



BLACK MOUNTAIN DOOR™

AMWELD® LASER-EDGE™ STEEL DOORS & FRAMES



POLYSTYRENE CORE

Amweld 15 LE Laser-Edge™
Amweld 25 LE Laser-Edge™ Galvannealed
Amweld 17 LE Seamless Edge
Amweld 27 LE Seamless Galv.
Amweld 21 LE Replacement

MINERALBOARD CORE*

Amweld 35 LE Temperature Rise
Amweld 37 LE Temperature Rise Seamless

Gauges 14 | 16 | 18 | 20

Standard Features

- Continuous laser-welded edge seam (Laser-Edge™)
- Fully bonded, heat cured, nip rolled, core
- Positive pressure / fire rated
- Closer reinforced
- Flush top channel
- Inverted bottom channel
- Non-handed design
- Universal 4 1/2" hinge prep
- Prime painted

Special Options

- Beveled lock edge
- Galvannealed (A60) steel (25 LE)
- Seamless Edge (17 LE)
- Custom Hardware Preps
- Decorative colors available
- Full line of lites and louvers

*250° temperature rise core
Ideal for interior and exterior applications

POLYURETHANE CORE

Amweld 83 LE Galv.
Amweld 85 LE Laser-Edge™
Amweld 87 LE Seamless Edge
Amweld 89 LE Seamless Galv.

Gauges 14 | 16 | 18 | 20

Standard Features

- Continuous laser-welded edge seam (Laser-Edge™)
- Fully bonded, heat cured, nip rolled, core
- Not available fire rated
- Closer reinforced
- Flush top channel
- Inverted bottom channel
- Non-handed design
- Universal 4 1/2" hinge prep
- Prime painted

Special Options

- Beveled lock edge
- Galvannealed (A60) steel (83 LE)
- Seamless Edge (87 LE)
- Custom Hardware Preps
- Decorative colors available
- Full line of lites and louvers

HONEYCOMB CORE

Amweld 45 LE Laser-Edge™
Amweld 47 LE Seamless Edge

Gauges 14 | 16 | 18 | 20

Standard Features

- Continuous laser-welded edge seam (Laser-Edge™)
- Fully bonded, heat cured, nip rolled, core
- Positive pressure / fire rated
- Closer reinforced
- Flush top channel
- Inverted bottom channel
- Non-handed design
- Universal 4 1/2" hinge prep
- Prime painted

Special Options

- Beveled lock edge
- Galvannealed (A60)
- Seamless Edge (47 LE)
- Custom Hardware Preps
- Decorative colors available
- Full line of lites and louvers

Ideal for interior applications where insulation is not required.

DECORATIVE DOORS

Amweld 61 LE Laser-Edge™
Amweld 63 LE Seamless Edge

POLYSTYRENE CORE

6 PANEL / 8 PANEL
2 PANEL / 1 PANEL

Gauges 16* | 18 | 20

(A40) Galvannealed Steel

- Continuous laser-welded edge seam (Laser-Edge™)
- Fully bonded, heat cured, nip rolled, core
- Positive pressure / fire rated
- Closer reinforced
- Flush top channel
- Inverted bottom channel
- Non-handed design
- Universal 4 1/2" hinge prep
- Prime painted

Special Options

- Seamless Edge (63 LE)
- 8 panel design
- 2 panel with half glass
- Custom Hardware Preps
- Decorative colors available

Ideal as a decorative entrance door

*16 gauge available in 6 panel only

SPECIALITY & ACOUSTICAL DOORS

Amweld 51 LE Series Soundshield
Amweld 7900 Series FireSonic

Soundshield® 16 Gauge Standard Performance

- Continuous laser-welded edge seam (Laser-Edge™)
- Seamless Edge (17 LE)
- 16 gauge meets STC 42
- Unit includes frame and sound seals

Soundshield® acoustic doors are made in a similar design to the 15 LE door. Special Soundshield® core provides the desired acoustical performance. Available galvannealed for exterior use. Ideal for band rooms, quiet areas, meeting rooms, etc.

FireSonic® 14 | 16 | 18 Gauge Standard Performance

- Single meets STC 35, 45, 47, 49, or 51
- Double meets STC 49
- Seamless Edge (17 LE)
- Includes frame and sound seals

FireSonic® acoustical doors are made in similar design to the 700 Series door. FireSonic® core provides desired acoustical performance and durability of a steel-stiffened door. Ideal for quiet rooms where security is also a main consideration.

STILE AND RAIL

Amweld 300 SERIES (F6)
(A40) Galv. Steel

16 Gauge

Standard Features

- True Stile and rail tubular construction
- Non-handed construction
- Full glass design (FG)
- 5 1/2" top / stiles 8" bottom rail
- Fully welded corners
- Flush top and bottom
- Meets SDI level 3, model 3
- Galvannealed standard

Special Options

- Flush glass with mid-rail (FG2)
- Half glass design (G)
- Vision lite design (V)
- Polystyrene core as shown or fiberglass type insulation
- Flush panel design available

Ideal for high-frequency entrances to replace aluminum storefront doors, as well as high abuse applications including schools and hospitals.

