



Arctic Tern
Cargo Door
Installation Guide

**PLEASE READ ENTIRE INSTALLATION GUIDE
BEFORE ATTEMPTING INSTALLATION.**

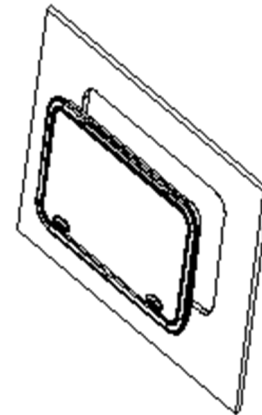
*Issues caused by improper installation are not covered under the
product warranty.*



Arctic Tern Cargo Door Installation Guide

Recommended tools and supplies:

- Drill / screw gun
- 3/16" and 1/8" drill bits
- #20 torx bit
- Masking tape and electrical tape
- Polyurethane adhesive: 2 tubes for large doors, 1 tube for the small and medium doors
- #10 flat washers
- Scotch Brite pad
- Isopropyl alcohol



Step 1: Mark and cut the door hole: The cut hole opening should be the size of the door, plus 2mm. Example: 300x600mm door = 302mm x 602mm cut hole opening. Cut the hole using a suitable saw for your wall material. Masking tape should be used to protect surrounding areas from the saw base. Note: If your wall is not solid, you may need to create embedded framing around the door opening to support the door. Composite walls can be cored with a hole saw, and a wooden plugs glued in the wall at each mounting screw location.

Step 2: Prepare the door for installation: Temporarily tape #10 flat washers to the back of the flange on the door frame where adhesive will later be applied. This allows for proper offset for the adhesive, which should not be fully compressed, and to ensure the mounting holes are properly aligned during final installation.

Step 3: Trial fitting: Lift the door into the cut out. Have a helper open the cargo door and hold the door frame firmly against the wall. Your mounting screws will go through the door frame, and into the door jamb. Using a 1/8" drill bit, drill holes into the top and bottom of the door frame, and into the door jamb (4 holes total). Using a 3/16" drill bit, enlarge the holes in the aluminum door frame only (not into the door jamb). Secure the door into the door opening using 4 of the screws provided. Drill and add additional screws through the frame at about 12" intervals. Do not use the provided silicone sealing washers yet for this step.

Note: The mounting screws must not span an open gap. Spanning a gap may distort the door frame and prevent the door from operating smoothly. If gaps exist where the screws go through, fill the gap with a plastic or wooden shim. Close the door, test for proper latch function, and smooth door operation. If there is any binding in the operation of the door, you may need to adjust or shim the door frame to achieve a perfect alignment between the frame and the door.

Step 4: Masking for ease of adhesive cleanup: Once the alignment of the door is perfect and all the screws are in place, use the masking tape to mask all around the exterior flange of the door. Masking tape is best for the straight sections, and the electricians tape works well around the corners.

Step 5: Remove the door assembly from the wall. Remove and discard the #10 washers. Scuff the wall surface where the glue will bond, as well as the flange on the door. Clean both surfaces with isopropyl alcohol.

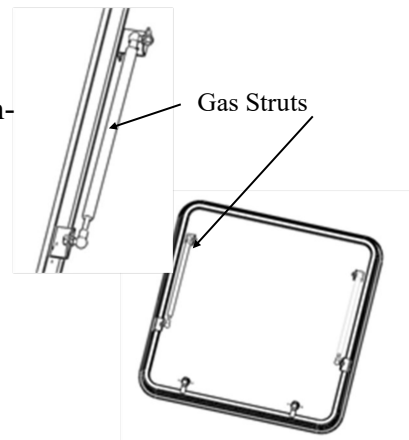
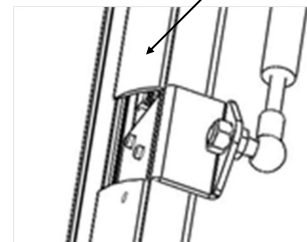
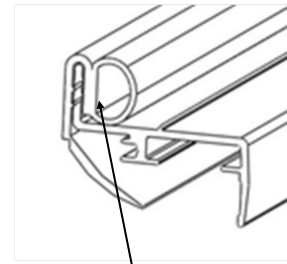
Step 6: Run a 1/4" bead of polyurethane adhesive around the back of the door flange. Push the door gently into the door opening. Open the door and have a helper support it. Compress the adhesive until the holes in the door frame line up with the holes in the door jamb, no farther. Start all the screws through the door frame, then snug them down. Be sure to use the included silicone gel sealing washers. Do not over-tighten these screws. You should see adhesive evenly squeezing out around the door frame.

Step 7: . Gently check the function and fit of the door in the frame one last time. Make any last-minute adjustments quickly before the adhesive sets. Close the door and allow the adhesive to cure before subjecting the door to stress or outdoor elements.

Step 8: When the adhesive is set to a soft rubbery consistency, use a razor knife to cut the squeezed-out rubber all around the frame, and then remove the masking tape. This will give you a clean adhesive edge with minimal cleanup.

Step 9: A bead of adhesive should be run around the inside of the door to fill any gaps and further secure the door.

Step 10: Strut installation: If your door is equipped with gas struts and they were not pre-installed, have a helper hold the door while you install the struts. The gas cylinder-side should be attached to the door, and the rod-side should be attached to the door frame. This ensures proper lubrication and sealing of the strut. The strut should be installed on the inside of the frame bracket, away from the sealing flange, and on the outside of the door bracket, toward the sealing lip. This gives a straighter alignment of the strut and does not obstruct the opening.



Clean the door with a cleaner or polish suitable for powder coating. We highly recommend NOVUS products. You can find out more on our website or give us a call to order.