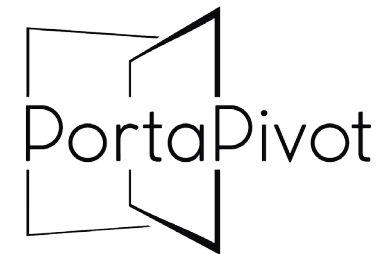




# ASSEMBLY MANUAL

## PortaPivot 6530 XL

Watch our instruction videos on [www.portapivot.com](http://www.portapivot.com)



STEALTHPIVOT  
By PortaPivot

Patented technology

# PortaPivot 6530 XL & StealthPivot XL Complete Kit

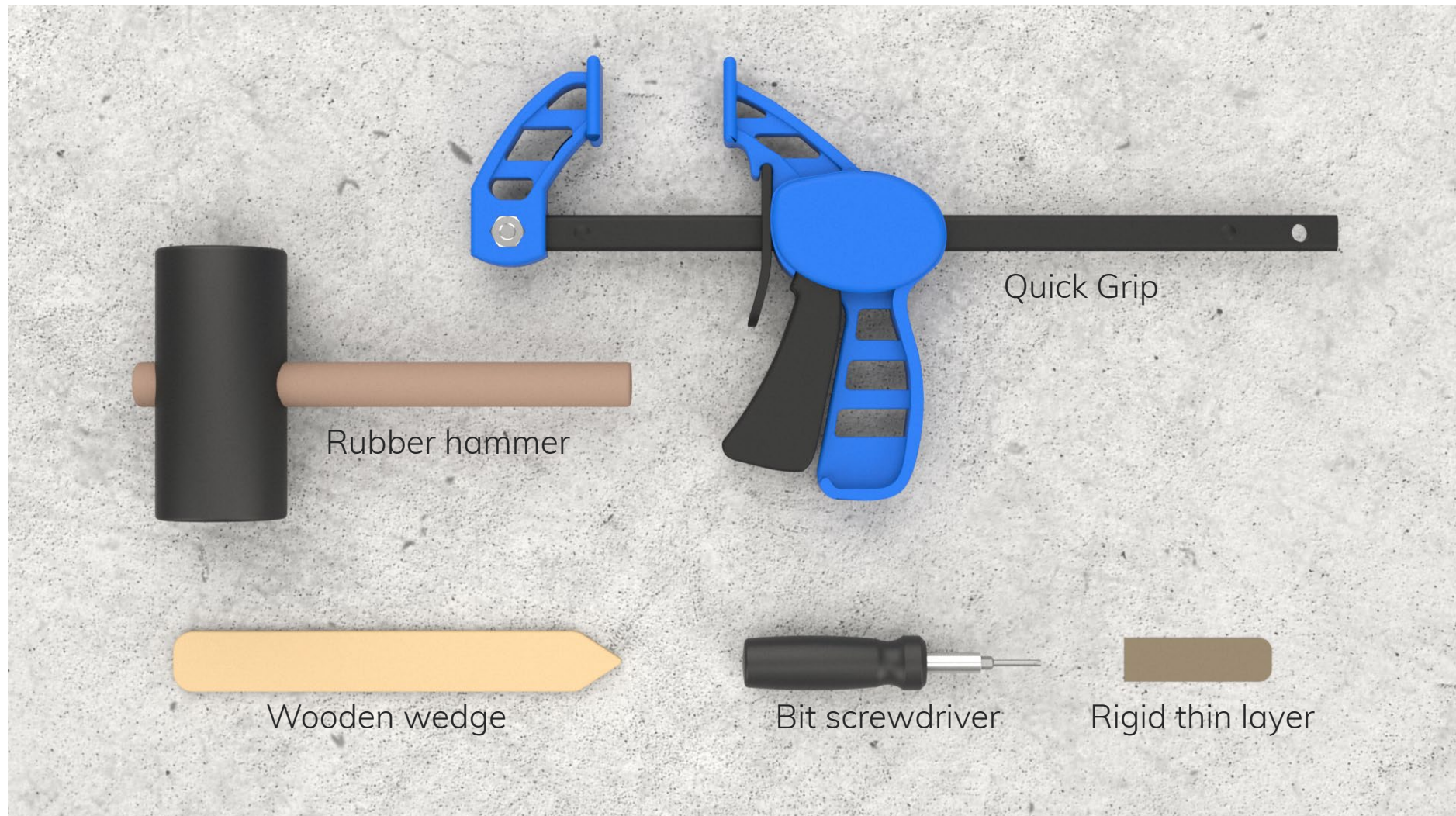
Hardware  
& accessories

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 5kg.

'Complete' StealthPivot XL kit is displayed, but assembly is also possible with 'Essential' or 'Basic' kit.

# Recommended tools

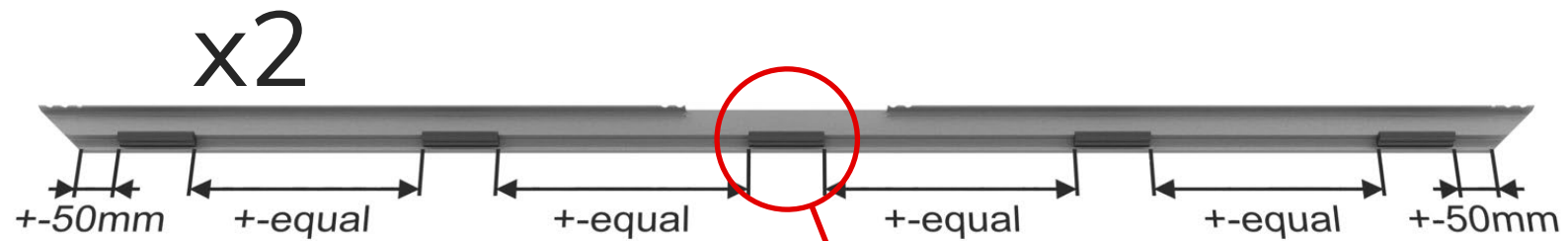
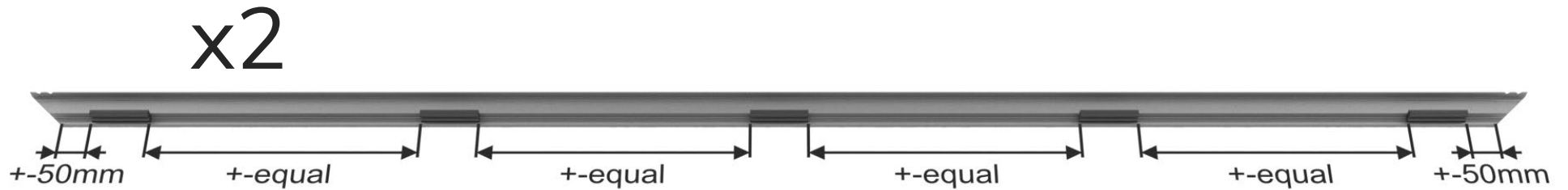


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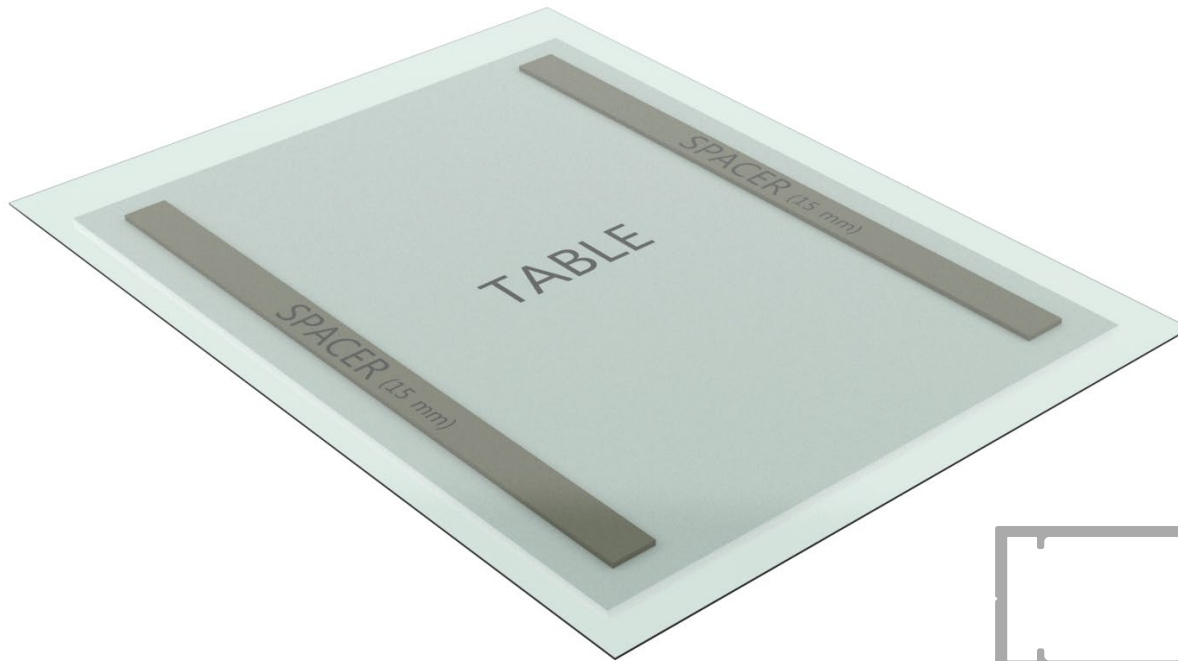


Slide in 5 EPDM inserts (GLB6-8) into every profile, and distribute them evenly.

