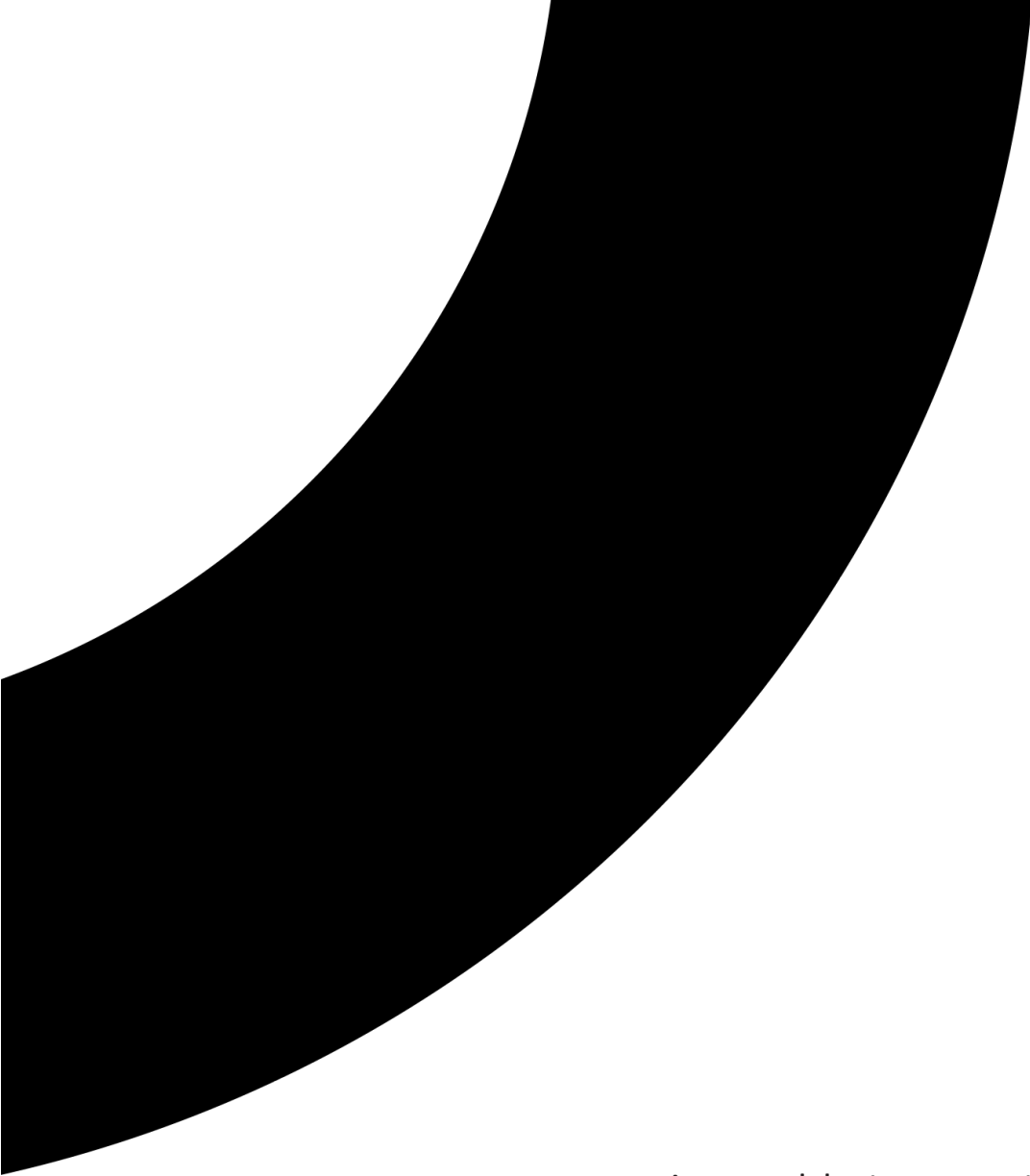


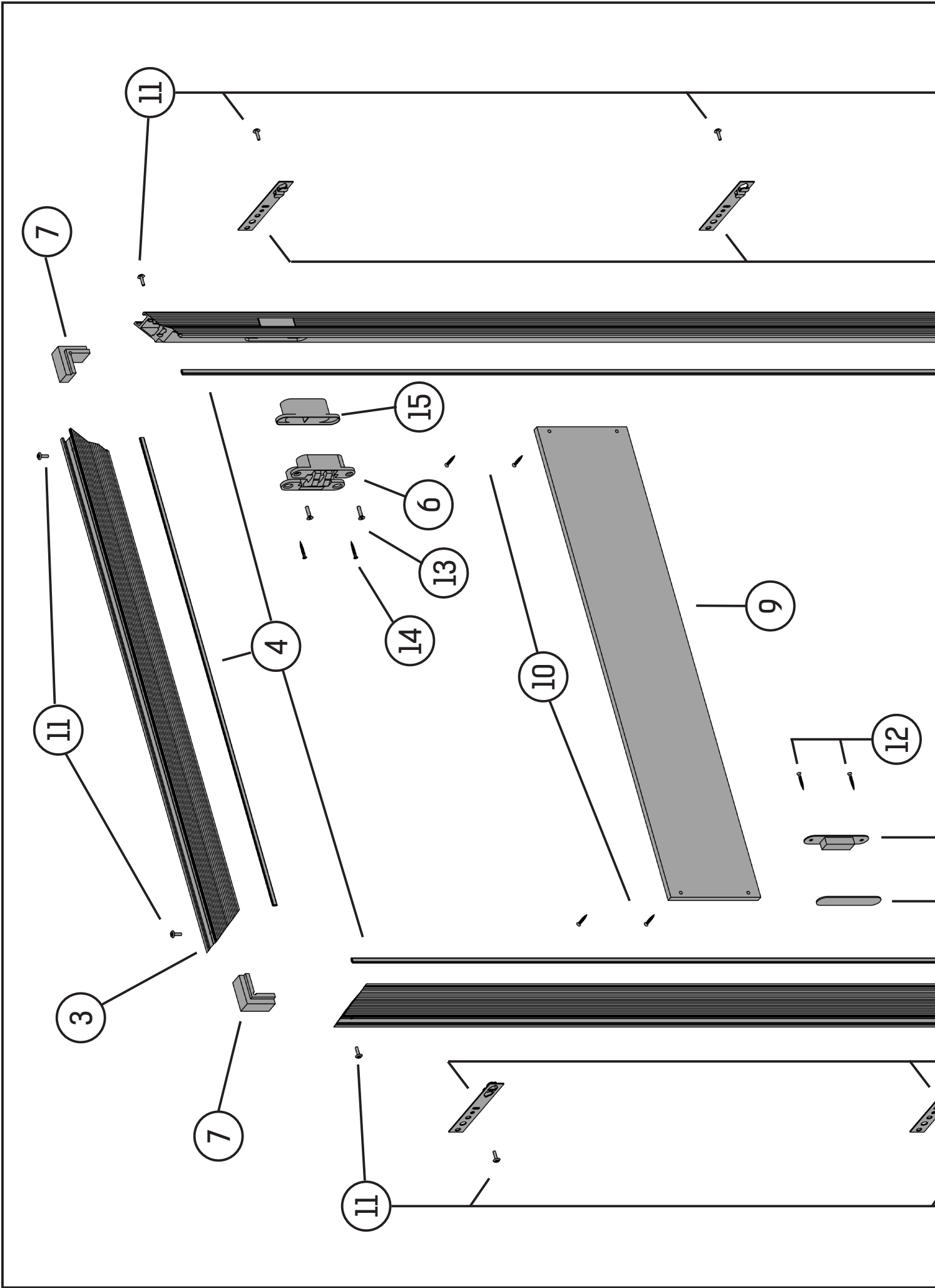


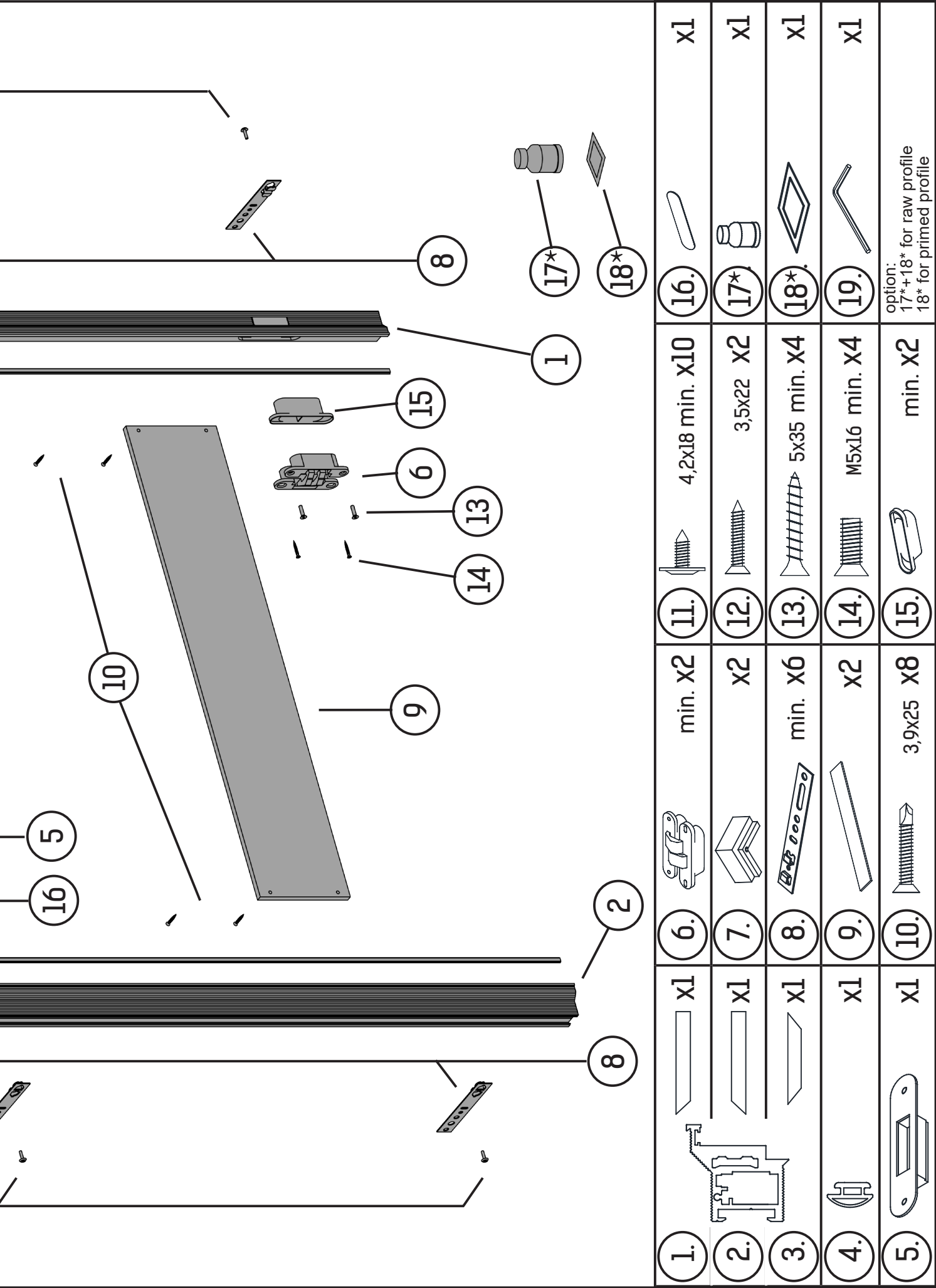
