

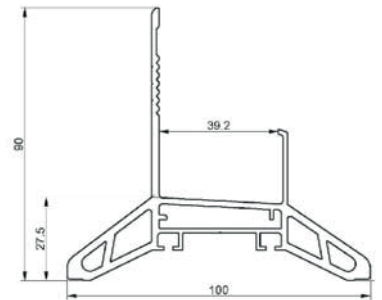
FF Addition information

SafeStep Manual

1

If treshold profile 1041L is used:

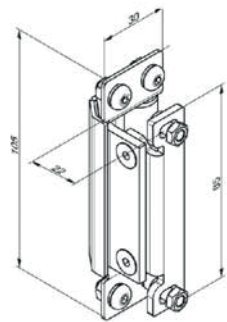
- Length: B1-2mm from bottom
- Length: B2-2mm from bottom
- Length: B3-2mm from bottom
- Length: B4-2mm from bottom



2

If hinge 1034HI is used:

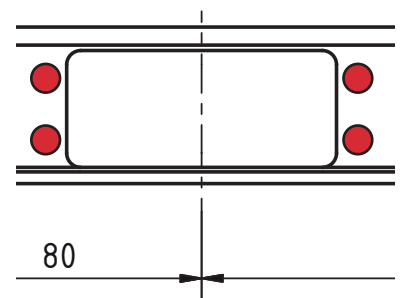
- Length: B5+3mm
- Length: B7+3mm
- Length: T5+3mm
- Length: L5+3mm

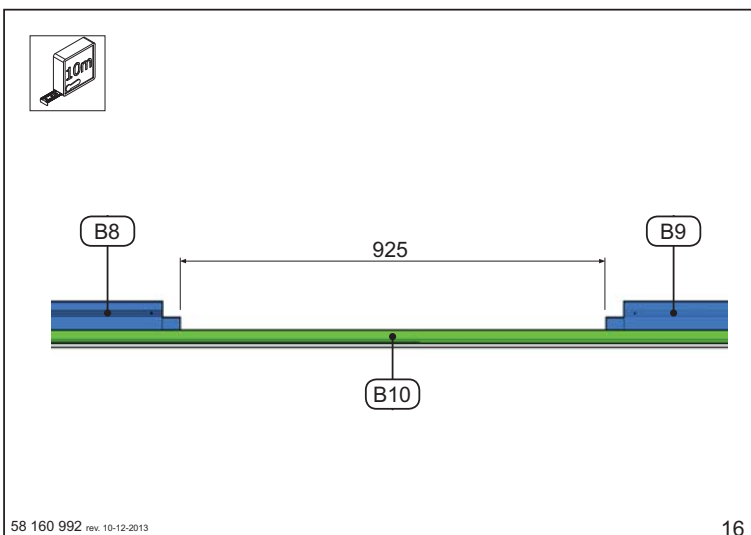
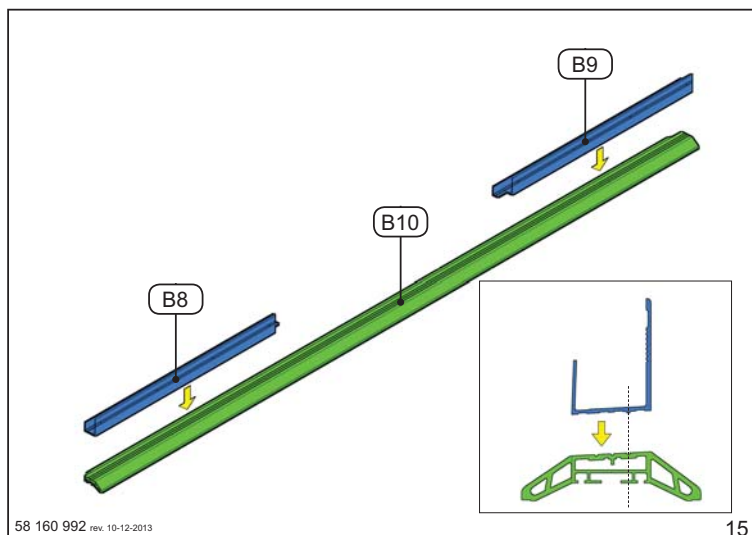
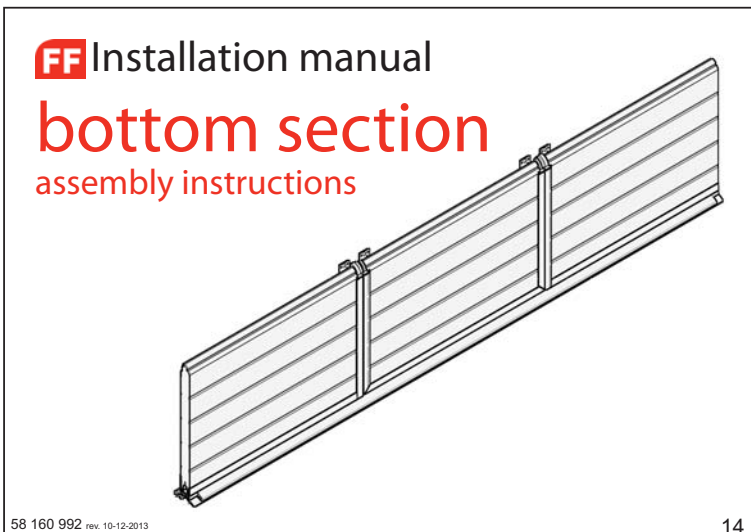
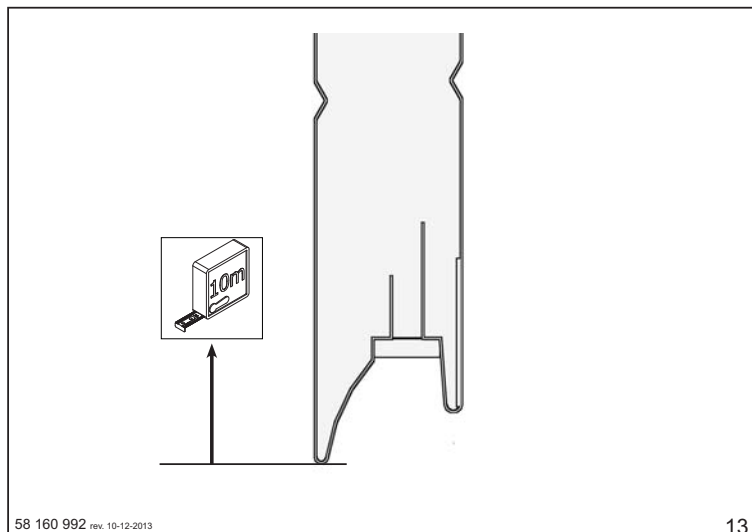
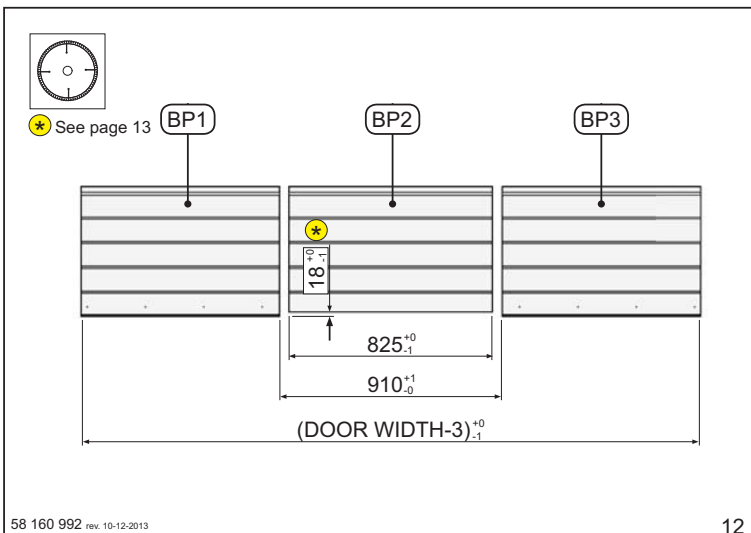
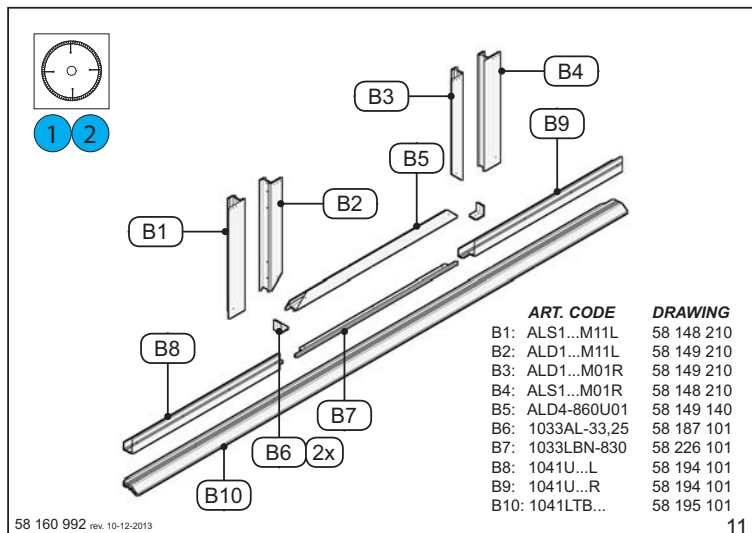
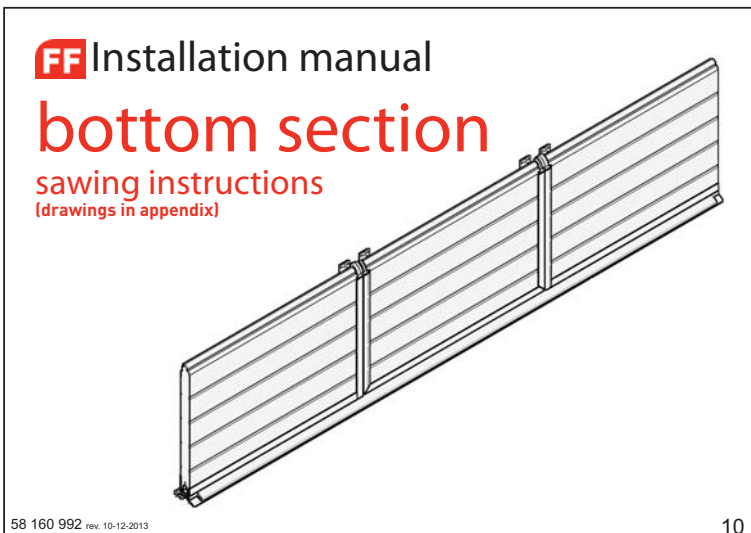
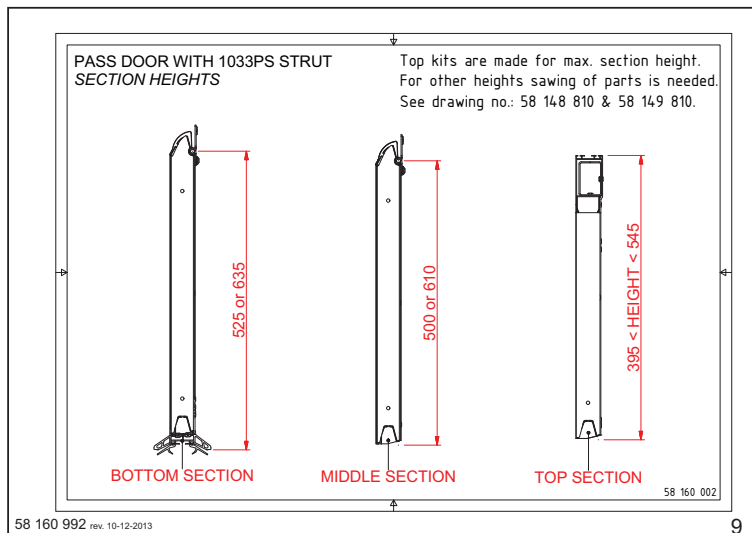


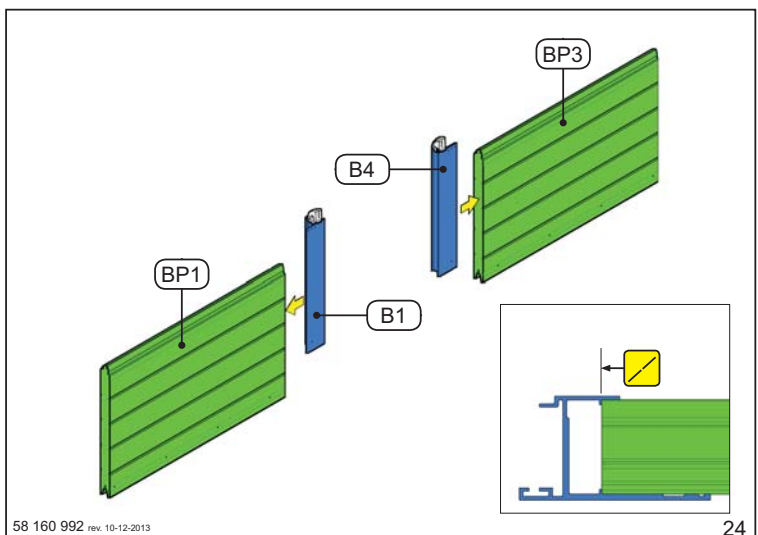
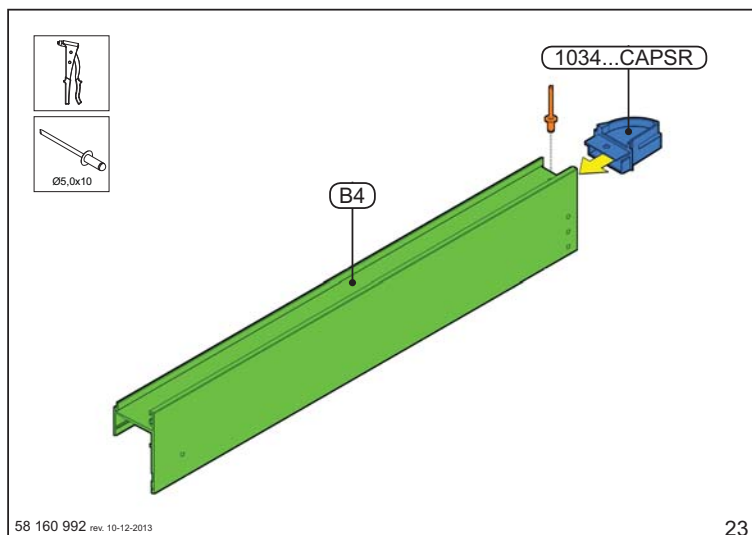
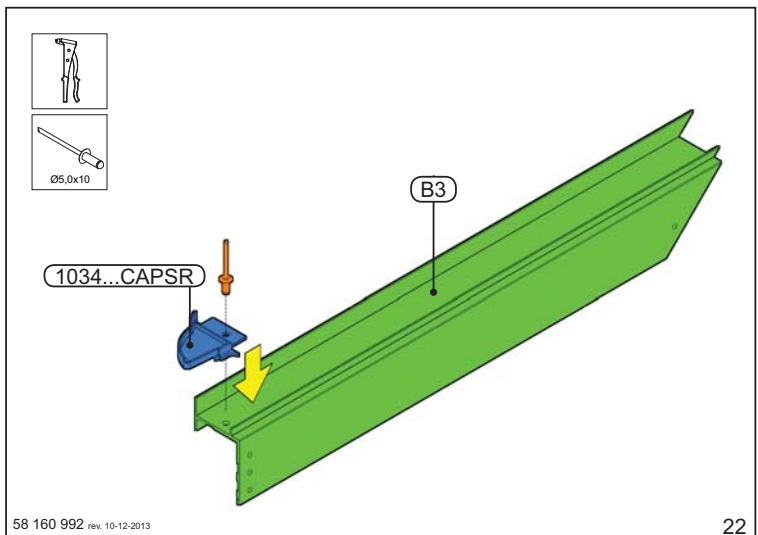
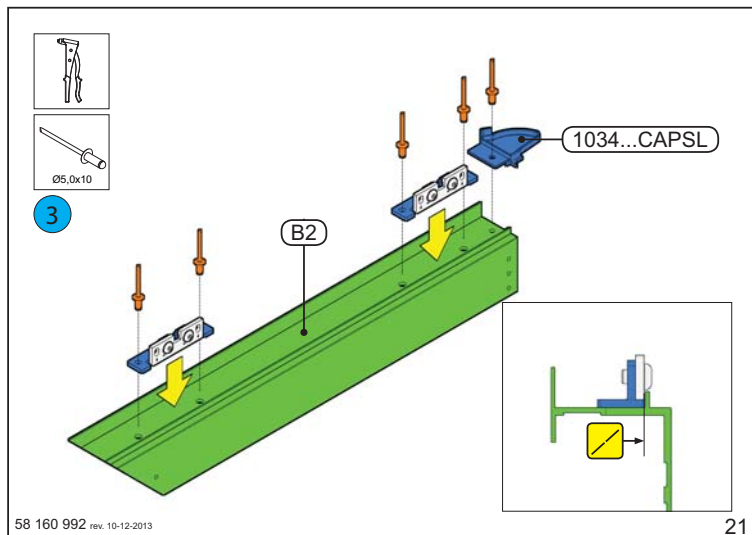
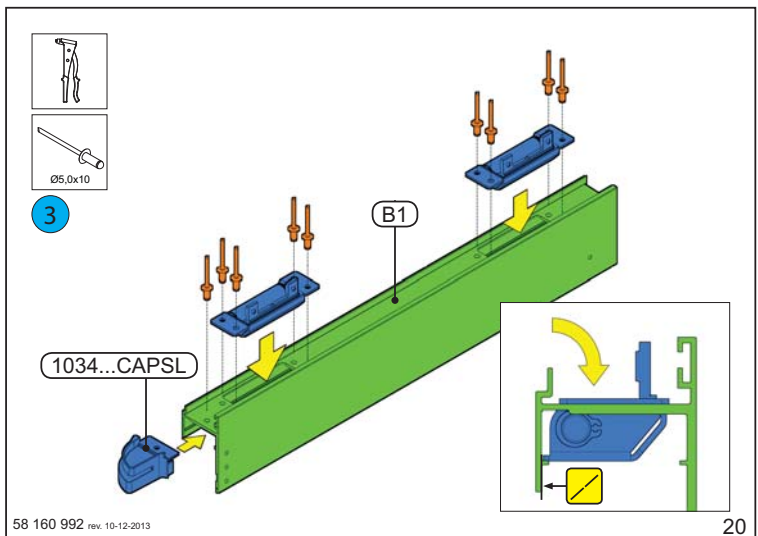
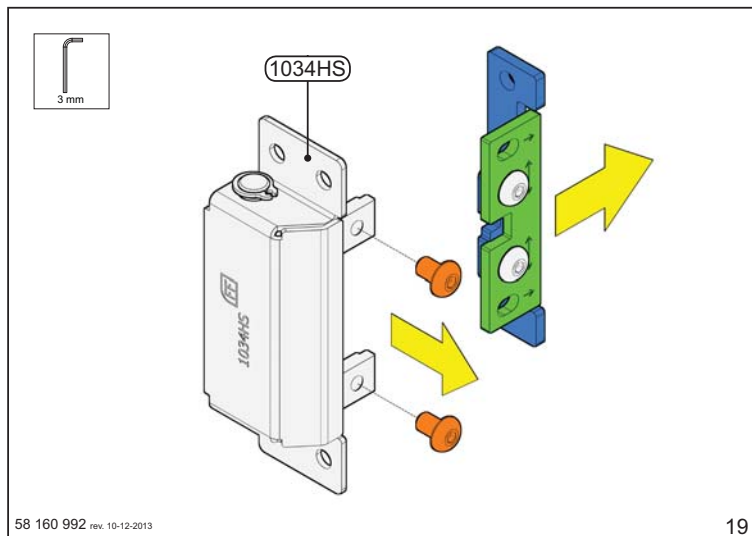
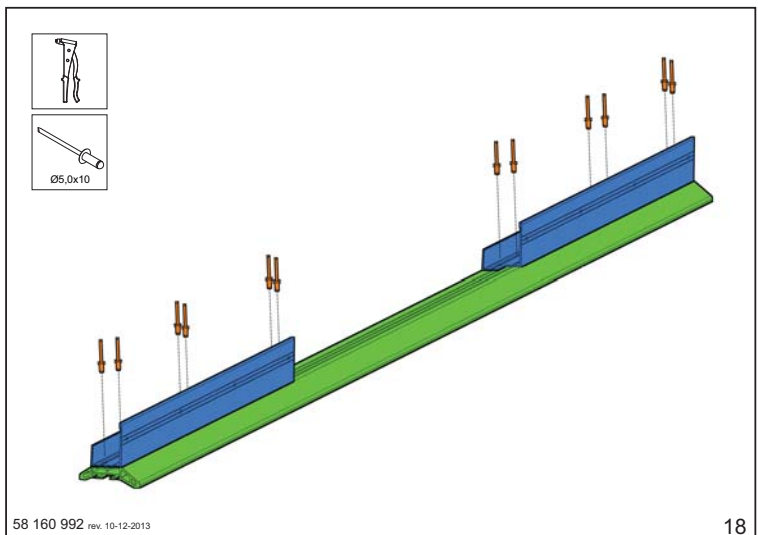
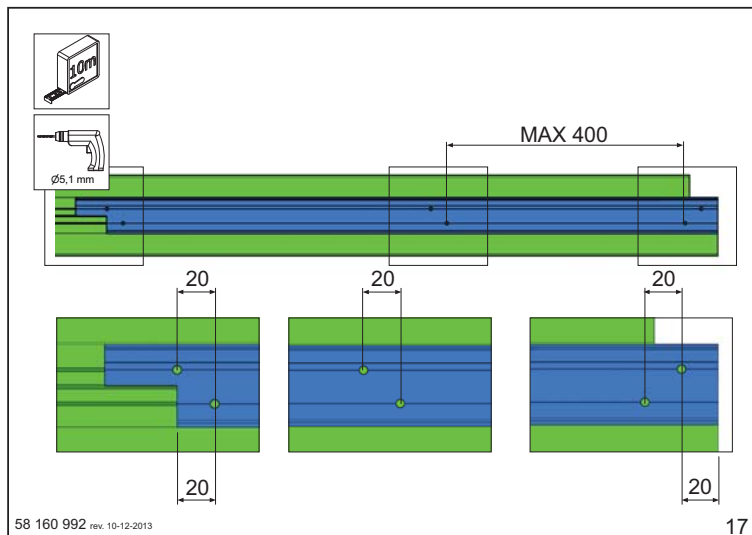
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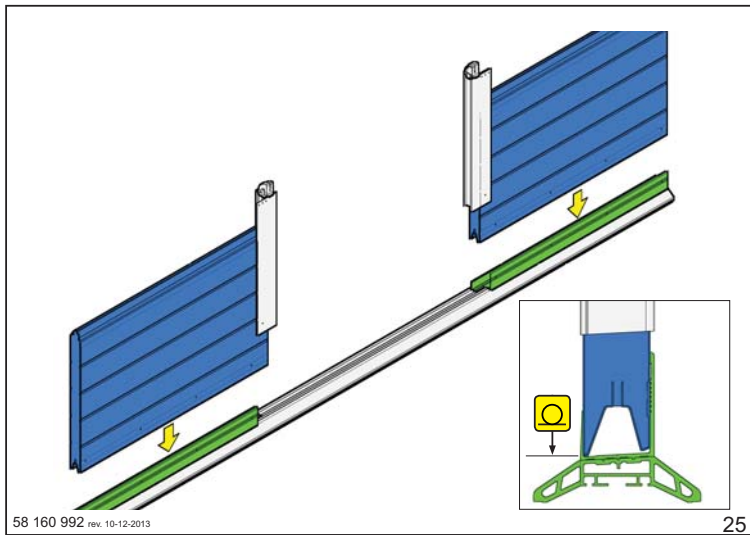
If round indicated holes are Ø6,5:

- Use M5 bolts & nuts to place hinge

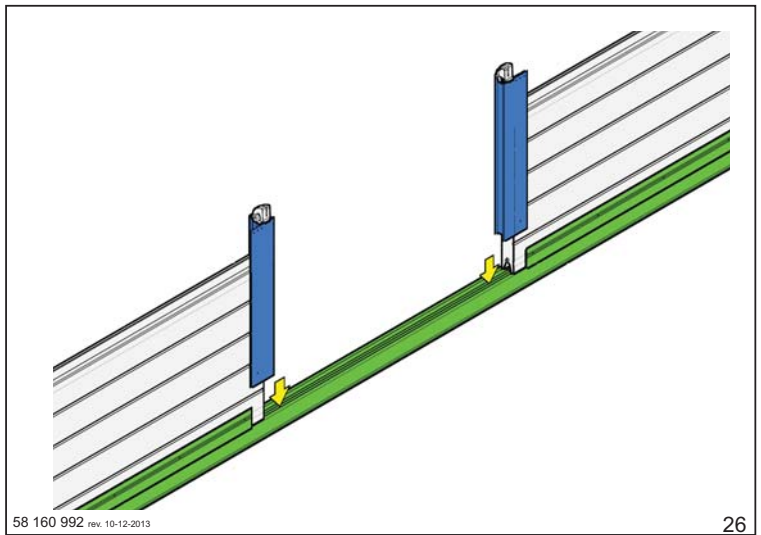




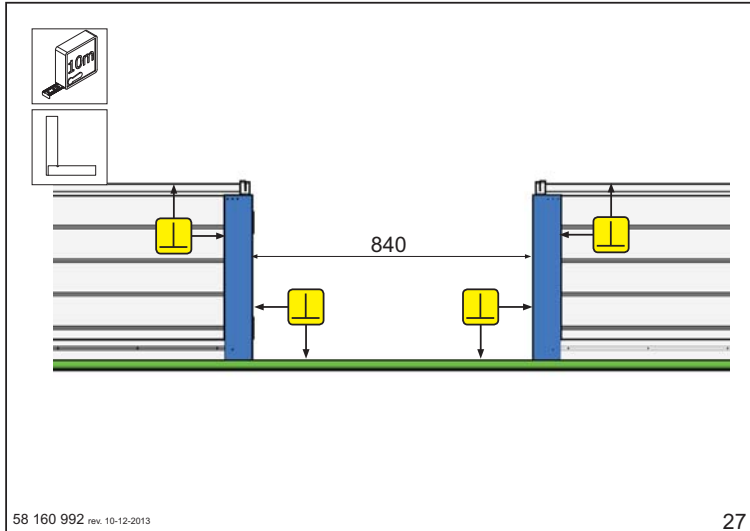




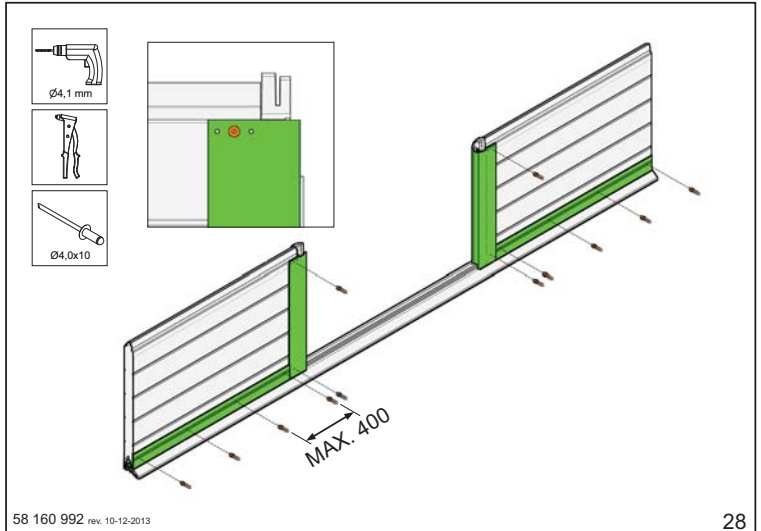
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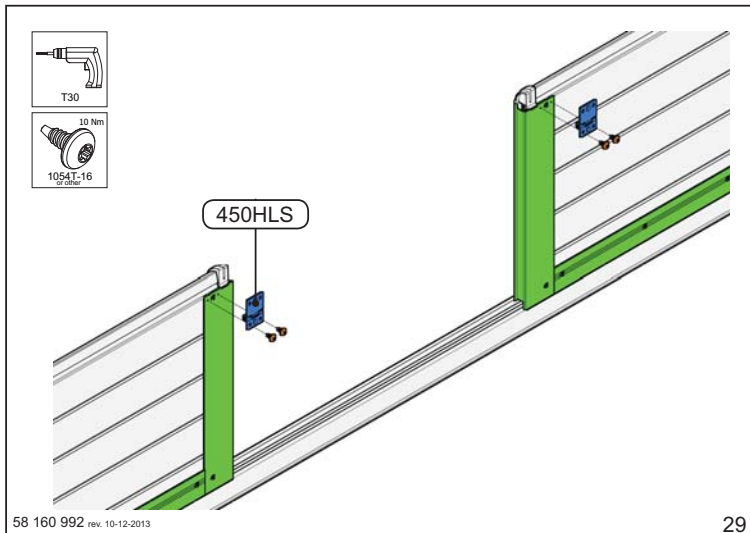
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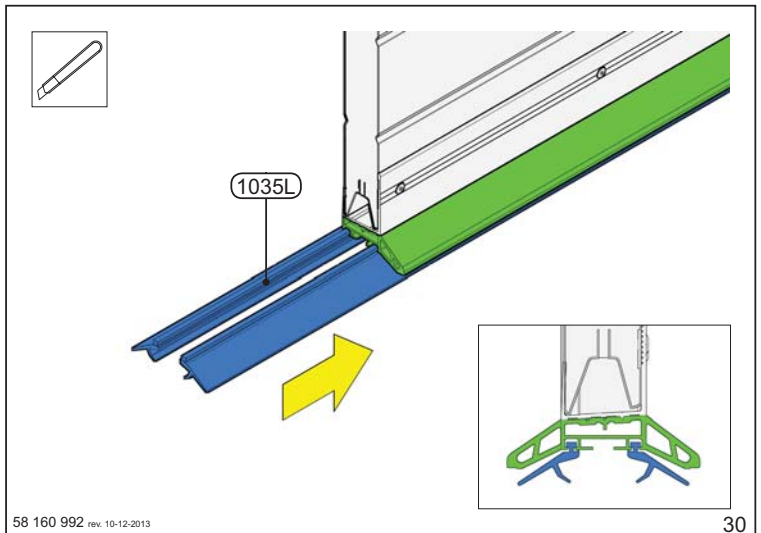
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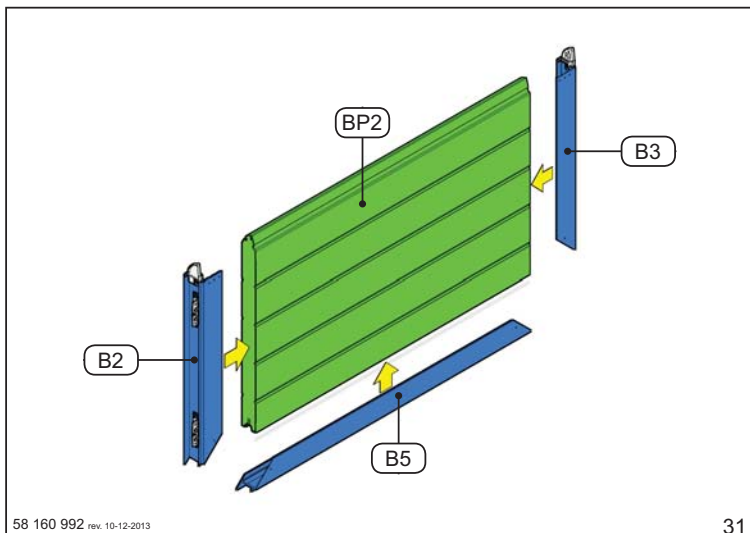
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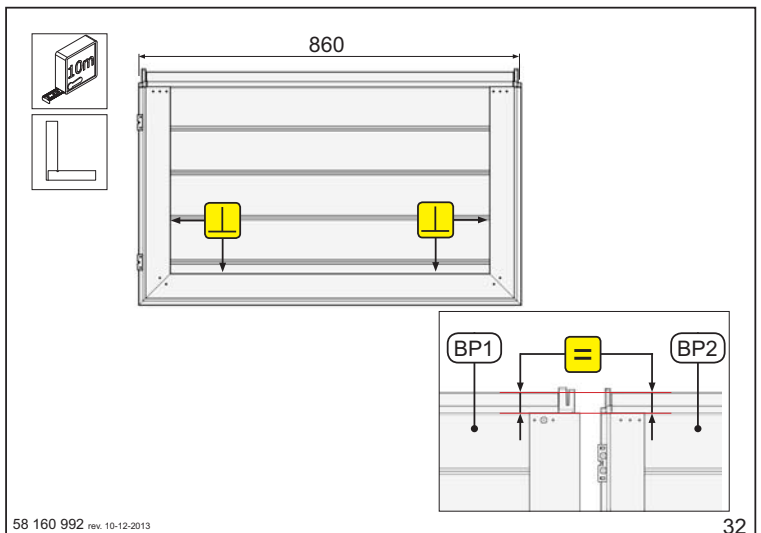
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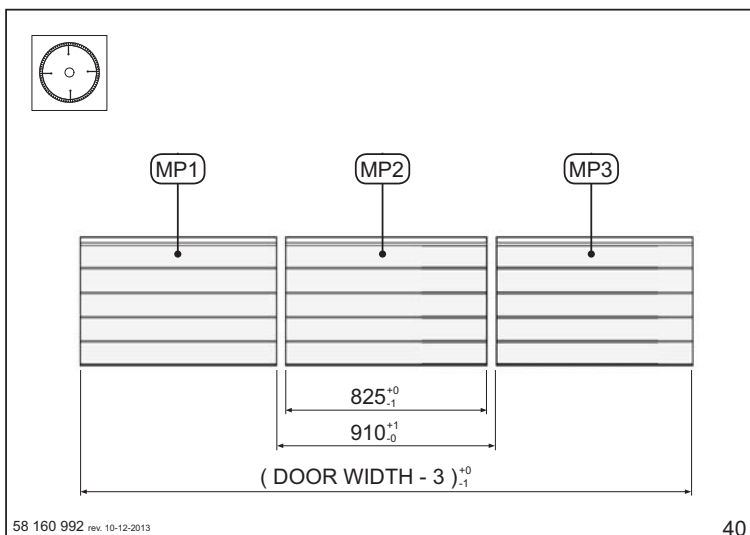
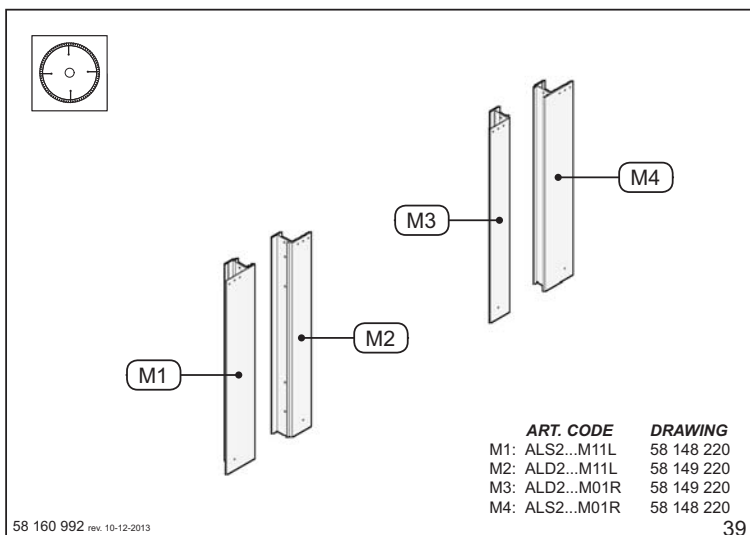
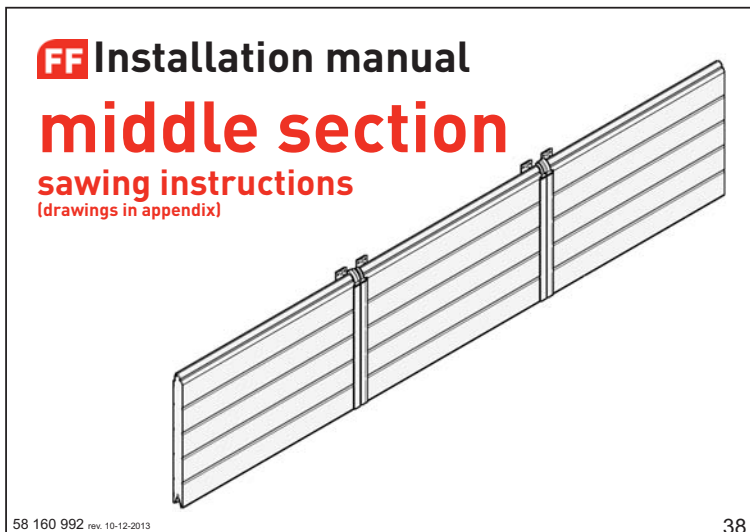
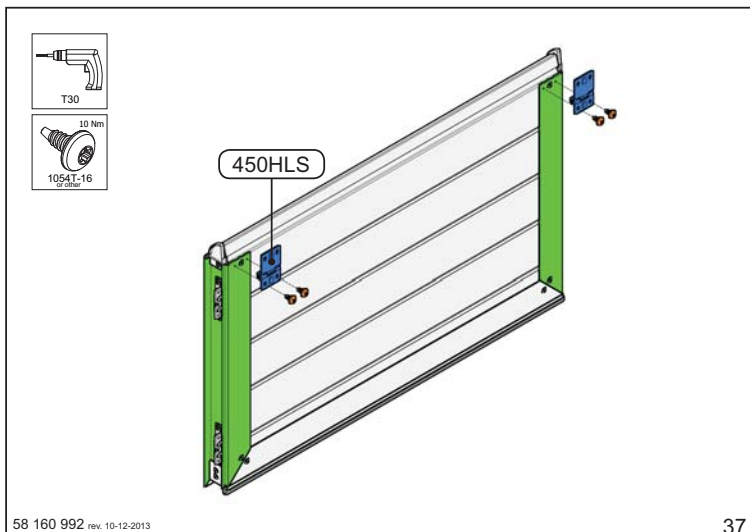
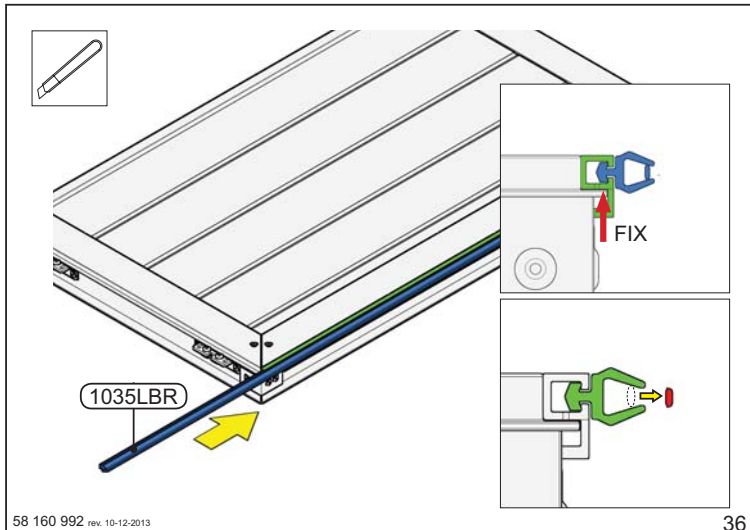
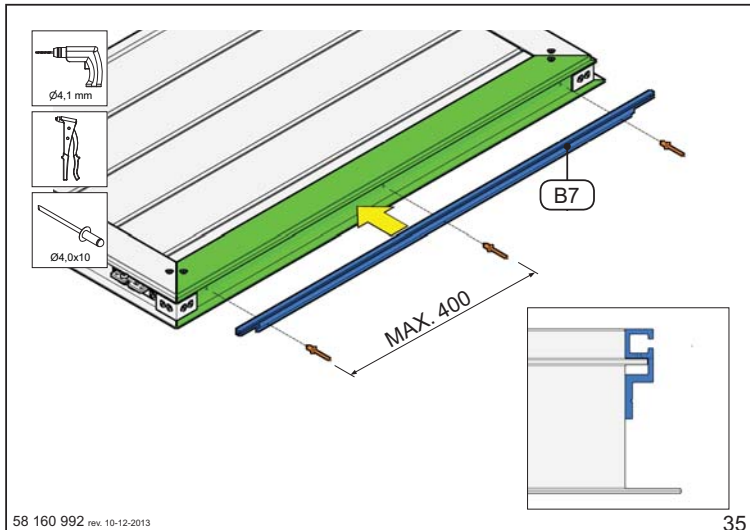
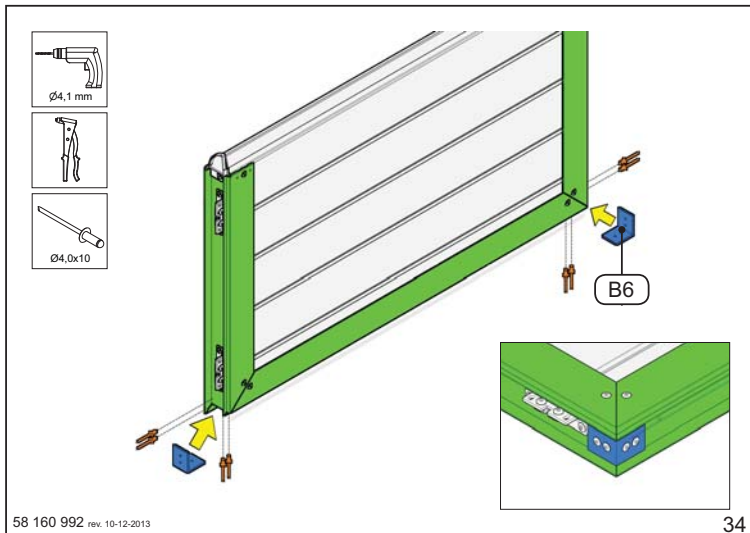
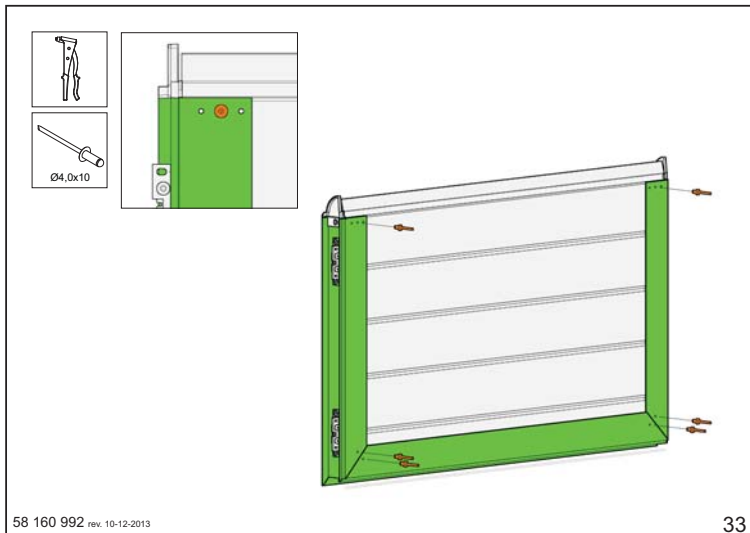
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31



