

Door and hatch installation SO-1, SO-1S, HS-1 and HS-1S	1
--	---

INSTALLATION INSTRUCTIONS

Civil Defense Products

JTK POWER OY

Metalli-Jokela

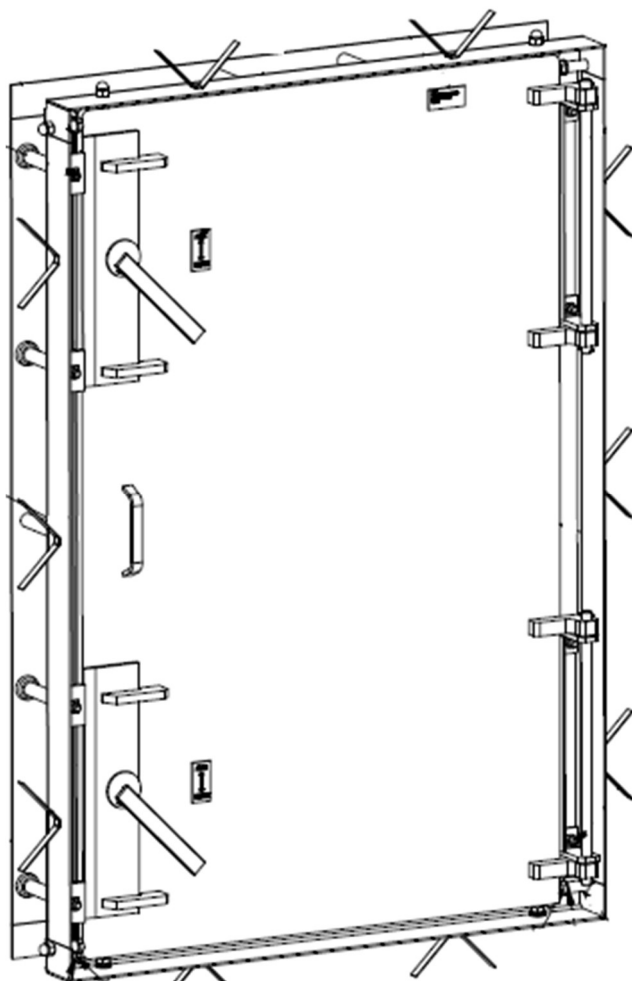
Teollisuustie 6

FI-66600 Vöyri

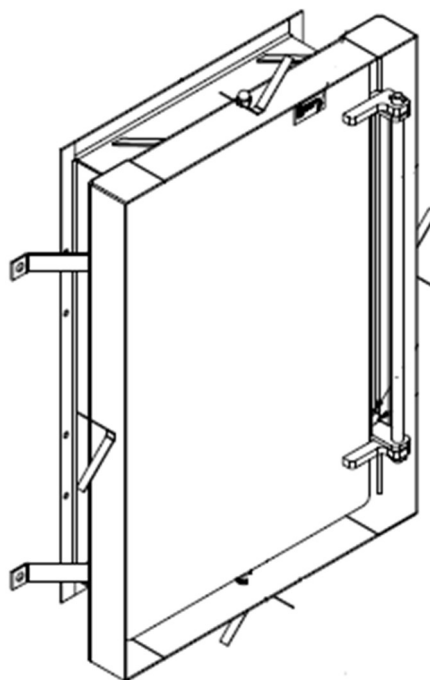
safety@jtk-power.comwww.jtk-power-group.com

Door and hatch installation SO-1, SO-1S, HS-1 and HS-1S2

SO-1 and SO-1S C-1790-07



HS-1 and HS-1S C-1792-07



Content

Before installation needed actions:	3
Actions during installation:	3
Actions after casting:	3
Bolt tightening torque:	4
Seal instalation:	4
Door maintenance:	5

JTK POWER OY

Metalli-Jokela
Teollisuustie 6
FI-66600 Vöyri

safety@jtk-power.com
www.jtk-power-group.com



**Door and hatch installation
SO-1, SO-1S, HS-1 and HS-1S3****Before installation needed actions:**

1. Check that the handedness of the product corresponds to the structural plans.
2. Check the opening direction of the product. The door opens outwards from the shelter, and the hatch opens inwards into the shelter.
3. Check that the reinforcement instructions for the product are available.