SR01

Assembly instruction

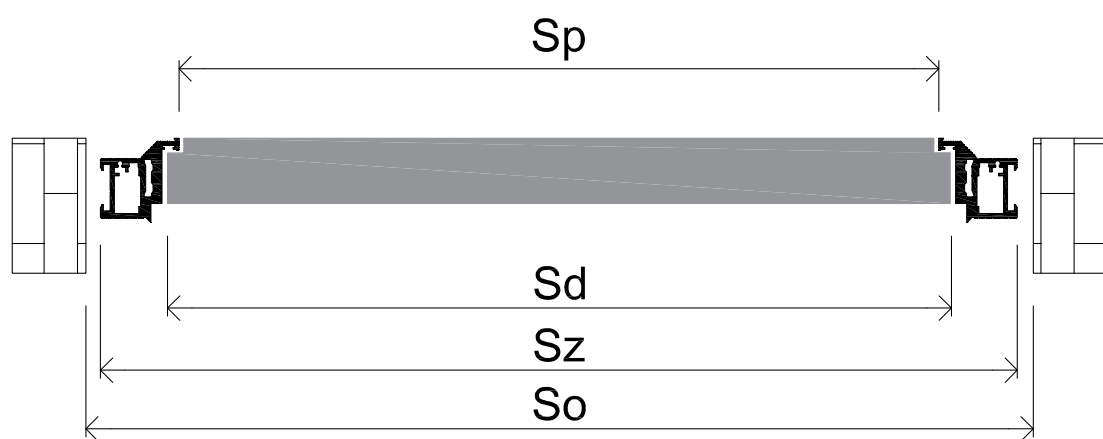
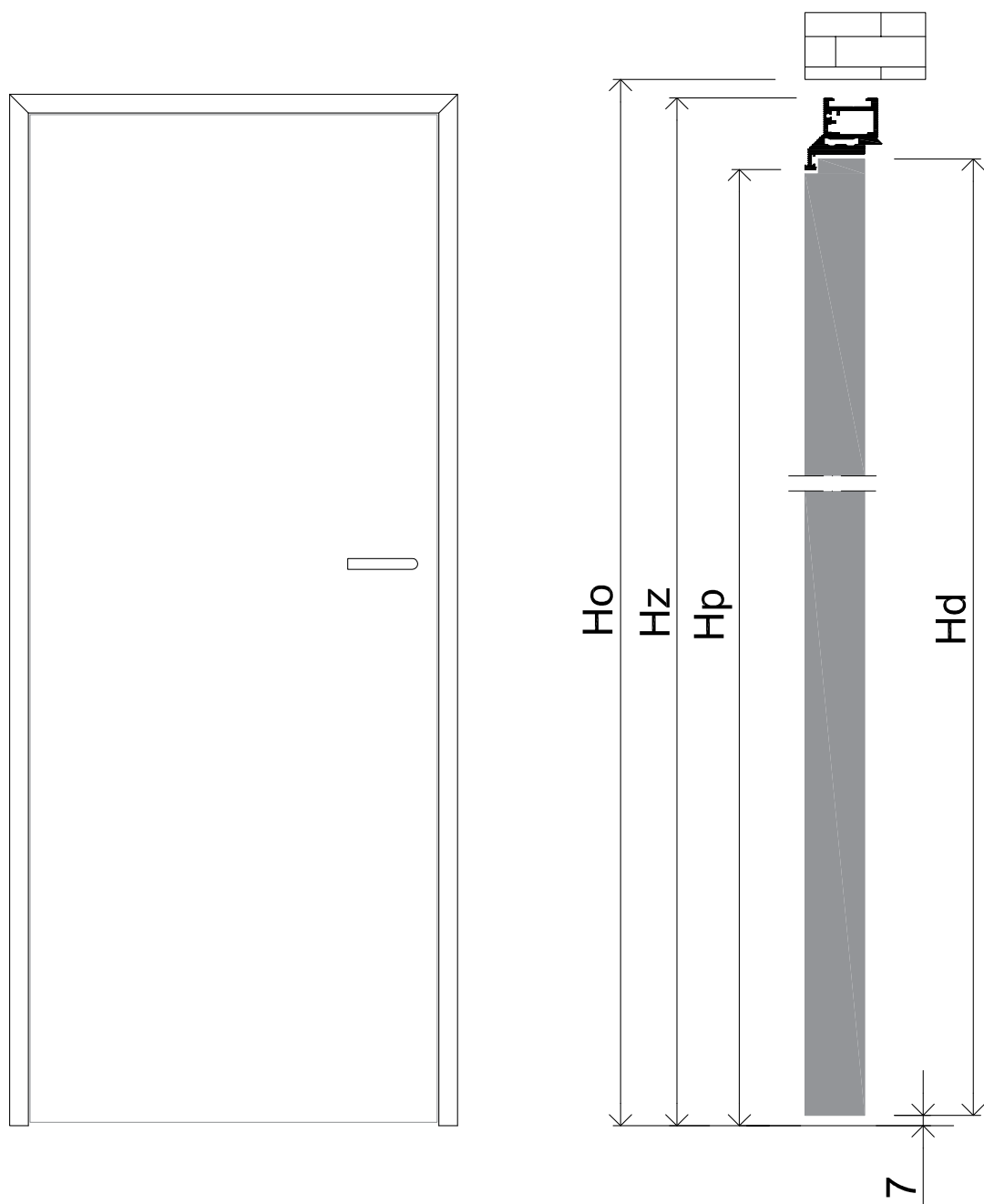
SARA PRO PLUS '40

