



Door Machinery



800-824-6242

NEW PRODUCTS



4900CNC Automatic Door Lite Machine

**FULLY AUTOMATED LITE CUTTING
AND LOCK PREP FOR DOORS
UP TO 8-0**

**No
Templates
Required**

Page 38



Magnum Pre-Drill Carriage

**DRILLS 6 HINGE SCREW PILOT HOLES
SIMULTANEOUSLY**

**Accelerates
Production**

**AVAILABLE ON NEW OR EXISTING
NORFIELD MAGNUMS (POST-'94)**

Page 4



535 Door Loader with Door Rotation

**ROTATES DOORS AS NEEDED FOR
RH AND LH SWING**

**Reduces
Prep Time**

**SIMPLIFIES DOOR STACKING AND
REDUCES CHANCE FOR ERROR**

Page 16



Staging Center

**STAGES DOORS FOR UNINTERRUPTED
PRODUCTION FLOW IN DOOR LINES THAT
INCLUDE BEVELLERS**

**Elimates
a
bottleneck**

Page 17



Edda 1500 Stretch Wrap Machine

**FAST, COST-EFFECTIVE METHOD FOR
PROTECTING DOORS AND/OR LINEAR
STOCK FROM SHIPPING AND HANDLING
DAMAGE**

**Fully
Automatic**

Page 36

Norfield

TABLE OF CONTENTS



DOOR MACHINES

E-Series Magnum Door Machine.....	2-4
Signature Series Magnum Door Machine	5-11
Eagle Automatic Prehung Door System.....	12-19
5000 Prehanging System	20-24
4000 Prehung Door Line.....	25-28

ACCESSORY DOOR SHOP MACHINES

1120 Automatic Casing Saw	29
V-Nailer Casing Assembly Machines.....	30
450 Automatic Flow-Through Stop Stitcher	31
440S Manual Stop Stitcher	32
Automatic Screwfeeder	32
2300ASR Automatic Strike Jamb Router	33
250M Strike Jamb Router	34
260MX Strike Jamb Router	34
Ball Catch Machine	35
Wraprot 1500 Pallet Wrapper	35
Spinner 1500 Automatic Stretch Wrap Machine	36
Prehangers Workbench	37
360S Rotating Tilt Table	45

EXTERIOR DOOR SHOP MACHINES

8900 Deep Lock Mortiser	9
4900CNC Automatic Door Lite Machine	38-39
4800XY Door Lite Machine	40-41
3800 Door Lite Machine	42-43
1700HJR Automatic Hinge Jamb Router.....	44
350H Hinge Mortising Machine.....	45
Talon CDS Exterior Door Assembly Station.....	46
Time Fold Series Exterior Door Line	47
EDM Exterior Door Machine	48

E-SERIES MAGNUM DOOR MACHINE

FAST AND VERSATILE

FULLY AUTOMATED LOCK PREP

INTEGRATED DOOR BEVELER

RESIDENTIAL, COMMERCIAL, OR ARCHITECTURAL DOORS

Flat jambs with or
without stop applied



Single
Rabbeted Jambs



Double
Rabbeted Jambs



Split Jambs



Shortened Cycle Time: Lock drill, latch drill, AND faceplate mortiser are fully automatic.



Quick & easy changeovers: switch between standard door heights in 30 seconds – no tools, no scales.



Process nearly any door: infinite adjustability for door width, height, and machining patterns.

*The most popular door machine in the industry
for over 40 years.*

Throughput rate

w/screwfeeder

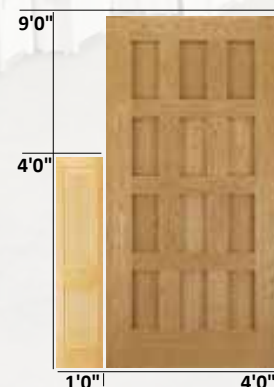
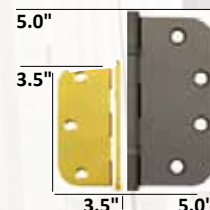
40

doors/hour

w/o screwfeeder

30

doors/hour



Quick change for flush hinge mortising on square and double-beveled doors.





Quick change for lock backset easily toggle between 2-3/8" & 2-3/4" backsets.



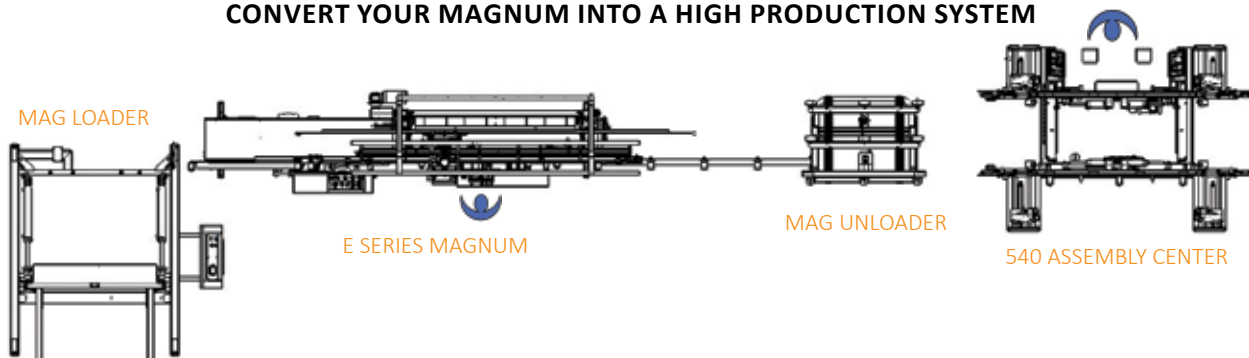
Customize doors for proper function: integrated heavy duty beveler includes edge easing.



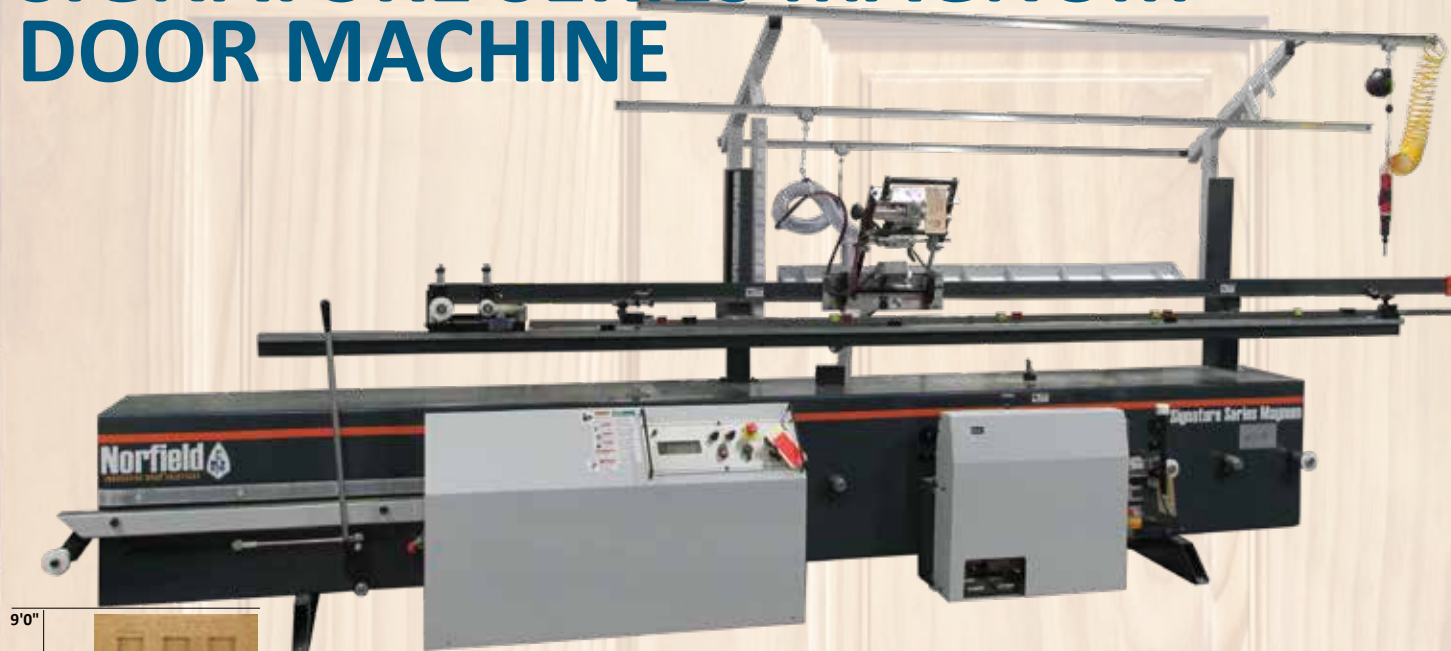
Pre-Drill Carriage: (optional) speeds throughput by simultaneously drilling all 6 pilot holes for each 3-1/2" hinge.

process	product	specs	features	options
 	E-Series Magnum Door Machine Fast easy production of residential, architectural, and commercial doors and jambs Large flexibility for hinge and lock location 30 second changeover between pre-set door configuration Integrated power-fed door beveler with edge easing sander	Door Width 1'0" to 4'0"* <i>*Hinge mortising only on doors narrower than 1'6.</i> Door Height 4'0" to 9'0" Door Thickness 1-3/8" to 2-1/4" Jamb Width 2-1/2" to 10-1/2" Jamb Thickness 1/2" to 1-5/8" Hinge Size 3" to 5" (3-1/2" - 5" or 3"-4-1/2") Hinge Radius 1/4" and 5/8" Lock Backsets 2-3/8" & 2-3/4" Faceplate Routing up to 1-1/4" x 2-3/4" Infeed Height 18" Outfeed Height 18" Approx. Shipping Wt. 4200 lbs. Floor Space 5'W x 18'L Electrical 208V/230V 3 Ph@30 Amps 208V/230V 1 Ph@30 Amps Air 2.2 CFM @ 90 PSI 8.5 CFM @ 90 PSI for manual screwdriver & pre-drill 10 CFM @ 90 PSI for auto screwfeed & pre-drill	<ul style="list-style-type: none"> • Automatic faceplate routing • Quick change backset between 2-3/8" & 2-3/4" • Quick change flush hinge mortising between square and double-bevel doors • Bolt on wear surfaces • Raised moulding capable • Standard equipment includes two index bars: one for doors up to 8-0 and one for doors up to 9-0 • Partial lock boring for door pulls • Thumb switch controlled pneumatic jamb thickness adjustment • Self-centering butt router for easy hinge mortising • 3.5° beveler/sizer with edge-easing sanders • Variable speed power feed allows for soft and hardwood doors • Infinite door width adjustment 	<ul style="list-style-type: none"> • 2nd butt router with tram rail extension for easy switch between 1/4" and 5/8" radius • Scaled index bar • Spare parts package • Air inline screwdriver kit for quick hinge application • Air inline pre-drill kit for easier hinge application on hardwood doors • Vacuum for dust collection • Auto Screw Feeder • 9' index bar • 8' index bar • Extended part warranty • Additional jamb clamp • Extended hinge router for mull post prep

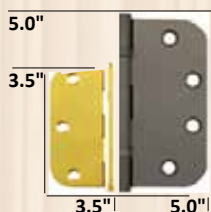
CONVERT YOUR MAGNUM INTO A HIGH PRODUCTION SYSTEM



SIGNATURE SERIES MAGNUM DOOR MACHINE



PROCESS RESIDENTIAL, COMMERCIAL, OR ARCHITECTURAL DOORS.



Double
Rabbeted Jamb



Split Jamb

Flat Jamb with
stop applied



Single
Rabbeted Jamb

Throughput rate

w/screwfeeder
30
doors/hour

w/o screwfeeder
20-25
doors/hour



Fast, consistent production: prep for lock and hinges in door and hinge jamb in about 1 minute.



Process almost any door: infinite adjustability for hinge/lock locations and door height/width.



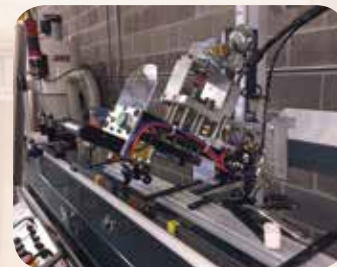
Precise machining every time: pre-set index bars dictate correct reveals and hardware locations.





High quality output: mortise for flush hinges in beveled or square door stiles.



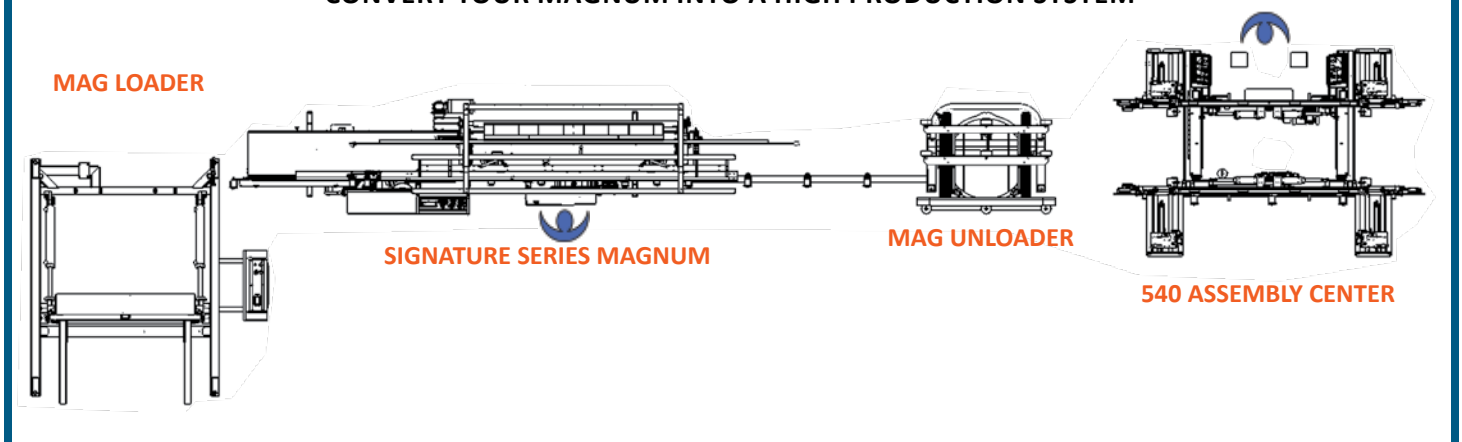
Optional door beveler: size and bevel doors for proper performance.



Pre-Drill Carriage: (optional) speeds throughput by simultaneously drilling all 6 pilot holes for each 3-1/2" hinge.

process	product	specs	features	options
 	<p>Signature Series Magnum Door Machine</p> <p>Most versatile machine on the market.</p> <p>Fast, easy production of residential prehangs.</p> <p>Custom doors.</p> <p>Specials and replacement doors.</p> <p>High end architectural and commercial doors.</p>	<p>Door Width 1'0" to 4'0"* *Hinge mortising only on doors narrower than 1'6.</p> <p>Door Height 4'0" to 9'0"</p> <p>Door Thickness 1-3/8" to 2-1/4"</p> <p>Jamb Width 2-1/2" to 10-1/2"</p> <p>Jamb Thickness 1/2" to 1-5/8"</p> <p>Hinge Size 3-1/2" to 5"</p> <p>Hinge Radius 1/4" and 5/8"</p> <p>Lock Backsets 2-3/8" to 5"</p> <p>Faceplate Routing up to 1-1/4" x 2-3/4"</p> <p>Infeed Height 18"</p> <p>Outfeed Height 18"</p> <p>Approx. Shipping Wt. 3,500 lbs.</p> <p>Floor Space 5'W x 18'L</p> <p>Electrical 208V/230V 3 Ph@30 Amps 208V/230V 1 Ph@30 Amps</p> <p>Air 2.2 CFM @ 90 PSI 8.5 CFM @ 90 PSI for manual screwdriver & pre-drill 10 CFM @ 90 PSI for auto screwfeed & pre-drill</p>	<ul style="list-style-type: none"> Machine doors from 4' to 9' tall and from 1' to 4' wide Raised moulding compatible Standard equipment includes two index bars: one for doors up to 8-0 and one for doors up to 9-0 Partial lock boring for door pulls Thumb switch controlled pneumatic jamb thickness adjustment Insert cutters for low cost cutting blade replacement Self-centering butt router for easy hinge mortising 3.5º beveler/sizer 3.5º hinge mortising Self-centering face plate mortising Auto-start and power lift on faceplate router for ease of routing Infinite door width adjustment Power feed wheel bypass Two year part warranty 	<ul style="list-style-type: none"> 2nd butt router with tram rail extension for easy switch between 1/4" and 5/8" radius Scaled index bar Spare parts package Air inline screwdriver kit for quick hinge application Air inline pre-drill kit for easier hinge application on hardwood doors Vacuum for dust collection Auto Screw Feeder 9' index bar 8' index bar Sizer/Beveler Extended part warranty Extended hinge router for mull post prep

CONVERT YOUR MAGNUM INTO A HIGH PRODUCTION SYSTEM



MAGNUM ACCESSORY MACHINES

MAGNUM LOADER

SPEED PRODUCTION BY MINIMIZING OPERATOR MOTION

FEED HEAVY DOORS INTO THE MAGNUM WITHOUT MANUAL LIFTING

Standard Features

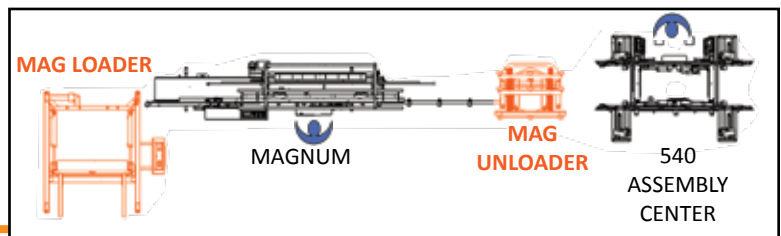
- 2,800 lb. capacity allows for stacks of the heaviest doors
- 48" stack height (including pallet) accommodates most house jobs
- Heavy duty construction for long life
- Photo-eye automatically stages the next door
- Simple operator friendly controls

Options

- Front Load Conveyor
- Side Load Conveyor

Specs

Door width	1'0" to 4'0"
Door height	4'6" to 9'0"
Door thickness	1-3/8" to 2-1/4"
Infeed height	12" horizontal
Outfeed height	18"
Electrical	208V or 230V 3 Ph
Floor space req. (min.)	8' x 7'10"
Approx. shipping wt.	1,800 lbs.



