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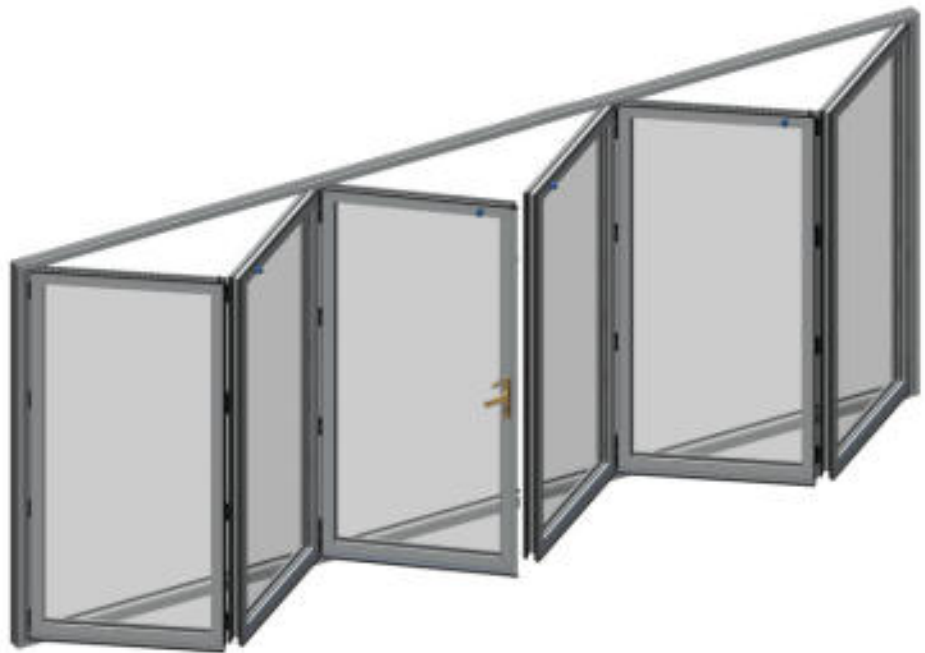
EXTERNAL ALUMINIUM

6 DOOR BiFOLD DOOR SET

Integrated Cill

Assembly Instructions

Bespoke and Standard Sizes



About your patio door set

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.

Important information

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

Automatic closures and operators

- The hardware systems are designed for manual operation. Poorly adjusted automatic closures can impart significant destructive forces to tracks, bearings and stops. Such hardware used in installations is expressly excluded from warranty terms.

Care of doors and frames on site

- Please check doors, frames and cill at the time of delivery and within 72 hours of delivery to ensure that they are acceptable and in good condition. If you find a component missing or damaged, please inform your supplier immediately. We keep replacement components of most set parts and these can be sent out to you quickly. This will save you having to repackage and return the whole set, and allows you to continue with the project. (See contents list on page 3 for full list).
- When storing prior to installation, the doors and frames should be handled with care and stored in a dry, ventilated building. Doors and frames should be stored flat and on a level surface (not on edge or on end).
- Should you need to store the doors before installation, they must still be fully inspected and checked for damage or faults and reported within 72 hours of delivery, repacking if necessary.
- Remove the blue plastic protective film immediately after installation. We do not recommend to leave this on for long periods of time as moisture can get trapped underneath the film, causing permanent marks on the aluminium powder coating.
- Do not leave masking tape on the aluminium powder coating for long periods of time. It is important it is removed within 24 hours of applying.

Trimming

- This bi-fold door is not designed to be trimmed on site and should be fitted as supplied. Trimming the doors or frame will void the warranty.

Conditions of sale

- We shall not be held responsible for any incidental work expenses arising out of or because of any defects in our product, or bad workmanship to our product. In the event of goods having manufacturing defects and requiring replacement, our liability will be limited to the value of the door or frame component only. These notes do not affect your statutory rights with the retailer of this product.

Maintenance

The aluminium powder coating and bi-fold door hardware in buildings is subject to deterioration from everyday use, and also environmental attack due to atmospheric and other conditions. Maintenance of the powder coating and hardware is even more important in severe environments such as close to marine areas, and some industrial areas. Even stainless steel products require maintenance to prevent deterioration in some environments. We require the following minimum maintenance to be followed otherwise the warranty shall be void.

Tracks and bearings

Using a spatula or similar (not your fingers), apply a small amount (typically a ½ teaspoon of white petroleum jelly, Vaseline or similar lubricant to the inner lip of each side of the track. Ensure that the wheels pass through the lubricant and it is evenly distributed along the track. Put additional lubricant around the bearings. Lubrication reduces wear, improves smoothness and further protects against corrosion of tracks and bearings. Remove all surface contaminants by wiping all visible track surfaces with a damp soft cloth and mild detergent, then wipe clean with a clean cloth. In severe environments, apply a thin film of corrosion preventative such as WD40, by wiping with a soft cloth moistened with one of these products.

Stainless steel bearings are manufactured from hardening-grade stainless steel and although this material performs considerably better than plated steels, it is susceptible to corrosion unless maintained as described as above.

Hangers, 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.

Hinges

Wipe down the visible surfaces with warm soapy water on a soft rag and then rinse off by wiping with a clean damp rag. Application of a thin film of a light machine oil or WD40 will help maintain the original lustre of the metal finish.

Twin point locks

Spray application of a suitable lubricant such as WD40 to the sliding pin inside the bolt and to the lock cylinder is recommended. 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 monthly
- Close to marine environment - 3 monthly

Aluminium powder coating

Preferably, every time you clean your windows also clean the aluminium doors and frames, or at the minimum every 3 months (or monthly if within 5 miles of the sea, or in industrial areas.) Wash the outside of the doors and frames with soapy water using a mild detergent and soft lint free cloth. Dry the surface using a clean absorbent cloth or leather, then buff with a soft cloth.

Introduction to Assembly

QUICK GUIDE

Your aluminium bifold door set is supplied with the frame unassembled and in 4 pieces ready for assembly on site. The doors are all pre-glazed and the glazing is 'toe and healed' in the factory to balance the glazing in each door, then in the full set.

Every bifold door set is pre-assembled in our factory to ensure it is operating perfectly before we deliver it. We then dismantle the frame and remove some hardware, before carefully packing it for transportation to your home.

When you receive the bifold door set to install it, assemble the frame then install it into the brickwork opening.

Attach the hardware to the doors into the frame.

Because the bifold door set has already been assembled and operated in our factory, as long as the frame is installed securely into the brickwork opening, completely level and square in every plane, and the hardware is correctly attached, then the installed bifold door set should operate perfectly, without the need for further adjustment.

