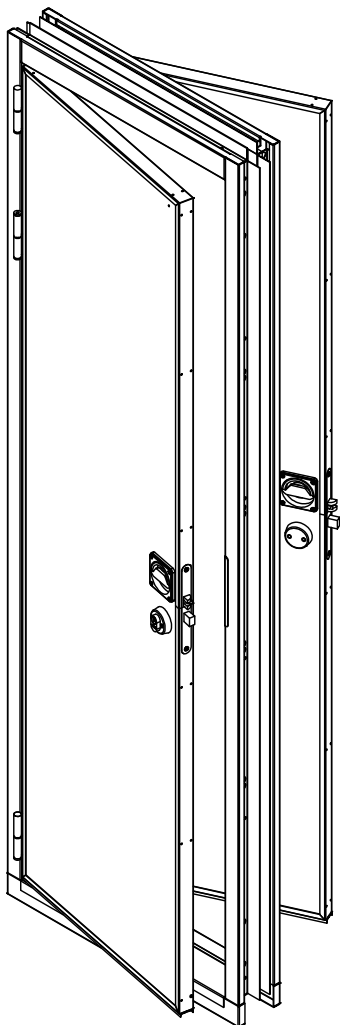




ANTTI MARINE

Antti Marine Doors Installation instructions for connecting cabin doors



VOASENNUS_EN

28-01-2022

These instructions replace
the installation instructions for
connecting cabin doors
20-10-2020.

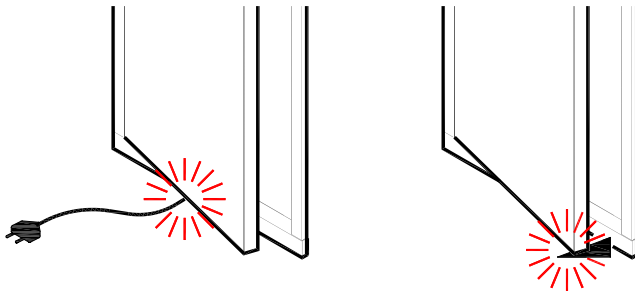


**Read the installation instructions
of the door before starting the installation.**

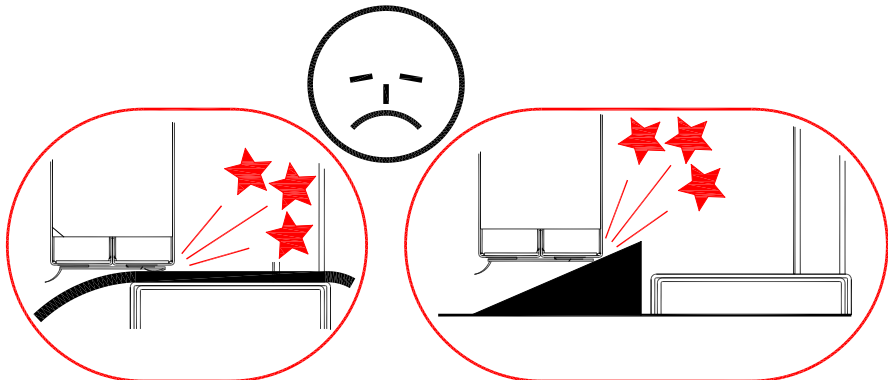
**Note that the installation means and methods in this
manual are indicative.**

**Install the door taking into account this manual and
the requirements on site.**

**Take care not to damage the bottom sealing of
the door during installation.**



Damage can be caused by ...



... a cable between the door and the threshold ...

... door wedge.



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MAINTENANCE INSTRUCTIONS

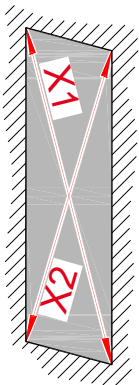
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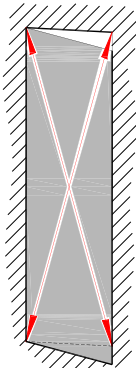
INSTALLATION INSTRUCTIONS

Check the door aperture

$X1 = X2$



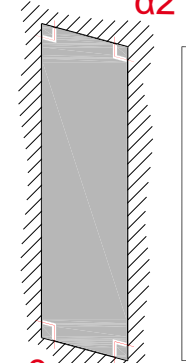
$X1 \neq X2$



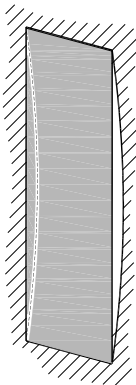
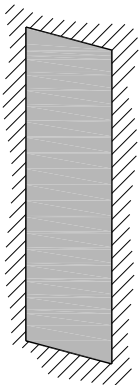
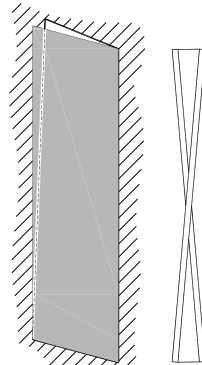
$\alpha1 \dots \alpha4 = 90^\circ$

