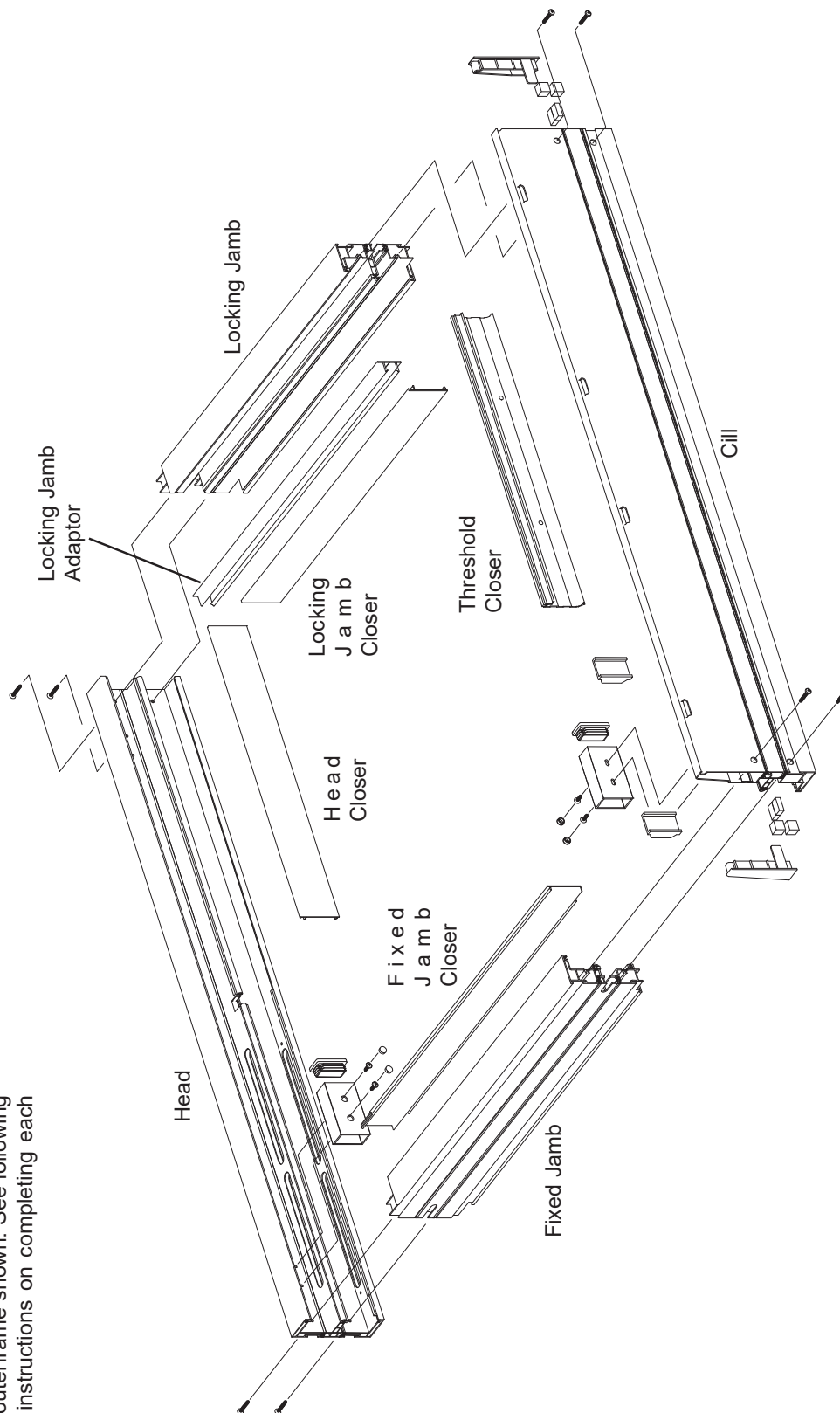


ASSEMBLY - OUTERFRAME

Typical 2 pane OX outerframe shown. See following pages for detailed instructions on completing each joint.



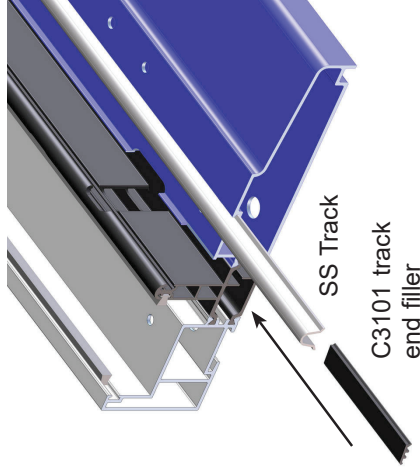
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ASSEMBLY - OUTERFRAME

TECHNICAL

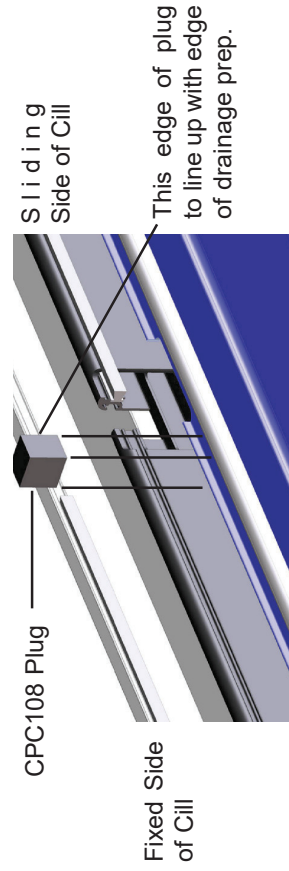
Track Assembly

Slide stainless steel track into groove in cill. Fit track end fillers (C3101) to the gap at either end of the cill as shown below. On 3 pane units, at the non-sliding end, slide track filler CPC111 into track recess. Completely seal all track end filler at cill ends.



