

FHC G50™

TOP-HUNG BI-FOLDING GLASS DOOR SYSTEM

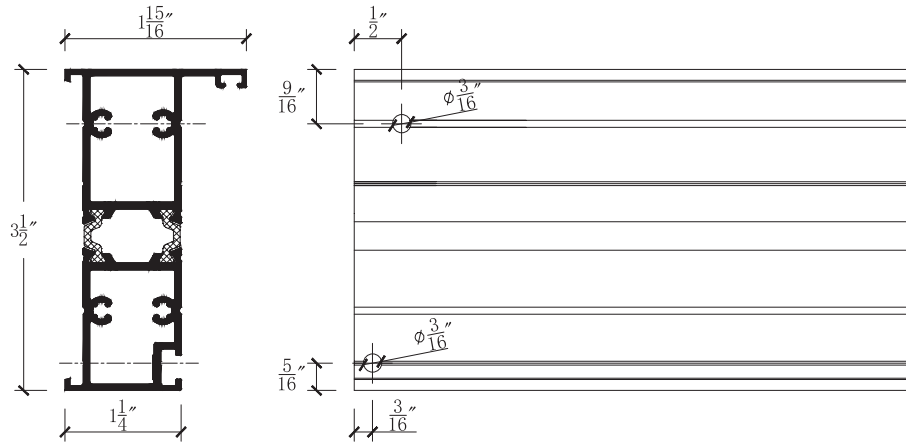


TOP-HUNG BI-FOLDING GLASS DOOR SYSTEM

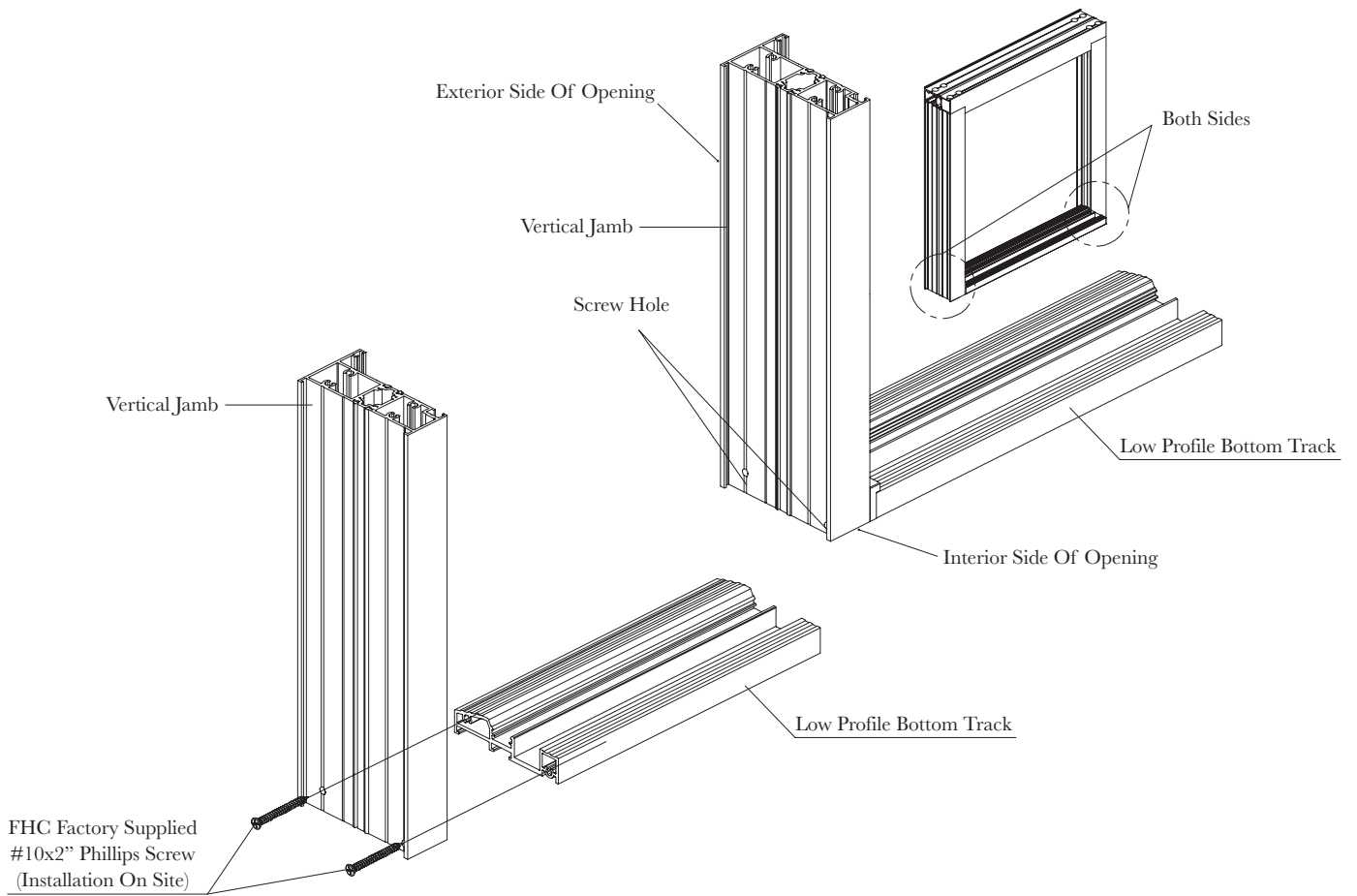
- Thermally Broken for Energy Efficiency
- Designed to be Used for Exterior & Interior Applications
- Minimal Sightline for Optimal Daylight
- Unobstructive Views When Opened
- Various Configurations, Access Swing Door Can Be Incorporated for Easy Entry
- Inward Stacking
- Concealed Hinges and Latching Hardware
- Top-Hung Rollers Create a Smooth Effortless Transition With Bottom Guide
- Accepts 1-3/16" Glass or Can Be Shipped Fully Glazed by FHC
- Satin Anodized, Dark Bronze Anodized, Matte Black and Custom Painted Finishes Available



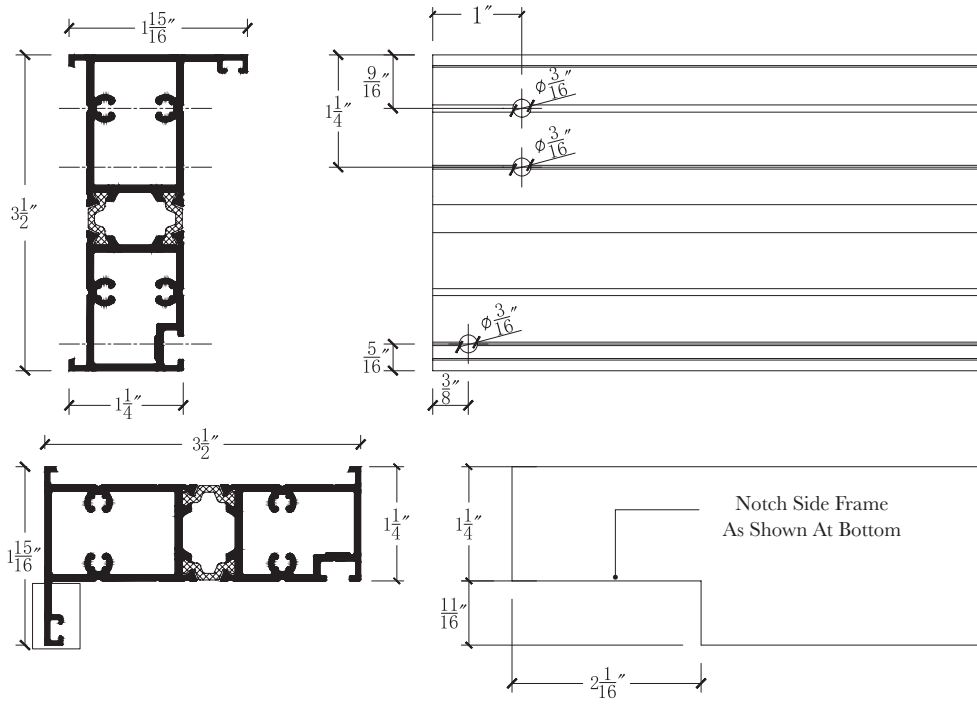
Frame Assembly For Low Profile Bottom Track “Interior Applications”



