



# STEELDOR++ FITTING AND MAINTENANCE INSTRUCTIONS

## SURVEYING

Accurate surveying is important for correct installation. Please take good measurements and supply accurate widths and heights for each door to the nearest millimetre.

We follow the same principle of most steel door manufacturers, whereby the outer dimensions of the frame are made 10mm smaller on the width and 5mm smaller on the height. This allows for a 5mm tolerance on either side of the doorsets, and 5mm above.

It is the client's responsibility to ensure the opening is square, clean and accessible, prior to installation.

## EQUIPMENT & TOOLS REQUIRED

- ✓ Masonry drill and drills to suit fixings
- ✓ Pencil or marker pen
- ✓ Spirit level
- ✓ Steel tape
- ✓ Fixings to comply with the minimum fixing standards
- ✓ Tools to install fixings, i.e. cordless/corded drills
- ✓ Mastic or similar filler

## PRE-INSTALLATION CHECKS

- ✓ Check that the door frame supplied will fit into the opening
- ✓ Ensure the area is clear of all obstructions
- ✓ Open supplied package and check contents against delivery note
- ✓ Check that it is safe to drill around the opening
- ✓ Make sure the structure to which the door will be fitted is strong and solid.

## FIRE RATED DOORS

Additional requirements for fire rated doors:

- ✓ Fixings to the main structural surround should comprise of steel screws of sufficient length to penetrate the main structure by a minimum of 30mm, although 120mm is recommended (plastic rawl plugs are not acceptable).
- ✓ All fixings and hardware must be steel (no plastic).
- ✓ Steel screws are to be inserted at a maximum of 500mm centres.
- ✓ Fixing clearing holes in the frame may be covered using steel or plastic bungs.
- ✓ Any packers or shims used during installation must be made from steel.
- ✓ Gaps between the opening and the frame should be less than 5mm, and sealed with a fire rated intumescent sealant. Any gaps larger than 5mm must be filled with steel.

- ✓ On FIREDOR++ double doors, an overlap of 18mm covering the passive door leaf (anti-pry strip) is required.
- ✓ The passive door on double doors must be fixed top and bottom, and the active leaf must have a centre latch, as minimum.

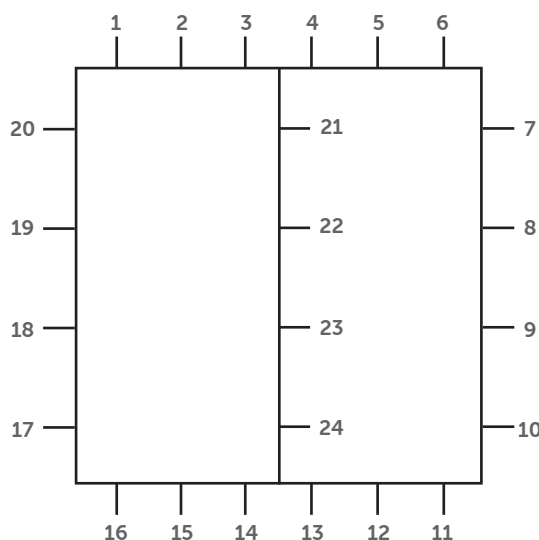
The maximum gaps allowed around a fire rated door are as follows:

For FIREDOR++ doors:

- ✓ 20, 19, 18, 17, 7, 8, 9, 10 = 7mm
- ✓ 1, 2, 3, 4, 5, 6 = 10mm
- ✓ 21, 22, 23, 24 = 5.5mm
- ✓ 16, 15, 14, 13, 12, 11 = 20mm

For security-rated FIREDOR++ doors:

- ✓ 20, 19, 18, 17, 7, 8, 9, 10 = 6mm
- ✓ 1, 2, 3, 4, 5, 6 = 4.2mm
- ✓ 21, 22, 23, 24 = 5.6mm
- ✓ 16, 15, 14, 13, 12, 11 = 20mm





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## SECURITY RATED DOORS

When installing security rated doors, the client must be fully satisfied that the structure around the aperture is more secure or equivalent to the doorset rating.

Strongdor++ doorsets are LPCB certified to LPS 1175 SR2, SR3 and SR4, respectively. To ensure that the installation complies with the accreditation, follow one of the minimum fixing standards below.

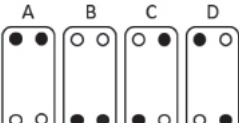
The minimum fixing standards (below) assume installation direct into substrate not via intermediate substrate, such as plasterboard. The perimeter of the door should be made good, using mastic or similar.

