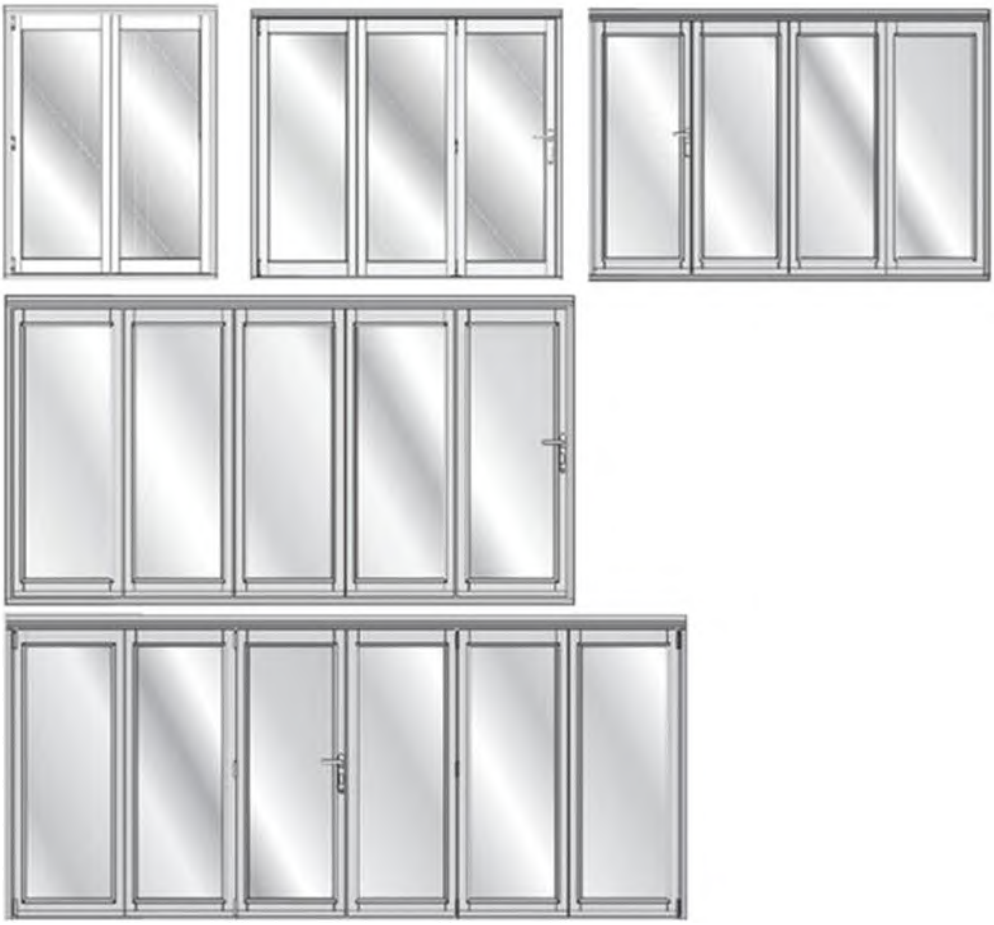
External Aluminium Bifold Door sets

Assembly Instructions



About your Aluminium Bifold Door

All products must be installed in accordance with accepted good trade practice (and in accordance with supplied instructions where applicable), and maintained in accordance with these procedures or else the warranty shall be void.

The advice given in this document assumes fitting will be carried out by a qualified professional following the Code of Practice for the Survey and Installation of Windows and External door sets, where applicable.

Important Information

All of our external aluminium bifold doors and frames, glazing units and hardware components are guaranteed for a full 10 years against the occurrence of manufacturing faults and the powder coating finish is guaranteed for 15 years, all subject to correct installation, regular maintenance and care in use as detailed below.

We recommend that a competent trades person installs this product. A single person must NEVER carry out the installation, as some of the components are heavy.

Handling and Storage

Take care when unloading the products as they may have shifted during transportation. The products are heavy. Always wear gloves, use specialized equipment such as glass lifting suction cups and have at least two people to unload / carry them.

You are responsible for safe handling of the products, and for selecting appropriate handling equipment. Conduct a thorough inspection of the product(s) immediately after receiving them, including temporarily removing any protective tape, and then reapplying before installation.

Important: All damages or missing parts must be reported within 72 hours of receipt and before commencing installation. When storing the doors / frames and glass before installation, and once all items have been fully checked, they should be handled with care and stored in a dry, ventilated building.

Loose glass should never be placed directly onto hard floors such as concrete, but should be placed on cardboard, sheeting or wooden batons, on edge rather than flat. The glass should be stored on its edge and at a 3-6 degree angle. Glass should not be stored horizontally or on top of each other and should not come into contact with anything harder than itself.

Important: The glass must be inspected before being fitted. We cannot accept claims for any missing items, damages or scratched glass after 72 hours following delivery or after installation has begun.

Installation

This door set is designed to be installed by competent trades persons with good knowledge and previous experience of installing bifold doors. Thoroughly read and understand these instructions before you begin installation. It is presumed that the installer possesses basic skills and an understanding of door, window, wall and roof installation, and joint sealant guides.

Before commencing the installation, carry out a final check to make sure the aperture is the correct height and width to accommodate the outer frame size. The brickwork opening should be approximately 10mm greater in both height and width than the outer frame size when measuring at the tightest points.

Our aluminium doors are supplied with most hardware factory fitted and everything pre-machined. This design allows for simple on-site assembly by experienced trades persons. The outer frame needs to be securely fixed into the opening perfectly square and level on all planes.

The aluminium bifold doors are bottom hung, the weight of the doors is supported via the bottom rollers and threshold.

Important: The threshold must be sufficiently packed to ensure there are no dips or rises along the full length of the bottom tracks. When fixing the frame head, ensure there is no bowing.

About your Aluminium Bifold Door (Cont)

Care and Maintenance

Aluminium Door and Frame Components

All our aluminium bifold door sets are supplied fully powder coated providing a high quality and durable finish, unless otherwise stated.

The profiles may have protective tape applied to interior and exterior surfaces to protect them during manufacturing and handling. Protective tape must be fully removed before or on installation. Protective tape and masking tape should not remain on exterior surfaces for an extended period of time. They will begin to fuse to the surface making the adhesive residue difficult to remove. Failure to remove tape may permanently damage the frame finish.

To maintain the external aluminium powder-coated finish, wash regularly with soapy water and then dry off with a soft lint-free cloth. As a minimum, the external surfaces must be washed at least every three months, and monthly if within five miles of the sea or in an industrial area. Our general recommendation would be to wash the external aluminium every time you clean your windows, which should normally be more regularly than the minimum requirement.

The powder coating is not guaranteed unless the doors are installed at least 800 metres away from the sea.

The threshold should be kept clear of debris and regularly cleaned to ensure the drainage channels remain clear, which can be done whilst cleaning the rest of the door set. The threshold should be stepped over when entering and leaving and not used as a step, to avoid damage to the threshold and seals.

Important: We cannot accept any claims for damages, including scratches to the powder coating and aluminium reported 72 hours following delivery, and / or after installation has commenced.

Glazing Units

To reduce carbon emissions from the home and to keep heating and cooling bills down, the government has recommended that all manufacturers use a special Low E thermal glass within the sealed units to comply with Building Regulations Part L.

This glass is coated with a special substance to comply with the above and occasionally, and in certain light conditions, may produce transient visual effects, this can sometimes look like a transparent film or haze, and make the glass appear cloudy. This is very infrequent and only affects a minority of door sets. As a company, we do have to comply with the new regulations which are for the benefit of all, and this is not a detect.

Due to demands for better thermal efficiency, it is normal for condensation to form on the outside of the glazing units, to the exterior side of the property. This demonstrates that the glass is performing as it should by reducing the transfer of heat from the internal side of the property to the external side of the property, this is not a defect. For any condensation forming to the inside of the property, this is normally due to high levels of moisture in the air and / or insufficient ventilation in the room, the moisture is then forming on the cold surface. If condensation is forming inside the glazing unit (between the panes of glass) it is likely that the glazing seal has been compromised.

Tempered glass means it has been toughened to be up to five times stronger than normal glass. It is unusual to break such strong glass, but sharp objects hitting the glass at certain points can cause breakage. Tempered glass is also known as safety glass. This means that if it breaks it will shatter into smaller fragments which are less likely to cause injury, unlike non-tempered glass which breaks into large, sharp fragments.

Laminated glass is also called safety glass and comprises of multiple layers of glass sandwiched together. Due to its high strength, this prevents the glass from breaking into large pieces. If the glass breaks, it will produce a 'spider web ‘effect similar to what is commonly seen in shattered car windscreens. Laminated glass will also increase the sound rating insulation.

About your Aluminium Bifold Door (Cont)

Glass must be regularly maintained and cleaned to stop break down of the glass or seals. This can be done using a mild solution such as washing-up liquid diluted in water. Do not use abrasive cleaning solutions as this may cause scratching.

Visual distortions caused by reflections in toughened glazing units are a natural phenomenon and not a fault.

Laminated, toughened or coated glass is acceptable if bubbles or blisters, fine scratches no more than 2.5cm long and /or minute particles are neither obtrusive or bunched. The glass used in sealed units is processed glass, therefore certain blemishes are unavoidable. More blemishes may be visible in laminated glass due to its layered construction.

For carrying out glass inspections, stand at least 3 metres away from the glazing, view at a 90-degree angle and look directly through the sealed unit(s). The glass must be viewed in natural daylight but not with the sun directly on it. Any moisture must be removed from the surface of the glass before inspecting.

Hardware Components

The exterior hardware in your bifold door set can deteriorate from everyday use, and also because of the weather and local environment. That's why regular maintenance of your door hardware is even more important if you live in severe environments like coastal / marine areas and some industrial locations.

