

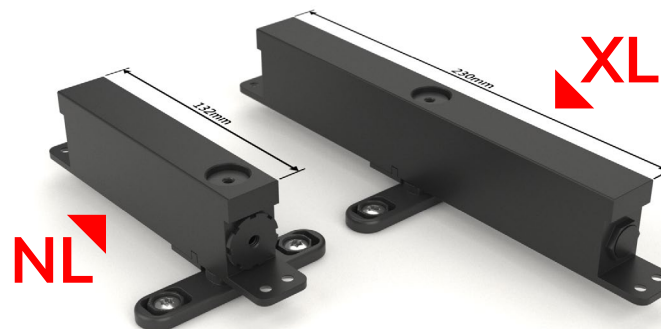
ASSEMBLY MANUAL

PortaPivot 6530

Depending on the selected door size, a **normal (NL)** or **extra large (XL)** pivot hinge is included. All installation steps are identical, unless stated otherwise.

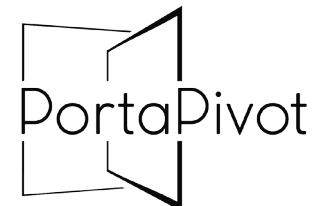
◀ **NL pivot hinge**
Door width smaller than 1250 mm.

XL pivot hinge ▶
Door width larger than 1250 mm.

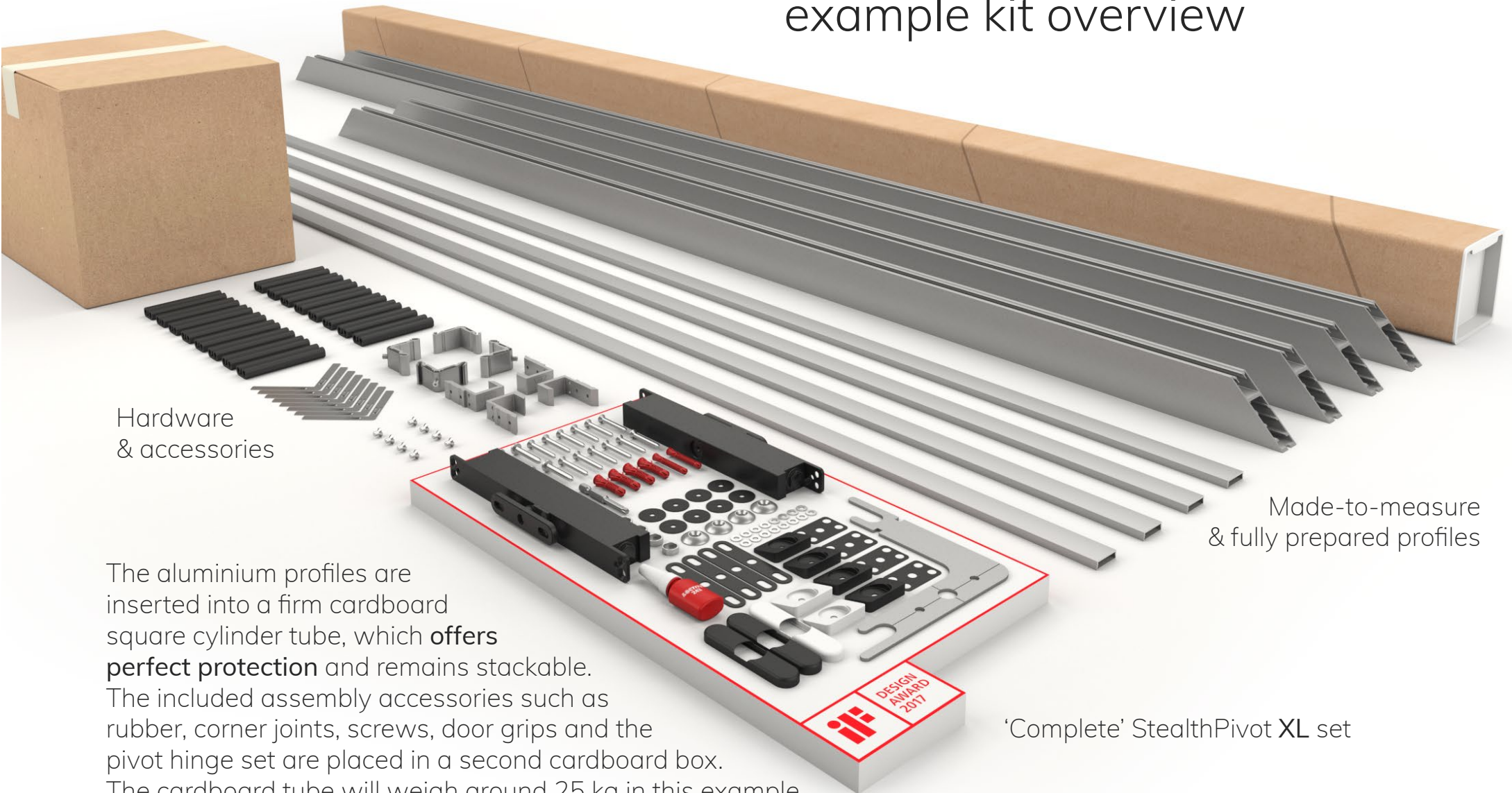


Patented technology

STEALTHPIVOT
By PortaPivot



PortaPivot 6530 **XL** example kit overview



Hardware
& accessories

Made-to-measure
& fully prepared profiles

The aluminium profiles are inserted into a firm cardboard square cylinder tube, which **offers perfect protection** and remains stackable. The included assembly accessories such as rubber, corner joints, screws, door grips and the pivot hinge set are placed in a second cardboard box. The cardboard tube will weigh around 25 kg in this example and the square box will weigh around 5 kg.

'Complete' StealthPivot **XL** set

Materials to be purchased locally:

- Safety glass or paneling
- Silicone spray

Recommended tools:



Rubber hammer



Saw cut marker
(Supplied with kit)



Wooden wedge



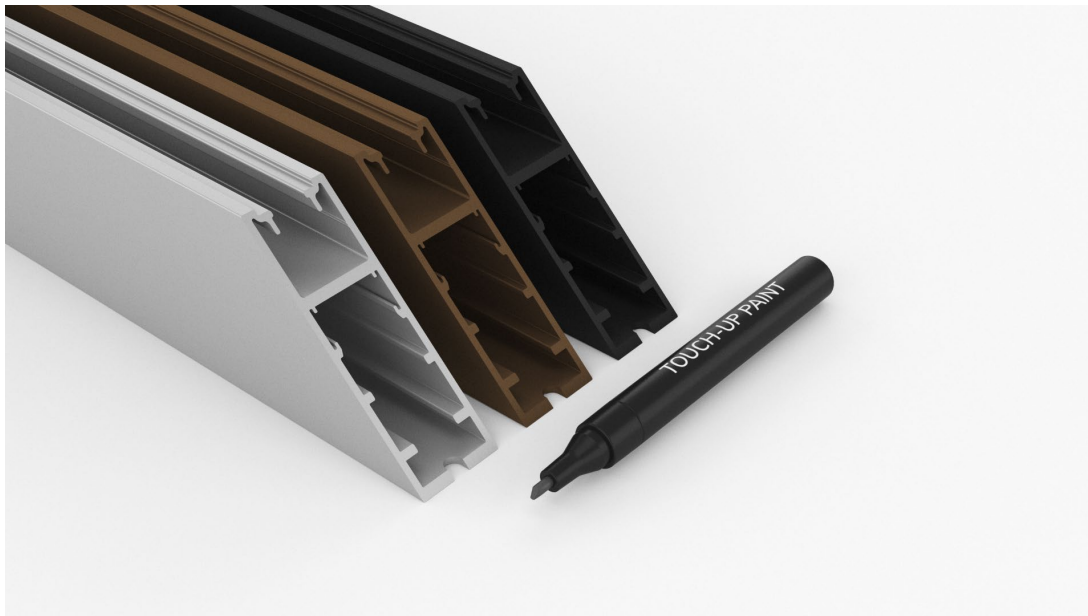
Bit screwdriver



Rigid 2mm aid
(Supplied)



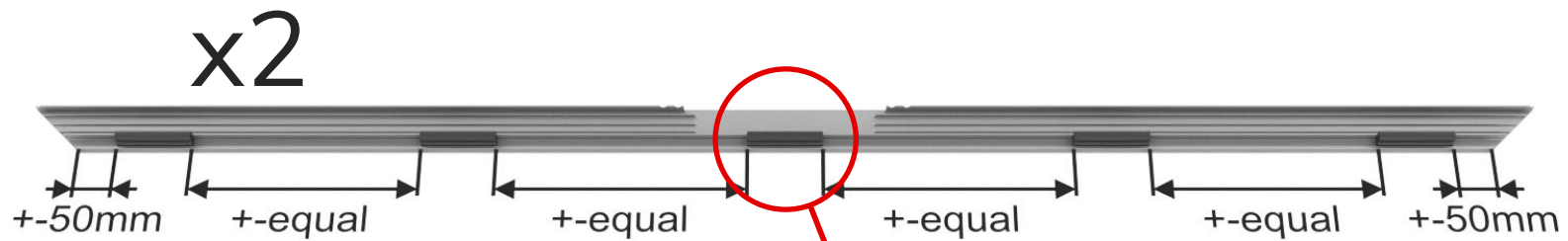
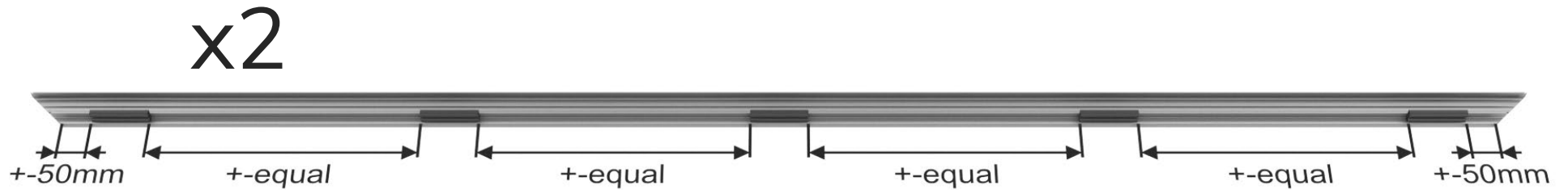
Degrease the saw cuts and use the supplied marker to paint the cuts.



Remove excessive paint from visual sides with acetone or alike

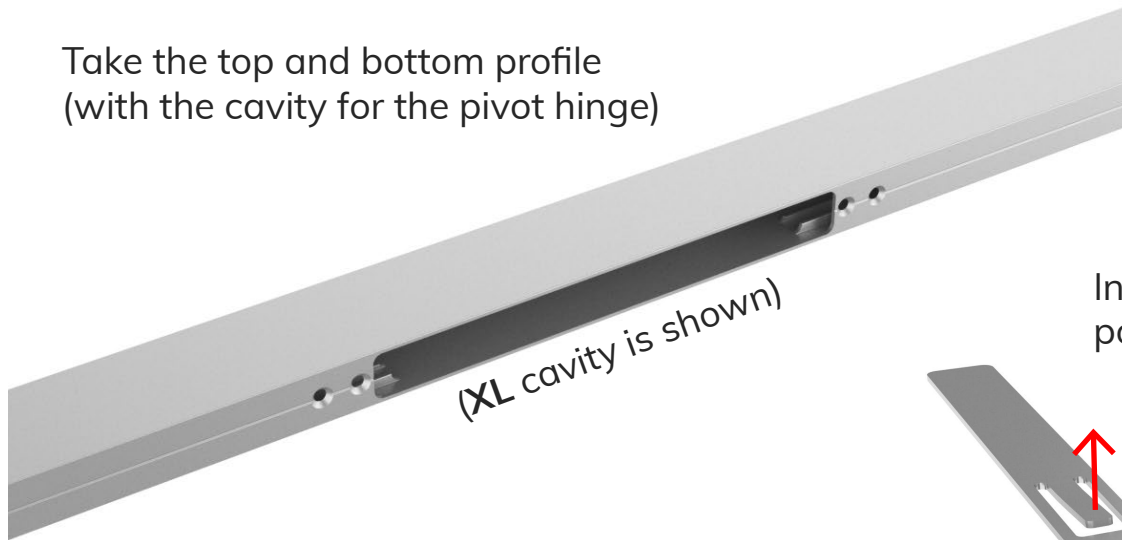
Slide in 5 EPDM inserts (GLB6-8) into every profile, and distribute them evenly.