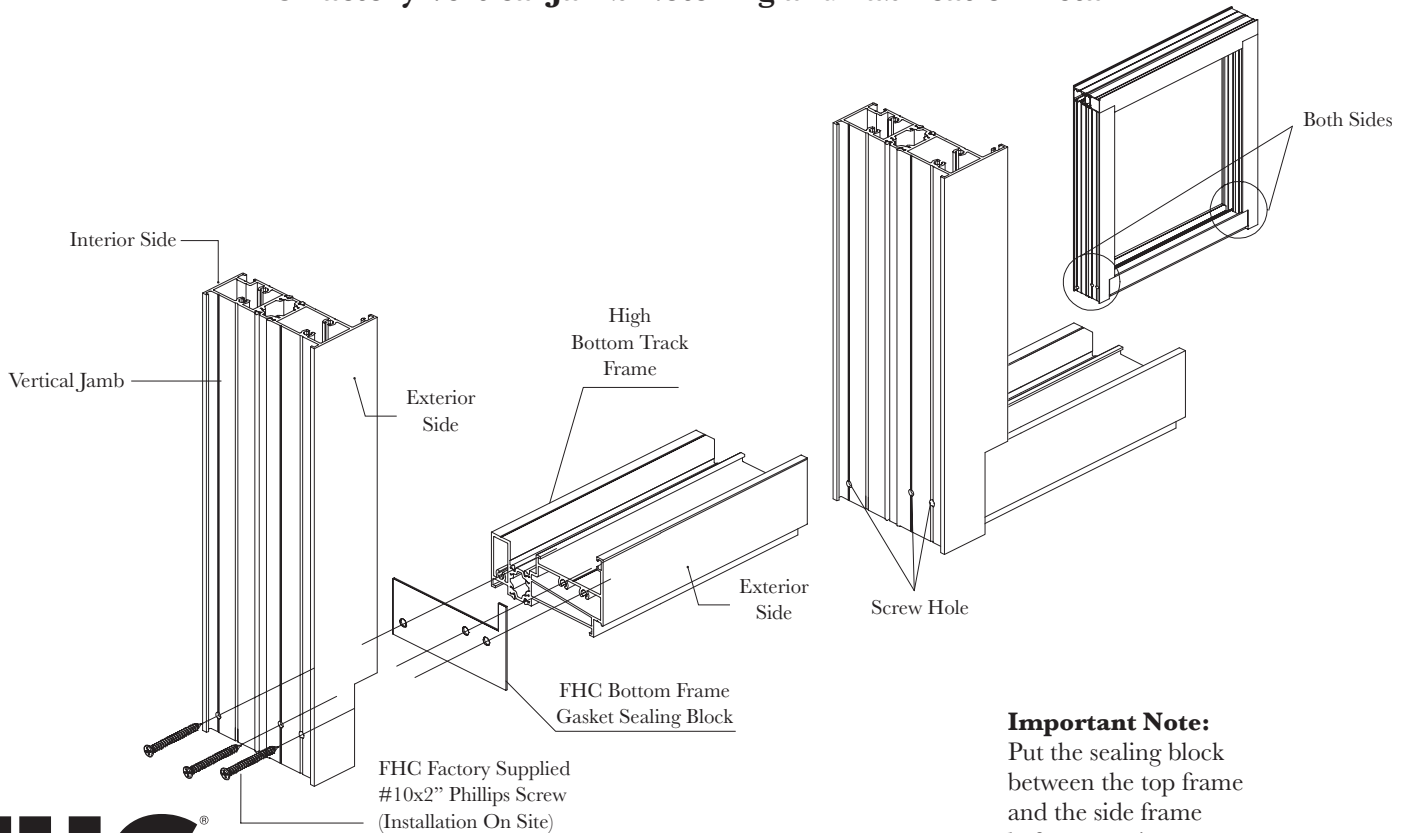
FHC Factory Vertical Jamb Fabrication Detail



Frame Assembly For High Bottom Track “Exterior Applications”



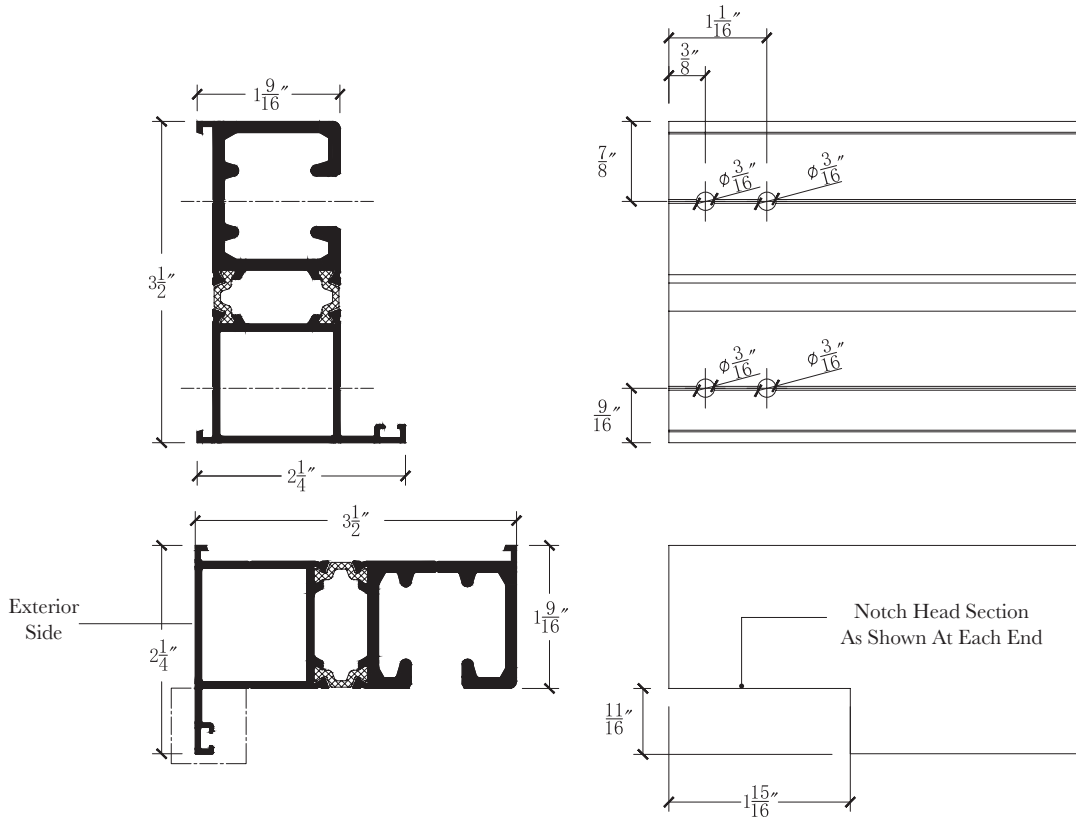
FHC Factory Vertical Jamb Notching and Fabrication Detail



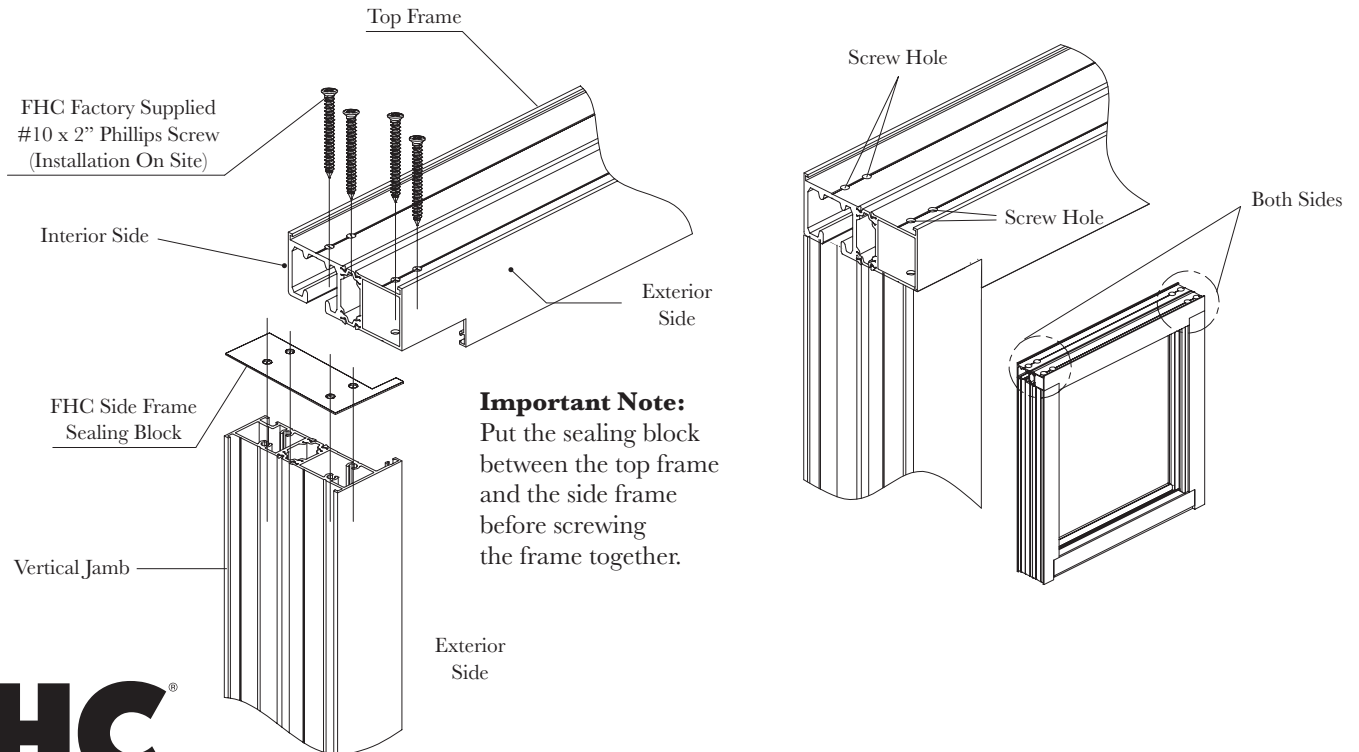
Important Note:
Put the sealing block between the top frame and the side frame before screwing the frame together.



