



**ARCHITECTURAL DOORS**



## Our Vision

Our commitment to manufacturing quality architectural, residential wood and High Pressure Decorative Laminate (HPDL) doors has become a time-honored tradition that has lasted decades, and is still growing. Our choice selection of hardwood and materials, expert craftsmanship, advanced machinery, mixed with experienced salespeople and management has largely accounted for our company's remarkable longevity.

## Where Tradition Matters

For over 60 years Haley Brothers has been mastering the art of crafting architectural wood and decorative laminate doors. Since this time we have earned an unparalleled reputation for dedication to the exceptional quality and focus on providing superbly well-crafted doors supported by world-class customer service.

Our integrity and commitment to quality has maintained a level of respect in the marketplace that very few companies can match.



## What We Offer

- **Premium quality** architectural wood doors which include sustainable components friendly to our environment.
- **Wide selection** of veneer species with pre-finishing options; high density plastic laminate (HPDL) and hardboard door faces.
- **Solid core options** including Warnock-Hersey fire ratings, lead-lined, and sound transmission class (STC) cores; NAUF, LEED, and FSC certification.
- **Machining options** for most architectural door hardware applications including vision light and louver preps.



# Quality Crafted Architectural Flush Doors

## APC-1 *Entry Level, Thin Veneer Birch or Red Oak Architectural Door*



**Maximum Size:** 4' 0" X 8' 0"

**Thickness:** 1 3/8" or 1 3/4" **5-Ply Construction**

**Core:** Particleboard LD-2; Meets or exceeds requirements of ANSI A208.1 and CS236-66. Lumber and strand core also available. Lead lined available.

**Stiles:** 1 1/4" softwood bonded to core. Laminated hardwood available.

**Rails:** 1 1/4" softwood bonded to core. Larger rails available; bonded to core. (Stile and rail frame dimensions may vary due to hardware specifications.)

**Faces:** Only available with thin faced 2-ply Rotary Natural Birch and Plain Sliced Red Oak; MDF substrate.

**Adhesives:** Type II interior; Type-I available.

**Lites and Louvers:** Total areas of openings must not exceed 40% of door face area or 50% of door height. Must be minimum of 5" from door edges.

**Prefitting:** May be prefit to net sizes and machined for hardware as specified.

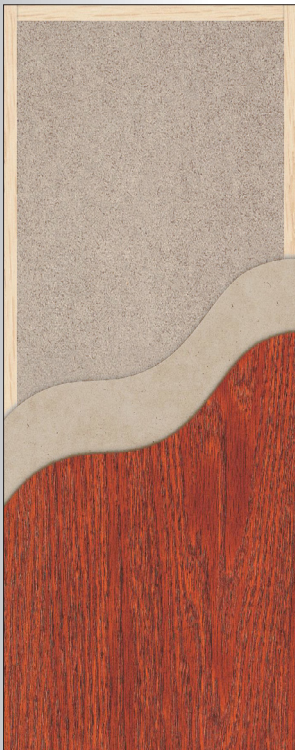
**Finishing:** Both species available raw or with water-borne stain base UV finish that meets or exceeds WDMA or AWI system TR-6. EPA and California Air Resources Board (CARB) approved.

**Warranty:** Two-year limited warranty for original installation. See our website for details.

**Environmental Features:** LEED credits available.

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## APC-2 *Heavy Duty Commercial for Hospitals, Schools and Offices*



**Maximum Size:** 4' 0" X 10' 0"

**Thickness:** 1 3/8" or 1 3/4" **5-Ply Construction**

**Core:** Particleboard LD-2; Meets or exceeds requirements of ANSI A208.1 and CS236-66. Lead lined available. (1LD-1 core used for plastic laminate faces.)

**Stiles:** 1 1/4" laminated hardwood bonded to core.

**Rails:** 1 1/4" minimum; softwood; bonded to core. (Stile and rail frame dimensions may vary due to hardware specifications.)