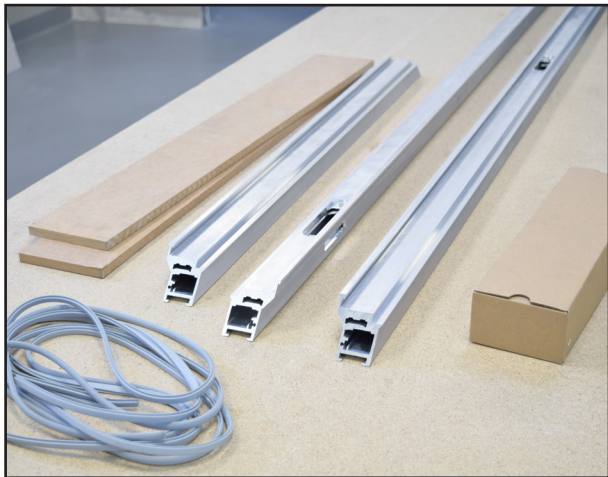
inwards



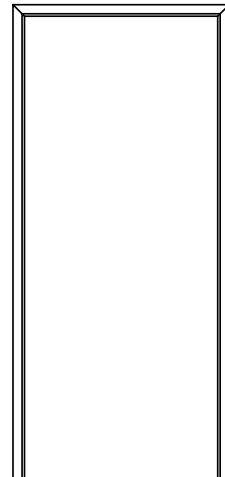


1.		x1		6.		min. x2	11.		4,2x18 min. x10	16.		x1
2.		x1		7.		x2	12.		3,5x22 x2	17*		x1
3.		x1		8.		min. x6	13.		5x35 min. x4	18*		x1
4.		x1		9.		x2	14.		M5x16 min. x4	19.		x1
5.		x1		10.		3,9x25 x8	15.		min. x2	option: 17*+18* for raw profile 18* for primed profile		

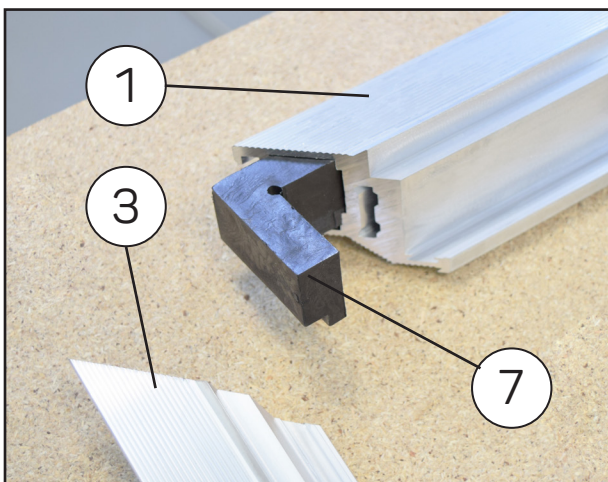
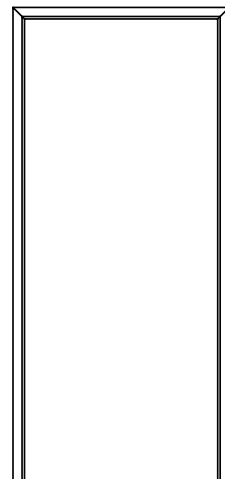




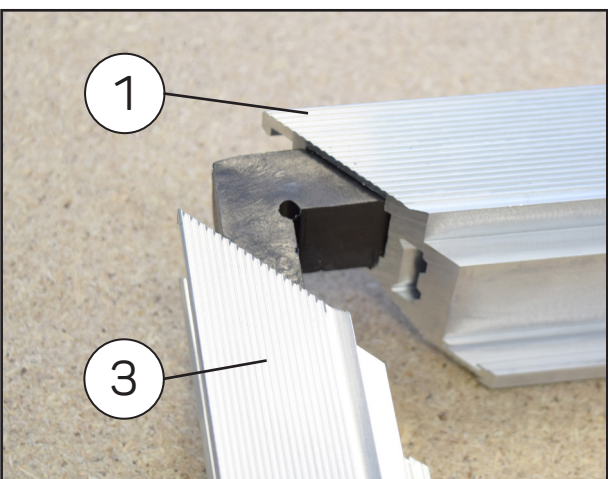
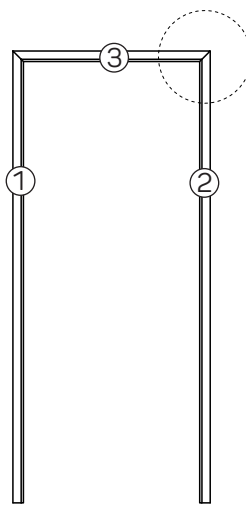
A. Unpack the elements of Sara Pro Plus 40 door frame



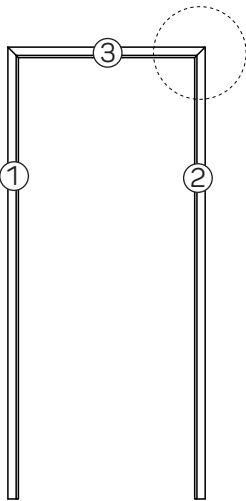
B. Arrange the frame profiles

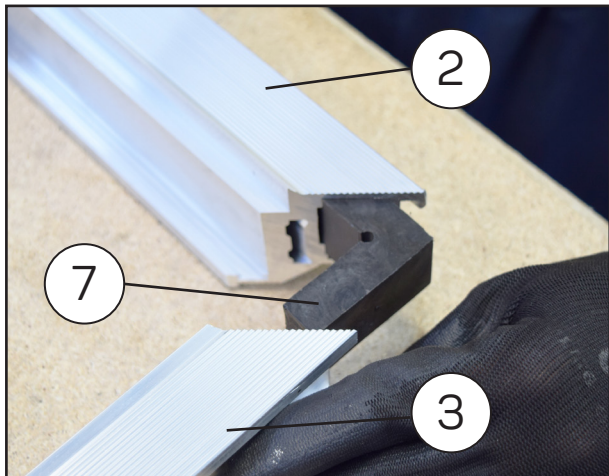


C. Put the plastic corners [7] into the vertical profile of the frame [1]

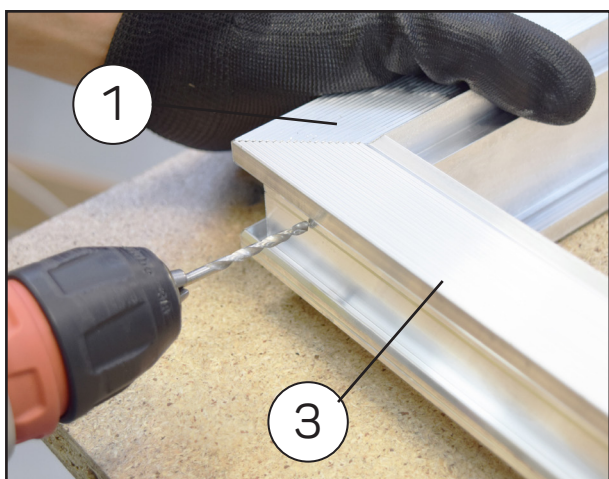
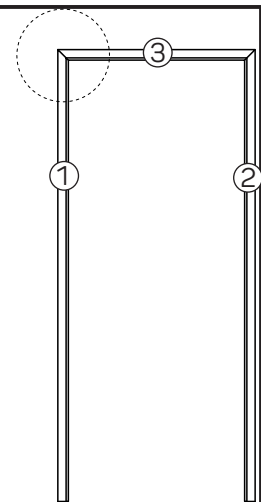


D. Assemble the vertical profile [1] with horizontal profile [3] with previously inserted corners, paying attention to joining the profiles evenly

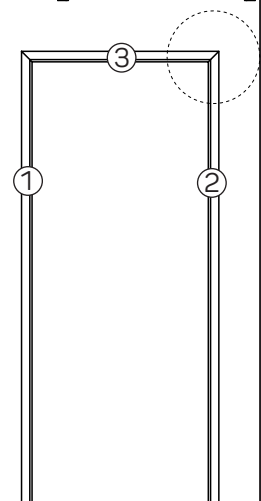




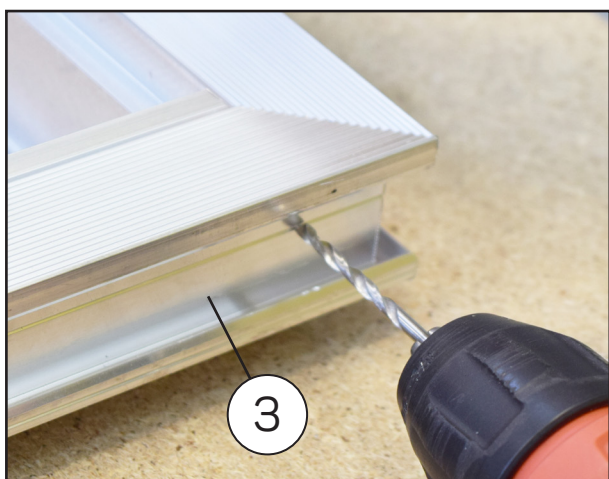
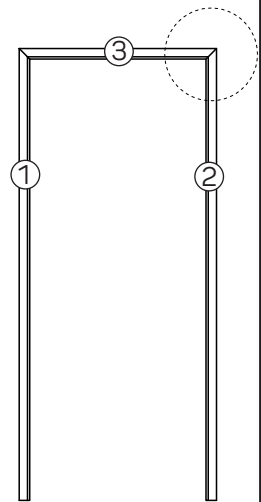
E. As in the vertical profile [1], insert the plastic corners [7] into the vertical profile [2]



