



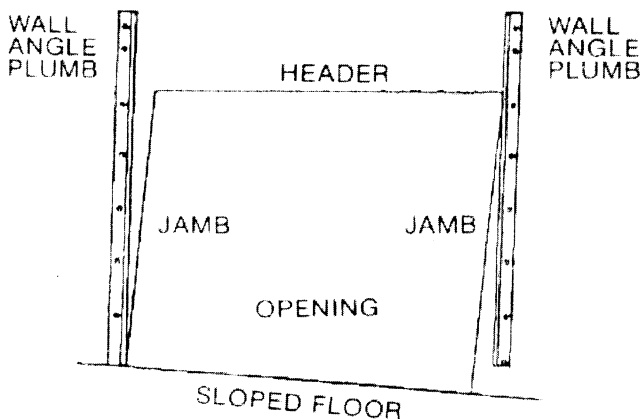
ASTA Door Corporation

Installation Instructions — Model 400/600 Heavy Duty Rolling Steel Service Door

USE ASTA DOORS PARTS ONLY — ALL OTHERS SHALL VOID WARRANTY
FOR MORE INFORMATION CONTACT ASTA DOOR CORP. (770) 974-2650

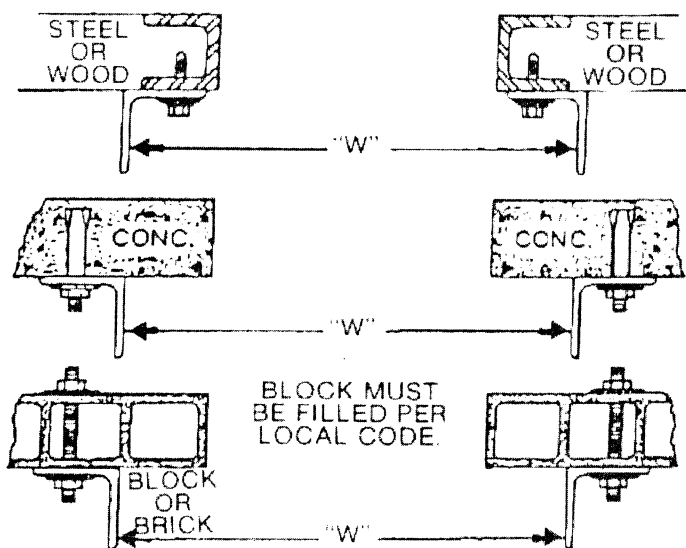
1. PREPARATION

- 1.1 CHECK THE HEIGHT AND WIDTH OF THE OPENING
- 1.2 CHECK IF THE DOOR JAMBS ARE PLUMB
- 1.3 CHECK IF THE FLOOR AND HEADER ARE LEVEL
- 1.4 THE WALL ANGLES IN STEP 2 MUST BE INSTALLED PLUMB AND LEVEL TO EACH OTHER EVEN IF JAMB IS NOT PLUMB AND FLOOR IS SLOPED. SEE EXAMPLE BELOW.



2. WALL ANGLES

- 2.1 EVENLY SPACE WALL ANGLES OUTSIDE OPENING SO THAT THE DISTANCE BETWEEN THEM IS AS SHOWN BELOW.



GUIDE TYPE	"W" DIMENSION
ALL NON-WINDLOCKS	BARREL + 1"
MALLEABLE WINDLOCKS	BARREL + 1 3/4"
STAMPED WINDLOCKS	BARREL + 1"

- 2.2 FASTEN WALL ANGLES TO JAMBS ACCORDING TO THE FOLLOWING TABLE:

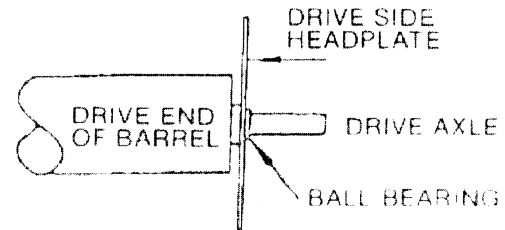
JAMB	FASTENERS
STEEL	DRILL 3/8" (S) DIA HOLES FOR 3/8" SELF TAPS DRILL 27/64" DIA HOLES AND TAP 1/2-13 FOR 1/2" BOLT
WOOD	LAG BOLTS 3/8 INCH
CONCRETE	EXPANSION BOLTS 1/2 INCH
BLOCK OR BRICK	THRU-BOLTS OR ALL THREAD 1/2 INCH

*NUMBER AND SIZE OF FASTENERS MUST MATCH SLOTS PROVIDED IN WALL ANGLE

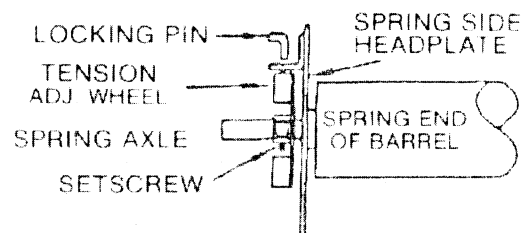
3. BARREL ASSEMBLY

NOTE: RIGHT HAND OPERATION SHOWN THROUGHOUT. LEFT HAND OPPOSITE

- 3.1 FIT DRIVE SIDE HEADPLATE ONTO DRIVE AXLE OF BARREL AS SHOWN BELOW
THE DRIVE END OF THE BARREL HAS NO AXLE BEARING AND NO COUNTERBALANCE SPRING. THE THE DRIVE SIDE HEADPLATE HAS A BALL BEARING ATTACHED.



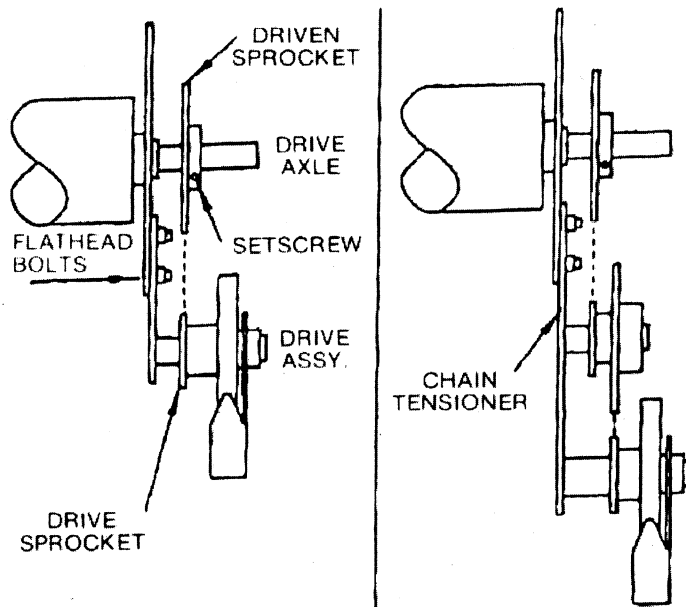
- 3.2 FIT SPRING SIDE HEADPLATE ONTO SPRING AXLE AS SHOWN BELOW. THE SPRING END OF THE BARREL HAS AN AXLE BEARING AND A COUNTERBALANCE SPRING. THE SPRING SIDE HEADPLATE HAS NO BEARING.
- 3.3 FIT TENSION ADJUSTMENT WHEEL ONTO SPRING AXLE AND INSERT KEY. DO NOT INSERT LOCKING PIN OR TIGHTEN SETSCREW AT THIS TIME



CAUTION KEY MUST BE COMPLETELY INSERTED INTO TENSION ADJ. WHEEL OR DAMAGE AND INJURY COULD OCCUR.

4. DRIVE ASSEMBLY

- 4.1 FIT DRIVEN SPROCKET ONTO DRIVE AXLE. DO NOT INSERT KEY INTO KEYWAY OR TIGHTEN SETSCREW AT THIS TIME.



