

TITGEMEYER ^{GTO}

YOUR SOLUTION

■ **GETO[®] Megaport II** flush rear doors
Assembly Instructions



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Gebr. TITGEMEYER GmbH & Co. KG

Osnabrück

Assembly instructions for GETO Megaport II flush rear doors

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GETO® Megaport II flush rear doors

Assembly Instructions

Pre-assembly work

Please read the following installation instructions **before installing** the GETO Megaport II flush rear doors.

TITGEMEYER cannot be held responsible for incorrect installation work. It is assumed that only suitably qualified employees will be used for the installation work and that, at all times, the relevant technical standards and applicable regulations will be observed.
The products constantly undergo improvement and technical review.

These installation instructions apply to the 2-door and 4-door versions of the GETO Megaport II flush rear doors.

The following fitting materials are supplied

- Bottom door gear keepers
- Top door gear keepers
- Double pivoting hinges (unassembled) for the doors comprising:
 - Aluminium hinges with bushes, unmilled
 - 4 aluminium hinges with bushes, milled
 - 4 torsion springs
 - 1 hinge bracket per hinge
 - 2 cheese head screws with M 8 safety nut per hinge

Tools required for the installation work

- C clamps, clamps
- Set square
- Drill and drill bits
- Installation tool for 6.5 mm blind rivets
- Ring and open-ended spanners: 13, 17 mm
- Allen key, 6 mm
- Ratchet and adaptors 13, 17 mm

Tightening torque for bolted joints

M 10 thread - screw grade 8.8 - torque 49 Nm

Assembly sequence

- Adjust, align and fasten the door leafs on the rear frame
- Adjust, align and fasten the hinge brackets on the rear frame
- Rivet or weld on the hinge brackets
- Fit the double pivoting hinge plates
- Fit the top and bottom door gear keepers
- Fit the leg springs (tension springs) in the hinges

Preparatory steps

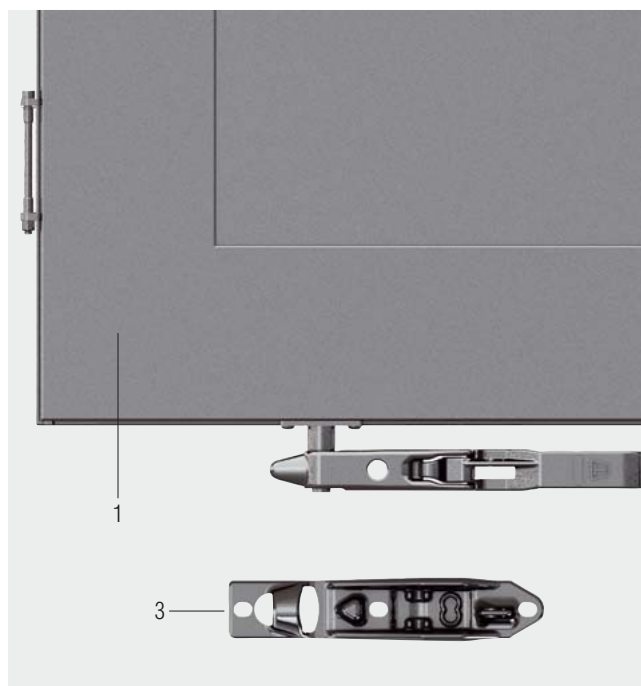
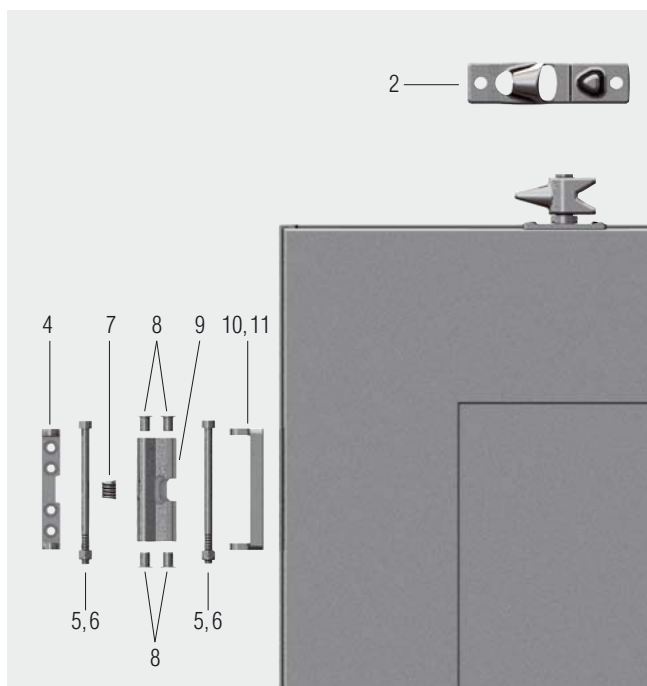
The rear frame on which the flush rear doors are to be fitted must be assembled on a flat surface without any misalignments.
The diagonal deviation should be < 3 mm!

