



Aluminium rear door set



ALUMINIUM REAR DOOR SET

GENERAL INFORMATION

PRESENTATION OF THE PRODUCT

The **MAGNA** rear door has many innovative elements, from a design point of view, that make it almost unique compared to traditional doors.

Its main characteristics are functionality, versatility, high resistance, structural rigidity and excellent watertight seal, together with its light weight, a typical characteristic of aluminium, and its easy of assembly, deriving from the fact that it is supplied in an **assembly KIT**.

This design philosophy has led to the realisation of the **MAGNA** door with three vertical elements per wing, which are easily assembled with two horizontal caps, one at the top and one at the bottom, eliminating the use of the frame and giving the door, also from an aesthetic point of view, an entirely new look.

The coupling between the contours was designed so that there is a slight curving radius in order to favour, in the case of painwork, the penetration of a greater quantity of paint, so as to avoid the formation of bubbles and breaks in the layer of paint.

It is necessary to point out that the lack of frames with 45° joints makes it possible to reduce door height adaptation operations to the simple trimming of the contours, without intervening on the caps.

One of the peculiarities of the **MAGNA** door is the possibility, during the assembly phase, of using the external panel alone as a template for welding the hinges to the joint angles; this operation is significantly simplified by having to move a single panel (only about 15 kg) instead of the entire door.

MAGNA has the possibility of being assembled by welding suitable hinges on any steel stanchion, or on special hinges in aluminium, to be riveted to the steel joint angle.

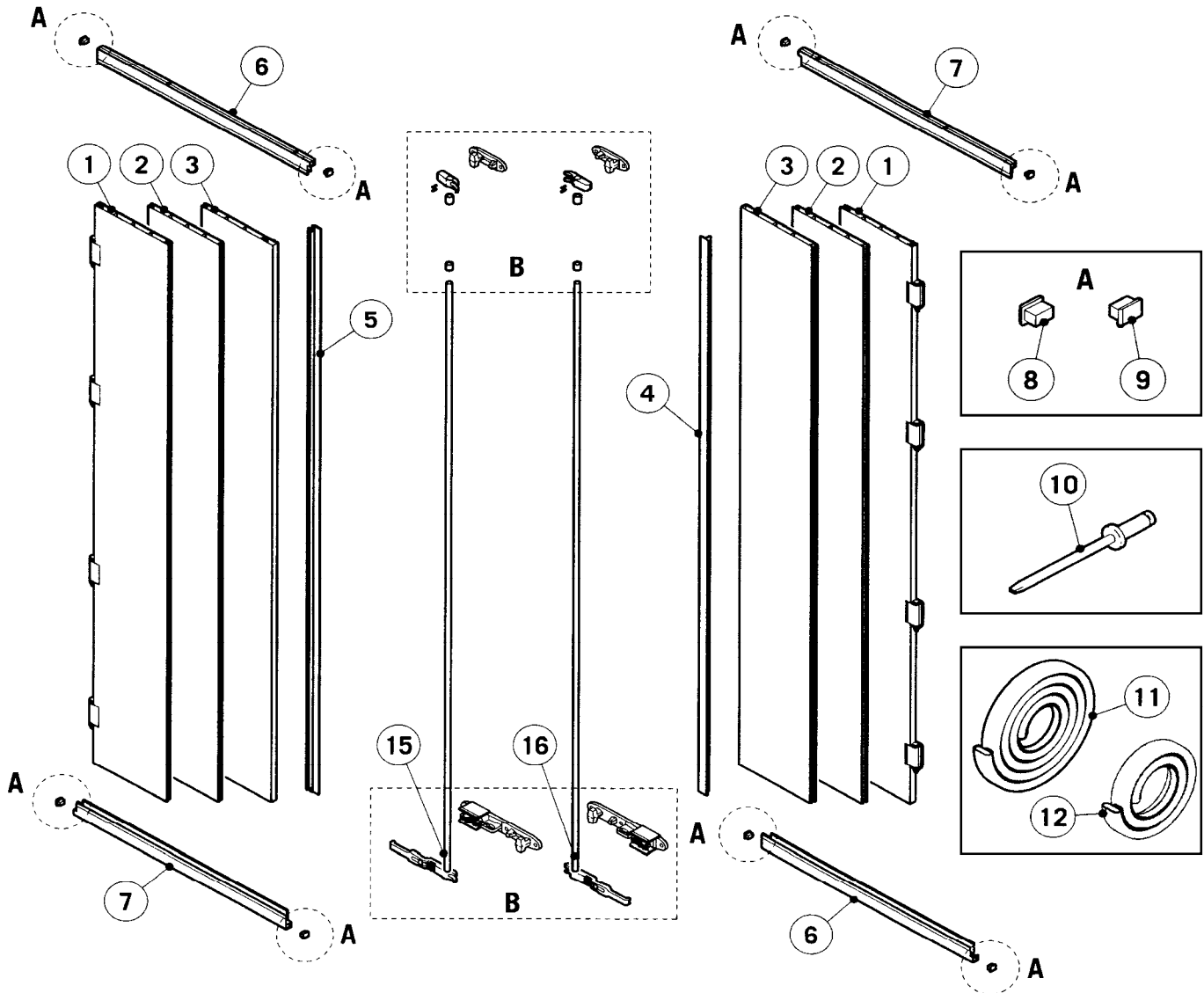
A further element of versatility is supplied by the central contours, which were designed by providing for a seat for the possible insertion of a double-lock.