MAGNUM UNLOADER

EFFICIENTLY CONVEY DOORS FROM MAGNUM TO ASSEMBLY STATION WITHOUT LIFTING

Standard Features

- Non-marking rollers
- Foot pedal activation
- Tilts 90° vertical to horizontal
- Connector bracket with rollers included

Option

- Turntable for changing material flow direction

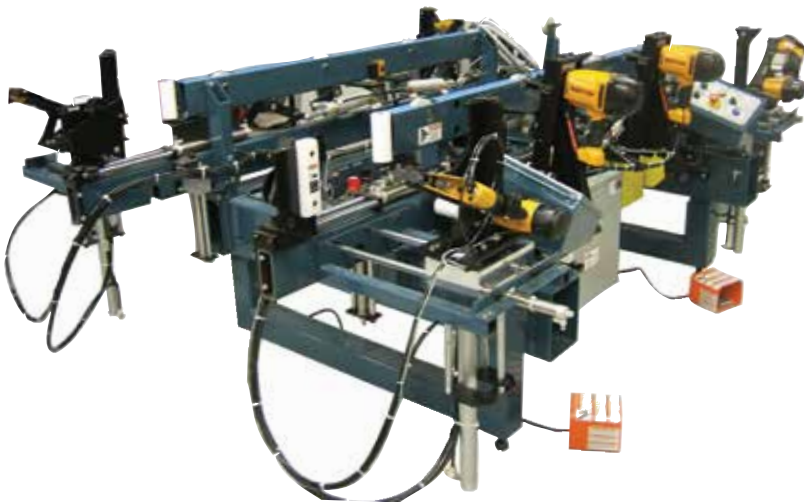
Specs

Door width	1'6" to 4'0"
Door height	up to 9'0"
Door thickness	1-3/8" to 2-1/4"
Infeed height	18"
Outfeed height	36" - 41"
Electrical	None
Pneumatic	.5CFM @ 90PSI

Floor Space req. (min.)

3'6" x 7'10" short bar	
3'6" x 9'10" medium bar	
3'6" x 11'10" long bar	
Approx. shipping wt	400 lbs





540AC AUTOMATIC DOOR FRAME ASSEMBLY MACHINE

QUICK, PRECISE DOOR FRAME ASSEMBLY WITH ONE OPERATOR

Standard Features

- 25-second cycle with one operator
- Quick change for varying jamb widths and staple patterns
- Foot pedal control frees operator's hands for material placement
- Consistent staple location and countersink
- Non-marring rollers safely process pre-finished doors
- Raised moulding ready

Options

- Strike Side Nailing for shipping nail
- Single outfeed support roller
- Split jamb staplers (to hold halves together during handling)
- 10' outfeed conveyor

Specs

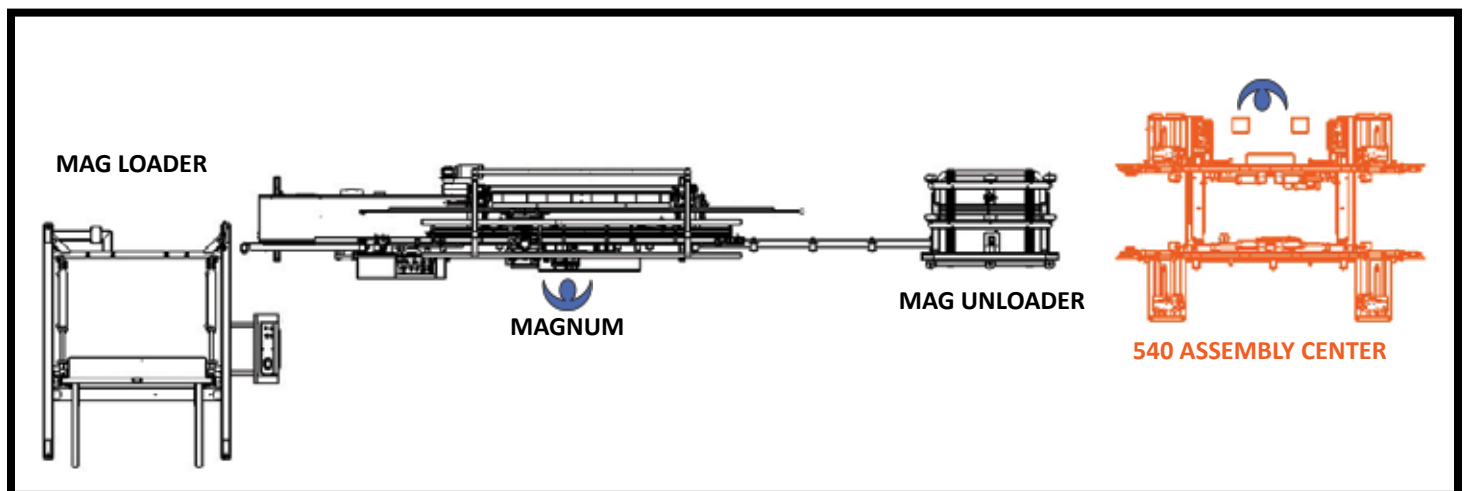
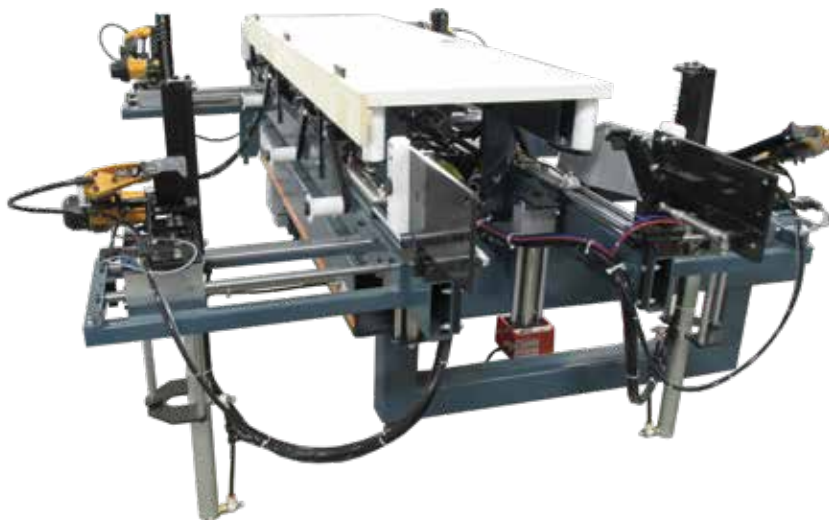
Door Width	1'6" to 4'0"
Door Height	6'6" to 8'0"
Door Thickness	1-3/8" to 1-3/4"

Jamb Width	2-1/2" to 10-1/2"
Jamb Height	6'6" to 8'0"
Jamb Thickness	3/8" to 1-1/2"

Raised Mouldings:

Max. Height:	3/4"
Min. Dim. to Door Edge:	3-1/8"

Electrical	1PH 120V @ 10Amps
Pneumatic	15CFM @ 100psi 1/2" supply
Approx. Shipping Wt.	1400 lbs.





8900 AUTOMATIC DEEP LOCK MORTISER

BUILT-IN FACEPLATE ROUTING AND HANDS-FREE POCKET MORTISING

Standard Features

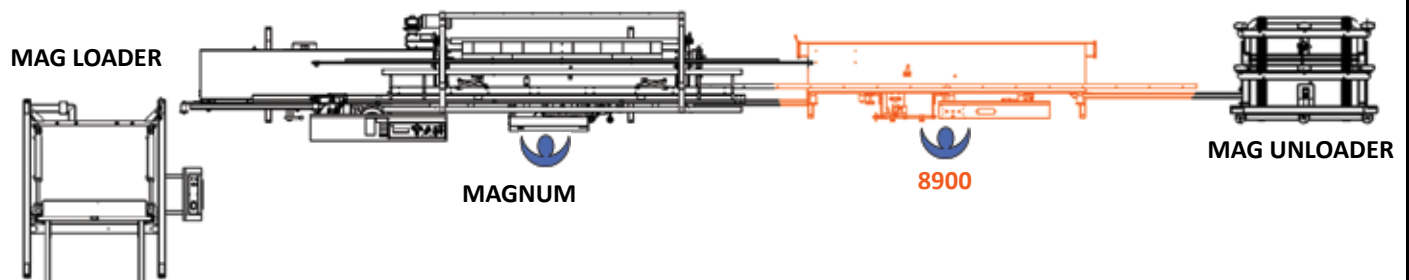
- Quick setup using turret, which controls width for four settings while adjustable stop is used for fine tuning the fit of the plate
- Integrate into a Magnum System
- Mortiser and faceplate router dust collection
- Faceplate routing with square to face of door or on a 3° bevel; Changeover time: 15 sec

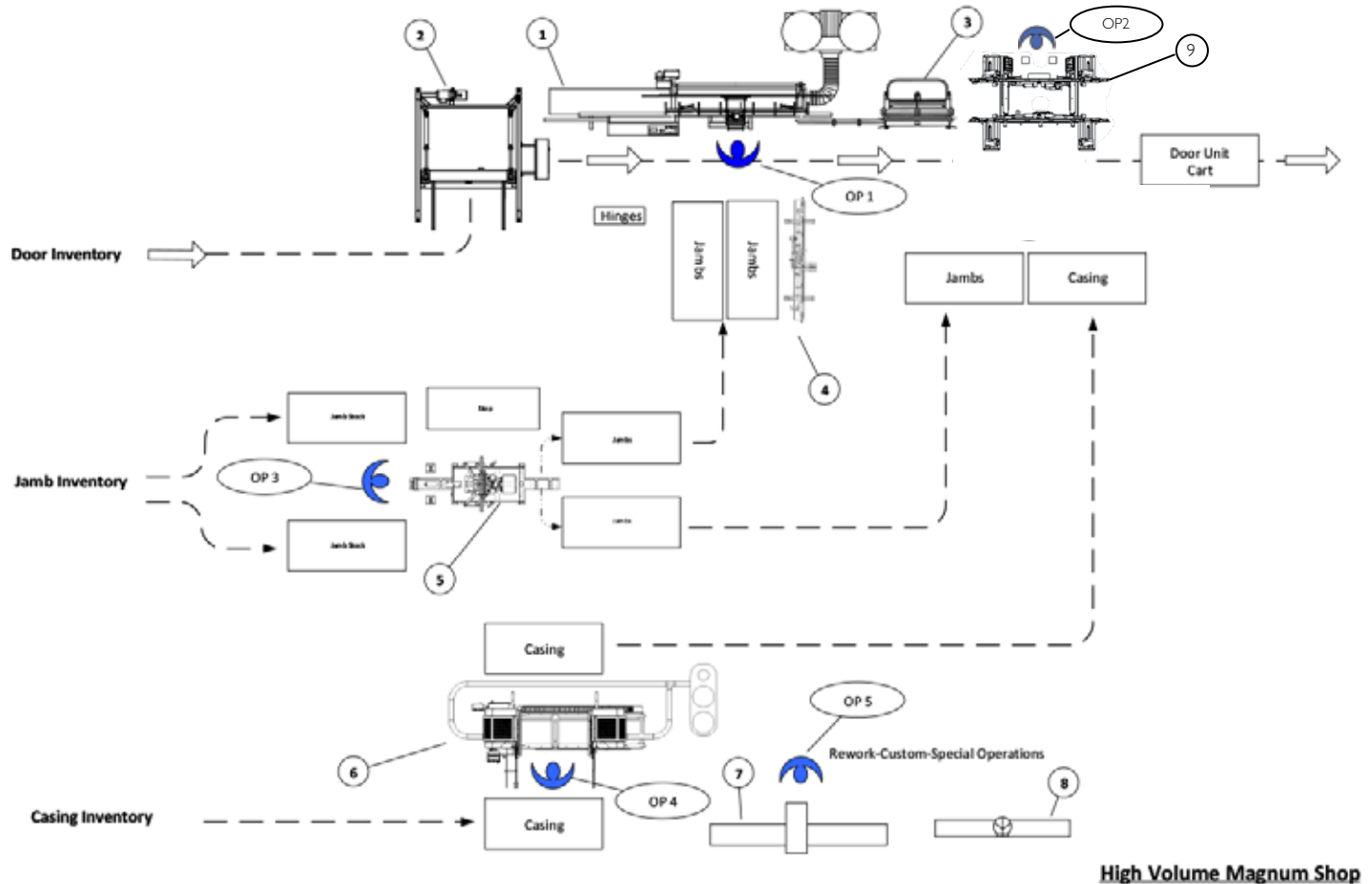
Specs

Door Height	6'4" to 9'0"	Electrical	208/230V @ 15 Amps
Door Thickness	1-3/8" to 2-1/4"	Pneumatic	2 CFM @ 100 psi
Door Width	no limit	Floor Space Req. (min.)	3' x 15'
Pocket Length	1" to 8"	Approx. Shipping Wt.	1100 lbs.
Pocket Depth	up to 6"		
Pocket Width	3/4" to 1-1/4"		
Faceplate Width	1" to 1-1/4"		
Faceplate Length	1/2" to 8-1/2"		
Faceplate Depth	up to 3/8"		



MAGNUM LINE WITH 8900 DEEP LOCK MORTISER





SUGGESTED MAGNUM SYSTEM SHOP LAYOUT

MACHINERY

- | | |
|------------------------|---------------------------------------|
| 1. E-Series/Sig Magnum | Door machine |
| 2. Magnum Loader | Loads a stack of doors |
| 3. Magnum Unloader | Tilts door horizontal for assembly |
| 4. 250M/250MX | Strike jamb router |
| 5. 450 | Stop stitcher |
| 6. 1120 | Double-end trim saw |
| 7. Radial Arm Saw | Cuts jamb and stop material to length |
| 8. Chop Saw | Cuts and miters custom materials |
| 9. 540 | Assembles door |

MACHINE THROUGHPUT RATE

Magnum = 30 doors per hour

FLOOR SPACE REQUIREMENT

4,000 Square Feet

ELECTRICAL REQUIREMENT

50 Amps @ 230V 3-Phase (Plus Vacuum Input)

AIR SUPPLY

30 CFM @ 90 PSI

MANPOWER REQUIREMENT

4 people

Operator 1

Door Machine Operator performs all machining to door and hinge jamb, including hinge application.

Operator 2

Door Unit Assembler assembles the frame around the door and applies casing to complete the door unit.

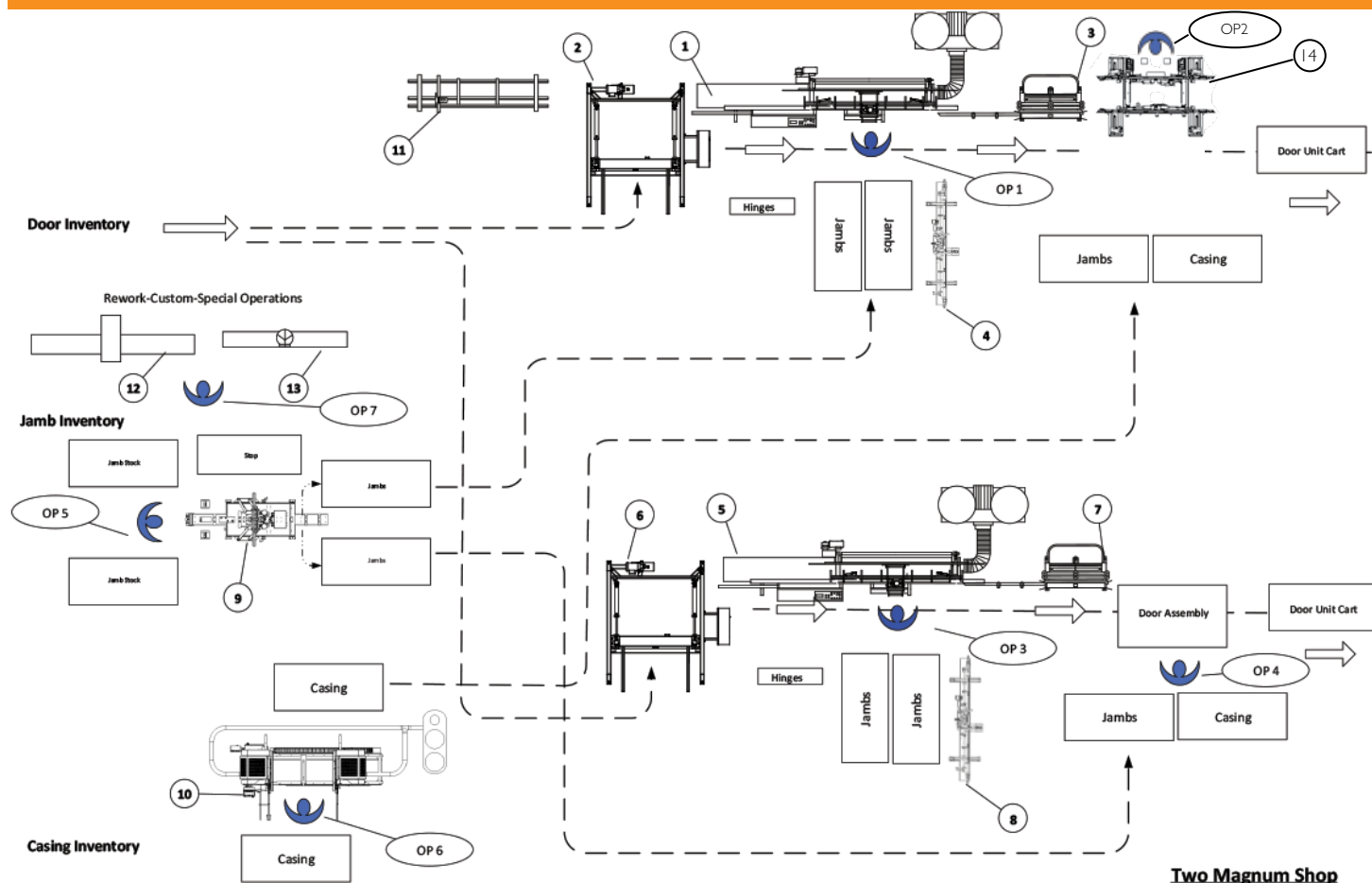
Operator 3

450 Operator, applies stop to flat jambs and stocks the primary line as well as machining the strike jambs on the 250M/250MX.

Operator 4 and 5

1120 Operator and any custom jamb or door prep.

Since the stations shown are not full time jobs, operators 4 and 5 are the same person, filling to supply sub-components to the line as needed. Usually these positions include pulling blank doors and all sub-components.



