



# BI-PART INDUSTRIAL SLIDING DOOR

## Installation Instructions and Operators Manual



### MODELS

- SLDB- 2016
- SLDB- 3016
- SLDB- 4016

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### To Contact PS DOORS:

**By Mail:** PS DOORS  
Attn: PS Access Solutions  
1150 S. 48th Street  
Grand Forks, ND 58201

**Website:** [www.pdoors.com](http://www.pdoors.com)

**By Email:** [4psinfo@pdoors.com](mailto:4psinfo@pdoors.com)

**By Phone:** Phone 701.746.4519  
Toll Free 877.446.1519

**IMPORTANT!** Read entire Installation Instruction and Operations and Maintenance Manual to become familiar with the product.

**NOTICE** The effectiveness of the product is directly related to the proper installation & operation of this product. Failure to properly maintain this product **will** affect performance.

#### Compliance and Publication Notice

This manual has been compiled and published covering the latest product descriptions and specifications.

The contents of this manual and the specifications of this product are subject to change without notice.

PS DOORS reserves the right to make changes without notice in the specifications and materials contained herein and shall not be responsible for any damages (including consequential) caused by reliance on the materials presented, including but not limited to typographical and other errors relating to the publication.

**Safety Precautions:** The following icons are used throughout this Manual.

- ▲ DANGER** Indicates an imminently hazardous situation which, if not avoided, will result in death or serious injury.
- ▲ WARNING** Indicates a potentially hazardous situation which, if not avoided, could result in death or serious injury.
- ▲ CAUTION** Indicates a potentially hazardous situation which, if not avoided, may result in minor or moderate injury.
- NOTICE** Indicates manufacture's statement of additional information.
- IMPORTANT!** Indicates a required action.
- CRITICAL** Indicates a vital component to product performance.

## **LIMITED WARRANTY**

PS DOORS warrants this product and components to be free from defects in material and workmanship for a period of Five (5) years from date of shipment. If within the term of this warranty, if any Swing Door or component is found to be defective upon inspection by an authorized PS DOORS representative, PS DOORS will replace or repair, at PS DOORS' discretion, any part found to be defective. Any field labor charges incurred are the sole responsibility of the customer.

To make a claim under this warranty, contact PS DOORS at the address shown below.

PS DOORS	Toll Free: 877-446-1519
Attention: Warranty	Phone: 701-746-4519
1150 S. 48th Street	Fax: 701-746-8340
Grand Forks, ND 58201	Email: 4psinfo@psdoors.com

Unauthorized modification of or to this product voids the PS DOORS Limited Warranty. Accordingly, you can expect any request for warranty repair to be charged to you, if the product requires service after unauthorized modification. Authorized modifications, received in writing from PS DOORS, as long as the modification is accomplished in strict accordance with PS DOORS' instructions, does not void warranty. To request product modifications contact PS DOORS, 1150 S. 48<sup>th</sup> Street, Grand Forks, ND 58201, phone 877-446-1519, email: 4psinfo@psdoors.com.

PS DOORS SHALL NOT BE LIABLE FOR ANY CONSEQUENTIAL OR INCIDENTAL DAMAGES.

All other warranty's, express or implied including any warranty of merchantability, are expressly excluded. Some states do not allow the exclusion or limitation of consequential or incidental damages, so the above limitation or exclusion may not apply to you.

WARRANTY DOES NOT APPLY TO ANY DAMAGE OR DETERIORATION CAUSED BY MODIFICATION, ABUSE, APPLIED PAINT FAILURE OR FAILURE TO PROVIDE REASONABLE AND NECESSARY MAINTENANCE.

This warranty gives you specific legal rights, and you may also have other rights, which vary, from state to state.

**Exclusions:**

1. Gaskets / weather seals are considered a "wear-item" and are not covered under this warranty.
2. Hardware and locking/latching devices are warranted by respective manufacturers. See related documentation for details.

## **SECTION 1. BI-PART SLIDING DOOR INSTALLATION**

**IMPORTANT!** Read and get acquainted with ALL Instructions prior to beginning installation.

### **I. GENERAL INFORMATION**

This manual contains information regarding installation, operation, and maintenance of the PS DOORS Bi-Part Sliding Door. Operation in a manner other than intended could result in damage or less than acceptable performance, for which the manufacturer will not be held responsible.

