



ASTA Door Corporation

Installation Instructions Model 300 Commercial Slat Door

USE ASTA DOOR PARTS ONLY — ALL OTHERS SHALL VOID WARRANTY.
FOR MORE INFORMATION CONTACT: ASTA DOOR CORP. (770) 974-2600

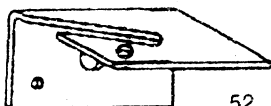


DIAGRAM 1

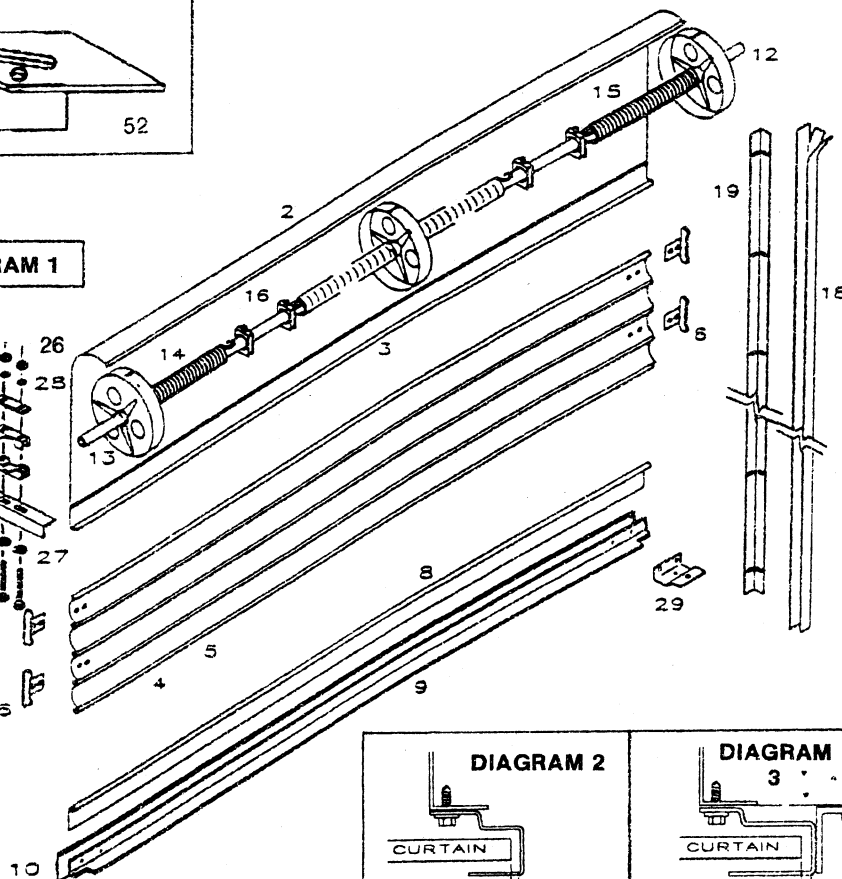
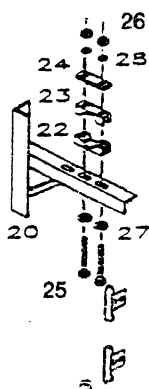


DIAGRAM 2

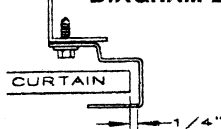


DIAGRAM 3

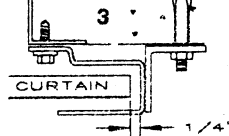
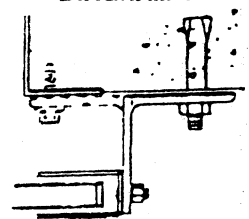
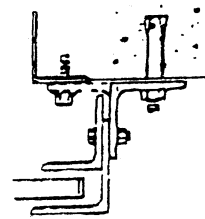


DIAGRAM 4

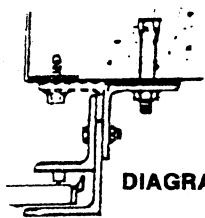


5/16"