SUGGESTED MAGNUM SYSTEM SHOP LAYOUT

MACHINERY

- | | |
|--------------------------|---|
| 1. E-Series / Sig Magnum | Door machine for interior doors |
| 2. Magnum Loader | Loads a stack of doors |
| 3. Magnum Unloader | Tilts door horizontal for assembly |
| 4. 250M / 250MX | Strike jamb router |
| 5. Magnum | For special, custom, and exterior units |
| 6. Magnum Loader | Loads a stack of doors |
| 7. Magnum Unloader | Tilts door horizontal for assembly |
| 8. 250M / 250MX | Strike jamb router |
| 9. 450 | Stop jamb sticher |
| 10. 1120 | Double end trim saw for mitering casing |
| 11. Door Cut-Off Saw | Cuts doors for custom applications |
| 12. Radial Arm Saw | Cuts jamb and stop material to length |
| 13. Miter/Casing Saw | Cuts jamb, casing and stop |
| 14. 540 | Assembles door |

MACHINE THROUGHPUT RATE

Magnum = 30 doors per hour

FLOOR SPACE REQUIREMENT

5,525 Square Feet

ELECTRICAL REQUIREMENT

80 Amps @ 230V 3-Phase (Plus Vacuum Input)

AIR SUPPLY

40 CFM @ 90 PSI

MANPOWER REQUIREMENT

6 people

Operators 1 and 3

Door Machine Operator performs all machining to door and hinge jamb.

Operator 2

Door Unit Assembler assembles the frame around the door and applies casing to complete the door unit.

Operator 3 and 4

Door Unit Assemblers assemble the frame and apply casing to the door unit.

Operator 5

450 Operator prepares flat jambs by applying stop.

Operators 6 and 7

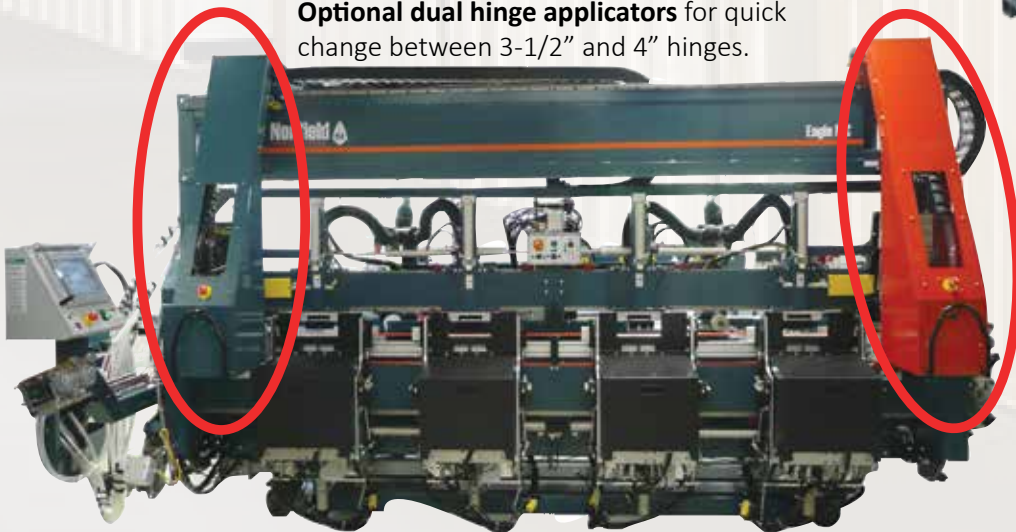
1120 Operator, since the stations shown are not full time jobs, operators 6 and 7 are the same person, filling in to supply sub-components to the line as needed. Usually these positions include pulling blank doors and all sub-components.

EAGLE AUTOMATIC PREHUNG DOOR SYSTEM

FOR HIGH PRODUCTION
OF PREHUNG DOORS
UP TO 8-0



Optional dual hinge applicators for quick
change between 3-1/2" and 4" hinges.





High speed: produce a door every 45-60 seconds with the optional hinge applicator.



Flexible: instant change-overs between 6-8, 7-0, and 8-0 doors using graphical touchscreen.



Quick screw color changes and easy access to automatic screw-feeder.



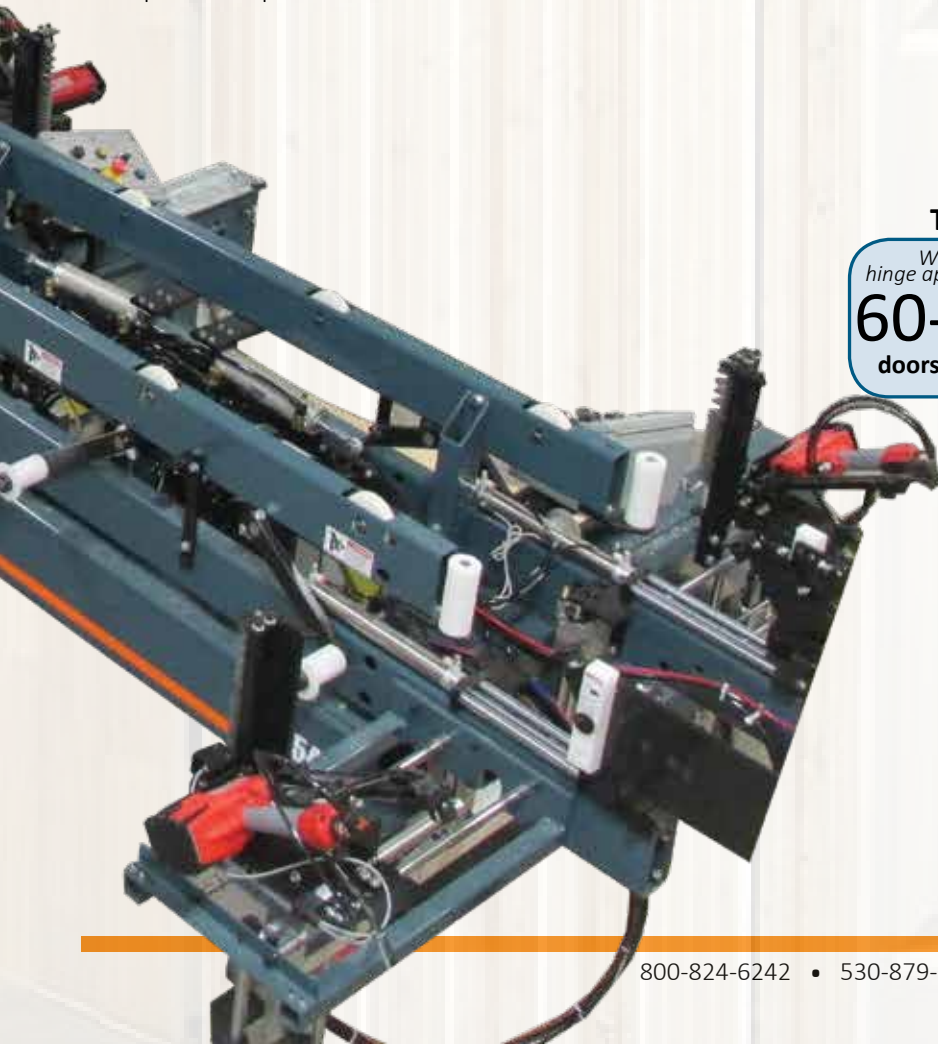
High Quality: prevent splits and crooked screws with the optional pilot hole predrills.



Optional automatic ball catch drills



Flush hinges in square or double-beveled doors with zero change-over time.



Throughput rate

With
hinge applicator
60-80
doors/hour

Without
hinge applicator
30-40
doors/hour



Flat Jamb with
stop applied



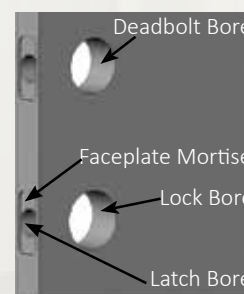
Single
Rabbeted Jamb



Double
Rabbeted Jamb



Split Jamb



EAGLE MC STANDARD FEATURES

- One-touch door height change-overs for doors up to 8'-0"
- Automatic hinge mortising in door and hinge jamb
- Automatic lock drilling, latch drilling, and faceplate mortising
- Automatic deadbolt prep
- Automatic door infeed, width adjustment, and positioning
- One-touch powered tilt for flush hinge mortising in square or double beveled doors
- One-touch change-over between 3-1/2" and 4" hinge mortising
- 10" pictorial color touchscreen control panel
- On-screen diagnostics and troubleshooting
- Raised moulding ready
- Processes raised moulding, louvered, and prefinished doors
- Quick-change between 3 different hinge thickness
- Hinge routing modules compensate for convex or concave door edges

EAGLE MC OPTIONS

- Automatic Hinge Applicator with pre-drill and auto screwfeeding for 3-1/2" hinges
- Automatic Hinge Applicator with pre-drill and auto screwfeeding for 4" hinges
- Automatic hinge screw pilot hole pre-drill for 3-1/2" hinges
- Automatic hinge screw pilot hole pre-drills for 4" hinges
- Automatic ball catch drills (cycles during hinge/lock machining)
- Dust collector with auto start
- Spare parts package

EAGLE MC INSTALLATION

Shipping Wt.	6,500 lbs
Floor Space	10'W x 13'L x 7'6"H
Electrical	208/230V 3Ph@50 Amp
Air	50CFM @ 100 PSI 1" air supply with 3/4" air line

EAGLE MC SPECIFICATIONS

Capabilities

Door Width	1'6" to 3'6"
Door Height	6'6" to 8'0"
Door Thickness	1-3/8" to 1-3/4"
Jamb Width	2-1/2" to 7-1/2"
Jamb Height	6'6" to 8'0"
Jamb Thickness	3/8" to 1-1/2"

Hinge Size	3-1/2" to 4"
Hinge Radius	5/8"

Hinge per door	2, 3 or 4
----------------	-----------

Min. distance from the top of the door to the edge of the hinge mortise is 4-1/2".

Lock and deadbolt bore

Diameter	1/2" to 2-1/8"
Lock Height	35" to 65"
Backset	2-3/8" and 2-3/4"

Latch bore

Diameter	1/2" to 1-1/4"
Lock Height	34-1/2" to 65-1/2"

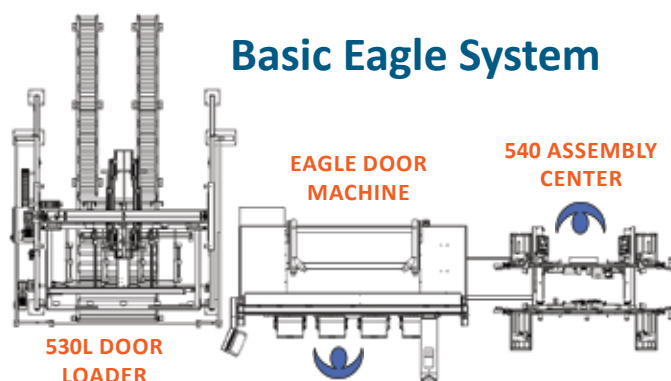
Faceplate mortise

Plate Width	up to 1-1/2"
Plate Length	up to 2-1/2"

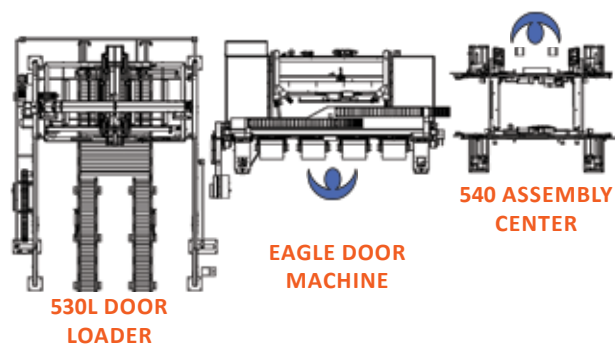


We'll customize your Eagle line to fit your production needs.

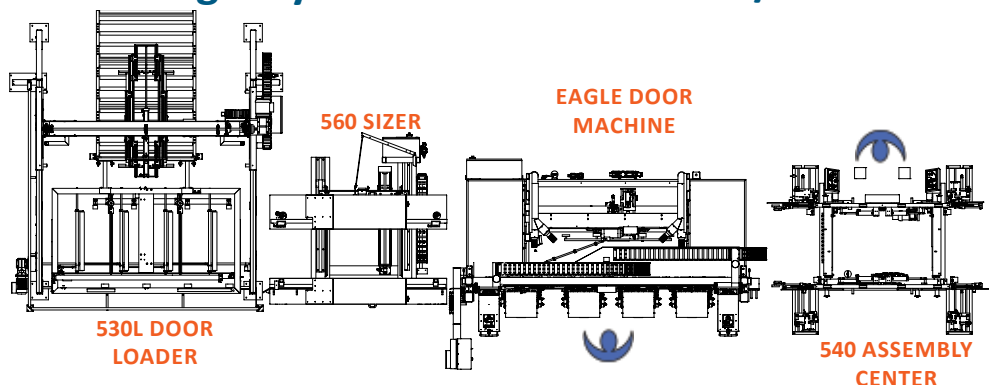
Basic Eagle System



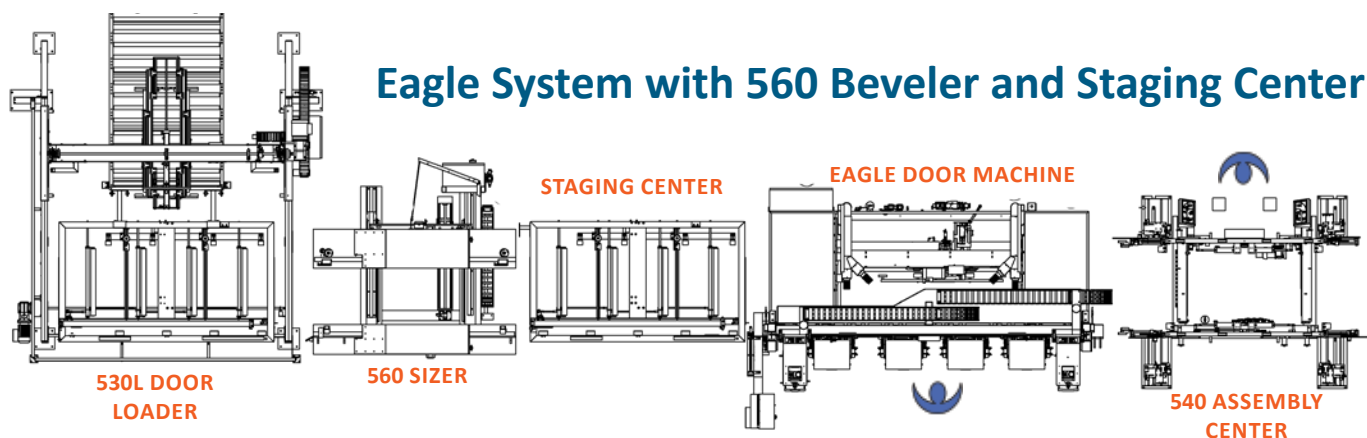
Basic Eagle System with Reversed Door Loader



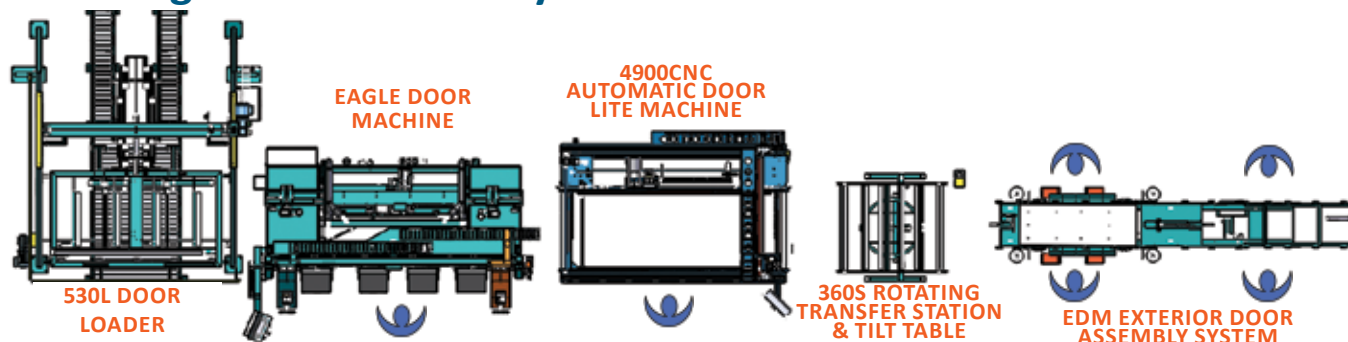
Eagle System with 560 Beveler/Sizer



Eagle System with 560 Beveler and Staging Center



Eagle Exterior Door System with 4900CNC Door Lite Cutter





(Standard safety
guards removed
for photo)

530L AUTOMATIC DOOR LOADER

AUTOMATICALLY LIFTS AND FEEDS DOORS FROM FULL STACK

530L & 535L Standard Features

- Draws from 7' high door stack – no adjustments for door widths or thicknesses
- Automatically feeds flush, raised panel, or raised moulding doors with no adjustments
- Touchscreen controls located at door machine to minimize operator motion
 - *(When mated to a Norfield Eagle or 5000, controls integrated into door machine touchscreen panel)
- Non-marring rollers convey prefinished doors without scratching
- May be adapted to an existing horizontal door line
- Fully guarded for worker safety

Options

- Extended conveyors for staging door stacks
- Reverse feed configuration (doors feed from front side of line) (530 only)
- Powered door stack feeder – operator may replace depleted stacks without leaving door machine
- Spare parts

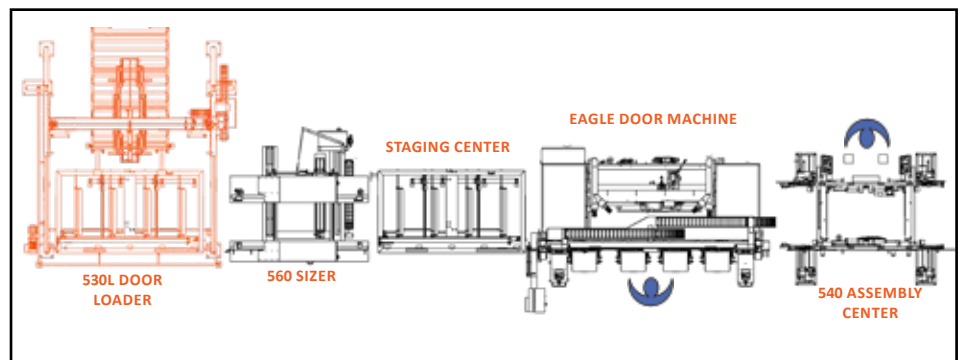
530L & 535L Specs

Door Width	1'6" to 3'6"
Door Height	6'6" to 8'0"
Door Thickness	1-3/8" to 1-3/4"
Door Weight	up to 150 lbs.
Max Stack Height	96"
Electrical	3Ph 208-230V @ 25 Amps
Pneumatics	15CFM @ 100psi
Floor Space	13'W x 12'L x 11'-6"H
Overall Height	11'2"
Approx Shipping Wt.	5500 lbs.