**Faces:** All commercially available Premium Grade 2-Ply hardwood species; high density fiberboard (HDF); and high pressure decorative laminates (HPDL.)

**Adhesives:** Type-II Interior; Type-I available.

**Lites and Louvers:** Total areas of openings must not exceed 40% of door face area or 50% of door height. Must be minimum of 5" from door edges.

**Prefitting:** May be prefit to net sizes and machined for hardware as specified.

**Sound Transmission Class:** Available up to STC-41.

**Finishing:** All species available raw or with water-borne stain base UV finish that meets or exceeds WDMA or AWI system TR-6. EPA and California Air Resources Board (CARB) approved.

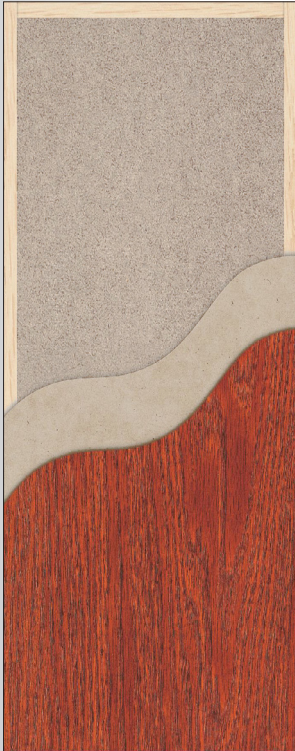
**Warranty:** Lifetime warranty for original installation. See our website for details.

**Environmental Features:** LEED credits available; No Added Urea Formaldehyde (NAUF) and FSC (Forest Stewardship Council) components available.



# Quality Crafted Architectural Flush Doors

## APC-3 Heavy Duty Wider Stiles for Superior Performance



**Maximum Size:** 4' 0" X 10' 0"

**Thickness:** 1 3/4" 5-Ply Construction

**Core:** Particleboard LD-2; Meets or exceeds requirements of ANSI A208.1 and CS236-66. Lumber and strand core also available. Lead lined available. (1LD-1 core used for plastic laminate faces.)

**Stiles:** 1 3/8" Laminated hardwood bonded to core.

**Rails:** 1 1/4" minimum softwood; hardwood optional; bonded to core. (Stile and rail frame dimensions may vary due to hardware specifications.)

**Faces:** All commercially available Premium Grade 2-Ply hardwood species; high density fiberboard (HDF); and high pressure decorative laminates (HPDL.)

**Adhesives:** Type II interior; Type-I available.

**Lites and Louvers:** Total areas of openings must not exceed 40% of door face area or 50% of door height. Must be minimum of 5" from door edges.

**Prefitting:** May be prefit to net sizes and machined for hardware as specified.

**Sound Transmission Class:** Available up to STC-41.

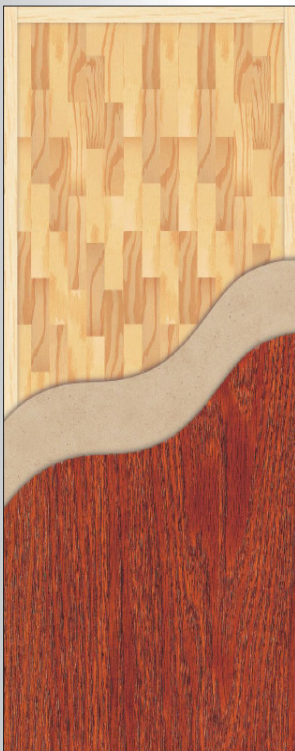
**Finishing:** All species available raw or with water-borne stain base UV finish that meets or exceeds WDMA or AWI system TR-6. EPA and California Air Resources Board (CARB) approved.

**Warranty:** Lifetime warranty for original installation. See our website for details.

**Environmental Features:** LEED credits available; No Added Urea Formaldehyde (NAUF) and FSC (Forest Stewardship Council) components available.

