



IVES 045XY Half Surface Continuous Hinges Installation Guide


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**Installation Instructions
Half Surface
Continuous Hinges**

Model	Description
045XY	Half surface, narrow frame
046XY	Half surface
053XY	Half surface, narrow frame and door stile
054XY	Half surface, narrow door stile

The 045XY, 046XY, 053XY, and 054XY are high-quality, easy-to-install continuous hinges that allow all clearances to be adjusted after the door is secured to the frame. The hinges are available in lengths of 83", 85", 95", and 119". Before installing a new hinge, check frame condition and make any necessary repairs at this time. If the top of the frame is not perfectly level, the new hinge will allow for vertical adjustment so the door will clear the lower of the top two corners of the frame.

 Please follow the installation instructions carefully. Not doing so may result in improper installation and void the manufacturer’s guarantee. Anodizing or painting the product in the field will void the guarantee.

Installation Notes

Reinforcing and Rivet Nuts:	No frame reinforcement is required for doors up to 200 lbs. For doors between 200 and 450 lbs, a 16 gauge channel in the frame is required. For doors greater than 450 lbs (600 lb max.), rivet nuts are required in the frame in addition to the frame reinforcement.
Doors:	For doors up to 200 lbs, no door reinforcement is required. For doors, greater than 200 lbs (up to 600 lbs), a 16 gauge channel in the door is required. This is applicable for both TEK screw and through-bolt installations.
Pair of Doors with Mullions:	If the mullion is between the doors, treat it as a single door installation. If the mullion is behind the doors, treat like a double door installation.

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Determine hinge length.

ⓘ All standard hinge lengths are supplied slightly shorter than nominal door height to avoid threshold or carpeting clearance problems. All uncut hinges are templated and non-handed. Use the same model for both left and right-hand openings.

1a If the hinge is taller than the door, the hinge must be cut to match the door height. The hinge must not be taller than the door height.

1b If cutting is required, mark a line on the cover and both ends of the hinge.

ⓘ The hinge should be cut equally from both ends to keep the bearings in the middle.

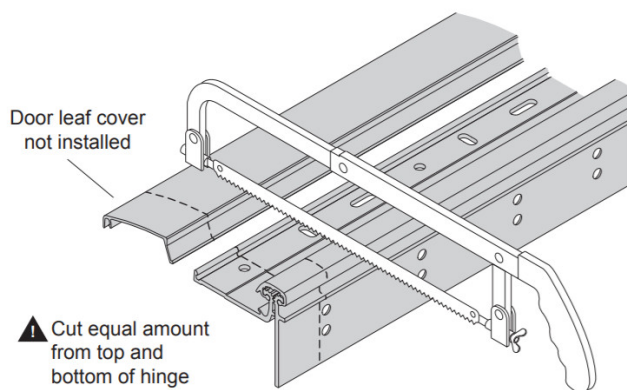
Cut hinge (if necessary).

2a Fold hinge so the channel is up.

2b From each end, cut along a line through the entire hinge.

2c Cut cover to the same length as a hinge.

2d Debur all cut edges with a file.

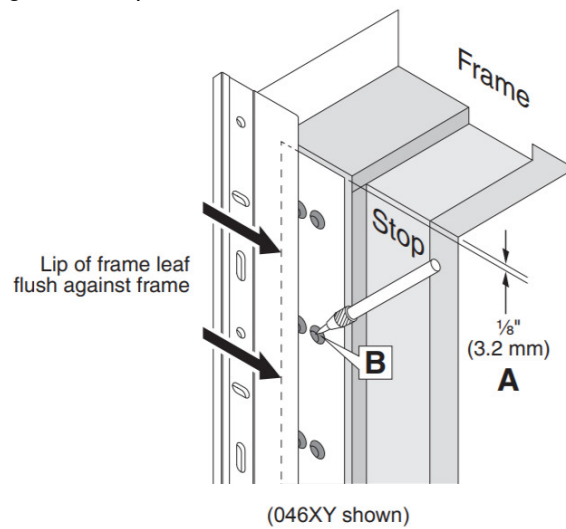


(046XY shown)

Mark frame hole locations.

