



**FlexiForce® pass door
installation and production.**

**Step-by-step pictures
manual.**

SafeStep®





Content

page/pages

■	Preparing low threshold profile, part 1	5/138
■	Preparing low threshold profile, part 1	13/138
■	Cutting panels with simple hand cutting machine	22/138
■	Fixing alu profiles with caps / end caps to panels	33/138
■	Fixing alu profiles of pass door top section in door panel	42/138
■	Assembling/placing bottom section with threshold	53/138
■	Finalize preparation of door blade	71/138
■	Installation of door blade part 1	77/138
■	Installation of door blade part 2	95/138
■	Preparation of pass door sections	102/138
■	Installation of pass door sections	114/138
■	The result of installation	126/138
■	Alternative straight cutting of low threshold	131/138



Installation time

- March 2011: Experienced door installer builds his first SafeStep pass door with proper tooling and FlexiForce instructions within 4 hours.

- Preparing low threshold profile **20min**
 - Cutting, de-burring, mounting sticker 1041LT
- Preparing door sections **90min**
 - Fixing end caps, alu profiles, strut, side-hinges
- Preparing pass door sections **30min**
 - Fixing alu profiles
- Placing and fixing door sections **45min**
 - Fixing bottom panels to low threshold
 - Stacking the door sections, fixing hinges
- Finishing installation pass door **30min**





Conditions/Tools

- Panels cut with simple cutting machine. Took 30min, not included in stated time.
 - Alu profiles and hinges of SafeStep system pre-cut/pre-assembled in FF NL, supplied as kit.
 - No lock or door pusher is installed.
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- Distance profile used to cut flanges of threshold profile with cutting machine.
 - Frame/tool used to position alu profiles of pass door at 90 degree angle on panels.
 - Frame/tool used to fix position of door sections around pass door.
 - Frame is used to position aluminum profiles at correct width of pass door and at 90 degree angle. Profiles fixed before drilling/riveting.
 - Plastic filling plates used to eliminate play during pass door installation.



Preparing threshold

- Preparing low threshold profile, part 1
- one piece alu profile, code 1041L3000/5000
- Cut the length
- Remove flanges at end of profile:
 - Made radial cut in flanges
 - Place filling block and put sticker to prevent scratches
 - Fix profile and filling block and make cut along alu profile.
- Alternatively use a grinder with special blade.

















Preparing threshold

- Preparing low threshold profile, part 2
- Mark length and position of flanges which need to be removed for pass door opening.
- Fix alu profile and drill hole in middle of inner flange which needs to be removed.
- Place filling block and cut flange from middle to both sides
- Repeat this for outer flange and de burr the cut.
- Place the sticker (1041LT)



















Cutting

- Cutting panels with simple hand-cutting machine





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Fixing alu profiles

- Fixing alu SafeStep profiles with caps / end caps to panels
- Separate hinges blades by loosening bolts and position caps on alu profiles
- Fix caps making sure there is no burr between cap and alu profile.
- Position profiles with cap on panel and place section in frame/tool to align correctly.
- Fix position by clamps and assemble alu profiles and end caps with rivets.
- Mark length and position of flanges which need to be removed for pass door opening.



















Fixing alu profiles

- Fixing the alu SafeStep profiles of the pass door top section in the door panel.
- Mount top seal in horizontal top alu profile and position it in door panel together with vertical alu profiles.
- Position correctly with frame/tool.
- Fix alu profile with rivets to panel and reinforce construction by riveting angle brackets in corners of alu profiles.























Bottom section

- Assembling and placing bottom section with low threshold profile.
- Place low threshold profile and pre-assembled bottom sections (without end caps) with help of frame/tool in correct position.
- Fix bottom panels with rivets to low threshold profile and remove bottom section.
- Fix end caps and side hinges.





































Door blade

- Finalize preparation of the door blade
- Fix end caps and side hinges to sections and fix strut (80PS..) to top section of pass door.













Installation blade

- Installation of door blade part 1
- Place bottom section and frame/tool in door opening.
- Mount bottom brackets with cables and mount rollers in side hinges.
- Stack all sections of door in correct position against frame/tool and mount rollers.





































Installation blade

- Installation of door blade part 2
- Fix screws of intermediate hinges and upper leafs of side hinges and take away frame/tool.















Pass door sections

- Fix caps to alu profiles making sure there is no burr between cap and profile.
- Position profiles with cap on panel and place section in frame/tool to align correctly. Fix position by clamps and assemble alu profiles / end caps with rivets.
- For bottom section important to reinforce corners by riveting angle brackets over corner of alu profiles.
- Slide and fix bottom seal in separate alu retainer and rivet to bottom section of pass door.
- For top section it is important to reinforce corners by riveting angle brackets over corner of alu profiles.

























Pass door sections

- Installation of pass door sections
- Mount 2 middle section by connecting screw of hinge blades.
- Place filling plates and lock 2 sections before to fix screws of intermediate hinges.
- Make sure seal between panels is not hindering a proper stacking and positioning of sections.
- Mount bottom and top section of pass door in similar way.

























The result!

- Result of the installation











Alternative

- Alternative straight cutting of low threshold in pass door opening.
- Cutting out a square on inside of bottom pass door casing profile gives a good connection in case of an easy straight cut of low threshold profile.





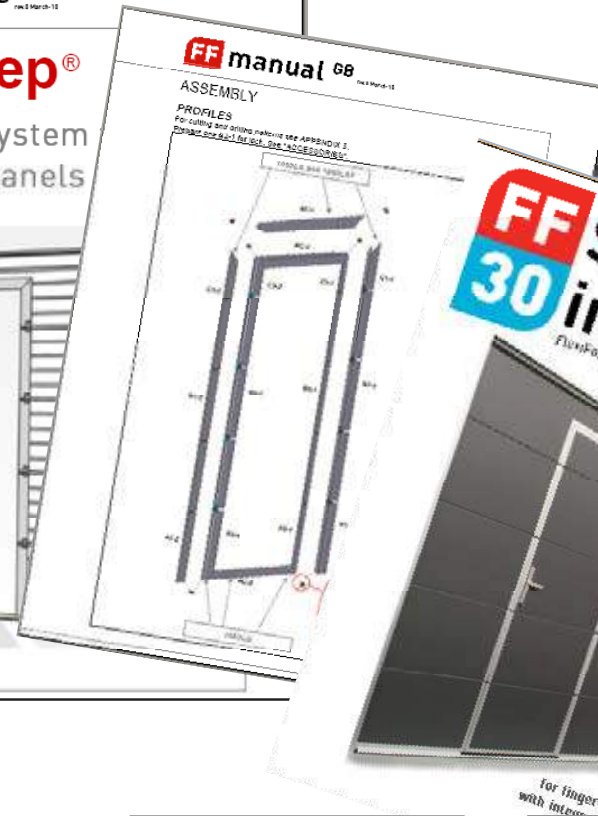








More information:





Happy installing!

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