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## ALC Extra Strength, Stability and Better Screw-Holding Capacity



**Maximum Size:** 4' 0" X 10' 0"

**Thickness:** 1 3/4" 5-Ply Construction

**Core:** Architectural Lumber Core; One specie of edge glued, low-density, kiln-dried wood blocks of random lengths and staggered joints; bonded to stiles and rails. Lead lined available.

**Stiles:** 1 1/4" laminated hardwood bonded to core; 1 3/8" hardwood optional.

**Rails:** 1 1/4" minimum; softwood; bonded to core. (Stile and rail frame dimensions may vary due to hardware specifications.)

**Faces:** All commercially available Premium Grade 2-Ply hardwood species; high density fiberboard (HDF.) **Not recommended for plastic laminate faces.**

**Adhesives:** Type-II Interior; Type-I available.

**Lites and Louvers:** Full lite available with no less than 6" stile width and top height, and 10" bottom height. No hardware preps within 2 1/4" from lite/louver opening.

**Lites and Louvers:** Total areas of openings must not exceed 40% of door face area or 50% of door height. Must be minimum of 5" from door edges.

**Prefitting:** May be prefit to net sizes and machined for hardware as specified.

**Finishing:** All species available raw or with water-borne stain base UV finish that meets or exceeds WDMA or AWI system TR-6. EPA and California Air Resources Board (CARB) approved.

**Warranty:** Lifetime warranty for original installation. See our website for details.

**Environmental Features:** LEED credits available; No Added Urea Formaldehyde (NAUF) and FSC (Forest Stewardship Council) components available.

## SCL *Provides the Greatest Stability; for Large Cut-Out Applications*



**Maximum Size:** 4' 0" X 10' 0"

**Thickness:** 1 3/4" **5-Ply Construction**

**Core:** Structural Composite Lumber Core; One specie of laminated structural composite strand lumber; kiln dried and glued together. Core bonded to stiles and rails. Lead lined available.

**Stiles:** 1 1/4" (3/8" matching edge band laminated over softwood substrate.)

**Rails:** 1 1/4" minimum; softwood; bonded to core. (Stile and rail frame dimensions may vary due to hardware specifications.)

**Faces:** All commercially available Premium Grade 2-Ply hardwood species; high density fiberboard (HDF); and high pressure decorative laminates (HPDL.)

**Adhesives:** Type-II Interior; Type-I available.

**Lites and Louvers:** Full lite available with no less than 6" stile width and top height, and 10" bottom height. No hardware preps within 2 1/4" from lite/louwer opening.

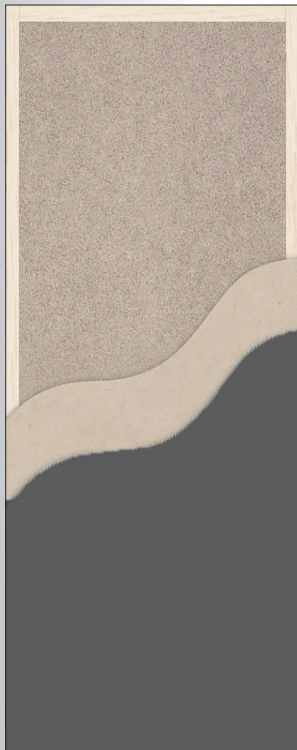
**Prefitting:** May be prefit to net sizes and machined for hardware as specified.

**Finishing:** All Species available raw or with water-borne stain base UV finish that meets or exceeds WDMA or AWI system TR-6. EPA and California Air Resources Board (CARB) approved.

**Warranty:** Lifetime warranty for original installation. See our website for details.

**Environmental Features:** LEED credits available; No Added Urea Formaldehyde (NAUF) and FSC (Forest Stewardship Council) components available.