3a Open hinge and place frame leaf flat against the surface of the frame, leaving a 1/8" gap between the top of hinge and frame header. The Lip of the frame leaf should be flush against the edge of the frame.

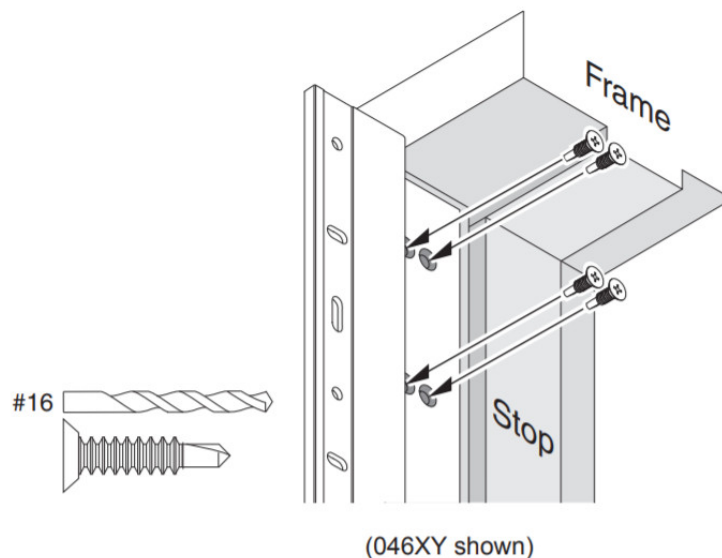
3b Mark center of each hole using a center punch.



Mount hinge to frame.

4a Use #12-24 x 3/4" self-drilling tapping screws to fasten the frame leaf of the hinge to frame.

① #16 pilot drill is recommended for all holes.



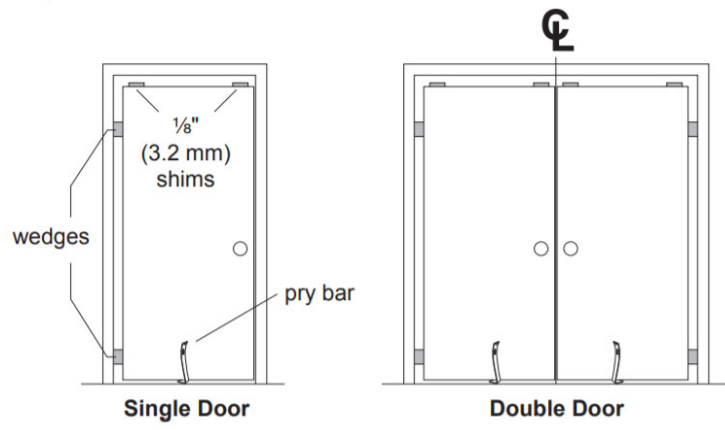
Position door.

5a Tape 1/8" shims to top edge of the door at each corner for spacers.

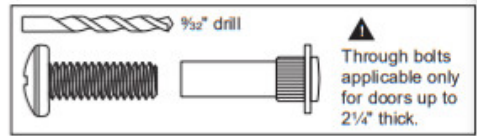
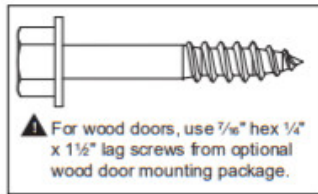
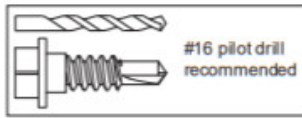
5b Position door against stops and leave it resting on the threshold, with a thin pry bar placed underneath. Shift door so the lockside edge is wedged snugly against the frame, top to bottom.

① If necessary, use shims between the door and hinge side of the frame to keep the door wedged safely in position.

