1.0 FLUSH DOOR SHUTTERS

1.0 Flush door shutters shall have a solid core and may be of the or non-decorative (Paintable type as per IS 2202 (Part I). Nominal thickness of shutters shall be 25 mm.

1.1 Width and height of the shutters shall be as shown in the drawings or as mentioned in Bill of Quantities (BOQ) or as indicated by the Engineer-in-Charge. All four edges of the shutters shall be square. The shutter shall be free from twist or warp in its plane. The moisture content in timbers used in the manufacture of flush door shutters shall be not more than 12 per cent when tested according to IS: 1708.

1.2 Core
The core of the flush door shutters shall be a 1st class hard wood block board having wooden strips held in a frame constructed of stiles and rails. Each stile and rail shall be a single piece without any joint. The width of the stiles and rails including lipping, where provided shall not be less than 45 mm and not more than 75 mm. The width of each wooden strip shall not exceed 30 mm. Stiles, rails and wooden strips forming the core of a shutter shall be of equal and uniform thickness. Wooden strips shall be parallel to the stiles.

End joints of the pieces of wooden strips of small lengths shall be staggered. In a shutter, stiles and rails shall be of one species of timber. Wooden strips shall also be of one species only but it may or may not be of the same species as that of the stiles and rails. Any species of timber may be used for core of flush door. However, any non-coniferous (Hard wood) timber shall be used for stiles, rails and lipping.

1.3 Face Panel
The face panel shall be formed by gluing, by the hot-press process on both faces of the core, either plywood or cross-bands and face veneers. The thickness of the cross bands as such or in the plywood shall be between 1.0 mm and 3.0 mm. The thickness of the face veneers as such or in the plywood shall be between 0.5 mm and 1.5 mm for commercial veneers and between 0.4 mm and 1.0 mm for decorative veneers, provided that the combined thickness of both is not less than 2.2 mm. The direction of the veneers adjacent to the core shall be at right angles to the direction of the wooden strips. Finished faces shall be sanded to smooth even texture. Commercial face veneers shall conform to marine grade plywood and decorative face veneers shall conform to type I decorative plywood in IS: 1328.

1.4 Lipping
Lipping shall be provided internally on all edges of the shutters. Lipping shall be done with battens of 2nd class teak wood of depth not less than 25 mm. For double leaved shutters, depth of the lipping at meeting of stiles shall be not less than 35 mm. Joints shall not be permitted in the lipping.
1.5 Rebating
In the case of double leaves shutters the meeting of stiles shall be rebated by 8 mm to 10 mm. The rebating shall be either splayed or square type as shown in drawing where lipping is provided. The depth of lipping at the meeting of stiles shall not be less than 35 mm.

1.6 Tolerance
Tolerance on width and height shall be ± 3 mm and tolerance on nominal thickness shall be ± 1.2 mm. The thickness of the door shutter shall be uniform throughout with a permissible variation of not more than 0.8 mm when measured at any two points.

1.7 Adhesive
Adhesive used for bonding various components of flush door shutters namely, core, core frame, lipping, cross-bands, face veneers, plywood etc. and for bonding plywood shall conform to BWP type, phenol formaldehyde synthetic resin adhesive conforming to IS 848.

1.8 Tests
Samples of flush door shutters shall be subjected to the following tests:
(a) End Immersion Test
(b) Knife Test
(c) Glue Adhesion Test

One end of each sample shutter shall be tested for End Immersion Test. Two specimens of 150 x 150 mm size shall be cut from the two corners at the other end of each sample shutter for carrying out Glue Adhesion Test. Knife Test shall be done on the remaining portion of each sample shutter. Test shall be done as per CPWD specification.