**Beware: sharp edges!**

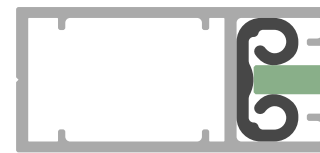


**Always position 1 insert above pivot axis**

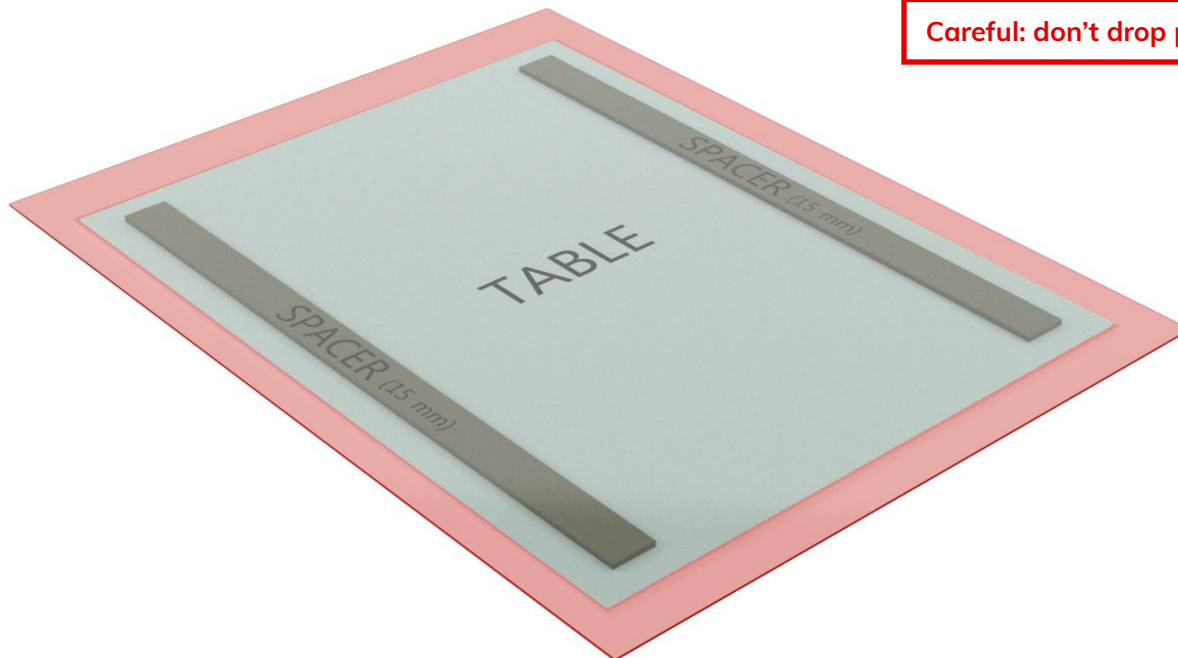


Use 2 wooden spacers (+-15 mm thick) on an assembly table and place the locally purchased panel on top.

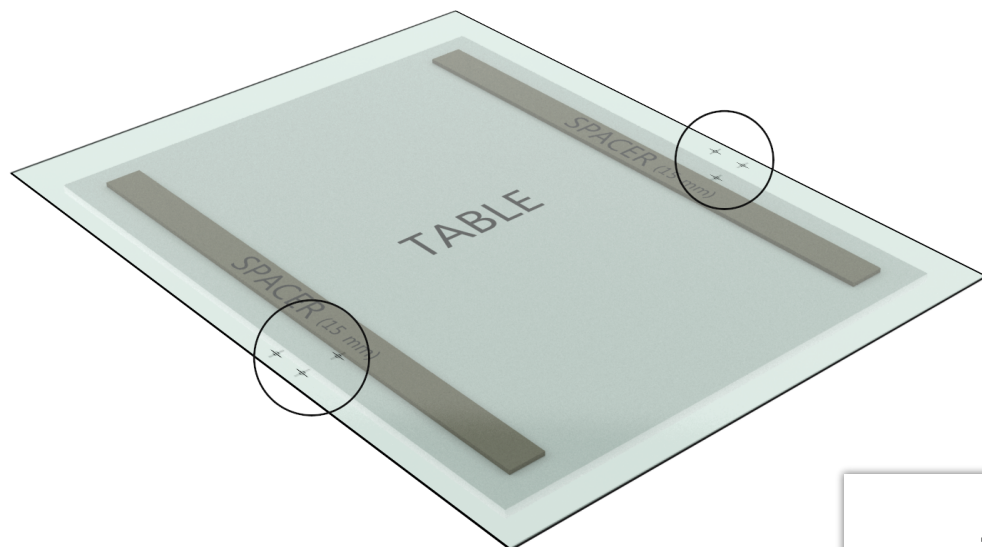
Spacers are needed to provide space when mounting the aluminium profiles around the panel.



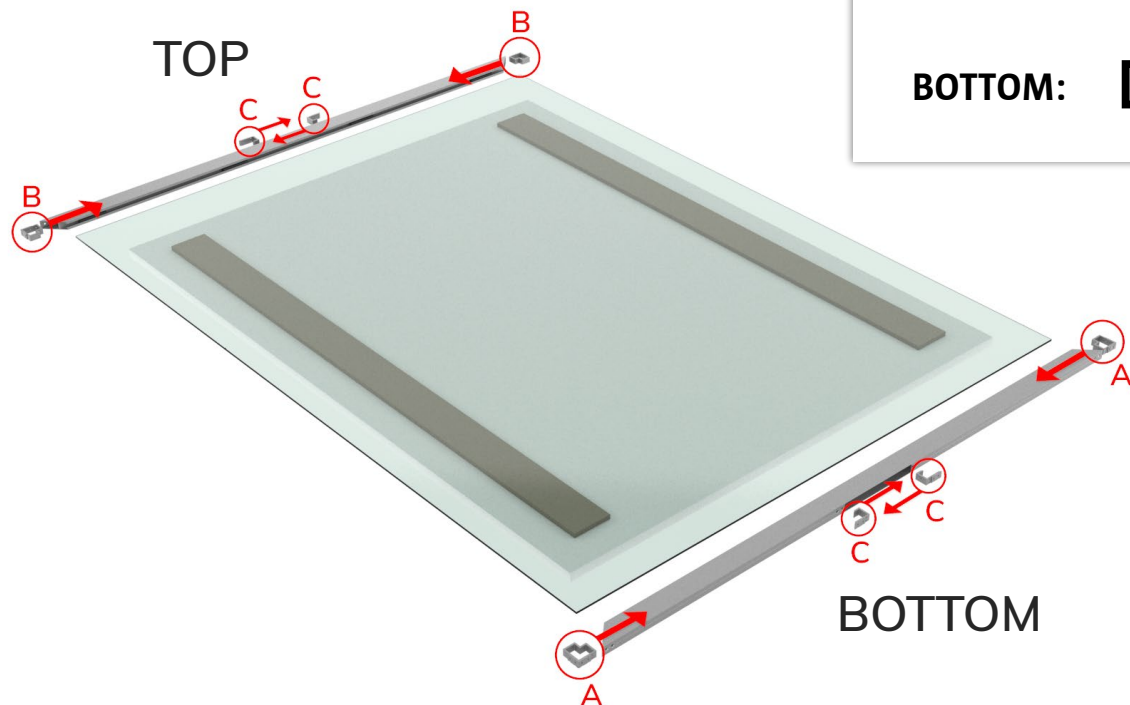
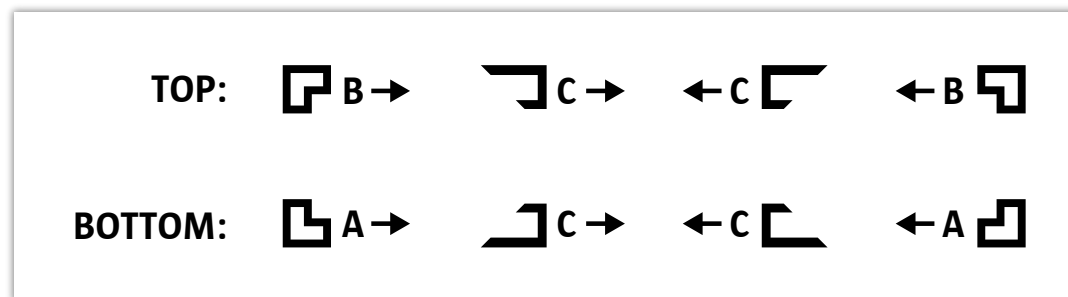
Careful: don't drop profiles!



Keep a clear region around the table to assemble the aluminium profiles.



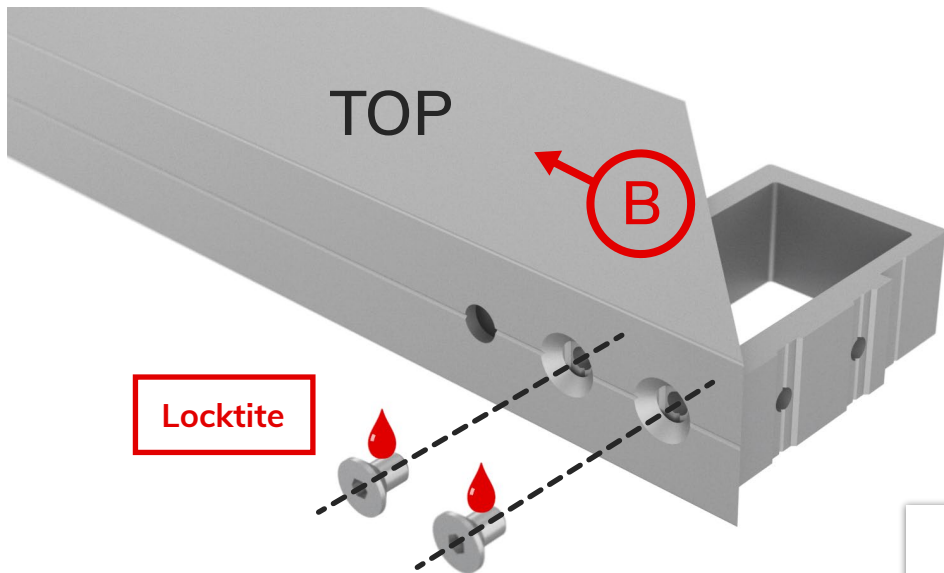
If panel has pre-drilled holes, note that it has a top and bottom side!



All connection parts are labeled.

Exact positioning is essential for assembly!

