

INSTALLATION INSTRUCTIONS

Welding instructions for Class-A Hinged doors (Single and Double)

1. Check that the size of the steel is correctly measured and cut (see drawing for the doors).
2. Check that the steel bulkhead is straight and has the correct angles.
3. Check before installation that the angles of the frame are at 90 degrees to one another.
4. Spot-weld the frame into the bulkhead in each corner (on the hingeside of the frame).
5. Check the middle dimension of the frame (must be the same as top and bottom).
6. Spot-weld in the middle of the frame (vertically).
7. Install the door and make sure it closes properly, then check that the gaps between the edges of the door and the frame are correct.
8. If all works satisfactorily, continue by welding intermittent 25-30 mm long welds max. 300 mm apart and with an 'a-measure' of 3-4 mm (on one side of frame).
9. Make sure the door still closes properly, checking that the gaps between the door and frame are correct.
10. Weld the other side with intermittent 25-30 mm long welds, max. 300 mm a part and with an 'a-measure' of 3-4 mm.
11. Make a final opening and closing test.

Hinges and locks should be oiled from time to time.