

**For more than 35 years, Haustüren-Ring has stood for modern production technology, careful workmanship and innovative solutions.**

**In addition to continuous product development, we attach great importance to excellent service to always offer our customers the optimal solution.**

**Caring for our customers by personal support and advice is particularly important to us, be it our field staff, who support you on site throughout Europe, or our office team, which provides you with technical and professional support.**

**With Haustüren-Ring as your partner you can rely on unique and high quality workmanship.**

**More than 35 years ago just an idea - now a manufacturer of safe and unique external door blanks of excellent quality.**



## PROCESSING INSTRUCTIONS FOR EXTERNAL DOOR BLANKS

Moisten blanks with water before processing and subject both sides to a visual and dimensional inspection after approx. 60 minutes. Do not process damaged or defective blanks.

### A. Storage/conditioning

1. Store external door blanks in such a way that the expected moisture content (12 % +/- 1 %) of the blank is maintained also during intermediate storage. Store blanks flat on three well aligned timber supports to avoid distortions or other irregularities.
2. Protect blanks from ground water and wall moisture.

### B. Shortening of blanks

1. Before shortening the blanks and cutting of apertures for glazed panels check position of steel frame (see technical data sheet with drawing).
2. Reduction in length is always dependent on the applicable rebate geometry and hardware used. Observe sufficient timber width for proper screw fastening.
3. The steel frame must be surrounded by 10 mm unmachined solid wood. On the lock side, the blank should be shortened only by the lipping dimensions to maintain the lock case depth.
4. The insert lipping dimensions are specified in the attached data sheet (ATTENTION: measure hinge side for checking type of blank). The stamp with the technical data is at the BOTTOM!

### C. Attaching the lippings

1. Check moisture content (12 % +/- 1 %) of lipping before glue application. If possible, store lipping and blank in an air-conditioned room for one week.
2. For attachment use glue of stress group D4 (EN 204). Heat resistance of at least 50°C must be guaranteed during the 30 minute pressing time.
3. Lippings should be made of solid wood with vertical growth rings (low wood shrinkage).
4. Avoid thickness tolerances between door blank and solid wood lipping (glue failure).

### D. Blank veneering

Before veneering calibrate blank and remove dust from blank!

1. Moisture content of the veneer must be approx. 12 % +/- 1 %.
2. External door blanks with diagonal cross veneer must always be veneered.
3. Different veneer thicknesses and sliced veneers cause glue failures and must not be glued. Avoid using hot melt threads because low pressing temperature may cause glue failure.
4. The adhesive bond must be waterproof and heat resistant up to 100°C (D4 glue).
5. The structure must be symmetrical (identical internal and external veneer thicknesses).

### E. Pressing pressure

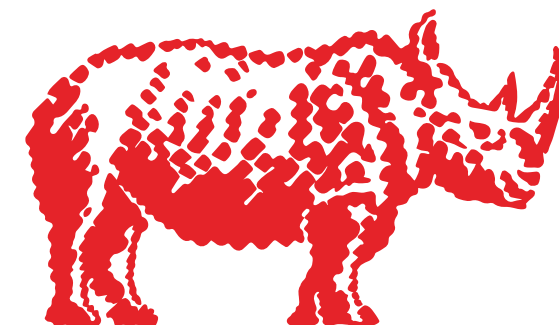
1. As a rule, the pressing temperature and pressing time depend on the types of glue and hardener used. Important: always observe manufacturer instructions! The pressing temperature must not exceed 100°C for a maximum duration of 10 minutes.
2. After pressing store doors with the two faces uniformly covered, between 1 and 2 days for intermediate conditioning.
3. The core of landing doors and acoustic/heat resistant doors cannot be veneered due to the core layer structure!!

### F. Apertures for glazed panels and surface treatment

Before surface treatment, moisten top layer with water, grind and remove dust!

