

4000 PREHANGING SYSTEM

System Includes:

- 4000 MACHINING CENTER
- 4100 ASSEMBLY CENTER
- 4200 LOADER



100-350+
doors/shift

ACCURATE - Precisely accomplishes drilling and mortising operations.

EFFORTLESS - Automatic routing, drilling and changeover controlled by straightforward and easy to read control panel.

INNOVATIVE - Automatically compensates for dimensional variation in door width and/or thickness.

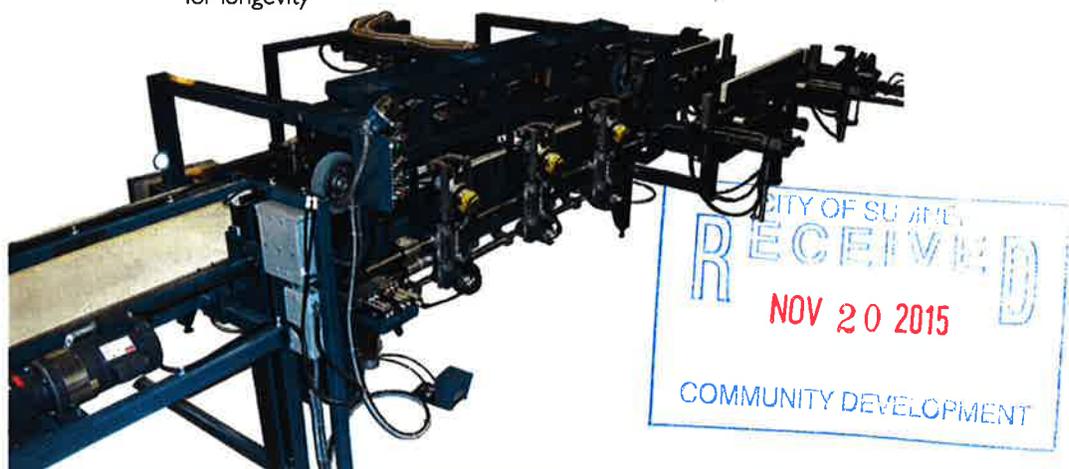
ECONOMICAL - Cost effective solution for high production shops.

4000 MC STANDARD FEATURES

- Bottom-up clamping system, which accommodates both interior and exterior doors
- Underside lock drilling enables exit cut viewing for quality control
- Superior dust collecting system
- Chip breaker to achieve crisp clean hinge mortising
- Automatic lock, latch and faceplate machining
- Industrial-grade material and parts for longevity

4000 MC OPTIONS

- Power feed automatically feeds door into machining center
- Automatic deadbolt capability speeds up operation
- Vacuum package facilitates safe, clean operation
- Spare parts and extra bit package promote proactive maintenance
- Autofeed screwfeeder option makes for consistent production

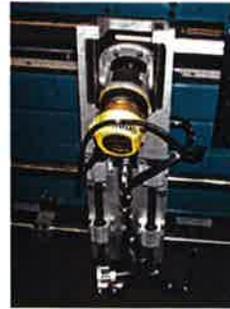




4000 MC latch and faceplate motors



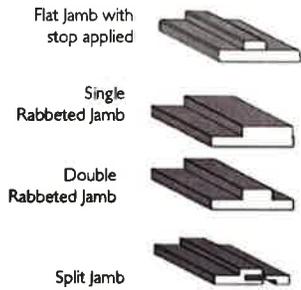
4100 AC Gun Assembly



4000 MC Hinge Router



4000 MC Control Panel



4000 MC SPECIFICATIONS

Capabilities

Door Width 1'6" to 3'6"
 Door Height 6'6" to 7'0"
 Door Thickness 1-3/8" to 1-3/4"

Jamb Width 2-1/2" to 10-1/2"
 Jamb Height 6'6" to 7'0"
 Jamb Thickness 1/2" to 1-1/2"

Hinge Size 3-1/2" to 4" std
 Hinge Radius 5/8" only
 Hinge pattern adjustable 29" - 33"