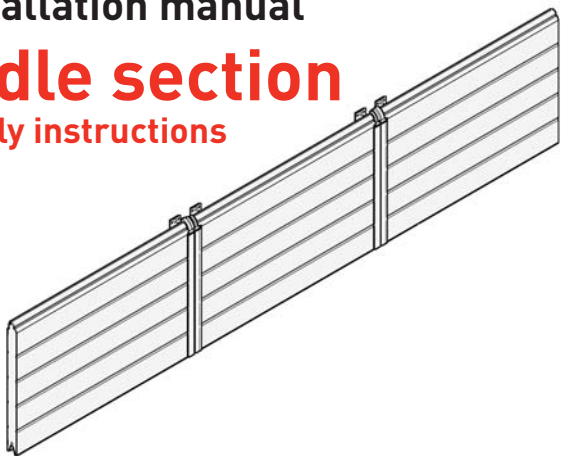
32



FF Installation manual

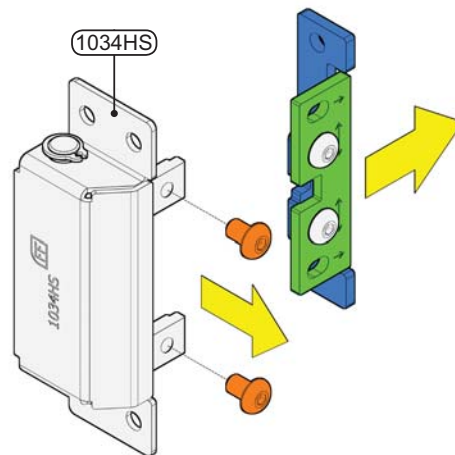
middle section

assembly instructions



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41

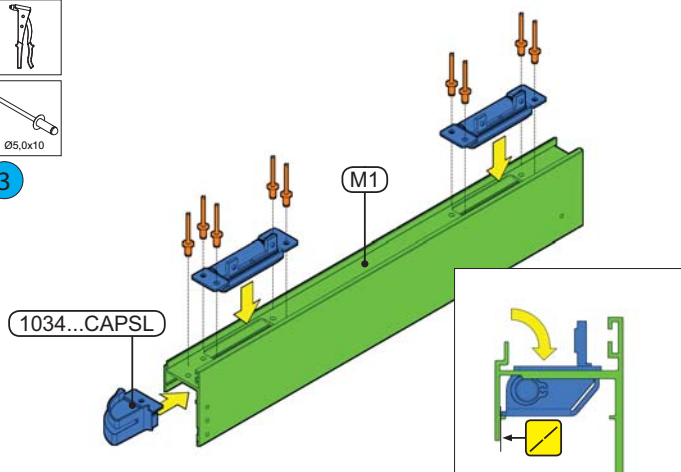


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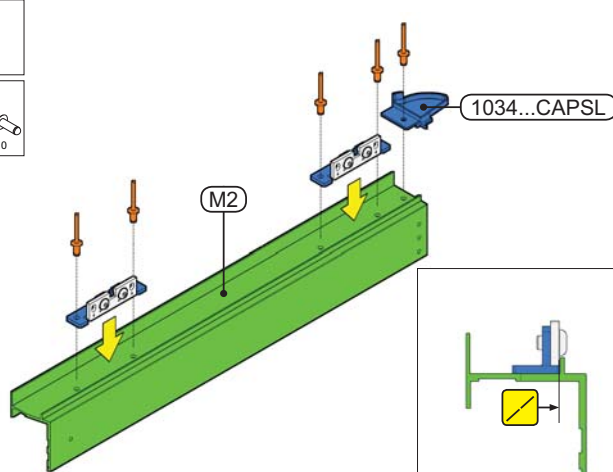


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43



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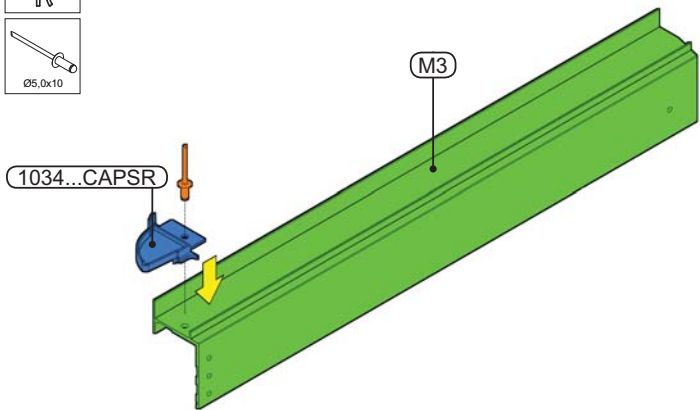


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44



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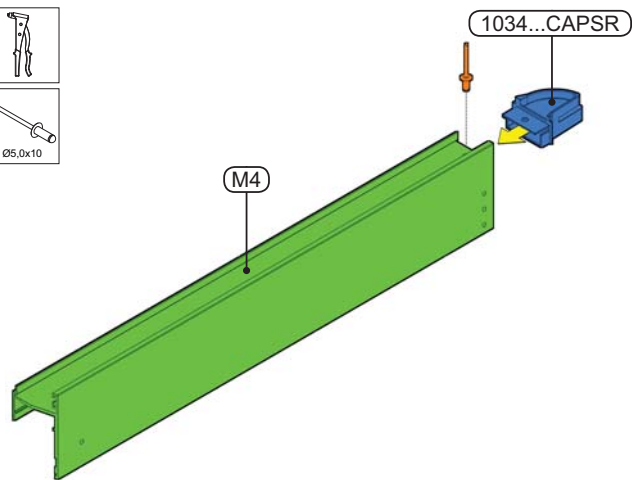


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45

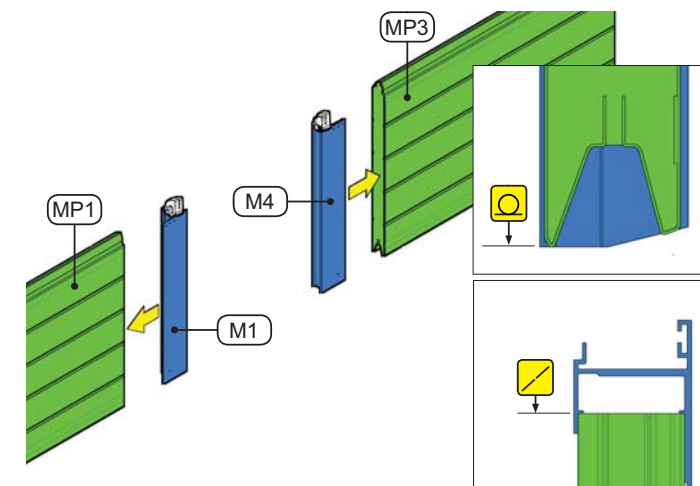


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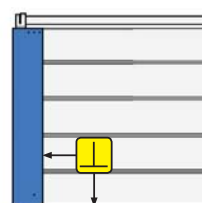
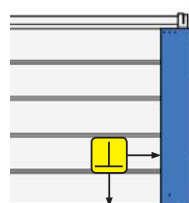
58 160 992 rev. 10-12-2013

46



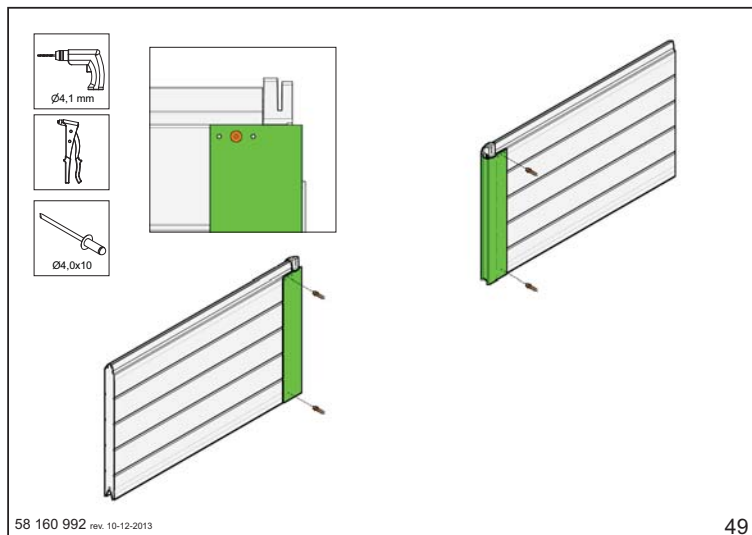
58 160 992 rev. 10-12-2013

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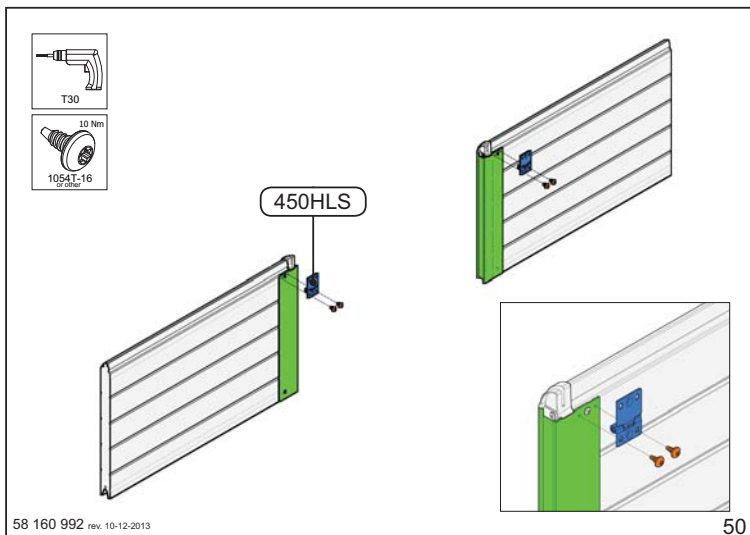


58 160 992 rev. 10-12-2013

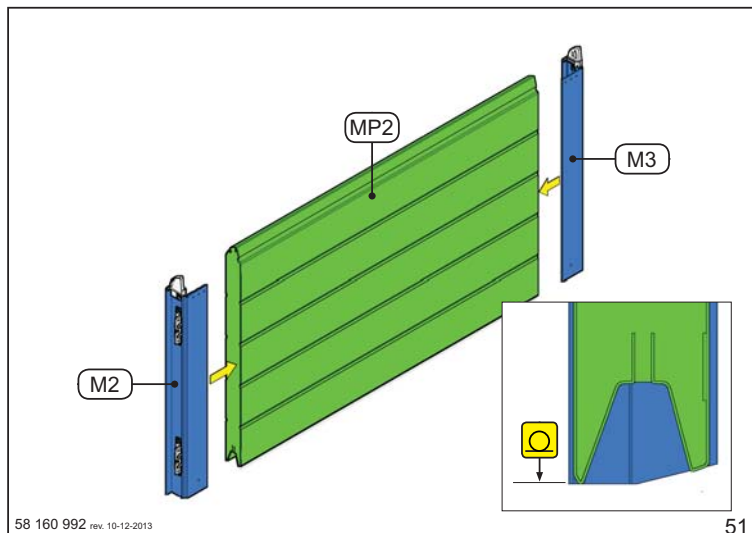
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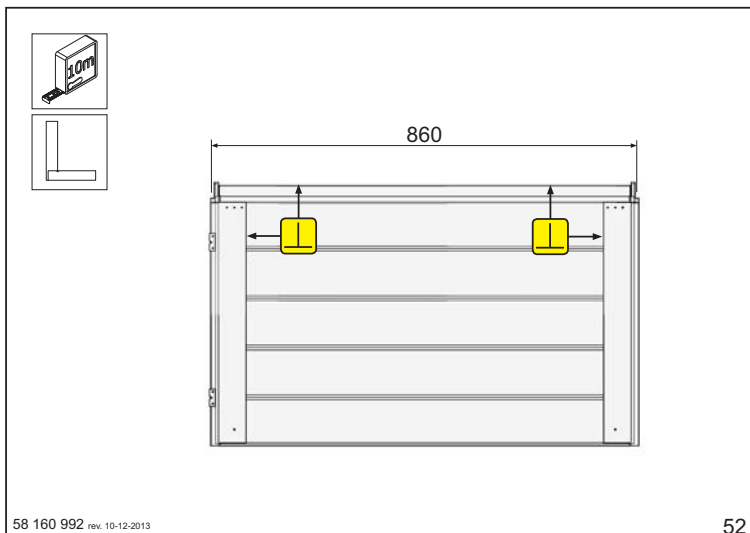
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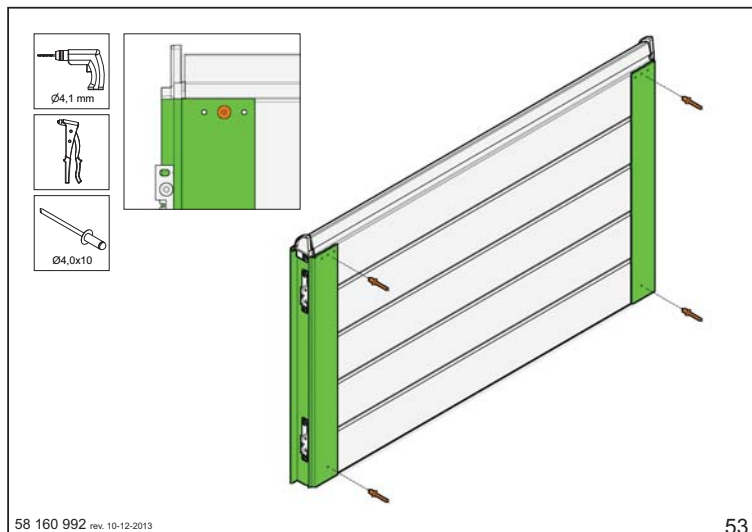
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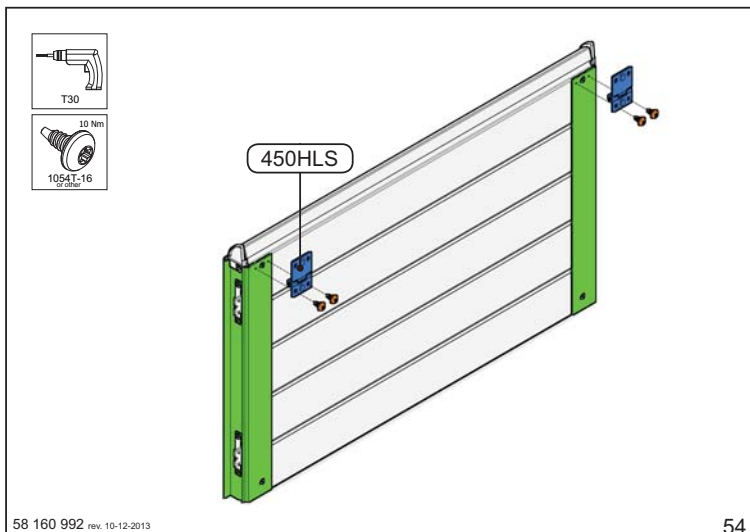
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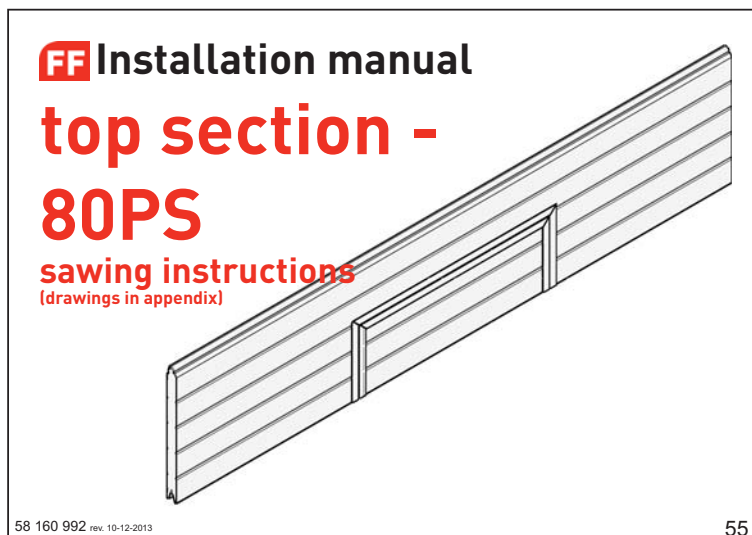
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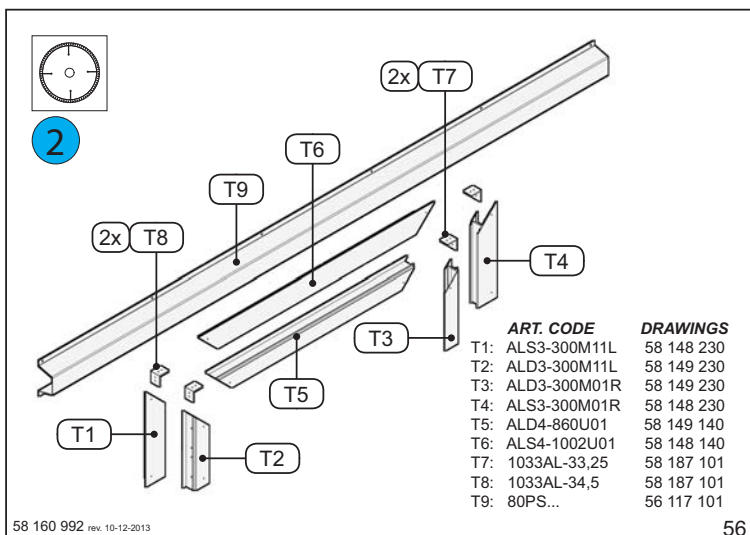
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54

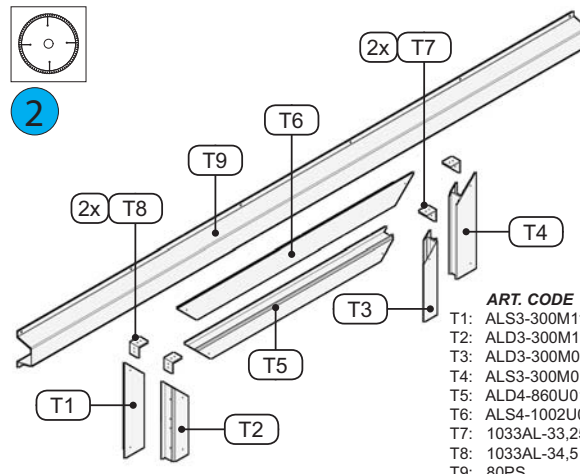
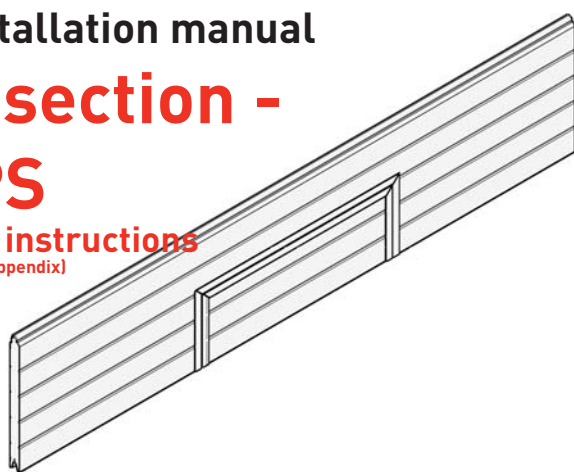


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56

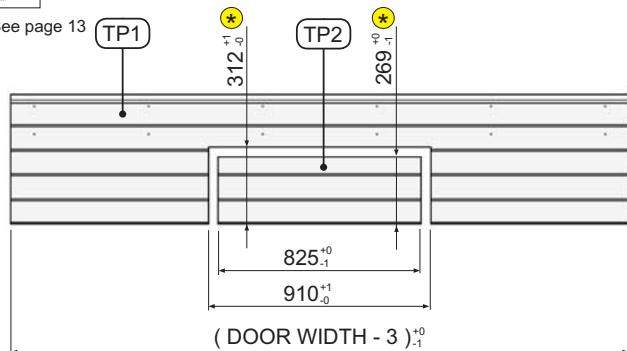
FF Installation manual **top section -** **80PS** sawing instructions (drawings in appendix)



ART. CODE	DRAWINGS
T1: ALS3-300M11L	58 148 230
T2: ALD3-300M11L	58 149 230
T3: ALD3-300M01R	58 149 230
T4: ALS3-300M01R	58 148 230
T5: ALD4-860U01	58 149 140
T6: ALS4-1002U01	58 148 140
T7: 1033AL-33,25	58 187 101
T8: 1033AL-34,5	58 187 101
T9: 80PS...	56 117 101



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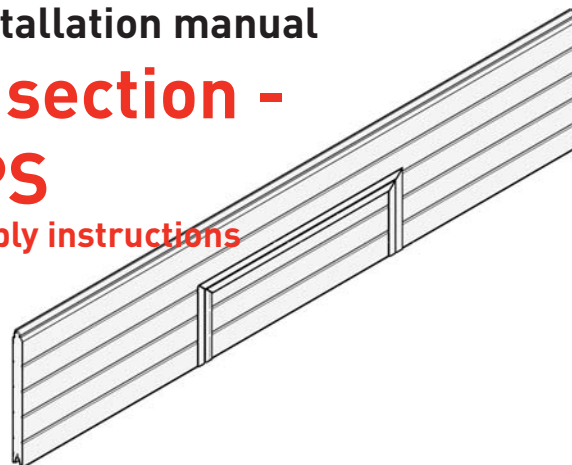
57

FF Installation manual

top section -

80PS

assembly instructions

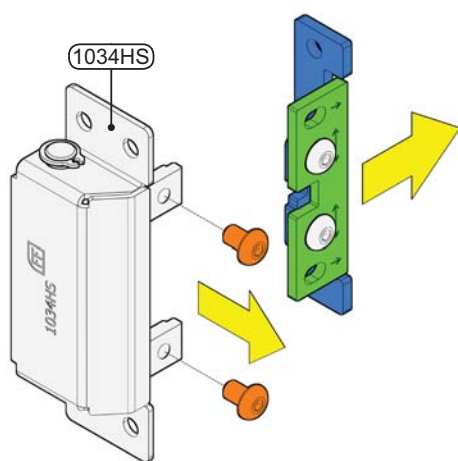


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3 mm



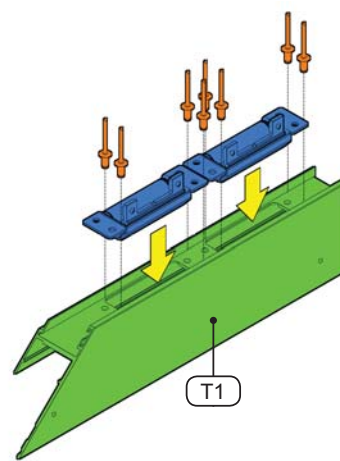
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Ø5,0x10

3



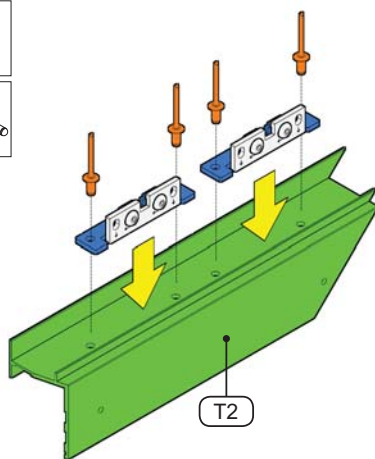
58 160 992 rev. 10-12-2013

60



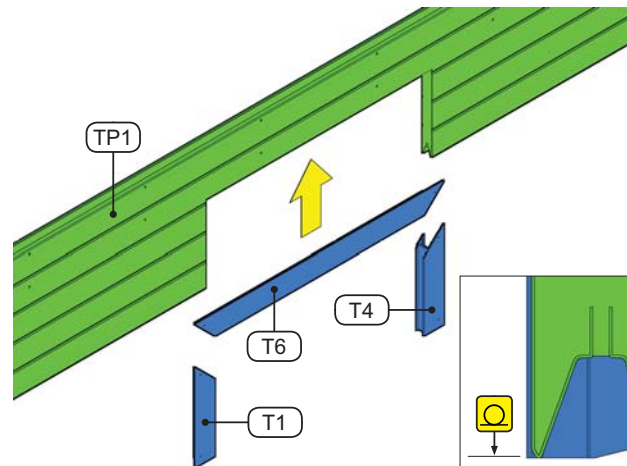
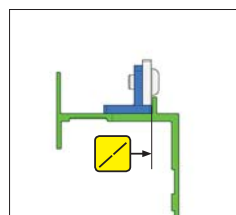
Ø5,0x10

3



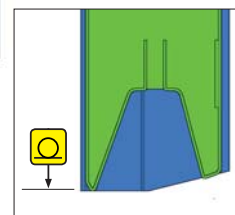
58 160 992 rev. 10-12-2013

61

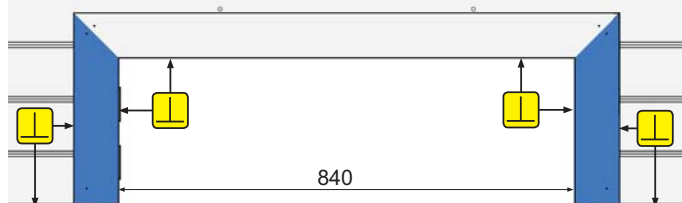


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62



10 mm



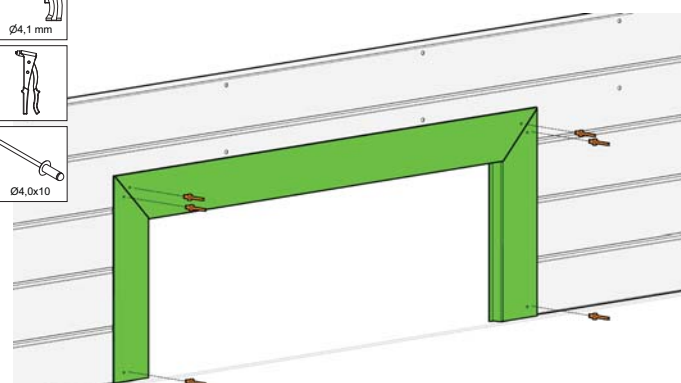
58 160 992 rev. 10-12-2013

63



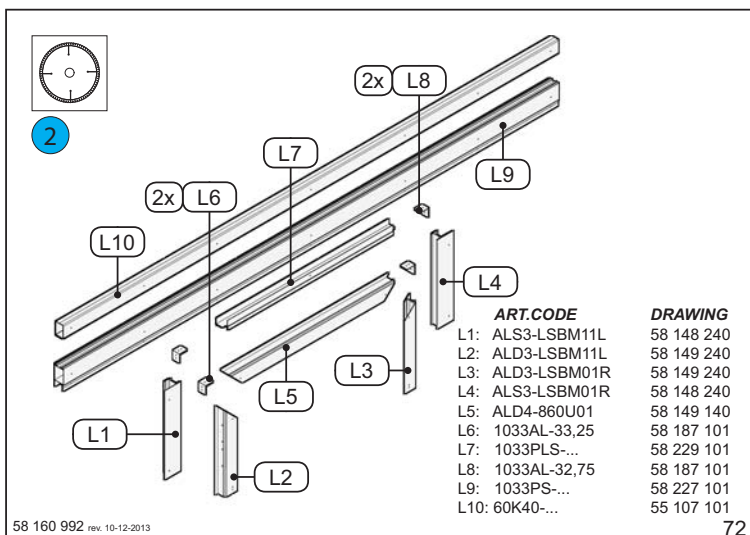
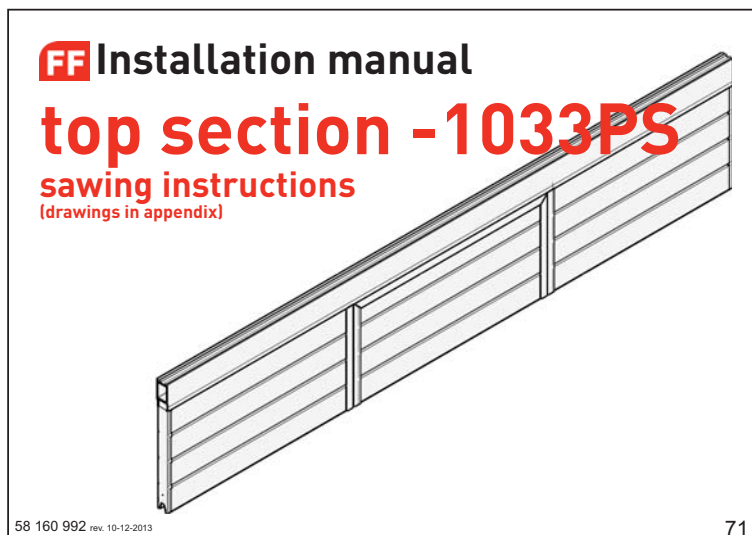
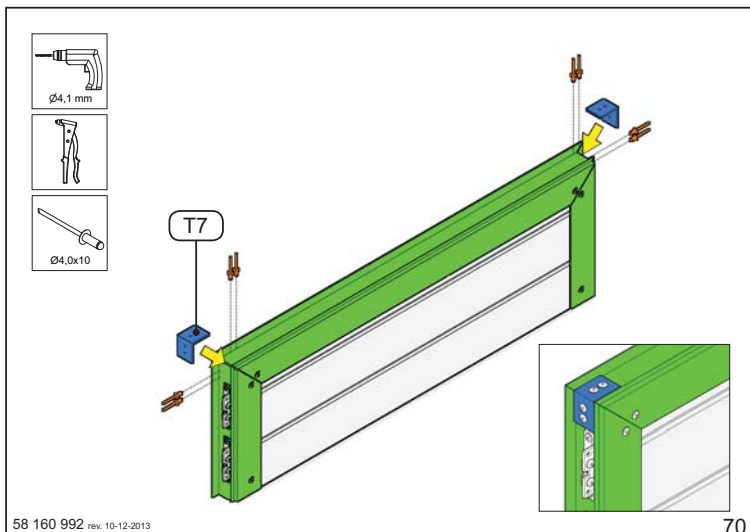
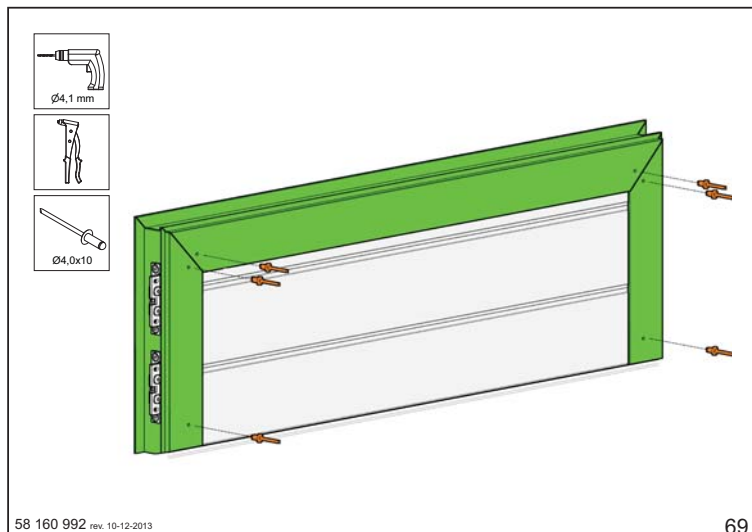
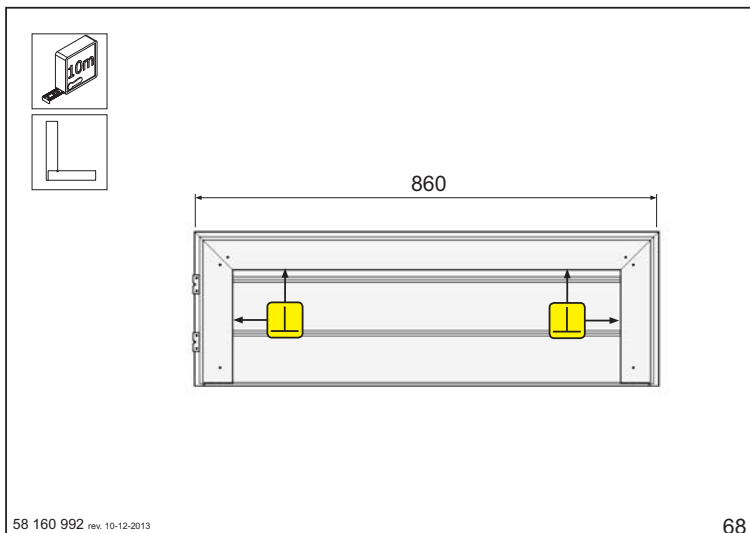
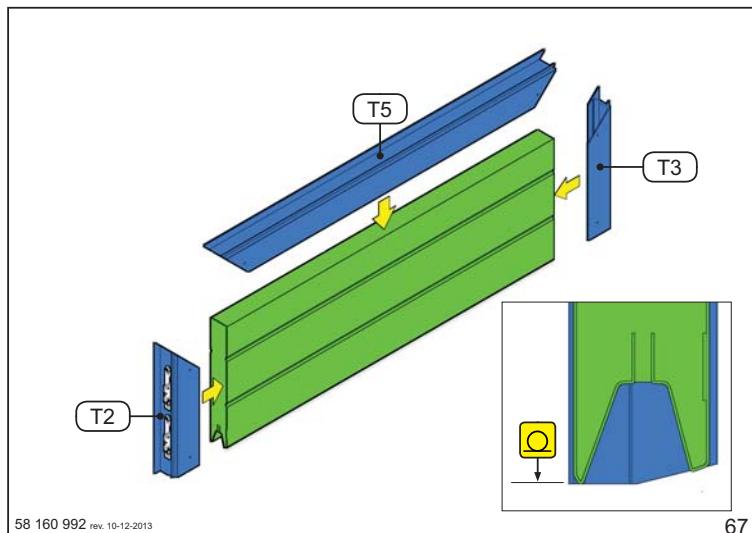
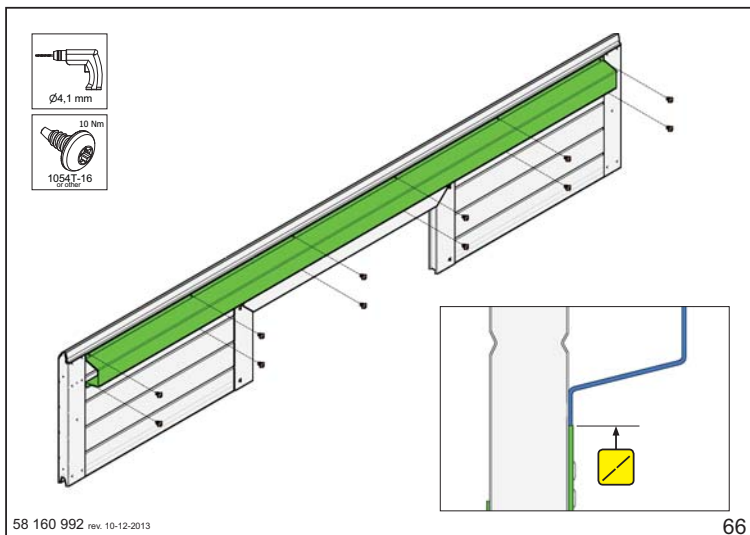
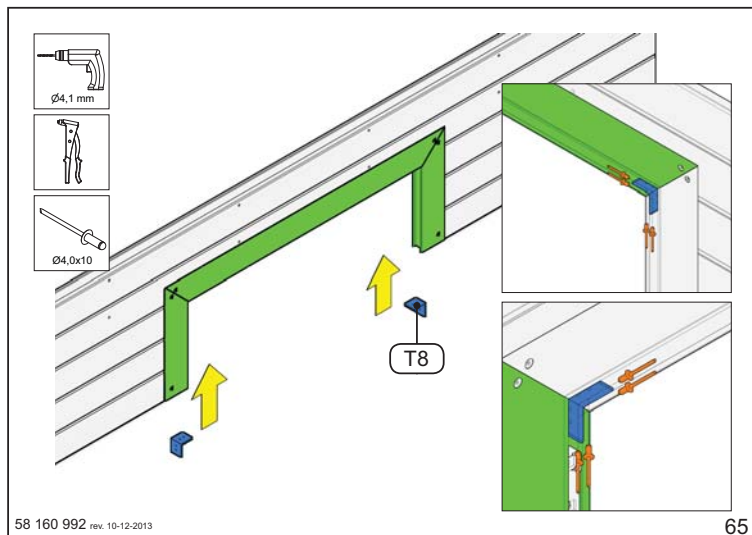
Ø4,1 mm

Ø4,0x10

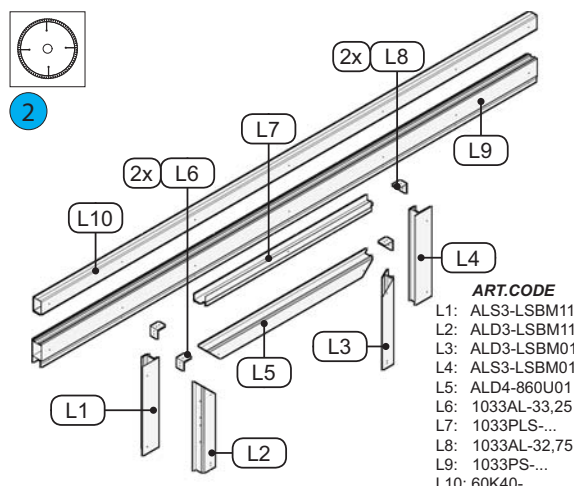
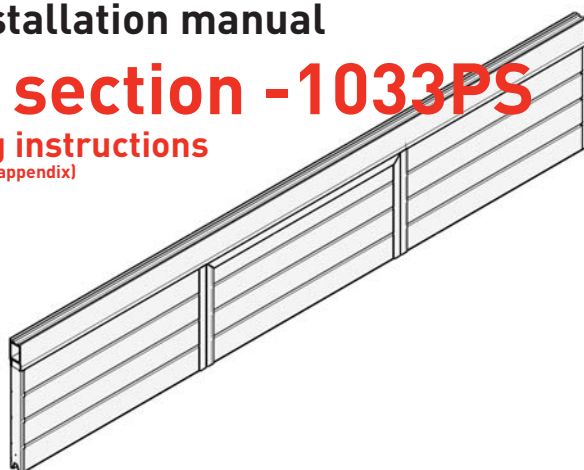