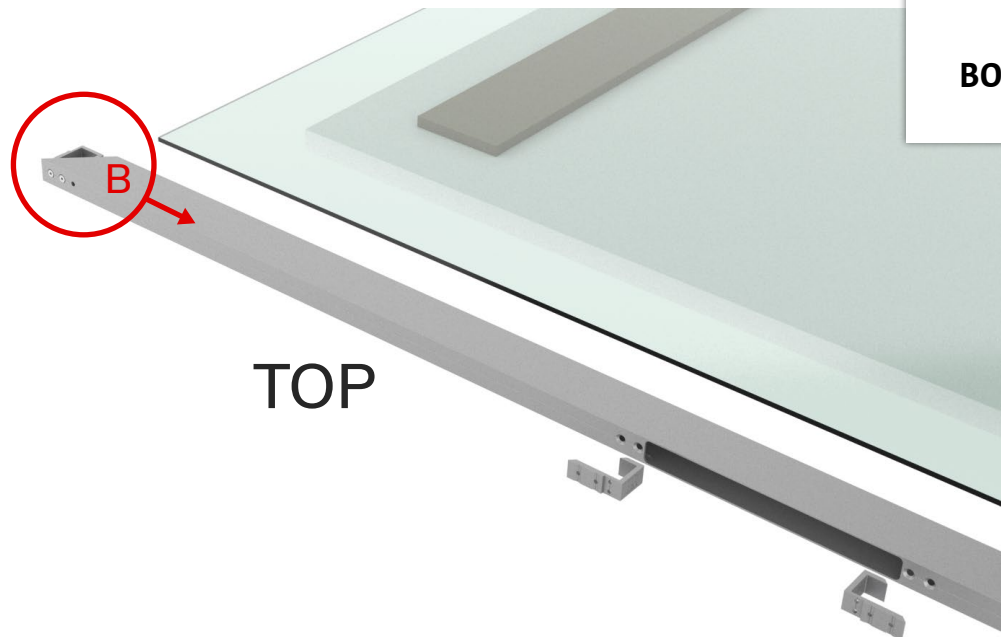
All labels face inwards.



Slide B parts in the top profile, labels facing inwards.

Screw in top screws, using locktite.

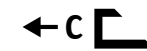
**Do not tighten fully yet!**



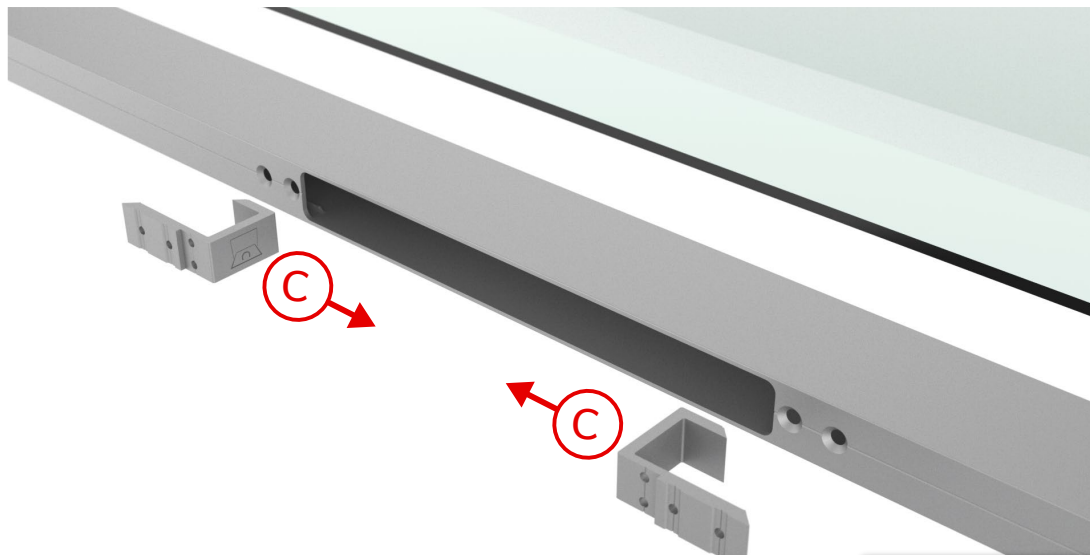
TOP:



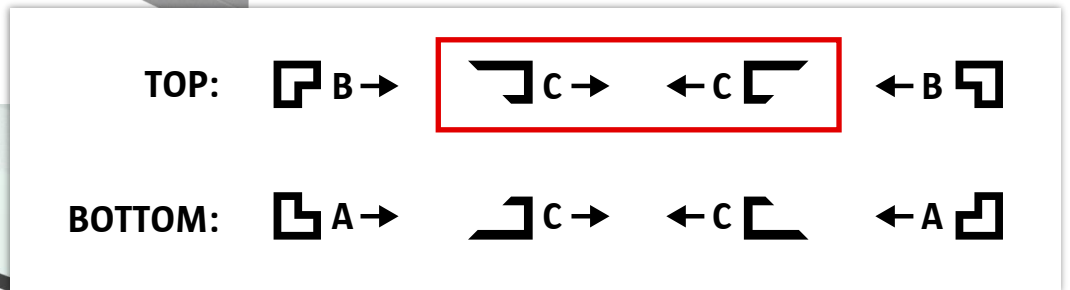
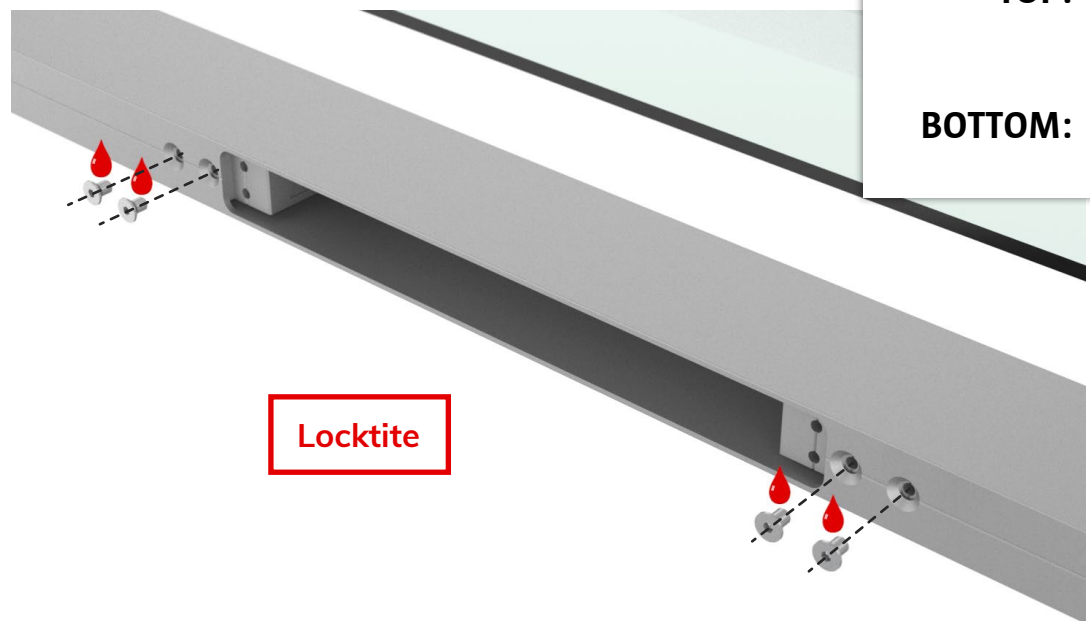
BOTTOM:



Repeat for the top right corner.



Slide in the C parts with labels facing inwards.

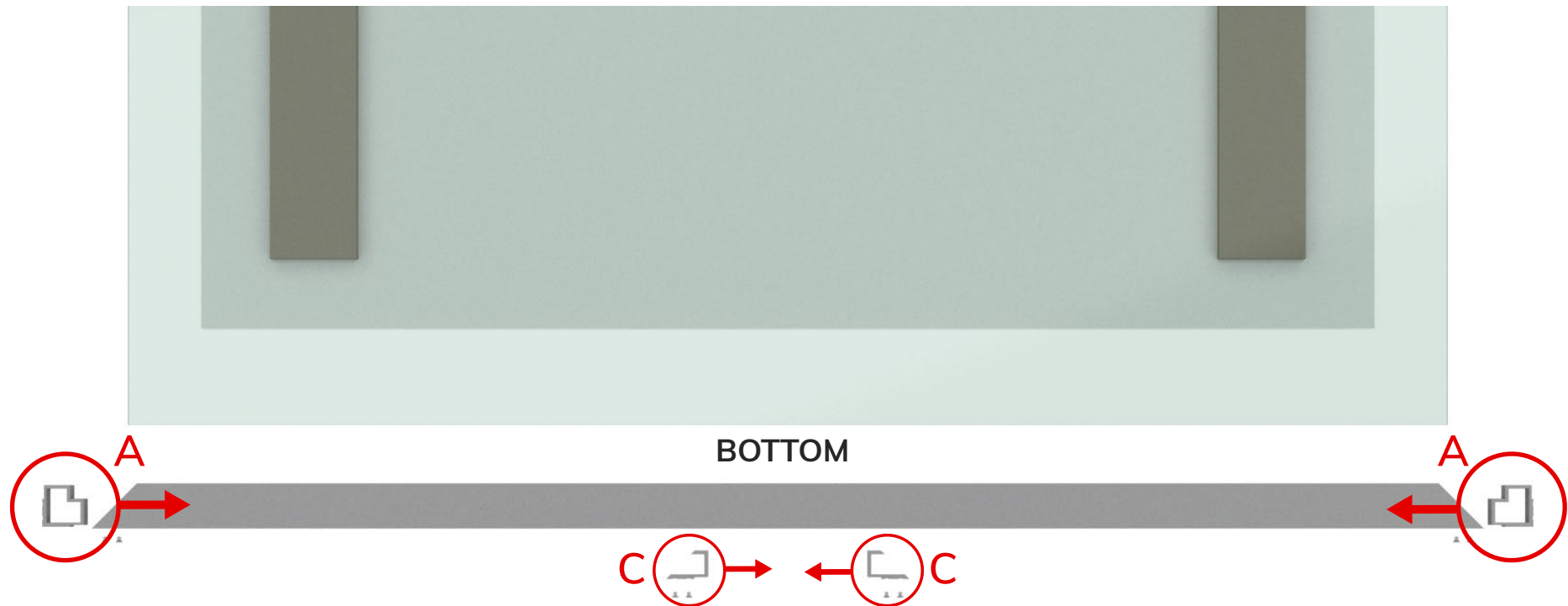






Lock with 4 screws.  
Use locktite on all screws.