We require that the below minimum maintenance is carried out as often as necessary to prevent deterioration. As a guideline, we recommend that this maintenance is done every three months if you live in a marine environment, or every six months if you live in a more general location, otherwise your guarantee will not be valid.

Tracks and bearings

Important: Once your installation has been completed, and before fully operating your door set, please carefully remove any debris / swarf from the top and bottom tracks to ensure nothing comes into contact with any moving components.

After cleaning the tracks, using a microfibre cloth, apply a small amount of lubricant such as a silicone spray to the inner lip of each side of the track. Extra lubricant can be added around the bearings. Adding lubricant in this way reduces wear, improves smoothness and gives additional protection against corrosion of track and bearings.

Hinges, pivots and brackets

A light spray application of a suitable lubricant such as WD40, followed by a light wipe with a dry cloth to remove excess, is recommended to all hinges, pivots and brackets. Exposed surfaces should first be wiped with warm soapy water and a soft rag, and then rinsed clean before applying preventative.

Twin point locks

Spray application of a suitable lubricant such as WD40 silicone spray. A tube attached to the nozzle will help concentrate the spray where you want it to go. There are access holes or slots on all twin point locks, so that this can be done without removing the locks from the doors.

Frequency

The procedures mentioned above need to be carried out as often as is necessary to prevent deterioration in the installed environment, however we recommend the following minimum frequency of application; General environment – 6 months Close to marine environment - 3 months.

Introduction to Assembly

QUICK GUIDE

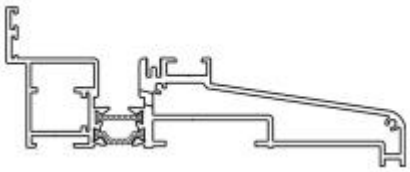
Supply Option 1 – Frame and doors built up with loose glass Temporarily secure the frame perfectly, plumb square and level on all panes into the opening using packers. Once the frame is fully secure in the opening, the doors can then be opened and folded back to allow access to the frame fixing points. Direct fix all around the frame ensuring the fixings are silicone dipped. Re-check the frame levels and then the glass can be installed, and toe and heeled. Once the glazing units are fully installed, and the doors are operating correctly, fit the internal glazing bead.

Supply Option 2 – Frame built up, doors loose and fully glazed Temporarily secure the frame perfectly, plumb square and level on all panes into the opening using packers. Once the frame is fully secure in the opening, direct fix all around the frame ensuring the fixings are silicone dipped. Re-check the frame levels and then hang the pre-glazed doors.

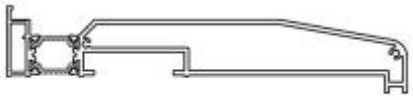
Supply Option 3 – Frame broken down, doors loose and fully glazed Assemble the frame and temporarily secure the frame perfectly, plumb square and level on all panes into the opening using packers. Once the frame is fully secure in the opening, direct fix all around the frame ensuring the fixings are silicone dipped. Re-check the frame levels and then hang the pre-glazed doors.

Contents

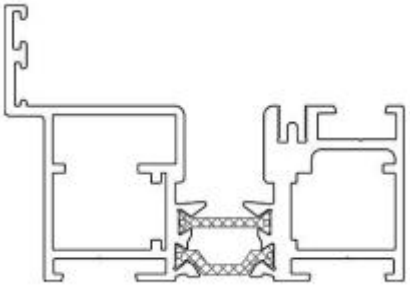
Integrated threshold / cill (standard open out door sets)



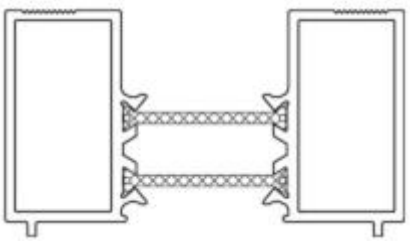
* Drip cill (open in door sets and loose threshold option)



* Threshold (open in door sets and loose cill option)



* Frame head add-on (optional extra)



Contents (Continued)

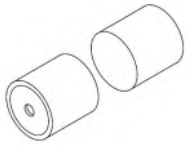
Hardware

Wedge Glazing Gasket – Qty 1 role
(Loose glass only)

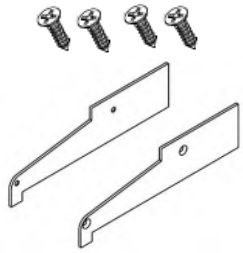
Handles – Qty 1 pair
(Excluding 2 door and 4 door folding to one side)

Hinge Screw Bag – Qty 1
(Machine Screws – Qty 2 per hinge & Self-Drilling Screws – Qty 1 per hinge)

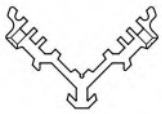
Extended Magnetic Catch - Qty 1
(Excluding 2 door and 4 door sets)



Cill End Caps
Qty 2
Fixings Qty 4



Mechanical Corner Cleat Qty 4
(Qty 8 for loose threshold and drip cill orders)



M6 x 16 Machine Screws Qty 8
(Qty 16 for loose threshold and drip cill orders)

Corner Chevron
Qty 2
(Qty 4 for loose threshold and drip cill orders)

Installation Bag Contents (Optional Extra)

Hardened steel direct frame fixings 7.5 x 90mm - Qty 30

SDS Drill Bit 6.5mm x 210mm – Qty 1

HSS Drill bit 6.5mm x 101mm – Qty 1

Drill Bit ¼ HEX TX30 – Qty 1

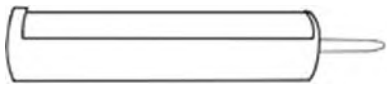
Drill Bit 1.4 HEX PZ No.2 – Qty 1

Assorted bag of packers and wedges

Allen Key 3mm – Qty 1

Allen Key 4mm – Qty 1

Clear Silicone



PLEASE NOTE: These instructions have been written based on the purchase of our optional installation kit, which was available to purchase at the time of placing your original order. If you did not select our installation kit, please ensure you use equivalent types of good quality fixings that are suitable for installing doors and windows.

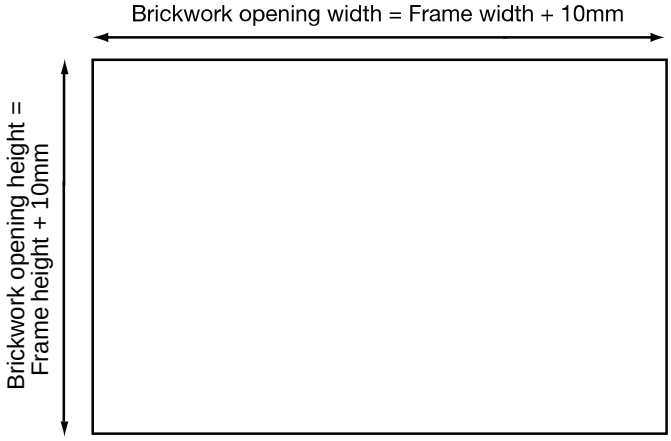
VERY IMPORTANT NOTE: To speed installation, we have pre-installed some components in production.

Twin point lock and handle
Multi point lock (main access door, excluding a 2 door or 4 door folding to one side)
Hinges
Trickle vents
(Flush vents installed in both end door panels / non-flush fitted in frame head add-on)

Preparing the site

Brickwork opening:

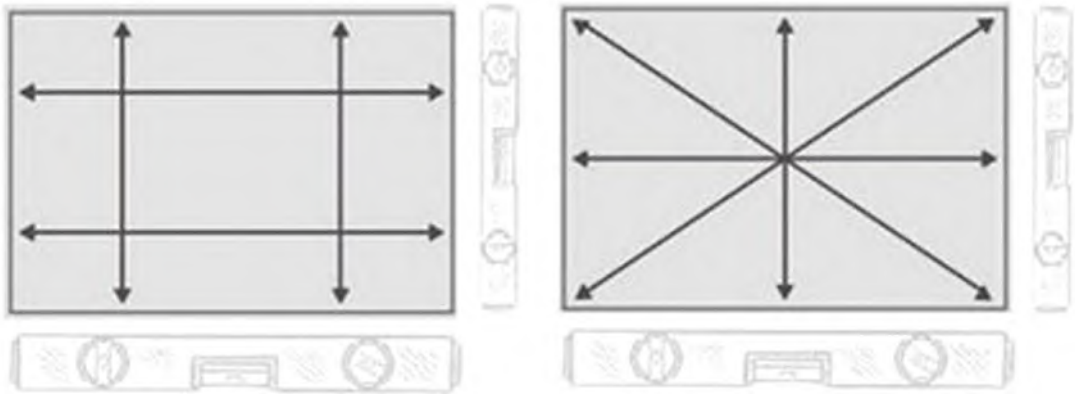
When preparing the site please prepare the brickwork opening to be 10mm more in height and width than the outside assembled frame size of the door frame.



Example sizes:

Outer Frame:	**Brickwork Opening:**
2090mm W x 2090mm H	2100mm W x 2100mm H
2390mm W x 2090mm H	2400mm W x 2100mm H
2690mm W x 2090mm H	2700mm W x 2100mm H
2990mm W x 2090mm H	3000mm W x 2100mm H
3590mm W x 2090mm H	3600mm W x 2100mm H
3990mm W x 2090mm H	4000mm W x 2100mm H
4190mm W x 2090mm H	4200mm W x 2100mm H
4790mm W x 2090mm H	4800mm W x 2100mm H
4990mm W x 2090mm H	5000mm W x 2100mm H

It is essential that all 4 internal surfaces of the brickwork be levelled before installation. Please ensure that all dimensions are correct for installation before proceeding, as the outer frame must be installed square and level into the opening.



