

DOOR CONSTRUCTION & PRESS TECHNOLOGY (3-PLY, 5-PLY, 7-PLY)

VT Industries manufactures both hot and cold press doors to ensure the best and most consistent door construction possible. Specialty door constructions may require partial or complete cold press processes. Doors are available in 3-, 5-, and 7-ply construction.

Hot Press Technology involves pressing each door individually in a platen under controlled pressure, temperature and time, based on the type and thickness of material.

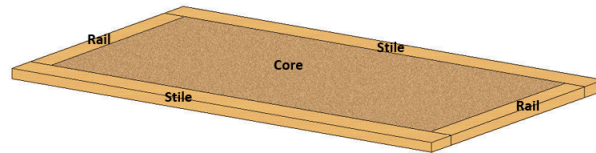
Cold Press Technology involves placing a pile of doors in a press at the ambient building temperature until the adhesives are cured depending on the surrounding temperature and humidity conditions.

	HOT PRESS*	COLD PRESS
Pressure	Controlled - (Individually pressed)	Uncontrolled - (Bottom door of pile will have more pressure than the top door)
Temperature	Controlled - (Based on the type of material and thickness for each door)	Uncontrolled - (Ambient Conditions of the building)
Time	Controlled - (Based on the type of material and thickness for each door)	Uncontrolled - (30 minutes to one hour, plus 4-8 hours to allow glue curing time)
Platen	Controlled - (Individually pressed)	Uncontrolled - (Stacked door to door to door in one press opening)

*VT double hot press technology allows us to adjust pressure, temperature and time for crossband and face material

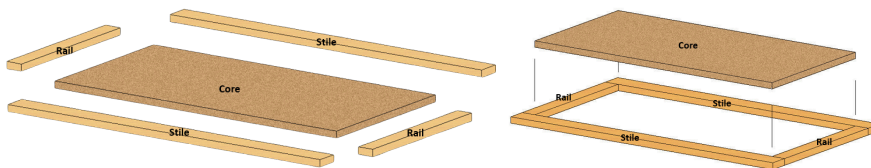
Bonded Core:

- VT manufactures bonded core doors using 3-ply (HPDL only), 5-ply, & 7-ply (lead only)
- Stiles and rails bonded to core and assembly sanded



Loose Lay-up/Drop in Core:

- VT does not manufacture loose lay-up/drop in core 7-ply doors
- Stiles and rails placed loose around core without adhesive

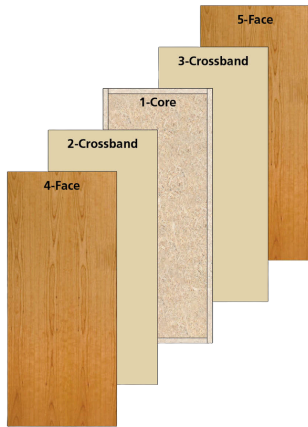


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3-Ply Construction (Laminate or Primed HDF Faces):



5-Ply Construction (Laminate, Veneer, MDO, Palladium Faces):



7-Ply Construction (Laminate, Veneer, MDO, Palladium Faces): Lead Only