This product is manufactured to specific guidelines. Unauthorized alteration in any way will result in voiding Factory Warranty, and may cause product to fail.

### **II. STORAGE PRIOR TO INSTALLATION OF PRODUCT**

- A. Store materials in a dry, ventilated location. If outdoor storage is required, block materials and tarp in a tent-like arrangement, elevated above the product with open sides to allow airflow.

### III. INSTALLATION SITE PREPARATION

- A. Clear work area of any debris and obstructions which may impede the installation of the product.
- B. Ensure you have necessary tools available.
- C. Ensure any required permits have been obtained.
- D. Ensure the appropriate number of workers are available to conduct the installation.

### IV. PRE-INSTALLATION SAFETY PRECAUTIONS

- A. Comply with all OSHA Safety Regulations and/or company safety policies when installing.
- B. Install only on surfaces capable of supporting all loading. Structural analysis of mounting surface is the responsibility of the owner.

### V. INSTALLATION:

- A. Conduct installation of the Sliding Door in accordance with Construction Drawings provided and this installation instruction.
- B. General Installation Guidelines:
  1. Install in accordance with best construction practices.
  2. Utilize only approved fasteners as provided or specified by Manufacture.
  3. Install all components plumb, level, and square as indicated on construction drawings.
  4. Field modifications, if required, must be coordinated with manufacturer.

**IMPORTANT!**

Read entire Manual to become familiar with the product before installation.

**NOTICE**

This installation instruction depicts a standard Bi-Part Sliding Door installation. For custom Bi-Part Sliding Door installation, please refer to the original drawings for specific instructions. Optional component installation may not be included in this manual. Separate drawings and/or instructions may accompany this manual.

## INSTALLATION STEPS

### STEP 1 - Determine Levelness of Slide Path:

The sliding path of the door needs to be level. If imperfections are present;

- Locate the high point on the floor along the entire travel path of the door, as illustrated in Figure 1, Point 1.
- Mark this point on the door jambs as illustrated by the dotted line and Point 2, in Figure 1.
- These marks will be used to locate the *Center Stop and Trail Jamb Channels* in later installation steps.

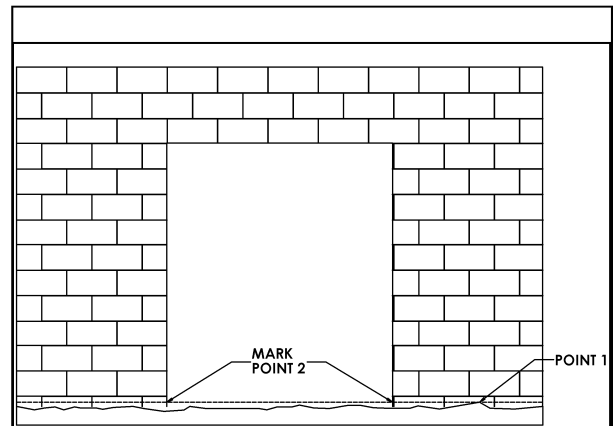


FIGURE 1

### STEP 2 - Optional Frame Extension (If Included):

Refer to shop drawing to see if your door has a *Frame Extension*. If it is required, continue to follow Step 2. If not, proceed to Step 3.

- Dry fit the three (3) *Frame Extension* pieces in the opening. If all pieces fit properly, lay frame extension on a flat, level surface and weld together making sure assembly is square.
- Once welded together slip Frame Extension Assembly into opening and weld or mechanically fasten into place.

