

10. In case, Pre-laminated door is being used by customer, No painting is required. Proper sealing must be done on edges as recommended above.
11. For Post Lamination at site, user should ensure lamination at both sides with same thickness HPL to avoid warpage
12. For Routing/carving/grooving application in plain door:

Maximum depth of routing should not exceed 8mm.

Routing must be done on both side/ or in case of single side routing, back side must be grooved with grid size of 5inch x 5 inch or below. The minimum width of such grooves to be 9 mm and depth 5 – 6 mm. (Single side routing results in development of stress from other side which will leads to warpage/bend)



Sealer coat must be done immediately after routing on both sides

After routing the door must be kept horizontally on flat surface for 1-2 days before fixing on door frame.

Routing to be done leaving at least 125mm from all edges for door up to 3 ft. wide and for door with width above 3 ft. minimum 150 mm to leave, which is structural area in case of routed doors.

13. The HDHMR Door is a wooden product and should be handled, stored and installed properly to avoid warpage and chipping/damages.
14. The HDHMR Door is strictly for internal usage; do not expose these doors to direct sunlight or rain.

Note: Warping / twist/ buckling are within the norms of IS:2202- 1999. (The pre-condition stated all above should be strictly followed)

HDHMR ADVANTAGES



HIGHER DENSITY



TOUGHER THAN PLYWOOD



NOMINAL COST



HIGHLY WATER RESISTANCE



BORER RESISTANCE



MULTIDIMENSIONAL BONDING TECHNOLOGY



HIGHER SCREW HOLDING STRENGTH IN CORE



ZERO BUBBLE FINISH



ENVIRONMENT FRIENDLY



NO SPLINTERS/ CHIPPING



IDEAL ROUTABLE SUBSTRATE



Manufactured & Marketed By :-
Balaji Action Buildwell



Corporate Office: G-11, Udyog Nagar, Peeragarhi, Main Rohtak Road, New Delhi-110041

Customer Care Service: 011-41120018, 41120098

Download the Action TESA app, available on **Google Play Store & App Store**



HDHMR DOOR

INSTRUCTION *manual*



ABOUT HDHMR DOOR

“HDHMR Door” is the latest avatar for **Door Industry**. This novel application will add wings to your Doors in both commercial and residential segment. Inheriting the desirable properties viz. strength, durability & innovative application “HDHMR Door” is the best available substitute of Flush Doors & Traditional Doors. Manufactured by using the finest and strongest wood fibres of eucalyptus hard wood and best quality glue made in-house enhances the desired product performance. USP's are as mentioned below:

REAL WOOD STRENGTH & APPLICATION

- Real Wood Structure- Solid structure from inside
- Huge Surface Strength - Made from Eucalyptus hard wood
- Ensures Safety: - It is very difficult to punch a hole in HDHMR Door.
- Hassle free Lock installation
- Can be cut into any size, horizontally or vertically as per requirement.

INNOVATIVE APPLICATION - NEXGEN DOORS

- Unique Finish – Jointless surface product gives a unique finish in product.
- Best Routing & Engraving Surface - It can be made to any design as per architect's or customer's choice.
- No waviness - Ideal surface to paste the laminate, Veneer, membrane.... with zero bubble.
- Highly Water Resistant – Can be used in highly moist climatic areas & places.

COST EFFICIENT -

- Cost Savvy – Less Glue, High Production & Less Manpower
- Smooth Surface - Can be beautifully polished with various Colors matching with Door Frames.
- Value for Money – Can apply Duco Paint finish. No waviness & consumes less Paint

AVAILABLE IN: Length (inch) - 78, 81, 84 & 96
(Plain & Prelaminated)

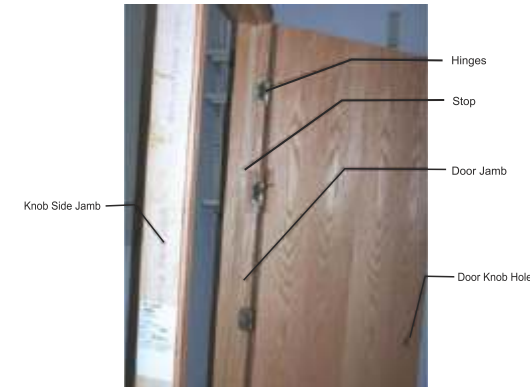
Width (inch) - 27, 30, 33, 36, 39, 42, 45 & 48

Thickness : 30mm & 32mm

DOOR CARE

instructions

1. HDHMR Doors are produced and packed in an ideal climatic condition, it is recommended that upon receipt of these doors at consumer end, it must be unpacked and kept on a flat surface with uniform weight to stabilise these doors in local climatic condition for 2-3 days.
2. The minimum Door Frame (Jamb) should be 3"x4" and above for single leaf (single stop).



3. The final Door size (inclusive of edge banding tape/ lipping or any other seal) should be kept 5 mm smaller from the internal opening of door frame/ Jamb to withstand with climatic changes.
Proper tools must be used for fixing of lock, handle, magic eye, door closer, door stopper, tower bolts etc.
4. It must be ensured that tower bolt and lock must be fixed simultaneously with fixing of hinges, and especially for under construction site care must be taken that the doors are not kept in open hanging position for longer period.
5. It is recommended to fix 4 number of 5 inch long butt hinge (12 to 14 gauge) for the door height up to 7 ft. height and 5 number of 5 inch long butt hinge for the door height above 7 ft.

6. While fixing hinges on door counter sunk (CSK) chipboard screw of size 4x 50mm to be fixed with pre drilling of pilot bore of 2.5mm and 50mm depth. Screws must be tightened with proper screw driver with torque limiter to avoid over tightening of screws. Never hammer screws / nails on doors.



7. Hinge position for door up to 7 ft. – first hinge 150 mm from top, second 250 mm from first hinge, third centre of 2nd and 4th , 4th hinge- 150 mm from bottom edge

Hinge position for door above 7 ft. – first hinge 150 mm from top, second hinge 250 mm from first hinge, third and fourth hinge to be fixed in proportion between 2nd and 5th , Fifth hinge- 150 mm from bottom edge.

8. Door edges must be sealed properly to restrict door expansion with following options:
 - a. Edge Banding
 - b. Hardwood Lipping
 - c. Epoxy/ acrylic/ PU sealing or painting
9. In case, Plain HDHMR Door is being used by customer, proper painting on both side surfaces at same time with epoxy/synthetic/PU/Deco paint or with sealer/primer/paint application.