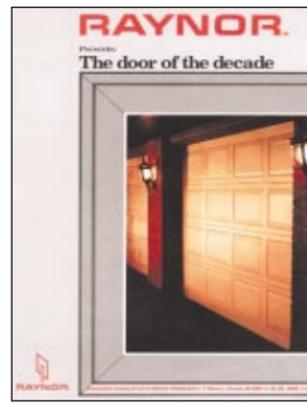


FROM THE PAGES OF
HISTORY

**The Steel Raised-Panel Garage Door
The First Decade: 1978-1989**

Editor's Note: Since 1950, the steel raised-panel (SRP) garage door has likely been the single most popular sectional garage door in North America. This is an attempt to capture an accurate chronology of the early significant events in the development of this historic door. Wherever possible, we sought for verifiable data through direct contact with knowledgeable company representatives.

The Raynor Decade, 1980.



1974

The Idea. Martin Door President David Martin approaches Stanley Door President Elliott Smith about developing a residential sectional steel garage door with raised-panel designs like those found in the new Stanley steel entry door. Using a raised-panel redwood garage door from Seagate Mills in Oregon as an ideal design, Stanley engineers Jim Sealy and Aldo Romanelli work on a prototype. Martin recalls that the first prototype collapsed when opened.

1980

Clopay introduces its Model 80 SRP door in 1979 or 1980. With spot-welded construction, the door uses a green weldable prime-painted surface, painted with an electrostatic paint system. The manufacturing line includes a "lock bead" to prevent slippage in the die, minimizing oil canning (a waviness in the steel surface).

Raynor announces its Decade door, later saying the door is the first SRP door to be "marketed successfully on a national level." The door is 2" thick with 24-gauge steel skins. The first Raynor model has a smooth surface, offered in white primer only, no windows, and in a limited number of sizes. To achieve a wood door look, Raynor's top and bottom sections are taller than the two middle sections, and the top and bottom "rails" are taller.

1983

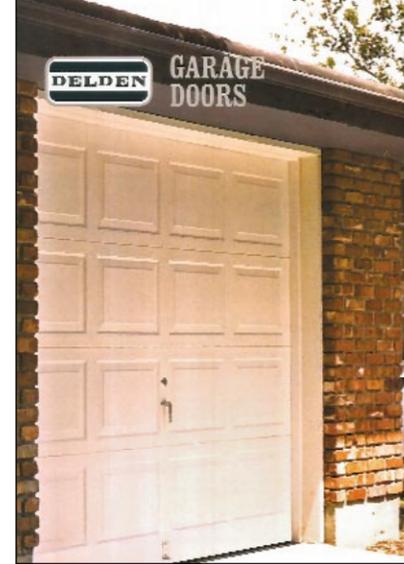
Amarr introduces its first SRP door, the Heritage, with "an enhanced raised-panel design."

Delden introduces its Century (C-300) door, a "true 24-gauge" SRP door with a smooth surface. To simulate a wood door look, the doors include 5" top and bottom rails with a 5" end stile profile.

The Garage Door Group is formed in Kansas City, Mo., producing residential raised-panel steel sections for Amarr, Delden, and Ankar.

Tog-L-Loc Construction. Clopay begins using a new technique called Tog-L-Loc to fasten the stile framework to the door without piercing the paint surface.

Wood-Grain. A wood-grain exterior begins to appear on models from Raynor, Clopay, and others.



The Delden Century, 1983.

1985

Garaga introduces the industry's first aluminum raised-panel garage door, the High Technology door, offered in white and medium bronze. The insulated version is manufactured with a high-speed polyurethane injection method. A steel High Technology door is added in 1986.

Tog-L-Loc Retainer. Amarr introduces a fastenerless bottom retainer, attached with the Tog-L-Loc method.



The Wayne-Dalton Foamcore, 1987.

1987

Foamcore. Wayne-Dalton introduces Foamcore, a foamed-in-place SRP door with a poly laminate liner on the inside, offering an insulated door at an economical price. Foamcore later becomes the largest-selling individual brand name garage door sold in the U.S.



The GADCO Freedom HDPE door, 1989.

1988

Longer Warranty. Raynor warrants its SRP Decade doors "for as long as you own your home."