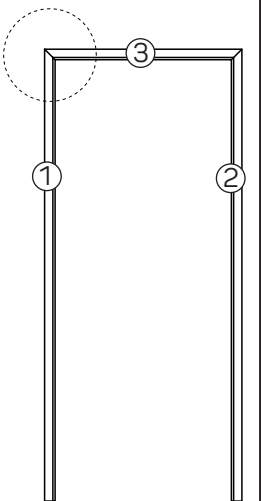
F. After joining the profiles [1] and [3] evenly, drill through them and the plastic corner [7] with the diameter 3 drill piece

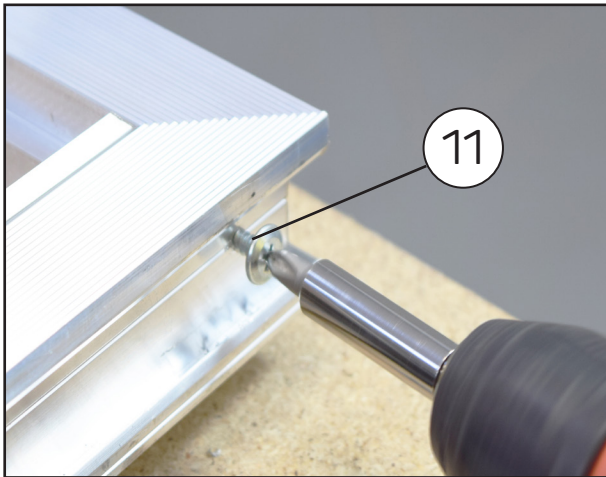


G. Screw the screws [11] into the drilled holes to lock the corners in their position

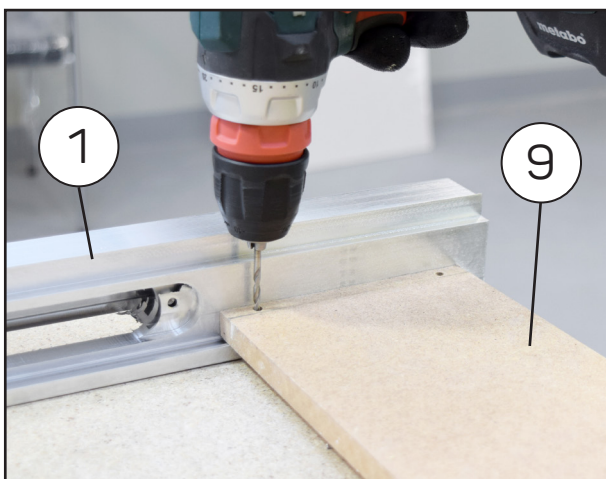
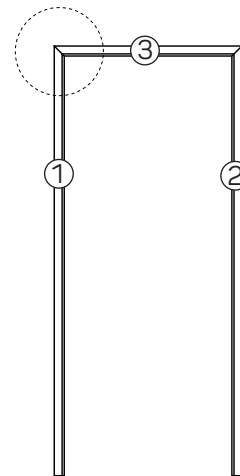


H. Assemble the vertical profile [2] with the horizontal profile [3], joining the profiles evenly, then as in the case of the second corner, drill holes with the bit diameter 3

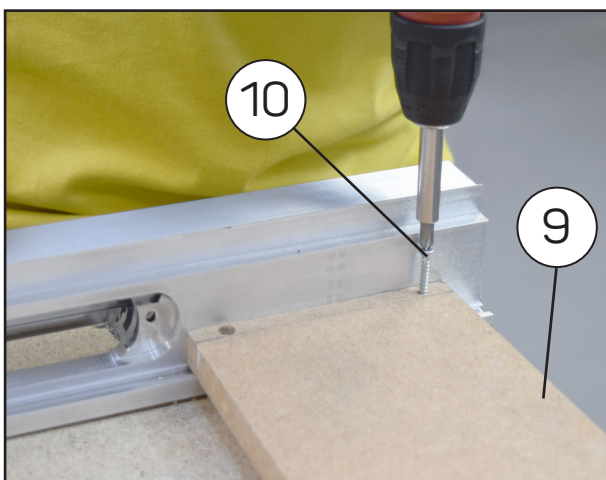
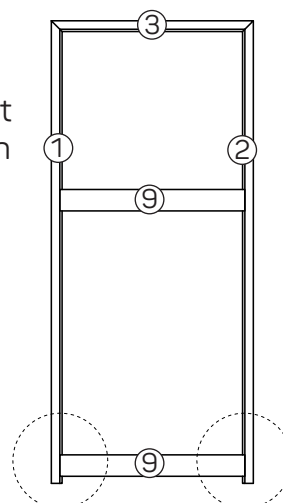




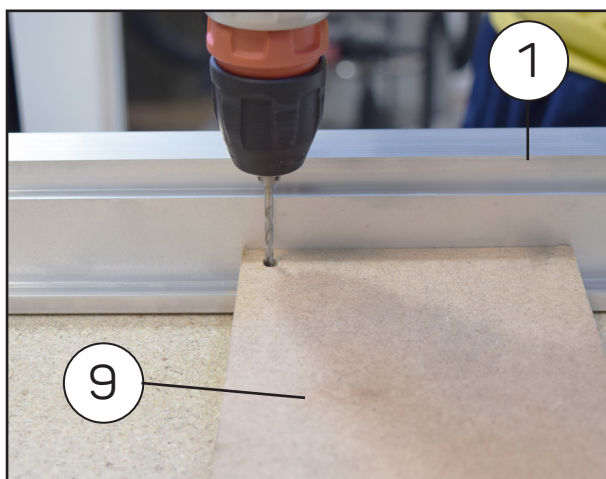
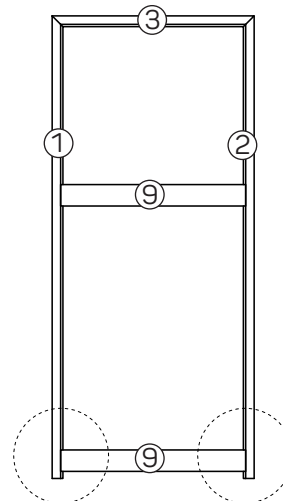
I. Tighten the corner with screws [11] to lock the profile joints



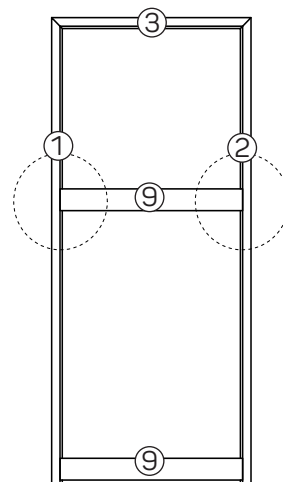
J. Add the expansion strips [9] and then drill holes in strip [9] and the profile, in the place that will be covered by the seal, with the diameter 3 drill piece