Beware: sharp edges!

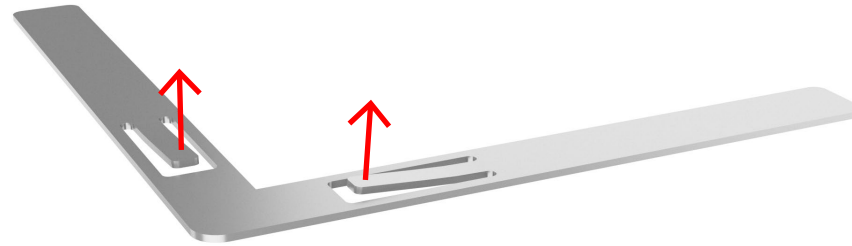


Always position 1 insert above pivot axis

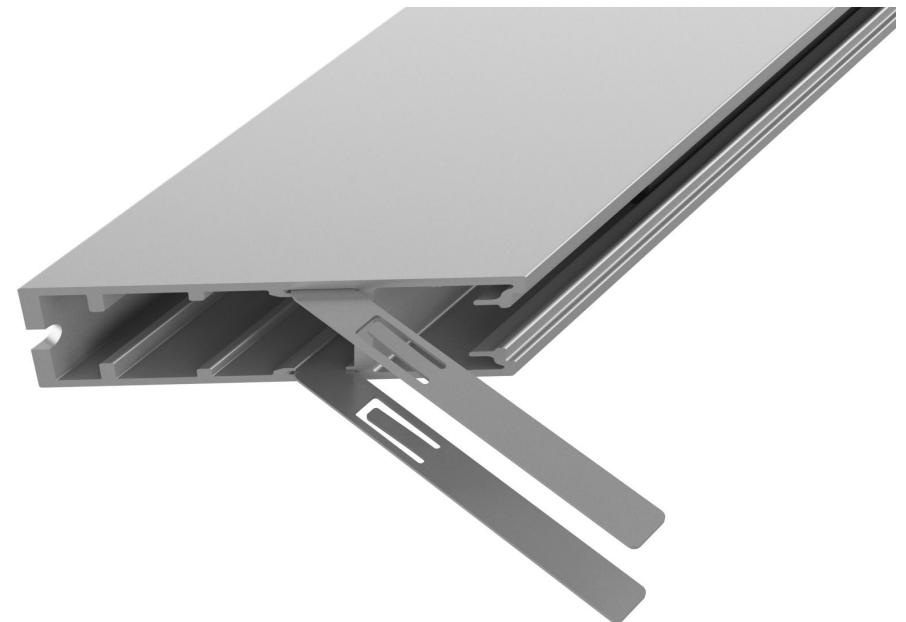
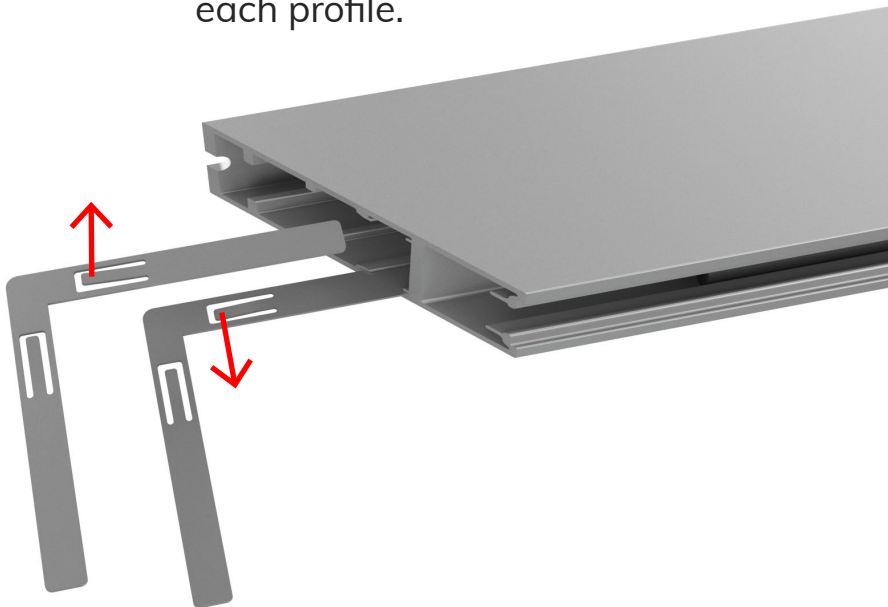
Take the top and bottom profile
(with the cavity for the pivot hinge)



Install the corner guide with the clamps
pointing towards the outside of the profile.



Insert 2 corner guides in each end of
each profile.

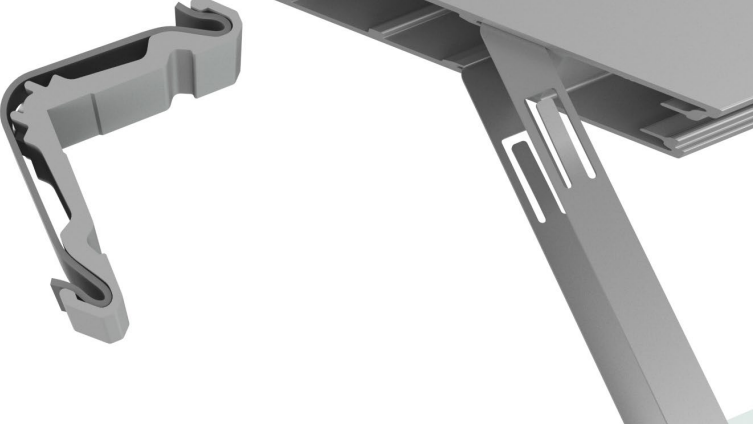


StealthPivot **NL** and StealthPivot **XL** share identical installation steps

do not tighten!



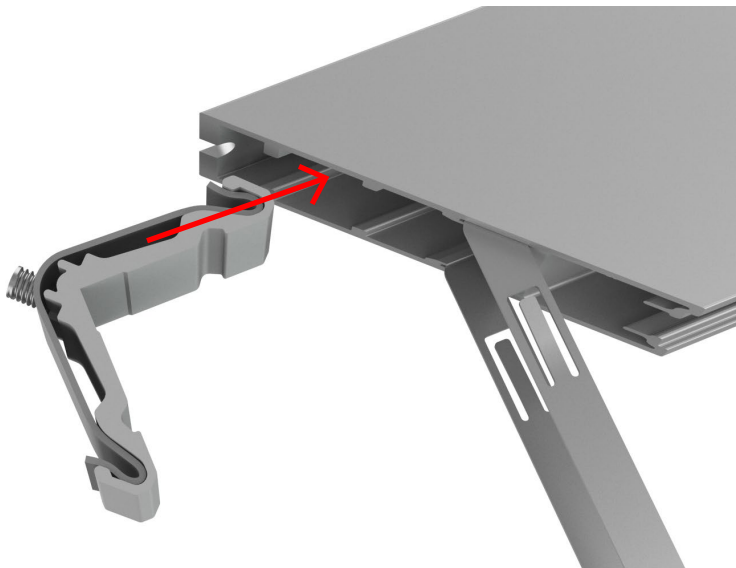
Locktite



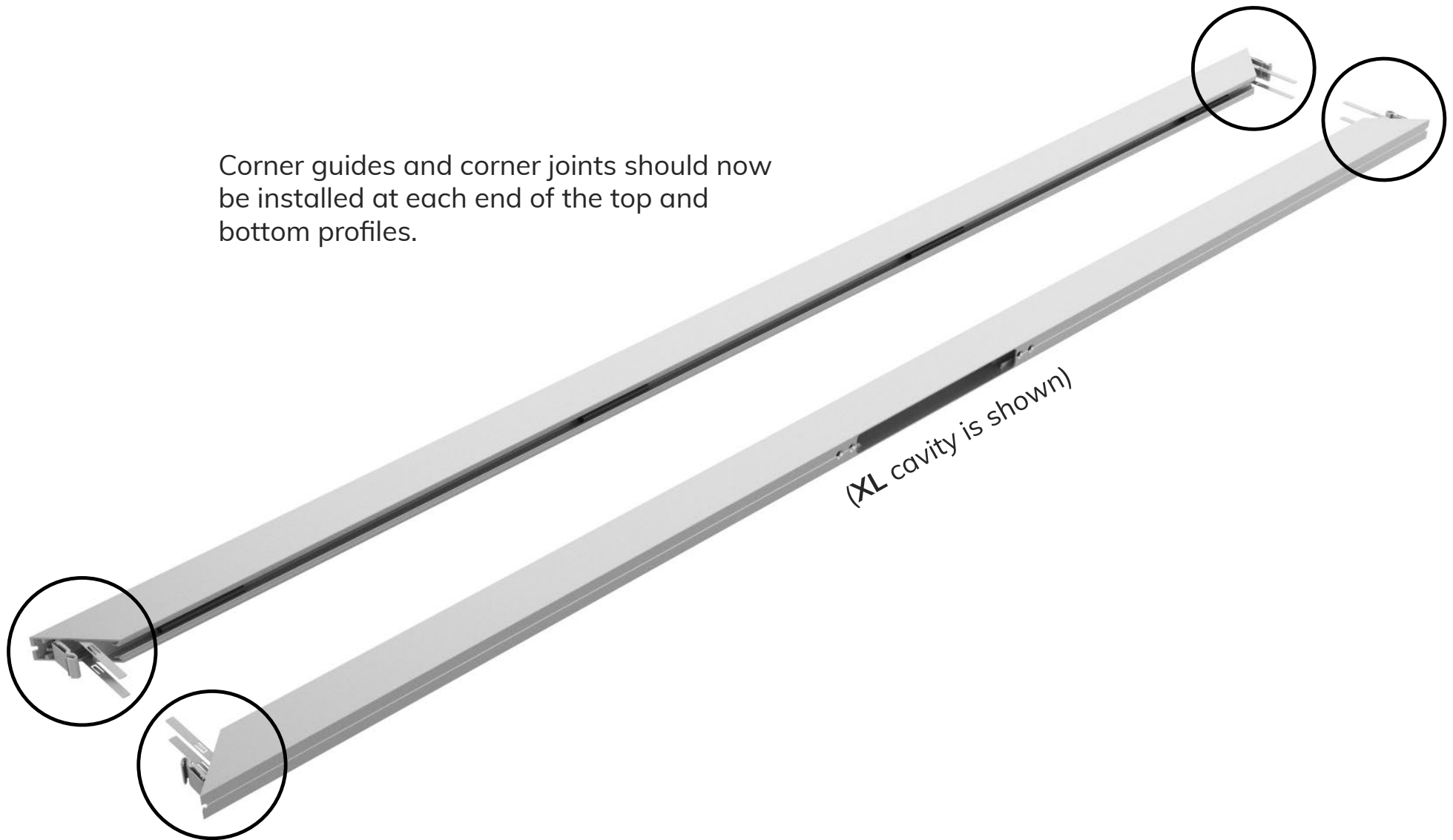
The corner joint comes pre-assembled.