Check the aperture to make sure there is no loose plaster or brickwork, and that it is free of any debris or brick dust. Ensure that a solid, level base is present at the required dimensions and can provide packing points at 150- 250mm centres and fixing points at 500-600mm centres.

Ensure floor levels do not obstruct door operation or impede drainage.

The brickwork opening is classed as a finished opening size, so it is important you have allowed for any additional plaster work, trims, architraves, etc.

Finishing around the frame is a personal preference and should be decided between yourself and the installer.

Insulated cavity closer's may be required.

Ensure you have the relevant / correct damp proof course in place.

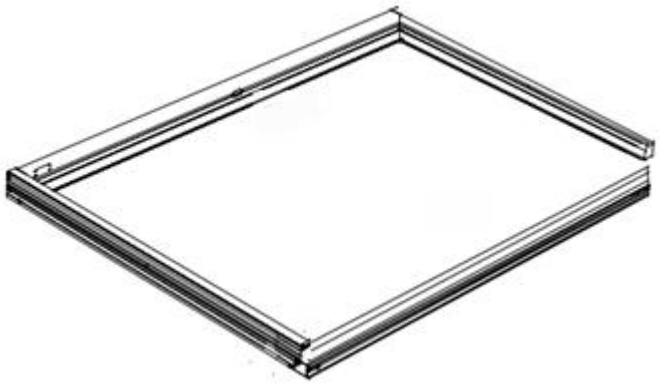
Assembling the frame

If your frame has been supplied built up (supply option 1 and 2), please skip this section and refer to ‘Installing the assembled frame’.

Lay all 4 pcs of the frame on top of cardboard or similar protective covering to prevent damage to the aluminium.

For standard door sets the threshold and cill will be integrated (1 piece).

If you have ordered an open in door set or an extended drip cill, the cill will be supplied loose and requires fitting into the opening and the frame sitting on top.



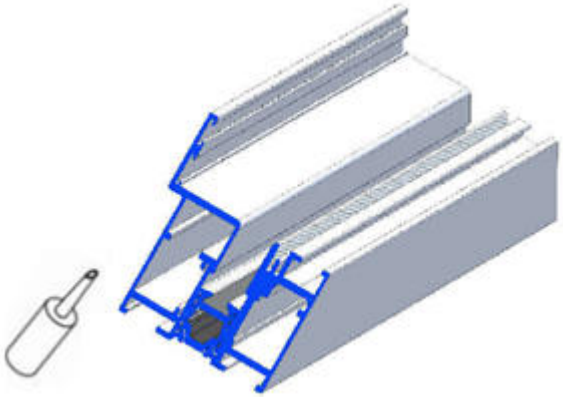
Please note: For open in door sets, the frame rebate will be to the outside and hinged on the inside. For open out door sets, the frame rebates will be to the inside and hinged on the outside.

Mechanical Corner Cleat Assembly - Frame Head, jambs and *loose threshold * (please refer to the next section for fitting of the integrated threshold / cill.)

Insert the 2 corner chevrons into the grooves in the frame head.

Insert the mechanical corner cleats into the frame head.

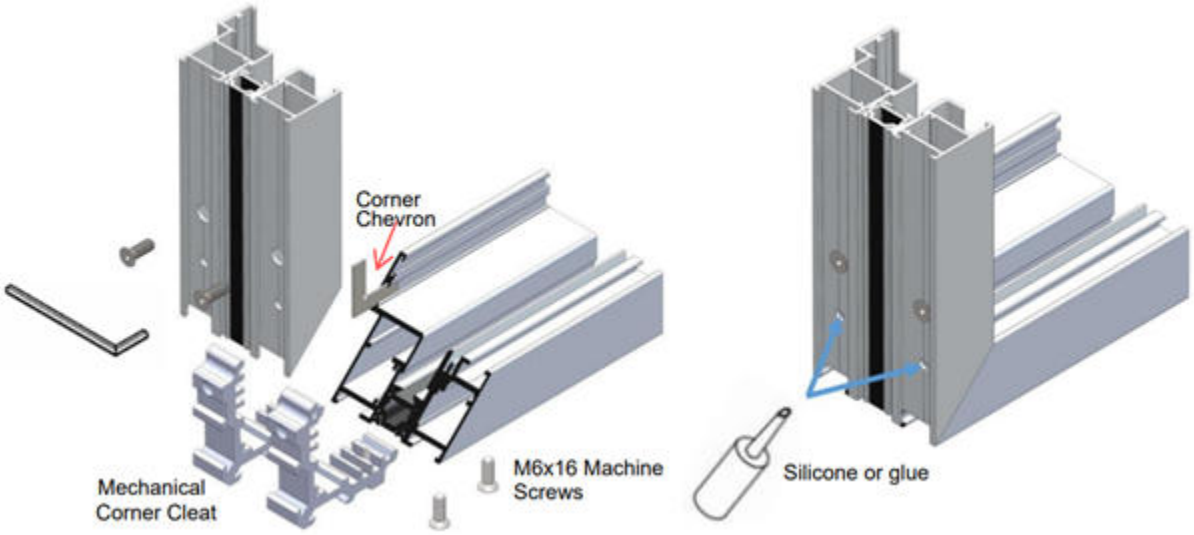
Apply low modulus silicone sealant to the aluminium profiles to be joined together.



Assembling the frame (Continued)

Carefully align the mitre joints, then using a 4mm Allen Key, carefully tighten the machine screws at the side and bottom. Progressively tighten all 4 machine screws, bit by bit, to ensure a tight mitre joint, then clean off any excess silicone.

Fill in the remaining smaller holes with low modulus silicone or glue as shown below.



Repeat the process on the opposite corner of the frame and threshold.

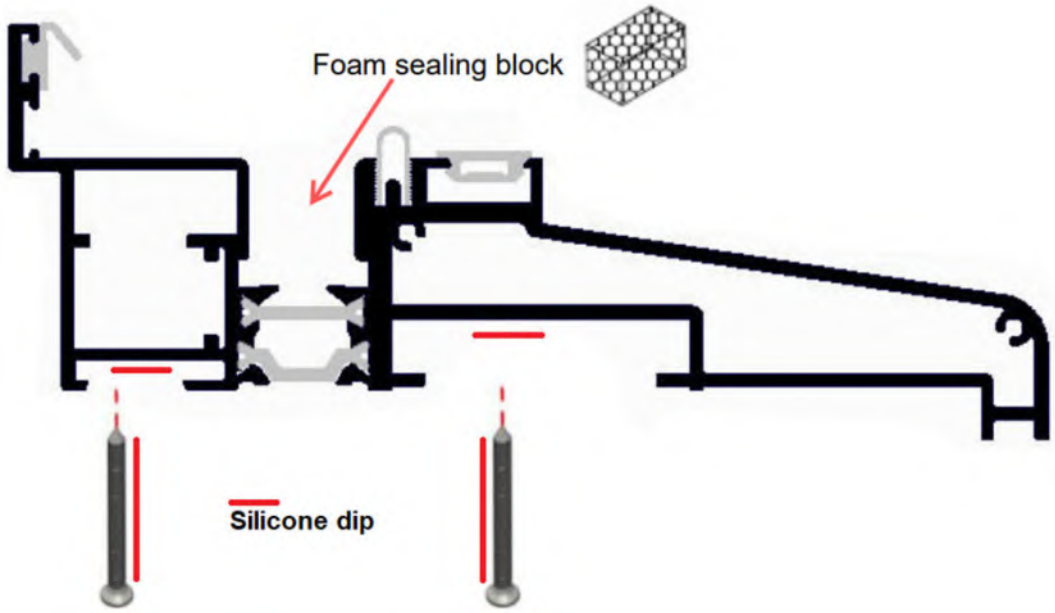
Assembling the frame continued (integrated threshold / cill)

Please skip this step if you have been supplied with a separate threshold and cill.
Please follow the cleat assembly process used above for connecting the threshold and jambs.

Insert the foam sealing block supplied into the channel of the integrated cill.

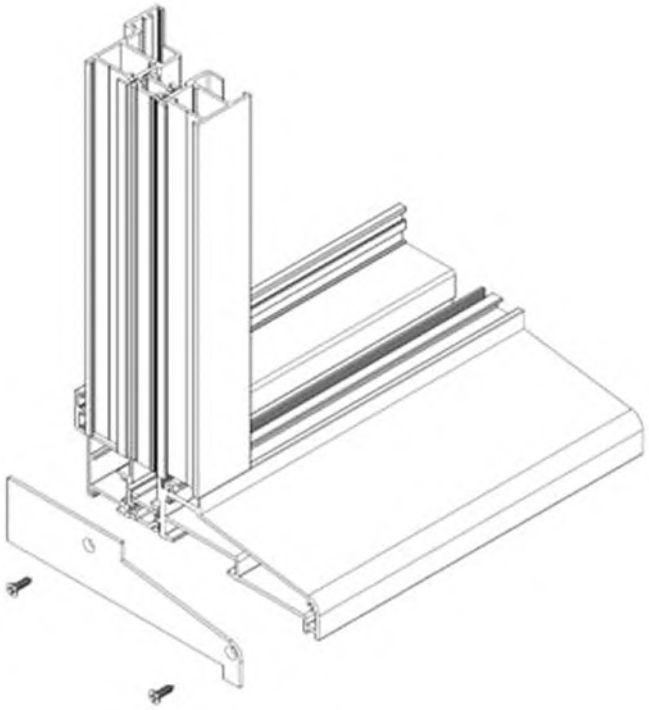
Before locating the jambs onto the cill, mastic seal both ends of the jambs and the face of the thermal break - silicone sealing all touching faces.

Once the jambs are aligned onto the cill, silicone dip the machine screws provided and secure.