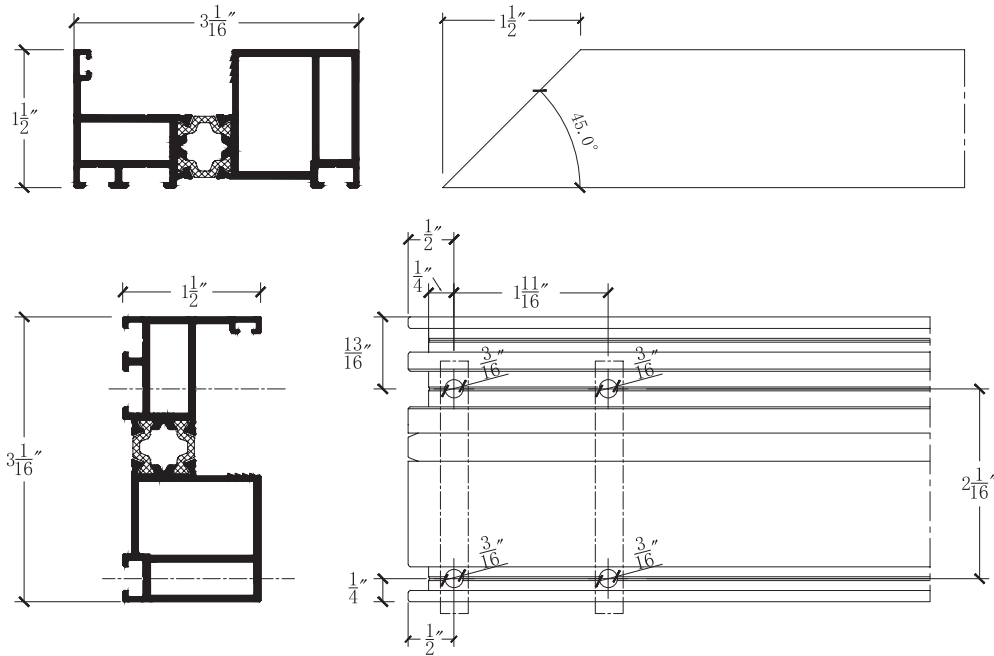
Frame Assembly For Top Track “Interior And Exterior Applications”



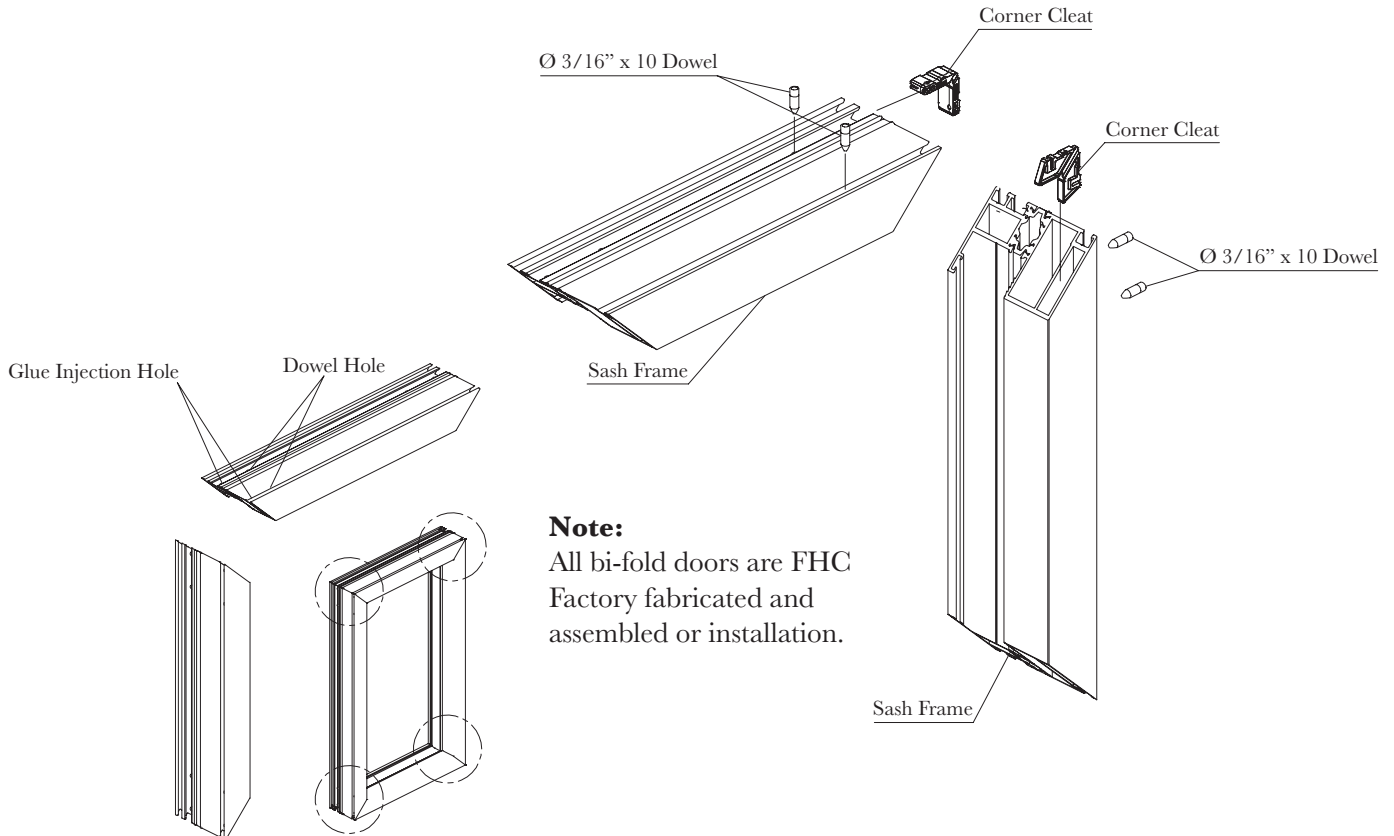
FHC Factory Top Track Notching and Fabrication Detail



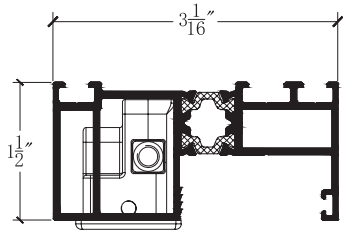
Bi-Fold Door
FHC Factory Fabricated Assembly Process