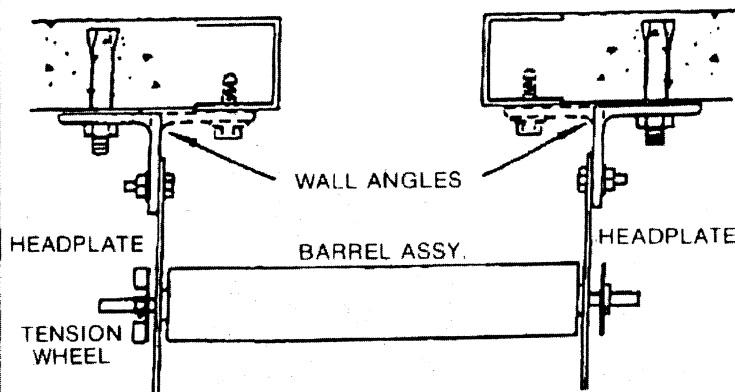
SINGLE REDUCTION

DOUBLE REDUCTION

- 4.2 FASTEN DRIVE ASSEMBLY TO DRIVE SIDE HEADPLATE WITH TWO 1/2 INCH FLATHEAD BOLTS, FLATWASHERS AND NUTS. DO NOT TIGHTEN BOLTS AT THIS TIME.
- 4.3 SLIDE HEADPLATE UP AGAINST BARREL SPACER AND ALIGN DRIVEN SPROCKET WITH DRIVE SPROCKET.
- 4.4 INSTALL ROLLERCHAIN ONTO DRIVE AND DRIVEN SPROCKETS AND SECURE MASTER LINK. GREASE ROLLERCHAIN.
- 4.5 INSERT KEY COMPLETELY INTO DRIVEN SPROCKET KEYSEAT.

5. MOUNTING BARREL ASSEMBLY

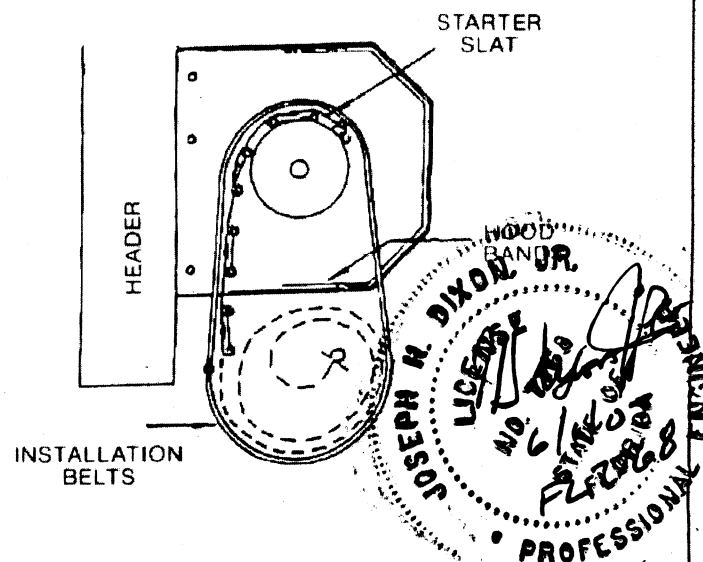
- 5.1 RAISE COMPLETE BARREL ASSEMBLY WITH A MECHANICAL HOIST OR A FORKLIFT AND FASTEN HEADPLATES TO WALL ANGLES WITH 1/2 IN. BOLTS, LOCKWASHERS AND NUTS AS SHOWN BELOW. USE FLATHEAD BOLTS WHERE COUNTERSUNK HOLES ARE FOUND.



- 5.2 SPACE PIPE EQUALLY BETWEEN HEADPLATES.
- 5.3 ALIGN DRIVE AND DRIVEN SPROCKETS.
- 5.4 ADJUST CHAIN TENSIONER AND TIGHTEN BOLTS.
- 5.5 TIGHTEN DRIVEN SPROCKET SETSCREW.
- 5.6 ADJUST POSITION OF TENSION WHEEL ON SPRING AXLE TO WITHIN 1/4 IN. OF HEADPLATE AND TIGHTEN SETSCREW. DO NOT INSERT PIN IN TENSION ADJ. WHEEL AT THIS TIME.

