



COMMERCIAL AND ARCHITECTURAL
DOOR MANUFACTURER

19-STEP FINISH PROCESS

1. Raw door face veneer and stiles are sanded with 180 grit paper.
2. Prior to stain or sealer application, a fine sanding with 220 grit paper through a high-precision electronic state-of-the-art wide belt sanding machine is performed.
3. Faces and stiles have water and polyurethane based stain applied with a direct and reverse roller coat system. Depending on desired color, two coats may be required.
4. Two separate brushes push the stain deep into the pores while wiping off excess stain.
5. Door travels through a 50-foot drying oven making product dry to the touch in minutes.
6. Top and bottom rails are machine sprayed with polyurethane.
7. Stiles are machine sprayed with polyurethane.
8. A 100% solid polyurethane sealer is applied with a roller coat system.
9. Door travels through ultraviolet lite for curing.
10. A second 100% solid polyurethane sealer is applied with a roller coat system.
11. Door travels through ultraviolet lite for curing.
12. Opposite face of door passes through the same 1 thru 11 step process.
13. A final face sanding with 280 grit finishing paper is performed to ensure a smooth finish.
14. A first top coat of 100% solid polyurethane is applied with a roller coat system.
15. Door travels through ultraviolet lite for curing.
16. A final top coat of 100% solid polyurethane is applied with a roller coat system.
17. Door travels through ultraviolet lite for curing.
18. Opposite face of door passes through the same 13 thru 17 step process.
19. Door is inspected both sides for quality control.

A 19-STEP PROCESS INSURING EVERY DOOR MEETS "AWI TR-6 PREMIUM".