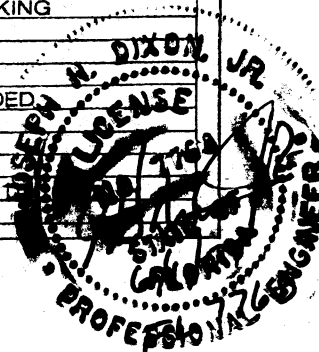
1/2"

DIAGRAM 5



1/2"

1	VARIABLE	CURTAIN SUB-ASSY.:	27	750103	FLAT WASHER, 3/8"
2	241006	TOP SHEET	28	750203	LOCK WASHER, 3/8"
3	VARIABLE	STARTER/ENDING SLAT	29	280301	DOOR STOP
4	VARIABLE	SLAT, CURVED	30	280104	SLIDE BOLT
5	VARIABLE	SLAT, FLAT	31	730301	BOLT, 1/4-20 x 1-1/4"
6	450143	ENDLOCK	32	740201	NUT, 1/4-20 SELF LOCKING
7	VARIABLE	BOTTOM BAR SUB-ASSY.:	33	740102	NUT, 5/16-18
8	VARIABLE	STARTER/ENDING SLAT	34	750101	FLAT WASHER, 1/4"
9	VARIABLE	BOTTOM ANGLE, 2" x 2" x 3/16"	35	730115	BOLT, FLAT HEAD SLOTTED 5/16"-18 x 1"
10	270201	ASTRAGAL	36	730915	BOLT, RIB "D" 1/4-20 x 5/8"
11	VARIABLE	AXLE SUB-ASSY.:	37	740101	NUT, 1/4-20 FLANGE LOCK
12	VARIABLE	AXLE PIPE	38	430000	REDUCTION GEAR ASSY.:
13	220306	FLANGE-BEARING DRUM ASSY.	39	430102	RING GEAR
14	VARIABLE	SPRING - L.H.	40	430101	PLANETARY SPROCKET
15	VARIABLE	SPRING - R.H.	41	430103	IDLER GEAR
16	230003	SPRING CLAMP ASSY.	42	430200	IDLER GEAR CARRIER
17	VARIABLE	GUIDE CHANNEL, LEFT	43	750101	FLAT WASHER 1/4"
18	VARIABLE	GUIDE CHANNEL, RIGHT	44	430104	COLLAR
19	VARIABLE	WALL ANGLE	45	730202	BOLT, 5/16-18 x 3"
20	450150	SUPPORT BRACKET, LEFT	46	740202	NUT, 5/16-18 SELF LOCKING
21	450151	SUPPORT BRACKET, RIGHT	47	750104	SPACER, SQUARE
22	310101	AXLE SADDLE CASTING	48	770301	U-BOLT, 3/8"-16
23	310103	AXLE CLAMP	49	740103	NUT, 3/8-16
24	310102	KEEPER PLATE	50	420101	KEEPER PLATE, EXTENDED
25	730103	BOLT, 3/8-24 x 3-1/2"	51	420400	CHAIN
26	740104	NUT, 3/8-24	52	420405	CHAIN KEEPER
			53	430106	STAY BRACE, UPPER
			54	730713	SELF-DRILLING SCREW
			55	430300	CHAIN GUIDE



IMPORTANT REMARKS:

DO NOT CUT THE BANDS WHICH HOLD DOOR IN A ROLL. YOU WILL BE TOLD AT A LATER TIME EXACTLY WHEN TO CUT THEM. NO GUARANTEE WILL BE GIVEN OR RESPONSIBILITY ACCEPTED BY THE MANUFACTURER IF THE DOOR IS NOT INSTALLED AS INSTRUCTED. FOR PERFECT OPERATION, FOLLOW THE INSTRUCTIONS AS GIVEN. PLEASE REVIEW ALL THE STEPS BEFORE BEGINNING.

