

Assembly Instruction

FOPPE Craftmann´s door | series HT72+



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Assembly Instructions

General Information

Congratulations!

You have selected a high-quality FOPPE Metallbaumodule product.

To ensure, that you have the utmost pleasure from the product, thoroughly read these assembly instructions.

Necessary installation material

Begin by checking the profiles and surfaces for any evidence of damage and check the accessories for completeness by using the job order for reference.



Further information of operation and maintenance for the Craftmann's door is available as download on our homepage. Visit us at www.foppe.de.

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Start by assembling the door hinges. To do this, unscrew the screw anchors as far as they will go/to the lock position.



2

Insert the bushes in the bottom section.



3

Press in the plastic ring at the bottom.



4

Insert the bushing with the pin part in the top hinge part.

Next press in the plastic ring at the top and press on the plastic cap at the top and bottom.



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The hinge is now put in place and pressed all the way into the pre-drilled sections.



6

Use the enclosed Allen key to tighten the bolts.



7

Next open the door leaf section, in order to secure the outer caps from the inside by means of the enclosed Allen key.



8

The hinge is now completely assembled.

Note: We have provided some information on adjusting door hinges on page 13.



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To do this, take the supplied handle pin and press it into the mount on the handle. Insert the handle in the square mount (latch) of the pre-fitted lock.



10

Fix the handles with the enclosed stainless steel countersunk screws M5 x 25 mm, 3 ea. per long plate handle or 2 ea. per oval handle, and 2 ea. stainless steel countersunk screws M 5 x 16 mm for the oval profile cylinder rosettes.



11

Press the covers on the substructures of the handles and rosettes.



12

Mix the adhesive according to the instructions on the cartridge. Follow the instructions for use on the cartridge. The curing times stated here must be complied with without fail. Subsequent correction of the corners after curing is only possible with difficulty.



Use a commercially available silicon gun to distribute the adhesive in the hollow spaces of the sections.

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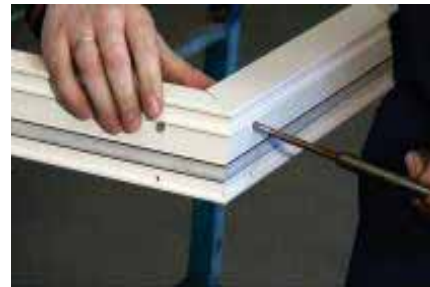
13

Take the 3 corner connectors of the outer frame and join the lateral frame sections to the upper frame section.



14

Drive the supplied aluminium nails 5 mm into the pre-punched holes of the outer frame and into the corner connector, so that the sections "pull together" at the mitres. Align the corners. Use the enclosed cleaning cloth and cleaning agent to wipe off any adhesive which oozes out. Repeat this several times, since cured adhesive cannot be removed from the surface.



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For clarification: 2 corner connectors in the door leaf frame.



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Assemble the door leaf frame. To do this, place the base on the pre-fitted T connectors of the lateral door leaf sections and the top part of the frame on the lateral door leaf sections.

Drive the aluminium nails 5 + 7 mm into the pre-punched holes of the base and 5 mm into the holes of the lateral and top door leaf sections.



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Attention: Align the door leaf frame and carefully wipe off the adhesive. Repeat this several times.



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After you have inserted the 3 seals into the section for the adjustable base, cut the outer seal back to the rebate width.



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Screw the stainless steel door sill brackets to the retractable sill.



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Attach the end pieces and screw them to the door leaf frame. To do this, use the special countersunk screws 3.9 x 20 mm with a tip.



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Pull the bottom rebate seal into the adjustable sill and glue it to the sealing piece of the door.



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Please note that the seal must be pushed into the end piece of the sealing piece.



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Glue the outer rebate seal to the sealing piece.



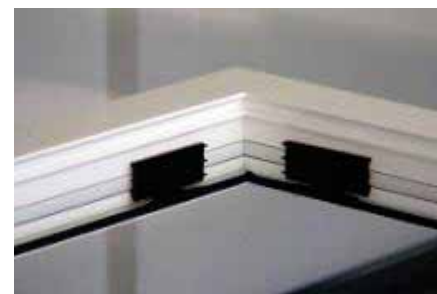
24

Pull the rebate seal into the outer rebate groove of the lateral and top door leaf frame.



25

Pull the glass rebate seal into the door leaf frame. The glass bridges are then inserted. At the bottom on the hinge side and at the top on the handle side, approx. 100 mm from the corners in each case.



26

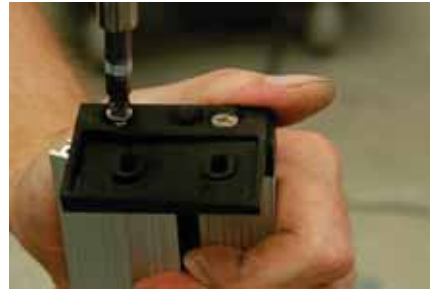
The glass strips are inserted to complete the door leaf frame. Please note that these have an overlength of approx. 2 mm and have to be cut to the required size. Start with the horizontal glass strips and then insert the vertical glass strips. Use a suitable saw to cut the glass strips to size. A handsaw (mechanical) does not cut the corners cleanly.



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Detail: Aluminium step rail with plastic end piece.



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Take the aluminium step rail and screw down the plastic end pieces on the side with the stainless steel countersunk screws 4.2 x 32 mm. (See also detail above)



29

The completed step rail is now screwed to the lateral outer frame. The stainless steel countersunk screws 4.2 x 32 mm are used for this.



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The door sill is screwed into the two pre-drilled attachment holes in the frame.



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Note: Only if the door was ordered with a sill for new buildings.

In the case of a sill for new buildings, a steel tube 30/30/2 is screwed under the step rail, and the EPDM foil thereby clamped. If required and with a screw connection through the door sill from above, please drill and countersink on-site.



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Finally the rebate seal is pulled into the outer frame.



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Attach the door leaf and carry out an initial function test on the assembly table.



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To finish, install the profile cylinder and carry out another function test.



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On request, we can also supply you with an outer push handle.

As shown in the picture, the screw anchors are screwed all the way into the drill holes and the handle attached and secured with the grub screws.

We recommend that a threadlocker, e.g. Loctite, is used to secure the grub screws against loosening.



Functional Check

Finally, perform a functional check. We hope you enjoy putting your self-assembly door together. You can view a film about our self-assembly door of the Alcoa AA610 series on our home page. Visit us at www.metallbaumodule.de

Appendix: Information on adjusting door hinges

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Undo the outer cap.



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The grub screw can be adjusted with an Allen key after the outer cap has been removed. The rebate clearance can be thereby reduced or increased. (+/- 2.5 mm)

The contact pressure on the hinge side is adjusted by turning the bushes by 90°. A special adjustment tool is required for this. This can be ordered from FOPPE Direkt Versand GmbH (Article no.: 45005053000)



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Height adjustment: Remove the bottom cap and use an Allen key to adjust the door leaf. (-1 mm/+3 mm)





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