Fitting Cill Plug at Interlock Drainage Point

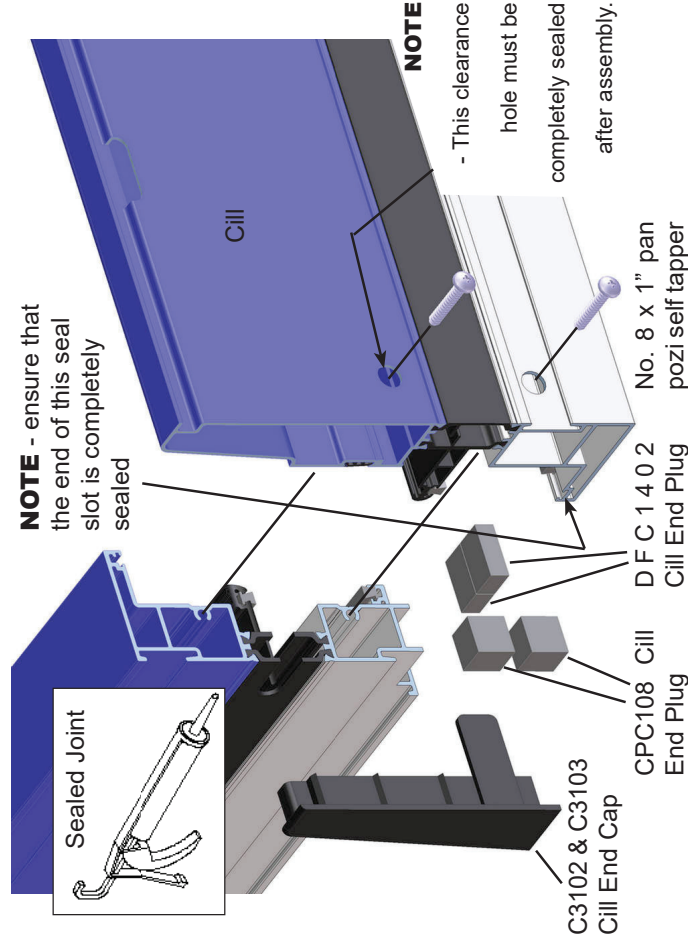
At every interlock drainage point, fit plug CPC108 as shown below - seal into position using Henkel Terostat 934 (clear) or 939 (grey, black or white).



Jamb to Cill Assembly

Slide pile DFC1450 into appropriate grooves in jamb and cill (see general arrangements). Coat entire cut ends of both jambs with Henkel Terostat 934 (clear) or 939 (grey, black or white). Seal plugs DFC1402 & CPC108 into recesses in cill as shown below and cill end cap C3102 & C3103 using the same sealant. Apply a generous amount of sealant to cill rebate / jamb inner face joint.

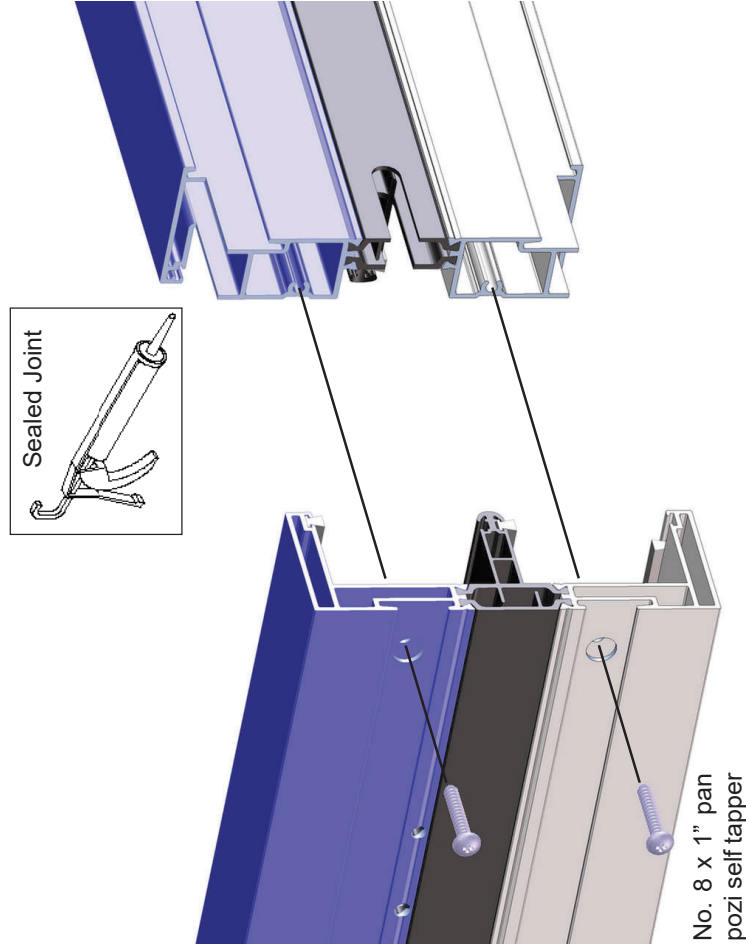
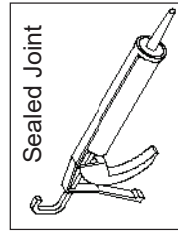
Assemble using 2 off No. 8 x 1" pan pozi self tappers per joint. Check for any weak spots in sealing and rectify. Clean off excess sealant immediately using Teroson FL cleaner.



