

Amweld is the only hollow metal door manufacturer with **laser-welded** precision doors. When you compare our laser-welded doors with the competition's spot-welded doors, you will see a definite gap in technology, strength, quality, and aesthetics. Laser-welding doesn't cost any more, and it provides a product of uncommon beauty and value. **And, our Lifetime Warranty speaks for itself!**

For more information about Amweld products, services and our warranty, visit: [www.amweld.com](http://www.amweld.com)

**Proudly American, Fiercely Independent, Fiercely Loyal.**



- POLYSTYRENE CORE**
- 15 LE **LASER EDGE**
  - 25 LE **LASER EDGE GALV.**
  - 17 LE **SEAMLESS EDGE**
  - 27 LE **SEAMLESS GALV.**
  - 21 LE **REPLACEMENT**
  - 35 LE **TEMPERATURE RISE**
  - 37 LE **TEMPERATURE RISE SEAMLESS**

**Gauges 14, 16, 18, & 20**

- Standard Features**
- Continuous Laser-Welded Edge Seam (Laser Edge)
  - Fully Bonded, Heat Cured, Nip Rolled, Core
  - Positive Pressure/Fire Rated
  - Closer Reinforced
  - Flush Top Channel
  - Inverted Bottom Channel
  - Non-Handed Design
  - Universal 4 1/2" Hinge Prep.
  - Prime Painted
- Special Options**
- Beveled Lock Edge
  - Galvanized (A40) or (A60) Steel (25 LE)
  - Seamless Edge (17 LE)
  - Replacement Door (21 LE)
  - Custom Hardware Preps.
  - Decorator Colors Available
  - Full Line of Lites and Louvers
  - 250° Temperature rise core
- Ideal for interior and exterior applications.*



- POLYURETHANE CORE**
- 83 LE **GALV.**
  - 85 LE **LASER EDGE**
  - 87 LE **SEAMLESS EDGE**
  - 89 LE **SEAMLESS GALV.**

**Gauges 14, 16, 18 & 20**

- Standard Features**
- Continuous Laser-Welded Edge Seam (Laser Edge)
  - Fully Bonded, Heat Cured, Nip Rolled, Core
  - Note: Available Fire Rated
  - Closer Reinforced
  - Flush Top Channel
  - Inverted Bottom Channel
  - Non-Handed Design
  - Universal 4 1/2" Hinge Prep.
  - Prime Painted
- Special Options**
- Beveled Lock Edge
  - Galvanized (A40) or (A60) Steel (83 LE)
  - Seamless Edge (87 LE)
  - Custom Hardware Preps.
  - Decorator Colors Available
  - Full Line of Lites and Louvers
- \* Available in 16 and 18 gauge only  
Ideal for extreme temperature conditions.*



- HONEYCOMB CORE**
- 45 LE **LASER EDGE**
  - 47 LE **SEAMLESS EDGE**

**Gauges 14, 16, 18 & 20**

- Standard Features**
- Continuous Laser-Welded Edge Seam (Laser Edge)
  - Fully Bonded, Heat Cured, Nip Rolled, Core
  - Positive Pressure/Fire Rated
  - Closer Reinforced
  - Flush Top Channel
  - Inverted Bottom Channel
  - Non-Handed Design
  - Universal 4 1/2" Hinge Prep.
  - Prime Painted
- Special Options**
- Beveled Lock Edge
  - Galvanized (A40) or (A60) Steel
  - Seamless Edge (47 LE)
  - Custom Hardware Preps.
  - Decorator Colors Available
  - Full Line of Lites and Louvers
- Ideal for interior applications where insulation is not required.*



- DECORATIVE DOORS**
- 61 LE **LASER EDGE**
  - 63 LE **SEAMLESS EDGE**
  - POLYSTYRENE CORE/  
6 PANEL, 8 PANEL

**Gauges 16, 18, & 20**

- Standard Features**
- (A40) Galvanized Steel
  - Continuous Laser-Welded Edge Seam (Laser Edge)
  - Fully Bonded, Heat Cured, Nip Rolled, Core
  - Positive Pressure/Fire Rated
  - Closer Reinforced
  - Flush Top Channel
  - Inverted Bottom Channel
  - Non-Handed Design
  - Universal 4 1/2" Hinge Prep.
  - Prime Painted
- Special Options**
- Seamless Edge (63 LE)
  - 8 Panel Design (67 LE)
  - 2 and 4 Panel Options
  - Custom Hardware Preps.
  - Decorator Colors Available
  - PVC 1/2" Insulated Glass Inserts  
1-Lite/9-Lite 2-Lite/15-Lite/Full Lite
- Ideal as a decorative entrance door*



