

## INSTALLATION INSTRUCTIONS FOR 663HD,

New doors should be 3/16" undersize for hinge clearance between the door and frame.

All standard length hinges are non-handed and can be used for right or left hand doors. Standard length hinges are supplied at the nominal door height.

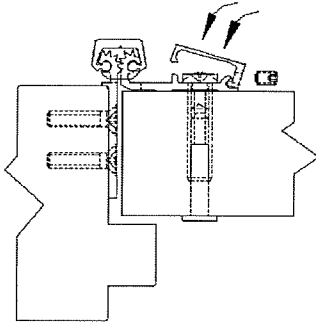
**CUTTING-** If a hinge must be cut, use a hacksaw cutting one end only. With the hinge closed and standing with cap up or on its side with cap closest to you, cut so that you cut through the cap first. If you cut off a set screw bearing, re-install it on the hinge. The hinge becomes handed after cutting and must be installed with the cut end at the bottom to allow chips to work out and to keep the templated hole pattern at the top. **Fire rated hinges must be cut at the factory. Do not cut in the field. Contact factory for information on fire-rated hinges.**

**TO POSITION NEW DOOR-** Remove existing hinges/pivots from the existing door and frame. Place the new door in the opening and shim so that the door is plumb and square. Clearances between door and frame should be 1/8" from the top and 1/8" on the lock side. The 678HD and 663HD have a 3/32" door inset. If needed, a continuous shim may be installed under the door leaf for a deeper inset. Contact factory for shims and installation instructions.

**INSTALLING HINGE-** With hinge leaves open, place the frame leaf against frame with the top of the hinge 1/16" to 3/32" below the header for door clearance. Frame leaf alignment flange must be tight against the frame face. Attach the frame leaf at using one hole at the top and one hole at the bottom using the 12-24 flat head screws provided. Now attach the door leaf to the door through two of the locator holes using the TEK screws supplied. Remove shims and check door clearances. If door sags slightly, note amount of adjustment needed to bring door back into alignment. Then locate and mark (using 3/8" x 1 transfer punch) for the top and bottom thru bolts in the door. Remove door and drill holes with 3/8" dia. drill. Re-hang the door with the top and bottom thru bolts and make any necessary adjustments to the frame leaf. When door is aligned, finish securing the frame leaf with the flat head screws. Mark and drill the remaining thru bolt holes in the door and install the remaining thru bolts and 1/4-20 shoulder screws.

For extra security, apply a bead of construction or panel adhesive inside the door leaf molding or over the sex bolt heads.

**INSTALLING COVER-** Before installing the door leaf cover, check that the 3 set screws do not protrude into the interior of the cover. Line up the end of the cover with the top end of the hinge. Starting at the top, apply pressure long the length of the cover and snap into place as you go down the length of the hinge. If using a hammer, use a block of wood to protect the cover. When the cover is on, tighten the 3 set screws to secure it.



NOT FOLLOWING INSTALLATION INSTRUCTIONS MAY RESULT IN IMPROPER INSTALLATION AND VOID THE MANUFACTURER'S WARRANTY.

SCREW DETAIL		
	QTY.	DESCRIPTION
FRAME	25	12-24 X 7/8" PH. F.H. UNDERCUT SELF DRILLING THREAD FORMING TEK SCREW
DOOR	10	1/4-20 X 1-9/16L. X 3/8 DIA. SEX-BOLT & 1/4-20 X 1" PH. HEAD SHOULDER SCREW
	4	12-24 X 11/16 PH.PN. HD. SELF DRILLING TEK SCW. (LOCATOR HOLE)

## STANLEY.

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HALF SURFACE  
INSTALLATIONS INSTRUCTIONS

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