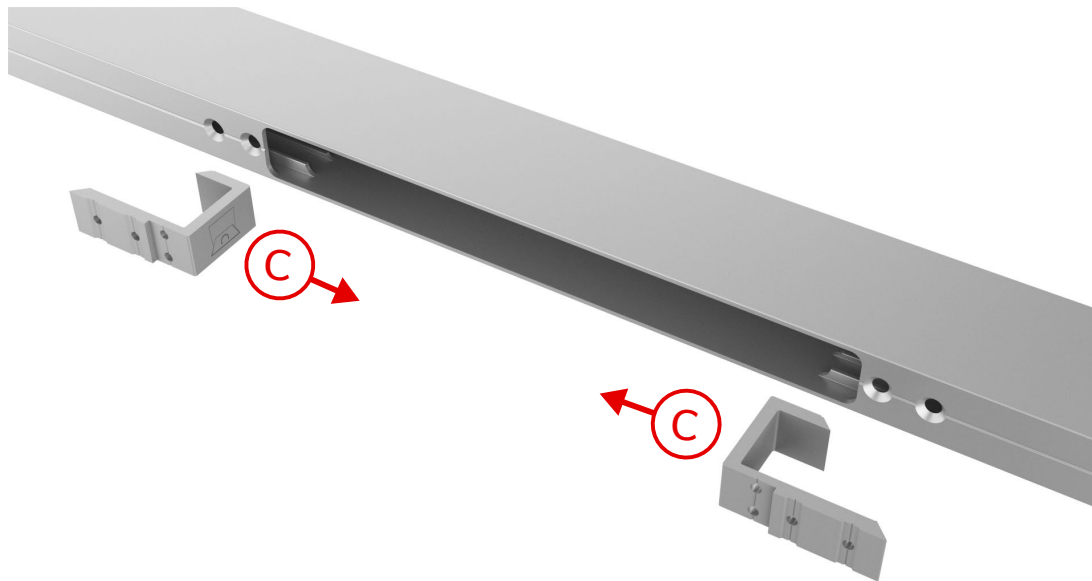
Insert the inbus screw, apply locktite, **but do not tighten yet!**

Slide the corner joint into each end of the top and bottom profile.

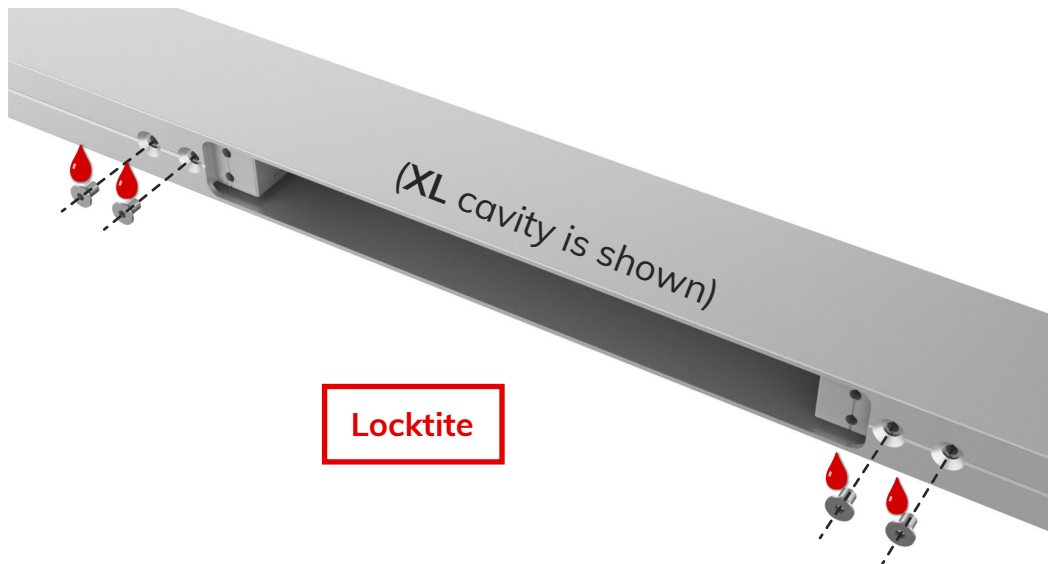


Corner guides and corner joints should now be installed at each end of the top and bottom profiles.



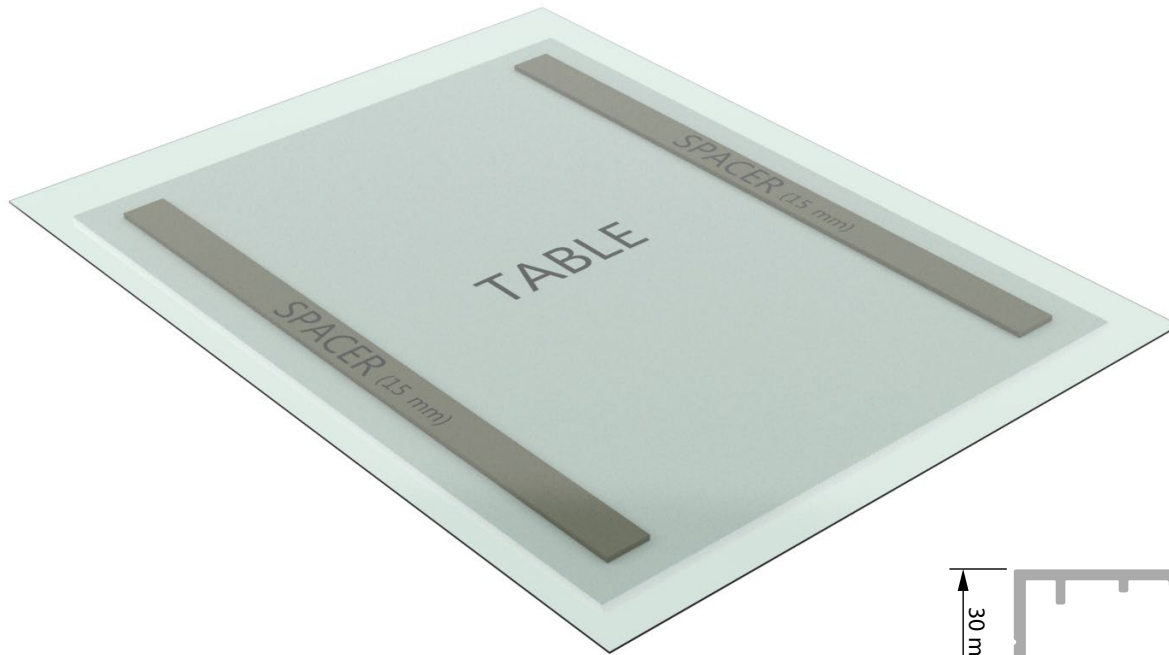


In both top and bottom profiles, slide in the parts labelled C with their labels facing inwards.



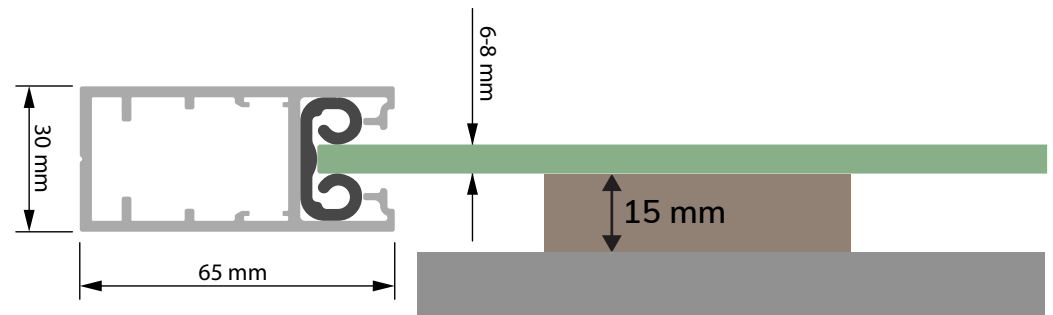
Insert 4 screws.
Use locktite on all screws.

Do not tighten fully yet!

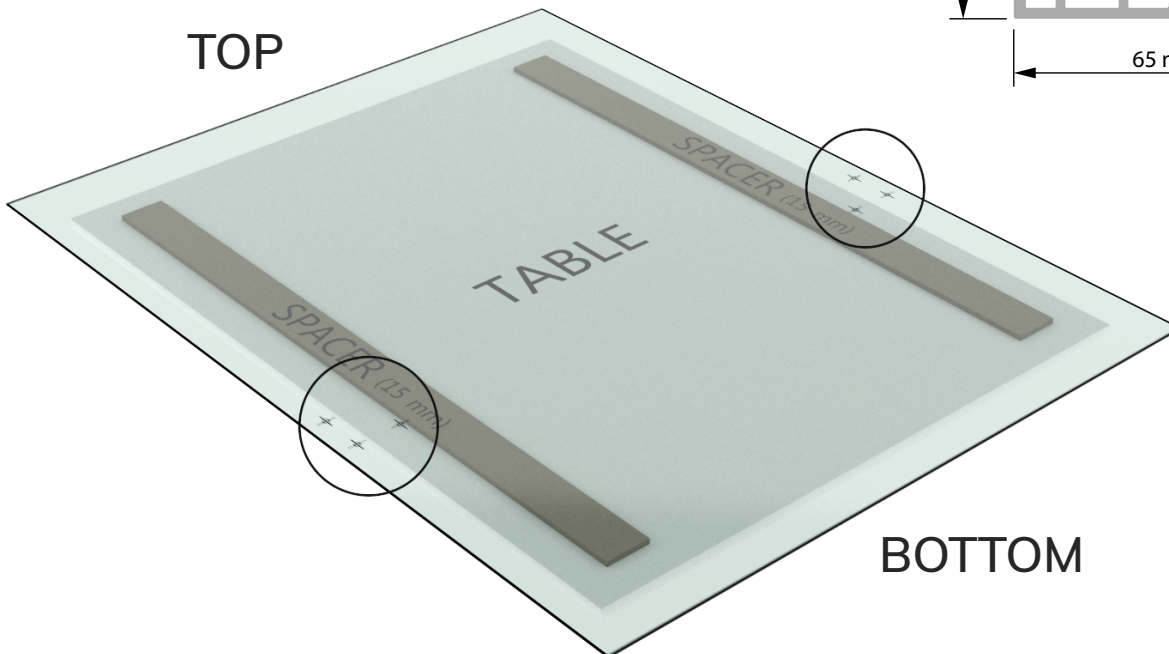


Use 2 wooden spacers (+-15 mm thick) on an assembly table and place the locally purchased panel on top.

Spacers are needed to provide space when mounting the aluminium profiles around the panel.

