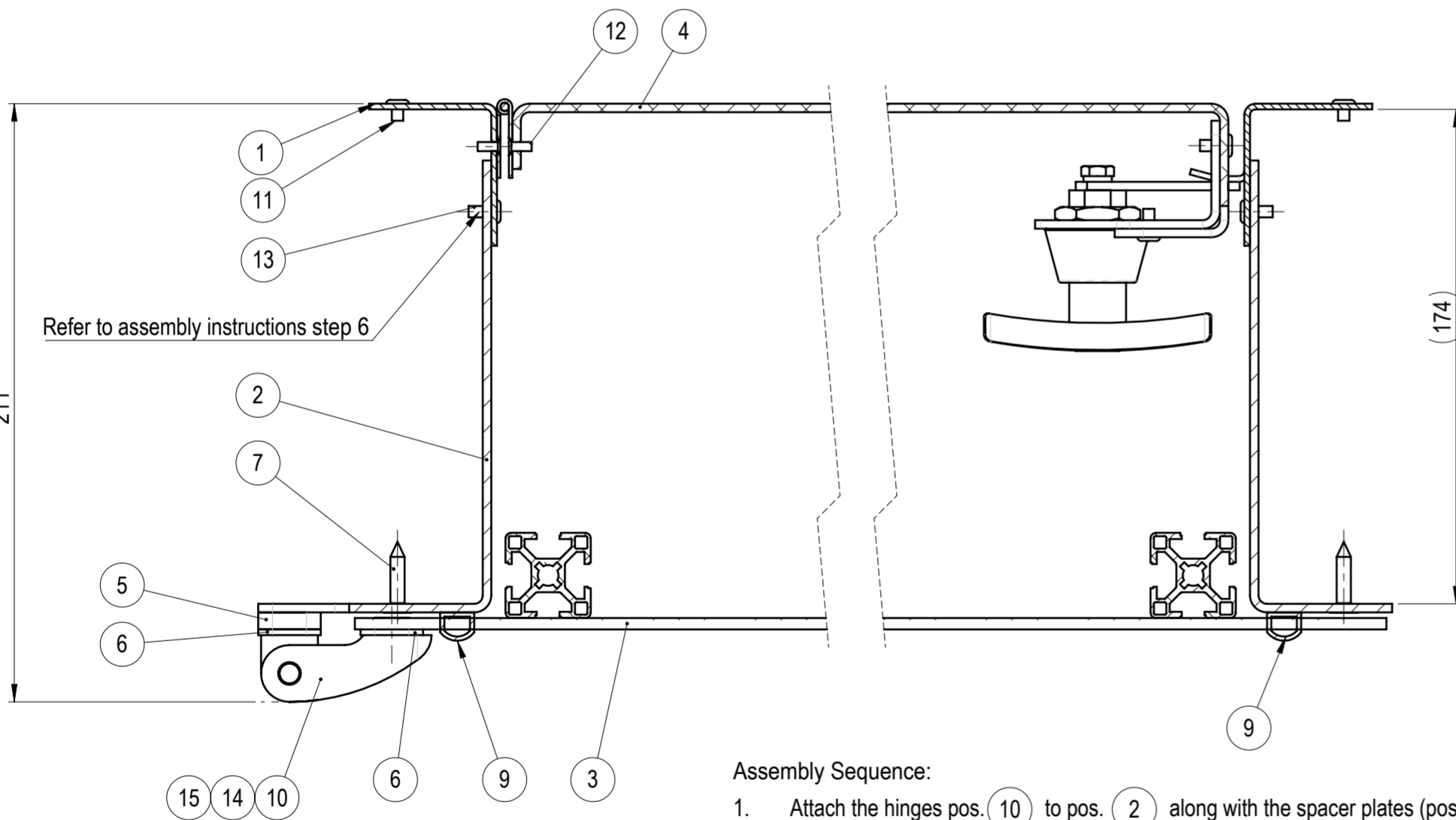
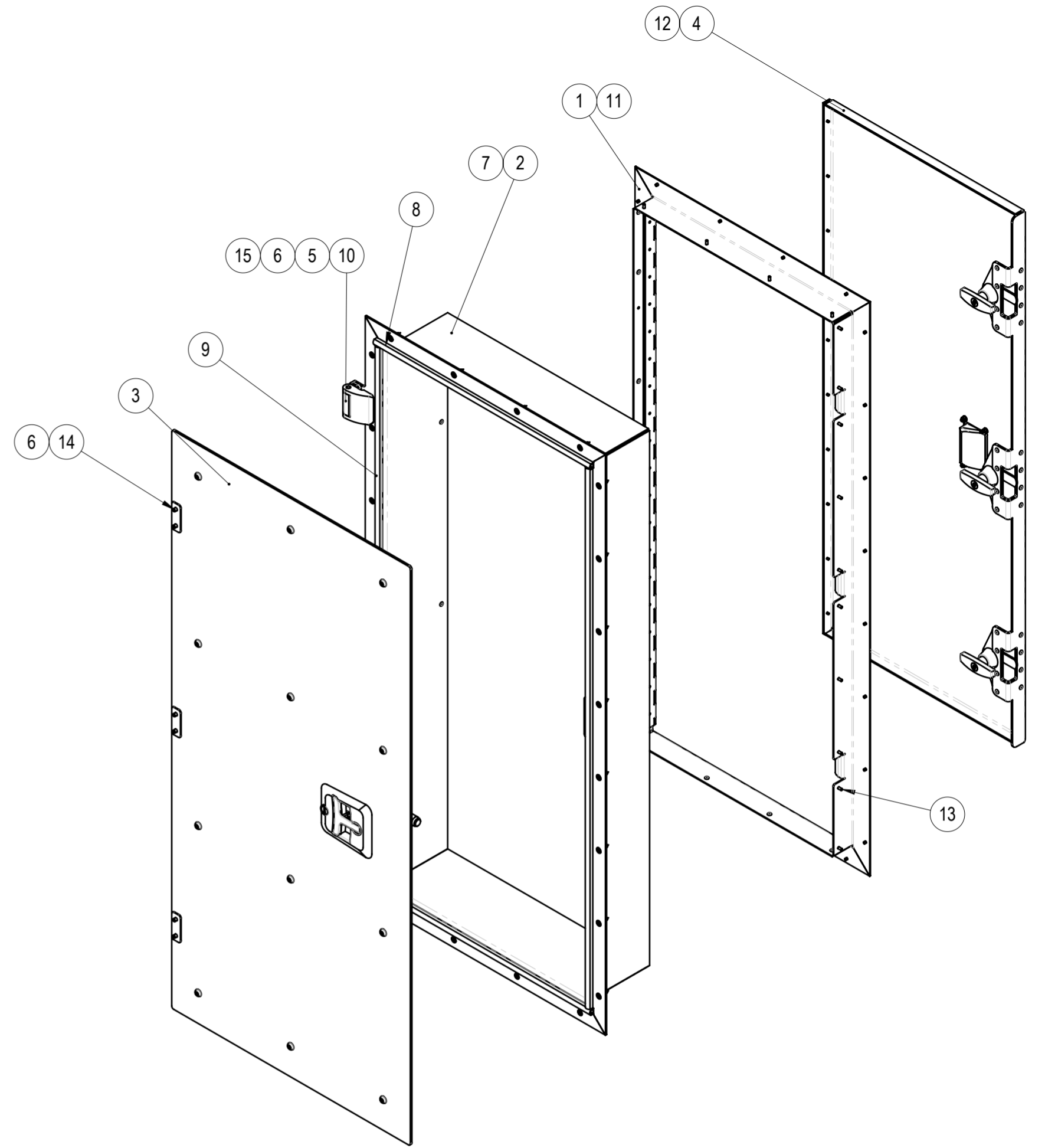