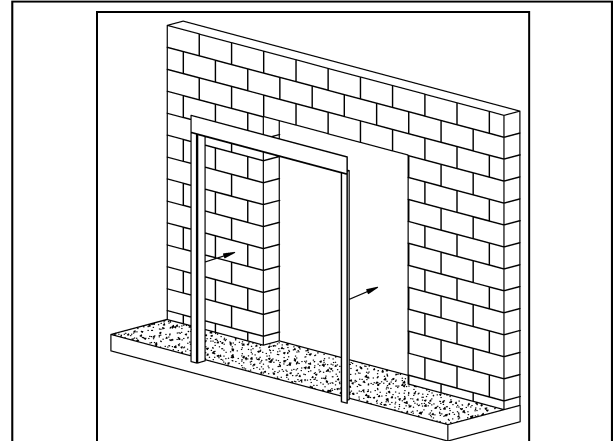


FIGURE 2

**STEP 3 - Determine Jamb Lap Distance:**

- From the shop drawing, determine Jamb Lap Distance [the distance between the center of the opening and the outside edge of the *Trail Jamb Channels* Figure 3, Point 3 and 4].
- Mark this distance on the jamb or frame extension member. This mark will be used to locate the *Trail Jamb Channels (A)* in a later installation step.

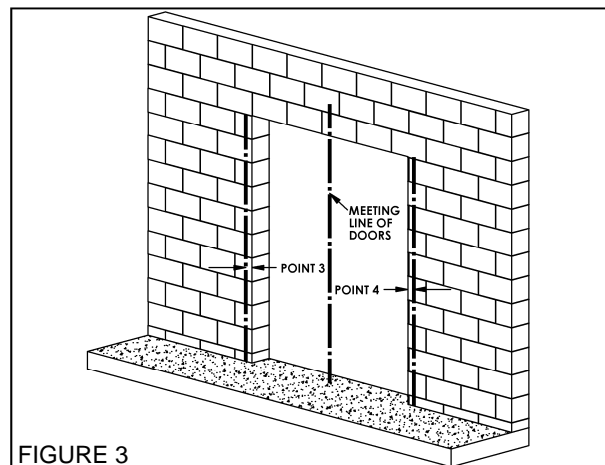


FIGURE 3

**STEP 4 - Mount Trail Jamb Channels:**

- Mount the *Trail Jamb Channels* to the door jamb or frame extension. The outside edge of the *Trail Jamb Channels* should line up with the marks you made in Step 3. Make sure it is PLUMB.
- The bottom of the attached stay roller plate should be FLUSH with the high-point line made in Step 1.
- If the floor is reasonably level, these plates will rest on the floor.

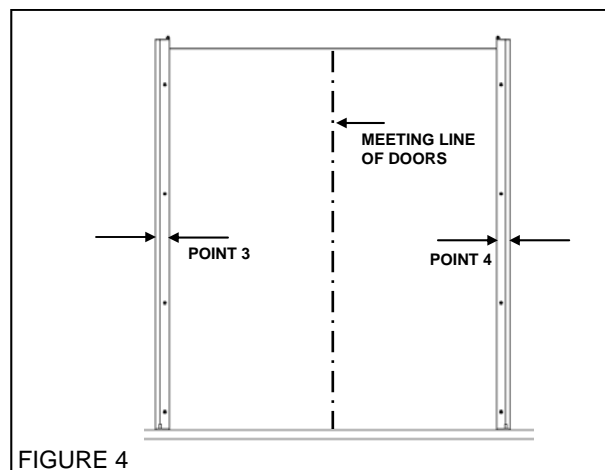


FIGURE 4

**STEP 5 - Mount Top Track Assembly:**

- Mount *Top Track Assembly* to the top of the *Trail Jamb Channels*.
- Place the top track assembly on the threaded stud welded to the top of the trail jamb channel. Tighten the flange nut provided to fasten the pieces together at Point 5, Figure 5.
- After making sure the track is in the correct position and LEVEL. Anchor track securely to building structure or frame extension at holes provided. Provide additional bracing as required where no wall attachment is available.