GETO® Megaport II flush rear doors
 Assembly Instructions
List of supplied parts

List of supplied parts for GETO® Megaport II

Item	Item name	Part No.
1	Door leaf right/left	
2	Top door gear keepers	240 526 000
3	Bottom door gear keepers	240 207 000
4	Hinge bracket: rivet-on/screw-on version	240 515 000
5	Cheese head screw M 8 x 130 – 8.8 DIN 912	240 523 000
6	Safety nut M 8 galvanised DIN 982	661 822 000
7	Torsion spring made of 1.4301	240 521 000
8	Bush M 8	240 518 000
9	Hinge, milled	240 308 000
	Hinge, milled – extra-large spacing	240 308 001
	Hinge, unmilled	240 309 000
	Hinge, unmilled – extra-large spacing	240 309 001
10	Bolt-on bracket, casting	240 516 000
	Bolt-on bracket, casting – extra-large spacing	240 307 000
11	Cheese head screw M 8 x 16 – 8.8 DIN 912 (not shown)	240 520 000

The quantities of items 4 to 11 that are supplied depends on the number and type of hinge systems.



GETO® Megaport II flush rear doors

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Assembly preparation

Ensure that the flush rear door bearing surfaces are properly aligned and flat.

The diagonal deviation on the rear frame should be < 3 mm!

When constructing the frame, its external width should tally with the specifications provided with the order for the door kit.

First, position the left, then the right-hand leaf on the frame at the desired point of installation.

Align the door leaves as per the specifications and lock in place using the C-clamps and clamps.

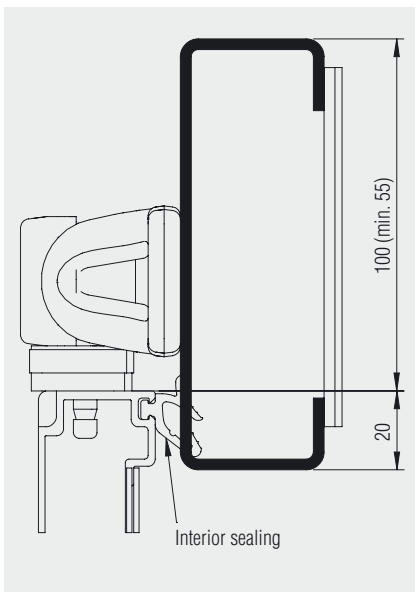
At least 20 mm of the horizontal seal inside the top and bottom of the door leaf should be showing.

Use larger overlaps for even better results!

The rear portal frame should be at least 30 mm wide.

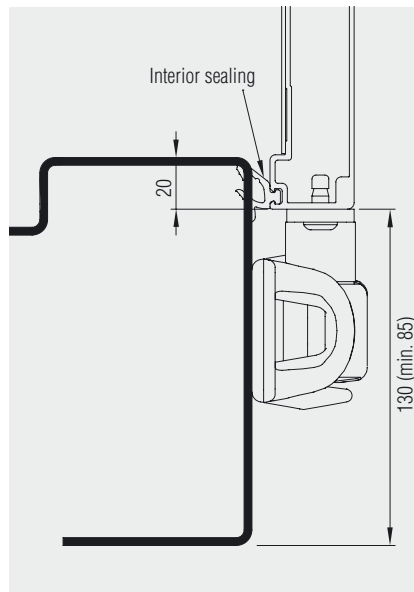
The door frames must not touch in the middle!