- SPECIALTY DOORS**
- ACOUSTICAL DOORS**
- 51 LE SERIES **SOUNDSHIELD®**
  - 7900 SERIES **FIRESONIC®**

- SOUND SHIELD®**
- 16 GAUGE**
- Standard Performance**
- Continuous Laser-Welded Edge Seam (Laser Edge)
  - Seamless Edge (53 LE)
  - 16 Gauge Meets STC 42 or 45
  - Unit includes Frame and Sound Seals
- Soundshield Acoustical Doors are made in a similar design to the 15 LE door. Special Soundshield core provides the desired acoustical performance. Available galvanized for exterior use. Ideal for band rooms, quiet areas, meeting rooms, etc.*
- FIRESONIC®**
- 14, 16 & 18 Gauge Standard Performance**
- Single Meets STC 45, 47, 49, or 51
  - Double Meets STC 41, 47, or 49
  - Includes Frame and Sound Seals
- FireSonic acoustical doors are made in similar design to the 700 Series door. FireSonic® Core provides desired acoustical performance and durability of a steel-stiffened door. Ideal for quiet rooms where security is also a main consideration.*



- STILE AND RAIL**
- 300 SERIES (FG)**
- [A40] Galvanized Steel]

- 16 Gauge Standard Features**
- True Stile and Rail Tubular Construction
  - Non-Handed Construction
  - Full Glass Design (FG)
  - 5 1/2" Top/Stiles
  - 8" Bottom Rail
  - Fully Welded/Mitered Corners
  - Flush Top and Bottom
  - Meets SDI Level 3, Model 3
  - Galvanized Standard
- Special Options**
- Flush glass w/ Mid-Rail (FG2)
  - Half Glass Design (G)
  - Vision Lite Design (V)
  - Polystyrene Core As shown
  - Flush Panel Design Available
- Ideal for High-Frequency Entrances to replace aluminum storefront doors, as well as High Abuse Applications including Schools and Hospitals.*



- STEEL STIFFENED**
- 700 SERIES (HANDDED)**
- 500 SERIES (NON-HANDED)**
- (WELDED SEAM)**

- Gauges 14, 16 & 18**
- Standard Features**
- 22 Gauge Steel Stiffeners Hat Shaped/Welded 6" O.C.
  - Batt Wool Insulation
  - Fully Welded (Seamless) Edges
  - Square Edges (500)
  - Beveled Hinge/Lock Edge (700)
  - Inverted Top and Bottom Channel
  - Meets NAAMM/HMMA Specifications
- Special Options**
- Galvanized (A40) Steel Available
  - 18 Gauge Steel Stiffeners
  - Lites and Louvers Installed
  - Variety of Hardware Preparations
  - Flush Top and/or Bottom Cap
  - Meets NAAMM/HMMA (HMMA-861)
  - A Variety of Hurricane-Resistant Products are Available (consult Technical Data Manual)
- Per NAAMM/HMMA Specifications, some visible spot welds at steel stiffener locations should be expected. High gloss finishes are not recommended.  
Ideal for extreme durability and security purposes where aesthetics are not top priority.*



- SECURITY DOORS**
- (BULLET RESISTANT)**
- 1538 (LEVEL 1)
  - 1544 (LEVEL 3)

- 16 Gauge Standard Features**
- 16 Gauge Panels with 14 Gauge Security Plates
  - Supercore®, Polystyrene Core
  - 1538 Series Meets "UL" Level 1 (One Plate)
  - 1544 Series Meets "UL" Level 3 (Two Plates)
  - 5" Heavy Weight Hinge Preparation
  - Unit Includes Security-Approved Hardware
- Ideal for high security requirements including banks, electric substations, ATM buildings, etc.*



**ROLL-FORMING PRODUCES  
FRAMES WITH:  
CONSISTANT PROFILES,  
CONSISTANT SHAPES,  
CONSISTANT SIZES**

To insure that Amweld's laser-welded doors fit accurately, we have completely revamped our frame manufacturing process at our Garrettsville, Ohio plant. Our new Roll forming line produces 80% of our standard frames.