## Plastic Laminate *Outstanding Durability; Unlimited Design Options*



**Maximum Size:** 4' 0" X 10' 0"

**Thickness:** 1 3/8" or 1 3/4" **3-Ply or 5-Ply Construction**

**Core:** Particleboard 1LD-1; Meets or exceeds requirements of ANSI A208.1 and CS236-66. Lead lined available.

**Stiles:** 1 1/4" softwood up to 1 5/8" laminated hardwood; bonded to core.

**Rails:** 1 1/4" softwood up to 2 1/2" laminated hardwood; bonded to core. (Stile and rail frame dimensions may vary due to hardware specifications.)

**Faces:** Some faces may be backed with HDF substrate. Not recommended for lumber (stave) core doors. Matching plastic edges are recommended.

**Adhesives:** Type II interior; Type-I available.

**Lites and Louvers:** Total areas of openings must not exceed 40% of door face area or 50% of door height. Must be minimum of 5" from door edges.

**Prefitting:** May be prefit to net sizes and machined for hardware as specified.

**Sound Transmission Class:** Available up to STC-41.

**Warranty:** Lifetime warranty for original installation. See our website for details.

**Environmental Features:** LEED credits available; No Added Urea Formaldehyde (NAUF) and FSC (Forest Stewardship Council) components available.



# Quality Crafted Architectural Flush Doors

## **AFD-20** 20 Minute Fire Protection



**Maximum Size:** 4' 0" X 10' 0"; Dutch door maximum 8' 0" height. Category "A" maximum height is 9' 0".

**Thickness:** 1 3/4" 5-Ply Construction

**Core:** Particleboard LD-2; Meets or exceeds requirements of ANSI A208.1 and CS236-66. Lead lined available.

**Stiles:** 1 1/4" laminated hardwood bonded to core; 1 3/8" optional.

**Rails:** 1 1/4" softwood bonded to core. Larger rails available. (Stile and rail frame dimensions may vary due to hardware specifications.)

**Faces:** All commercially available Premium Grade 2-Ply hardwood species; high density fiberboard (HDF); and high pressure decorative laminates (HPDL.)

**Adhesives:** Type II interior.

**Lites and Louvers:** Full lite available with no less than 6" stile width and top height, and 10" bottom height. No hardware preps within 2 1/4" from lite/louver opening.

**Prefitting:** May be prefit to net sizes and machined for hardware as specified.

**Sound Transmission Class:** Available up to STC-41.

**Finishing:** All Species available raw or with water-borne stain base UV finish that meets or exceeds WDMA or AWI system TR-6. EPA and California Air Resources Board (CARB) approved.

**Warranty:** Lifetime warranty for original installation. See our website for details.

**Environmental Features:** LEED credits available; No Added Urea Formaldehyde (NAUF) and FSC (Forest Stewardship Council) components available.

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## **AFD-45/60/90** Mineral Core and FireStop for Highest Fire Protection



**Maximum Size:** 4' 0" X 10' 0"

**Thickness:** 1 3/4" 5-Ply Construction

**Core:** Mineral core.

**Stiles:** 1" Georgia Pacific FireDefender® FireStop.

**Rails:** 1 1/2" top and 1" bottom Georgia Pacific FireStop. (Stile and rail frame dimensions may vary due to hardware specifications.)

**Faces:** All commercially available Premium Grade 2-Ply hardwood species; high density fiberboard (HDF); and high pressure decorative laminates (HPDL.)

**Adhesives:** Type-II Interior

**Lites and Louvers:** Please see our 45, 60, and 90 minute fire rated specification sheets on our website for lites and louvers criteria.

**Prefitting:** May be prefit to net sizes and machined for hardware as specified.

**Finishing:** All Species available raw or with water-borne stain base UV finish that meets or exceeds WDMA or AWI system TR-6. EPA and California Air Resources Board (CARB) approved.

**Warranty:** Lifetime warranty for original installation. See our website for details.



# Quality Crafted Architectural Flush Doors



## Sustainability is our Goal

At Haley Bros., we understand that there are many dimensions to *sustainability*. Our manufacturing element is more about than just recycling or healthy indoor air. Our commitment to the environment extends from our factories right back to the forests that are the ultimate sources for all wood products, and whose preservation is vital for our planet's future.

