



»KIT PARA PORTON ABATIBLE MARCA FLEXIFORCE MOD.1034KIT.

installation manual

1034KIT

assembly instruction
for pass doors.



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2005



MANUAL DE INSTALACION




FF-MANUAL PASSDOOR



ATTENTION! GENERAL WARNINGS!



To install, use and maintain this kit safely, a number of precautions must be taken. For the safety of all concerned pay heed to the warnings and instructions given below! If in doubt, contact your supplier.

SPECIAL SAFETY WARNINGS OR REMARKS IN THIS MANUAL ARE INDICATED WITH THIS SYMBOL:  READ THESE WARNINGS CAREFULLY.

- ✓ This manual has been written for use by experienced fitters and as such is not suitable for d.i.y. purposes or for use by trainee fitters.
- ✓ Before starting, read this manual carefully!
- ✓ Certain components may be sharp or have jagged edges. As such you are advised to wear safety gloves.
- ✓ All the components which have been supplied are designed for use with this specific overhead door. Replacement or adding additional components may have an adverse effect on the safety of, and the guarantee on, the door. Also the CE-approval which has been granted to this door combination will be cancelled when components are changed or installation is n
- ✓ Ensure that there is sufficient light during installation. Remove obstacles and dirt. Make sure that there is no one else present other than the fitters. Other people (children!) may get in the way or endanger themselves during the installation.
- ✓ Ensure that the building is constructed strong enough to carry the overhead door construction. It is the responsibility of the installing company to use fixing materials which are strong enough and equipped to fix the overhead door to the building.
- ✓ Environments closed by an electrical operated overhead door with operators which are not disconnectable and where the door cannot be manual operated must be equipped with a pass door.
- ✓ If a pass door is fitted in the leaf of a power-operated door, it shall be provided with a device (for example FlexiForce article 97019) which prevents movement of the drive when the pass door is not fully closed and stops the door movement if the pass door is opened.

This door can only be taken into use, when all instructions are followed and:

- ✓ the installer has checked the combination of hardware, panel and e-operator as being approved and safe. Make sure to check the max. peak force and the proper functioning of the safety edge system in combination with the operator.
- ✓ all documentation has been handed over to the end-user: Ila Declaration of conformity, User Guide, Maintenance Instructions, Dismantling instructions, Service Log Book and this manual.
- ✓ a CE-identification plate has been placed on the door.
- ✓ user has been given instructions and demonstration of the proper use and functioning of the door.

Contact your sales team if you have any questions or remarks

Flexi-Force B.V.
P.O. Box 37
3770 AA Barneveld
The Netherlands
Tel. +31-(0)342-427777, info@flexiforce.nl

Assembly instruction for passdoors.

The passdoor must be installed at a minimum distance of 500mm from the side of the overhead door.

Sign convention:

Panel 1 = lower panel

Panel 2 = panel on top of panel 1

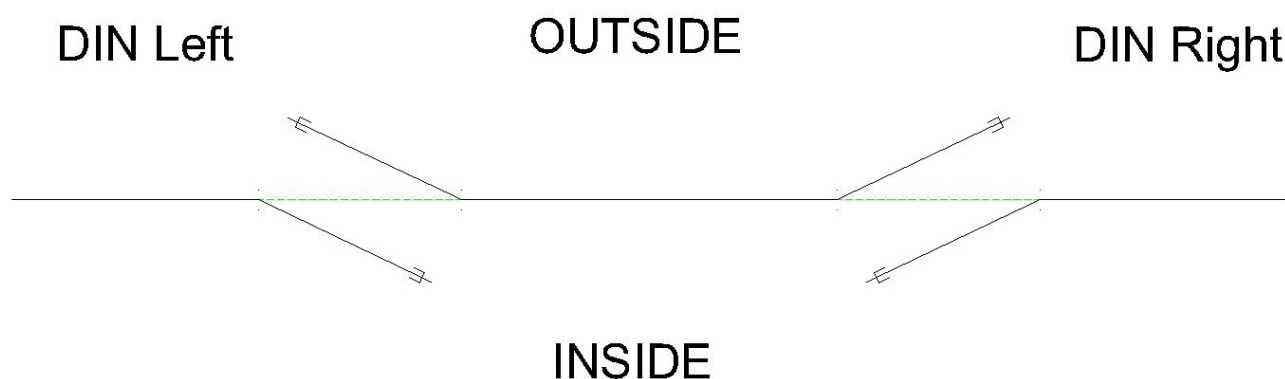
Panel 3 = panel on top of panel 2

Panel 4 = top panel

OHD = Overhead door

PD = Passdoor

This instruction is for passdoors that, seen from the inside, have the passdoor hinge on the left side and open to the outside. This is called DIN RIGHT. The passdoor is placed into the 4 bottom panels of an overhead door.



This passdoor kit includes the following components:

QTY	DESCRIPTION	LENGTH	REMARKS
6	1032END	610	
2	1032END	522	
2	1032END	522	
2	1032END	970	
1	1032END	495	
2	1033U	430	
2	1033U	610	
1	1032END	893	
1	1032END	893	
1	1032END	495	
1	1032RN	960	
2	1034N	482	
2	1034N	610	
140	Blind rivet	d1 x L = 5 x 8	DIN 7337
12m	1032RUB		