ASSEMBLY - OUTERFRAME

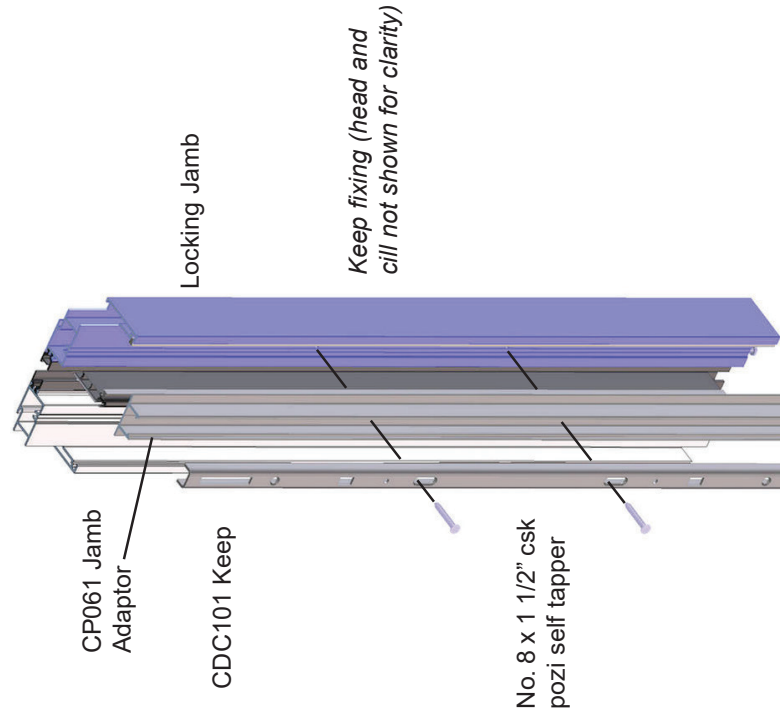
Jamb to Head Assembly

Slide pile DFC1450 into appropriate grooves in jamb and head (see general arrangements). Coat entire cut ends of both jambs with Henkel Terostat 934 (clear) or 939 (grey, black or white). Assemble using 2 off No. 8 x 1" pan pozi self tappers per joint. Check for any weak spots in sealing and rectify. Clean off excess sealant immediately using Teroson FL cleaner.



Keep and Jamb Adaptor Fixing

Drill 3.5 dia holes through existing holes in jamb adaptor into jamb. Fix keep (CDC101) using only two No. 8 x 1 1/2" csk self tapper through the two central slotted holes, though the jamb adaptor into the jamb. Final fixing is carried out after installation / adjustment through the remaining holes using the same screws. CP069 trim must be fitted above and below keep AFTER installation and adjustment.

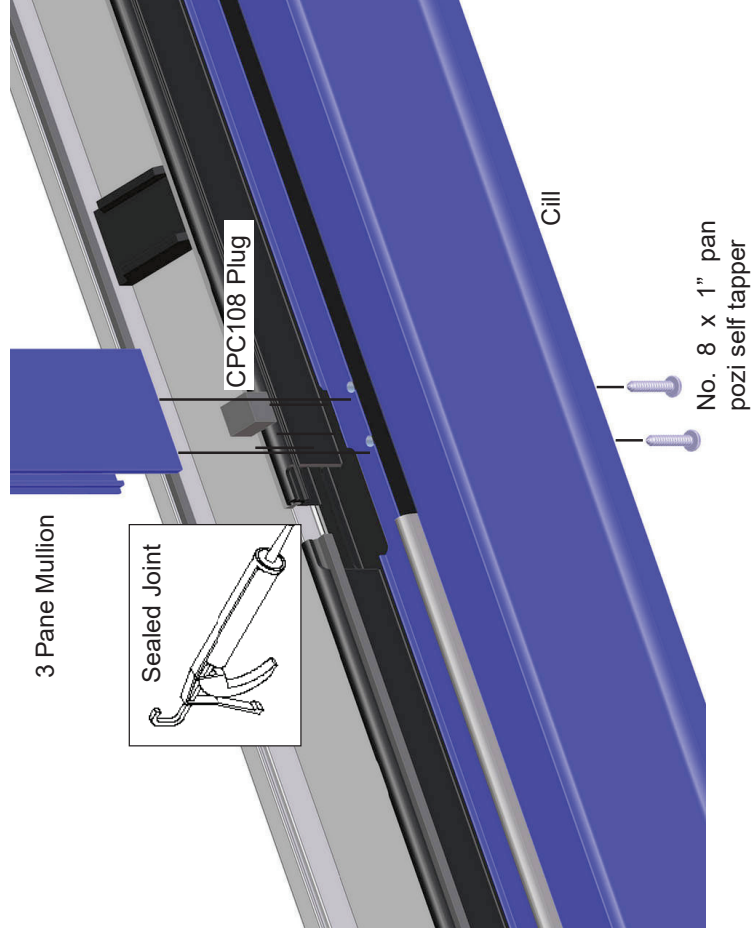
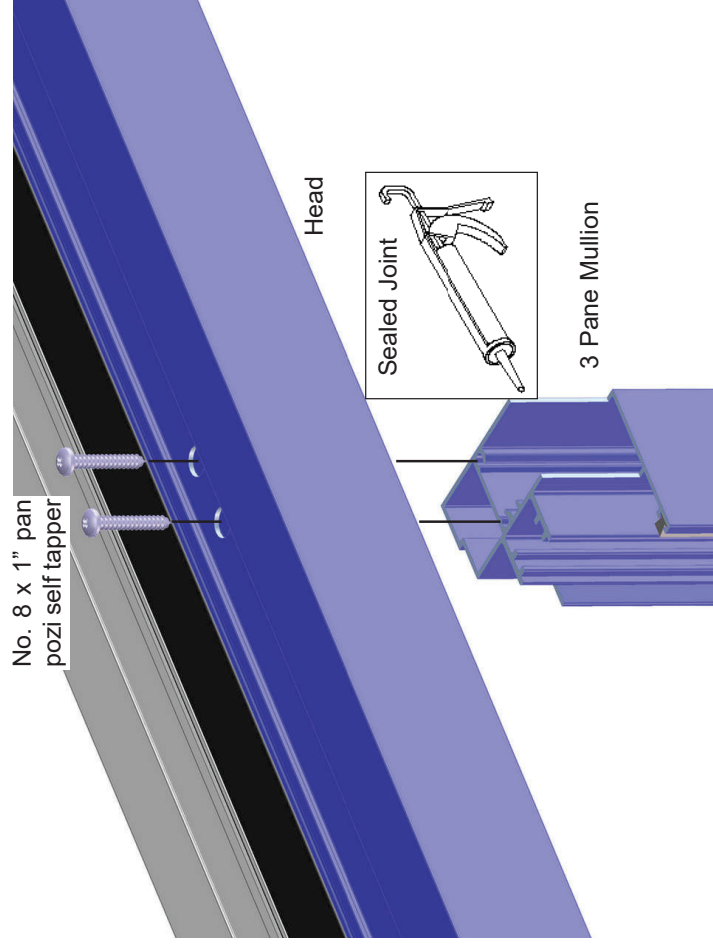


