

Work Instruction:

CAD Drawing Notes:

- Door frame head default thickness is 44mm
- Door frame head, screen frame head, door & screen jambs adjacent to structural opening to be structural opening depth wide unless extensions have been specified
- Screen sill, door & screen jambs abutting one another to be 100mm wide or minimum width specified by glass certificate, whichever is smaller

CNC Instructions:

- From the screen drawing referenced on the works order determine which door jamb requires drilling
- The top fixing point shall be maximum 75mm from the underside of the door frame head
- The bottom fixing point shall be maximum 75mm from the bottom of the door jamb
- Fixing centres shall not exceed maximum 250mm
- All fixings shall be at door thickness + 25mm (69mm for 44mm door leaves & 79mm for 54mm door leaves) from the opening face
- Use the calculator on the Technical Datasheet to calculate the quantity of holes to be drilled and their centres by adding the following information from the works order:
  1. Door height
  2. Threshold gap
  3. Door frame head thickness
  4. Head rebate
  5. Screen head thickness
  6. Screen sill thickness
- This information calculates the start position, number of holes & hole centres in both the door jamb and the associated screen jamb from the top of each
- From the screen drawing referenced on the works order determine which screen jamb requires drilling for fixings.
- Rebate 1 face centrally for 1nr 20 x 2mm Palusol Intumescent strip
- The top fixing point shall be maximum 140mm from the underside of the screen frame head
- The bottom fixing point shall be maximum 140mm from the top face of the frame sill

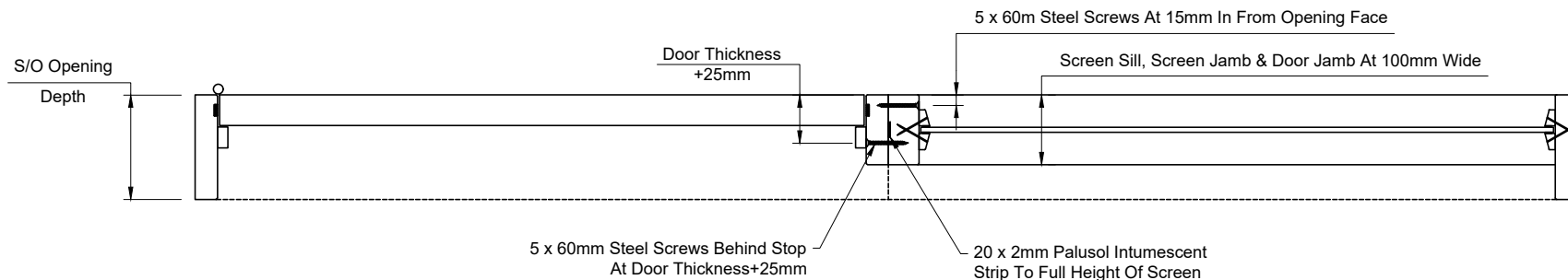
Work Instruction cont'd:

CNC Instructions cont'd:

- Fixing centres shall not exceed maximum 250mm
- All fixings shall be at 15mm in from the opening face
- Rebate for the sill & drill for fixings using the start position, spacings & quantities calculated previously

Assembly Instructions:

- Assemble the doorset to the requirements set out in the relevant works order
- Ensure door gaps are correct & that the door latches & releases correctly
- Securely fit a brace to the bottom of the door frame jambs
- Remove the door leaf & set aside for packing
- Assemble the screen frame as per works order requirements
- Check the drilled screen jamb is rebated for a 20 x 2mm Palusol intumescent
- Extend the rebate from the screen jamb through the frame head
- Fit 1nr full height 20 x 2mm Palusol intumescent strip
- Offer up the assembled door frame to the assembled screen frame
- Ensuring the push & pull faces are flush pilot drill through the top fixing point of the door frame & loosely insert 1nr 5 x 60mm steel screw
- Ensuring the push & pull faces are flush, pilot drill the bottom fixing point & fix with 1nr 5 x 60mm steel screw
- Pilot drill & fix the remaining fixing holes ensuring the joint between the door frame & screen frame is tight without gaps
- If the glass & bead position shown on the screen drawing are such that the fixings are exposed, pellet the fixings as required
- Where the glazing bead is positioned to cover the fixing screws pelleting is NOT required
- Glaze the screen to the specification noted on the relevant drawing



All Dimensions Are In mm Unless Stated

Do Not Scale.

If In Doubt Ask!

Description: **Doorpac - Modular Screen Assembly Instructions - FD30 & FD60**

Drawn By: **P.Brash**

Approved: **Approved**

Revision:

Cert / FoA Ref:

Date: **29/05/2026**

Drawing No:

Size: **See Above**

Tolerance: **+/- 0.25mm**

**CF5228**

Fire Rating:

**DP25083**

Job No:

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**CF5229**

**FD30S / FD60S**

Rev00

