

Bofor Marine Products - Mounting Instructions 05

Mounting Item: Hatch or Door

Vessel Material Type: Aluminium or Steel

Mounting Type: Bolting

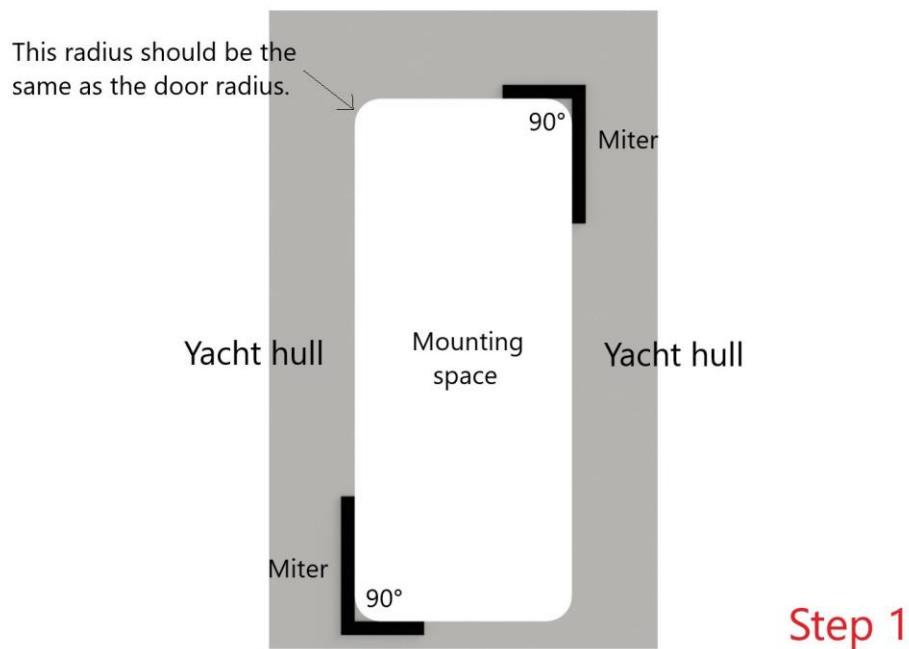
Bolt Quality: A4 316

Important Note: Consider same rules apply to both doors and hatches.
Keep the door closed and locked through all following steps.

Following the success criteria steps will let you experience the Bofor quality at its finest.

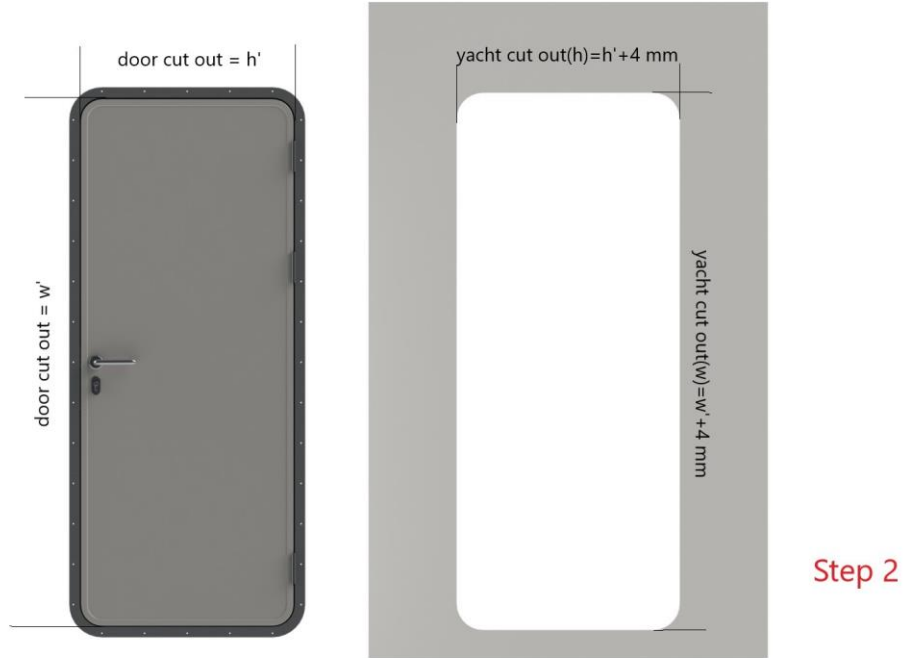
Success Criteria Steps

1. **Mounting Area Structure Control:** Make sure there are no warpage issues with the door and the door position is in the right order.