NOTE: LEFT HAND SHOWN THROUGHOUT, RIGHT HAND OPPOSITE

STEP NO 1 - CHECK THE OPENING

- A. CHECK THE HEIGHT AND WIDTH OF THE OPENING.
- B. CHECK IF THE DOOR JAMBS ARE PLUMB.
- C. CHECK IF THE FLOOR AND HEADER ARE LEVEL.
- D. CHECK THE DIMENSION PANEL FOR SIDE ROOM AND HEAD ROOM REQUIREMENTS.
(SEE DIAGRAM 6)

STEP NO. 2 - INSTALL SUPPORT BRACKETS

- A. MARK THE HORIZONTAL (A1) & (A2) OF THE SUPPORT BRACKETS. (SEE DIAGRAM 6)
- B. MARK THE VERTICAL LOCATION OF THE SUPPORT BRACKETS BY USING THE "Y" DIMENSION. CHECK THE HEIGHT OF EACH BRACKET TO VERIFY THAT THE DOOR WILL BE PARALLEL TO THE FLOOR. THE DOOR MUST BE LEVEL.

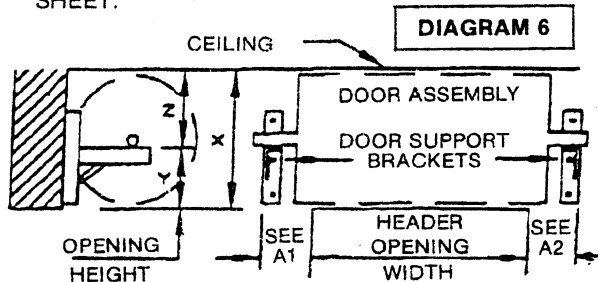
NOTE:

VERIFY THE MINIMUM HEADROOM REQUIREMENT. DIMENSION "Z". IF INSUFFICIENT, LOWER THE BRACKETS & GUIDES UNTIL "Z" IS OBTAINED.

- C. DRILL HOLES AND FASTEN THE BRACKETS WITH THE FASTENERS PROVIDED. OR AS REQUIRED TO OBTAIN A SOLID MOUNTING. USE THROUGH BOLTS ON SOFT BRICK OR BLOCK.

NOTE:

FOR DOORS THAT COME WITH ROLLER CHAIN DRIVE ASSEMBLIES REFER TO SUPPLEMENT SHEET.



CLEARANCE REQUIREMENTS OF DOOR

OPENING HEIGHT	X	Y	Z
UP TO 8'	20"	9"	11"
UP TO 14'	21"	10"	11"
OVER 14'	23"	11"	12"

OPERATION	A1	A2
ELECTRIC OPERATION	9"	6"
CAST REDUCTION GEAR	10"	6"
ALL REDUCTIONS ON DOORS 14' WIDE OR WIDER.	10"	7"

NOTE: PROVIDE ADEQUATE BACKING FOR BRACKET LOCATION.

STEP NO. 3 - INSTALL DOOR ASSEMBLY

I. SINGLE REDUCTION:

SEE STEP NO. 3 OF SINGLE REDUCTION IN SUPPLEMENT SHEET.

II. DOUBLE REDUCTION:

SEE STEP NO. 3 OF DOUBLE REDUCTION IN SUPPLEMENT SHEET.

III. CAST REDUCTION:

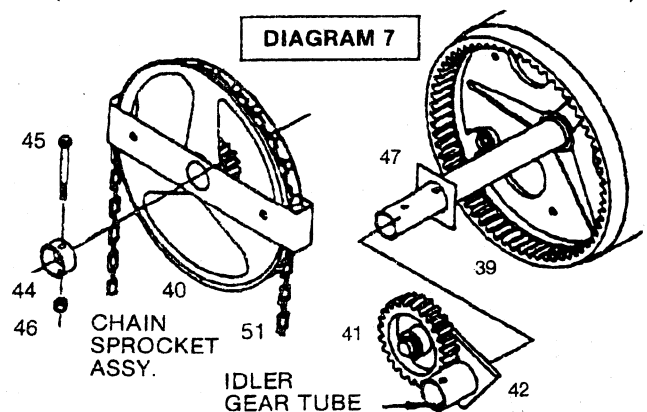
FOLLOW THE STEPS BELOW.