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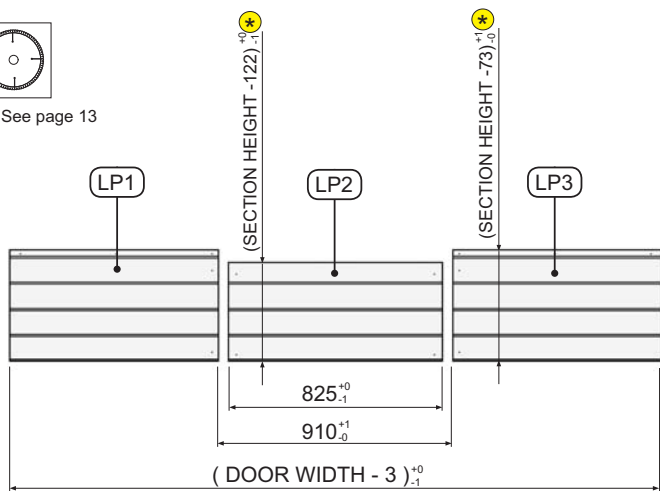
FF Installation manual **top section -1033PS** sawing instructions (drawings in appendix)



ART.CODE	DRAWING
L1: ALS3-LSBM11L	58 148 240
L2: ALD3-LSBM11L	58 149 240
L3: ALD3-LSBM01R	58 149 240
L4: ALS3-LSBM01R	58 148 240
L5: ALD4-860U01	58 149 140
L6: 1033AL-33,25	58 187 101
L7: 1033PLS-...	58 229 101
L8: 1033AL-32,75	58 187 101
L9: 1033PS-...	58 227 101
L10: 60K40-...	55 107 101



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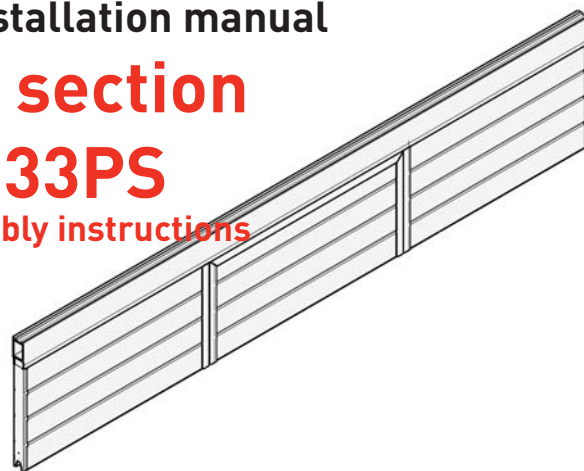
73

FF Installation manual

top section

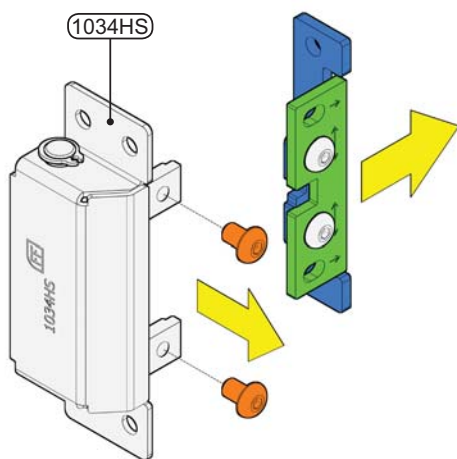
-1033PS

assembly instructions



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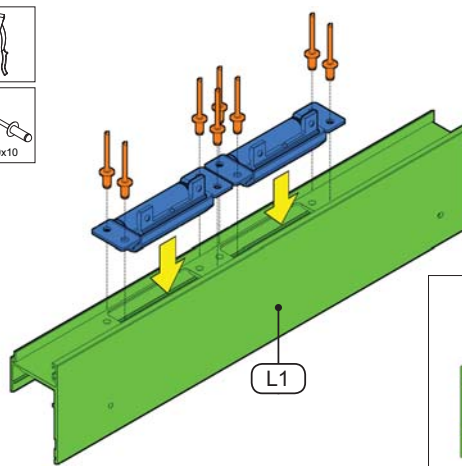


58 160 992 rev. 10-12-2013

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3

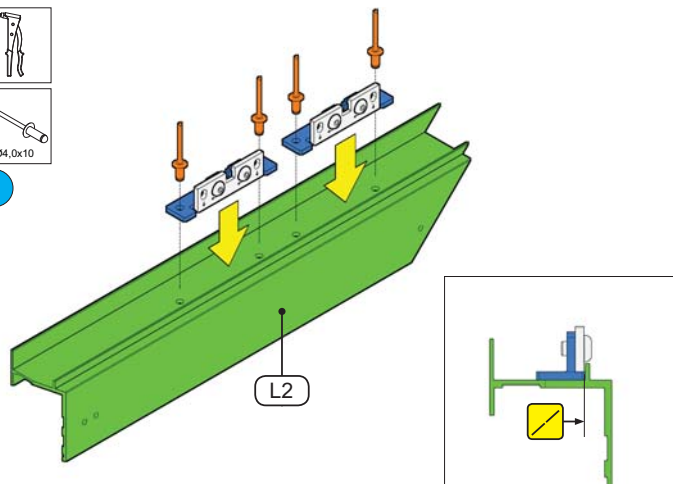


58 160 992 rev. 10-12-2013

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3

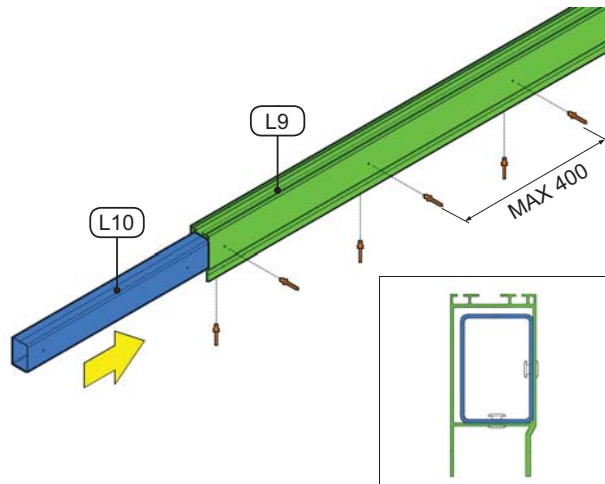


58 160 992 rev. 10-12-2013

77

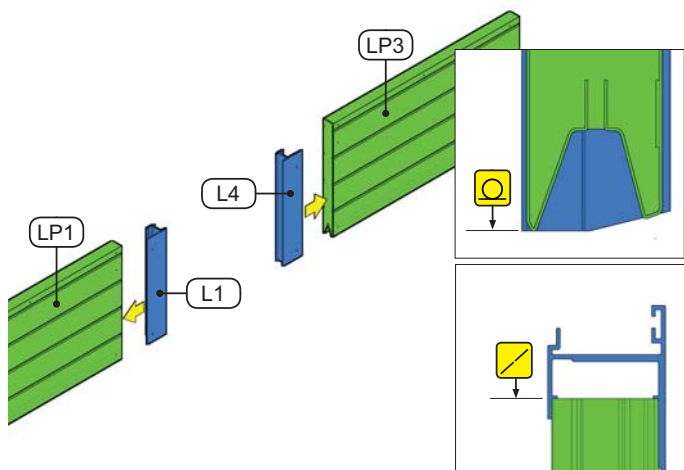


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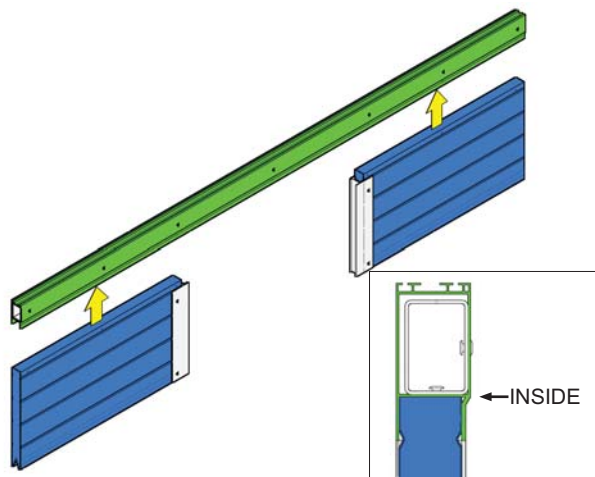
58 160 992 rev. 10-12-2013

78



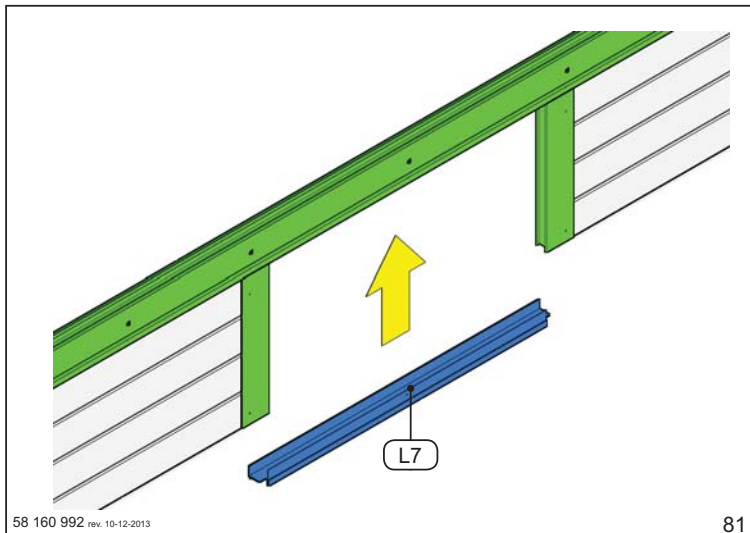
58 160 992 rev. 10-12-2013

79

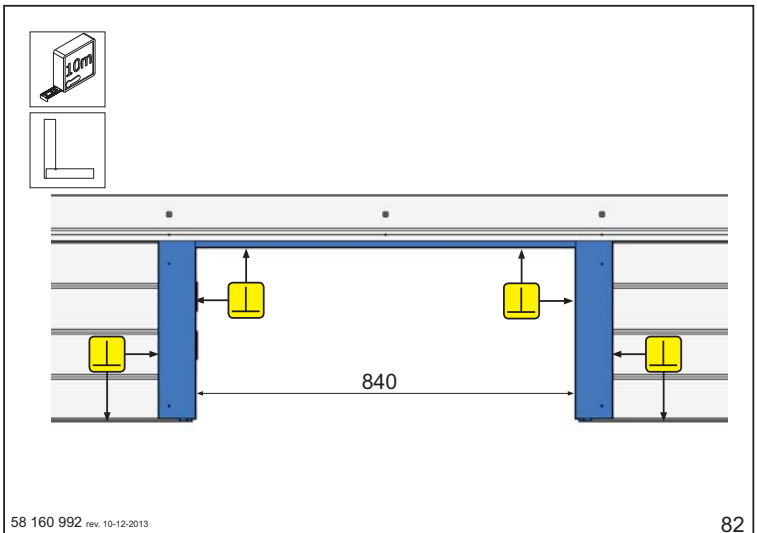


58 160 992 rev. 10-12-2013

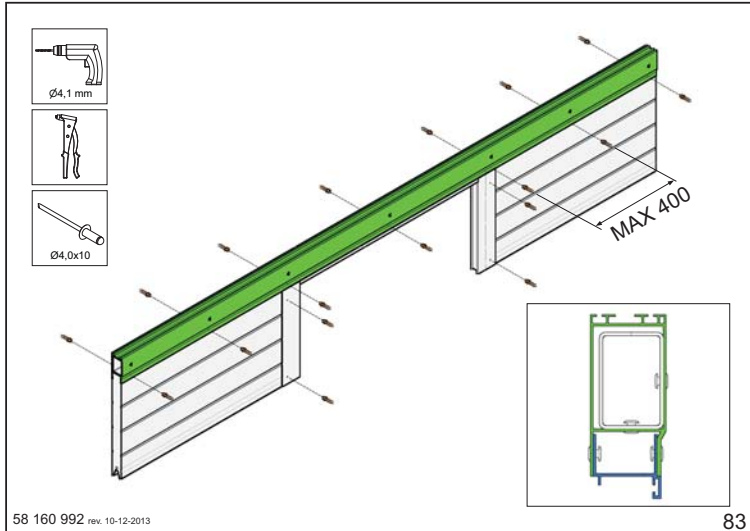
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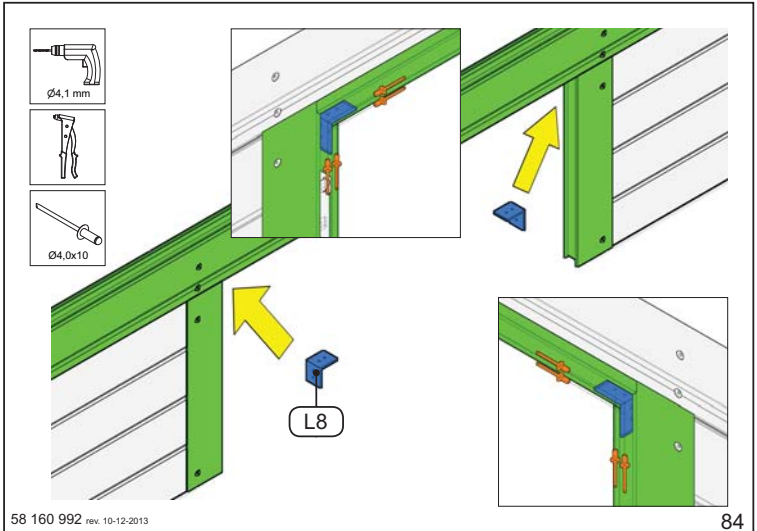
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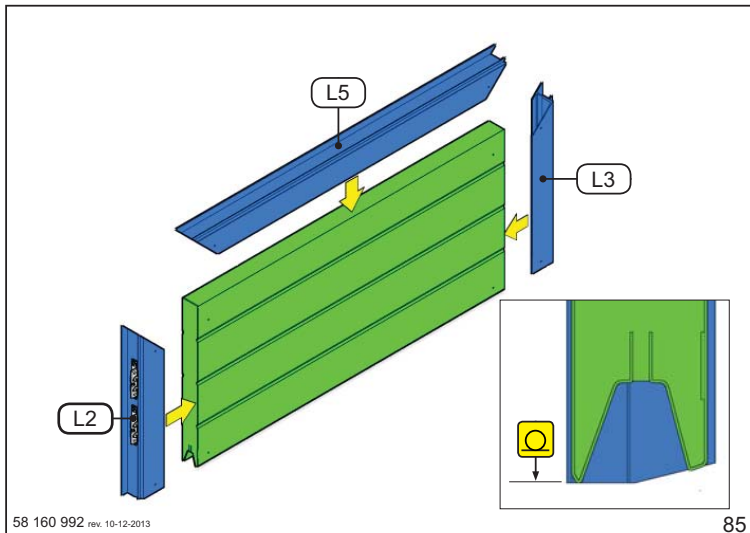
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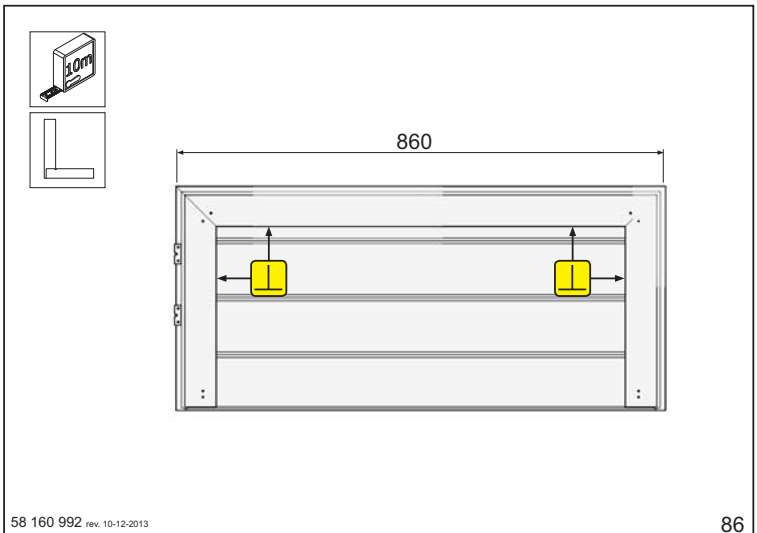
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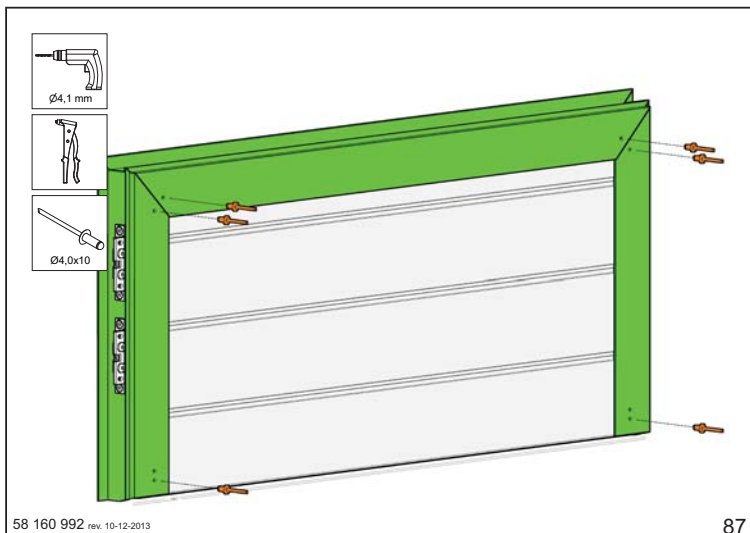
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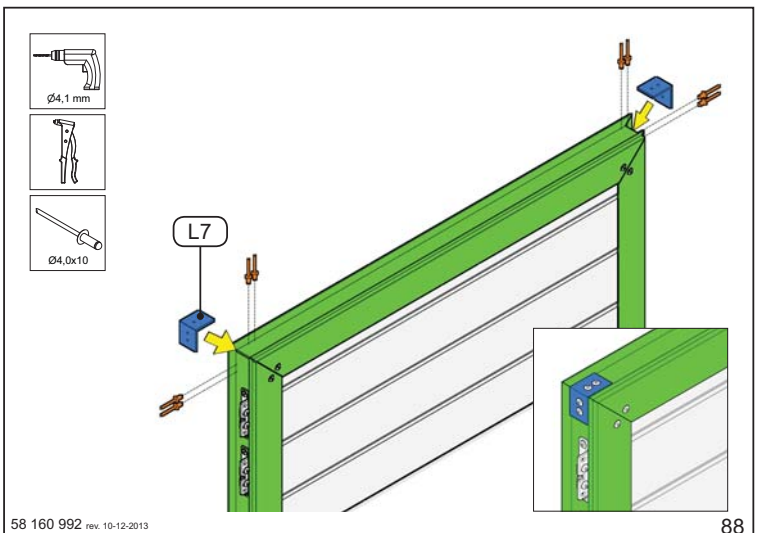
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86



87



88

FF Installation manual

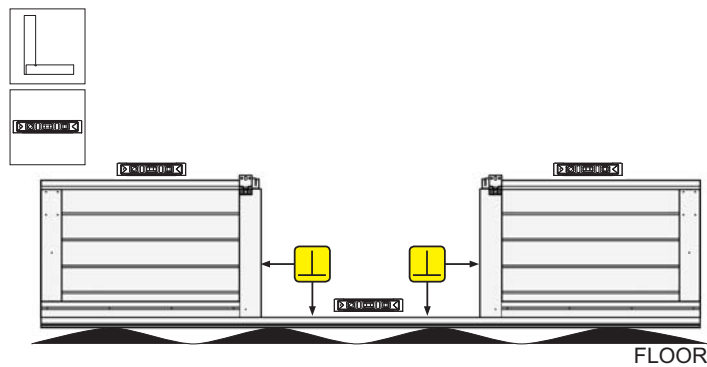
complete door

assembly instructions



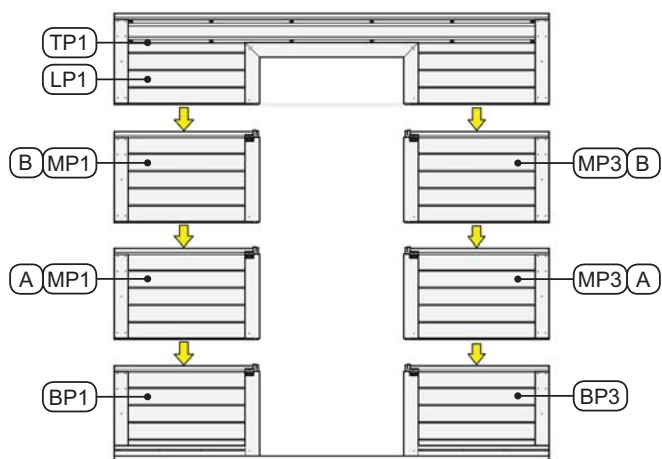
58 160 992 rev. 10-12-2013

89



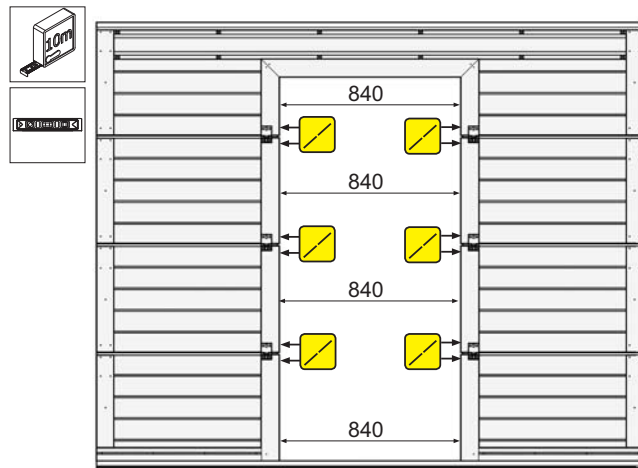
58 160 992 rev. 10-12-2013

90



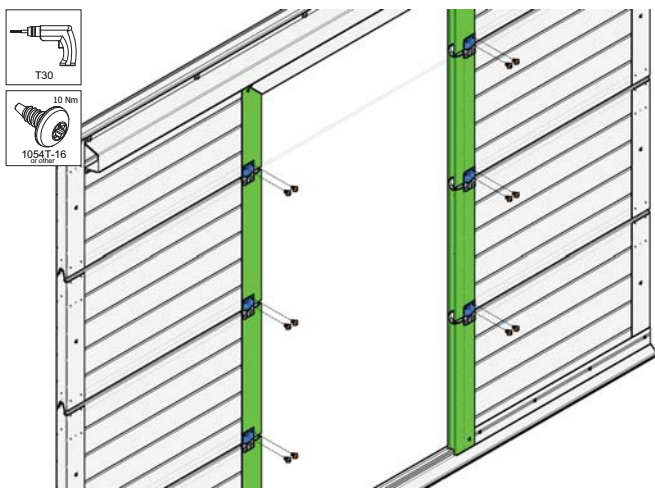
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91



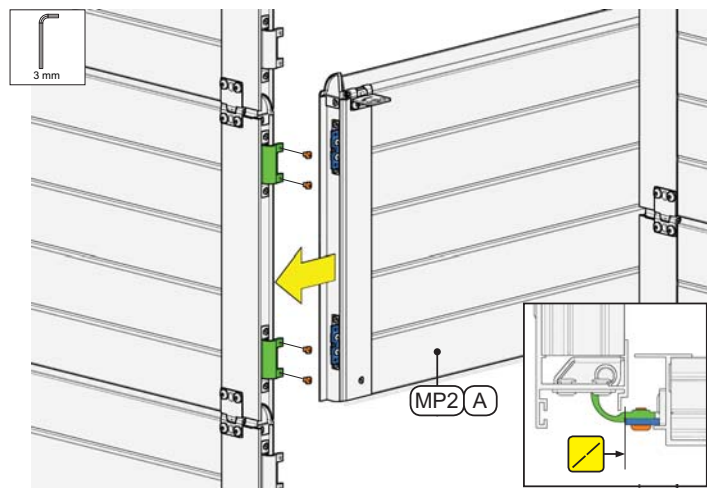
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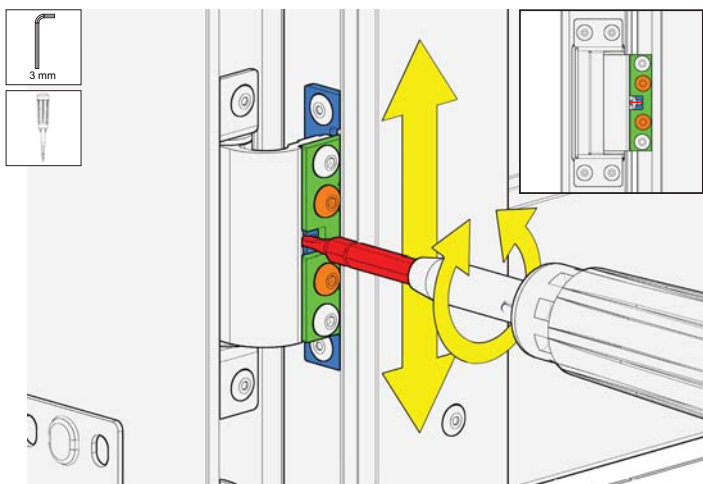
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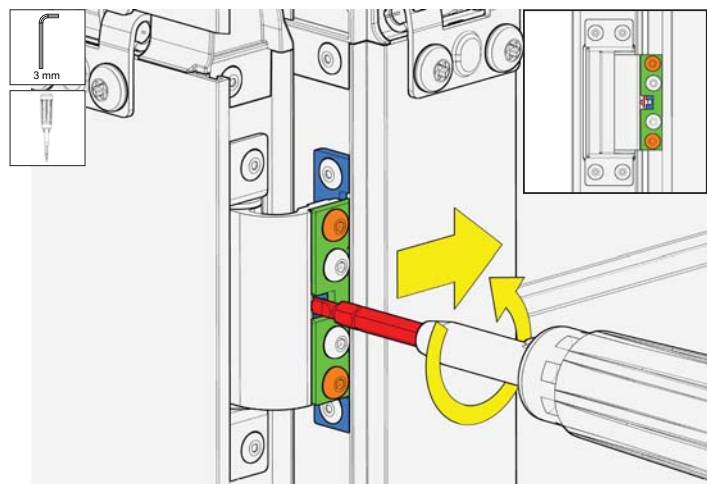
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94



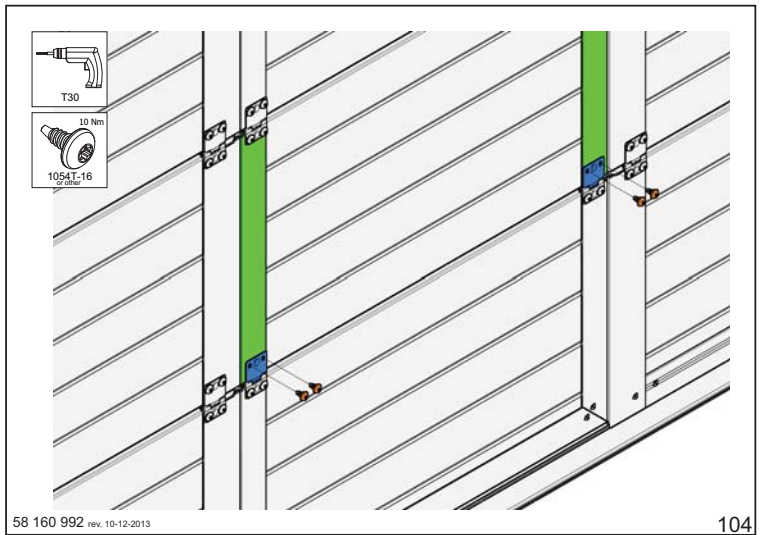
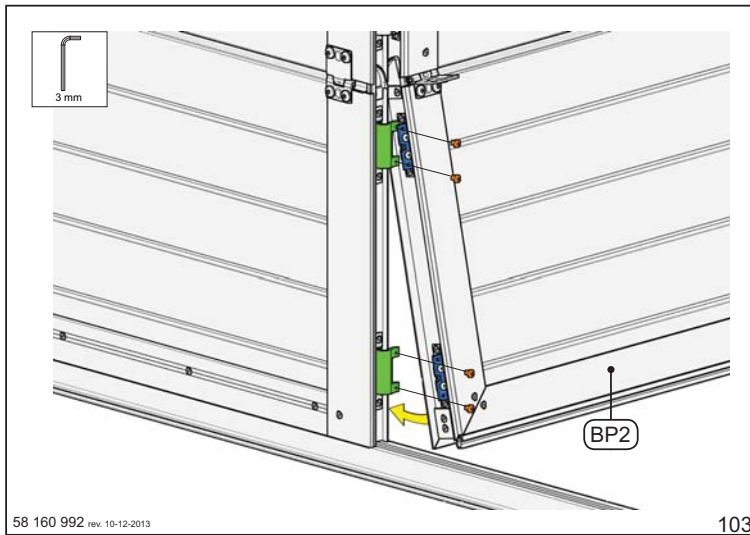
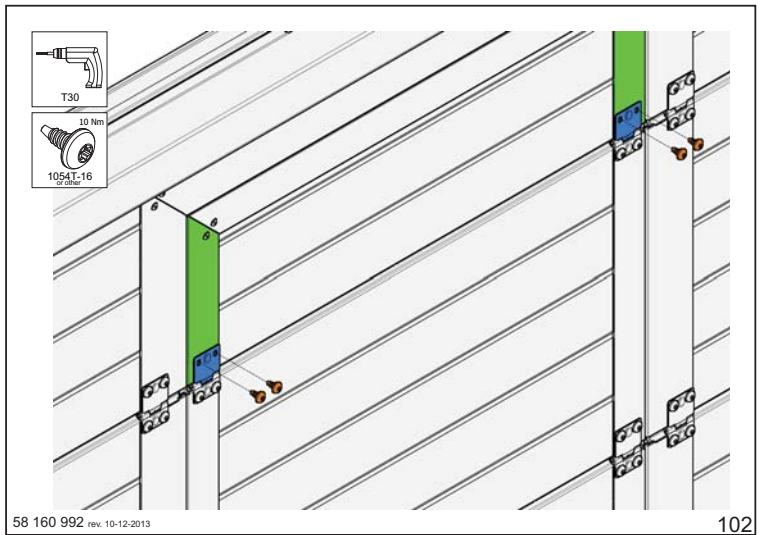
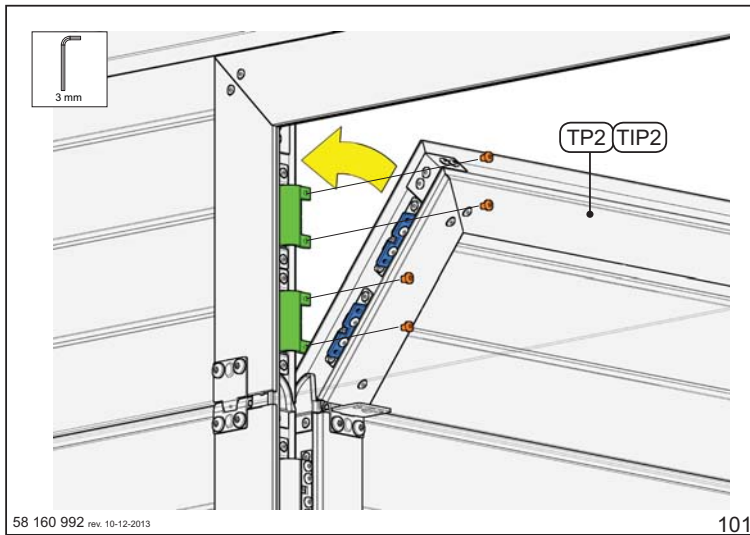
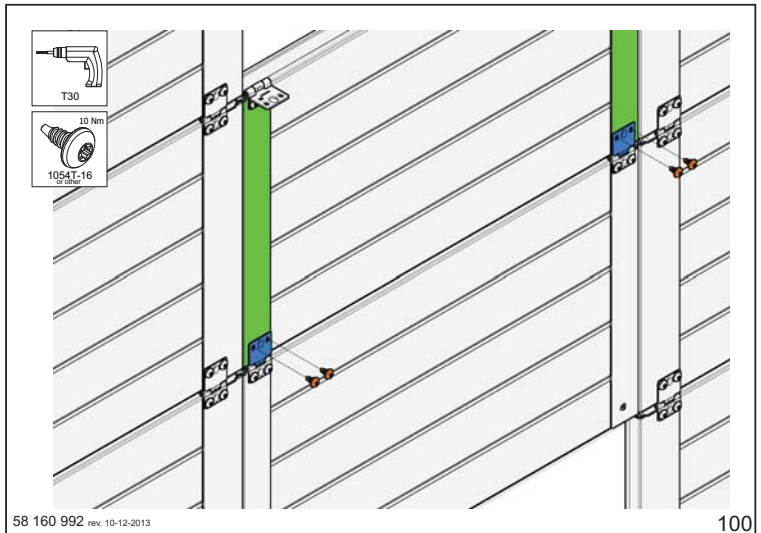
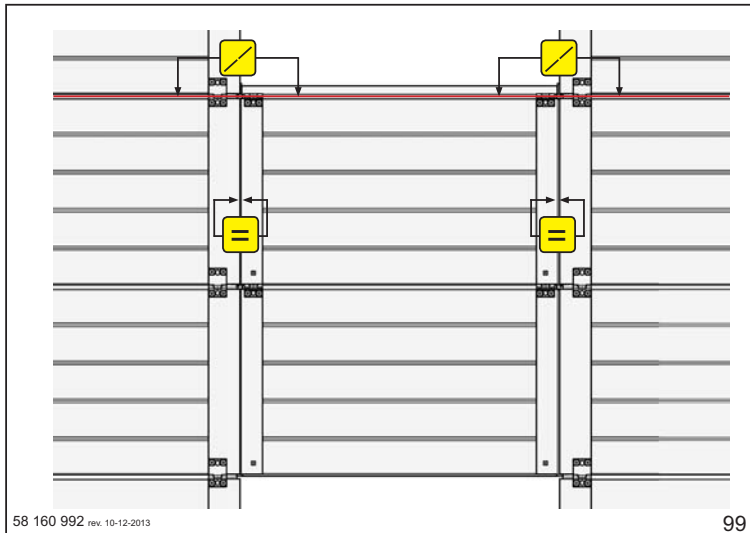
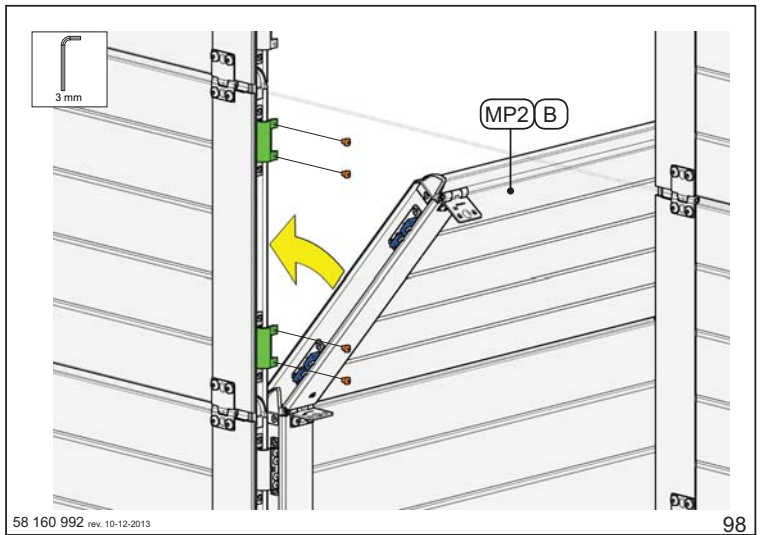
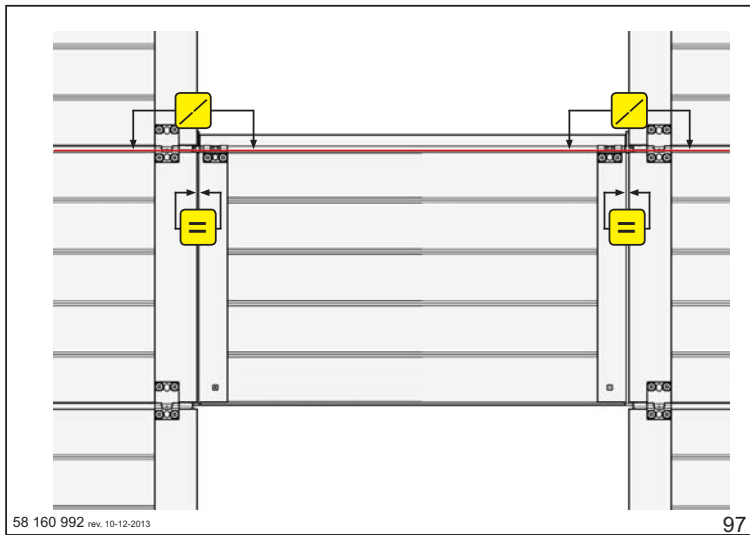
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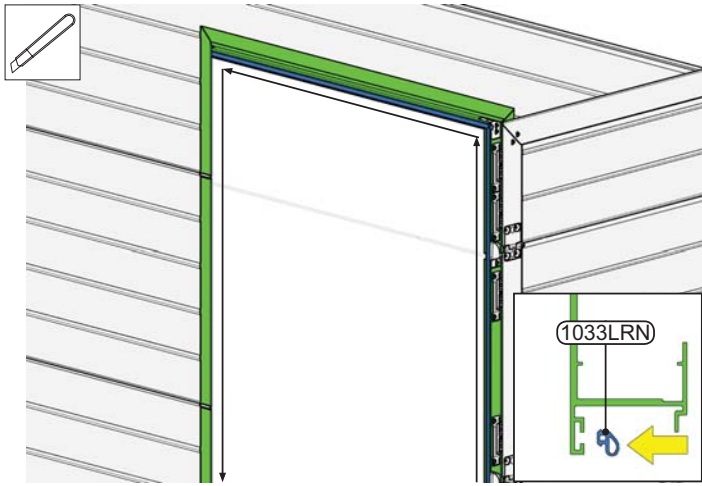
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58 160 992 rev. 10-12-2013

96





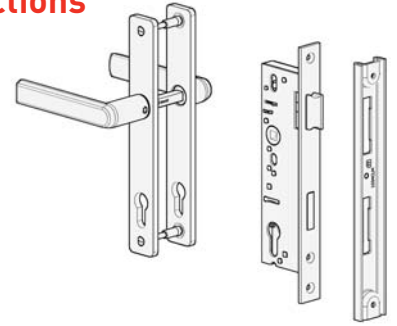
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105

FF Installation manual

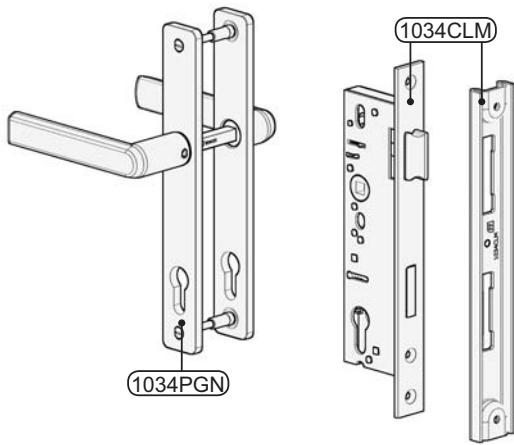
lock assembly

assembly instructions



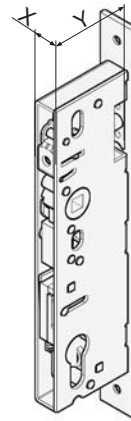
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106