Full and detailed installation instructions are contained within this Instruction booklet

Contents

Please check the contents of the packages to ensure all parts are present before beginning assembly

Aluminium Parts

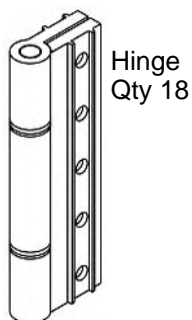
Doors

Door 1 (Door to frame jamb)	Quantity 1	Door 4 (Door to frame jamb)	Quantity 1
Door 2 (Mid Door)	Quantity 1	Door 5 (Mid Door)	Quantity 1
Door 3 (Mid/End Door)	Quantity 1	Door 6 (Acces Door)	Quantity 1

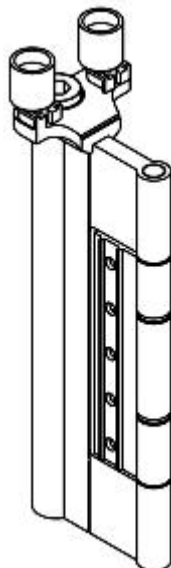
Frame Pack

Frame Head	Quantity 1
Frame Jambs	Quantity 2 (1x Left and 1x Right)
Integrated Cill	Quantity 1

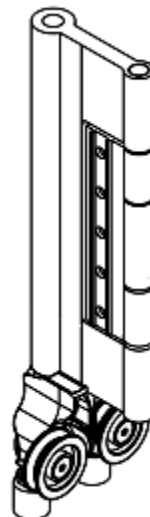
Hardware



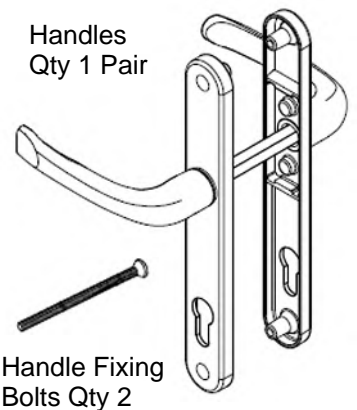
Top Guide
Qty 2



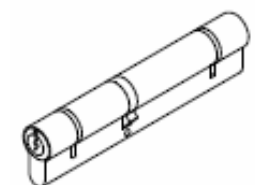
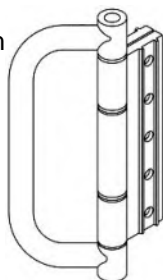
Bottom Roller
Qty 2



Handles
Qty 1 Pair



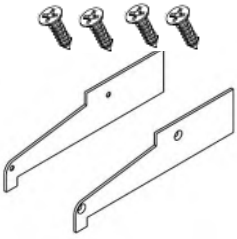
Hinge with
Handle
Qty 2



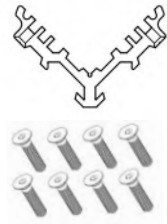
Anti Bump Cylinder
Qty 1 (Keys Qty 3)

Contents (2)

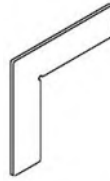
Cill End Caps
Qty 2
Fixings Qty 4



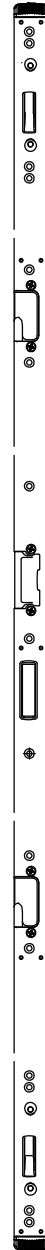
Mechanical Corner
Cleat - Qty 4
With M6 x 16 Machine
Screws Qty 8



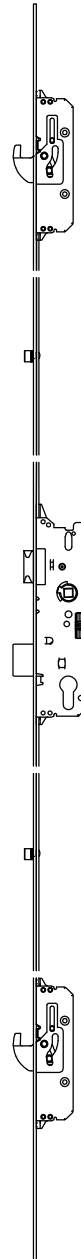
Corner
Chevron
Qty 2



Lock Keep
Qty 1



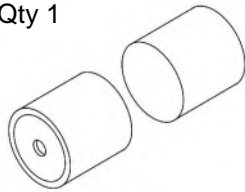
Multi Point
Door Lock
Qty 1



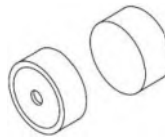
Black Bungs 12mm
Qty 8



Extended Magnetic
Catch
Qty 1



Short Magnetic
Catch
Qty 1 (pre-fitted)



Installation Bag Contents

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



B. SDS Drill bit 6.5mm x 210mm - Qty 1



C. HSS Drill bit 7mm x 105mm - Qty 1



D. Power bit 1/4 x 70mm TX30 - Qty 1



E. Insert bit 1/4 x 25 pozi No2 - Qty 1



F. Allen Key 3mm - Qty 1



G. Allen Key 4mm - Qty 1



H. Assorted bag of Packers and Wedges

VERY IMPORTANT NOTE

To speed installation, we have pre-installed some components in production.

- The twin point lock and handles is installed into Doors 1 & 4.
- The frame jamb / Door 1 & 4 hinges are installed onto the frame jambs.
- The hinges in between Doors 1 & 2 and the top guide and bottom roller are all installed on Door 2.
- The hinges in between Doors 4 & 5 and the top guide and bottom roller are all installed on Door 5.
- The multi point door lock is installed into the Door 6.
- The lock keep is installed onto Door 3.
- The short magnetic catch is installed onto Doors 2 & 3

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.