Actions during installation:

1. Reinforce according to the instructions
2. Support the product on the reinforcement at the hinges and latches, both vertically and horizontally.
3. Make sure that the latches are in the CLOSED position during pouring.
4. Protect the door leaf during pouring.

Actions after casting:

1. Remove the support pieces between the door leaf and the frame
2. Check the function of the latches and the door closing and opening
3. Tighten the screws of the hinge and latches to the torque specified in the instructions.
4. Paint the door with topcoat.
5. The doors must be painted to corrosion resistance class C2 and the hatches to C3 (EN ISO12944)
 - a. The door has a primer (Tikkurila Temaprime 60-80 µm)
 - b. The door can be painted overCan be painted with commonly used types of corrosion resistance paint. A suitable combination is, for example:
 - i. TEMAPRIME EUR 80 µm +TEMALAC FD 50 40 µm =>Total 120 µm
 - ii. This meets the requirements C2-M and C3-L
6. Install the seal according to the instructions.

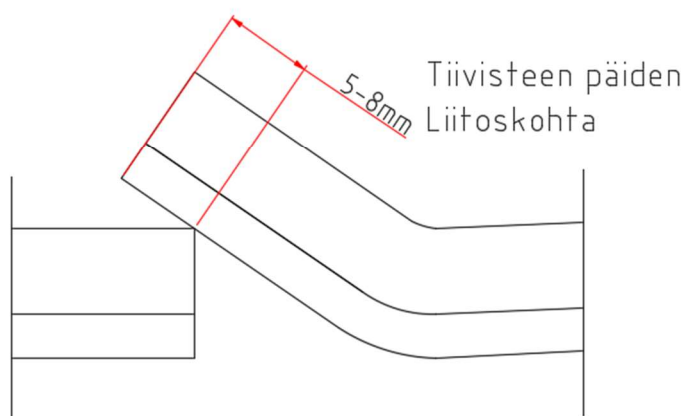
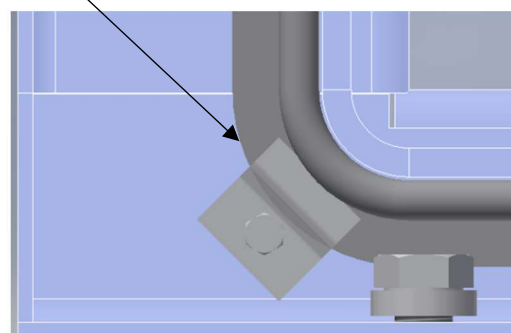
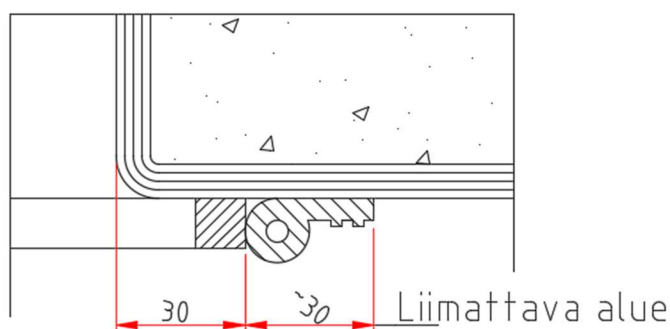
**Door and hatch installation
SO-1, SO-1S, HS-1 and HS-1S4****Bolt tightening torque**

Bolt size	Torque (Nm)
M16 8.8	130
M20 8.8	250

Seal instalation

1. Remove/loosen the seal clips at the corners of the door.
2. Measure the correct length of the seal.
3. Apply the glue according to the glue manufacturer's instructions. The glue used can be a universal contact glue and different brands can be used.
4. Do not stretch the seal but press it into place so that its shape is maintained. The height of the seal must be approx. 14 mm.
5. At the junction of the beginning and end of the seal, the seal can extend 5-8 mm, in which case the ends of the seal are pressed together, and the connection point is pressed down.
6. Finally, tighten the seal clip in place.

