



Man Door INSTALLATION

Prepare the Surface:

- Clean the surface area of the shipping container where you will be welding the frame. Remove any rust, dirt, or paint using the angle grinder with a grinding disc. Ensure the surface is clean and free from contaminants.

Position the Frame:

- Position the 40 in. x 82-½ in. steel frame inside the shipping container where you want it to be welded. Use clamps to hold the frame in place and ensure it is square and level, or use a tape measure. Mark the positions where you will weld the frame to the container using chalk or a marker.

Welding Precautions:

- Ensure proper ventilation in the welding area to prevent inhalation of fumes.
- Wear appropriate personal protective equipment (PPE) including a welding helmet, gloves, and safety glasses.
- Keep a fire extinguisher nearby in case of emergencies.

Tack Welding:

- Begin by tack welding the frame to the shipping container at the marked positions. Tack welding involves making small welds to temporarily hold the frame in place. Check the alignment and squareness of the frame before proceeding to full welding.

Welding the Frame:

- Once the frame is securely positioned and aligned, begin welding along the marked positions. Use a welding technique suitable for the material thickness and type of welding machine you are using (MIG, TIG, or stick).
- Weld along each side of the frame, ensuring good penetration and fusion between the steel frame and the container.
- Maintain a consistent welding speed and technique to achieve strong, uniform welds.

Inspect Welds:

- After completing the welding, inspect the welds thoroughly for any defects such as cracks or incomplete fusion. Use a wire brush or grinder to remove any slag or spatter from the welds.

Finish and Clean Up:

- Once satisfied with the weld quality, allow the welded joints to cool down naturally. Do not cool them rapidly with water as this can cause stress and distortion.

- Clean up the work area, removing any welding debris or tools.
- Store welding equipment safely.

Test for Structural Integrity:

- After the welds have cooled, perform a structural integrity test by applying pressure or load to the welded frame. Ensure it can withstand the intended use and weight requirements.