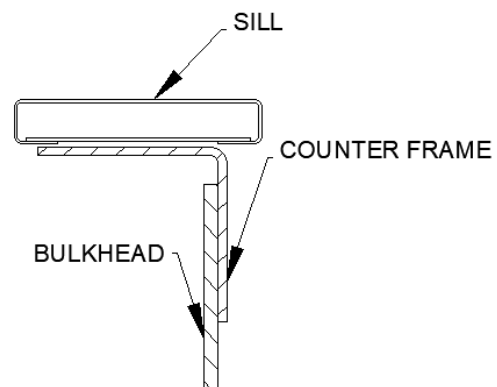
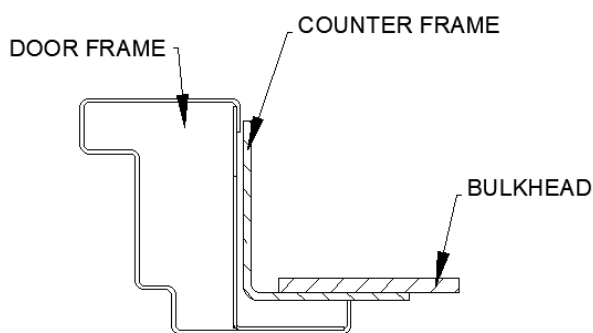
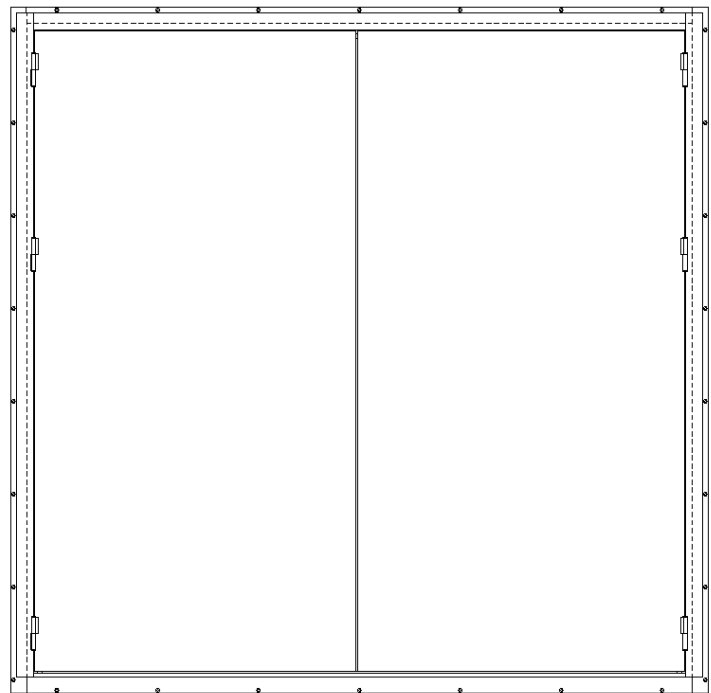
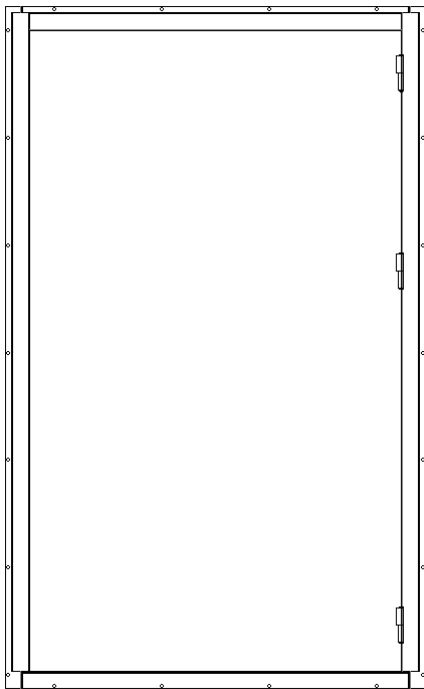
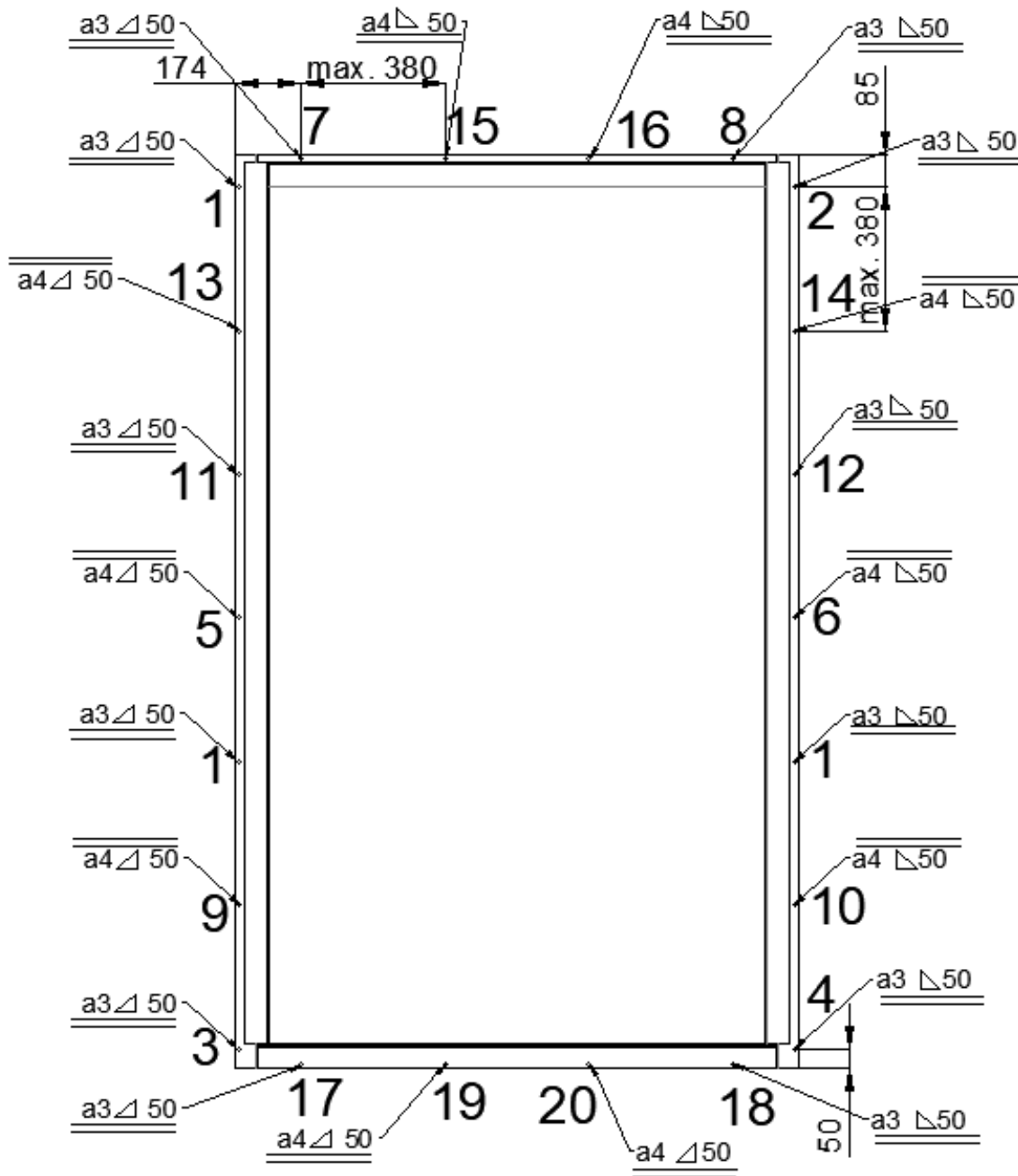


