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Series 6500

Fabrication & Assembly Instructions (For Surface Mount K.D. Kits)



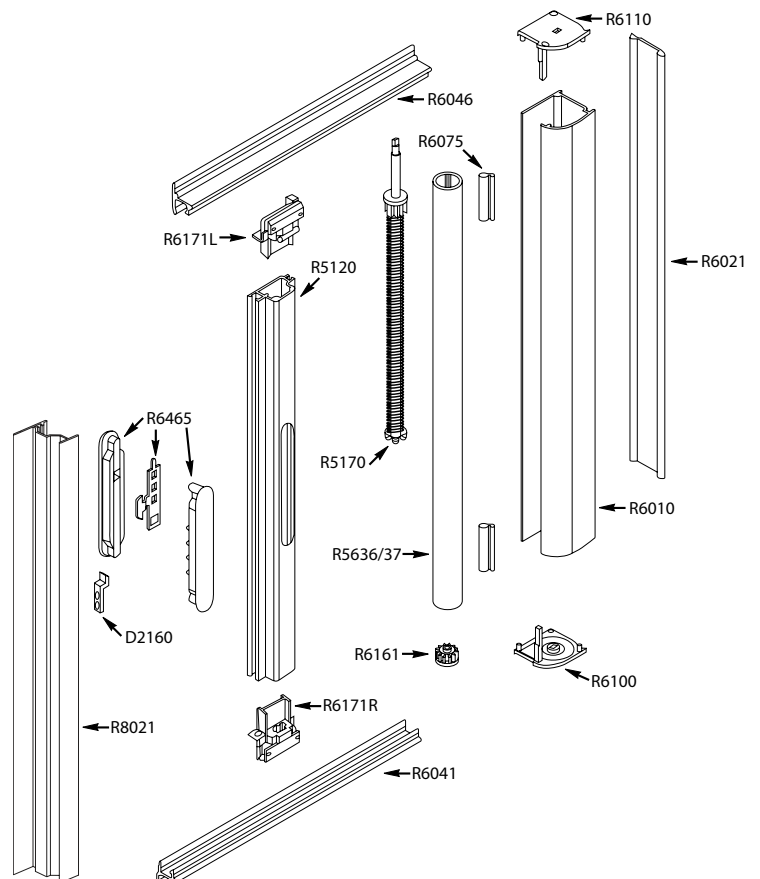
IMPORTANT:
REVIEW ALL INSTRUCTIONS
THOROUGHLY
BEFORE STARTING STEP 1

TOOLS REQUIRED:

- Tape Measure
- Hack or Chop Saw
- Drill Motor
- 1/8" Drill Bit
- 13/64" Drill Bit
- Phillips Head Screwdriver
- Pencil or Scriber
- File

Series 6500 Surface Mount Parts List

R5120##	Drawbar
R5636MF	Tube with Screen 82"
R5637MF	Tube with Screen 96"
R5170	Spring Roller Assembly
R8021##	Facemount Closer
D2160	Die Cast Strike & Screw Assembly
R6465BL/WH	Handle Assembly with Strike
R6010##	Housing
R6021##	Surface Mount Hinge
R6041##	Sill Track
R6046##	Head Track
R6075BL/WH	PVC Cushion
R6110BL/WH	Housing End Cap - LH
R6100BL/WH	Housing End Cap - RH
R6161BL/WH	Bushing with Pan
R6171(BL/WH)L	Drawbar End Cap Assembly - LH
R6171(BL/WH)R	Drawbar End Cap Assembly - RH
##	- Door color





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Step 1 Examine Door Opening Condition

This door system requires a flush surface the entire perimeter of the opening in order to properly install. To clear the opening, the flush surface must be at least 2 1/2" at the jamb the housing will be installed on, at least 9/16" at the jamb the closer will be installed on, and at least 1 1/8" at the head and sill.

Record measurements below.