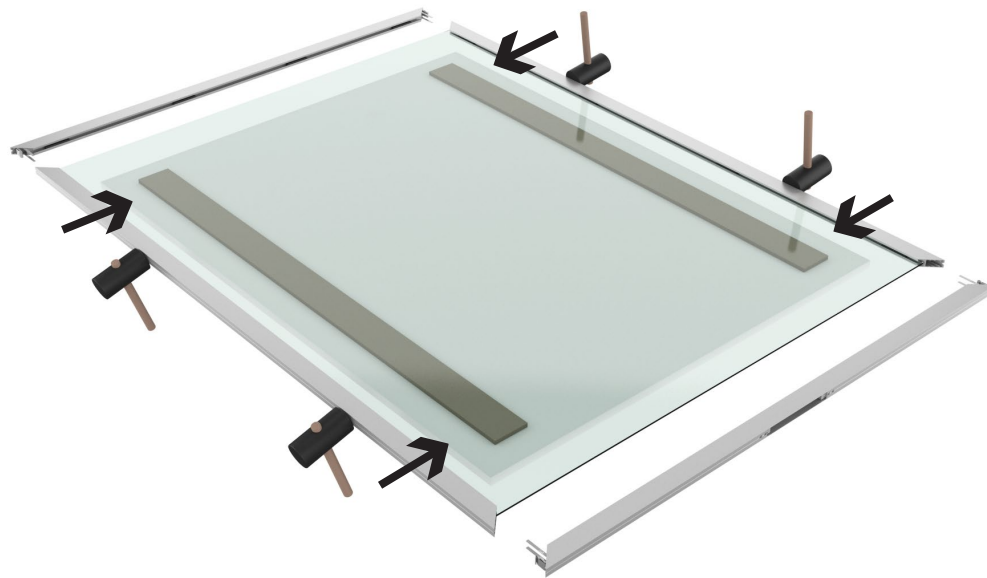


TOP



BOTTOM

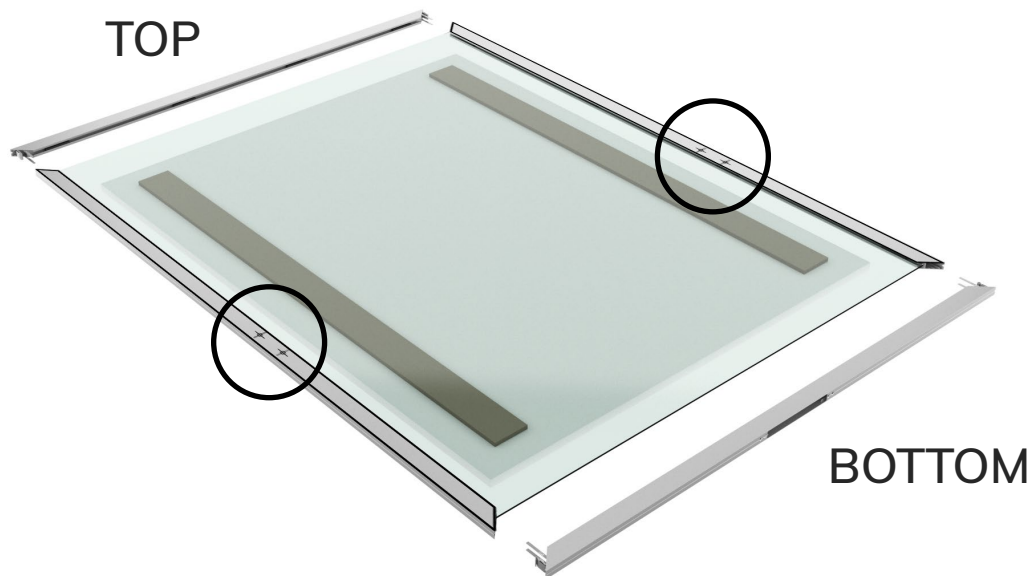
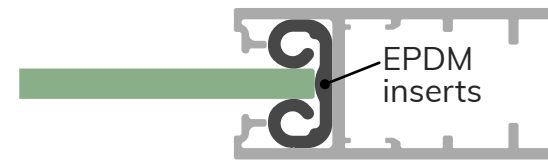
If your panel has pre-drilled holes, note that it has a top and bottom side!



Push left and right profile with their EPDM inserts over the panel.

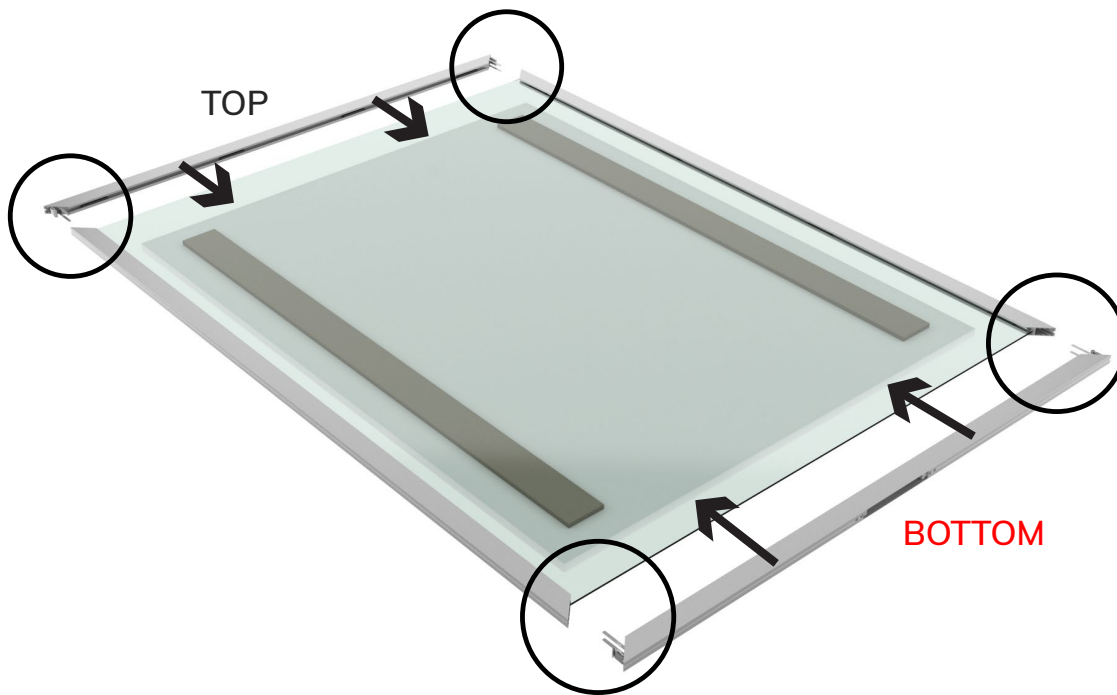
Apply extra silicone spray on EPDM inserts if necessary.

Use a rubber hammer to facilitate positioning.



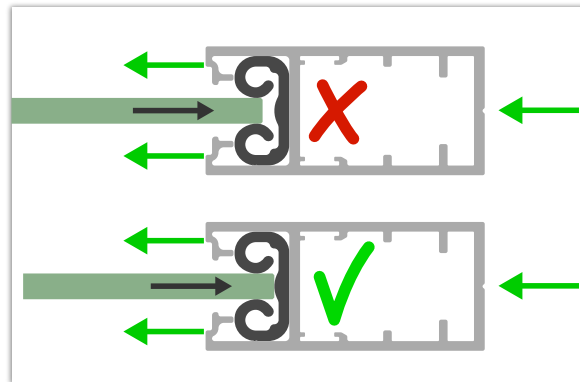
Careful: don't drop profiles!

If there are holes for doorgrrips in the profiles, their top/bottom orientation is important.

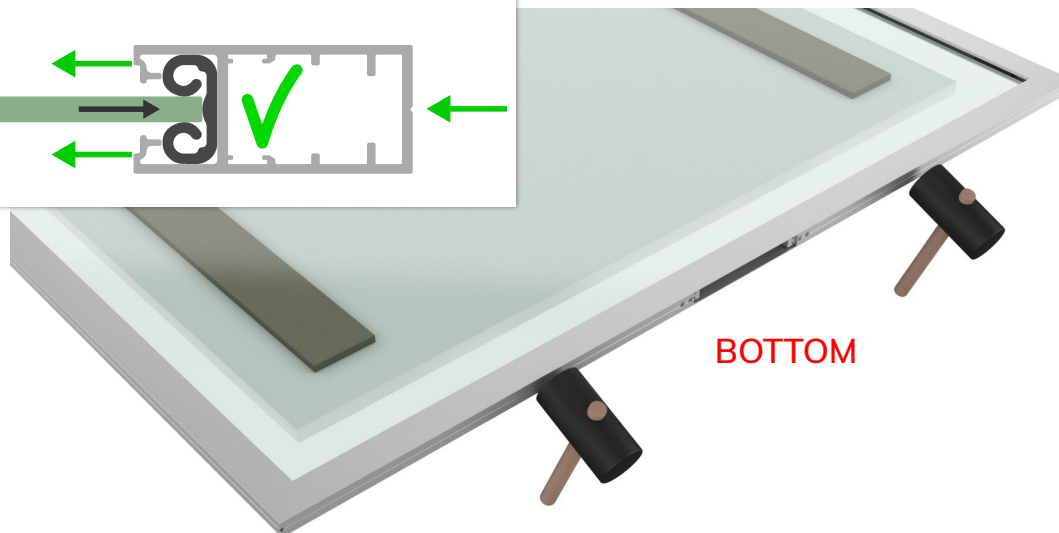


Carefully slide the top and bottom profile into left and right profile, and over the panel.

Careful: don't drop profiles!

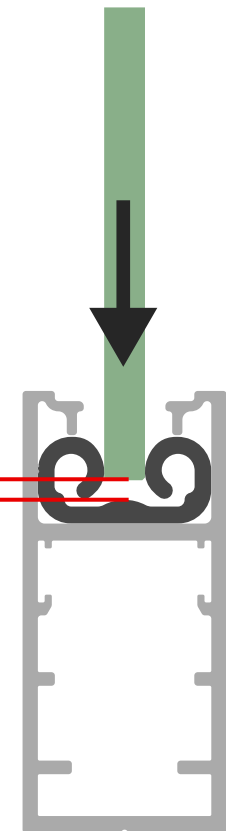


Step 4: When all profiles are inserted, use a rubber hammer to position the bottom profile with the EPDM inserts against the panel.

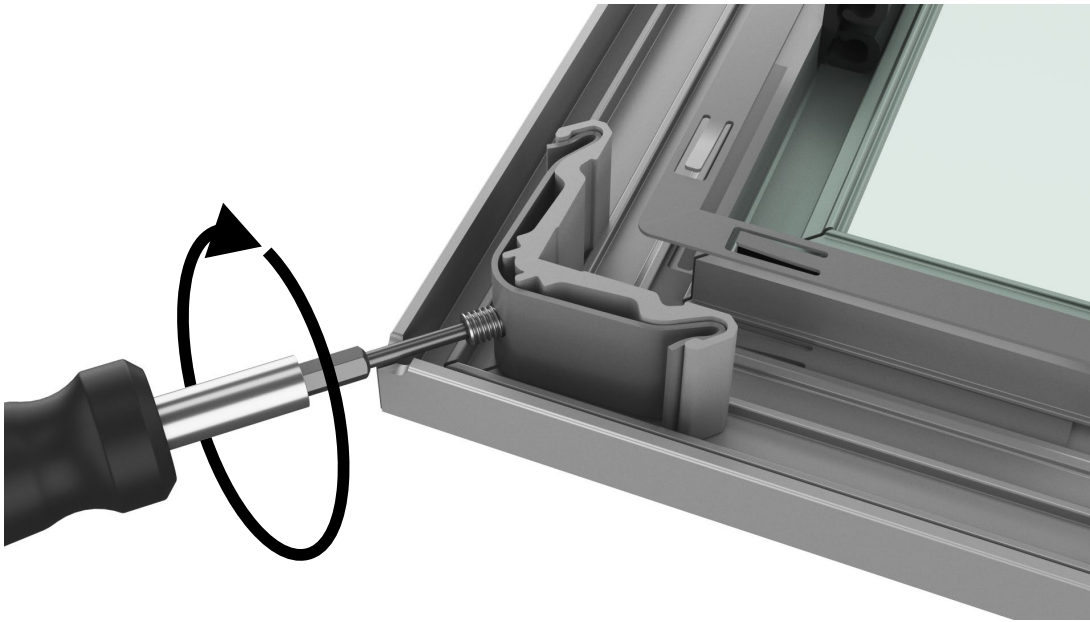


must be 0 mm!!

If NOT positioned correctly, the panel will slide down when the fully assembled door is put upright!!