1032END

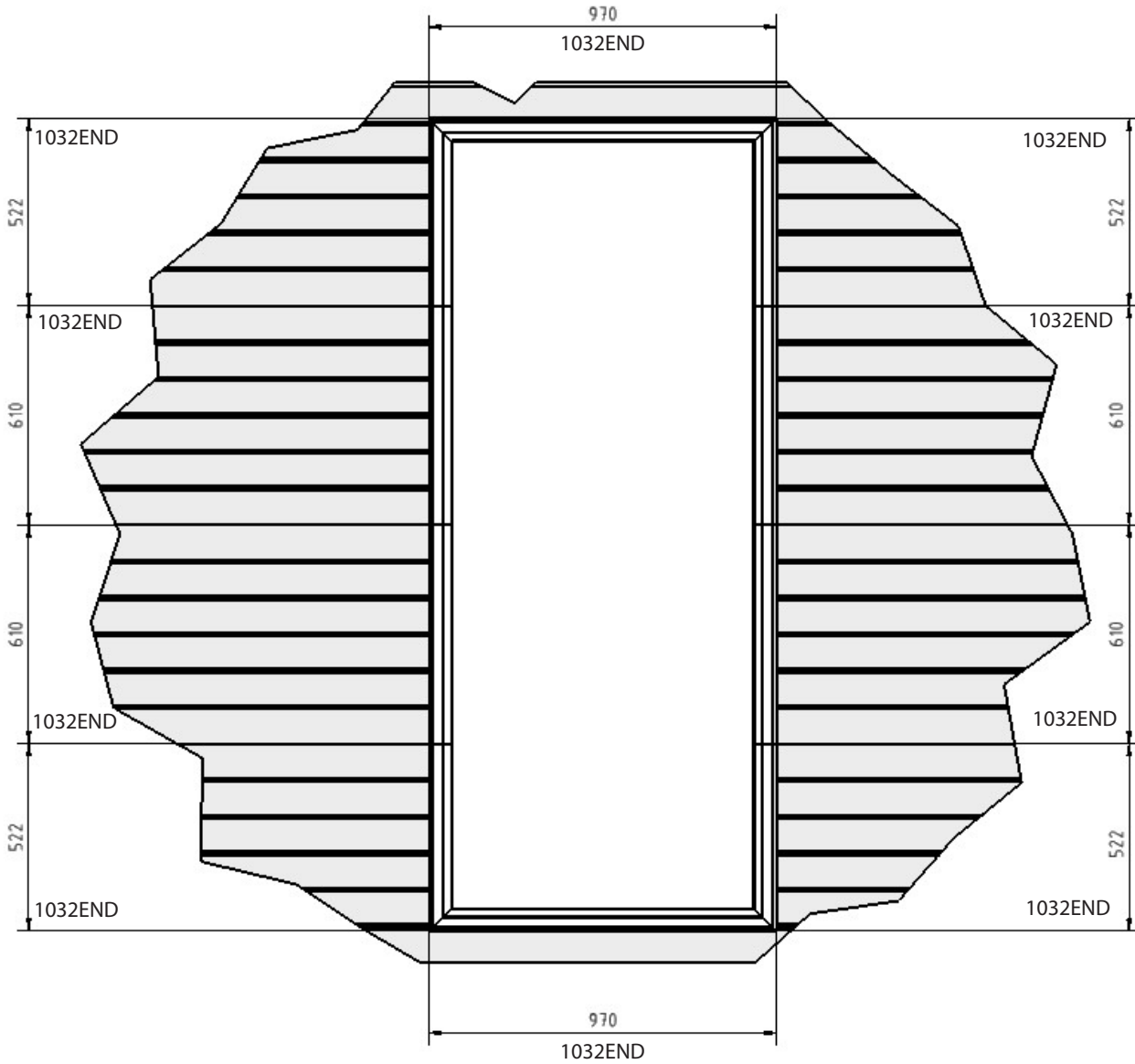


1033U

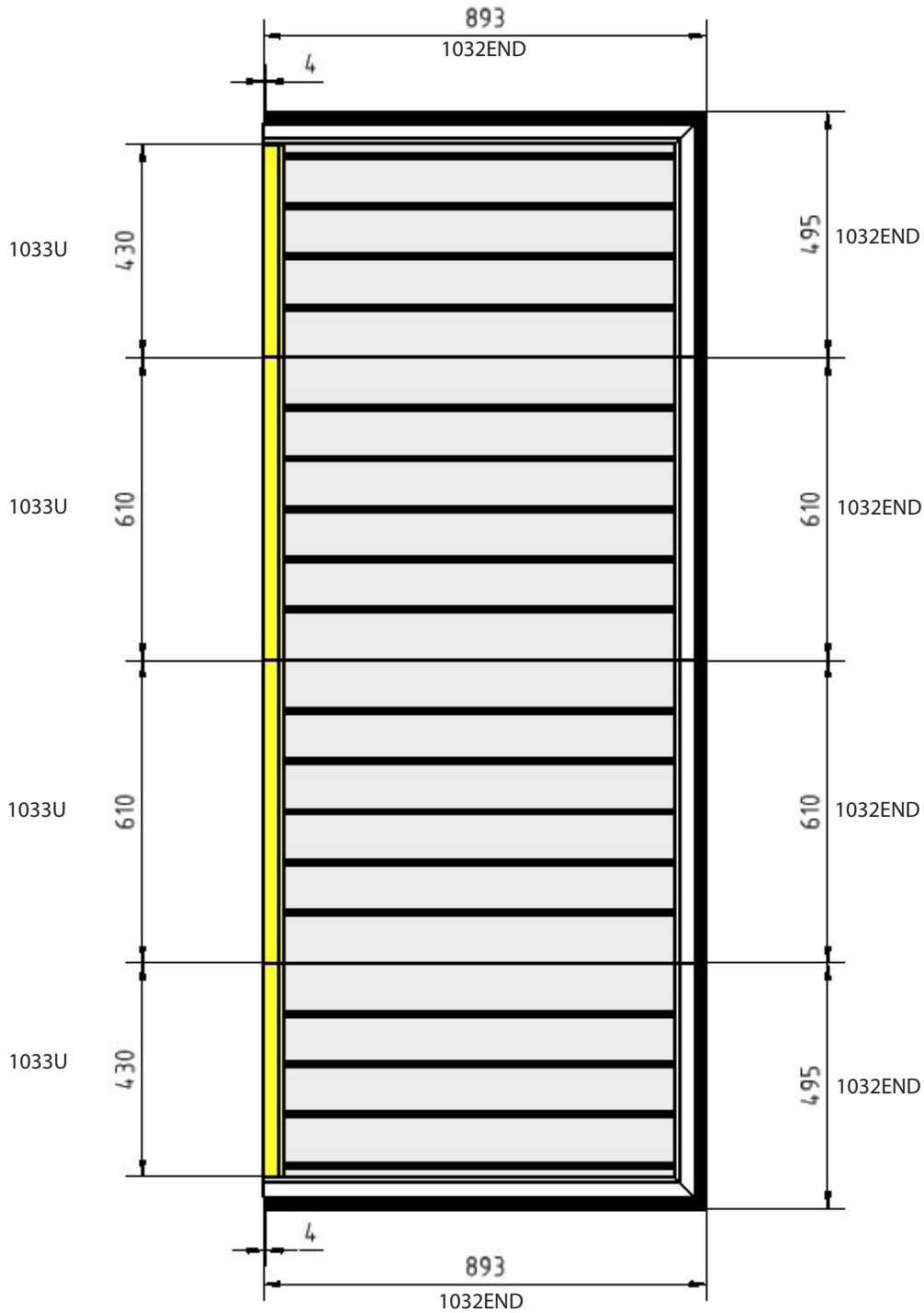


1034N

VIEW FROM INSIDE DIN RIGHT



VIEW FROM THE INSIDE DIN RIGHT



Cutting out the opening for the passdoor

1 Mark the width of the opening on the OHD. Width = 900 mm



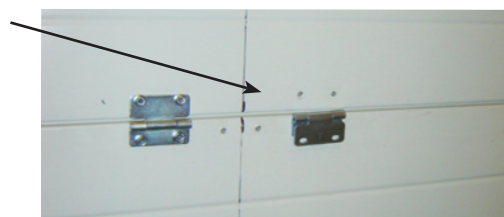
2 Mark the height of the opening on the OHD. The marked height of panel 1 is 500 mm measured from the centerline of the hinges between panels 1 and 2. The marked height of panel 4 is 490 mm measured from the centreline of the hinges between panels 3 and 4.



3 Assemble 12 hinges around the marked area (inside and outside); 6x hinges on 100 mm from the outside of the marked area. 3x hinges on 100 mm on the inside of the marked area (PD hinge side) and 3x hinges on 140 mm on the inside of the marked area (lock side)



4 De-assemble the top hinge leaves of the 6 hinges inside the marked area



5 Drill holes in the 4 corners of the marked area.



6 Cut out the opening for the PD



7 Place away the panel parts in a logical order. Be careful with panels 2 and 3.



Mounting the profiles in the opening in the overhead door

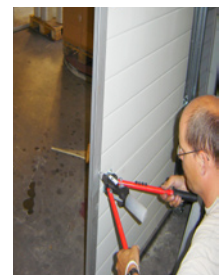
- 8 Place the bottom 1032END profile in the opening of the OHD. Place it symmetrical in the opening and not tight onto the OHD. The exact position will be determined by the adjacent profiles.
- 9 Mount the 2 lower 1032END profiles onto panel 1. Align the top side with the centreline of the hinges between panel 1 and 2.