Width: _____ x Height: _____

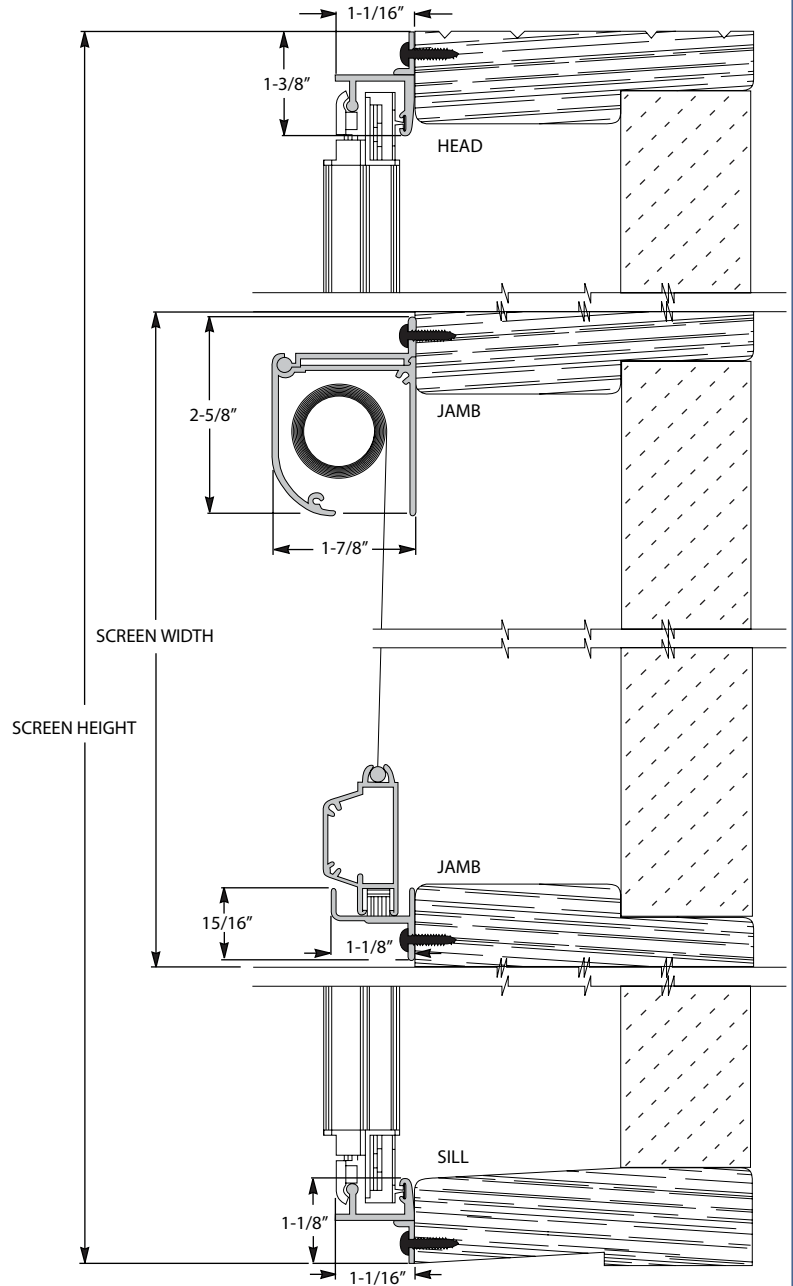
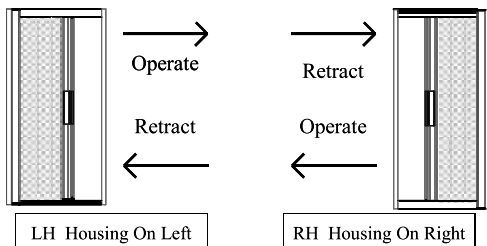
Note:

The dimensions for a Surface Mount Door are derived from the details in this section. Measuring by these dimensions will provide a door that will fit your opening.

Step 2 Determine the Proper Side of Opening to Install Door

For a normal installation the Roll-Away® Door will be installed on the same side as the hinges on the main door. Will the door operate from Right to Left, or Left to Right?
Note: French door installations have 1 each (1 Left to Right and 1 Right to Left).