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ASSEMBLY - OUTERFRAME

Fitting of 3 Pane Mullions

Slide pile DFC1450 into groove in 3 pane mullion. Coat entire cut ends of mullion with Henkel Terostat 934 (clear) or 939 (grey, black or white). Fit plug CPC108 as shown under mullion at cill - seal into position using Henkel Terostat 934 (clear) or 939 (grey, black or white). Assemble using 2 off No. 8 x 1" pan pozi self tappers per joint. Check for any weak spots in sealing and rectify. Clean off excess sealant immediately using Teroson FL cleaner. Fitting of keep is similar to the 2 pane as shown on previous page but without the adaptor profile.



It is **ESSENTIAL** that the 9.5 dia clearance holes on the under side of the cill for fitting the 3 pane mullion have CPC109 hole plugs **SEALED** into them, including any un-used holes on non-handed cut down kits.

INSTALLATION

Fitting Frame Into Aperture

It is vitally important that the cill is laid flat and level to achieve good performance. Jambes must be vertical in both planes, and no twist or other distortion allowed in the frame.

Prior to installing the frame, the opening should be checked to ensure that it is free of debris, and that any projecting brickwork has been trimmed back.

Any damaged damp proof membranes should be replaced or additional membranes incorporated.

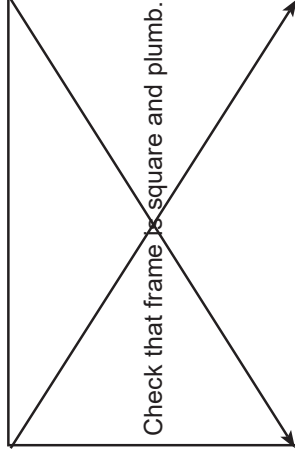
When the opening was originally measured a suitable gap should have been allowed around the window, this will allow the window to be packed to ensure that it is plumb and square within the opening.

Ideally the frame should be bedded on mortar.

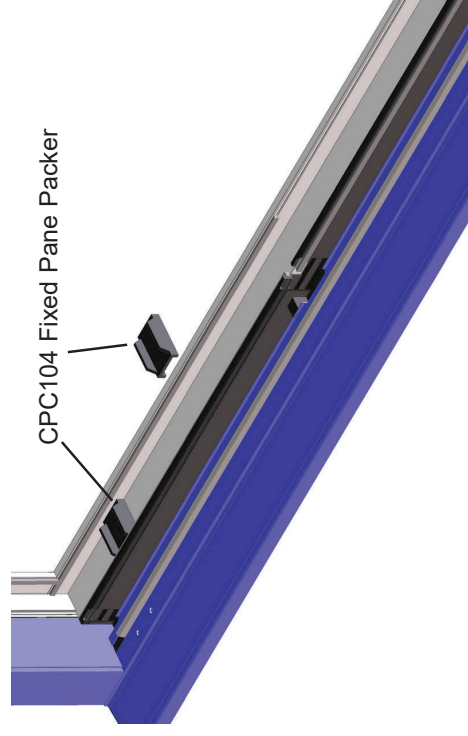
The frame can then be positioned in the opening and held square by packing at the very corners of the frame, taking care not to damage or deform the frame profiles.