- 10 Place the top 1032END profile in the opening of the OHD. Place it symmetrical in the opening and not tight onto the OHD. The exact position will be determined by the adjacent profiles.
- 11 Mount the 2 upper 1032END profiles onto panel 4. Align the bottom side with the centreline of the hinges between panel 3 and 4.



- 12 Assemble the remaining 1032END profiles onto panels 2 and 3
- 13 Now adjust the vertical position of all profiles so that they connect properly
- 14 Now adjust the horizontal position for all profiles by using a 2.5m long ruler and thus aligning all profiles on the left and right side



- 15 Blind rivet all the profiles on the inside of the door. When drilling holes in the 4 corners pull the mitres in the 4 corners together for perfect alignment. Use 2 blind rivets for each profile. For the bottom profile 1032END (threshold) use 3 blind rivets



16 Mount the PD hinge 1034N onto the 4 side profiles 1032END. Start with panel 2 and blind rivet in a Z-pattern for maximum strength

17 Following panel 2, mount in a similar way the 1034N hinges on panel 3, panel 4 and panel 1



18 Assemble profile 1033U onto the PD hinge 1034N on panel 2. Align the 1033U profile on the PD hinge 1034N so that when the PD is closed it closes properly. When the position is known, blind rivet the 1033U profile onto the PD hinge 1034N

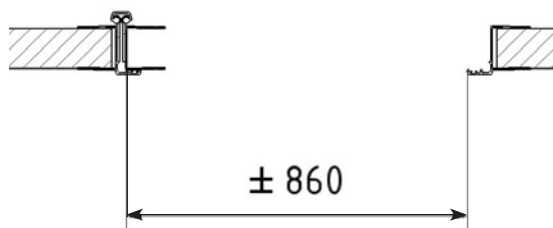
19 Repeat previous step for the 1033U profiles onto the PD hinges 1034N on panel 3, panel 1 and panel 4.