The assembly KIT contains all the necessary elements for rapid assembly of the door without the need to add any components. This KIT is significantly limited in terms of volume and weight (about 115 kg for the largest size), offering significant advantages during both the transport and warehouse storage phases. The KIT also contains easy assembly instructions that make commissioning even more intuitive and quick.

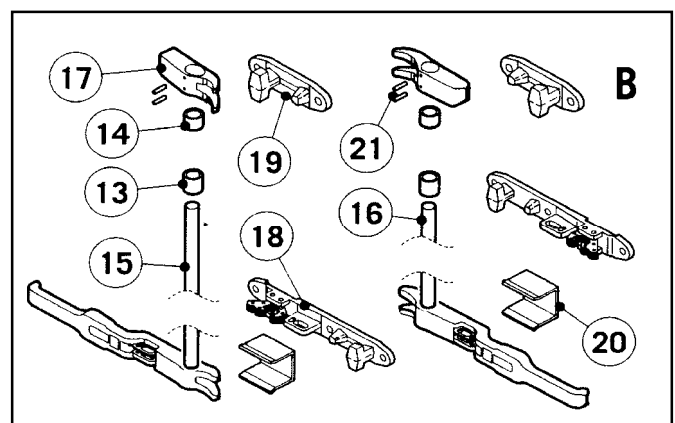
AVAILABLE VERSIONS

The KIT is available in 6 different versions, based on the height. The door can be used in the version in which it is supplied (**in bold** in the table), that is to say without the need to make any structural modifications. If necessary, it is still possible to reduce the length of the door: the minimum length to which the door can be reduced is indicated *in italics*.

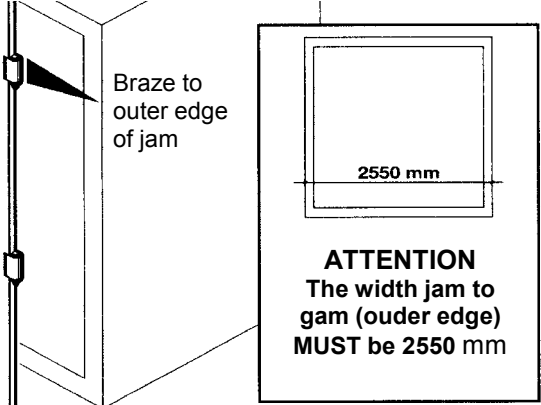
KIT Code	KIT Height (port)	Height reducible to	Door height
5103-2224-4	2400mm	<i>2200mm</i>	2446mm
5103-2325-4	2500mm	<i>2300mm</i>	2546mm
5103-2426-4	2600mm	<i>2400mm</i>	2646mm
5103-2527-4	2700mm	<i>2500mm</i>	2746mm
5103-2628-4	2800mm	<i>2600mm</i>	2846mm
5103-2830-4	3000mm	<i>2800mm</i>	3046mm