$\alpha1$

$\alpha2$



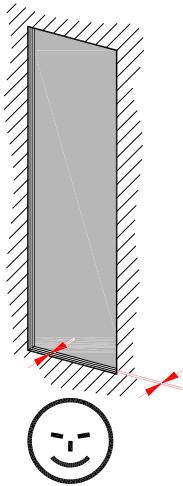
$\alpha1 \dots \alpha4 \neq 90^\circ$



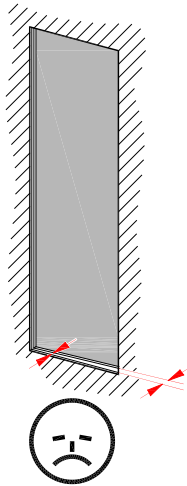


Check the location of the doorways relative to each other

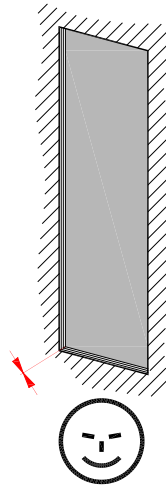
$X1 = X2$



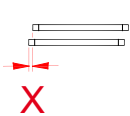
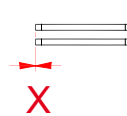
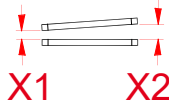
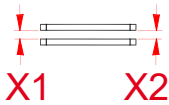
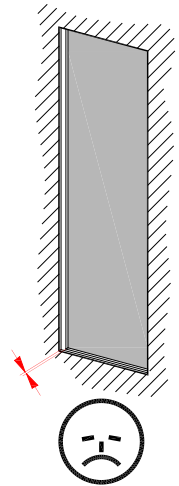
$X1 \neq X2$



$X = 0$



$X \neq 0$

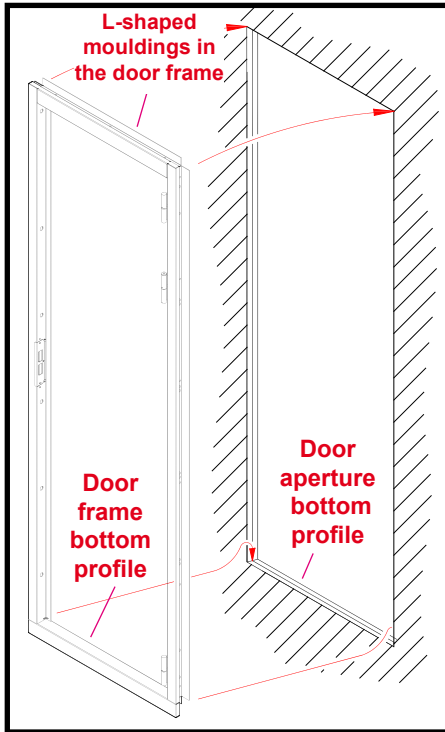




Installation of the door frame

Frame installation and attachment on the side of hinges

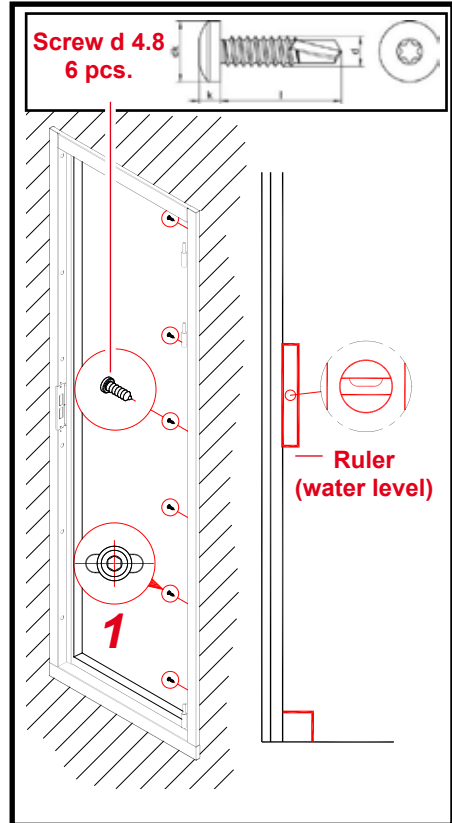
Choose the handing of the frames based on the structural drawings of the vessel.



Picture 1.

If the door frame is equipped with optional L-shaped mouldings (see image 1), some of the steps listed in these instructions are not applicable!

1. Place the first frame into the wall aperture. Lower the bottom profile of the frame onto the bottom edge profile of the aperture.



Picture 2.