6. MOUNTING CURTAIN ASSEMBLY

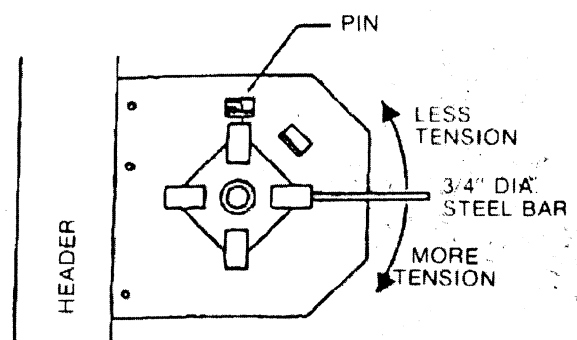
- 6.1 RAISE CURTAIN ASSEMBLY WITH MECHANICAL HOIST OR FORKLIFT AND HANG IT ONTO BARREL WITH INSTALLATION BELTS.
- 6.2 HOOK STARTER SLATS ONTO ATTACHMENT BARS AND FASTEN WITH 5/16-18, 1/2 IN. LONG BOLTS AND FLATWASHERS AS SHOWN IN FIGURE BELOW.



- 6.3 PULL HAND CHAIN TO ROLL CURTAIN ONTO BARREL WHILE ASSISTING TENSION WHEEL TO ROTATE FREELY.

CAUTION SECURE HAND CHAIN SO CURTAIN WILL NOT UNCOIL DURING TENSIONING PROCEDURE. KEEP CURTAIN CLOSE TO WALL AND AWAY FROM HOOD BANDS.

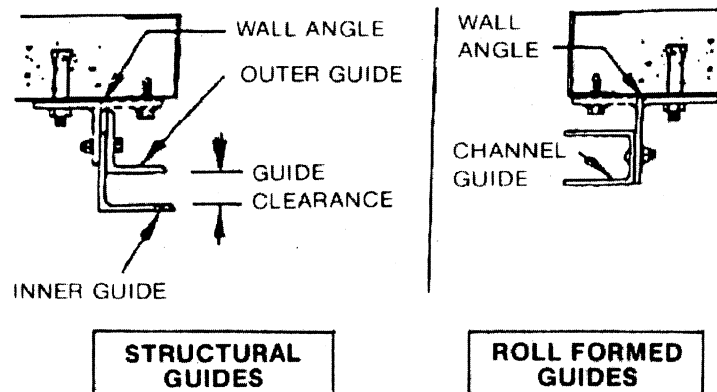
- 6.4 APPLY 3 TO 4 COMPLETE TURNS OF TENSION TO THE TENSION ADJ. WHEEL BY ALTERNATELY PULLING DOWN ON THE TENSION TOOL, AND INSERTING THE PIN, AS SHOWN BELOW.



CAUTION TEST DOOR AND ADJUST TENSION AS NEEDED FOR PROPER CURTAIN BALANCE. LARGE DOORS MAY REQUIRE MORE THAN 4 TURNS OF TENSION. APPLY MORE OR LESS TENSION IN 1/4 TURN INCREMENTS.