1. Pre-assembled external panel (2 items)
2. Intermediate panel (2 items)
3. Internal panel (2 items)
4. Front flange for right pane (1 item)
5. Rear flange for left pane (1 item)
6. Left top rail and right crosspieces bottom rail (2 items)
7. Right top rail and left crosspieces bottom rail (2 items)
8. Rubber left plugs (4 items)
9. Rubber right plugs (4 items)
10. Stainless steel 6.4*12 rip rivets (74 items)
11. Seal (12.5 metre roll)
12. Grey seal strip (3 metre roll)
13. Long roundels 25 mm in height (2 items)
14. Short roundels - height 19 mm (2 items)
15. Ø18mm round bar for shot bolt + left handle (1 items)
16. Ø18mm round bar for shot bolt + reight handle (1 item)



17. Twin slide hooks (2 items)
18. Lower hook plate (2 items)
19. Upper hook plate (2 items)
20. Protection plates (2 items)
21. Elastic plugs 5*30 (4 items)



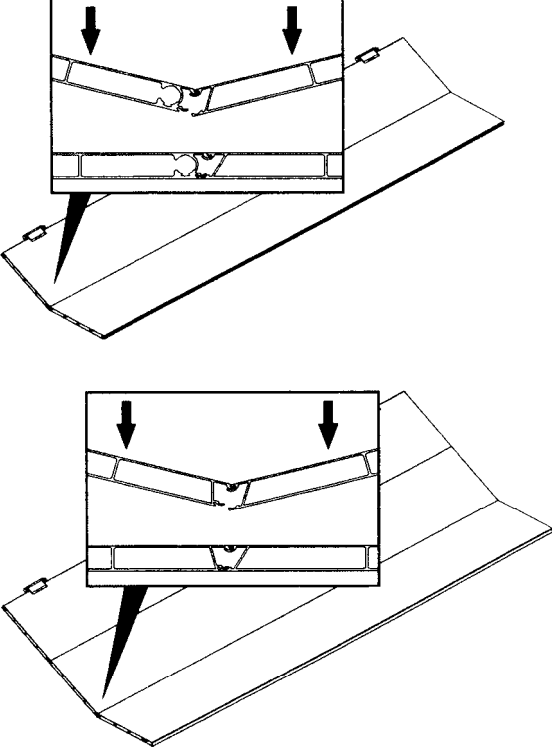
Braze to outer edge of jam

2550 mm

ATTENTION
The width jam to gam (ouder edge) **MUST** be 2550 mm

All the components required to fit the doors are included in the KIT. The elastic beading for closure are also included (if you prefer beading the closure instead o brazing). To drill we recommend a d=6.5 tip for the d=6.4 rivets and d=5 for the d=4.8. The glue to attach the seals is NOT included (we recommend LOXEAL Istant 43 S glue).

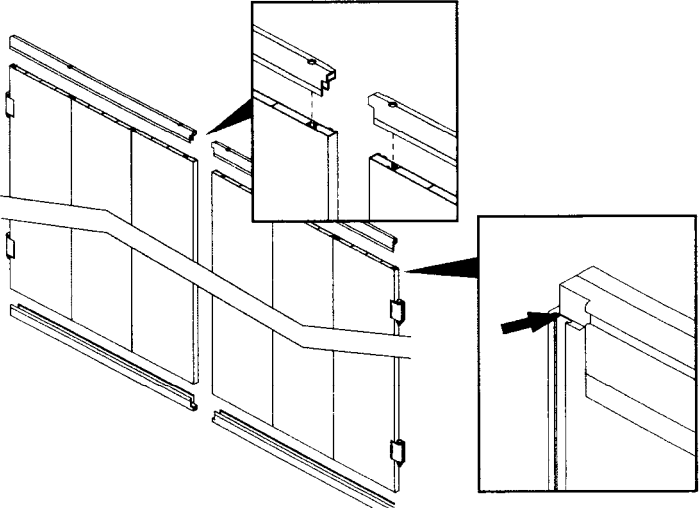
1 Move the panels matching the clip in mounts.
Press both panels until the clip in mounts close.