These frames have the tightest tolerances in the industry, and are made to accept hardware that will fit right the first time, every time...making installation easy and accurate.

Job requirements are coordinated so headers and strikes come through at the same time insuring all job materials are on time and 100% complete.

Roll forming produces any profile from 4 3/4" to 8 1/2" and up to 12'4" in length for either drywall or masonry configuration.

Hardware preps are programmed into the roll formers database reducing location errors common in manual piercing. Both hardware and silencer piercing are done automatically on line.

Precision roll forming makes frame installation easier and more accurate.

*Amweld's roll-forming technology produces frames with the tightest tolerances in the industry.*



**400 SERIES (INTERLOCK®)  
14 OR 16 GAUGE STEEL  
Standard Features**

- Knocked Down with Precision Fit Interlock® Corners
- 3" - 18 3/4" Jamb Depth
- 2" Faces Standard
- 5/8" High Stops
- 1/2" Returns\*
- Unequal Rabbet Design
- Anchors Available for Masonry, Wood and Metal Stud Walls

**Special Options**

- Galvanized (A40) or (A60) Frames Available for Exterior Use
- Special Faces 1" thru 4" and more
- 4" Header Design Available
- Equal Rabbet Design
- Special Hinge or Lock Locations
- Decorator Colors Available
- Special Profiles Available

*Standard steel frames are available knocked-down or welded and ground smooth. Profiles and anchors to fit any wall condition. Embossed 3-hour label standard. Variety of Hardware Preparations available. (Standard is a 4 1/2" hinge (standard or heavyweight) preparation and 4 7/8" strike.)*

*\* 7/16" returns standard on 5 3/4" Frame*

**2600 SERIES (SLIP-ON)  
DRYWALL  
16 GAUGE STEEL  
Standard Features**

- Knocked Down with Precision Fit Sure-Fit® Corners
- Installs Over Finished Walls
- 3" - 12 3/4" Jamb Depth
- 5/8" High Stops
- 1/2" Double Returns
- Unequal Rabbet Design
- 18 Gauge Welded Strap Sill Anchors
- Screw Adjusting Jamb Anchors

**Special Options**

- Galvanized (A40) or (A60) Frames for Exterior Use
- Special Faces available in 1", 1 1/4", 1 1/2", 1 3/4"
- Pre-drilled and Countersunk Sill Holes Available
- Equal Rabbet Design
- Special Hinge or Lock Locations
- Decorator Colors Available
- 4600 Series - Trimmed Opening

*Standard (slip-on) drywall frames are designed for quick and easy installation over finished walls. Embossed 1 1/2-hour label standard. A variety of hardware preparations available. (Standard is 4 1/2" (standard or heavyweight) hinge preparation and 4 7/8" strike.)*

**800 SERIES ADJUSTABLE  
16 GAUGE STEEL  
Standard Features**

- Interlock® Corner Construction
- Split Frame Design
- Installs over Finished or Existing Walls
- 3 1/4" - 9 7/16" Jamb Depth
- 2" Face and 1/2" Return Standard

**Special Options**

- Galvanized (A40) or (A60) Frames Available for Exterior Use
- Special Faces Available from 1" - 8"
- Special Returns Available from 3/8" - 1"
- Fire Ratings Available (see Technical Data Manual)
- Decorator Colors Available
- 1200/1800 Series - Replacement Frames

*Adjustable steel frames are designed to retrofit walls or encapsulate existing frames. Custom variations are available to wrap almost any wall condition. Ideal for lead-paint encapsulation.*

**4400 SERIES  
DOUBLE-EGRESS  
14 OR 16 GAUGE STEEL  
Standard Features**

- Knocked Down with Mitered Corners
- 4" - 12 3/4" Jamb Depth
- 5/8" High Stops
- 1/2" Returns
- Anchors Available for Masonry, Wood and Metal Stud Walls

**Special Options**

- Galvanized (A40) or (A60) Frames Available
- Variety of Custom Hardware Preparations Available
- Decorator Colors Available

*Note: Standard double egress frames are designed for cross corridor application to assist in traffic flow pattern. (4 1/2" (standard or heavyweight) hinge preparation is standard.)*

