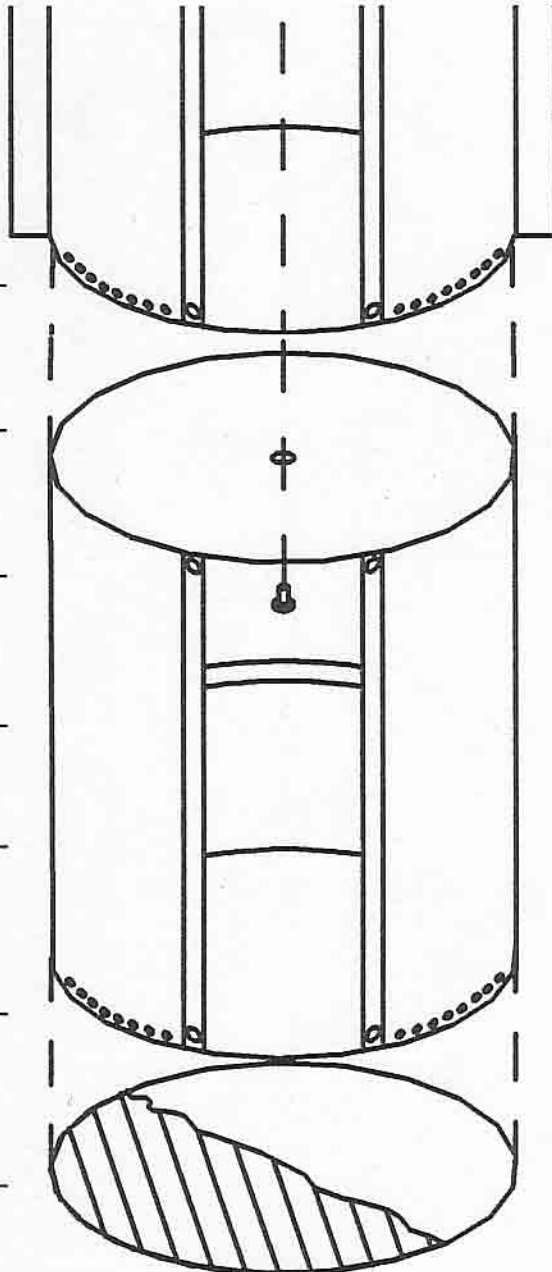


ASSEMBLY AND DISASSEMBLY  
OF METAL

**ESECO** Speedmatic®

REVOLVING DARKROOM DOORS



# ASSEMBLY OF METAL REVOLVING SPEEDMATIC DARKROOM DOOR

## Step #1

Stand inside drum cylinder\* on end. Slide together at the seam matching corresponding letters. Use 3 Screws to hold together. Lay on side being careful metal does not bend.

\*(marked inside cylinder)

NOTE: from bottom of cylinder to center of finger-grips should be 40" This indicates bottom of door.

## Step #2

Stand rings 1B and 2B on steel drum panel. Start where indicated by "Start". Use two (2) long screws in first and last hole. All those in between are short screws. Use Awl to line up holes.

## Step #3

Insert Riv nuts in each handrail hole from outside of inner drum. Put each of the #10-32 screws 1 1/4" long through the holes in the handrail, then through long black plastic spacers and into each riv nut. Use 2 self-tapping screws to attach ends of handrail from outside inward.

## Step #4

Insert each of the eight plastic spacers into square aluminum channel tube on outside panel and align with hole.

## Step #5

Stand the inside cylinder onto the wood platform of (1A) and place the top of (2A) on top of drum. Wrap 2 or 3 (depending on size) metal outer panel around inside cylinder. Start as indicated with 4 bolts on top, 4 bolts bottom, and the short screws in between.

## Step #6

Hold castor bracket in place and insert the socket cap screw through the bracket and into the bottom ring of the door. The holes in the bottom ring are 1/4" from sq. tube upright. Screw socket cap screw tight with the Allen Wrench provided. Repeat process on other caster brackets. Leave the caster up and not touching the floor. Once the door is pushed into the opening and centered you can adjust the casters. Screw each of the casters all the way down until they touch the floor.

