

## INSTALLATION INSTRUCTIONS

**PODSZUCK**

### A-CLASS HINGED SINGLE DOORS

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Before starting the installation of the door, please check that the cut in bulkhead meets the following requirements.

The bulkhead opening should be clean and flat. When mounting the frame, care should be taken to ensure the frame is not twisted, so that it can be installed with right angle in each corner.

1. Control the door set identification number at the code marking on the door.
2. Remove carefully the doorleaf from the frame.
3. Position the frame into the opening. Centre the frame in the opening.
4. Adjust the hinge jamb into a vertical position, both directions. Secure the frame in the position by using at least two clamps. Do not under any circumstances force the frame to the bulkhead, if required use shims.
5. Tack weld the frame at both side close to the hinges, hinge jamb side only.
6. Mount the doorleaf to the frame.
7. Adjust the frame so the gaps between frame and leaf at the back, top and front is equal. Also adjust the frame so the gap between rebate and leaf is approx. 2 mm. When the gaps is established fix frame to the bulkhead by using clamps.
8. Tack weld the frame to the bulkhead. Remove the clamps.
9. Check the closing function of the door. Make sure that the door leaf does not jamb into the sill.
10. Weld the frame intermittent. Start welding on the pull side on the top of both the jambs. Then continue weld lower on the push side, both jambs. Continue weld intermittently the jambs of the frame by alternative welding on pull and push side. During the welding, make sure that the frame does not move or twist.
11. Weld the frame head and sill intermittently, by using the same procedure as per jams.
12. Check the closing function of the door.
13. Weld the frame continuously on pull side between intermittent welding.
14. Fix the hardware to the door, in accordance to attached installation manual, i.e. lock, doorcloser, magnet holder.