**SPECIALTY FRAMES  
14 OR 16 GAUGE STEEL**

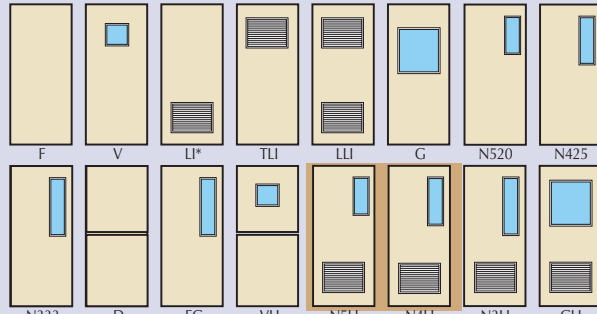
- 3000 Series Thermal Break Frames Minimize Condensation Problems.\*
- Available in a Variety of Specialized Face Trim, Backbends, and Return Profiles.
- Amweld offers Cove, Stepped Ogee and Splay Faces for a Distinctive Custom Look.
- Pocket Slide Frame.
- Non-Handed Frame Systems for the Metal Building Industry.
- 1400 or 1600 Bullet Resistant for UL752 Level 1 or 3 Protection.
- Hospital Stop
- Kerfed

*Amweld's frame manufacturing capabilities are second-to-none. See Amweld's Architectural Data Manual for additional information.*

*\* Available in 14 gauge (A40) galvanized only.*

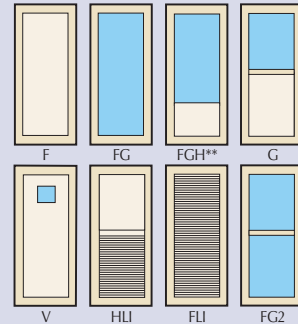


## STANDARD DOOR DESIGN - SERIES 15LE/17LE, 25LE/27LE, 35LE/37LE, 45LE/47LE, 85LE/87LE, 700



\*Louvered doors available with any light combination shown above. Louvers and lites cannot be combined in labeled doors. \*\*ADA Compliant

## STILE & RAIL DOOR DESIGN - SERIES 300



## GENERAL AVAILABILITY OF FIRE RATINGS

Description	FIRE RATED FRAMES						Description	FIRE RATED DOORS								
	400	600	800	1800	2600	4400		15LE	25LE	35LE	45LE	500	700	61LE	51LE	300
3 Sided Single	.	.	.	.	.	.	3 Hour Rating	.	.	.	.	.	.	.	.	.
3 Sided Double	.	.	.	.	.	.	3 Hr. Rating w/ Lite	.	.	.	.	.	.	.	.	.
4 Sided Single	.	.	.	.	.	.	1 1/2 Hour Rating	.	.	.	.	.	.	.	.	.
Slip-on Drywall	.	.	.	.	.	.	3/4 Hour Rating	.	.	.	.	.	.	.	.	.
Double Egress	.	.	.	.	.	.	20 Min. (N.H.S.)	.	.	.	.	.	.	.	.	.
Contra Swing	.	.	.	.	.	.	Positive Pressure	.	.	.	.	.	.	.	.	.
Multi-Swing	.	.	.	.	.	.	Fusible Link Louvers	.	.	.	.	.	.	.	.	.
Transom w/o Bar	.	.	.	.	.	.	250° Temp. Rise	.	.	.	.	.	.	.	.	.
Transom w/ Bar	.	.	.	.	.	.	450° Temp. Rise	.	.	.	.	.	.	.	.	.
Adjustable	.	.	.	.	.	.	Height up to 8'-0" *	.	.	.	.	.	.	.	.	.
4 hour in Drywall	.	.	.	.	.	.	Height up to 10'-0" *	.	.	.	.	.	.	.	.	.
10'-0" Opening Ht.	.	.	.	.	.	.	Embossed Panels	.	.	.	.	.	.	.	.	.
Fire Window	.	.	.	.	.	.	Protection Plates to 48" A.F.F.	.	.	.	.	.	.	.	.	.
Side/Transom Lite	.	.	.	.	.	.	Double Egress	.	.	.	.	.	.	.	.	.
K-D	.	.	.	.	.	.										
Welded	.	.	.	.	.	.										
Hospital Stops	.	.	.	.	.	.										
Positive Pressure	.	.	.	.	.	.										
Snap In Anchors	.	.	.	.	.	.										
4 Sided Access	.	.	.	.	.	.										

\*Consult Amweld Tech Data for Information

The above charts are intended to be a brief synopsis, not a complete description or a "mix and match". Amweld's Tech Data is to be consulted for more specific information.

# TECH DATA

## DOOR/SERIES/GAUGES



Standard Non-handed hinge preparation. (minimum 10 gauge). Prepare for standard and heavy weight 4.5" Hinges



Standard handing plate to allow jobsite handling for additional versatility.

## STANDARD, FIRE, CUSTOM, STILE & RAIL BULLET RESISTANT

SERIES	THICKNESS	GAUGE	SINGLE WIDTH	DOUBLE WIDTH	HEIGHT
15, 17, 25, 27 LE	1 3/4"	14, 16, 18, 20	2'0" thru 4'0"***	4'0" thru 8'0"***	6'8", 7'0", 7'2", 7'10", 8'0", 10'0"***
45, 47, 83, 85, 87 LE	1 3/4"	14, 16, 18, 20	2'0" thru 4'0"	4'0" thru 8'0"	6'8", 7'0", 7'2", 8'0"
61-63 LE	1 3/4"	16, 18, 20	2'8" thru 3'6"	5'4" thru 7'0"	6'8", 7'0"
51-53 LE	1 3/4"	16	2'0" thru 4'0"	not available	6'8" - 7'0", 7'2", 8'0"
1538 LE (One 14 ga. plate)	1 3/4"	16	3'0" thru 4'0"	not available	6'8" - 7'0"
1544 LE (Two 14 ga. plate)	1 3/4"	16	3'0" thru 4'0"	not available	6'8" - 7'0"
21 LE	1 3/4"	16, 18	2'0" thru 4'0"	4'0" thru 8'0"	6'8" - 7'0"
300	1 3/4"	16	4'0" thru 8'0"	5'0"-6'0" - 7'0" - 8'0"	6'8", 7'0", 7'2", 7'10", 8'0"
300 Full Glass	1 3/4"	16	4'0" thru 8'0"	5'0" thru 8'0"	6'8", 7'0", 7'2", 7'10", 8'0"
500	1 3/4"	16, 18	2'0" thru 4'0"	4'0" thru 8'0"	6'8" - 7'0", 7'2" - 7'10" - 8'0"
700	1 3/4"	14, 16, 18	2'0" thru 4'0"*	4'0" thru 8'0"	6'8" - 7'0", 7'2" - 7'10" - 8'0" - 10'

\*Door leaves over 4'0" available.

\*\*Limited availability in 20 gauge.

## 15LE SERIES THERMAL CONDUCTIVITY

Guage	U Value		R Value	
	Btu/(ft <sup>2</sup> ·h·°F) Winter	W/(m <sup>2</sup> ·K) Still Air <sup>2</sup>	ft <sup>2</sup> ·h·°F/Btu Winter	(m <sup>2</sup> ·K/W) Still Air <sup>2</sup>
20	0.28 (1.59)	0.24 (1.36)	3.57 (0.63)	4.16 (0.73)
18	0.28 (1.59)	0.25 (1.42)	3.57 (0.63)	4.00 (0.70)

1 Apparent U Factor corrected to a winter design with 15 mph (24 kph) winds.  
2 Apparent U Factor corrected to still air on both sides.



MADE IN U.S.A.

**AMWELD**  
BUILDING PRODUCTS  
A division of ARK II Manufacturing, LLC

# FINISHING TOUCHES



## PREFINISHED DOORS & FRAMES

You can choose Amweld's low VOC primer or 12 decorator colors\* to reduce the costs of jobsite painting and cleaning. Special frame carton available.

Amweld pre-painted material is intended as a substitute for field finish, and should be of comparable quality to a field applied finish. Carefully compare factory prefinish and field applied finish costs.

All Amweld Doors and Frames are available in prefinish with the exceptions being the Series 300, 51LE, 53LE, 1538, 1544, 500, 700 Doors.

\* Prefinish colors shown are approximate. Color chips available for architect approval upon request.



Dark Bronze



Colonial Red



Skylight Blue



Seal Brown



Atrium Green



Bronze Gold



Antique Bronze



Surrey Beige



Mullion Gray



Ivory



Sandstone



White

**These items can be shipped within 48 hours:**

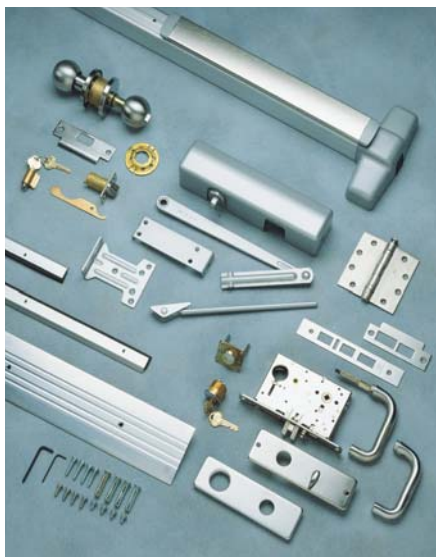
- Standard and heavy duty mortise locks, full escutcheon, sectional trim, and lever handle sets.
- Mortise deadlocks.
- Bored locks (light, standard and heavy duty).
- Tubular deadlocks.
- Rim Panic exit devices (labeled and standard).
- Vertical rod surface applied (labeled and standard exit devices).
- Full mortise template hinges.
- Half mortise hinges.
- Spring template hinges.
- Surface door closers.
- Overhead door holders.
- Open back strikes.
- Listed and non-listed interviewers.
- Kickplates.
- Automatic and self-latching flush bolts.
- Surface bolts.
- Padlocks.
- Thresholds.
- Floor sweeps.
- Door stops.
- Push and Pull plates.

**These items are special order:**

- Pre-assembled (unit) locks.
- Double acting spring hinges, template and clamp type.
- Anchor or Pivot reinforced hinges.
- Double acting hinges.
- Single acting floor checks.
- Double acting floor checks.
- Concealed closers.
- Head mounted closers.
- Electric strikes.
- Electric hinges.
- Roller latches.
- Push and Pull bars.
- Flush Pulls.
- Rescue hardware.
- Emergency exit locks.
- Electronic security hardware
- Vertical rod/concealed.

## HARDWARE

Amweld carries a complete line of brand name hardware for interior and exterior openings, as well as fire barrier and security doors.



The Independence Hardware by Amweld brand provides strong value, great customer benefits, and an independent choice for architects, building owners, contractors, and distributors. For more information on Independence Hardware by Amweld, visit their website at:

www.independence-hardware.com  
Phone: 877-437-1237 Fax: 330-527-5449



Please call your local Amweld distributor for specifics about the brand name products shown above.

## ADVANCED INFORMATION TECHNOLOGY SERVICES

### AmTech

Amweld leads the way with it's AmTech On-Line ordering and order tracking system.

### FabMaker

With Amweld's FabMaker software, you can easily draw fab elevations and estimate with accuracy.

For more information, contact the IT Department at Amweld.

Your options for specifying and ordering Amweld products are as follows:

- Log on to [www.amweld.com](http://www.amweld.com) and go to spec wizard
- Send an e-mail to: [marketing@amweld.com](mailto:marketing@amweld.com) and request a hard copy of the Amweld Technical Data Manual
- [www.sweets.com](http://www.sweets.com)
- [www.FirstSourceONL.com](http://www.FirstSourceONL.com)
- [www.arc.com](http://www.arc.com)



**Quality Hollow Metal Doors, Frames, and Architectural Hardware.**

**AMWELD BUILDING PRODUCTS**  
A division of ARK II Manufacturing, LLC  
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Garrettsville, OH 44231  
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800-248-6116  
FAX: 330-527-5122  
[www.amweld.com](http://www.amweld.com)

**DISTRIBUTION / SERVICE CENTERS**

**Chicago Service Center**  
624 Anderson Drive  
Romeoville, IL 60446  
815-293-4400  
FAX: 815-293-4402

**Los Angeles Distribution Center**  
138 University Parkway  
Pomona, CA 91768  
909-594-8355  
FAX: 909-594-8183

**Southeast Distribution Center**  
995 Charles Street  
Longwood, FL 32750  
407-478-0728  
FAX: 407-478-0732



**PROUDLY AMERICAN, FIERCELY INDEPENDENT, FIERCELY LOYAL.**