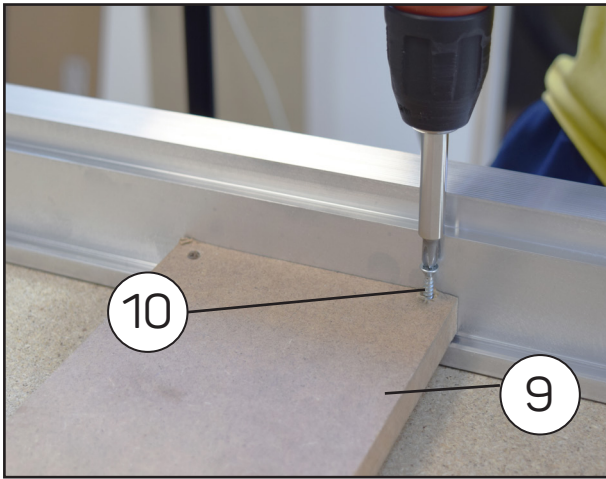


K. Screw in the screws [10] in the drilled holes in the expansion strip [9] and the frame profile

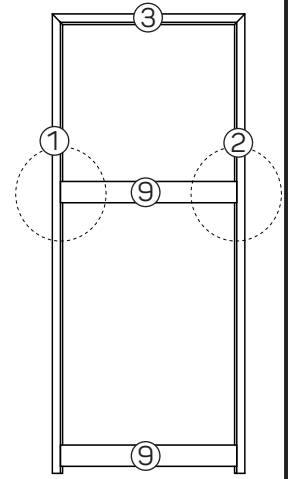


L. In the second strip [9] drill openings of diameter 3

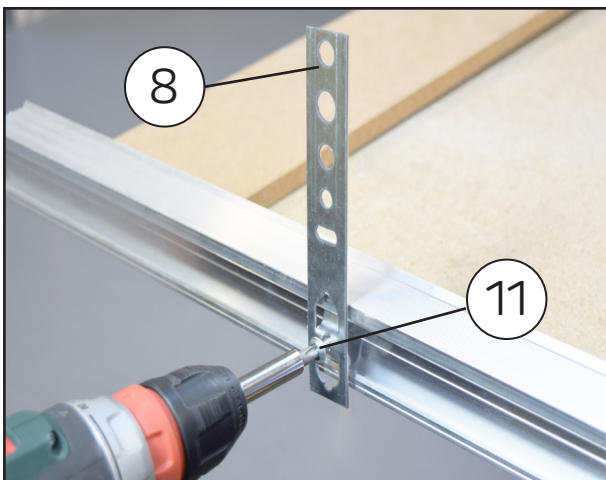
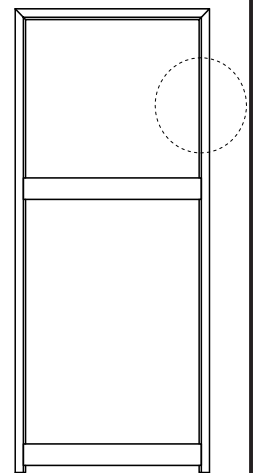




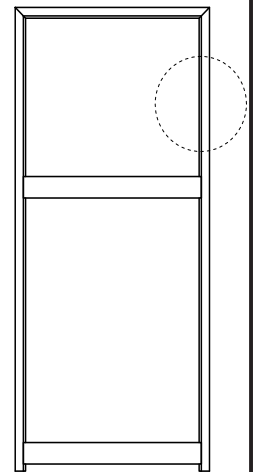
M. Then screw the screws [10] into the drilled holes



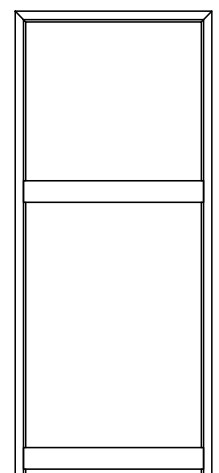
N. Insert the anchors [8] at a slant into the vertical profile seats [1] and [2], and turn them until they lock



O. Then tighten the anchors [8] to the profile with screws [11]

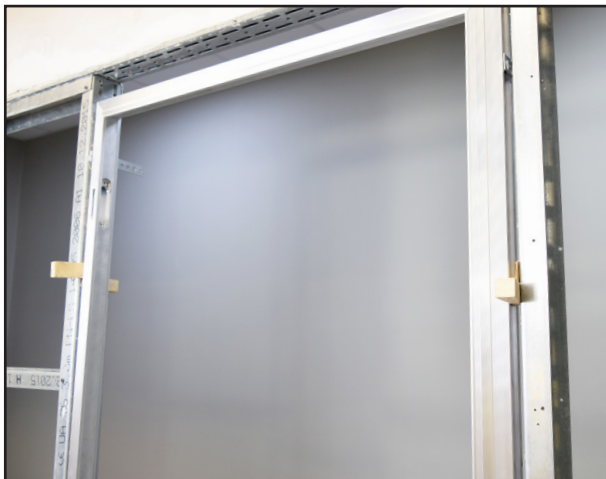
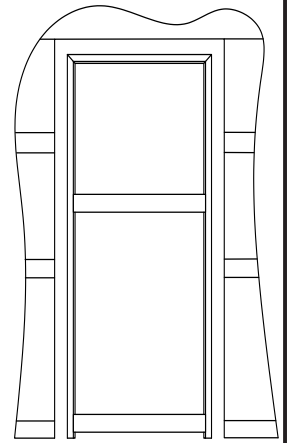


P. A correctly assembled door frame

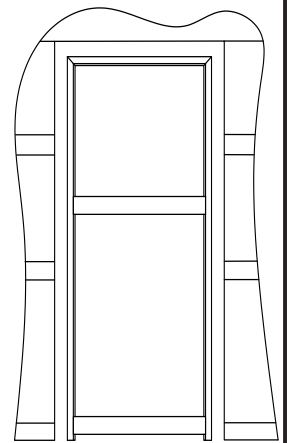




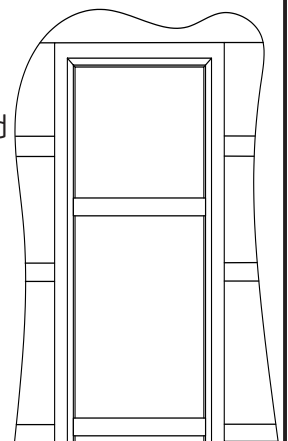
R. Put the assembled door frame in the opening of the building



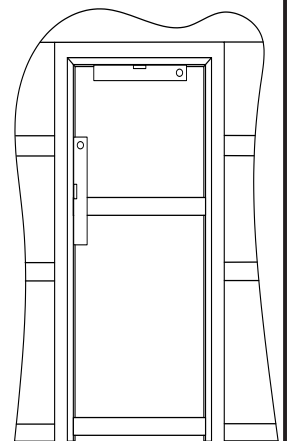
S. Then clamp the door frame in the hole



T. Pay attention to the depth of the frame. The outer edge of the frame should be levelled with the surface of the finished wall

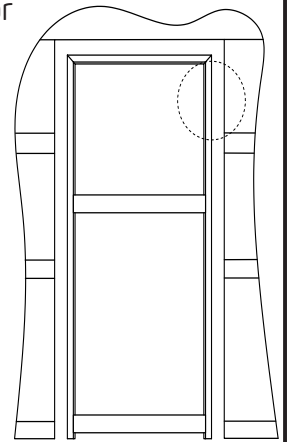


U. After the wedging, check the vertical and horizontal frame setting and adjust it if necessary

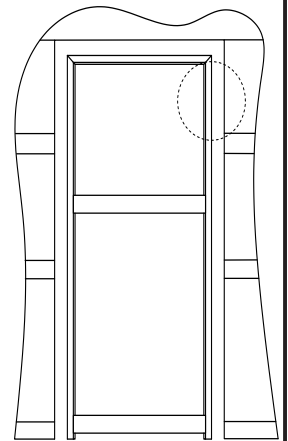




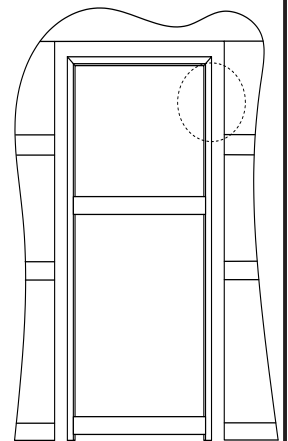
W. Fill the gaps between the door frame and the wall with a low-pressure mounting foam



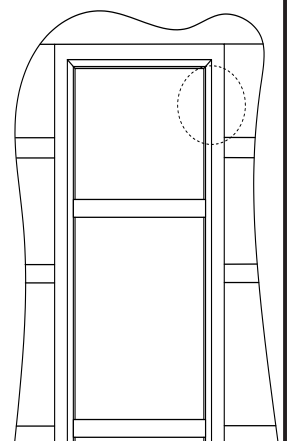
X. Once the mounting foam has dried, bend the anchors [8]



Y. Tighten the anchors to the construction opening, taking care not to change the profile settings

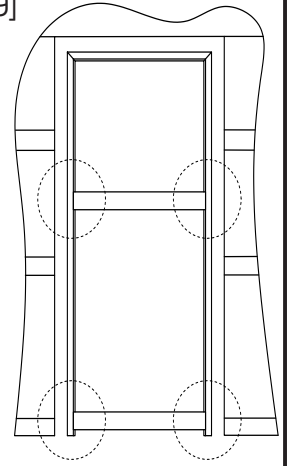


Z. Cut the excess of dry foam with a knife and pull out the wedges

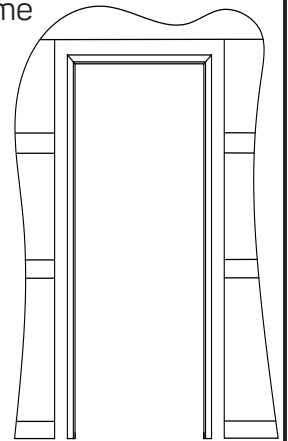




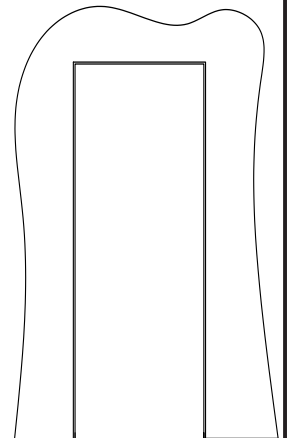
2A. Dismantle expansion strips [9]



