

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.



ENLARGEMENT OF DOOR EDGE

Our patented Laser-Edge welding process doesn't cost any more, and it provides a product of uncommon beauty and value. **And, our Lifetime Warranty speaks for itself!**

Note: Only those doors noted as Laser-Edge and/or listed with a product code of LE are considered Laser-Edge doors.



POLYSTYRENE CORE
15 LE LASER EDGE
25 LE LASER EDGE GALV.
17 LE SEAMLESS EDGE
27 LE SEAMLESS GALV.
21 LE REPLACEMENT

MINERALBOARD CORE*
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.

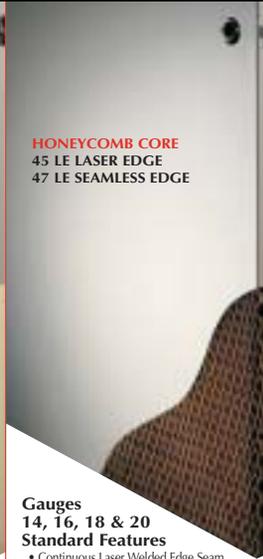


POLYURETHANE CORE
83 LE GALV.
85 LE LASER EDGE
87 LE SEAMLESS EDGE
89 LE SEAMLESS GALV.

Gauges 14, 16, 18 & 20

- Standard Features**
- Continuous Laser-Welded Edge Seam (Laser Edge)
 - Fully Bonded, Heat Cured, Nip Rolled, Core
 - Not 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 Panel with Half Glass
 - Custom Hardware Preps.
 - Decorator Colors Available
- 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
 - 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 35, 45, 47, 49, or 51
 - Double Meets STC 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 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 or Fiberglass Type Insulation
 - 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)
(LASER EDGE)

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.



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

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.



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*, 7/16" returns at 5 3/4"
- Unequal Rabbet Design
- Anchors Available for Masonry, Wood and Metal Stud Walls
- WHI - 3-hour and positive pressure embossment

Special Options

- Galvanized (A40) or (A60) Frames Available for Exterior or Interior 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
- Fire Rating Available up to 14" Jamb Depth

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
- WHI - 1 1/2-hour and positive pressure embossment

Special Options

- Galvanized (A40) or (A60) Frames for Interior 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" - 10 7/16" Jamb Depth
- 3" - 12 3/4" Return Standard

Special Options

- Galvanized (A40) or (A60) Frames Available for Interior or 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 16, 14 OR 12 GAUGE STEEL AVAILABLE

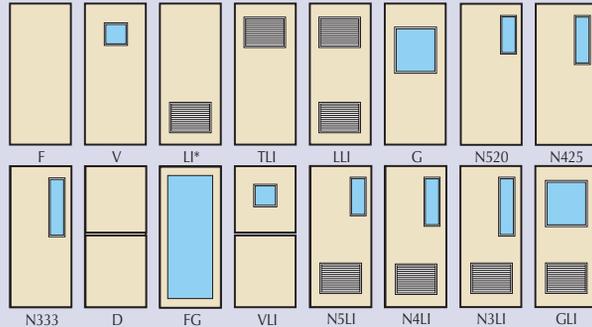
- 3000 Series Thermal Break Frames - Minimize Condensation Problems.*
- Available in a Variety of Specialized Face Trim, Backbends, and Return Profiles.
- Amweld offers Cove, Stepped Ogee and Stepped Face Trim for a Distinctive Custom Look.
- Pocket Slide Frame.
- Non-Handed Frame Systems for the Metal 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 (A60) galvanized only.

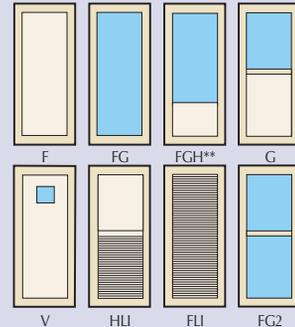


STANDARD DOOR DESIGN - SERIES 15LE/17LE, 25LE/27LE, 35LE/37LE, 45LE/47LE, 85LE/87LE, 700



*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

FIRE RATED FRAMES Description	Series Available						FIRE RATED DOORS Description	Series								
	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" *	•	•	•	•	•	•	•	•	•
3 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 (replacement door)	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 ² ·h·°F) Winter	W/(m ² ·K) Still Air	ft ² ·h·°F/Btu Winter	(m ² ·K/W) Still Air ²
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.

Manufacturers of Quality
Products for Over 60 Years!

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.

Dark Bronze and Polar White colors are available at a lower cost than all other colors, since these paint colors are inventoried in large quantities.

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.



** These colors are available at a lower price than all other colors, due to a higher quantity of products painted with these colors.

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.

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.



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.

SPECIFYING & ORDERING

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

- Log on to www.amweld.com and go to spec wizard
- Send an e-mail to: marketing@amweld.com and request a hard copy of the Amweld Technical Data Manual
- www.sweets.com
- www.FirstSourceONL.com
- www.arcat.com
- Contact an Amweld Customer Service Representative at 800-248-6116



A division of ARK II Manufacturing, LLC

Quality Hollow Metal Doors, Frames, and Architectural Hardware.

For product details and specific company information, visit our website at www.amweld.com or call our Ohio headquarters Toll Free at 800-248-6116.

DISTRIBUTION / SERVICE CENTERS

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

Southeast Distribution Center
955 Charles Street, #109
Longwood, FL 32750
407-478-0728
FAX: 407-478-0732

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

Texas Service Center
4712 Macro Drive
San Antonio, TX 78218
210-310-1115
FAX: 210-310-1291

PROUDLY INDEPENDENT AND FIERCELY LOYAL!