B-B
SCALE: 1 : 2



Assembly Sequence:

1. Attach the hinges pos. (10) to pos. (2) along with the spacer plates (pos. (6) and pos. (5));
2. Fasten pos. (3) and check if adjustment of shim plates is necessary. Ensure sufficient clearance for the sealing gaskets (pos. (8) and (9));
Important! After securing the door to the wall, shimming between pos. (2) and pos. (10) will no longer be possible!
3. Once the doors (pos. (3)) are properly aligned, remove them while keeping the hinges attached to pos. (2);
4. Secure the outer hatch frame (pos. (2)) to the wall;
5. From the opposite side of the wall, insert pos. (1) and fasten it to the other side of the wall;
6. Using a Ø4.1mm drill bit, drill through pos. (1) into pos. (2) and rivet them together;
7. Rivet the door (pos. (4)) to pos. (1) through a piano hinge. Check door movement and adjust the latch tongue if needed;
8. Reattach the doors (pos. (3));
9. Apply self adhesive profile around the perimeter (pos. (8) and (9));
10. Adjust the pos. (3) door mechanism to ensure smooth operation.



Assembly Notes:

- Use thread-locking adhesive on all screw-fastened components;
- After assembly, both doors must open and close freely. The door mechanisms should operate smoothly without excessive force.

NO.	PART NO	DESCRIPTION	MATERIAL	PROCESSING	REVISION	WEIGHT	QTY
1	105-30231-00	Inner hatch frame assembly	-	ASY		5.58	1
2	105-30232-00	Outer hatch frame	-	WLD PNT		16.70	1
3	105-30233-00	Outside door	-	ASY		12.57	1
4	105-30234-00	Inside door	-	ASY		6.56	1
5	105-30230-01	Spacer plate 1	6082 T6	LC		0.02	3
6	105-30230-02	Spacer plate 2	6082 T6	LC		0.01	6
7	CSK Wood screw d5x25	CSK Wood screw	Stainless steel A2	COTS		0.00	24
8	588.7788 L=932	Rubber D profile self adhesive (Fixxprofile)	Micropore rubber	COTS		0.03	2
9	588.7788 L=1186	Rubber D profile self adhesive (Fixxprofile)	Micropore rubber	COTS		0.06	2
10	Elesa+Ganter_GN 138-ZD-60-62-A-SW	Hinge GN 138-ZD-60-62-A-SW	-	COTS		0.24	3
11	ISO-15979-4x6 (1,0-3,0)	Standard rivet, dome head	St/St	COTS		0.00	27
12	ISO-15980-3,2x6 (1,5-3,5)	RIV-CS-A2/A2-(3,0-5,0)-3,2X8,0	A2/A2	COTS		0.00	10
13	ISO-15983-4x10 (4,5-6,5)	Standard rivet, dome head	A2/A2	COTS		0.00	28
14	ISO10642 (DIN7991) M6x12	CSK socket screw	FlakeZn-8.8	COTS		0.00	6
15	ISO10642 (DIN7991) M6x20	CSK socket screw	FlakeZn-8.8	COTS		0.01	6

		MATERIAL	WEIGHT	DEBURR AND BREAK SHARP EDGES	REVISION	DATE	
		-	42.602 Kg	DO NOT SCALE DRAWING		02.06.2025	
Designed by M. Supols Drawn by M. Supols Technical ref.		SURFACE PROTECTION	MACHINING	THERMAL CUTTING	WELDING	SCALE	
		-	ISO 2768 mK	ISO 9013 221	ISO 13920 BF	1:10	
		PART NO. 105-30230-00					
		DESCRIPTION Double door hatch				SHEET 1/1	