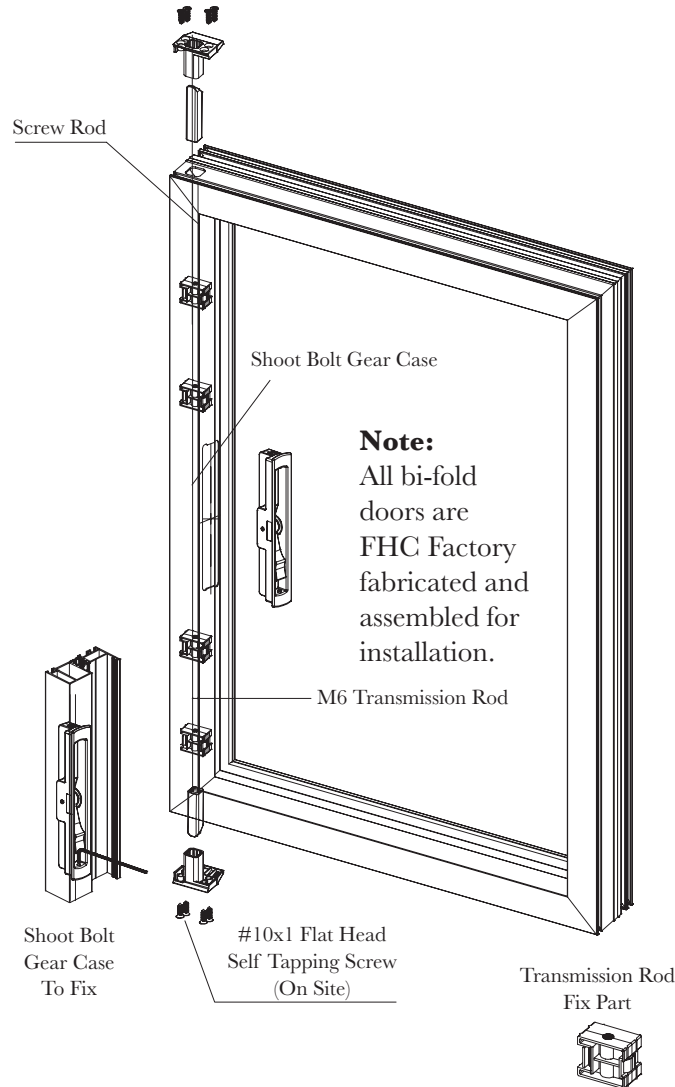
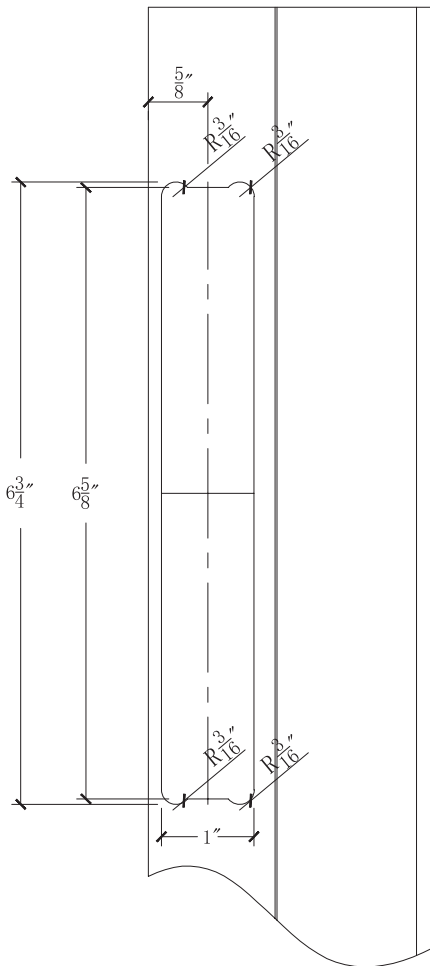
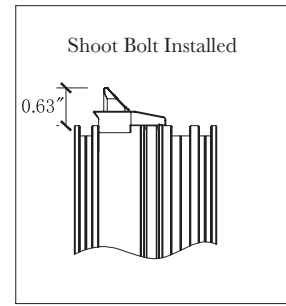
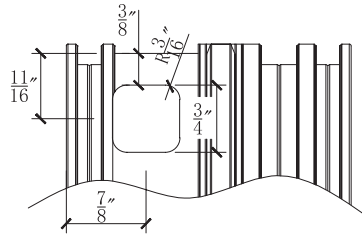
FHC Glue Injection Dowel Hole



Bi-Fold Door Hardware And Accessory Process
FHC Factory Fabricated And Supplied



Sash Profile Opening
 (Installed Shoot Bolt)

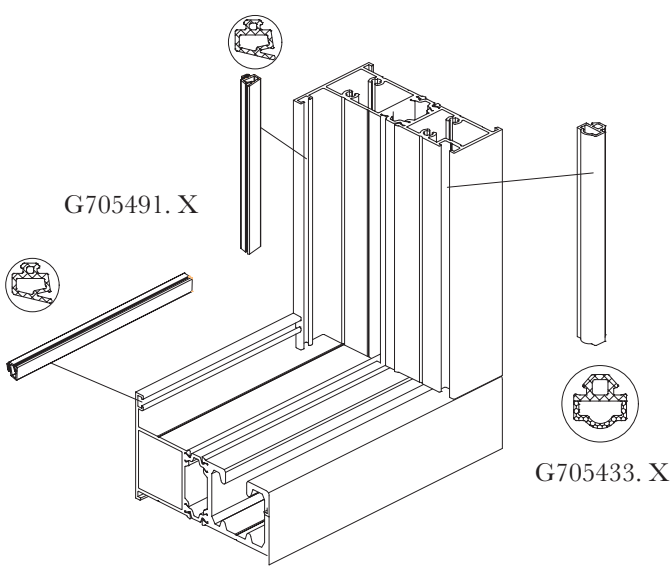


Technical Information:

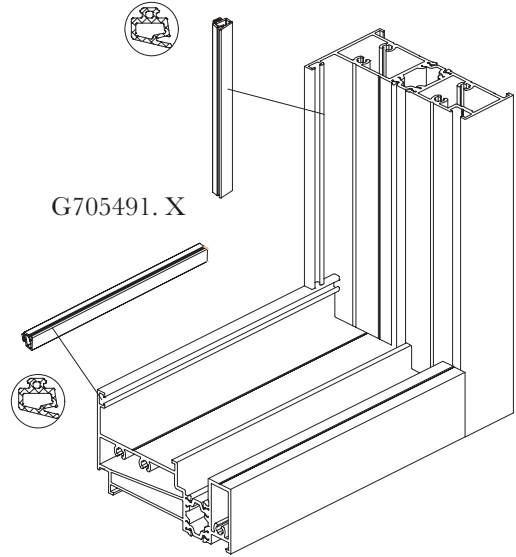
1. Process the mounting holes on the profile according to the size of the drawing;
2. Put the positioning parts into the two upper and lower sides of the profile before the corners of the profile group. The positioning parts are placed on the screw rod, and the position is about 7-7/8" a way from both ends;
3. After the window sash is assembled and glass is glued and fixed, install gear case, screw the screw rod into the two ends of the gear case, and screw the shoot bolt head into the screw rod;
4. Put the end block into the pin head and fix it on the window sash with M5 self-tapping screws;
5. Tighten the screws on the upper and lower sides of the gear case with a 2.5 mm hex wrench and make sure that the gear case is roughly in the middle position.



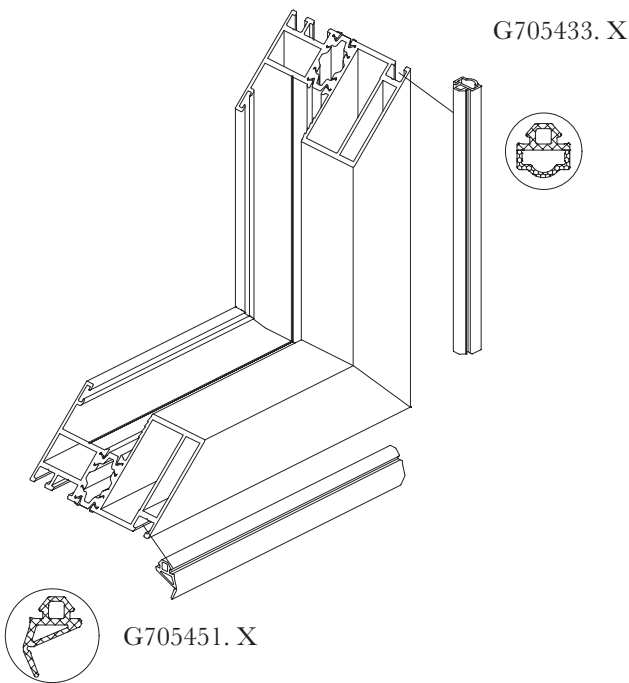
Bi-Fold Door Gasket Installation Process FHC Factory Installed