To check for squareness, measure the diagonals from corner to corner, these diagonal dimensions should not differ by more than 1 or 2mm, if they do then adjust the packing until the frame is square within the opening.

The lay of the frame in to out can be checked by using a spirit level on the jambs. On replacement applications, the correct position of the frame might not align with the original. This will require some remedial work to make good the plaster reveal around the frame on the inside as well as any render that is present on the outside.



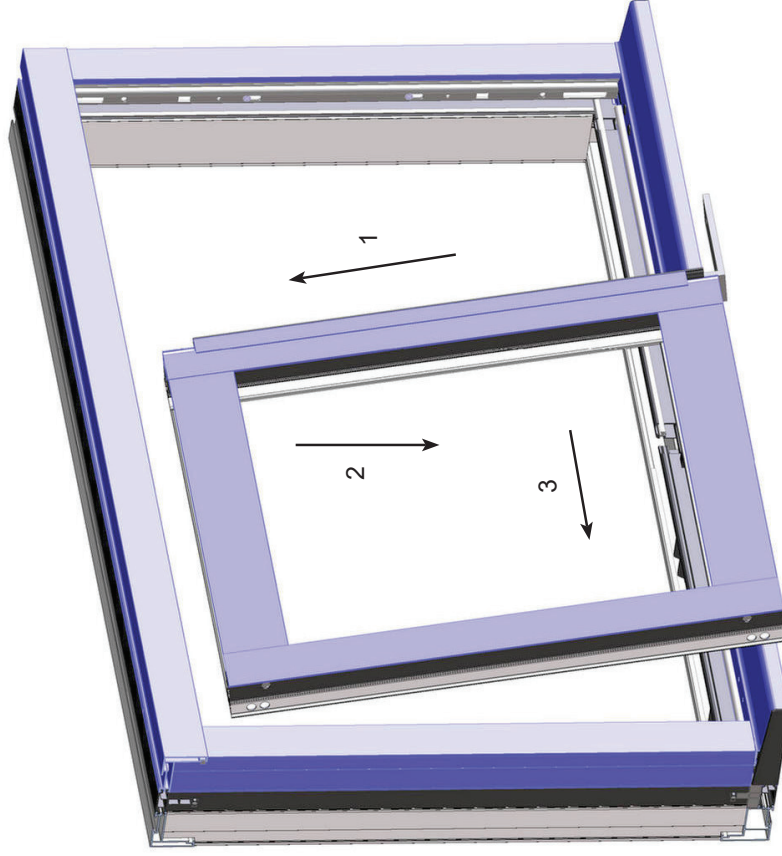
Fit CPC104 Fixed pane packers into inner recess of cill near to corners of fixed pane as shown below.



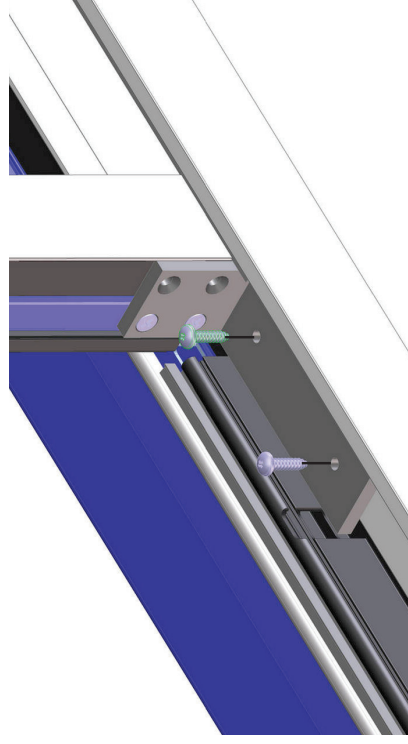
INSTALLATION

Fitting Fixed Pane

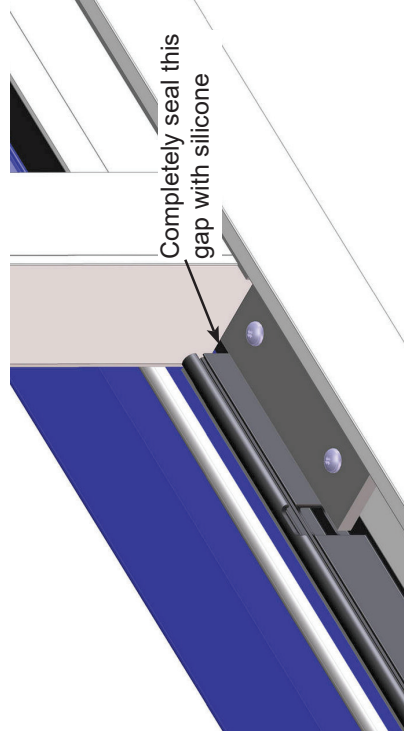
Lift fixed pane into inner head channel, then swing bottom into inner cill channel and gently lower the pane onto the packers. Slide pane FULLY into fixed jamb.



Drill 4.2 dia through holes in fixed pane retaining bracket into cill. Fix using 2 off No. 10 x 3/4" pan pozi self tappers.