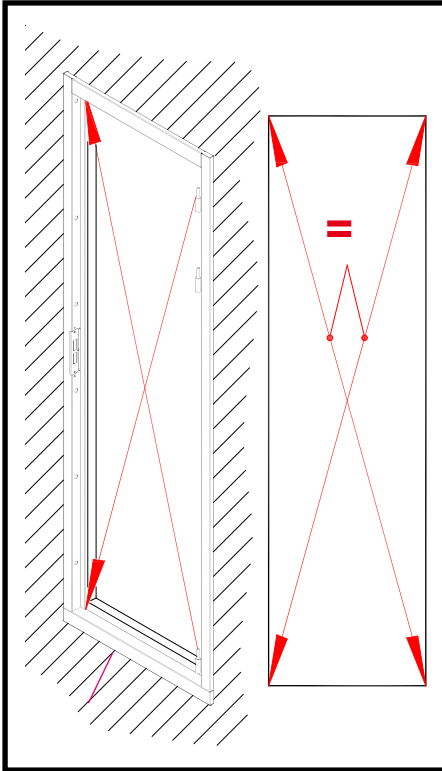
1. Attach the frame on the side of hinges to the vertical profile by six d 4.8X19 ZN DIN7504-N screws.

Place the screws in the middle of elongated holes of the frame to ensure the possibility for adjustment (detail 1).

2. Check the straightness of the attached edge of the frame by a ruler and the verticality by a water level (assembly in the hall).

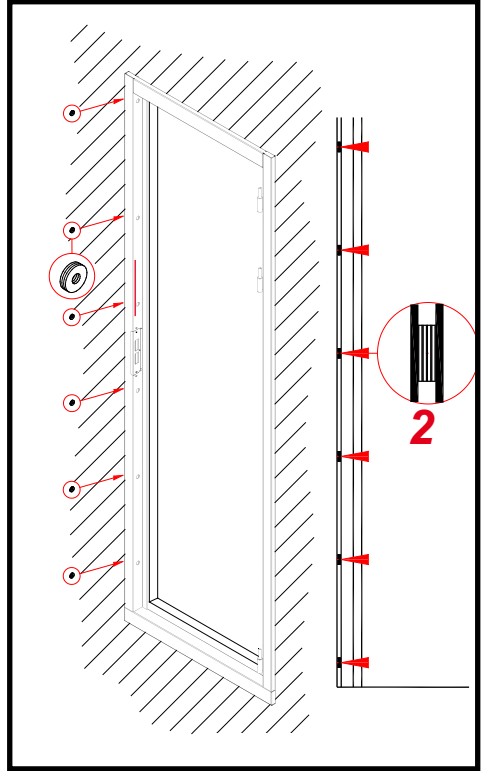


Frame installation on the side of lock counterpart



Picture 3.

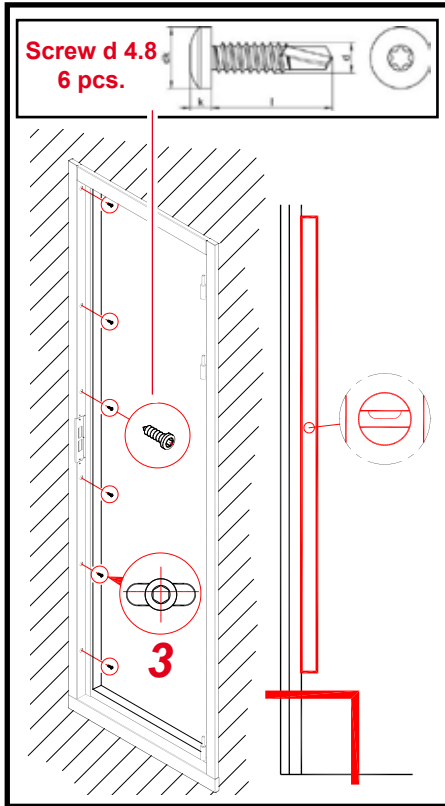
1. Measure the diagonal dimensions of the frame aperture.
2. Move the vertical profile on the side of lock counterpart of the frame in such a way that the diagonal dimensions have exactly same length.
3. Brace the vertical profile in this position until it is fixed (figure 4).



Picture 4.

If the doorway is so wide that the vertical profile of the frame does not reach the side of the door aperture, then install suitable spacers (detail 2) in between, at the place of each screw.

If the door frame is equipped with L-shaped mouldings, this step can not be completed!

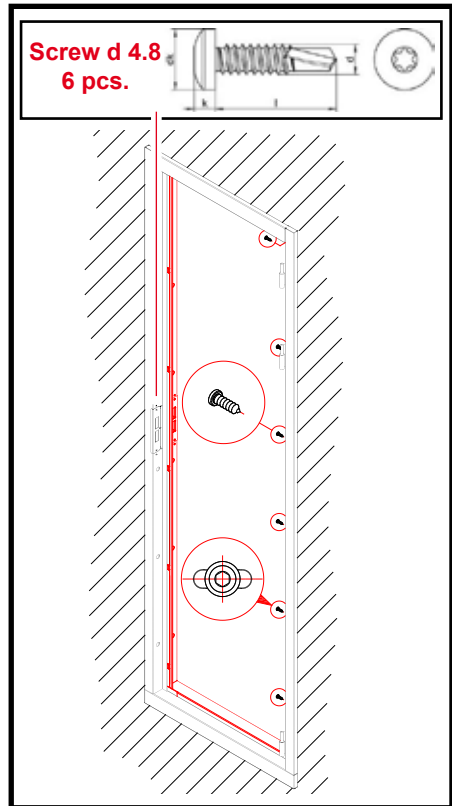


Picture 5.