A. ASSEMBLE DRIVE REDUCTION AS FOLLOWS:

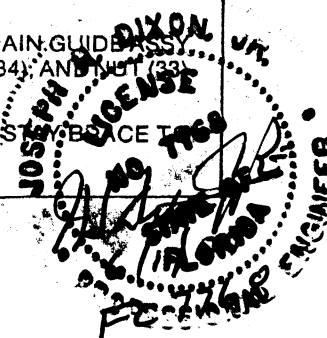
1. SLIDE ON SPACER WASHER (47).
2. SLIDE ON IDLER GEAR ASSY. (42).
3. SLIDE ON CHAIN SPROCKET ASSY. OVER IDLER GEAR TUBE.
4. SLIDE ON THE COLLAR (44) OVER IDLER GEAR TUBE AND ALIGN HOLES.
5. SECURE WITH 5/16" x 3" BOLT (45) AND 5/16" SELF LOCKING NUT (46).
(SEE DIAGRAM 7)

NOTE:

KEEP IDLER GEAR AT A 10 OR 2 O'CLOCK POSITION (WITH THE BOTTOM ANGLE BEING AT 6 O'CLOCK).



- B. LIFT THE DOOR ASSY UP ONTO THE DOOR SUPPORT BRACKETS. AS SHOWN IN DIAGRAM 8). PLACE THE SADDLE CASTING (22) UNDER THE AXLE. TAKE CARE TO CENTER THE DOOR IN THE OPENING. IF SIDEWAYS MOVEMENT IS NECESSARY, BE CERTAIN THE DOOR CURTAIN AND AXLE AND THE AXLE MOVE TOGETHER.
- C. POSITION THE DOOR AS INSTRUCTED IN THE CORRESPONDING DIAGRAM 8.
- D. INSTALL STAY BRACES (53) TO CHAIN GUIDE ASSY. (43) BY USING BOLT (35) WASHER (34) AND NUT (33).
(SEE DIAGRAM 8)
- E. USE TEK SCREW (54) TO SECURE STAY BRACE TO SUPPORT BRACKET (20).



STEP NO. 4 - AXLE HARDWARE

I. SINGLE REDUCTION:

SEE STEP NO. 4 OF SINGLE REDUCTION IN SUPPLEMENT SHEET.

II. DOUBLE REDUCTION:

SEE STEP NO. 4 OF DOUBLE REDUCTION IN SUPPLEMENT SHEET.

III. CAST REDUCTION:

FOLLOW THE STEPS BELOW:

A. DRIVE SIDE

DOORS UNDER 20' WIDE

AFTER PLACING AXLE SADDLE (22) UNDER AXLE, PLACE THE 2 AXLE CLAMPS AND EXTENDED KEEPER PLATE (50) ON TOP OF AXLE AS SHOWN. INSTALL 3/8" BOLTS (25), U-BOLT (48). LOCK WASHER (28) AND NUT (26) AS SHOWN. DO NOT TIGHTEN BOLTS. INSTALL STAY BRACE (53) TO CHAIN GUIDE (55) BY USING BOLT (35), WASHER (34), AND NUT (33). USE TEK SCREW (54) & WASHER (43) TO SECURE STAY BRACE (53) TO BRACKET (20).

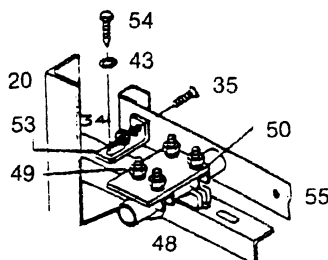


DIAGRAM 8

DOORS 20' WIDE OR WIDER

AFTER PLACING AXLE SADDLES (22) UNDER AXLE, PLACE THE 2 AXLE CLAMPS (23) & KEEPER PLATES (24) ON TOP OF AXLE AS SHOWN IN DIAGRAM 8A. INSTALL 3/8" BOLTS (25), LOCK WASHER (28) AND NUT (26). DO NOT TIGHTEN BOLTS.

INSTALL STAY BRACE (53) TO CHAIN GUIDE (55) BY USING BOLT (35), WASHER (34), AND NUT (33). USE TEK SCREW (54) & WASHER (43) TO SECURE STAY BRACE (53) TO TOP BRACKET (20).

