



# 9540 Roll-Up Door Installation Guide

SteelBlue Building Components 6600 Steubenville Pike  
One Robinson Plaza - Suite 240 Pittsburgh, PA 15205

Phone 412-857-3496  
[www.steelbluebc.com](http://www.steelbluebc.com)

Initial Release | 10.17.2025



## Important Safety Information

### Important Information

- ◆ SteelBlue Building Components doors must be installed by trained rolling door technicians qualified to install product safely with proper knowledge, tools, safety, and installation equipment. Carefully read installation instructions, familiarize yourself with all installation procedures, warnings, cautions and notes before attempting to install door. SteelBlue Building Components will not warranty or accept responsibility for doors not installed per these installation instructions.
- ◆ Carefully read installation instruction, familiarize yourself with all installation procedures, warnings, cautions, and notes before attempting to install door.
- ◆ Inspect received door assembly for visible damage and/or component shortages.
  - A. Shipping damage: file damage claim immediately with freight carrier, supply door supplier with photo documentation to receive replacement components.
  - B. Part shortage: immediately contact door supplier with parts shortage claim, order number, door model and photo documentation are encouraged to expedite process.
  - C. Incorrect parts: if received door components and parts do not match those referenced in these installation instructions, immediately contact door supplier.
- ◆ If, at any time before or during installation, you are unfamiliar, uncomfortable, or confused by the installation procedures outlined in these instructions, **do not attempt to install door assembly**; immediately contact the door supplier with questions/concerns.

## Read All Warnings Below

- ◆ Use appropriate safety equipment to avoid serious injury.
  - ◆ Clear floor at opening of all debris before installing product.
  - ◆ Use appropriate lifting equipment and correct lifting procedures to avoid damage, serious injury or death.
  - ◆ Moving door could result in death or serious injury. Do not close door until doorway is clear.
  - ◆ Control the speed of the door during manual operation.
  - ◆ Do not stand or walk under a moving door.
  - ◆ Keep doorway clear and in full view while operating door.
  - ◆ Do not permit children to play on, near, with door or operate door controls.
  - ◆ Unlock door before opening door.
  - ◆ Sensing devices on motor operating doors should be tested at least weekly.
  - ◆ Visually inspect door and hardware monthly for worn and/or broken parts and check if door operates freely. Do not operate a door with a broken spring(s).
  - ◆ Components are under extreme spring tension and could result in death or serious injury.
  - ◆ Door must be fully opened when making adjustments
- Retain these instructions for reference.
- These instructions as well as Operation & Maintenance Manual are available via pdf download at [www.steelbluebc.com](http://www.steelbluebc.com) or upon request.

◆ SteelBlue Building Components doors must be installed by trained rolling door technicians qualified to install product safely with proper knowledge, tools, safety and installation equipment.

## Handle with Care - do's & don'ts

---

### DO's

- ✔ Carefully inspect all product for damage upon receipt.
- ✔ Use protective foam between product and surface or any object it may come into contact with while in transit, storage and/or installation.
- ✔ Carefully unload product from any type of crating material assuring no contact with fasteners or sharp edges.
- ✔ Clear floor at opening for debris before installing product.
- ✔ Single person lifting of product could cause injury. Use assistance when moving or lifting.
- ✔ Install product with appropriate lifting equipment.

### DON'Ts

- ✘ **Do not** – stand on product.
- ✘ **Do not** – climb on product.
- ✘ **Do not** – walk on product.
- ✘ **Do not** – throw or toss product.
- ✘ **Do not** – allow sharp objects to come in contact with product.
- ✘ **Do not** – leave product unsecured while in transit or during installation.

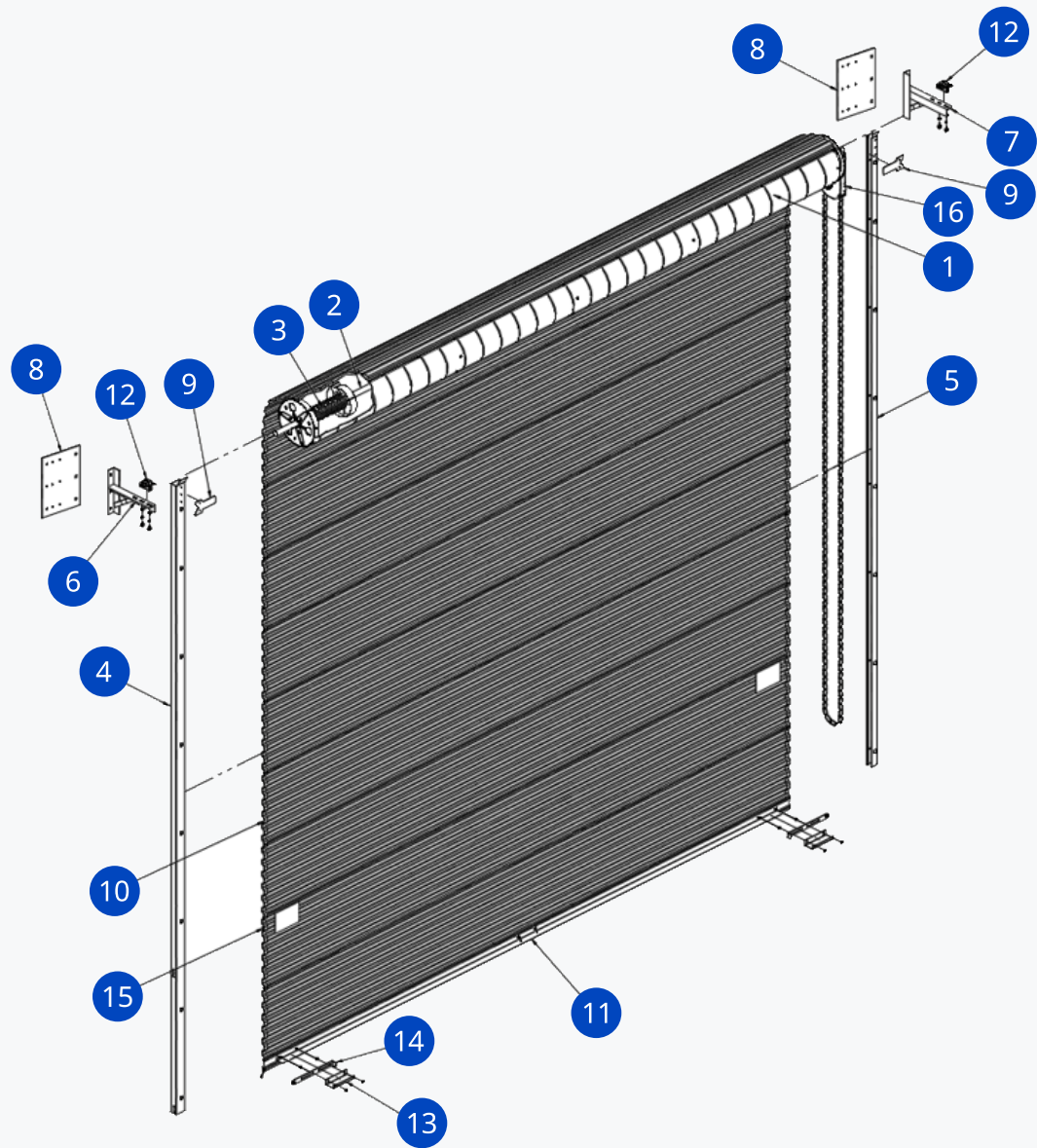
✦ Failure to adhere to the above conditions will result in personal injury or product damage not covered under SteelBlue Building Components product warranty. Always handle product with care and review all instructions, warnings and notes before installing product.