7. GUIDE ANGLES

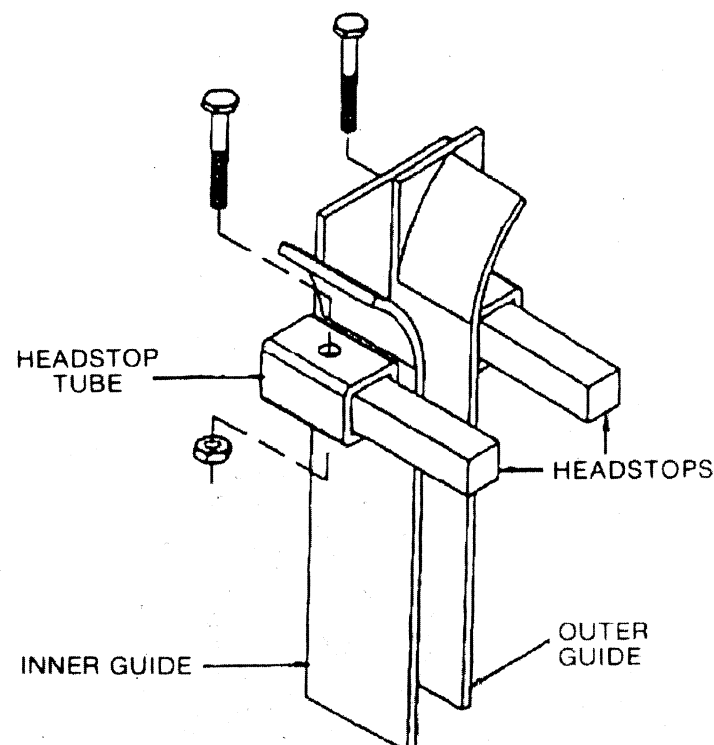
7.1 FASTEN INNER AND OUTER GUIDES TO THE WALL ANGLES WITH 3/8 INCH BOLTS, NUTS AND LOCKWASHERS. THE FIGURE BELOW SHOWS THE PROPER MOUNTING FOR ALL STRUCTURAL GUIDE SYSTEMS, AND ROLL FORMED GUIDES.



7.2 ADJUST GUIDE CLEARANCE TO ALLOW 1/8" of curtain movement.

7.3 INSERT HEADSTOPS INTO HEADSTOP TUBES AND FASTEN WITH 5/16" x 1 3/4" BOLTS AND LOCKNUTS AS SHOWN BELOW. DOORS WHICH ALSO HAVE REMOVABLE HEADSTOPS ON THE CUTER GUIDE MUST BE ASSEMBLED SIMILARLY.

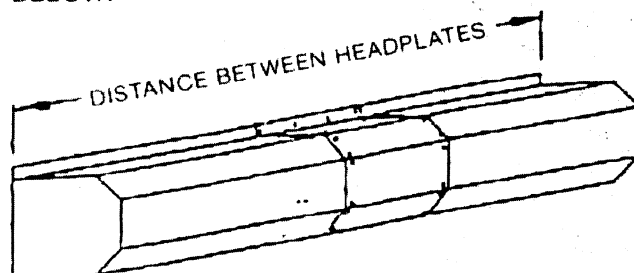
7.4 APPLY GREASE INSIDE GUIDE CHANNEL TO ALLOW FREE CURTAIN MOVEMENT.



8. HOOD

8.1 IF THE PROVIDED HOOD IS A SINGLE PIECE OR FACTORY COMBINED MULTIPLE PIECES, THEN SKIP TO INSTRUCTION 8.4.

8.2 IF HOOD WAS PROVIDED IN TWO OR MORE PIECES THEN OVERLAP THE PIECES SO THAT COMBINED HOOD LENGTH IS EQUAL TO THE MEASURED DISTANCE BETWEEN THE HEADPLATES AS SHOWN BELOW.



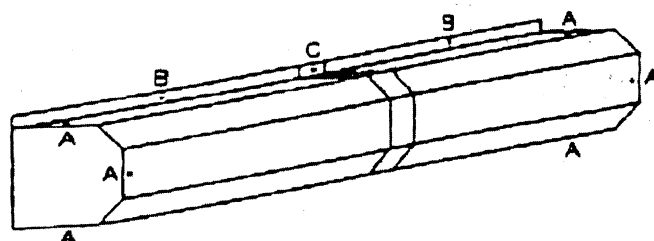
8.3 FASTEN OVERLAPPED AREA TOGETHER WITH FOUR POP RIVETS IN EACH FLAT SECTION. (28 RIVETS TOTAL)

