

Please read following information prior to installation;

1. When unpacked and prior to installation—check the product for any damage or abnormality, notify any defects in writing within 7 days of delivery
2. Doors are supplied with spacers between door and frame; these spacers must not be removed prior to installation
3. The doorset should be installed with the door closed into the frame & with spacers left in place to prevent the frame from becoming warped and being fastened into the wall out of square
4. The doorset must be installed square and into a flat surface, out of flat or out of wind surfaces will cause the door frame to twist and the door will not be able to close correctly
5. Colourbond steel is supplied with a protective plastic coating, this must be removed within 7 days of installation, or damage to the Colourbond surface can occur
6. Maintenance of door locks and other hardware fitted to this door must be in accordance with the manufacturer's recommendations; technical data sheets are available upon request
7. This product is covered by the ARA Manufacture standard warranty conditions, available on website.

Pre-Installation Checklist:

1. Unpack the doorset and check that it is the correct size, is undamaged and is the correct door number relating to your opening
2. Do not open the door until the doorset has been installed and fastened into the wall; packers are taped between door leaf and frame to maintain the correct clearance and these should be left in place with the door closed as per the installation procedure outlined below. Failure to follow this instruction may cause the frame to warp and prevent the door from being able to be installed true and square, claims to repair or replace doors that have not been installed as per these instructions will not be accepted
3. Check that the wall (that the doorset is to be installed into) is vertical and flat and that the opening each side of the door is level one side to the other i.e. it doesn't 'kick out' on one side compared to the other *(Refer Fig 1)*
4. Check that you have shims or packers, preferably steel shims in 1mm & 2mm thicknesses. These are used to shim the rear of the frame between the frame and the wall to prevent bowing the frame.

Fig 1

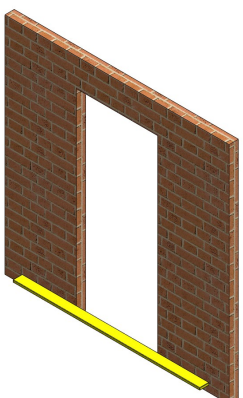


Fig 2

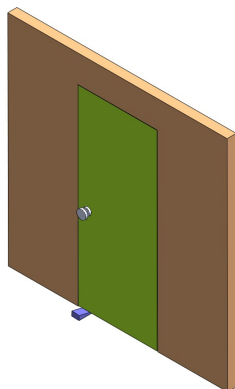


Fig 3

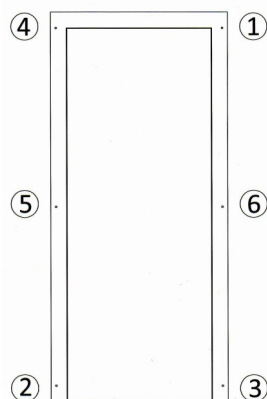


Fig 4

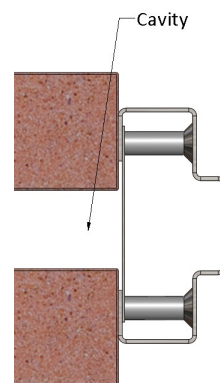
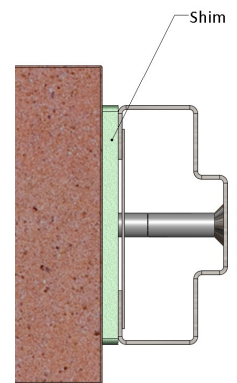


Fig 5



Straight edge to check wall is flat — ie no gaps between straight edge & wall

Timber or steel studwall steel clad exterior transportable buildings:

These instructions pertain to the installation of Sealeck "T" or "P" series frames pre-hung with steel doors with or without an internal trim frame into steel clad transportable or similar buildings:

1. If provided, remove the rear trim frame from the packed set (but do not mix up with others as these are factory matched sets). Identify with door number if appropriate
2. With the door leaf closed into the frame, and with factory fitted packers (between door leaf and frame) fitted, lift the door & frame, set into position and push into the structural opening
3. For four sided frames with a threshold, packers are fitted between door leaf and frame at top and bottom. Ignore steps 4 & 5 following and go to step 6
4. For three sided frames, when the doorset is located into the correct position tap a wedge beneath the door leaf on the lock side (*Refer Fig 2*) to prevent the door leaf from sagging. Tap the wedge in until the clearance at the top of the door between door leaf and frame has closed up to within 1mm of the frame head
5. The door is now packed up higher than square, and will settle due to a small amount of play in the hinges when it is released. This should then settle back to become square
6. With the door leaf wedged up to this position ensure that the frame is pushed flush against the wall surface and install fixing screws to the following locations:
 - If the doorset is provided with an internal trim frame check that sufficient space exists and that this frame can be inserted on the inside, then;
 - On the main frame, install fixing screws through the overlapping flange and into the wall panel each side as follows: 1st top right, then bottom left, then bottom right then top left, then middle each side (*Refer Fig 3*)
 - On the trim frame (if fitted), install fixing screws through the overlapping flange and into the wall panel each side as follows: 1st top right, then bottom left, then bottom right then top left, then middle each side (*Refer Fig 3*)
7. *For three sided frames, remove the wedge beneath the door leaf and check that the door settles to the 'square' position. The gap across the top of the door between door leaf and frame should be equal
8. Open the door and remove the packers between door leaf and frame and check that the door closes correctly, the latch bolt engages the strike plate, and the door doesn't protrude from the frame at either the top or bottom lock side corners. Doors that 'kick out' at the bottom or top are usually a result of a structural opening that is not aligned (see pre-installation checklist Item 3)
9. If the latch bolt doesn't enter the strike plate cavity, or binds, the strike plate opening may need to be filed at the relevant edge to ease the ability of the latch to enter smoothly
10. Now install the balance of fixing screws into the frames, both inside and outside and do a final check that the door operates correctly.

