

REV	DATE	DRAWN/CHKD	DESCRIPTION
C	10APR96	JSS	PRN: A8-11 (SEE REC. DWG)
D	22JUN2005	AAE/MDY	PRN: P2005-0758

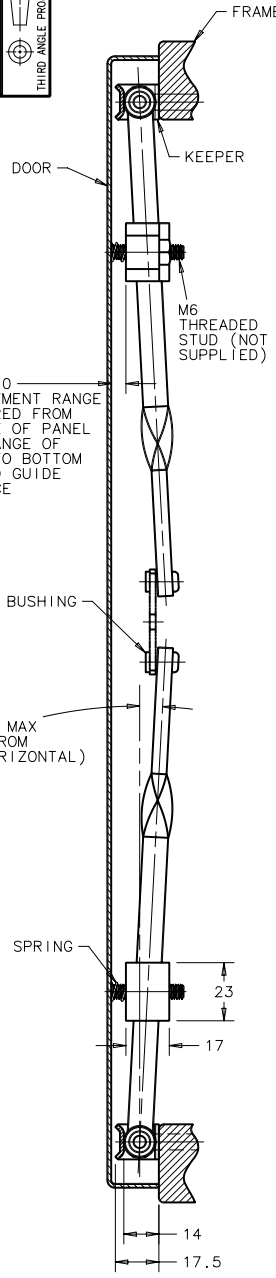
3 TO 10 ADJUSTMENT RANGE MEASURED FROM INSIDE OF PANEL OR FLANGE OF STUD TO BOTTOM OF ROD GUIDE SURFACE

MILLIMETERS
ALL DIMENSIONS WITHOUT TOLERANCES ARE FOR REFERENCE ONLY.

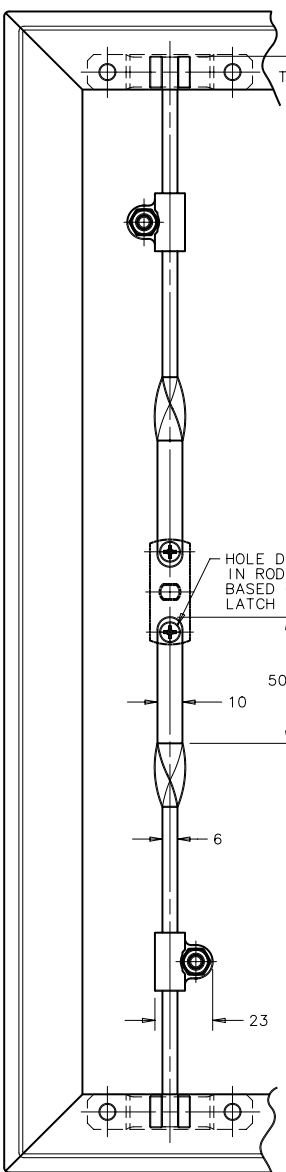
A3 PAPER SIZE
THIRD ANGLE PROJECTION

ROD ASSEMBLY PART NUMBER

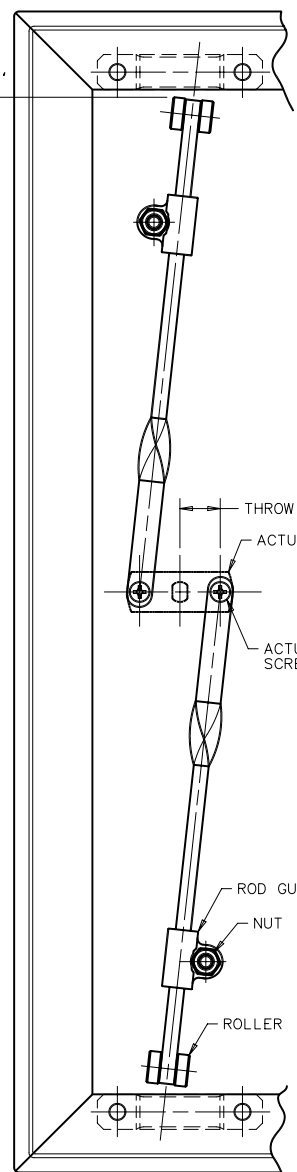
A8-10-XXXX
A8-11-XXXX (FOR PRODUCT CLASS 92)
A8-12-XXXX (FOR PRODUCT CLASS 01)