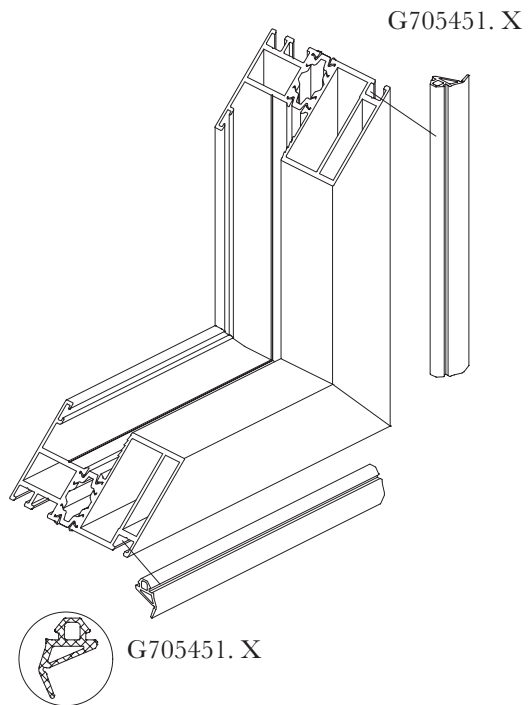
Bi-Fold Jamb/Head Detail



Bi-Fold Sill Track/Jamb Detail

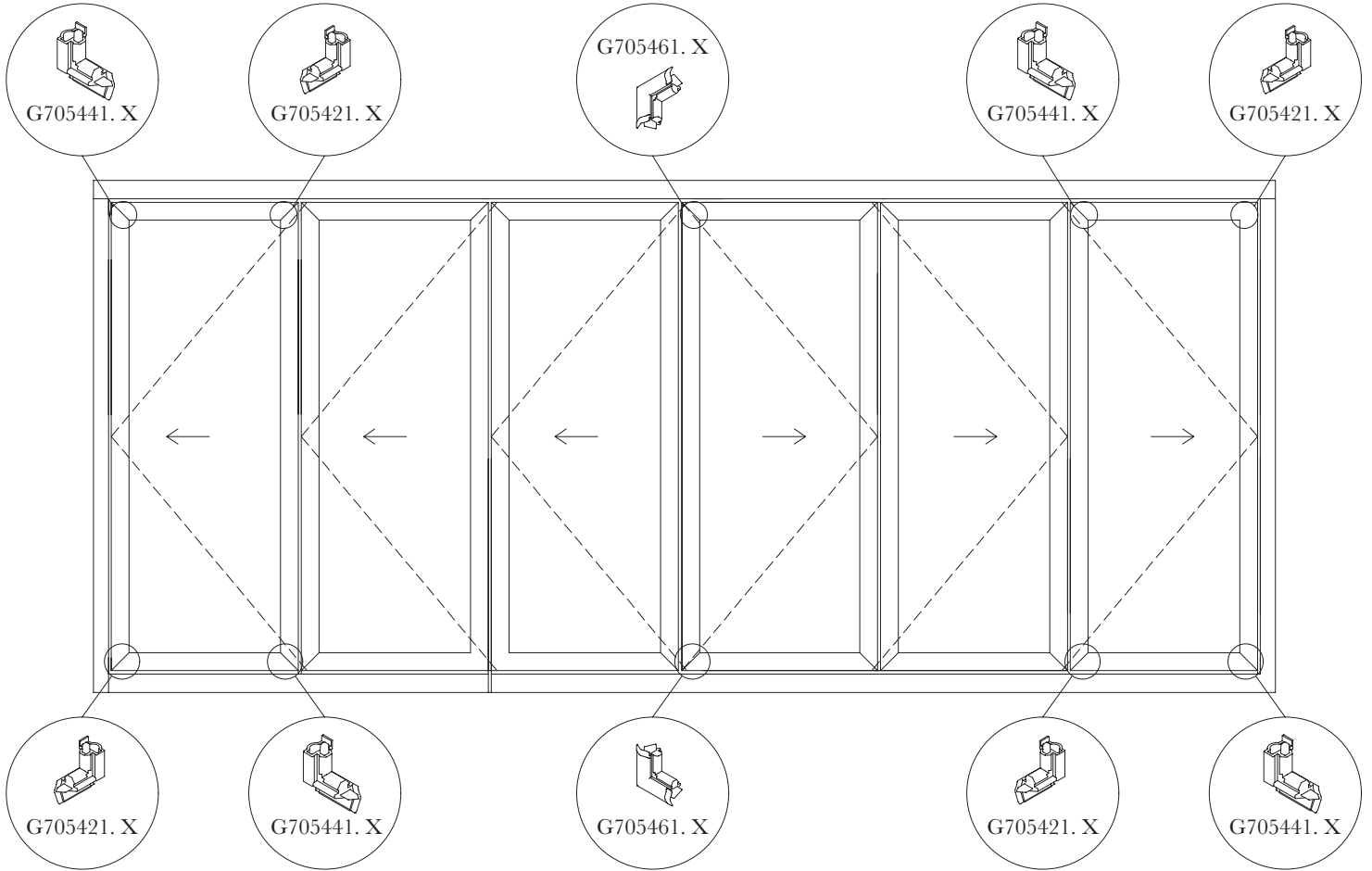


Typical Bi-Fold Panel



Typical Bi-Fold Lead Door Panel

Bi-Fold Door Corner Gasket Installation FHC Factory Installed

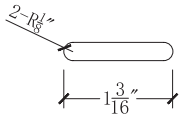


Exterior Side

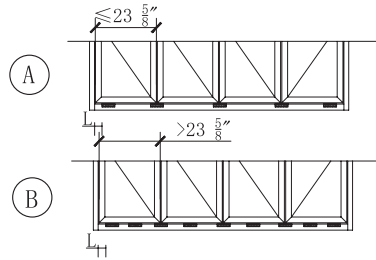


Interior Side

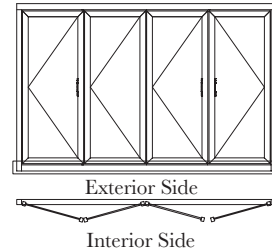
**FHC Factory Provided
Drainage Details (Only For Exterior Doors)**



FHC Factory Slot Size Detail



Drainage Channel Quality And Size Range
L=2"

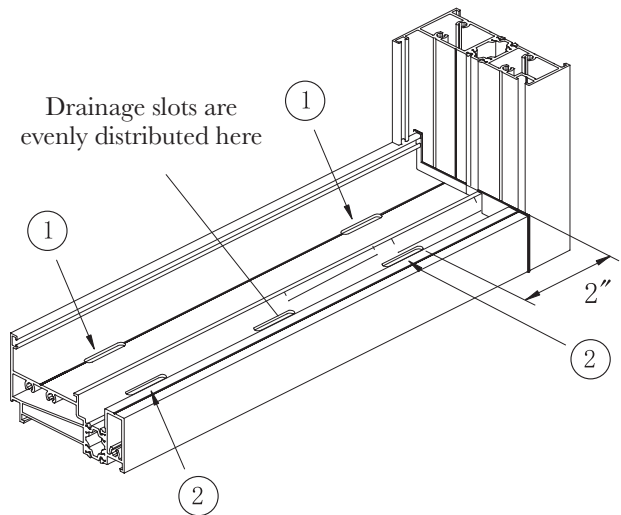
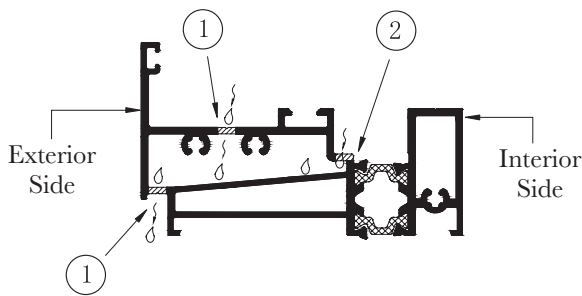


The drain slot are all open on the exterior side

Technical Notes:

When the panel width is less than or equal to 23-5/8", the drainage channel uses method A

