The Madera stainable steel door has a stained oak grain look textured into the steel. The Madera Smooth Grain (SG) has a stained cherry or maple wood grain design on smooth steel. Both styles provide an attractive flush or 6 panel embossed pattern. The 6 panel embossed door's stiles and rails graining direction duplicates a typical standard wood grain pattern. The stain is factory applied. See stain color information shown below. The stained product is protected with an ultra-violet (UV) resistant clear coating.

STANDARD STAIN COLORS AVAILABLE
GOLDEN AUTUMN BOURBON SALEM PROVINCIAL NUTMEG

CUSTOM STAIN COLORS
Custom stain color matching is available. Physical custom stain sample must be submitted to factory for color matching, then matched samples will be returned for approval before order can be processed. Additional lead-times may apply.
Hardware locations shown match Ceco standard frames.

Finished Floor

DOOR ELEVATION

VERTICAL SECTION

HORIZONTAL SECTIONS

Note: All visible surfaces are wood grained. Grain is not shown on all details for clarity.

POLYSTYRENE FOAM CORE (STANDARD) FOR EMBOSSED OR FLUSH DOORS

MINERAL CORE (OPTIONAL) PERMANENTLY BONDED TO THE INSIDE OF BOTH FACE SHEETS.

*OPTIONAL - POLYURETHANE DROP-IN SLAB CORE (FLUSH ONLY)

Conversion: 1" = 25.4 mm, e.g., 1-3/4" = 44.4 mm
TECH-DATA

16 GAGE STEEL END CHANNELS
WELDED TO BOTH FACE SHEETS

VERTICAL EDGES
CENTER EDGE SEAM WITH INTERMITTENT SPOT WELDS.
SPOT WELDS ARE FILLED AND GROUND SMOOTH.

OPTIONAL TOP AND BOTTOM CAPS ARE AVAILABLE

CLOSER REINFORCEMENT (OPTIONAL)

14 GAGE STEEL CHANNEL WELDED TO END CHANNEL

LOCK PREPARATION CYLINDRICAL TYPE
14 GAGE LOCK CHANNEL

(LC1) (ANSI A151.2)
2-3/4" BACKSET

LOCK EDGE IS BVEVELED 1/8" in 2" (1:16)

HINGE PREPARATION
4-1/2 OR 5 IN. HIGH, STANDARD OR HEAVY WEIGHT, FULL MORTISE HINGES
ANSI A156.7 TEMPLATE
HINGE EDGE IS HANDLED AND NOT BVEVELED.

LOCK PREPARATION MORTISE TYPE
(LM1) (ANSI A115.1)
2-3/4" BACKSET
(LMO) SIMILAR TO DETAIL LESS FACE CUTOUT
(LP0) SIMILAR TO DETAIL LESS ALL CUTOUTS AND REINFORCEMENT

OVERLAPPING ASTRAGAL 4471M
FOR 1-3/4" THICK DOORS

GLAZING TRIM
SMOOTH GRAIN SHOWN. TEXTURED GRAIN USED ON MADERA®

GLAZING TRIM
3/8" WIDE GLAZING POCKET

Optional Glass Pocket Width: 5/8", 7/8", 1-1/8"
**TECH-DATA**

**MADERA® WOOD GRAIN STEEL DOORS**

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### STANDARD SIZES

**Nominal Door Opening**

<table>
<thead>
<tr>
<th>WIDTH</th>
<th>SINGLE</th>
<th>DOUBLE</th>
<th>HEIGHT</th>
</tr>
</thead>
<tbody>
<tr>
<td>2'-0&quot;</td>
<td>4'-0&quot;</td>
<td>6'-8&quot;</td>
<td></td>
</tr>
<tr>
<td>2'-4&quot;</td>
<td>4'-8&quot;</td>
<td>7'-0&quot;</td>
<td></td>
</tr>
<tr>
<td>2'-6&quot;</td>
<td>5'-0&quot;</td>
<td>7'-2&quot;</td>
<td></td>
</tr>
<tr>
<td>2'-8&quot;</td>
<td>5'-4&quot;</td>
<td>7'-0&quot;</td>
<td></td>
</tr>
<tr>
<td>2'-10&quot;</td>
<td>5'-8&quot;</td>
<td>7'-10&quot;</td>
<td></td>
</tr>
<tr>
<td>3'-0&quot;</td>
<td>6'-0&quot;</td>
<td>8'-0&quot;</td>
<td></td>
</tr>
<tr>
<td>3'-4&quot;</td>
<td>6'-8&quot;</td>
<td></td>
<td></td>
</tr>
<tr>
<td>3'-0&quot;</td>
<td>7'-0&quot;</td>
<td></td>
<td></td>
</tr>
<tr>
<td>4'-0&quot;</td>
<td>8'-0&quot;</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

### SIZE LIMITS

**Design/Material**

<table>
<thead>
<tr>
<th>FLUSH DESIGN</th>
<th>6 PANEL SG</th>
<th>6 PANEL SG</th>
</tr>
</thead>
<tbody>
<tr>
<td>16, 18 ga.</td>
<td>18 ga.</td>
<td>18 ga.</td>
</tr>
</tbody>
</table>