535L AUTOMATIC DOOR LOADER WITH DOOR ROTATION

ROTATE DOORS AS NEEDED TO SELECT RIGHT AND LEFT SWING



560SB AUTOMATIC DOOR SIZER/BEVELER

APPLY 3.5° BEVEL TO LOCK SIDE OF DOOR



Standard Features

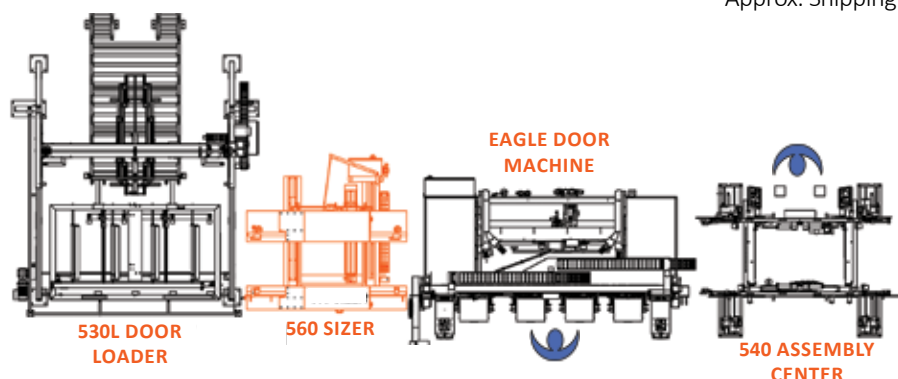
- Adjustable power feed rates for various wood hardnesses
- One-touch quick-change from 0 to 3/16" undercut
- Capable of machining doors with raised moulding
- Integrates into a Norfield high speed door production systems
- Adjustable sanding wheels for easing sharp corners

Option

- Staging center
- Spare parts
- Dust collection

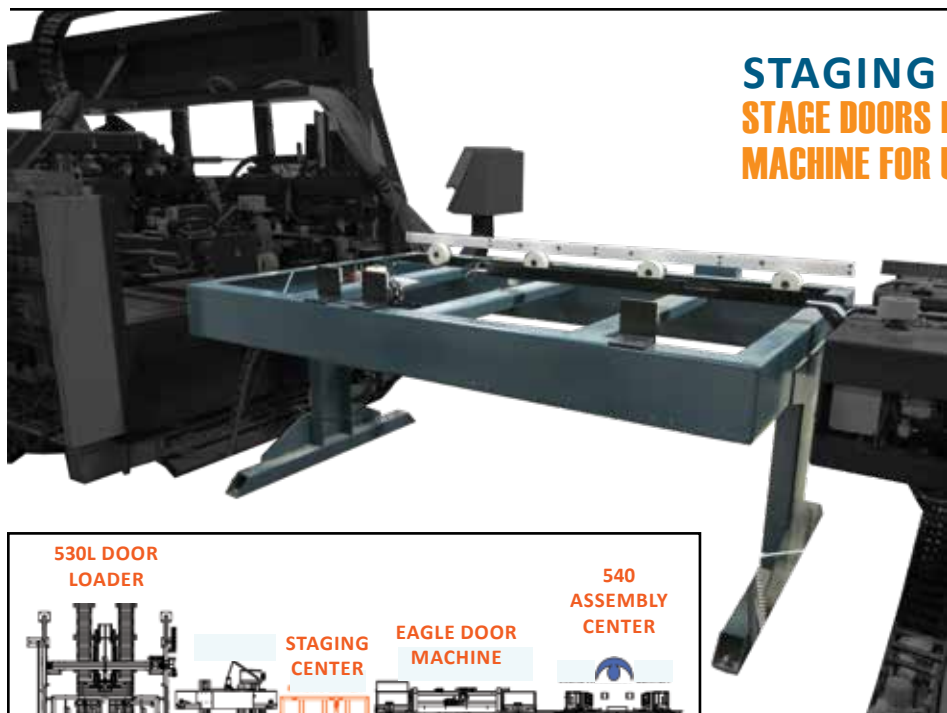
Specs

Door Width	1'6" to 4'0"
Door Height	6'6" to 8'0"
Door Thickness	1-3/8" to 1-3/4"
Electrical	3Ph 208-230V @ 150 Amps
Pneumatics	10 CFM @ 90 psi
Approx. Shipping Wt.	2500lbs.



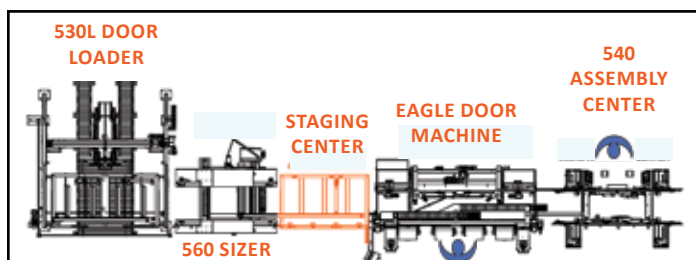
STAGING CENTER

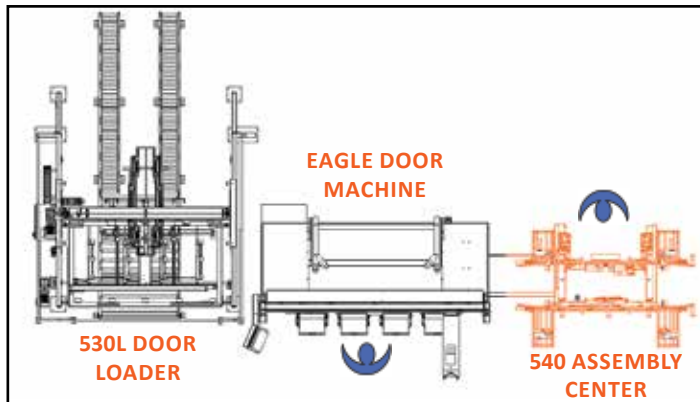
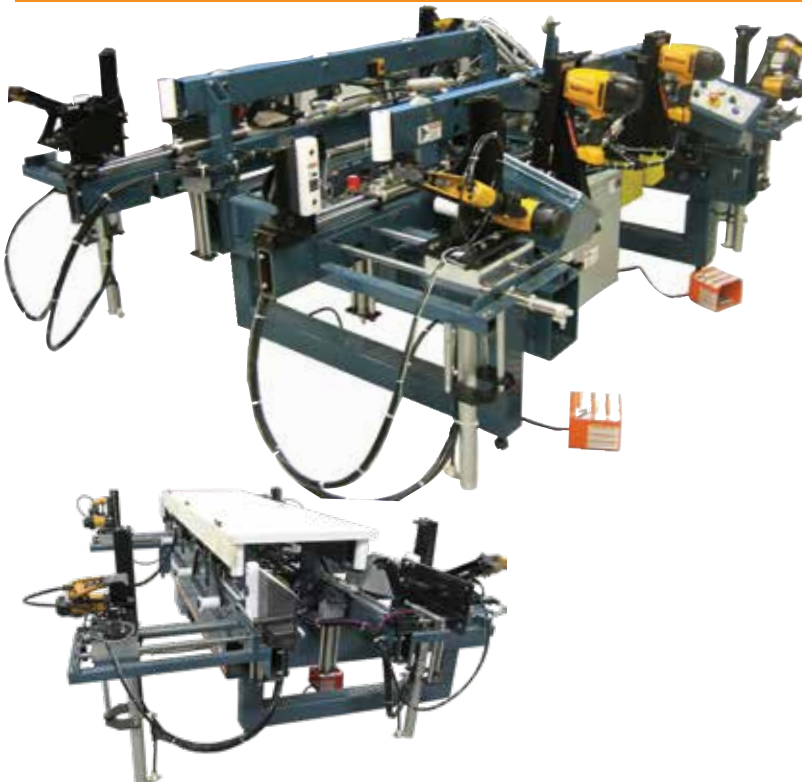
STAGE DOORS BETWEEN BEVELER AND DOOR MACHINE FOR UNINTERRUPTED PRODUCTION FLOW



Specs

Door Width	1'6" to 3'6"
Door Height	6'6" to 8'0"
Door Thickness	1-3/8" to 1-3/4"
Electrical	supplied by sizer
Pneumatic	supplied by sizer
Floor Space Req. (min.)	92" x 57"
Shipping Wt.	600 lbs.





540AC AUTOMATIC DOOR FRAME ASSEMBLY MACHINE QUICK, PRECISE DOOR FRAME ASSEMBLY WITH ONE OPERATOR

Standard Features

- 25-second cycle with one operator
- Quick change for varying jamb widths and staple patterns
- Foot pedal control frees operator's hands for material placement
- Consistent staple location and countersink
- Non-marring rollers safely process pre-finished doors
- Raised moulding ready

Options

- Strike Side Nailing for shipping nail
- Single outfeed support roller
- Split jamb staplers (to hold halves together during handling)
- 10' outfeed conveyor

Specs

Door Width 1'6" to 3'6"

(Up to 4'0" with Magnum Line)

Door Height 6'6" to 8'0"

Door Thickness 1-3/8" to 1-3/4"

Jamb Width 2-1/2" to 10-1/2"

Jamb Height 6'6" to 8'0"

Jamb Thickness 3/8" to 1-1/2"

Raised Mouldings:

Max. Height: 3/4"

Min. Dim. to Door Edge: 3-1/8"

Electrical 1PH 120V @ 10Amps

Pneumatic 15CFM @ 100psi 1/2" supply

Approx. Shipping Wt. 1400 lbs.

360S ROTATING TILT TABLE TILT FINISHED DOOR UNITS UPRIGHT FOR EASY TRANSFER TO DOOR CART

360S Standard Features

- Rotate top-first units 180° then tilt to right-side-up orientation
- Foot-pedal control for hands-free operation
- Facilitates door lifting and reduces opportunity for back injuries
- Processes door slabs or finished units

Specs

Door Width 1'0" to 3'6"

Door Height up to 8'0"

Supports Unit Weight 200 lbs.

Infeed height at horizontal position 40"

Pneumatic 1 CFM @ 90 psi

Floor Space Req. (min.) 9' dia.

Approx. Shipping Wt. 400 lbs.



MACHINERY

- | | |
|--------------------|-------------------------------------|
| 1. Eagle System | Automated door machine system |
| 2. 2300 | Automated strike jamb router |
| 3. Magnum Loader | Loader for stack loading of Magnum |
| 4. Magnum | Door machine custom, exterior units |
| 5. Magnum Unloader | Feeds assembly table |
| 6. 450 | Stop jamb stitcher |
| 7. 1120 | Double-end trim saw |

Eagle System = 45 doors per hour (6'8" to 8'0")
Magnum = 30 doors per hour

6,000 Square Feet

100 Amps @ 230V 3-Phase (Plus Vacuum Input)

60 CFM @ 90 PSI

7 people total for both lines, plus stock-puller/warehouse worker (not shown).

Eagle System Machining Stage Operator.

Eagle System Assembly Stage Operator.

Eagle System Casing Applicator.

Magnum Operator- custom specials and exteriors.

Door Unit Assemblers- for custom special, and exterior units; frame assembly and casing application.

450 Operator- for casing and jamb preparation.

1120 Operator- for casing and jamb preparation. Also stocks primary line.

5000 PREHANGING SYSTEM

**HIGH SPEED PREHUNG DOOR SYSTEM WITH
AUTOMATIC HINGE APPLICATION**

System Includes:

530 LOADER

5000 MACHINING CENTER

540 ASSEMBLY CENTER



Throughput rate

*With
High speed option*

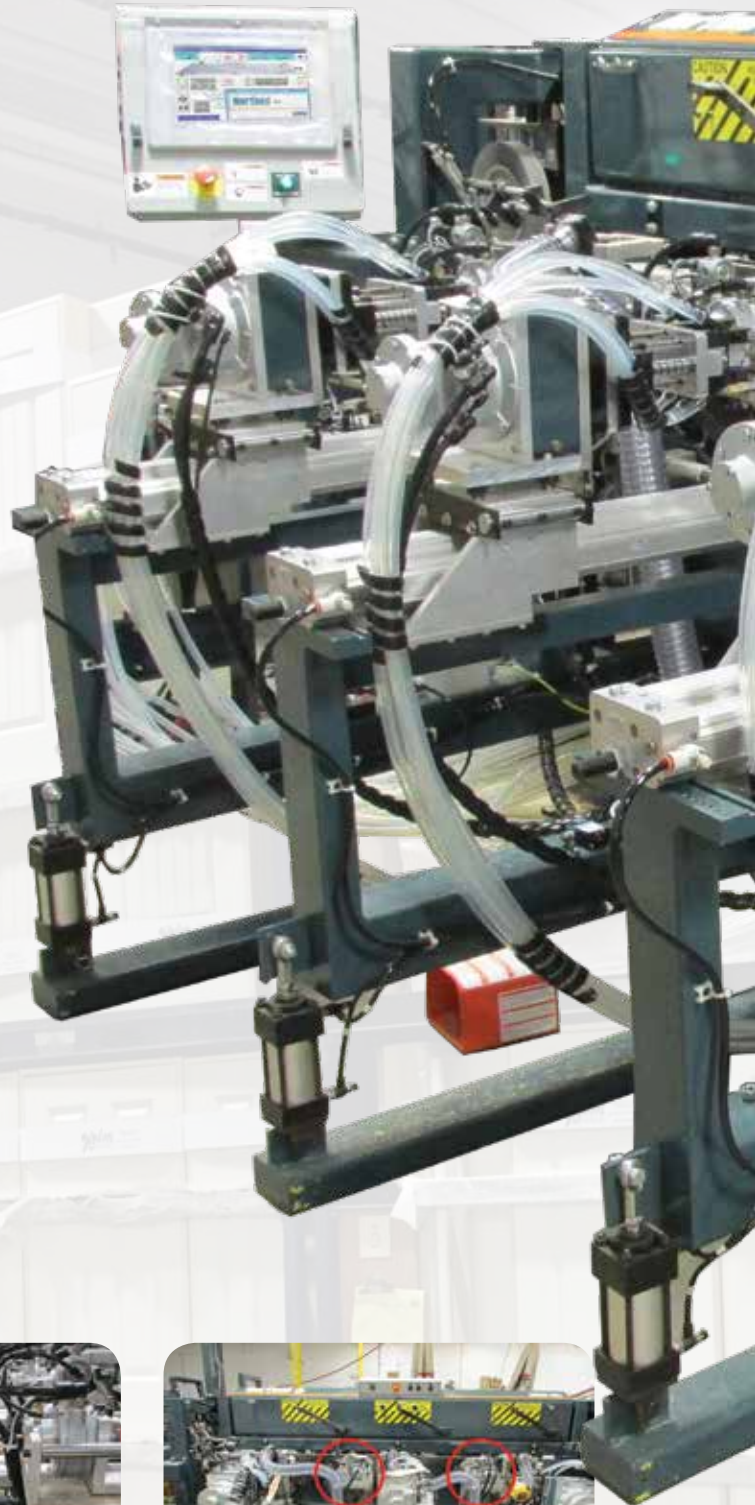
140

doors/hour

*Standard
Speed*

120

doors/hour



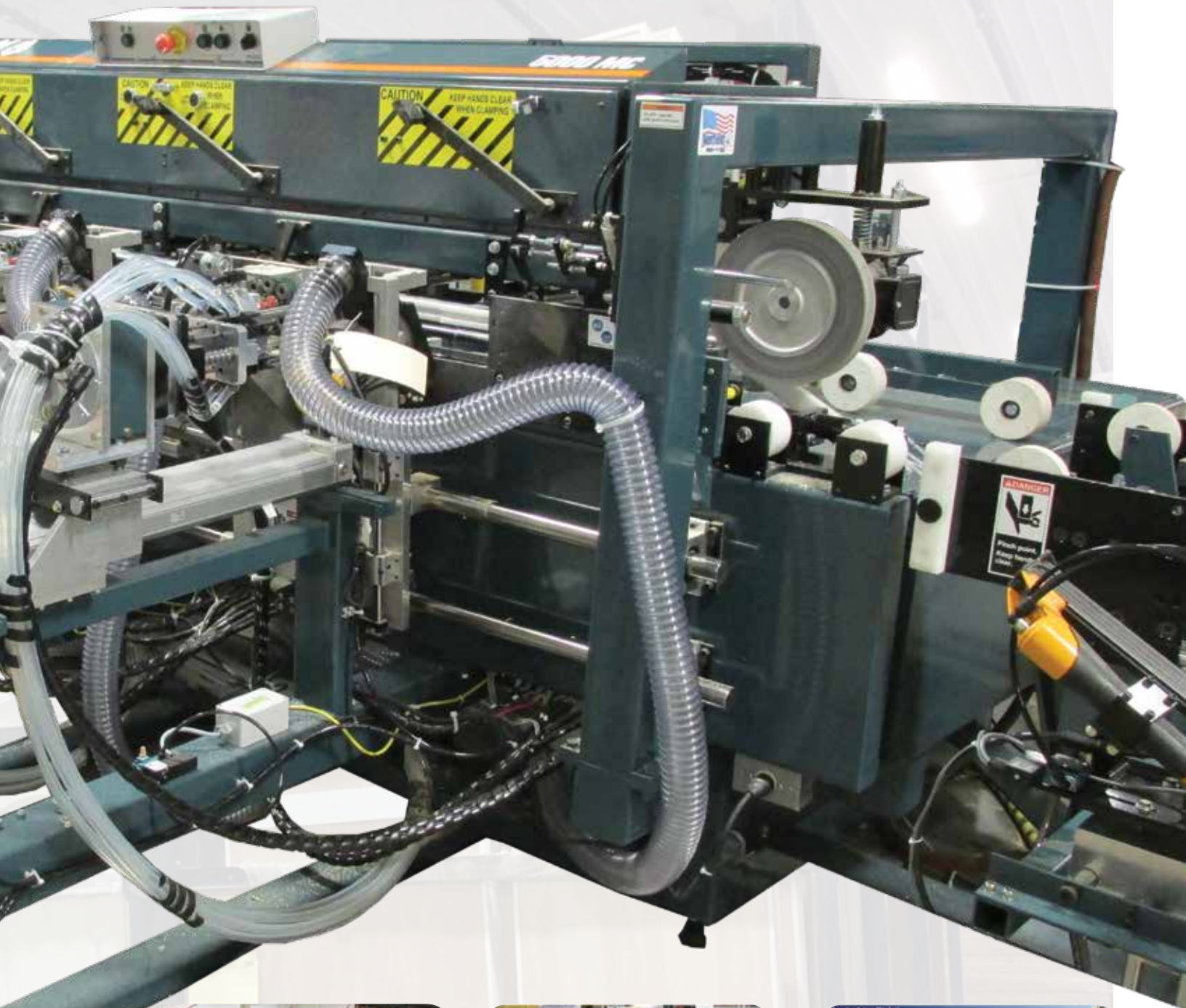
High Speed Production: system-wide automation enables cycle times as fast as 25 seconds per door.



Fully Automated Hinge Application: standard hinge applicators install 2 or 3 hinges simultaneously.



Standard Automatic Predrills: ensure hinge screws are straight and do not split stile or jamb.