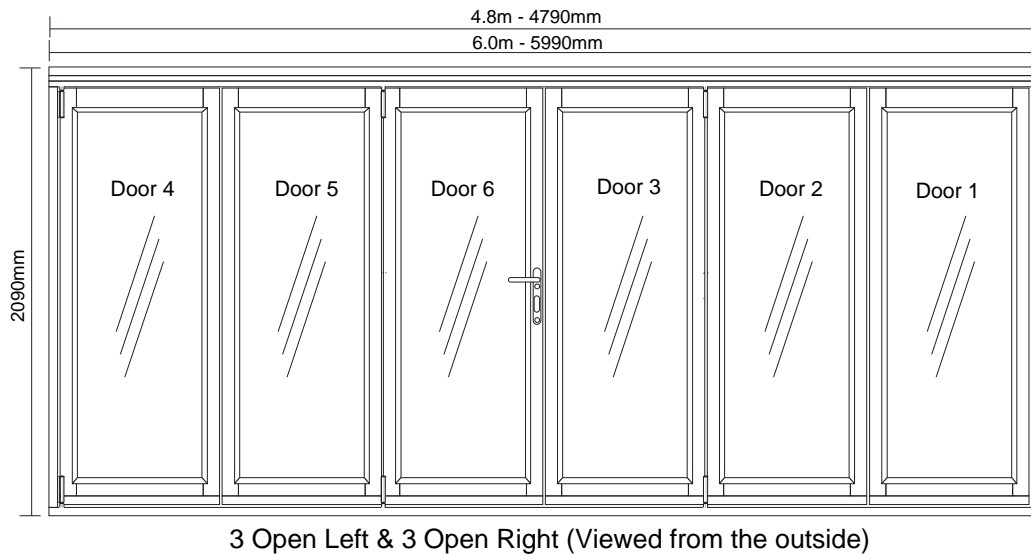
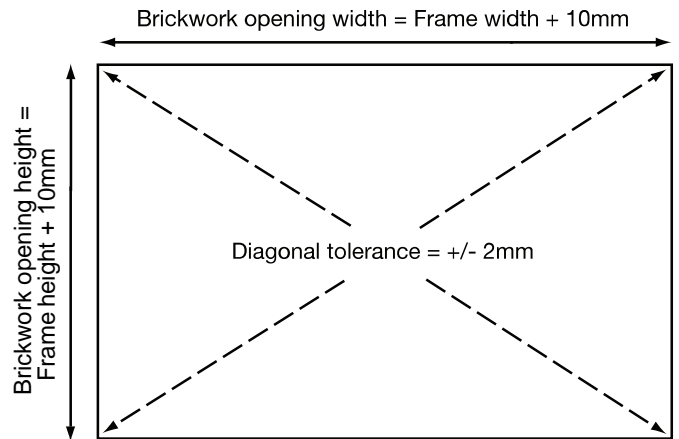
It is essential that all 4 internal surfaces of the brickwork be levelled before installation. Please ensure that all dimensions are correct for installation before proceeding, as the set must be installed square and level into the opening.

Standard sized Aluminium door sets outer frame dimensions are as follows;

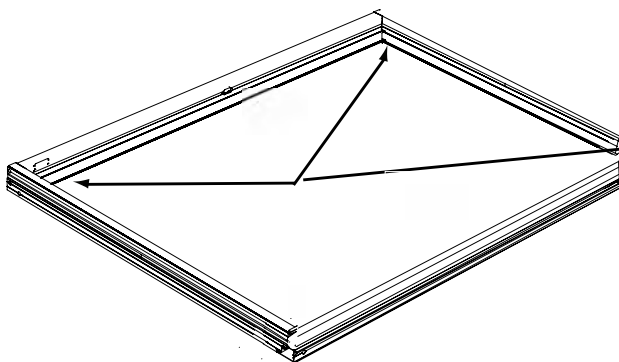
4.8m - Door set = 4790mm wide x 2090mm high
6.0m - Door set = 5990mm wide x 2090mm high

The Brickwork opening sizes are:

4.8m - Door set = 4800mm wide x 2100mm high
6.0m - Door set = 6000mm wide x 2100mm high



Assembling the frame



- 1 Lay the 4 pcs of frame on the floor on top of cardboard or a similar protective covering to prevent damage to the aluminium.

- 2 Assemble the complete frame by fixing the jambs to the head and bottom rail using the corner chevrons and mechanical corner cleats.
The integrated cill screws into the jambs.

Assembling the frame continued

Mechanical Corner Cleat Assembly - Frame Head & Jambs

2 a) Insert the 2 corner chevrons into the grooves in the frame head (Fig 1).

b) Insert the mechanical corner cleats into the frame head (Fig 1).

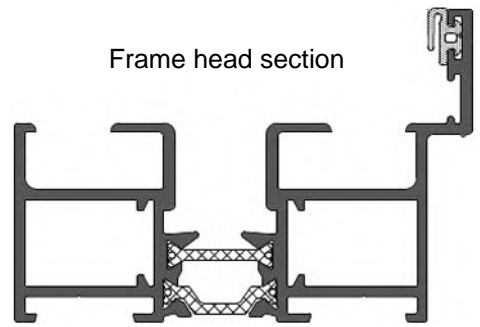
c) Apply low modulus silicone sealant to the aluminium profiles to be joined together.

d) Carefully align the mitre joints, then using the 4mm Allen Key (G), 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.

e) Fill in the remaining smaller holes with low modulus silicone or glue as shown below (Fig 2).

f) Repeat the process on the opposite corner of the frame (Fig 3).

Frame head section



Frame jamb section
(with adjustable jamb attached)

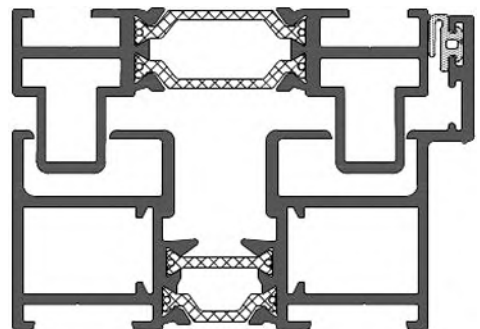


Fig 1.

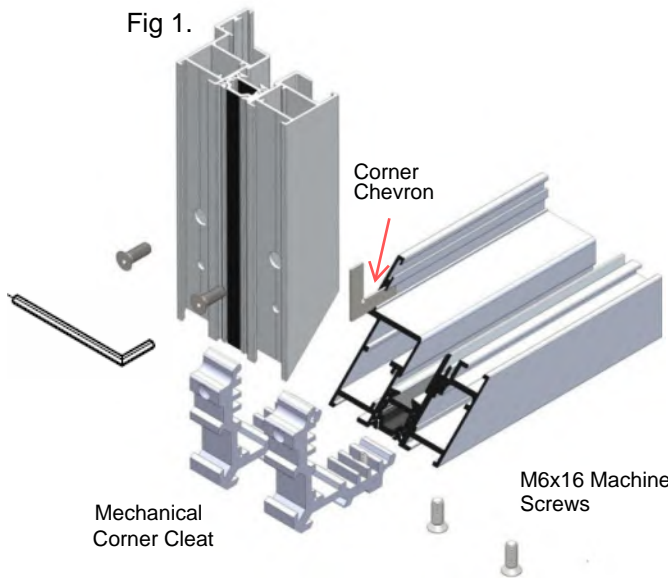


Fig 2.

