



HOLLOW METAL DOORS

PART 1 - INTRODUCTION

A. General

Doors may be classified by their method of operation. There are four basic types: swinging, sliding, rolling steel, and revolving. Though revolving doors are seldom, if ever, made of carbon steel, sliding and rolling steel may be hollow metal.

This standard applies to hollow metal doors that are side-hinged swinging and mounted on either hinges or pivots

B. Types of Construction

The details shown on the following pages pertain to HMMA door constructions outlined in the following NAAMM/HMMA standard specifications:

- HMMA 860, "Guide Specifications for Hollow Metal Doors and Frames", is used and specified for hollow metal doors and frames subject to less rigorous use than commercial and institutional applications.
- ANSI/HMMA 861, "Guide Specifications for Commercial Hollow Metal Doors and Frames", is used and specified in commercial work is the continuously welded edge seam construction and it is this type that is the basis of the NAAMM Standard.
- ANSI/HMMA 862, "Guide Specifications for Security Hollow Metal Doors and Frames", is used and specified in applications where security against vandalism, break-in, or theft is a major concern.
- ANSI/HMMA 863, "Guide Specifications for Detention Security Hollow Metal Doors and Frames", is used and specified for detention security.
- ANSI/HMMA 865, "Guide Specifications for Swinging Sound Control Hollow Metal Doors and Frames", is used and specified for applications where sound control is a factor.
- ANSI/HMMA 866, "Guide Specifications for Stainless Steel Hollow Metal Doors and Frames", is used and specified when stainless steel is required for corrosion resistance or aesthetics is a factor.
- ANSI/HMMA 867, "Guide Specifications for Commercial Laminated Core Hollow Metal Doors and Frames", is used and specified for doors incorporating the use of laminated cores.

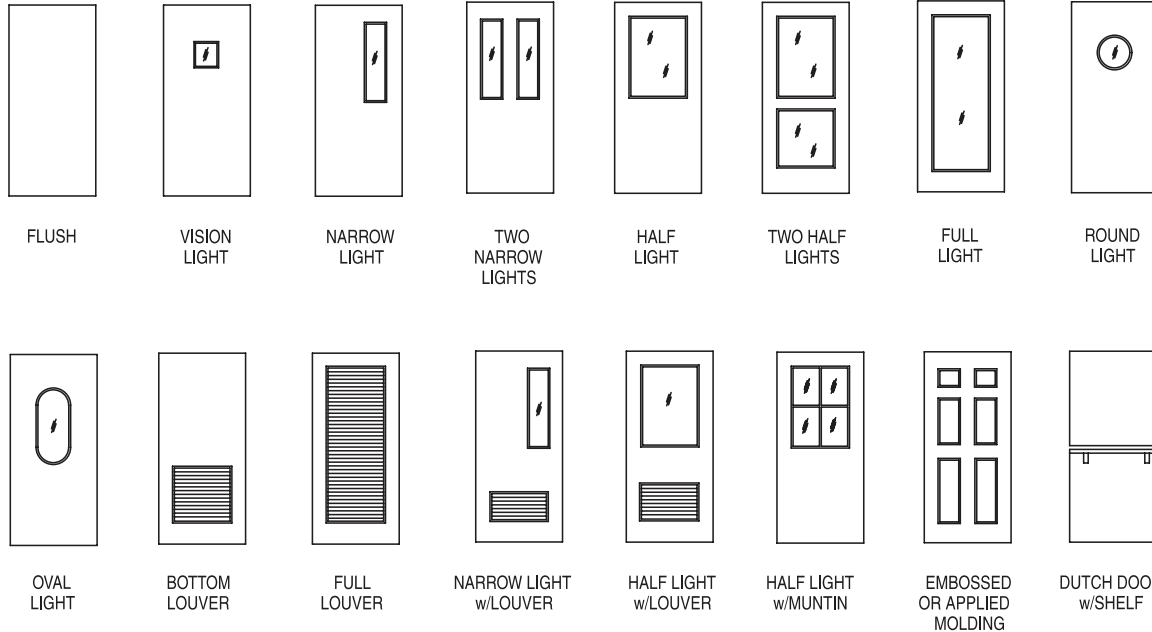
HMMA 850, "Fire rated Hollow Metal Doors and Frames". Since fire rated doors may differ in certain details of construction, refer to HMMA 850, "Fire Rated Hollow Metal Doors and Frames" standard for guidance.