20 Blind rivet all profiles of the OHD on the outside (2 rivets per profile)



Mounting the profiles on the leafs of the Passdoor

21 Measure the distance from the inside of profile 1033U to the 1032END profile according to lower figure (approx 860 mm) This dimension is the width of the panels for making the PD



22 Cut panel 2 for the PD to the width that was measured in the previous step. After cutting, remove the burrs with a chisel to make the assembly of the panel into the 1033U more easily.



23 Assemble panel 2 into the 1033U and align panel 2 so that it is in line with the panel 2 from the OHD



24 Blind rivet panel 2 to the 1033U profile (outside first)

25 Cut panel 3 for the PD to the width that was measured in step 21. After cutting remove the burrs with a chisel to make the assembly of the panel into the 1033U more easily.

26 Assemble the panel into the 1033U and onto panel 2

27 Before blind riveting the 1033U and panel 3, mount the top hinge leafs and thus restoring the connection between panels 2 and 3. Because of this, the position of panels 2 and 3 will be restored to the situation that was before the opening in the OHD was cut.

28 When the hinges have been mounted, blind rivet 1033U onto panel 3 (outside first)

29 Cut panel 1 for the PD to the width that was measured in step 21. After cutting remove the burrs with a chisel to make the assembly of the panel into the 1033U more easily.

30 Also cut panel 1 from the bottom side to reach a smaller height; the height is 455 mm measured from the centreline of the hinges between panels 1 and 2 (eg 25mm longer as the length of profile 1033U.)

31 Assemble the panel into the 1033U and underneath panel 2

32 Before blind riveting the 1033U and panel 1, mount the top hinge leafs and thus restoring the connection between panels 1 and 2. Because of this, the position of panels 1 and 2 will be restored to the situation that was before the opening in the OHD was cut.

33 When the hinges have been mounted, blind rivet 1033U onto panel 1 (outside first)

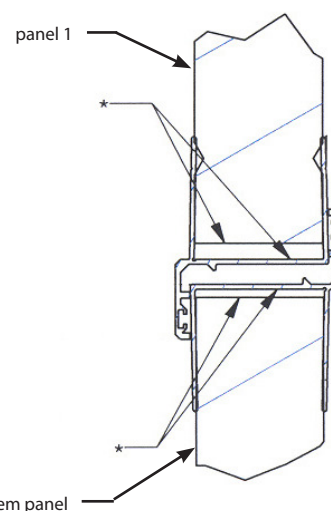
34 Cut panel 4 for the PD to the width that was measured in step 21. After cutting remove the burrs with a chisel to make the assembly of the panel into the 1033U more easily.

35 Also cut panel 4 from the top side to reach a smaller height; the height is 455 mm measured from the centreline of the hinges between panels 3 and 4 (eg 25mm longer as the length of profile 1033U).

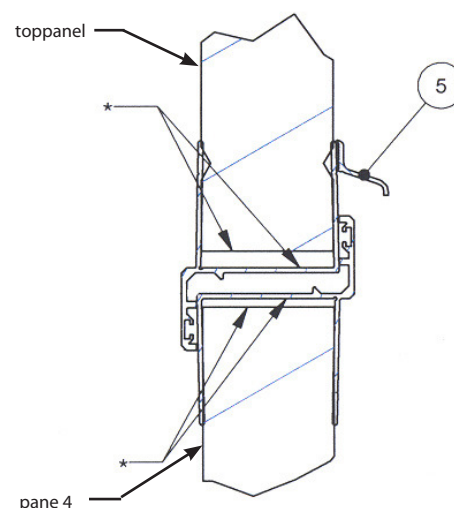
36 Assemble the panel into the 1033U and onto panel 3

37 Before blind riveting the 1033U and panel 4, mount the top hinge leafs and thus restoring the connection between panels 3 and 4. Because of this, the position of panels 3 and 4 will be restored to the situation that was before the opening in the OHD was cut.