INSTALLATION GUIDE FOR A60 MARINE DOORS BY WELDING



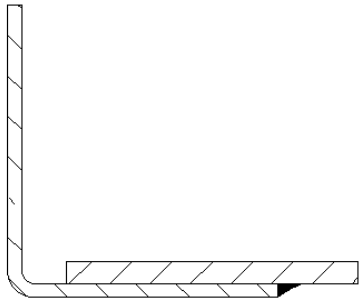
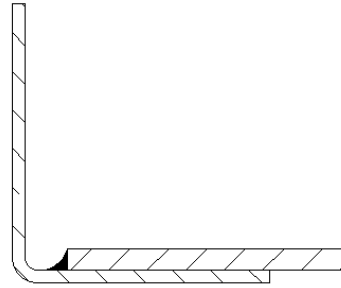
1. Check the dimensions of bulkhead opening according to door L-counterframe and drawings;
2. Check that bulkhead have cuttings for the possible fittings for locks, indication switches, door closers and other hardware;
3. Check the straightness of bulkhead;
4. Clean the bulkhead opening if needed (grinding tools);
5. Lift the L-counterframe to bulkhead opening;
6. Check the clearances, diagonal dimension and vertical straightness;
7. Weld the upper corners of counterframe No 1 and 2 according drawing 1 and 1.1.