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E. DOOR DESIGNS

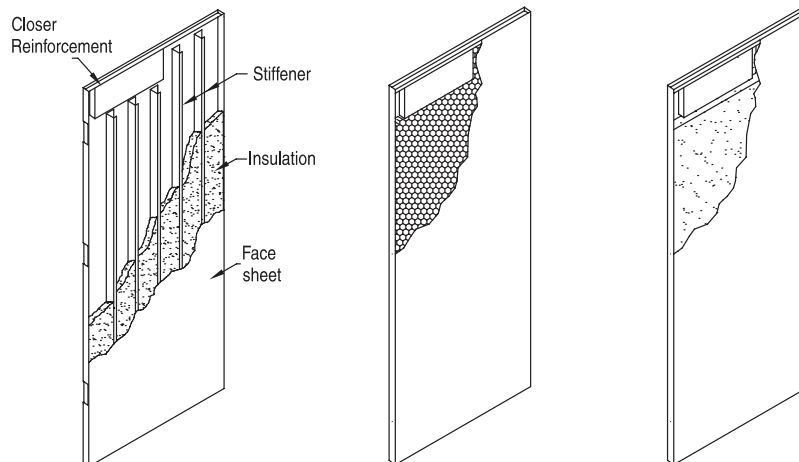


PART 2 - CONSTRUCTION FEATURES

A. Constructions

There are two basic types of door constructions:

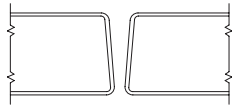
- **STEEL STIFFENERS** – Vertical steel stiffeners, which can be channel, zee, hat, or similar shaped sections, support the face sheets. The stiffeners are attached to the face sheets by spot or projection welding.
- **LAMINATED CORE** – This is a sandwich construction in which the face sheets are separated by a core comprised of honeycomb (“Kraft” paper) or polyurethane or polyisocyanurate or polystyrene or core board or steel stiffeners. The core is laminated to the faces by means of an adhesive. Foamed-in-place polyurethane cores are self-bonding and do not require additional adhesive.



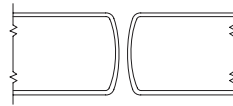


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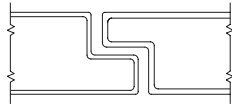
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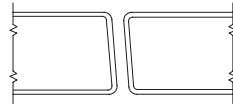
V-BEVEL



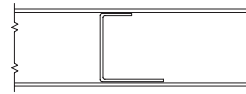
BULLNOSE
USED ON DOUBLE-ACTING
CENTER-PIVOTED DOORS



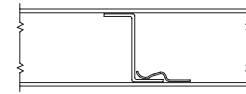
RABBETED



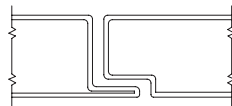
PARALLEL BEVEL



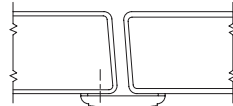
CHANNEL



ZEE



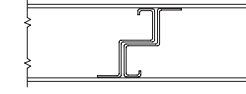
INTEGRAL ASTRAGAL



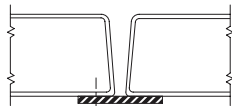
PARALLEL BEVEL
WITH MOLDED SURFACE ASTRAGAL



