

REVEALS

Information Bulletin 264



Eggers Industries

Date: February, 2015

Applicable Rules:

1. Reveals may be horizontal, vertical, or radiused*, and may intersect.
2. Reveals are not allowed in 45-minute Particle or 45-min Agrifiber core
3. Where reveals are allowed their dimensions location from lites and door edge as well as inlay requirements will vary.
4. Both faces of the door require the identical reveals to maintain the warranty. Exception: SCL core doors can have shallow reveals one side only or a different reveal pattern on the two faces. This exception does not apply if inlays are required.
5. Reveals in exterior doors are subject to manufacturing approval and will void the warranty.
6. Reveals (with or without inlays) cannot be closer than 7" to the lock stile of doors having concealed vertical rod hardware. This applies to both horizontal and vertical reveals (See figure #3).
7. Reveals requiring inlays must be factory cut.
8. Reveals adjacent to a lite cutout are limited to a maximum depth of 3/64".
9. Available reveal layouts may be limited due to conflicts between hardware machining and the inlay/reveal machining.
10. Warranted and available in U.L. doors labeled 20 through 90 minute.
 - A. Depth:
 1. Without Hardwood Inlay:

The dimensions are limited to 3/64" deep by 1/4" wide. Cross-banding will be visible in the bottom of the reveal (See figure #1). There is no maximum length for shallow reveals. This is the only type of reveal allowed in acoustical and lead lined doors.



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2. With Hardwood Inlay:

The maximum dimension is 3/8" x 3/8". The inlay will be visible in the bottom of the reveal. Inlay species may be selected as compatible or contrasting with face veneer species as desired. A maximum of 31 lineal feet of reveals is allowed per side to maintain label and warranty (See figure #2). Inlays in 45-90 min doors cannot cross through the stiles, rails, or required blocking. Where blocking is not involved the minimum stile and rail dimension will be 1"; where 5" blocking is involved the minimum stile and/or rail dimension will be 6".

11. Warranted and available in non-rated, non-mineral core doors.

A. Depth:

1. Without Hardwood Inlay:

The dimensions are limited to 3/64" deep by 1/2" wide. Cross-banding will be visible in the bottom of the reveal (See figure #1). There is no maximum length for shallow reveals. This is the only type of reveal allowed in acoustical, lead lined and specific bullet-resistant doors.

2. With Hardwood Inlay:

The maximum dimension is 3/8" x 1/2". The inlay will be visible in the bottom of the reveal. Inlay species may be selected as compatible or contrasting with face veneer species as desired. To maintain the warranty reveals cannot exceed 31 lineal feet per face (See figure #2).

* If a radius reveal is required you must contact the factory for pricing and warranty information.

Explanation of 3/64" Reveal Depth

Eggers has set the maximum depth of reveals without inlays at 3/64". This dimension allows approximately .065" of cross-banding to remain between the reveal on door core, based on a standard veneer face and 1/11" cross-band. The actual thickness of cross-banding will differ based the tolerances of the materials being used, and the component options.

The inlay requirement is due to both structural and aesthetic concerns. While the use of inlays for reveals deeper than 3/64" addresses the structural concerns they do not avoid all of the aesthetic issues. The aesthetic issue arises when the requested depth of the reveal is close to the location of the crossband/inlay bond. In such cases the component and machining tolerances may result in part of the reveal having crossband showing at the bottom. To prevent this, the minimum depth of reveals



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requiring an inlay will 5/32". This dimension allows for various face options over a 1/11" cross-band plus machining tolerance.

Finished options for reveals:

The table below defines the reveal appearance for the reveal finishing "picks" available with factory finished doors.

PICK	(Shallow) Reveal without Inlay – Crossband is the Visible Surface in the Reveal	Reveal with Inlay – Matching or Compatible Lumber is the Visible Surface in the Reveal
BLACK PAINT	Reveal will be painted black	Reveal will be painted black
SAME AS FACE	If the face will be finished with an <u>opaque varnish</u> the reveal will match the face. If face will be <u>stained</u> the reveal will have the same stain applied as the face, but it will not match the face (usually the reveal will be darker in appearance).	If face will be finished with an <u>opaque varnish</u> the reveal will match the face. If face will be <u>stained</u> the reveal will have the same stain applied as the face and will match the face.
MATCH SAMPLE	The reveal will be finished a different opaque varnish or stain than the face and will match an approved sample with a reveal. For this option there will be separate sample approval numbers for the face and the reveal.	The reveal will be finished a different opaque varnish or stain than the face and will match an approved sample with a reveal.

Terminology

Due to confusion in using different terms to describe the same constructions this information section is to clarify and standardize the terms we use to describe constructions.



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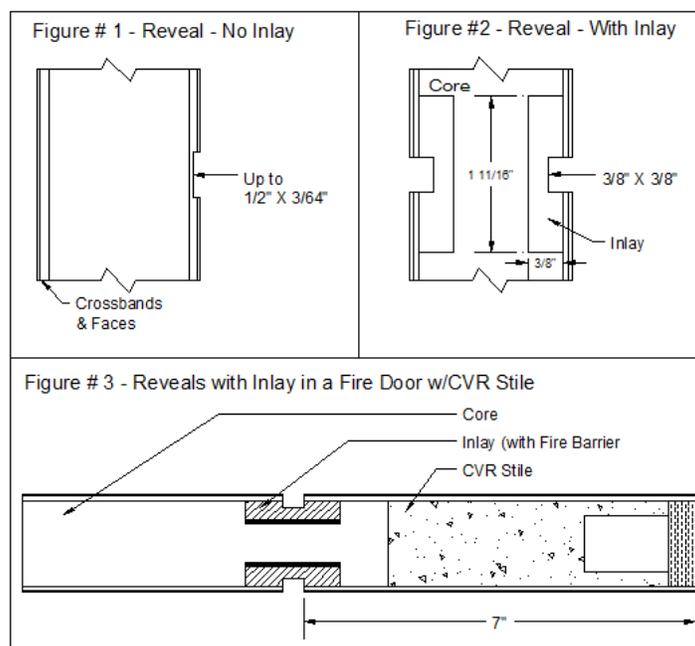


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The terms “reveals” and “quirks” have been used interchangeably. To standardize, Eggers literature and computer codes will only reference the term “reveal”. The following terms and definitions describe where we will use certain terms.

1. Reveals without inlays: Reveals 3/64” deep, do not need lumber glued into cores, see Figure #1
2. Reveals with inlays: Reveals that require lumber to be glued into a groove in the core prior to face application, see Figures #2 and #3.
3. Inlays
lumber or similar material glued into a groove in the core material prior to the application of the door facing.
4. Liners:
Interior blocking used around cutouts for lites and louvers. Liners extend from one face of the door to the other, replacing the core material in that area.



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