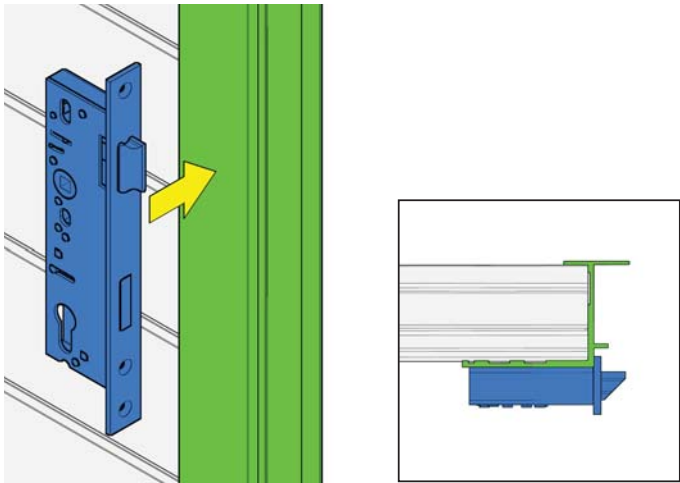
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107



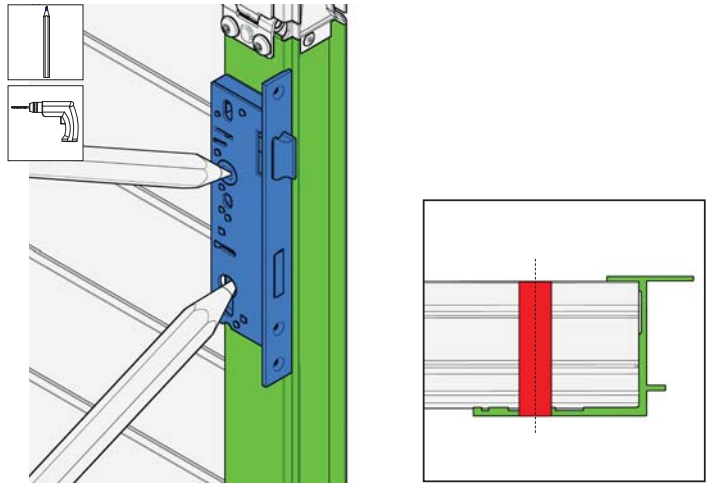
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108



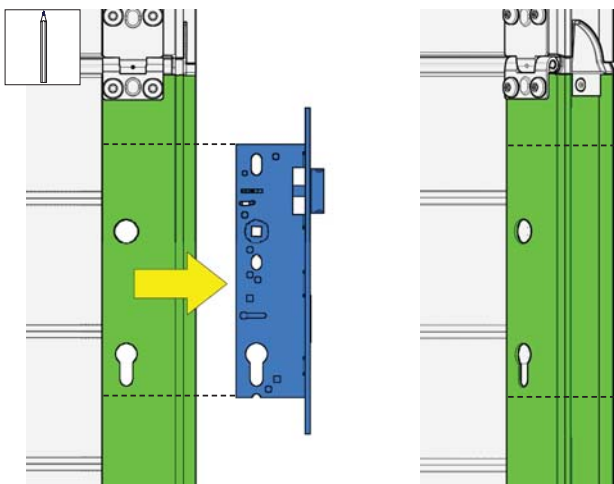
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109



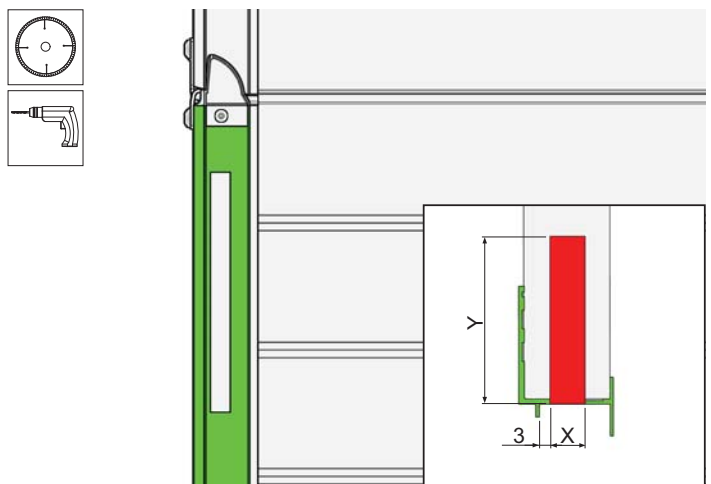
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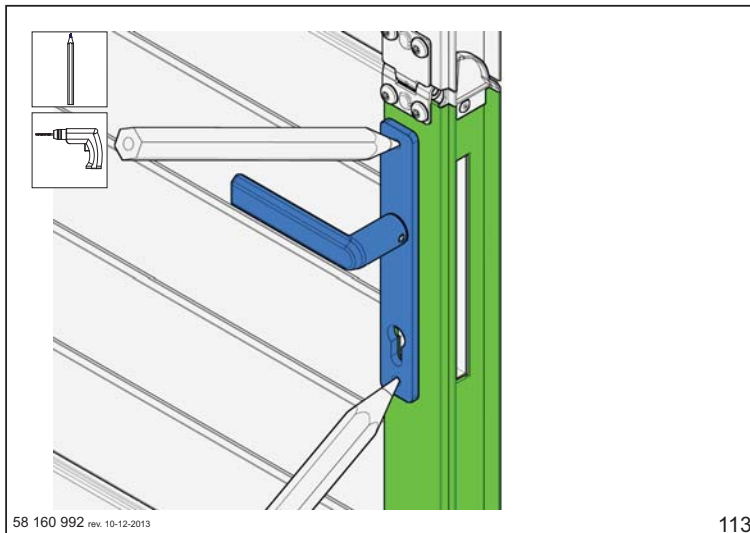
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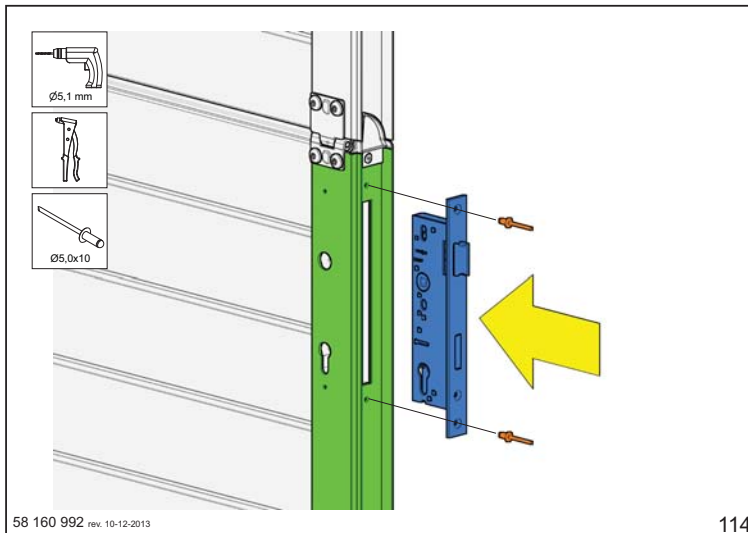


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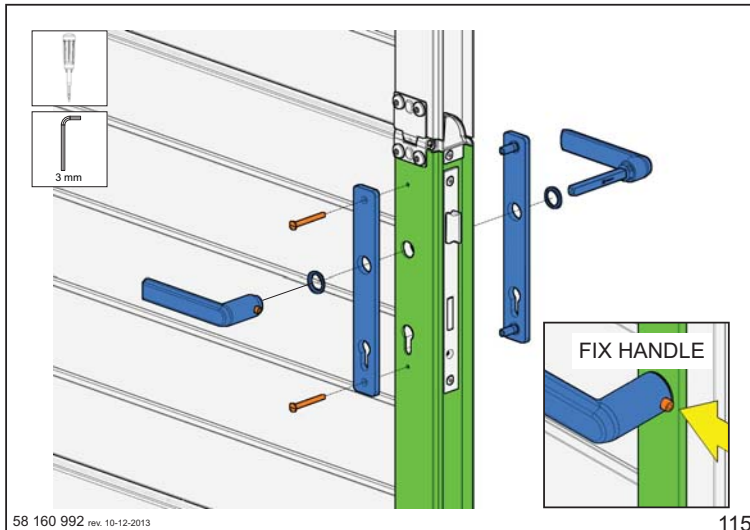
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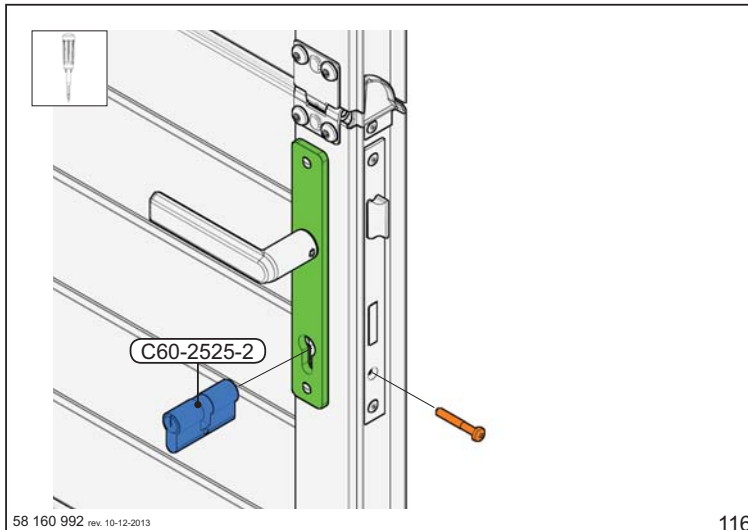
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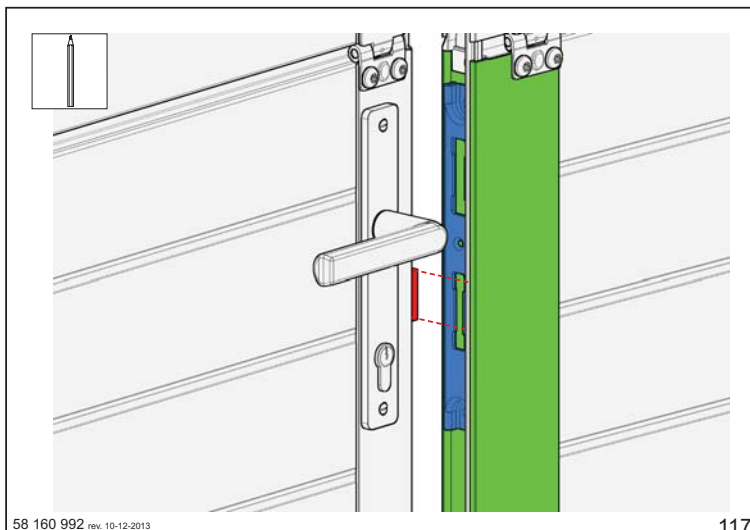
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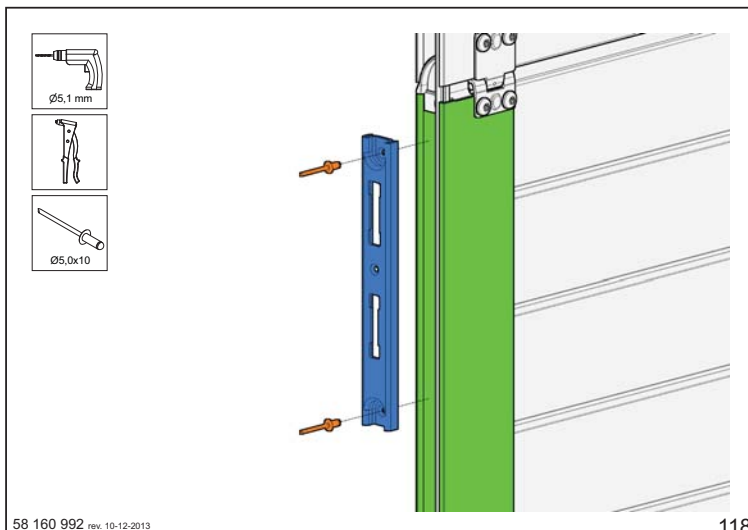
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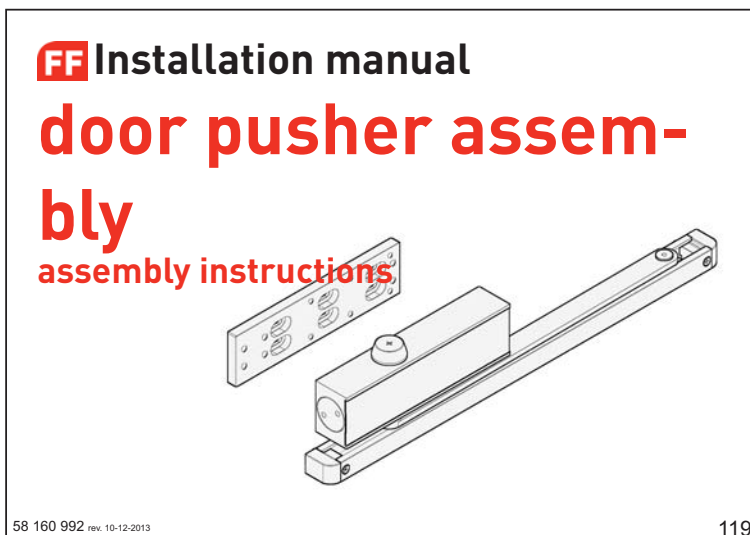
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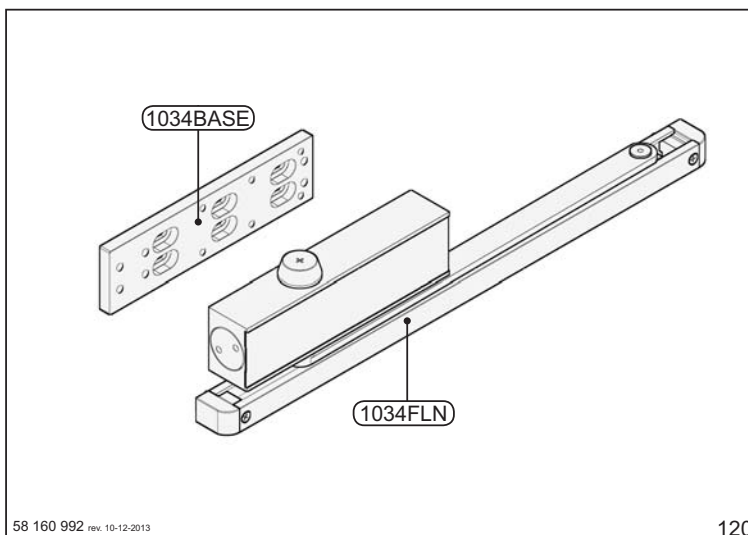
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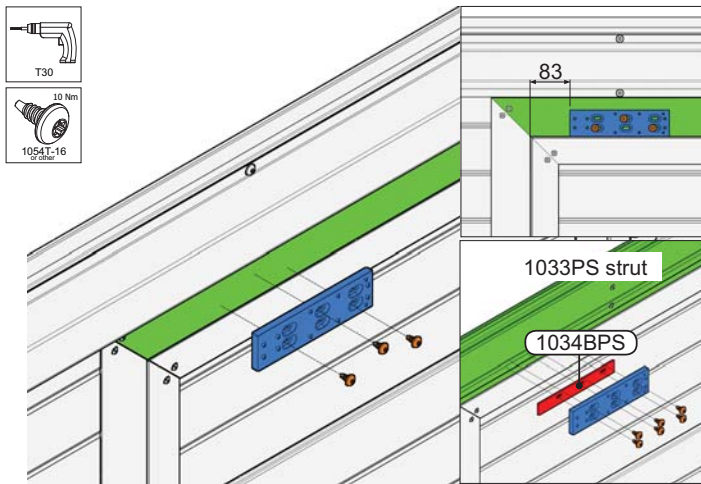
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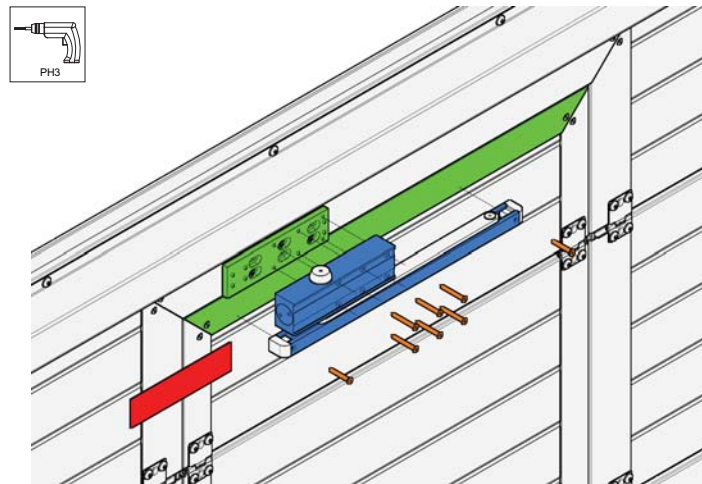


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58 160 992 rev. 10-12-2013

121



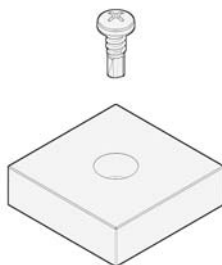
58 160 992 rev. 10-12-2013

122

FF Installation manual

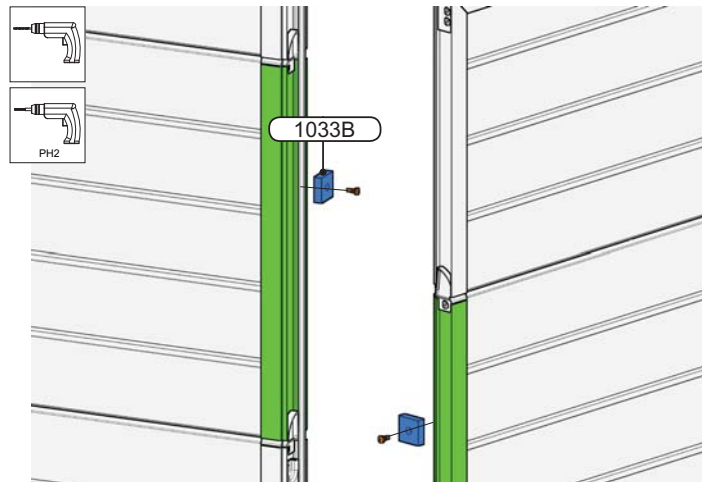
1033B

(apply when door width > 3000mm)



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FF Installation manual

maintenance



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MAINTENANCE SAFE STEP PASS DOOR

The Safe Step pass door should be maintained and check regularly to ensure safe operation and use.

GENERAL

1. The maintenance may only be carried out by qualified overhead door mechanics
2. Replacement of broken or worn components should always be done by qualified overhead door mechanics
3. When checking the door, always disconnect the electrical main power supply.
Make sure that it is blocked against re-engaging without knowing.

REGULAR MAINTENANCE

After installation

1. Grease the hinges
2. Check if seals stay in place while opening and closing the overhead door
3. Clean aluminium profiles with 'Eloxal' aluminium cleaner

MECHANIC
MECHANIC
MECHANIC/USER

Every year (or after every 1500 cycles)

1. Check fixation of the lock handle
2. Grease the hinges
3. Check fixation of the 450... hinges
4. Grease the door pusher
5. Check fixation of 80PS strut screws
6. Check quality and position of the seals

MECHANIC
MECHANIC
MECHANIC
MECHANIC
MECHANIC
MECHANIC

After every 10000 cycles

1. Replace the 1033LBR between the door and the threshold

MECHANIC

58 160 992 rev. 10-12-2013

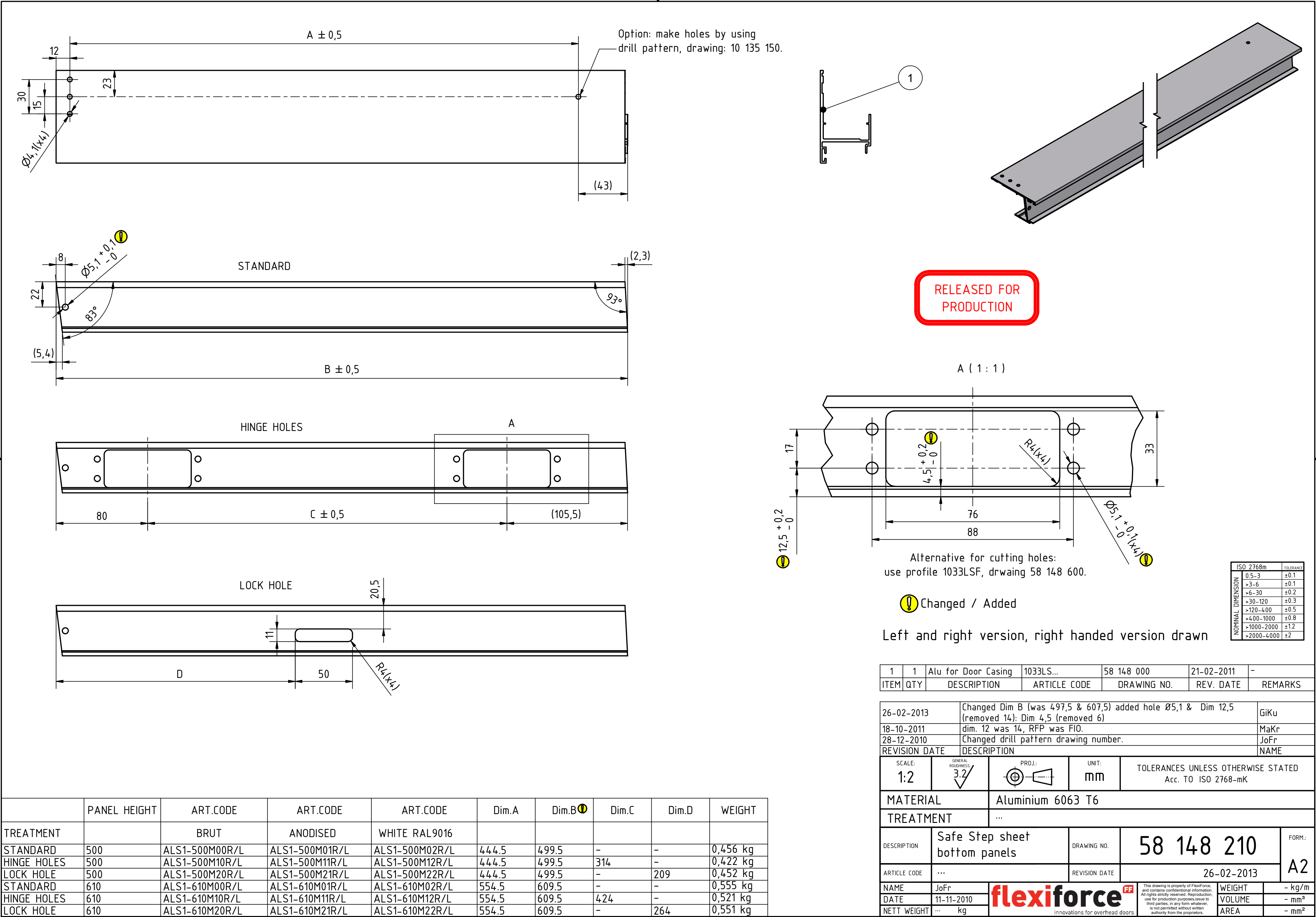
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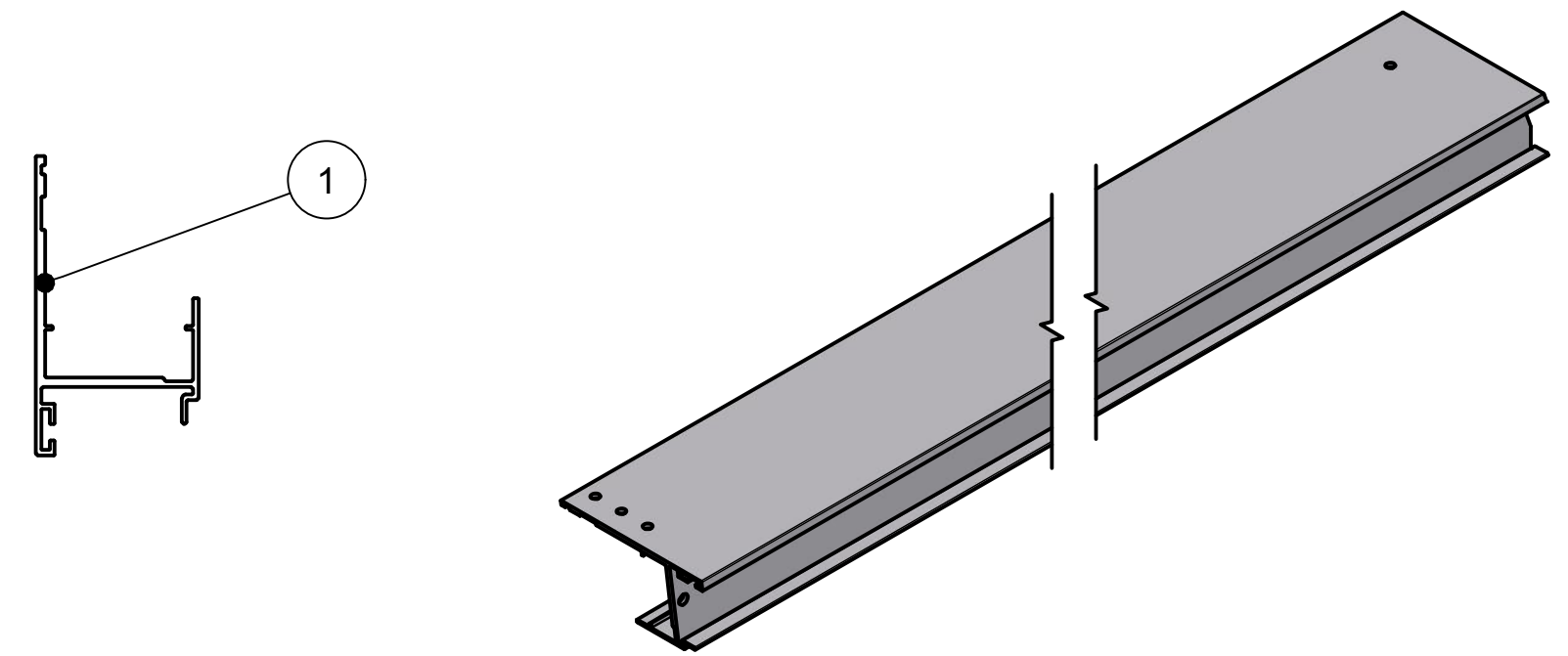
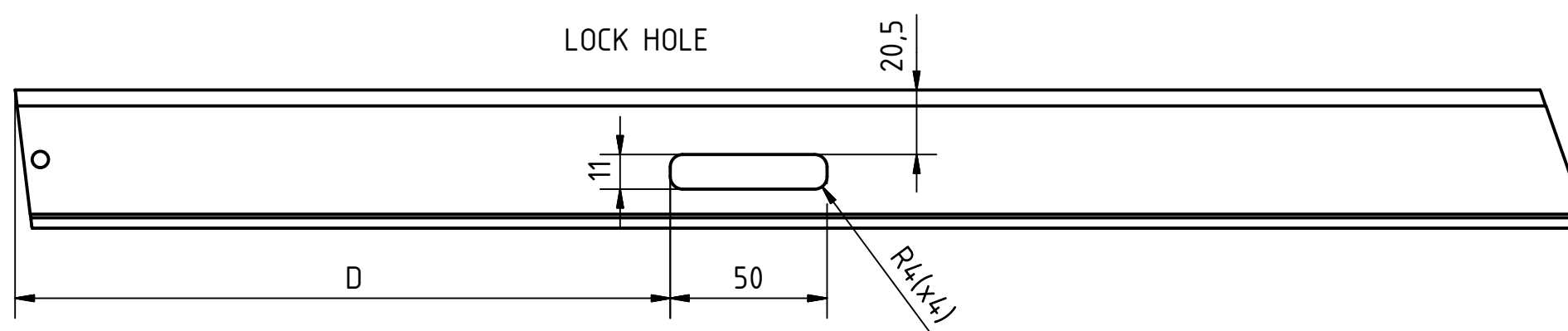
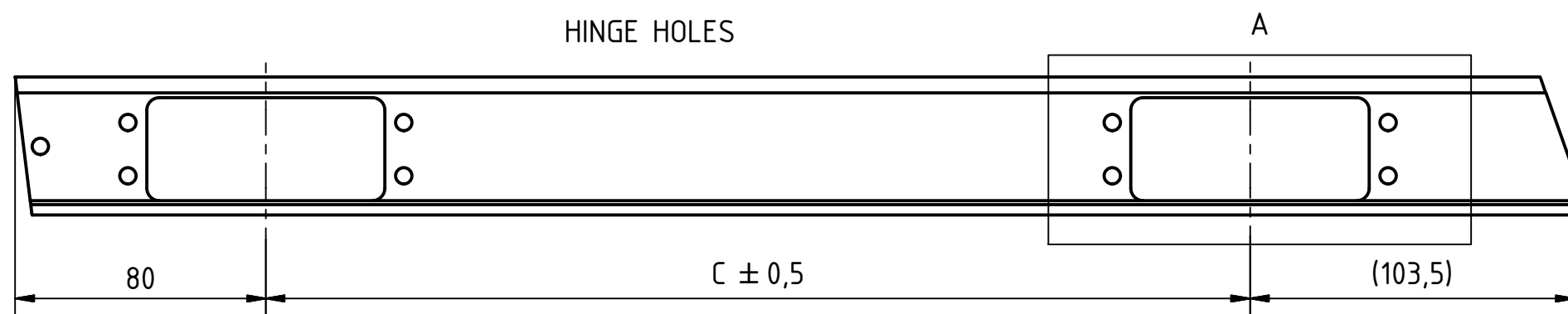
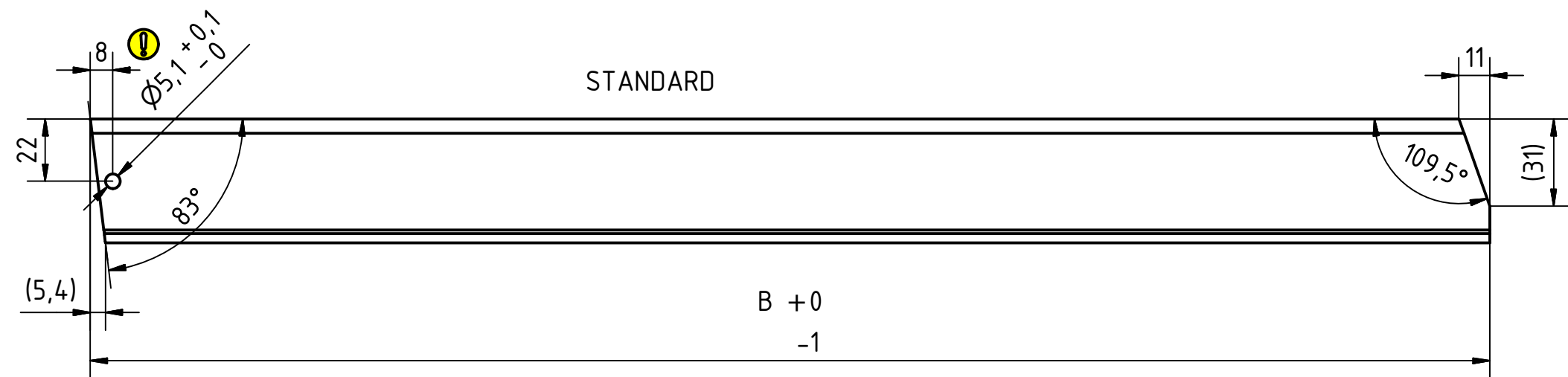
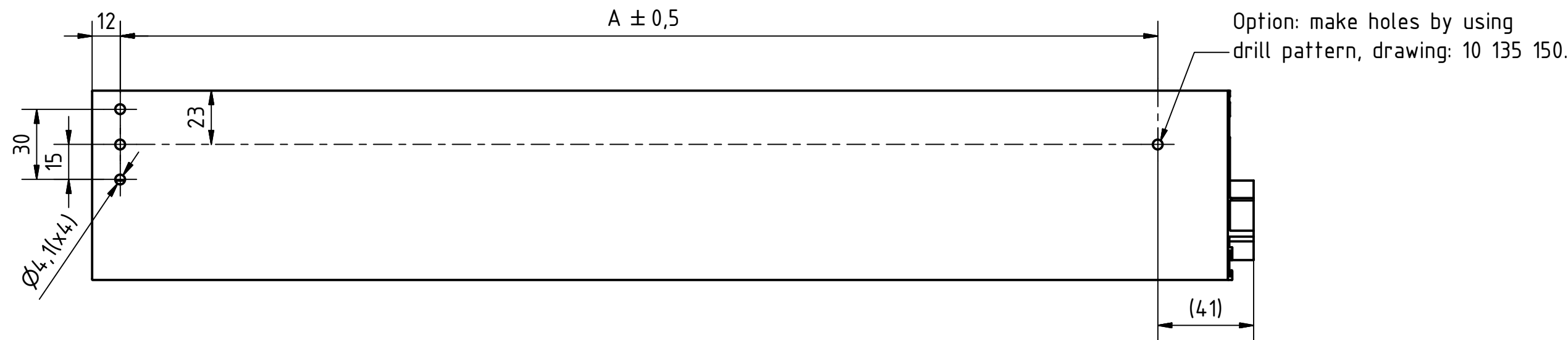
FF Installation manual

appendix

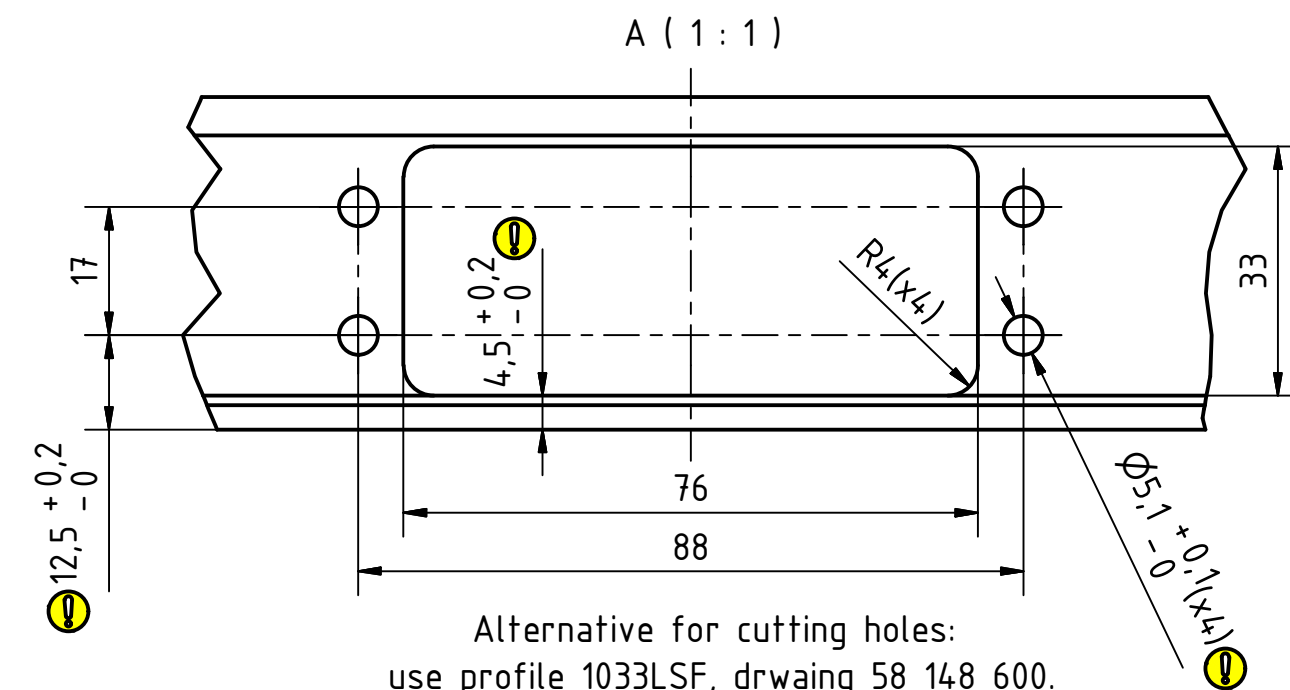
58 160 992 rev. 10-12-2013

127





RELEASED FOR PRODUCTION



Changed / Added

Left and right version, right handed version drawn

ISO 2768m	TOLERANCE
0,5-3	±0,1
>3-6	±0,1
>6-30	±0,2
>30-120	±0,3
>120-400	±0,5
>400-1000	±0,8
>1000-2000	±1,2
>2000-4000	±2

1	1	Alu for Door Casing	1033LS...	58 148 000	21-02-2011	-
ITEM	QTY	DESCRIPTION	ARTICLE CODE	DRAWING NO.	REV. DATE	REMARKS

26-02-2013	Added Hole Ø5,1 & remark, Dim 12,5 (removed 14), Dim 4,5 (removed 6)	GiKu
18-10-2011	dim. 12 was 14, RFP was FIO.	MaKr
09-03-2011	Added angle.	JoFr
REVISION DATE	DESCRIPTION	NAME

SCALE: 1:2	GENERAL ROUGHNESS 3.2	PROJ.	UNIT: mm	TOLERANCES UNLESS OTHERWISE STATED Acc. TO ISO 2768-mK
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MATERIAL	Aluminium 6063 T6
TREATMENT	...