## FSC Certification

Haley architectural doors may be ordered as *FSC certified*. Haley Bros is proud to support *FSC (Forest Stewardship Council)* certification because FSC standards address the well-being of forest dependent communities and workers as well as the health and ecological integrity of the forest themselves.

## Recycling and Efficient Use of Resources

Our architectural doors also contain high levels of recycled content. We can stretch limited forest resources by recycling wood as much as possible. The particleboard core contains both wood recycled from mill waste (pre-consumer recycled content) as well as wood diverted from the landfill (post-consumer recycled content.) Equally important, our state-of-the-art manufacturing processes are highly efficient, both in energy and in the wood materials that go in to our doors.

## NAUF-Indoor Air Quality

We strictly avoid the use of inexpensive wood binders that contain dangerously high levels of formaldehyde and can off-gas in to interior environments, causing a variety of health problems. That's why our *NAUF (No Added Urea Formaldehyde)* products meet or exceed the latest Cal Green and California Air Resources Board (CARB) IAQ standards- the most stringent anywhere.

## Haley architectural doors have numerous environmental features and contributes to multiple LEED credits:

- \* Recycled content (MR 4.1) (MR 4.2)
- \* Geographic dependent (MR 5.1) (MR 5.2)
- \* FSC certified (MR 7)
- \* Ultra-low VOC: All adhesives contain No Added Urea Formaldehyde (IEQ 4.1)
- \* Ultra-low VOC: Low emitting materials; paints/coatings (IEQ 4.2)
- \* Ultra-low VOC: Low emitting materials; composite wood (IEQ 4.4)

For more information, including documentation you need to prove LEED compliance, please visit our website at [www.haleybros.com](http://www.haleybros.com).



## Veneer and Finish Options

### Birch

**Raw Color-** Cream or light brown tinged with red, nearly white sapwood.

**Grain/Appearance-** Heartwood is very apparent in rotary natural birch and tends to be a light reddish brown to brown, and has a grain with a very wavy appearance and a fine, even texture. Plain sliced features slightly wavy to classic cathedral pattern. Low natural luster.

**Characteristics-** Heavy, very strong.

#### Rotary Natural Birch



Clear

Heritage

Monarch

Newport

Oxford

Regency

Windsor

#### Rotary White Birch



Clear

Blonde

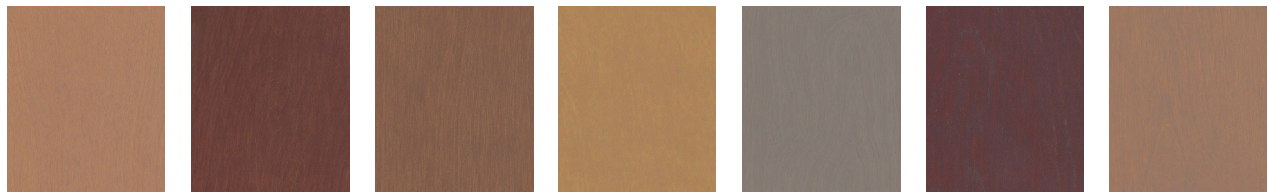
Heritage

Pear

Ember

Acorn

Mocha



Windsor

Spice

Pecan

Newport

Oxford

Regency

Monarch

Actual grain, amount and presence of darkened heartwood and color may be slightly different from what you see on these pre-finished pages. We recommend requesting a pre-finished physical sample for an accurate representation of your desired finish.