Installation gap approx. 5 – 6 mm!



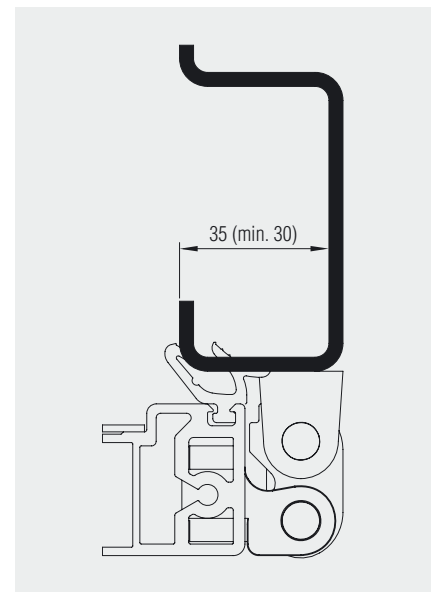
Portal frame header:

- To ensure effective sealing, the seal must overlap the header by at least 20 mm.
- A further 55 mm is required to fit the top door gear keepers.



Rear bottom member:

- To ensure effective sealing, the seal must overlap the header by at least 20 mm.
- A further 85 mm is required to fit the bottom door gear keepers.



Corner posts:

- To ensure effective sealing, the seal must overlap the posts by at least 30 mm.

Fitting the hinge brackets

The outer radius of the door hinges must be flush to the outer edges of the rear frame!

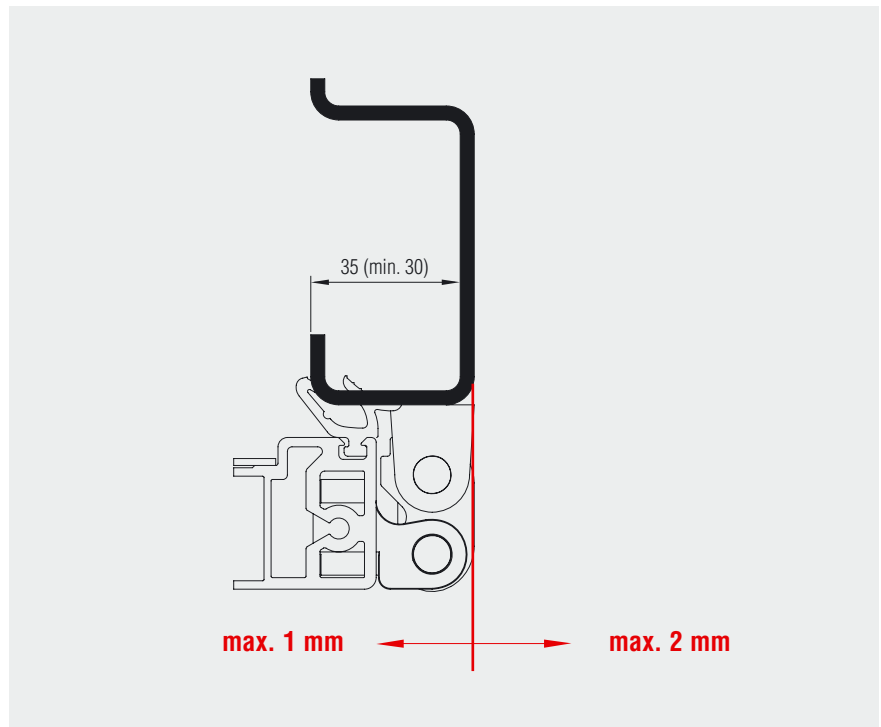
Tolerance:

**max. 1 mm inwards,
max. 2 mm outwards.**

This tolerance must be observed at all times to ensure that the doors open and fold completely!

**Adjusting and attaching the
hinge brackets**

The hinge bracket and door hinge must be installed at the same height. The hinge bracket must be properly aligned to the hinge and rest flush to the outer edge of the rear frame.