✦ Review door assembly and general parts descriptions bill of material from page 4, figure 1 to familiarize yourself with common parts of rolling sheet door assembly.

✦ Door assemblies are manufactured per opening widths and heights specified at time of order. SteelBlue Building Components will not be held responsible for opening widths and heights that do not match those specified at time of order.

## Door Assembly & General Part Description

9540 Series



Operation & Maintenance Manual available via pdf download @ [www.steelbluebc.com](http://www.steelbluebc.com) or upon request

figure 1

### General Bill of Materials

Item	Description	Item	Description	Item	Description
1	12" Spiral Barrel	6	LH T-Bracket	11	Bottom Bar/Astragal Assembly
2	1-5/16" O.D. Axle	7	RH T-Bracket	12	Stamped Axle Support
3	Spring/Counterbalance Assembly	8	Large Mounting Plate	13	Step Plate
4	LH, 14GA. Commercial Guide	9	Comm. Head Stop	14	Slide Lock
5	RH, 14GA. Commercial Guide	10	26GA. Corrugated Curtain	15	Latch (if required)
				16	Optional Lifting Mechanism

# Headroom/Sideroom Dimensional References

Table A: Headroom Requirements

Opening Height	Vertical Headroom	Horizontal Headroom
Thru 8'-0"	20"	20"
Over 8'-0" Thru 10'-0"	21"	21"
Over 10'-0" Thru 14'-0"	23"	23"

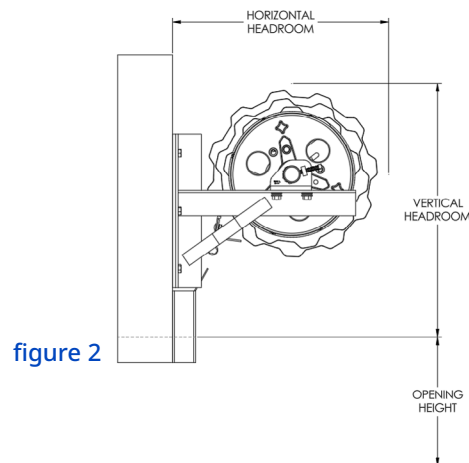


figure 2

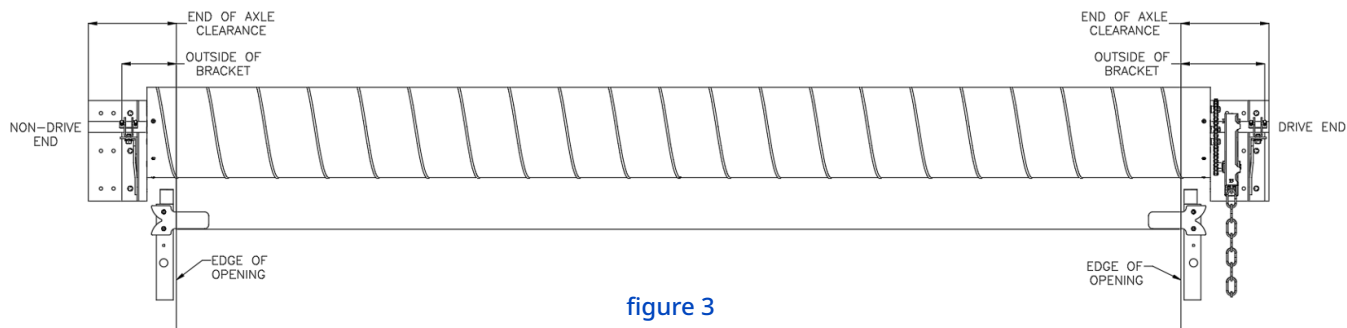


figure 3

Table B: Sideroom Clearance Requirements

Operation	Outside of Bracket Drive End	Outside of Bracket Non-Drive End	Outside of Axle Drive End	Outside of Axle Tension End
Push-Up	6 1/2"	6 1/2"	10 1/2"	10 1/2"
Chain Hoist	10"	6 1/2"	10 1/2"	10 1/2"
Electric	10"	6 1/2"	10 1/2"	10 1/2"

### Important notes

- ◆ Dimensions are referenced from edge of the opening.
- ◆ For critical fits due to reduced available headroom or sideroom clearances, consult factory.

## Step 1: Wall Opening

- ✦ Check wall opening width and height and verify these measurements against size of door to be installed.
- ✦ Verify that the jambs are plumb.
- ✦ Check floor and header for level.
- ✦ Check for adequate side clearance at jambs and clearance above and at sides of header. Check vertical and horizontal headroom requirements. See **Tables A & B** for minimum requirements.
- ✦ Verify that guide mounting surface on jamb is flush.

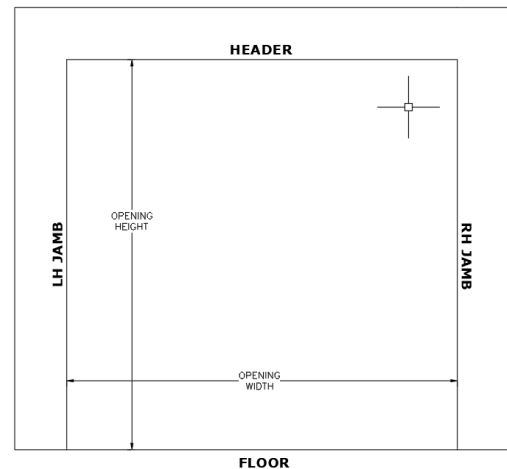


figure 4: Wall Opening

## Step 2: Installing Mounting Plates

Doors mounted to steel or wood jambs will require mounting plates to be installed on each jamb. (2) Large Mounting Plates provided as standard. For doors mounted to a flush surface, such as concrete or CMU wall, skip this step and go to Step 3.

- ✦ Large Mounting Plates to be installed on both sides of the door.
- ✦ Attach the mounting plates  $\frac{1}{2}$ " from the edge of the door jamb and  $3\frac{3}{8}$ " above the lower edge of the door header using the appropriate fasteners from **Table C**. Door brackets must be level with each other for proper door operation.