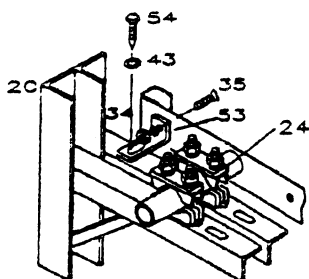


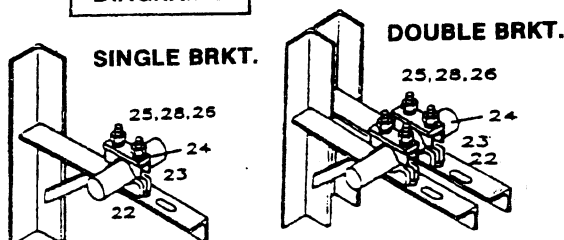
DIAGRAM 8A

B. NON-DRIVE SIDE

PERFORM THE FOLLOWING STEPS TWICE FOR DOUBLE BRACKETS. AFTER PLACING AXLE SADDLE (22) UNDER AXLE, PLACE THE AXLE CLAMP (23) AND KEEPER PLATE (24) ON TOP. INSTALL 3/8" BOLTS (25). LOCK WASHERS (28). AND NUT (28). DO NOT TIGHTEN.

REPEAT STEPS FOR DOUBLE BRACKET CONFIGURATION. (SEE DIAGRAM 9).

DIAGRAM 9



STEP NO. 5 - PRE-TENSION SPRINGS

- A. LOCATE AND SECURE CHAIN KEEPER (52) APPROX. 4'-0" ABOVE FLOOR.

CAUTION:

FAILURE TO SECURE CHAIN KEEPER OR, FAILURE TO SECURE BOTH LEADS OF THE HAND CHAIN TO THE CHAIN KEEPER MAY RESULT IN PROPERTY DAMAGE AND/OR INJURY.

- B. SCORE A HORIZONTAL LINE ON THE AXLE. THEN GRIP THE HAND CHAIN SECURELY AND PULL CHAIN SO THAT AXLE ONLY ROTATES TOWARD THE INSIDE OF THE OPENING. (SEE DIAGRAM 10). DO NOT ALLOW THE DOOR ASSY. TO SPIN. PLACE BETWEEN 1 TO 2 TURNS ON THE AXLE. SECURE BOTH LEADS OF THE HAND CHAIN ON THE CHAIN KEEPER. CHECK FOR PROPER ENGAGEMENT OF THE HAND CHAIN ON CHAIN KEEPER.

DIAGRAM 10

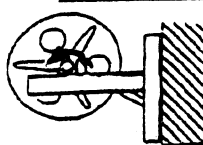


DIAGRAM 10A



- C. IF THE DOOR IS HAND OPERATED, TENSION THE SPRINGS BY USING PIPE WRENCHES TO ROTATE THE AXLE BETWEEN 1 TO 2 TURNS.

NOTE: YOU WILL REQUIRE TWO PEOPLE TO ADJUST DOOR TENSION SAFELY. (SEE FIGURE ABOVE - DIAGRAM 10A).

WARNING:

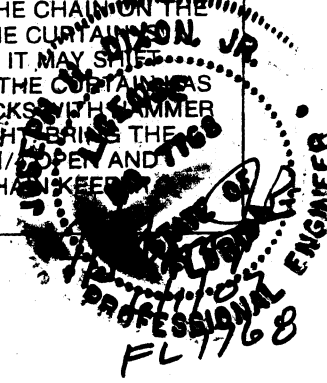
DO NOT RELEASE PIPE WRENCHES UNTIL AXLE CLAMPS ARE TIGHTENED SECURELY.

- D. TIGHTEN SECURELY BOTH AXLE CLAMPS.

CAUTION:

FAILURE TO SECURELY TIGHTEN BOTH AXLE CLAMPS WILL RESULT IN LOSS OF SPRING TENSION WHICH MAY CAUSE PROPERTY DAMAGE AND/OR INJURY.

- E. WITH BOTTOM ANGLE IN THE DOWN POSITION SECURELY TAKE HOLD OF THE BOTTOM ANGLE. CUT THE BANDS AND SLOWLY BRING THE CURTAIN TO GROUND LEVEL. SECURE THE CHAIN ON THE CHAIN KEEPER. MAKE SURE THE CURTAIN IS STRAIGHT UP AND DOWN, FOR IT MAY SHIFT DURING TRANSPORTATION. IF THE CURTAIN HAS SHIFTED, LIGHTLY TAP ENDLOCKS WITH HAMMER UNTIL THE CURTAIN IS STRAIGHT. BRING THE CURTAIN BACK UP TO ABOUT 1/2 OPEN AND SECURE THE CHAIN ON THE CHAIN KEEPER.