GETO® Megaport II flush rear doors

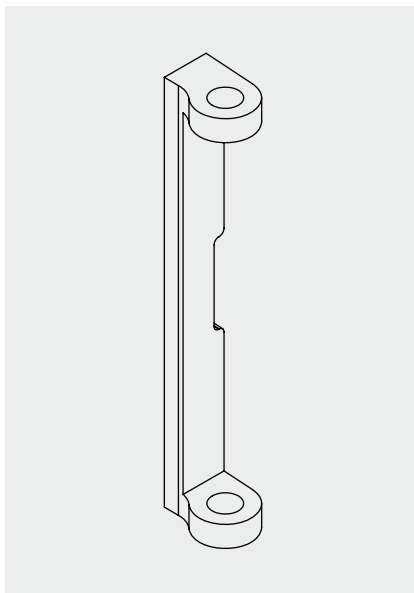
Assembly Instructions

The hinge brackets can be riveted, screwed or welded on.

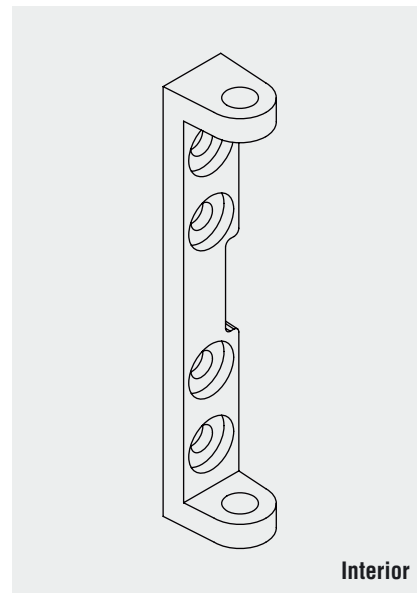
Hinge bracket versions

Two different hinge brackets are available for installing the door. The standard option used is the rivet-on version, which can also be welded on.

When installing on a GETO Van, only the weld-on option is available!



Weld-on version for GETO Van

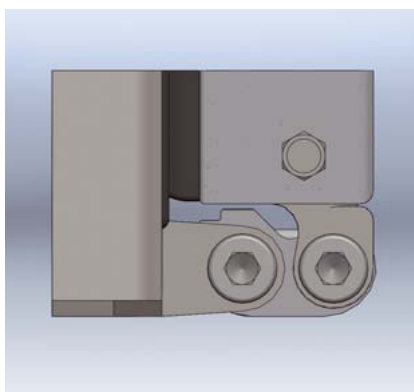


Rivet, screw and weld-on version
M-Lock blind rivet 6.4 x 14.2 mm A2 / A2
Grip range = 2.0 - 9.5 mm
Part no.: 415 920 000

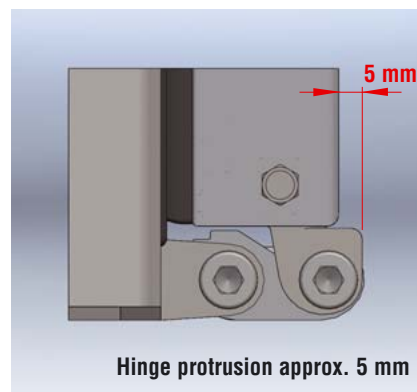
Double pivoting hinge

Both hinge versions are installed in exactly the same way!

It is also possible to retrofit double pivoting hinges by replacing the hinge plates and screw-in brackets in the door leaves.



Standard



Extended version

Installing the double pivoting hinges

Hinge with plastic bushes, unmilled = for middle hinge position (without spring)
Hinge with plastic bushes, milled in the middle = for top and bottom door hinge respectively (with spring)

The curvature on the hinge plate must face the rear frame.
Insert the hinge bolts from above and fasten using hexagon nuts.
Do not overtighten the hinge bolts. One or two threads should still be showing on the hexagon nut!

Do not install the tension springs at this point!



Hinge with milled edge installed top and bottom



Milled hinge



Unmilled hinge with plastic bush



Do not install the tension springs at this point!

GETO® Megaport II flush rear doors

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Installing the door gear keepers

Position the top and bottom door gear keepers for the door locks where they are to be installed, then align them and secure in place.

Align the door gear keepers so they are parallel to each other and rest firmly against the cam lock.

The height of the door leafs must not be off-centre when closed!

Ensure that the door frame profiles do not touch!

If necessary, check the diagonals on the rear frame max. deviation +/- 3 mm

Drill holes (10.5 mm) in the middle of the slotted holes in the door gear keepers.