1. Attach the frame on the side of hinges to the vertical profile by six d 4.8X19 ZN DIN7504-N screws.

Place the screws in the middle of elongated holes of the frame to ensure the possibility for adjustment (detail 1).

2. Check the straightness of the attached edge of the frame by a ruler and the verticality by a water level (assembly in the hall).



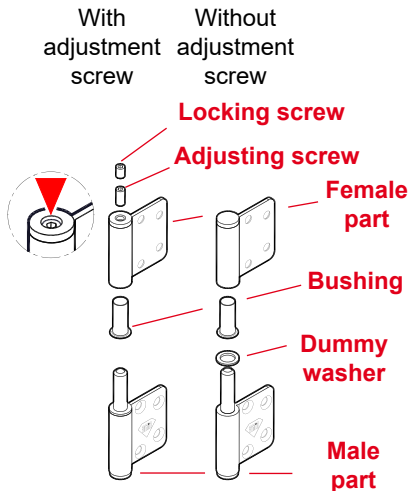
Kuva 6.

1. Following the instructions in images 1 - 5, attach the doorway's second (other handing) frame from the side of the other cabin.

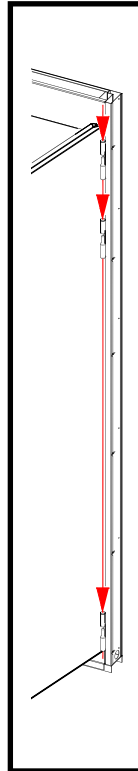


PLEASE NOTE!
2-D hinge is permanently lubricated.
Do not use lubricants!

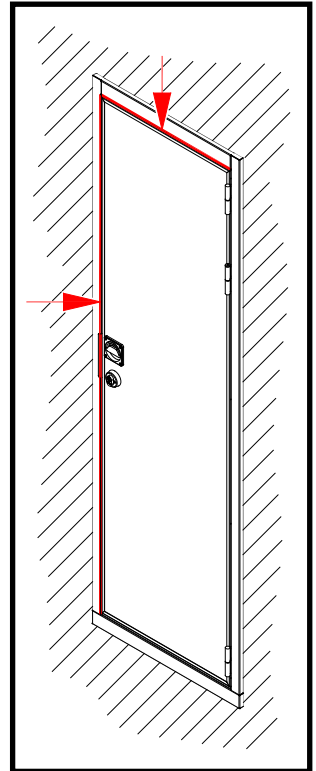
Hinge types Pivot bearing hinge



Picture 7.



Picture 8.



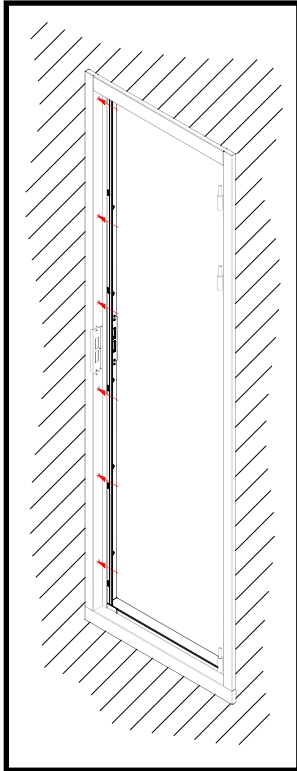
Picture 9.

1. Lift the door back into its place. Align the door leaf with the hinge pegs on the frame at **all** hinges and lower the door leaf onto the hinges (figure 8).

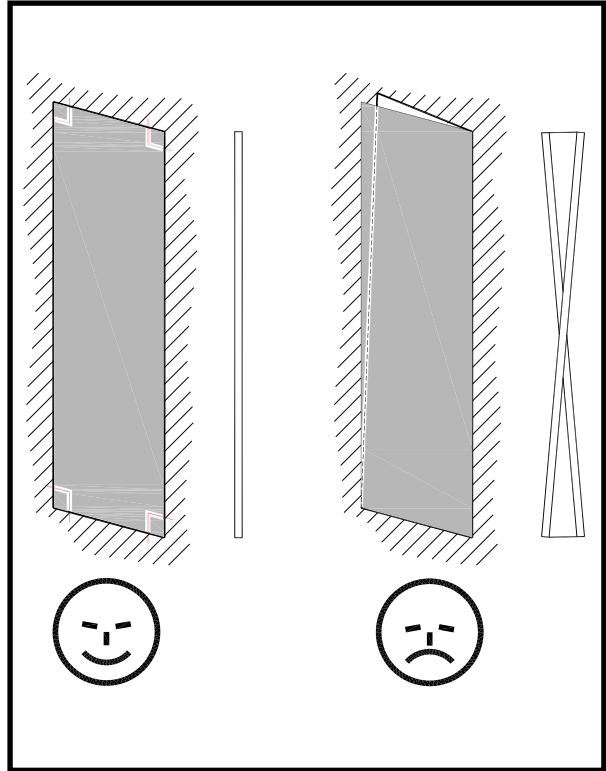
Observe that the bushing of the pivot bearing hinge comes into the upper part and the hinge washer comes onto the pivot of the lower part.