● **Larger images and more finishes are available at [www.haleybros.com](http://www.haleybros.com)**





## Veneer and Finish Options

### Birch

#### Plain Sliced White Birch



Clear

Windsor

Monarch

Newport

Oxford

Regency

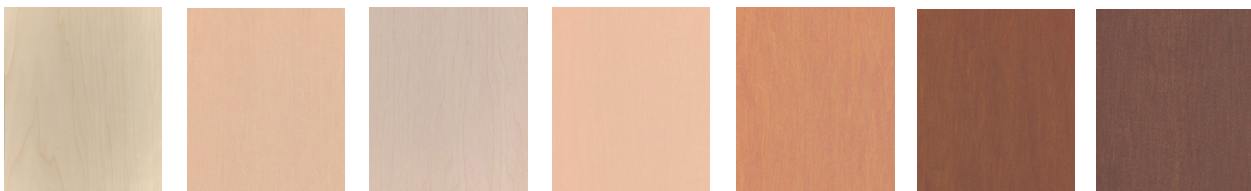
### Maple

**Raw Color-** Ranges from nearly white, to an off-white cream color, sometimes with a reddish or golden hue.

**Grain/Appearance-** Generally straight when quarter sliced, but classic cathedral grain when plain sliced. Has a fine, even texture.

**Characteristics-** Heavy, hard, tough. Excellent resistance to abrasion and indentations.

#### Plain Sliced White Maple



Clear

Blonde

Heritage

Pear

Ember

Acorn

Mocha



Windsor

Spice

Pecan

Newport

Oxford

Monarch

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## Veneer and Finish Options

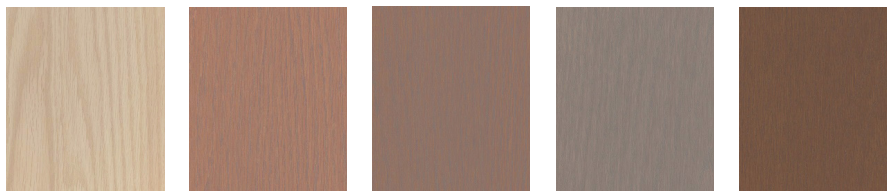
### Oak

**Raw Color-** (Red Oak) Slightly redder tinge than white oak and is more uniform in color. Heartwood has a more reddish cast. (White Oak) Light brown with a grayish tinge in the heartwood.

**Grain/Appearance-** (Red Oak) Grain is straight, with a coarse, uneven texture. (White Oak) More pronounced and longer rays than red oak.

**Characteristics-** Strong and durable; White oak resists moisture better than red oak.

#### Plain Sliced Red Oak



Clear

Windsor

Monarch

Oxford

Santa Rosa

#### Plain Sliced White Oak



Clear

Heritage

Windsor

Newport

Oxford

Monarch

Actual grain, amount and presence of darkened heartwood and color may be slightly different from what you see on these pre-finished pages. We recommend requesting a pre-finished physical sample for an accurate representation of your desired finish.

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## Veneer and Finish Options

### Cherry

**Raw Color-** Heartwood is a light pinkish brown when freshly cut, darkening to a deeper golden brown. Sapwood is a pale yellowish color, typically 1-2" wide.

**Grain/Appearance-** Has a fine to medium texture with close grain. The grain is usually straight or slightly wavy, with occasional gum pockets.

**Characteristics-** Lightweight, relatively hard.

#### Plain Sliced Cherry



Clear      Heritage      Monarch      Oxford      Newport      Windsor

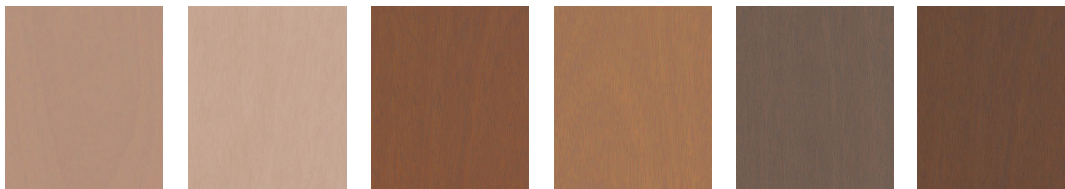
### Mahogany

**Raw Color-** Heartwood color is variable, ranging from a very pale pink to a deeper reddish brown, sometimes with streaks of medium to dark reddish brown.