BOTTOM

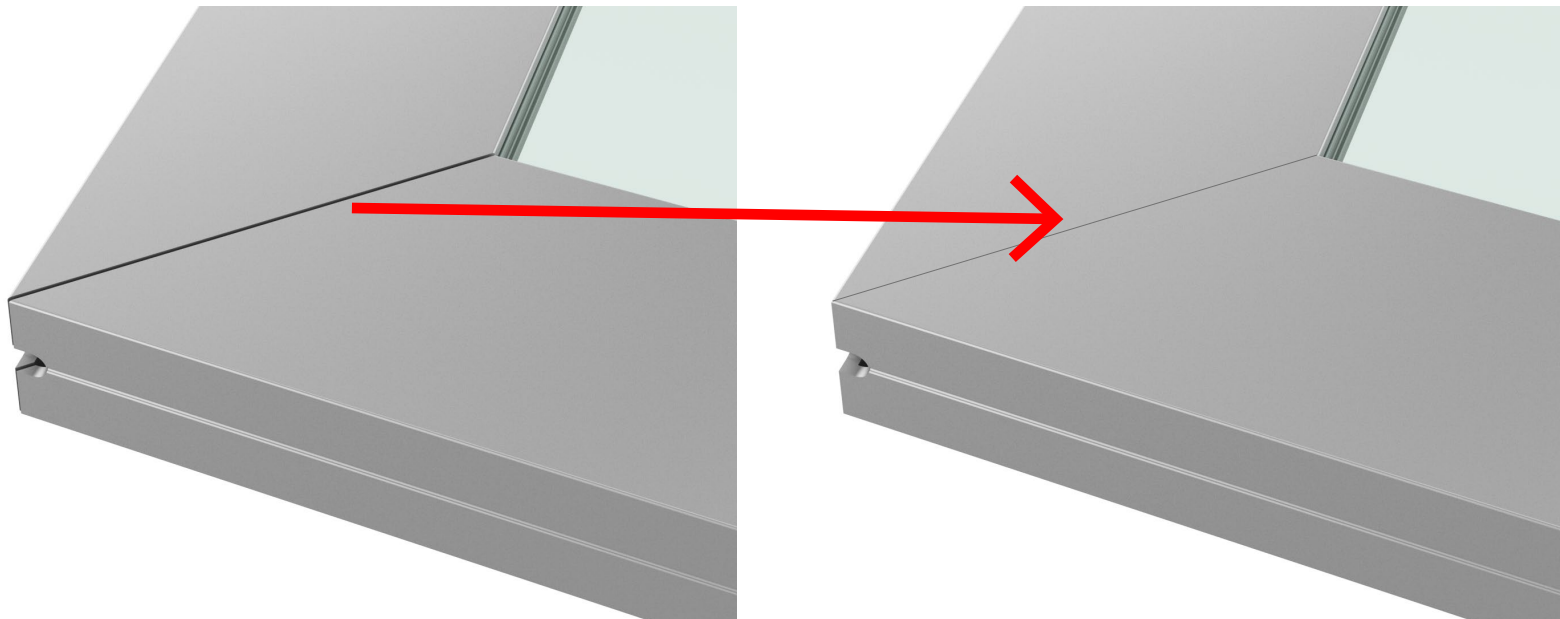


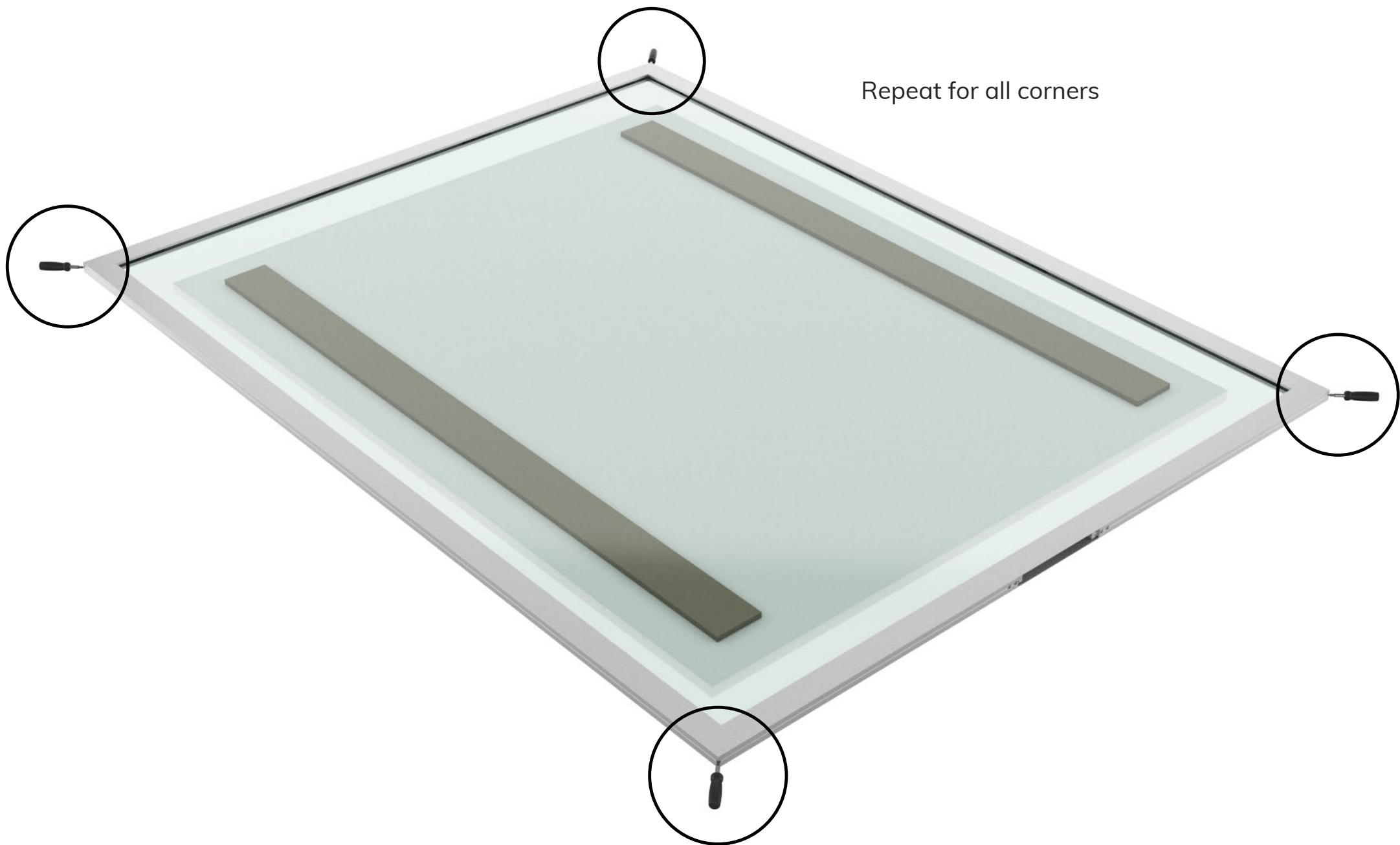
**Carefully tighten the inbus screw by hand!
Over-tightening will damage the corner joint!**

By tightening the inbus screw inside the corner joint, the profiles will be secured to each other.

This will also clear any gaps between the profiles.

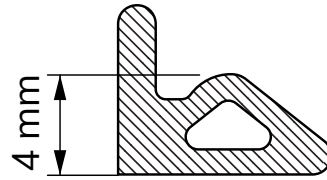
Make sure to carefully align the profiles as best as possible before tightening the inbus screw.



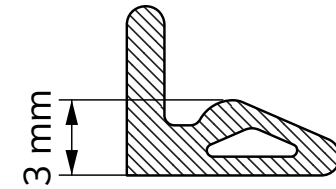


Repeat for all corners

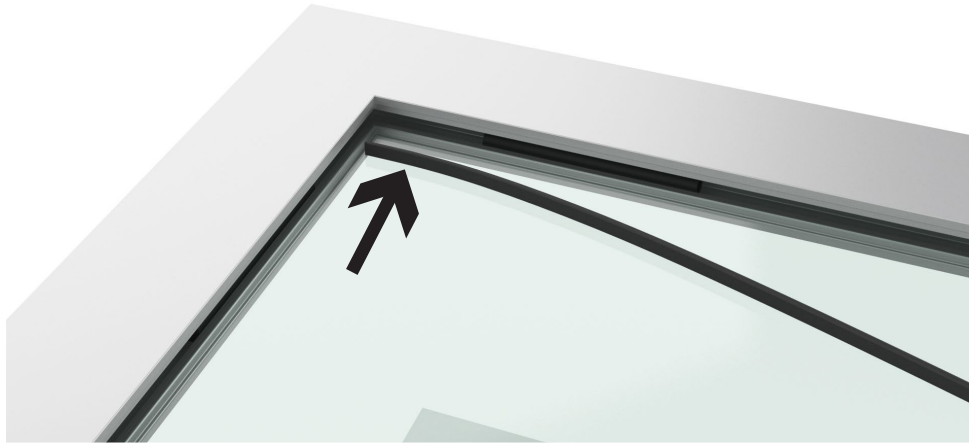
Use the appropriate rubber filler for 6 mm or 8 mm thick panels.



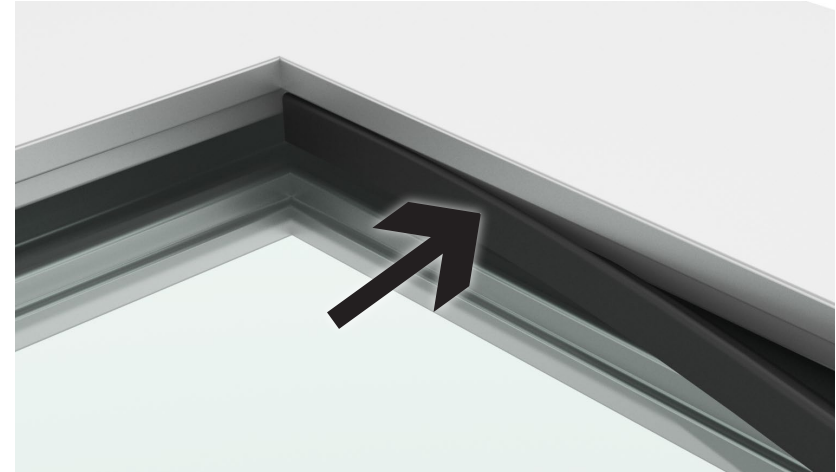
6mm panel
use GBL6



8mm panel
use GBL8

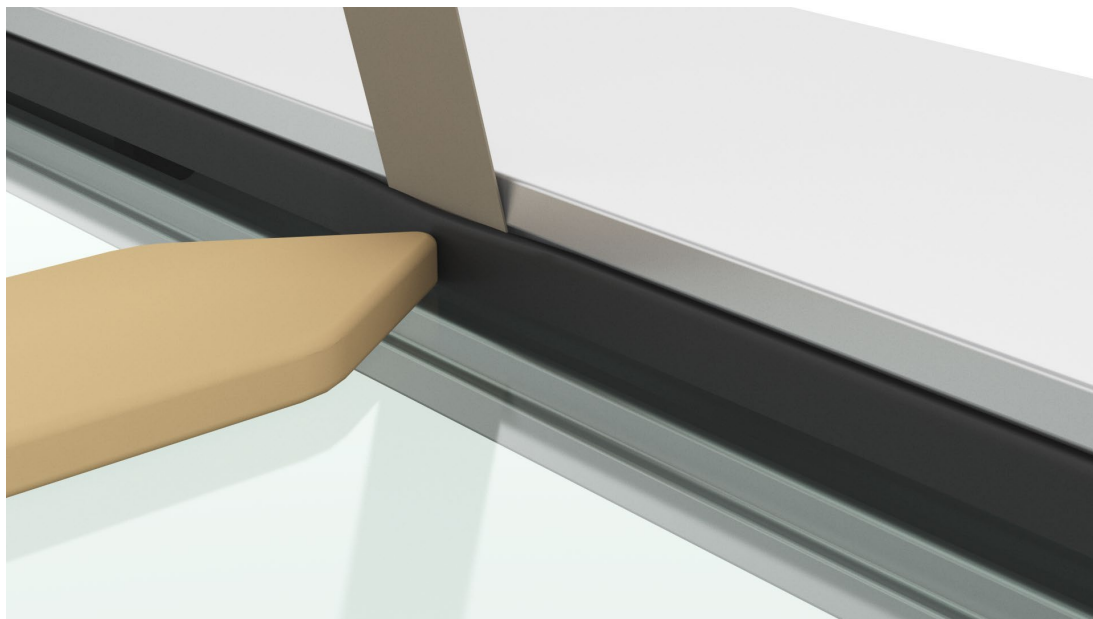


Push the rubber profile in the top left corner.