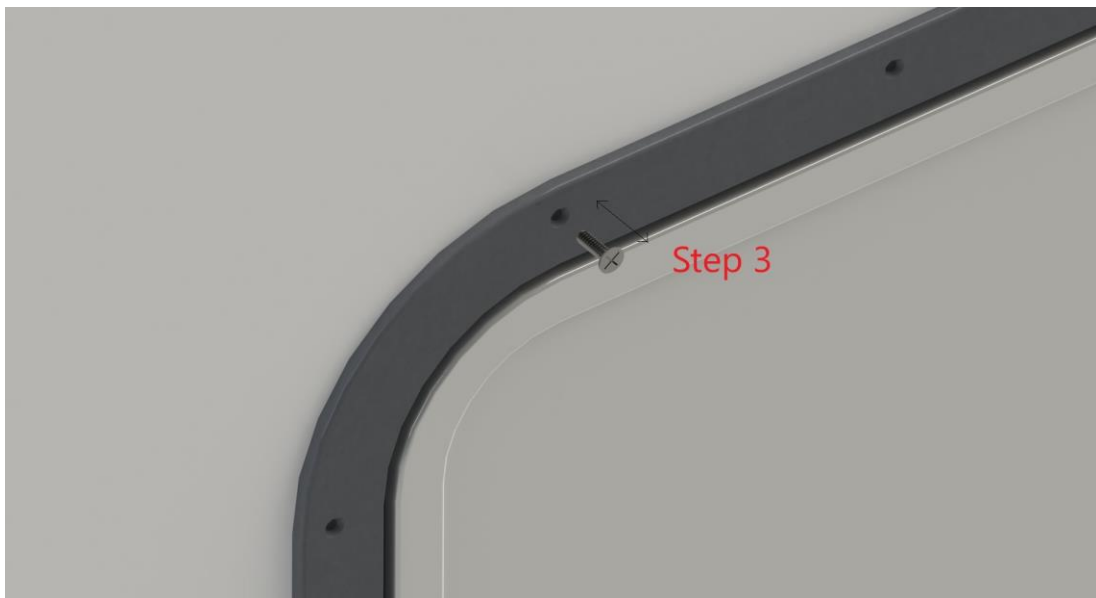


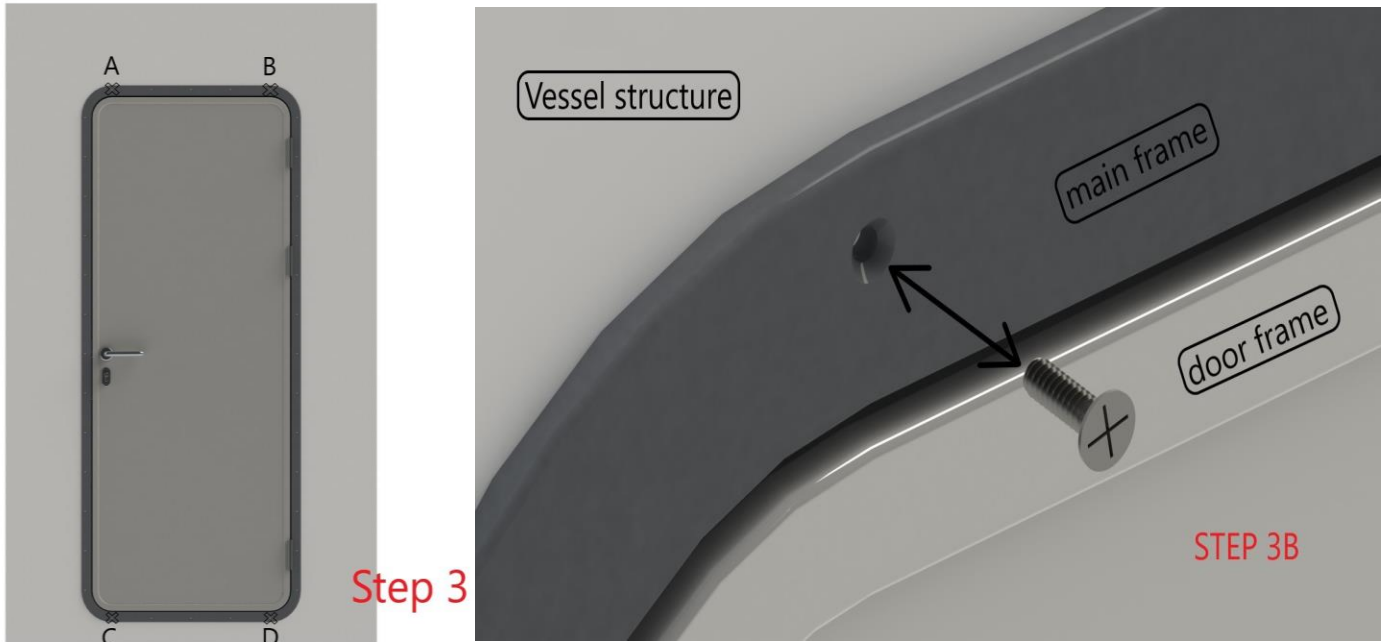
- Alignment of mounting area with door cut-out:** Make sure the door cut-out fits to structure cut-out. The cut-out area should be extended by additional 2mm on each side compared to door cut-out, corresponding to sum of 4mm on both x and y axis.