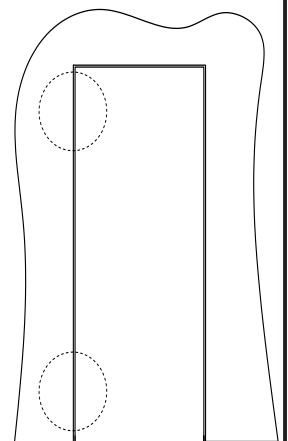
2B. A correctly installed door frame in the building opening



2C. Door frame with plasterboard built over it

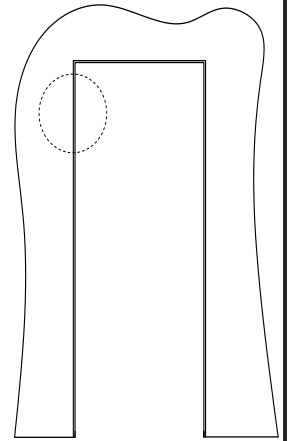


2D. In the hinge milling areas, cut the plasterboard so the hinge will fit

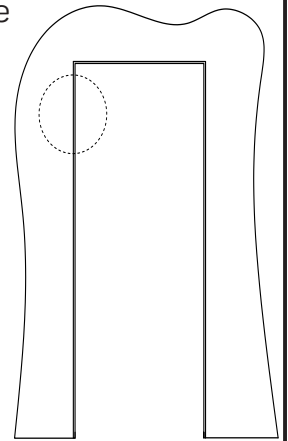




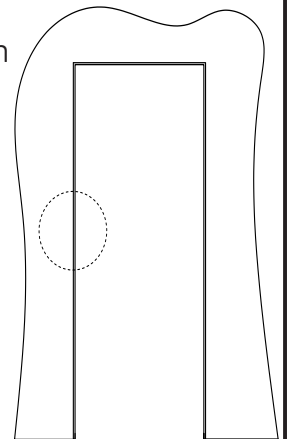
2E. Insert the plastic caps (covers) [15] into the hinge seats. Fill in jointing of plasterboard and door frame with plaster and reinforce it with a glass fibre mesh or a fibreglass tape to join the panels



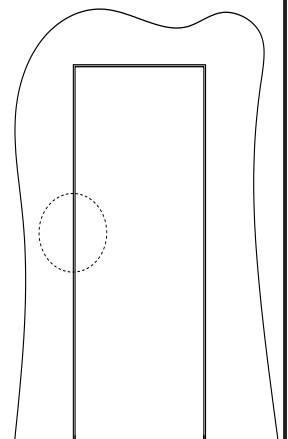
2F. Use a tissue [18*] to degrease the surface of the profiles

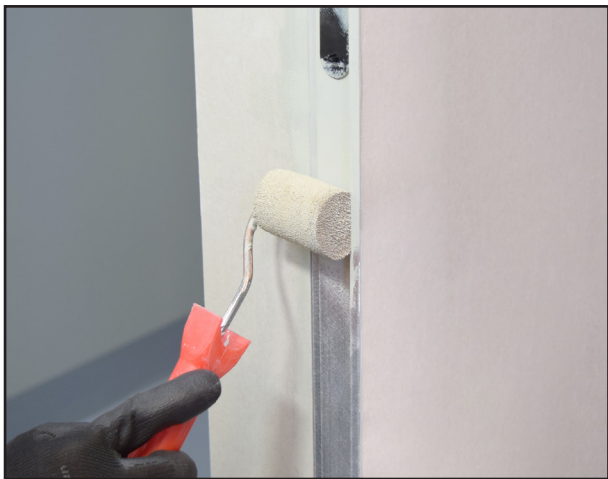


2G. Secure the seal seats with a paint tape not to stain them during painting, which could make it difficult to insert the seal at a later stage

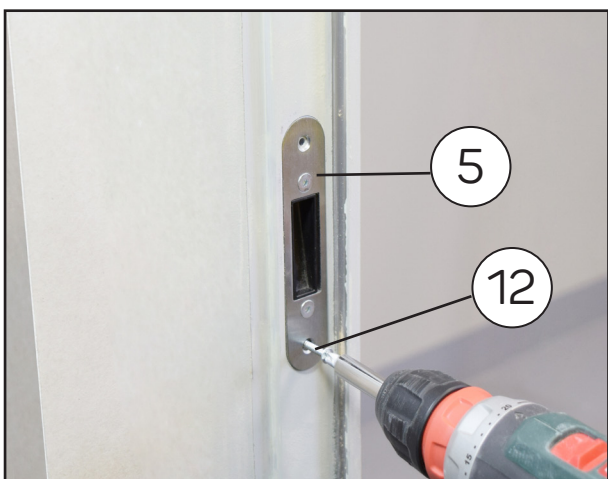
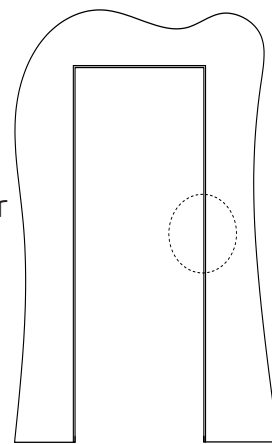


2H. Cut off the excess tape , leaving the corner unsealed

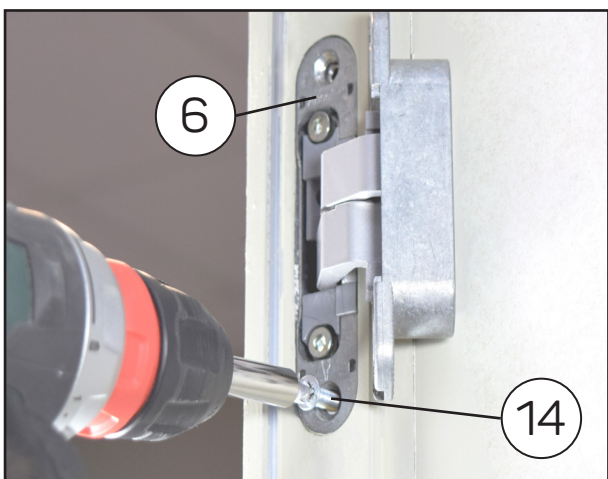
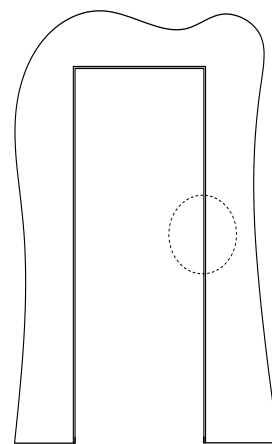




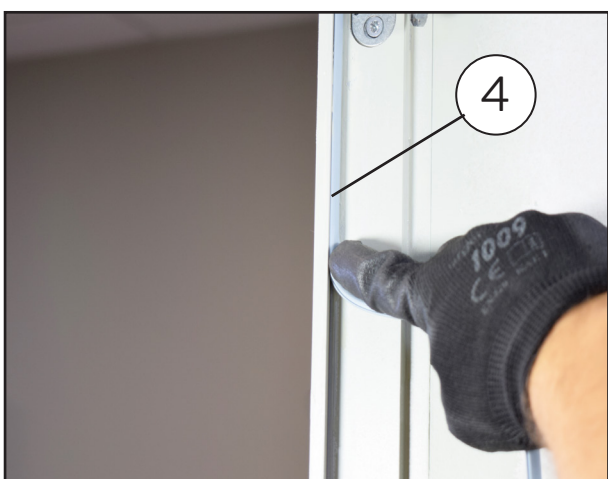
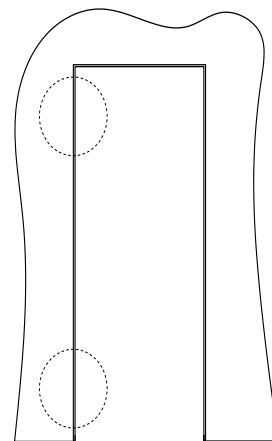
- 2I. Paint the surface of the profiles using aluminium primer [17*], and after it has dried completely, paint the door frame with a wall paint. When painting, use covers for hinge stiles [16] and the hinges [15]



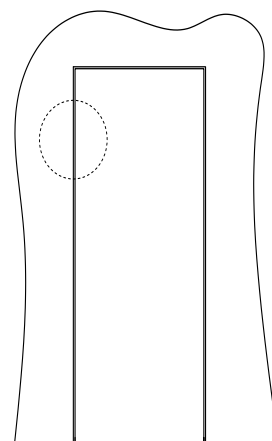
- 2J. With screws [12], screw the locking plate [5] into the door frame profile

