



Bonded Metal Elevator Door Skins are the perfect way to carry a design theme across a project, from cab interior to cab exterior and beyond. Included within this group are door skins for elevator car doors and hoistway doors. Elevator car doors are an integral part of the cab itself and move along with it. Hoistway doors are the exterior doors located between an elevator shaft or hoistway and the floor landing; they're only visible from outside the elevator cab on each floor. When the cab reaches its destination, the elevator car door and hoistway door open simultaneously.

Bonded Metal Elevator Door Skins are available for both elevator car doors and hoistway doors. Both may be specified in a wide range of Bonded Metal colors, patterns and patinas that provide maximum design versatility and unprecedented resistance to abrasion and wear.

Material Description

Bonded Metal is the product of a unique technology that casts metal granules in a tough, FRP matrix. Advanced mold-making techniques assure perfect reproduction of every fine detail in the original patterned surface. The result is lightweight but extremely durable castings with the character and appearance of solid metal.

Bonded Metal Elevator Door Skin selections are defined by three basic parameters:

Parameter	Description	Page
Material	The metal incorporated into the composite that gives the surface its color and character. Slight variation in color can occur due to the nature of the Bonded Metal manufacturing process.	3-6
Patina	A contrast-enhancing surface treatment applied to the Bonded Metal.	3-6
Pattern	The distinctive texture or design cast into the Bonded Metal surface.	3-6

Bonded Metal Characteristics

Aspect	Description
Environment	Suitable for interior and select exterior applications. When installed outdoors, it is normal for the surface to weather over time to a deeper patina. Bonded Metal does not absorb moisture and should not rot or rust.
Fire Rating	Bonded Metal is NFPA and IBC class B fire rated and UBC class 2 fire rated.
Routine Maintenance	The Bonded Metal surface has been sealed with a high-quality interior/exterior acrylic lacquer. It is a hard, durable finish that will last for many years but can be damaged if cleaned improperly. Avoid using harsh abrasives. If solvents are ever required for cleaning only naphtha or other aliphatic hydrocarbons should be used. Additional details can be found in the Architectural Materials Care & Maintenance document on our website.

Material Thickness

The Bonded Metal castings available for elevator door skins have an overall sheet thickness of 3.5 mm or less. If door edges and returns are being used, the added thickness needs to be considered. It is the specifier's responsibility to determine if the desired Bonded Metal casting is suitable for a particular application in terms of both clearance and local code compliance. Please see page 7 for individual pattern thicknesses.

Door Skin Sizes

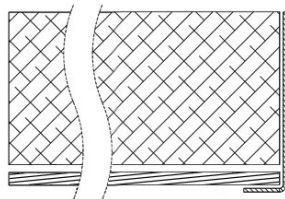
Elevator Door Skins are available for the standard overall clear opening sizes shown below:

Standard Elevator Clear Opening Dimensions			
3'0" x 7'0"	3'6" x 7'0"	4'0" x 7'0"	Custom sizes are available by special order. For some configurations, pattern placement and layout restrictions may apply.
3'0" x 8'0"	3'6" x 8'0"	4'0" x 8'0"	
3'0" x 9'0"	3'6" x 10'0"		Single-speed side-opening doors are limited to a maximum door skin sheet width of 48" including returns.

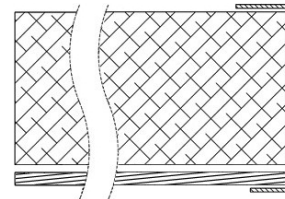
Edges and Returns

Bonded Metal Elevator Door Skins are typically used with a formed metal trim piece that captures the exposed edge of the Bonded Metal casting. Edge trim can be specified with an "L" shaped return or with a "U" shape that returns around the back side of the door.

"L" SHAPED RETURN



"U" Shaped return



Installation

Standard contact adhesive or epoxy resin should be used for adhering Bonded Metal Elevator Door Skins. All laminating should be performed using appropriate pressure and time considerations. Forms+Surfaces assumes no responsibility or liability for the efficacy of any third party's laminating procedures. Forms+Surfaces recommends the use of contact adhesives and epoxy resins that meet or exceed the following general performance criteria:

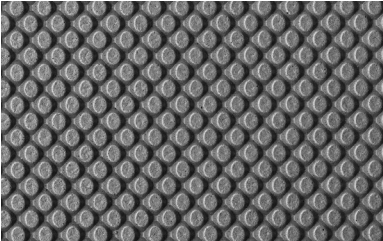
	T-Peel Strength	Shear Strength
Contact Adhesive	20-25 pli	1100 psi
Epoxy Resin	20-25 pli	2750 psi

Note: Data assumes a seven-day cure at 75° F.

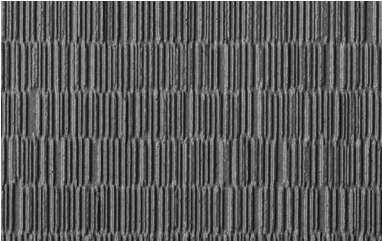
Standard Pattern & Color Options

All of the patterns shown on pages 3-6 are available as standard options.