✦ Note: Door drive operation may be installed on either end of door assembly

figure 5: Mounting Plates

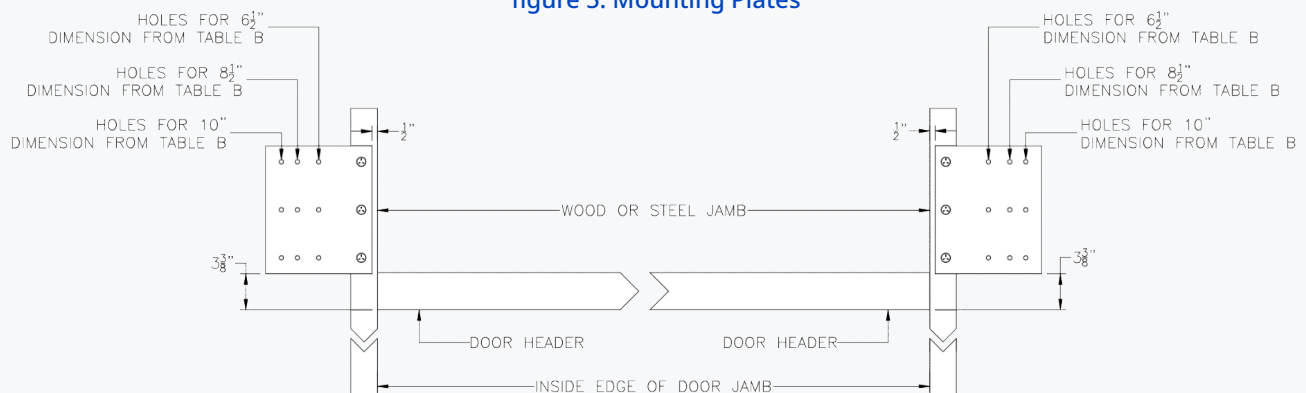


Table C: Wall Fasteners for Mounting Plate to Jamb

Item	Jamb	Fasteners	Drill Size
MTG Plates	Steel	3/8-16 x 1-1/4" Carriage Bolt and Nut	7/16"
MTG Plates	Wood	3/8 x 3" Lag Screw	15/64"

### Step 3: Door Bracket Installation to Flush Wall

- ✦ If you are installing door to a flush wall, attach door brackets to wall using appropriate dimensions provided in **Table B**.
- ✦ Height of door bracket above top of door open to be 11". See **Figure 6**.
- ✦ Attach door brackets to jamb with fasteners provided. **Table D**.

figure 6: Door Bracket to Flush Wall

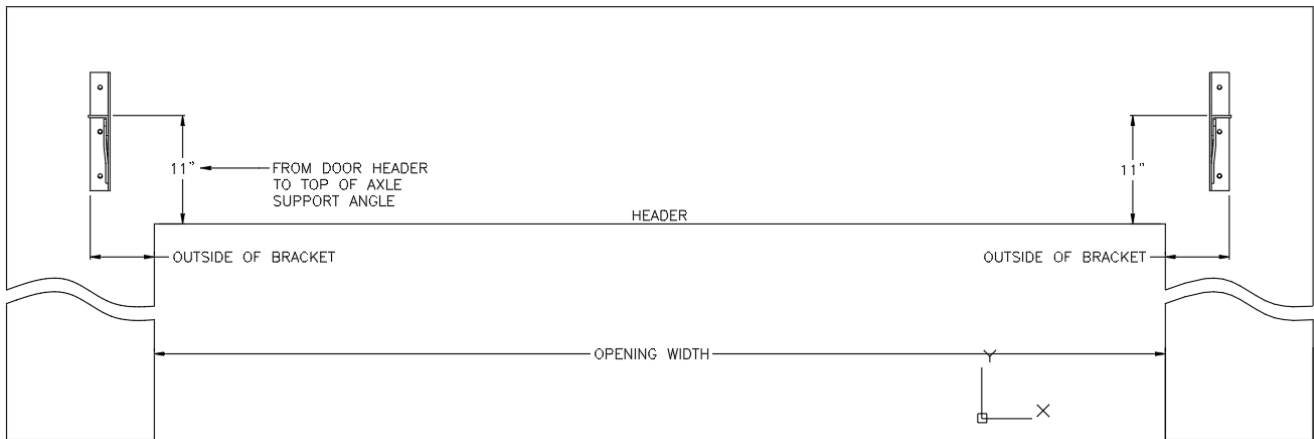


Table D: Wall Fasteners for Bracket to Flush Wall

Item	Jamb	Fasteners	Drill Size
Brackets	Concrete / Filled Block	3/8 x 4" Wedge Bolt	3/8"

#### Warning!

- ✦ Door can fall if both brackets are not securely fastened to the jambs. All fasteners attaching brackets to jambs must fit securely into a structural member or surface. If door falls, serious injury or death and/or damage to door can result.
- ✦ Door brackets must be level with each other for proper door operation.

## Step 4: Door Bracket Installation to Mounting Plates

- ✦ Align the door brackets to the set of holes in mounting plate that correspond to the appropriate dimensions provided in **Table B**.
- ✦ Attach door brackets to mounting plates with fasteners provided. **Table E**.

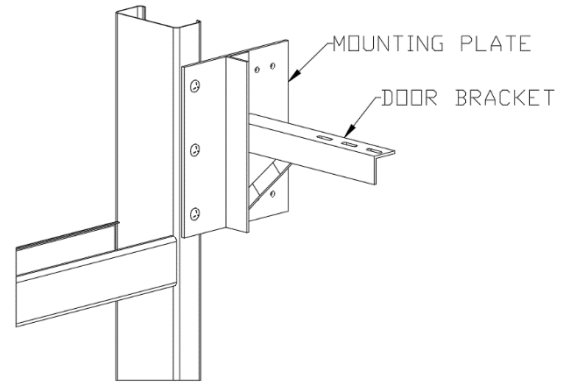


figure 7: Door Bracket to Mounting Plate

Table E: Wall Fasteners for Bracket to Mounting Plate

Item	Jamb	Fasteners	Drill Size
Brackets	Steel	3/8-16 x 1-1/4" Hex Bolt and Nut	7/16"
Brackets	Wood	3/8-16 x 1-1/4" Hex Bolt and Nut	7/16"

Choose the installation method from step 5 that best corresponds to the door order.

## Step 5a: Stamped Axle Support Installation (Push-Up / Manually Operated)

- ✦ Using one (1) Stamped Axle Support per side, with directional arrows pointing towards wall, slide Stamped Axle Support over axle.
- ✦ Tighten 3/8-16 square head set screws hand tight, will position and tighten completely once door is installed. See **Figure 8**.

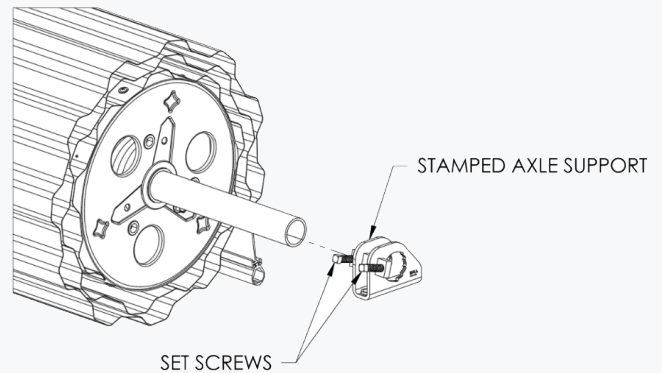


figure 8: Stamped Axle Support Installation

**\*\*If door is push-up / manually operated, skip to step 6 of the instructions\*\***

## Step 5b: 4.4:1 Chain Hoist Setup (if required)

- ✦ Attach Sprocket to drum using (3) 3/8" flat washers, (3) 3/8" lock washers, and (3) 3/8-16 x 1-1/2" hex bolts as shown in **Figure 9**.
- ✦ Slide reduced drive assembly over axle, align sprockets, and then install chain over sprockets.
- ✦ Tighten 3/8-16 square head set screws on reduced drive once in place.
- ✦ Slide the Stamped Axle Support onto axle.
- ✦ Tighten 3/8-16 square head set screws on Stamped Axle Support once in position.