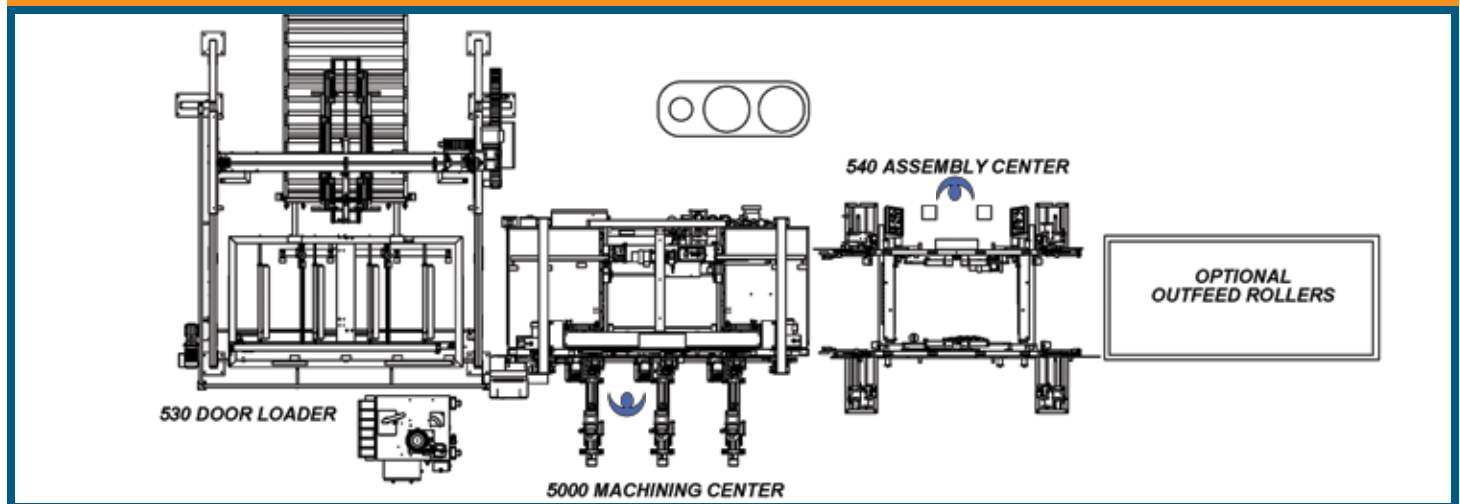
Automatic Screwfeeder (optional) is simple and easy-access for quick color changes and clearing bad screws.



Routes for flush hinges in square OR beveled doors with zero change-over time.

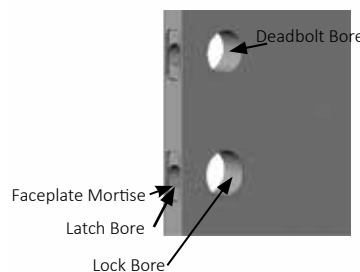
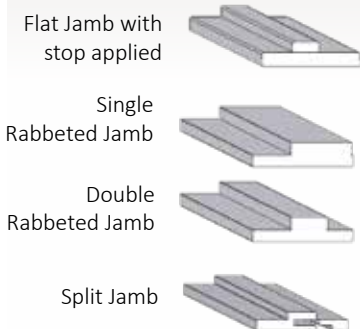


Simple, graphical touchscreen control panel makes learning to operate the 5000 is quick and easy.



5000 MC STANDARD FEATURES

- Automatic door width adjustment, door feeding, and door positioning for RH and LH
- Automatic hinge mortising in door and jamb
- Automatic lock drilling, latch drilling, and faceplate mortising
- Automatic hinge screw pilot hole drills for 3-1/2" hinges
- Powered tilt for 0°-3° hinge mortising
- Simultaneous automatic hinge applicators for 2 or 3 hinges (operator places hinges on applicators)
- Center mounted cycle start controls are ergonomically placed for operator
- No adjustment for door thickness changes
- 10" operator touchscreen with graphical interface for ease of use
- Raised moulding compatible
- E-stop with air dump releases pinch points and clamps for operator safety



5000 MC SPECIFICATIONS

Capabilities

Door Width	1'6" to 3'6"
Door Height	6'6" to 7'0"
Door Thickness	1-3/8" to 1-3/4"
Jamb Width	2-1/2" to 10-1/2"
Jamb Height	6'6" to 7'0"
Jamb Thickness	1/2" to 1-1/2"
Stop Thickness	1/2" max
Hinge Size	3-1/2" to 4" std
Hinge Radius	5/8" only
Pre-drill Pattern	3-1/2" only
Hinge Application	3-1/2" only
Lock Backsets	2-3/8" to 2-3/4"
Faceplate Width	1" to 1-1/8"
Faceplate Length	2-1/4" to 2-3/4"
Faceplate Router	up to 1-1/8" x 2-3/4"

Raised Moulding Height	up to 3/4"
From edge of door	3-1/4"

Operating temperature above 50° Fahrenheit

5000 MC OPTIONS

- Automatic Screwfeeding
- Two-bowl screwfeeder for quick color change
- High-speed Option for increased production output
- Dust Collection Vacuum with auto start
- Spare parts package

TOUCHSCREEN FEATURES

- Graphic user interface for intuitive control
- Pop-up messaging for error control
- On-screen diagnostics & help screens greatly increase the effectiveness of trouble shooting

5000 INSTALLATION

Approx. Shipping Wt.	12,000 lbs.
Floor Space	9'W x 11'6"L x 6'H
Electrical	208/230V 3Ph@50 Amps with neutral 208/230V 3Ph 60Hz
Air Vacuum	30 CFM @ 90 PSI 2700 CFM through 8" duct

5000 ACCESSORY MACHINES



530L AUTOMATIC DOOR LOADER AUTOMATICALLY LIFTS AND FEEDS DOORS FROM FULL STACK

530L Standard Features

- Draws from 7' high door stack – no adjustments for door widths or thicknesses
- Automatically feeds flush, raised panel, or raised moulding doors with no adjustments
- Touchscreen controls located at door machine to minimize operator motion
 - *(When mated to a Norfield Eagle or 5000, controls integrated into door machine touchscreen panel)
- Non-marring rollers convey prefinished doors without scratching
- May be adapted to an existing horizontal door line
- Fully guarded for worker safety

Options

- Extended conveyors for staging door stacks
- Reverse feed configuration (doors feed from front side of line)
- Powered door stack feeder – operator may replace depleted stacks without leaving door machine
- Spare parts

360S ROTATING TILT TABLE TILT FINISHED DOOR UNITS UPRIGHT FOR EASY TRANSFER TO DOOR CART



360S Standard Features

- Rotate top-first units 180° then tilt to right-side-up orientation
- Foot-pedal control for hands-free operation
- Facilitates door lifting and reduces opportunity for back injuries
- Processes door slabs or finished units



540AC AUTOMATIC DOOR FRAME ASSEMBLY MACHINE QUICK, PRECISE DOOR FRAME ASSEMBLY WITH ONE OPERATOR

Standard Features

- 25-second cycle with one operator
- Quick change for varying jamb widths and staple patterns
- Foot pedal control frees operator's hands for material placement
- Consistent staple location and countersink
- Non-marring rollers safely process prefinished doors
- Raised moulding ready

Options

- Strike Side Nailing for shipping nail
- Single outfeed support roller
- Split jamb staplers (to hold halves together during handling)
- 10' outfeed conveyor

Specs

Door Width	1'6" to 4'0"
Door Height	6'6" to 8'0"
Door Thickness	1-3/8" to 1-3/4"
Jamb Width	2-1/2" to 10-1/2"
Jamb Height	6'6" to 8'0"
Jamb Thickness	3/8" to 1-1/2"
Raised Mouldings:	
Max. Height:	3/4"
Min. Dim. to Door Edge:	3-1/8"
Electrical	1PH 120V @ 10Amps
Pneumatic	15CFM @ 100psi 1/2" supply
Approx. Shipping Wt.	1400 lbs.

MACHINERY

- | | |
|--------------------|---|
| 1. 5000 System | Single Stack Door Loader
Volume interior door line
Assembly Table |
| 2. Magnum Loader | Door loader for Magnum |
| 3. Magnum | Door Machine |
| 4. Magnum Unloader | Door Unloader for Magnum |
| 5. 450 | Stop jamb stitcher |
| 6. 250M/250MX | Strike jamb router |
| 7. 2300ASR | Automatic strike plate router |
| 8. 1120 | Double-end trim saw |

5000 System = 140 doors per hour
Magnum = 30 doors per hour

7,700 Square Feet

100 Amps @ 230V 3-Phase (Plus Vacuum Input)

70 CFM @ 90 PSI

10 people, 7 operators and 3 stock pullers (not shown)

5000 System Machining Stage Operator.

Assembly Stage Operator.

Casing Applicator

Magnum Operator- custom specials and exteriors.

Door Unit Assembler- for custom, special, and exterior units; frame assembly and casing application.

450 Operator- for casing and jamb preparation.

1120 Operator- for casing and jamb preparation. Also stocks primary line.

4000 PREHUNG DOOR LINE

SIMPLE, AUTOMATIC PREHANGING SYSTEM FOR SMALL AND MEDIUM SIZED DOOR SHOPS



Fast: hinge routers complete 2 or 3 mortises in about 8 seconds, allowing for quick manual hinge application.



Fully Automated Lock Prep drills lock and latch holes, and mortises face-plate during hinge prep for reduced cycle time.



Hands-free door infeed/outfeed (with optional 4200 Loader) speeds throughput and reduces chance for injury.



Simple control panel enables quick change-overs.



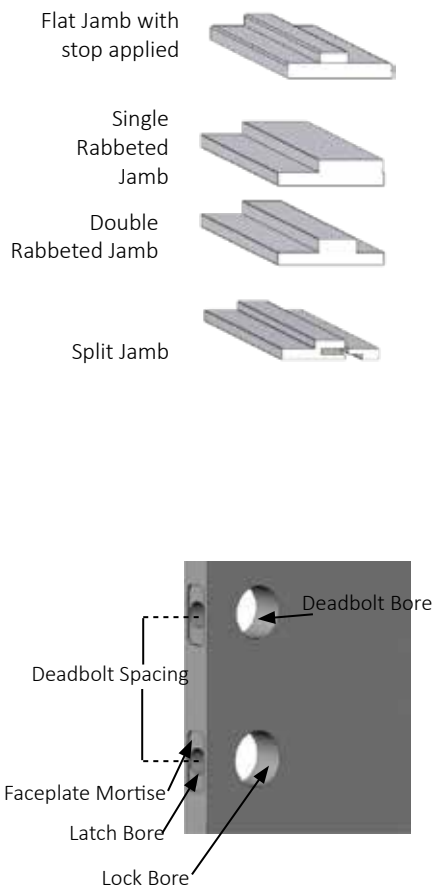
Optional Automatic Screwfeeder with overhead track cuts hinge application time by 50%.

Throughput rate

With
Screwfeeder
40-50
doors/hour

Without
screwfeeder
30-40
doors/hour





4000 MC STANDARD FEATURES

- Powered door infeed/outfeed
- Automatic hinge mortising in door and jamb
- Automatic lock drill, latch drill, and faceplate mortiser
- Selectable automatic deadbolt lock prep
- Hinge routers factory set at square or 3° for flush hinges in square or double beveled doors
- Zero change-over between 1-3/8" and 1-3/4" doors
- Quick change between 3-1/2" and 4" hinge mortising
- Dust collection ready

4000 MC OPTIONS

- Automatic screwfeeder with overhead track
- Dust collection vacuum with auto start
- Spare parts package

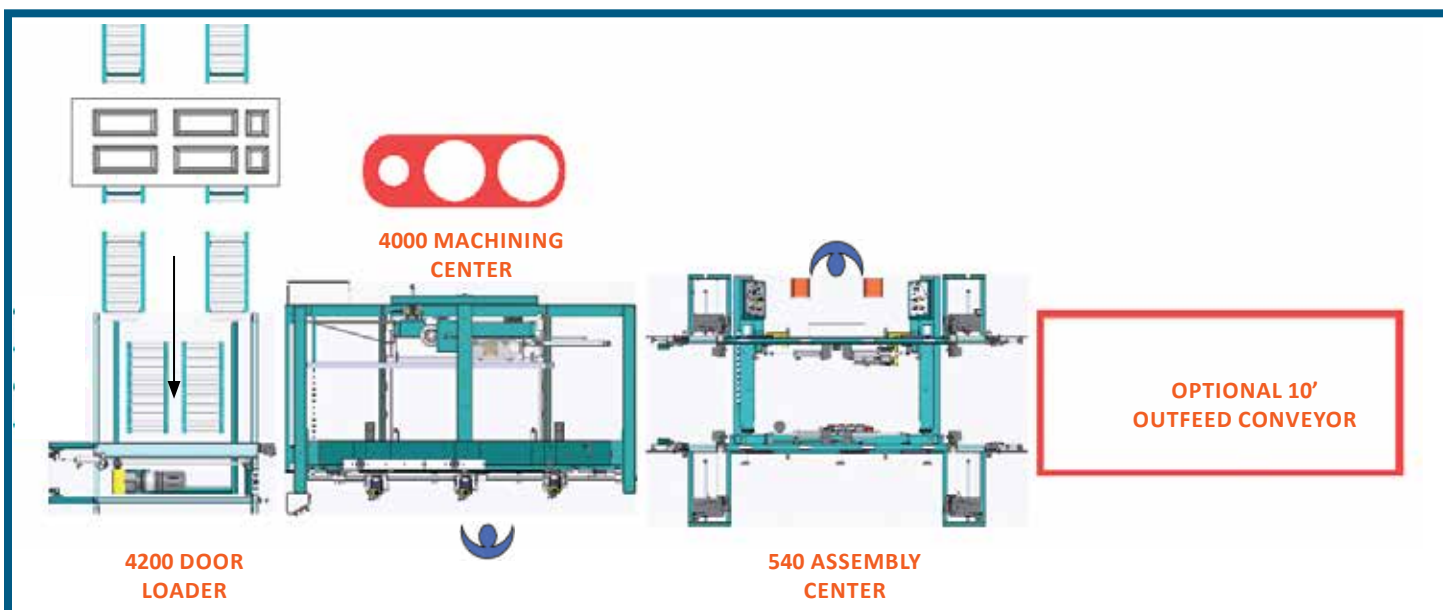
4000 MC SPECIFICATIONS

Capabilities

Door Width	1'6" to 3'6"
Door Height	6'6" to 7'0"
Door Thickness	1-3/8" to 1-3/4"
Jamb Width	2-1/2" to 10-1/2"
Jamb Height	6'6" to 7'0"
Jamb Thickness	1/2" to 1-1/2"
Stop Thickness	1/2" max
Hinge Size	3-1/2" to 4" std
Hinge Radius	5/8" only
Lock Backsets	2-3/8" to 2-3/4"
Faceplate Width	1" to 1-1/8"
Faceplate Length	2-1/4" to 2-3/4"
Faceplate Router	up to 1-1/8" x 2-3/4"

4000 INSTALLATION

Approx. Shipping Wt.	3,000 lbs.
Floor Space	6'6"W x 9'0"L x 6'H
Electrical	230V 1 Ph 208/230V or,
Air	15 CFM @ 90 PSI
Vacuum	2700 CFM @ 8" duct



4000 ACCESSORY MACHINES



4200L DOOR LOADER SIMPLE, STURDY DOOR LIFT AND FEEDER

Standard Features

- Automatic feed sends top door into 4000 machining center
- Automatic vertical indexing positions next door at proper infeed height

4200L Options

- Staging conveyor for rear-feed or end-feed of the door stack



540AC AUTOMATIC DOOR FRAME ASSEMBLY MACHINE QUICK, PRECISE DOOR FRAME ASSEMBLY WITH ONE OPERATOR

Standard Features

- 25-second cycle with one operator
- Quick change for varying jamb widths and staple patterns
- Foot pedal control frees operator's hands for material placement
- Consistent staple location and countersink
- Non-marring rollers safely process prefinished doors
- Raised moulding ready

Options

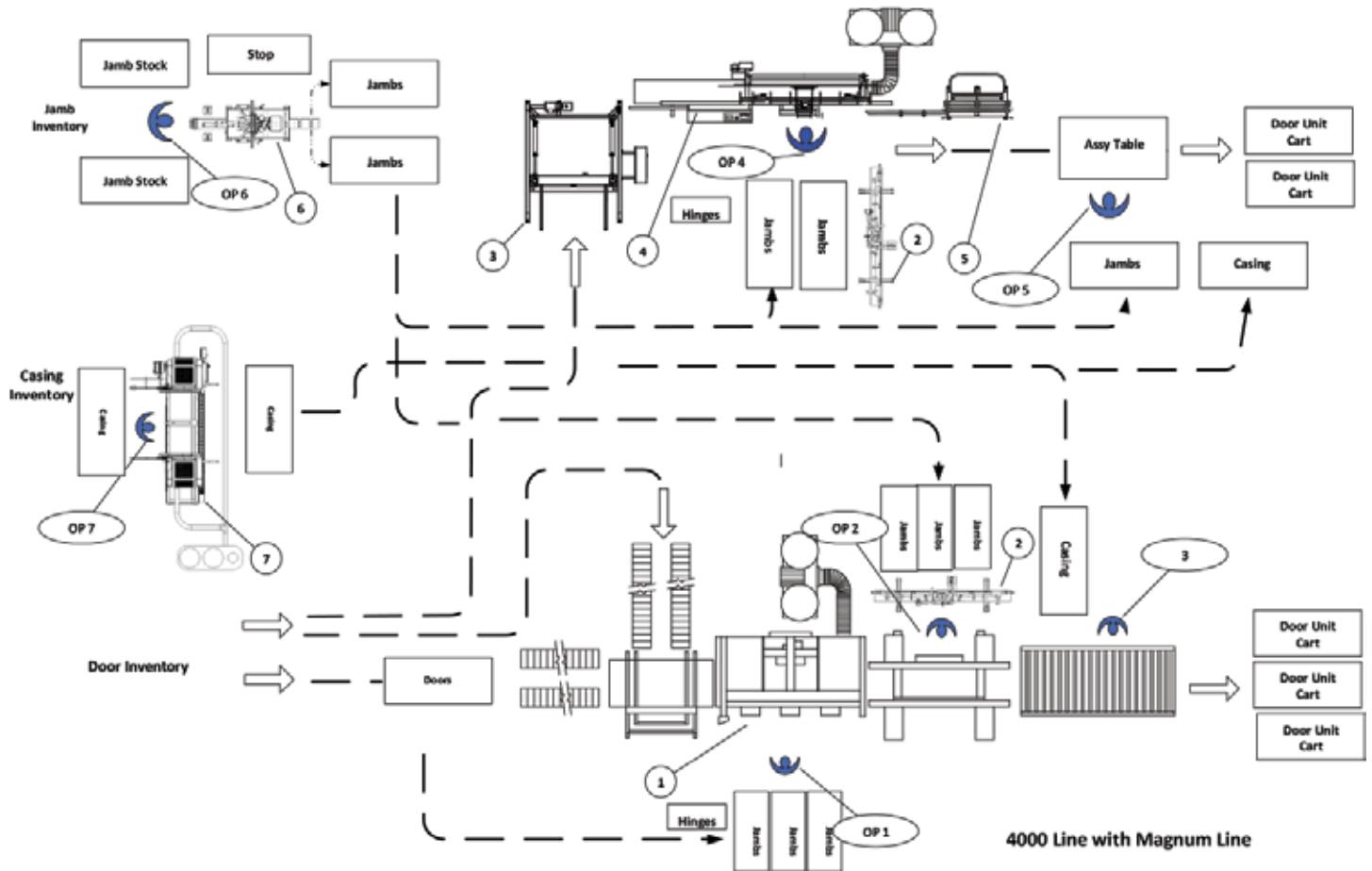
- Strike Side Nailing for shipping nail
- Single outfeed support roller
- Split jamb staplers (to hold halves together during handling)
- 10' outfeed conveyor



360S ROTATING TILT TABLE TILT FINISHED DOOR UNITS UPRIGHT FOR EASY TRANSFER TO DOOR CART

360S Standard Features

- Rotate top-first units 180° then tilt to right-side-up orientation
- Foot pedal control for hands-free operation
- Facilitates door lifting and reduces opportunity for back injuries
- Processes door slabs or finished units



SHOP LAYOUT SUGGESTIONS WITH THE 4000 SYSTEM

MACHINERY

- | | |
|--------------------|-------------------------------------|
| 1. 4000 System | Automated door machine system |
| 2. 250M/250MX | Strike Jamb Router |
| 3. Magnum Loader | Loader for stack loading of Magnum |
| 4. Magnum | Door machine custom, exterior units |
| 5. Magnum Unloader | Feeds Assembly Table |
| 6. 450 | Stop Jamb Stitcher |
| 7. 1120 | Double-end Trim saw |

MACHINE THROUGHPUT RATE

- | | |
|-------------|---------------------|
| 4000 System | = 45 doors per hour |
| Magnum | = 30 doors per hour |

FLOOR SPACE REQUIREMENT

6,000 Square Feet

ELECTRICAL REQUIREMENT

100 Amps @ 230V 3-Phase (Plus Vacuum Input)

AIR SUPPLY

60 CFM @ 90 PSI

MANPOWER REQUIREMENTS

7 people total for both lines, plus stock-puller/warehouse worker (not shown).