LH Door will operate from Left to Right
RH Door will operate from Right to Left





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Step 3 Determine Clearance Required For Normal Operation

In order to assure the Roll-Away® door's operation doesn't interfere with the prime/main doors operation, you must allow proper clearance between the two. The prime/main doors handle set normally determines the minimum amount of clearance required. A straightedge held across the opening where the door will be installed will indicate clearance. Do you have room between the straightedge and the main door handle set, or any other door hardware?

YES... there is enough clearance to install all parts for normal operation. Proceed to Step 4.

NO... there is not enough room for normal operation. *Contact the factory before cutting any parts or proceeding further.*

Step 4 Screen Tube Fabrication

Note:

These fabrication instructions create a door that extends vertically beyond the opening 1 1/8" on a side, 2 1/2" on the housing side, and 9/16" on the closer side.

Carefully remove all the Roll-Away® Series 6000 screen door parts from the carton and place on a flat table or bench. You will need the following parts to complete step 4: #R5630.

The Screen Tube Assembly (#R5630) is poly-wrapped on each end and is ready to cut to size. Locate the tube end with the Red tape and cut exactly 1 11/16" less than the screen height (Step 1). Tube is easiest to cut with wrapping and tape intact (Remove in Step 6).

Example:

Screen Height = 80" (Step 1) Cut the "Red" end of the tube until the overall length = 78 5/16".

Step 5 Hinge, Housing & Drawbar Fabrication

Locate the Hinge (#R6021). Cut the hinge exactly 1 1/8" less than the screen height (Step 1).

Example:

Screen height (Step 1) minus 1 1/8". If the Screen height is 80", then cut the Housing at 78 7/8".

Locate the Housing (#R6010). Cut the Housing exactly 1 3/8" less than the screen height (Step 1).

Example:

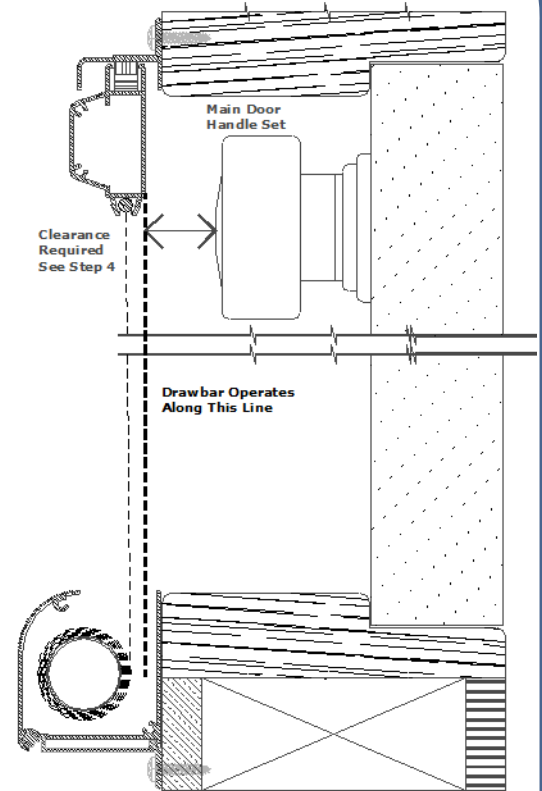
Screen height (Step 1) minus 1 3/8". If screen height is 80", then cut Housing at 78 5/8".

Locate the Drawbar (#R5120). Cut the Drawbar exactly 3 9/16" less than the screen height (Step 1).

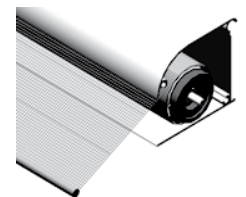
You may wish to cut both ends evenly to keep the handle slot centered.

Example:

Screen height (Step 1) minus 3 9/16". If screen height is 80" then cut the drawbar at 76 7/16".