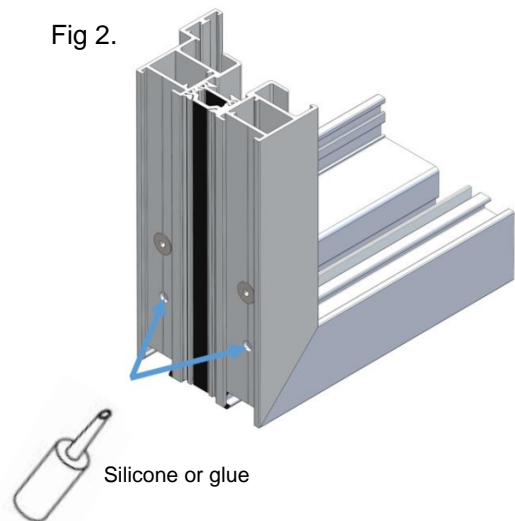


Fig 3.



Assembling the frame continued

- 2 g)** Insert the foam sealing block supplied into the channel of the integrated cill (Fig 1).
- h)** Before locating the jambs onto the cill, mastic seal both ends of the jambs and the face of the thermal break.
- i)** Once the jambs are aligned onto the cill, silicone dip the machine screws provided and secure (Fig 1).
- j)** Any excess silicone should be wiped off at this point.
- k)** Silicone seal both end caps onto the cill. Silicone dip the screws and fix the caps in place using the 1/4 x 25 pozi bit (Fig 3).

IMPORTANT-

Ensure no water can escape from the ends of the cill past the jambs. Any fixings breaching the drainage channel (Fig 2) must be silicone dipped.

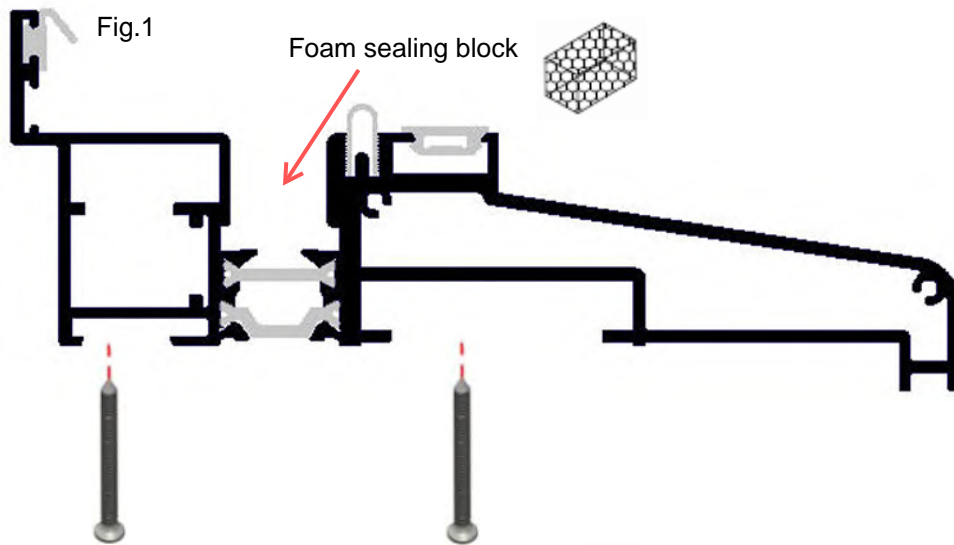


Fig 2.

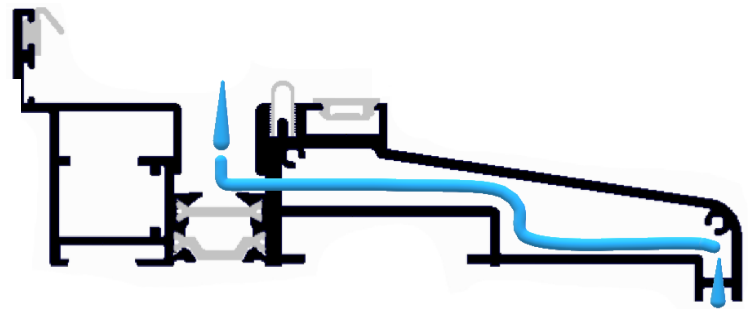
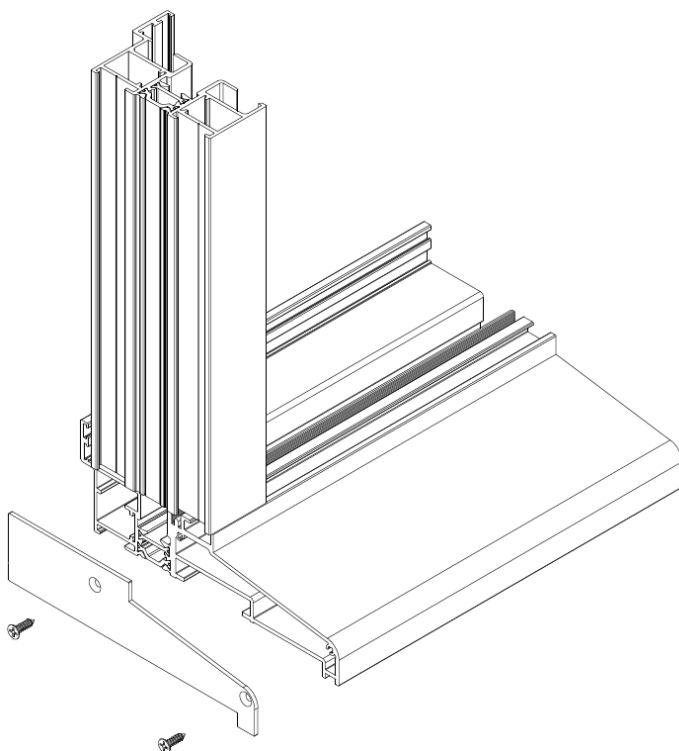


Fig 3.



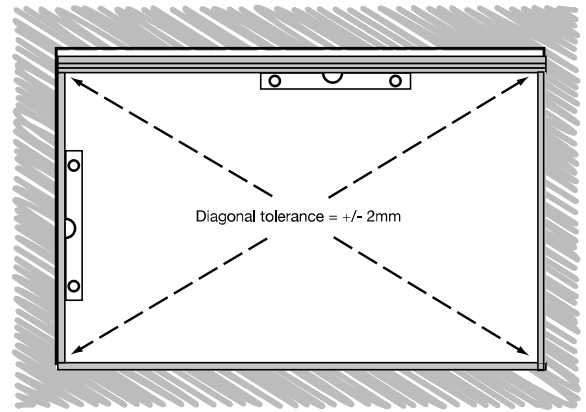
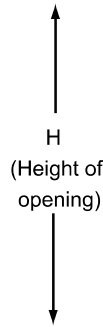
Installing the assembled frame

3 The frame should be installed with the outer edge of the frame jambs up to a maximum of 5-10mm back from the face of the brickwork.