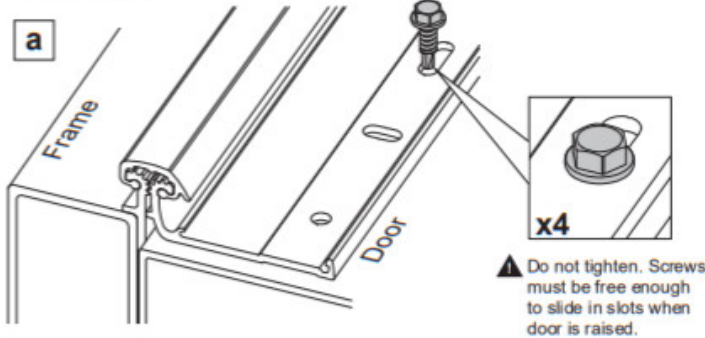
For double doors, mark the exact middle of the frame header, and push the two doors together at their meeting edges with the top corners directly under the mark. Wedge hinge sides as above.



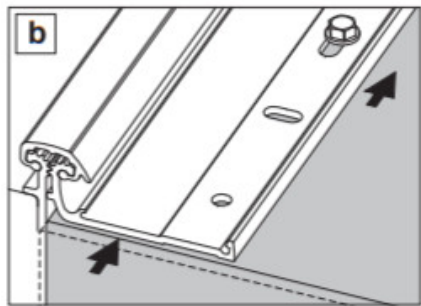
Mount door to hinge.



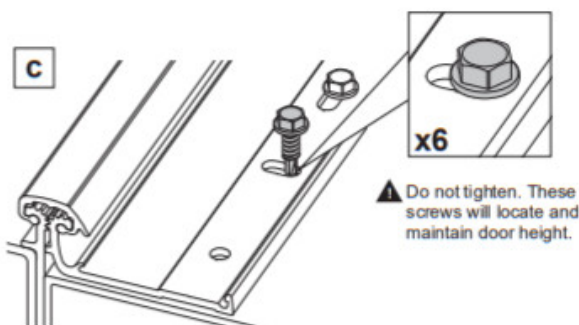
(046XY shown)



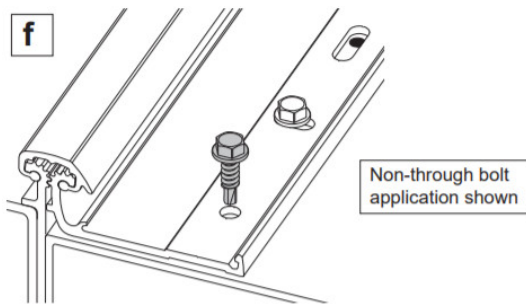
a. Fold door leaf of hinge against door. Install a hex screw at the bottom end of each vertical slot.



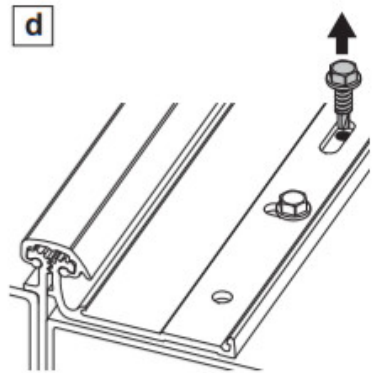
b. Use pry bar to raise door until tight against shims between the top of door and frame header.



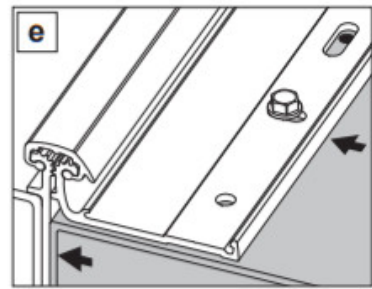
c. Install screws into lock side end of each horizontal slot. Repeat for double doors.



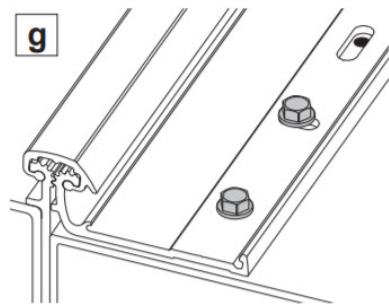
f. Install screws into two or three round holes at both top and bottom of hinge. Open and close door slowly, checking all edges for clearance. Repeat for double doors.



d. Remove shims from top of door(s) and remove screws from vertical slots.



e. Adjust lateral clearances of door by prying door from lock side of frame. For double doors, make sure they remain centered.



g. Tighten all screws on door leaf. Reconnect the closer and any other hardware.

