



STEEL PROFILE DOOR AND PARTITION INSTALLATION MANUAL

The door set or non-bearing element wall can be installed to:

- **a rigid wall** (stone wall, lightweight concrete - Aeroc, Fibo, etc., concrete wall, etc.), with a thickness ≥ 125 mm, the fire resistance is at least the same as the installed partition.
- **a lightweight wall** (gypsum-coated metal or wood frame) with a thickness of ≥ 100 mm and a fire resistance of at least the same as the installed partition. When installing larger doors, it is advisable to install timber reinforcement element in the metal frame to ensure the rigidity of the wall construction.

The construction must be fixed tightly and firmly in the completed wall and floor (if necessary, take into consideration the thickness of possible flooring materials when constructing the floor).

The most suitable installation time is after screeding (concrete pouring) or before floor surface finishing and before any possible finishing work on the wall, if the side cheeks are finished without a *covering strip*.

When you are using cover strips, it is desirable to install them after completing construction work, incl. painting.

For installation, you need:

- Measuring tape, long and short levelers
- Rubber hammer to install glass strips (if the glasses are not mounted on the frame)
- Electric drill and drills according to fasteners
- Torx T30 screwdriver or other according to screw type
- Tin strips to support the doorsill (if necessary)
- Insulating materials
- Lubricants for hinges and the lock
- If necessary, sealing materials (sealant, etc.)
- Fasteners

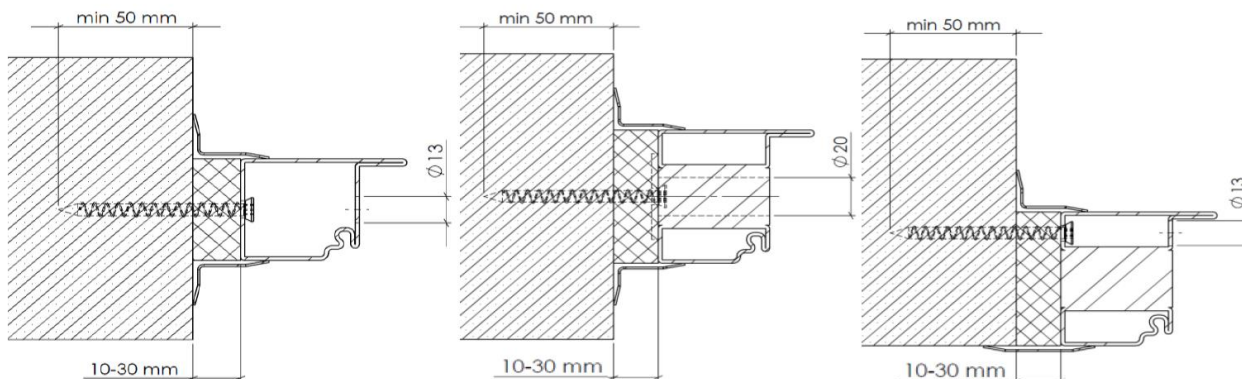
Fastening devices:

The fastening devices and materials used for the installation of fire protection products must be non-flammable. The gap between the wall and the frame must be sealed with stone wool, with a density of ≥ 28 kg / m³ or with a suitable (fire door) foam. When fixing with screws, use an appropriate fastener for the wall type.

For rigid walls:

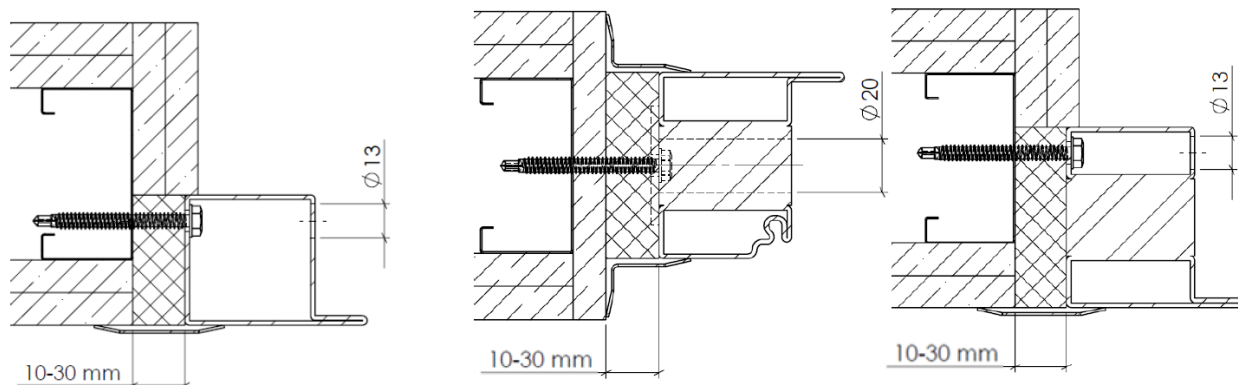
∅=min 7,5mm; depending of the wall, either concrete or fibo wall screws. The screw must reach a minimum of 50 mm in the wall

NB! When selecting the length of the screw, take into account the width of the gap between the wall and the frame.

