

MOUNTING INSTRUCTION FOR WELDED A-RATED DOOR

Valid for: **MV4298. MV4360. MV4361**

MOMEc
DOORS OF SWEDEN

1. Dismantle door leaves and frames.

1.1 Mark door leaf and frame.

2. Check Cut-out

2.1 Size of hole in bulkhead according to drawing and specification.

2.2 Bulkhead and frame must overlap min. 25mm.

2.3 Bulkhead must be straight and aligned with frame.

2.4 Sill at the correct height to the surroundings.

3. Notch weld

3.1 Notch weld the frame in the corners and mid-height.

3.2 If the width is more than 1000mm, notch weld also on the middle of the top and bottom.

4. Check measurements

4.1 Maximum diagonal tolerance: 3mm

4.2 Maximum width and height tolerance: $\pm 1\text{mm} / \pm 2\text{mm}$

4.3 Maximum misalignment: ± 1

5. Welding

5.1 Protect the gasket if there is one.

5.2 Weld 3-50/150 according to numbered sequence on the drawing.

5.3 Gaps more than 1mm between frame and bulkhead is not approved.

6. Installation of door leaf in frame

6.1 Mount lock, handle, door closer and other accessories.

6.2 Maximum width and height tolerance: $\pm 2\text{mm}$

6.3 Maximum misalignment: ± 1

6.4 Check function.

6.5 Grease lock and hinges.

7. Service and maintenance

7.1 Check function of lock, door closer etc every 2-6 weeks, depending on frequency of use and environment.