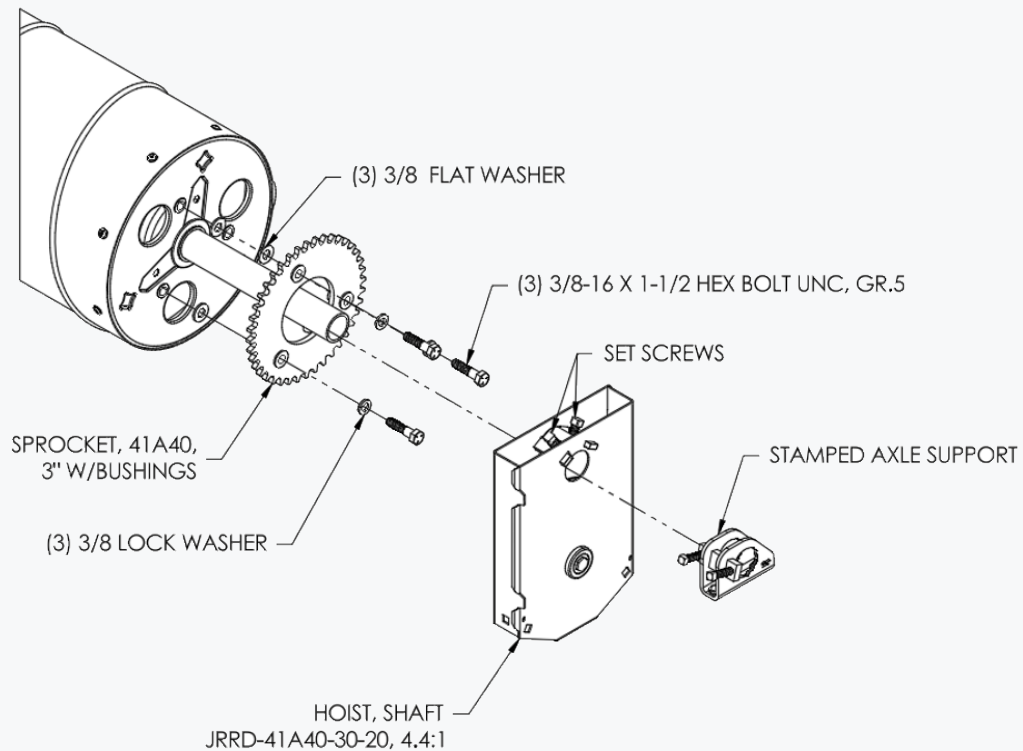


figure 9: Chain Hoist 4.4:1  
(Curtain removed from illustration)

## Step 5c: Electric Motor Setup (if required)

- ✦ Motor should come with the appropriate hardware/sprocket in order to attach to the drum.
- ✦ Install sprocket per manufacturer's instructional manual.
- ✦ Slide the Stamped Axle Support onto the axle.
- ✦ Tighten 3/8-16 square head set screws on Stamped Axle Support once in position.

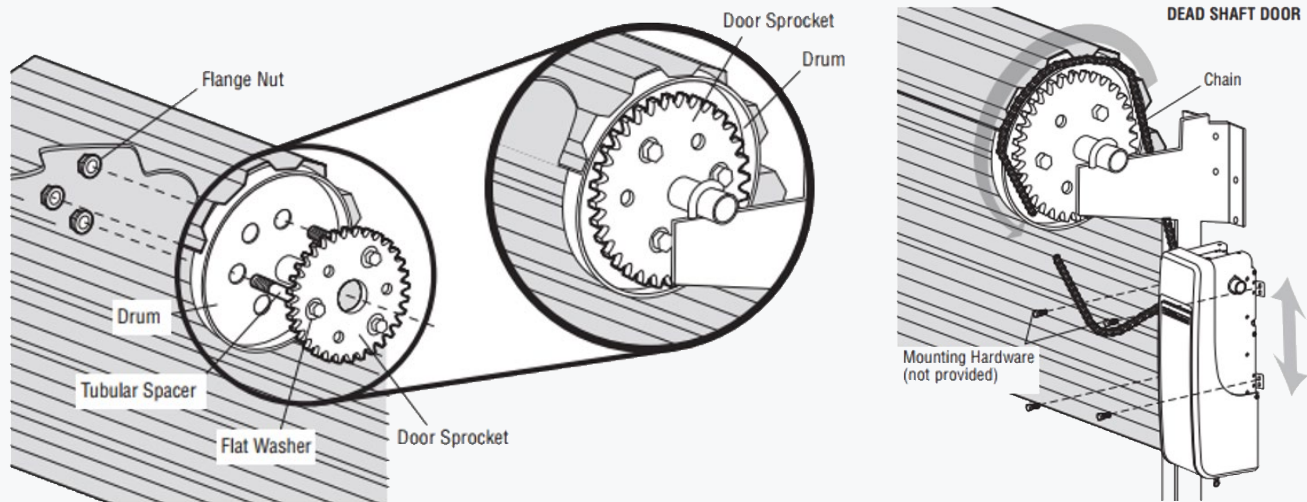


figure 11: Electric Operator

### Warning!

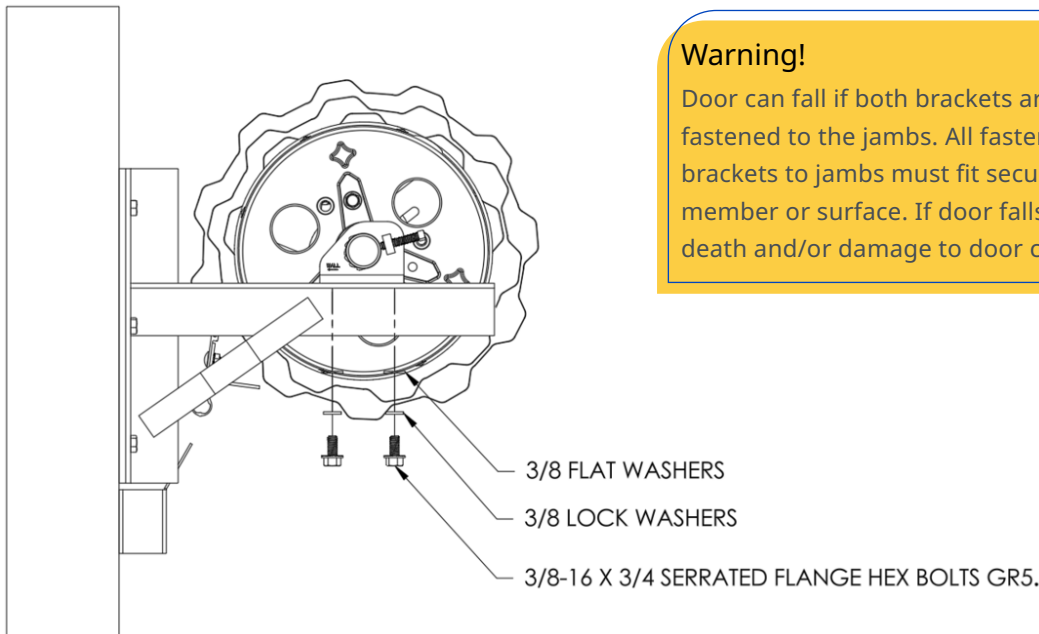
- ✦ Before lifting door into position, ensure all set screws are tightened to adequately secure stamped axle support. Failure to secure will result in falling parts, which could lead to serious injury or death.