**For lightweight walls:**

Internal doors: Self-drilling screws for metal frame lightweight walls $\varnothing = \text{min } 5,5\text{mm}$; $L = \text{min } 60\text{mm}$

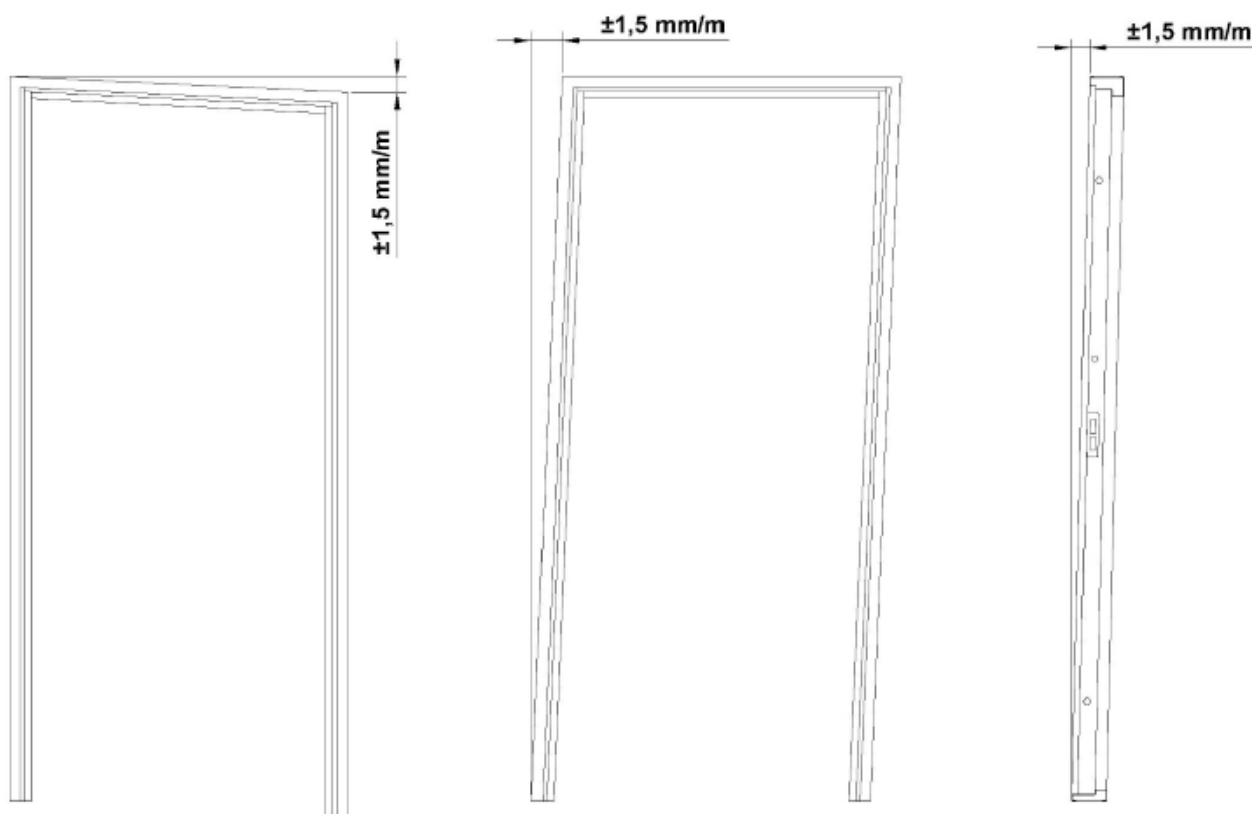
External and fire rated doors: Self-drilling screws for metal frame lightweight walls $\varnothing = \text{min } 6,3\text{mm}$; $L = \text{min } 60\text{mm}$

**Installation**

- When transporting the construction to the wall, avoid damage to the surface. If necessary, cover the surfaces with cardboard, film or other materials.
- Make sure the dimensions of the wall and construction fit. The gap between the wall and the frame can be 10-30 mm on the sides and at the top. The gap should be the same on both sides.
- NB! In case of larger gaps the wall must be adjusted to the required dimensions.
- Separate the door leaf / leaves from the door frame, lifting them from the hinges
- Lift the construction upright into the wall on a finished and level floor.
- **Fasten** the construction's upper **corners** according to the existing fastening points.
- Place the door leaf (-leaves) in the frame and adjust the gaps between them so that they are parallel, making sure the construction is parallel as well.
- **Fasten** the construction's lower **corners** according to the existing fastening points

Check the door movement and gaps, make sure the frame is level and adjust, if necessary.