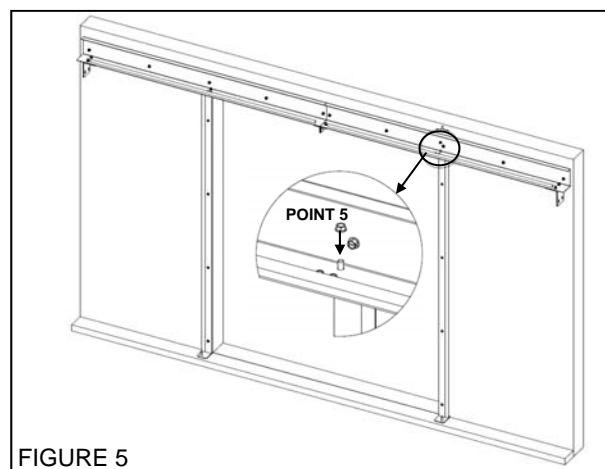


FIGURE 5

## STEP 6 - Install Bottom Guide Rollers:

- Install *Bottom Guide Rollers* on stud at bottom of *Trail Jamb Channels* as illustrated in Figure 6.

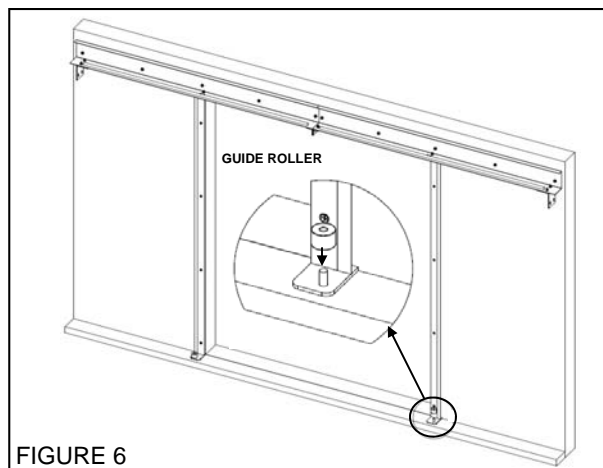


FIGURE 6

## STEP 7 - Hang and Adjust Doors

- Remove *Safety Stud* (7-A).
- Set door panel over the *Bottom Guide Roller* (7-B). Lift door slightly to set top rollers on the track rail.
- Reinstall *Safety Stud*.
- Move door back and forth slowly to ensure proper operation.
- Plumb door by adjusting top trolley bolts. Also adjust floor clearance with these bolts. (7-C)
- Repeat for opposite panel.

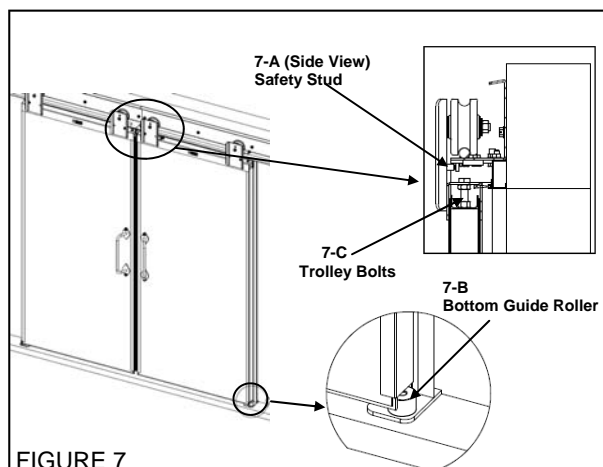


FIGURE 7

## STEP 8 - Weatherstrip

- Refer to the shop drawing for each step. In most cases the head weather-stripping will be **FACTORY INSTALLED**.
- If not, attach *HEAD SEAL* to head channel. It should extend all the way to the stop angle and be flush with the bottom of head channel.
- Attach *TRAIL JAMB SEAL* to trailing edge of door (**NOT TO TRAIL JAMB**).
- Attach *SILL SEAL* to door. Refer to shop drawing to locate correct side. **Be sure to keep screws above bottom guide channel.** Use weatherstrip screws provided for all brush seal.