The adjustment hinge is easily recognised by the screw hole in the deck of the upper part of the hinge.

1. Close the door and check that the door is pressed at the sides indicated by arrows, evenly at each point, against the sealing of the frame.
2. If this is not the case (i. e. the frame is not levelled), fix the position of the frame (see figure 11).



Picture 10.



Picture 11.

1. If necessary, slacken the screws of the vertical profile on the side of the lock counterpart of the frame.
2. Fix the position of the frame so that both of its vertical profiles are exactly parallel vertically.
3. Tighten several screws and try pressing the door against the sealings as described in paragraph 1 figure 9 on the previous page.
4. After you have fixed the position of the frame, tighten all the screws you slackened earlier.
5. If necessary, adjust also the position of the other frame.



NOTE!

Do not fix the bottom profile of the frame with screws. The upper profile to be fixed with screws only in exceptional cases (ready-made holes).

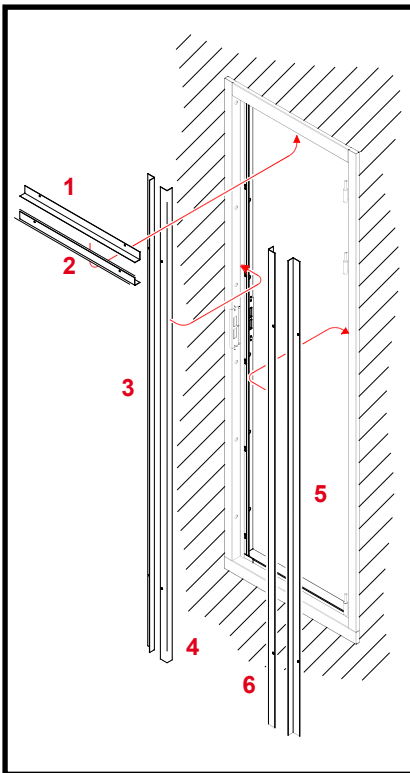


Image 12.

1. Tap the spacers of the frame into place. Use a soft plastic or rubber hammer.
Note the order of installation (1-6).
2. Firstly, attach the upper mouldings to the tabs of the frame's top profile. The perforated flange of the moulding attaches to the tabs of the frame. Center the length of the upper mouldings.
3. Starting from the top, install the vertical mouldings so that their upper edges are pressed against the upper moulding.



Attachment of tin threshold strips to the bottom profiles of the frames and assembly of protective plugs into the screw holes

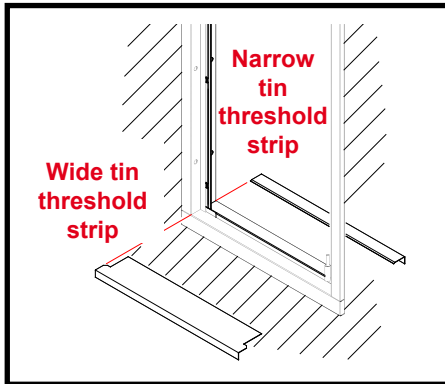


Image 13.

1. Remove the protective films from the adhesive tapes of the wide tin threshold strip.
2. Attach the wide tin strip to the bottom profiles of the frame.
Observe that the slots in the surface tin strip correspond to the form of the vertical profile of the frame!
3. Carefully press the surface tin strip into place.
4. Remove the protective film over the wide tin strip's surface.
5. Remove the protective films from the adhesive tapes of the narrow tin threshold strip. Add fire-approved adhesive paste to the inner surface and ends of the strip.
6. Attach the narrow strip to the bottom profile of the frame and to the wide tin threshold strip.
Take care not to damage the painted surface of the door frame when attaching the strips!
7. Remove the protective film over the surface of the narrow strip.

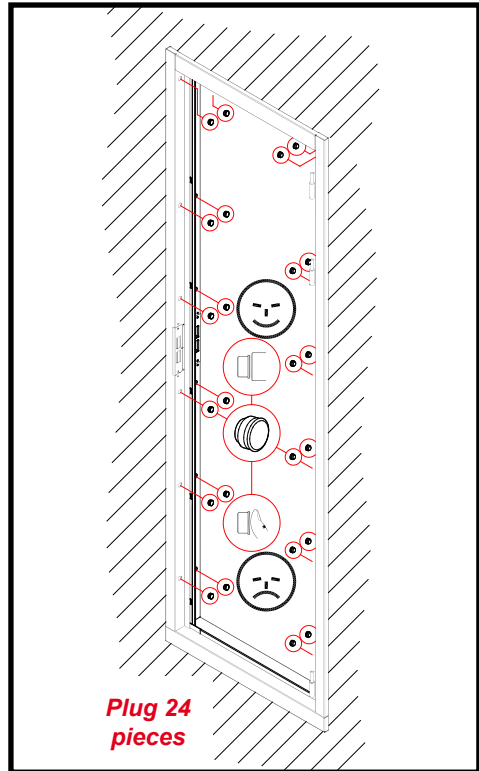


Image 14.

