



TRU-FRAME®
A name you can build on.



Series 7500

Fabrication & Assembly Instructions (For Surface Mount K.D. Kits)



IMPORTANT:
REVIEW ALL INSTRUCTIONS
THOROUGHLY
BEFORE STARTING STEP 1

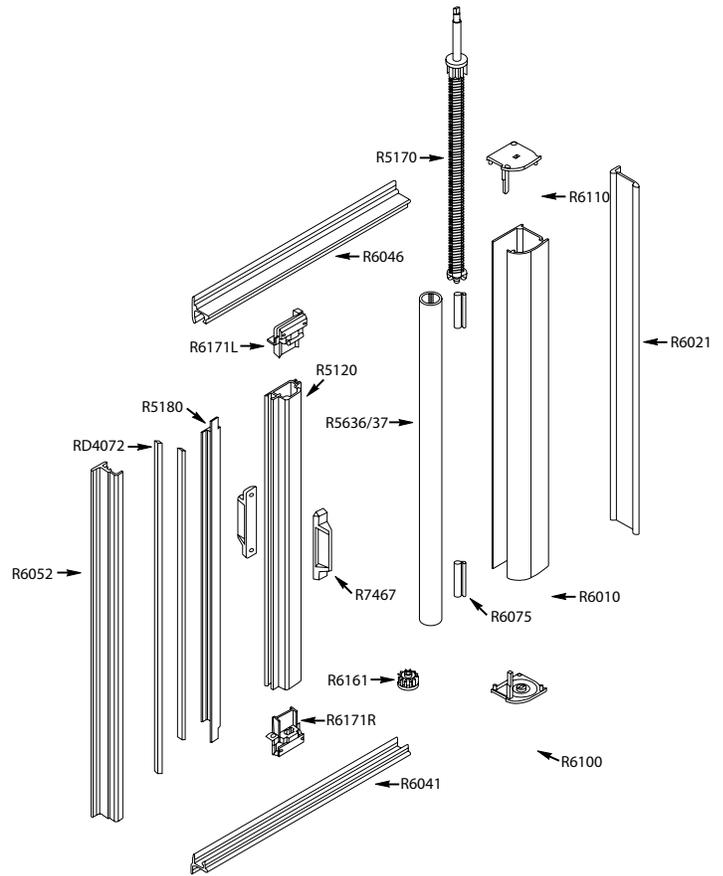
TOOLS REQUIRED:

- Tape Measure
- Hack or Chop Saw
- Drill Motor
- 1/8" Drill Bit
- 13/64" Drill Bit
- Phillips Head Screwdriver
- Pencil or Scriber
- File

Series 7500 Surface Mount Parts List

R5120##	Drawbar
R5636MF	Tube with Screen 82"
R5637MF	Tube with Screen 96"
R5170	Spring Roller Assembly
R5180##	Astragal
R6052##	Surface Mount Closer Jamb
R6010##	Housing
R6021##	Surface Mount Closer Jamb
R6041##	Sill Track
R6046##	Head Track
R6075BL/WH	PVC Cushion
R6110BL/WH	Housing End Cap - LH
R6100BL/WH	Housing End Cap - RH
R6161BL/WH	Bushing with Pin
R6171(BL/WH)L	Drawbar End Cap Assembly - LH
R6171(BL/WH)R	Drawbar End Cap Assembly - RH
R7467BL/WH	Pull Handle
RD4072	Magnet

- Door color





TRU-FRAME®
A name you can build on.

Step 1 Examine Door Opening Condition

This door system requires a flush surface the entire perimeter of the opening in order to properly install. To clear the opening, the flush surface must be at least 2-1/2" at the jamb the housing will be installed on, at least 9/16" at the jamb the closer will be installed on, and at least 1-1/8" at the head and sill.

Record measurements below.