It is critical that the frame is fitted square and level.

Use the packers provided to level the frame. Start at the bottom rail and insert the first packer **DIRECTLY UNDER THE FRAME JAMB** starting at the side of the frame which looks to be the highest

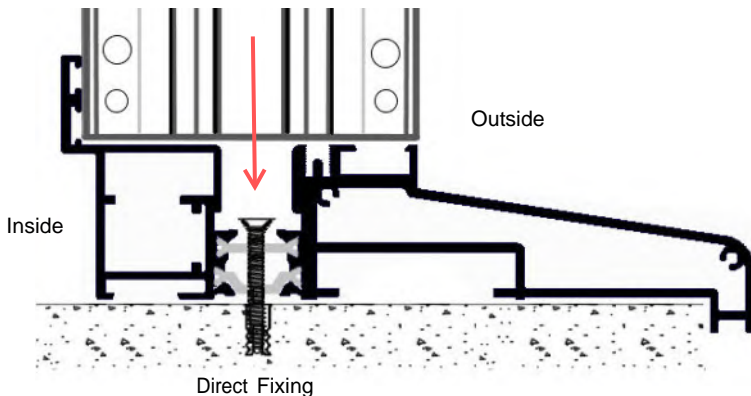
The diagonals must be the same, +/- 2mm.



The diagonals must be the same +/- 2mm.

IMPORTANT NOTE:

The frame must be installed into the brickwork opening completely upright, square and level in every plane, before continuing with the installation. The door set uses a bottom rolling system so it is vitally important the cill is level and adequately supported by using packers as necessary.



4 Direct fix 150mm from all corners and every 500mm maximum centres, using the hardened steel direct frame fixings provided (A).

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.

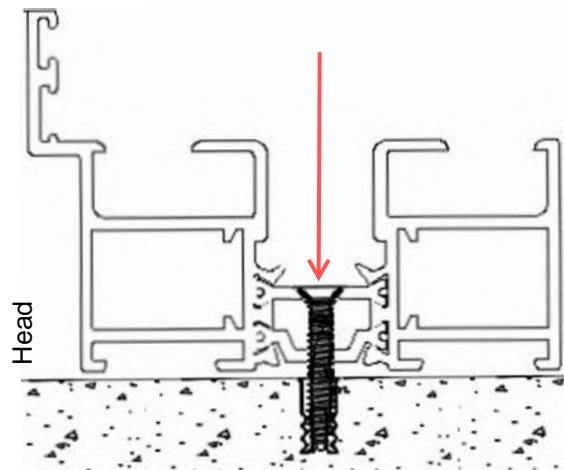
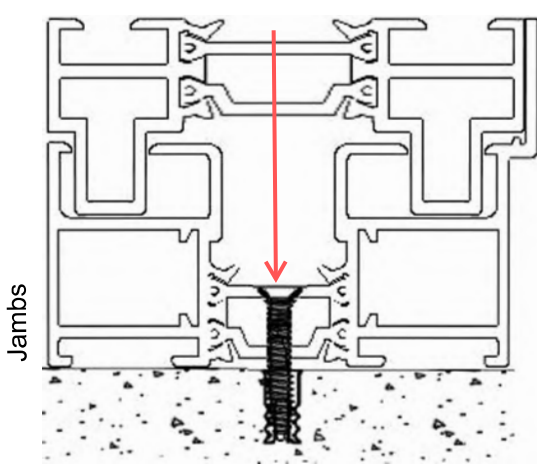
Ensure you have a packer where the roller comes to rest in the closed position.

Fix directly through the cill, head and jambs into the brickwork. Holes will need to be drilled into the head cill and jambs for the fixings, using the HSS long 7mm drill provided (C).

The adjustable jambs have been pre-drilled with 13mm clearance holes to allow access to direct fix through the thermal break in the outer frame jambs. These 13mm holes should be plugged with the 12mm black bungs supplied.

The hardened steel frame fixings fix directly into the brickwork without the need for plugs. After drilling the holes in the aluminium frame use the 6.5mm SDS masonry drill (B) to drill holes into the brickwork. Then fix using the hardened steel frame fixings with the T30 bit provided (D).

DO NOT OVER TIGHTEN THE FIXINGS OR DISTORT THE ALUMINIUM FRAME

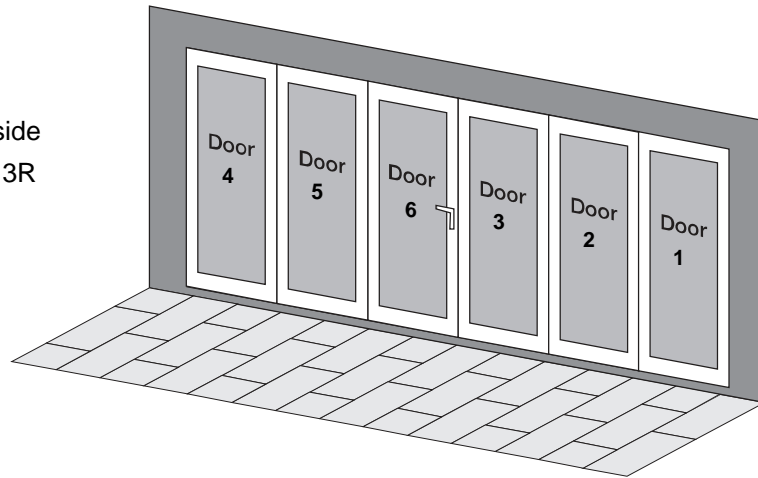


Finally apply silicone to seal all around the perimeter of the frame - especially along the complete length of the bottom cill

Opening options

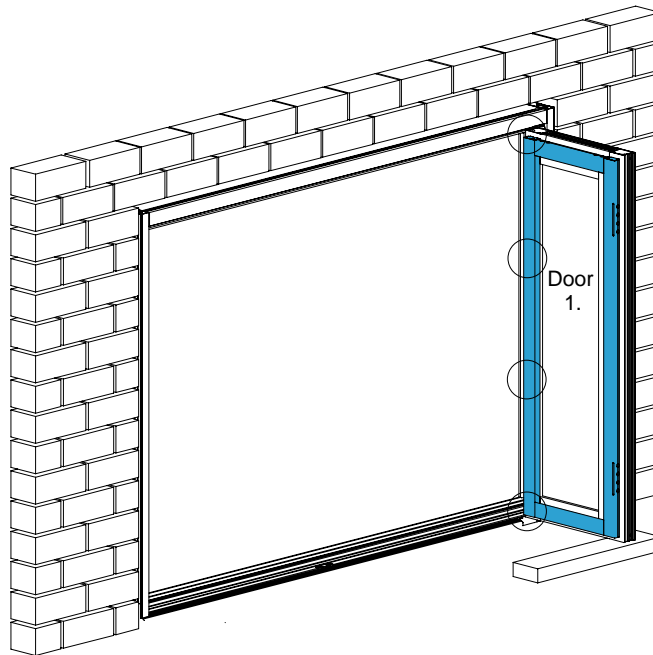
- 5** The aluminium bi-fold doors always open outwards.
The diagram below confirms the opening when VIEWED FROM THE OUTSIDE.
The access door is always Door 6.

