



Cast Door Remounting Instructions

On all Intrepid, Vigilant and Defiant Parlor Stove replacement doors, the hinge bosses on the doors are not drilled out in the factory as they need to be custom matched to the hinge bosses on the stove front for these models. Following are **two** different instructions for drilling the hinge bosses to match the stove. The best option is to use extra long drill bits for the drilling procedure.

Tools needed: electric hand drill; center punch; hammer; c-clamp

Materials Needed: long 3/16" drill bit (optional long 1/8" drill bit), required length of rope gasket, small marking pencil, new replacement door(s), door pins, aerosol paint to match if the stove is painted and gasket cement.

HINGE DRILLING PROCEDURE OPTION ONE

The procedure for replacing doors on all Vermont Castings stove models is basically the same. For correct positioning of the new door on to the stove, it is necessary for the technician to physically fit the door to the stove. Although all the doors on Vermont Castings stoves are machine drilled at the factory for production, to replace a door in the field requires hand drilling of the new door pinholes. It is not difficult if one is patient and precise.

STEP 1: Preparation

Remove the defective door from the stove. Remove any handles on the door for later replacement onto the new door.

STEP 2: New Door Preparation and Positioning for Door Pin Hole Marking

Check the bottom of the new door bosses for a smooth, shiny surface. If the bottom of the boss is rough, use a hand file to make a smooth surface for a legible pencil mark.

Hold the new door without gasket and handle onto the stove in the closed position. In the case of installing one door only on a two-door unit, check the line between the new door and the corresponding left or right front door. In the case of installing two new front doors, install the door that sits behind first and make sure both new doors line up properly before going on. An extra set of hands will be needed to position the overlapping door for this.

When the door is exactly where it should be in the closed position (remove the overlapping door at this point if installing 2 doors), mark up through the existing boss holes on the stove front or end plate with a small, narrow pencil.

Remove the door, and with a center punch, strike the center of the pencil marks on the new door bosses for correct drilling start.

STEP 3: Door Drilling

Clamp the door flat on a workbench or table for drilling.

Drill with a 3/16" drill bit through the bottom boss center punch mark. Try to aim at the top boss center punch mark or drill straight through.

Slide a long 3/16" (or 1/8" to pilot the second hole and later drill through with 3/16" bit from above) drill bit through the hole just drilled and drill the upper door boss hole through the center punch mark. If the top of the long drill bit does not hit the upper center punch mark directly, the new door boss hole can be reamed slightly for drill movement. If you have problems with this procedure, refer to the next section.

OPTIONAL STEP 2 & 3: New Door Preparation and Door Drilling

If you cannot drill through the bottom boss into the top boss because you do not have a long enough drill bit or it won't line up, use the optional procedure listed on the second page titled "**Vermont Castings Door Optional Hinge Drilling**".

STEP 4: New Door Finishing

If not enameled, paint the new door at this time.

Drive door pins into the holes just drilled.

Gasket the new door with cement and fiberglass gasket.

If the new door is the door used for the handle, attach the new handle or handle from the old door.

Slide the new door into place on the stove and adjust the striker bolt for a good snug handle fit.

VERMONT CASTINGS DOOR OPTIONAL HINGE DRILLING

Tap out both door hinges and remove the broken door from the stove casting.

On the old door, cover the **bottom** of the lower hinge tab and the **top** of the upper hinge tab with masking tape or equivalent. Press the tape until the outline of the tab is well defined. Trace the outline with a pencil. On the tape, mark the location of the hole.

Transfer both tracings to the new door. Ensure to align the actual edges of the tab with the traced outline on the masking tape. Mark the location of the hole in the cast tab.

Drill out with a 3/16" drill bit. Take special care to drill straight through.