Width: _____ X Height: _____

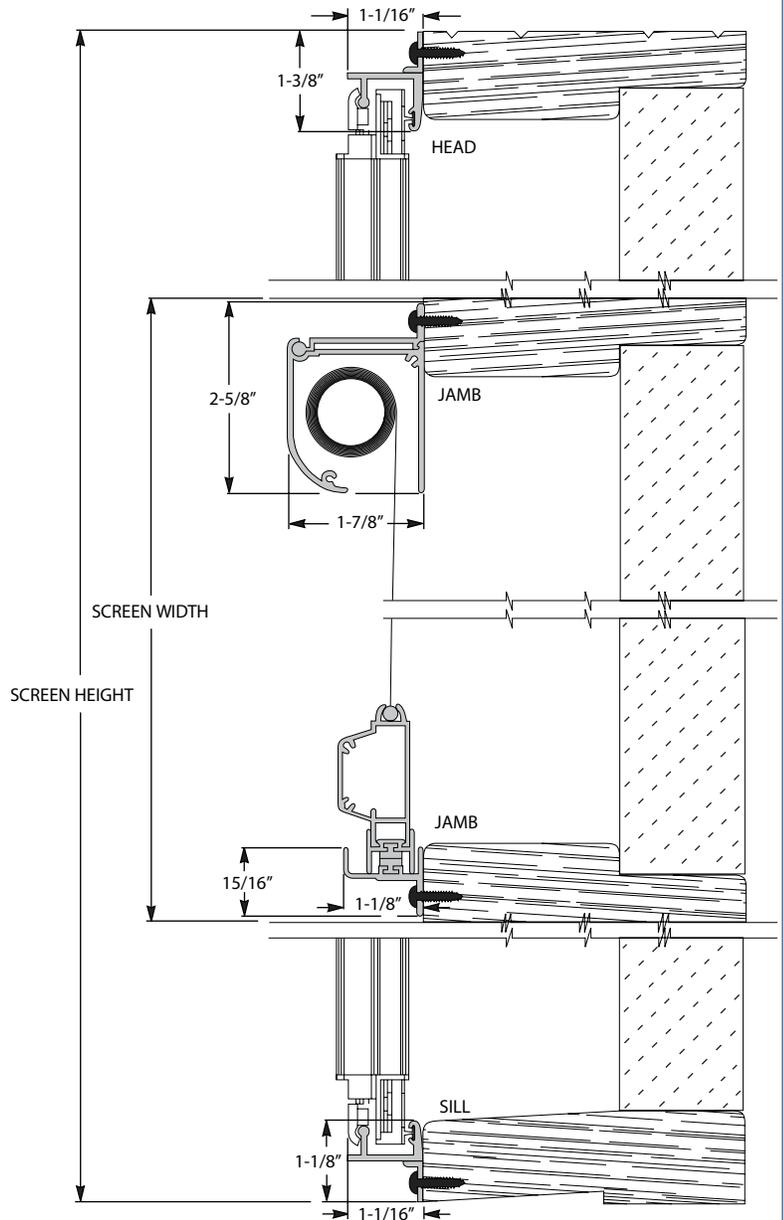
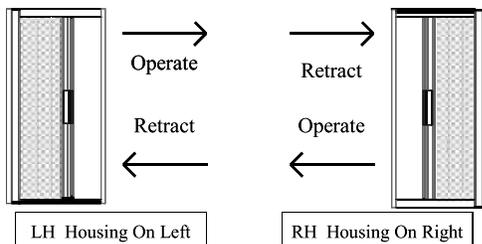
Note:

The dimensions for a Surface Mount Door are derived from the details in this section. Measuring by these dimensions will provide a door that will fit your opening.

Step 2 Determine the Proper Side of Opening to Install Door

For a normal installation the Roll-Away® Door will be installed on the same side as the hinges on the main door. Will the door operate from Right to Left, or Left to Right?
Note: French door installations have 1 each (1 Left to Right and 1 Right to Left).

LH Door will operate from Left to Right
RH Door will operate from Right to Left





TRU-FRAME®
A name you can build on.

Step 3

Determine Clearance Required For Normal Operation

In order to assure the Roll-Away® door's operation doesn't interfere with the prime/main doors operation, you must allow proper clearance between the two. The prime/main doors handle set normally determines the minimum amount of clearance required. A straightedge held across the opening where the door will be installed will indicate clearance. Do you have room between the straightedge and the main door handle set, or any other door hardware?

Yes, there is enough clearance to install all parts for normal operation. Proceed to Step 4.

NO, there is not enough room for normal operation. *Contact the factory before cutting any parts or proceeding further.*

Step 4

Screen Tube Fabrication

Note:
These fabrication instructions create a door that extends vertically beyond the opening 1 1/8" on a side, 2 1/2" on the housing side, and 9/16" on the closer side.

Carefully remove all the Roll-Away® Series 7500 screen door parts from the carton and place on a flat table or bench. You will need the following parts to complete step 4: #R5630.

The Screen Tube Assembly (#R5630) is poly-wrapped on each end and is ready to cut to size. Locate the tube end with the Red tape and cut exactly 1 11/16" less than the screen height (Step 1). Tube is easiest to cut with wrapping and tape intact (Remove in Step 6).

Example:
Screen Height = 80" (Step 1). Cut the "Red" end of the tube until the overall length = 78 5/16".

Step 5

Hinge, Housing, Drawbar & Astragal Fabrication

Locate the Hinge (#R6021). Cut the Hinge exactly 1 1/8" less than the screen height (Step 1).

Example:
Screen height (Step 1) minus 1 1/8". If the Screen height is 80", then cut the hinge at 78 7/8".

Locate the Housing (#R6010). Cut the Housing exactly 1 3/8" less than the screen height of (Step 1).

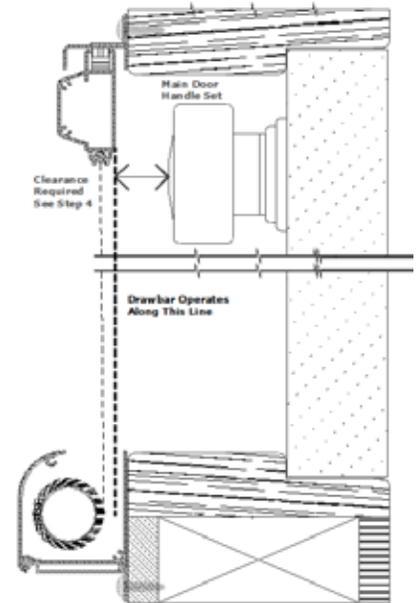
Example:
Screen height (Step 1) minus 1 3/8". If Door height is 80", then cut the housing at 78 5/8".

