**DURULITE INDUSTRIAL, STANDARD & SECURITY DOOR INSTALLATION INSTRUCTIONS**

**PREPARATION**

MEASURE WIDTH AND HEIGHT OF FRAMED OPENING AND COMPARE WITH OTHER DIMENSIONS. FRAMED OPENING DIMENSIONS MUST MEET ORDER DIMENSIONS WITHIN THE FOLLOWING TOLERANCES:

- SINGLE DOORS: HEIGHT: +1/4" -1/2" WIDTH: +1/4" -1/2"
- DOUBLE DOORS: HEIGHT: +1/4" -1/2" WIDTH: +1/8" -1"

IF THE FRAMED OPENING DOES NOT MEET THE ORDER DIMENSIONS WITHIN THESE TOLERANCES CALL THE FACTORY AT 1-800-547-8858

**FOR PROPER INSTALLATION**

FOR DOORS TO OPERATE PROPERLY, FRAMED OPENINGS MUST BE SQUARE AND PLUMB. MAKE NECESSARY ADJUSTMENTS TO SQUARE AND PLUMB OPENING.

**DRILL BIT SIZES (2) (3) (4)**

- FOR STEEL JAMS: USE: 5/8" DRILL BIT.
- FOR WOOD JAMS & ROLL PIN INSTALL: USE: 3/16" DRILL BIT.
- FOR SECURITY DOORS: USE: 7/8" DRILL BIT.

*ON SECURITY DOORS USE A 1/4-20 TAP* (PART 14) ONLY.

3/16" DRILL BIT IS REQUIRED FOR THE ROLL PIN INSTALLATION AND IS INCLUDED WITH YOUR HARDWARE PACKAGE.

**FASTENERS (3)**

- FOR STEEL JAMS: USE: 1/4" X 1 7/8" TEK SCREW.
- FOR WOOD JAMS: USE: 1/4" X 3" HARDWARE SCREW.
- FOR SECURITY DOORS: USE: 1/4-20 X 7/8" SOCKET HEAD.

- FOR: (FOR STEEL JAM) USE: 1/4-20 X 1 7/8" TEK SCREW.
- FOR WOOD JAM: USE: 1/4" X 3" HARDWARE SCREW.
- FOR SECURITY DOORS: USE: 1/4-20 X 1/1/2" TEK SCREW.

**STEP 1. MARKING AND DRILLING JAMB FOR HARDWARE.**

**NOTE:** PROCEED ONLY AFTER COMPLETING THE "PREPARATION" SECTION AT LEFT.

USE A PLUMB TO ENSURE THE CENTERLINE OF JAMB, PLACE TEMPLATE ON THE INSIDE FACE OF JAM WITH BOTTOM OF TEMPLATE TOUCHING FINISHED FLOOR OR SILL, LINE UP CENTERLINE ON TEMPLATE WITH CENTERLINE OF JAMB.

MARK HOLES THROUGH TEMPLATE ON JAM WITH CENTER PUNCH. **NOTE:** SEE "DIM A" FROM "HARDWARE LOCATION" SECTION, PAGE 2, FOR YOUR APPLICATION.

REPLACE TEMPLATE FROM JAM AND DRILL HOLES (SEE "DRILL BIT SIZES" AT LEFT).

**STEP 2. ATTACHING HARDWARE AND HANGING DOOR.**

ATTACH PILLOW BLOCK TO JAMB. NOTCH SIDE UP, WITH SINGLE FASTENER (DO NOT TIGHTEN FASTENER AT THIS TIME).

PLACE UPPER V-CAM (6) AND ROLLER ASSEMBLY (3) OVER UPPER HINGE ADAPTOR SHAFT (SEE FIGURE 4). TILT THE LOWER PILLOW BLOCK TO APPROXIMATELY A 30° ANGLE (SEE FIGURE 2). THIS ALLOWS YOU TO INSERT THE LOWER HINGE ADAPTOR INTO THE LOWER PILLOW BLOCK WITHOUT INTERFERENCE FROM THE HANGER. LIFT THE DOOR AND INSERT THE LOWER HINGE ADAPTOR SHAFT INTO THE LOWER PILLOW BLOCK.

STAND THE DOOR UPRIGHT, PLACE THE BACKER PLATE BEHIND THE V-CAM ASSEMBLY (6) AND FASTEN TO JAM USING APPROPRIATE FASTENERS (SEE "FASTENING AT LEFT") AND TIGHTEN. INSERT REMAINING FASTENERS INTO LOWER PILLOW BLOCK (AND TIGHTEN.

**NOTE:** PILLOW BLOCK NOTCH MUST POINT UP.

**STEP 3. DOOR SWING AND HEIGHT ADJUSTMENT.**

**NOTE:** IF YOUR OPENING HEIGHT IS OUT OF TOLERANCE AS INDICATED UNDER THE "PREPARATION" SECTION AT LEFT CALL THE FACTORY AT 1-800-547-8858, OTHERWISE CONTINUE FROM HERE.