**Do not tighten fully yet!**

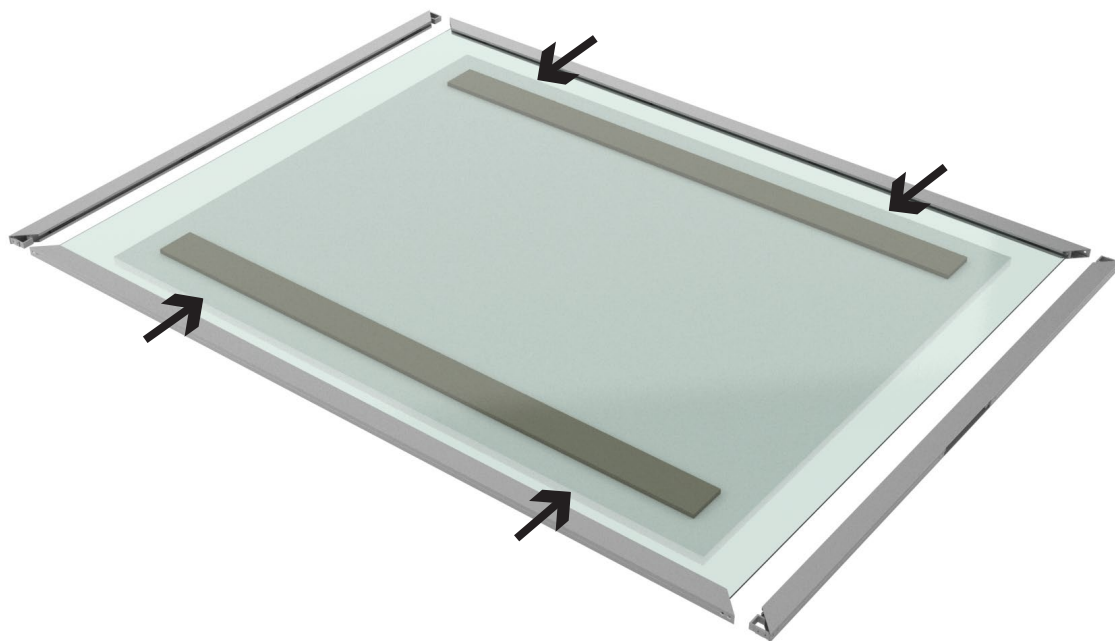


Repeat for the bottom profile, now **with A parts in the corners** and C parts in the middle.



TOP:  B →  C → ← C  ← B 

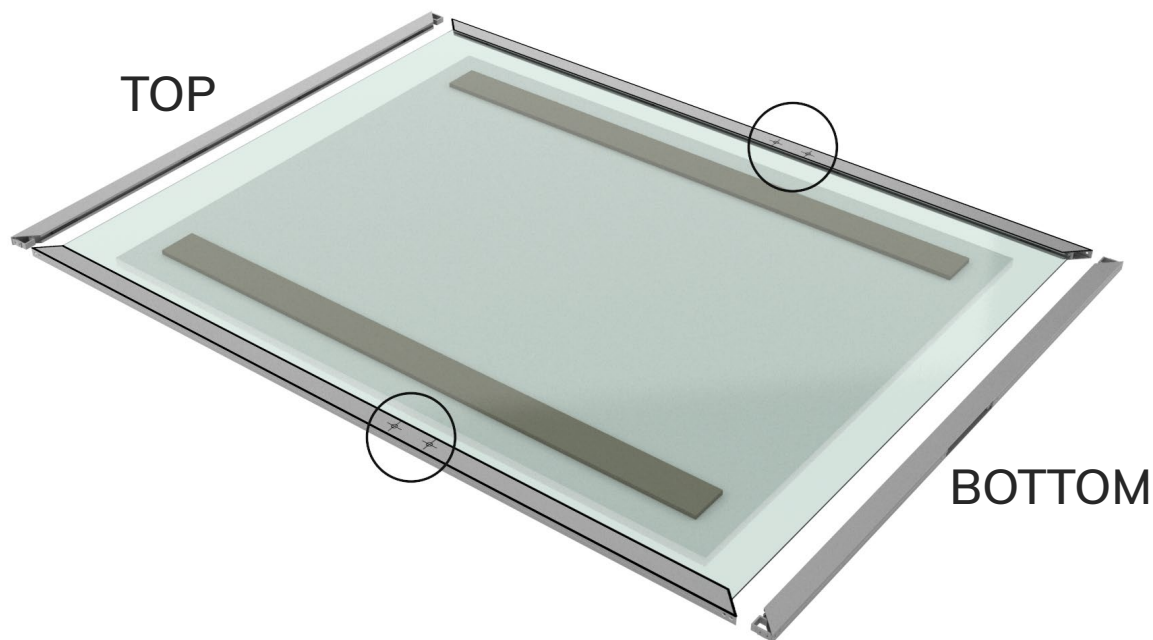
BOTTOM:  A →  C → ← C  ← A 



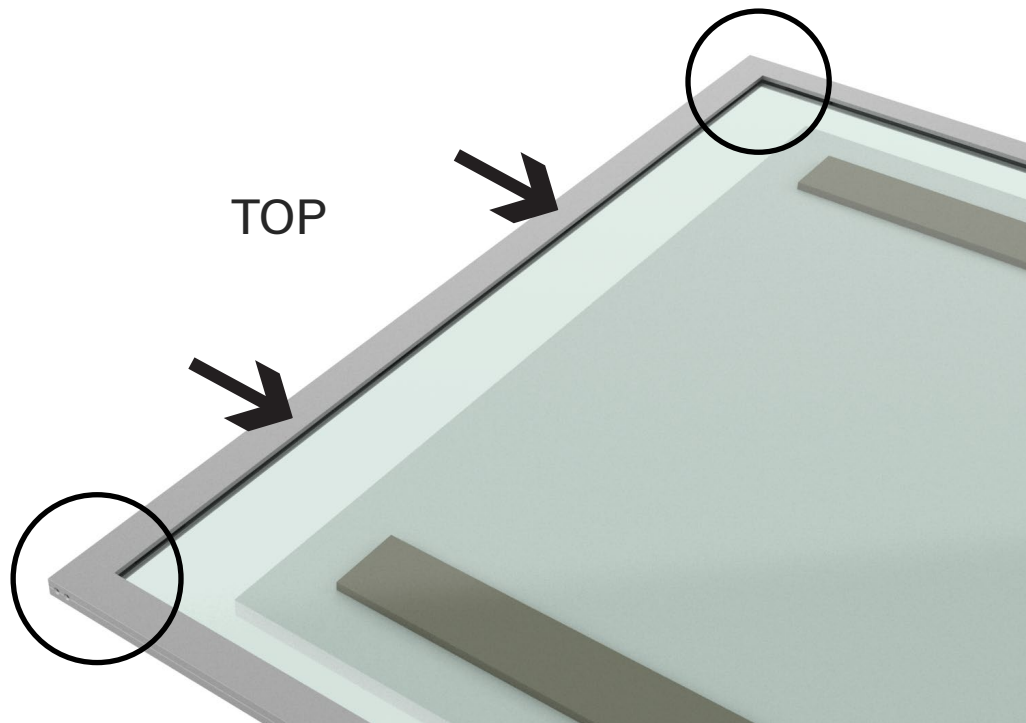
Step 1: Push left and right profile with their EPDM inserts over the panel.

Apply extra silicone spray on EPDM inserts if necessary.

**Careful: don't drop profiles!**



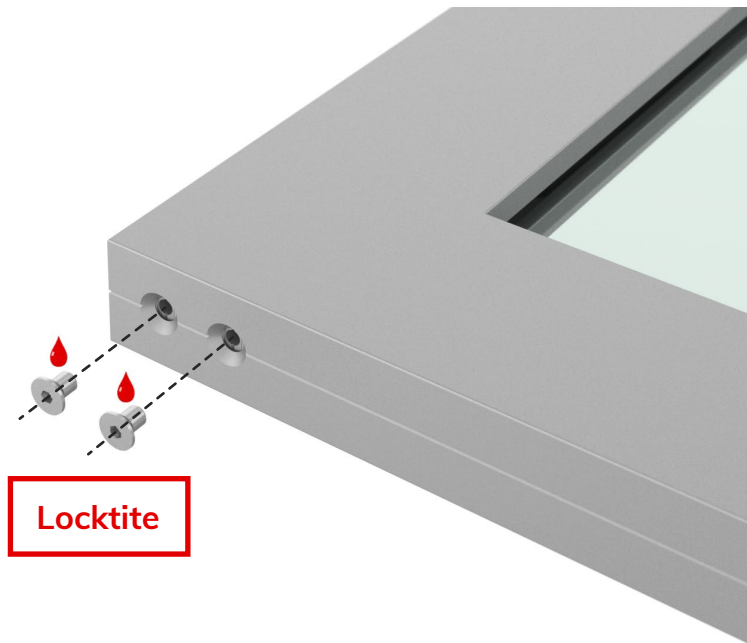
If there are holes for door grips in the profiles, their top/bottom orientation is important.