STEEL PROFILE DOORS / METAL DOORS / MARINE DOORS

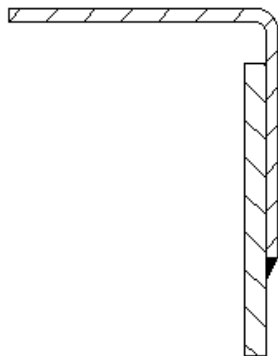
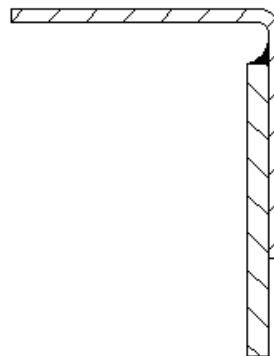


Drawing 1

STEEL PROFILE DOORS / METAL DOORS / MARINE DOORS

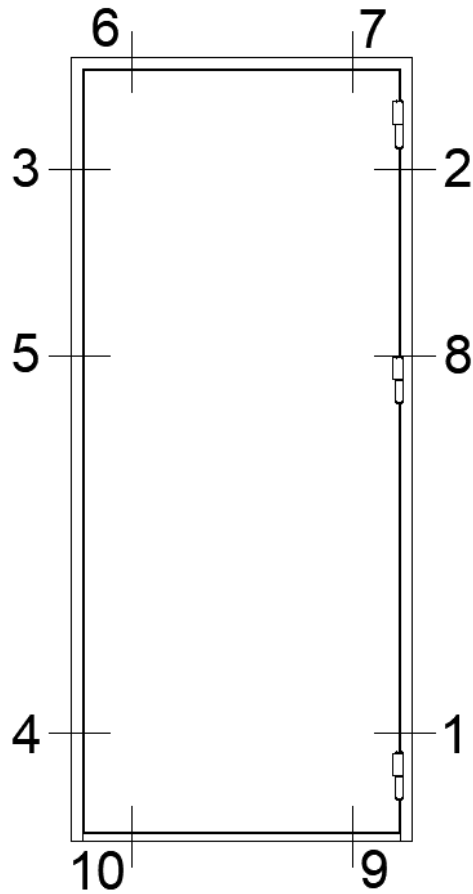
*Drawing 1.1**Drawing 1.2*

8. Check the diagonal dimensions.
9. Weld lower corners of frame No 3 and 4 according to drawing 1 and 1.1.
10. Gap between the bulkhead can be up to 20mm, if needed use spacer plates for welding;
11. Check the vertical dimensions and clearance of L-counterframe;
12. Weld L-counterframe according to drawing 1, 1.1 and 1.2 with distance between the welding spots max 455 mm, length of welding stitches 50mm;
13. Weld L-counterframe sill part according to drawing 1. No 17 and 18 according to drawing 1.3. and No. 19 and 20 according to drawing 1.4.

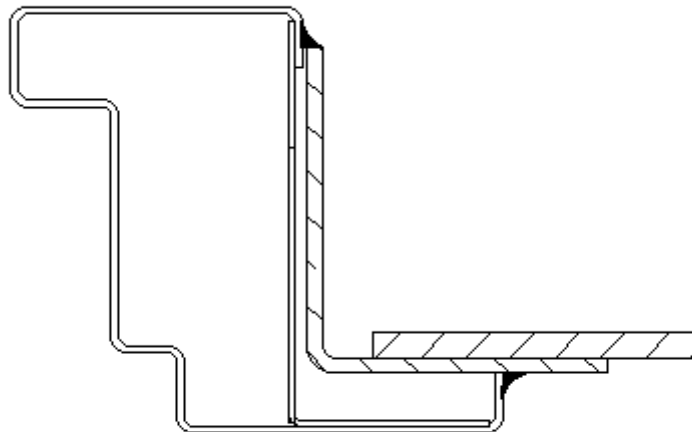
*Drawing 1.3**Drawing 1.4*

14. Check the straightness and clearance of L-counterframe;
15. Fit the door frame without door leave to L-counterframe;
16. Check the straightness of door frame in L-counterframe;
17. Keeping frame straight, weld the points 1, 2, 3 according to drawing 2 and 2.1
18. Check the straightness of door frame in L-counterframe;

STEEL PROFILE DOORS / METAL DOORS / MARINE DOORS



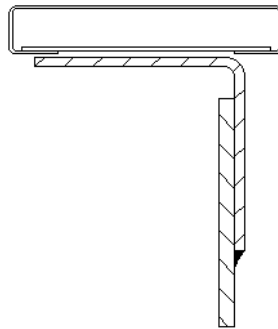
Drawing 2



Drawing 2.1

STEEL PROFILE DOORS / METAL DOORS / MARINE DOORS

19. Install the door leaf on hinges;
For double door install first active door leaf;
20. Keeping doorleaf on correct position in frame weld the point no 4 according to drawing 2 and 2.1;
21. Check the gaps between frame and door leaf lock side $5\pm 2\text{mm}$, hinge side $2\pm 2\text{mm}$;
22. For double-leaf doors install now passive door leaf;
23. Check the operation of locks and latches and adjust if needed;
24. Weld rest of the fixing points according to drawing 2 and 2.1 – distance between the welding max 455mm;
25. Weld points 9 and 10 according to drawing 2.2.



Drawing 2.2

26. Check once again the gaps, door locks and latches operation.