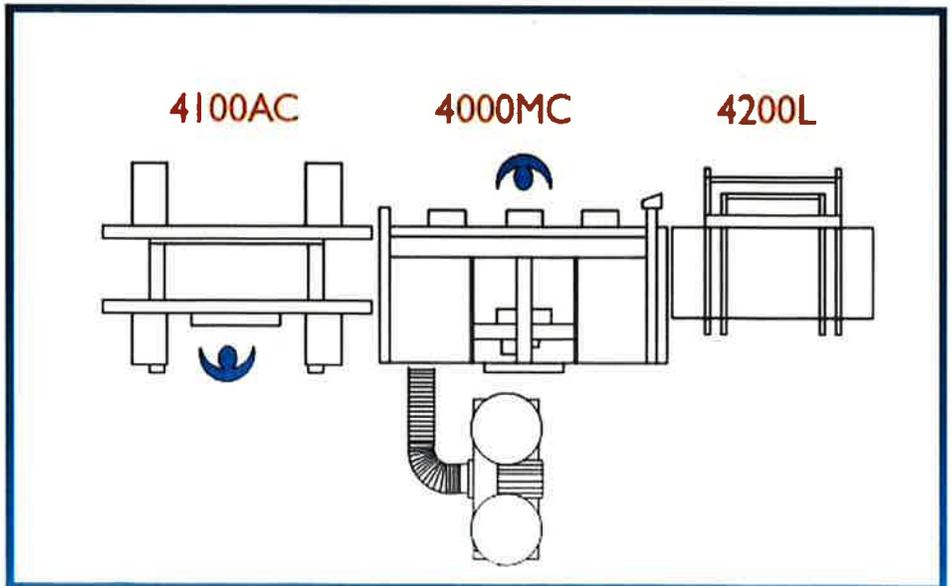
Lock Backsets 2-3/8" to 2-3/4"
 Faceplate Width 1" to 1-1/8"
 Faceplate Length 2-1/4" to 2-3/4"
 Faceplate Router 1/2" to 1-1/8" x 2-3/4"

4000 INSTALLATION

Approx. Shipping Wt. 3,000 lbs.
 Floor Space 6'6"W x 9'0"L x 6'H

Electrical 230V 1 Ph
 208/230V or
 460V 3Ph

Air 15 CFM @ 90 PSI
 Vacuum 1900 CFM @ 8" duct



4000 ACCESSORY MACHINES



4100AC ASSEMBLY CENTER

Standard Features

- Roller systems accommodate both left and right hand doors, eliminating lifting.
- Multi directional clamping to properly clamp unit for tight fitting corners.
- Vertical clamping levels the surface of the head/leg joints for stapling.
- Large control knobs for ease of operation
- Rugged construction insures reliability and long machine life
- Heavily protected proximity sensor reads the location of each staple from manually adjusted index tabs

4100AC Options

- Strike side nail guns secure door for shipping
- Out-feed support roller to maintain production flow
- 10' out-feed conveyor rollers



4200L LOADER

Standard Features

- Automatic vertical indexing to position door at proper work height, eliminating adjustments
- Infinitely adjustable for stacking, de-stacking, loading and unloading of materials.

4200L Options

- Pneumatic feed
- End load conveyor
- Side load conveyor



360S MATERIAL STAGING DEVICE

360S Standard Features

- Foot pedal activation
- Rotates 360°
- Tilts from 80° vertical to 0° horizontal
- Will maneuver a 200lb. door easily and smoothly
- Rollers glide material into place
- Built for years of rugged use