The door / construction may, if necessary, be not level according to the frame installation tolerances accepted to ensure the door is working normally.



Secure the rest of the fasteners.

- Fill the gap between the frame and the wall with a stone wool with a density of at least ≥ 28 kg / m³ or a suitable fireproof foam (in the case of a fireproof door, a standard mounting foam can be used).
- Check that the door and hardware work correctly.
- If the hardware is not installed, it must be done in accordance with the installation instructions. Make sure that the hardware meets the appropriate fire resistance class. We recommend using self-drilling screws to fasten the hardware.
- If necessary, install separately supplied glass seals and glasses.
- Place plugs on visible mounting holes.
- The door set (door frame, top and side panels) can be disassembled for transport and reassembled with special connecting brackets. Screw holes for connection in the profile can be drilled during installation.

INSTALLATION OF GLASS

1 Installation of fireproof glasses

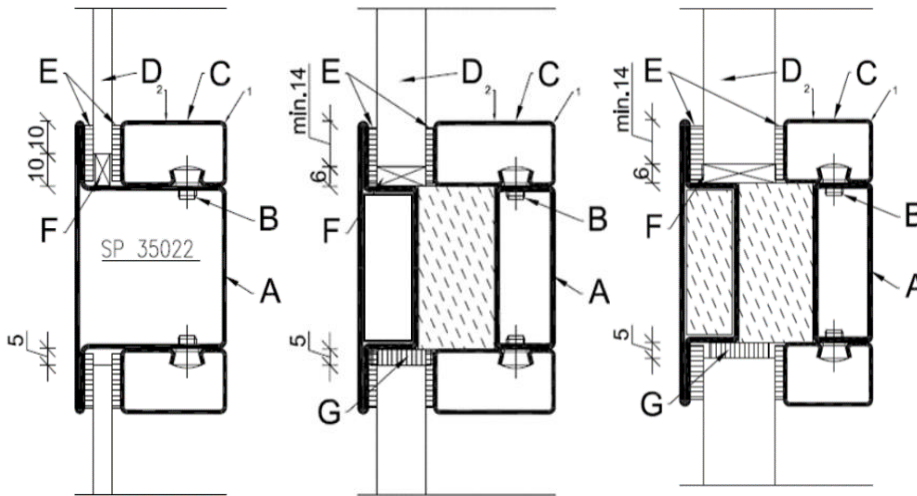
- While installing the glasses (see Figure 8), make sure that they are not broken, there are no cracks or other damage. Damaged glasses may be installed with the temporary purpose of covering an opening, in which case the product is not in accordance with the previously stated requirements and warranty conditions.
- The opening of the frame is wiped clean from dust and dirt.

- Make sure that the glass strips (C) are installed in the same place on the construction where they were before the installation of the glasses. In the case of separately packed glass strips, make sure that the markings on the construction and the strips match.
- On the edge of the glass strips and the profile, a Kerafix ceramic seal of a suitable thickness is installed in the factory. If the seal is included, install it so that it's at least 1 mm lower than the exterior of the profile handle.
- If necessary, remove the fastening screws (B) from the profile (B) when placing the glass in the wall.
- The glass must be installed on distance blocks, that are placed ~60-100 mm from the corners of the glass.
 - o SP35000 (TPU705 E30-EW60) - distance block 6x5x80mm
 - o SP76500 (TPU706 EI30) - distance block 6x16x80mm
 - o SP76500/79000 (TPU706 EI60) - distance block 6x25x80mm

- **NB!** When placing the **Contraflam glass** in the glazing opening, make sure that the imprint is in the lower corner (usually the glass also has a stamp). Check that the space between edges of the glass and the profile is equal. Then insert the seal included in the package (G) around the perimeter of the glass edge and the frame. No seal is placed under the glazing blocks.



- First, install the horizontal glazing beads (from profile to profile) and then vertical glazing beads between them. To fasten the glazing beads, hit the outer corner with a rubber hammer or wood block (**in the direction marked by arrow 1** on the figure 8) above the screw fastening on the base of the glazing beads. Start fastening the glazing beads from one end of the bead and continue towards the other end. Make sure that the glazing beads are fastened correctly on the screws and that there is no gap between the glazing beads and the profile. If necessary, hit the glazing beads above the fastening screw in the direction of the screw's axis (in the direction marked by arrow 2 on the figure 8).
- In an outdoor environment or in other wet conditions the surfaces of the glass seals of the fire doors must be coated with fireproof silicone.