STEP NO. 6 - INSTALL DOOR STOPS AND SLIDE BOLT LOCKS

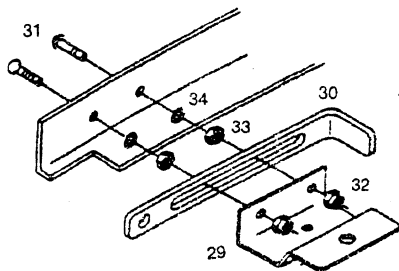


DIAGRAM 11

- A. INSTALL THE DOOR STOP (29) AND THE SLIDE BOLT LOCK (30) TO THE BOTTOM ANGLE (9) ON EACH SIDE OF THE DOOR USING THE APPROPRIATE HARDWARE AS SHOWN. (SEE DIAGRAM 11).
- B. BRING DOOR BACK UP TO ABOUT ONE FOOT BELOW HEAD. SECURE CHAIN ON CHAIN KEEPER.

STEP NO. 7 - INSTALL DOOR GUIDES

- A. FIND THE GUIDE TYPE PROVIDED: 1-PIECE, 2-PIECE, 3-PIECE, OR WINDLOCK. SELECT PROPER MOUNTING FOR STEEL, WOOD, OR CONCRETE AND NOTE THE CLEARANCE DIMENSIONS SHOWN IN DIAGRAM 2 THROUGH 5 ON THE FRONT PAGE.
- B. IF MOUNTING 2-PIECE OR 3-PIECE GUIDE TO CONCRETE. ASSEMBLE THE GUIDE PIECES AS SHOWN WITH THE FASTENERS PROVIDED. NEXT SLIDE GUIDE ASSEMBLY OVER ENDS OF THE CURTAIN SO THAT HEAD STOP IS ABOVE BOTTOM ANGLE. MAINTAIN THE CLEARANCE DIMENSIONS SHOWN IN DIAGRAM 4 OR 5. LOCATE POSITION OF TOP FASTENER ON WALL ANGLE AND INSTALL FASTENER. BRING CURTAIN DOWN TO 6" ABOVE FLOOR. LOCATE AND INSTALL BOTTOM FASTENER. THE GUIDE SHOULD BE PLUMB AT THIS POINT. LOCATE, DRILL, AND SECURE BALANCE OF FASTENERS.
- C. ALL GUIDE TYPES MOUNTING TO STEEL OR WOOD: INSTALL WALL ANGLE ONLY WITH FASTENERS PROVIDED AT THE DIMENSION SHOWN IN DIAGRAM 4 OR 5. NEXT SLIDE CHANNEL OR INNER & OUTER ANGLES AT THE ENDS OF CURTAIN AS EXPLAINED ON STEP 7A. AND INSTALL THEM TO THE WALL ANGLES WITH FASTENERS PROVIDED.

NOTE:

THE DOOR SHOULD MOVE UP AND DOWN EASILY. THERE SHOULD BE APPROX. THE CLEARANCES BETWEEN THE GUIDE AND THE CURTAIN AS SHOWN. USE ADJUSTMENT IN WALL ANGLE TO OBTAIN PROPER CLEARANCES.

STEP NO. 8 - CHECK AND ADJUST BALANCE

- A. IF THE DOOR LOWERS EASILY AND RAISES HARD, MORE TENSION IS REQUIRED. IF THE DOOR LOWERS HARD AND RAISES EASILY, LESS TENSION IS REQUIRED. (SEE DIAGRAM 12)

CAUTION:

BEFORE ADJUSTING THE SPRINGS, PULL THE DOOR INTO THE UP POSITION.