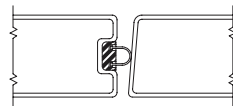
HAT SECTIONS



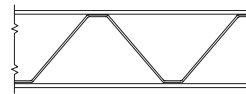
OFFSET CHANNEL



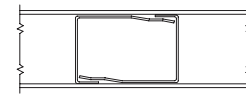
V-BEVEL
WITH FLAT SURFACE ASTRAGAL



RECESSED
WEATHERSTRIPPING



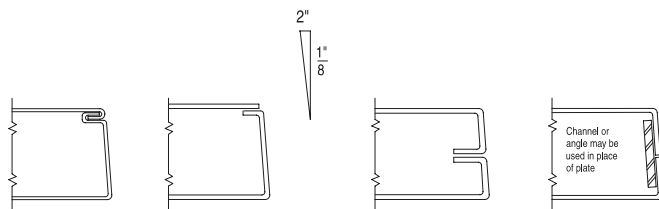
TRUSS



INTERLOCKING CHANNELS

B. MEETING EDGE PROFILES

C. STIFFENER SECTIONS

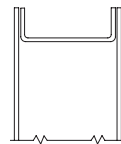


LOCKSEAM

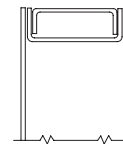
PAN & SKIN

CENTER SEAM

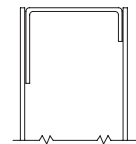
CENTER SEAM



INVERTED
CHANNEL



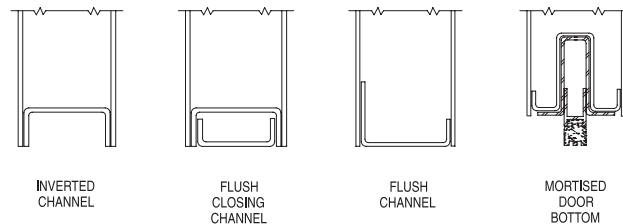
FLUSH
CLOSING CHANNEL
SEALED IF REQUIRED.



FLUSH CHANNEL
SEALED IF REQUIRED

D. STILE EDGE DETAILS

E. TOP EDGE DETAILS

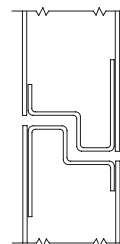


INVERTED
CHANNEL

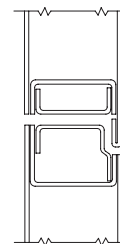
FLUSH
CLOSING
CHANNEL

FLUSH
CHANNEL

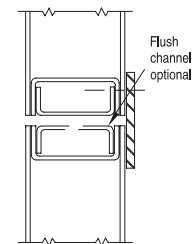
MORTISED
DOOR
BOTTOM



RABBETED



INTEGRAL
ASTRAGAL



APPLIED
ASTRAGAL

F. BOTTOM EDGE DETAILS

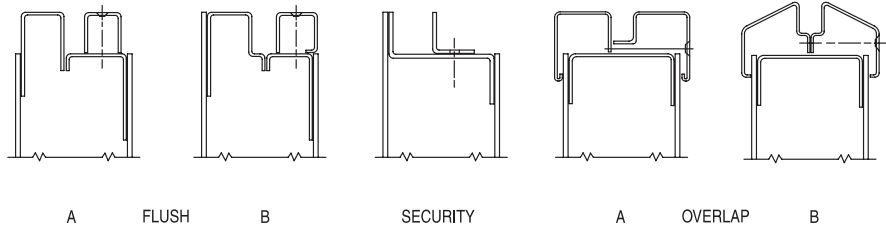
G. TOP EDGE DETAILS WITH FLUSH TRANSOM PANEL



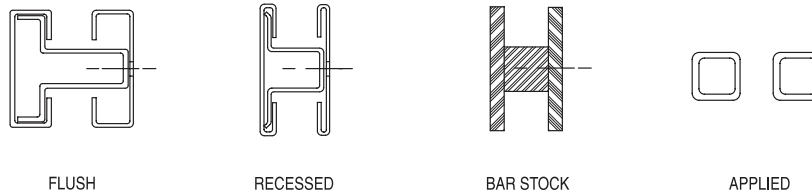
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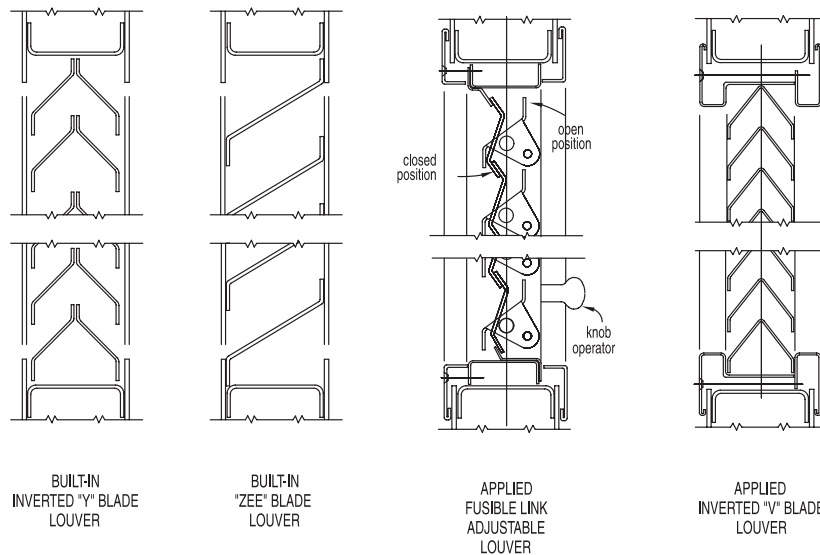
H. GLAZED OPENINGS AND RECESSED PANEL MOULDINGS



