

GENERAL: This document defines **SIGNUM Timber 49 dB Acoustic Door specifications** which meet with **ASTM E90/ ISO 10140-2, ASTM E413** and **ISO 717-1** for Sound Transmission Loss (**STC**) measurement. It includes proprietary design and performance specifications.

MATERIALS

Timber used for frame and shutter shall be seasoned hardwood or other species as per requirements. Core shall be sandwich type multi layered non-combustible composite. Anchor Bolts shall be of size M8 x 75 mm, galvanized. Vision Panel (optional) shall be of hermetically sealed double glazed unit (DGU) type of float or toughened glass.

CONSTRUCTION

Frame: Timber frames shall have a triple rebated profile of 150 mm x 78 mm constructed from seasoned timber. Frames shall be seasoned till maximum moisture content is less than 15%. Frames shall be in fully-assembled form with mitered joints for direct assembly at site. Support strip shall be provided on bottom of frame between vertical jambs to prevent warping/ damage during transport or installation. Provision for anchor bolt fasteners on each vertical jamb for fixing to Wall/ RCC surface shall be made. Center to center distance between the anchor fasteners shall not be more than 600 mm. Grooves for intumescent strip of size 10 mm x 4 mm shall be provided on both vertical jambs and horizontal jamb of frame.

Shutter: Timber shutters shall be 75 mm thick, fully flush double skinned, finished with PVC/ timber edge band on all four edges. Shutters shall have no visible screws or fasteners on either face.. Shutters shall be constructed sandwiched with proprietary sound deadening insulating material bonded to the inner surfaces of the boards using suitable permanent glue. Special Noise insulating acoustic gaskets shall be mounted on door periphery on 3 sides (and in the meeting edges in case of double doors) along with bottom drop down gasket/ seal to ensure maximum sound insulation from edges of door. Shutters shall be factory hot-pressed with ply or veneer or laminate on both faces. Shutters shall be factory prepared with pre-punched cut-outs and timber block supports to receive iron mongerey. Beading for vision panel shall be square or rectangular in shape with an HDHMR angled profile of 30 x 30 mm, with both sides bonded to the shutter face. Clearances at jambs and heads shall not be more than 3 mm between the frame and shutter. Floor level to shutter bottom clearance i.e. undercut shall not be more than 19 mm.

FINISHES

Timber Frames shall be suitably prepared and a coat of anti-termite paint (black) applied to face in contact with walls. All other faces shall be polished and coated with melamine or primed with top coat of PU Paint to match laminate on shutter or machine-pressed with laminate to match shutter faces.

Shutter surfaces shall be suitably prepared and finished with polish and coat of melamine in case of veneers or primed with top coat of PU paint in case of ply or laminated and edges painted to match laminate shade as per project requirement. Paint shade shall be of approved RAL colour shade for the project and wherever used, primer shall be 35 microns DFT and top coat of two component polyurethane paint also 35 microns DFT.

QUALITY ASSURANCE

Timber Acoustic doors shall be manufactured by a unit certified for its quality systems as per ISO 9001: 2015 standards from a recognized certifying authority. Timber door unit shall be designed and manufactured to comply with relevant specifications. Acoustic door unit shall be GreenPro certified to be eco-friendly by CII-IGBC (Indian Green Building Council).

PACKAGING

Frames and shutters shall be covered with 3 mm foam sheets and wrapped with clear stretch film to prevent damages to surface finish during transportation and at site. Packaging labels shall be applied to each set as per project schedule for easy identification at site. Additional protection such as side bolsters from card-board paper shall be used to protect during transit and at-site storage. All frames shall be stacked flat and shutters flat/ vertically on top of bolsters in clean, dry, well-ventilated areas.

SIGNUM