View from outside looking inside
3L and 3R



Fitting Door 1 to the frame jamb

- 6 a)** Locate Door 1, which fixes to the right 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.
Ensure the integrated cill 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.
The hinges are already fixed to the frame jamb which just need fixing to Door 1.



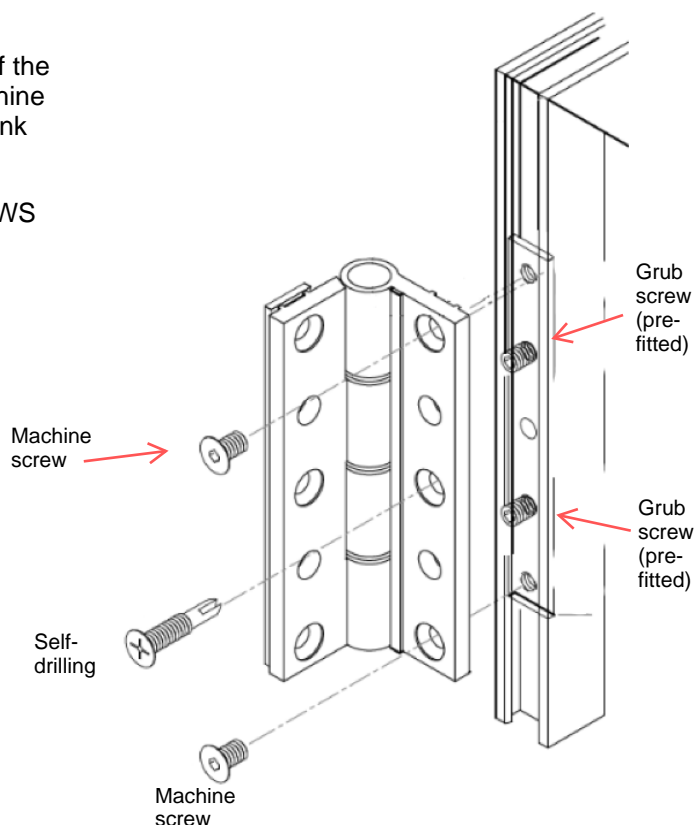
Fitting Door 1 to the frame jamb continued

- 6 b)** With the door at right angles and supported on blocks (being careful not to damage the seal on the bottom of the door), use the 3mm Allen key (F) and M5x10mm machine screws to fix the door in the top and bottom countersunk hinge hole positions.

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

IMPORTANT NOTE

The seal gasket is fitted under the door outside edge. Please take care to ensure when the door rests on the block, it rests on the ALUMINIUM PART ONLY AND NOT THE SEAL- This will prevent damage to the seal.

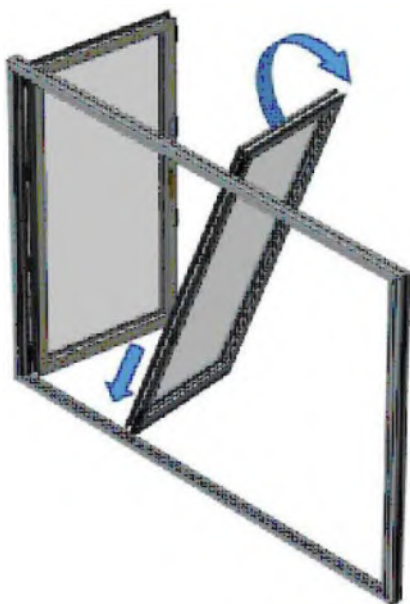


Fitting the middle door (Door 2)

- 7 a)** Locate Door 2, paying attention to the panel glass beads and drainage holes. Door 2 has its hinges and roller already attached.

Slightly lean the door to locate the bottom roller into the middle channel of the integrated cill (Fig. 1) page 10.

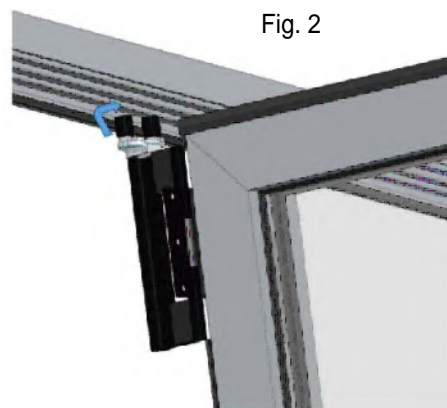
Fig. 1



7 b)

Align the top guide of Door 2 and locate it in the middle channel of the top track (Fig.2).

Fig. 2

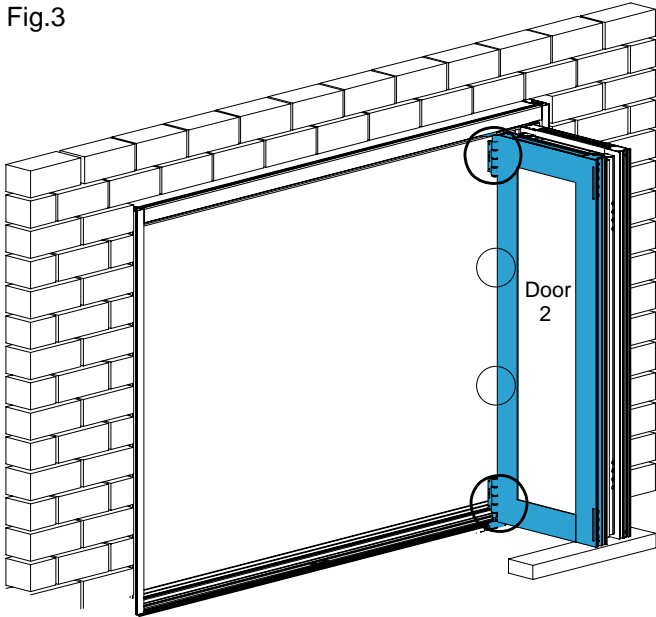


7 c)

Move the door to the right-angle position and support on blocks, ensuring the weight is not on the door seal (Fig.3. Page 11)

Fitting the middle door (Door 2) continued

Fig.3



7d) Fit Door 1 to Door 2 with the 4 hinges which are already fitted to Door 2 using the M5x10mm machine screws and the 3mm Allen key (F) in to each hinge leaf. Align the clamping plates with the hinges to do so. Keeping both doors on an angle (Fig.4) will allow for better access.