Locate the Drawbar (#R5120). Remove the Astragal (#5180). Cut the drawbar exactly 3 9/16" less than the screen height (Step 1).

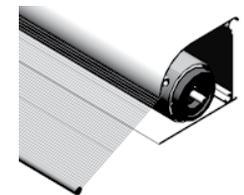
Example: Screen height (Step 1) minus 3 9/16". If the screen height is 80" then cut the drawbar at 76 7/16".

Locate the Astragal. Cut the Astragal exactly 1 11/16" less than the screen height (Step 1). Notch cut end of Astragal to match machined end.

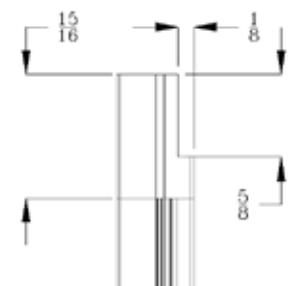
Example: Screen height (Step 1) minus 1 11/16". If Screen height is 80", then cut the Astragal at 79 5/16".



CORRECT Screen Placement In Housing



WRONG Screen Placement In Housing



Astragal (#R5180) Notching Dimensions



TRU-FRAME®
A name you can build on.

NOTE: MAKE SURE ALL CUTS ARE SMOOTH AND FREE FROM BURRS

Step 6

Door Unit Assembly

A. Insert the spring (#R5170) into the **CUT** end of the screen tube from Step 4. It may be necessary to trim 1/32" from the thick fingers on the spring end to allow ease of insertion and proper operation (Figure 7). Make sure that the spring is firmly seated before proceeding. Lightly tap end cap (#R6110) onto top of spring in notch provided (Figure 8). Regardless of operation, spring must be installed in the end shown in figure 8.

B. Insert the tube bushing (#R6160) into the opposite end of the screen tube.

C. Remove all packaging materials and labels from the screen tube assembly.

D. Carefully insert the screen tube into the housing. Make sure that the screen will roll out in the proper direction (Step 5). **DO NOT PULL ON SCREEN.** Insert the hinge into the housing.

E. Thread spline end of screen onto the drawbar. Spline should overhang each end of drawbar equally.

F. Insert top and bottom guides (#R6171L & #R6171R) into ends of drawbar. Push remaining lengths of spline into notch on guides at either end of drawbar.

G. Be sure that the Drawbar guides are firmly in place. Insert two #6 x 3/8" pan-head screw through the holes in the drawbar guides. These screws will hold drawbar guides firmly in place. Fasten securely.

H. Tension the spring by rotating end cap in the direction that puts tension on the screen (clockwise). (See figure 8) Rotate the cap 5 times. It is recommended that you rotate the cap several times and release it to take out any slack in the spring or screen mesh prior to the final rotations. This will bring the drawbar handle taut against the housing and provide the optimum tension on the screen. Holding the wound cap firmly, insert the cap and fasten to the housing using two (2) #6 x 3/8" flat head screws provided.

I. Insert bearing pin into bushing, then screw bottom cap onto opposite end of housing. Make sure the bearing pin is properly seated in the bottom end cap and fasten with two (2) 3/8" flat head screws provided.

J. Test the tension of the screen by grasping the housing at the mid-point with one hand, and the drawbar in the other, and slowly operate the screen. The screen should unroll evenly, with no binding. Operate the screen several times to fully seat the screen fabric. It may be necessary at this point to add an extra wind to the spring, to take up any slack that may have appeared during seating.

K. Move the cushions to their respective positions on the housing face. The housing end caps are equipped with posts, notched to set the cushion height. (Figure 9.) While the cushions will remain in place in normal operation, it is recommended to apply a couple of drops of cyanoacrylate adhesive between the cushion and the outside of the housing to prevent accidental dislodgement.

L. The handle set can be positioned as desired (Figure 10.) Set the inside handle in the desired location on the drawbar, insuring clearance for the main door handle/knob, and with a felt tip pen, mark the screw hole locations. Using a 1/8" drill bit, drill two holes and secure the handle to the drawbar using #8 x 3/4 flat head screws. Repeat for the outside handle.

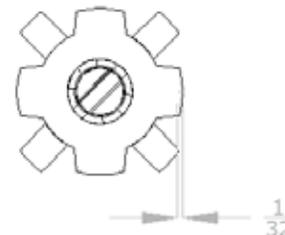


Figure 7

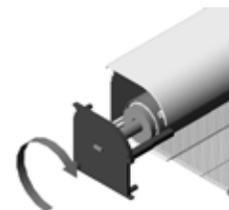


Figure 8



Figure 9

Housing cut away for clarity. The cushion is positioned against the notch in the end cap post



Figure 10

Handle Assembly
(from left to right):

Inside handle
Latch
Exterior Inside Slide
Exterior Handle

ASSEMBLY COMPLETE
PROCEED TO STEP 1 OF INSTALLATION INSTRUCTIONS