1. Doors with apertures for glazed panels or infill panels featuring surface-mounted or rebated glazing beads or infill panel fixings, must be so designed that no moisture penetrates into the door leaf.
2. The engagement length of the screws used for infill panel fixings or glazing beads must be at least 40 mm for the core.
3. The infill panel fixings and glazing beads must be pre-drilled with a hole diameter 0.5 mm larger than the screw diameter.
4. Before, the borehole surface must be reworked using a countersink. It is not possible to countersink the screws when screwing them in!
5. Infill panel fixings and glazing beads can always be glued!
6. The mitred corners of the infill panel fixings and glazing beads must always be sealed.
7. Make sure that the doors are not exposed to moisture (shell construction moisture), because the colour and structure of the interior steel frame (extreme load) may show.
8. Untreated, primed, and oiled doors are excluded from warranty.
9. Moisten surface with water before priming and sand after drying.
10. Apply finishes as specified by the paint manufacturer. Special care must be taken that the top and bottom areas of the front sides are coated with a minimum dry layer thickness of 100 µm for woodstains and 120 µm for opaque finishes. In particular in external areas, the edges should be rounded with a 2 mm radius to prevent separation of the applied finish!
11. The surface structure must always be symmetrical (external to internal face).

All the information and instructions given here are based on experience or test results. They, however, must be adapted to the local conditions and materials used. For special dimensions exceeding the maximum standard dimensions (113 x 224 cm), no test certificates are available, so that the tolerances specified in the test certificate do not apply in this respect and exceedances may occur. All this is herewith agreed by the customer/client as being in accordance with the contract. In case of complaints, only the blank will be replaced.



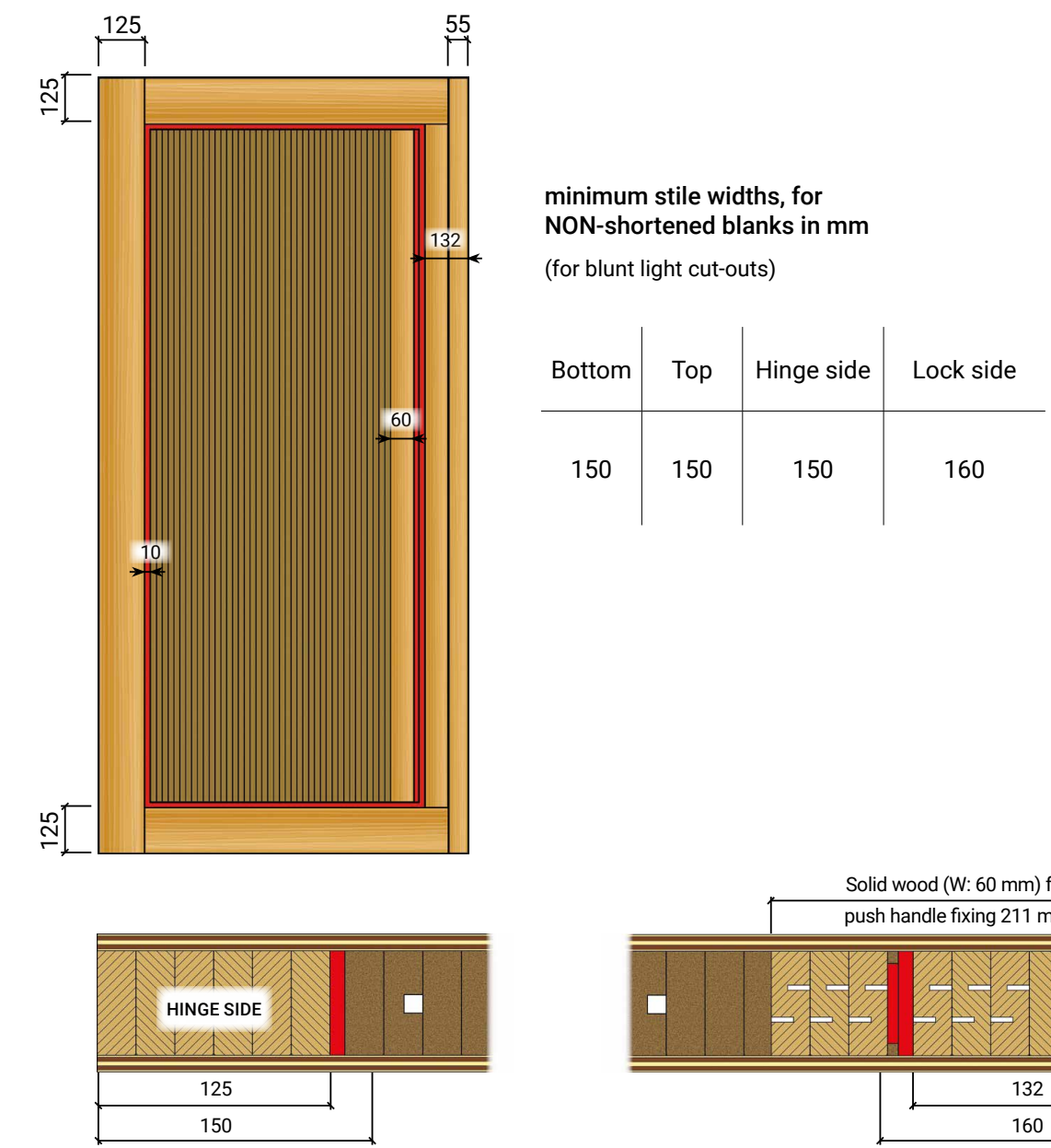
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**TYPE** OBJEKT  
OBJEKT VARIABEL  
48, 58, 68, 78 mm