## Step 6: Lifting Door

- ✦ Raise door using appropriate lifting equipment, ensuring a protective barrier is maintained between product and any surface or object that it may come into contact with.
- ✦ Position door on brackets with both Stamped Axle Supports resting safely on top of bracket flange.
- ✦ Door should be positioned as close as possible to header while maintaining ability to rotate and clear bottom bar.
- ✦ Each end of the door should be equal distance from header and curtain must be centered in the opening.

### Warning!

Do not allow door assembly to roll off brackets or move sideways off edge of bracket. If door falls, serious injury or death and/or damage to door can result.



### Warning!

Door can fall if both brackets are not securely fastened to the jambs. All fasteners attaching brackets to jambs must fit securely into a structural member or surface. If door falls, serious injury or death and/or damage to door can result.

figure 12: Securing Stamped Axle Support to Brackets

#### Stamped Axle Support Placement:

(Up to 12'-0" Tall Door, Use front slots closest to header)  
(Over 12'-0" Tall Door, Use back slots, furthest from header)

Choose the installation method from step 7 that corresponds to the door order.

## Step 7a: Push-Up / Manually Operated Stamped Axle Support Placement

- ✦ Loosen set screws.
- ✦ Attach (1) Stamped Axle Support per side to door T-bracket using (2) each 3/8-16 x 3/4 serrated hex bolts, 3/8 lock washers and 3/8 flat washers into the slots closest to the opening. See Figure 13.
- ✦ Tighten set screws once in place.

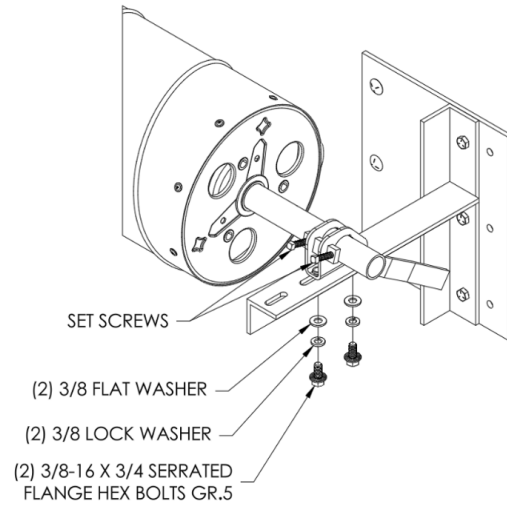


figure 13: Securing Stamped Axle Support  
(Curtain removed from illustration)

## Step 7b: Reduced Hand Chain Install (if required)

- ✦ Loosen set screws on Stamped Axle Support.
- ✦ Attach Stamped Axle Support to T-bracket using (2) each 3/8-16 x 3/4 serrated hex bolts, 3/8 lock washers and 3/8 flat washers. See Figure 14.
- ✦ Feed hand chain over chain sprocket wheel and through chain hoist assembly. Connect the ends of the chain, being careful not to twist the chain. Hand chain may be lengthened or shortened as necessary.
- ✦ Loosen set screws in chain hoist assembly, realign door sprocket and chain hoist sprocket then apply chain #41 chain.
- ✦ Tighten set screws in chain hoist assembly.
- ✦ Tighten set screws in Stamped Axle Support once in place.
- ✦ Install hand chain keeper on wall or jamb.

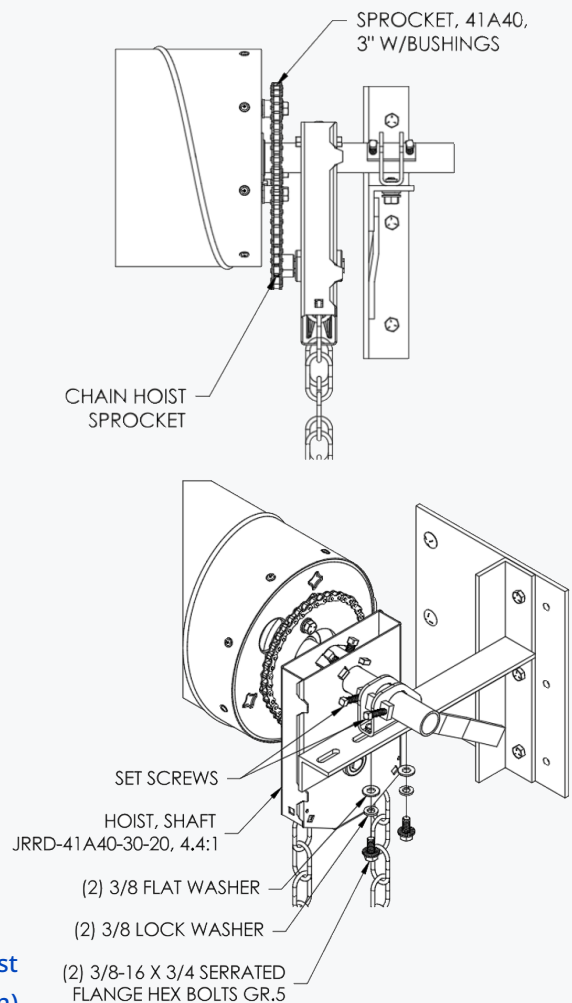


figure 14: Securing Stamped Axle Support w/ 4.4:1 Chain Hoist  
(Curtain removed from illustration)

## Step 7c: Electric Motor Install (if required)

---

- ✦ Loosen set screws on Stamped Axle Support.
- ✦ Attach Stamped Axle Support to T-bracket using (2) each 3/8-16 x 3/4 serrated hex bolts, 3/8 lock washers and 3/8 flat washers.
- ✦ Tighten set screws in Stamped Axle Support once in place.
- ✦ Install motor and chain per motor manufacturer's recommendations.

## Step 8: Position Door

---

- ✦ At both ends of the door, slightly loosen the set screws on the Stamped Axle Supports.
- ✦ Push door assembly toward header leaving room for door rotate freely. Each end of the door to be equal distance from the header. Curtain to be centered in the opening.
- ✦ Tighten set screws loosened in above step.

### **Warning!**

Ensure all set screws on stamped axle support are adequately tightened securing axle in preparation for adding tension.

## Step 9: Setting Initial Spring Tension

- ✦ Rotate the door two (2) revolutions in the direction that would send the bottom bar down through the guides.
- ✦ While firmly holding the door at the bottom bar, cut the tape and plastic wrap that holds the door in a coil and remove it from door. For a push-up/manually or electrically operated door, hold the door so the bottom of the door is just below the head stop area while someone installs the guides in Step 10. For a reduced hand chain door, the chain may be attached to the chain keeper on wall to hold the door in place while the guides are installed in step 10.