Step 2: Slide the top profile into left and right profile, and over the panel

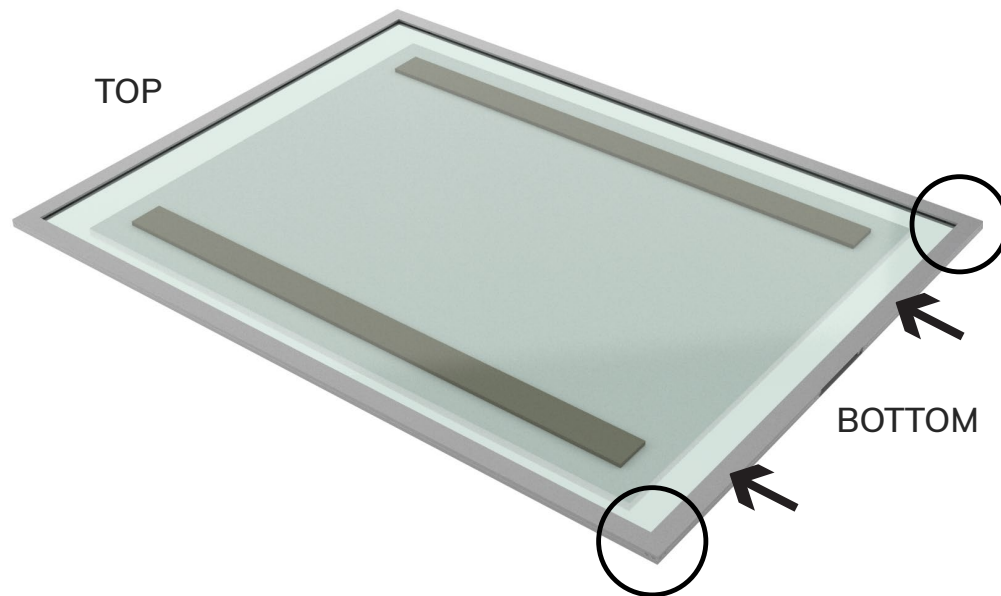
Apply extra silicone spray on EPDM inserts if necessary.

**Careful: don't drop profiles!**



Insert screws into side profiles (left and right side).

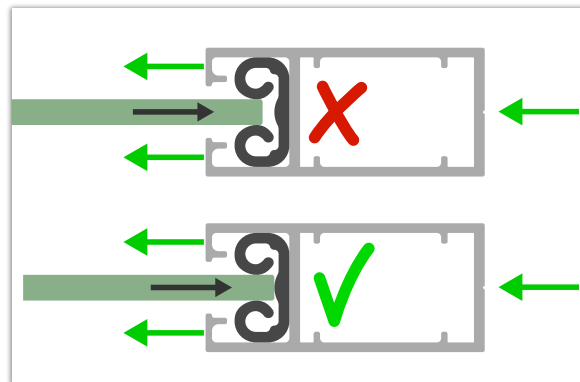
**Do not tighten fully yet!**



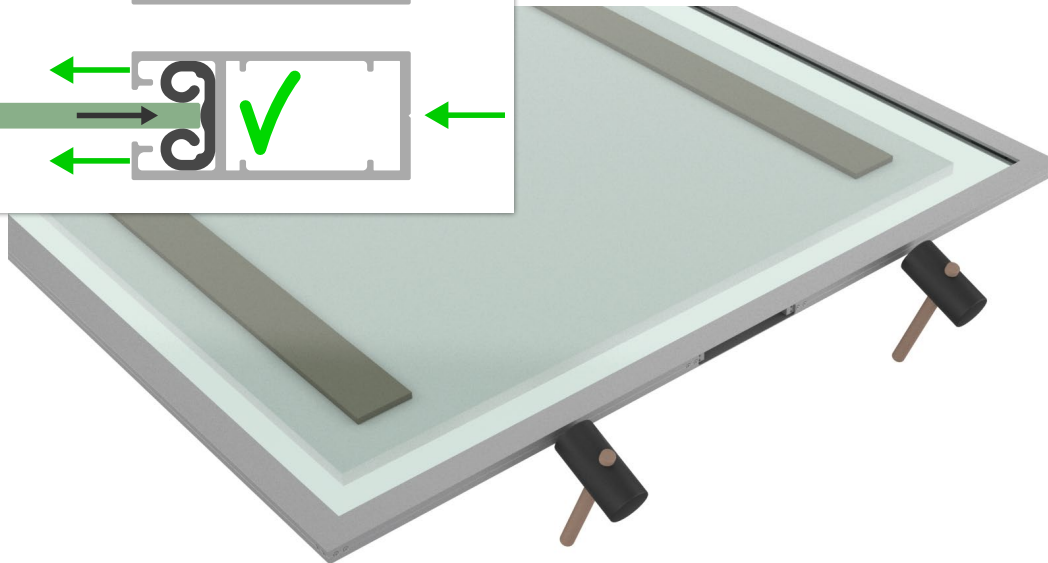
Step 3: Slide the bottom profile into left and right profile, and over the panel

**Do not tighten fully yet!**

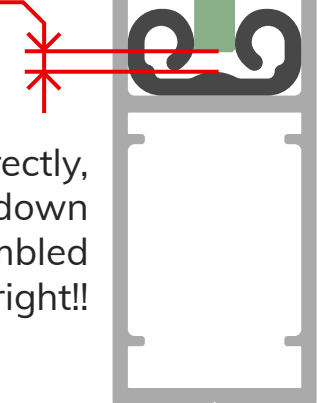
**Careful: don't drop profiles!**



Step 4: When all screws are inserted (not fully tightened), use a rubber hammer to position the bottom profile with the EPDM inserts against the panel.



**=0 mm!!**



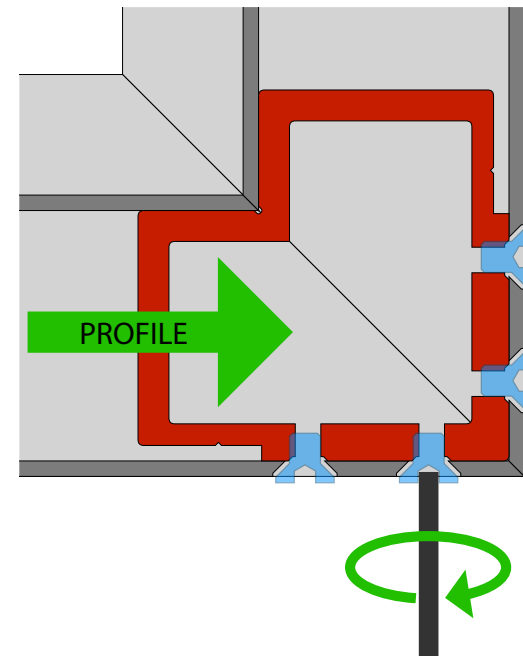
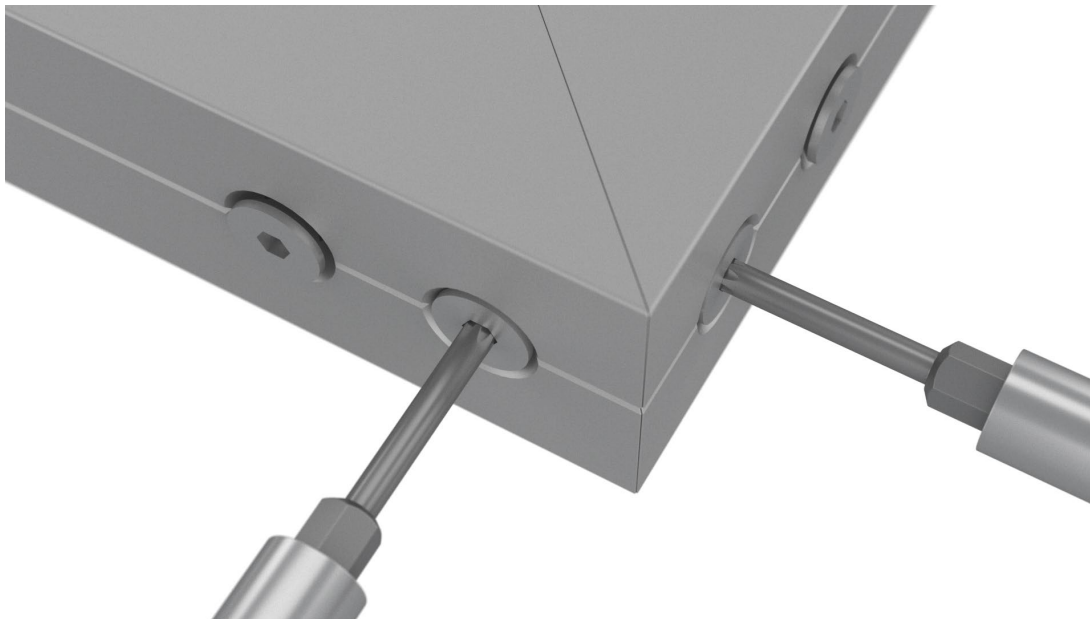
If NOT positioned correctly, the panel will slide down when the fully assembled door is put upright!!





Adjust corner alignment by tightening the screws one by one.

This will take some practise and is a trial and error process to get it perfect!



