

# STEEL DOOR Installation Instructions

1. Verify that opening size, head, side, and back spaces available are correct for the door and hardware you are installing. Install, or check jambs - 2x6 is suggested, 2x4 is the minimum (Figure 1). Make sure they are plumb and square.

2. Nail trim stops temporarily to jambs, flush with the inside. Stops will be reset after door is installed.

3. Lay bottom section on saw horses face down. (Saw horses should be padded to prevent sections from being scratched.) Attach bottom corner brackets to bottom of end stiles, flush with bottom section using three 'Red Head', type  $\frac{1}{4}$  x  $\frac{3}{4}$  self-drilling screws (Figure 2). **▲ WARNING:** 'Red' signals that the bracket is under tension when the door is installed. Attach #1 hinges to top edge of bottom section using #14 X  $\frac{3}{4}$ " sheet metal screws.

4. Outside lift handle is installed horizontally across bottom rail of section in the center of the section about 1- $\frac{1}{2}$ " from bottom edge.

4a. On SRP (or "pan" type) doors, there is a steel back-up plate (2  $\frac{1}{4}$ " X 8") to reinforce the outside lift handle. If door is insulated, install lift handles on bottom section using #14 X  $\frac{3}{4}$ " sheet metal screws (Figure 3), if not use carriage bolts and nuts. The inside step plate is installed on the center stile, as shown, using #14 X  $\frac{3}{4}$ " sheet metal screws.

4b. On Advantage (or "sandwich" type) doors, using the lift handle as a template, locate and drill two  $\frac{3}{8}$ " holes spaced as shown in the drawing. Slide aluminum spacers into the holes. Insert  $\frac{1}{4}$  x 2- $\frac{1}{4}$ " carriage bolts through handle and spacers as shown (Figure 4). Attach nuts and tighten.

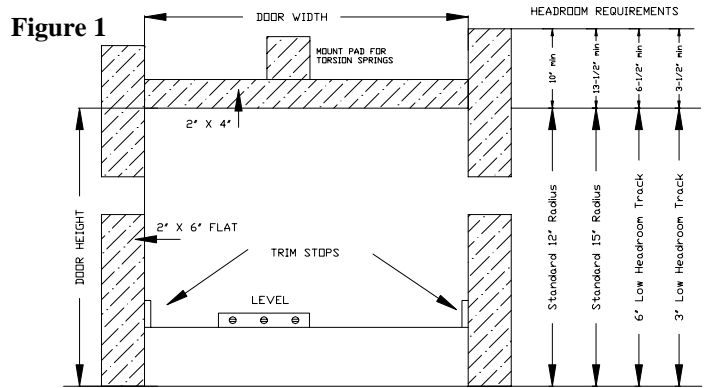


Figure 2

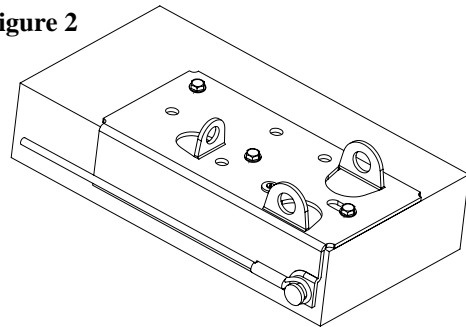


Figure 3

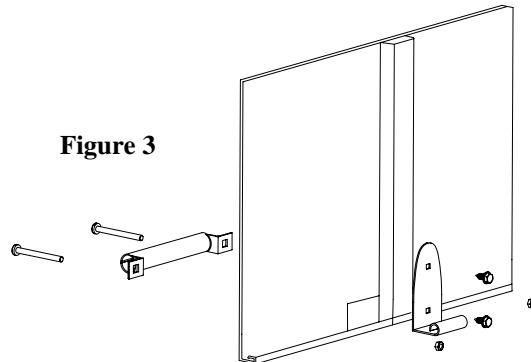
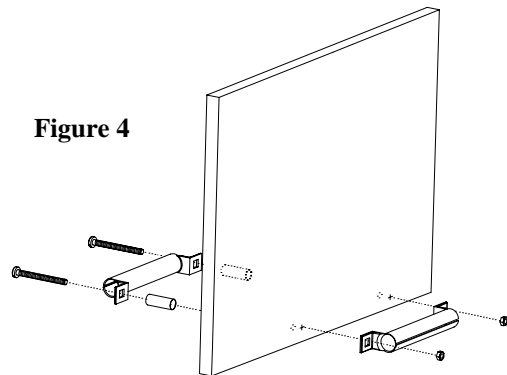