## Step #7

Insert the 1/2"x3" bolt up through the inside of the hole in the top of the inner cylinder then up through the suspension bearing and put the 1/2" jam nut on top. Adjust so inside cylinder turns freely.

## Step #8

Attach left side rail at top of J channel with screw. Letting side rail hang attach right side rail the same way. Put screws in bottom hole of side rail into bottom of door. Put remaining screws in from inside door to the out side.

# DISASSEMBLY OF METAL SPEEDMATIC REVOLVING DOOR

NOTE-THIS PROCEDURE REQUIRES TWO  
PEOPLE. USE A 3/4" WRENCH

## Step #1

Remove the 1/2" locking nut from the top of the suspension brace assembly. This will allow the 1/2" x 3" Suspension Bolt to be removed from the inside of the door cylinder.

## Step #2

Using a #19 drill bit, take out the black rivets holding the outside metal cylinder panel assemblies around the top and bottom of outside drum.

## Step #3

Remove eight 1/4" x 1 1/4" screws from the four square aluminum channel felt seal assemblies. Remove outside metal panel and top.

NOTE-BE CERTAIN NOT TO MISPLACE THE EIGHT SPACERS THAT INSERT IN THE ALUMINUM CHANNEL.

## Step #4

Drill out the rivets holding side rails to the top of the J bar. Drill out the rivets holding the side rail to the bottom ring.

## Step #5

Remove the castor from the mounting bracket. Remove the cap screws and take off the castor bracket from the bottom ring of the door.

## Step #6

Remove hand rail and the black spacers from the inside cylinder. Drill out two rivets on end of handrail with #19 drill bit.

## Step #7

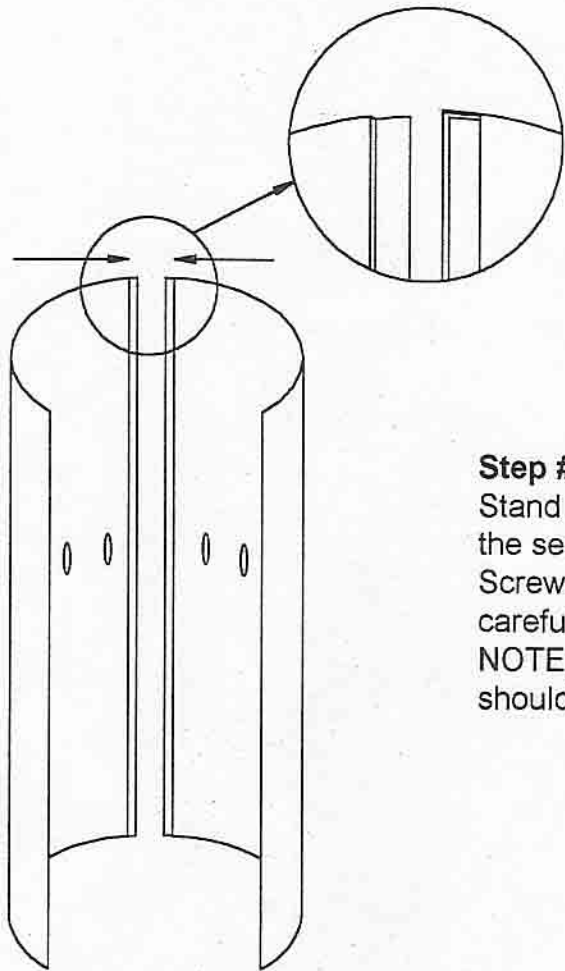
Lift the inside cylinder assembly off of the door base and lay the cylinder on it's side.

## Step #8

With the inside cylinder laying on its side use a #19 drill bit to remove the rivets from around top and bottom.