1. Install the 24 protective plugs into the screw holes in the vertical profiles of the frames.

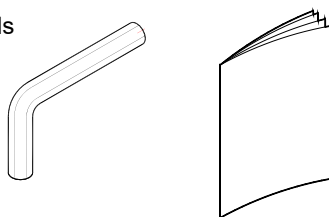
Install the plugs using a flat-headed tool (such as the handle of a screwdriver), NOT your thumb!



Pin supported hinge adjustment

Tools required for adjustment

Picture 15. Adjusting tools

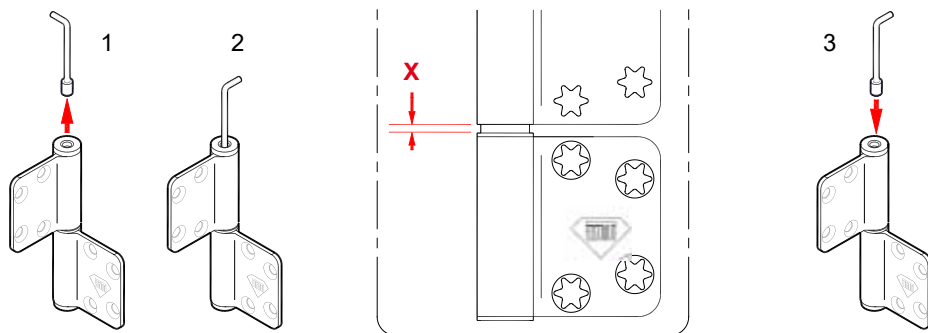


No adjustment plates are needed for the adjustment!

3 mm hex tool

Adjusting and refitting instructions of 2-D hinges

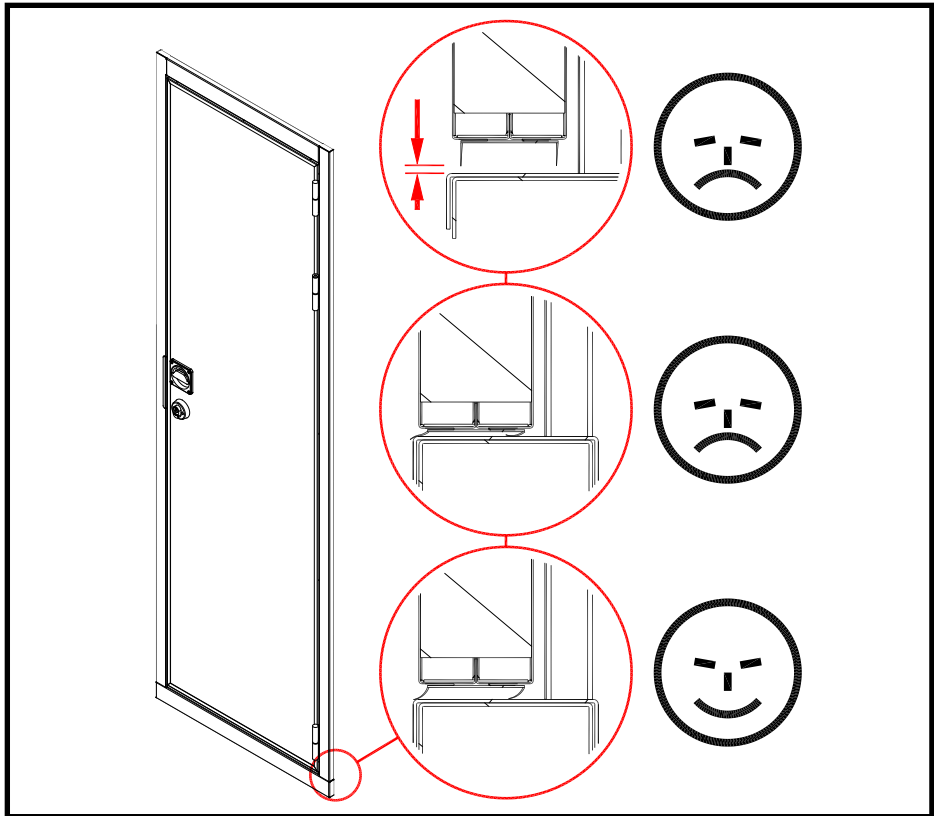
Adjusting of 2-D hinge



Picture 16.

1. Use an hex tool to remove the hinge locking screw.
2. Use the hinge adjusting screw to adjust a 2.2 - 6 mm space (X in the picture) between the upper and lower hinge parts.
Use the same hex tool.
3. Reinstall the hinge locking screw and ensure the adjustment by tightening the locking screw against the adjusting screw.
Check that the adjustment is not altered when the locking screw is tightened.