Clip DF1107 fixed interlock capping into place with the bottom resting on the fixed pane retaining bracket. Completely seal the gap between the interlock capping and the polyamide upstand in the cill

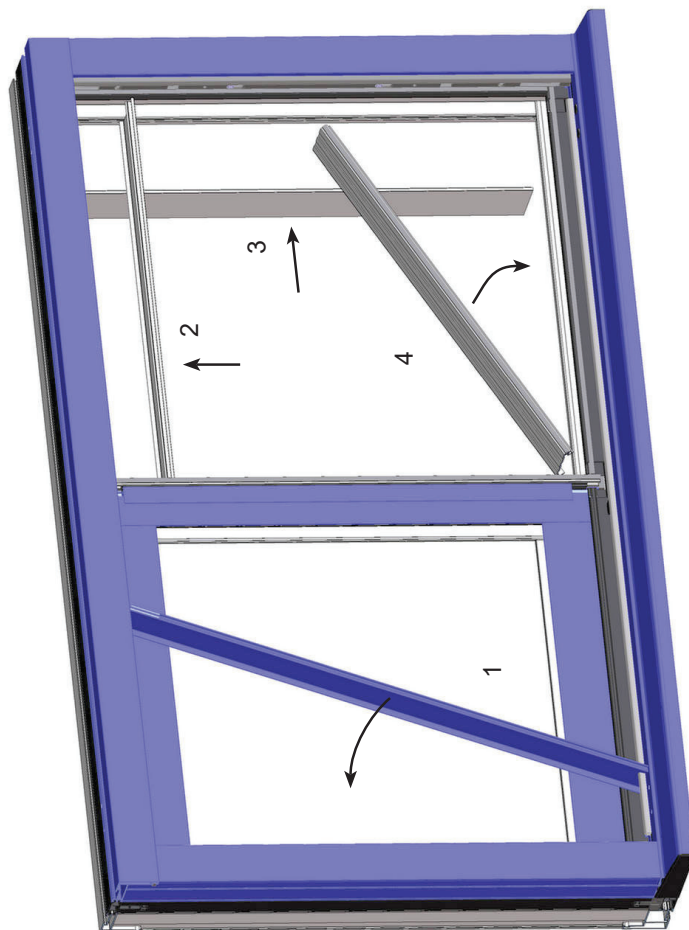


Completely seal this gap with silicone

INSTALLATION

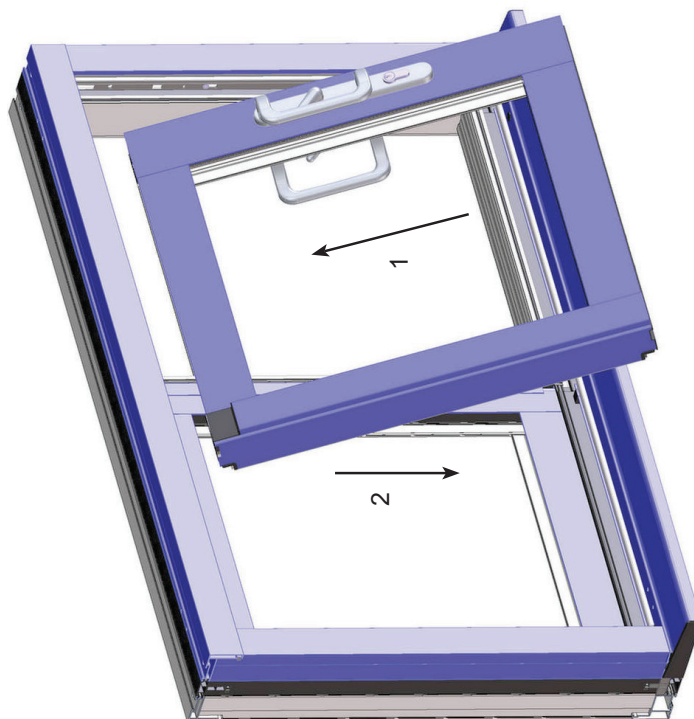
Fitting Head, Jamb & Threshold Closers

Clip in head, jamb and threshold closers in the sequence shown below. Seal butt joints in all internal closers using Henkel Terostat.



Fitting Sliding Pane

Lift sliding pane into outer head channel then swing bottom of pane inwards and gently lower the rollers onto the track. Slide pane to a near closed position and check that the lock stile is parallel to the jamb. If necessary adjust rollers using a pozi drive screw driver through the hole at the bottom of the stile / interlock (remove interlock capping to gain access to the interlock end roller adjustment). Reduce the load on the roller adjustment screw by lifting the pane slightly whilst adjusting. The ideal nominal gap between the bottom rail liner and the top of cill is 6mm. This will result in 12mm panel edge cover at the head.

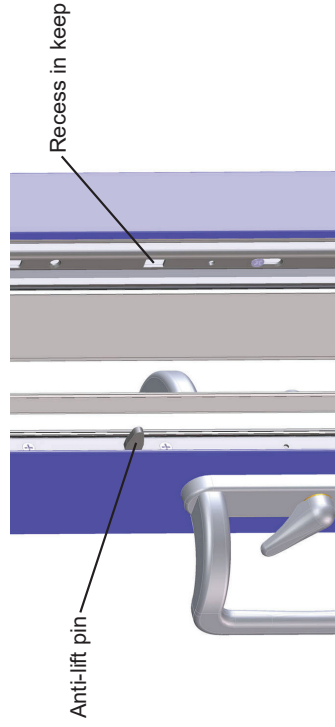


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INSTALLATION

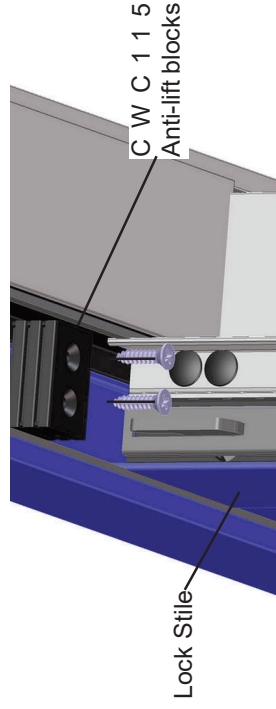
Adjusting Keep

Slacken two keep fixing screws previously fitted. Line up recess in keep with anti-lift pin on lock. Re-tighten screws and check lock operation. Adjust if necessary. Once Keep is correctly adjusted, fit No. 8 x 1 1/2" csk pozi self tappers to all remaining keep fixing holes. Fit C1630 trim above and below keep. (NB trim does NOT fit into stile).