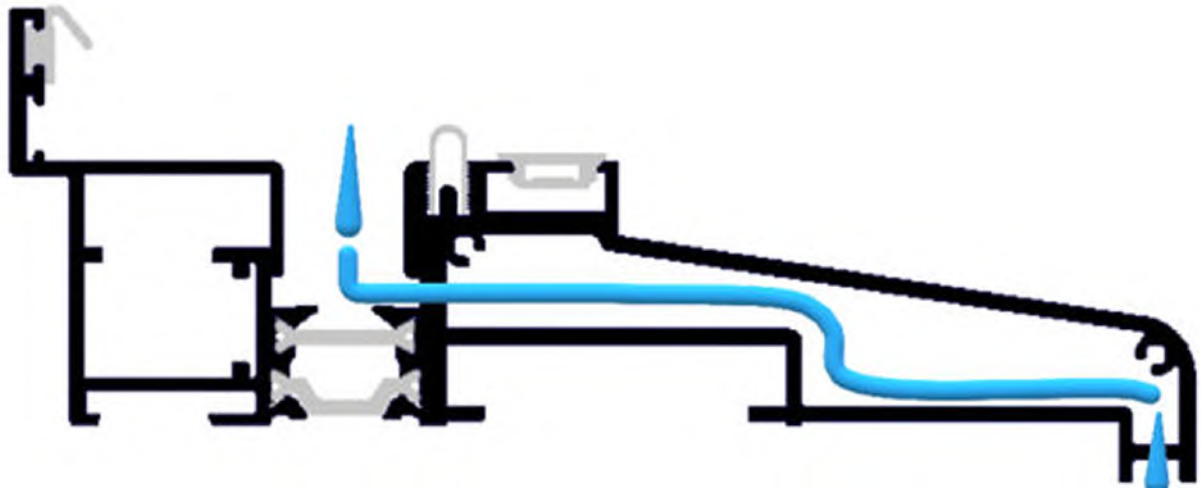
Any excess silicone should be wiped off at this point.

Silicone seal both end caps onto the cill. Silicone dip the screws and fix the caps in place using a 1/4 x 25 pozi bit.



Assembling the frame continued (integrated threshold / cill)

Drainage path.



Fitting the optional drip cill

Please skip this step if you have been supplied with an integrated threshold / cill.

Before fitting the cill into the opening, clear the aperture of any dirt / debris, ensuring you have a clean level surface to fix to.

Ensure you have the correct structural damp proof course in place.

Locate the cill and cill end caps. Glue and fix the end caps in position.

The easiest way to install the frame with a cill is to level the cill in the opening first, temporarily fixing this in place and then lift the assembled frame on top.

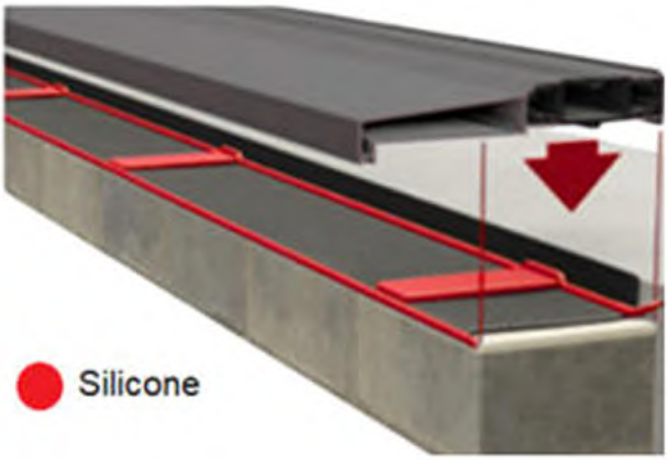
Place packers along the bottom of the opening to create a level bed for the cill to sit on, place at each end of the frame and then approximately 600mm centres or where each fixing point will be located.

Temporarily lift the frame into the opening and check the bottom of the frame is sitting perfectly level. Remove the frame and silicone the packers in place. Ensure you have packers located where the bottom roller(s) will come to rest in the closed position.

If the surface is uneven then a mortar bed may be necessary. If a mortar bed is not required then seal along edge using silicone sealant as shown below.

Fitting the optional drip cill (Continued)

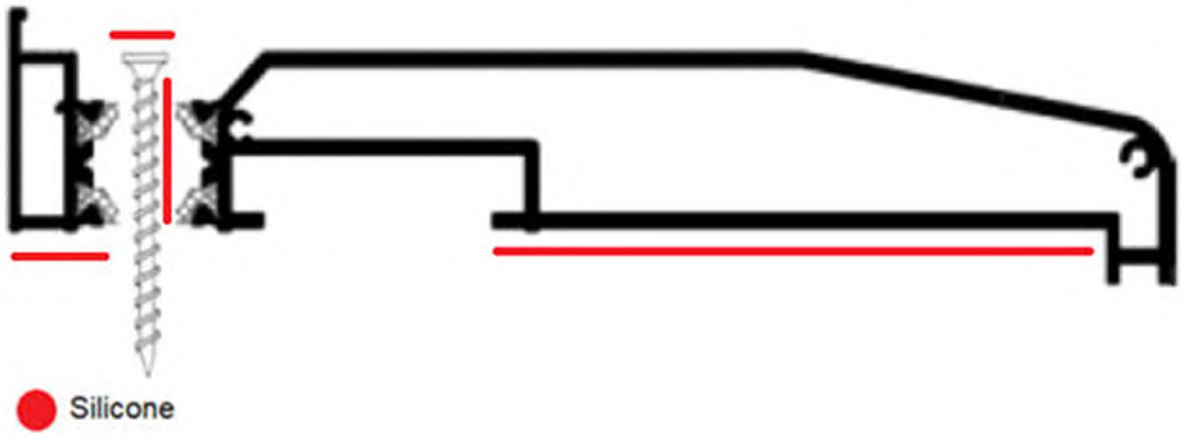
Create a bed of silicone or mortar for the frame to sit on the lift the frame into the opening ready for securing to the brick work.



Once the cill position is level and fully supported, use a 6.5mm HSS drill to drill a hole at each end of the cill through the thermal break. Use a 6.5mm SDS masonry drill to drill through these holes into the masonry. Finally fix the cill in place using Qty 2 direct frame fixings.

Use this same method for fitting the fully assembled frame with an integrated cill or no cill.

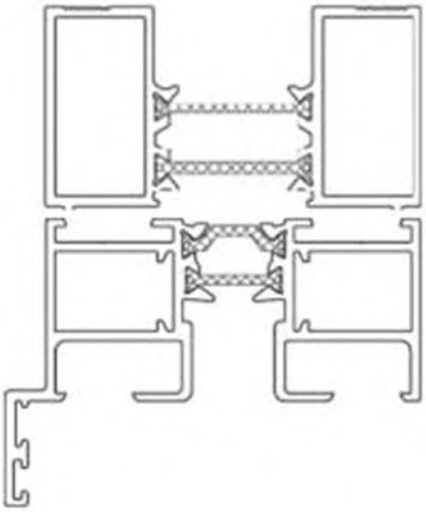
Important: The cill must be sat on a bed of silicone or motor and all fixings must be silicone dipped.



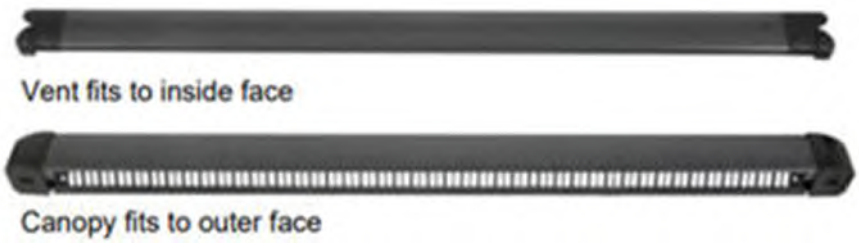
Fitting the optional frame head add-on

If your order does not have an optional frame head add-on, please skip this step.

If your door set has an optional frame head add-on, this sits on top of the frame head. The add-on will be supplied loose when it arrives to you, and will require screwing to the frame head before installing into the opening.



As standard our flush trickle vents are fitted into the outer door sashes, however if you've ordered our non-flush fitting trickle vents these will be attached to the frame head add-on, and the ventilation holes pre-machined. Ensure the add-on is joined to the frame head so the canopies of the trickle vents are on the external side of the frame.



Installing the assembled frame

Clear the aperture of any dirt / debris, ensuring you have a clean level surface to fix to.

Before lifting the frame into the opening do one final check to ensure that the bottom of the brick work opening is completely level, packed and sealed accordingly as per the previous section ‘Fitting the Drip Cill’.

Ensure you have the correct structural damp proof course in place.

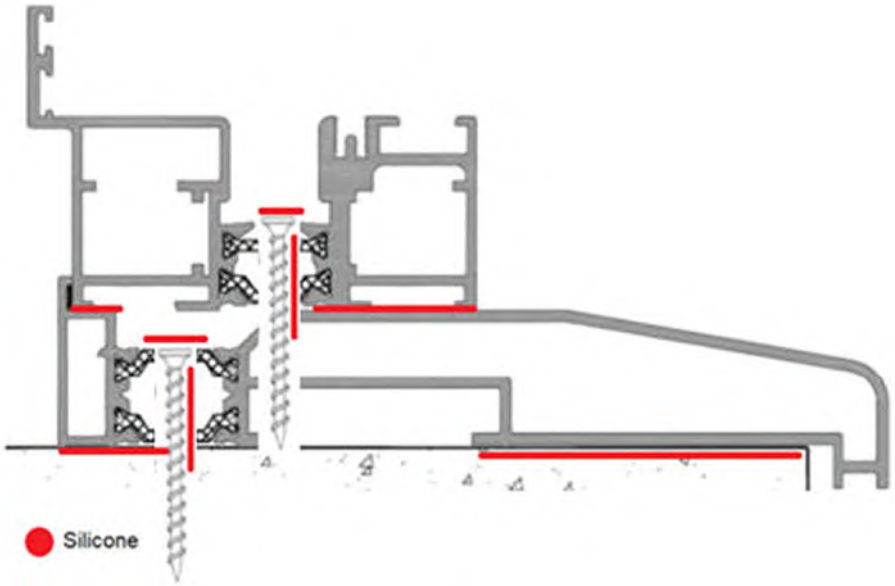
Important: During the installation, repeatedly check the alignment and squareness of the outer frame. Measure the distance across diagonally to check squareness. Without these checks the installation may be unsatisfactory, causing damage to the doors and / or incorrect operation.