(continued on next page)



Picture 17.

(continued from previous page)

4. Check the adjustment of the hinge also in relation with the positioning of the bottom sealing.
 - Case 1 shown in the figure: the door is adjusted too high - the bottom sealing of the door does not touch the threshold.
 - Case 2 shown in the figure: the door is adjusted too low - the bottom sealing of the door collides with the threshold.
 - Case 3 shown in the figure: the door has the correct height - the first lip of the bottom sealing of the door touches the threshold, and the second lip rests on the corner of the threshold.



CLEANING INSTRUCTION

With cleaning of Antti Marine Doors instructions given in this manual should be followed.

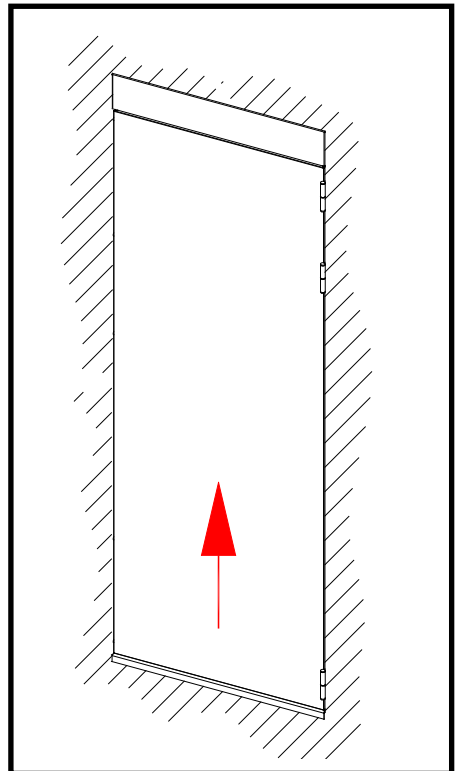
The cleaning instructions for special materials shall be transmitted separately.

General

Antti Marine doors are manufactured for normal use from materials that are durable and anticorrosive. Door structures are made of zinc coated steel and some parts (e.g. hinges) are made of stainless steel.

With cleaning of the door surfaces conventional cleaning methods and detergents can be used. Use of abrasive and corrosive methods and detergents (solvents) are not suggested. For cleaning should be used slightly moistured sweeping with soft cloth or equal.

With cleaning of the door surfaces it is advised to use direction from bottom to top. This is to avoid flow stains.





Different surfaces and coatings

Painted surfaces

Wipe with soft cloth or equal. Use of conventional cleaning detergents is advised. Solvents can be used only with limitations. Solvents should be tested firstly on small invisible test area.

Solvents might cause decline of gloss or softening of the surface, both cause cleaning problems in the future and surface is more sensitive for dirt. A surface with loss of gloss can be polished with polishing agent e.g. wax.

Pvc

Wipe with soft cloth or equal. Use of conventional cleaning detergents is advised. Solvents can be used only with limitations.

Solvents should be tested firstly on small invisible test area. Solvents might cause decline of gloss or softening of the surface. Pvc-surface can be polished with polishing agent. Detailed instructions from manufacturers of pvc-foils.

Laminates

Wipe with soft cloth or equal. Use of conventional cleaning detergents is advised. Solvents can be used only with some limitations.

Solvents should be tested firstly on small invisible test area. Solvents might cause decline of gloss or softening of the surface. Laminate surface can be polished with polishing agent suitable for laminate surfaces. Detailed instructions from manufacturers of laminates.

Stainless steel

Wipe with soft cloth or equal. Use of conventional cleaning detergents is advised. Solvents can be used.

It is especially noticed that stainless steel surface finishings (e.g. brushing) might change because of cleaning.



Special surfaces

For the special surfaces cleaning method and detergents must be requested separately.

As a general cleaning method wiping with slightly moistured soft cloth can be used. If needed light detergents can be used.



Manufacturer is not responsible for damages on surfaces, if instructions given in this manual are not followed.



Manufacturer's responsibility does not cover normal wear of surfaces nor changes because of exposure of time and/or light.

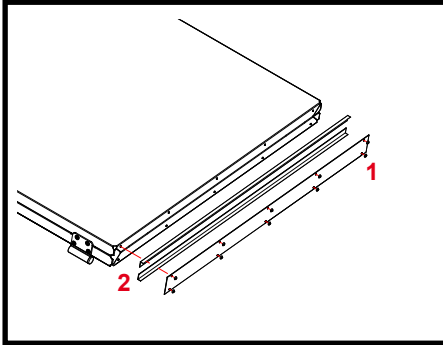


Use of rubbing cleaning substances are totally forbidden. They might cause scratches or wearing to cleanable surface.