38 When the hinges have been mounted, blind rivet 1033U onto panel 4 (outside first)



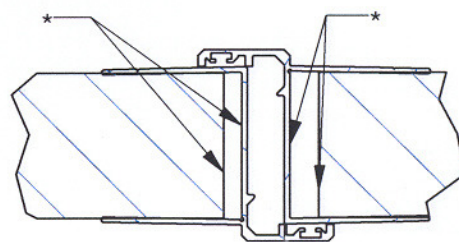
*space used for compensation of cutting tolerances



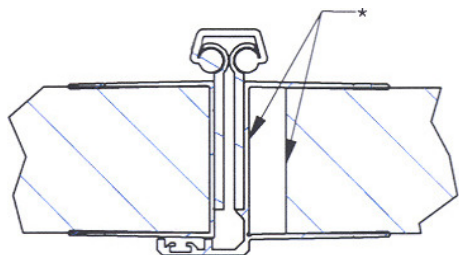
*space used for compensation of cutting tolerances

5 = rain profile 1034RN

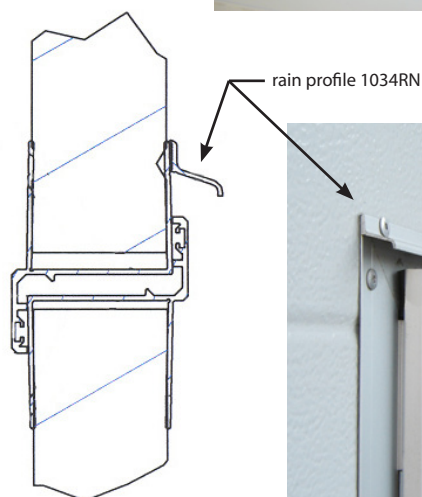
- 39 Assemble the top 1032END profile onto the PD. The 4 mm cut out in the 1032END profile should fall behind the PD hinge 1034N. Make sure that the top 1032END profile of the PD is parallel to the top 1032END profile from the OHD. Do not blind rivet yet.
- 40 Assemble the 1032END profile onto panel 4 and adjust it to connect to the top 1032END profile of the PD
- 41 Assemble the 1032END profile onto panel 3 and panel 2
- 42 Assemble the bottom 1032END profile onto the PD. The 4 mm cut out in the 1032END profile should fall behind the PD hinge 1034N, Make sure that the bottom 1032END profile of the PD is parallel to the bottom 1032END profile from the OHD
- 43 Assemble the 1032END profile onto panel 1 and adjust it to connect to the bottom 1032END profile of the PD
- 44 Align all 1032END profiles in a vertical line
- 45 Blind rivet 1032END profile from step 40 onto panel 4 on the outside (2 blind rivets per profile)
- 46 Blind rivet the top 1032END profile onto panel 4 on the outside
- 47 Blind rivet the bottom 1032END profile onto panel 1 on the outside
- 48 Blind rivet all the other 1032END profiles in such a way that you work from the top left corner and lower right corner (seen from the outside) to the lower left corner. This is to be able to make final adjustments on the way to the lower left corner. All rivets on the outside.
- 49 Blind rivet all profiles of the PD on the inside (2 rivets per profile)
- 50 Mount the lock 1034LOCK/1034GRIP/1034PL/C60-2525-2 (according to the installation leaflet that is included) onto panel 2.
- 51 Mount the door closer 1034FL and 1034BASE according to the installation leaflet (option)
- 52 Mount the rain profile 1034RN above the PD.



*space used for compensation of cutting tolerances



1034LOCK/1034GRIP/
1034PL/C60-2525-2






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innovations for overhead doors

FF-MANUAL PASSDOOR

 (229) 461-7028

 portonesautomaticos@adsver.com.mx
ads.portonesautomaticos@outlook.com



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