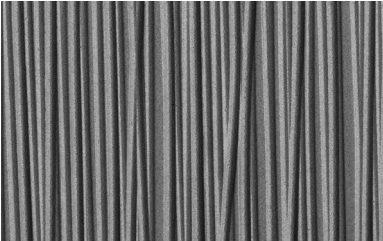
Bonded Aluminum, Natural Patina



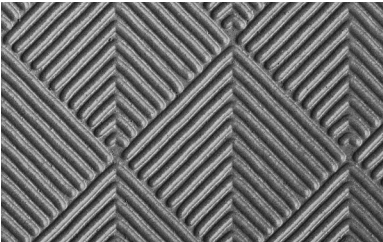
Austin



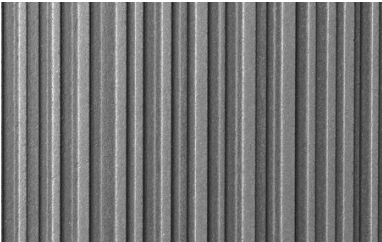
Dash



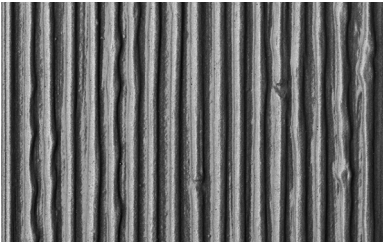
Grass



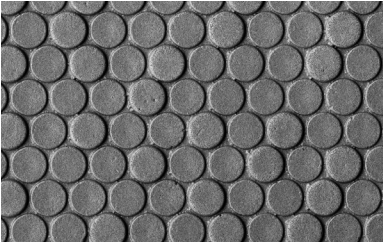
Herringbone



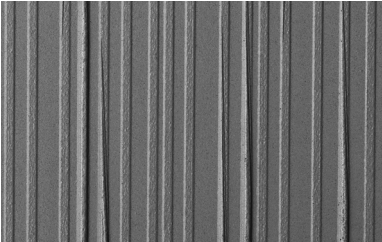
Loft



Rain



Trevia

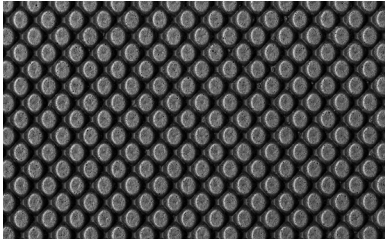


Undercurrent

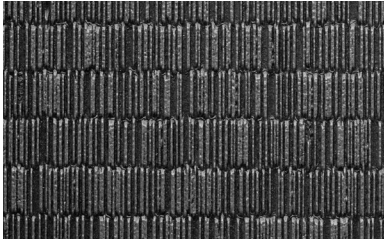
Note: Because different computers will render colors and textures differently, actual finishes may vary from those shown.

Standard Pattern & Color Options, continued

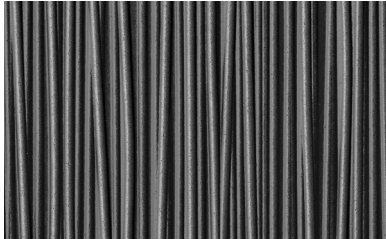
Bonded Aluminum, Dark Patina



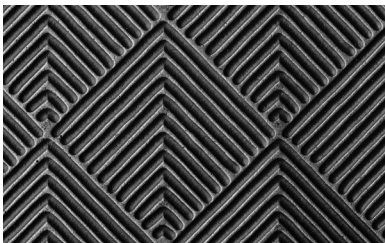
Austin



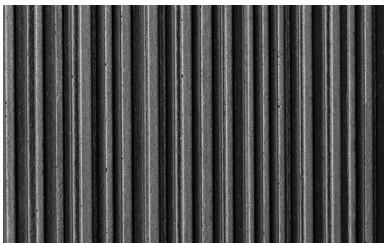
Dash



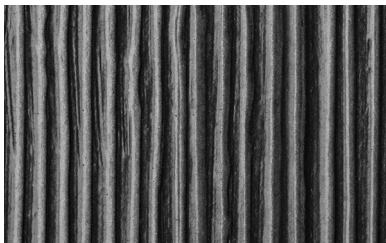
Grass



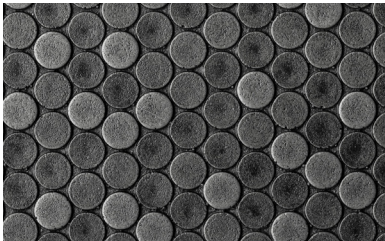
Herringbone



Loft



Rain

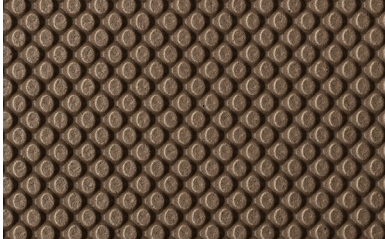


Trevia

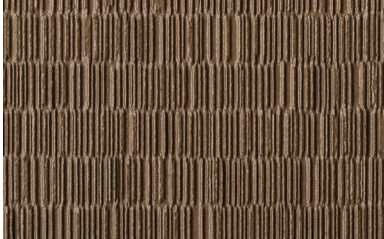
Note: Because different computers will render colors and textures differently, actual finishes may vary from those shown.