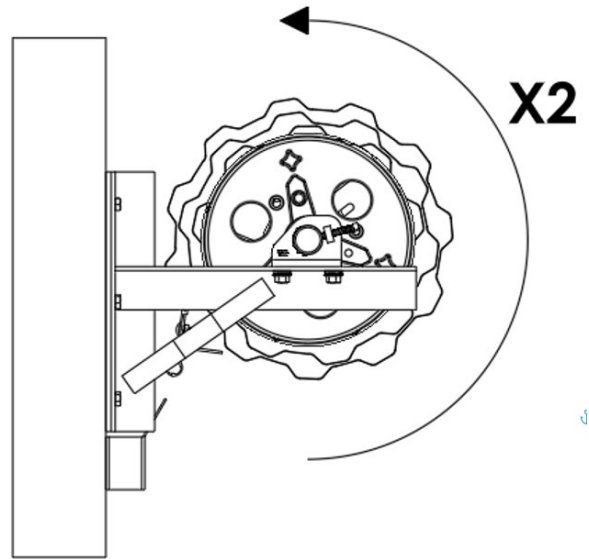


figure 15: Setting Initial Spring Tension

### Warning!

Ensure that astragal is not cut during the tape and plastic removal.

### Warning!

Extreme spring tension can cause serious injury or death. Installation, repairs and adjustments must be made by a trained rolling service door technician using proper tools and instructions. Door must be fully open while making adjustments.

## Step 10a: Mounting Guides to Jambs

---

- ◆ The guides should be positioned centered on the opening spaced curtain width +1/2" apart, measured from back of guide to back of guide. Both guides must be plumb and level. See Figure 16.
- ◆ Once both guides have been correctly positioned, attach to jambs using the appropriate fasteners at each hole location. See Table F.

Table F: Wall Fasteners for Mounting Plate to Jamb

Item	Jamb Type	Fasteners	Drill Size
Guides	Steel	#12-14 x 1-1/4 Flange Tri-Seal Screw	-
Guides	Masonry / Filled Block	1/4 x 2-1/4 Screw-Bolt+	1/4
Guides	Wood	#14-10 x1-1/2 Wood Screw	-

### Warning!

Door can fall if both brackets are not securely fastened to the jambs. All fasteners attaching brackets to jambs must fit securely into a structural member or surface. If door falls, serious injury or death and/or damage to door can result.

### Note:

Door assemblies are manufactured per opening widths and heights specified at time of order. SteelBlue will **NOT** assume responsibility for opening widths or heights that do not match those specified at time of order.

### Notes:

- ◆ Install guides and brackets with fasteners supplied.
- ◆ Install guides per mounting option detail that applies to specific installation applications.

## Step 10b: Installing Guides

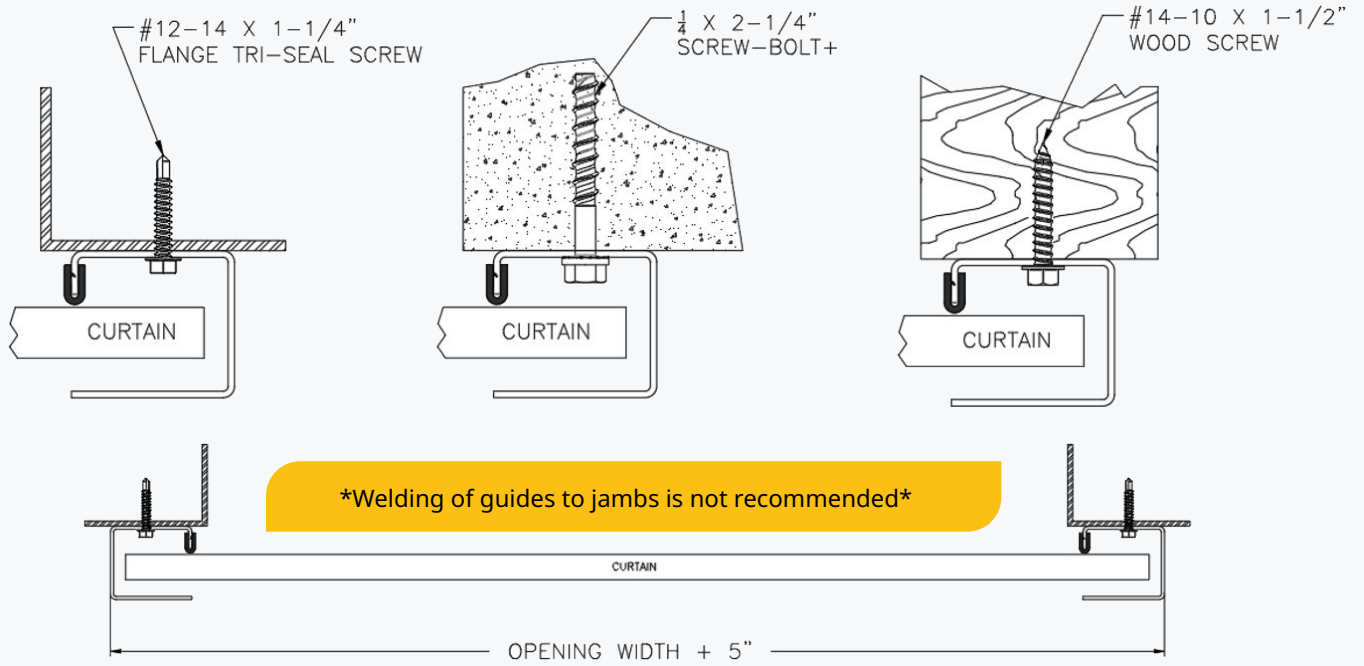


figure 16

## Step 11: Head Stops

- ✦ Slide (2) 1/4-20 x 5/8 carriage bolts from the inside of each guide into square head stop holes.
  - ✦ If door is manually operated, then use the bottom two square holes.
  - ✦ If door has chain hoist or electrically operated, then use the top two square holes. Ensure handles on front of door are not installed.
- ✦ Secure each head stop to guide with a 1/4" Keps nut.