# TYPE OBJEKT VARIABEL



## TECHNICAL DATA Blanks Type Objekt

Sound insulation values of unit:  
 U-value unit without aperture for glazed panel:  
 Test method DIN EN 1121:  
 Classification DIN EN 12219:  
 Burglar resistance DIN EN 1627:

Standard core  $R_{wp} = 32$  dB  
 Standard core 68 mm 1,0 W/m<sup>2</sup>K  
 Test climates c, d, e  
 Class 3 (c, d, e)  
 RC2, RC2N

# FIRST STEPS

## BEFORE PROCESSING ...

... of blank, check hinge-side insert lipping width for exact type determination!

Moisten blanks with water before processing and subject both sides of blanks to visual and dimensional inspection after approx. 60 minutes. Do not process damaged or defective blanks.

The dimensions given in the scheme show the insert lipping width in mm up to the beginning of the steel frame. When shortening the blanks, take account of their rebate dimensions. A 10 mm distance to the steel frame without any milled groove or rebate should be maintained, so that the insert remains well edged (shear and tensile resistance of adhesive bond).

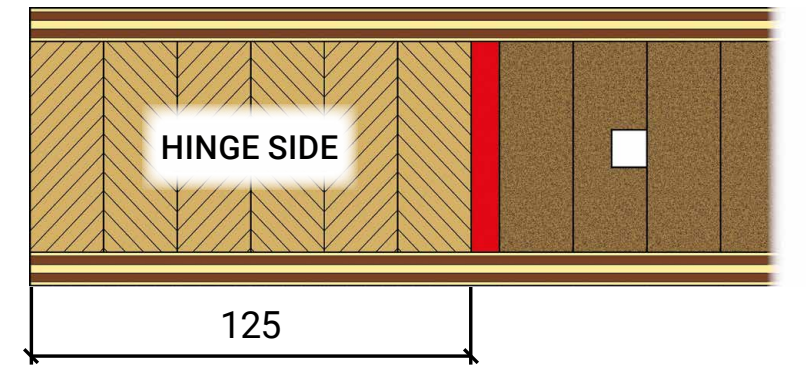
The bottom is marked with the technical data of the blank.

Shortening of the lock side is not allowed!

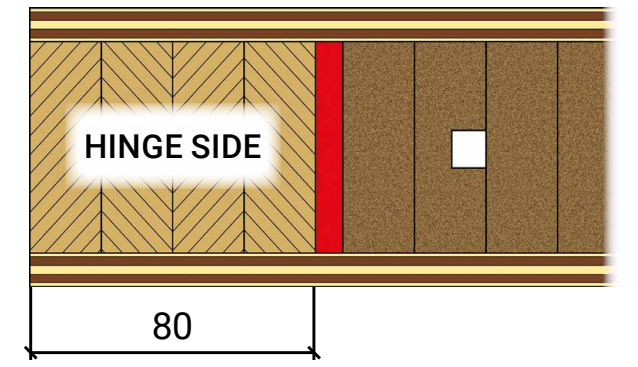
**ATTENTION:** For apertures for glazed panels take account of the allowance for fixing the glazing beads!



