

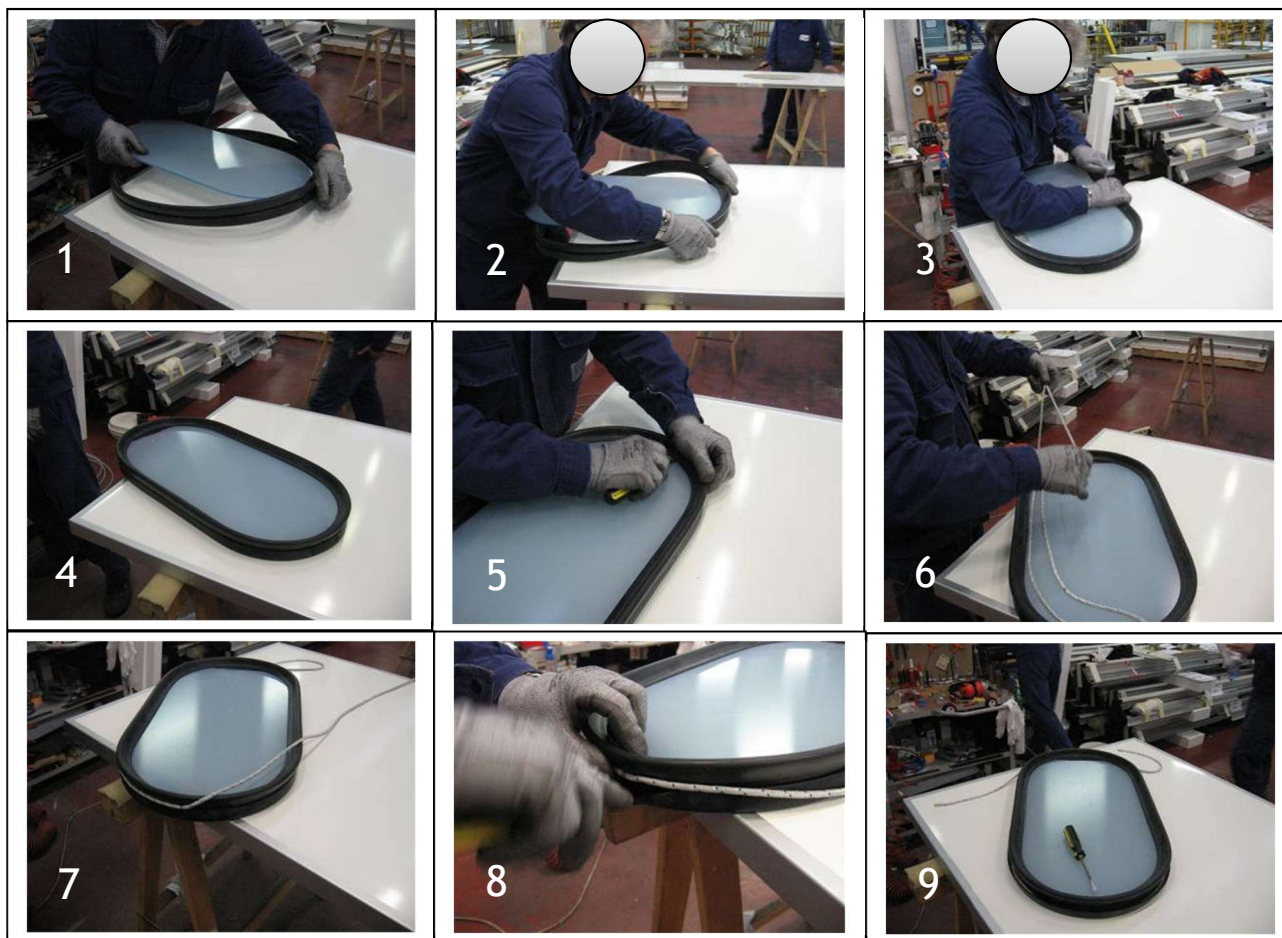
1. Introduction

This work instruction describes the assembly process of the PVC porthole with gasket on the leaf of a semi-insulating SI door. The procedure is also analogous for the swinging doors.

