

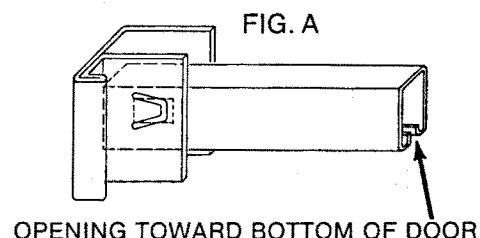
# INSTRUCTIONS FOR ASSEMBLING NO. 6020 TAB-LOC™ STEEL DOOR FRAME SYSTEM WITH SELF-FLASHING WHITE VERTICALS



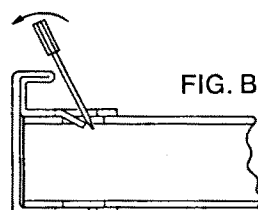
1. **Important!** Check opening size and door size prior to assembling. If vertical members need to be shortened, it must be done at this time. Verticals may be shortened in 1½" increments up to a total of 1'-0".

NOTE: Before cutting, the two verticals must be laid out with the channels for the laterals facing each other, just as they will be when the frame is assembled. The cutting to size is then done on the bottom of both or the top of both. Do not cut the bottom of one vertical and the top of the other or the tabs will not line up.

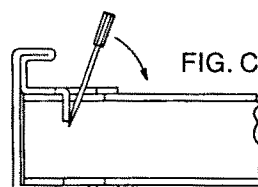
2. Select level assembly site with clearance to turn door over and lay out members as in Figure E.
3. Align vertical tabs over lateral member cut-outs as shown in Figure A with open channel of laterals toward bottom of door.



4. **Important!** With laterals and verticals in place, bend tabs for loose assembly as shown in Figure B.

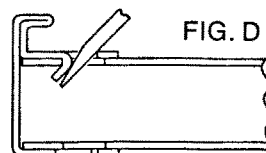


5. After loose assembly has been completed, bend tabs to tight position as shown in Figure C working from center lateral toward top and bottom of door.

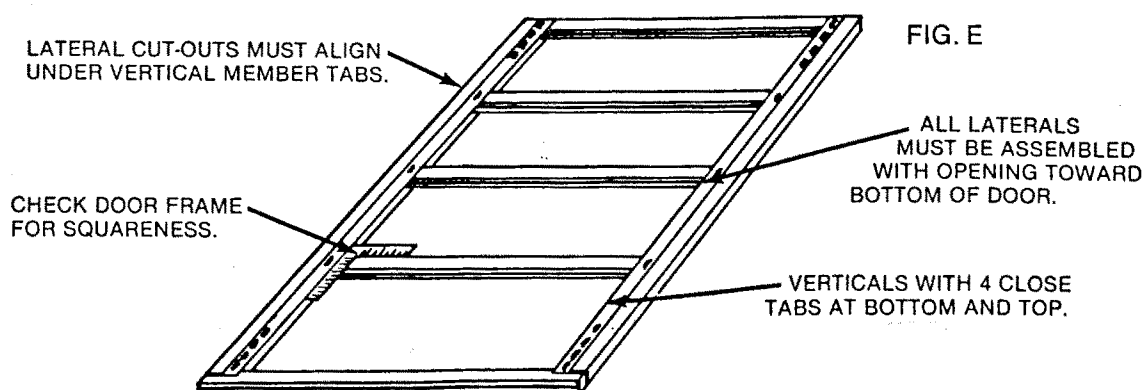


6. SQUARE DOOR FRAME.

7. Pry tab in final lock position with tapered tool as shown in Figure D. This aligns all members and holds frame square.

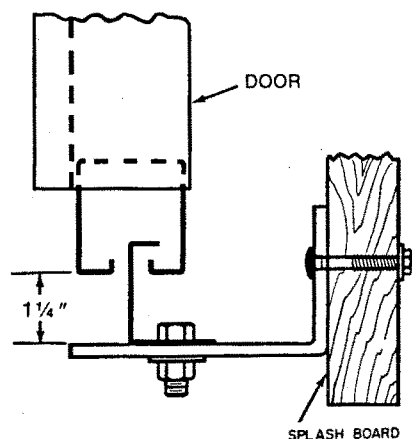
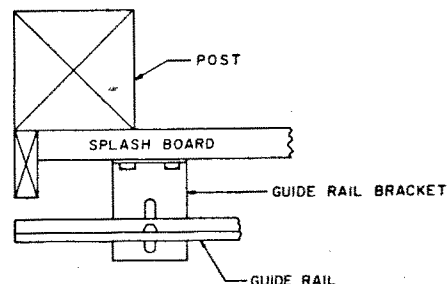


8. Turn door frame over and repeat tab locking procedure.

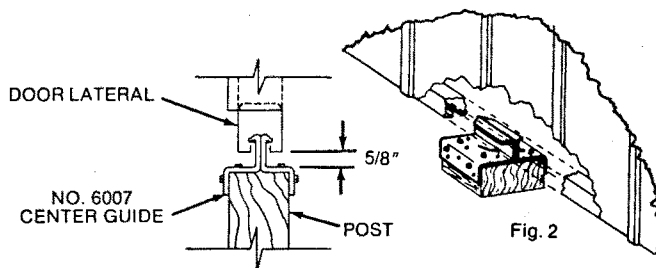


After door panels have been completely assembled, siding fastened to frame, trolley hangers installed, hung and plumbed; make all lateral adjustments in the hangers to obtain proper clearance at the header and jambs. Installation of guide rail and brackets can now be accomplished.

- a. Attach brackets to guide rail loosely with 3/8" x 3/4" bolts. One bracket and bolt is furnished for each hole in guide rail.
- b. Align end of guide with inside of door opening.
- c. **IMPORTANT:** To prevent the wind from lifting doors away from the building, fasten guide rail brackets to the splashboard with 5/16" carriage bolts or 3/8" lags. **DO NOT USE NAILS.** Hold the bottom of guide rail approximately 1-1/4" below the bottom of the door.
- d. Make adjustments so doors operate properly. Tighten all fasteners to secure brackets and guide rail in its final position.

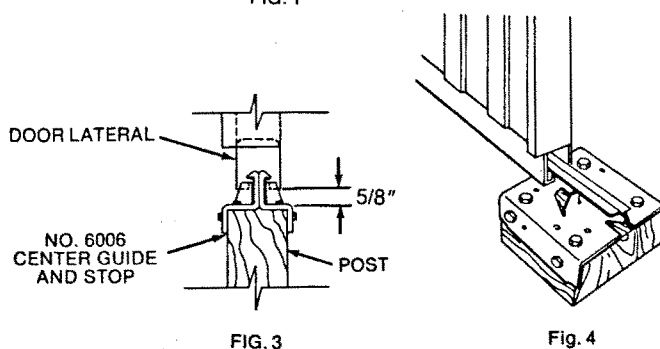


**NOTE:** On all doors 10' and wider it is recommended two No. 6007 center guides be installed back to back (as illustrated in figures 1 & 2) in the center of the door when in the closed position.



On bi-parting doors, use two No. 6006 center guides and stops back to back (as illustrated in figures 3 & 4) in the center of the opening.

Both Nos. 6006 & 6007 must be adjusted to engage the bottom lateral of the door when the door is in the closed position.



See your dealer for trolley hangers, rail, latches, door stops and other National TAB-LOC™ accessories.

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