CENTRAL PANEL

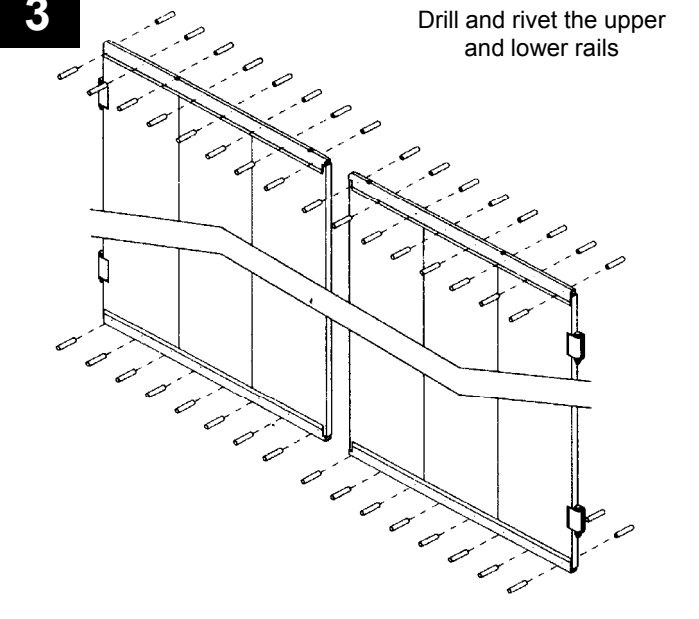
The central panel is slightly shorter (1 mm) than the outer panels to avoid interference during fitting the top and bottom rails. It is, therefore necessary to ensure that it does not extend on either extremity

2 Check that the holes drilled in the rails coincide with the site for the closure beads



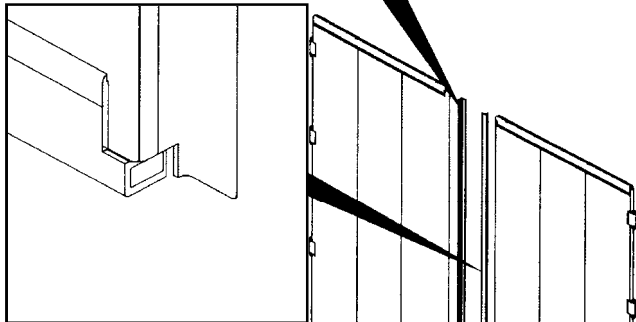
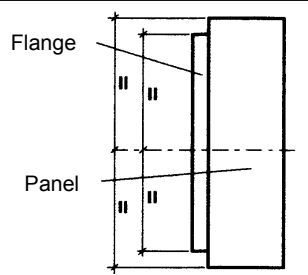
Also check that the seal clip sites are on the same side

3 Drill and rivet the upper and lower rails

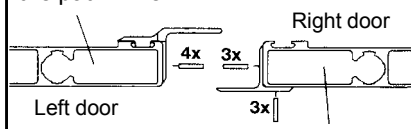


4

The front flange is 10 mm shorter than the panel: during fitting, ensure that it is vertically centred with the panel on the right door



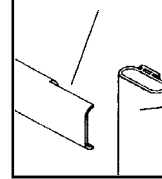
Fit the rear flange with 4 rivets on the part in view



Fit the front flange with 3 rivets both on the part in view and the part not in view (1 at the centre and 2 at

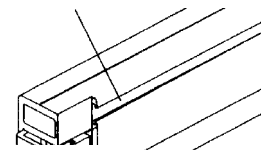
5

Shape the horizontal seals as indicated



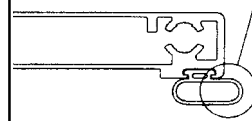
After insertion glue the shaped part

Insert the seals from the 12.5 metre roll into the external channelling

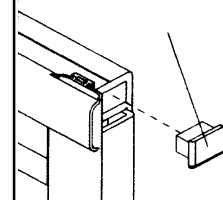


Insert the grey seal from the 3 metre roll into the channelling on the right door