STEEL STIFFENED

Amweld 700 Series (Handed)
Amweld 500 Series (Non-Handed)
(Welded Seam)

Gauges 14 | 16 | 18

Standard Features

- 22 gauge steel stiffeners hat shaped welded 6" O.C.
- Batt wool insulation
- Fully welded (seamless) edges
- Square edges (500)
- Beveled hinge/lock edge (700)
- Inverted top and bottom channel
- Meets NAAMM/HMMA specifications

Ideal for extreme durability and security purposes where aesthetics are not top priority.

Special Options

- Galvannealed (A60) steel available
- 18 gauge steel stiffeners
- Lites and louvers installed
- Variety of hardware preparations
- Flush top and/or bottom cap
- Meets NAAMM/HMMA (HMMA-861)
- A variety of hurricane-resistant products are available

Per NAAMM/HMMA specifications, some visible spot welds at steel stiffener locations should be expected. High gloss finishes are not recommended.

SECURITY DOORS

(BULLET RESISTANT)
Amweld 1538 (Level 1)
Amweld 1544 (Level 3)
(Laser-Edge™)

16 Gauge

Standard Features

- 16 gauge panels with 14 gauge security plates
- Supercore, Polystyrene core
- 1538 Series meets "UL" level 1 (One Plate)
- 1544 Series meets "UL" level 3 (Two Plates)
- 5" heavy weight hinge preparation
- Unit includes security-approved hardware

Ideal for high security requirements including banks, electric substations, ATM buildings, etc.



Amweld 400 SERIES (Interlock®)
Steel Gauges 14 | 16

Standard Features

- Knocked down with precision fit Interlock® corners
- 3" - 20" jamb depth
- 2" faces standard
- 5/8" high stops
- 1/2" returns*, 7/16" returns at 5 3/4"
- Unequal rabbet design
- Anchors available for masonry, wood and metal stud walls
- WHI - 3-hour & positive pressure embossment

Special Options

- Galvannealed (A60) frames available for exterior and interior use
- Special faces 1" thru 4" and more
- 4" header design available
- Equal rabbet design
- Special hinge or lock locations
- Decorator colors available
- Special profiles available
- Fire rating available up to 20" jamb depth

Standard steel frames are available knocked-down or welded and ground smooth. Profiles and anchors to fit any wall condition. Embossed 3-hour label standard. Variety of hardware preparations available. (Standard is a 4 1/2" hinge (standard or heavyweight) preparation and 4 7/8" strike.)

**7/16" returns standard on 5 3/4" frame*



Amweld 2600 SERIES (Slip-On) Drywall
Steel Gauges 16

Standard Features

- Knocked down with precision fit Sure-Fit® corners
- Installs over finished walls
- 3" - 15" jamb depth
- 5/8" high stops
- 1/2" double returns
- Unequal rabbet design
- 18 gauge welded strap sill anchors
- Screw adjusting jamb anchors
- WHI - 1 1/2-hour & positive pressure embossment

Special Options

- Galvannealed (A60) frames available for interior use
- Special faces available in 1", 1 1/4", 1 1/2", 1 3/4"
- Pre-drilled and countersunk sill holes available
- Equal rabbet design
- Special hinge or lock locations
- Decorator colors available
- 4600 Series - trimmed opening

Standard (slip-on) drywall frames are designed for quick and easy installation over finished walls. Embossed 1 1/2-hour label standard. A variety of hardware preparations available. (Standard is 4 1/2" (standard or heavyweight) hinge preparation and 4 7/8" strike.)



Amweld 800 SERIES Adjustable
Steel Gauges 16

Standard Features

- Interlock® corner construction
- Split frame design
- Installs over finished walls
- 3 1/4" - 10 7/16" jamb depth
- 2" face and 1/2" return standard

Special Options

- Galvannealed (A60) frames available for interior or exterior use
- Special faces available from 1" to 8"
- Special returns available from 3/8" to 1"
- Fire ratings available
- Decorator colors available
- 1200/1800 Series - replacement frames

Adjustable steel frames are designed to retrofit walls or encapsulate existing frames. Custom variations are available to wrap almost any wall condition. Ideal for lead-paint encapsulation.



4400 SERIES Double-Egress
Steel Gauges 14 | 16

Standard Features

- Knock down with mitered corners
- 4" - 12 3/4" jamb depth
- 5/8" high stops
- 1/2" returns
- Anchors available for masonry, wood and metal stud walls

Special Options

- Galvannealed (A60) frames available
- Variety of custom hardware preparations available
- Decorator colors available

Note: Standard double-egress frames are designed for cross corridor applications to assist in traffic flow pattern. (4 1/2" (standard or heavyweight) hinge preparation is standard.)