I. TYPICAL MUNTINS



J. LOUVER DESIGNS

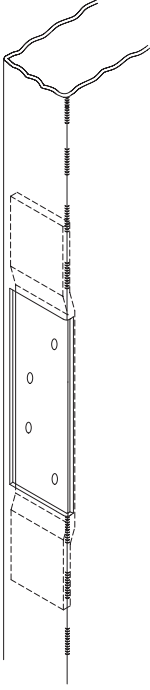




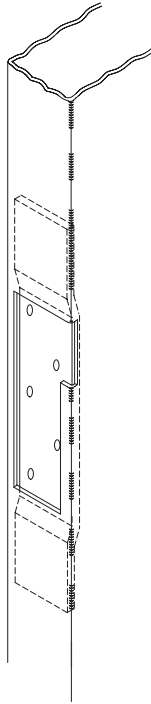
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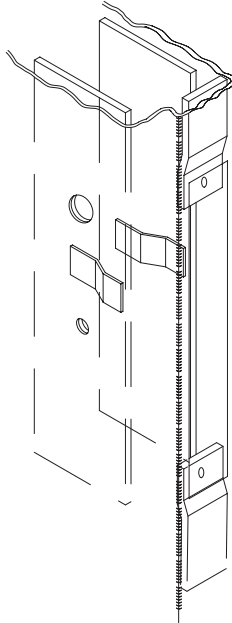
K. TYPICAL HARDWARE PREPARATIONS



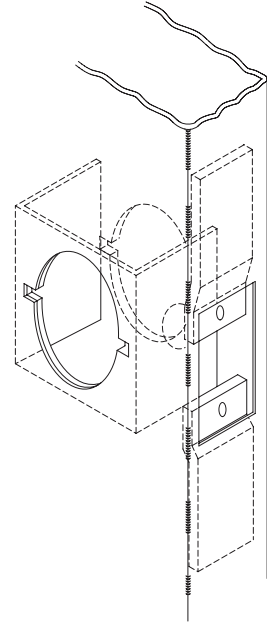
BUTT HINGE



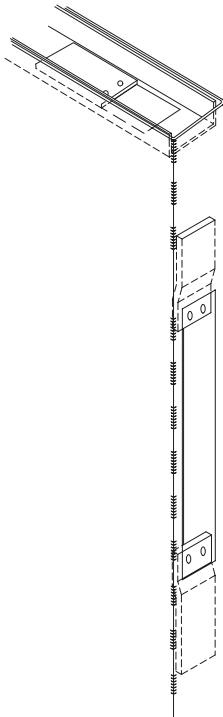
INTERMEDIATE
PIVOT



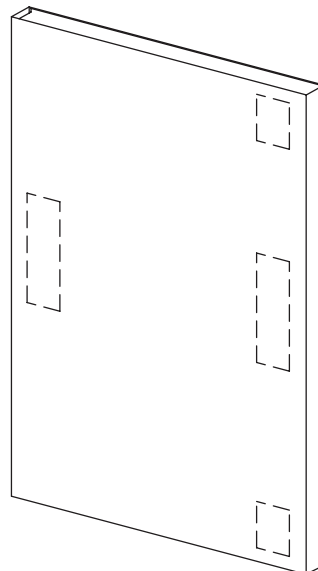
MORTISE LOCK



CYLINDRICAL LOCK



FLUSH BOLT



PANIC HARDWARE



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