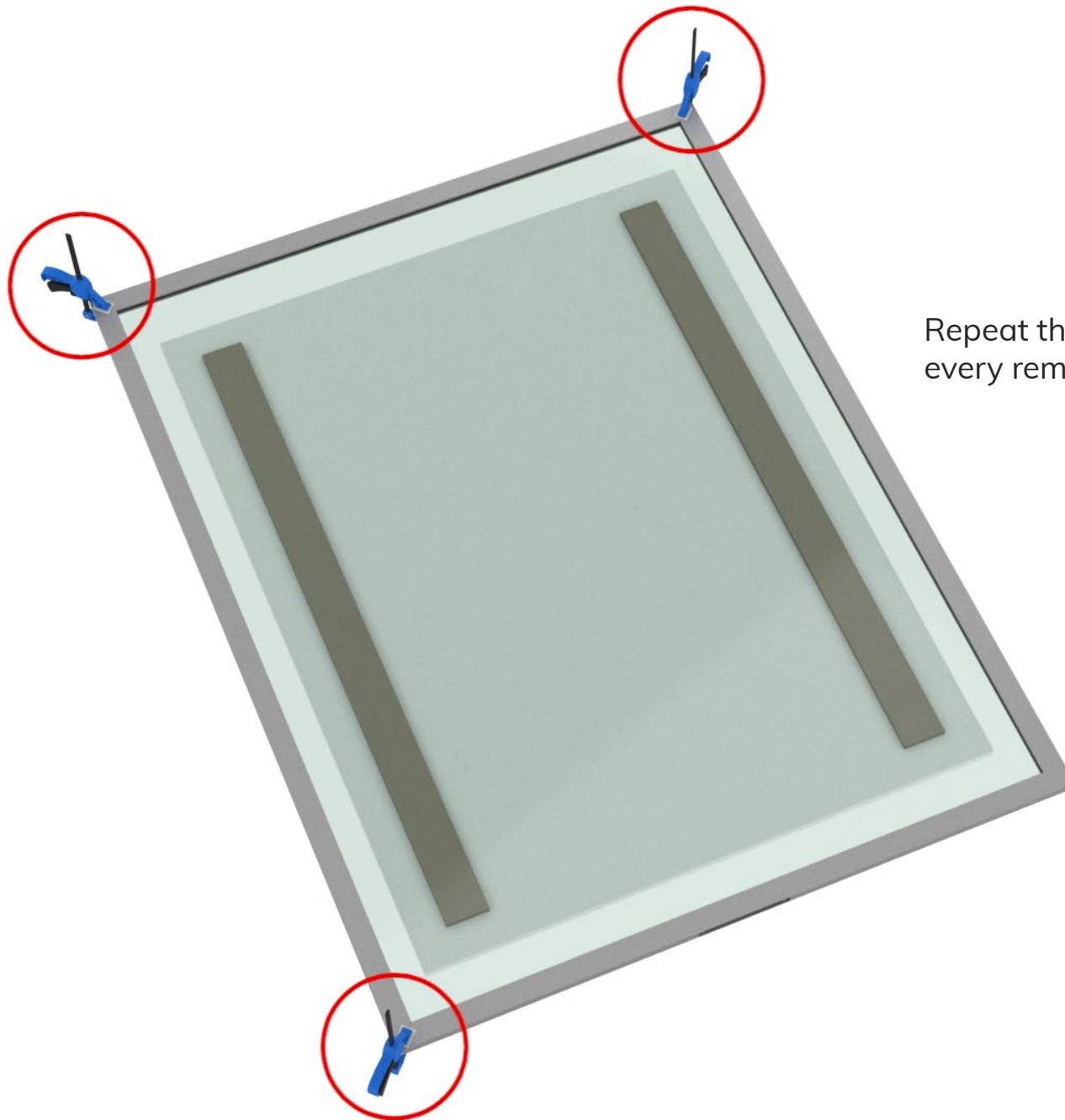


Before tightening all screws, prevent vertical shifting using a quick grip tool.

Protect profiles against scratches.

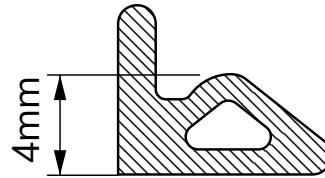
Tighten all screws while maintaining a perfect corner alignment with the quick grip.



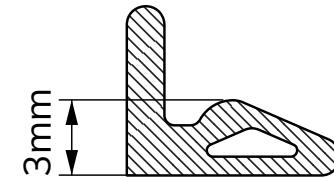


Repeat the same process for every remaining corner.

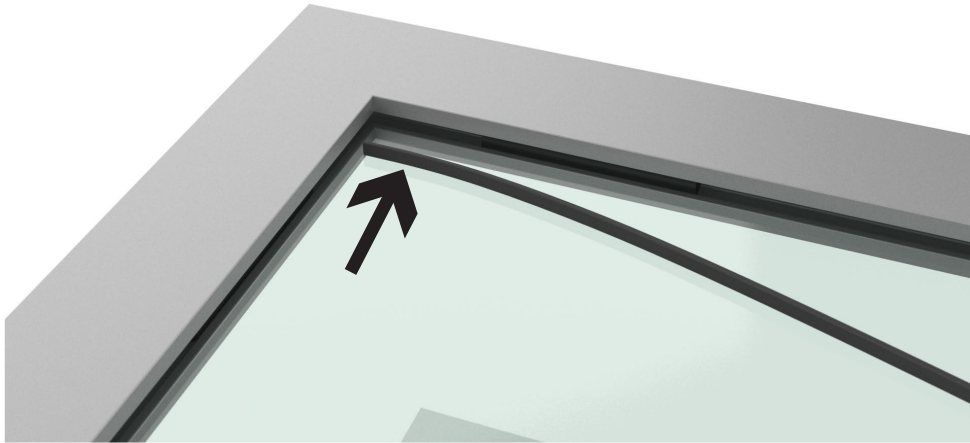
Use the appropriate rubber filler for 6 mm or 8 mm thick panels.



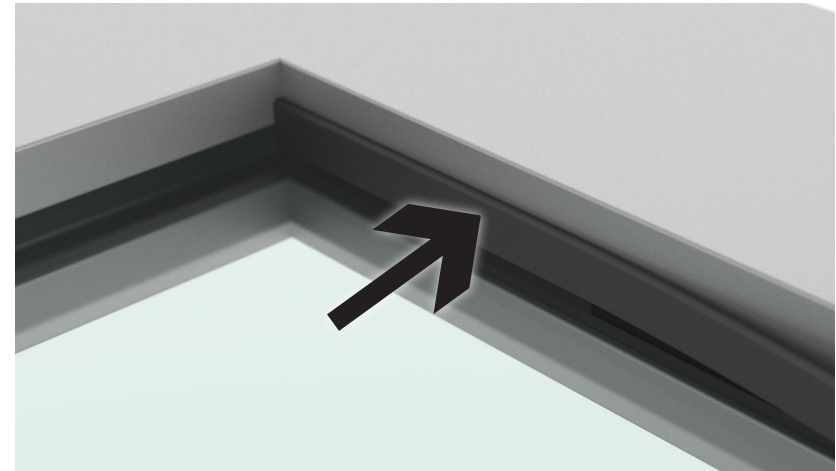
6mm panel  
use GBL6



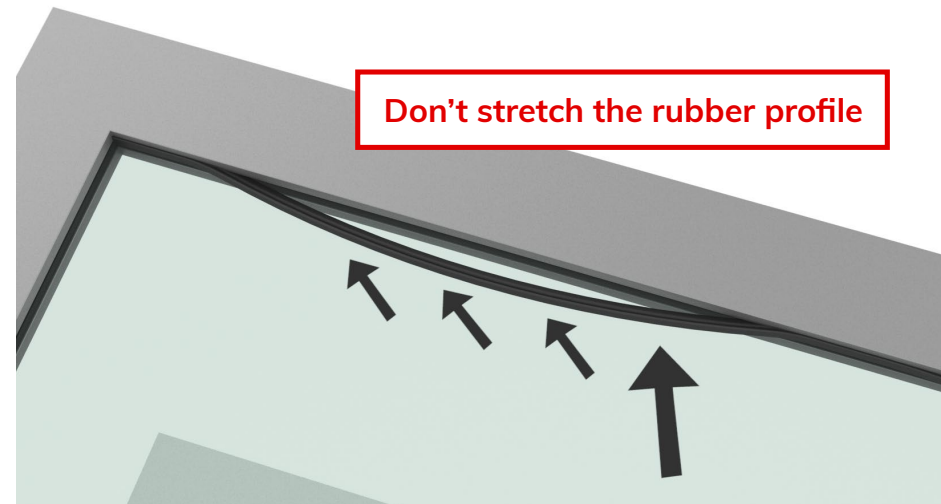
8mm panel  
use GBL8



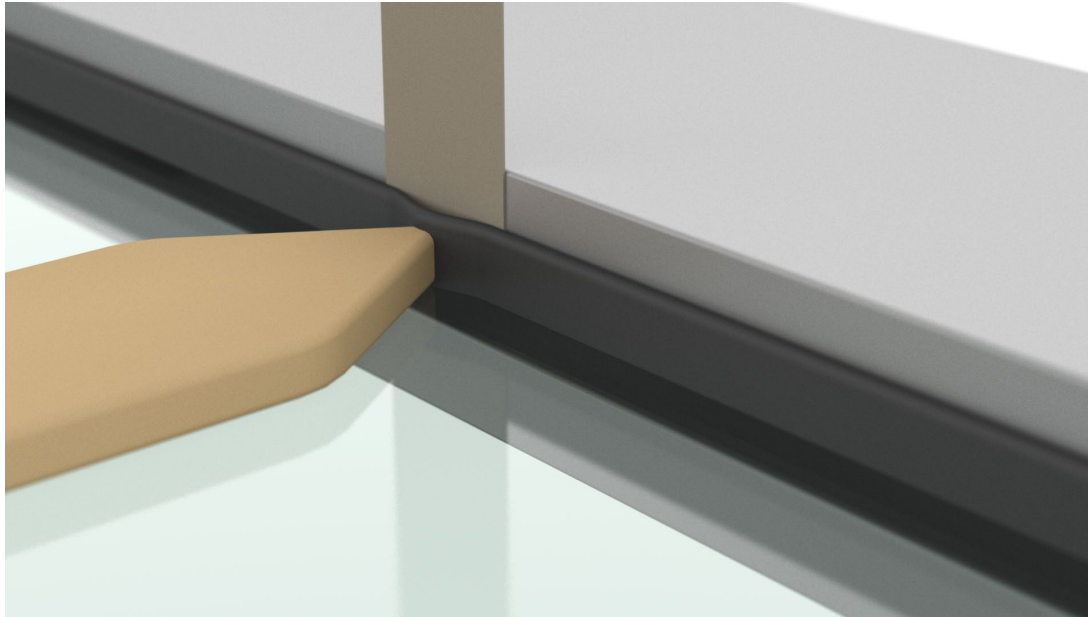
Push the rubber profile in the top left corner.