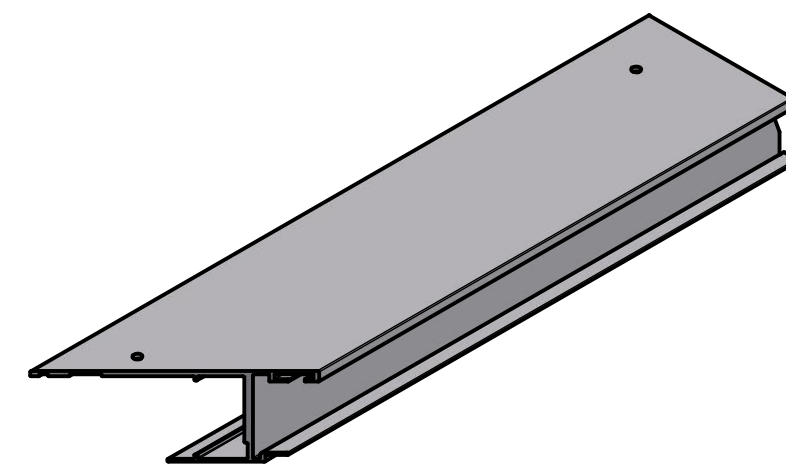
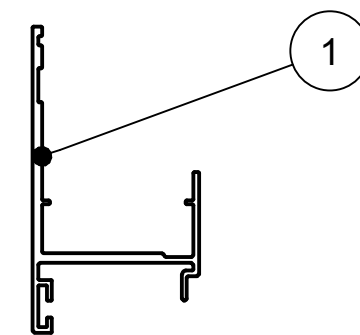
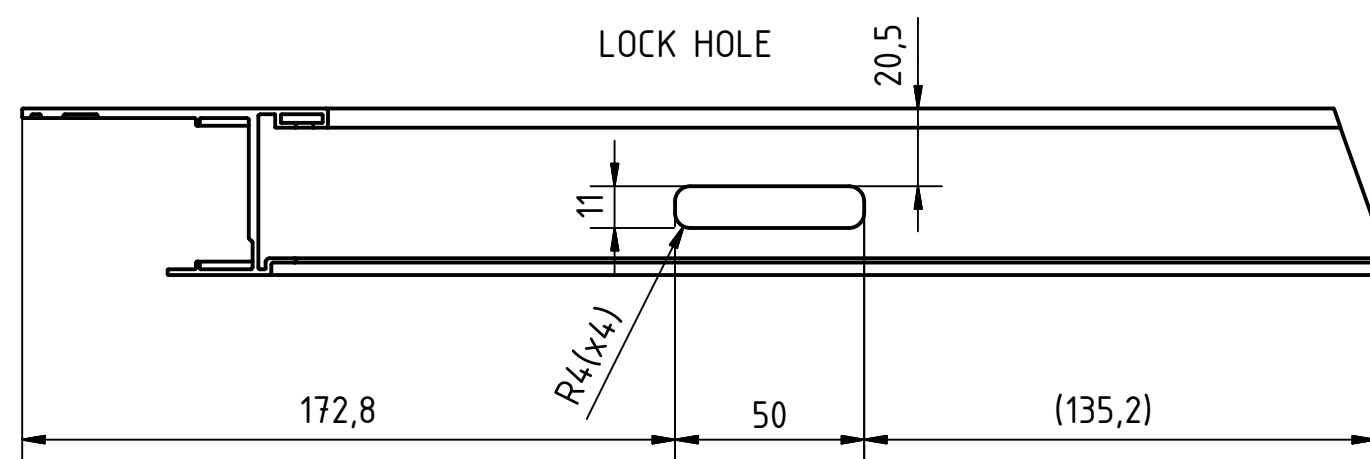
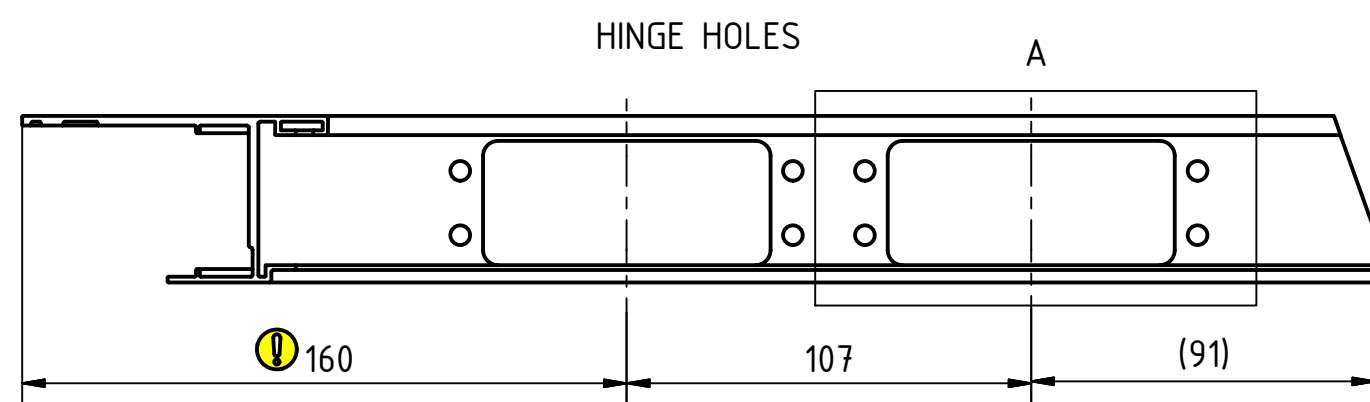
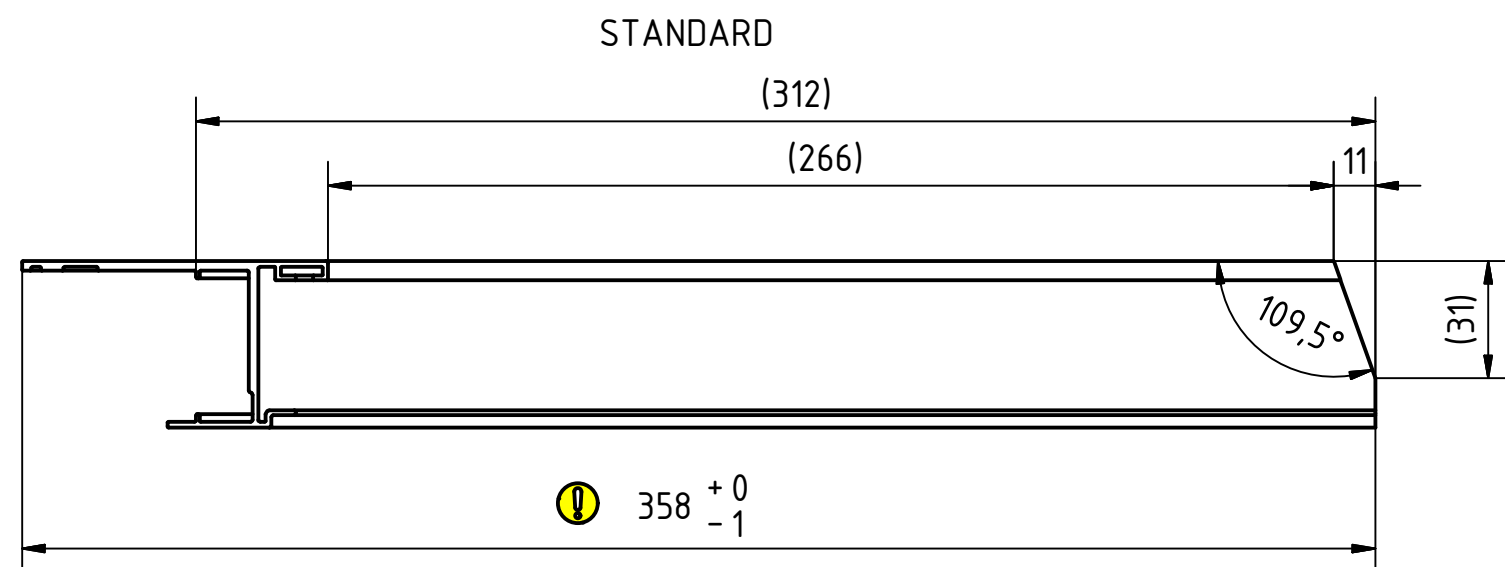
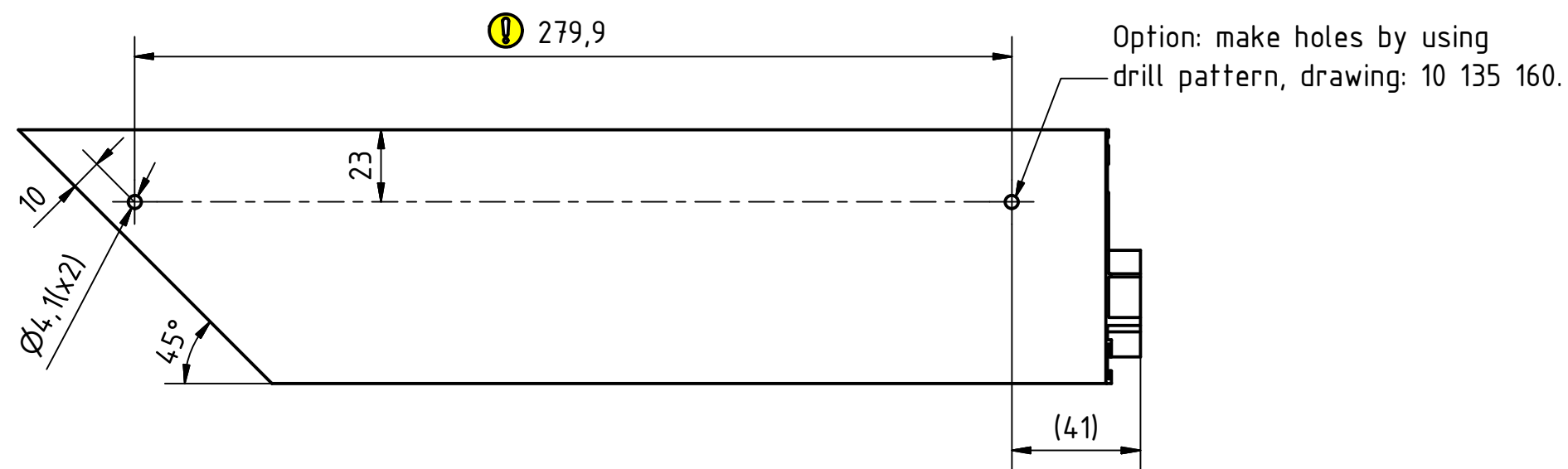
DESCRIPTION	Safe Step sheet middle panels	DRAWING NO.	58 148 220	FORM.: A2
ARTICLE CODE	...	REVISION DATE	26-02-2013	
NAME	JoFr			
DATE	11-11-2010			
NETT WEIGHT	... kg			

flexiforce
innovations for overhead doors

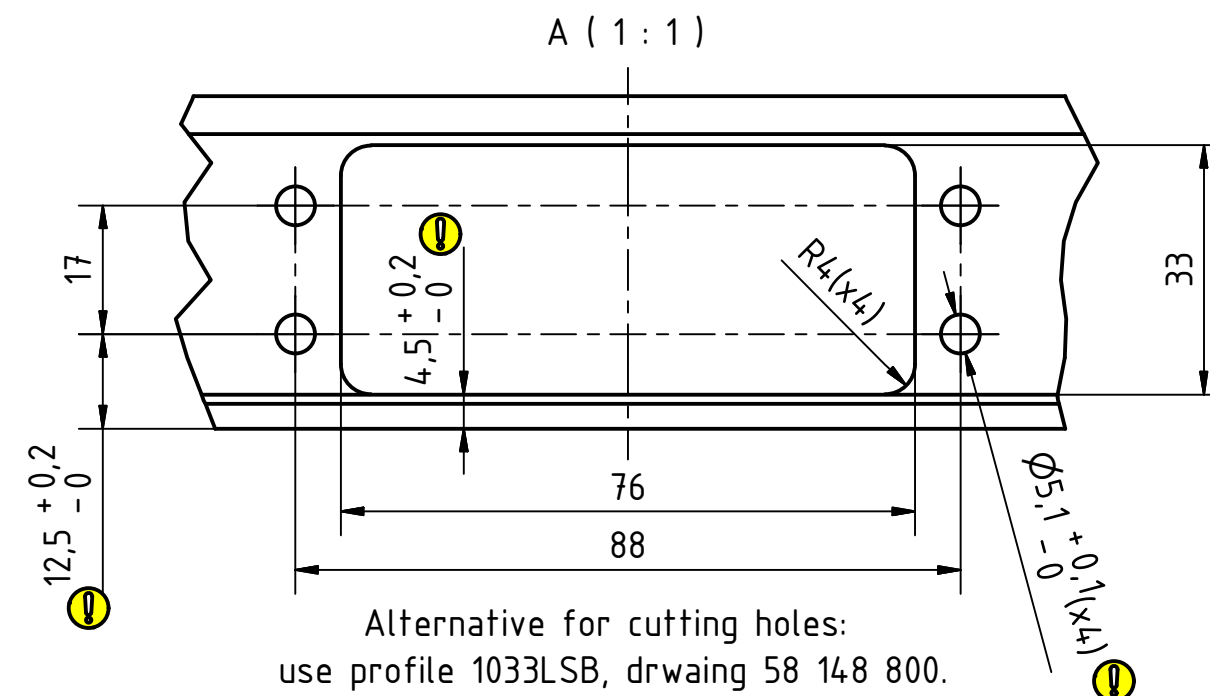
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WEIGHT	- kg/m
VOLUME	- mm ³
AREA	- mm ²

	PANEL HEIGHT	ART.CODE	ART.CODE	ART.CODE	Dim.A	Dim.B	Dim.C	Dim.D	WEIGHT
TREATMENT		BRUT	ANODISED	WHITE RAL9016					
STANDARD	500	ALS2-500M00R/L	ALS2-500M01R/L	ALS2-500M02R/L	444,5	497,5	-	-	0,45 kg
HINGE HOLES	500	ALS2-500M10R/L	ALS2-500M11R/L	ALS2-500M12R/L	444,5	497,5	314	-	0,416 kg
LOCK HOLE	500	ALS2-500M20R/L	ALS2-500M21R/L	ALS2-500M22R/L	444,5	497,5	-	209	0,447 kg
STANDARD	610	ALS2-610M00R/L	ALS2-610M01R/L	ALS2-610M02R/L	554,5	607,5	-	-	0,549 kg
HINGE HOLES	610	ALS2-610M10R/L	ALS2-610M11R/L	ALS2-610M12R/L	554,5	607,5	424	-	0,507 kg
LOCK HOLE	610	ALS2-610M20R/L	ALS2-610M21R/L	ALS2-610M22R/L	554,5	607,5	-	264	0,545 kg



RELEASED FOR PRODUCTION



Changed / Added

Left and right version, right handed version drawn

ITEM	QTY	DESCRIPTION	ARTICLE CODE	DRAWING NO.	REV. DATE	REMARKS
1	1	Alu for Door Casing	1033LS...	58 148 000	21-02-2011	-

26-02-2013	Added Dim. 12,5 (removed 14), Dim. 4,5 (removed 6), added remark hole Ø5,1, 358 (was 355) 160 (was 157,5), 279,9 (was 276,9)	GiKu
18-10-2011	RFP was FIO.	MaKr
28-12-2010	Changed drill pattern drawing number and tolerance.	JoFr
REVISION DATE	DESCRIPTION	NAME

SCALE: 1:2	GENERAL ROUGHNESS 3.2	PROJ.:	UNIT: mm	TOLERANCES UNLESS OTHERWISE STATED Acc. TO ISO 2768-mK
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MATERIAL	Aluminium 6063 T6
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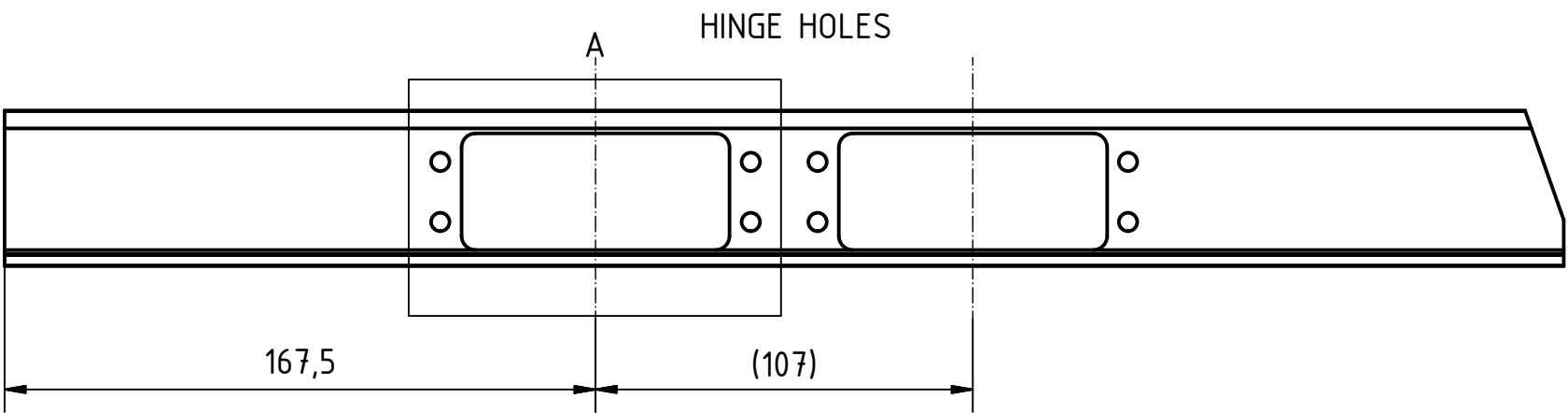
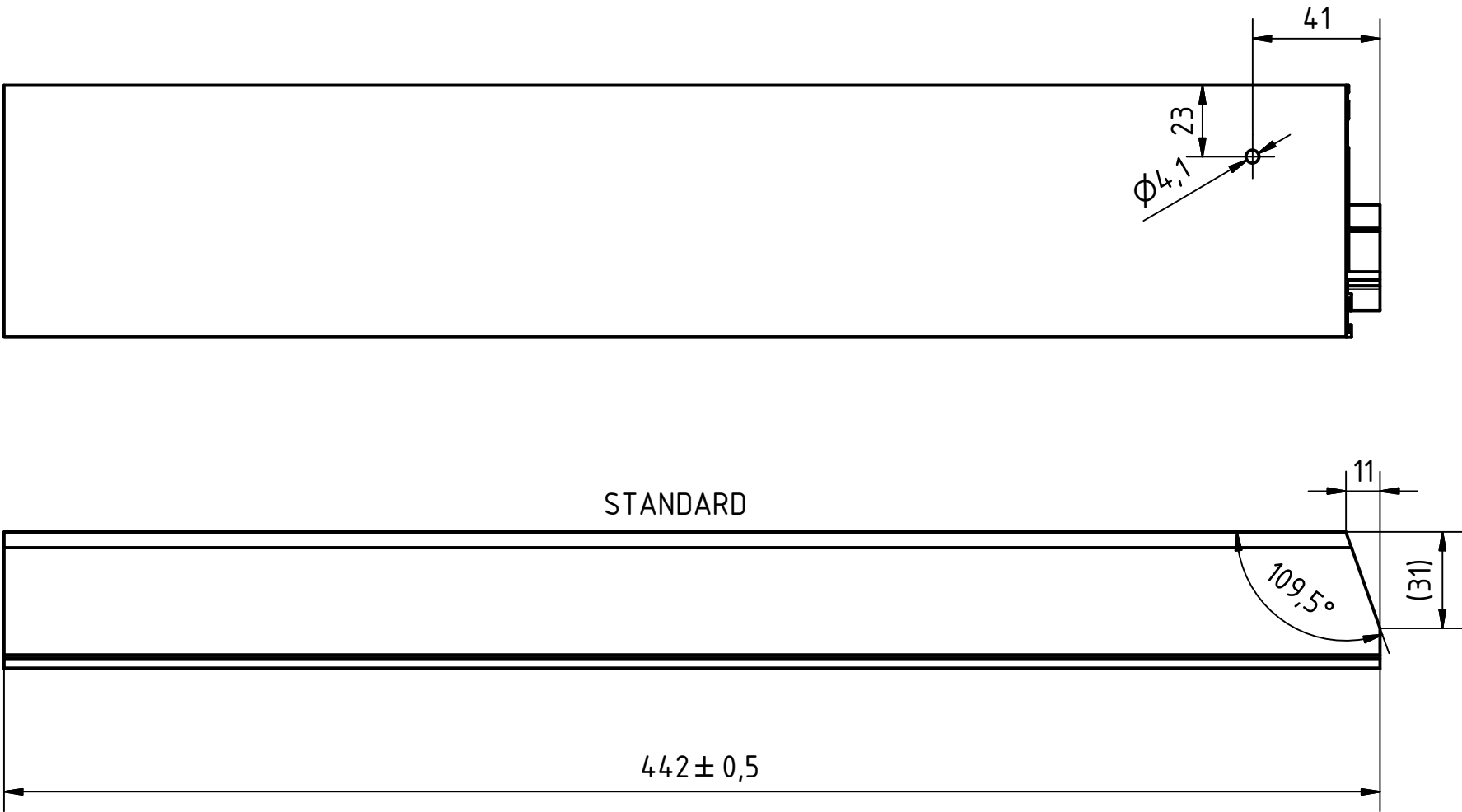
TREATMENT	...
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DESCRIPTION	Safe Step sheet top panels	DRAWING NO.	58 148 230	FORM.: A2
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ARTICLE CODE	...	REVISION DATE	26-02-2013
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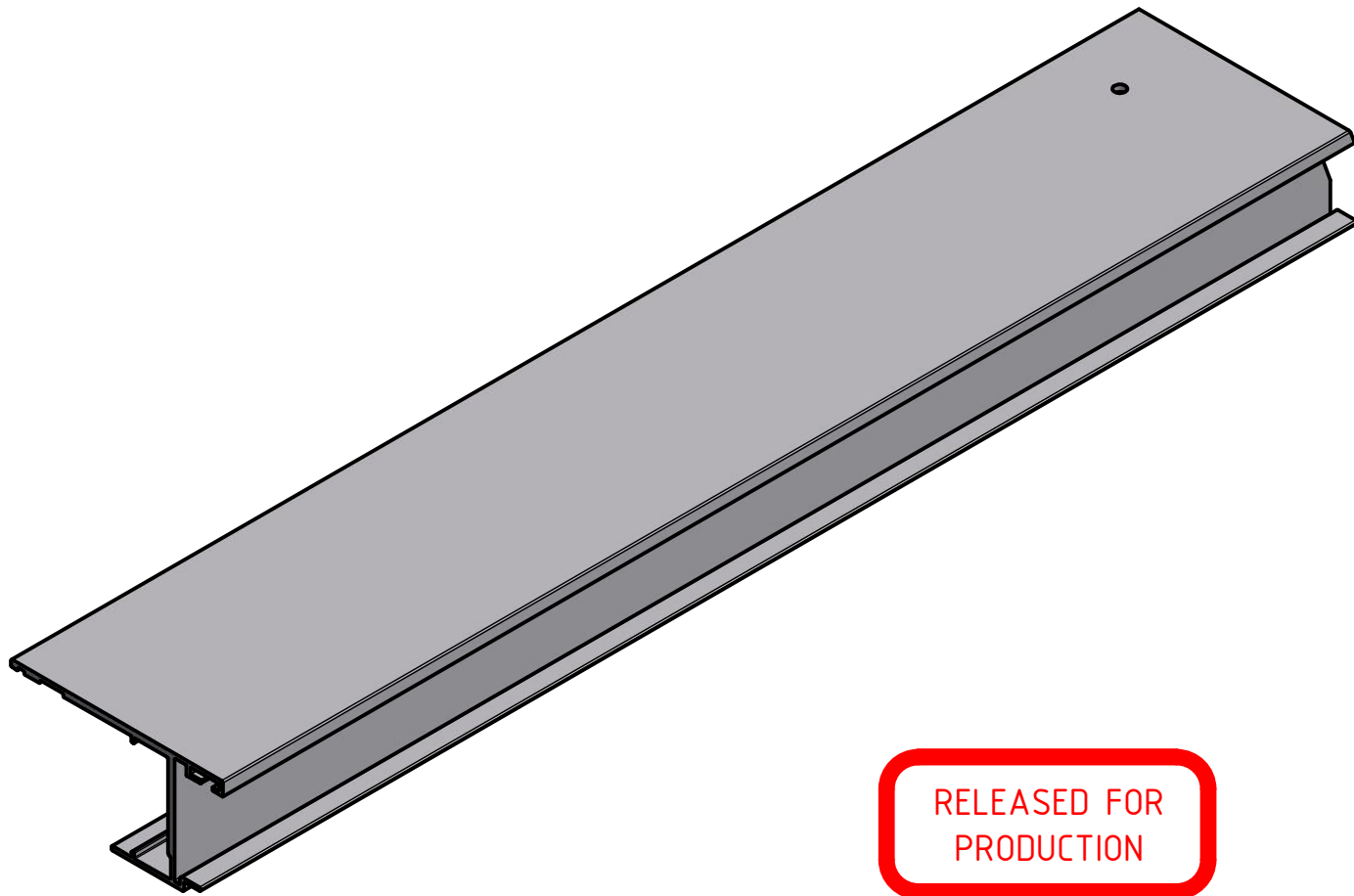
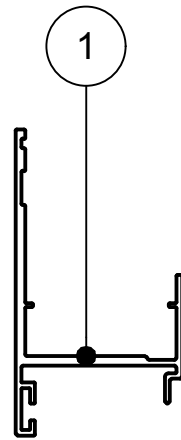
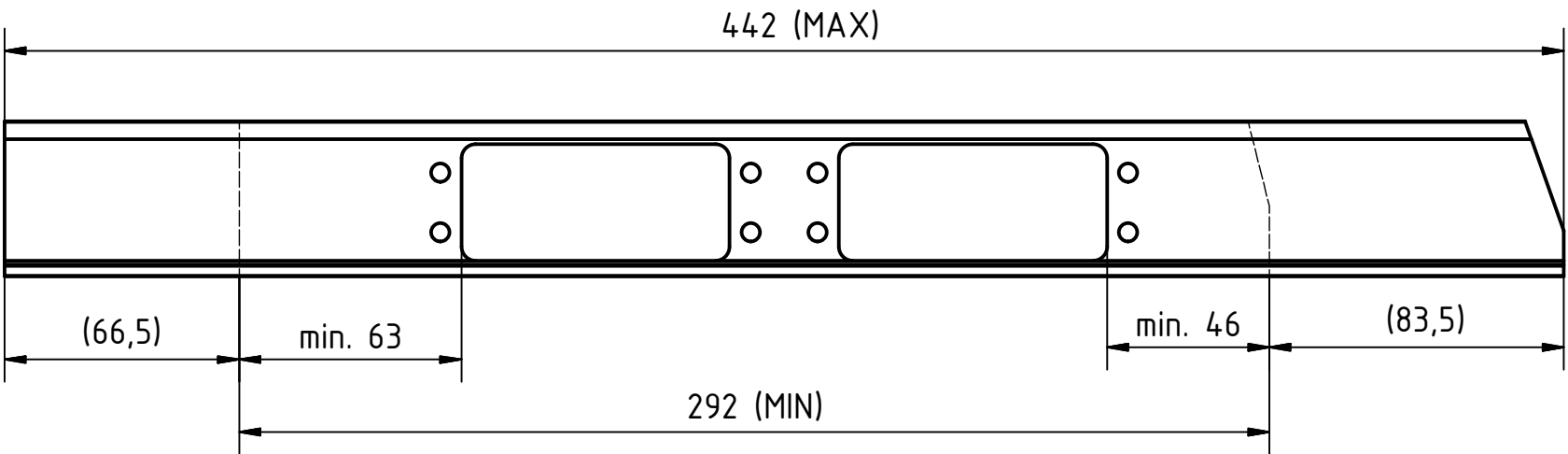
NAME	JoFr	DATE	11-11-2010	NETT WEIGHT	... kg
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WEIGHT	- kg/m	VOLUME	- mm³	AREA	- mm²

	PANEL HEIGHT	ART.CODE	ART.CODE	ART.CODE	WEIGHT
STANDARD	500/610	ALS3-300M00R/L	ALS3-300M01R/L	ALS3-300M02R/L	0,283 kg
HINGE HOLES	500/610	ALS3-300M10R/L	ALS3-300M11R/L	ALS3-300M12R/L	0,25 kg
LOCK HOLE	500/610	ALS3-300M20R/L	ALS3-300M21R/L	ALS3-300M22R/L	0,279 kg



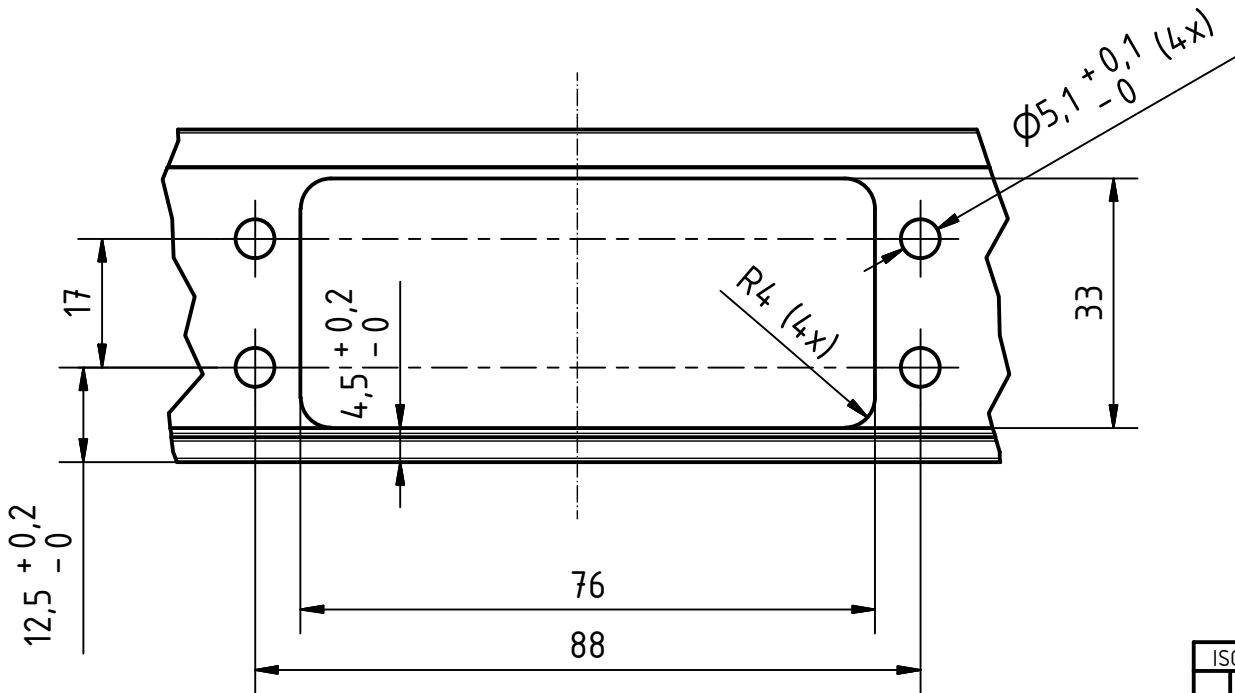
	PANEL HEIGHT	ART.CODE	ART.CODE	WEIGHT
TREATMENT		BRUT	ANODISED	
STANDARD	500/610	ALS3-LSBM00R/L	ALS3-LSBM01R/L	0,405 kg
HINGE HOLES	500/610	ALS3-LSBM10R/L	ALS3-LSBM11R/L	0,373 kg

SAW INSTRUCTION BASED ON MANUAL:
SECTION HEIGHT-103



RELEASED FOR
PRODUCTION

A (1 : 1)



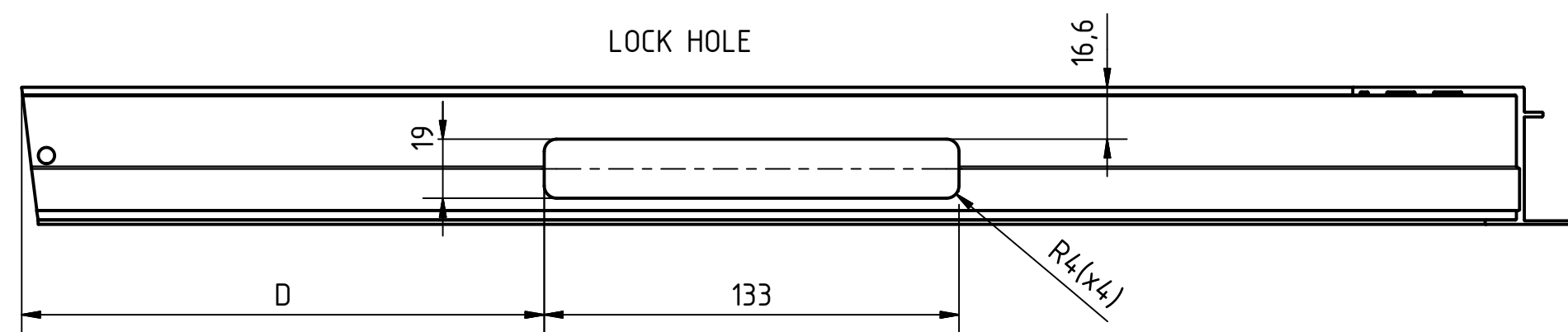
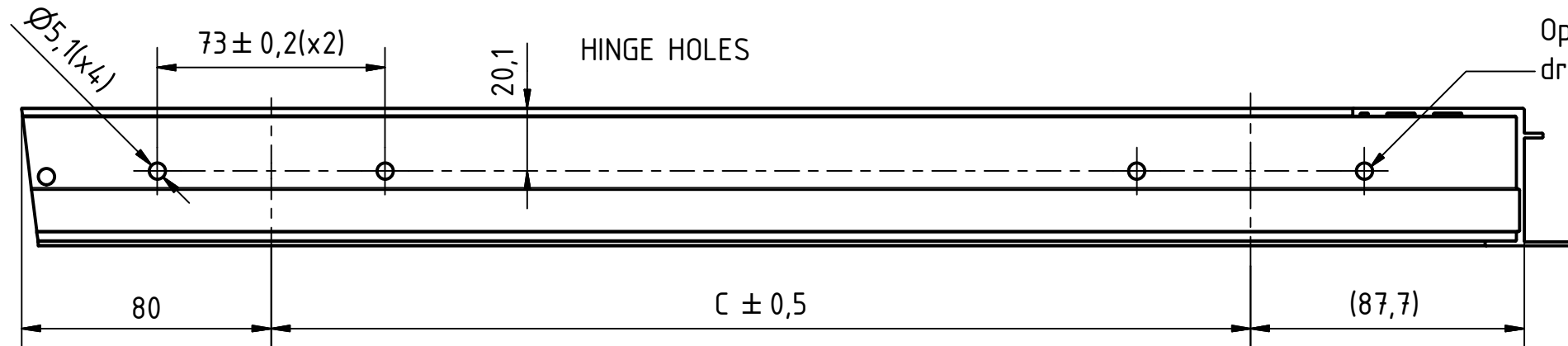
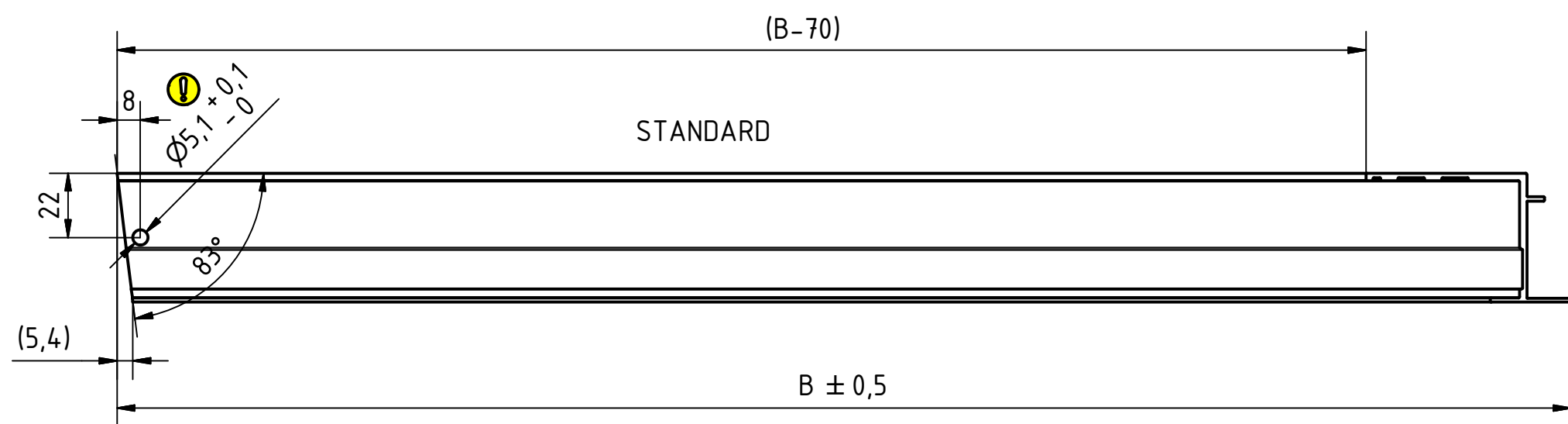
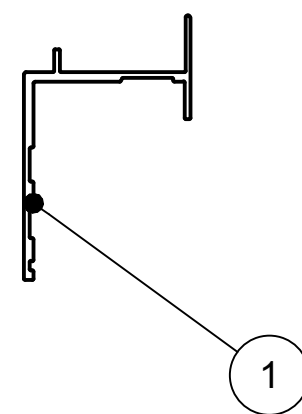
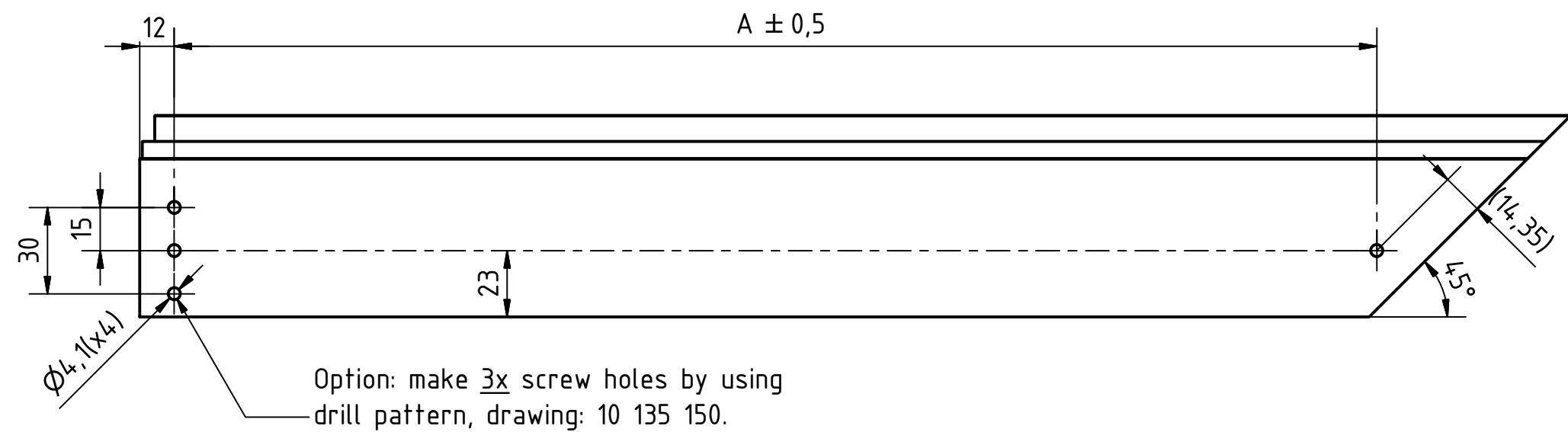
Alternative for cutting holes:
use profile 1033LSB, drwaing 58 148 800.