Operator 1

4000 System Machining Stage Operator.

Operator 2

4000 System Assembly Stage Operator.

Operator 3

4000 System Casing Applicators.

Operator 4

Magnum Operator- custom specials and exteriors.

Operator 5

Door Unit Assembler- for custom, special, and exterior units; frame assembly and casing application.

Operator 6

450 Operator- for casing and jamb preparation.

Operator 7

1120 Operator- for casing and jamb preparation. Also stocks primary line.

1120 Automatic Casing Saw

FOR HIGH SPEED PRODUCTION OF PREHUNG

DOOR CASING LEGS AND HEADS

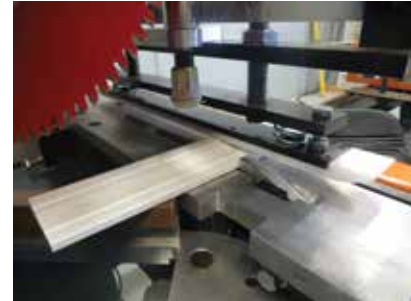


Top-down cutting stroke ensures clean edge with no splintering.

(Guards removed for photos)



Preset stops ensure quick & precise length adjustment without measuring.



Fixed material stop enables quick, no-tool change-over for varying material widths. *(Guards removed for photos)*



Easy-load material hopper holds 8 pieces, allowing operator to "keep up" with 25 pieces/minute through-put.



1120 STANDARD FEATURES

- Automatic flow-through design for high speed output
- Quick, no-tool adjustments for varying material profiles
- Powered saw angulation
- Foot pedal start/stop
- Easy-load feed hopper
- Dust collection ready
- Saw brakes

1120 SPECIFICATIONS

Materials: casing or brickmould
 Door Heights: up to 8'-0"
 Door Widths: down to 1'-6"
 Material Width: 1" to 4-1/2"
 Material Thickness: 3/8" to 1-1/2"
 Typical Cycle 25 ppm

Electrical 208/230 VAC-3Ø-60 HZ-30amp
 Pneumatic 20CFM @ 90psi
 Floor Space Req.(min.) 8' x 16'
 Approx. Shipping Wt. 1600 lbs.

V-Nailer

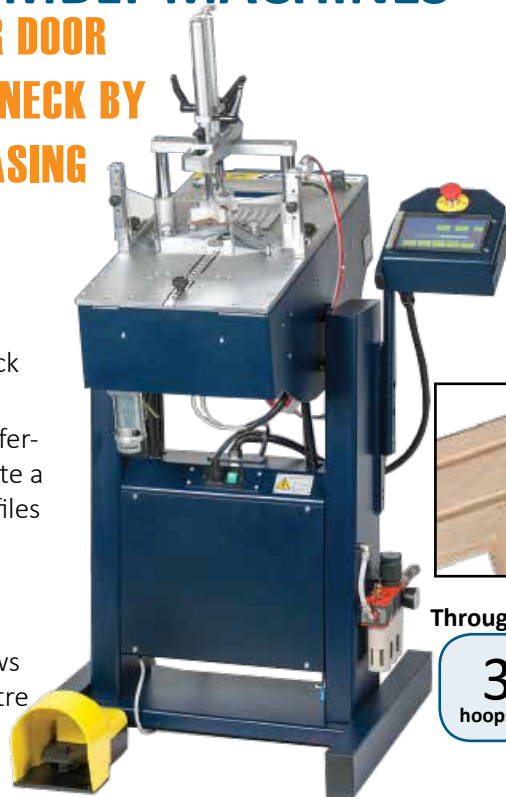
CASING ASSEMBLY MACHINES

ELIMINATE A MAJOR DOOR PRODUCTION BOTTLENECK BY PRE-ASSEMBLING CASING

AMP U-600 MULTICHANNEL

Formerly ITWVN4MPMC

- Automatic cycle enables quick assembly of casing "hoops"
- 5 magazines hold up to 5 different nail sizes to accommodate a wide variety of material profiles
- Touchscreen control panel stores up to 5,000 different nailing patterns
- Tapered fastener shape draws parts together for a tight mitre joint



Throughput Rate

3-4
hoops/minute



Produce 3 casing hoops per minute

Moulding Width:

1/4" to 4-1/2"

Moulding Height:

1/4" to 3-1/4"

Machine Dimensions

Length: 27"

Width: 14"

Height: 48"

Weight: 309 lbs

115/220 Volts 50/60 Hz

12CFM@110psi

- Automatic cycle enables quick assembly of casing "hoops"
- Fully programmable nail spacing and stacking allows customized nail patterns for each profile
- Touchscreen control panel stores up to 5,000 different nailing patterns
- Tapered fastener shape draws parts together for a tight mitre joint

**TOUCH-SCREEN CONTROLLED;
DRIVE AND STACK
V-NAILS IN UP TO 10
POSITIONS**



VNAILS

24-005	5mm vnails (13/64)
24-006	7mm vnails (9/32)
24-011	10mm vnails (25/64)
24-016	12mm vnails (15/32)
24-017	15mm vnails (19/32)

available in quantities at www.norfield.com

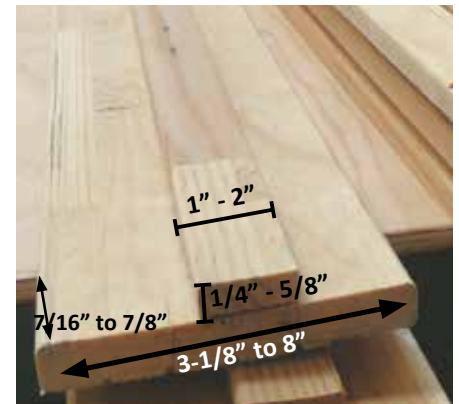
450 Automatic Flow-Through Stop Stitcher



**INCREASE PREHUNG DOOR OUTPUT
WITH PRE-APPLIED STOP**

**ELIMINATE MANUAL STOP APPLICATION
BOTTLENECK**

**CONSISTENT FASTENER COUNT, LOCATION,
AND COUNTERSINK DEPTH**



Throughput Rate

10-12
jamb/minute

450 STANDARD FEATURES

- Foot pedal actuation for hands-free operation
- Available with staplers or brad nailers
- Process square cut or mitred stop
- Process rabbeted or dadoed ("lugged") jambs
- No adjustments for jamb length or width

450 SPECIFICATIONS

Jamb Width	3-1/2" to 8"
Jamb Thickness	7/16" to 7/8"
Stop Width	1" to 2"
Stop Thickness	1/4" to 5/8"
Reveal Choices	1-1/2", 1-7/16", 1-13/16"



440S

MANUAL STOP STITCHER

**COST-EFFECTIVE SOLUTION FOR
LOW TO MID-VOLUME DOOR SHOPS**



440S FEATURES

- Foot pedal actuated clamps speed up production
- Adjustable gun mount for left or right-handed operator
- Easily adjustable reference stops
- Choice of brad nailer or stapler
- Turret stops enable quick change-overs between legs & heads

440S SPECS

Jamb Width	3-1/2" to 10"
Jamb Length	up to 8'
Jamb Thickness	3/8" to 3/4"
Stop Width	1" to 2"
Stop Length	up to 8'
Stop Thickness	up to 3/8"
Reveal Choices	1-7/16" 1-13/16"

Pneumatic	2.8 CFM @ 90PSI
Floor Space Req. (min)	2'-3"W x 9'6"L x 5'4"W
Shipping Wt.	650lbs



Automatic Screwfeeder

CUT HINGING TIME BY 50%

**AUTOMATICALLY FEEDS
SCREWS TO DRIVER TIP TO
SPEED HINGE APPLICATION**

**VIBRATORY BOWL PROVIDES
EASY ACCESS FOR QUICK
COLOR CHANGES**

**AVAILABLE WITH PISTOL-GRIP
OR INLINE TOOLS FOR USE ON
HORIZONTAL OR VERTICAL
DOOR MACHINES**



2300ASR Automatic Strike Jamb Router

**THE 2300ASR BOOSTS EFFICIENCY
AND QUALITY WITH FAST,
HANDS-FREE STRIKE JAMB PREP**



Throughput Rate

4-5
jamb/minute



Quick change jamb stops allow easy adjustments for varying door heights.



Graphical control panel is easy to use and language-neutral.

2300 STANDARD FEATURES

- Infinitely adjustable jamb stops
- Accommodates a variety of jamb widths and lengths
- Foot pedal operation for ease of use
- Dust collection ready
- Automation allows the operator to multi-task

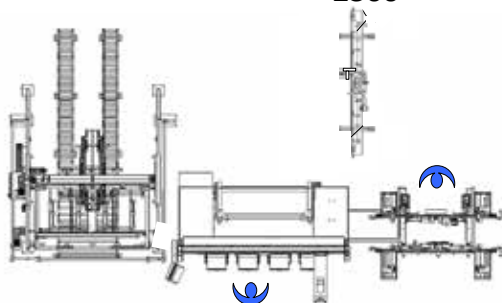
2300 OPTION

- 1200 CFM vacuum

2300 SPECIFICATIONS

Single or double rabbeted jambs	
Strike Plate Type	Full lip only
Strike Plate Sizes	2-1/4" to 3"
Jamb Length	70" to 96"
Jamb Width	2-1/2" to 10-1/2"
Jamb Thickness	3/8" to 1-1/2"

2300



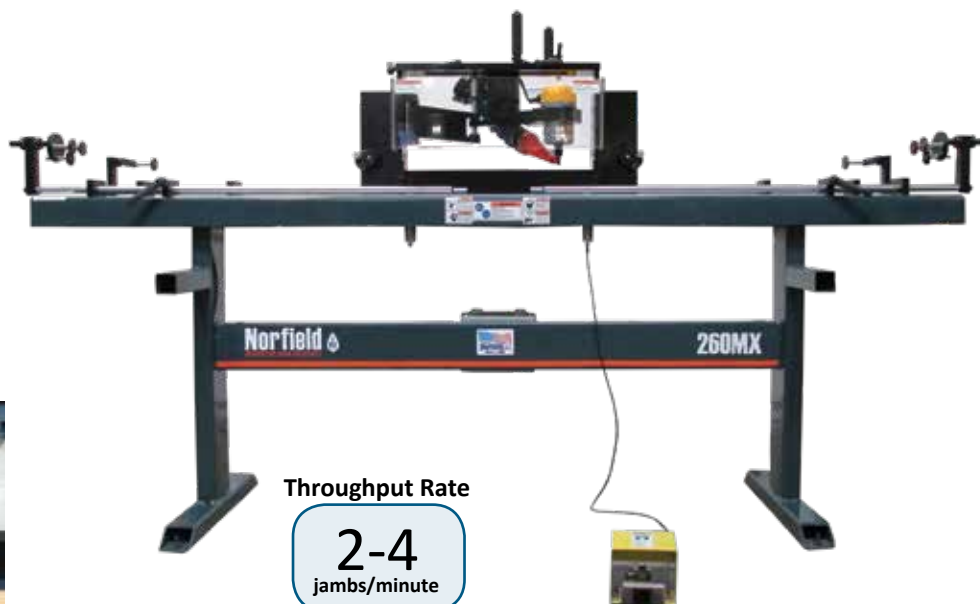
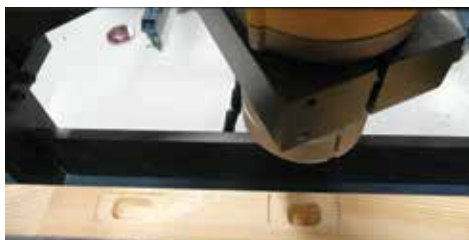
Reduce labor by integrating strike prep into your production line.



260MX

**VERSATILE JAMB ROUTER WITH
DOUBLE PREP TEMPLATE FOR
INTERIOR OR EXTERIOR JAMBS,
MULL POSTS, AND BALL CATCH
HEADS**

**QUICK-CHANGE TEMPLATES;
CUSTOM TEMPLATES AVAILABLE**



260MX STANDARD FEATURES

- Laser alignment system included with machine
- Dual thumb switch controls for safety
- One pair of ball catch stops included
- Quick change for different plate thicknesses
- One full lip + deadbolt template included with machine
- All existing 250M templates can be used on the 260MX

260MX OPTIONS

- Dust collection vacuum
- Additional pair of ball catch stops for head jams
- Overhead material rack
- Custom templates

260MX SPECIFICATIONS

Material

- Width no limit
- Length up to 9'0"
- Thickness to 2"
- Process any strike up to 12" long, including T-strike



Laser alignment for non-standard mortise locations



Preps mull posts:

processes mull posts and T-astragals up to 2" thick.

250M

**COST EFFECTIVE AND VERSATILE
SINGLE-PREP STRIKE JAMB ROUTER**

250M STANDARD FEATURES

- Processes more than 75 types of strikeplates with quick-change template system
- Adjustable deadbolt stop system to accurately place the deadbolt prep
- Includes 2-1/4" - 1/4R full lip template and 2-3/4" - 1/4R deadbolt template

250M OPTIONS

- Dust collection vacuum
- Ball catch stops for head jams
- Custom templates
- Laser alignment kit
- Overhead material rack



250M SPECIFICATIONS

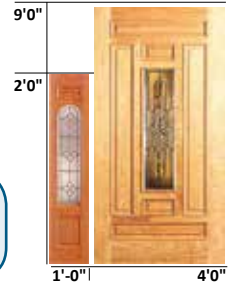
Material

- Width no limit
- Length up to 9'0"
- Thickness to 1-5/8"
- Process any strike up to 4-7/8" long, including T-strike

Ball Catch Machine

**LOW COST, STAND ALONE SOLUTION
FOR PREDRILLING BALL CATCHES**

IMPROVED QUALITY & CONSISTENCY



2+
doors/minute

BALL CATCH MACHINE STANDARD FEATURES

- Quick change adjustment for drilling 2-1/2" to 5" from door edge
- Pneumatic door clamping with foot pedal
- Self centering drill guide (1-3/8" to 1-3/4" door thickness)

BALL CATCH MACHINE OPTIONS

- 650 CFM Vacuum

BALL CATCH SPECIFICATIONS

Door Width	1'0" to 4'0"
Door Height	2'0" to 9'0"
Door Thickness	1-3/8" to 1-3/4"

Ball Catch Drill Diameters
3/4", 7/8", 15/16", 1"
(Includes one bit)

Electrical	115V 60hz @20 Amps
Pneumatic	less than 1.0CFM
Floor Space Req.	3'x8' (min)
Shipping Wt.	300lbs.
Vacuum Connection	2"

Wraptor 1500

SEMI-AUTOMATIC PALLET WRAPPER

PROTECTS AND CONTAINS YOUR PACKAGES

WRAPTOR SPECIFICATIONS

Table Diameter	59"
Table Turn Speed	4-12rpm
Voltage	220/230 3-phase
Power Supply	1.3kW
Stretch Tension	0- 250
Height	85"
Width	59"
Depth	99"

Film Roll Adjustment

Film Width	7 to 20"
Max Roll Diameter	10"
Roll Inside Diameter	3"
Max Weight	37lbs

Packaging product dimensions

Maximum Dimension	47-1/4" x 31-1/2"
Height	86"
Loading Capacity	3300lbs

EDDA



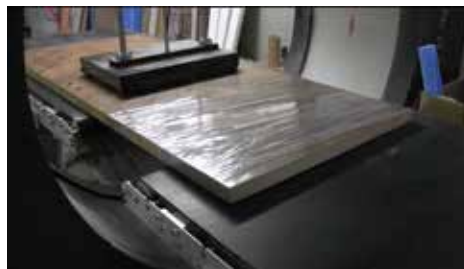
FEATURES

- Wraps up to 40 loads per hour
- 200% power pre-stretch head allows less film to be used to wrap product resulting in a lower cost per package
- Compact footprint
- Photo eye detects height of pallet
- 3 preset programs to choose from
- Smooth start and stop of the turntable

Spinner 1500

AUTOMATIC STRETCH WRAPPING MACHINE

EDDA



WRAPTOR SPECIFICATIONS

Product wrap size

Max. Length	Unlimited
Min. Length	4" x .70" x 21"
Power Req.	208/230 volt, 3 PH
Total Weight	3527lbs
Ring Speed	10 to 50RPM

Conveyor Belt

Length	6'
Working Height	34"