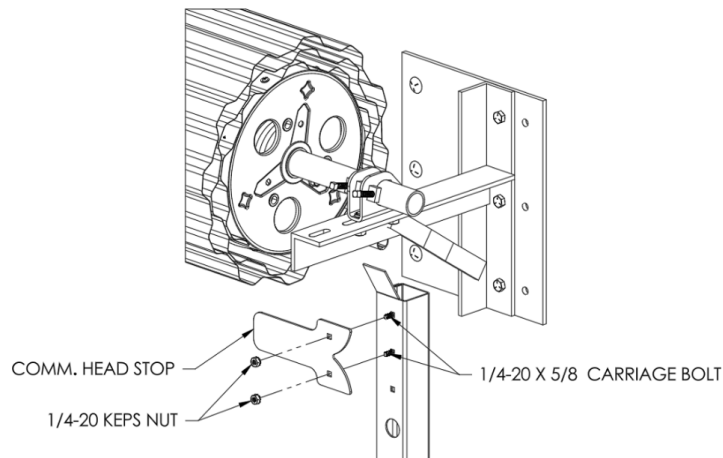


figure 17: Head Stops

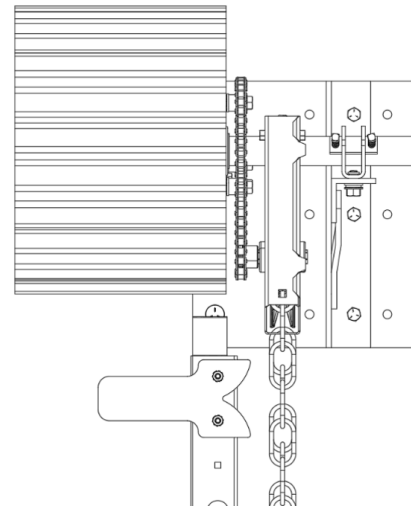


figure 18: Head Stops

## Step 12: Slidelock, Step Plate & Pull Rope

- ✦ Transfer the 1/4-20 x 5/8" carriage bolts and 1/4-20 Keps nut from both ends of the bottom bar to the two holes at the center of the bottom bar and handle.
- ✦ For chain hoist operated doors, lower the bottom bar and install the slide lock and step plate using (2) 1/4-20 x 1" carriage bolts, (2) 5/16-18 hex nuts, (2) 1/4 flat washers and (2) 1/4-20 nylon lock nuts. Do this at both ends of bottom bar. **See Figure 19.**
- ✦ \*For electrically operated doors, lower bottom bar and install step plate using (2) 1/4-20 x 5/8 carriage bolts and (2) 1/4-20 Keps nuts. **See Figure 19 (OMIT SLIDE LOCK)**
- ✦ For manually (push-up) operated doors only, install rope in one of the holes at the center of the horizontal leg of the bottom bar angle and handles at center and each end of bottom bar with step plates. **(OMIT SLIDE LOCK)**

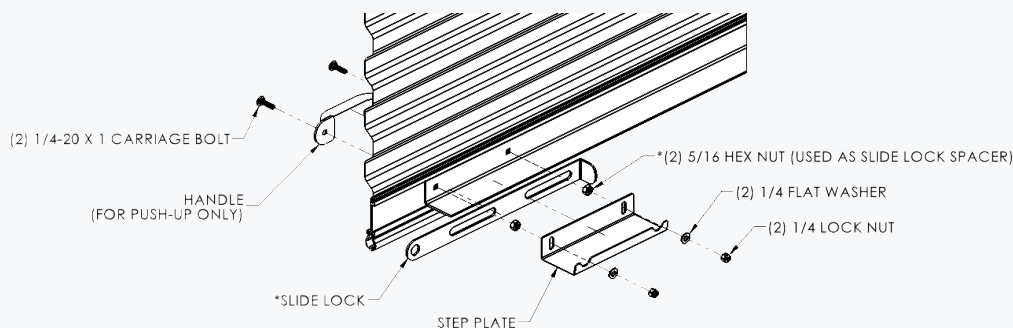


figure 19: Slidelock & Step Plate (Manual Operation)

### Note:

- ✦ Before cycling door to test operation, ensure that all fasteners and set screws are tightened and securing all components.

## Step 13: Check Manual Door Operation

- ✦ Cycle door by raising and lowering door to its fully closed and fully open position.
- ✦ Evaluate spring tension. If adjustments to spring tension are require, **proceed to Step 14.**
- ✦ Set limits of electrically operated doors at this time.
- ✦ Refer to specific operator instructions for setting limits.

### Warning!

Two people are required to adjust door tension safely.



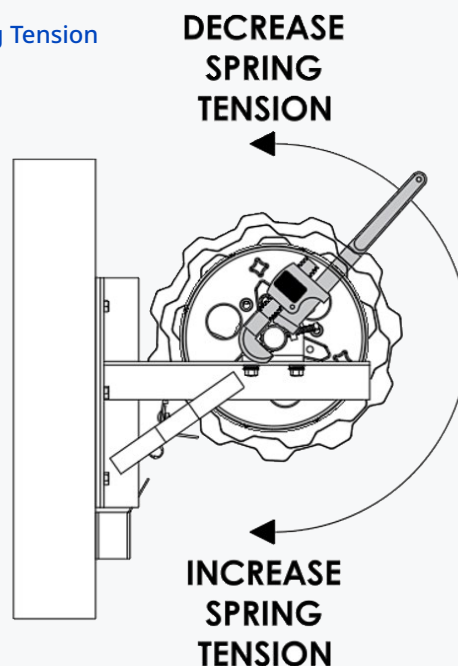
## Step 14: Adjust Spring Tension (if required)

- ✦ If door closes easily but is hard to open, then more tension is required.
- ✦ If the door is hard to close buy easy to open, then less tension is required.
- ✦ Each person should firmly place a large tensioning device on the axle (pipe wrench is preferred). Loosen the set screws on the Stamped Axle Supports and reduced drive assembly if applicable.
- ✦ Pull down on tensioning device to increase tension or push up on tensioning device to decrease tension.
- ✦ Tight set screws on Stamped Axle Support and reduced drive assembly if applicable.
- ✦ Test door and repeat the above steps as necessary.

### Warning!

Extreme spring tension can cause serious injury or death. Installation, repairs and adjustments must be made by a trained rolling service door systems technician using proper tools and instructions. Door must be fully open while making adjustments.

figure 20: Adjust Spring Tension



### Warning!



Door must be fully opened when making adjustments.



## Step 15: Product Safety Labels

- ◆ Visual ✓ for RDD-201 on tension bracket.
- ◆ Visual ✓ for RDD-204 on bottom bar.
- ◆ Install RDD-202 door drive side, guide, or jamb.



RDD-202 Rolling Door Safety Label

<b>⚠ WARNING</b>

<b>Moving door could result in death or serious injury</b> <b>Do NOT close door until doorway is clear</b>
<b>SAFETY INSTRUCTIONS</b>
<ol style="list-style-type: none"> <li>Control the speed of the door during manual operation.</li> <li>Do not stand or walk under moving door.</li> <li>Keep doorway clear and in full view while operating door.</li> <li>Do NOT permit children to play on, near, or with door, or operate door controls.</li> <li>Unlock door before opening door.</li> <li>Sensing devices on motor operating doors should be tested frequently.</li> <li>Adjustments or repairs must ONLY be made by a trained door systems technician using proper tools and instructions.</li> <li>Visually inspect door and hardware monthly for worn and/or broken parts and check if door operates freely. DO NOT operate a door with a broken spring.</li> </ol>
Place label at a readable height on door drive side guide or jamb. Do NOT remove, cover, or paint over label. This label should be inspected periodically for legibility, and a replacement label should be ordered from the door manufacturer as needed.
 12/07 RDD-202 ©

<b>⚠ WARNING</b>

<b>Components under extreme spring tension could result in death or serious injury.</b>
<b>SAFETY INSTRUCTIONS</b>
<ol style="list-style-type: none"> <li>Repairs and adjustments must be made by a trained rolling door systems technician using the proper tools and instructions.</li> <li>Door <b>must</b> be fully opened when making adjustments.</li> </ol>
Do NOT remove, cover, or paint over label. This label should be inspected periodically for legibility, and a replacement label should be ordered from the door manufacturer as needed.
 12/07 RDD-201 ©
Order # _____

RDD-201 Tension Safety Label

<b>⚠ WARNING</b>	<b>SAFETY INSTRUCTIONS</b>	4. Do NOT permit children to play on, near, or with door, or operate door controls.	7. Adjustments or repairs must ONLY be made by a trained door systems technician using proper tools and instructions.	Attach label to bottom bar.	
	<ol style="list-style-type: none"> <li>Control the speed of the door while manually operating.</li> <li>Do not stand or walk under moving door.</li> <li>Keep doorway clear and in full view while operating door.</li> </ol>	5. Unlock door before opening door.	8. Visually inspect door and hardware monthly for worn and/or broken parts and check if door operates freely. DO NOT operate a door with a broken spring.	Do NOT remove, cover, or paint over label. This label should be inspected periodically for legibility, and a replacement label should be ordered from the door manufacturer as needed.	
Moving door could result in death or serious injury. Do NOT close door until doorway is clear.		6. Sensing devices on motor operated doors should be tested frequently.			12/07 RDD-204 ©

RDD-204 Rolling Door Bottom Bar Label

- ◆ SteelBlue Building Components requires the following product safety labels to be in place and/or installed to fully complete installation.
- ◆ Any case where product safety labels are missing or damaged, contact SteelBlue Building Components immediately to obtain replacements.