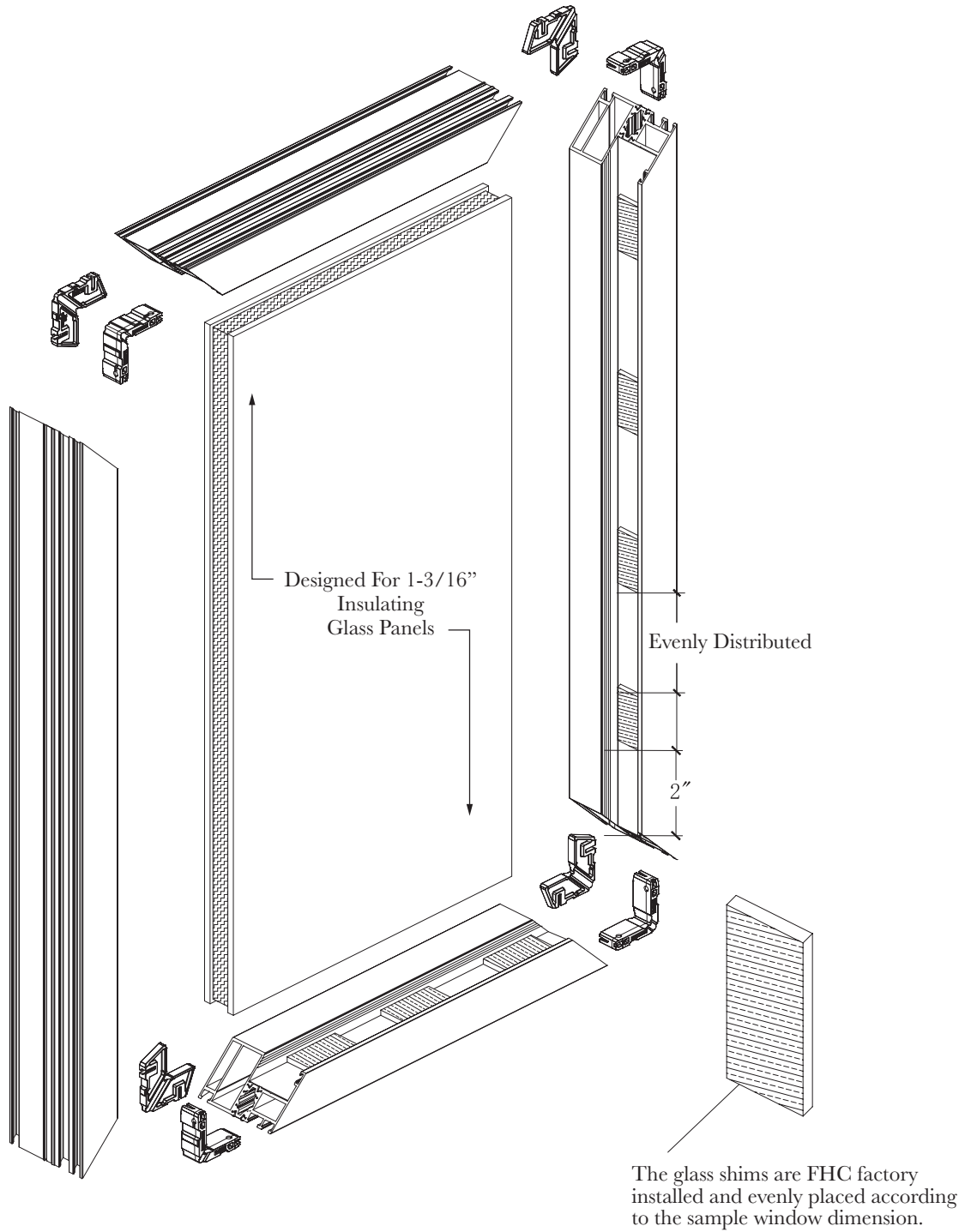
When the panel width is more than 23-5/8", the drainage channel uses method B



Reference:

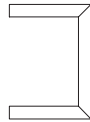
Drawing drainage above for slot placement in sill track.

Bi-Fold FHC Factory Assembly Process Isometric Detail

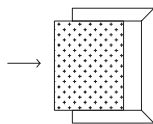


Glazing Instructions

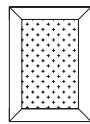
1. Assemble the sash (2 horizontal + 1 vertical) in a "C" form.



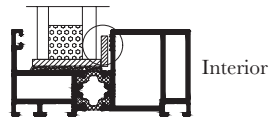
2. Slide the glass in the sash:



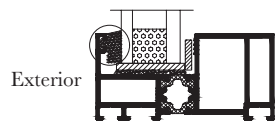
3. Connect the last sash profile (1 vertical):



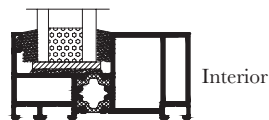
4. Pad the glass evenly with a 1/8" shim on the interior position:



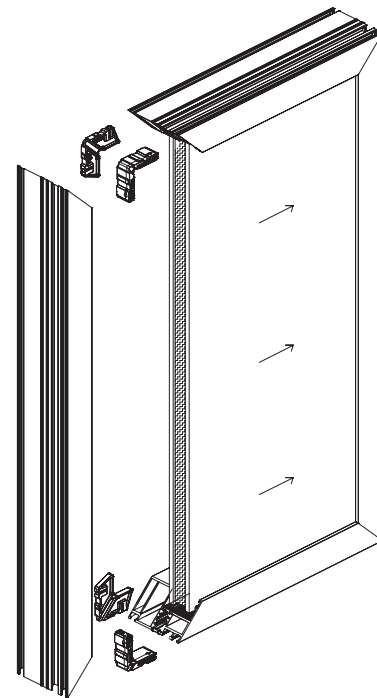
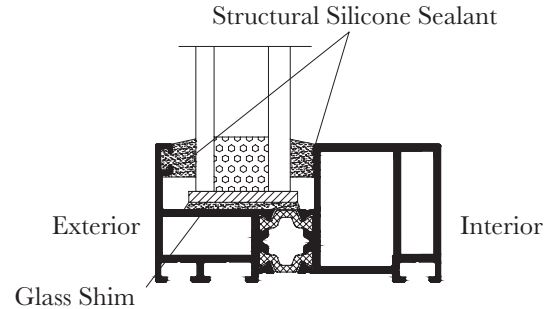
5. Clean the glass.
6. Glue around the sash (use structural silicone) on the exterior position:



7. Clean silicone excess.
8. Let it dry 24 hours.
9. Remove the shims and glue the other sash side (interior position), use structural silicone:



10. Clean excess.
11. Let it dry 24 hours.

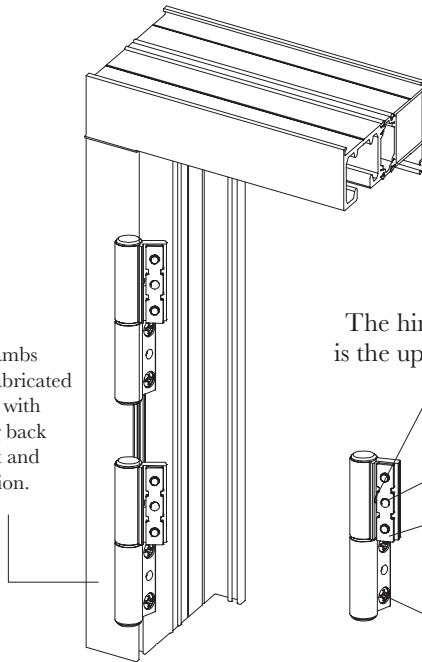


Technical Note:

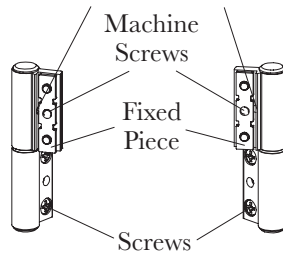
After complete assembly and glue injection, remove the remaining glue in time. Then wait for the sash to stand for 2-3 days before continuing to the next step.

Hardware and Accessory Assembly

All vertical jambs are factory fabricated and prepped with hinged fixing back plates for fast and easy installation.

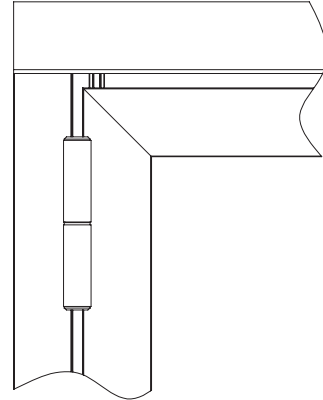


The hinge with screw holes is the upper part of the hinge

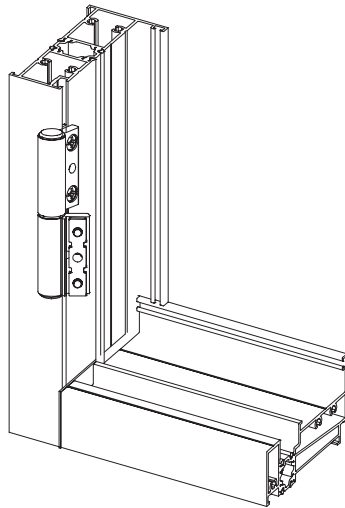
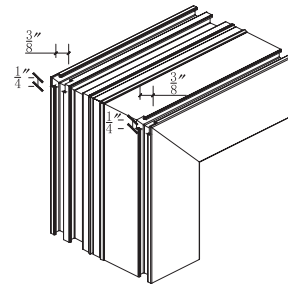


Hinge A

Hinge B



FHC Manufacturing will Mill the four corners of the sash, in order to install the hinge fixing piece.