In other words if the door cut out is $h*w$ the mounting hole should be $(h+4)*(w+4)$ mm.

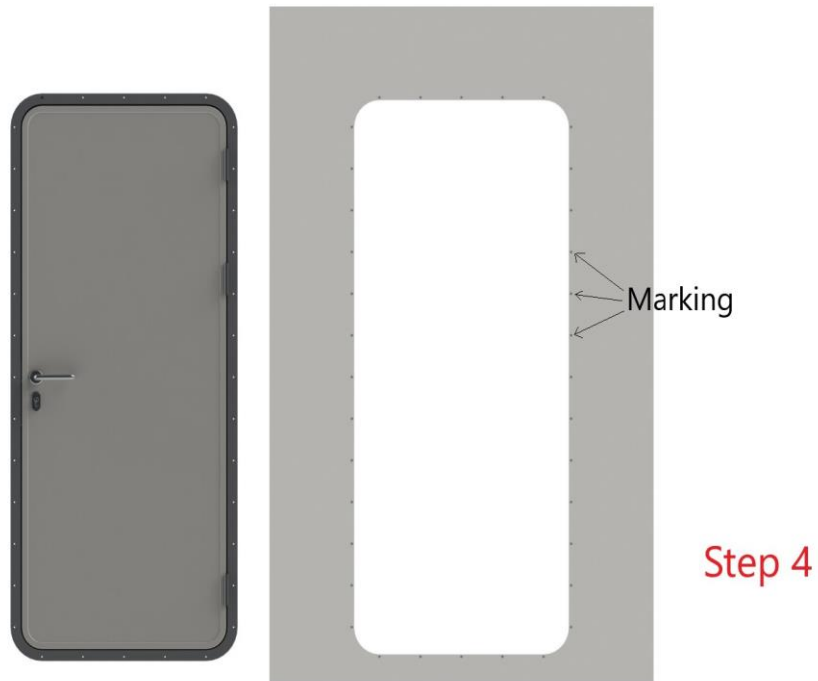


- Rehearsal fitting:** Slightly screw 4 bolts on 4 corners of the door (A-B-C-D) to fit the door. Don't force the bolts, screw them in ease.