Figure 4

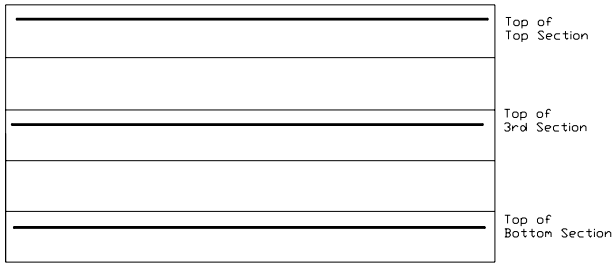


**WARNING: \*All Lift Handles Must Be Attached.\***

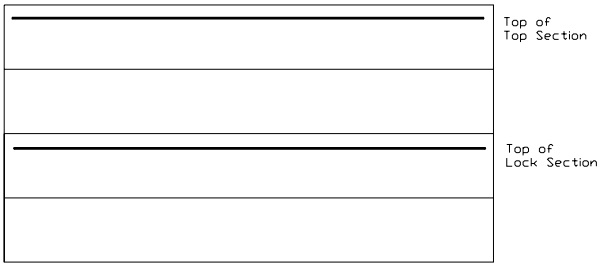


**Figure 5**

Five Section Door



Four Section Door



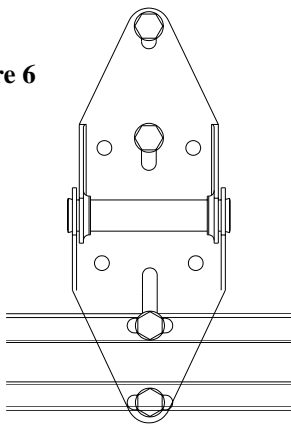
**TWO CAR DOORS ONLY:** Strut location is shown for both Four Section and Five Section Doors (Figure 5).

**5.** Place rollers into spaces provided in bottom corner brackets and hinges. Place bottom section in opening. Level section using a shim if necessary and drive nails into jamb at angle to hold section in opening.

**6.** Install vertical track on one side of section, turning rollers in to track ( If shim was used to level bottom section in opening, install first vertical on side of door away from the shim). Fasten track to jamb through bottom track clip only using 5/16" x 1-5/8" lag screw provided. Maintain 1/2" space between track and edge of bottom section.

**TWO CAR DOORS ONLY:** attach strut to lower leaf of hinges with strut clips (Figure 6).

**Figure 6**



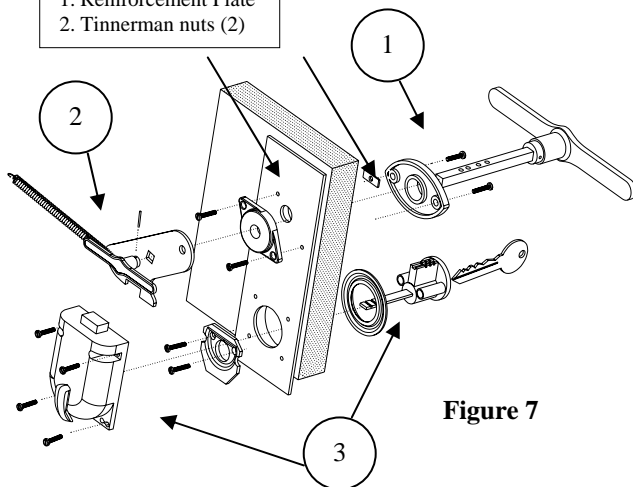
**7.** Place lock section on saw horses and attach #2 hinges to end stiles. Center stiles always get #1 hinges. Install sequence of lock is outlined in Figure 7.

