

INSTALLATION INSTRUCTIONS

A-Class sliding door single
Drawing D201146, D201147 (Hellbergs Int. HI-SKD-F79-2)
and double (Hellbergs Int. HI-SKDD-F79-RW).
Bolted or welded installation.

1. Control measurement of size and angles of hole in bulkhead.
2. Lift the frame in position.
3. Adjust the frame jambs into vertical position and adjust the sill and frame head into a horizontal position. Also adjust any twist between frame jambs and bulkhead by using shims and fix with clamps.
4. Tack weld the forward jamb into the bulkhead only at upper and lower parts.
5. Measure the diagonal and angle of the frame in each corner (90 degrees angle).
6. Check the horizontal position of the sill and frame head. Tack weld rear jamb to bulkhead only at the upper and lower parts.
7. Measure the distance between the jamb at the top, middle and bottom of the frame. The distance has to be equal. Tack weld 50% of remaining spots.
8. Install the rear track angle holder to frame.
9. Clean the track inside and wheels properly for smooth operation.
10. Adjust the tracks straightness and vertical position and tack weld.

11. Fix brackets and track.
12. Lift up the door leaves on the track.
13. Check that the doors closes smoothly. Also check the gap between doorleaf and flange iron. When necessary adjust track, and/or hanger in the bracket on door leaf.
14. Weld the frame permanently to the bulkhead. Weld the sill to the floor plate.
15. Check that the doors close and open smoothly.
16. Apply the wire to the balance weight.
17. Insert the balance weight into the balance weight casing, and pull out the wire at top of the casing.
18. Apply the balance weight wire to the first hanger. It is important to adjust the length of the wire, when door is in closed position, so that the balance weight will not touch the floor. The wire should be straight.
19. Fix the brake cylinder to its bracket on the frame and leaf. Adjust the brake cylinder, so when the door is closing it follows the doors movement smoothly.
20. Fix lock and handle to the leaf. Check the function of the lock.
21. Place the doors in open position. Apply, by welding the endstop to the track or install the holding magnet to the leaf.
22. Finally check the total function of the sliding door.