- B. SECURE THE DOOR IN THE UP POSITION BY ONE OF THE FOLLOWING METHODS:

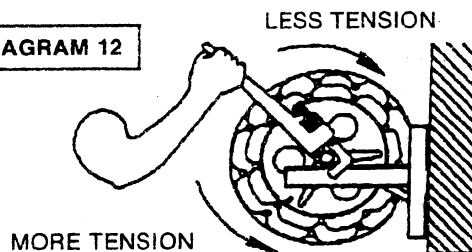
1. TIE A ROPE AROUND THE DOOR ROLL
2. PLACE A CLAMP AT THE TOP OF THE GUIDE CHANNEL TO SECURE THE CURTAIN IN THE GUIDE CHANNEL.

WARNING:

WHEN THE AXLE CLAMPS ARE LOOSENEED, THE SPRINGS WILL BE VERY STRONG. YOU WILL REQUIRE TWO PEOPLE TO ADJUST THE DOOR TENSION SAFELY.

- C. EACH PERSON SHOULD FIRMLY PLACE A LARGE PIPE WRENCH ON THE AXLE AS SHOWN IN DIAGRAM 12. LOOSEN THE AXLE CLAMPS AND PULL DOWN FOR MORE TENSION AND UP FOR LESS TENSION.
- D. RETIGHTEN THE AXLE CLAMP HARDWARE.
- E. REPEAT THE ABOVE STEPS IF FURTHER ADJUSTMENT IS NECESSARY. BEGINNING AT STEP 9A.

DIAGRAM 12



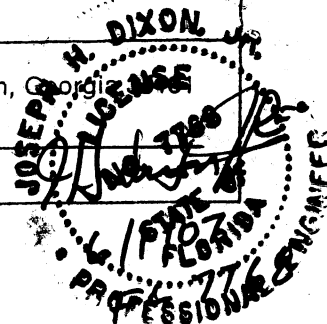
TROUBLESHOOTING

- A. DOOR CURTAIN DRAGS IN GUIDES:
 1. CHECK DOOR MOUNTING BRACKETS FOR LEVEL.
 2. ADJUST LOCATION OF GUIDES. SEE DIAGRAMS 2-5.
 3. DOOR DRUM ASSEMBLY MAY BE SET TOO CLOSE OR TOO FAR FROM WALL. NOTE SLOTS FOR ADJUSTMENT.
 4. ADJUST LEAD-IN BEND AT TOP OF GUIDES.
- B. DOOR DOES NOT CONTACT FLOOR LEVEL:
 1. USE A SPIRIT LEVEL TO CHECK WHETHER THE DOOR OR THE FLOOR IS OUT OF LEVEL.
 2. CHECK THAT AXLE IS LOCATED IN THE SAME POSITION IN THE SLOTS ON THE MOUNTING BRACKETS.