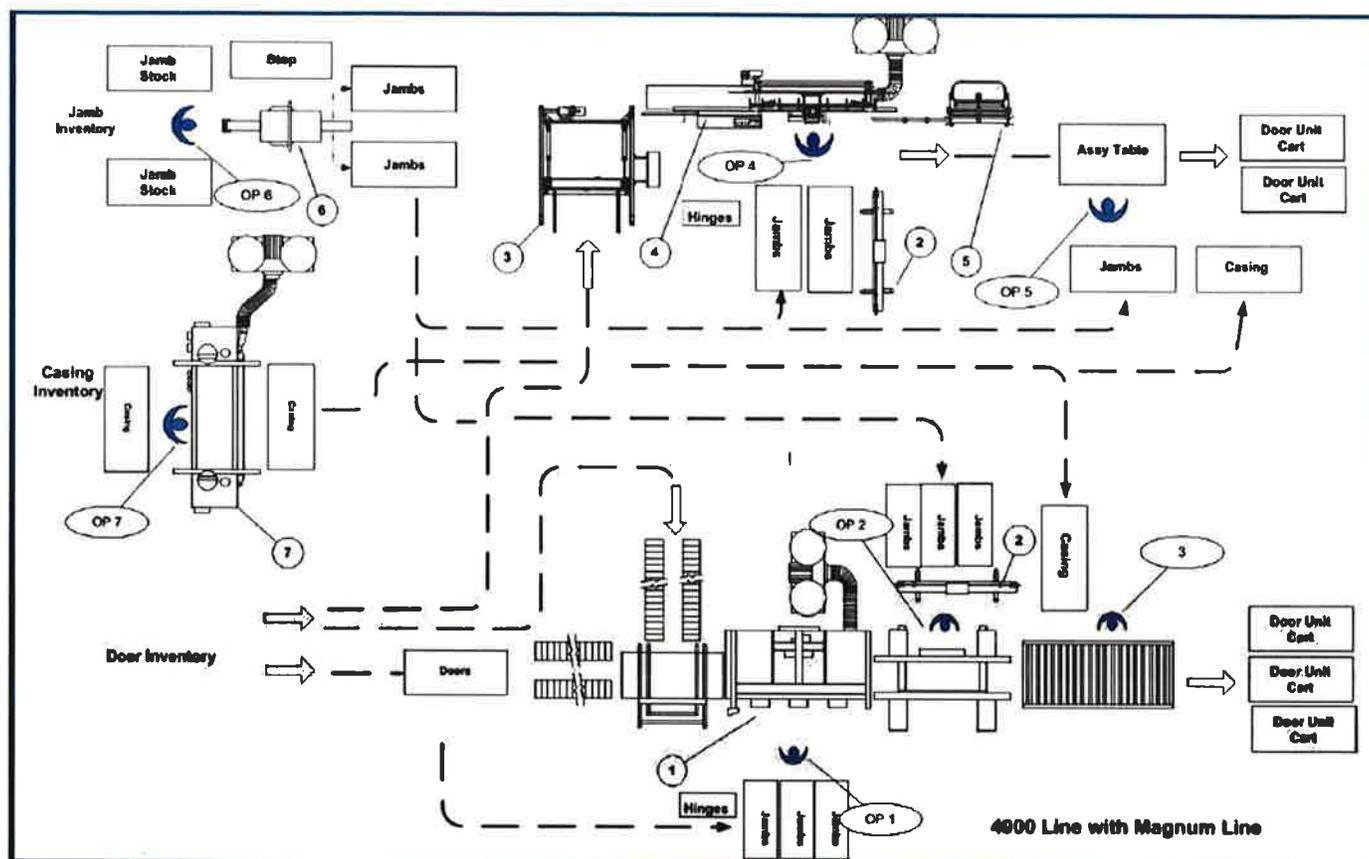
DOOR HAND

All doors are denoted by the direction of their swing, or their "hand." Before a door can be hung, its swing must be known.

Currently, there are two methods used to determine the hand of a door: The first method, the one most straightforward and commonly used, designates the door simply as Right Hand (RH) or Left Hand (LH). To determine the swing of the door, simply face the hinge pin side of the door and note the location of the door knob. If the knob is to the left, it is a Left Hand door. If the knob is to the right, it is a Right Hand door.

The other method currently in use designates the door as either Right Hand Reverse (RHR) or Left Hand Reverse (LHR). To determine the swing of the door in this method, face the outside of the door. The outside is the street side of an entrance door; the corridor (hall) side of a room door; or the side opposite the hinge pins on a communicating door (a door that connects two rooms). If the door opens toward you and the hinges are on the left, it is a Left Hand Reverse. If the hinges are on the right, it is a Right Hand Reverse.

Although both methods are equally accurate and achieve the required results, the first system is preferred. Before hanging a door, make sure that all concerned agree on the method that will be used. This will prevent confusion down the line when the pre-hung doors are actually being installed.



SHOP LAYOUT SUGGESTIONS WITH THE 4000 SYSTEM

300-400 DOORS PER SHIFT

MACHINERY

- | | |
|---------------------|---------------------------------------|
| 1. 4000 System | Automated door machine system |
| 2. 250M/250MX | Strike jamb router |
| 3. Magnum Loader | Loader for stack loading of 4. Magnum |
| 5. Magnum | Door machine custom, exterior units |
| 6. Magnum Un-Loader | Feeds assembly table |
| 7. 450 | Stop jamb sticher |
| 8. 1020/1120 | Double-end trim saw |

MACHINE CAPACITY RATE

- | | |
|-------------|---------------------|
| 4000 System | = 45 doors per hour |
| Magnum | = 30 doors per hour |

FLOOR SPACE REQUIREMENT

6,000 Square Feet

ELECTRICAL REQUIREMENT

100 Amps @ 230V 3-Phase (Plus Vacuum Input)

AIR SUPPLY

60 CFM @ 90 PSI

MANPOWER REQUIREMENTS

7 people total for both lines, plus stock-puller/warehouse worker (not shown).

Operator 1

4000 System Machining Stage Operator.

Operator 2

4000 System Assembly Stage Operator.

Operator 3

4000 System Casing Applicators

Operator 4

Magnum Operator - custom specials and exteriors.

Operator 5

Door Unit Assemblers - for custom, special, and exterior units; frame assembly and casing application.

Operator 6

450 Operator - for casing and jamb preparation.

Operator 7

1020 Operator - for casing and jamb preparation. Also stocks primary line.