***For through-bolt application only, skip ahead to 6h-6k.**

If lock side clearance is satisfactory, insert remaining screws into round holes.

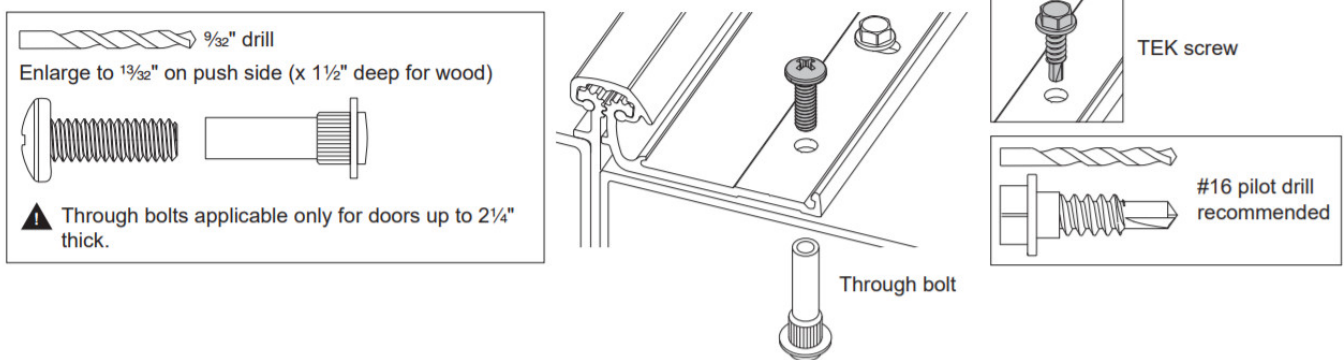
For through bolt applications only

- h. When the door is aligned, mark all locations for through bolts in round holes on the hinge. Eight through bolts are provided and it is recommended to install at least one on each end of the hinge if choosing to use through bolt installation option.
- i. With the hinge still mounted to the frame, remove the door from the opening and drill the through bolt holes all the way through the door with 9/32" drill bit.

For the remaining round holes, TEK screws will be used. A #16 bit is recommended to drill pilot holes.

⚠ DO NOT DRILL TEK SCREW HOLES THROUGH THE DOOR.

- j. On the push side of the door only, enlarge the through bolt holes using a 13/32" bit. For wood or composite doors, only drill the through bolt holes 1-1/2" deep.
- k. Secure door to hinge with 1/4"-20 screws and through bolts. Install TEK screws in pilot holes and tighten evenly.



Install door leaf cover.

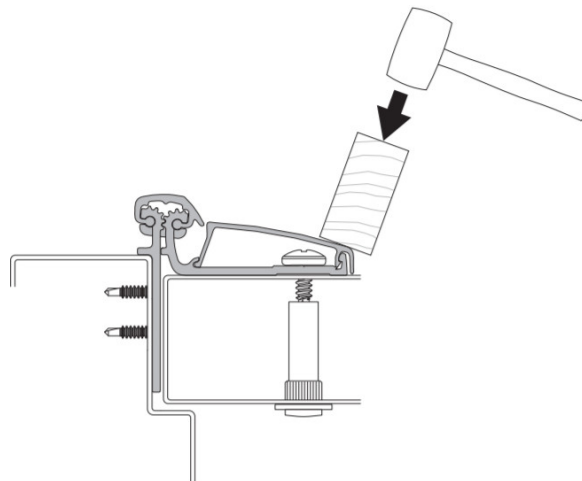
Follow these instructions carefully to avoid denting the cover edges or surfaces.

ⓘ This cover is vandal-resistant and non-removable, and should not be installed until the door is operating properly.

7a Close the door

7b Position the inner lip under the curved hook near the hinge joint of the door leaf, making sure it is in place from top to bottom.

7c Align cover with top of the hinge and use a light hammer tap against a cushioning woodblock to snap it in place from top to bottom.





Customer Service
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Documents / Resources



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