INTERNATIONAL STANDARD

ISO 6443

Second edition
2005-10-15

Door leaves — Method for measurement of height, width, thickness and squareness

Vantaux de portes — Méthode de mesure de la hauteur, la largeur, l'épaisseur et l'équerrage

Reference number
ISO 6443:2005(E)

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Published in Switzerland

Foreword

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The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

ISO 6443 was prepared by Technical Committee CEN/TC 33, *Doors, windows, shutters, building hardware and curtain walling* (as EN 951:1998) and was adopted, under a special “fast-track procedure”, by Technical Committee ISO/TC 162, *Doors and windows* in parallel with its approval by the ISO member bodies.

This second edition cancels and replaces the first edition (ISO 6443:1980) which has been technically revised.

Throughout the text of this document, read “... this European Standard ...” to mean “... this International Standard ...”.

Foreword

This European Standard has been prepared by Technical Committee CEN/TC 33 "Doors, windows, shutters and building hardware", the secretariat of which is held by AFNOR.

This European Standard replaces EN 25:1975.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by June 1999, and conflicting national standards shall be withdrawn at the latest by December 1999.

This standard is one of a series of standards for doors. The test method relates to performance requirements to be published in EN 1529.

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and the United Kingdom.

1 Scope

This European standard applies to all rectangular door leaves and the measurable parameters of doors of other shapes.

This standard specifies the method to be used to measure the dimensions of height, width and thickness, and defects of squareness of door leaves.

2 Apparatus

2.1 Measurement instrument for height and width

Steel measuring tape or similar measuring instrument, accurate to 0,5 mm.

2.2 Measurement instrument for thickness

Micrometer or similar measuring instrument accurate to 0,01 mm.

2.3 Measurement instrument for squareness

A metal square having two arms with inside reference dimensions of (500 ± 1) mm. The right angle between the arms shall be accurate to 0,1 mm in 500 mm. The square shall incorporate a dial or digital gauge accurate to 0,1 mm mounted at the 500 mm reference point of one arm (see figure 1).

NOTE : An additional block and feeler gauges may be used in place of the dial or digital gauge

3 Test specimens

Test specimens shall be stored and tested in a non-destructive environment within the ranges of 15 °C to 30 °C and 25 % to 75 % relative humidity.

Doors which are designed to be glazed, shall be supplied for testing with all glazing carried out in accordance with the door manufacturer's specifications.

4 Procedure

4.1 Height and width measurement

Measure, to the nearest 1 mm, the height and width of each door leaf along lines a-a, b-b, c-c, d-d parallel to, and (20 ± 5) mm from, each edge respectively (see figure 2).

NOTE : In the case of a door leaf with rebated edges, the dimensions of height or width should be measured to the inner edges of the rebates.

4.2 Thickness measurement

Measure the thickness at 6 points located (20 ± 5) mm from the edges and at the positions indicated in figure 2, to the nearest 0,1 mm.

NOTE : If a measuring point occurs where the thickness is not representative of the doors, e.g. because of surface profiles, local adjustment of the measurement position is permitted.

4.3 Squareness measurement

Measure any deviation from squareness of the door leaf at all four corners to the nearest 0,1 mm.

5 Expression of results

Record :

- height and width measurements and maximum deviations in relation to the specified dimensions ;

- thickness measurements and maximum deviation in relation to the specified dimension ;

- the four measured values of deviation from squareness.

6 Test report

The test report shall contain the following information :

a) reference to this European standard ;

b) all necessary details to identify the door leaf ;

c) all relevant details concerning the type, specified dimensions, materials, form and construction of the door leaf ;

