

APPLICATION DATA SHEET



ENVIROGRAF®

AP038-03-2020

Product Number: 38

Intumescent Material ES/MP

ES/MP; ES/MP/900; ES/MP/FC; ES/MP/GP; ES/MP/V; ES/MP/PLY

PLEASE READ CAREFULLY

Many panelled doors are found in a damp cold atmosphere in buildings that have, in some cases, been empty for many years. It is essential that the property is dried out first and the heating has been turned on for at least two months to allow for any shrinkage of the moisture-filled timber. Otherwise, if treated before the doors have dried out thoroughly, the paper will buckle and the panels will shrink and crack. In recent years, we have seen doors in which (after drying out) there was a gap between the panel and the stile of up to 10mm width. In extreme cases, check over the building with a moisture meter. For new panelled door manufacture, Envirograf® Membrane cloth (ES/MP), can be adhered sandwiched between two panels, using Product 46 (IA intumescent adhesive) at a rate of 4m² per litre.

IMPORTANT a spirit based undercoat or topcoat **must** be applied to the card.

GENERAL REQUIREMENTS FOR ALL DOORS

All doors with a thickness of stiles and rails between 30mm and 35mm must have the stiles, rails, and beads coated with the Envirograf® intumescent coating system (clear or white finish). Doors with stiles and rails 36mm or more thick only need the beads to be coated with the Envirograf® intumescent coating system.

PREPARATION OF EXISTING VARNISHED VENEERED DOORS

Wash the doors down with detergent water and clean off with warm, clean water. Ensure that all wax and grease has been cleaned off. An Envirograf® de-waxing fluid is available if required. Rub all the panels with coarse glass paper and be certain to dust off and remove all flaking varnish and ensure all corners are given a good key, then apply one coat of the supplied **ENVIROGRAF® PRODUCT 93 (STABOND)**

BONDING/SEALING LIQUID TO THE PANELS ONLY.

Coat the beads and (if necessary) the stiles and rails with Envirograf® Product 42 (HWAP adhesion primer) at 12m² per litre (this dries in about 30 minutes). When dry apply two coats of Envirograf® Product 42 HW02N intumescent coating at 8m² per litre per coat (this dries in about 1 to 1½ hours). Cut the Envirograf® veneer or plywood panels to the size of each door panel, then evenly apply with a comb applicator Envirograf® Product 46 (IA water-based intumescent adhesive) to both the grey flecked side and to each door panel to ensure a perfect bond. Once the adhesive has been applied on both surfaces insert the Envirograf® veneer or plywood panels on the door panel. Once everything is dry, apply the Envirograf® clear top coat to the whole door. **Do not apply any adhesion primer to the panels.**

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PREPARATION OF EXISTING PAINTED DOORS

Wash the doors down with detergent water and clean off with warm, clean water. Ensure that all wax and grease has been cleaned off. An Envirograf® de-waxing fluid is available if required. Rub all the panels with coarse glass paper and be certain to dust off and remove all flaking paint and ensure all corners are given a good key, then apply one coat of the supplied **ENVIROGRAF® PRODUCT 93 (STABOND) BONDING/SEALING LIQUID TO THE PANELS ONLY.**

Coat the beads and (if necessary) the stiles and rails with Envirograf® Product 42 (HWAP adhesion primer) at 12m² per litre (this dries in about 30 minutes). When dry, apply two coats of Envirograf® Product 42 HW01F intumescent coating to the beads, stiles, and rails at 8m² per litre per coat. Cut the white card to the size of the door panels then evenly apply with a comb applicator Envirograf® Product 46 (IA water-based intumescent adhesive) to both the grey flecked side and to each door panel to ensure a perfect bond. Once the adhesive has been applied on both surfaces insert the white card on the door panel. Once everything is dry, apply the Envirograf® Product 42 HW04/S undercoat and HW top coat to the door and panels. **Do not apply any adhesion primer to the panels.**

IMPORTANT

Only the risk side (i.e. the room side) of the door needs to be upgraded. If the door is at the top of stairs or is separating from a corridor, then both sides of the door must be treated.

MAKING NEW PANELLED DOORS

Apply the protection cloth between two pieces of plywood using Envirograf® Product 46 (IA water-based intumescent adhesive) to adhere together. The panels must be rebated into the stiles and rails by 15mm and adhered in with the same adhesive.

CHEMICALLY-STRIPPED DOORS

If a door has been chemically-stripped, the door must be left for two weeks and be regularly washed with clean water to extract all the stripping chemicals from the wood.

REMEMBER THE INTUMESCENT DOOR SEALS, LOCK PROTECTION, AND PROTECTED DOOR CLOSERS!

A fire door is not a fire door without intumescent seals on the door or frame, plus intumescent paper must be placed around locks (see Envirograf® Products 69, 71, and 100). Protected door closers should be fitted, such as the all-in-one Envirograf® Product 71A door closer 3-hinge set with factory-fitted intumescent fire protection. Door stops only need to be 12mm thick or less, NOT 25mm THICK!