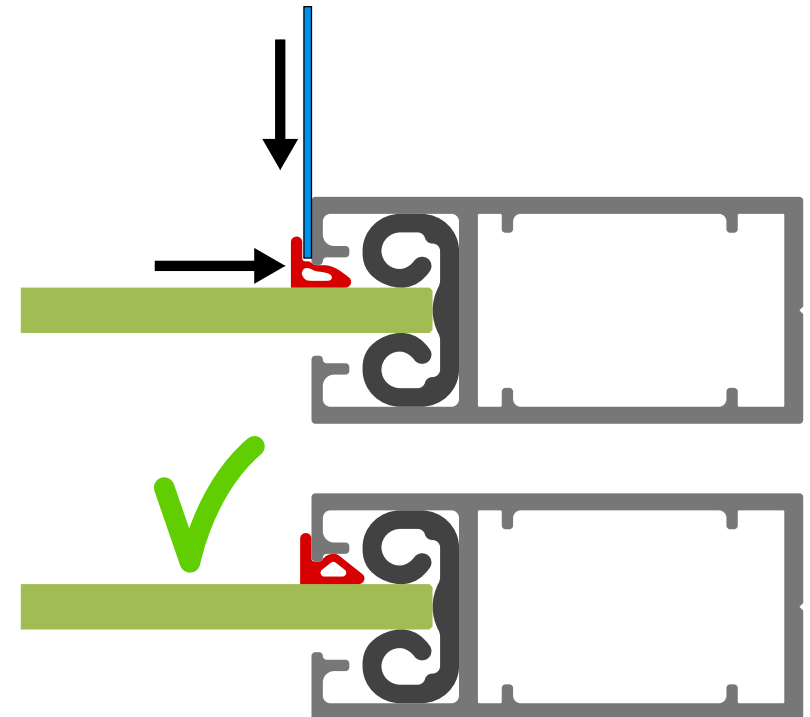
Push in at a further point, and work your way backwards to prevent stretching of the rubber profile while mounted.





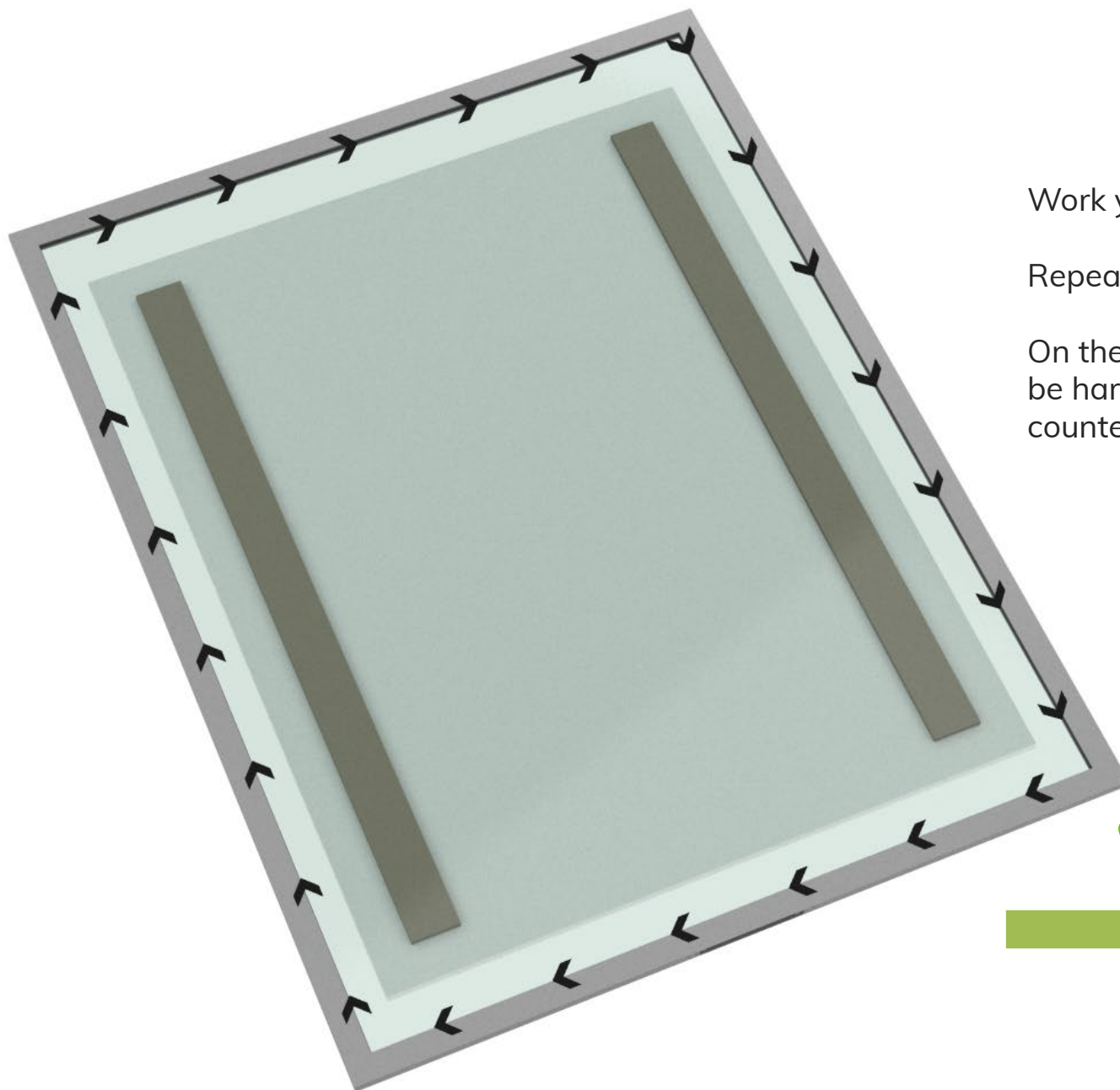


If rubber doesn't pop into place well, use a 1-2 mm thick aid (creditcard) to push the rubber down while pressing it in place.



Don't stretch the rubber profile

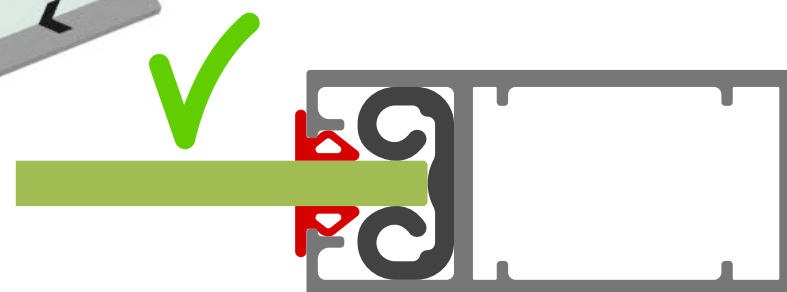
Use a wooden tool to press the rubber tightly (90°) into the corners without stretching it.

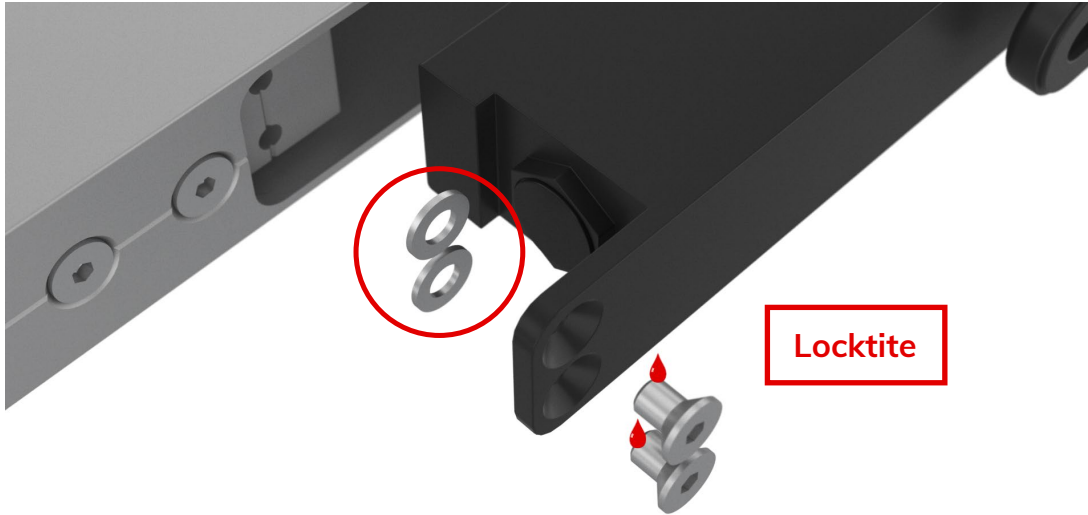


Work your way all around.

Repeat for the other side of the door leaf!

On the other side the rubber profile will be harder to insert because of the counterpressure from the first rubber.





Insert the StealthPivot XL into the doorframe.

Default joint dimensions (=distance between floor/ceiling and door leaf edge):

Bottom = 0 mm shims = joint 11 mm

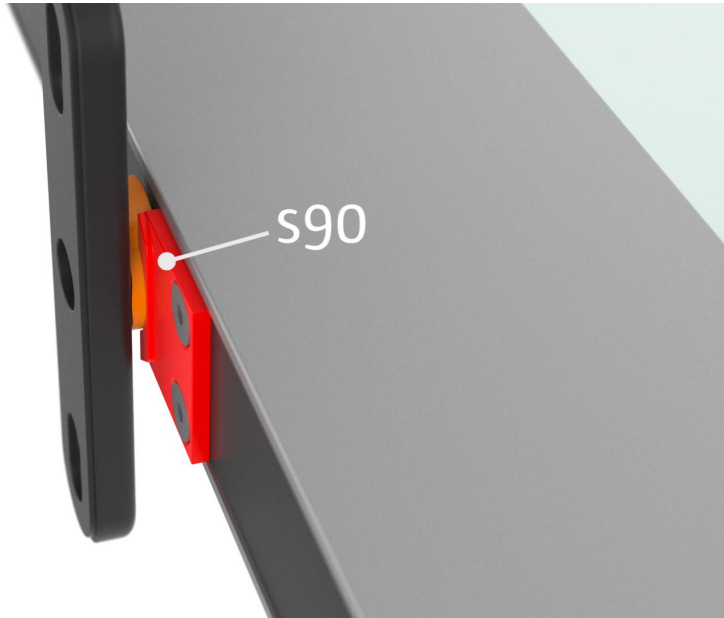
Top = 2 mm shims = joint 12,5 mm

Use more or less shims to adjust the desired joint dimensions in regard to the measurements of the doorway.