**Grain/Appearance-** Grain is straight to interlocked, with a medium to coarse texture. Quarter sliced surfaces can also exhibit a ribbon-stripe appearance.

**Characteristics-** Relatively hard, very lustrous and durable.

#### Plain Sliced African Mahogany



Clear      Heritage      Windsor      Newport      Oxford      Monarch

Actual grain, amount and presence of darkened heartwood and color may be slightly different from what you see on these pre-finished pages. We recommend requesting a pre-finished physical sample for an accurate representation of your desired finish.

● **Larger images and more finishes are available at [www.haleybros.com](http://www.haleybros.com)**



## Veneer and Finish Options

### Walnut

**Raw Color-** Light gray-brown to dark purplish-brown.

**Grain/Appearance-** Plain to highly figured. Grain is usually straight, but can be irregular with crotches, curl, and occasional burls. Has a medium texture and moderate natural luster.

**Characteristics-** Moderately heavy, very strong for its weight; exceptionally stable.

#### Plain Sliced Walnut



Clear

Newport

Oxford

Windsor

### Ash

**Raw Color-** Cream to a very light brown heartwood with wide lighter colored sapwood.

**Grain/Appearance-** Straight; moderately open grain, somewhat lustrous appearance.

**Characteristics-** Heavy, strong, stiff; high in shock resistance.

#### Plain Sliced White Ash



Clear

Heritage

Windsor

Newport

Oxford

Monarch

Regency

Actual grain, amount and presence of darkened heartwood and color may be slightly different from what you see on these pre-finished pages. We recommend requesting a pre-finished physical sample for an accurate representation of your desired finish.

● **Larger images and more finishes are available at [www.haleybros.com](http://www.haleybros.com)**

## Factory Finishing

Since these are photographed images of veneers and finishes, the actual grain, amount and presence of darkened heartwood and color may be slightly different from what you see on these pre-finished pages. We recommend our customers request a pre-finished physical sample for an accurate representation of your desired finish. These requests are easily sent to us on the "Contact" page of our website: [www.haleybros.com/contact.html](http://www.haleybros.com/contact.html) or you may call us.

Need to *match an existing finish stain* on your job? We have years of experience of matching different colors including many plastic laminate solid colors. We request at least a 4" X 4" sample and 5-7 working days to produce matched finish samples for your approval.

### *Transparent Finish*

Haley provides finishes on both faces and vertical edges, while the top and bottom rails are sealed. Stains are gas dried, then finely scuffed. Top coat is applied passing through three UV lights. All factory finished doors are poly bagged or slip sheeted.

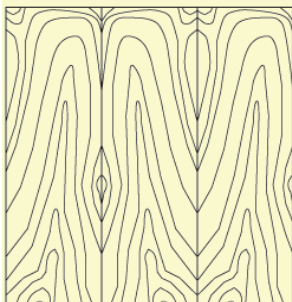
Our finishing system meets or exceeds AWI System TR-6 Catalyzed Polyurethane. It is water based stain and clear top coats that contain no VOC's (Volatile Organic Compounds.)



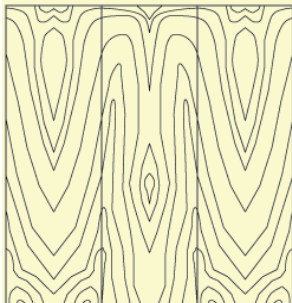
## Veneer Matching



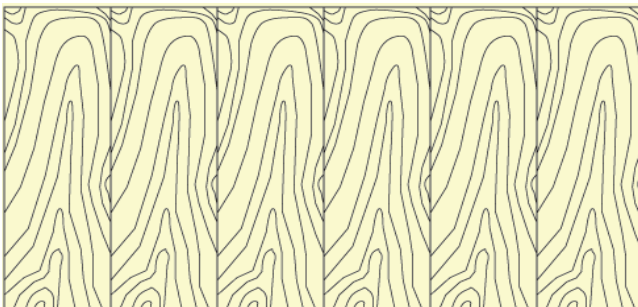
**BOOK MATCH-** The panels are slid and flipped, much like the pages of a book. This creates a repeating pattern over 2 panels where the grain lines connect at either end. Since the panels are flipped, light is refracted differently on adjacent panels and stains may be accepted differently. This sometimes creates a *barber-pole effect*, where panels alternate from a lighter shade to a darker shade. Certain species of wood accentuate this effect.