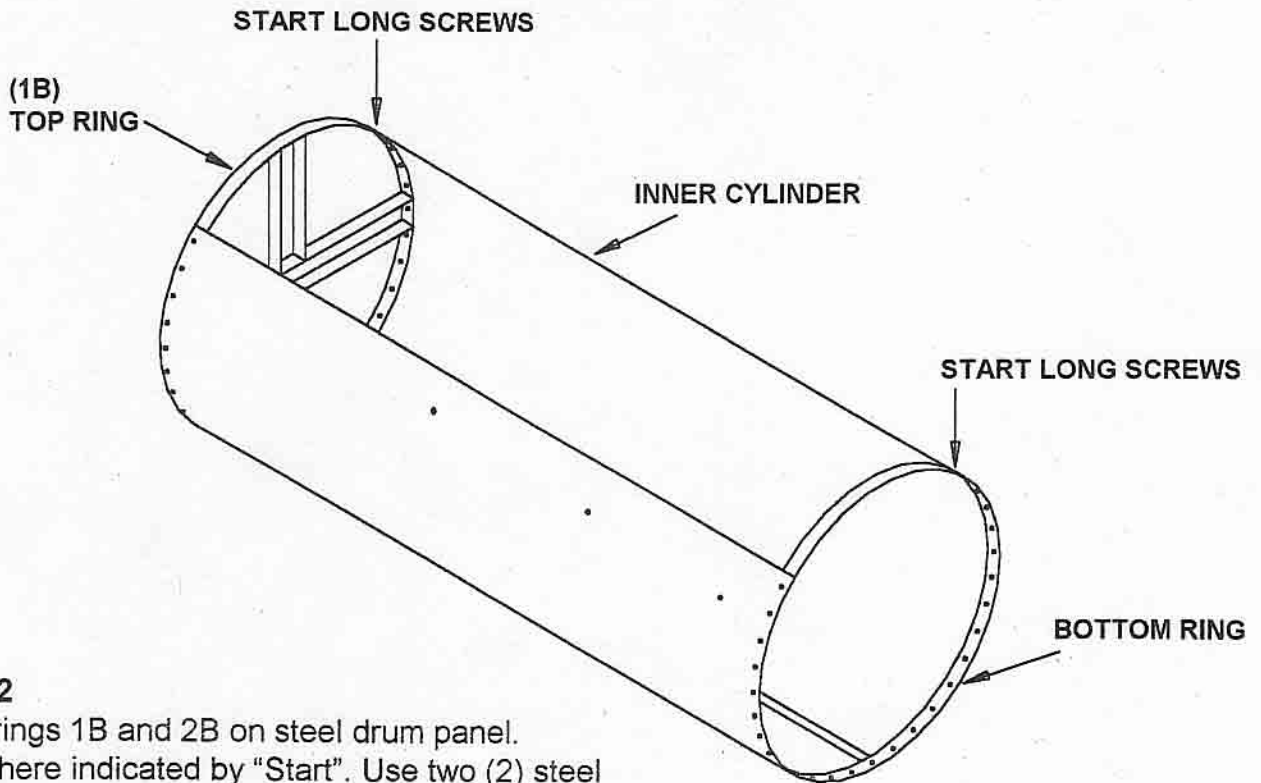
## Step # 9

Remove the inside cylinder top assembly and bottom ring. The door is now ready to be moved and reassembled.