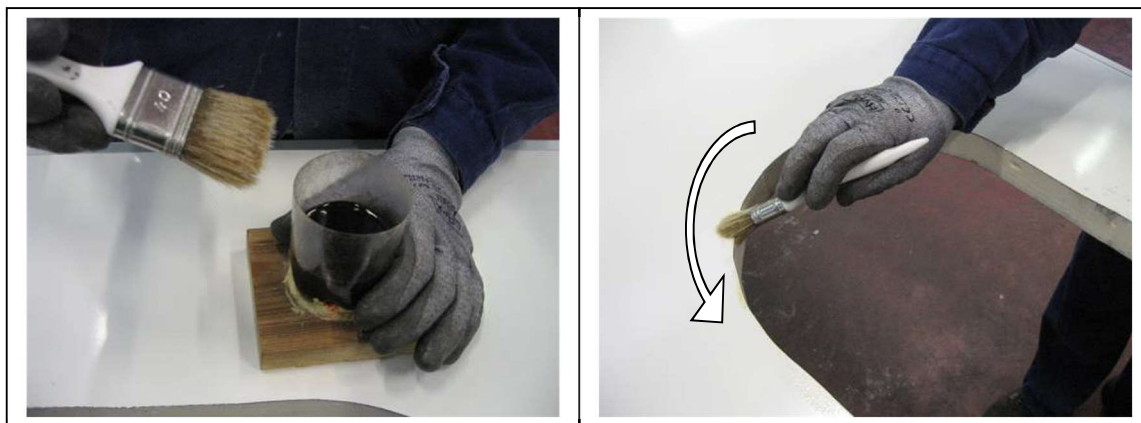
2. Assembly Phases



Phase 1: prepare to insert the porthole (1). Remove a part of the protective film of the porthole from both sides (2 - 3) to facilitate its removal after installation of the door.



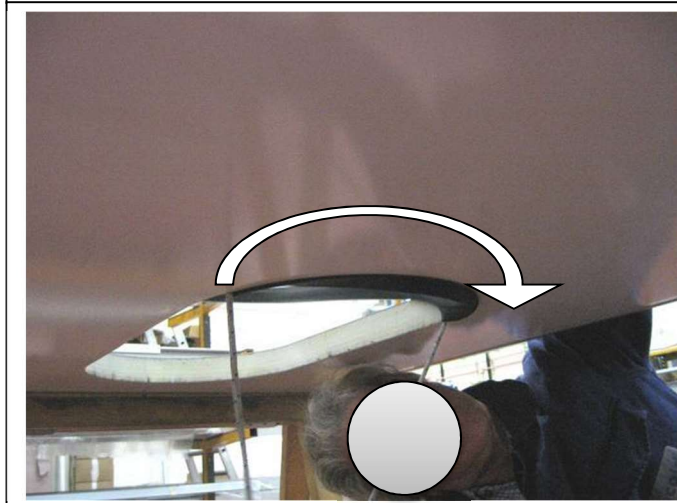
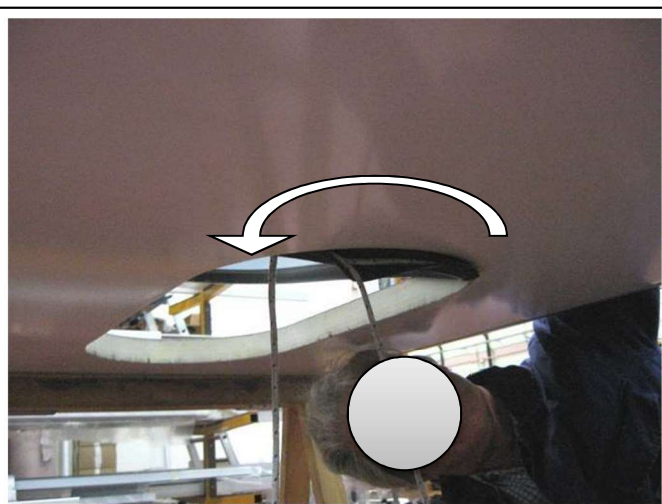
Phase 2: prepare the porthole for installation. Insert the gasket along the entire perimeter and make sure that the upper lip is in the correct position; use the screwdriver to extract it completely (5). Insert the cord on the internal side of the gasket, in the lower portion and around the entire perimeter, to facilitate its positioning on the lower side of the leaf.



***Phase 3:** distribute an anti-rust solution with a brush.*



***Phase 4:** position the porthole starting from the end (1) and making sure it is fully inserted using a hammer (2). Remove the upper lip of the seal from the inserted door portion (3 - 4). Complete the insertion of the front part of the porthole by hitting the opposite end with a rubber hammer (5).*



***Phase 5:** pull the ends of the rope for the section of the inserted seal, in both directions. This positions the lower lip of the gasket. After the operation, check the correct positioning of the lower lip.*



***Phase 6:** hit the porthole with a rubber hammer from the opposite end to the inserted one to complete the installation from the inserted side (1). Insert the opposite end (2).*



Phase 7: sequence for positioning the porthole. Insert the opposite end by arching the porthole (1); then press hard along the entire perimeter (2) and hit the porthole with the rubber hammer until it is fully inserted (3). Proceed with the extraction of the upper lip of the gasket (4) using a screwdriver (7), during the operation hit the porthole with a rubber hammer in the positions where it does not assume the horizontal position (5). Also hit the gasket with a hammer to make sure it adheres completely to the perimeter of the porthole hole (6) and (8). Complete the extraction of the upper lip of the gasket (7).



Phase 8: in the lower part of the porthole, pull the string to position the lower lip of the seal. At the end of the operation, make sure that the gasket is positioned correctly. Then beat the perimeter of the gasket with a hammer (see figure 8 in the previous phase).



Phase 9: clean the surface of the door and remove any processing residues.