ASTA Door Corporation

4255 McEver Industrial Drive, P.O. Box 420, Acworth, Georgia
Office: (770) 974-2600 / Fax: (770) 974-1455





ASTA Door Corporation

MODEL 300 COMMERCIAL SLAT DOOR SUPPLEMENT SHEET I. SINGLE REDUCTION

NOTE: LEFT HAND SHOWN THROUGHOUT, RIGHT HAND OPPOSITE

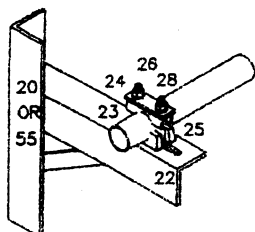


DIAGRAM 10

STEEL

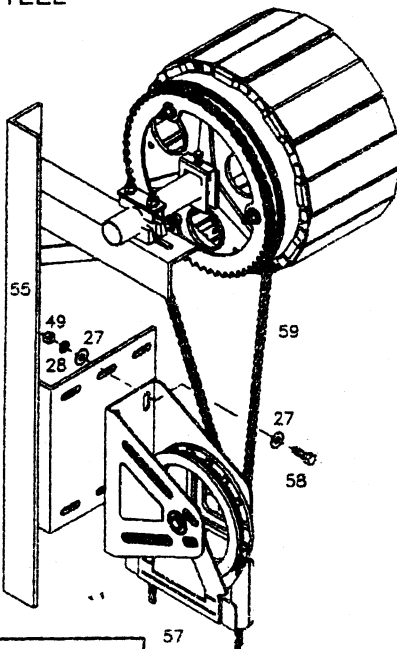


DIAGRAM 11

CONCRETE & WOOD

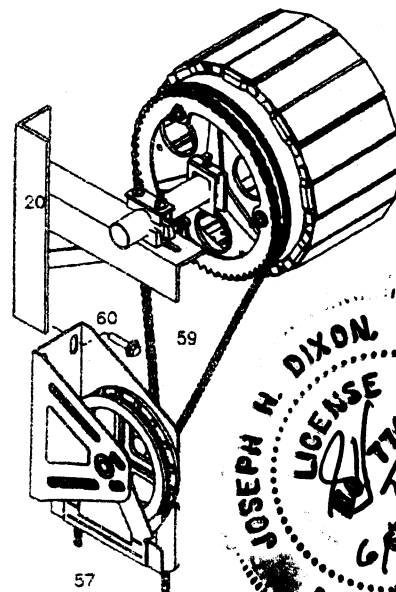
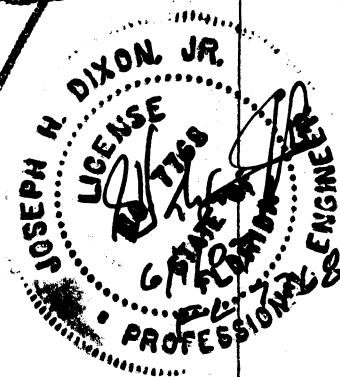


DIAGRAM 12



20	450150	SUPPORT BRACKET, LEFT	28	750203	LOCK WASHER 3/8"
22	310101	AXLE SADDLE CASTING	49	740103	NUT 3/8" — 16
23	310103	AXLE CLAMP	55	VARIES	SINGLE SUPPORT BRACKET ASSY.
24	310102	KEEPER PLATE	57	VARIES	SINGLE REDUCTION DRIVE
25	730103	BOLT 3/8" — 24 X 3.1/2"	58	730106	SCREW HEX HD CAP 3/8" — 16 X 1.25PL
26	740104	NUT 3/8" — 24	59	440004	#41 CHAIN 110 PITCHES
27	750103	FLAT WASHER 3/8"	60	760101	3/8" X 1.7/8" MASONRY ANCHOR

STEP NO. 3 — DOOR & AXLE ASSEMBLY

- A. LIFT THE DOOR ASSY. UP ONTO THE DOOR SUPPORT BRACKETS AS SHOWN IN DIAGRAM 10.
- B. PERFORM THE FOLLOWING STEP FOR BOTH SIDES:
AFTER PLACING AXLE SADDLE (22) UNDER AXLE, PLACE THE AXLE CLAMP PLATE (23) & KEEPER PLATE (24) ON TOP.
INSTALL 3/8" BOLTS (25), LOCK WASHERS (24) & NUT (26) (SEE DIAGRAM 10).
- NOTE:** DO NOT TIGHTEN HARDWARE UNTIL INSTRUCTED.

STEEL MOUNT

STEP NO. 4 — INSTALL REDUCTION DRIVE

- A. AS SHOWN IN DIAGRAM 11, MOUNT REDUCTION DRIVE (57) BY USING 3/8" SCREW (58), WASHER (27), LOCK WASHER (28) & NUT (49).
DO NOT TIGHTEN HARDWARE.
- B. INSTALL CHAIN #41 (59) ON CURTAIN SPROCKET TO ALIGN SPROCKET OF REDUCTION DRIVE. TIGHTEN HARDWARE.

CONTINUE STEP NO. 5 IN INSTALLATION INSTRUCTION

CONCRETE & WOOD MOUNT

STEP NO. 4 — INSTALL REDUCTION DRIVE

- A. FOLLOW DIAGRAM 12 TO INSTALL CHAIN #41 (59) ON CURTAIN SPROCKET TO ALIGN SPROCKET OF REDUCTION DRIVE (USE ALL 110 PITCHES).
DO NOT TIGHTEN HARDWARE.
- B. FASTEN THE REDUCTION DRIVE TO CONCRETE BY USING 3/8" ANCHOR (60). DO NOT TIGHTEN HARDWARE.
ADJUST REDUCTION DRIVE UP OR DOWN IF NEEDED TENSION CHAIN #41 (59). TIGHTEN HARDWARE.

CONTINUE STEP NO. 5 IN INSTALLATION INSTRUCTION