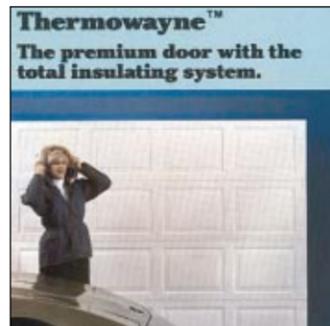
1978

Stanley introduces the industry's first steel raised-panel (SRP) door. According to best recollections, the door is 1-3/8" thick and probably named the Sta-Lite 500. Later, Stanley produces a 2" model. The original door features welded construction and pinch-resistant section joints that are later removed for stronger construction. Initial sales are lackluster. Competitors begin working to develop their own version of the SRP door.

1981

Wayne Door (which became Wayne-Dalton in 1982) announces its first SRP door, the Thermowayne, "the first door to utilize foamed-in-place polyurethane insulation filled between two steel sheets." The 1-3/8" thick door includes a "true thermal break" and unique integral struts. The door is honored at the 1982 World's Fair in Seattle for its breakthrough insulating features.

Windsor introduces its first SRP door, the Model 450. Windsor Door offers a unique emboss option: a design engraved into the standard embossment.



The Wayne Door Thermowayne with integral struts, 1981.



The Windsor 450, 1981.

1982

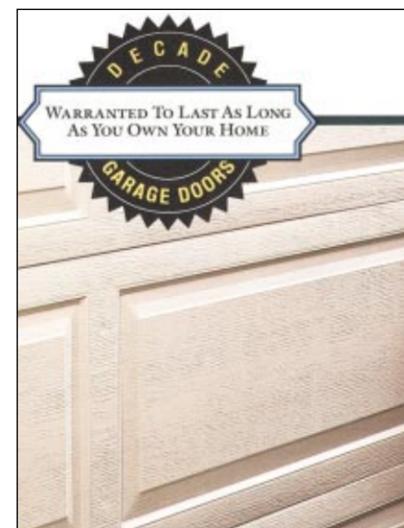
Overhead Door introduces its Series 187/188 SRP door. The doors feature a small box hinge specifically designed for steel doors and "curled interior panel edges for added safety."

Longer Warranty. Raynor announces a 10-year section warranty against rust.

1984

GADCO introduces the Americana Series 7524 SRP door and soon adds a wood-grain texture.

Raynor adds ranch panels in 1986 and an extended warranty in 1988.



1986

Colors. More section colors appear besides white. Brown was likely the second color. By 1990, many manufacturers offer five or more colors such as almond, sandstone, grey, etc.

Decorative Windows. By the late 1980s, many decorative window options are available, usually formed with plastic inserts in various designs.

Martin Door produces its first SRP door, the Woodcraft WC24. Sections are made of a higher tensile steel for better dent resistance. For safety, the doors feature hemmed edges on certain flanges and stiles, and rounded corners on all mounting brackets.

Spilman-Jellá Mfg. (which became Anozira in 1987) produces a 23-gauge SRP door, the first prepainted stiles, a steel top section with ranch windows, and the first mixed-panel door.

Wide Panels. Spilman-Jellá (Anozira) introduces the industry's first "ranch" panel, a wide version of the basic rectangular raised-panel design, along with a wood-grain texture. Raynor debuts Decade II, also with ranch panels and wood-grain texture.

Recessed Panel. Clopay introduces the first SRP door with a fully stamped "recessed panel."

1989

Builder Door. Amarr produces the Builder's Select door, its first 25-gauge residential garage door for the builder market.

The Golden Rectangle. Garaga begins using a 21" x 13" raised-panel design based upon the Golden Number ratio (1.618:1.0) used by ancient Greek architects. Leonardo da Vinci called it the "divine proportion."

HDPE. GADCO adds the Freedom Series 9000 door, a high-density polyethylene door with the raised-panel design and wood-grain texture.

Laminated Insulation. To compete with the success of Wayne-Dalton's Foamcore, Anozira introduces a 26-gauge SRP pan door with 3/4" or 1" of EPS insulation laminated to the interior skin.

Sandwich Construction. Clopay develops a line of "sandwich" insulated doors with interior and exterior steel skins, offered in 2" and 1-3/8" sections with a thermal break. Raynor introduces Decade III, also a 2" insulated sandwich door with thermal break.

Snap-In Window Inserts. Clopay introduces snap-in inserts for easy changing of decorative window designs.

Stainable Steel. Raynor announces Decade StainGrain, an SRP door with a stainable surface.

Please send any additions or corrections to daseditor@dasma.com. Our thanks to the following companies that responded to our request for historical data: Amarr, Anozira, Clopay, Delden, GADCO, Garaga, Martin Door, Overhead Door, Raynor, Stanley, Wayne-Dalton, and Windsor.