**BALANCED MATCH-** A step up from the book match is a balance match, where the width of the leaves is consistent across a panel.



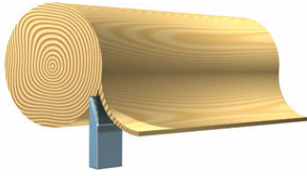
**CENTER MATCH-** The most aesthetically appealing is a balance and center match, where *the leaves are all the same width and the grain pattern is centered on the panel*. This is the most labor intensive and, therefore, is most expensive.



**SLIP MATCH-** The panels are "slipped" in to place without turning or flipping. The effect is a repeating pattern in which the grain lines are not continuous. Slip matching is especially pleasing with rift or quarter sawn veneer where the grain tends to be straight. Since the panels are not flipped, *light reflects the same from leaf to leaf* and stain is accepted equally.

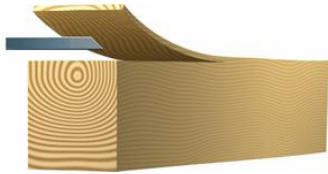
- **More veneer matching options are available. Please contact our customer service department.**

## Veneer Cut Options



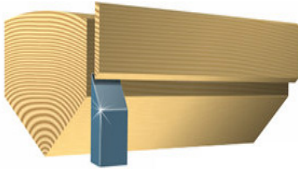
### *Rotary*

A full log is placed in a lathe and turned against a blade which peels a continuous sheet of veneer along the annular growth rings. Rotary cut veneer is exceptionally wide and produces bold, variegated grain markings.



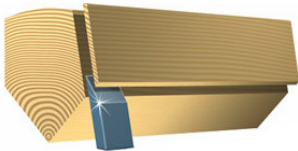
### *Plain Sliced*

A log is cut in half lengthwise and placed on the slicer. Individual leaves of veneer are cut parallel to the original cut. Flat cutting produces the well-known cathedral or loop-grain effect in the center of the leaf and straighter grain along the edges.



### *Quarter Sliced*

A log is cut in quarters lengthwise and placed on the slicer. Individual leaves of veneer are cut at a 90-degree angle to the growth rings. Quarter cutting produces a striped, often straight-grain effect.



### *Rift Cut*

Oak is the only species that is rift cut. Instead of quarter cutting, oak is cut about 15 percent off the quartered position to avoid the bold flake effect caused by rays which radiate from the center of the oak log. Rift cutting produces a comb-grain effect.

### Selection of Proper Species

The selection of the proper wood species for an architectural design can be the end result of a number of contributing factors and conditions. Appearance, intended use, costs, hardness and relative stability are the more important among many considerations.

The unique quality that wood relates to design is that each species has its own distinguishing characteristics. Once the species is chosen, its effectiveness may vary according to the manner which it is sliced, veneered, treated, and finished. (See Veneer Cut Options.)

An informed choice will reward the owner with the best possible performance by a natural building material.



All Haley products made in USA

*Our commitment to manufacturing quality architectural wood and High Pressure Decorative Laminate (HPDL) doors has become a time-honored tradition that has lasted decades, and is still growing. Our choice selection of hardwood and materials, expert craftsmanship, advanced machinery, mixed with experienced salespeople and management has largely accounted for our company's remarkable longevity.*

*We take great pride in constructing an outstanding product to meet your specification, and we thank you for allowing us an opportunity to offer you our architectural doors.*

*Please contact our sales representative for more information regarding our product. Or, please visit our website at **[www.haleybros.com](http://www.haleybros.com)**.*

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