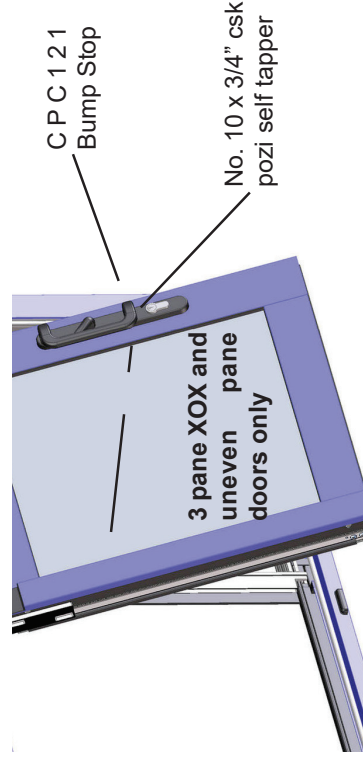
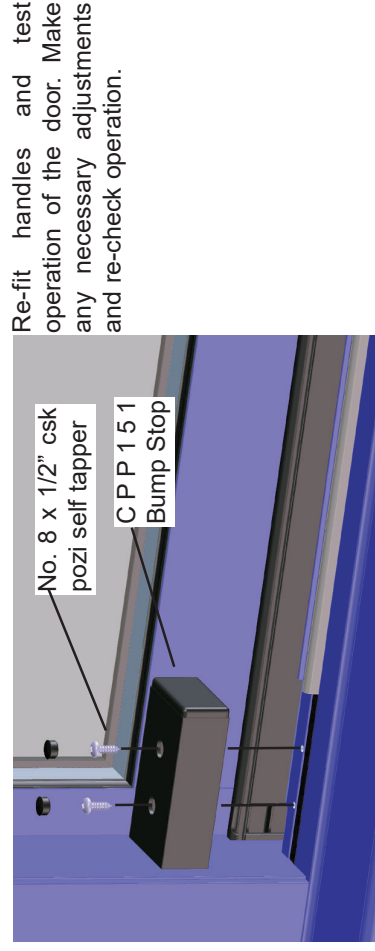
Fitting Anti Lift Blocks (NOT required where concealed trickle vent is fitted)

Temporarily remove handles and cylinder. Without bump stops fitted, carefully open door as far as it will go. Using CWC115 anti-lift block as a template, with it held tight against the polyamide upstand, drill two 4.2 dia holes. Fit 2 or 3 anti-lift blocks and / or horseshoe packing shims depending on clearance using No. 10 x 1 1/4" csk pozi self tapper. Repeat as close to lock jamb as possible.