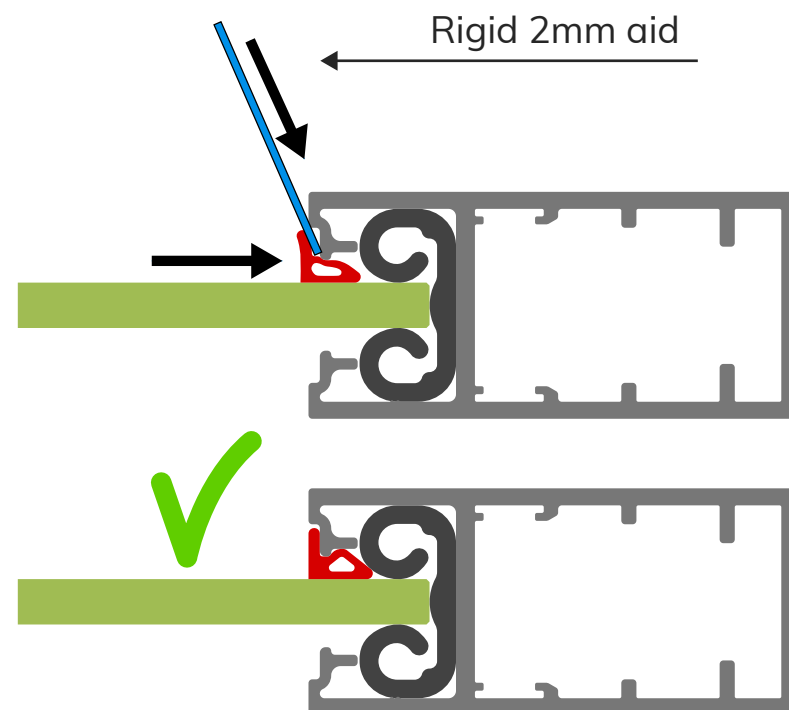


Push in at a further point, and work your way backwards to prevent stretching of the rubber profile while mounted.

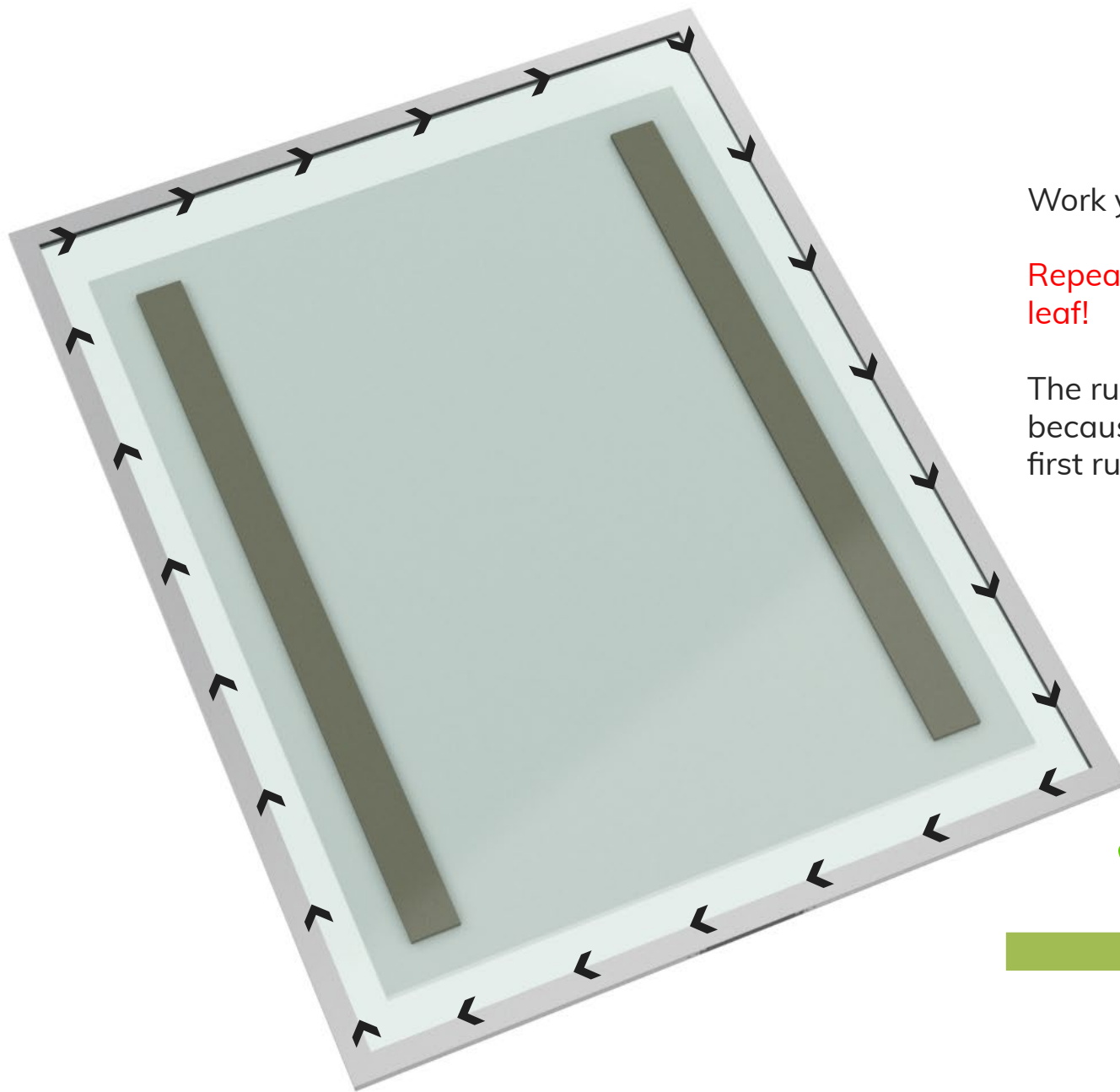




If rubber doesn't pop into place well, use 2 mm supplied aid to press the rubber down while pushing it in place.



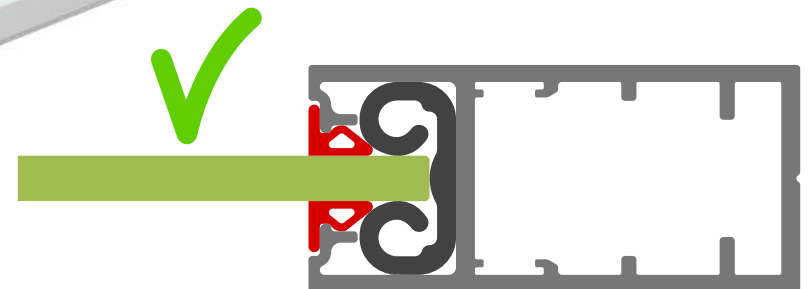
Use a wooden tool to press the rubber tightly (90°) into the corners without stretching it.



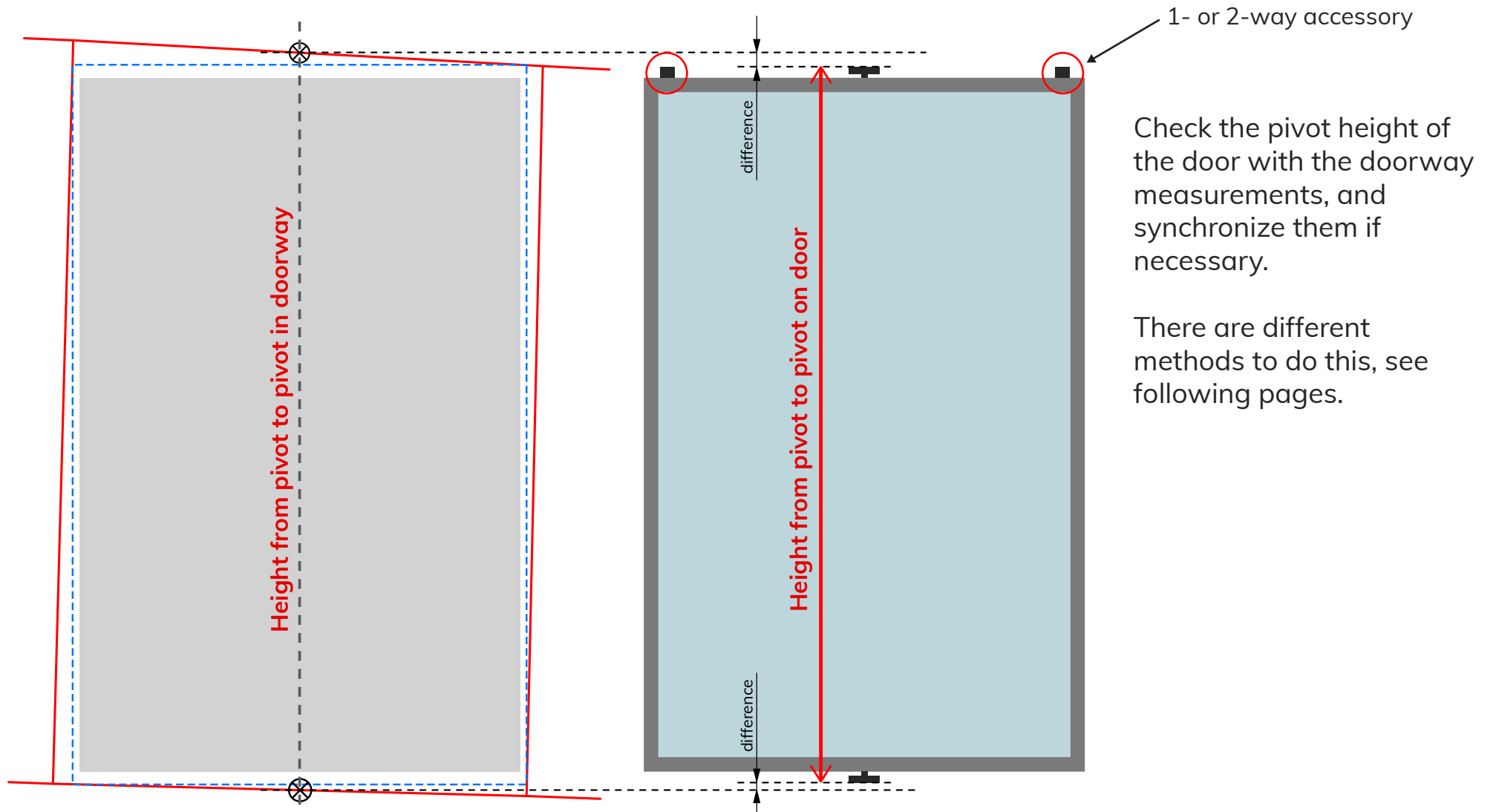
Work your way all around.