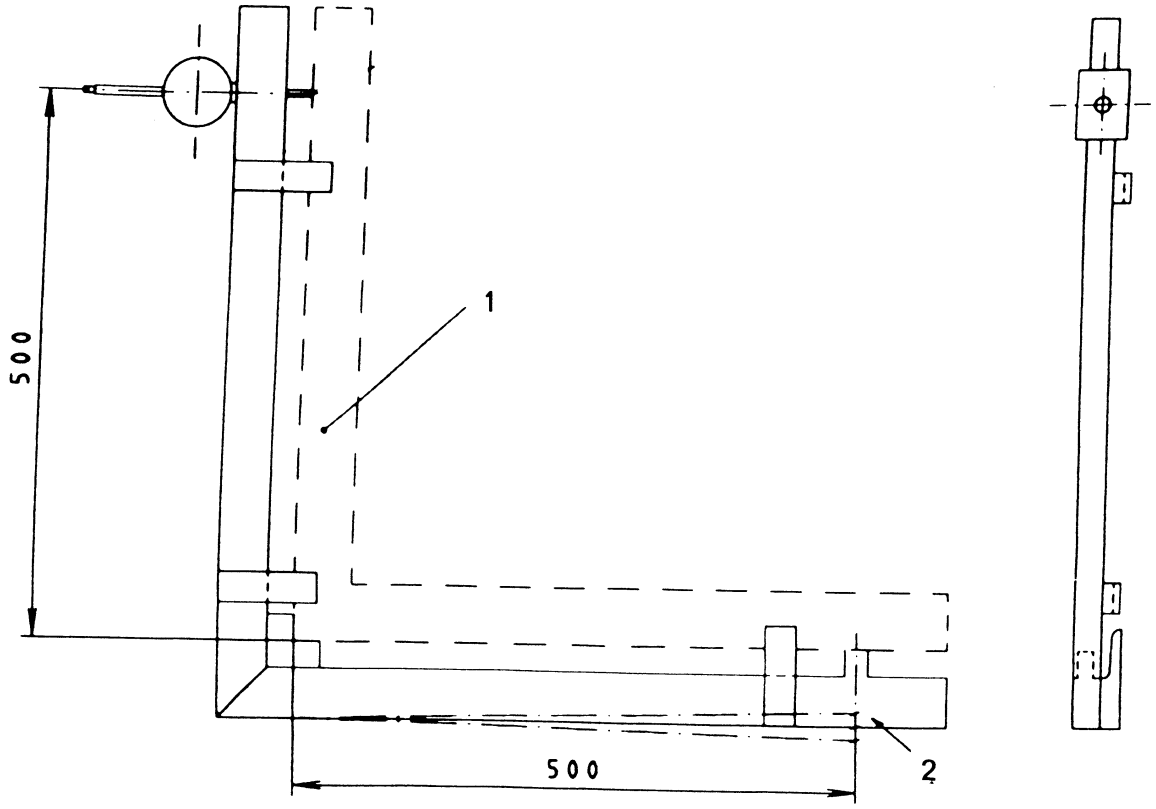
d) laboratory storage and testing conditions ;

e) the results expressed as in clause 5 ;

f) name of testing laboratory ;

g) date of test.

Dimensions in millimetres



1 Reference square to calibrate the instrument
2 Max. 0,1 mm deviation from squareness

Figure 1 : Measurement instrument for squareness including reference square for calibration

Dimensions in millimetres

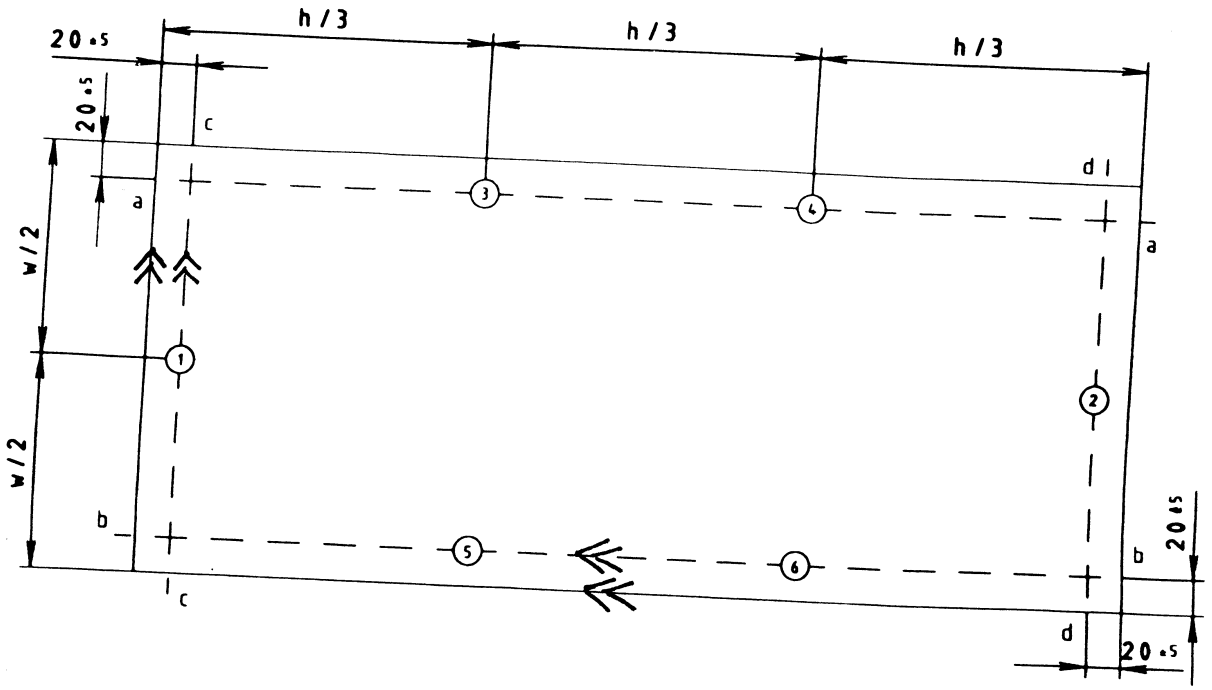


Figure 2 : Measuring points and lines for door leaf

ICS 91.060.50

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