CORRECT Screen Placement In Housing



WRONG Screen Placement In Housing



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NOTE: MAKE SURE ALL CUTS ARE SMOOTH AND FREE FROM BURRS

Step 6

Door Unit Assembly

A. Insert the spring (#R5170) into the **CUT** end of the screen tube from Step 4. It may be necessary to trim 1/32" from the thick fingers on the spring end to allow ease of insertion and proper operation (Figure 7). Make sure that the spring is firmly seated before proceeding. Lightly tap end cap (#R6110) onto top of spring in notch provided (Figure 8). Regardless of operation, spring must be installed in the end shown in figure 8.

B. Insert the tube bushing (#R6160) into the opposite end of the screen tube.

C. Remove all packaging materials and labels from the screen tube assembly.

D. Carefully insert the screen tube into the housing. Make sure that the screen will roll out in the proper direction (Step 5). **DO NOT PULL ON SCREEN.** Insert the hinge into the housing.

E. Thread spline end of screen onto the drawbar. Spline should overhang each end of drawbar equally.

F. Insert top and bottom guides (#R6171L & #R6171R) into ends of drawbar. Push remaining lengths of spline into notch on guides at either end of drawbar.

G. Be sure that the Drawbar guides are firmly in place. Insert two #6 x 3/8" pan-head screw through the holes in the drawbar guides. These screws will hold drawbar guides firmly in place. Fasten securely.

H. Tension the spring by rotating end cap in the direction that puts tension on the screen (clockwise). (See figure 8) Rotate the cap 5 times. It is recommended that you rotate the cap several times and release it to take out any slack in the spring or screen mesh prior to the final rotations. This will bring the drawbar handle taut against the housing and provide the optimum tension on the screen. Holding the wound cap firmly, insert the cap and fasten to the housing using two (2) #6 x 3/8" flat head screws provided.

I. Insert bearing pin into bushing, then screw bottom cap onto opposite end of housing. Make sure the bearing pin is properly seated in the bottom end cap and fasten with two (2) 3/8" flat head screws provided.

J. Test the tension of the screen by grasping the housing at the mid-point with one hand, and the drawbar in the other, and slowly operate the screen. The screen should unroll evenly, with no binding. Operate the screen several times to fully seat the screen fabric. It may be necessary at this point to add an extra wind to the spring, to take up any slack that may have appeared during seating.

K. Move the cushions to their respective positions on the housing face. The housing end caps are equipped with posts, notched to set the cushion height. (Figure 9.) While the cushions will remain in place in normal operation, it is recommended to apply a couple of drops of cyanoacrylate adhesive between the cushion and the outside of the housing to prevent accidental dislodgement.

L. The handle set can be reversed if necessary. The lock button must be at the top of the handle set for proper operation. To disassemble the handle, remove the two handle screws. Remove the exterior handle. Carefully separate the inside nylon slide by gently tugging until it separates from the remaining nylon slide. Care must be taken during this procedure not to dislodge the handle spring, or the spring could fall into the drawbar cavity. Remove the latch from the inside nylon handle, and remove the interior handle assembly from the drawbar. Reverse this process to reassemble the handle. (Figure 10.)

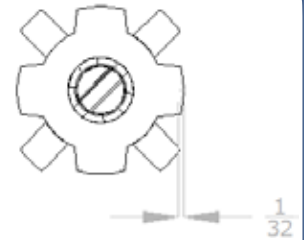


Figure 7

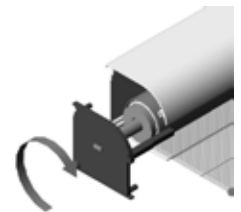


Figure 8



Figure 9

Housing cut away for clarity. The cushion is positioned against the notch in the end cap post

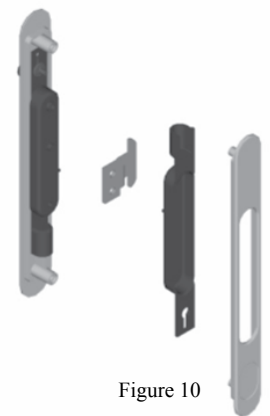


Figure 10

Handle Assembly
(from left to right):

Inside handle
Latch
Exterior Inside Slide
Exterior Handle

ASSEMBLY COMPLETE
PROCEED TO STEP 1 OF INSTALLATION INSTRUCTIONS