Corner seal clamp

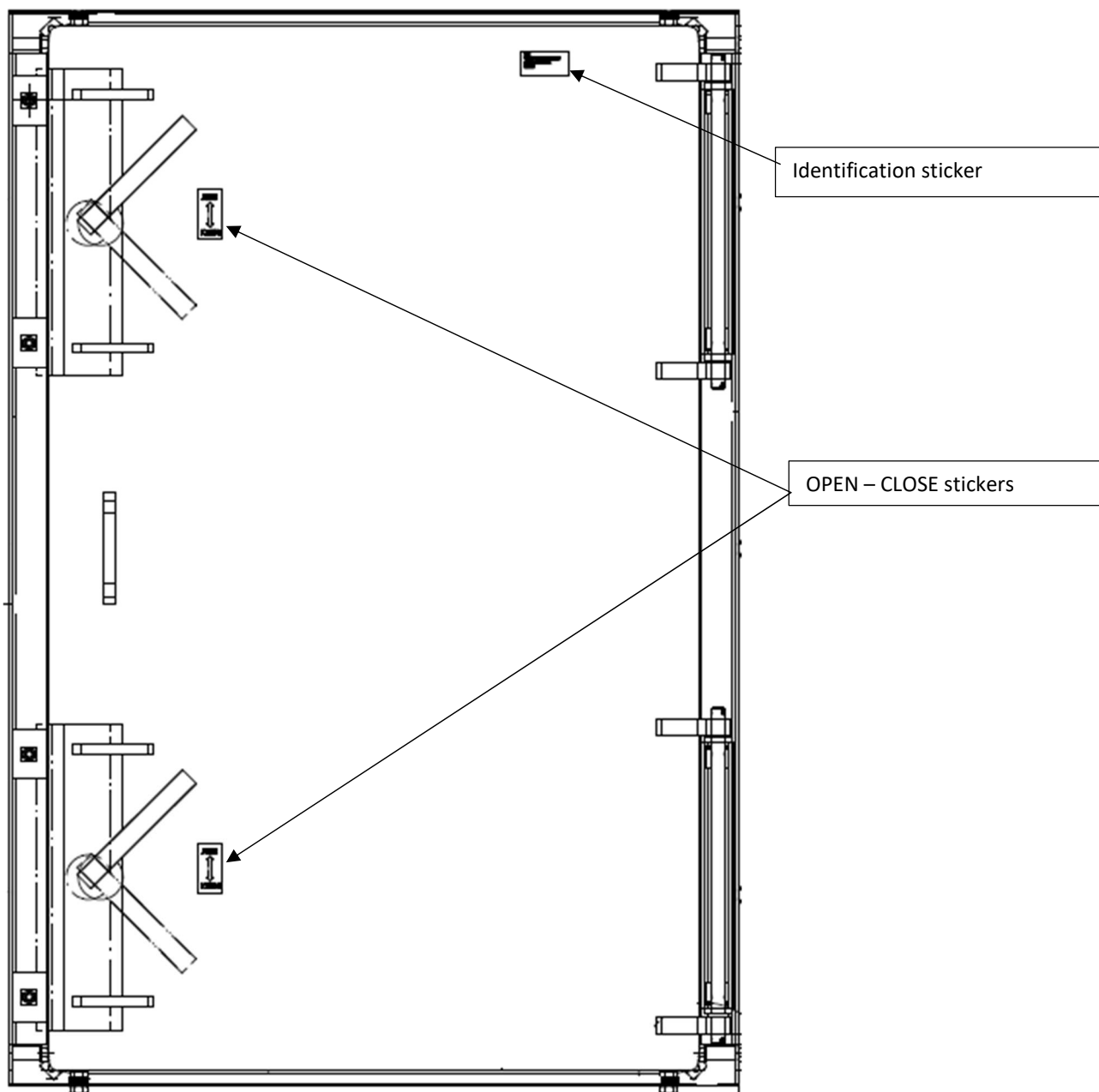


Door and hatch installation SO-1, SO-1S, HS-1 and HS-1S5

Door maintenance

The space between the door and hatch hinge shaft and lugs must be lubricated approximately every 12 months. The oil can be, for example, chain oil or a similar product.

During maintenance, it can be checked that the product labels are in place.



JTK POWER OY

Metalli-Jokela
Teollisuustie 6
FI-66600 Vöyri

safety@jtk-power.com
www.jtk-power-group.com

ISO 9001
ISO 14001
BUREAU VERITAS
Certification