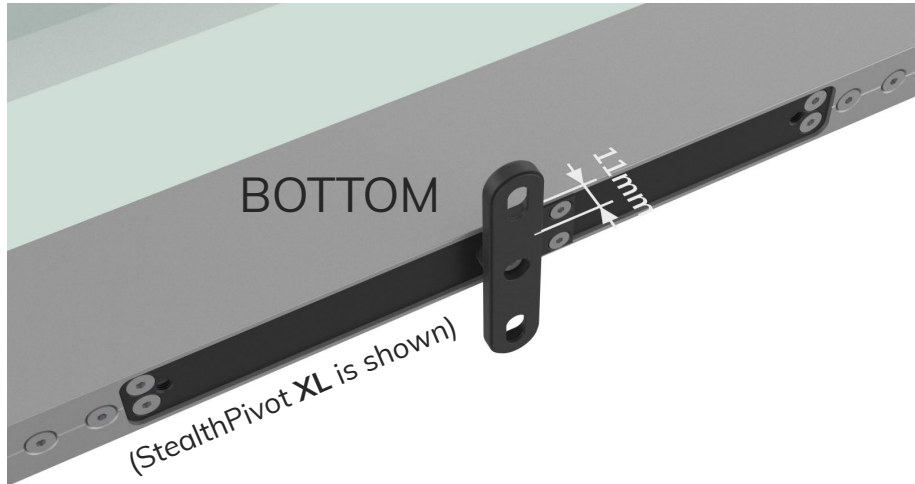
Repeat for the counterside of the door leaf!

The rubber profile will be harder to insert because of the counterpressure from the first rubber.



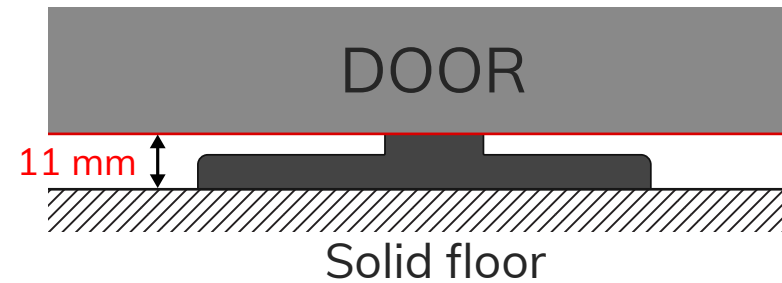
Synchronize pivot axis height in doorway





Adjust bottom hinge height

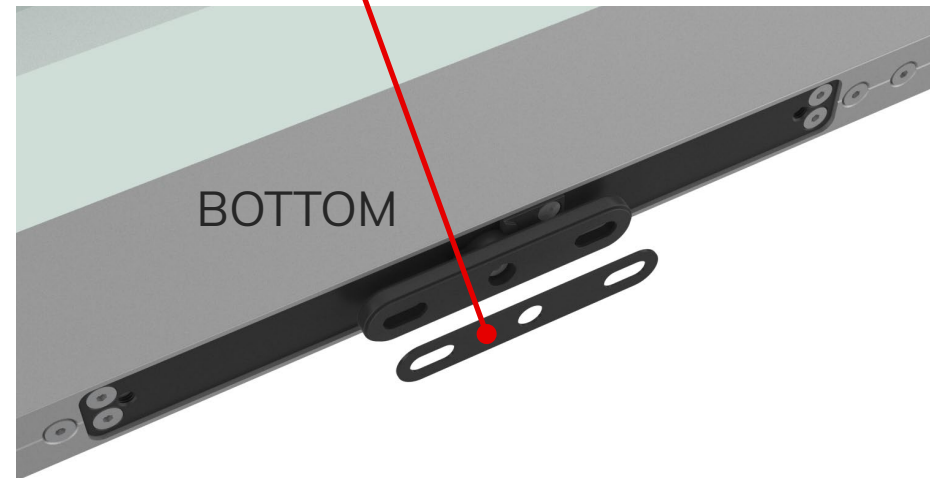
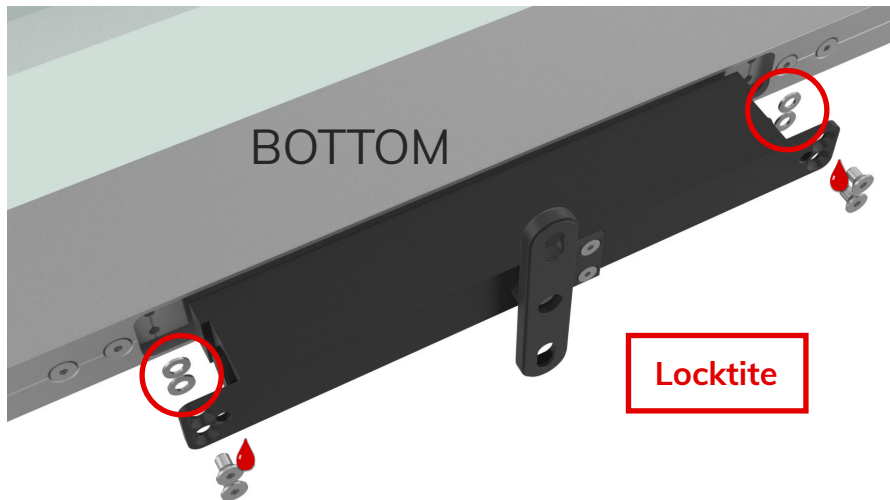
The default bottom joint dimension is 11 mm
(=distance between floor and door leaf edge).



To increase the bottom joint, you have 2 options:

1. Use (supplied) shims between hinge and door leaf.
This is the preferred method for the bottom hinge.

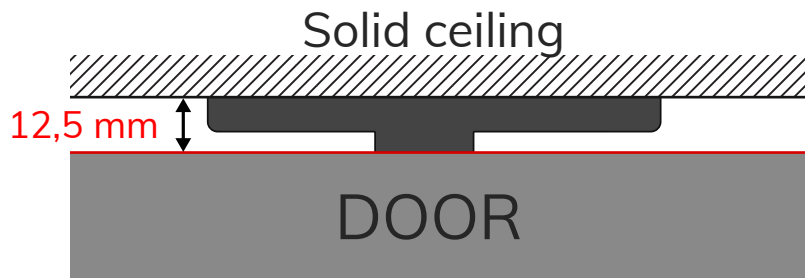
2. Use supplied shims between floor and hinge
(= less stable).



StealthPivot **NL** and StealthPivot **XL** share identical installation steps

Adjust top hinge height

The default top joint dimension is 12,5 mm (=distance between ceiling and door leaf edge). This is necessary for the optional 1-way accessory and positioning magnets

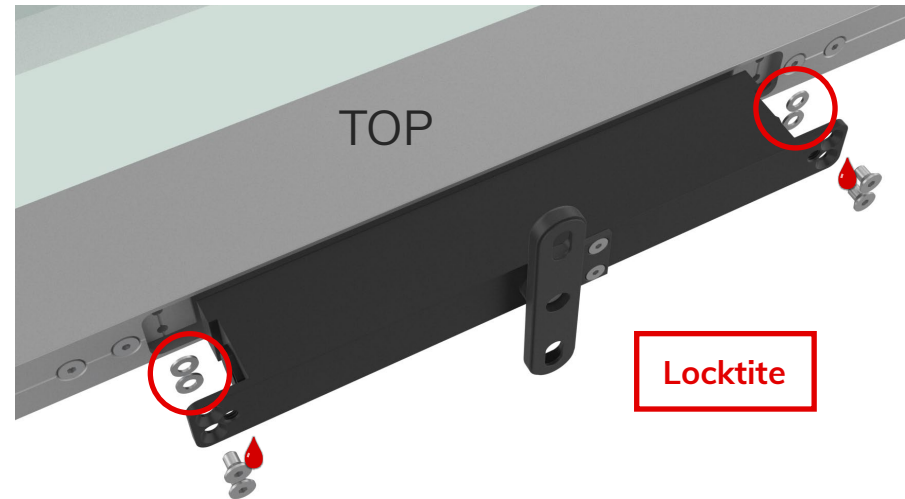


To increase the top joint, you have **3 options**:

1. Adjust the inbus screws to move the hinge further away from the door leaf (loosen 4 screws first).



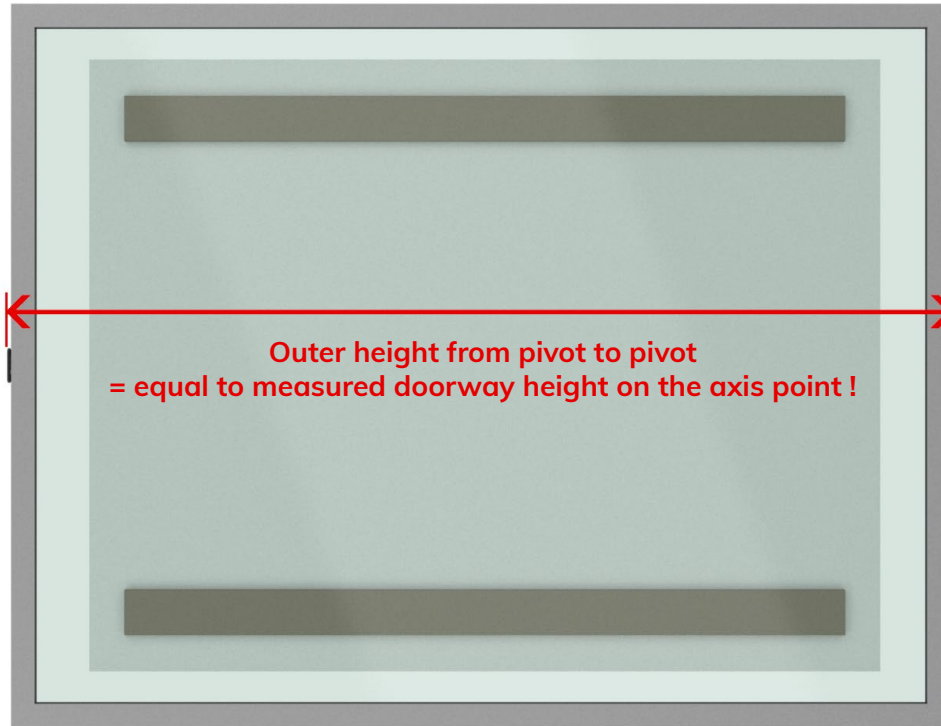
2. Use (supplied) shims between hinge and door leaf.



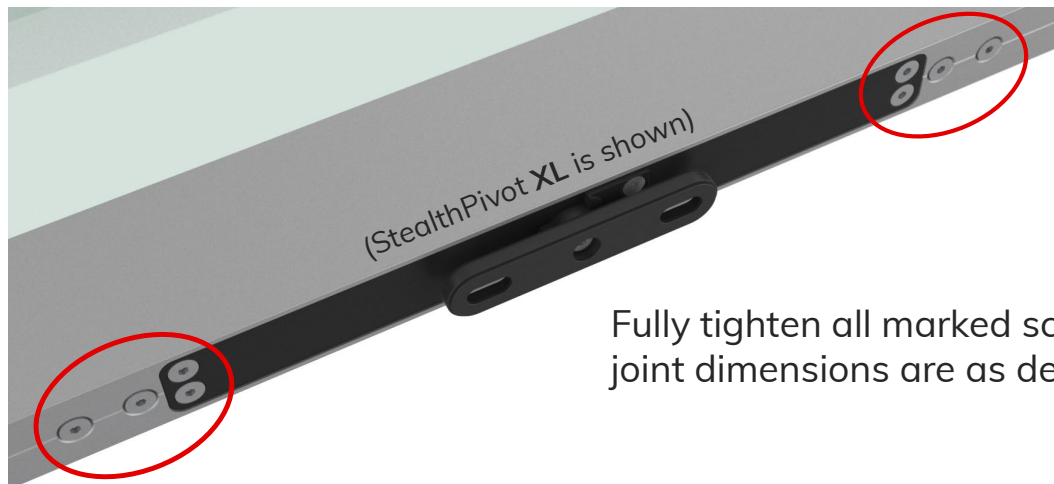
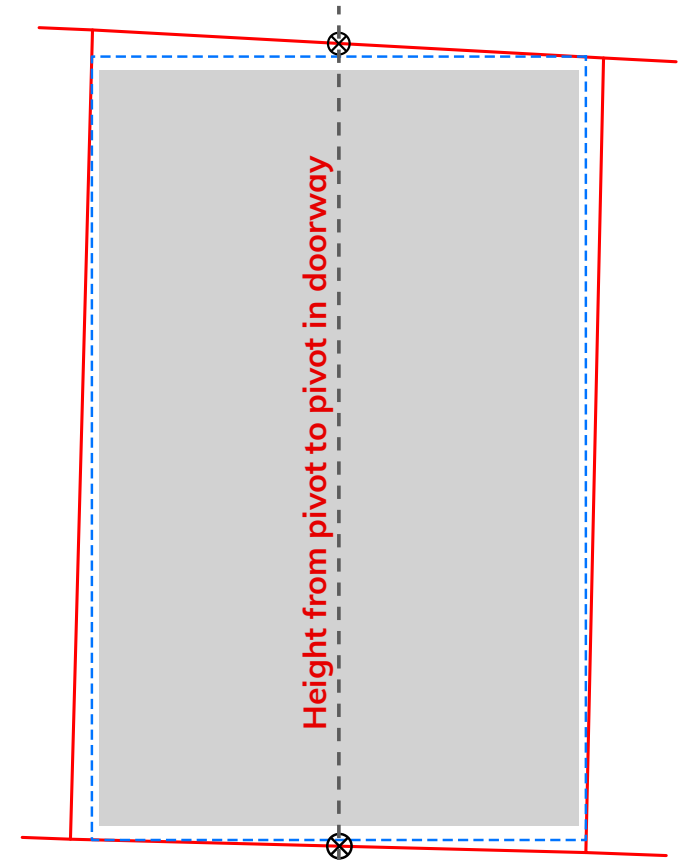
3. Use supplied shims between ceiling and hinge (= less stable is not preferred at the top hinge).