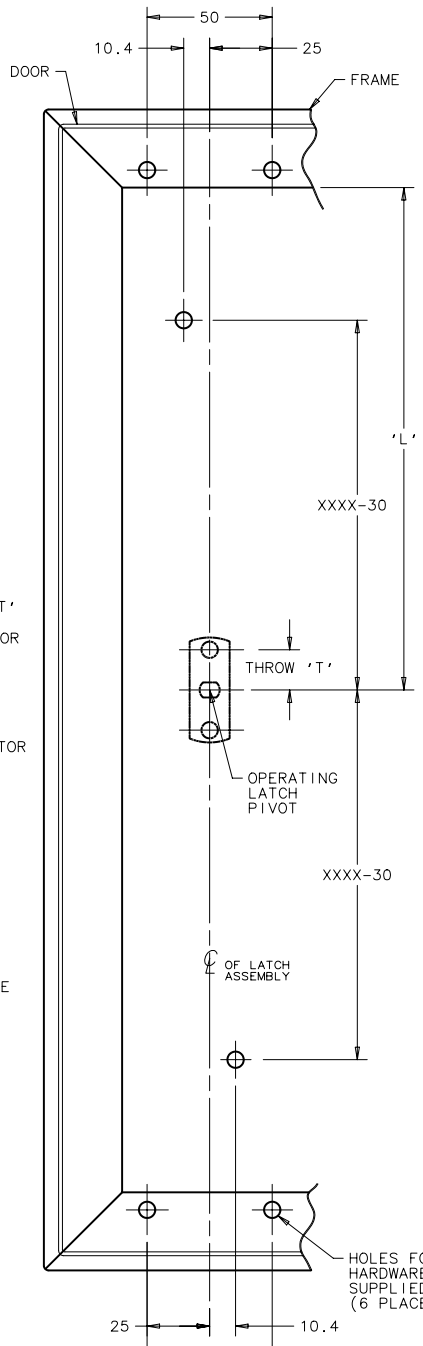
SIDE VIEW LATCHED POSITION



VIEWED FROM INSIDE ENCLOSURE LATCHED POSITION



VIEWED FROM INSIDE ENCLOSURE UNLATCHED POSITION



DOOR/FRAME PREPARATION

MATERIAL AND FINISH:

ROD: 6061 ALUMINUM, NATURAL
ROLLER: BRASS, NATURAL
RIVET: 7050 ALUMINUM, CLEAR ANODIZED
ROD GUIDE: NYLON, NATURAL
SPRING: 302 STAINLESS STEEL, PASSIVATED
NUT: LOW CARBON STEEL, ZINC PLATED PLUS YELLOW CHROMATE DIP
KEEPER: 1010 STEEL, ZINC ALLOY PLATED, BRIGHT CHROMATE PLUS SEALER

ROD LENGTH SELECTION:

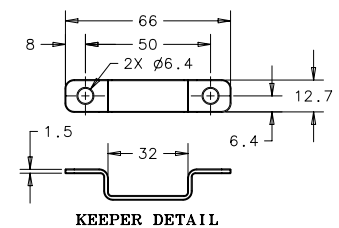
1. DETERMINE THE LATCH CENTERLINE POSITION ON THE DOOR, USING THE RECOMMENDED LATCH POSITION FROM FRAME EDGE. THE LATCH CENTERLINE WILL ALSO BE THE ROD ASSEMBLY CENTERLINE. THE LATCH CENTERLINE PIVOT POINT TO THE CORRESPONDING FRAME EDGE IS WHERE THE ROD LENGTH IS DETERMINED. THIS IS IMPORTANT TO INSURE THAT THE ROLLERS CLEAR THE FRAME WHEN THE DOOR IS OPENED. THE AMOUNT OF ROLLER CLEARANCE FROM THE FRAME EDGE IS DIRECTLY PROPORTIONAL TO THE THROW OF THE ACTUATOR AND THE AMOUNT OF ROLLER ENGAGEMENT ON THE KEEPER OR FRAME.
2. DETERMINE ROD LENGTH(S), IN MILLIMETERS FROM 250 MIN. TO 1500 MAX., USING THE FOLLOWING FORMULA:
$$L - T + 7 = XXXX$$
WHERE THE VARIABLES AND CONSTANTS ARE:
L = LATCH PIVOT CENTERLINE TO FRAME EDGE DIMENSION
T = LATCH ACTUATOR THROW
7 = ROLLER ENGAGEMENT CONSTANT
XXXX = ROD LENGTH(S) ORDERED BY CUSTOMER
3. THE ROD ASSEMBLY LENGTH DETERMINED IN STEP 2 SHOULD BE ROUNDED DOWN TO THE NEXT SMALLEST MILLIMETER. EXAMPLE: IF YOU DETERMINE YOUR ROD LENGTH TO BE 624.6 MILLIMETERS, THEN THE ROD LENGTH (XXXX) IS 0624. FOR ASSEMBLIES OVER 1500 MILLIMETERS, CALL SOUTHCORP FOR INFORMATION.
4. THE ROD ASSEMBLIES ARE ORDERED TWO OF THE SAME LENGTH OR ONE EACH OF DIFFERENT LENGTHS.

ASSEMBLY INSTRUCTIONS:

1. ATTACH EACH ROD ASSEMBLY TO AN ACTUATOR USING ONE M4x8 MACHINE SCREW AND THREADED BUSHING (APPLY 1.7 Nm TORQUE TO SECURE). ROD END MAY BE FASTENED TO THE TOP OR BOTTOM SIDE OF THE ACTUATOR. THE ROD ANGULAR POSITION MUST NOT EXCEED 5 DEGREES MAXIMUM, MEASURED FROM THE ROD ROLLER END.
2. PLACE SPRING AND ROD GUIDE ON A M6 THREADED STUD (NOT SUPPLIED). DEPRESS ROD GUIDE 1.5 MILLIMETERS MINIMUM AND THREAD THE NUT ONTO THE STUD. DEPRESS THE ROD GUIDE TO ADJUST THE POSITION OF THE NUT FOR UP TO 3 MILLIMETER ROLLER ENGAGEMENT. **NOTE:** DEPRESS ROD GUIDE BEFORE ADJUSTING. FAILING TO DEPRESS THE ROD GUIDE BEFORE ADJUSTING MAY STRIP ITS DETENT. THE ROD GUIDE IS DESIGNED WITH AN INTEGRAL NUT LOCKING FEATURE TO PREVENT THE NUT FROM ROTATING.
3. OPTIONAL KEEPER, PART NUMBER A8-60 (ORDER SEPARATELY-ONE PER EACH ROD) IS MOUNTED ON THE FRONT SIDE OF THE FRAME. THE KEEPER EDGE IS ALIGNED TO THE INSIDE EDGE OF THE FRAME. OTHERWISE, THE ROLLERS CAN ENGAGE ON THE BACKSIDE OF THE FRAME. THE FRAME MUST HAVE A 3 MILLIMETER MINIMUM OUTSIDE RADIUS OR CHAMFER TO INSURE SMOOTH ROLLER ENGAGEMENT DURING LATCH ACTIVATION, IF KEEPER IS NOT USED.

ASSEMBLY INSTRUCTIONS FOR PRODUCT CLASS 01 AND 92 ASSEMBLIES:

1. PLACE EACH ROD ASSEMBLY ONTO THE STUD OF THE PAWL (OR ACTUATOR) SUB-ASSEMBLY. THEN PLACE THE APPROPRIATE HARDWARE FROM THE ROD AND LATCH ASSEMBLIES ONTO THE LATCH SHAFT. THE ROD END MAY BE FASTENED TO THE TOP OR BOTTOM SIDE OF THE ACTUATOR. THE ROD ANGULAR POSITION MUST NOT EXCEED 5 DEGREES MAXIMUM, MEASURED FROM THE ROD ROLLER END.
2. NOW REFER TO STEPS 2 AND 3 OF THE ABOVE ASSEMBLY INSTRUCTIONS.



KEEPER DETAIL