bottom = 11,0 mm | top = 12,5 mm

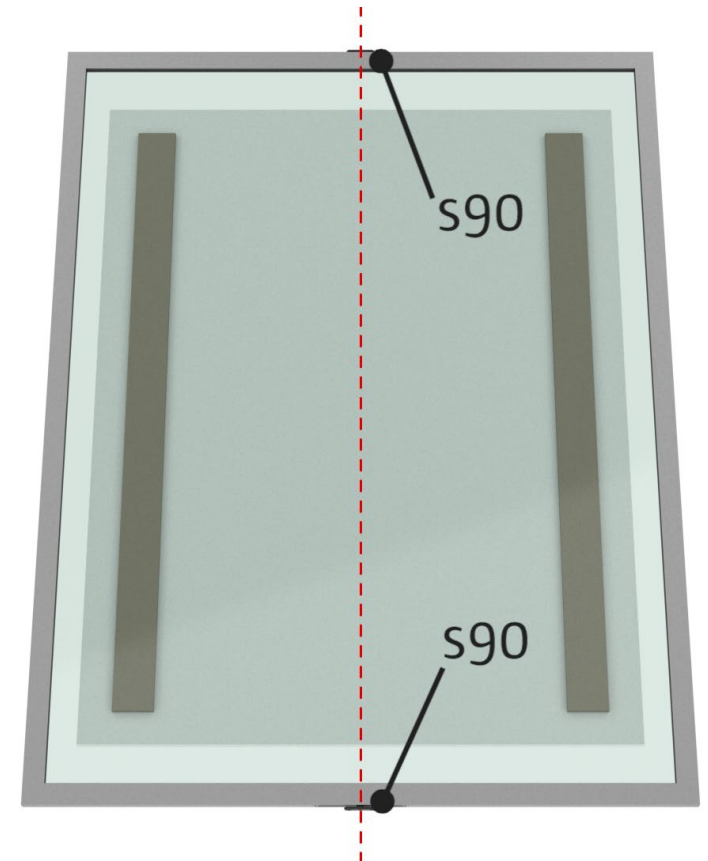


Fully tighten all marked screws when joint dimensions are as desired.



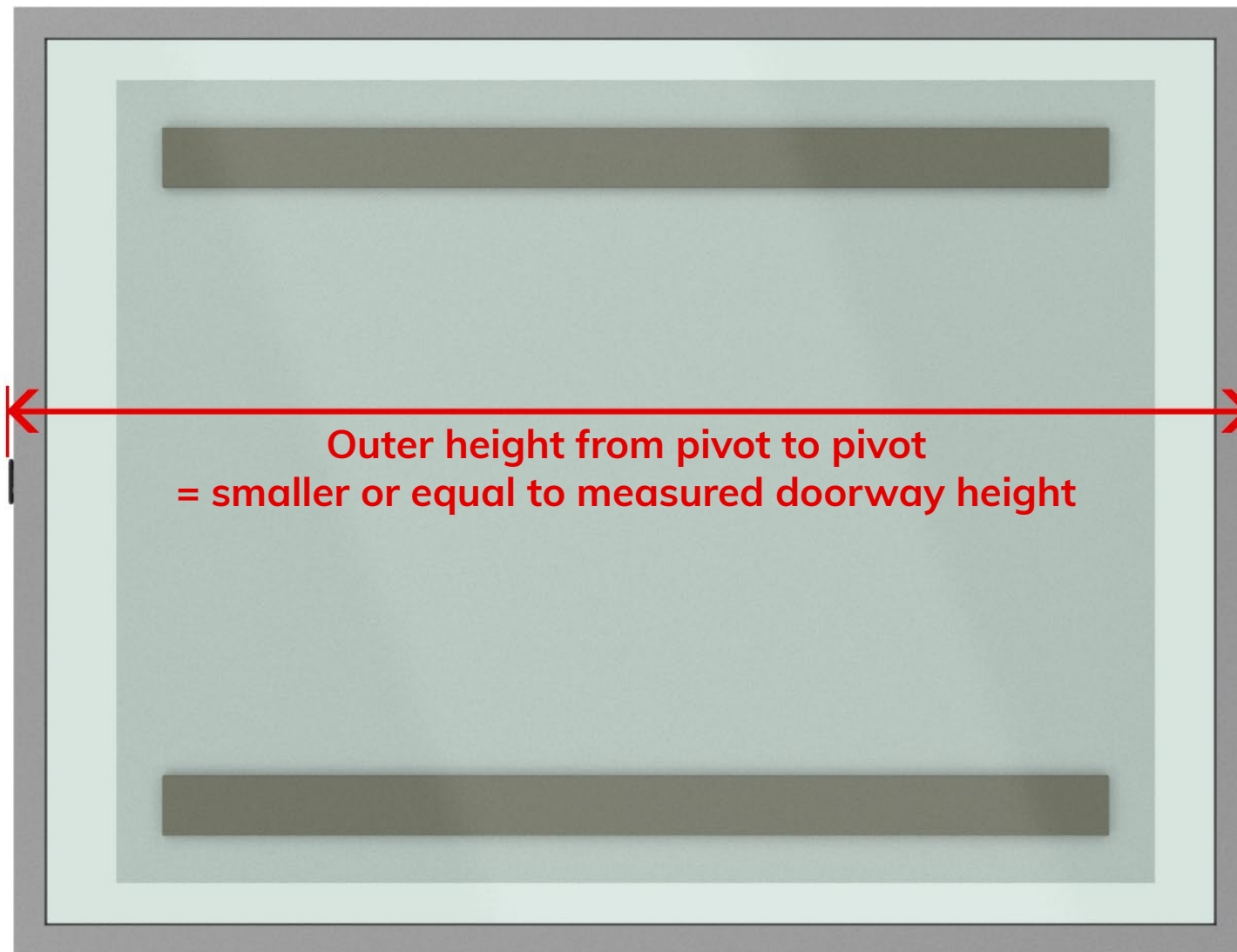
The s90 will stop the door in open position at  $\pm 90^\circ$ .

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



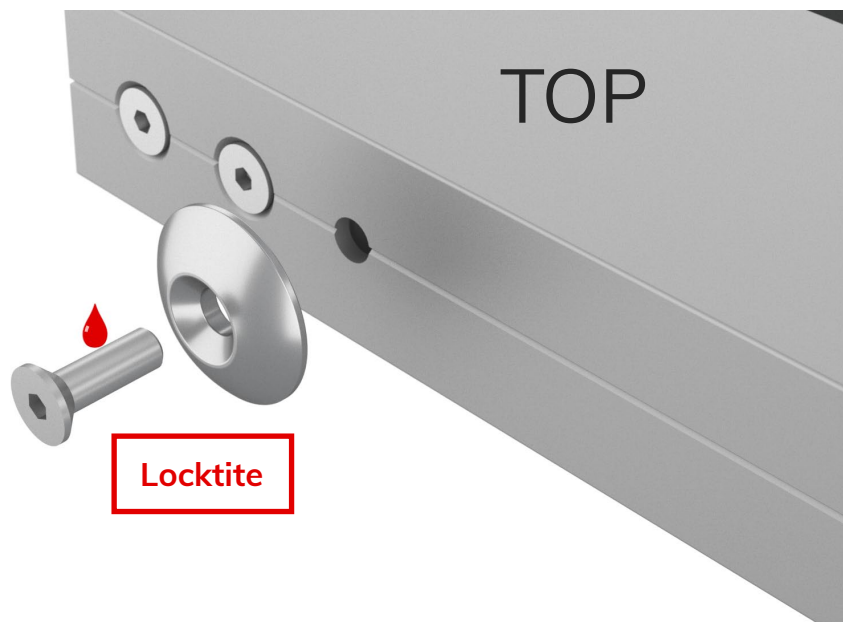
For unlimited  $360^\circ$  rotation, remove the s90 from top and bottom pivot. This is only advised for central axis position.



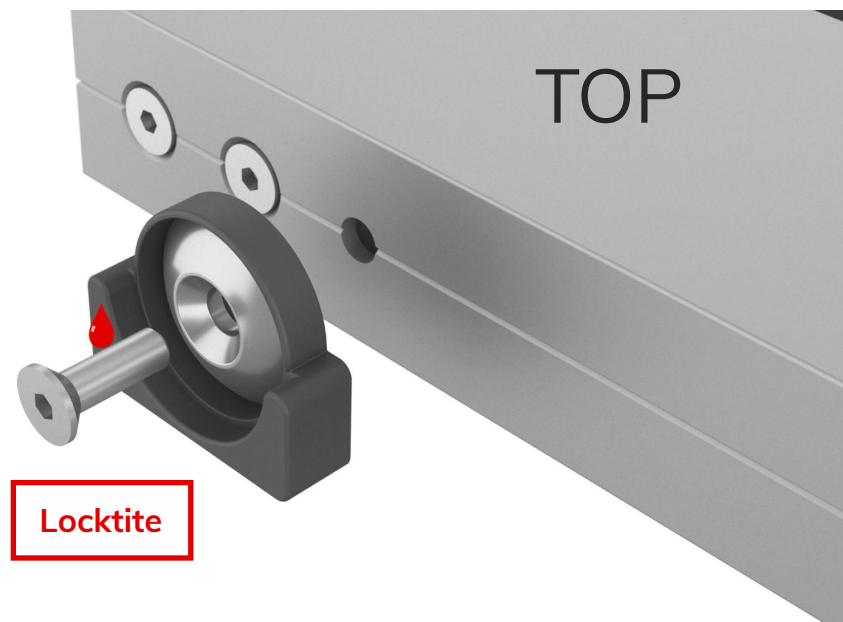


Measure the fully finished door leaf from top to bottom and compare with your doorway measurements before installing the door into the doorway!  
Adjustments can be made by changing the shims (see page 19), or by adding shims between the pivot mounts and floor or ceiling (see manual door leaf installation)

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



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



When using a 1-way at both sides,  
make sure the orientation is correct.

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

All manuals are also available in video format on [www.portapivot.com](http://www.portapivot.com)