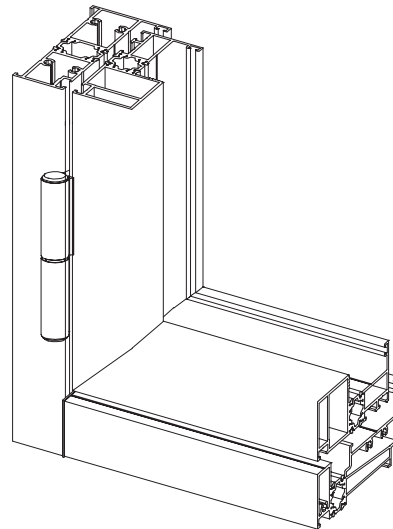
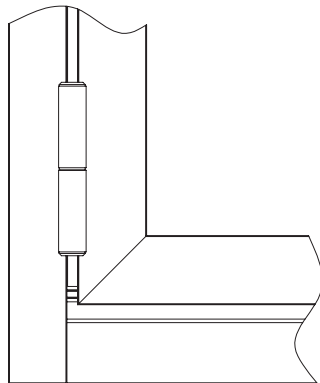
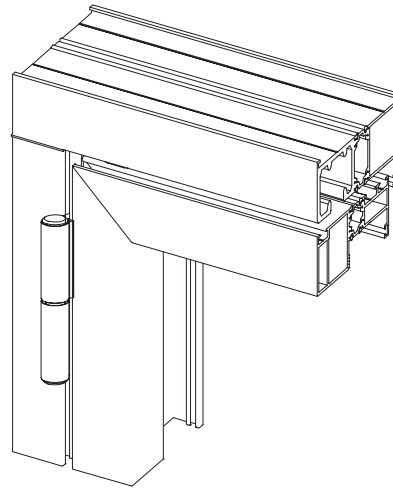
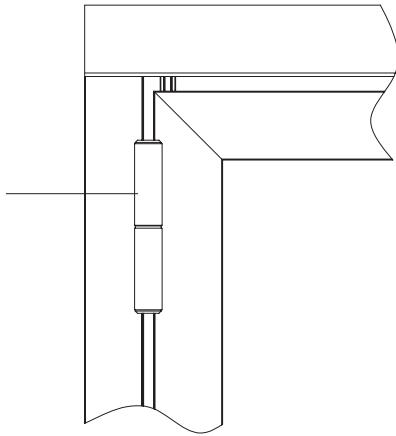


Hinge Installation Steps:

1. Remove the fixing piece and install it on the frame and sash respectively.
2. Tighten the screws to fix the hinge and the fixing piece.
3. Tighten the machine screws with 2.5 mm hex wrench to fix the hinges on the frame and sash.
4. As the hinge is load-bearing, when the hinge is installed on the left side of the door, hinge A is installed on the top of the door, and hinge B is on the bottom of the door. When the hinge is installed on the right side of the door, the hinge A is installed on the bottom of the door, and hinge B is on the top.

Hardware and Accessory Assembly

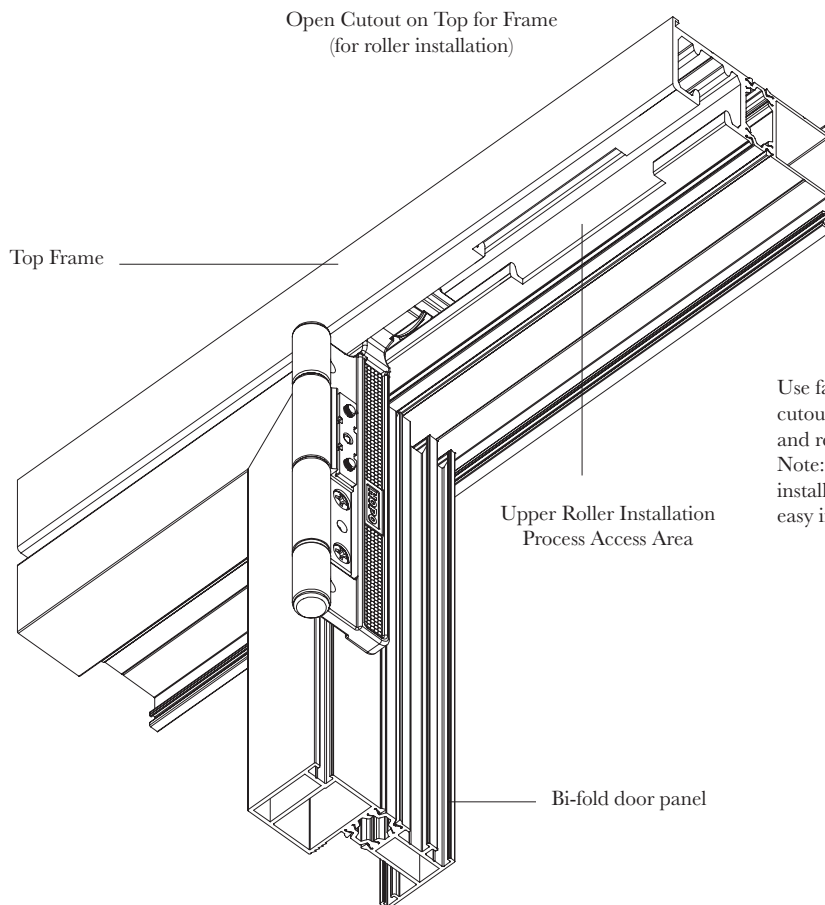
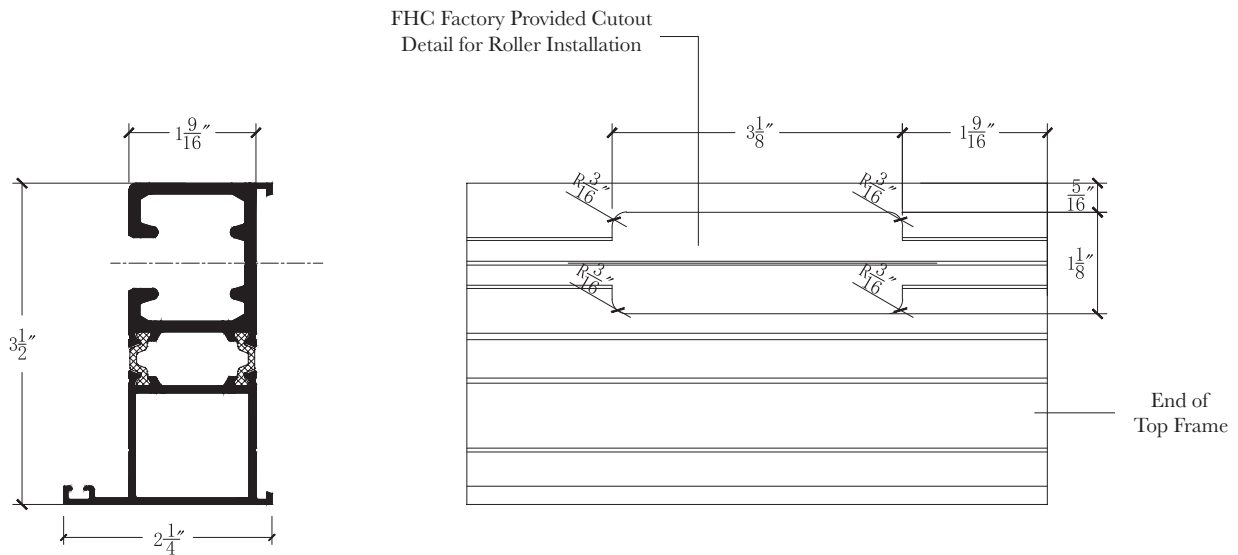
FHC's G50 bi-fold hinges are all factory installed to each bi-fold door panel and come ready for installation. Mounting screws are included.