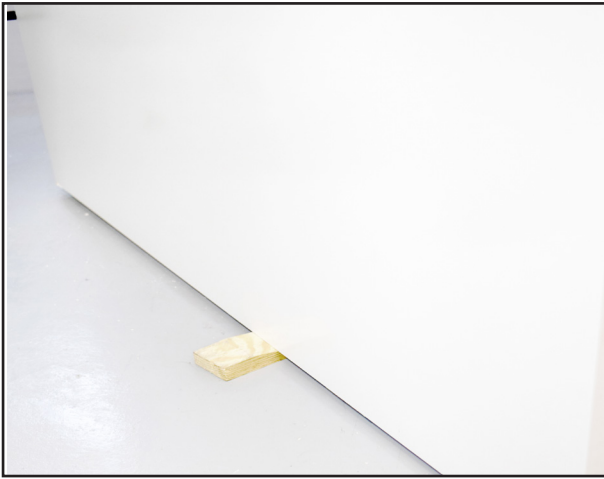


- 2K. Using the screws [14], tighten the hinges [6] to the frame profile

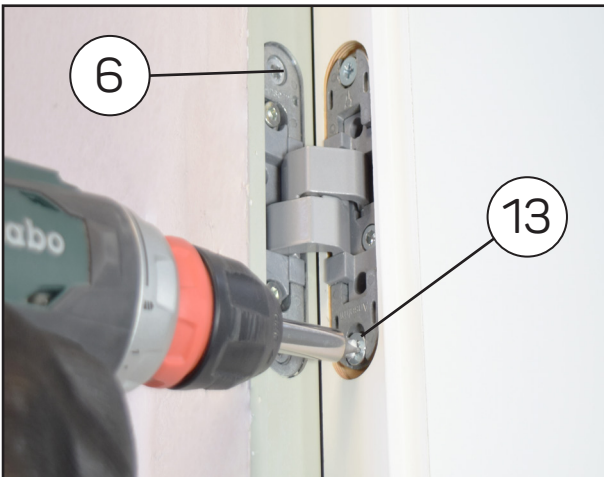
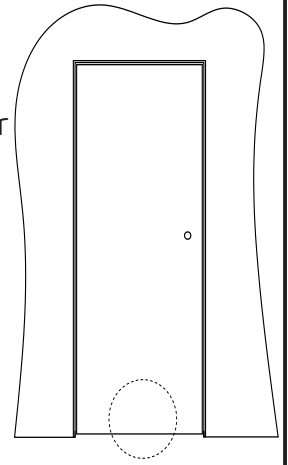


- 2L. Insert the seal [4] into the socket, properly cutting it in the corners of the frame as well as at the length of the profiles. As the seal is not symmetrical, insert it into the seat with the correct side

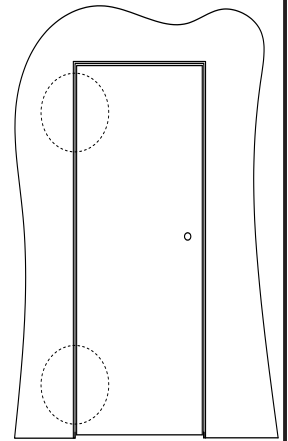




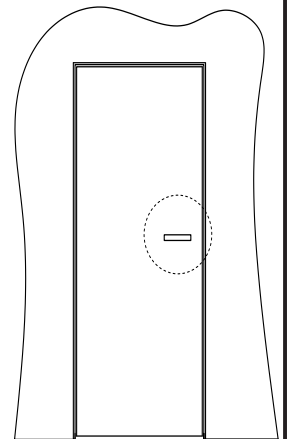
2M. Put the door into the door frame by lifting it with a wedge inserted under the door, which will make it easier to attach it to the hinges



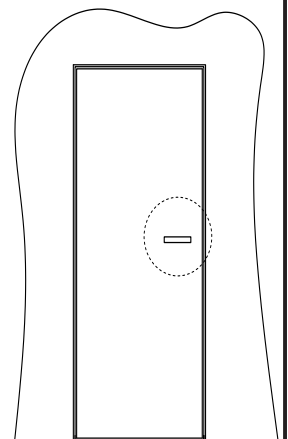
2N. Screw the hinges [6] to the door using previously drilled holes for screws [13] to prevent the door leaf from splitting

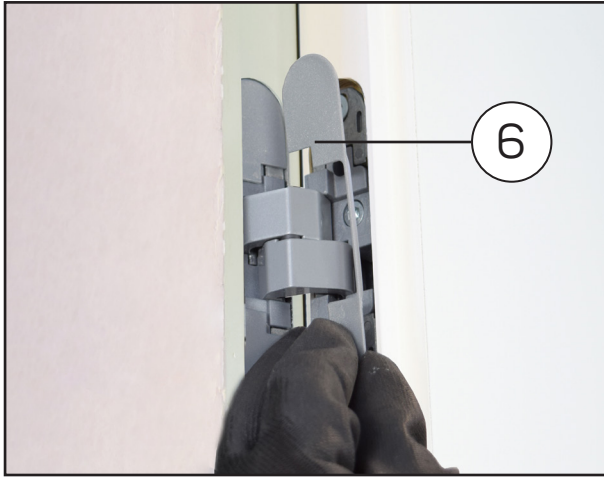


2O. Put the spindle and the handle base of the door handle

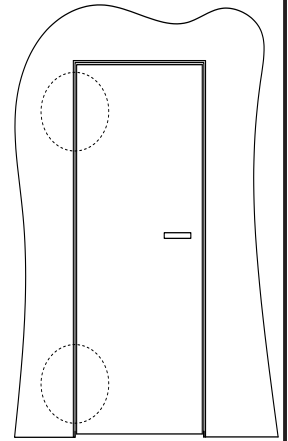


2P. Mount the handle

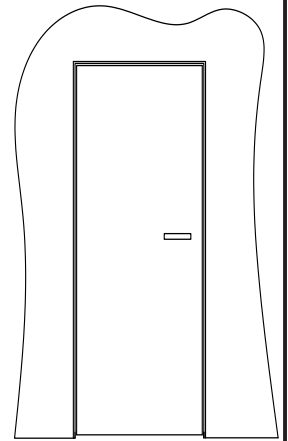




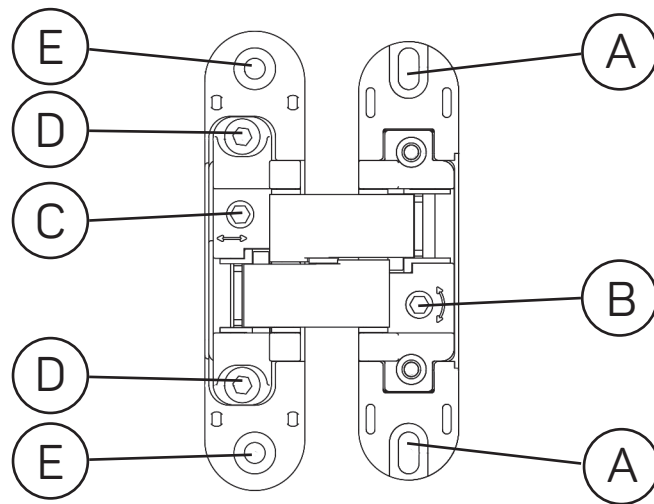
2R. Adjust the hinges [6] with the Allen key [19] according to the instructions provided, aligning them to achieve even gaps between the door and the door frame, allowing the door surface to adhere the front face of the profile. Then put the hinge caps on the hinges [6]



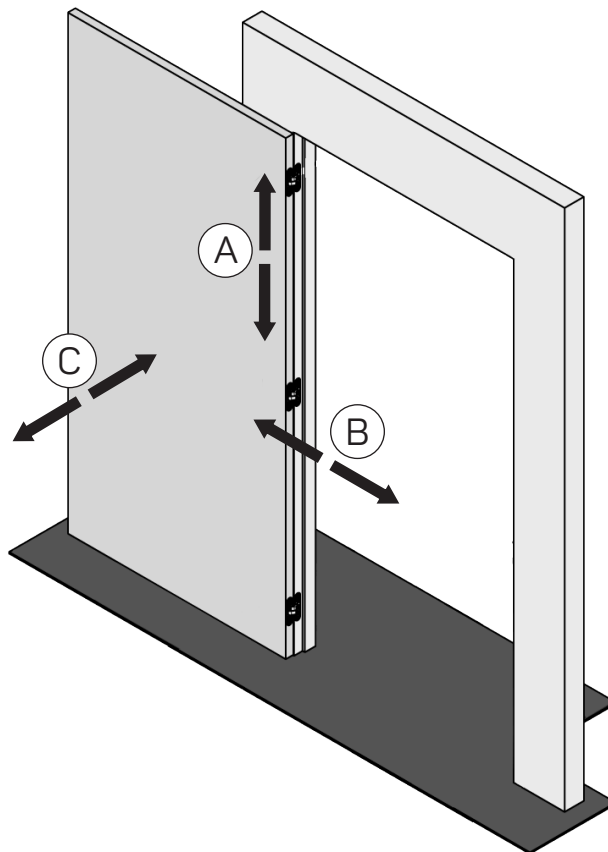
2S. The final effect of the properly assembled Sara Pro Plus inward door frame