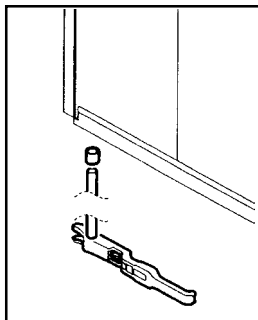
The seals must be inserted with the "wider" part to the outside



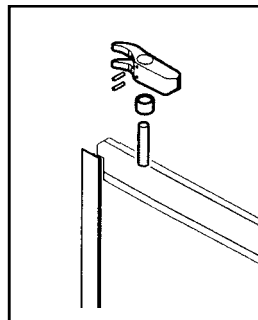
Apply the pugs to the rails



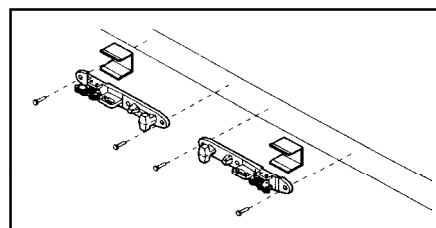
6



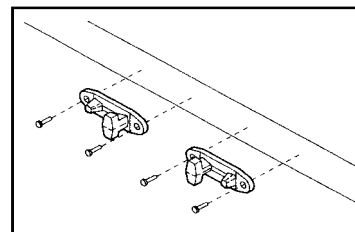
Insert the d=18 mm plugs (complete with handles) remembering to interpose the long roundels 25 mm)



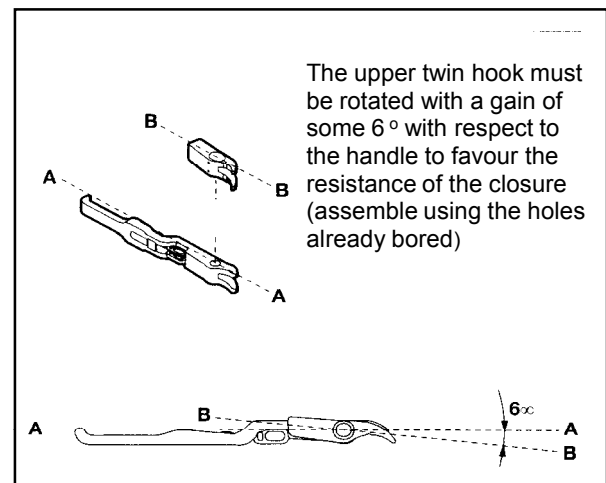
Mount the twin hooks interposing the short roundels (19 mm). Fix the hooks with elastic plugs.



Fix the lower hook plates interposing the protective plates (the hook plates is shaped to avoid the washer)



Fix the upper hook plates to the frame



The upper twin hook must be rotated with a gain of some 6° with respect to the handle to favour the resistance of the closure (assemble using the holes already bored)

Pos.	Description	Notes	Material
1	Upper left/lower right head-piece		AL/AN
2	Upper right/lower left head-piece		AL/AN
3	External ledge contour 2990 mm	1	AL/AN
4	Internal ledge contour		AL/AN
5	Ledge seal 3000 mm		EPDM
6	External contour left/right wing	2	AL/AN
7	Central contour left/right wing		AL/AN
8	Internal contour left/right wing		AL/AN
9	Door cotour/crop end seal 12 m		EPDM
10	Door contours seal/60 m roll		EPDM
11	Upper hook KIT	3	AC/DACR
12	Lower hook KIT	4	AC/DACR
13	Closing handle		AC/DACR
14	Drilled rod iron d=18 mm		AC/GR
15	KIT - n° 4 "8"hinges	5	AL/AN
16	KIT - n° 4 hinges pivots to be welded	6	AC
17	KIT - n° 4 hinges pivots to be welded		AC/INOX

- Note 1 - Cut to size under installer's responsibility
- Note 2 - We always suggest to check the measure "L" between the hinges and provide to order the proper profiles.
- Note 3 - Hook + holder
- Note 4 - Hook + guard
- Note 5 - 4 hinges + 8 springs + 16 ferrules + 8 pegs
- Note 6 - 8 trastes + 8 pins + 8 screw nuts