Industrial steel buildings:

These instructions pertain to the installation of Sealeck "T" or "P" series frames pre-hung with steel doors into steel clad Industrial buildings:

1. These instructions assume the following:
 - That purlins or other framework has been provided into a framed opening in the building to enable the door frame to be connected to the building framework
 - That the building has been clad and that the door frame will fit over the exterior cladding

2. With the door leaf closed into the frame and with factory fitted packers (between door leaf and frame) in place, lift the door & frame set and position and push into the structural opening
 3. When located into correct position, tap a wedge beneath the door leaf on the lock side (*Refer Fig 2*) to prevent the door leaf from sagging. Tap the wedge in until the clearance at the top of the door between door leaf and frame has closed up to within 1mm of the frame head. The door is now packed up higher than square and will settle due to a small amount of play in the hinges when it is released and should then settle back to become square
 4. With the door leaf wedged up to this position ensure that the frame is pushed flush against the wall surface and install fixing screws (*Refer Fig 3*)
 5. Now remove the wedge beneath the door leaf and check that the door settles to the square position, the gap across the top of the door between door leaf and frame should be equal
 6. Open the door and remove the packers between door leaf and frame and check that the door closes correctly, the latch bolt engages the strike plate and the door doesn't protrude from the frame at either the top or bottom (lock side) corners. Doors that 'kick out' at the bottom or top are usually a result of a structural opening that is not aligned (see pre-installation checklist Item 3)
 7. If the latch bolt doesn't enter the strike plate cavity, or binds, the strike plate opening may need to be filed at the relevant edge to ease the ability of the latch to enter smoothly
 8. Now install the balance of fixing screws into the frame both on the external flange and through the frame return on the inside ("P" series frames only) and do a final check that the door operates correctly
 9. If fitted into portable buildings that need to be transported after installation, then the supplied packers need to be re-fitted back into the original gaps between door & frame. This ensures the door doesn't move or twist during the moving process.
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Masonry walls

These instructions refer to the installation of Sealeck "R" series frames with pre-hung doorsets into masonry (brickwork or concrete) walls.

1. This instruction *assumes* that the door and frame is being installed into an existing prepared opening in either a single or double, brick or concrete masonry wall. For building in frames during brickwork erection or for installation of frames into "tilt up" concrete openings for "cast in" applications see next section:
2. With the door leaf closed in the frame and with factory fitted packers (between door leaf and frame) fitted, lift the door & frame set into position and push into the structural opening
3. When located into correct position tap a wedge beneath the door leaf on the lock side (*Refer Fig 2*) to prevent the door leaf from sagging. Tap the wedge in until the clearance at the top of the door between door leaf and frame has closed up to within 1mm of the frame head. The door is now packed up higher than square and will settle due to a small amount of play in the hinges when it is released and should then settle back to become square
4. With the door leaf wedged up to this position ensure that the frame is pushed to the correct position in the depth of the opening. Check that the frame will be supported by the masonry wall each side, you want to avoid the frame from protruding from the wall on one side and being recessed into the wall on the other
5. The correct "R" series frame fixing method for this type of installation is one with CSK holes around the perimeter of the frame reveal. These holes suit dynabolts or similar fastenings screwed through the frame out into the brickwork or into masonry walls. Ensure that the frame is

positioned so that these bolts will enter solid masonry rather than into the cavity of double brick-work (*Refer Fig 4*)

6. Install several screws diagonally into the frame without tightening the bolts, once you have an even number of bolts installed (at least 2 at the top and 2 at the bottom) fit shims in the space between the rear face of the frame and the wall and tighten the screws as necessary to hold the shims firmly without over tightening (*Refer Fig 5*) Provide sufficient shims to prevent the frame from warping as the bolts are tightened
 7. Now remove the wedge beneath the door leaf and check that the door settles to the square position, the gap across the top of the door between door leaf and frame should be equal.
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Cast in frames into tilt-up or walls being bricked

1. When frames are to be fitted with steel doors, it is normal procedure to provide frames with plywood blanking to enable the frame to be held square and prevent warping of the frame during the casting in process. Refer to ARA Manufacture prior to casting in of frame into walls
 2. Doors and frames will be factory pre-hung to ensure that they are matched and then frames are identified and doors removed and held pending completion of the walls and advice that the doors may be shipped for installation
 3. Door leaves may then be simply hung by screw fixing to the existing hinges
 4. Providing that door blanks have been used and the frame has remained true and square then the door should open and close and latch correctly
 5. Open the door and check that the door closes correctly, the latch bolt engages the strike plate and the door doesn't protrude from the frame at either the top or bottom (lock side) corners. Doors that kick out at the bottom or top are usually a result of a structural opening that is not aligned (see pre-installation checklist Item 3).
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***Thank you for purchasing a quality ARA Manufacture product
—we trust it will provide you with many years of good service***