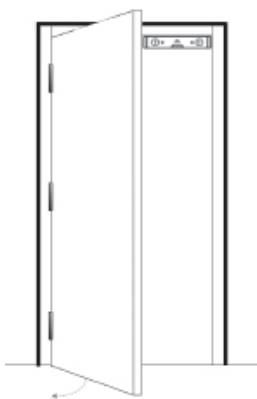
Door Type	Substrate						
	Brick, Block & Concrete			Steel			
	Min Qty	Size, Grade & Min Bolt Diameter	Min Length	Min Qty	Size & Grade	Min Length	Min Steel Thickness
(SR2)	24	M8 8.8 Grade 8mm Dia	60-150mm	24	M8 8.8 Grade +	30mm	3mm
	16	5.5 Tek Screw	16mm	16	5.5 Tek Screw	16mm	3mm
	7	6.3 Tek Screw	16mm	7	6.4 Tek Screw	16mm	3mm
	15	M6 A2 Screw	16mm	15	M6 A2 Screw	16mm	3mm
	7	M6 10.9 Screw	16mm	7	M6 10.9 Screw	16mm	3mm
	4	M8 A2 Screw	16mm	4	M8 A2 Screw	16mm	3mm
	4	M8 10.9 Screw	16mm	4	M8 10.9 Screw	16mm	3mm
	24	Hilti Type Fixing 7mm Dia	60-150mm				
(SR3)	24	M8 8.8 Grade 8mm Dia	60-150mm	24	M8 8.8 Grade +	30mm	3mm
	13	M8 A2 Screw	16mm	13	M8 A2 Screw	16mm	3mm
	8	M8 10.9 Screw	16mm	8	M8 10.9 Screw	16mm	3mm
	24	Hilti Type Fixing 7mm Dia	60-150mm				
(SR4)	22	M8 A2 Grade 8mm Dia	60-150mm	22	M8 A2 Grade 8mm Dia	30mm	5mm
	21	M8 10.9 Grade 8mm Dia	60-150mm	21	M8 10.9 Grade 8mm Dia	30mm	5mm
	21	M10 10.9 Grade 10mm Dia	60-150mm	21	M10 10.9 Grade 10mm Dia	30mm	5mm
	9	M10 12.9 Grade 10mm Dia	60-150mm	9	M10 12.9 Grade 10mm Dia	30mm	5mm
	9	M10 A2-70 Grade 10mm Dia	60-150mm	9	M10 A2-70 Grade 10mm Dia	30mm	5mm
	9	M12 8.8 Grade 12mm Dia	60-150mm	9	M12 8.8 Grade 12mm Dia	30mm	5mm
	9	M12 10.9 Grade 12mm Dia	60-150mm	9	M12 10.9 Grade 12mm Dia	30mm	5mm
	9	M12 12.9 Grade 12mm Dia	60-150mm	9	M12 12.9 Grade 12mm Dia	30mm	5mm

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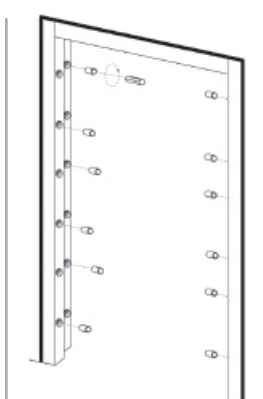
## SINGLE DOORS WITH ADJUSTERS

1. Insert the door and frame into the opening, and open the door to 90°, using packers underneath the door leaf to level the frame in the opening.
2. Place the spirit level parallel to the frame. If the head of the frame is not level, use packers to raise the lowest side of the frame to level.
3. Once the frame is aligned, screw the adjusters through the tapped holes using the hex tool supplied, ensuring the door is central in the opening. Adjusters must be arranged using one or more of the following patterns:
 

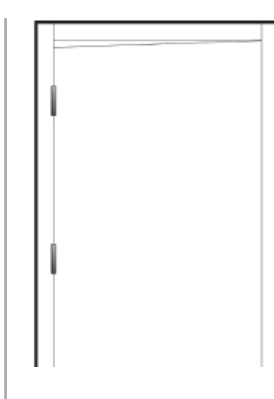

4. Level up the front face of the hinge post, ensuring the top of the frame does not lean in or out of the opening.
5. Using the hex tool supplied, fasten the top adjusters, then the bottom adjusters, and finally the middle adjusters. Care must be taken not to distort the frame by over-tightening the adjusters.
6. Close door leaf to test it in the frame. If the leading edge is too high, loosen the adjusters at the top edge of the hinge post. If it's too low, then tighten the adjusters towards the top edge.
7. Once adjustments are made, drill and insert fixings down both vertical posts. Do not tighten the fixings.
8. Double check the door alignment with a spirit level, then tighten fixings.
9. Test the door hardware and operation. Any panic hardware must have the opening force measured and recorded in the operation and maintenance manual.
10. Fit the bottom sill (if present). Level up with shims so it is parallel with the bottom of the door leaf, then drill and fit to floor.
11. Mastic seal around the door frame and bottom sill (inside and outside), as required.
12. Plug the fixing holes in the frame with bungs.
13. Re-check operation of the doorset.