ISO 2768m	TOLERANCE
0.5-3	±0.1
>3-6	±0.1
>6-30	±0.2
>30-120	±0.3
>120-400	±0.5
>400-1000	±0.8
>1000-2000	±1.2
>2000-4000	±2

Left and right version, right handed version drawn

1	1	Alu for Door Casing	1033LS...	58 148 000	21-02-2011	-
ITEM	QTY	DESCRIPTION	ARTICLE CODE	DRAWING NO.	REV. DATE	REMARKS

REVISION DATE	DESCRIPTION	NAME
SCALE: 1:2	GENERAL ROUGHNESS 3.2	PROJ.:
MATERIAL	Aluminium 6063 T6	UNIT: mm
TREATMENT	see table	TOLERANCES UNLESS OTHERWISE STATED Acc. TO ISO 2768-mK
DESCRIPTION	Safe Step: Top section with 1033PLS	DRAWING NO. 58 148 240
ARTICLE CODE		REVISION DATE 1-3-2013
NAME	JoFr	FORM.: A2
DATE	11-2-2013	flexiforce
NETT WEIGHT	N/A	innovations for overhead doors
WEIGHT	- kg/m	
VOLUME	- mm ³	
AREA	- mm ²	



! Changed / Added

RELEASED FOR PRODUCTION

NOMINAL DIMENSION	ISO 2768m	TOLERANCE
	0,5-3	±0,1
>3-6	±0,1	
>6-30	±0,2	
>30-120	±0,3	
>120-400	±0,5	
>400-1000	±0,8	
>1000-2000	±1,2	
>2000-4000	±2	

Left and right version, right handed version drawn

1	1	Alu for Door Panel	1033LD...	58 149 000	04-08-2011	-
ITEM	QTY	DESCRIPTION	ARTICLE CODE	DRAWING NO.	REV. DATE	REMARKS

28-02-2013	Dim. B (was 494.7 & 604.7), hole Ø5.1 added !	GiKu
18-10-2011	Dim. 12 was 14, RFP was F10.	MaKr
28-12-2010	Adjusted drawing numbers of drill patterns.	JoFr
REVISION DATE	DESCRIPTION	NAME

SCALE: 1:2	GENERAL ROUGHNESS 3.2	PROJ.	UNIT: mm	TOLERANCES UNLESS OTHERWISE STATED Acc. TO ISO 2768-mK
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MATERIAL	Aluminium 6063 T6
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TREATMENT	...
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DESCRIPTION	Safe Step door bottom panels	DRAWING NO.	58 149 210	FORM.: A2
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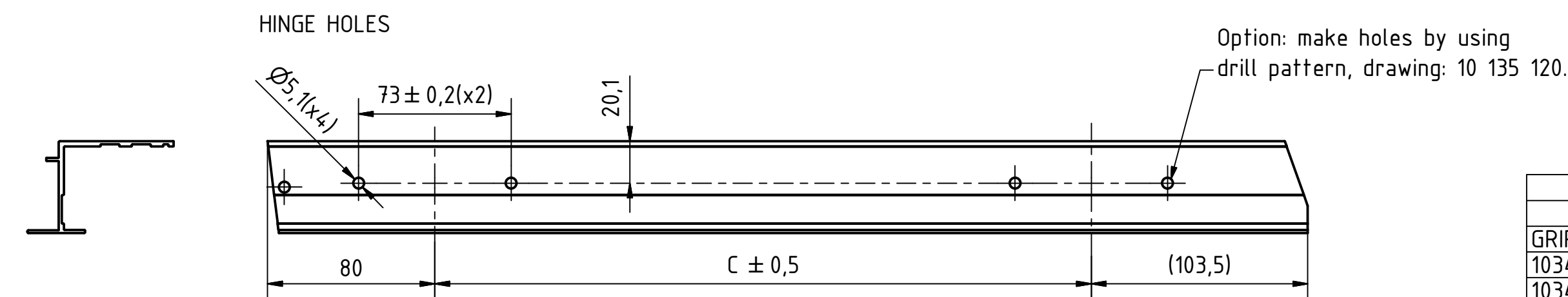
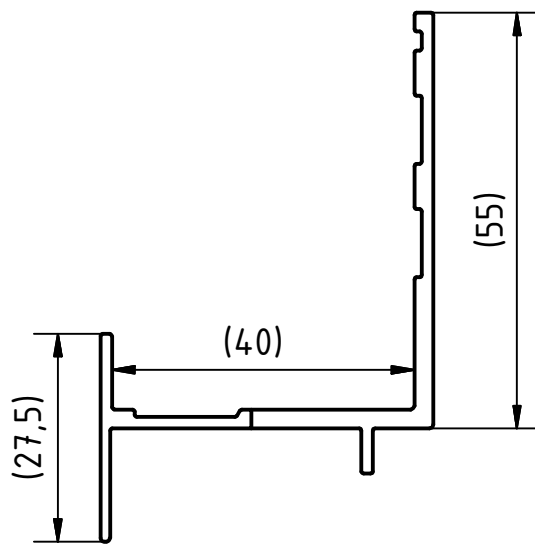
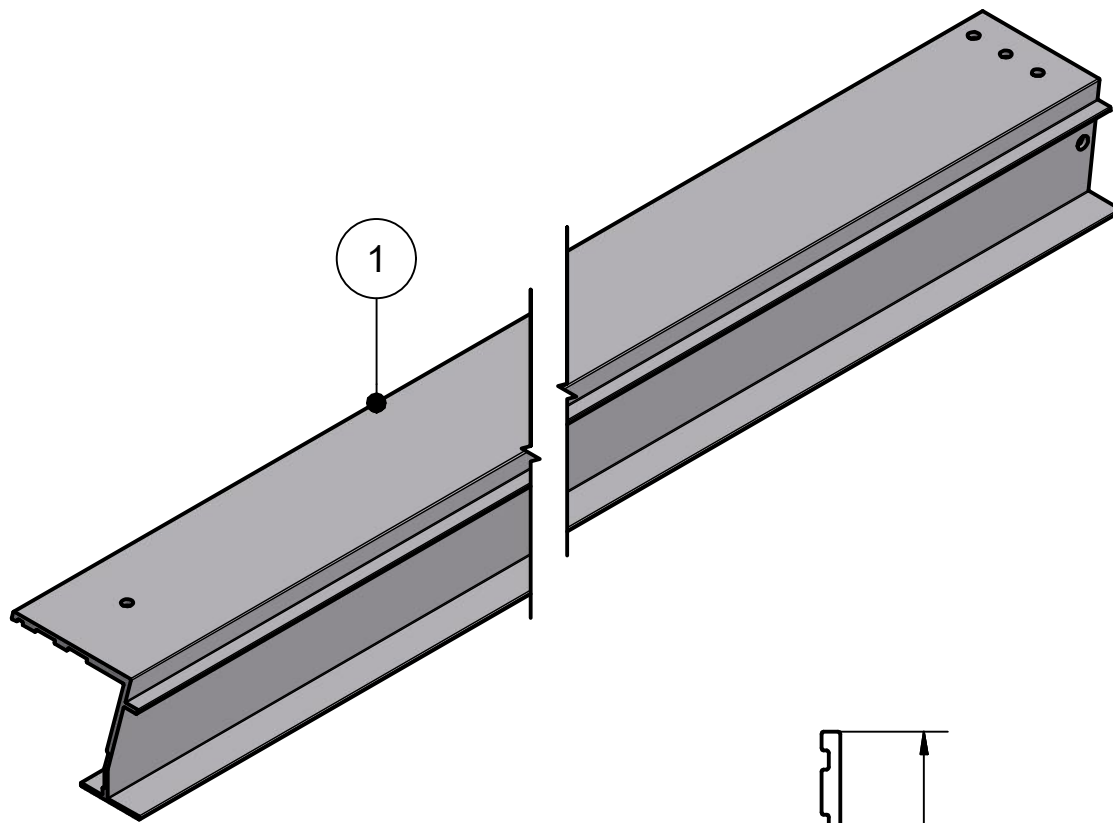
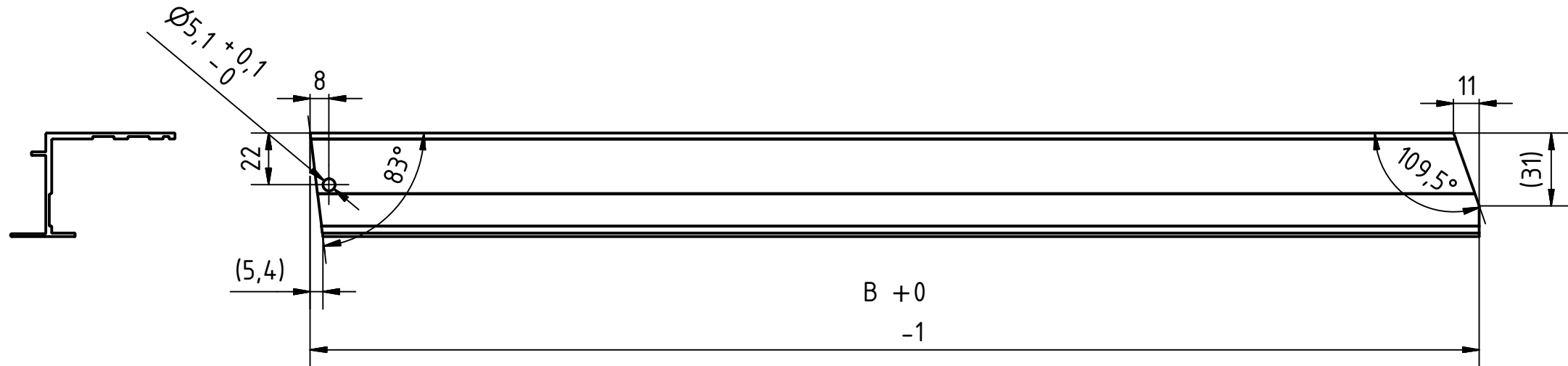
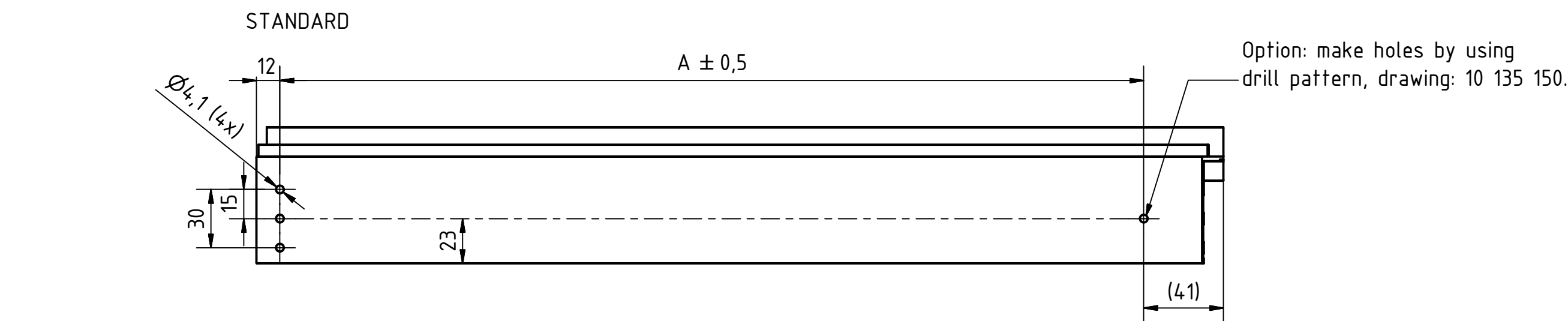
ARTICLE CODE	...	REVISION DATE	28-02-2013
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NAME	JoFr		WEIGHT	- kg/m
DATE	11-11-2010		VOLUME	- mm³
NETT WEIGHT	... kg		AREA	- mm²

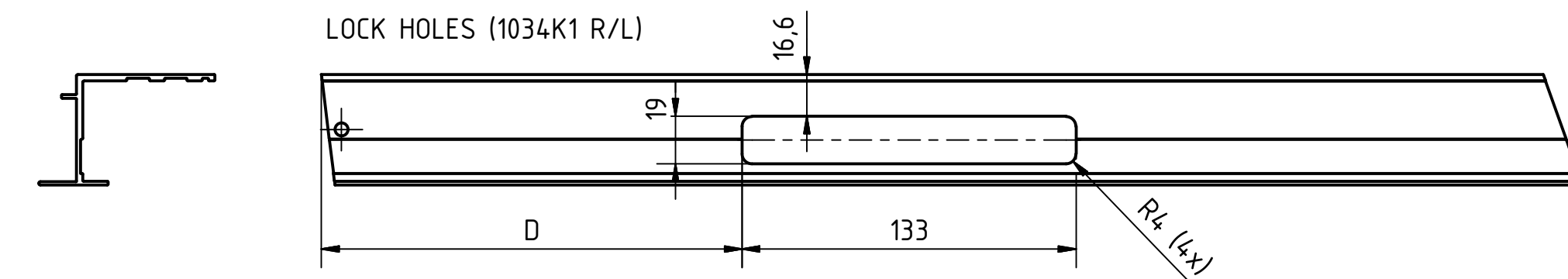
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	PANEL HEIGHT	ART.CODE	ART.CODE	ART.CODE	Dim.A	Dim.B !	Dim.C	Dim.D	WEIGHT
STANDARD	500	ALD1-500M00R/L	ALD1-500M01R/L	ALD1-500M02R/L	421.6	496.7	-	-	0,31 kg
HINGE HOLES	500	ALD1-500M10R/L	ALD1-500M11R/L	ALD1-500M12R/L	421.6	496.7	314	-	0,309 kg
LOCK HOLE	500	ALD1-500M20R/L	ALD1-500M21R/L	ALD1-500M22R/L	421.6	496.7	-	167,5	0,296 kg
STANDARD	610	ALD1-610M00R/L	ALD1-610M01R/L	ALD1-610M02R/L	531.6	606.7	-	-	0,378 kg
HINGE HOLES	610	ALD1-610M10R/L	ALD1-610M11R/L	ALD1-610M12R/L	531.6	606.7	424	-	0,376 kg
LOCK HOLE	610	ALD1-610M20R/L	ALD1-610M21R/L	ALD1-610M22R/L	531.6	606.7	-	222,5	0,36 kg

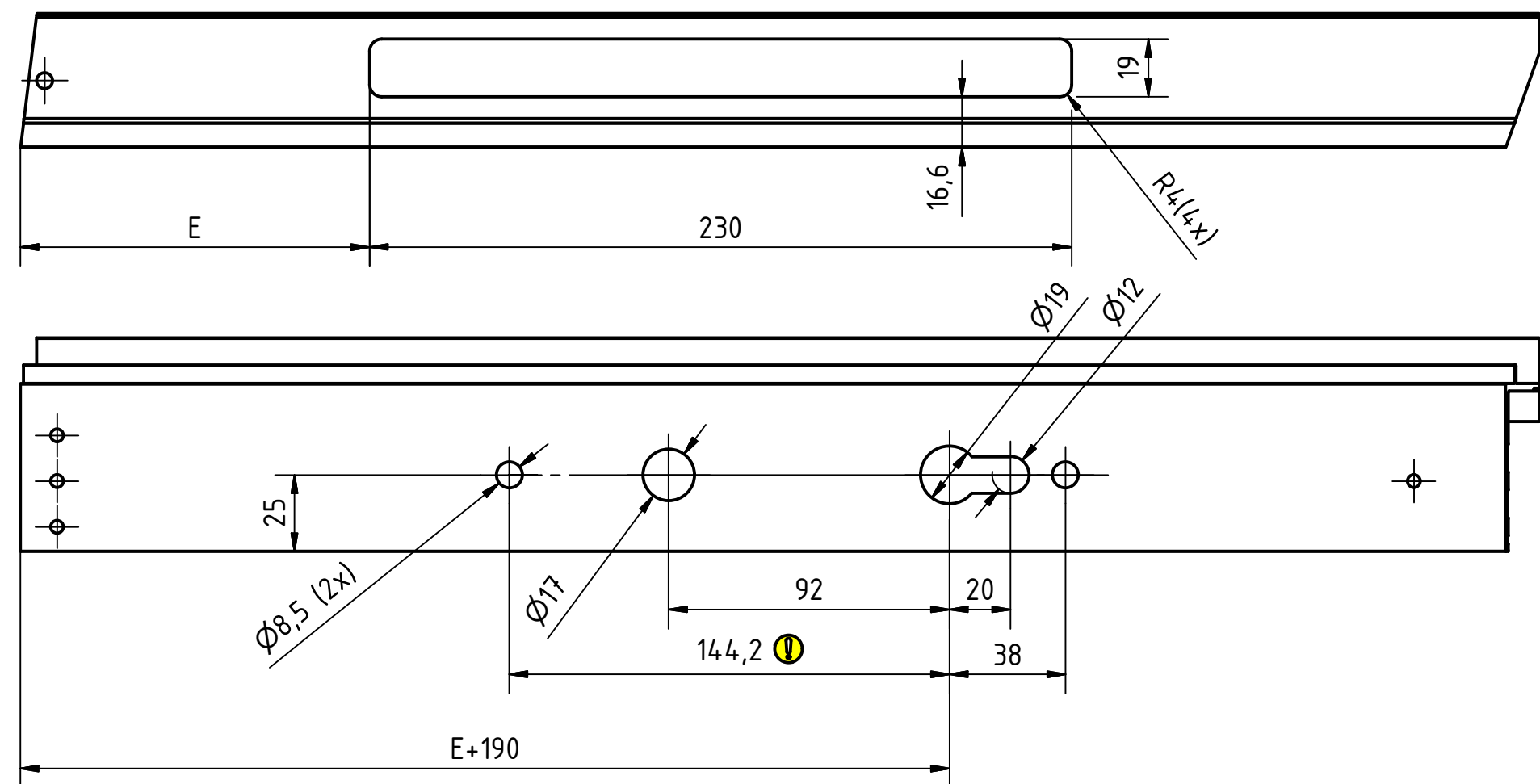
RELEASED FOR PRODUCTION



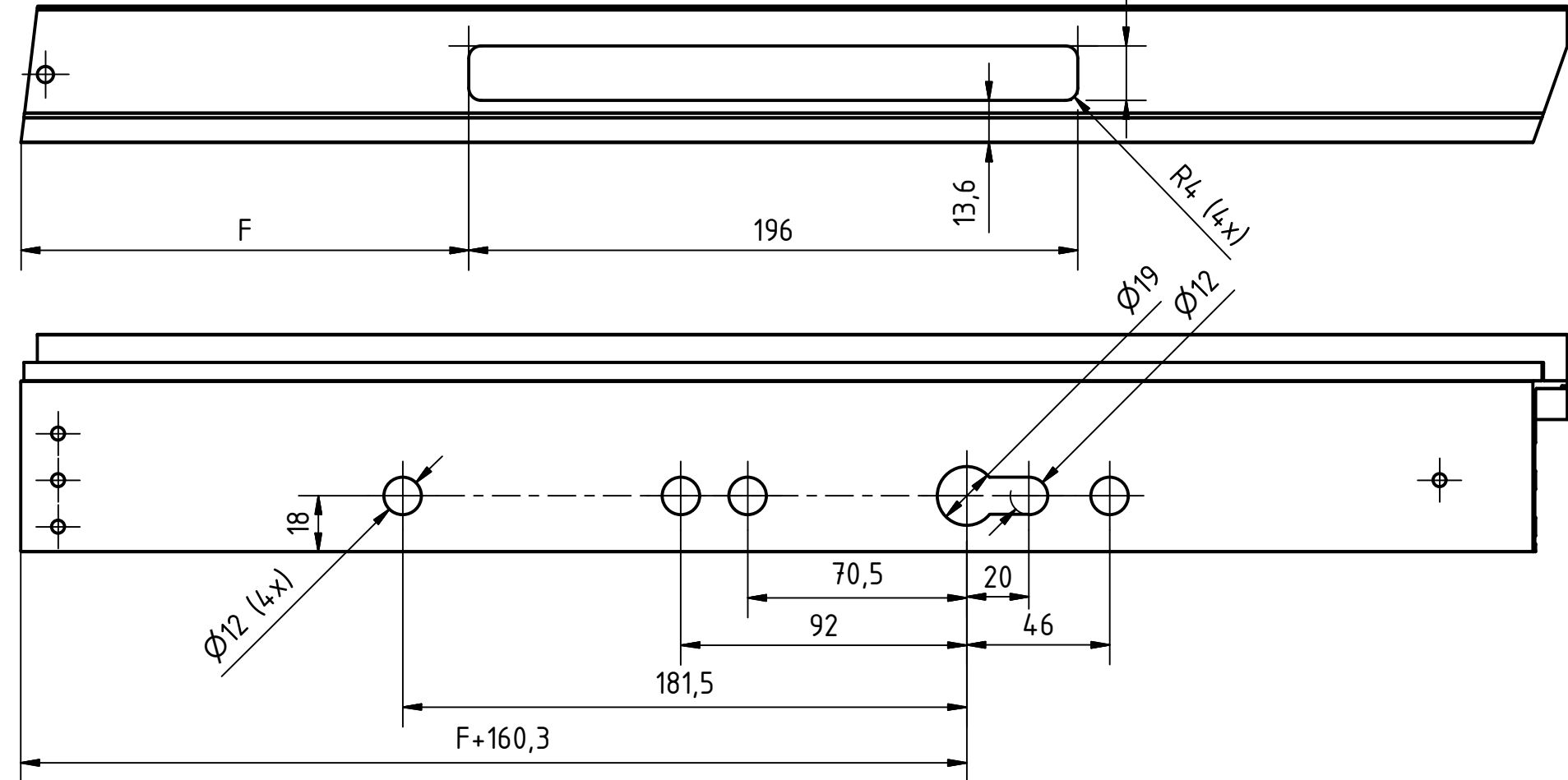
	LOCK	1034CLM	1034LOCK	1034LK1R/L
GRIP / PLATE				
1034P	PROFILE 2	PROFILE 2		-
1034PGN	PROFILE 3	PROFILE 3		PROFILE 1
1034PGHN	PROFILE 3	PROFILE 3		PROFILE 1



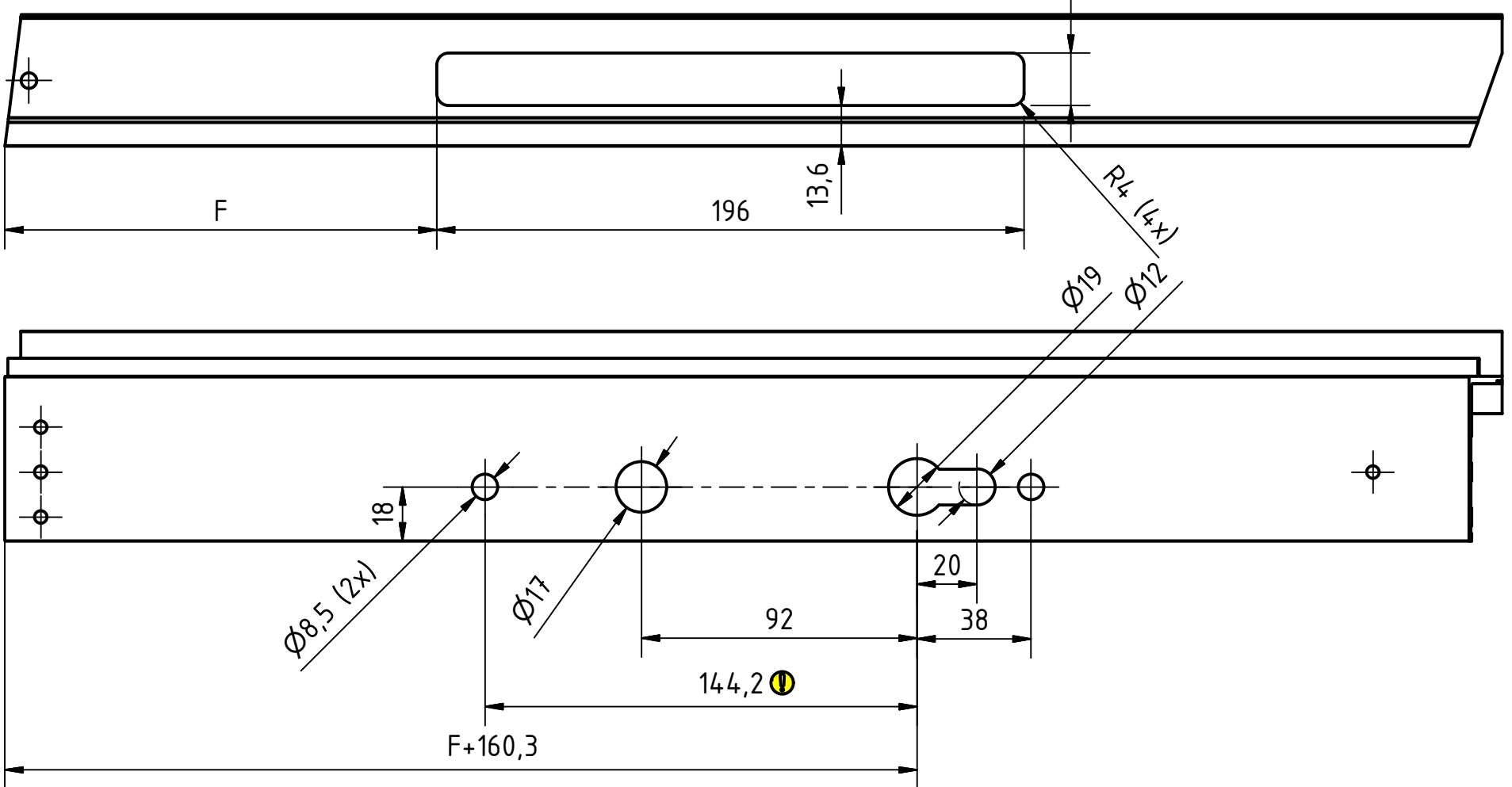
PROFILE 1



PROFILE 2



PROFILE 3



Changed / Added

Left and right version, right handed version drawn

1	1	Alu for Door Panel	1033LD...	58 149 000	07-03-2019	-
ITEM	QTY	DESCRIPTION	ARTICLE CODE	DRAWING NO.	REV. DATE	REMARKS
14-07-2020		Changed DIM 144.2 (was 164.2), changed 1034PGN & 1034PGHN (was 1034PG & 1034PGH)				DeTo
19-08-2015		Updated item 1				DeTo
26-11-2013		Changed dim 164.2, (was 157) - added lock table				OlDu
REVISION DATE		DESCRIPTION				NAME
SCALE:	1:2	GENERAL ROUGHNESS 3.2	PROJ.: 	UNIT: mm	TOLERANCES UNLESS OTHERWISE STATED Acc. TO ISO 2768-mK	
MATERIAL			Aluminium 6063 T6			
TREATMENT			...			
DESCRIPTION	Safe Step door middle panels			DRAWING NO.	58 149 220	FORM:
ARTICLE CODE	...			REVISION DATE	14-07-2020	A1
NAME	JoFr			The drawing is property of flexi force, and contains confidential information. All rights are reserved. Reproduction use for production purposes only to third parties, in any form whatsoever, is prohibited without the written authority from the proprietors.		WEIGHT - kg/m
DATE	11-Nov-10					VOLUME - mm³
NETT WEIGHT	... kg			innovations for overhead doors		AREA - mm²

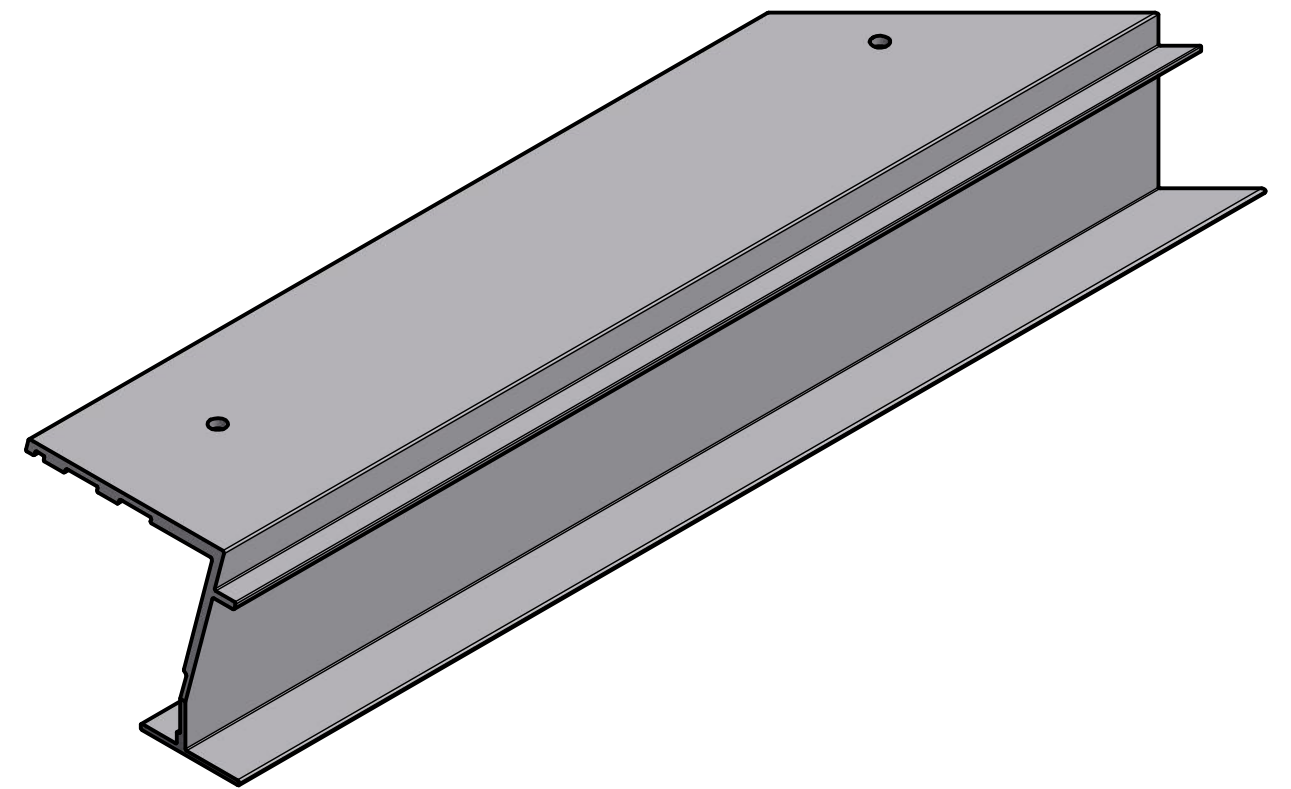
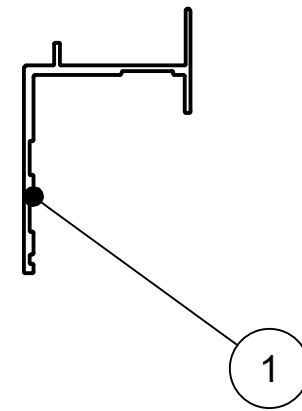
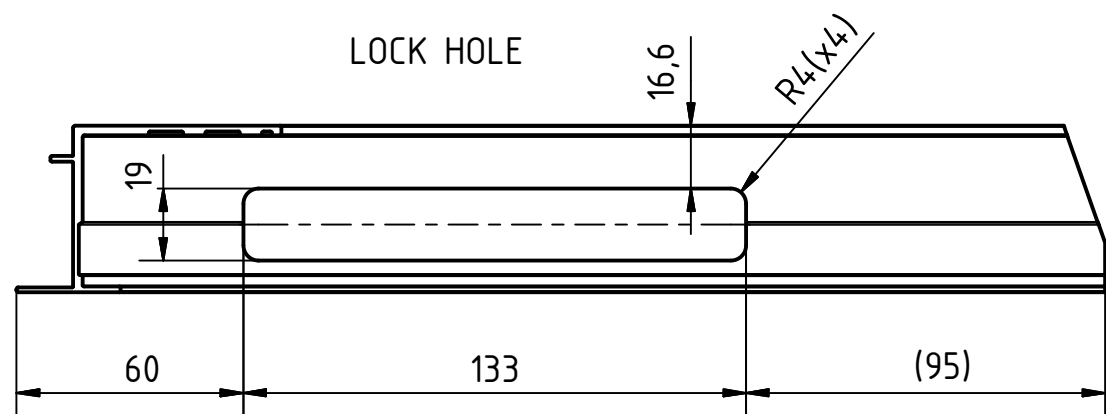
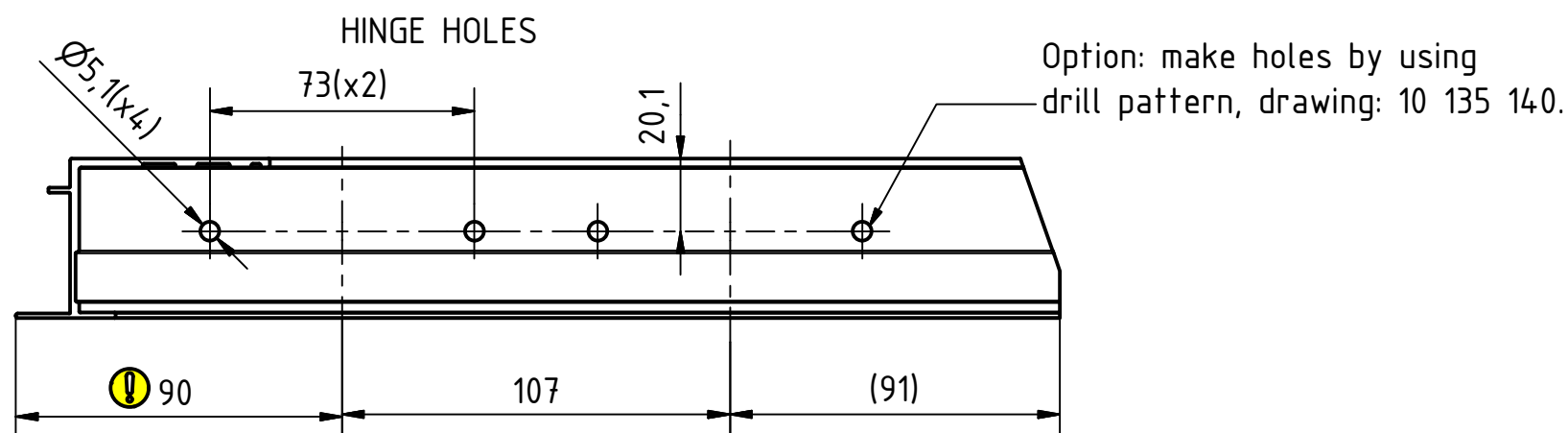
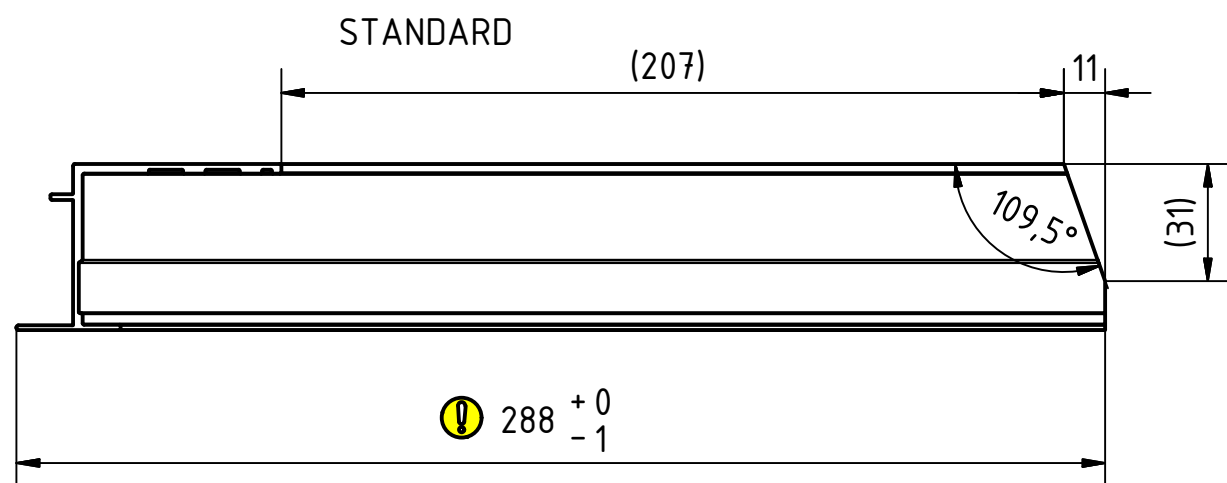
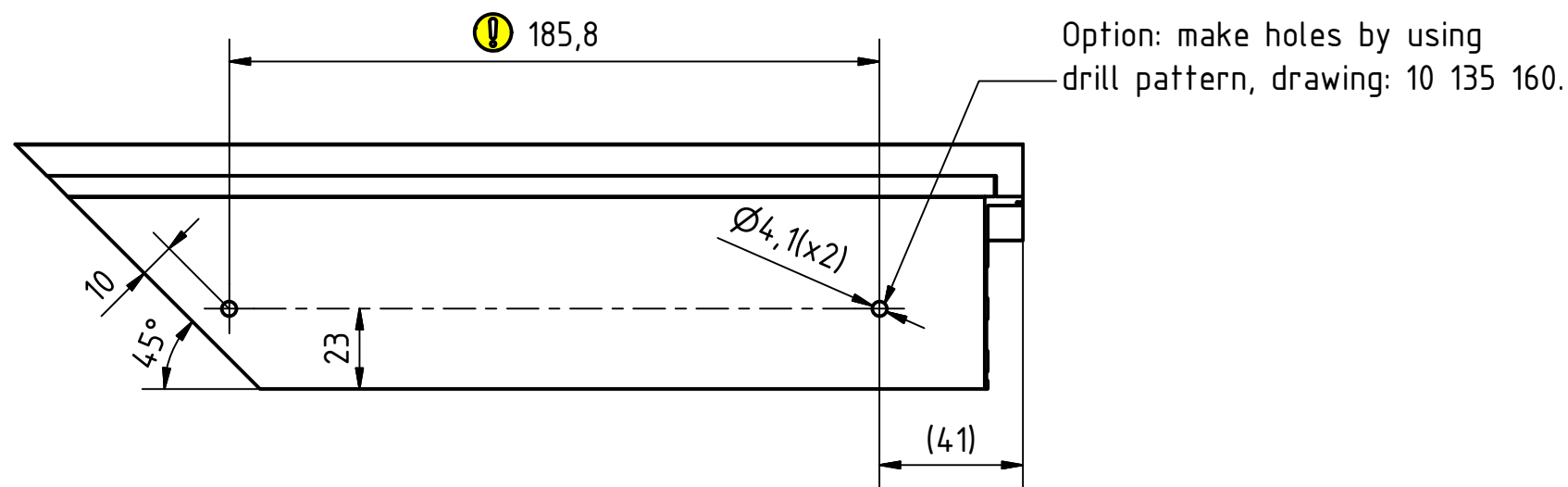
	PANEL HEIGHT	ART.CODE	ART.CODE	ART.CODE	Dim.A	Dim.B	Dim.C	Dim.D	Dim.E	Dim. F	WEIGHT
TREATMENT		BRUT	ANODISED	WHITE RAL9016							
STANDARD	500	ALD2-500M00R/L	ALD2-500M01R/L	ALD2-500M02R/L	444,5	497,5	-	-	-	-	0,325 kg
HINGE HOLES	500	ALD2-500M10R/L	ALD2-500M11R/L	ALD2-500M12R/L	444,5	497,5	314	-	-	-	0,324 kg
LOCK HOLE	500	ALD2-500M20R/L	ALD2-500M21R/L	ALD2-500M22R/L	444,5	497,5	-	167,5	-	-	0,312 kg
PROFILE 1	500	ALD2-500M30R/L	ALD2-500M31R/L	ALD2-500M32R/L	444,5	497,5	-	-	114,4	-	0,298 kg
PROFILE 2	500	ALD2-500M40R/L	ALD2-500M41R/L	ALD2-500M42R/L	444,5	497,5	-	-	-	144,1	0,301 kg
PROFILE 3	500	ALD2-500M50R/L	ALD2-500M51R/L	ALD2-500M52R/L	444,5	497,5	-	-	-	144,1	0,303 kg
STANDARD	610	ALD2-610M00R/L	ALD2-610M01R/L	ALD2-610M02R/L	554,5	607,5	-	-	-	-	0,396 kg
HINGE HOLES	610	ALD2-610M10R/L	ALD2-610M11R/L	ALD2-610M12R/L	554,5	607,5	424	-	-	-	0,395 kg
LOCK HOLE	610	ALD2-610M20R/L	ALD2-610M21R/L	ALD2-610M22R/L	554,5	607,5	-	222,5	-	-	0,38 kg
PROFILE 1	610	ALD2-610M30R/L	ALD2-610M31R/L	ALD2-610M32R/L	554,5	607,5	-	-	169,4	-	0,363 kg
PROFILE 2	610	ALD2-610M40R/L	ALD2-610M41R/L	ALD2-610M42R/L	554,5	607,5	-	-	-	199,1	0,366 kg
PROFILE 3	610	ALD2-610M50R/L	ALD2-610M51R/L	ALD2-610M52R/L	554,5	607,5	-	-	-	199,1	0,369 kg