1500S FEATURES

- Automatic product infeed/outfeed on powered, non-marring conveyor belts
- Adjustable wrap rotation speed determines product coverage area
- Adjustable wrap tension- Automatic stretchfilm clamp and cutter system
- Automatic hold-downs stabilize product during wrapping
- Photocell detects product and actuates automatic wrap-ping cycle start/stop
- Simple touchscreen control panel for machine parameter adjustments
- Mechanical brake and solid steel guards for optimum operator safety
- No setup time for different sized parts
- Highly protective packing materials

1500sBN Additional Features

- Dispenser for foam film or bubble wrap for additional protection (secured to product with stretch wrap)
- Automatic cutting and welding mechanism
- Additional powered conveyors

Prehangers Workbench

**EVERYTHING YOU NEED TO FULLY
MACHINE AND ASSEMBLE A PRE-HUNG
DOOR UNIT.**

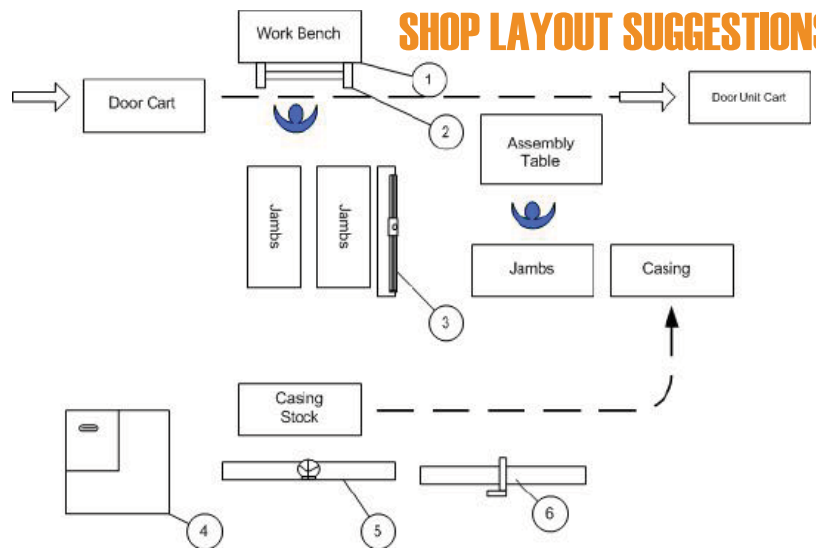
WORKBENCH STANDARD FEATURES

- Tilting table top
- Easily adjustable
- Processes both interior and exterior doors and jambs
- Hinge mortising and application
- Drilling of lock and latch hole
- Faceplate mortise
- Clamping of unit for squaring and stapling of door frames

WORKBENCH SPECIFICATIONS

Door Width	1'0" - 4'0"	Lockbore Backset	2-3/4" and 2-3/4"
Door Height	6'8" to 8'0"	Faceplate Router	Up to 1-1/4" x 2-3/4"
Door Thickness	1-3/8" to 2-1/4"	Air	2CFM @ 90PSI
Jamb Width	Up to 10-1/2"	Floor Space	5'W X 18'L
Jamb Thickness	1/2" to 1-5/8"	Electrical Req	115V 60Hz @ 20AMP
Hinge Size	3-1/2" to 5"(Std)	Approx Weight	260bs
Hinge Radius	1/4" to 5/8"		

SHOP LAYOUT SUGGESTIONS



Ergonomic tilting table top with clamps to hold doors and jambs in place.



Includes adjustable fixtures to ensure perfect and repeatable hinge mortises and spacing.



Completely assemble a prehung door easily on the Prehangers Workbench.

CAPACITY RATE

5 doors per hour

MANPOWER REQUIREMENTS

2 people

FLOOR SPACE REQUIREMENT

1500 Square Feet

ELECTRICAL REQUIREMENT

30 Amps @ 115 Volt 1-Phase

AIR SUPPLY

2 CFM @ 90 PSI

Operator 1

Performs all machining operations to the doors and hinge jambs. Also takes the blank doors and hinge jambs from carts and performs all the machining operations including hinge butt application; places the door with the hinge jamb attached near the assembly tables.

Operator 2

Machines the strike jamb, assembles frame and applies casing to complete the door unit. The door and hinge jamb are placed on the assembly table where the head jamb and strike jamb are stapled in. Casing is applied and the completed unit is stacked on a completed unit cart.

4900cnc Automatic Door Lite Machine

FAST AUTOMATED DOOR LITE CUTTING & LOCK PREP

INTUITIVE TOUCHSCREEN CONTROL PANEL

NO TEMPLATES REQUIRED



Easy-to-use graphic touchscreen stores all lite/lock configurations for quick setup.



Automatic edge prep cycles during lite cutting, expediting throughput.



Quiet and long-lasting high frequency router motor enables variable spindle speeds for clean cuts in fiberglass, steel or wood doors.

4900cnc STANDARD FEATURES

- Fully automated lite cutting with simultaneous automatic lock prep
- No templates required
- Graphical touchscreen stores hundreds of lite shapes and lock configurations
- Automatic door positioning and clamping
- Automatic variable plunge depth for extended bit life
- High frequency lite cutting motor
- Dust collection ready

4900cnc OPTIONS

- Dust collection vacuum
- Spare parts package
- Waste bin
- Spare tool holder kit for quick cutter change

4900cnc SPECIFICATIONS

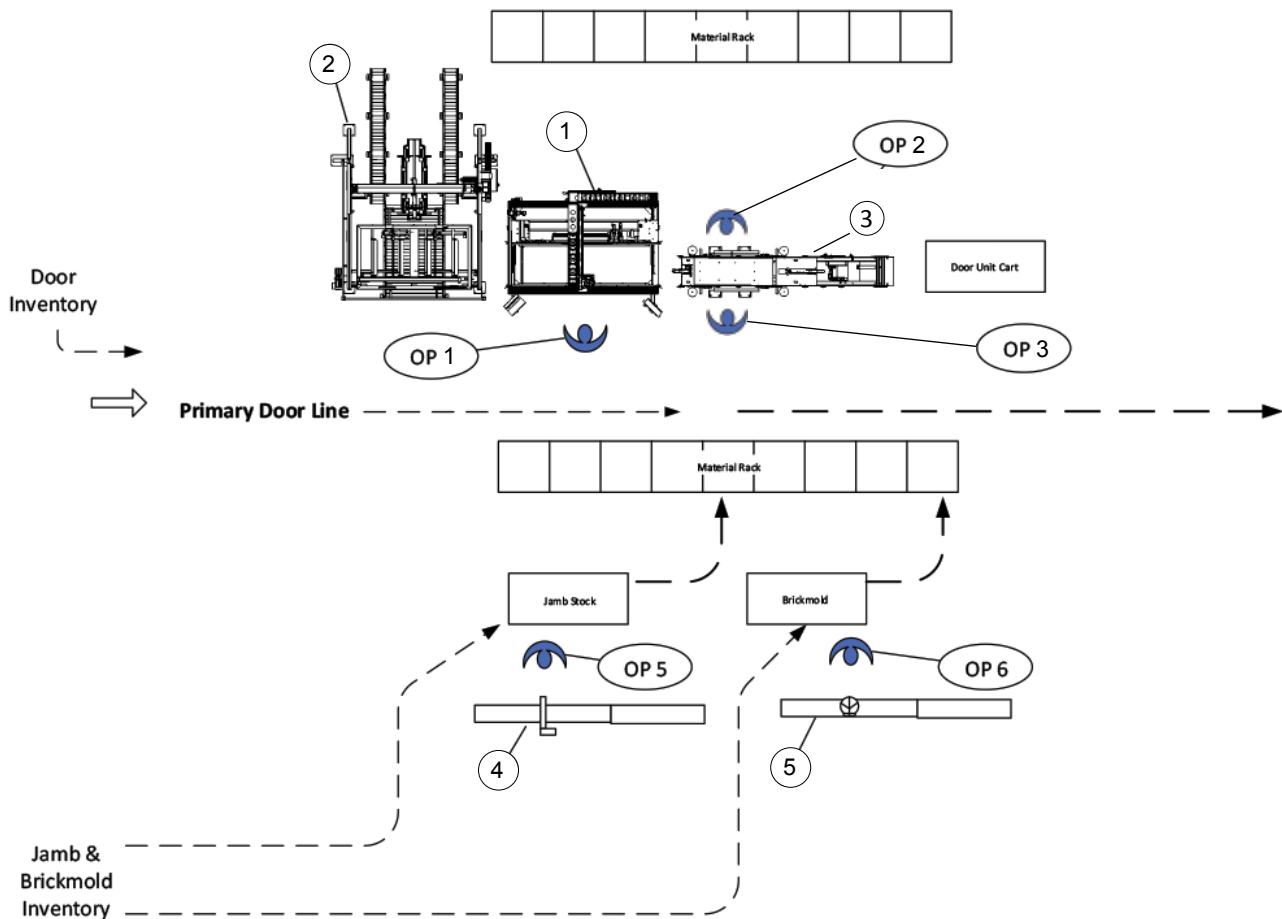
Door Width	10" to 4'0"
Door Height	5'0" to 8'0"
Door Thickness	1-3/8" to 2-1/4"
Max lite cutout dimensions:	Up to 1.5" from door edge
Lock Bore Sizes	1/2" to 2-1/8"
Lock Backset	2-3/8" to 2-3/4"
Faceplate Width	1" to 2-1/4"
Faceplate Length	1" to 4"
Electrical	208-230V 3PH 60amps
Pneumatic	15CFM @ 90 psi
Shipping Wt.	4500lbs.



Optional Waste bin



Can be mated to a Norfield door loader for more efficient throughput and reduced chance of injuries.



SHOP LAYOUT SUGGESTIONS WITH THE 4900

30-200 DOORS PER SHIFT

MACHINERY

- | | |
|-------------------|---|
| 1. 4900cnc | Exterior door window lite cutout & lock preparation |
| 2. 530L | Door Loader |
| 3. EDM | Door assembly system |
| 4. Radial Arm Saw | Cuts jamb and stop material to length |
| 5. Casing Saw | Cuts jambs, casing and stop |

MACHINE THROUGHPUT RATE

- | | |
|------------------------|---|
| 4900 Door Lite Machine | = 200+ doors per day |
| EDM | = 30-200 doors per day (depending on setup) |

FLOOR SPACE REQUIREMENT

4,950 Square Feet

ELECTRICAL REQUIREMENT

20 Amps @ 230V 3-Phase (Plus Vacuum Input)

AIR SUPPLY

5 CFM @ 90 PSI

MANPOWER REQUIREMENTS

3 people

Operator 1

4900 operator machines exterior door lite cutout and lock prep.

Operators 2 and 3

Assemble exterior door units.

Operators 4 and 5 (Part Time)

Part time special operations and modification workstations.

Operators 1 thru 3 could perform these tasks as work load changes

4800XY Door Lite Machine

NO TEMPLATES FOR RECTANGULAR LITES

8'-0" CAPABLE

OPTIONAL AUTOMATIC EDGE PREP



Removable index bars allow quick change between door lite sizes and designs.



Cut non-rectangular door lites by using removable templates.



XY axis locks simplifies lite cutting for rectangular door lites.

4800XY STANDARD FEATURES

- XY controls eliminate the need for templates when cutting rectangular door lites
- Template holder for curved cutout shapes
- Adjustable RPM speed control accommodates both wood, fiberglass and metal cutting
- Oscillating quill for greater bit life

4800XY OPTIONS

- Automated edge preparation
- Waste bin
- Dust collection vacuum
- Spare parts and extra bit packages
- Additional index bars
- 4'0" door width capability

4800XY SPECIFICATIONS

Door Width	10" to 3'6"
<i>(Min. distance between edge of panel & lite cutout is 1.75")</i>	
Door Height	up to 8'0"
Door Thickness	1-3/8" to 2-1/4"
Lock Bore Sizes	1-1/2" to 2-1/8"
Lock Backset	2-3/8" to 2-3/4"
Faceplate Width	up to 1-1/8"
Faceplate Length	up to 2-3/4"
Electrical	208V 60Hz/ 230V 60Hz
Pneumatic	5CFM @ 90 psi
Shipping Wt.	3000lbs.



Optional Waste bin

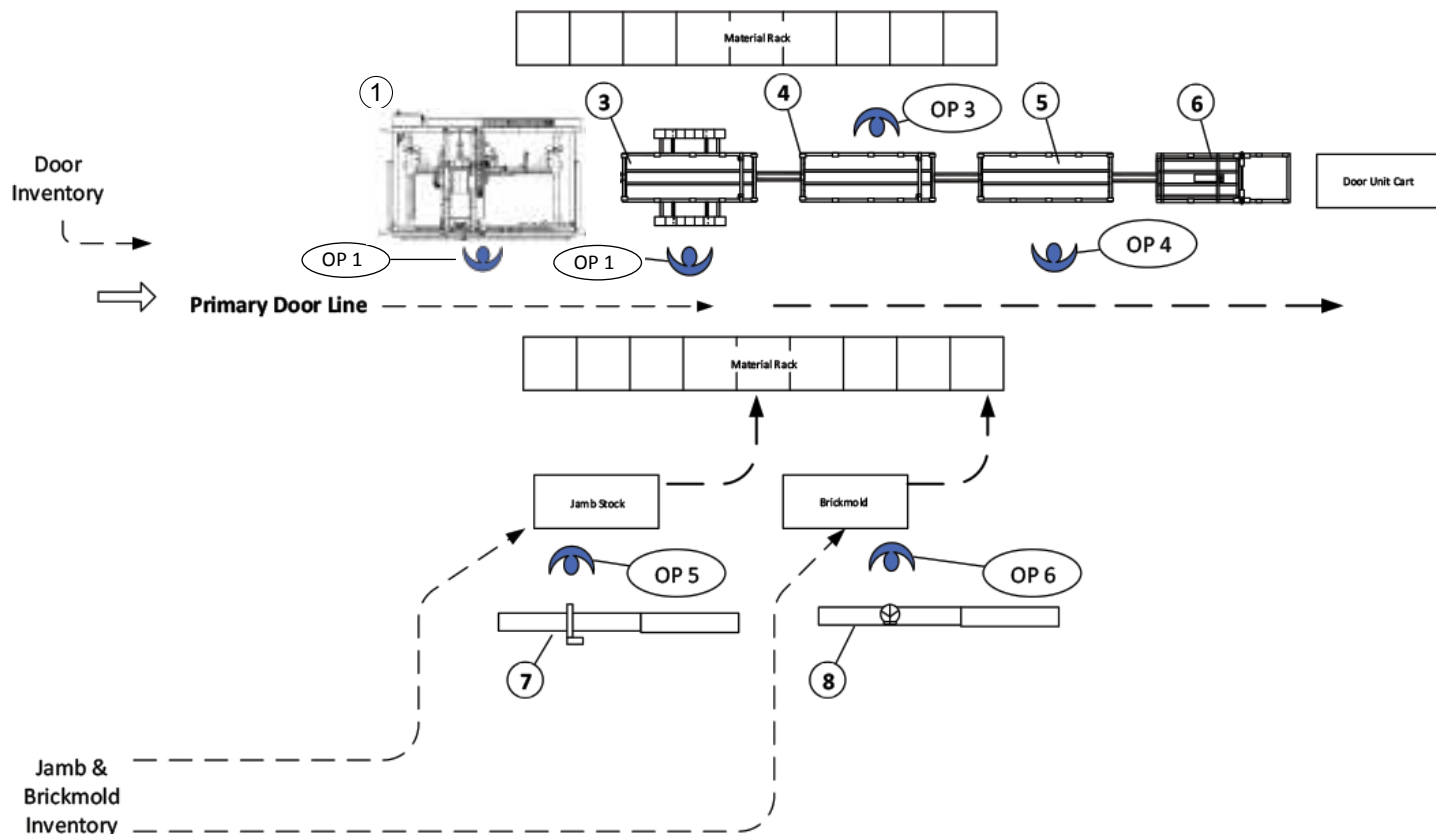


Automated edge prep. The optional edge prep (latch drilling and faceplate mortising) saves time by functioning automatically *during* lite cutting.

Door infeed. The 4800XY is capable of feeding doors from the left or right. Infeed height is set at the factory at either 33" or 40".

Side lites. The 4800XY can process side lites without lock prep. Cut up to a 6" lite in a 10" panel.

Oscillating quill. Extend the life of your door lite bits by utilizing this standard feature.



4800 / Time Fold Line

SHOP LAYOUT SUGGESTIONS WITH THE 4800

30-150 DOORS PER SHIFT

MACHINERY

- | | |
|--------------------------|--|
| 1. 4800 | Exterior door window lite cut-out and lock preparation |
| 3-6. Time Fold Series | Exterior door assembly system or EDM |
| 7. Radial Arm Saw | Cuts jamb and stop material to length |
| 8. Miter/Casing Chop Saw | Cuts jambs, casing, and stop |

MACHINE CAPACITY RATE

- | | |
|------------------------|--|
| 4800 Door Lite Machine | = Up to 150 doors per day |
| Time Fold Series | = 30-200 doors per day
(depending on setup) |

FLOOR SPACE REQUIREMENT

4,950 Square Feet

ELECTRICAL REQUIREMENT

20 Amps @ 230V 3-Phase (Plus Vacuum Input)

AIR SUPPLY

5 CFM @ 90 PSI

MANPOWER REQUIREMENTS

4 people

Operators 1, 2, and 3

Exterior Door Unit Assemblers assemble metal exterior door units.

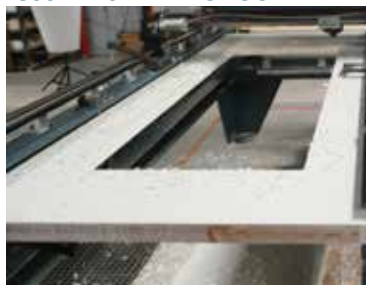
Operator 4

4800 Operator machines exterior door lite cut-outs and lock prep.

Operators 5 and 6 (Part Time)

Part time special operations and modification workstations. Operators 1 thru 4 could perform these tasks as work load changes.

4800 FINISHED PRODUCT



3800 Door Lite Machine

**HEAVY DUTY DOOR LITE CUTTER WITH
OPTIONAL POWERED LATCH DRILL &
FACEPLATE MORTISER**

PROCESS RESIDENTIAL OR COMMERCIAL DOORS

COMPACT FOOTPRINT



The popular 3800 is an efficient space saver for any door shop



Shown with optional overhead template

3800 STANDARD FEATURES

- Cuts any door lite shape
- Nine point clamping system secures door and template
- Adjustable spindle speed for cutting wood, fiberglass, or metal doors
- Dust collection ready

3800 OPTIONS

- Overhead template
- Automatic faceplate mortiser and powered latch drill
- Automatic pop-up roller system for easy door transfer
- Dust collection systems
- Optional waste bin
- Spare parts package
- Extended parts warranty

3800 SPECIFICATIONS

Door Height	up to 8'0" *
*May require repositioning	
Door Thickness	1-3/8" to 1-3/4"
Door Width	up to 3'0"
Lock Bore Sizes	1-1/2", 1-5/8", 1-3/4", 2-1/8"
	Custom templates available
Lock Backset	2-3/8" & 2-3/4"
Faceplate Width	Adjustable to 1-1/8"
Faceplate Length	Adjustable to 2-1/2"
Steel Door Skin Thickness	up to 18 gauge
	(18 gauge requires 2 passes)



Centralized panel allows the operator to control all machine functions from one position at the front of the machine.