Note:

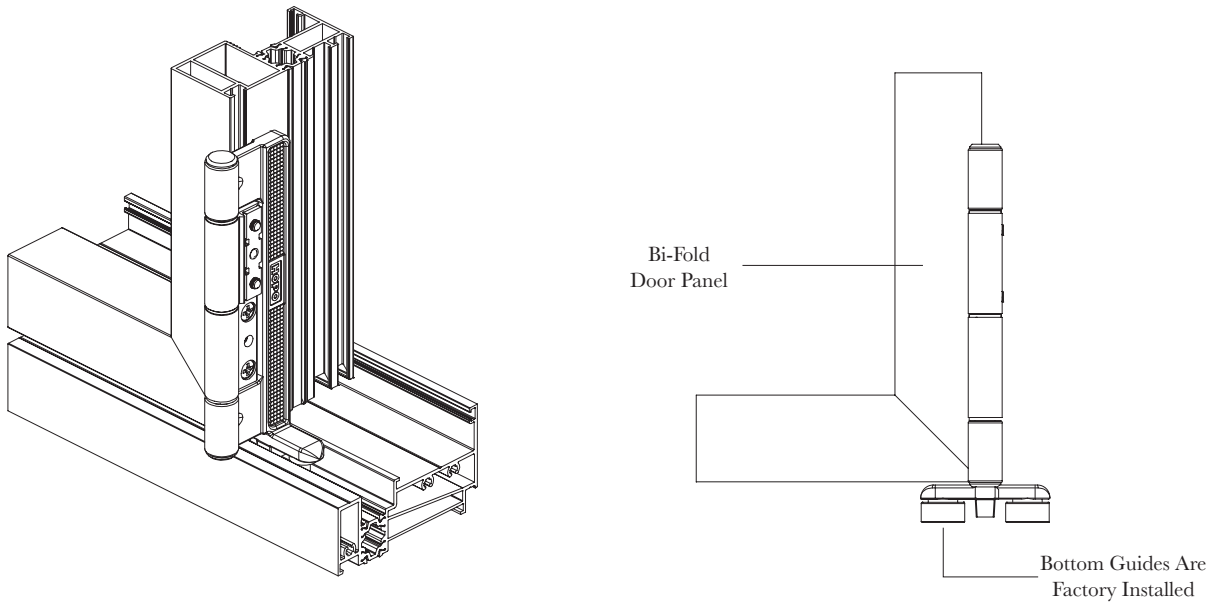
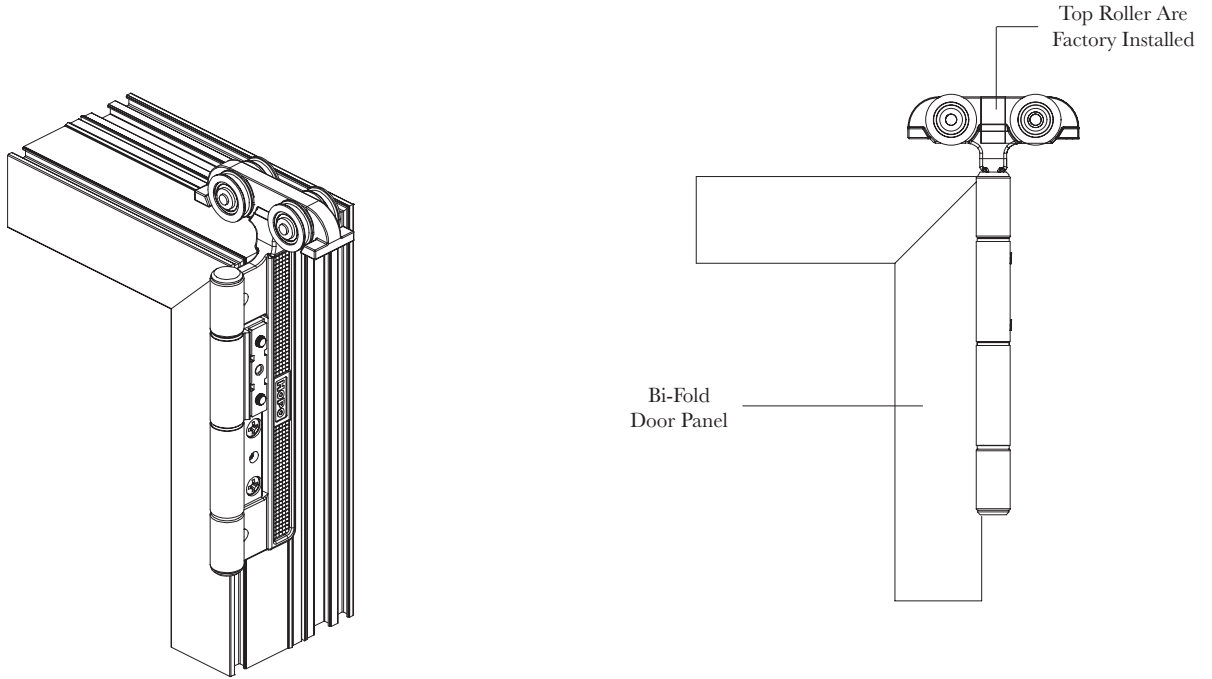
1. The distance between first hinge of the top and bottom installation positions and the edge of the sash frame is 4 inches.
2. The middle hinge position is located at the mid-point of the door.

Hardware and Accessory Assembly



Use factory provided access cutout in the top frame to install and remove the bi-fold top rollers. Note: The top rollers come factory installed on each bi-fold door unit or easy installation into the top frame.

Hardware and Accessory Assembly



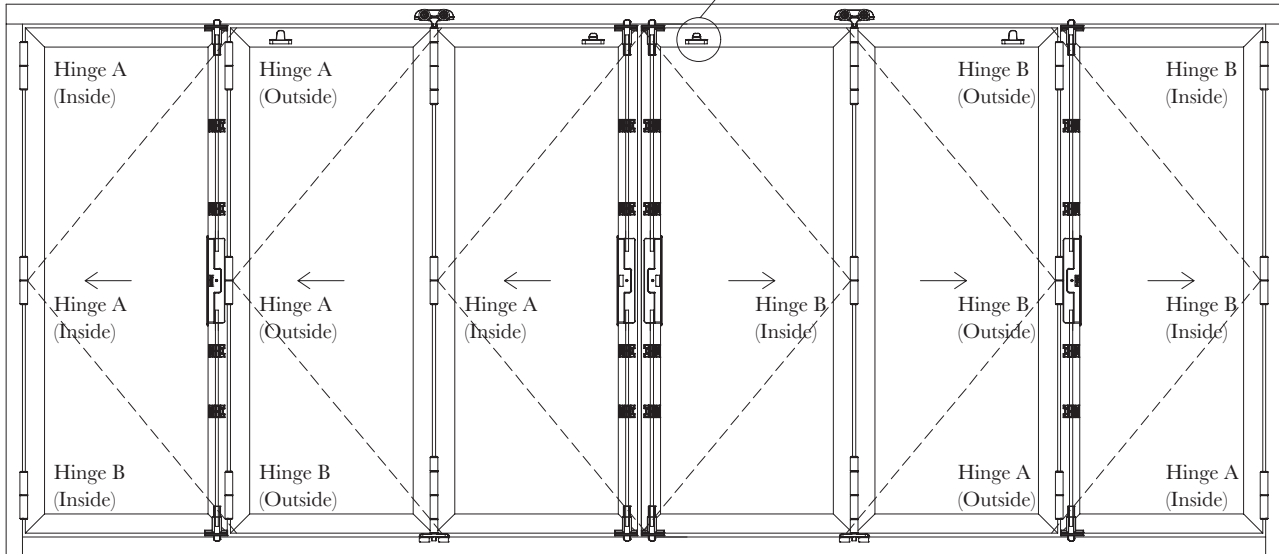
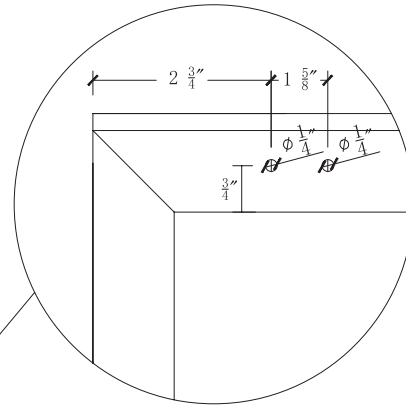
Technical Details:

1. The distance between roller of the top and bottom installation position and the edge of the sash frame is 1-1/2".
2. The middle hinge position needs to be aligned with the hinges on "left one" and "left two".

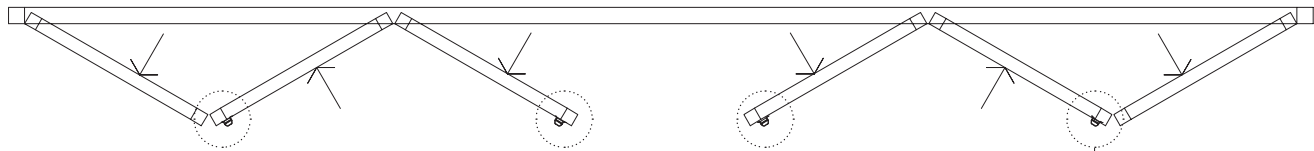
Hardware and Accessory Assembly Diagram

FHC's door panel catchers/bumpers are designed to be installed at the jobsite after installation. Use the guide on this sheet to locate and install them as required.

Door Panel Catcher
Installation On Site



Exterior Side



Interior Side

Door Panel Catcher