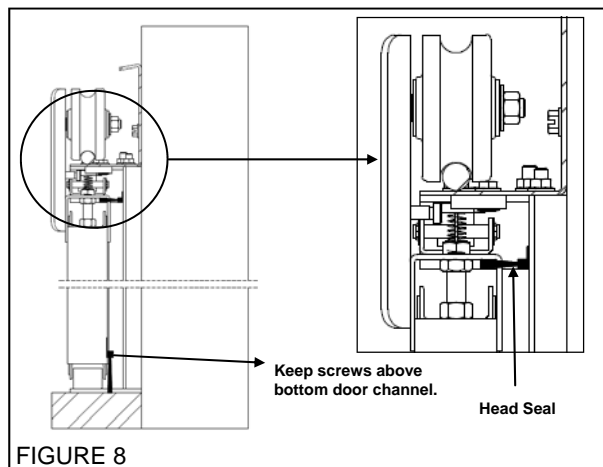


FIGURE 8

## STEP 9 - Optional Weatherhood (if applicable)

- Install End Caps in Weatherhood.
- Attach hood to wall above track. On installations where hood attaches to ribbed siding:
  - ⇒ The gaps need to be filled and caulked,

OR

- ⇒ A slot can be cut into the steel siding and the top vertical flange on the weatherhood can be slipped behind the siding and fastened in place.

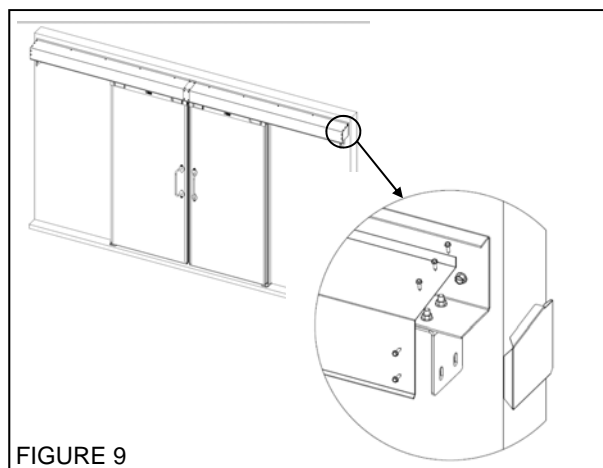


FIGURE 9

## SECTION 2. OPERATING & MAINTENANCE INSTRUCTIONS

**IMPORTANT!** Read entire Operations and Maintenance Manual to become familiar with the product.

### A. GENERAL INFORMATION

1. This manual contains information regarding operation and maintenance of a PS DOORS Bi-Part Sliding Door.
2. This product is manufactured to specific guidelines. Unauthorized alteration in any way will result in voiding Factory Warranty, and may cause product to fail.

### B. OPERATION GUIDELINES

1. The following procedures and information are supplied for the operation of the PS DOORS Industrial Bi-Part Sliding Door. Operation in a manner other than intended could result in damage or less than acceptable performance of the product, for which the manufacturer will not be held responsible.

### C. SAFETY PRECAUTIONS

1. Ensure opening is clear of all obstructions through the entire travel of the door during operation of door panels.
2. Use the handles when contacting door panel, staying clear of pinch points.
3. Do not force panels or components if they do not operate freely.
4. If removing panels or hardware for maintenance, consult documents for panel weights, and use appropriate lifting procedures or equipment. Protect all finishes, weather seals, and hardware. Always consult original factory drawings for all installation dimensions, details, hardware, and specifications.

### D. OPERATION UNDER NORMAL CONDITIONS

1. Under normal operation, Industrial Sliding Doors operate by sliding horizontally along the top track system in one direction. To operate, grasp the door handle and slide in the direction away from the closed position. Repeat operation is opposite direction to close sliding door.
2. The following provides information regarding operation of standard and optional components of the sliding door:

### E. STANDARD COMPONENTS

1. **Flush Pull Handle:** Provided on the side of the sliding door which is closest to the wall. This handle is designed to be large enough for gloved hands and is recessed to allow for the door to slide past the edge of the opening, providing for full clear opening of the doorway. *See Knuckle Saver Safety Stop for additional information.*
2. **Bow Handle:** Designed to be large enough for gloved hands, the Bow Handle is located on the side of the door panel away from the wall.

**NOTICE** Unauthorized modification of this product voids the PS DOORS Limited Product Warranty. Accordingly, you can expect any request for warranty repair to be charged to you, if it requires service after modification. Authorized modifications, received in writing from PS DOORS, as long as the modification is accomplished strictly in accordance with PS DOORS' instructions, does not void warranty. To request product modifications contact PS DOORS.