MAX. 4'0"x6'0"  3'0"x7'0"  3'6"x7'0"  
MIN. 2'0"x6'8"  2'8"x6'8"  2'8"x6'8"

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**FIRE DOORS**

**Labeling Agencies:**
- Underwriters Laboratory
- Warnock Hersey

**Test:** UL 10B, UL 10C, UL 1784, & NFPA 252

- **Rating:** 20 Min, 3/4 HR, 1 HR, 1-1/2 HR, or 3 HR
- **Max. Size:** 4'0" x 8'0" (Single) 8'0" x 8'0" (Pair)
- **Designs:** F, G, N, V, E5 & E603

Not all ratings are available in all sizes, designs and materials.

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**PRODUCT SPECIFICATIONS:**

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

Doors are made full-flush or 6-panel embossed. Face sheets are commercial quality, hot-dipped, zinc-iron alloy coated A40 galvannealed steel or A60 galvannealed steel for Smooth Grain conforming to ASTM A653 and ASTM A924.

Doors have center edge seams with intermittent spot welds. Spot welds are filled & ground smooth. Doors have polyurethane core that is securely bonded to both face sheets. Doors have 16 gage inverted top and bottom end channels welded to both face sheets. Optional closed flush by steel caps screwed in place.

**Hardware Provisions:** Hinge preparations are handed. Hinge edges are mortised for 4-1/2" or 5" high, standard and heavy weight hinges (specify which). 14 gage steel hinge channels 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 locks in accordance with ANSI A115. Optional closer reinforcement is a 14 gage steel channel.

**Stain:** Comes standard with factory stain finish with a UV protective top coat. For standard stain finish samples contact a ASSA ABLOY Door Security Solutions Sales office, or contact a Ceco Door Customer Service Professional.

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### MATERIAL

**DOOR FACE SHEETS**

<table>
<thead>
<tr>
<th></th>
<th>LEVEL</th>
<th>RECOMMENDED DOOR FRAME MATERIAL</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>A60</td>
<td>A40</td>
</tr>
<tr>
<td>18 Gage Steel (4090 max.)</td>
<td>Heavy Duty</td>
<td>—</td>
</tr>
<tr>
<td>16 Gage Steel (4090 max.)</td>
<td>Extra Heavy Duty</td>
<td>—</td>
</tr>
<tr>
<td>18 Gage SG Steel (4090 max.)</td>
<td>Heavy Duty</td>
<td>Std</td>
</tr>
<tr>
<td>16 Gage SG Steel (4090 max.)</td>
<td>Extra Heavy Duty</td>
<td>Std</td>
</tr>
</tbody>
</table>

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**PERFORMANCE**

<table>
<thead>
<tr>
<th></th>
<th>Polystyrene</th>
</tr>
</thead>
<tbody>
<tr>
<td>Core Thermal Insulation:</td>
<td>Calculated R Factor = 6.35 (ASTM C518)</td>
</tr>
<tr>
<td>Door Sound Transmission</td>
<td>STC 24 (F Design, 18 Gage Face Sheets, ASTM E90 &amp; E413 [Fully Operable])</td>
</tr>
<tr>
<td>Physical Endurance /Level: ANSI A250.4</td>
<td>18 Gage: Level A (1,000,000 Cycles) 16 Gage: Level A (1,000,000 Cycles)</td>
</tr>
</tbody>
</table>

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

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**Experience a safer and more open world**

**RETURN TO TOP**
MADERA® DOOR MAINTENANCE

All Madera® Doors are factory finished with a very durable multi-step process. However, routine and periodic maintenance is required to prolong the life and durability of the doors.

The following procedures are recommended for surface care:

**Cleaning**
Use a household or commercial cleaning product approved for finished wood surfaces. The best cleaning solution for finished surfaces is white vinegar. Dilute 2 cups of vinegar to 1 gallon of warm water. Clean and dry immediately.

**Recoating Finished Madera® Doors**
Due to wear and soiling over a period of time, doors may require a topcoat to be reapplied.

When over coating finished Madera® Doors, please use the following recommendations:

The ONLY acceptable overcoats for Madera® doors are premium quality exterior varnishes that contain Ultra Violet Inhibitors/Absorbers. These products will usually contain the following verbiage in the label: “superior UV protection resists UV Rays......” These products will help maintain the UV resistance of the original Madera® finish. Marine grade Varnishes are the best. Do not use any water base varnishes.

Before finishing, sand the surface lightly, but thoroughly, with 320 grit sand paper or fine steel wool (0000). Remove dust or debris with a tack cloth. Please read the manufacturer’s recommendations on the label. TEST A SMALL AREA BEFORE APPLYING TO THE COMPLETE DOOR.

The information and statements herein are believed to be reliable but are not to be construed as a warranty or representation for which Ceco Door assumes legal responsibility. Users should undertake sufficient verification and testing to determine the suitability for their own particular purpose of any information or products referred to herein.