Bolt the door gear keepers onto the rear frame.

Affix the top and bottom door gear keepers using:

Hexagon bolts M 10 x 30 - 8.8

DIN 933 galvanised;

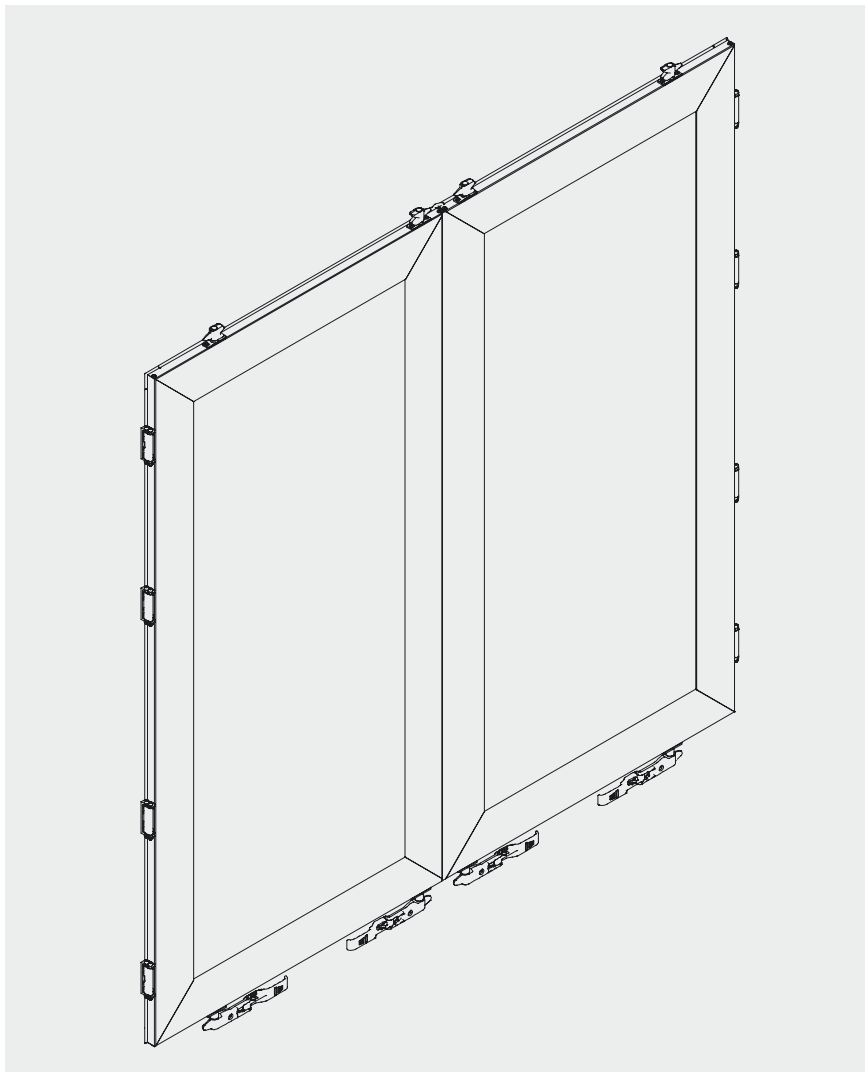
Washer 10.5, DIN 125, galvanised

Lock nuts M 10

DIN 985 galvanised



Top door gear keeper with cam

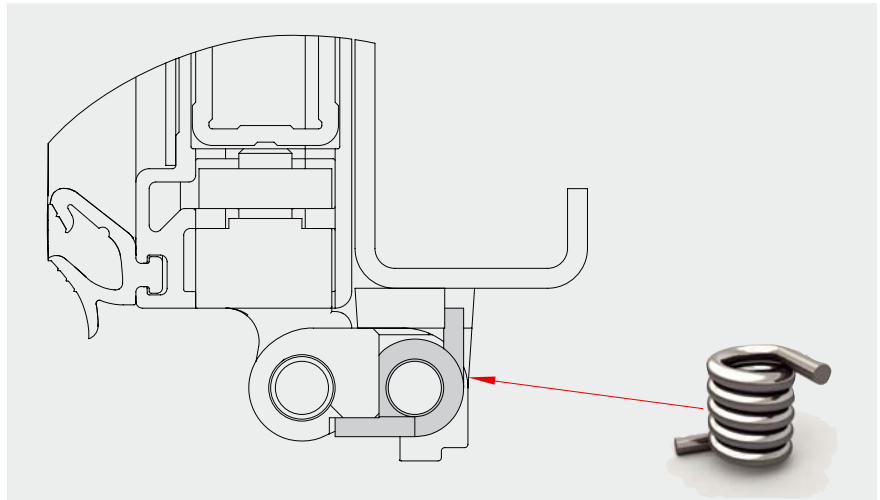


Bottom door gear keeper with locking handle

Inserting the tension springs into the double pivoting hinges

Note:

**The tension spring is untensioned when the door is open.
The spring will only tension when the door is closed and will move the hinge plate to the required position.**



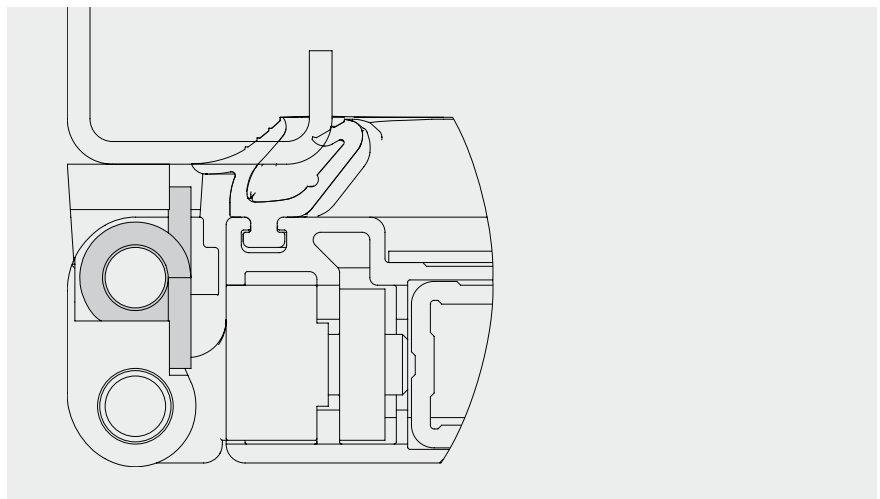
Open door; tension spring not under tension

- Open the door as far as it will go
- Remove the top and bottom hinge bolts from the rear frame one after another, insert the tension spring into the centre of the notch and re-attach and tighten the hinge bolts
- The double pivoting hinges should still move freely after the bolts have been "tightened"!



Open door; tension spring not under tension

Check that the door and the door locks are working correctly and re-adjust the door gear keepers if necessary.



Door closed, spring under tension

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Assembly Instructions

Important information

Notes on sealing the external transition from extrusion to panel on GETO® Megaport II flush rear doors

Pre-treating / cleaning the area around the hollow weld (panel – edge profile)

Moisten a lint-free, non-bleaching disposable paper towel with GETO PUR Cleaner 2 (making sure it is not dripping wet) and wipe the welded seam in one go, turn the towel over and then wipe again in the same direction.

Leave the pre-treated sealant application surfaces to air for at least 5 minutes.

If you suspect that some of the solvent might have been transferred from the towel into the area in or around the joints, allow an additional amount of time for the solvent to evaporate completely. To check whether this has occurred, insert a dark sheet of paper into the gap between the profile and the panel. The paper should not show any traces of moisture!

Applying GETO® PUR 21s sealant or Sikaflex 221

Cut the applicator nozzle so that it will produce the required bead thickness, then apply a bead of sealant to the area of transition between the panel and the edge profile.

When applying the sealant, make sure that it runs across the surface correctly. This can be achieved either by placing an excess of sealant ahead of the direction in which the sealant is to be applied through the nozzle or by forming and smoothening the sealant using a suitable spatula after the sealant has been applied.