MAINTENANCE INSTRUCTIONS

Replacing the bottom door sealings



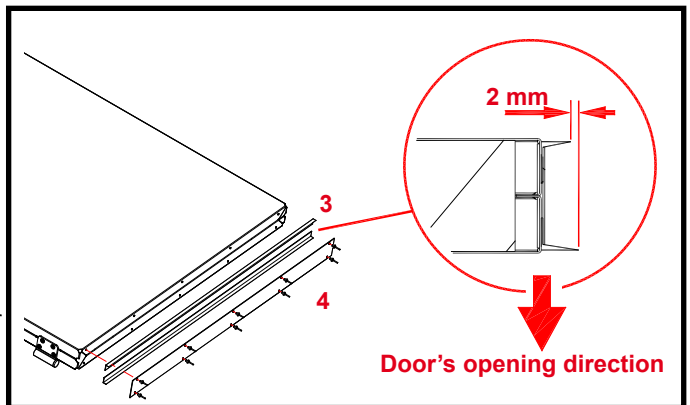
Lift the door off its hinges.

Place the door on a worktop. Ensure that the worktop surface does not scratch the door.

1. Undrill the blind rivets on the support moulding for the bottom sealing and remove the moulding.
2. Detach the sealing. Remove any glue residue from the surface of the door, using a plastic spatula if necessary. Clean grease and other dirt from the attaching surfaces of the new sealing.

Cut a piece of weather stripping 1-2 cm longer than the door width.

Detach the weather strips from each other.



3. Attach the stripping onto the door as shown in the picture.

Note the width difference of the sealing lips.

The wider lip must be placed on the side of the door's opening direction (lower sealing in the picture).

ATTENTION! Do not stretch the sealing.

4. Place the sealing support moulding into place. Position the rivet holes on the moulding and the door. Drill holes onto the sealing as well to prevent deformations of the sealing.

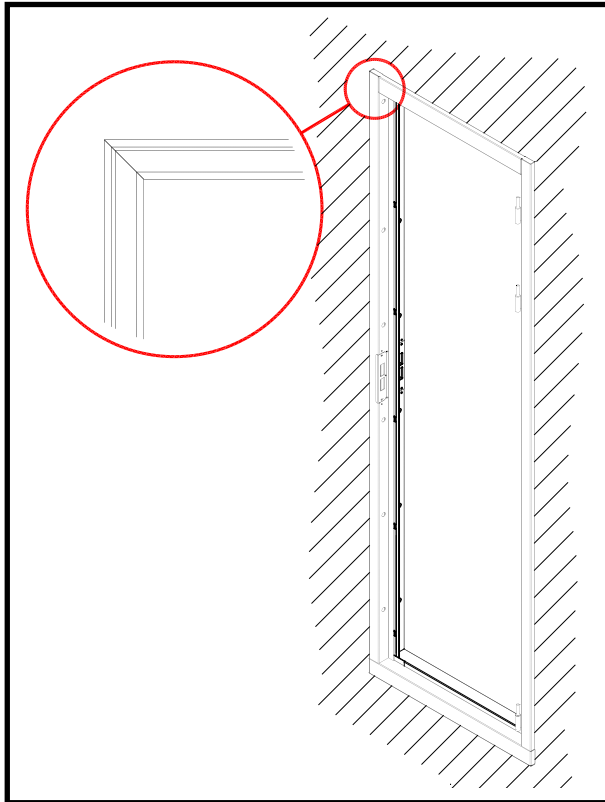
Attach the sealing support moulding using blind rivets.

Cut the sealing ends to their final length (approximately 2 mm longer than the width of the door on both sides).

Lift the door onto its hinges.



Replacing the vertical and upper sealing of the connecting doors



1. Remove the old sealing. Remove any possible glue residue from the frame, using a plastic spatula if necessary. Clean grease and other dirt from the connecting surfaces of the new sealing.

2. Installing the upper sealing

Cut a piece of weather stripping 1 - 2 cm longer than the width of the doorway. Pull the stripping off the other half.

Cut the other end of the sealing at an angle of 45°.

Attach the sealing onto the frame almost all the way, and cut the other end at an angle of 45° as well.

By so doing you will fit the sealing length closely onto the frame.

ATTENTION! Do not stretch the sealing. A stretched sealing will come off later at the ends.

3. Installing the vertical sealing

Cut a piece of weather stripping 1 - 2 cm longer than the height of the doorway. Pull the sealing off of each other.

Cut the ends of the sealing for the upper part of the doorway at an angle of 45°.

Attach the sealing onto the door frame almost all the way, starting at the top, and cut the lower ends of the sealing perpendicularly to fit the frame closely.



Recommended spare parts and quantities

See picture 7 on page 9

Item	Name 1	Name 2	Finish	Available	Pcs / door
HINGESET2DLM5	HINGESET 2D LEFT M5	Full set	Brushed stainless steel	In pieces	1 set / left handed door
HINGESET2DRM5	HINGESET 2D RIGHT M5	Full set	Brushed stainless steel	In pieces	1 setti / right handed door
119310	Bushing for hinges (included in the set)		Black	In pieces	3 pcs / door
DBTIIVHIGH	Gasket around the frame on three sides		Black	200 meter rolls	~5 m / door
115617	Sill gasket under the door leaf	2-parts 9x12+7x12	Black	125 meter rolls	~0,7 m / door

28-01-2022



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