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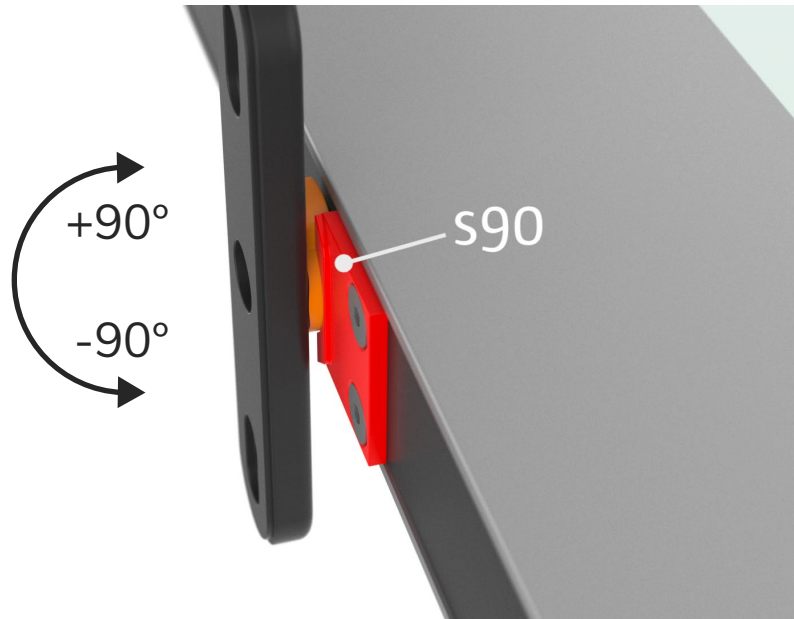


Double check the pivot to pivot distance with the measured doorway height at the axis point.



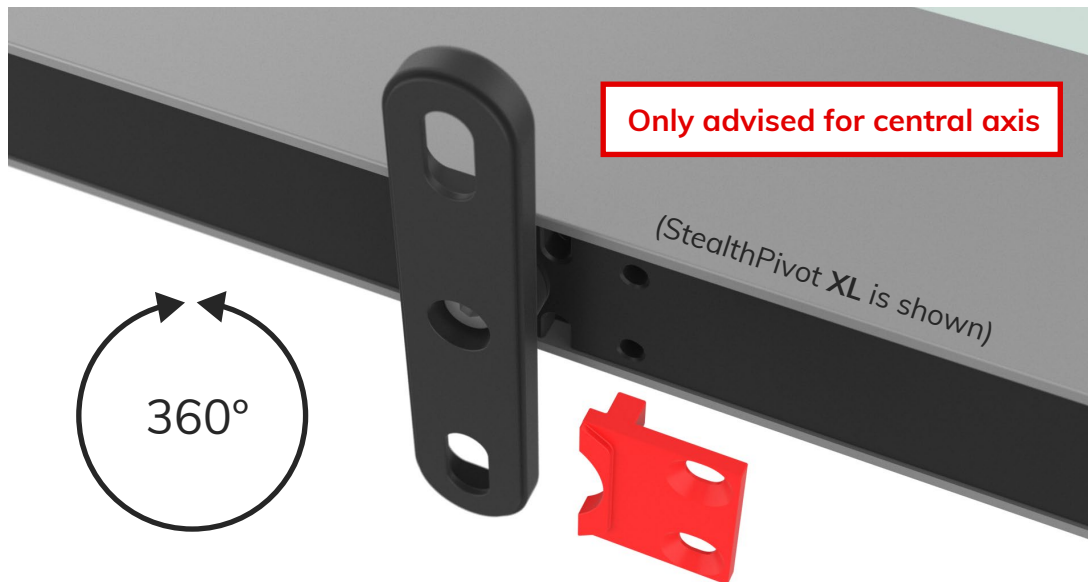
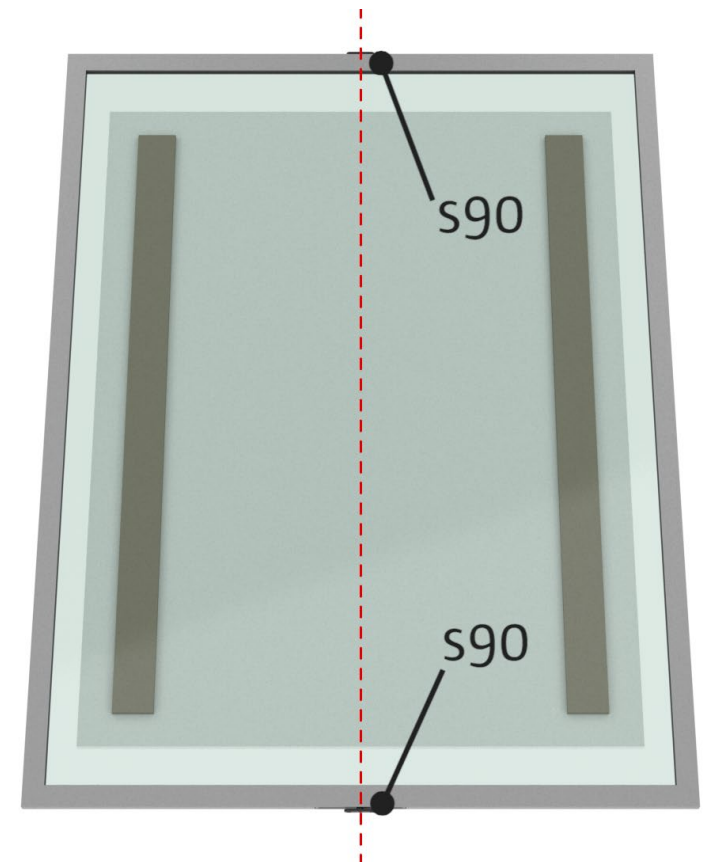
Fully tighten all marked screws when joint dimensions are as desired.

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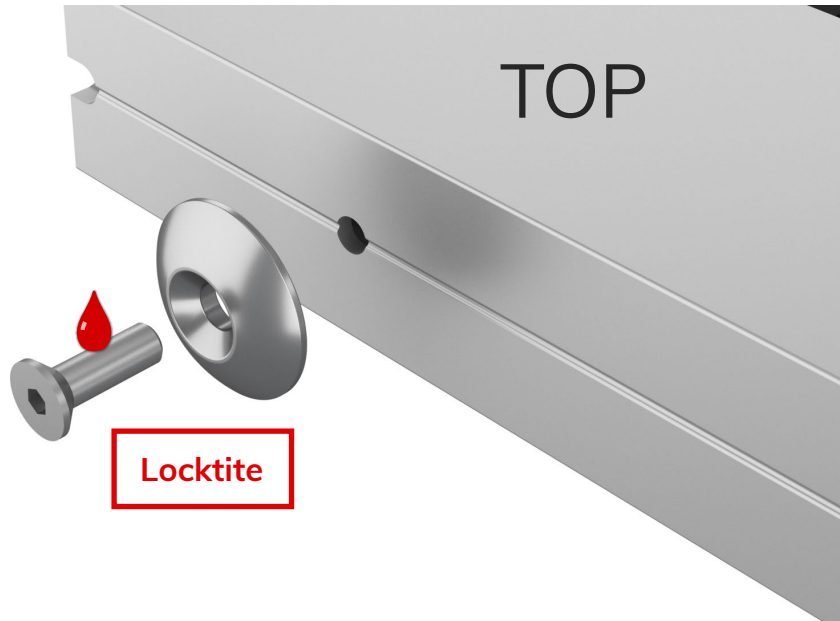
The s90 will stop the door in open position at $\pm 90^\circ$.

!! Make sure the s90 is always on the same side top and bottom !!

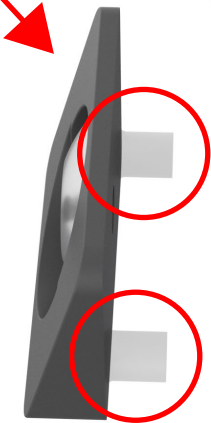
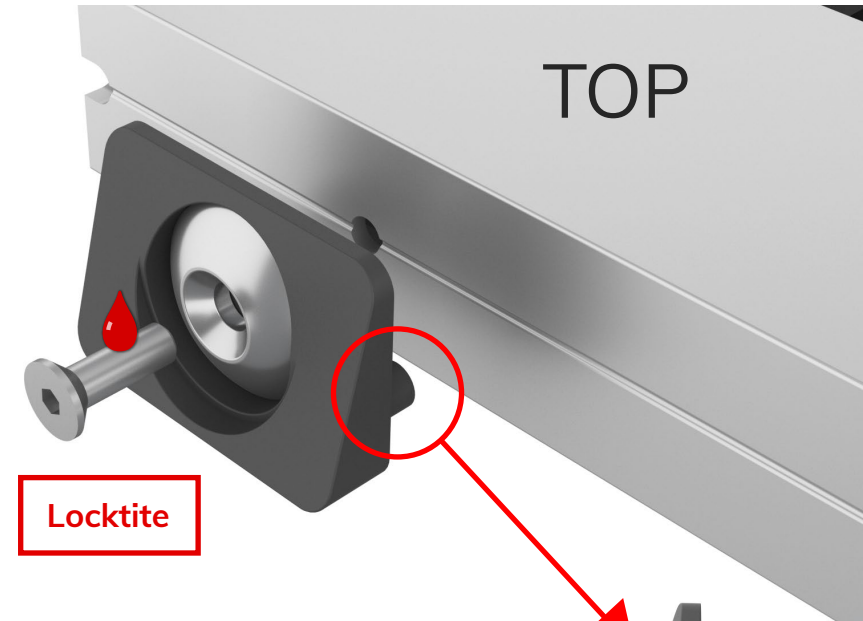


For unlimited 360° rotation, remove the s90 from top and bottom pivot. This is only advised for central axis position.

We advise to install the optional 2-way positioning magnet(s) onto the doorframe.
(For counter magnets on the ceiling, see 'Door installation manual')



If 1-way opening is desired, add the optional 1-way accessory.
(For counter magnet + 1-way on the ceiling, see 'Door installation manual')



Cut away both columns
before installation

StealthPivot **NL** only has one 1-way accessory

For further instructions on how to install
the fully assembled door in your doorway,
please refer to the DOOR INSTALLATION MANUAL