PLACE THE ADJUSTER PIPE TO BETWEEN THE DOOR FOR USE AS A SPACER. CENTER PANEL IN OPENING AND SET THE BEARING ON THE ROLLER ASSEMBLY TO LOWEST POSITION (SEE FIGURE 3).

TIGHTEN THE TOP CAP SCREW IN THE ROLLER ASSEMBLY AND REMOVE SPACER AND ALLOW DOOR TO REST IN OPENING. BE SURE THAT THE PANEL/PANELS ARE CENTERED IN OPENING BEFORE CONTINUING. IF PANEL/PANELS ARE NOT CENTERED YOU MUST LOOSEN THE CAP SCREWS AND READJUST PANEL/PANELS.

**STEP 4. HINGE GUARD AND SEAL.**

PEEL PAPER FROM DOUBLE FACE TAPE ON UPPER HINGE SEAL (SKIRT SIDE DOWN). ATTACH WITH #10 TEK SCREWS.

SET LOWER HINGE GUARD INTO PLACE ON FLOOR AND AGAINST JAMB, CENTERED OVER LOWER PILLOW BLOCK. MARK HOLES, REMOVE LOWER HINGE GUARD AND DRILL (SEE "DRILL BIT SIZES" AT LEFT).

ATTACH LOWER HINGE GUARD WITH FASTENERS AND SNAP SOLID RISER ONTO LOWER HINGE ADAPTOR SHAFT, JUST ABOVE THE LOWER PILLOW BLOCK.

**NOTE:** CHECK DOOR AT FULL SWING IN BOTH DIRECTIONS. IT MAY BE NECESSARY TO TRIM GASKET MATERIAL IN SOME AREAS.
**DURULITE INDUSTRIAL, STANDARD & SECURITY DOOR**
**INSTALLATION INSTRUCTIONS (Continued)**

**ROLL PIN INSTALLATION (See WARNING Below)**

**WARNING**
FAILURE TO INSTALL ROLL PIN AS INDICATED IN THESE INSTRUCTIONS WILL VOID ANY AND ALL WARRANTIES ATTACHED TO THIS PRODUCT!!!

**IMPORTANT:**
MAKE SURE PANELS CLOSE AND SWING CORRECTLY BEFORE PROCEEDING. DOOR SWING CAN NOT BE ADJUSTED AFTER PINNING.

**FIGURE “4-A”**
3/16” Ø ROLL PIN DRILL COMPLETELY THRU TO OTHER SIDE

**FIGURE “4-B”**

**SPRING ASSIST INSTALLATION**

**IMPORTANT:**
MAKE SURE THAT “ROLLER ASSEMBLY” IS PROPERLY MOUNTED AND PINNED BEFORE PROCEEDING.

**CAUTION:**
SPRING COILS MUST NOT TOUCH EACH OTHER WHEN DOOR IS IN THE OPEN POSITION. OVERTIGHTENING THE SPRING WILL CAUSE SEVERE DAMAGE TO THE ROLLER ASSEMBLY.

**STEPS:** (Refer to FIGURE “5”)
1. INSERT THREADED SHAFT (PIN 5544) INTO LOWER HINGE SHAFT UNTIL JAMB NUT BOTTOMS OUT, THEN TAKE HALF TURN ON JAMB NUT WITH OPEN-END WRENCH
2. SLIDE THIN WASHER (PIN 5552) OVER THREADED SHAFT, SLIDE SPRING (PIN 5553) OVER SHAFT, THREAD ADJUSTMENT WASHER (PIN 5545) ONTO (THREADED) SHAFT JUST ENOUGH TO GET IT STARTED.
3. TIGHTEN THE THREADED ADJUSTMENT WASHER (PIN 5545) ON THE THREADED SHAFT (PIN 5544) UNTIL THE DESIRED CLOSING ACTION IS OBTAINED.
4. PLACING OPEN-END HAND WRENCHES ON THE ADJUSTMENT WASHER (PIN 5545) AND ON THE JAMB NUT, TURN ONE AGAINST THE OTHER TO LOCK ADJUSTMENT WASHER IN PLACE.

**FIGURE “5”**

**WELD PLATE LOCATIONS**

**NOTE:** DIMENSIONS LISTED PERTAIN ONLY TO STANDARD FINISHED OPENING HEIGHTS. PLEASE VERIFY YOUR FINISHED OPENING HEIGHT WITH THE FACTORY PRIOR TO DRILLING. CONTACT THE FACTORY AT 1-800-547-6856.

**HARDWARE LOCATIONS**

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<th>OPENING HEIGHT</th>
<th>ACTUAL DOOR HEIGHT</th>
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**WELDPLATES**
- Standard
- Industrial

90° Durulite Standard (No Weld Plates)
90° Durulite Industrial (No Weld Plates)

**DIM "B"**

BOTTOM OF UPPER WELDPLATE (V-CAM)

TOP OF LOWER WELDPLATE (PILOT BLOCK)

WELDPLATES Standard
WELDPLATES Industrial