1. Install outer T-handle
2. Install Lock Bar Disc and interior T-handle
3. Install exterior Cylinder and Night latch

**8.** Slip lock bar guides on bar. Temporarily fasten lock bar guides to end stile of section with 1/4 X 3/4 self-drilling screws. Place rollers in elevated tube portion of hinge. Stack section by turning roller and section into track and fastening top portion of #1 hinges to bottom of lock section. Fasten track to jamb through second track clip, maintaining 1/2" spacing.

**9.** Attach hinges to #3 section, place rollers in elevated hinge tubes, stack and secure as above.

ADV Model Only  
1. Reinforcement Plate  
2. Tinnerman nuts (2)



**Figure 7**

**WARNING: \*Lock and T-Handles Must Be Installed.\***



**10.** Fasten remainder of vertical track using a minimum of two lags in the flag bracket, preferably in the top and bottom slots. Take a measurement from the top of the third section to the top of the vertical track. Install vertical track on opposite side of door maintaining the **SAME** top of door to top of track dimension as well as the 1/2" spacing from the edge of the door. Remove nails holding bottom section in place.

**11.** Fasten horizontal tracks to vertical tracks and angle brackets (Figure 8). Two car doors, using extension springs, a sheave plate must be fastened to horizontal and vertical angle with three 5/16" X 3/4" carriage bolts (Figure 9).

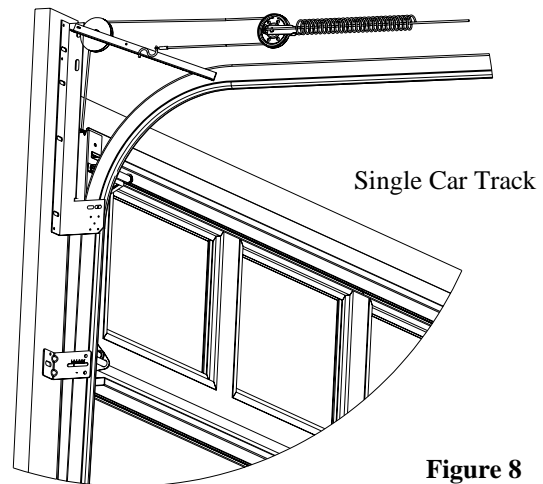
**12.** Bolt stationary sheave to angle on horizontal track for single car door or to sheave plate for a two car door using 3/8-16 x 1-1/4" bolts and nuts furnished. Tighten securely.

**13.** Install adjustable top roller fixtures on top section, fastening into holes provided. Insert roller into 1 top roller carrier, loosen adjusting bolt, then turn section and roller into track. Install opposite roller by removing slide, inserting roller into tube, and re-installing slide. Adjust and tighten both top roller carriers so that top section is plumb. Install any remaining hinge fasteners so that all hinges and sections are completely attached together.

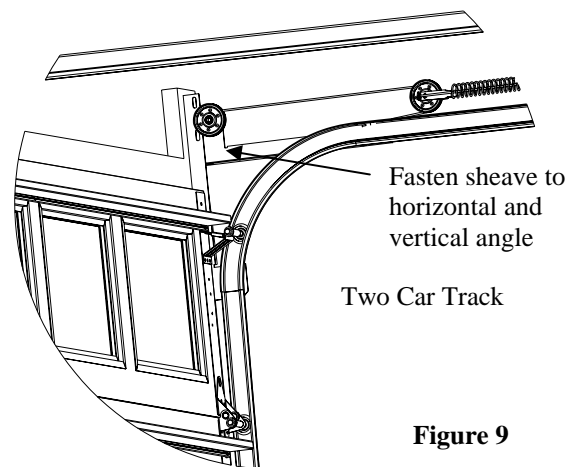
**TWO CAR DOORS ONLY :** install strut across top section (Figure 10).

**14.** Permanently set lock bar guides so that lock bars enter the hole in the track without obstruction but as close to the top of the hole as possible.