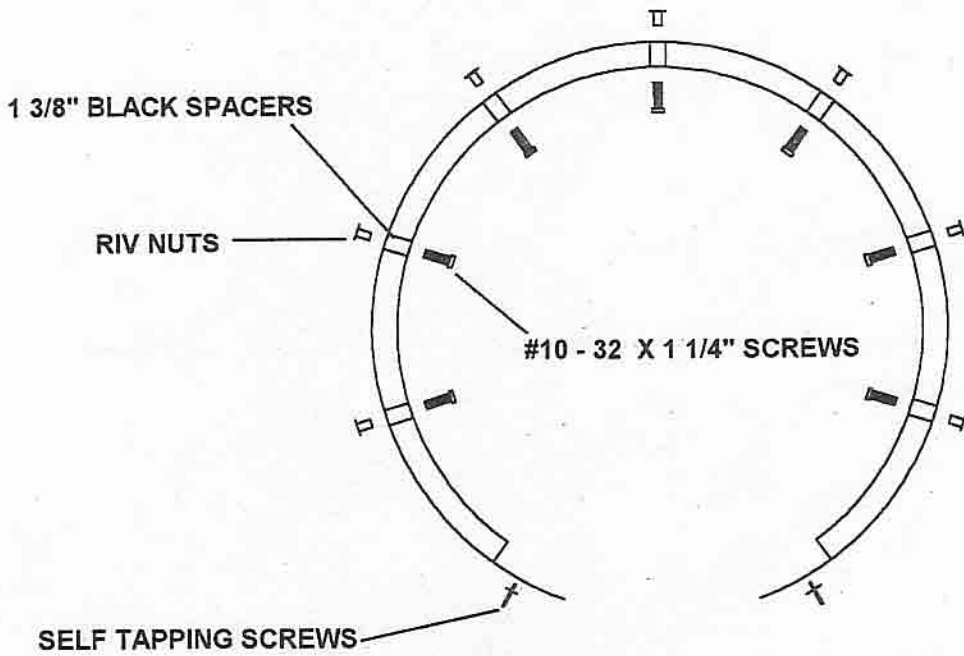
**Step #1**

Stand inside drum cylinder\* on end. Slide together at the seam matching corresponding letters. Use 3 Screws or rivets to hold together. Lay on side being careful metal does not bend. \*(marked inside cylinder)  
 NOTE: From bottom of cylinder to center of finger grips should be 40". This indicates the bottom of the door.



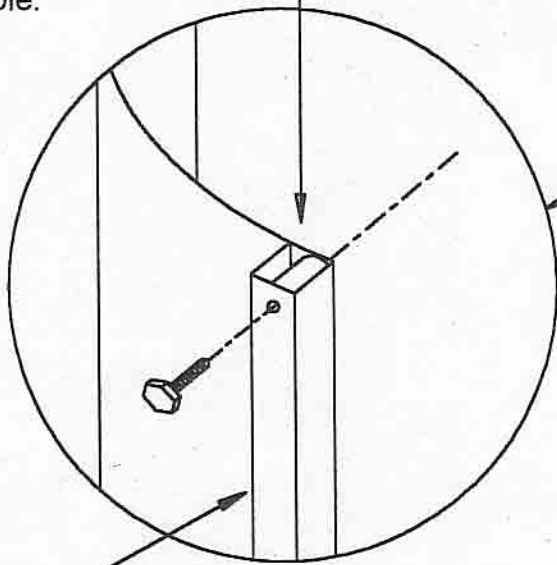
**Step #2**

Stand rings 1B and 2B on steel drum panel. Start where indicated by "Start". Use two (2) steel screws in first and last hole. All those in between are short screws.



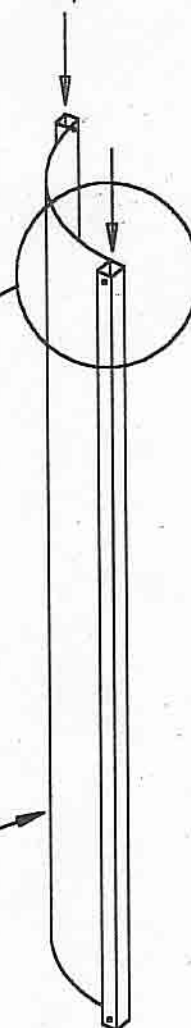
**Step #3**  
 Insert Riv nuts in each handrail hole from outside of inner drum. Put each of the #10-32 screws 1 1/4" long through the holes in the handrail, then through long black plastic spacers and into each riv nut. Use 2 self tapping screws on ends of hand rail. Attaching them from outside inwards.