Temporarily lift the frame into the opening. Sitting the integrated cill / threshold onto the levelled, packed and sealed brickwork as per ‘Fitting the Drip Cill’.

Installing the assembled frame (Continued)

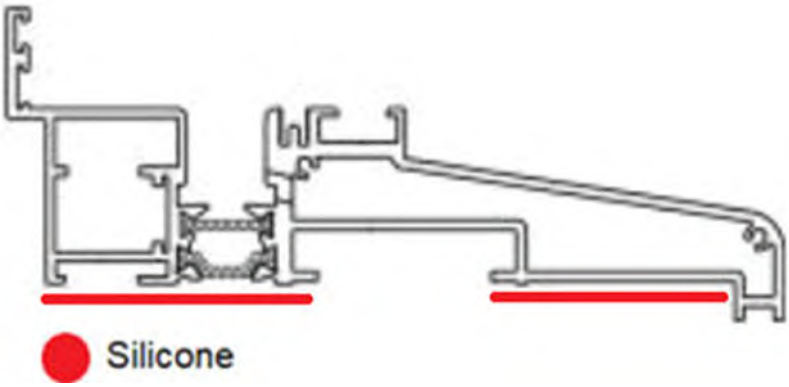
If you have already fitted a drip cill into the bottom of the brickwork opening, take care when lifting the outer frame on top not to damage the drip cill. You should have already levelled and fully supported your drip cill, meaning the threshold should automatically sit level on top.

Silicone seal the cill at the front and back, and both ends of the cill before sitting the threshold on top.



Where no drip cill is being used, level the frame using packers. Please refer to section ‘Fitting the Drip Cill’ for levelling and sealing the integrated cill / threshold.

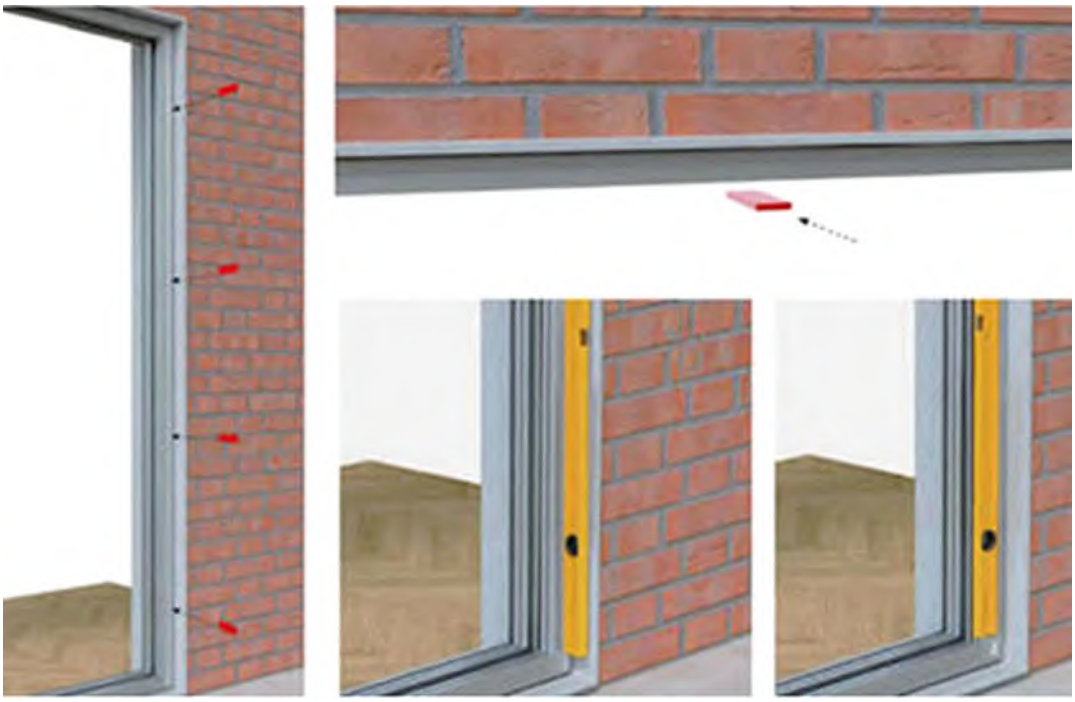
Remove the frame and create a bed of silicone or mortar for the frame to sit on the lift the frame into the opening ready for securing to the brick work. Ensure the frame is level and sufficiently packed to support the door set along its full width,
silicone any packers in place. If the surface is uneven then a mortar bed may be necessary.



Silicone and levelling example

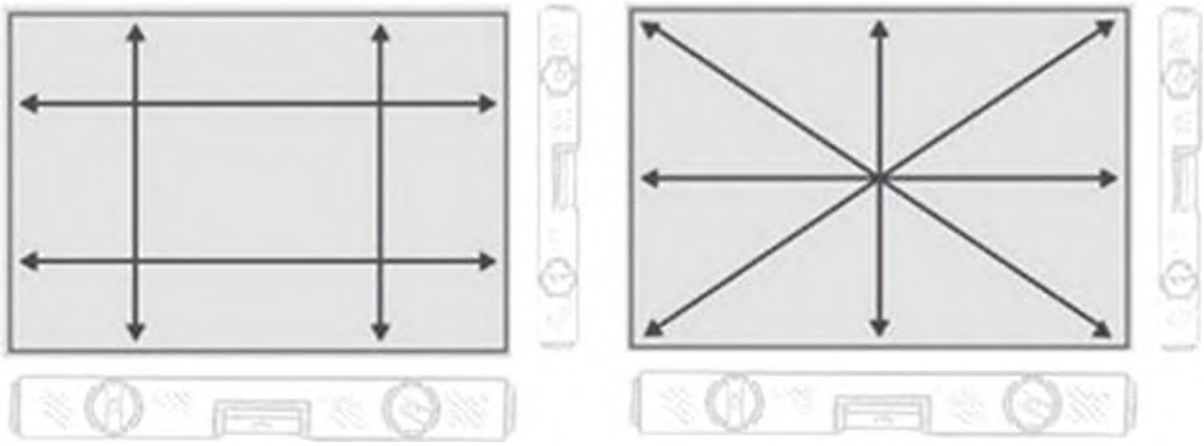
Installing the assembled frame (Continued)

Lift the frame back into the opening. Continue to pack all around the frame. Ensure the top and bottom tracks do not bow in any direction, the internal frame dimensions are consistent, and the structural opening does not transfer any load onto the frame.



Continually check the frame using a laser level and / or long spirit level as you go.

Important: The frame is installed into the brickwork opening completely upright, square and level in every plane. Measure diagonally across the frame and ensure the measurements are the same.



The door set uses a bottom rolling system, so it is vitally important the bottom frame section (and drip cill if selected) is level and adequately supported from front to back, without dips or raises, all the way along using packers as necessary.

Do not proceed unless you are 100% happy the frame is in upright, square and level in every plane and checked using a laser level.

Installing the assembled frame (Continued)

For door sets with pre-installed doors (supply option 1), once you are happy the frame is secured in place, you can now open the doors to allow access to the fixing points.

When the frame is in the opening square and level, drill pilot holes 150mm – 200mm from each corner and then at 500 -600mm centres. Use a HSS drill to drill through the frame sections and a SDS masonry drill for the lintel / brickwork.

Please note: For door sets with a height of 2391mm and over. The frame jambs will be supplied with frame jamb inserts pre-fitted. The inserts will have 12mm access slots pre-drilled to allow you access to drill the fixing points as per below. See 'Frame jamb insert' diagram below.

Finally fix in place with Torx 90mm direct frame fixings and a T30 bit, through the thermal break.

For the lock keep jamb fixing, remove the lock keep and drill / fix accordingly.

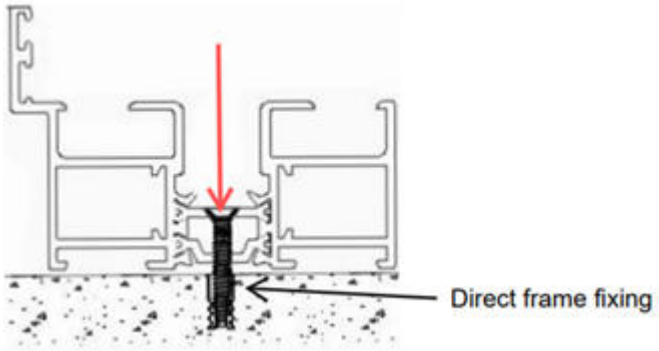
Ensure all fixings are silicone dipped and countersunk to ensure running gear is not obstructed.

If the amount of packing is more than 4mm under the cill then reduce the maximum centres to 250mm.