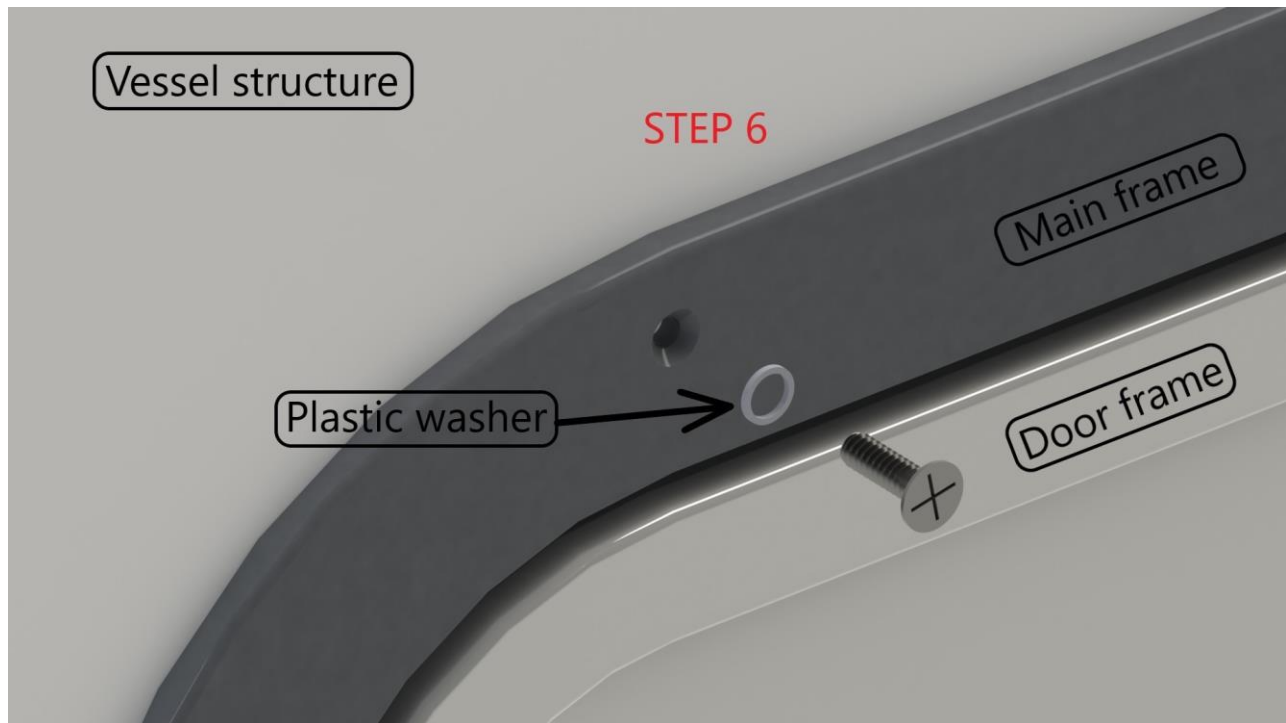


4. **Marking:** Mark the door frame from centre of the bolt holes(E) with hammer drill.



5. **Dismount the door** and secure it in a safe position for both the door and the crew.
6. **Plastic Washer:** Fit the bolts to the plastic washers. Thus the stainless steel bolts will have no contact with the paint.

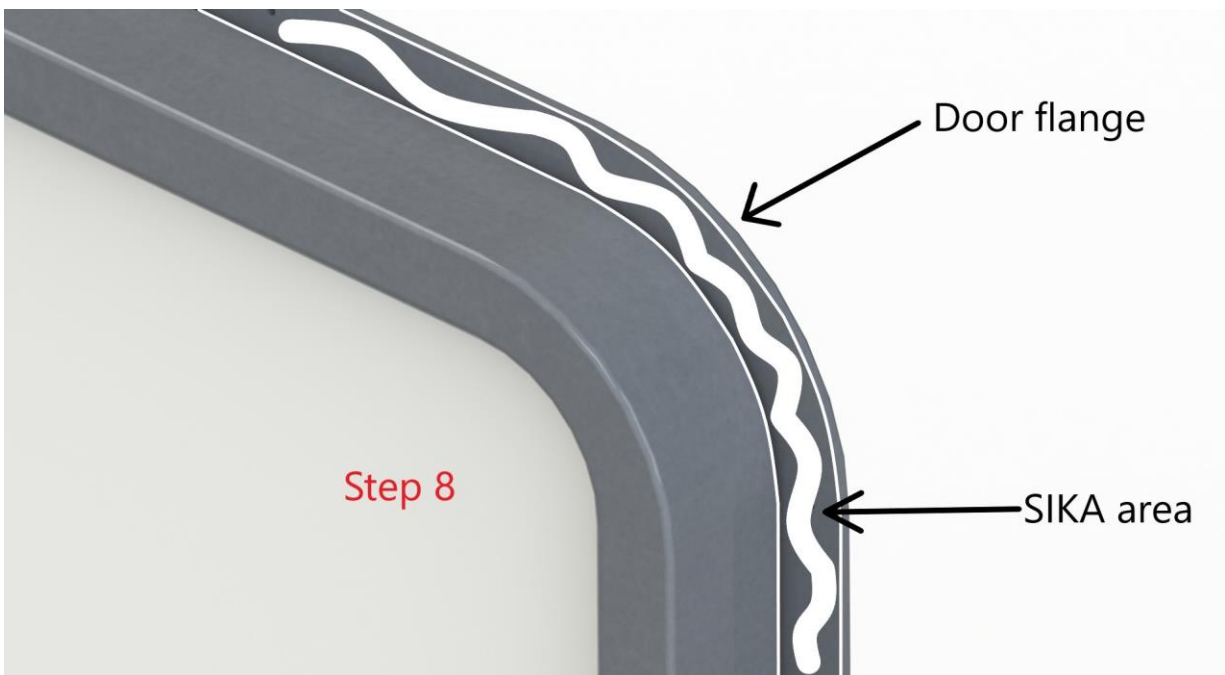
The plastic washer can be a soft material for most cases. Therefore if the operator forces the bolts on the plastic washer, the washer can possibly become out of shape, thereby useless.