## Operation & Maintenance

---

The following manual is provided to evaluate the operational performance and future maintenance of SteelBlue Building Components Rolling Sheet door product line. SteelBlue Building Components mandates rolling sheet door product installation by trained rolling door technicians and future maintenance by experienced/qualified personnel. Specific parts, components, assemblies, etc. that are determined to be defective, worn, or unsafe by performance evaluations or preventative maintenance programs must result in rolling sheet door assembly taken out of service. All repairs, part replacements or adjustments must be made by trained rolling sheet door technicians to place rolling sheet door assembly back in service. It is **MANDATORY** that all SteelBlue Building Components door technicians and other technicians, installers and future maintenance staff comply with all safety information, procedures, and instructions contained in this manual. **Failure to do so could result in premature part/component failure resulting in serious injury or death to others** and, with respect to SteelBlue Building Components door technicians, immediate termination of employment.

Adjustments, part replacement, repairs, etc. must be performed by trained rolling door technician

### Rolling Sheet Door Performance Evaluation

---

- ✦ Rolling Door operation should be easy at/near the open and closed positions. Rolling door may require more effort to open through the middle portion of travel.
- ✦ Rolling Door operation to the open position should result in bottom bar angle resting against the head stops and remain in the open position.
- ✦ Rolling Door operation should not exceed 35lb. of force for hand chain operation, and 30lb. for manual operation.
- ✦ Rolling Door operational balance evaluation:

If door operation is easy to close, but hard to open, spring tension needs to be increased.

If door operation is hard to close, but easy to open, spring tension needs to be decreased.

**Spring tension adjustments must be made by trained rolling door technician. Refer to Rolling Door installation instructions for tension adjustment procedures.**

#### Warning!

Extreme spring tension can cause serious injury or death



## Rolling Sheet Door Performance Evaluation (continued)

---

- ✦ Rolling Door electrical motor operation should be evaluated quarterly.
- ✦ Prior to Rolling Door electrical motor operation, ensure that doorway is clear and in full view before and during complete operation cycle.
- ✦ UL 325 requires constant pressure to close for doors without sensing edges or photoelectric sensors/eyes.
- ✦ Sensing devices should be tested at least weekly. Sensing edges should be tested at both ends to evaluate proper operation. Photoelectric eyes must be tested by breaking beam to evaluate proper operation.
- ✦ Evaluate operator limit setting at door travel open and closed positions. If operator limit setting has become out of sync with door open and closed positions, refer to operator installation instructions to reset limits.
- ✦ If at any time during Rolling Door electrical motor operation, motor sounds like it is under excessive load or stress to open the door:

Close door using motor operator. Engage motors manual operation feature to manually operate the door to the open position.

If door operation is heavy, cannot be completely opened or hard to open and will not stay in open position: Spring Assembly counterbalance evaluation is required, which may require adjustment or replacement.

**Spring tension adjustments must be made by trained rolling door technician. Refer to rolling door installation instructions for tension adjustment procedures.**

**Determination of counterbalance repair must result in rolling door taken out of service until required repairs are complete.**

## Visual Inspection

---

### Guides

- ✦ Guide fasteners must be present and secured in each existing hole/slot provided with fasteners supplied by SteelBlue Building Components.
- ✦ Guides must not be bent, crushed, or damaged in a way that binds the curtain and/or bottom bar assembly at any portion of travel.
- ✦ Head stops must be securely fastened in place at top of guide to prevent bottom bar from traveling out of the top of the guides when rolling door curtain is fully raised to the open position.
- ✦ Inspect guide wear strip (when provided) for excessive cracking, tearing, wear or absence.

### Brackets/Mounting Plates

- ✦ All fasteners must be present and installed per detailed installation instructions.
- ✦ Brackets & Mounting plates (when provided) must not be bent or damaged in a way that adversely effects the safe operation of the door assembly.

### Sprockets & Roller Chain Device

- ✦ **Sprocket misalignment will result in excessive wear and could cause roller chain to jump off of the sprocket during operation or lead to premature failure of roller chain assembly.**
- ✦ Visually inspect sprocket alignment between Rolling Door sprocket and output sprocket on motor operator. Align sprockets and tighten set screws as needed.
- ✦ Inspect roller chain for excessive wear or damage.
- ✦ Roller Chain Lubrication: SAE 20 oil to be used for service temperatures between 32°F and 104°F. Apply oil where chain tension is minimal.
- ✦ Check fasteners and tighten as required.

### Curtain

- ✦ During rolling door operation, curtain and bottom bar assembly must move freely inside guides and not contact header or ceiling.
- ✦ Latches, Handles, Slidelocks, Windlocks, etc. (when provided) must always be securely fastened to curtain assembly.
- ✦ **Windlocks should never be removed from curtain.**
- ✦ Inspect curtain wear material or rubber pads/strip (when provided) for excessive tearing, wear, or absence.
- ✦ Inspect weather seals, top draft stop, side draft stop, brush (when provided).

### Tensioning Devices & Axle Supports

- ✦ Fasteners attaching all tensioning devices and axle supports must be securely fastened.
- ✦ Set screws securing axle must be securely fastened.
- ✦ Inspect components for damage or deformity.

### Chain Hoist Gears

- ✦ Fasteners attaching all chain hoist components and gears must be securely fastened.
- ✦ Visually inspect gears for broken, cracked, missing or extremely worn teeth.
- ✦ Clear debris from gear teeth.

- 
- Determination of tensioning device repair or replacement must result in Rolling Door taken out of service until required repairs are completed. Repair or replacement must be performed by trained rolling door technician.
  - Product safety labels should be periodically inspected and cleaned by the product user as necessary to maintain good legibility for safe viewing distance.
  - Product safety labels should be replaced by the product user when they no longer meet the legibility requirements for safe viewing distance. In any case where products have an extensive expected life or where exposed to extreme conditions, the product user should immediately contact SteelBlue Building Components to obtain replacements.



SteelBlue Building Components 6600 Steubenville Pike  
One Robinson Plaza - Suite 240 Pittsburgh, PA 15205

Phone 412-857-3496  
[www.steelbluebc.com](http://www.steelbluebc.com)

Initial Release | 10.17.2025