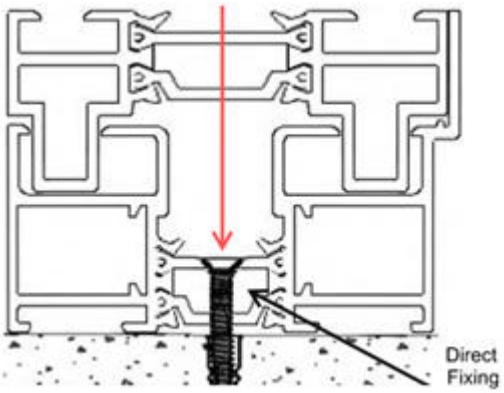
Ensure you have a packer where the roller comes to rest in the closed position.

Important: All fixings in the bottom threshold / cill must be silicone dipped. Do not over-tighten the fixings or distort the aluminium frame.

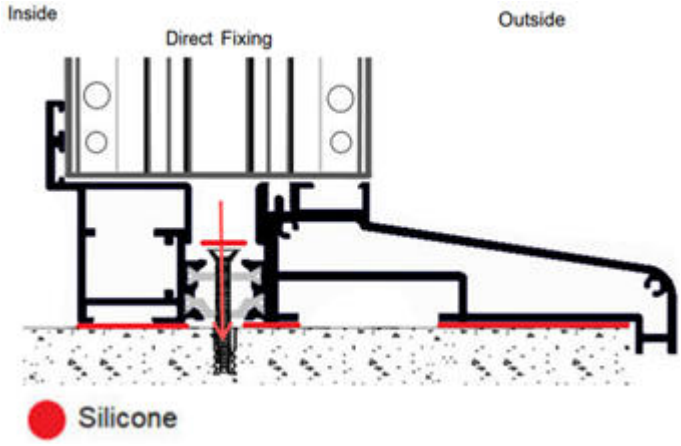
Frame Head & Jambs



Frame Jamb with Inserts



Frame Integrated Cill



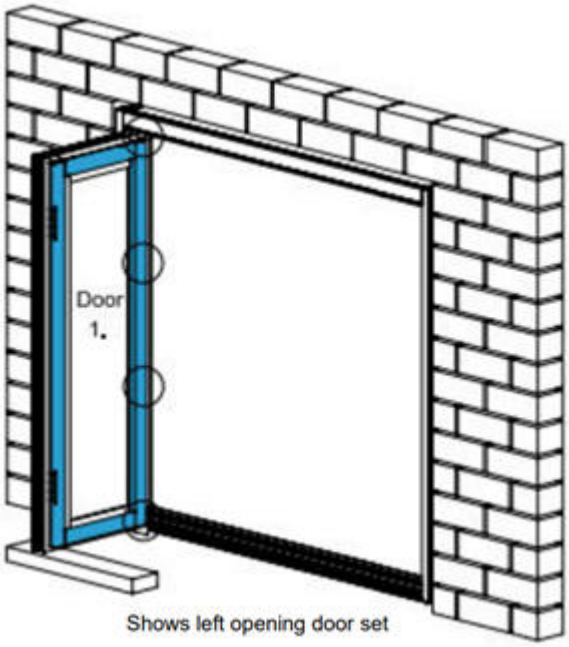
Fitting the doors (supply options 2 and 3)

If your frame has been supplied built up with the doors pre-fitted (supply option 1), please skip this section.

Locate Door 1, which fixes to the jamb of the frame. Look for the panel glass beads to determine the interior side, and panel drainage holes to determine the bottom of the door.

Do not rest the door on the bottom threshold during this process. Ensure the integrated cill / threshold and door are protected by using the discarded foam packaging or cardboard, and that you have a suitable support block to rest the door on.

Door 1 fixes to the frame jamb which is where the doors will fold to. The hinges will be pre-fitted to the outer frame and just need securing to the door.

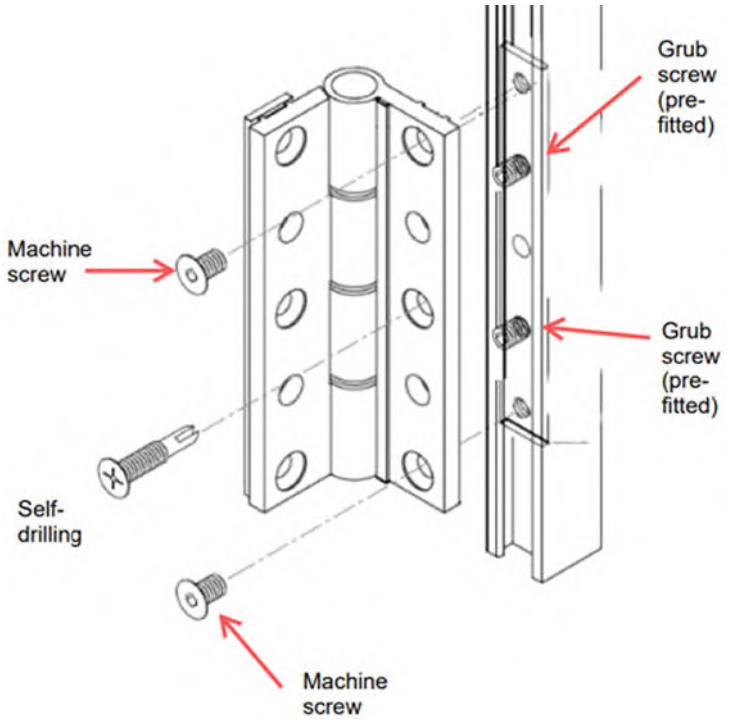


Shows left opening door set

With the door at right angles and supported on blocks (being careful not to damage the seal on the bottom of the door), use a 3mm Allen key and machine screws to fix the door in the top and bottom countersunk hinge hole positions as per the diagram opposite.

DO NOT FIT THE 4.2x25MM SELF-DRILLING SCREWS AT THIS POINT.

Important: A seal gasket is fitted under the door outside edge. Please take care to ensure the door rests on the aluminium part only to prevent damage to the seal.

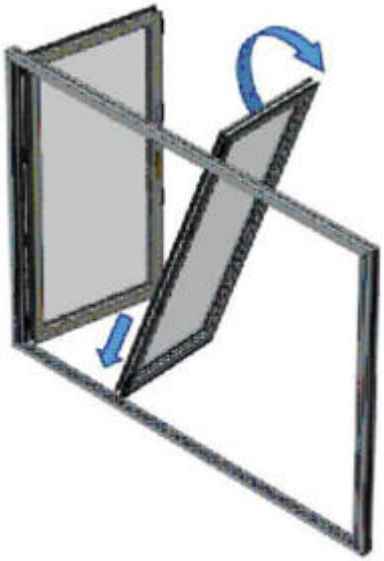


Fitting the doors (supply options 2 and 3- Continued)

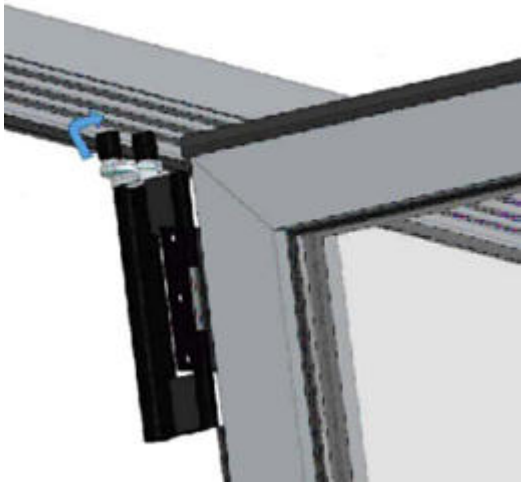
Repeat this process if your door set has a hinged panel on both frame jambs.

Locate Door 2, paying attention to the panel glass beads and drainage holes. Door 2 has its hinges and rollers already attached.

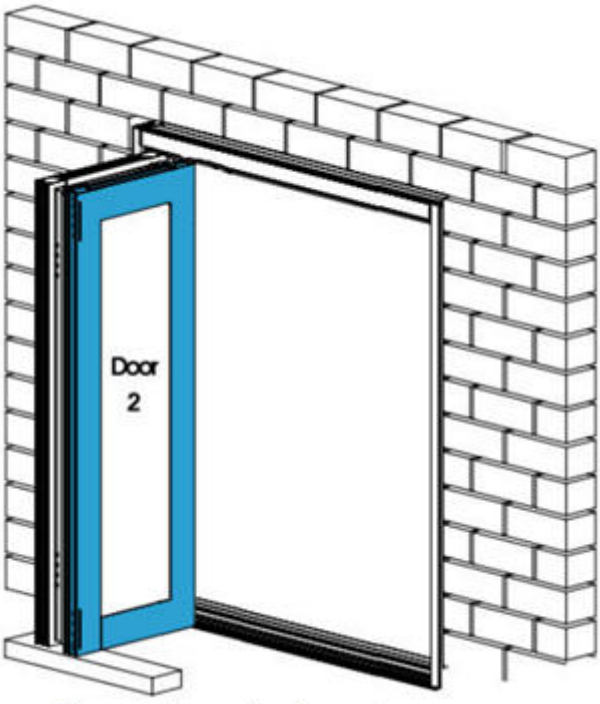
Slightly lean the door to locate the bottom roller into the middle channel of the integrated cill / threshold.



Align the top guide of door 2 and locate it in the middle channel of the top track.



Move the door to the right angle position and support on blocks, ensuring the weight is not on the door seal.