Standard Pattern & Color Options, continued

Bonded Bronze, Natural Patina



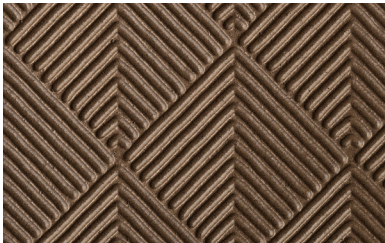
Austin



Dash



Grass



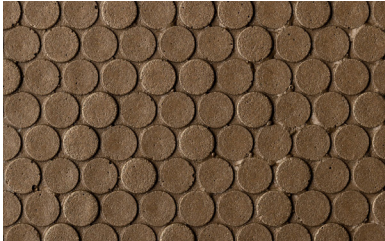
Herringbone



Loft



Rain



Trevia

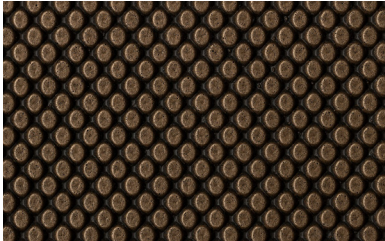


Undercurrent

Note: Because different computers will render colors and textures differently, actual finishes may vary from those shown.

Standard Pattern & Color Options, continued

Bonded Bronze, Dark Patina



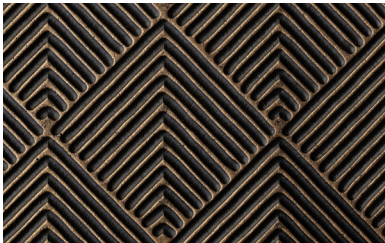
Austin



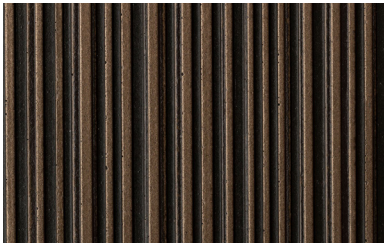
Dash



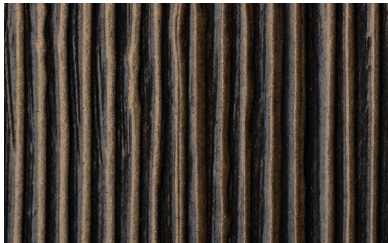
Grass



Herringbone



Loft



Rain



Trevia

Note: Because different computers will render colors and textures differently, actual finishes may vary from those shown.

Material Specifications

For use in standard applications, the chart below shows thickness and sheet size dimensions for all patterns suitable for Bonded Metal Elevator Door Skins. Additional pattern options may be available depending on your application.

Pattern	Patina		Sheet Thickness	Sheet Size
	Natural	Dark		
Austin	•	•	0.129" (3.3 mm)	47.2" x 119.6" (1200 x 3038 mm)
Dash	•	•	0.133" (3.4 mm)	47.5" x 119.4" (1207 x 3035 mm)
Grass	•	•	0.133" (3.4 mm)	47.9" x 120" (1219 x 3048 mm)
Herringbone (H)	•	•	0.137" (3.5 mm)	47.9" x 120" (1219 x 3048 mm)
Herringbone (V)	•	•	0.137" (3.5 mm)	47.9" x 120" (1219 x 3048 mm)
Loft	•	•	0.106" (2.7 mm)	47.8" x 119.8" (1215 x 3045 mm)
Rain	•	•	0.110" (2.8 mm)	47.9" x 120" (1219 x 3048 mm)
Trevia	•	•	0.118" (3.0 mm)	47.9" x 120" (1219 x 3048 mm)
Undercurrent	•		0.129" (3.3 mm)	47.6" x 119.4" (1210 x 3035 mm)

Technical Support & Project Management

Because each project is unique, our knowledgeable support team is ready to help. Our technical sales, engineering, sustainability, and project management professionals regularly assist our clients worldwide. Please contact us at 800.451.0410 or sales@forms-surfaces.com to discuss your project.

How To Specify

A Design Guide is available for Bonded Metal Elevator Door Skins to lead you through the specification process in a simple, checkbox format. The Design Guide captures all the information needed to generate a quote: dimensions, features, and other options. To get started, give us a call or visit us at www.forms-surfaces.com.