**WARNING** The door panel is heavy, verify panel weights (shown on drawings) and use appropriate lifting procedures and equipment when necessary.

Flush-Pull  
Handle



Bow Handle



## STANDARD COMPONENTS (Continued)

3. **Knuckle Saver Safety Stop (KSSS)**, provided on door panels wider than 32 inches.: The KSSS is the paddle handle located on the interior of the door above the flush pull handle. It is designed to stop the sliding door panel before the flush pull handle slides past the door jamb, thus eliminating the chance of injuring personnel's hands. If full opening of the door panel is required, lift and hold the KSSS paddle and carefully slide the door panel past the KSSS stop, thus allowing for full clear opening of the door frame.
4. **Dual Control Top Roller Trolley Assembly**: Although no interaction is required during operation, the Top Roller Trolley Assembly is what allows the door to operate (slide) under positive or negative pressure.
5. **Safety Studs**: Located on the Top Roller Trolley Assembly, under the track, these safety studs keep the door assembly from being able to be lifted off of the track system. Refer to Installation Instructions for additional detail.
6. **Bottom Guide Roller**: Although no interaction is required during operation the Bottom Guide Roller maintains the trajectory of the sliding door during operation. Additionally, it contributes to the ability of the sliding door to operate under positive and negative pressure.
7. **Weatherseal**: The PS Industrial Sliding Door utilizes a nylon brush filament weather seal to hold out the weather. Operation of the sliding door may be impacted by the improper installation of the weatherseal. See Inspection and Maintenance.

## F. OPTIONAL COMPONENTS

1. **Spring Reel Closer Assist (If provided)**: Although no physical interaction with the spring reel closer assist is required to operate the door, it is important to be aware that the spring reel closer assist will attempt to close the door once the sliding door panel has been opened.
2. **Floor Bolts (If provided)**: Depending upon the operation of your sliding door it may have floor bolts utilized to "pin" the door in the closed position. During operation the floor bolt must be raised into the up position to allow the sliding door panel to operate freely.
3. **Weatherhood**: The optional weatherhood provides a cover to protect the Top Roller Trolley Assembly from the elements, and from the build-up of debris which may hinder the operation of the sliding doors. It also provides a means of shedding moisture (rain or snow melt) away from your building.
4. **Vision Lites (Windows)**: Vision Lites are not required for the operation of the sliding door however, they do allow light into the building and allow pedestrians to see any oncoming walk traffic prior to operating the sliding door.
5. **Automated Operation**: This option allows for the sliding door to be operated by an electric or pneumatic operator and activated via push-buttons, sensors, or other means of activation. If your door is equipped with Automated Operation see the specific instructions provided with your sliding door.

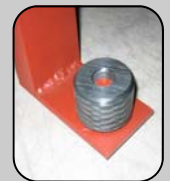
Knuckle Saver Safety Stop Paddle Handle



Top Roller Trolley

**WARNING** Safety Studs must be in place and tight. Without the safety studs in place the door panel may become detached from the sliding door track and could cause death or serious injury.

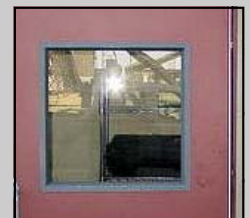
Bottom Guide Roller



Weatherhood



Vision Lite



## G. INSPECTION AND MAINTENANCE

The following is a listing of recommend inspection items for the sliding door. The sliding door has been designed to require minimum maintenance; however periodic inspection and maintenance will increase the life of the sliding door.

### 1. Frames

**Inspect:** Items/members for damage and misalignment.

**Maintenance Action:** Adjust, repair, or replace as needed, to meet original design tolerances.

**Inspect:** All anchor and connecting points for corrosion.

**Maintenance Action:** Repair or replace components as necessary.

### 2. Door Panel(s):

**Inspect:** Door panel for damage or corrosion.

**Maintenance Action:** Repair or touch-up finish as required.

**Inspect:** Door panel alignment and free movement; clearance from ground/walking surface.

**Maintenance Action:** Adjust door panel at trolley assembly using adjusting bolts. Refer to Installation Instructions for additional details.