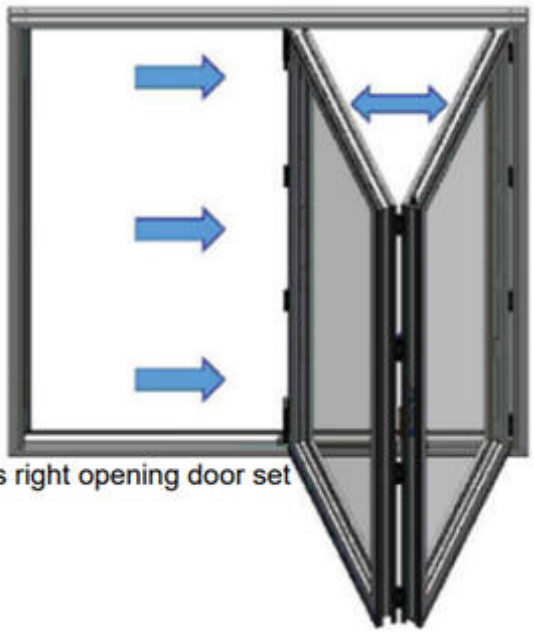
Shows left opening door set

Fitting the doors (supply options 2 and 3- Continued)

Fit Door 1 to Door 2 with the 4 hinges which are already fitted to Door 2 using the machine screws and a 3mm Allen key in to each hinge leaf.

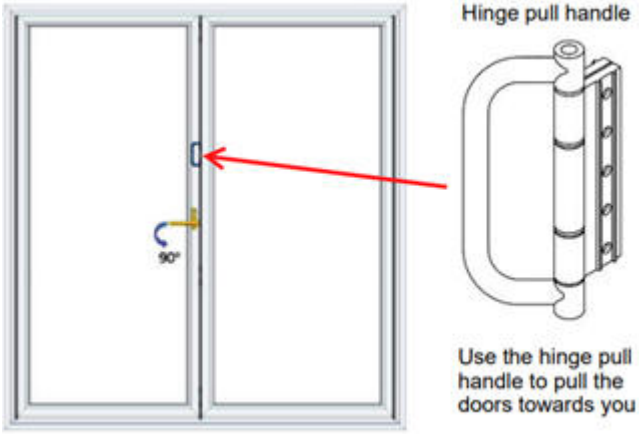
Align the clamping plates with the hinges to do so. Keeping both doors on an angle will allow for better access. The hinge with the pull handle will be second down from the top.

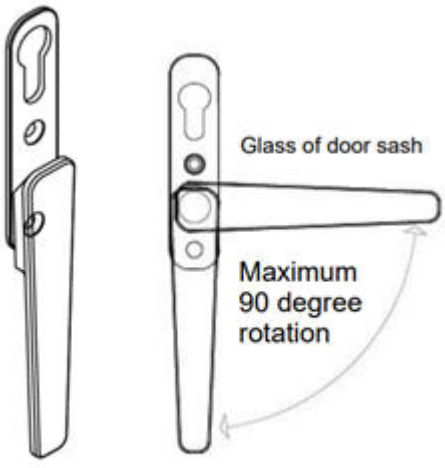
Do not fit the 4.2 x 25mm self-drilling screws at this point.



Shows right opening door set

Close the doors from the inside using the HINGE pull handle,then rotate the intermediate twin point lock handle 90 degrees to lock the doors closed.





Closed position Open position

DO NOT USE THIS HANDLE TO PUSH/PULL THE DOOR

Fitting the doors (supply options 2 and 3- Continued)

Locate any remaining connecting doors and repeat the above process. The hinges will be pre-fitted to the doors and will require temporarily securing using the machine screws and Allen key.

For any doors that require securing to the pre-fitted hinges on the opposite frame jamb, repeat the same process as followed when fitting door 1.

The glazing beads should always be to the inside.

Fitting the handles and magnetic catch

Skip this step if you have ordered a 2 door or 4 door bifold all opening to one side as you do not have a daily access door with an internal and external handle.

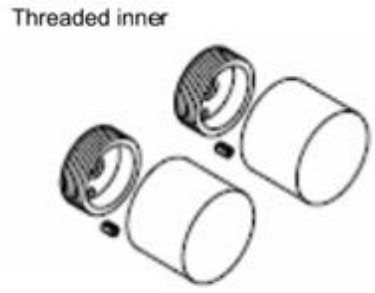
Fit the handles to daily access door where the main lock is pre-fitted using the long threaded bolts provided. The handle with the screw holes should be fitted to the inside, and the handle without screw holes should be fitted to the outside.

Check the operating of the lock with the access door in the OPEN position first, by lifting the handle and turning the key to lock the door, reverse the process to unlock the door.

Fitting the handles and magnetic catch (Continued)

Fitting the magnet catch

Screw the extended magnetic catches onto the threaded inner's which are located on the outside between any daily access door / main door, and the adjoining door.



Extended
magnetic catches

Final checks

Now check the lock is working when in the closed positioned and check the general operation of the doors.

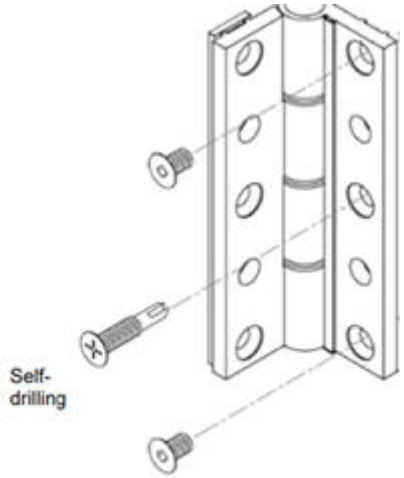
Important: When closing your bifold doors, please do not pull them along using the access door. Instead, begin from the hinged end of the door set - close the first hinged panel by pulling the hinge handle and engaging the twin-point lock (do not pull using the twin point locking handle), then continue working your way along each panel in sequence. The access door should remain fully open until all other panels are securely closed. Once the bifold panels are in place, you can then close and lock the access door last. Reverse this process when opening.

Failing to operate the doors correctly can cause misalignment and damage to the roller system and frame, and will invalidate your guarantee. You must never close the doors by dragging the access / main door first. The twin point lock handle must never by used to push and / or pull the doors.

Final fixing

If you are happy with the operation of the doors at this stage and they close smoothly without catching on the frames or lock keeps, you can now fit the self-drilling screws to each hinge leaf.

If not, please see our trouble shooting guide on page 12 to adjust the doors to their optimum position.



Glazing the doors (supply option 1)

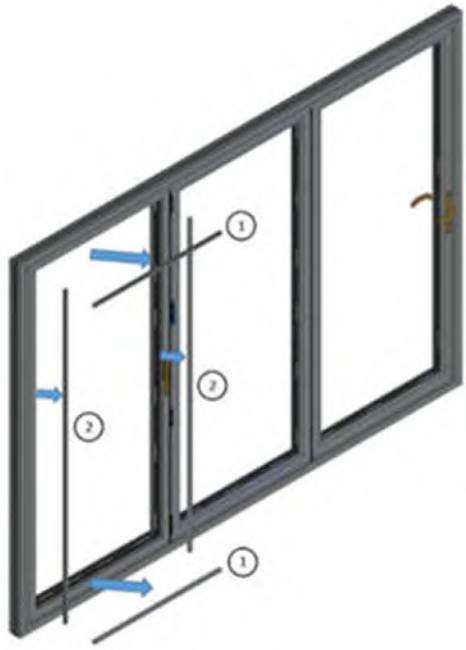
Do not continue with this process if the doors are not operating correctly.

The doors will need to be toe and heeled and this should be completed in accordance with the recommended British standards and by a person(s) experience with glazing doors and windows. You should not attempt this if you are not familiar with this process.

Fully close the doors and engage all locks to secure all doors in place.

Start from the first door panel hinged to the outer frame jambs, remove beads carefully and place them to one side.

Important: The glazing beads must be returned to their original positions and in the correct order, so make so make sure you take note of their original location.



Carefully place the glass into the frame, using a selection of glass setting blocks in varying thickness to ensure proper support. Be sure to support both the inner and outer panes of the glass.

Each panel must be toe and heeled in order for the doors to operate correctly.

Apply silicone between each vertical stack of packers to help secure them in place. Take care to ensure that none of the packers obstruct any drainage or pressure relief holes.

Toe & heeling should distribute the weight of the glass correctly to ensure the door is square and aligned as shown in the example below. Please take note of the door opening direction, the examples below are for left opening door sets.

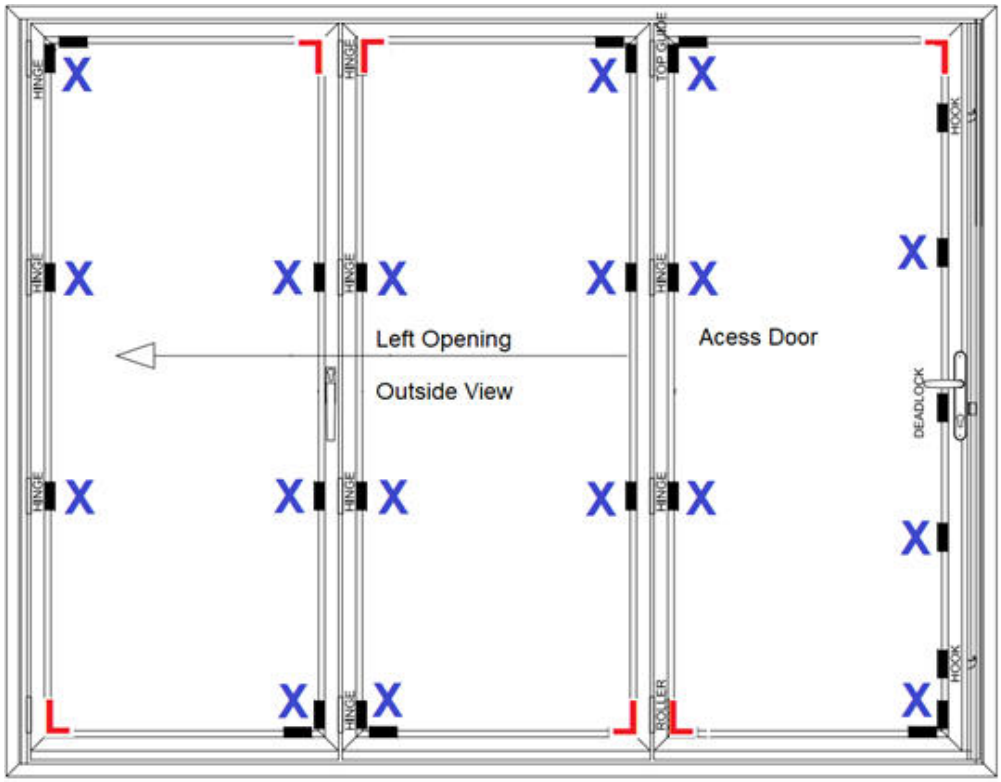
Support packers should be placed between all hardware component locations.

Glazing the doors (supply option 1 - Continued)

Below is a general guide however this task should be completed by a person experienced and trained in toe and heeling doors and windows.

L - Toe and Heeling

X - Support packing

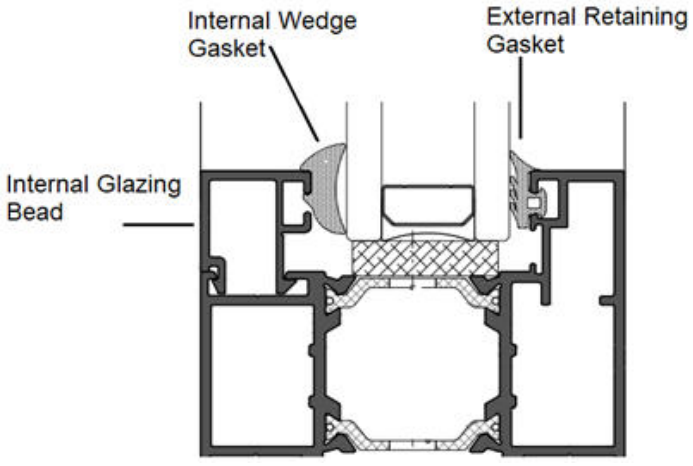


Once you are happy the glass is toe and heeled correctly and secured into the door panel, re-fit the glazing beads. Start with the top and bottom sections first, tapping into place with a glazing mallet, then install the longer side beading.

We advise spraying the units with mild soap/water mixture or glass cleaner to make beading and fitting the gasket easier. Ensure you have toe and heeled, and packed the units correctly.

Be careful not to scratch the paint profile.

Finally insert the internal wedge gasket to secure and seal. The gasket will require compressing and pushing in to locate correctly. It is recommended that a glazing paddle is used to help with the compression.



Repeat the same process on all the remaining door panels.

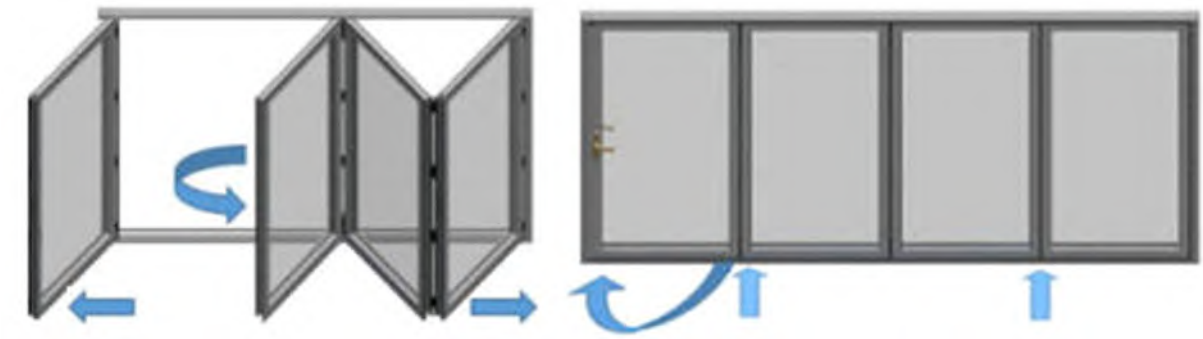
Re-check the door operation as per the steps in the previous section above ‘Final checks’ and below.

Operating the bifold doors

It's essential that your bifold doors are operated correctly to ensure smooth performance and long-term reliability. Improper use can lead to misalignment, damage to the rollers or frame, and will invalidate your warranty. Taking care during operation helps maintain the integrity of the system and ensures your doors continue to function as intended.

Closing the Doors
Always begin at door number one — the panel hinged directly to the frame, at the opposite end from your main access door. Use the hinge pull handles between doors one and two to pull them closed, then turn the twin-point handle to lock them securely in place. Do not use the twin point handle to pull or push the doors open. Continue this process along the set, closing and locking each section in order. The access door should remain fully open and folded back until all other panels are closed. Only then should you close and lock the access door. Do not drag the doors closed using the access door, as this can cause strain and misalignment.

Opening the Doors
To open the doors fully, start by opening the main access door and folding it back onto the adjacent panel. With the access door fully open, use the twin-point handle to release and fold the next section, working your way along until all panels are neatly stacked.



Finishing around the frame

Once you are satisfied with the correct installation of the frame and door operation, break off any protruding packers where necessary.

Remove any remaining temporary protective tape from all profiles. Clean down the aluminium and glass with warm, soapy water.

The final finish you wish to achieve comes down to personal preference and is to be discussed with your installer before commencing. Below is a general guide to sealing around the outer frame.

Expanding foam can be used to fill any large apertures around the frame. Be careful not to overfill. Trim or silicone around outer frame and seal below the external cill if applicable. Ensure the frame is free from dust and debris before applying to ensure an adequate barrier is created to prevent any water or air leakage.

Seal under and around the outside of the cill, ensuring you do not block any of the drain holes. Repeat the frame sealing on the inside using decorators caulk and/or trims. Take care to ensure any drainage holes are kept clear of debris and sealant.

Re- check the door for correct function and instruct the homeowner on their correct operation.

Trouble shooting guide

Check the operation and basic running of the doors to make sure the mechanisms are working properly by opening and close the doors as shown above.

If you're experiencing any difficulty with locking or operating your bifold doors, it's essential to first check the levels of the outer frame. Pay particular attention to the head and cill — any dips or rises in these areas can affect door alignment and performance. Misalignment caused by an uneven frame can lead to damage to the rollers and frame, and will invalidate your warranty.

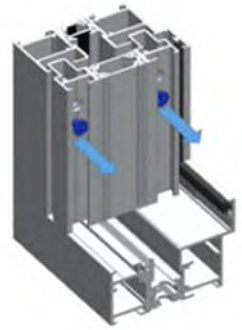
Next, assess the horizontal and vertical gaps between the outer frame and the door panels at the top, bottom, and sides. These gaps should be even and consistent across all panels.

If you've selected Supply Option 2 or 3 (loose glass) and you're confident the frame is upright, plumb, and perfectly level on all planes, it's important to re-check the toe and heeling of each panel. Ensure the glass units are seated correctly and fully supported to maintain proper alignment and smooth operation.

Overall heights of 2391mm and above
Door sets with a height of 2391mm or greater are supplied with frame jamb inserts to allow for fine adjustment during installation. If your doors appear to sit too close to or too far from the locking frame jamb, these inserts can be adjusted to correct the alignment.

To begin, remove the two strips of rubber gasket located within the frame jamb inserts. This will give you access to the securing and adjustment screws.

Next, release all bottom self-tapping screws that hold the insert in place. Once loosened, use the grub screws to carefully reposition the jamb as needed.



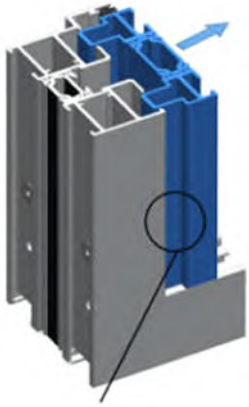
-4mm

0mm

+4mm

2mm gap

6mm gap



10mm gap

Check that the gaps between the door panels and the outer frame are even and consistent, and ensure the insert is set square and level. Once satisfied with the alignment, secure the insert by re-tightening the self-tapping screws.

Finally, check the door operation to confirm smooth movement and proper locking, then re-fit the rubber gaskets into the frame jamb inserts to complete the adjustment.

Brighouse HD6 1HA

DECLARATION OF CONFORMANCE

DoC Nº: HEP/FSDALICORD

Product Type:	Aluminium Bifold Double Glazed Door
Intended Use:	For use in domestic and commercial premises Not intended for use on escape route
Declared System of Assessment Performance:	3
Provisions to which the Product Conforms:	Annex ZA of EN 14351-1:2006+A2:2016
Reference to Supporting Product Certification and/or Test Reports *(supportive of compliance)*:	BFRC Thermal Report – S158/20221018/001

Declared Performance:

Essential Characteristics	Performance
Resistance to Wind Load:	Class A3 (1200Pa)
Watertightness:	Class 9A (600Pa)
Dangerous Substance:	No emissions of dangerous substances emitted
Load Bearing Capacity of Safety Device:	Npd
Acoustic Performance	Npd
Energy Rating:	C
Radiation Properties:	Npd
Air Permeability:	Class 4 (600Pa)

This declaration of performance is issued under the sole responsibility of Hepworth Framework Limited.

Signed for and on behalf of the Company by

Name of Representative: Richard Steckles **Job Title:** Managing Director

Representative Signature: **Date of Issue:** 24th February 2023

Product UKCA Marking Detail:

Hepworth Framework Limited
Brighouse HD6 1HA
23
EN 14351-1:2006+A2:2016
Aluminium Bifold Double Glazed Door
DoC Nº: HEP/FSDALICORD
Not intended for use on escape route