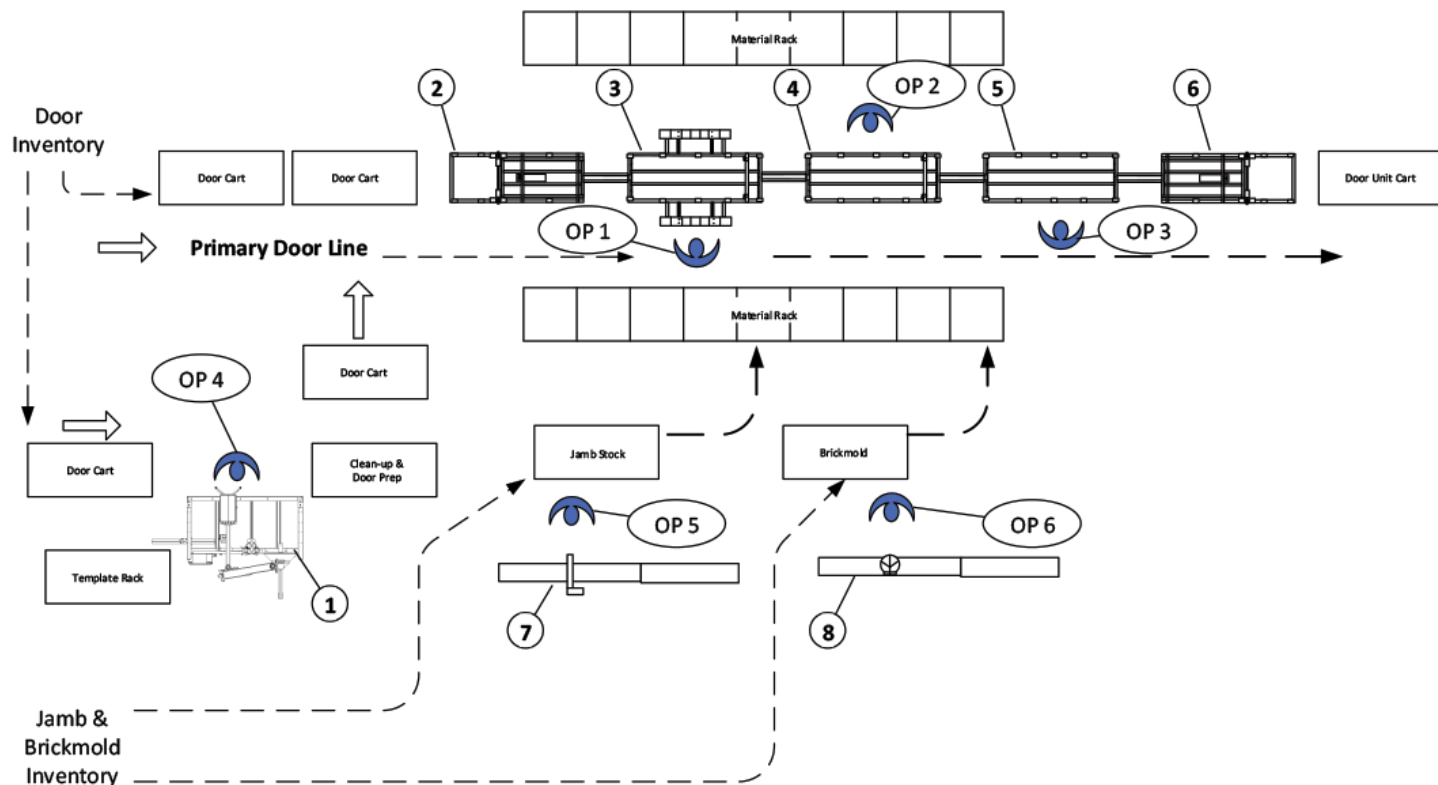
Rotary lock bore template accommodates 1-1/2", 1-5/8", 1-3/4", and 2-1/8".



The 3800 comes with standard lock boring and optional powered latch boring and automatic faceplate mortising.



Optional overhead template speeds production.



3800 / Time Fold Line

SHOP LAYOUT SUGGESTIONS WITH THE 3800

30-150 DOORS PER SHIFT

MACHINERY

- | | |
|-----------------------|---|
| 1. 3800 | Exterior door window lite cutout & lock preparation |
| 2-6. Time Fold Series | Exterior door assembly system or EDM |
| 7. Radial Arm Saw | Cuts jamb and stop material to length |
| 8. Casing Saw | Cuts jambs, casing and stop |

MACHINE CAPACITY RATE

- | | |
|------------------------|---|
| 3800 Door Lite Machine | = Up to 150 doors per day |
| Time Fold Series | = 30-200 doors per day (depending on setup) |

FLOOR SPACE REQUIREMENT

4,950 Square Feet

ELECTRICAL REQUIREMENT

20 Amps @ 230V 3-Phase (Plus Vacuum Input)

AIR SUPPLY

5 CFM @ 90 PSI

MANPOWER REQUIREMENTS

4 people

Operator 1, 2 and 3

Exterior door unit assemblers assemble metal exterior door units.

Operator 4

3800 operator machines exterior door lite cutouts and lock prep.

Operator 5 and 6 (Part Time)

Part time special operations and modification workstations. Operators 1 thru 4 could perform these tasks as work load changes

3800 FINISHED PRODUCT



1700HJR Automatic Hinge Jamb Router

HIGH PRODUCTION HINGE JAMB ROUTER



Throughput Rate

4-5
jamb/minute



1700 STANDARD FEATURES

- Quick change hinge locations
- Accommodates a variety of jamb widths and lengths
- Foot pedal operation for ease of use
- Dust collection ready for operator safety
- Mortise hinges from 3" to 4-1/2"

1700 OPTION

- 4 router module for 8'0" capability (3 router standard)
- 1200 CFM vacuum



Quickly change location of hinge mortises without tools.



Turret stop for various hinge reveals and widths for quick change between different jamb types.



Dust collection ready to help eliminate air borne particles.

1700 SPECIFICATIONS

Hinge Specs	3" - 4-1/2"
Jamb Length	70" to 112"
Jamb Width	2-1/2" to 10-1/2"
Jamb Thickness	3/8" - 1-5/8"
Electrical	115V @ 50 Amps
Pneumatic	3 CFM @ 90 psi
Floor Space Req. (min.)	12' x 3'
Approx. Shipping Wt	1100lbs
Vacuum Connection	4" duct

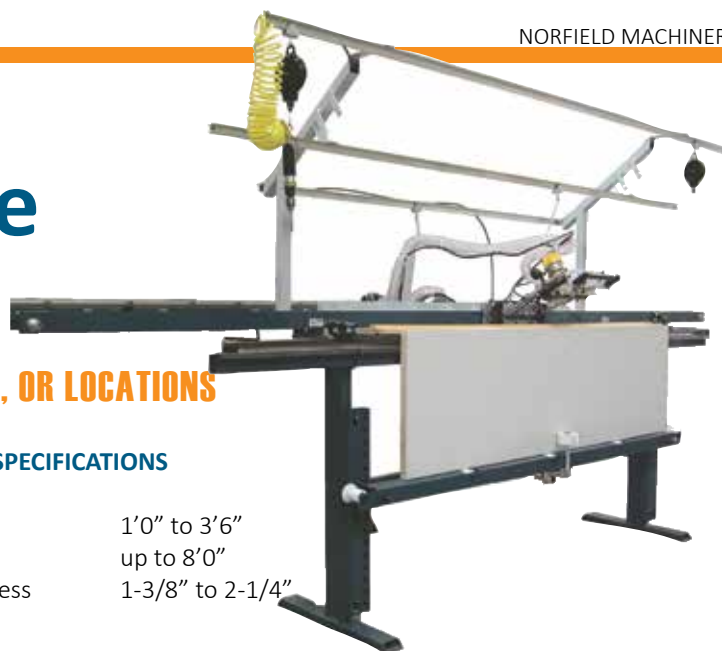


350H Hinge Mortising Machine

PROCESS DOOR AND/OR JAMB

8-0 CAPABLE

QUICK CHANGE OVER FOR HINGE SIZE, CORNER RADII, OR LOCATIONS



350H STANDARD FEATURES

- Pneumatic jamb clamps and jamb thickness adjustment
- Single point dust collection port
- Magnum-style hinge jamb routing
- Quick-change index bar with integrated stop system for different hinge patterns
- Quick-change for different hinge sizes
- Includes 1 index bar

350H OPTIONS

- Dust collection system
- Additional index bars
- 2nd router carriage for quick corner radius changes, OR for processing mull posts
- Hinge screw pilot hole predrill kit
- Screwdriver kit
- Scaled index bar

350H SPECIFICATIONS

Door

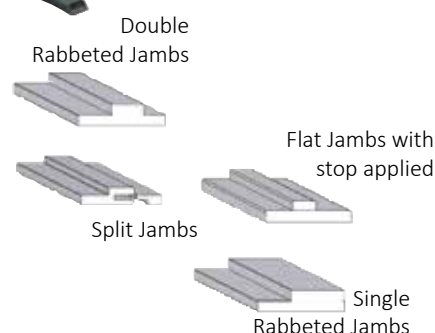
Width	1'0" to 3'6"
Height	up to 8'0"
Thickness	1-3/8" to 2-1/4"

Hinge

Hinge Size	3-1/2" to 5"
------------	--------------

Jamb

Width	2-1/2" to 10-1/2"
Length	up to 8'0"
Thickness	1/2" to 1-1/2"



360S Rotating Tilt Table

Tilt finished door units upright for easy transfer to door cart

360S Standard Features

- Rotate top-first units 180° then tilt to right-side-up orientation
- Foot-pedal control for hands-free operation
- Facilitates door lifting and reduces opportunity for back injuries
- Processes door slabs or finished units

Specs

Door Width	1'0" to 3'6"
Door Height	up to 8'0"
Supports Unit Weight	200 lbs.

Infeed height at horizontal position
40"

Pneumatic	1 CFM @ 90 psi
Floor Space Req. (min.)	9' dia.
Approx. Shipping Wt.	400 lbs.



Hinge pins must be up for units without casing



Table top rotates product for desired direction of flow.



Pneumatic power tilts product to a near vertical position to offload for packing or shipping, or to perform any finish work.

TALON CDS

EXTERIOR DOOR ASSEMBLY STATION



TALON CDS STANDARD FEATURES

The Talon will process:

- Door units up to 8'-0" high
- Double Doors
- Single or Double Sidelite Units
- Transom Lite Units
- Easy Width Adjustment (No Tools)
- Pneumatic Door Unit Tilt (80°)
- Dual Tilt Controls
- Locking Casters
- Built-In Air Manifolds
- Tool and Hardware Trays
- Talon tilts door unit to vertical for transference to door cart.
- Talon includes two purpose-built door carts allowing one operator to flip the unit

TALON CDS SPECIFICATIONS

Door Heights	6'6" to 8'0"
Door Widths	2'6" to 8'0"
Door Weight	500lbs max
Work Height	36" to 40"
Ceiling Clearance	120" min
Jamb Width	12" max
Pneumatic	2 CFM max
Floor Space Req.	5' x 7' min 9' x 9' max
Approx. Shipping Wt.	1000lbs.

TILTING DOOR CART

Maneuver heavy or awkward double doors with side lites or transoms with ease. Able to support even a 500 lbs. door unit. All four casters on the tilting door cart are on the ground for work; tilt forward on front caster to off-load the door unit. You won't have to lift and flip the unit to work on both sides. Simply lean it against the cart to get at the other side. Sturdy, well positioned handle makes it easy to tilt.

Dimensions:

60"W x 87.5"H x 26"D
Adjustable height to 110"

6450-900

Shipping: 120 lbs.



Time Fold Series

Exterior Door Assembly Line

FACILITATES EXTERIOR DOOR UNIT ASSEMBLY WITH POWERED LITE INSERTION AND DOOR TILT

MODULAR DESIGN ENABLES EXPANSION TO HIGH PRODUCTION LINE



TIME FOLD SERIES SPECIFICATIONS

Door Width	2'6" to 3'0"
Door Height	6'8" to 7'0"
Lock Bore Sizes	1-1/2" to 2-1/8"
Door thickness, casing, brick moulding, jamb width, and thickness are supported.	

TIME FOLD SERIES OPTIONS

- Lite insertion module includes a padded table that easily lifts the lite into the door cutout for assembly
- Head/sill clamp module holds sill tightly for accurate side jamb stapling
- Jamb supports hold jamb, improving installation of hinges to door and jamb (set of 4)
- Air hose assemblies lets you add air tools as needed
- Connector brackets protect air connection to adjacent work stations
- Hardware trays hold hinges, screws, etc., for easy access (set of 2)



Air manifold and conveyor wheel

ASSEMBLY PROCESS FOR A 3-STATION SYSTEM

Station A

- Pull door from stack/cart and place on station
- Pull hinge, jamb and sweep
- Install hinges to door and jamb
- Install shipping clips to lock side door
- Install sweep

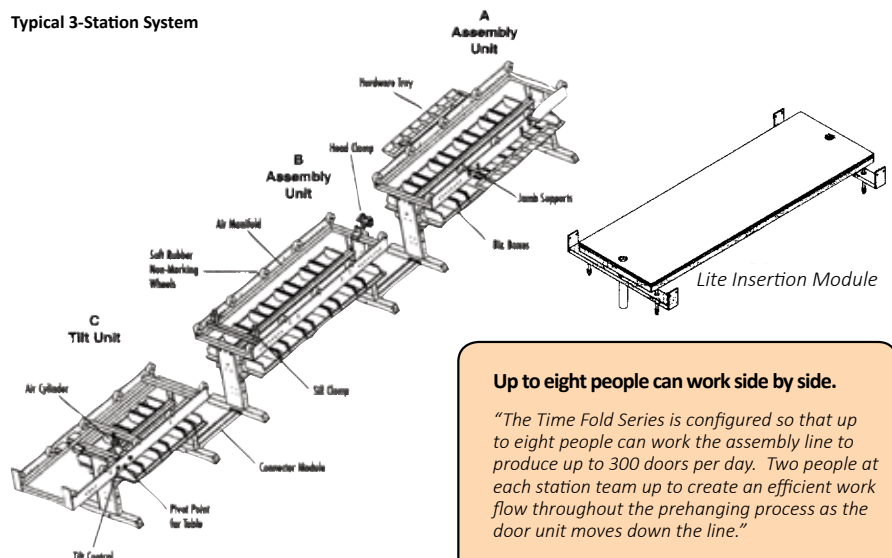
Station B

- Pull head and strike jamb and sill
- Staple side jambs to head jamb
- Caulk side jambs for sill
- Position sill and clamp
- Staple side jamb to sill
- Screw shipping clip to jamb

Station C

- Pull brick mold
- Install brick mold
- Install shipping brace to bottom of sill
- Install instruction and product labels
- Mark customer identification data
- Place completed unit in shipping area or cart

Typical 3-Station System



Up to eight people can work side by side.

"The Time Fold Series is configured so that up to eight people can work the assembly line to produce up to 300 doors per day. Two people at each station team up to create an efficient work flow throughout the prehang process as the door unit moves down the line."

EDM Exterior Door Machine

FOR EFFICIENT, HIGH-SPEED ASSEMBLY OF RESIDENTIAL EXTERIOR DOORS

8-0 CAPABLE

FEATURES DOOR FLIPPER, POWERED LITE INSERTION, AND TILT TABLE



Lite Insertion platform expedites lite kit installation.



Door Flipping Device eliminates manual lifting & reduces chance for injury.



Quick-adjust jamb supports enable convenient hinge application.



Corner support plates provide a flat surface for squaring jambs and freeing both hands for installation of fasteners.



Second stage provides brick-mould application station and tilts finished unit to upright for easy off-loading.

EDM SPECIFICATIONS

Door Width	2'6" to 3'0"
Door Heights	6'8", 7'0", 8'0"
Door Thickness	1-3/4"
Electrical	110V
Pneumatic	5CFM @ 90 psi
Floor Space	48" x 224"
Max Door Weight	180 lbs.

EDM FEATURES

- Pneumatic lite insertion platform
- Adjustable jamb supports
- Four corner support plates
- Integrated tool and supply trays
- Non-marring bed rollers
- Integrated tilt table

EDM OPTIONS

- Pistol grip air screwdriver
- Air hose assembly

Visit norfield.com

DOOR MACHINERY



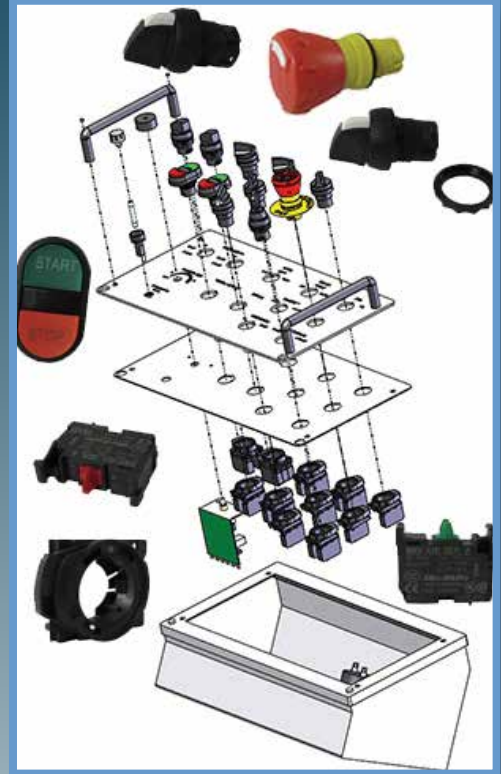
Our complete machinery product line with specifications and demonstration videos.

ONLINE STORE



Browse industry-leading Norfield Tools & Supplies for all your door shop needs.

MACHINE SUPPORT



Vast technical resources including manuals, schematics and how-to videos.





CUSTOMER SERVICE CONTACTS:

Phone

(800) 824-6242

(530) 879-3137

Address

422 Otterson Dr, Chico, CA 95928

Machinery Technical Support

norfield.com/machine-support

Machine Sales Fax

(530) 879-3141

E-Mail

machinesales@norfield.com

Tools & Supplies Sales Fax

(530) 879-3140