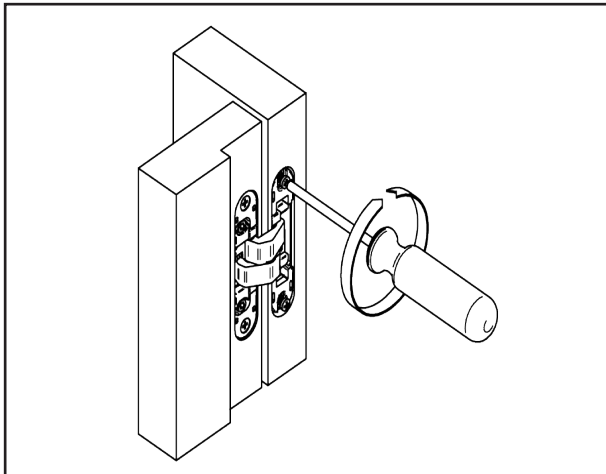


A manual for adjusting the standard hinges

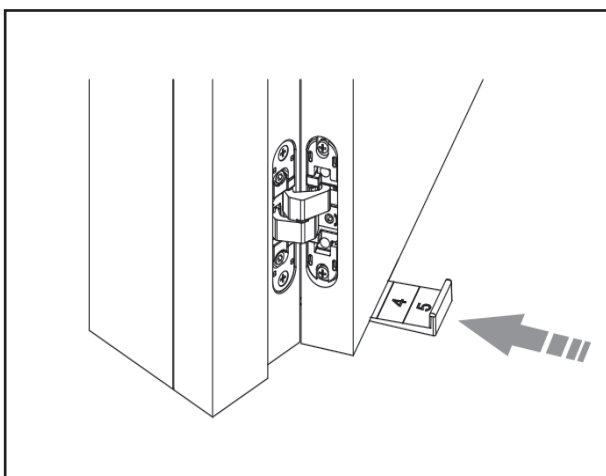


- A - Oval opening that serves for fastening the hinge to the leaf and for adjusting it up and down (making the top gap even)
- B - Bolt for hinge adjustment right and left (making leaf's side gaps even)
- C - Bolt for hinge adjustment front and back (making the leaf flush with wall surface)
- D - Bolt serving for unlocking/locking the position set by C bolt
- E - Round opening that serves for fastening the hinge to the door frame



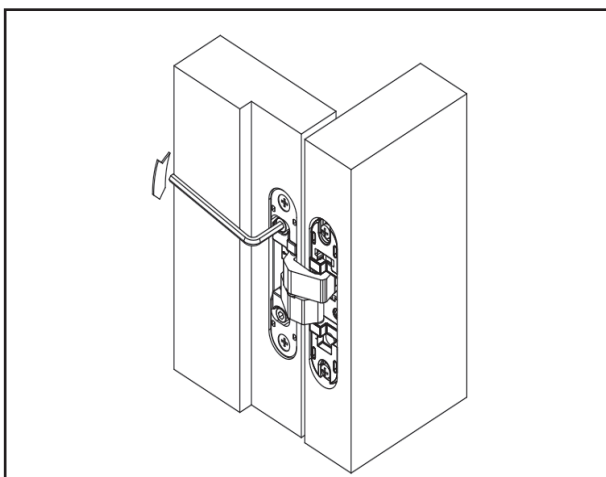


1. In order to adjust the leaf height (decrease or increase the top gap), loosen screws in openings [A] that hold all hinges in the leaf

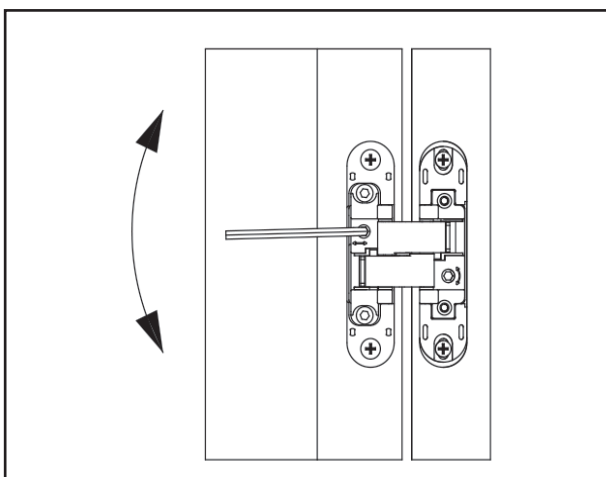


2. Using a wedge (an adjustment washer for doors), lift the door to the desired height in such a way that the gap between the door frame and the leaf is about 3 mm.
Then tighten all hinges to the leaf.

The range of hinge adjustment is **5 mm** from its lowest position

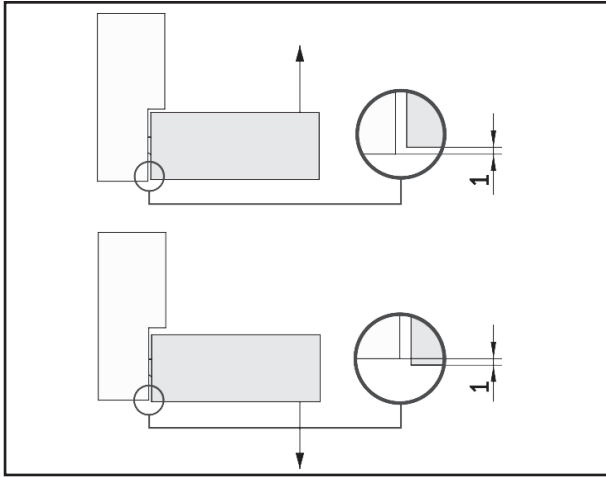


3. In order to adjust the leaf so that its surface is flush with the wall surface, first loosen [D] bolts

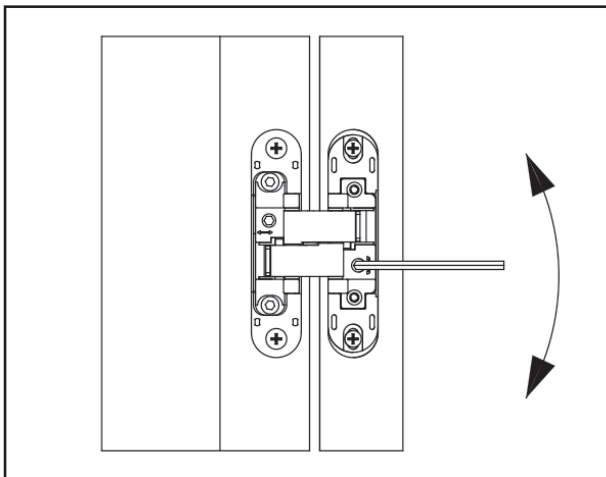


4. Then move the leaf closer to or farther from the door frame, by rotating [C] bolt.

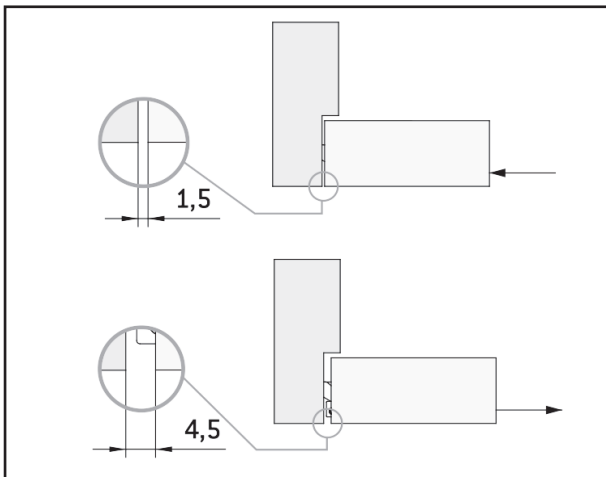
After adjusting the hinges in this plane appropriately, again tighten [D] bolts to lock the position



The range of hinge adjustment in this plane is **+/-1 mm**



5. In order to adjust the gaps between the leaf and the door frame on the sides, tighten or loosen [B] bolt in the hinge, which makes the leaf move right or left



The range of hinge adjustment in this plane is **+/-1.5 mm**

Adjust all hinges evenly so that none of them is overloaded, which will prevent their damage.