8.4 RAISE HOOD WITH MECHANICAL HOIST OR LIFT AND FASTEN TO HEADPLATES AND HEADER AS SHOWN IN THE FOLLOWING FIGURE BELOW.

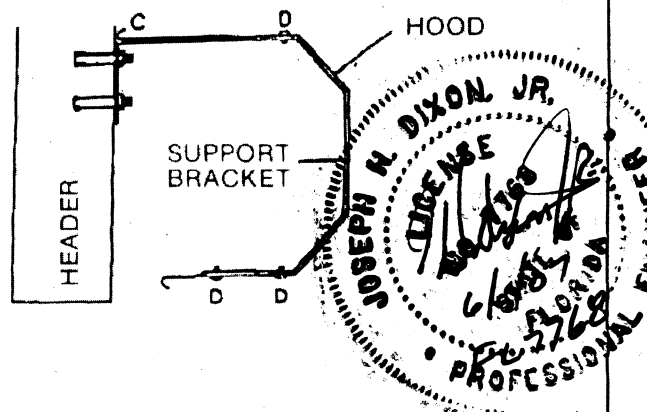
8.5 FASTEN HOOD TO HEADPLATES AT LOCATION "A" WITH 1/4 INCH SELF TAPPING SCREWS.

8.6 FASTEN HOOD TO HEADER AT "B"

8.7 HOODS OVER 16 FEET LONG REQUIRE ANOTHER FASTENER AT LOCATION "C".

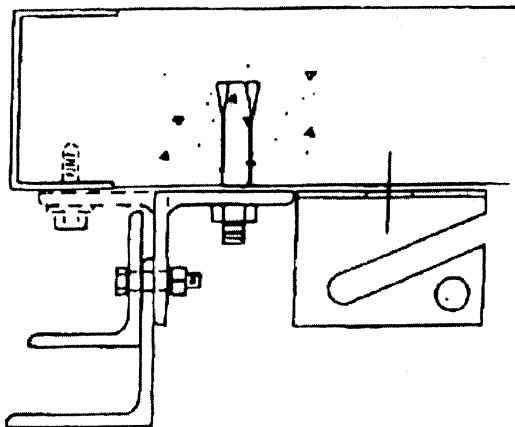


8.8 WHEN HOOD SUPPORT BRACKETS ARE SUPPLIED, INSTALL AT LOCATIONS "B" OR "C" AS NEEDED. FASTEN HOOD TO BRACKET AT LOCATIONS "D".

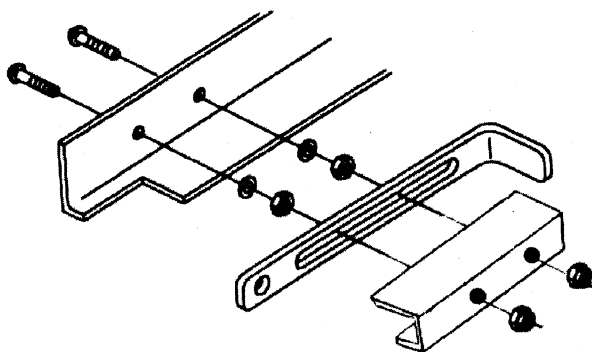


9. HANDCHAIN

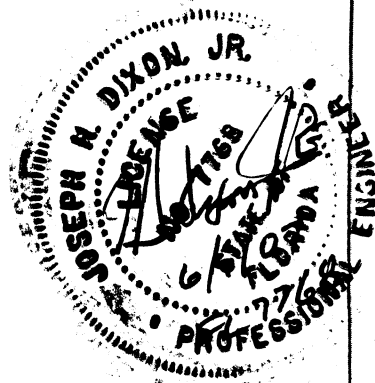
- 9.1 ADJUST HANDCHAIN LENGTH SO THAT IT HANGS BETWEEN 1 AND 2 FEET OFF THE GROUND.
- 9.2 FASTEN HANDCHAIN LATCH APPROX. 4' OFF THE GROUND AS SHOWN BELOW.



10. SLIDE BOLT LOCK (OPTION)



- 10.1 INSTALL SLIDEBOLT LOCKS TO BOTTOM ANGLE ON EACH SIDE OF DOOR USING APPROPRIATE HARDWARE SHOWN.



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