

Assembly Instructions

If the frame is delivered before the door leaf and/or is unassembled, it is the fitter's responsibility to ensure that there is a match between the frame and the door leaf's order number/position number. It is very important that the correct door is installed into the correct frame. Unassembled frames are assembled with screws at the corners. Pilot hole drilling is recommended to avoid cracking.

Before starting assembly, the height, width and diagonal dimensions of the opening must be checked. Check the floor is level. The frame and threshold are placed directly on the floor in the wall opening. The frame shall be fixed with a minimum of 8 fastening points in compliance with NS 3152:4. Frames with a width in excess of 1200mm shall have a fastening point at the centre of the lintel. The joint between the frame and the wall shall be a minimum of 5mm and a maximum of 20mm. This should be of an even width.

Adjustable assembly sockets with collar (factory supplied) can be used, as can screw fastener holes (factory supplied), or simply by using mounting screws. When using assembly sockets, support points must also be used (wedges), at least behind the low-est hinge and at the top of the closing side. If assembly sockets are not used, wedges must be used at every fastening point.

FRAME

WALL

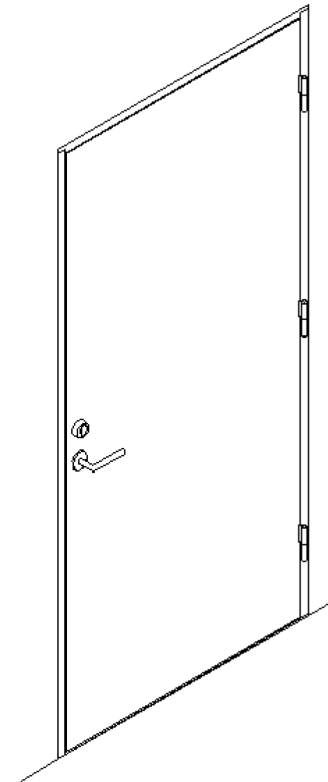
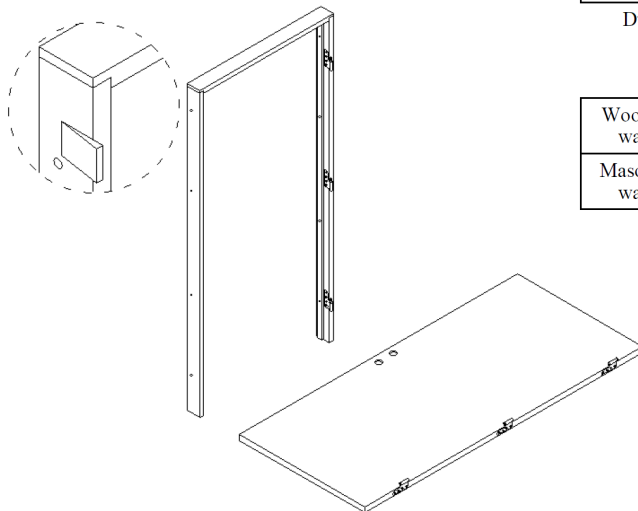
Module measurement B x H (dm)	Aperture dimensions B -0/+20 H -0/+20
Example: M 10 x 21	Min. 1000 x 2095 Maks. 1030 x 2110
M 13 x 24	Min. 1300 x 2395 Maks. 1330 x 2410

During assembly, screws shall be used as indicated in the table below.

14/5 HOLES

SOCKET

	14/5 HOLES	SOCKET
Wooden wall	Ø6 min. 80mm	Ø6 min. 50mm
Masonry wall	Ø6 min. 80mm w/8mm plug	Ø6 min. 50mm w/8mm plug



Clearance between the door and frame, when fully assembled, shall not exceed 3mm horizontally/2mm vertically. The space between the frame and the wall should be compacted hard and accurately with non-flammable insulation material. Minimum 92mm measured from the hanging side. Where an acoustic insulating door is concerned, it should be sealed on at least 1 side (hanging side) when door \leq Rw33, and on 2 sides when door \geq Rw38.

Assembly of the frame concludes with a final adjustment/inspection to ensure that the frame is vertically aligned and level. When the door is hung onto the frame, a further adjustment/inspection shall be made. Height-adjustable hinges, if used, must be adjusted to ensure equal weight distribution. The cylinder is mounted, separated and turned to fit armaments and countersinking.

Threshold solutions