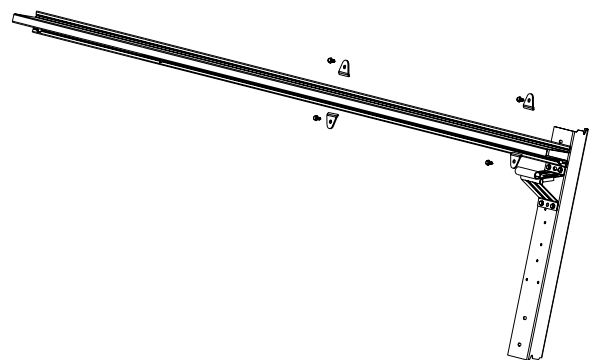
**TORSION SPRINGS:** Go to supplementary instructions



**Figure 8**



**Figure 9**



**Figure 10**

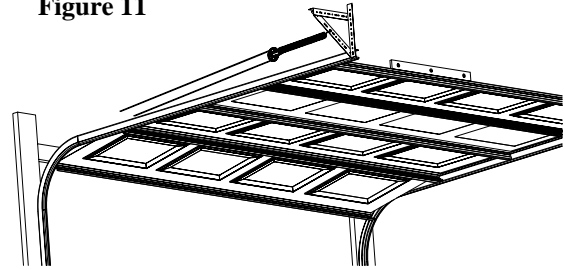


**WARNING: \*Place All Labels On Finished Door.\***



15. ▲ CAUTION Carefully lift door so that top and #3 section are in horizontal track, using blocks or saw horses as required and keeping door level. This must be done with extreme caution with the tracks held plumb and level by ropes if necessary. Securely hang track from ceiling, maintaining 1/2" spacing between track and edge of sections. Attach side brace track hangers to prevent sway(Figure 11). Be sure to fasten track hanger angles in to ceiling joists or other solid blocking if ceiling is finished.

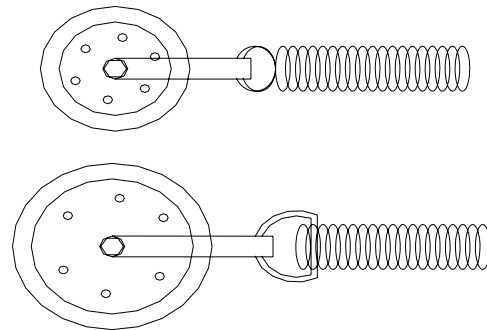
Figure 11



### EXTENSION SPRING INSTRUCTIONS

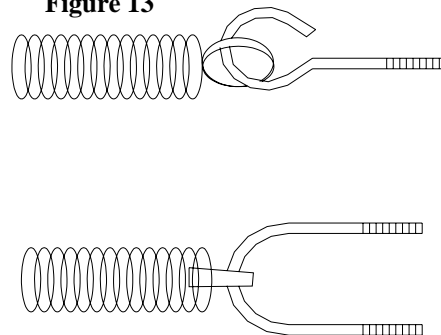
1. Attach SPRING SHEAVE to spring with 3/8" bolt and clevis (Figure 12). Attach rear end of spring to track support angle with "U" bolt (or eye bolt) provided (Figure 13). Location should be maximum 18" above track.

Figure 12



2. ▲ CAUTION. Lift Door and *SECURELY BLOCK* full open. Place keyhole end of cable over pin on the bottom corner brackets. Thread cable from bottom bracket up between Stationary Sheave and jamb, then over top of sheave, through spring sheave and return to front, anchoring end with cable connector (Figure 14) and "S" hook to angle near stationary sheave. Repeat with opposite cable and spring.

Figure 13

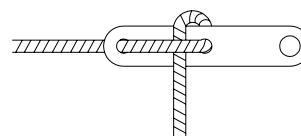


3. ▲ CAUTION. MAKE SURE ALL CABLE CONNECTIONS, SHEAVES AND BRACKETS ARE FASTENED TIGHT. **DOUBLE CHECK.**

4. Remove blocks holding door open and operate door up and down several times. If door will not remain in closed position, lengthen cables. If door closes too fast from its own weight or will not remain fully open, shorten cables.

5. ▲WARNING – All spring adjustments must be made with door securely blocked in full open position.

Figure 14



**STOP MOLDINGS-** Install stop moldings around perimeter of door to seal gap between jamb and door. Edge of stop or weatherseal should barely make contact with door so as not to bind against it during operation

**WARNING: DO NOT Attempt to fully open door prior to installing Back Hangers.**  
**\*All spring adjustments must be made with door securely blocked in Full Open Position.\***