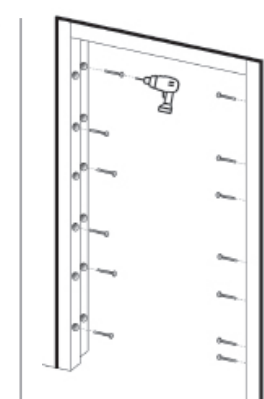
Steps 1-2



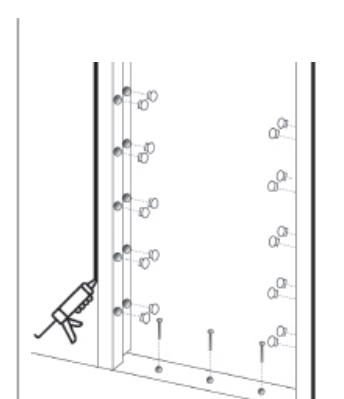
Steps 3-5



Step 6



Steps 7-9



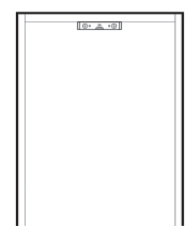
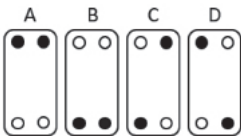
Steps 10-13



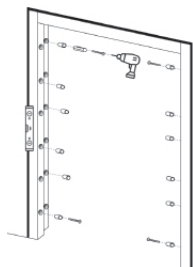
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## DOUBLE DOORS WITH ADJUSTERS

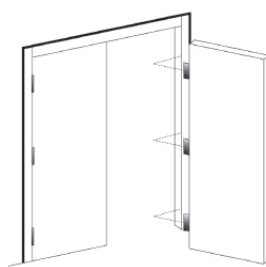
1. Assemble the door frame using fixing blocks and screws, then insert the frame into the opening.
2. Place the spirit level parallel to the frame. If the head of the frame is not level, use packers to raise the lowest side of the frame to level.
3. Screw the adjusters through the tapped holes using the hex tool supplied, ensuring the door is central in the opening. Adjusters must be arranged using one or more of the following patterns:
4. Level up the front face of the first hinge post, ensuring the frame does not lean in or out of the opening.
5. Drill and insert fixings into top and bottom fixing holes. If the doors are heavy, add one or two fixings to the middle of each post as well. Place packers close to the fixings. Do not tighten the fixings.
6. Position frame centrally in opening, with the first hinge post vertical. Double check the door alignment with a spirit level, then tighten fixings.
7. Hang the doors on the frame, then close the doors to check that they shut correctly and are hanging level, and test the door hardware.
8. If the doors bind at the top, loosen the adjusters on both sides at the top of the frame. If the doors are binding at the bottom, loosen the adjusters at the bottom.
9. Once adjustments are made, drill and insert fixings on all posts. Do not tighten the fixings.
10. Double check the door alignment with a spirit level, then tighten fixings.
11. Test the door hardware and operation. Any panic hardware must have the opening force measured and recorded in the operation and maintenance manual.
12. Fit the bottom sill (if present). Level up with shims so it is parallel with the bottom of the door leaf, then drill and fit to floor.
13. Mastic seal around the door frame and bottom sill (inside and outside), as required.
14. Plug the fixing holes in the frame with bungs.
15. Re-check operation of the doorset.



Steps 1-2



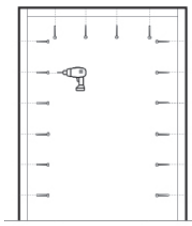
Steps 3-5



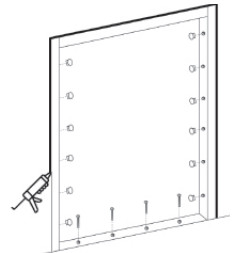
Step 6



Steps 7



Steps 8-10



Steps 11-14