**Step #4**  
 Insert each of the eight plastic spacers into square aluminum channel tube and align with hole.

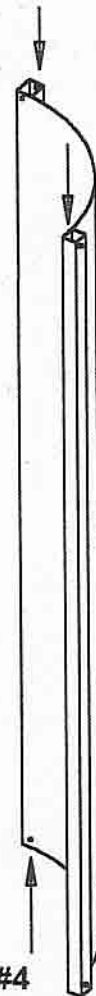


**Step #4**  
 square aluminum channel tube

**Step #4 square aluminum channel tube**



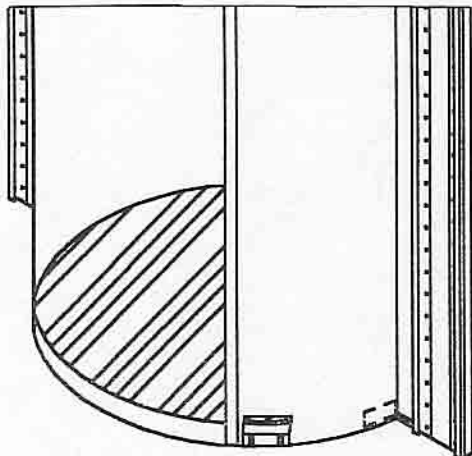
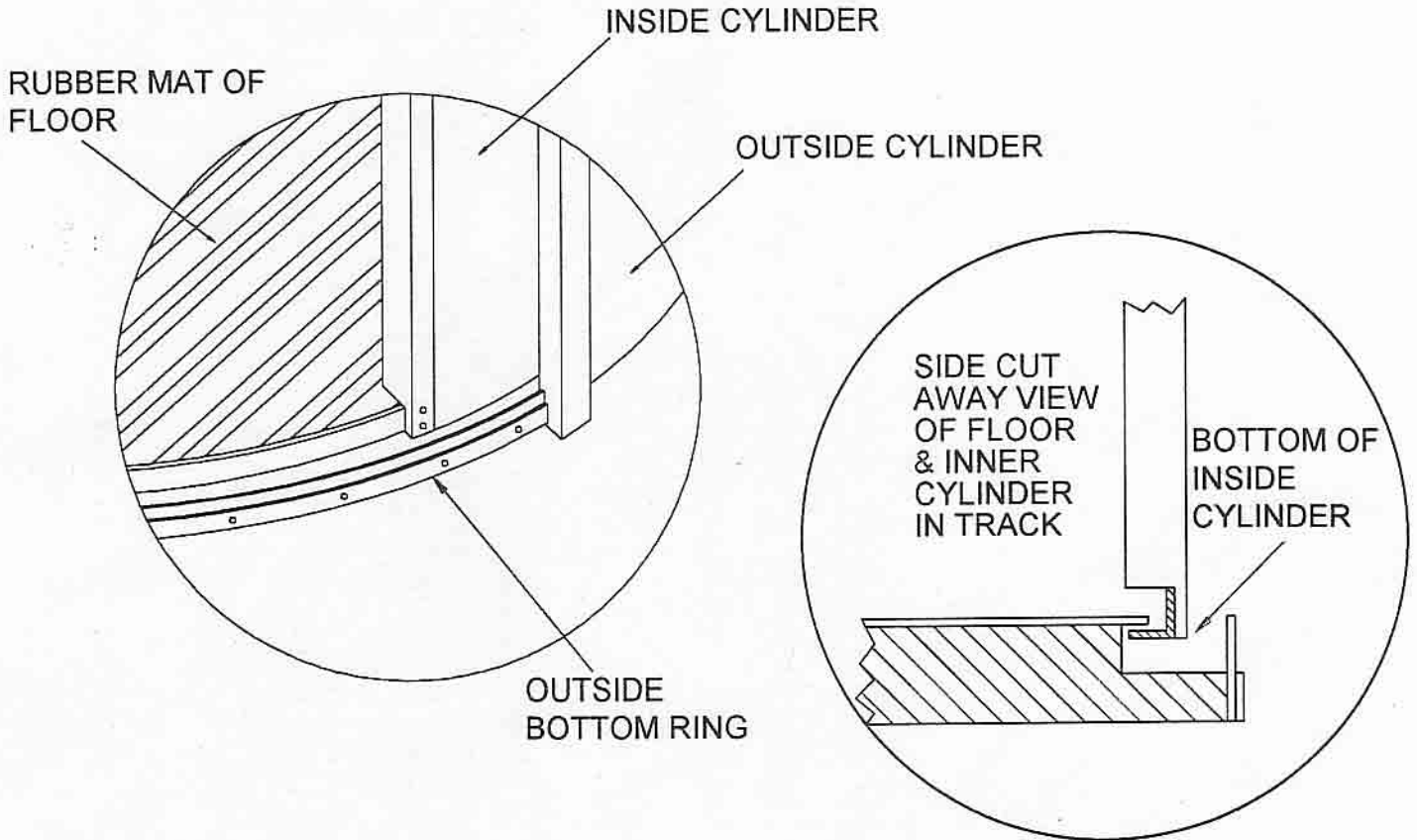
**Step #4**  
 outside cylinder