7. **Control the plastic washer:** Confirm the right positioning of the plastic washers. If any of them found out of position or out of natural ring shape use use a new plastic washer instead.



8. **Sika:** Use SIKA291 or similar under the door's flange and edges of the mounting zone.



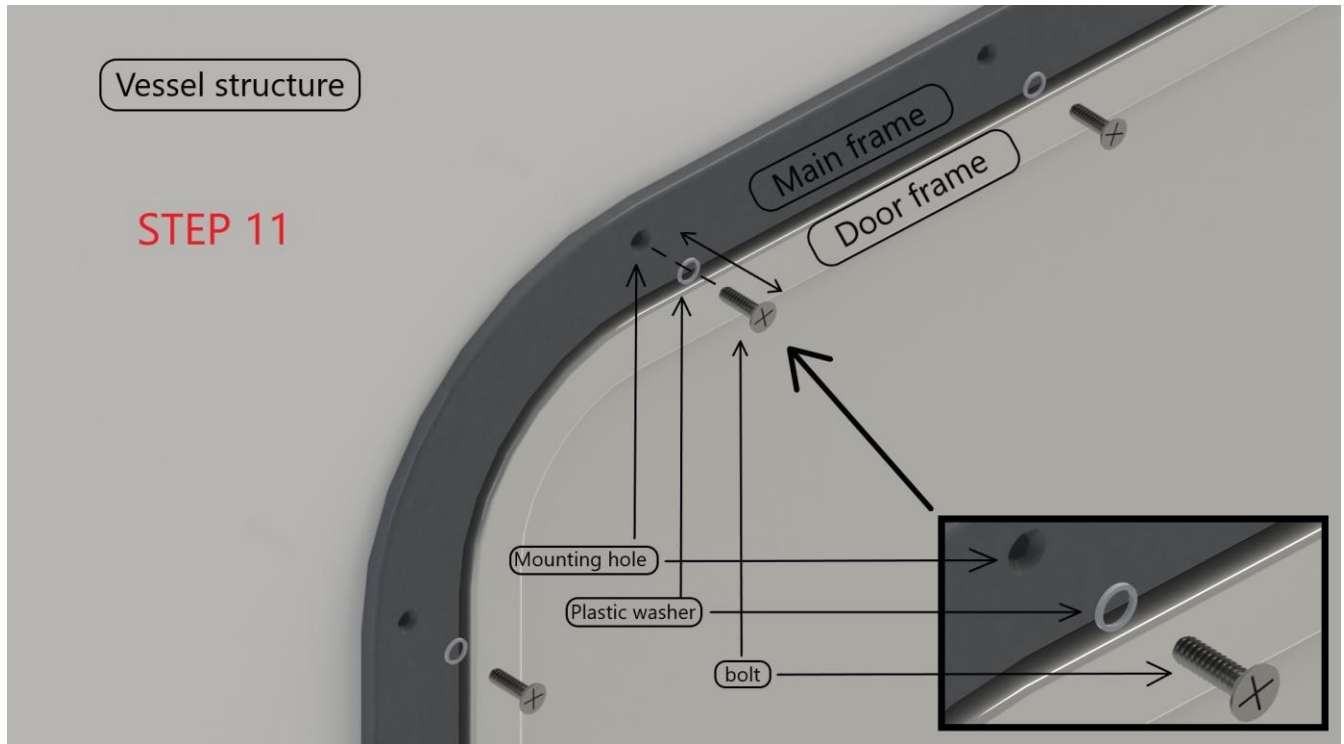
9. **Tef-Gel:** Use notable volume of tef-gel on bolt gears in order to prevent corrosion.



10. **Fixing:** Fix the door with water level meter from each corner as you use plastic washers and tef-gel on the corner bolts.



11. **Mounting:** Screw the rest of the bolts on the previously marked spots with using plastic washers and tef-gel.



12. **Cleaning:** Use common glass cleaning tools in order to precisely get rid of the unnecessarily extra SIKA.
13. **Make it Rest:** Make the door rest at closed position for 24 hours in order to let the SIKA get solidified.