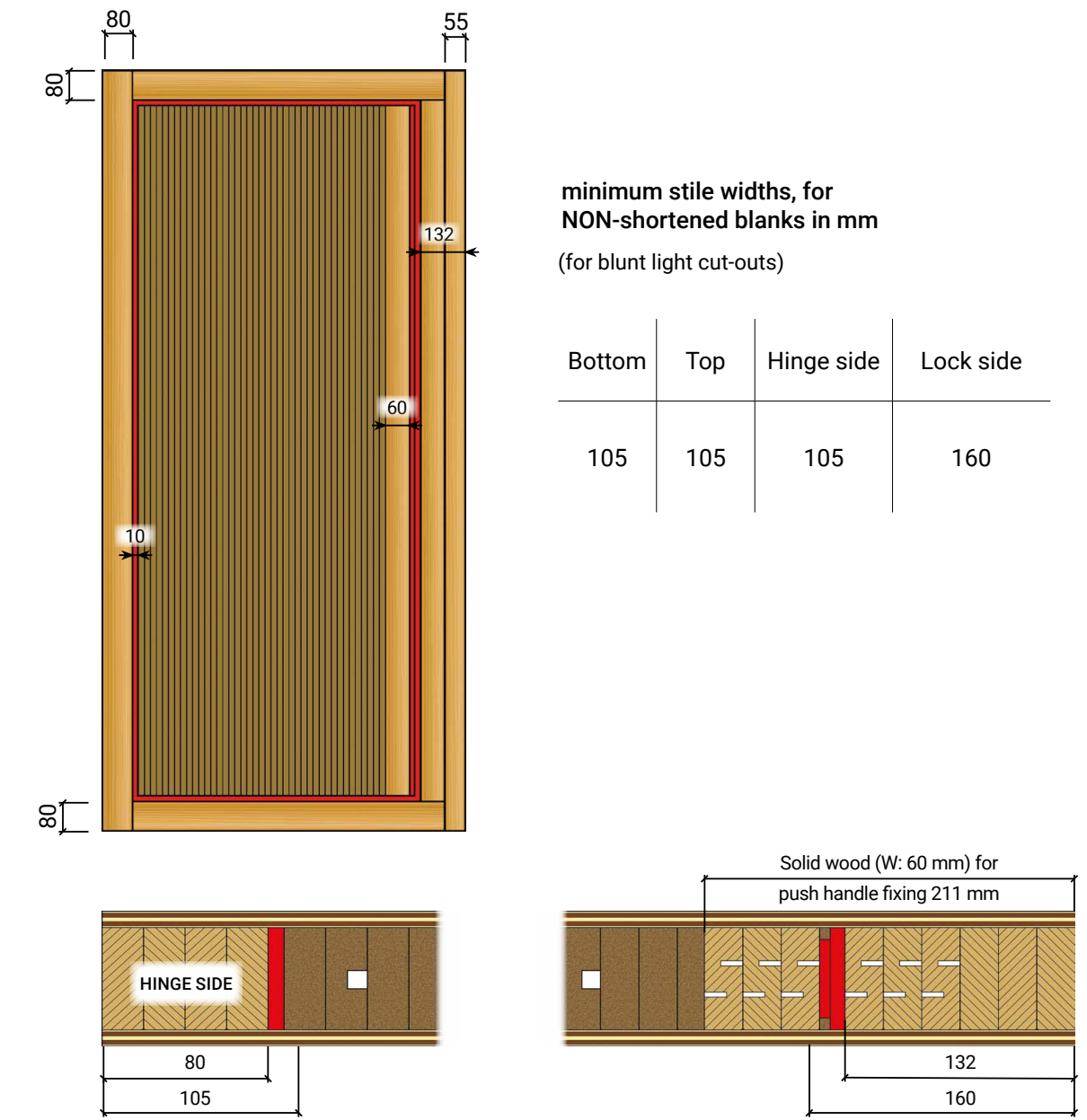
## TYPE OBJEKT VARIABEL



## TYPE OBJEKT



# TYPE OBJEKT



## Veneer Options

M = sliced veneer; L = vertical veneer; Q = horizontal veneer; F = fineline; E = insert lipping

OAK	M	L	Q	E
OAK knotty	M	L	Q	
SPRUCE	M	L	Q	F E
PINE	M	L	F	E
LARCH	M	L	Q	F E
OREGON PINE	M	L	Q	E
LARCH knotty	M	L	Q	
OKUME A	M	L		
OKUME B	M	L		
MERANTI		L	F	E
RED GRANDIS	M	L		E
MDF				

Veneer thickness 0.8 - 0.6 mm for goods on stock

For further embossed top layers such as Oak Rustikal and other timber species visit our website!