Fitting Bump Stops

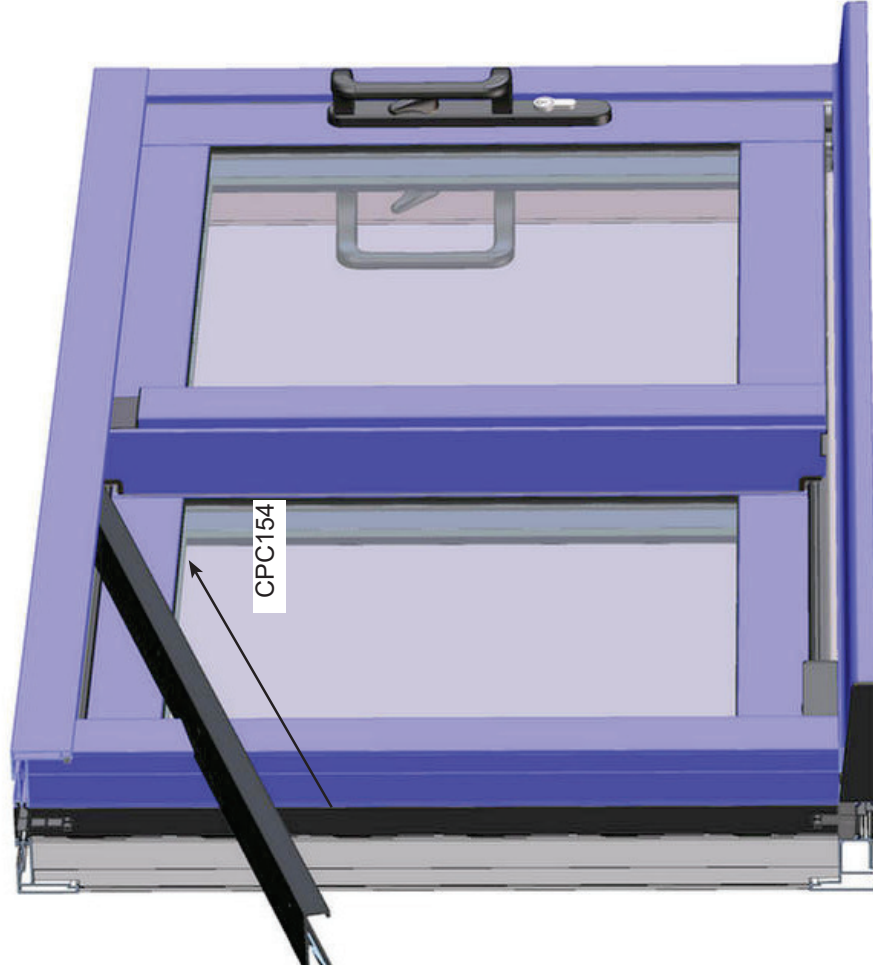
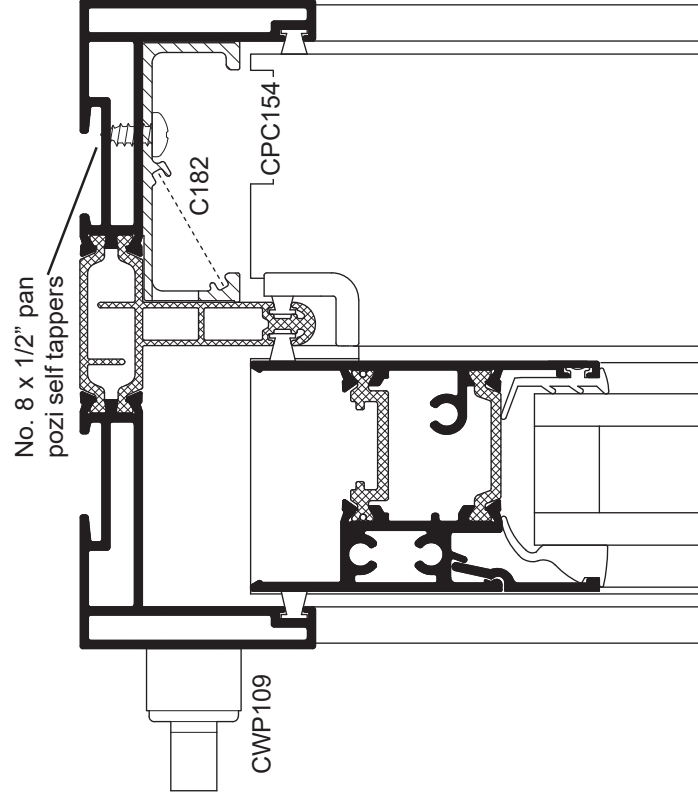
Fix CPP151 Bump Stops to head and cill using No. 8 x 1 1/2" pan pozi self tapper as shown below. On non-handed 2 & 3 pane cut down kits, where there are un-used bump stop fixing holes, fill them using CPC122 5mm hole plugs. Where necessary, a second bump stop buffer can be fitted to the opposite end of the stop to pack it off the jamb. On 3 pane XOX and uneven pane doors, use CPC121 bump stops fitted to the inside of the top and bottom rails as shown below.



INSTALLATION

Fitting Concealed Trickle Vent

Slide C182 mesh into groove in CPC154 trickle vent. With sliding pane(s) already fitted, close door into locked position. Slide CPC154 PVC extrusion up over the top of the sliding pane as shown alongside with the slots facing towards the inside. Take care not to distort the mesh. (on sites where access is restricted - near a return wall or similar - the CPC154 can be cut in two before inserting). Push the CPC154 tight against the polyamide downstand in the head. Drill 3.5 dia holes through existing holes in trickle vent into head. Fix using No. 8 x 1/2" pan pozi self tappers. Fix CWC109 operator to inside of head using screws supplied.



FINISHING OFF

Sealing

The recommended sealant for the exterior is Low Modulus Neutral Cure Silicone Sealant. Backing foam should be used where the perimeter gap is over 5mm. Where the gap is within the 5mm range, a neat application of silicone is all that is required on the outside.

A final check of the internal and external perimeter seals should be undertaken. Any weak spots that are identified should be rectified and tooled to a high visual finish. Any excess sealant must be cleaned off of the finished surfaces using appropriate cleaner.

Cleaning After Installation

If excess sealant is to be cleaned off. Ensure that any solvent used will not damage any of the metal finishes, synthetic rubbers or plastics which may be present.

Warning

Take particular care if there is any cement or plaster on the aluminium. It is harmful to the metal finish and should be washed off while still wet. DO NOT RUB or particles of grit will permanently damage the metal or paint finish.

Routine Cleaning

No aluminium finish is "Maintenance Free" and hence should be cleaned at regular intervals. See surface treatment suppliers literature/website for cleaning and maintenance requirements.

Maintenance

Locks and rollers are sealed for life and require no special regular maintenance other than wiping the faceplate of the lock and the stainless steel track down with a damp cloth periodically. In addition, regular checks must be made to ensure that the track is not damaged or obstructed in any way. If you are unsure DO NOT operate the door and seek professional help.

Operating And Safety Instructions

In order to preserve functionality of the door, and to guarantee safety, it is imperative the directives listed below are observed.

- *The door sash must not be burdened with additional weight.*
- *Do not place any objects between the sliding pane and frame.*
- *Do not allow children to operate the door.*
- *Do not leave pane open during strong winds.*
- *Caution! A slamming pane can lead to injuries while closing. Do not grasp the door between the sliding pane and frame.*