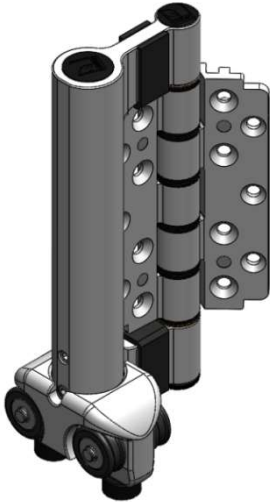


# New Product Fitting Instructions

## Bi-Fold Plus – New double roller, LBF050

As part of the on-going review of the product range we are pleased to announce the latest enhancement to the Bi-Fold Plus range of doors.



### Features and Benefits

The enhanced LBF050 double roller can be used on any Bi-Fold Plus door, and will require a new drilling jig in order to locate it in the correct position when manufacturing.

The new part includes the following amendments:

- All new extruded hinge flags, thicker & with additional fixings for increased strength.
- Shorter, sturdier post design for increased rigidity.
- 4 wheel & bearing rolling system to increase rolling stability.

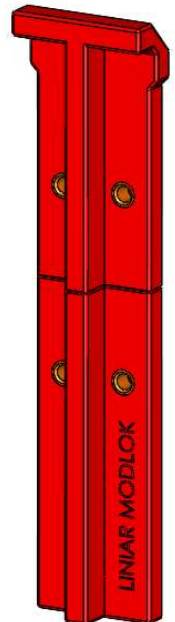
### New Drilling Jig

The introduction of the new LBF050 means a new drilling jig will be required when manufacturing the doors.

This jig will be supplied to you by the technical team and can be used for both “Bi-Fold Plus” & “ModLok Bi-Fold Doors (Feb ‘14)”.

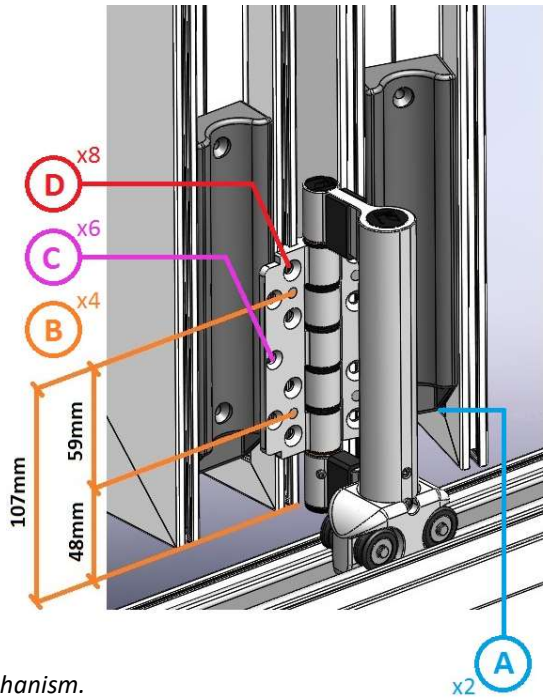
The new jig will include the following amendments:

- New drilling position for the corner of sashes, and fitting off butt hinge, and doubler roller products.
- Improved datum edges to help positioning when brush pile and weld sprues are present.
- Improved centreline markings.
- Extra length for easier handling when drilling.
- Machining centre users will need amended drilling positions to suit.



# Fitting Instructions

- A. Locate 2x LBF350 (Security Moulding) in central rebated sash channel. Align with inside edge of sash rebate. Secure in position using 4.3 x 20mm CSK PVC screws (4 places).
- B. Drill 4x using LMDJ (Drilling Jig) for dowel pin positions.
- C. Secure in position through moulding using 4.3 x 30mm CSK PVC screws (6 places).
- D. Secure in position through sash using 4.3 x 30mm CSK PVC screws (8 places).



Repeat these steps for the top rolling mechanism.

**Please note: LBF194, interlock seal will need to be replaced to suit new hinge position when retro fitting to a current Bi-Fold Plus installation.**

## Tolerance Amendments

Due to the increased flag thickness found on the new double roller assembly the allowed tolerance has been reduced to 8-10mm in the areas only where this product is fitted.

All other hinge points remain un-affected by this new part and retain the original tolerances.

**All Remaining Door Gap Tolerances:**  
6-10mm