ISO 2768m	TOLERANCE
0,5-3	±0,1
3-6	±0,1
6-30	±0,2
30-120	±0,3
120-400	±0,5
400-1000	±0,8
1000-2000	±1,2
2000-4000	±2

flexiforce

innovations for overhead doors

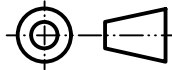
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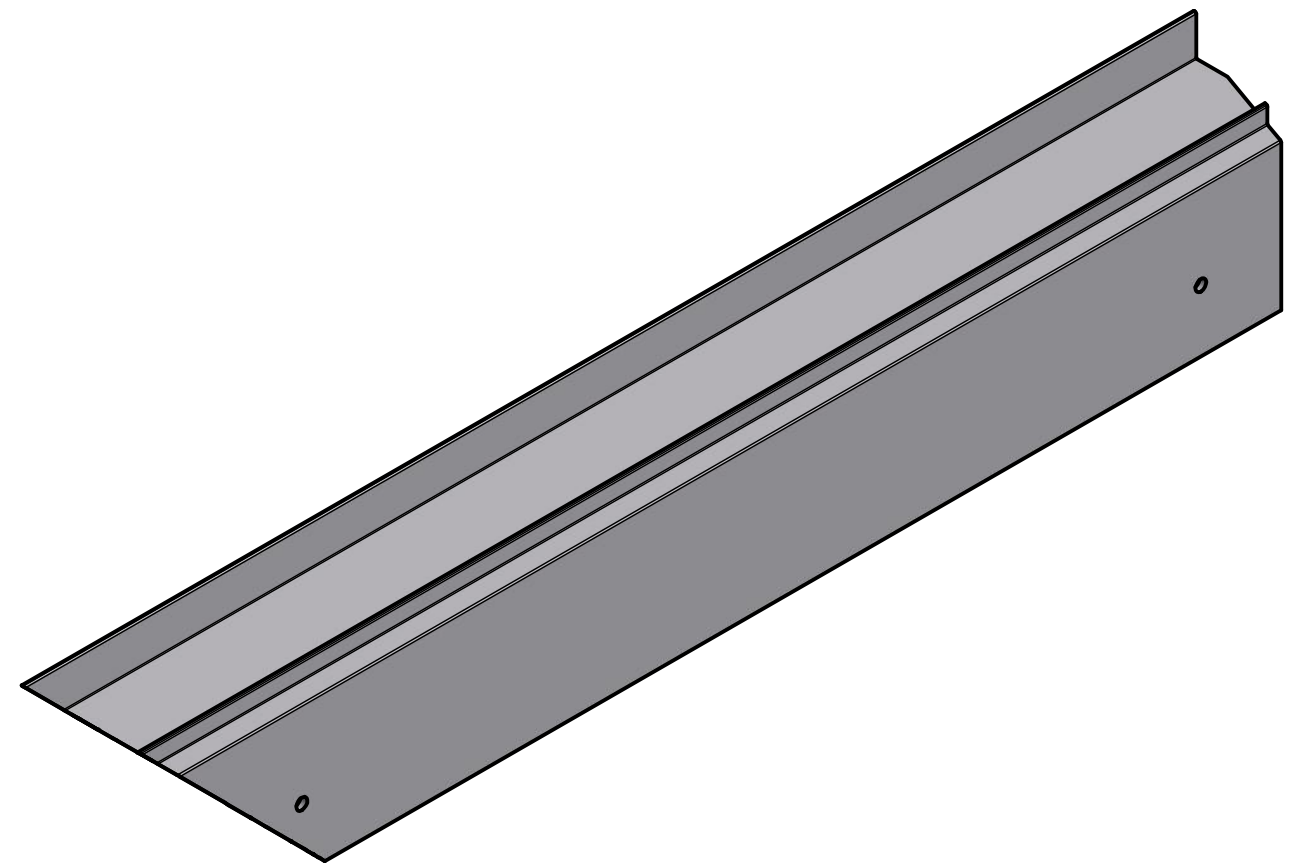
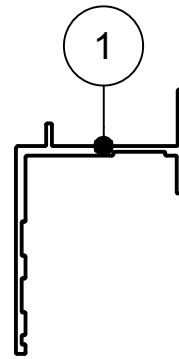
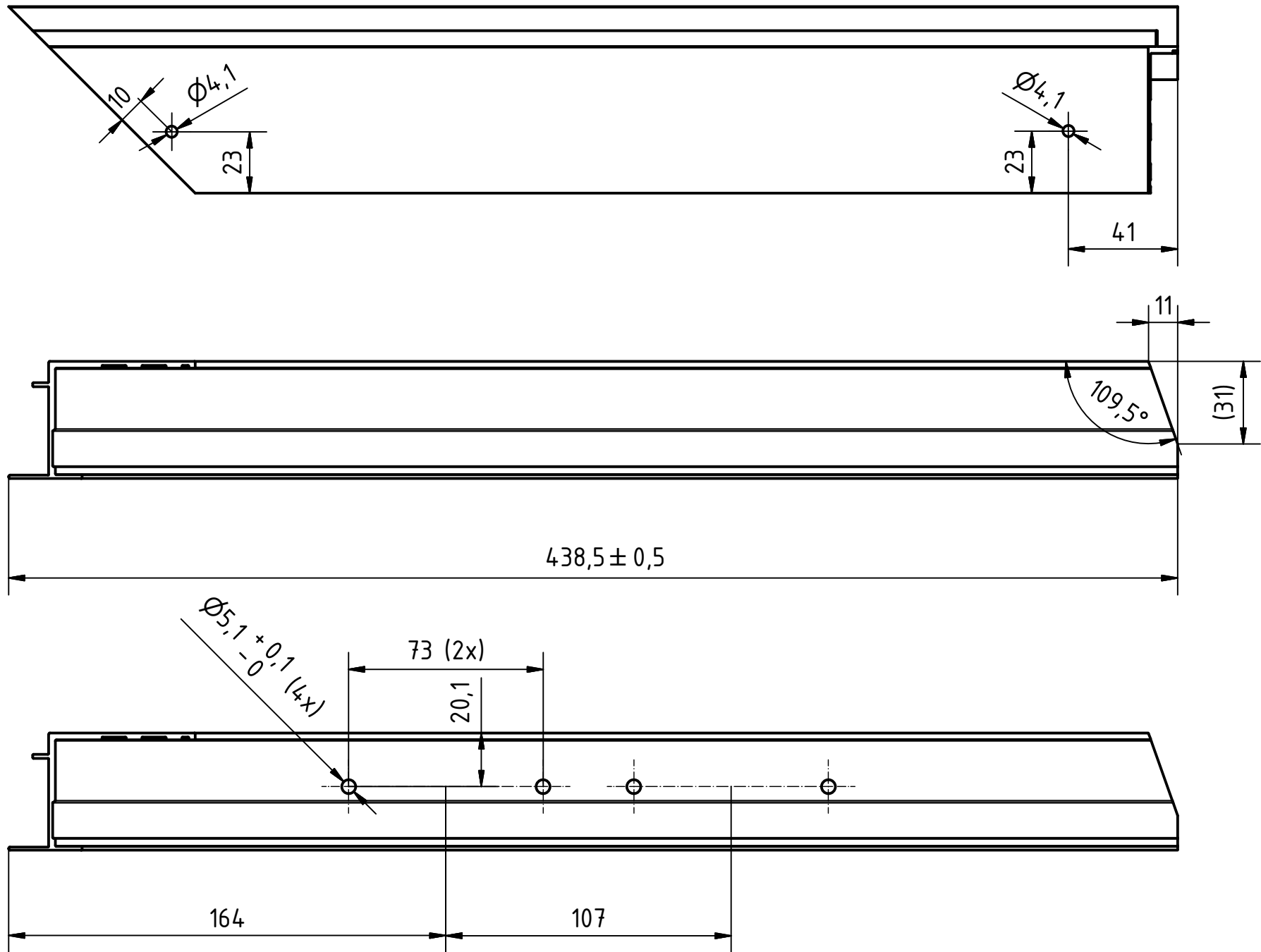
RELEASED FOR PRODUCTION

NOMINAL DIMENSION	ISO 2768m		TOLERANCE
	0.5-3		±0.1
	>3-6		±0.1
	>6-30		±0.2
	>30-120		±0.3
	>120-400		±0.5
	>400-1000		±0.8
	>1000-2000		±1.2
	>2000-4000		±2

Left and right version, right handed version drawn

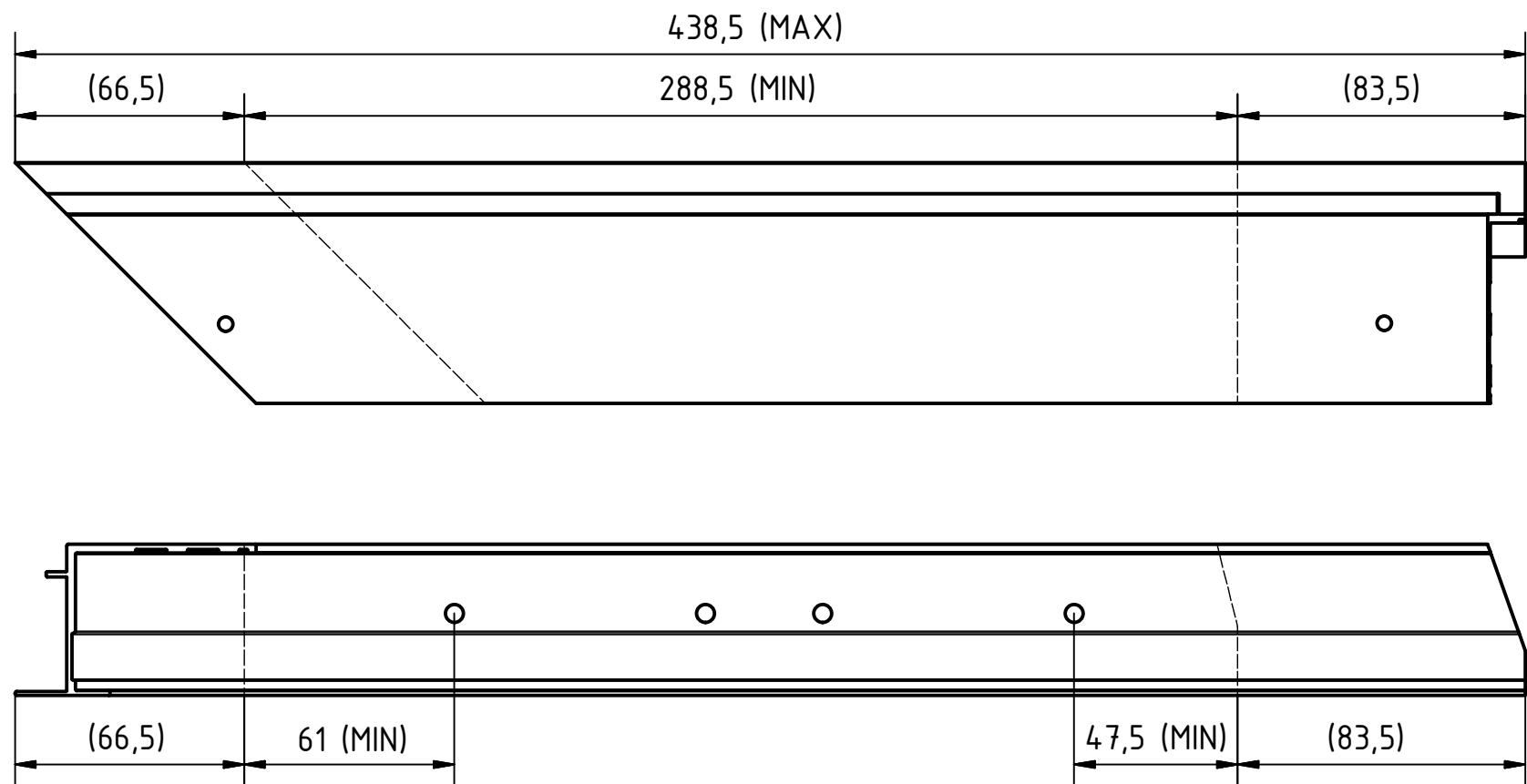
1	1	Alu for Door Panel	1033LD...	58 149 000	04-08-2011	-
ITEM	QTY	DESCRIPTION	ARTICLE CODE	DRAWING NO.	REV. DATE	REMARKS
28-02-2013		Changed 90 (was 88mm), 288 (was 285,5), 185,8 (was 183,4)			①	GiKu
18-10-2011		RFP was FIO.				MaKr
28-12-2010		Adjusted drawing numbers of drill patterns. Changed tolerance.				JoFr
REVISION DATE		DESCRIPTION				NAME
SCALE:		GENERAL ROUGHNESS	PROJ.:	UNIT:	TOLERANCES UNLESS OTHERWISE STATED Acc. TO ISO 2768-mK	
1:2		3.2/		mm		
MATERIAL		Aluminium 6063 T6				
TREATMENT		...				
DESCRIPTION	Safe Step door top panels		DRAWING NO.	58 149 230		FORM.:
ARTICLE CODE	...		REVISION DATE	28-02-2013		A2
NAME	JoFr		 This drawing is property of FlexiForce, and contains confidential information. All rights strictly reserved. Reproduction, use for production purposes, issue to third parties, in any form whatever, is not permitted without written authority from the proprietors.		WEIGHT	- kg/m
DATE	11-11-2010				VOLUME	- mm³
NETT WEIGHT	... kg				AREA	- mm²

	PANEL HEIGHT	ART.CODE	ART.CODE	ART.CODE	WEIGHT
TREATMENT		BRUT	ANODISED	WHITE RAL9016	
STANDARD	500/610	ALD3-300M00R/L	ALD3-300M01R/L	ALD3-300M02R/L	0,175 kg
HINGE HOLES	500/610	ALD3-300M10R/L	ALD3-300M11R/L	ALD3-300M12R/L	0,175 kg
LOCK HOLE	500/610	ALD3-300M20R/L	ALD3-300M21R/L	ALD3-300M22R/L	0,162 kg



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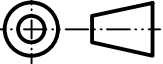
SAW INSTRUCTION BASED ON MANUAL:
SECTION HEIGHT-106,5



	PANEL HEIGHT	ART.CODE	ART.CODE	WEIGHT
TREATMENT		BRUT	ANODISED	
STANDARD	500/610	ALD3-LSBM00R/L	ALD3-LSBM01R/L	0,272 kg
HINGE HOLES	500/610	ALD3-LSBM10R/L	ALD3-LSBM11R/L	0,272 kg

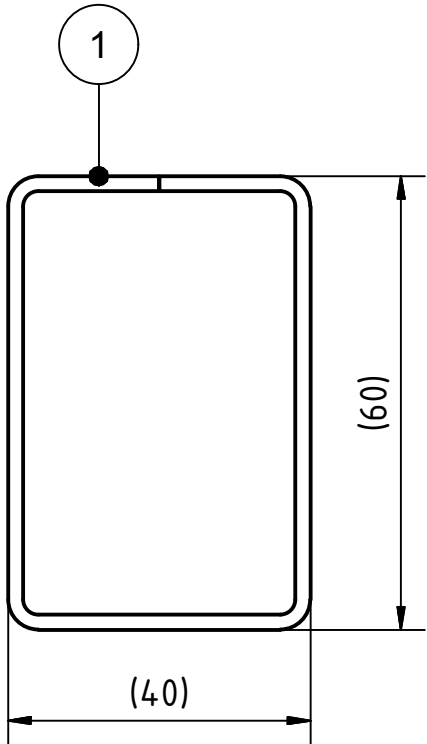
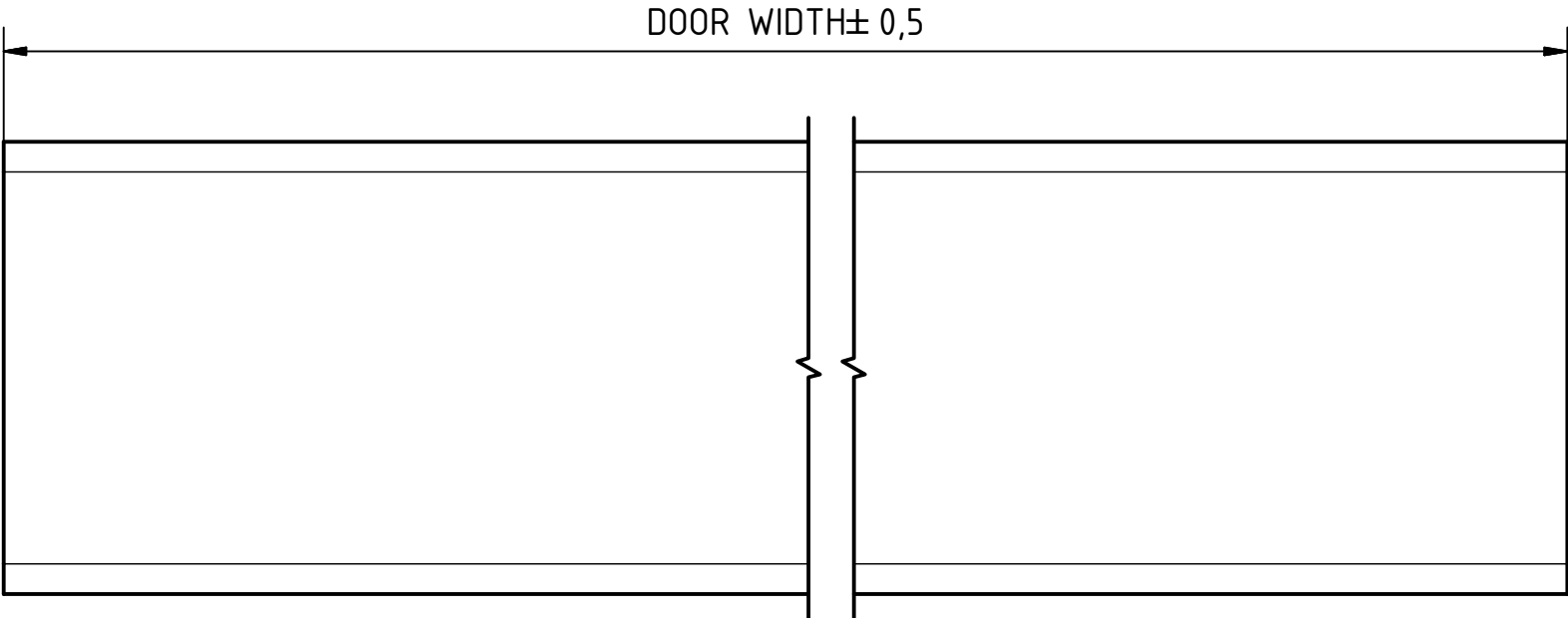
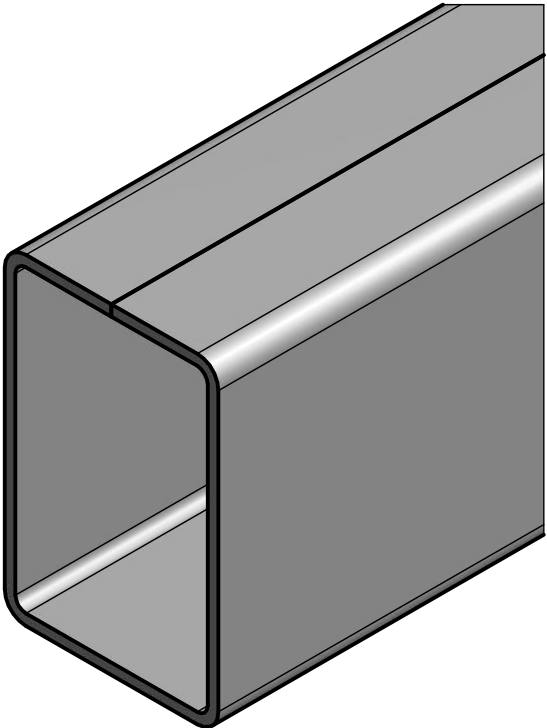
Left and right version, right handed version drawn

1	1	Alu for Door Panel	1033LD...	58 149 000	04-08-2011	-
ITEM	QTY	DESCRIPTION	ARTICLE CODE	DRAWING NO.	REV. DATE	REMARKS

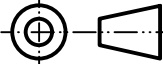
REVISION DATE		DESCRIPTION			NAME	
SCALE: 1:2	GENERAL ROUGHNESS 3.2/	PROJ.: 	UNIT: mm	TOLERANCES UNLESS OTHERWISE STATED Acc. TO ISO 2768-mK		
MATERIAL		Aluminium 6063 T6				
TREATMENT		see table				
DESCRIPTION	Safe Step door: Top section with 1033PS		DRAWING NO.	58 149 240		FORM.:
ARTICLE CODE	---		REVISION DATE	1-3-2013		A2
NAME	JoFr		This drawing is property of FlexiForce, and contains confidential information. All rights strictly reserved. Reproduction, use for production purposes, issue to third parties, in any form whatever, is not permitted without written authority from the proprietors.		WEIGHT	- kg/m
DATE	11-2-2013				VOLUME	- mm ³
NETT WEIGHT	N/A				AREA	- mm ²
		innovations for overhead doors				

ISO 2768m	TOLERANCE
0.5-3	±0.1
>3-6	±0.1
>6-30	±0.2
>30-120	±0.3
>120-400	±0.5
>400-1000	±0.8
>1000-2000	±1.2
>2000-4000	±2

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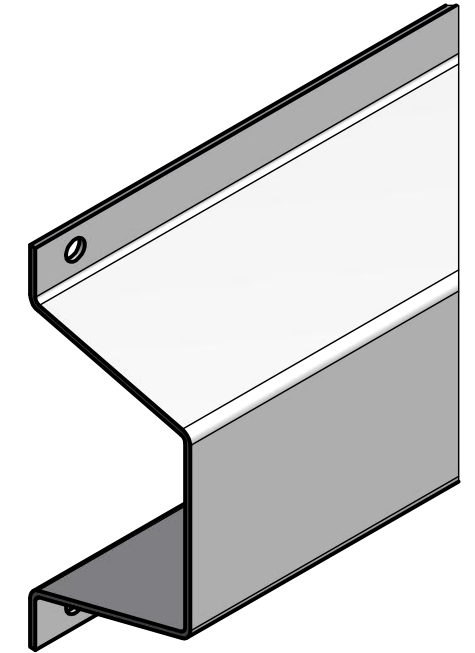
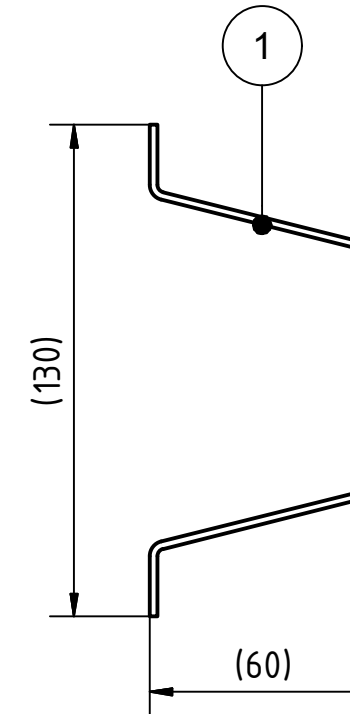
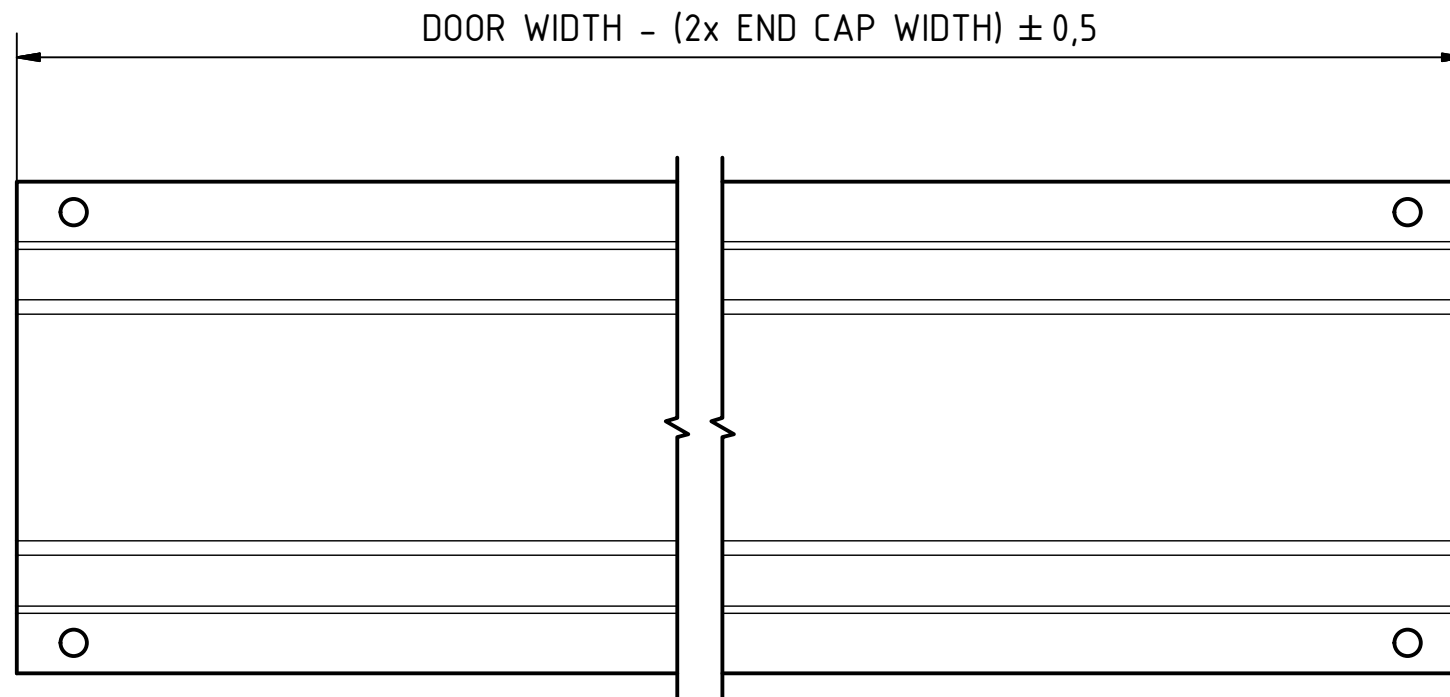


1	1	Box beam	60K40...	55 107 000	11-04-2012	-
ITEM	QTY	DESCRIPTION	ARTICLE CODE	DRAWING NO.	REV. DATE	REMARKS

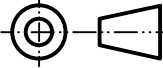
REVISION DATE		DESCRIPTION		NAME	
SCALE: 1:1	GENERAL ROUGHNESS: 3.2✓	PROJ.: 	UNIT: mm	TOLERANCES UNLESS OTHERWISE STATED Acc. TO ISO 2768-cK.	
MATERIAL		S235JRG2/Werkstoffnummer 1.0038			
TREATMENT		-			
DESCRIPTION	Box beam		DRAWING NO.	55 107 101	
ARTICLE CODE	60K40-...		REVISION DATE	23-01-2013	
NAME	MaKr	 innovations for overhead doors		WEIGHT	2,95 kg/m
DATE	23-1-2013			VOLUME	- mm ³
NETT WEIGHT	N/A			AREA	- mm ²

NOMINAL DIMENSION	ISO 2768c		TOLERANCE
	0.5-3		±0.2
	>3-6		±0.3
	>6-30		±0.5
	>30-120		±0.8
	>120-400		±1.2
	>400-1000		±2
	>1000-2000		±3
	>2000-4000		±4

RELEASED FOR
PRODUCTION

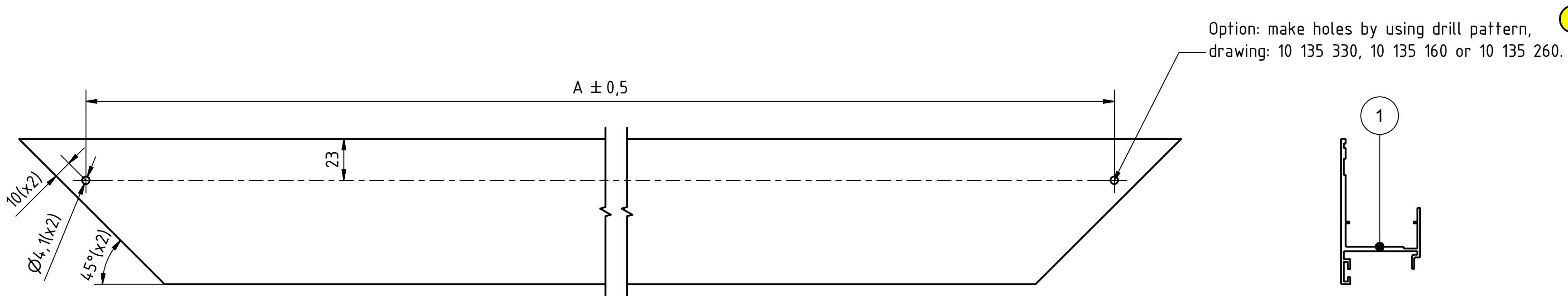


1	1	Passdoor strut	80PS...	56 117 000	10-12-2009	-
ITEM	QTY	DESCRIPTION	ARTICLE CODE	DRAWING NO.	REV. DATE	REMARKS

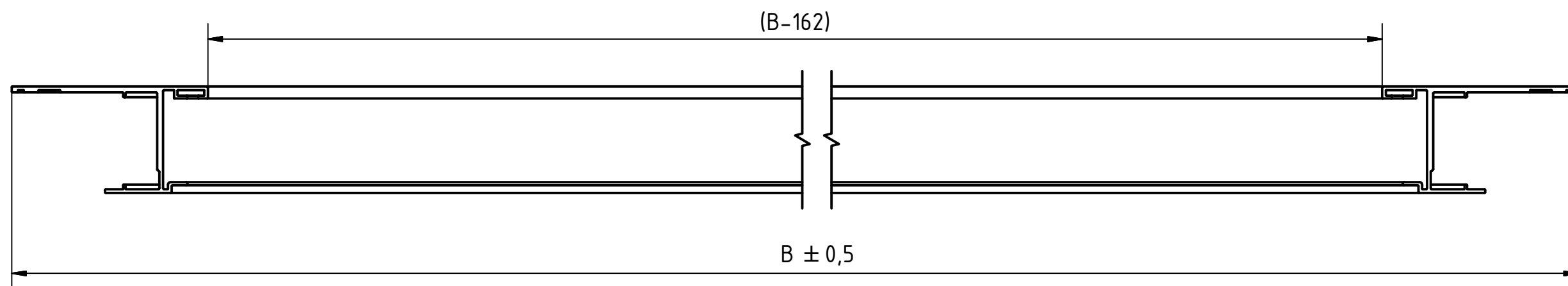
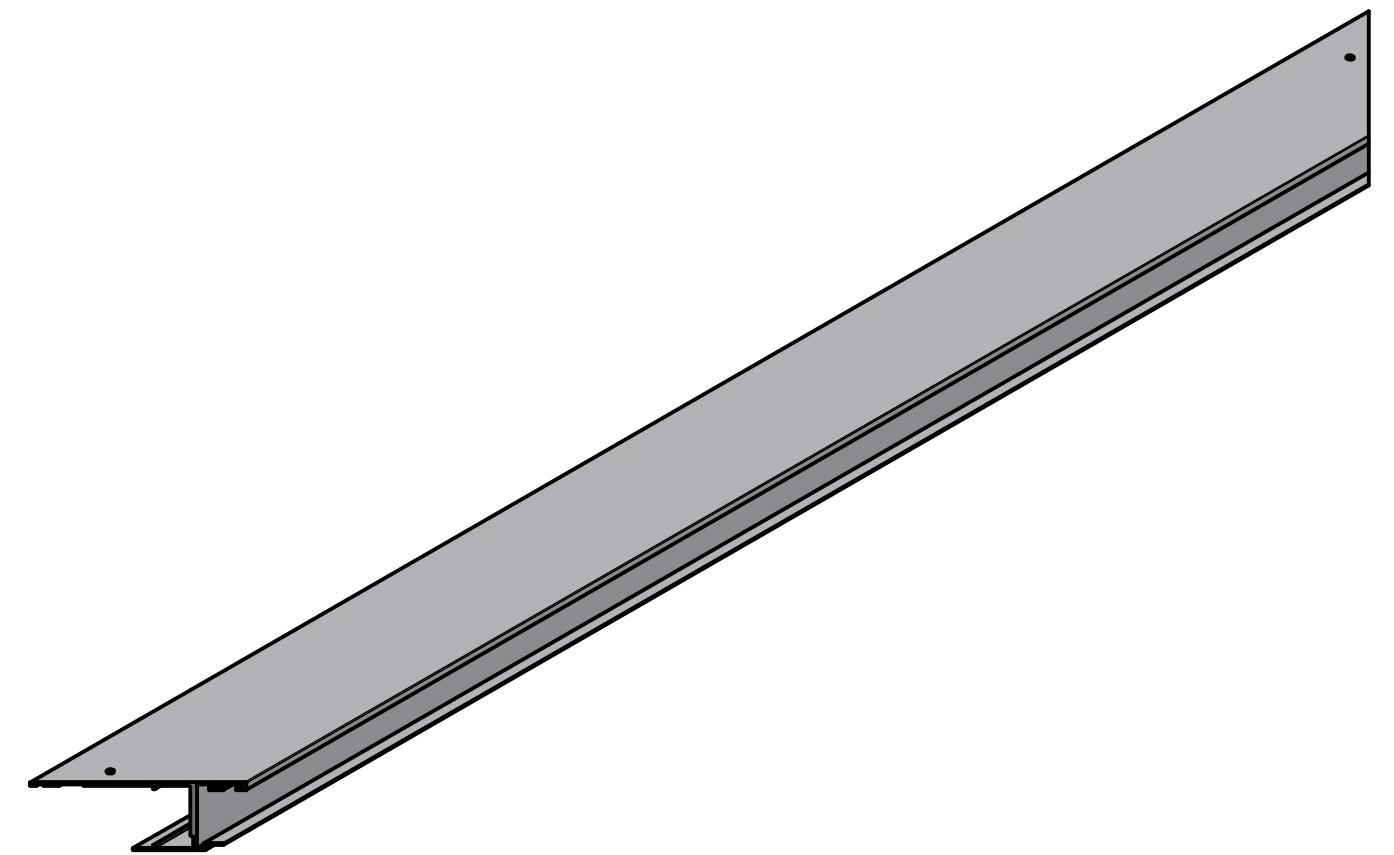
REVISION DATE		DESCRIPTION			NAME	
SCALE: 1:2	GENERAL ROUGHNESS: 3.2✓	PROJ.: 	UNIT: mm	TOLERANCES UNLESS OTHERWISE STATED Acc. TO ISO 2768-cK.		
MATERIAL		DX51D+Z200-M-A-C, RAL 9016				
TREATMENT		-				
DESCRIPTION	Passdoor strut		DRAWING NO.	56 117 101		FORM.: A3
ARTICLE CODE	80PS-...		REVISION DATE	23-01-2013		
NAME	MaKr	 FF innovations for overhead doors			WEIGHT	3,42 kg/m
DATE	23-1-2013				VOLUME	- mm ³
NETT WEIGHT	N/A				AREA	- mm ²
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NOMINAL DIMENSION	ISO 2768c		TOLERANCE
	0.5-3	±0.2	
	>3-6	±0.3	
	>6-30	±0.5	
	>30-120	±0.8	
	>120-400	±1.2	
	>400-1000	±2	
	>1000-2000	±3	
	>2000-4000	±4	

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PRODUCTION



NOMINAL DIMENSION	ISO 2768m	TOLERANCE
	0.5-3	±0.1
>3-6	±0.1	
>6-30	±0.2	
>30-120	±0.3	
>120-400	±0.5	
>400-1000	±0.8	
>1000-2000	±1.2	
>2000-4000	±2	

! changed / added

ITEM	QTY	DESCRIPTION	ARTICLE CODE	DRAWING NO.	REV. DATE	REMARKS
1	1	Alu for Door Casing	1033LS...	58 148 000	21-02-2011	-

23-01-2013	Updated drill pattern remark	JiGa
05-05-2011	RFP was FIO.	JoFr
28-12-2010	Changed drill pattern drawing number.	JoFr
REVISION DATE	DESCRIPTION	NAME

SCALE: 1:2	GENERAL ROUGHNESS 3.2	PROJ.	UNIT: mm	TOLERANCES UNLESS OTHERWISE STATED Acc. TO ISO 2768-mK
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MATERIAL	Aluminium 6063 T6
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TREATMENT	...
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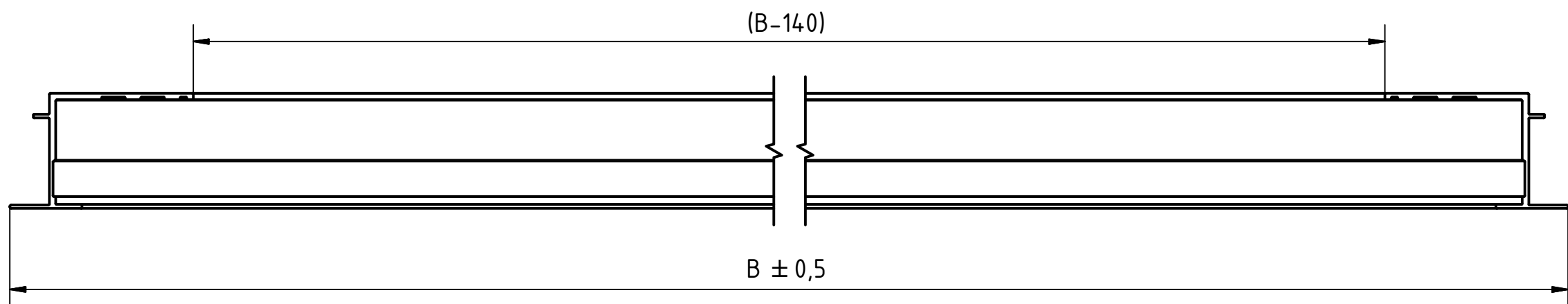
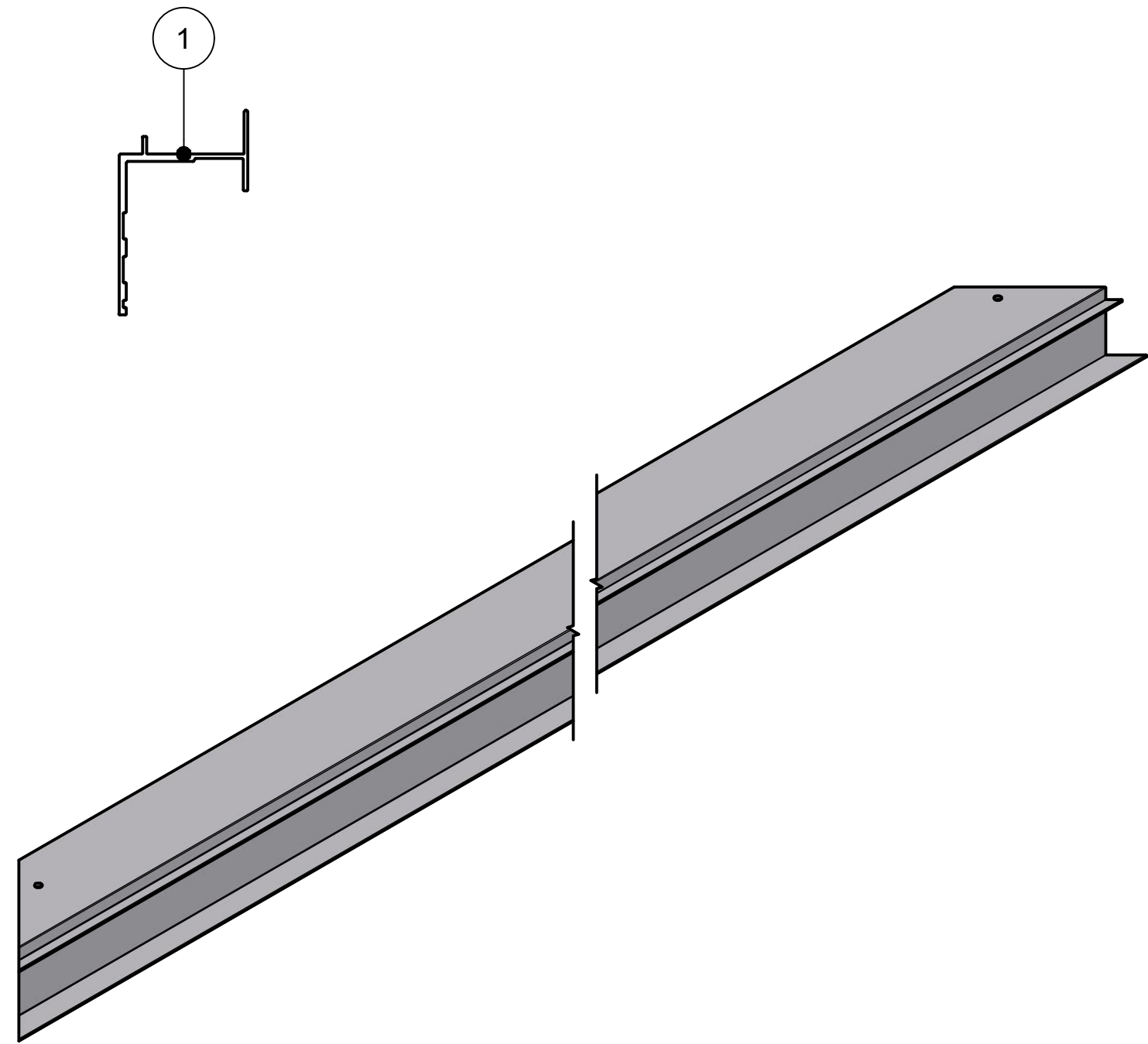
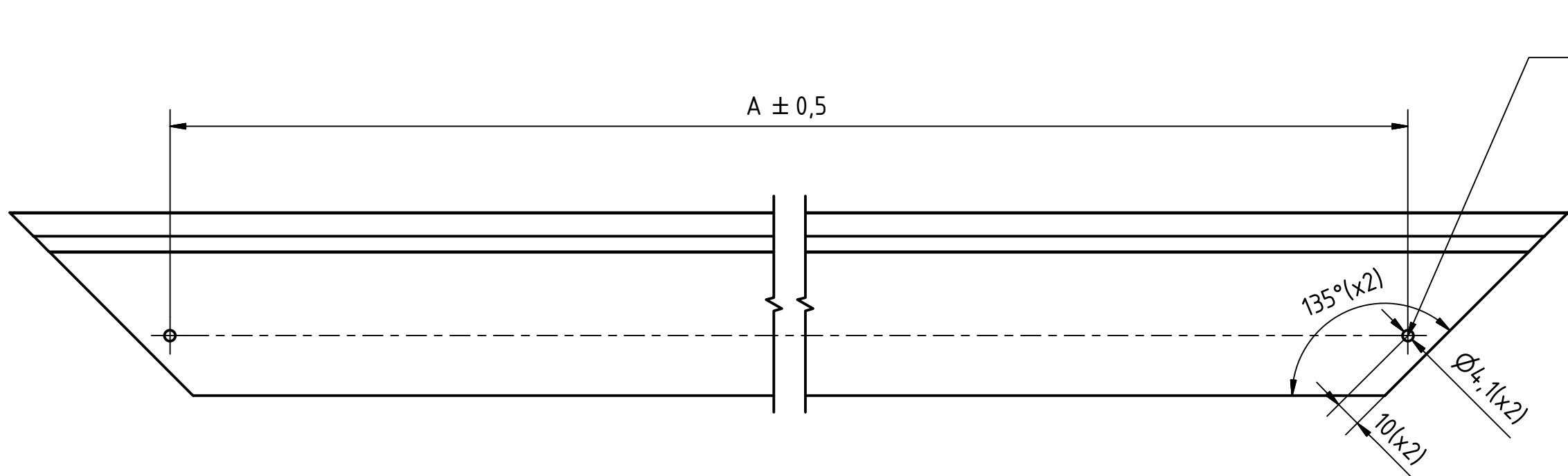
DESCRIPTION	Safe Step sheet horizontal	DRAWING NO.	58 148 140	FORM.: A2
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ARTICLE CODE	...	REVISION DATE	23-01-2013
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NAME	JoFr		WEIGHT	- kg/m
DATE	11-11-2010		VOLUME	- mm ³
NETT WEIGHT	... kg		AREA	- mm ²