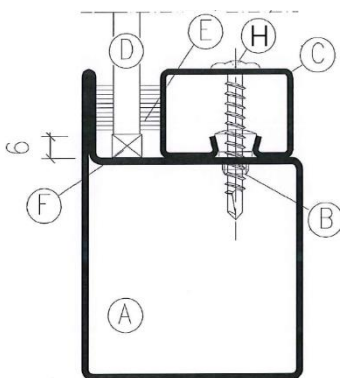


A	Profile
B	Glazing bead screw
C	Glazing bead
D	Glass
E	Cer. seal Kerafix 2-5 mm
F	Distance block
G	Kerafix FXL200 seal

FIGURE 8 (installation of glass E60 / EI30 / EI60)

IMPORTANT!

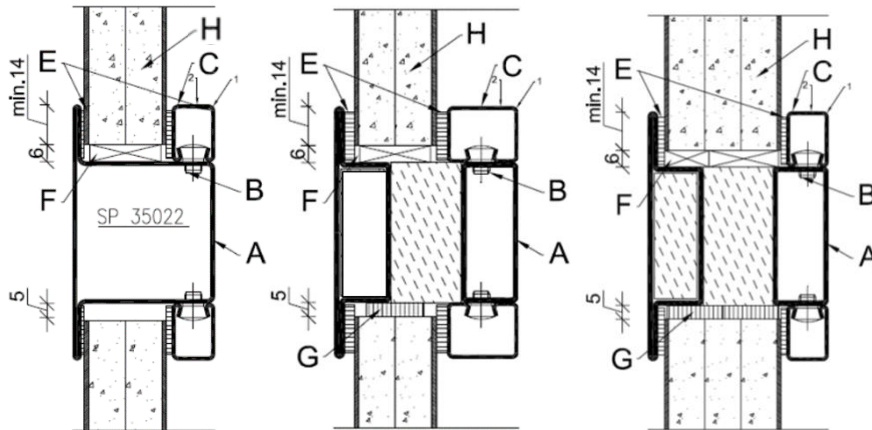
- 1) **A Kerafix FXL200 seal must be installed around the perimeter of Contraflam glasses (marked G on the figure). No seal is placed under the glazing blocks.**
- 2) **No seal is required in the case of 6mm glass (Pyroswiss / FeuerFest)**
- 3) **In the case of Pyroswiss 60 glass the strip must be fastened with extra screws (marked H on the figure), 150mm from the edge and at max 450 mm intervals. (see Figure 9)**



A	Profile
B	Glazing bead screw
C	Glazing bead
D	Pyroswiss 60
E	Cer. seal Kerafix 2000 2-5mm x 17mm
F	Distance block
H	Self-drilling screw Ø4,8x32mm (150mm from the corner of the glass strip and at max 450 mm intervals)

FIGURE 9 (Installation of Pyroswiss E60 6mm glass)

Instead of glass, there may be a casing that is similar to the installation of the glass (see Figure 10).



- E30-EW60, EI30 casing composition: 1,5mm steel leaf on both sides, 2 gypsum boards in the middle, no additional seal (G)

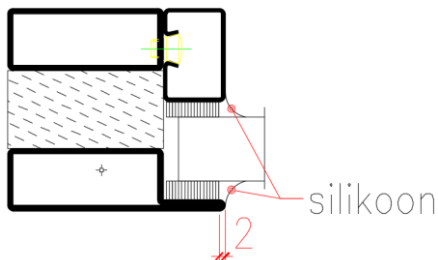
necessary to install on E30-EW60 casing

- Composition of EI60 casing: 1,5mm steel leaf on both sides, 3 gypsum board in the middle

FIGURE 10 (installation of casing E60 / EI30 / EI60)

2 Installing glasses and casing on non-fireproof door

- Make sure that a glass seal of appropriate thickness is installed on the glazing beads and profile edge.
- The seals are included with the products and the manufacturer SIA ISG ensures that the seal can be used respectively either inside or outside.
- The glass must be installed on distance blocs, that are placed ~100 mm from the corners of the glass.
- After placing the glass on the distance blocks, you can insert silicone between the edge of the glass and the frame, or install seal strips to fix the location of the glass (make sure that the space between the profile and glass is equal on both sides)
- We recommend you fasten the seal by means of silicone when the seal is used outside, as there is a danger of water flow between the glass and frame due to complicated weather conditions. In order to do that, a square EPDM sponge seal has to be used, which is placed approximately 2 mm lower than the outer surface of the profile and is covered with silicone.



- When installing non-fireproof barriers between sheets of steel, a Styro-foam board or the like may be installed, otherwise the glazing instructions for non-fireproof doors should be followed.