### 3. Safety Studs:

**Inspect:** Ensure safety studs are in place and tight.

**Maintenance Action:** Replace or tighten safety studs.

### 4. Handles:

**Inspect:** All handles for signs of wear.

**Maintenance Action:** Replace or repair as necessary.

### 5. Weatherhood:

**Inspect:** Ensure weatherhood is properly fastened and all clearances are within tolerances to allow for normal door operation.

**Maintenance Action:** Adjust weatherhood and replace or repair any damages.

### 6. Fasteners and mechanical connections:

**Inspect:** Ensure all fasteners are in place and adjusted to their original design standards.

**Maintenance Action:** Replace any damaged components. Refer to original product drawings.

### 7. Top Roller Assemblies

**Inspect:** Roller assemblies to ensure there are no flat spots on rollers, ensure roller bearings are greased and rollers operate freely.

**Maintenance Action:** Replace rollers which are damaged. Grease roller bearings via grease fittings with approved lubricants. Use a general purpose grease rated for the operating temperature of your geographical area and environmental conditions.

### 8. Caulk and Sealants:

**Inspect:** All sealants used to insure their effectiveness.

**Maintenance Action:** Replace any cracked, loose, or otherwise non-performing sealants.

**⚠ WARNING** Safety Studs must be in place and tight. Without the safety studs in place the door panel may become detached from the sliding door track and could cause death or serious injury.



## G. INSPECTION AND MAINTENANCE (Continued)

### 9. Weatherseals:

**Inspect:** All weatherseals around perimeter of opening for damage. Visually inspect all weatherseals for proper positioning and contact with door panel in the closed position.

**Maintenance Action:** Replace or repair if damage or deterioration to weatherseals has occurred. Use only factory recommended materials (consult manufacturer for original design standards).

### 10. Floor Bolt (if applicable):

**Inspect:** Operate all latching hardware to ensure smooth, uninhibited movement of all mechanical components.

**Maintenance Action:** Adjust floor bolt to operate smoothly or replace damaged components.

### 11. Spring Reel Closer Assist (if applicable):

**Inspect:** The Closer Assist assembly. Ensure all components are present, connected and operate freely.

**Maintenance Action:** Replace or repair Closer Assist as necessary.

### 12. Vision Lite (if applicable):

**Inspect:** Visually inspect vision lite glass for cracks, breaks, or deterioration of vision lite gasket or frame.

**Maintenance Action:** Replace broken or damage glass or gasket. Touch-up finish on any area which is showing signs of wear.

### 13. Finishes:

**Inspect:** Visually inspect all surfaces for signs of wear or corrosion.

**Maintenance Action:** Periodically clean surfaces and perform touch-up to finish as necessary.

### 14. Labels and Placards:

**Inspect:** All labels and placards.

**Maintenance Action:** Replace any labels and placards which are missing or unreadable.

### 15. General Housekeeping:

**Inspect:** Ensure the area around the sliding door is kept clear paying close attention to the trajectory of the sliding door.

**Maintenance Action:** Clean sill and jambs of any debris and keep the area clean throughout the operating area of the door. Including snow removal.

**NOTICE** The Spring Reel Closer Assist is designed to assist personnel in closing the sliding door, IT IS NOT A CLOSER, the door may not close solely under the power of the Spring Reel Closer Assist.

**CAUTION** The spring reel closer assist is under spring tension. Use caution when performing maintenance or disassembly procedures.

# INSPECTION & MAINTENANCE LOG

**IMPORTANT!** Periodic Inspection and Maintenance Required.

Date Purchased: \_\_\_\_\_

Product: \_\_\_\_\_

Model Number: \_\_\_\_\_

Serial Number: \_\_\_\_\_

Door Identifier / Number: \_\_\_\_\_

Location: \_\_\_\_\_

DATE INSPECTED	INSPECTED BY <i>(Print &amp; Sign)</i>	INSPECTION ITEMS NOTED	CORRECTIVE ACTION	CORRECTED BY <i>(Print &amp; Sign)</i>