Cleaning residual sealant off dirty surfaces

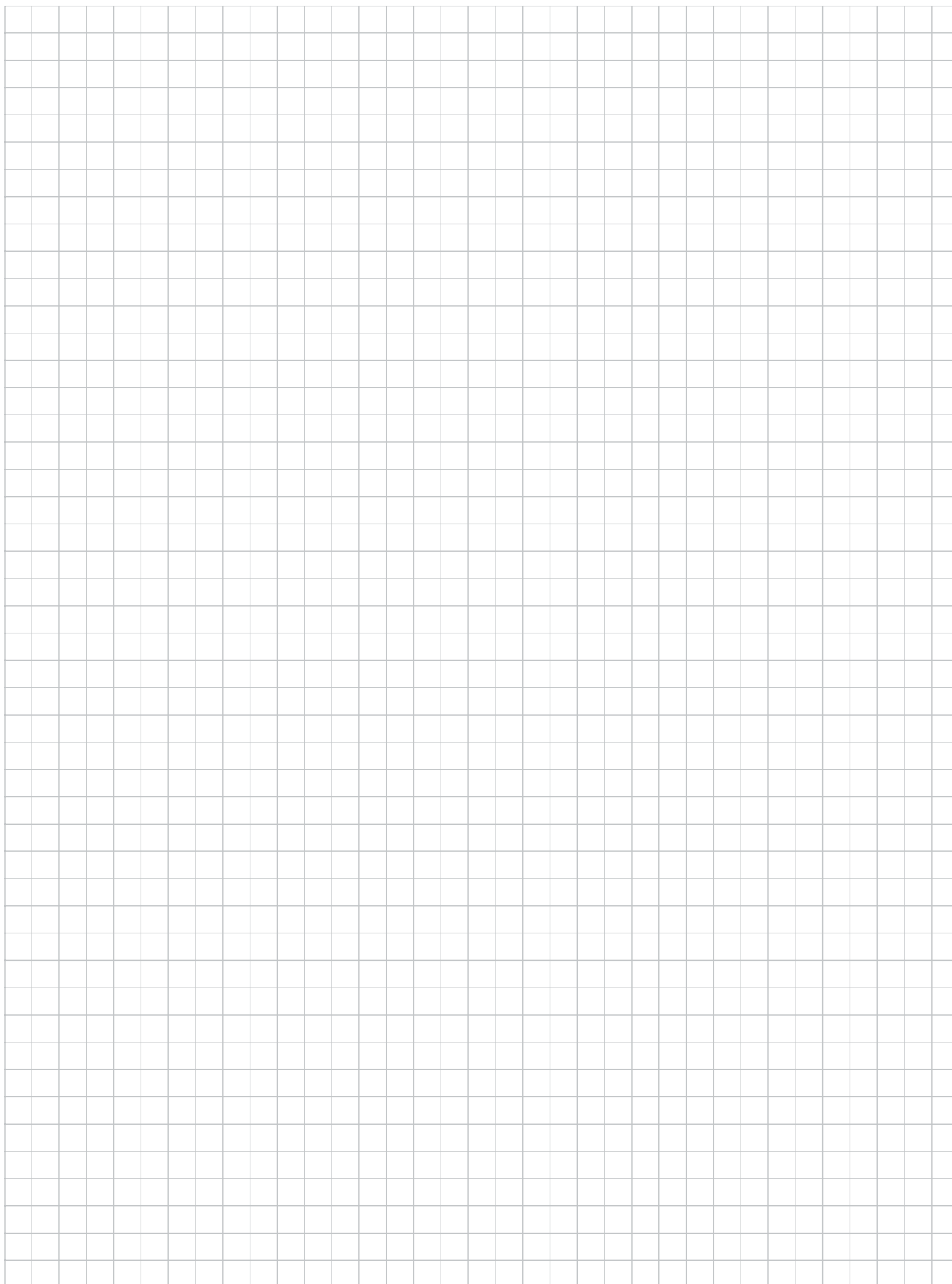
Unhardened sealant can be wiped off using lint-free, non-bleaching disposable paper towel soaked in GETO PUR Cleaner 2 until dripping wet.

Hardened residual sealant can only be removed mechanically.

Painting / varnishing GETO® Megaport II flush rear doors

With regard to painting / varnishing GETO Megaport II flush rear doors, including any pre-treatment of the surfaces in question, we advise you to observe the recommendations of the paint/varnish manufacturers concerned.

The door seals must always be kept free from paint or varnish so as not to impair their sealing properties.





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