The hinge with the pull handle will be second down from the top.

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

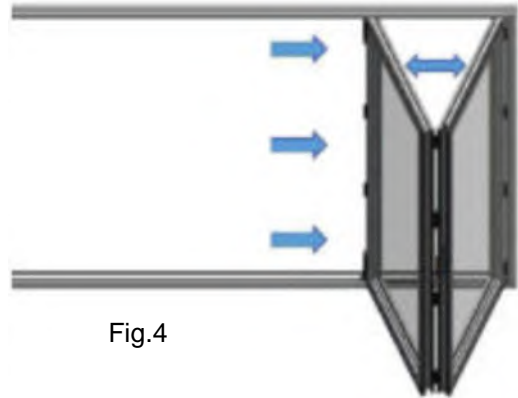
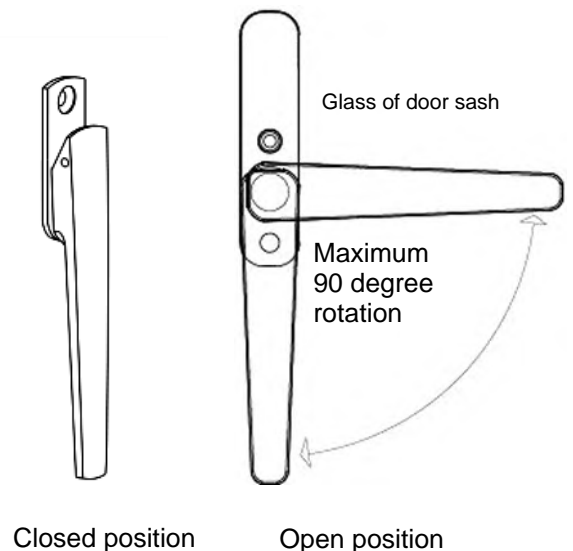
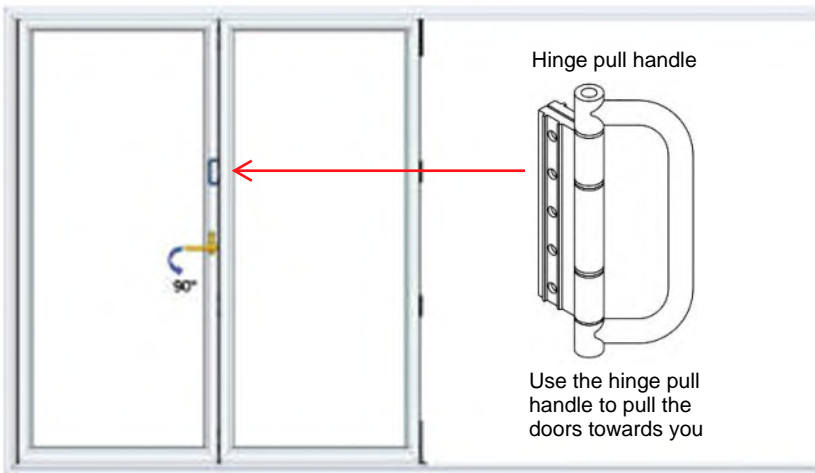


Fig.4

7e) 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.

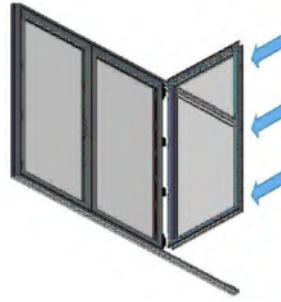


DO NOT USE THIS HANDLE TO PUSH/PULL THE DOOR

Fitting the Mid/End Door (Door 3)

- 8a)** With Doors 1 & 2 locked in place, support Door 3 on blocks adjacent to Door 2. Align the clamping plates with the hinges and attach the hinge leaves onto Door 3.

Alternatively you can keep Doors 1 & 2 open and at 90 degrees to the frame.



Fitting Door 4 to the Left Frame Jamb

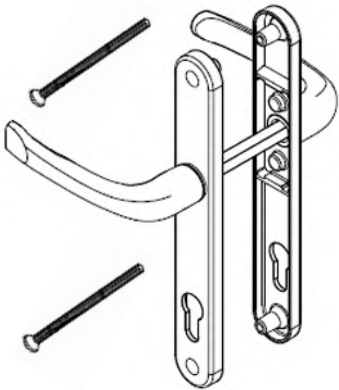
- 9** Fitting Door 4 to the left frame jamb is exactly the same as Door 1 to the right frame jamb, so please follow Steps 6a and 6b

Fitting the right Mid Door (Door 5)

- 10** Fitting Door 5 the left side mid door is exactly the same as fitting Door 2 on the right side, so please follow Steps 7a - 7d

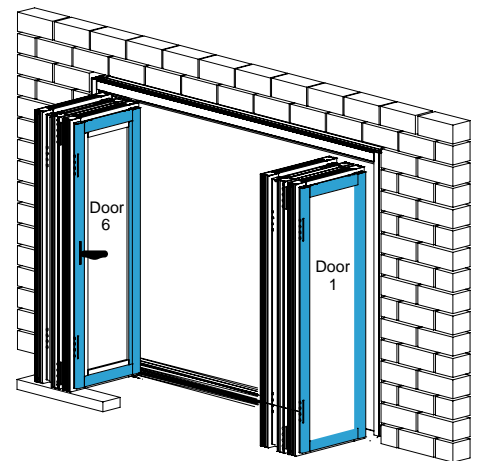
Fitting the Access Door (Door 6)

- 11** Fit the handles to Door 6 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.



- 11a)** With Doors 4 & 5 locked in place, support Door 6 on blocks adjacent to Door 5. Align the clamping plates with the hinges and attach the hinge leaves onto Door 6.

Alternatively, you can keep Doors 4 & 5 open and at 90 degrees to the frame.



- 11b)** Close Doors 4 & 5 (if opened) using the HINGE pull handle and from the inside rotate the intermediate twin point lock to secure them in place.