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	ART.CODE	ART.CODE	ART.CODE	Dim.A	Dim.B	WEIGHT
TREATMENT	BRUT	ANODISED	WHITE RAL9016			
STANDARD	ALS4-1002U00	ALS4-1002U01	ALS4-1002U02	927,7	1002	0,831 kg
STANDARD	ALS4-1212U00	ALS4-1212U01	ALS4-1212U02	1137,7	1212	1,005 kg



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ISO 2768m		TOLERANCE
NOMINAL DIMENSION	0.5-3	±0.1
	>3-6	±0.1
	>6-30	±0.2
	>30-120	±0.3
	>120-400	±0.5
	>400-1000	±0.8
	>1000-2000	±1.2
	>2000-4000	±2

1	1	Alu for Door Panel	1033LD...	58 149 000	04-08-2011	-
ITEM	QTY	DESCRIPTION	ARTICLE CODE	DRAWING NO.	REV. DATE	REMARKS

23-01-2013	Added new Art. Codes (replaces ALD4-860 & ALD1073). Updated drill pattern remark.					JiGa
05-05-2011	RFP was FIO.					JoFr
28-12-2010	Adjusted drawing number of drill pattern.					JoFr
REVISION DATE	DESCRIPTION					NAME

SCALE: 1:2	GENERAL ROUGHNESS 3.2	PROJ.: 	UNIT: mm	TOLERANCES UNLESS OTHERWISE STATED Acc. TO ISO 2768-mK	
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MATERIAL	Aluminium 6063 T6				
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TREATMENT	...				
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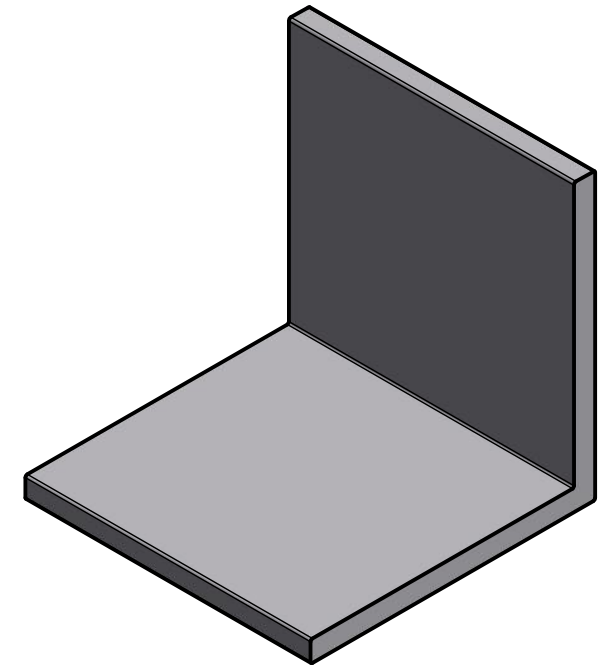
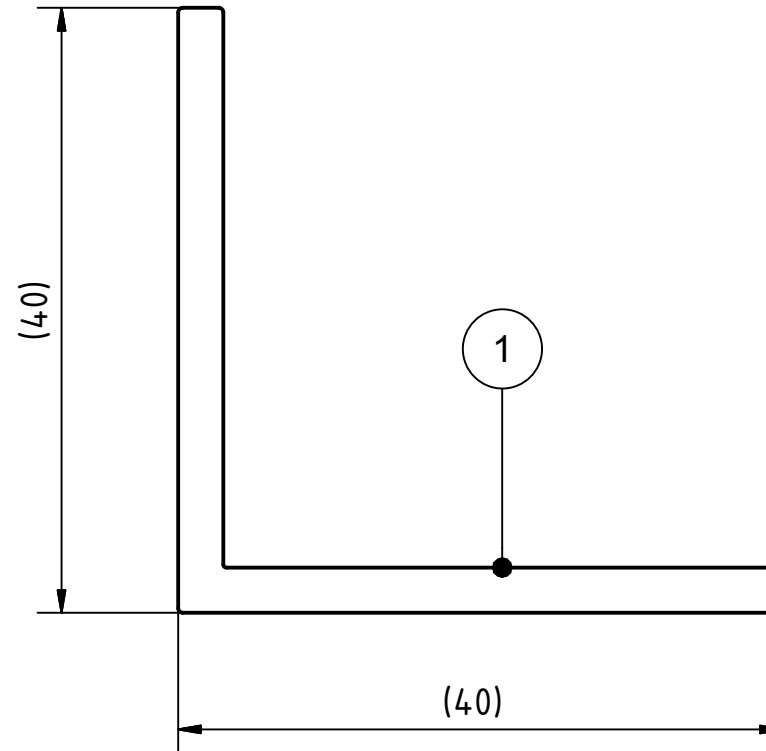
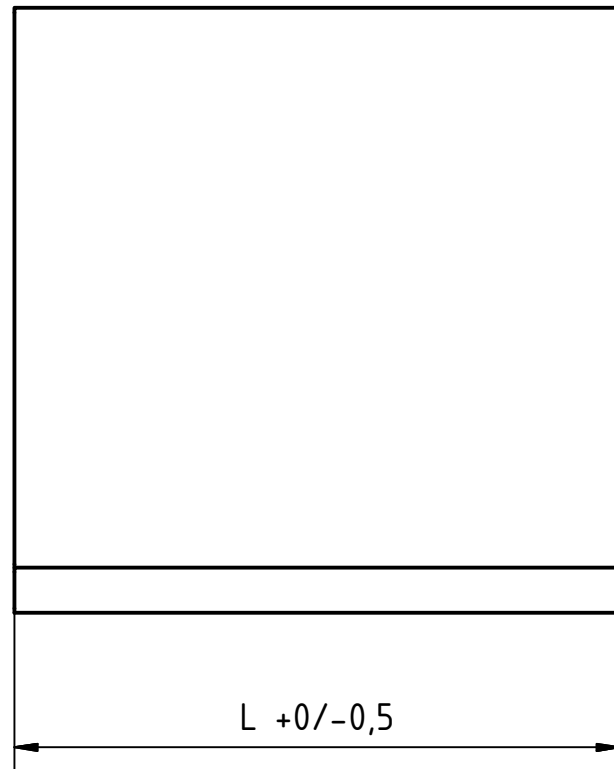
DESCRIPTION	Safe Step door horizontal		DRAWING NO.	58 149 140		FORM.: A2
ARTICLE CODE	...		REVISION DATE	23-01-2013		

NAME	JoFr	 innovations for overhead doors	This drawing is property of FlexiForce, and contains confidential information. All rights strictly reserved. Reproduction, use for production purposes issue to third parties, in any form whatever, is not permitted without written authority from the proprietors.	WEIGHT	- kg/m
DATE	11-11-2010		VOLUME	- mm ³	
NETT WEIGHT	... kg		AREA	- mm ²	

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	ART.CODE	ART.CODE	ART.CODE	Dim.A	Dim.B	WEIGHT
TREATMENT	BRUT	ANODISED	WHITE RAL9016			
STANDARD	ALD4-860U00	ALD4-860U01	ALD4-860U02	737,7	860	0,538 kg
STANDARD	ALD4-1070U00	ALD4-1070U01	ALD4-1070U02	947,7	1070	0,656 kg

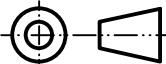
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1	1	Side Pass Door Corner Profile	1033AL3000	58 187 000	14-05-2012	-
ITEM	QTY	DESCRIPTION	ARTICLE CODE	DRAWING NO.	REV. DATE	REMARKS

Art. Code	L
1033AL-40	40 mm
1033AL-33,25	33,2 mm
1033AL-34,5	34,5 mm
1033AL-32,75	32,75 mm

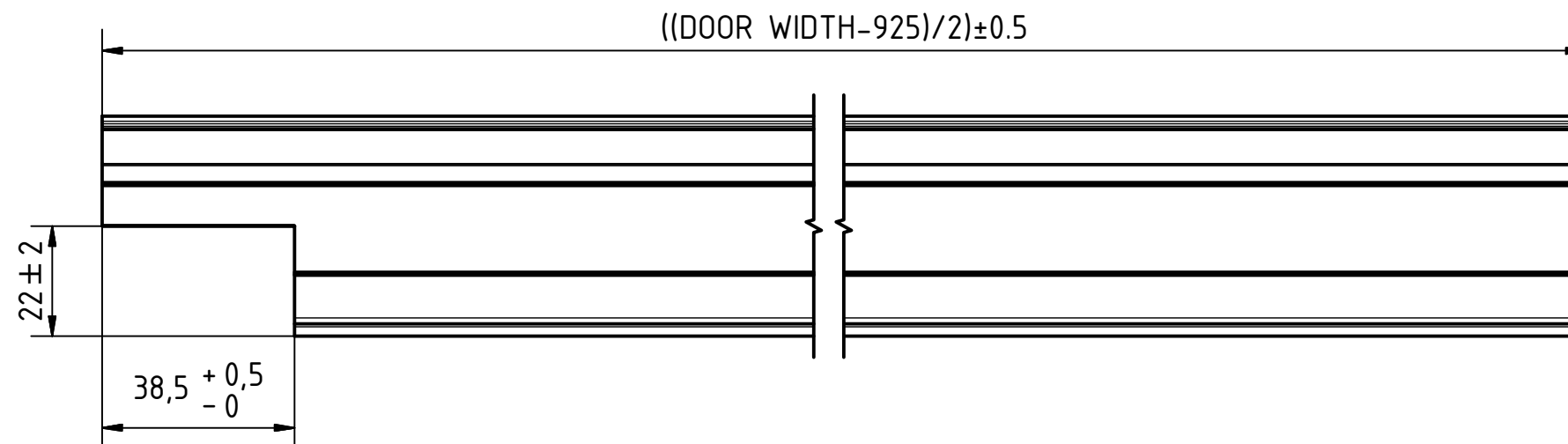
NOMINAL DIMENSION	ISO 2768c		TOLERANCE
	ISO 2768c	TOLERANCE	
0.5-3		±0.2	
>3-6		±0.3	
>6-30		±0.5	
>30-120		±0.8	
>120-400		±1.2	
>400-1000		±2	
>1000-2000		±3	
>2000-4000		±4	

REVISION DATE		DESCRIPTION			NAME	
SCALE: 2:1	GENERAL ROUGHNESS: 0.2✓	PROJ.: 	UNIT: mm	TOLERANCES UNLESS OTHERWISE STATED Acc. TO ISO 2768-cK.		
MATERIAL		Aluminium 6063 T6				
TREATMENT		-				
DESCRIPTION	Side Pass Door Corner Profile		DRAWING NO.	58 187 101		FORM.: A3
ARTICLE CODE	See table		REVISION DATE	23-01-2013		
NAME	JiGa	 innovations for overhead doors			WEIGHT	0,6 kg/m
DATE	23-1-2013				VOLUME	- mm ³
NETT WEIGHT	N/A				AREA	- mm ²

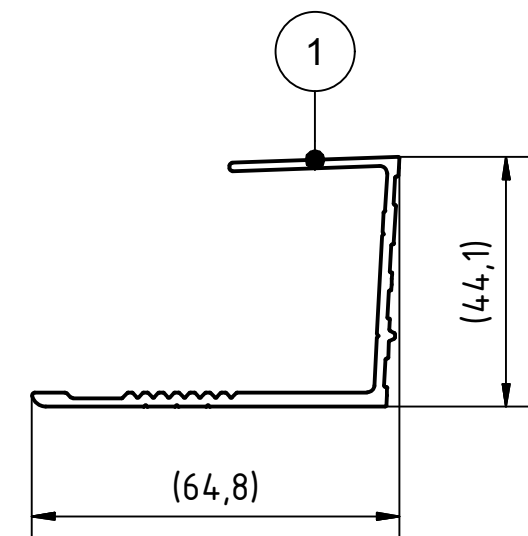
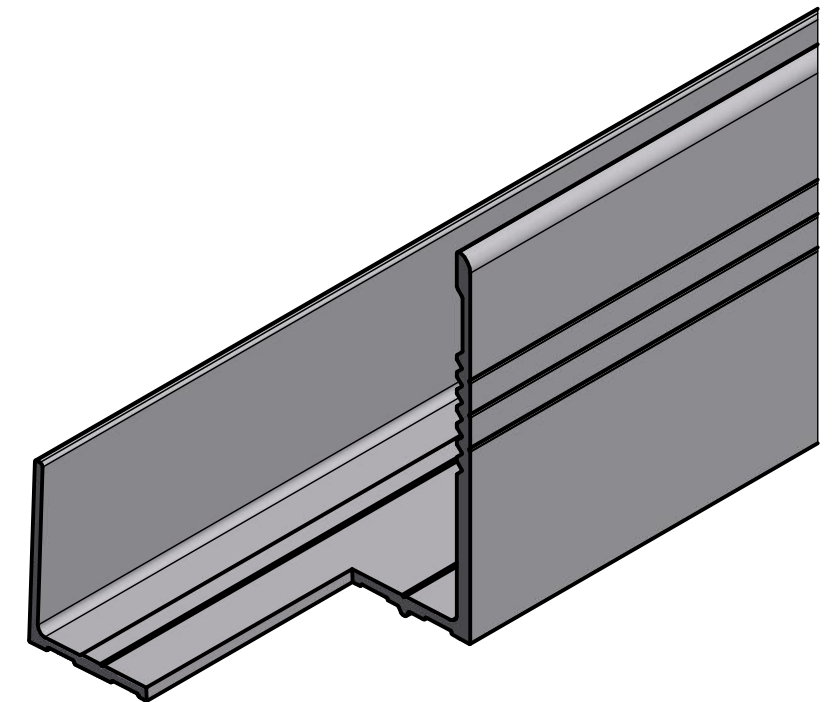
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Note:

If pass door is not in the middle,
the length of these profiles change.

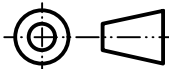


Left and right version, right handed version drawn

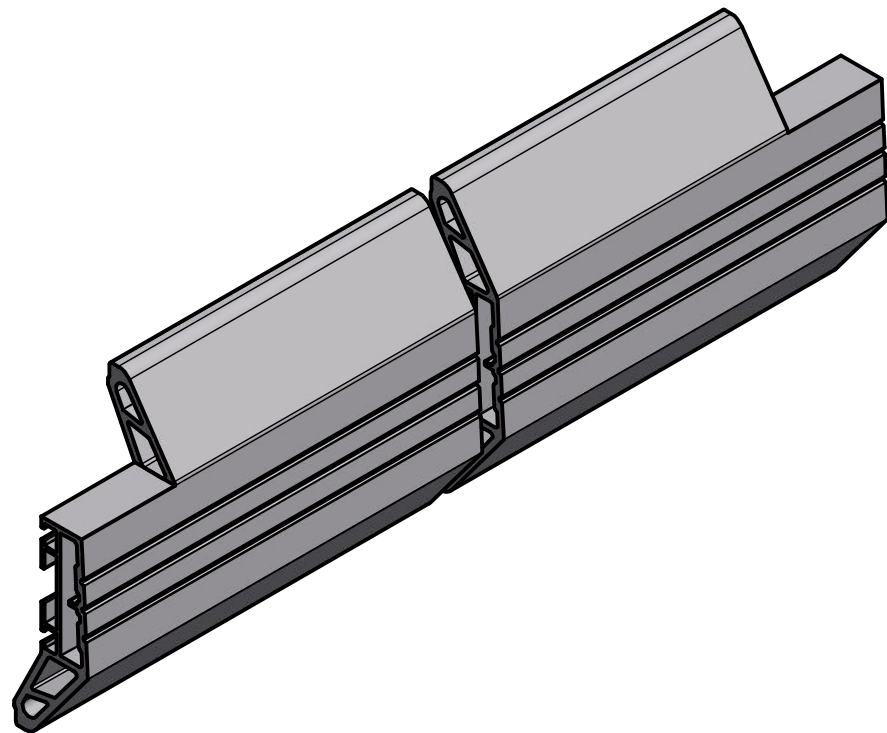
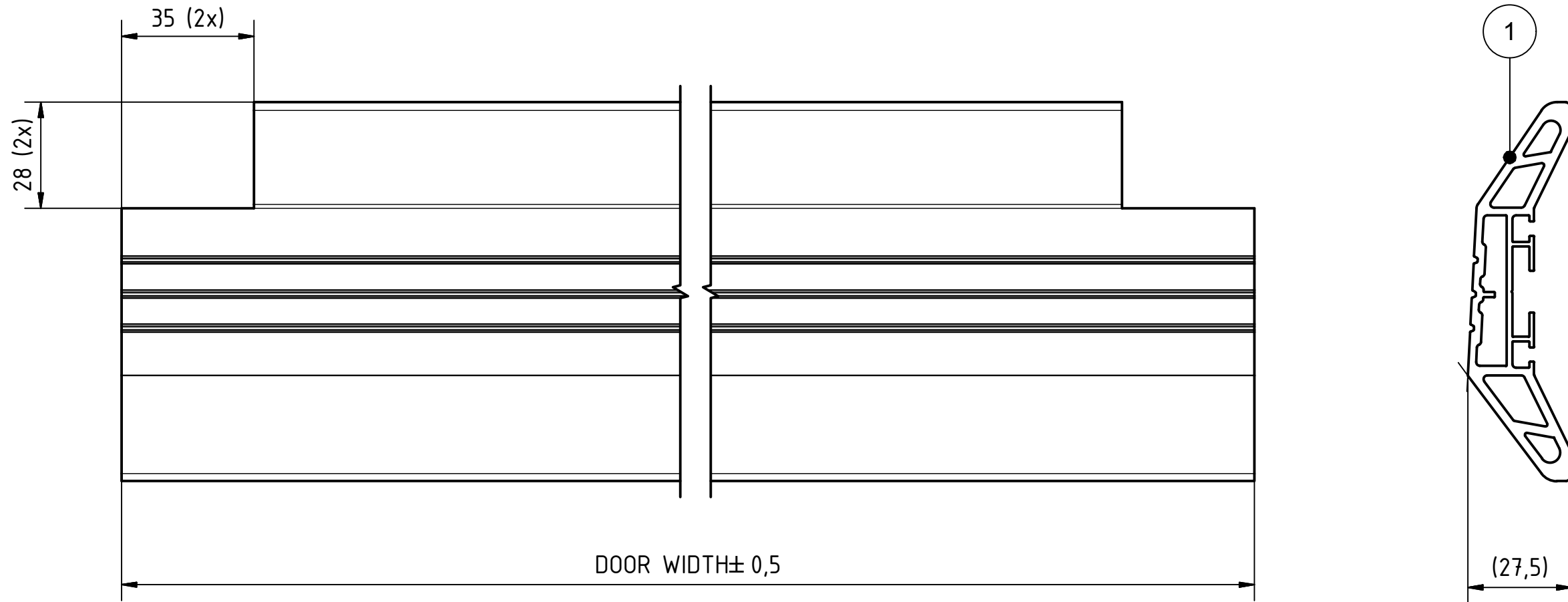


1	1	Upper part profile 40 mm	1041U....	58 194 000	5-3-2012	-
ITEM	QTY	DESCRIPTION	ARTICLE CODE	DRAWING NO.	REV. DATE	REMARKS

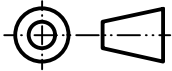
NOMINAL DIMENSION	ISO 2768c		TOLERANCE
	0.5-3	±0.2	
	>3-6	±0.3	
	>6-30	±0.5	
	>30-120	±0.8	
	>120-400	±1.2	
	>400-1000	±2	
	>1000-2000	±3	
	>2000-4000	±4	

REVISION DATE		DESCRIPTION			NAME	
SCALE: 3:4	GENERAL ROUGHNESS: 0.2✓	PROJ.: 	UNIT: mm	TOLERANCES UNLESS OTHERWISE STATED Acc. TO ISO 2768-cK.		
MATERIAL		Aluminium 6063 T6				
TREATMENT		-				
DESCRIPTION	Upper part profile 40 mm		DRAWING NO.	58 194 101		
ARTICLE CODE	1041U...R/L		REVISION DATE	23-01-2013		
NAME	Oldu	flexiforce FF innovations for overhead doors			FORM.: A3	
DATE	23-1-2013					
NETT WEIGHT	N/A					
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					VOLUME	- mm ³
					AREA	- mm ²

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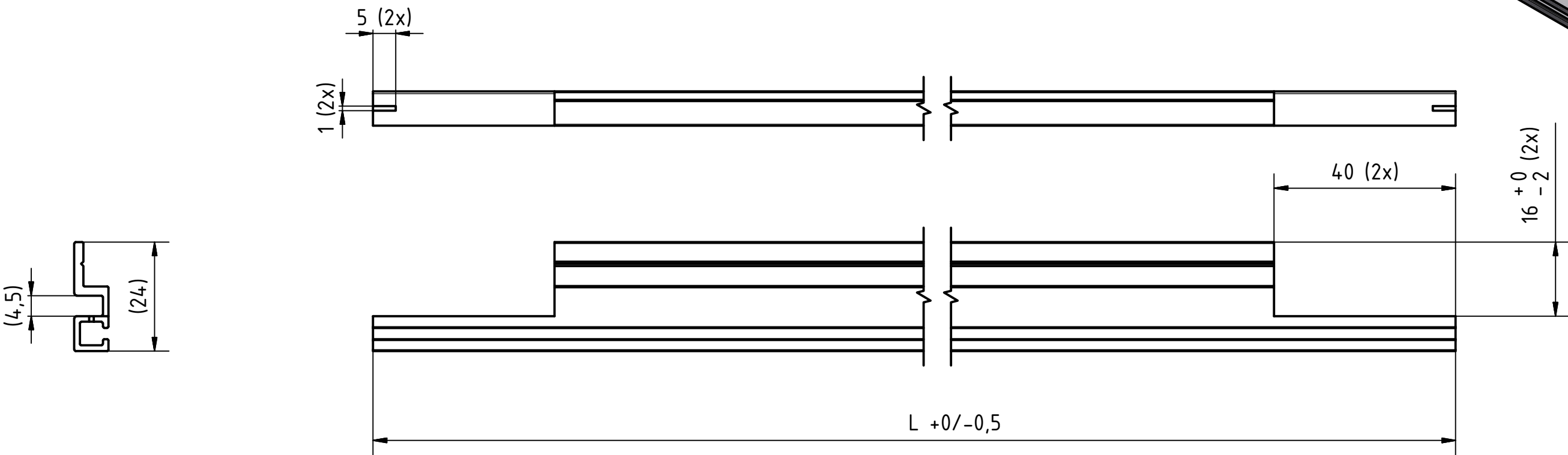
1	1	Low threshold profile	1041LTB	58 195 000	5-3-2012	-
ITEM	QTY	DESCRIPTION	ARTICLE CODE	DRAWING NO.	REV. DATE	REMARKS

REVISION DATE		DESCRIPTION			NAME	
SCALE: 3:4	GENERAL ROUGHNESS: 0.2 ✓	PROJ.: 	UNIT: mm	TOLERANCES UNLESS OTHERWISE STATED Acc. TO ISO 2768-cK.		
MATERIAL		Aluminium 6063 T6				
TREATMENT		-				
DESCRIPTION	Low threshold profile		DRAWING NO.	58 195 101		FORM.:
ARTICLE CODE	1041LTB...		REVISION DATE	23-01-2013		A3
NAME	Oldu	 innovations for overhead doors			WEIGHT	1,787 kg/m
DATE	23-1-2013				VOLUME	- mm ³
NETT WEIGHT	N/A				AREA	- mm ²
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NOMINAL DIMENSION	ISO 2768c		TOLERANCE
	ISO 2768c	TOLERANCE	
0.5-3		±0.2	
>3-6		±0.3	
>6-30		±0.5	
>30-120		±0.8	
>120-400		±1.2	
>400-1000		±2	
>1000-2000		±3	
>2000-4000		±4	

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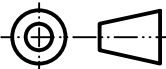
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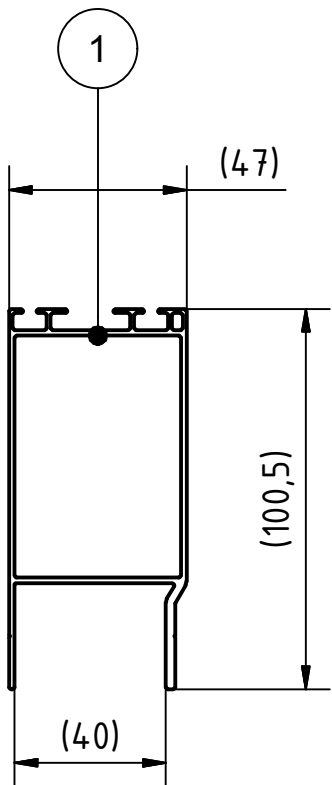
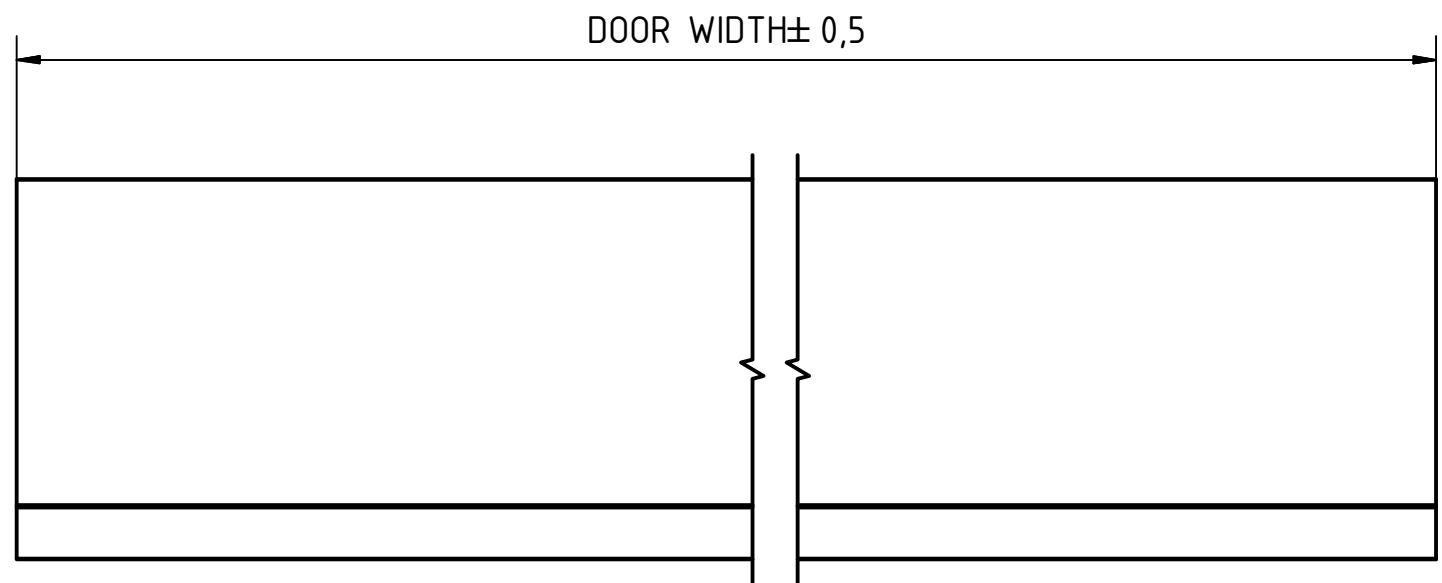
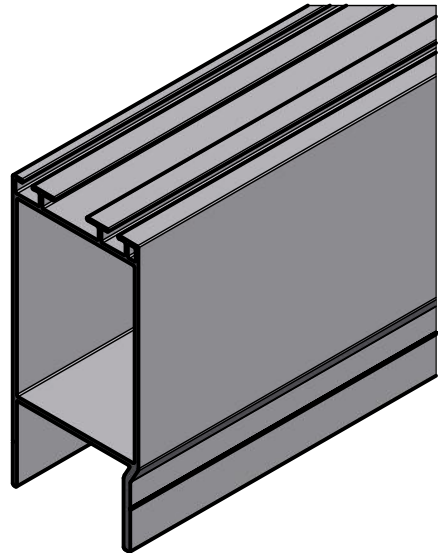
Art. Code	L	Treatment	Use	Drawing No.	Weight
1033LBNB-833	833 mm	Brut	1033LBNB-...	58 226 001	0,15 kg
1033LBNA-833	833 mm	Anodised	1033LBN-...	58 226 001	0,15 kg
1033LBNB-830	830 mm	Brut	1033LBNB-...	58 226 001	0,15 kg
1033LBN-830	830 mm	Anodised	1033LBN-...	58 226 001	0,15 kg

! Changed / Added

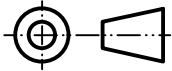
NOMINAL DIMENSION	ISO 2768m	TOLERANCE
	0.5-3	±0.1
	>3-6	±0.1
	>6-30	±0.2
	>30-120	±0.3
	>120-400	±0.5
	>400-1000	±0.8
	>1000-2000	±1.2
	>2000-4000	±2

13-02-2013	Added Art. Codes 1033LBNB-830 & 1033LBN-830			JiGa	
08-02-2013	Changed Art. Codes (was 1033LBNB-830 & 1033LBNA-830)			JiGa	
26-11-2012	Changed RFP (was RFT)			JiGa	
REVISION DATE	DESCRIPTION			NAME	
SCALE: 1:1	GENERAL ROUGHNESS: 	PROJ.: 	UNIT: mm	TOLERANCES UNLESS OTHERWISE STATED Acc. TO ISO 2768-mK	
MATERIAL		Aluminium 6063 T6			
TREATMENT		See table			
DESCRIPTION	Low threshold alu profile for seal - Length: 833mm - ...		DRAWING NO.	58 226 101	
ARTICLE CODE	1033LBN.-...		REVISION DATE	13-2-2013	
NAME	JiGa		This drawing is property of FlexiForce, and contains confidential information. All rights strictly reserved. Reproduction, use for production purposes, issue to third parties, in any form whatever, is not permitted without written authority from the proprietors.	FORM.: A3	
DATE	16-5-2012			WEIGHT	- kg/m
NETT WEIGHT	...			VOLUME	- mm ³
				AREA	- mm ²

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1	1	40mm top profile for internal strut	1033PS....	58 227 001	12-06-2012	-
ITEM	QTY	DESCRIPTION	ARTICLE CODE	DRAWING NO.	REV. DATE	REMARKS

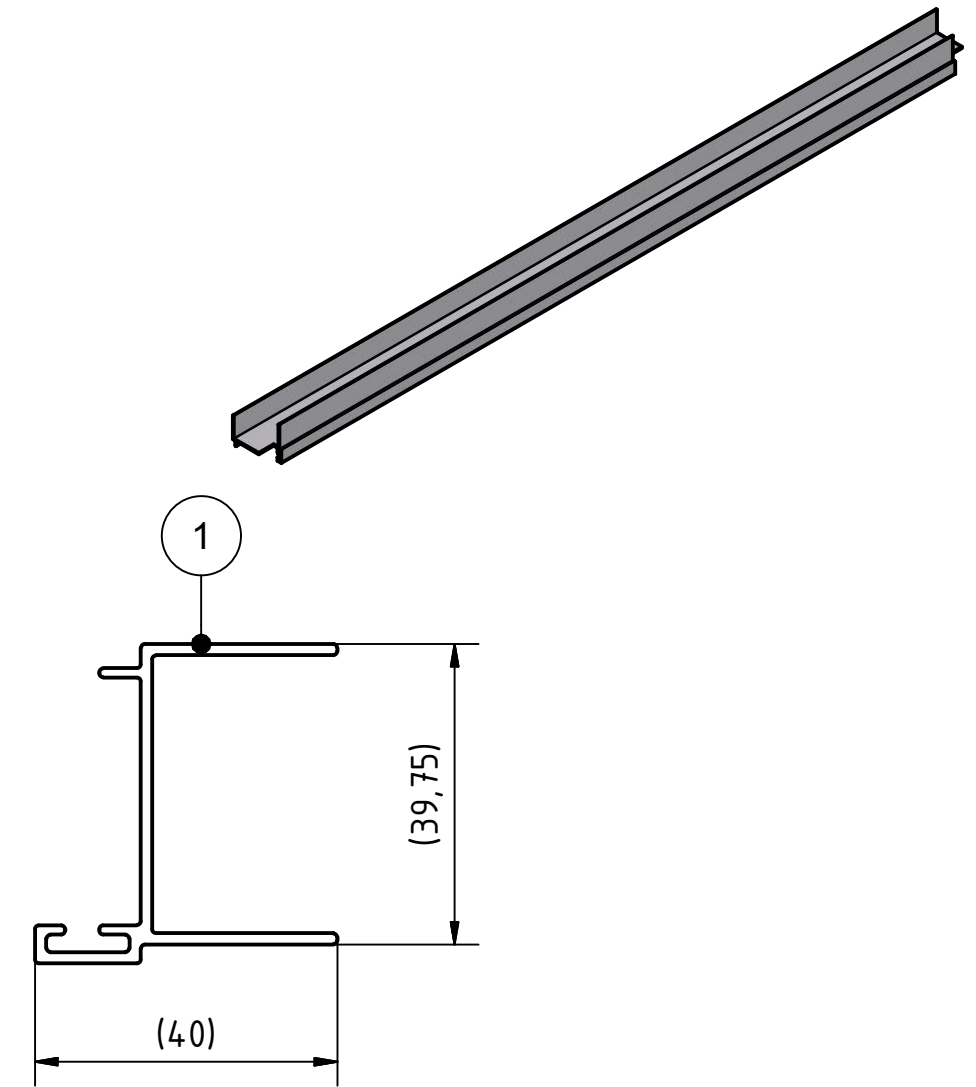
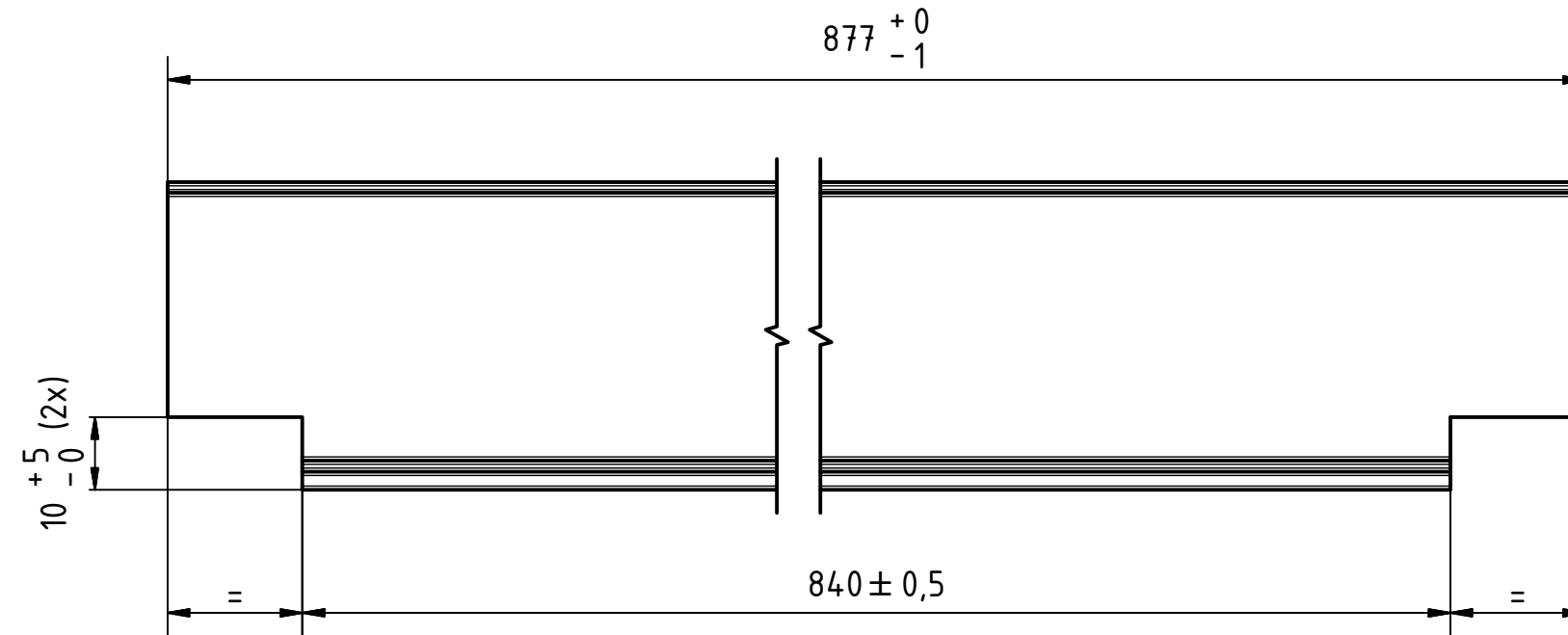
REVISION DATE		DESCRIPTION			NAME	
SCALE: 1:1	GENERAL ROUGHNESS: 3.2	PROJ.: 	UNIT: mm	TOLERANCES UNLESS OTHERWISE STATED Acc. TO ISO2768-cK .		
MATERIAL		Aluminium 6063 T6				
TREATMENT		-				
DESCRIPTION	40mm top profile for internal strut		DRAWING NO.	58 227 101		FORM.: A3
ARTICLE CODE	1033PS-...		REVISION DATE	23-01-2013		
NAME	JiGa				WEIGHT	- kg/m
DATE	23-1-2013				VOLUME	- mm ³
NETT WEIGHT	N/A				AREA	- mm ²
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NOMINAL DIMENSION	ISO 2768c		TOLERANCE
	0.5-3	±0.2	
	>3-6	±0.3	
	>6-30	±0.5	
	>30-120	±0.8	
	>120-400	±1.2	
	>400-1000	±2	
	>1000-2000	±3	
	>2000-4000	±4	

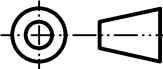
flexiforce FF
innovations for overhead doors

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1	1	40 mm top profile casing profile	1033PLS-3000	58 229 001	12-06-2012	-
ITEM	QTY	DESCRIPTION	ARTICLE CODE	DRAWING NO.	REV. DATE	REMARKS

REVISION DATE		DESCRIPTION			NAME		
SCALE: 1:1	GENERAL ROUGHNESS: 3.2✓	PROJ.: 	UNIT: mm	TOLERANCES UNLESS OTHERWISE STATED Acc. TO ISO 2768-cK.			
MATERIAL		Aluminium 6063 T6					
TREATMENT		-					
DESCRIPTION	40 mm top profile casing profile		DRAWING NO.	58 229 101		FORM.: A3	
ARTICLE CODE	1033PLS-...		REVISION DATE	23-01-2013			
NAME	JiGa	 innovations for overhead doors			WEIGHT	0.5 kg/m	
DATE	23-1-2013				This drawing is property of FlexiForce, and contains confidential information. All rights strictly reserved. Reproduction, use for production purposes, issue to third parties, in any form whatever, is not permitted without written authority from the proprietors.	VOLUME	- mm ³
NETT WEIGHT	N/A					AREA	- mm ²

NOMINAL DIMENSION	ISO 2768c		TOLERANCE
	ISO 2768c	TOLERANCE	
0.5-3		±0.2	
>3-6		±0.3	
>6-30		±0.5	
>30-120		±0.8	
>120-400		±1.2	
>400-1000		±2	
>1000-2000		±3	
>2000-4000		±4	

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WEIGHT
0.5 kg/m
VOLUME
- mm³
AREA
- mm²