**Step #4**  
 back side of square aluminum channel tube

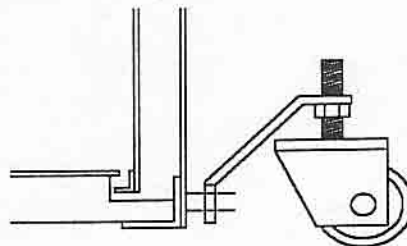
**Step #5**

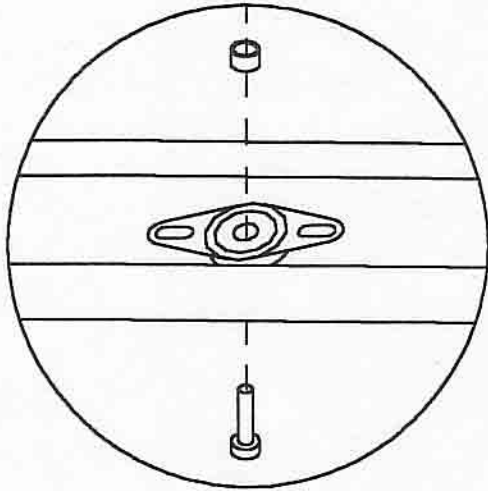
Stand the inside cylinder onto the wood platform of (1A) and place the top of (2A) on top of drum. Wrap metal outer panel around inside cylinder. Start as indicated with 4 bolts on top, 4 bolts bottom, and the short rivets in between.



**Step #6**

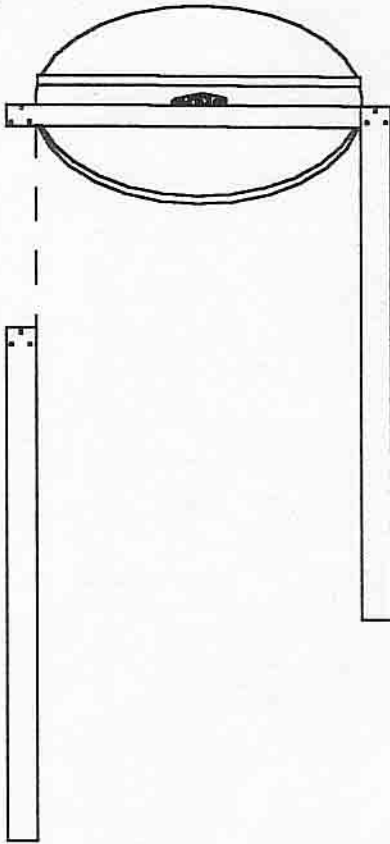
Hold castor bracket in place 1/4" from sq. tube upright. Screw in socket cap screw to hold in place using Allen Wrench. Repeat process on other castor brackets.





**Step #7**

Insert the 1/2"x3" bolt up through the inside of the hole in the top of the inner cylinder then up through the suspension bearing and put the 1/2" jam nut on top. Adjust so inside cylinder turns freely.



**Step #8**

Attach left side rail at top of J channel with screw. Letting side rail hang, attach right side rail the same way. Put screws in bottom hole of side rail into bottom of door. Put remaining screws in from inside door to the out side.