Repeat with Doors 1 & 2 if open and close Door 3 by pulling the door towards you, finally rotate the intermediate twin point lock.

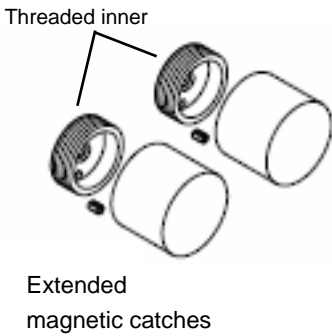
Close the Access Door 6 and lift the handle fully to ensure the lock engages.

Turn the key to fully lock the Access door.

To unlock the Access door use the key to unlock, then depress the handle to open the door.

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 14 TO ADJUST THE DOORS TO THEIR OPTIMUM POSITION.

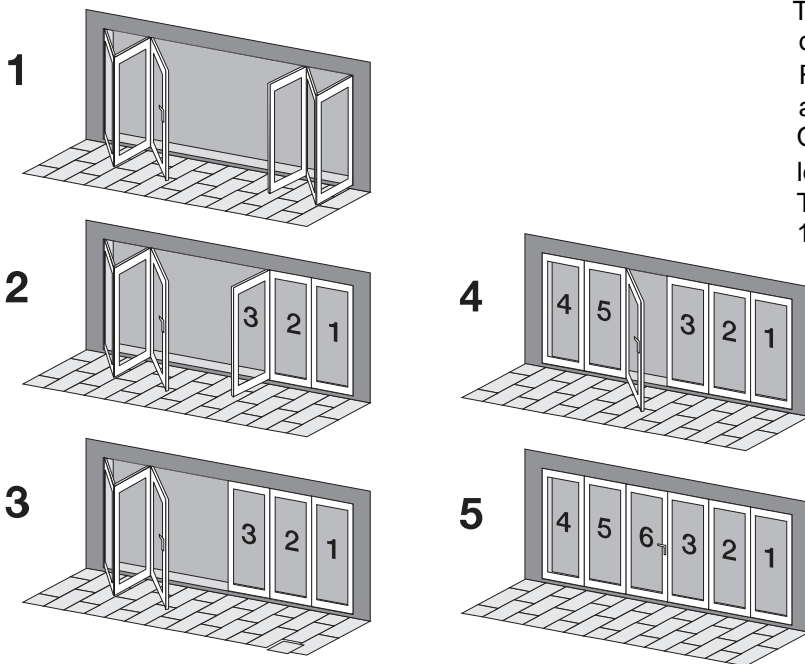
Fitting the magnetic catches



12 Screw the extended magnetic catches onto the threaded inner which are located on the outside of Door 5 and Door 6.

Operation of 6 Door bifold doors

13 When closing the door set, first close Doors 4 & 5 by pulling them towards you using the HINGE handle, then secure them with the twin point lock, by turning its handle 90 degrees. Repeat with Doors 1 & 2. Next, close Door 3 by pulling the door towards you and fix into place by rotating the handle on the twin point lock. Finally close the Access Door, Door 6 by lifting the handle FULLY and turning the key. Use Door 6 independently as a daily access door. To exist, turn the key to unlock and depress the handle to open the Access Door.

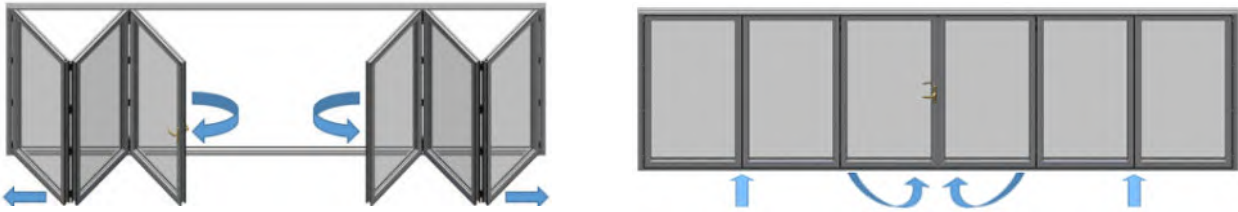


To fully open the set. Once the Access Door is open and secured on the magnetic catch. Rotate the twin point handle between Door 4 and Door 5 and open the doors. Open Door 3 by rotating the twin point lock and open so it is resting against Door 2. Then rotate the inside handle between Door 1 and 2.

Please note, failure to operate the doors as outlined above could result in damage to the roller system and frame. You must never close the doors by dragging the lead / access door first.

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 below.



If you are experiencing any locking or operational issues it is vital to check all levels of the outer frame, importantly that there is no dips or rises in the frame head and/or cill.

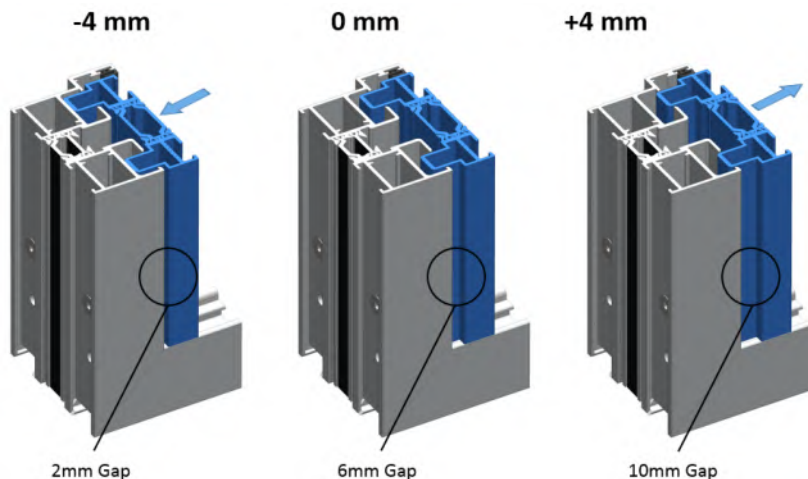
Assess the horizontal and vertical gaps between the outer frame and the top, bottom and sides of the door panels ensuring they are even and equal.

Width adjustment using adjustable jambs

- To adjust the width release all bottom self-tapping screws that secures the adjustable jamb.
- Use grub screws to change the position of the adjustable jamb.
- Check the gaps to be equal and adjustable jamb is set square and level.
- After completing adjustment fix the adjustable jamb in position by securing self-tapping screws.



- Adjustable jamb is designed to have both positive and negative adjustment as shown below.





Brighthouse HD6 1HA

DECLARATION OF CONFORMANCE

DoC N°: 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 <i>(supportive of compliance)</i> :	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:

