1-3/4" IMPERIAL (IU) POLYURETHANE CORE
FLUSH AND EMBOSSED PANEL STEEL DOORS
BEVELED LOCK EDGE, HANDED

FULL FLUSH OR SEAMLESS STYLE...
FOAMED-IN-PLACE POLYURETHANE CORE FILLS ENTIRE DOOR CAVITY. CORE IS
CHEMICALLY BONDED TO ALL INTERIOR SURFACES. HIGH IMPACT RESISTANCE.
EXCELLENT INSULATION CHARACTERISTICS.

SUGGESTED USE:
INTERIOR OR EXTERIOR...
CONDOMINIUMS
DORMATORIES
MOTELS/HOTELS
OFFICE BUILDINGS
URBAN RENEWAL
HEALTH CARE
INSTITUTIONAL
DATA PROCESSING
MERCANTILE
FOOD PROCESSING

FLUSH DESIGNS SIMILAR LESS EMBOSSED PANEL

EMBOSSED PANEL DESIGNS:
8 PANEL
6 PANEL
CROSSBUCK

DUTCH
V, G, & N
DESIGNS AVAILABLE

EC05
EC04
E101
E201
E202
E203

E301
E302
E303
E601
E609
E605
E604
E801

<table>
<thead>
<tr>
<th>1 PANEL</th>
<th>2 PANEL</th>
<th>3 PANEL</th>
<th>6 PANEL</th>
<th>8 PANEL</th>
<th>CROSS BUCK &amp; LITES</th>
</tr>
</thead>
<tbody>
<tr>
<td>MAX. SIZE</td>
<td>3'0&quot;x8'0&quot;</td>
<td>3'0&quot;x8'0&quot;</td>
<td>3'0&quot;x8'0&quot;</td>
<td>3'0&quot;x7'0&quot;</td>
<td>3'0&quot;x7'0&quot;</td>
</tr>
<tr>
<td>MIN. SIZE</td>
<td>2'8&quot;x6'8&quot;</td>
<td>2'8&quot;x6'8&quot;</td>
<td>2'8&quot;x6'8&quot;</td>
<td>2'6&quot;x6'8&quot;</td>
<td>2'8&quot;x6'8&quot;</td>
</tr>
</tbody>
</table>
Hardware locations shown match Ceco standard frames.

DOOR ELEVATION

VERTICAL SECTION

HORIZONTAL SECTIONS

(Conversion: 1” = 25.4 mm, e.g., 1–3/4” = 44.45 mm)

*See all embossed panel designs and size limitations on pages D3–1 or D3–4.

OVERLAPPING ASTRAGAL
4441
FOR 1–3/4” THICK DOORS

OVERLAPPING ASTRAGAL
4471
FOR 1–3/4” THICK DOORS

STEEL

INACTIVE
ACTIVE

INACTIVE
ACTIVE

STEEL

LISTED

LISTED
16 GAGE STEEL END CHANNELS

WELDED TO BOTH FACE SHEETS

INVERTED TOP AND BOTTOM

OPTIONAL TOP AND BOTTOM CAPS ARE AVAILABLE

VERTICAL EDGES

MECHANICALLY INTERLOCKED HEMMED EDGES

ALSO AVAILABLE SEAMLESS (WELDED OR BODY FILLER)

CLOSER REINFORCEMENT (OPTIONAL)

14 GAGE STEEL CHANNEL 20" LONG

LOCK PREPARATION

GOV. 160/161 CYLINDRICAL TYPE

(LC1)

(ANSI A115.2)

2–3/4" BACKSET

LOCK EDGE IS BEVELED 1/8" IN 2" (1:16)

HINGE PREPARATION

4–1/2 OR 5 IN. HIGH, STANDARD OR HEAVY WEIGHT, FULL MORTISE HINGES

HINGE EDGE IS HANDED AND NOT BEVELED.

(GLAZING TRIM)

SlimTrim

3/8" WIDE GLAZING POCKET

STEEL LISTED

GLAZING SYSTEM

FOR STANDARD 2'8" & 3'0" WIDE, 6'8" & 7'0" HIGH NON–LABELED EMBOSSED 2, 6 & CROSSBUCK PANEL DOORS

1/8" TEMPERED SAFETY GLASS

HIGH–IMPACT MOULDED POLYSTYRENE TRIM

OPTIONAL: 1/2" INSULATED GLASS
**PRODUCT SPECIFICATIONS:**

1-3/4" Thick steel doors shall be as manufactured by Ceco Door Products, Milan, TN USA. Doors shall conform to the Steel Door Institute guide specification, ANSI A250.8; see chart below for performance classifications.

**IMPERIAL doors are made full-flush or (optional) seamless style. Face sheets are commercial quality cold rolled steel conforming to ASTM A1008 and A568...or (optional) hot-dipped galvanized or galvanized steel conforming to ASTM A924 and A653 -- see chart below.

**Imperial full-flush doors** have mechanically interlocked, hemmed, hairline seams on vertical edges and have no visible seams on faces. Doors specified "seamless" have no visible seams on faces or vertical edges (S.D.I. Model 2). Face sheets are totally supported by a foamed-in-place polyurethane core. The core fills the entire door cavity and is chemically bonded to all interior surfaces. Density of foam exceeds 1.8pcf and it has a crush strength of 3600 psf. The top and bottom door edges are closed with 16 gauge steel channels welded to both face sheets.

**Hardware Provisions:** Hinge preparations are handed. Hinge edges are mortised for 4-1/2" or 5" high, standard and heavy weight hinges (specify which). 7 gage steel hinge reinforcements are welded inside the door edge and are drilled and tapped for fasteners in accordance with ANSI A156.7. The lock edge has a standard bevel (1:16) and is prepared for Gov. series 86, 160/161, or 90 locks in accordance with ANSI A115 (specify which). Optional closer reinforcement is a 14 gage steel channel.

**Paint:** 1-3/4" steel doors shall be provided with one coat of oven-cured neutral color primer paint. Primer coat shall conform with ANSI A250.10. The primer coat is a preparatory base for necessary finish painting. "Colorstyle" finish coat is also available from a selection of standard colors (optional). Colorstyle finish is electrostatically applied, oven-cured urethane enamel and shall conform to ANSI A250.3. For accurate color selectors ask for a Ceco Colorstyle chart.

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### MATERIAL

<table>
<thead>
<tr>
<th>DOOR FACE SHEETS</th>
<th>LEVEL</th>
<th>C.R.</th>
<th>GALV</th>
<th>RECOMMENDED DOOR FRAME MATERIAL</th>
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<tbody>
<tr>
<td>20 Gage Steel (4080 max.)</td>
<td>Standard Duty</td>
<td>N/A</td>
<td>STD N/A</td>
<td>16 Gage Steel</td>
</tr>
<tr>
<td>18 Gage Steel</td>
<td>Heavy Duty</td>
<td>STD</td>
<td>OPT</td>
<td>16 Gage Steel</td>
</tr>
<tr>
<td>16 Gage Steel</td>
<td>Extra Heavy Duty</td>
<td>STD</td>
<td>OPT</td>
<td>16 or 14 Gage Steel</td>
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**PERFORMANCE**

<table>
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<tr>
<th>Thermal Characteristic Value:</th>
<th>CORE CALCULATED (ASTM C518)</th>
<th>R = 11.01</th>
<th>U = 0.091</th>
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<tbody>
<tr>
<td><strong>NFRC</strong> 102–2014 &amp; ASTM FLUSH DOOR WITH MERCURY FRAME</td>
<td>R = 2.63</td>
<td>U = 0.38</td>
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<tr>
<td><strong>NFRC</strong> 102–2014 &amp; ASTM FLUSH DOOR WITH WEATHERKERF FRAME</td>
<td>R = 2.63</td>
<td>U = 0.38</td>
<td></td>
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<tr>
<td><strong>NFRC</strong> 102–2014 &amp; ASTM FLUSH DOOR WITH STANDARD FRAME</td>
<td>R = 2.50</td>
<td>U = 0.40</td>
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<tr>
<td><strong>NFRC</strong> 102–2014 &amp; ASTM EMBOSSED DOOR WITH MERCURY FRAME</td>
<td>R = 2.63</td>
<td>U = 0.38</td>
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<td><strong>NFRC</strong> 102–2014 &amp; ASTM EMBOSSED DOOR WITH WEATHERKERF FRAME</td>
<td>R = 2.44</td>
<td>U = 0.41</td>
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<td><strong>NFRC</strong> 102–2014 &amp; ASTM EMBOSSED DOOR WITH STANDARD FRAME</td>
<td>R = 2.56</td>
<td>U = 0.39</td>
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</tbody>
</table>

*NFRC 102–2014: The general requirements of testing shall be as defined in NFRC 102, ASTM C1199 and ASTM C1363.

**Sound Transmission Class:**

- Meets ANSI A250.4 Performance Test, 20 GAGE: Level B (500,000 Cycles); 18 and 16 Gage: Level A (1,000,000 Cycles)

**Physical Endurance Level:**

- (Conversion: 1" = 25.4 mm, e.g., 1-3/4" = 44.45 mm)