Specialty Frames
Steel Gauges 12 | 14 | 16

Standard Features

- 3000 series Thermal Break frames minimize condensation problems*
- Specialized face trim, backbends, and return profiles
- Pocket slide frame

- Non-handed frame systems for the Metal Building Industry
- 1400 or 1600 bullet resistant for UL752 level 1 or 3 protection
- Hospital stop
- Kerfed

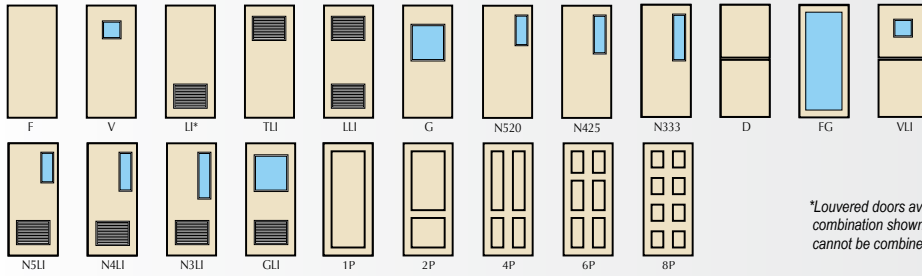
Black Mountain Door frame manufacturing capabilities are second-to-none. See our Technical Data Manual for additional information.

**Available in 14 gauge (A60) galvannealed only.*



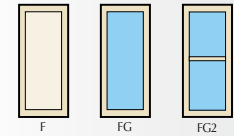
STANDARD DOOR DESIGN

Amweld Series - 15LE / 17LE, 25LE / 27LE, 35LE / 37LE, 45LE / 47LE, 85LE / 87LE,



STILE & RAIL DOOR DESIGN

Amweld Series - 300



*Louvered doors available with any light combination shown above. Louvers and lites cannot be combined in labeled doors.

GENERAL AVAILABILITY of Fire Rated Doors

Description	Series Available								
	15LE	25LE	35LE	45LE	500	700	61LE	51LE	300
3 Hour rating	•	•	•	•	•	•	•		
3 Hour Rating w/ Lite	•	•	•	•	•	•	•		
1 1/2 Hour Rating	•	•	•	•	•	•	•		
3/4 Hour Rating	•	•	•	•	•	•	•	•	
20 Minutes (N.H.S.)	•	•	•	•	•	•	•	•	•
Positive Pressure	•	•	•	•	•	•	•		•
Fusible Link Louvers	•	•		•	•	•			
250° Temperature Rise			•						
450° Temperature Rise			•	•	•	•		•	
Height up to 8'-0**	•	•	•	•				•	•
Height up to 10'-0**	•	•	•						
Embossed Panels							•		
Protection Plates to 48" A.F.F.	•	•		•	•	•			
Double Egress			•	•					
Height up to 120"					•	•			

*Consult the Black Mountain Door Technical Data Manual for information. The above charts are intended to be a brief synopsis, not a complete description or a "mix and match". Consult the Black Mountain Door Technical Data Manual for more specific information.

GENERAL AVAILABILITY of Fire Rated Frames

Description	Series Available					
	400	600	800	1800	2600	4400
3 Sided Single	•	•	•	•	•	
3 Sided Double	•	•	•	•	•	
4 Sided Single	•	•				
Slip-On Drywall		•				•
Double Egress						•
Contra Swing	•	•				•
Multi-Swing	•					
Transom w/o Bar	•					
Transom w/ Bar	•					
Adjustable			•	•		
3 Hour in Drywall	•					
10'-0" Opening Height	•					•
Fire Window	•					
Side / Transom Lite	•					
K-D	•	•	•	•	•	•
Welded	•		•	•		•
Hospital Stops	•	•				•
Positive Pressure	•	•	•			•
Snap In Anchors	•					
4 Sided Access	•	•				•
Height up to 120"	•					

CUSTOM COLOR MATCHING



STANDARD COLORS

- Dark Bronze
- Polar White

PREFINISHED DOORS & FRAMES

Prefinished doors and frames are a smart choice to improve appearance while reducing the costs of jobsite painting. Select from our standard low VOC decorator colors or contact our factory for custom color matching. Complementing the seamless appearance of Black Mountain Laser-Edge™

doors, is the exceptional finish of our in-house e-coating process. You can expect a high quality surface, consistent thickness and maximum durability. All Black Mountain doors and frames are available in prefinish with the exceptions of the Series 300, 51LE, 53LE, 1538, 1544, 500 & 700.

FabMaker

Advanced Information Technology Services

With Black Mountain's FabMaker software, you can easily draw fab elevations and estimate with accuracy. For more information, contact our IT Department.

Specifying & Ordering

Go to www.blackmountaindoor.com or send an e-mail to: marketing@blackmountaindoor.com for a hard copy of the Technical Data Manual.



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BUILT TO HIGHER STANDARDS

BLACK MOUNTAIN DOOR.



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