INSTALLATION INSTRUCTIONS

ENTICE SERIES

CLEAR FIN ENTRANCE SYSTEM
EXTERIOR GLAZE

Phone: (800) 421-6144 • Fax: (800) 582-7501
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11M0288

HANDLING, STORAGE, AND PROTECTION OF ALUMINUM

The following precautions are recommended to protect the material against damage. Following these precautions will help ensure early acceptance of your products and workmanship.

A. HANDLE CAREFULLY.
All aluminum materials at job site must be stored in a safe place, well removed from possible damage by other trades. Cardboard wrapped or paper interleaved materials must be kept dry.

B. CHECK ARRIVING MATERIALS.
Check for quantities and keep records of where various materials are stored.

C. KEEP MATERIALS AWAY FROM WATER, MUD, AND SPRAY.
Prevent cement plaster or other materials from damaging the finish.

D. PROTECT THE MATERIALS AFTER ERECTION.
Protect erected frame with polyethylene or canvas splatter screen. Cement, plaster, terrazzo, other alkaline solutions, and acid based materials used to clean masonry are harmful to the finish. If any of these materials come in contact with the aluminum, immediately remove with water and mild soap.

IMPORTANT: READ THIS MANUAL THOROUGHLY BEFORE BEGINNING INSTALLATION.

GENERAL INSTALLATION NOTES

Recommended Guidelines For All Installations:

1. **REVIEW CONTRACT DOCUMENTS.** Check shop drawings, installation instructions, architectural drawings, and shipping lists to become thoroughly familiar with the project. The shop drawings take precedence and include specific details for the project. Note any ***field verified*** notes on the shop drawings prior to installing. The installation instructions are of a general nature and cover most conditions.

2. **INSTALLATION.** All materials are to be installed plumb, level, and true. Install operable windows preglazed only.

3. **BENCH MARKS.** All work should start from bench marks and/or column lines as established by the architectural drawings and the general contractor with guaranteed accuracy. Working from these datum points and lines determine:
   a) The plane of the wall in reference to offset lines provided on each floor.
   b) The finish floor lines in reference to bench marks on the outer building columns.
   c) Mullion spacing from both ends of masonry opening to prevent dimensional build-up of daylight opening.

4. **FIELD WELDING.** All field welding must be adequately shielded to avoid any splatter on glass or aluminum. Results will be unsightly and/or structurally unsound. Advise general contractor and other trades accordingly. All field welds of steel anchors must receive touch-up paint (zinc chromate) to avoid rust.

5. **SURROUNDING CONDITIONS.** Make certain that construction which will receive your materials is in accordance with the contract documents. If not, notify the general contractor in writing and resolve differences before proceeding with work.

6. **ISOLATION OF ALUMINUM.** Aluminum to be placed in direct contact with uncured masonry or incompatible materials should be isolated with a heavy coat of zinc chromate or bituminous paint.

7. **SEALANTS.** Sealants must be compatible with all materials with which they have contact, including other sealant surfaces. Consult with sealant manufacturer for recommendations relative to joint size, shelf life, compatibility, cleaning, priming, tooling, adhesion, etc. It is the responsibility of the ***Glazing Contractor*** to submit a statement from the sealant manufacturer indicating that glass and glazing materials have been tested for compatibility and adhesion with glazing sealants, and interpreting test results relative to material performance, including recommendations for primers and substrate preparation required to obtain adhesion. The chemical compatibility of all glazing materials and framing sealants with each other and with like materials used in glass fabrication must be established. This is required on every project.

8. **FASTENING.** Within the body of these instructions "fastening" means any method of securing one part to another or to adjacent materials. Only those fasteners used within the system are specified in these instructions. Due to the varying perimeter conditions and performance requirements, perimeter and anchor fasteners are not specified in these instructions. For perimeter and anchor fasteners refer to the shop drawings or consult the fastener supplier.

9. **BUILDING CODES.** Due to the diversity in state/provincial local, and federal laws and codes that govern the design and application of architectural products, it is the responsibility of the individual architect, owner, and installer to assure that products selected for use on projects comply with all the applicable building codes and laws. U.S. Aluminum exercises no control over the use or application of its products, glazing materials, and operating hardware and assumes no responsibility thereof.

10. **EXPANSION JOINTS.** Expansion joints and perimeter seals shown in these instructions and in the shop drawings are shown at normal size. Actual dimensions may vary due to perimeter conditions and/or difference in metal temperature between the time of fabrication and the time of installation. Gaps between expansion members should be based on temperature at time of installation.

11. **COORDINATION WITH OTHER TRADES.** Coordinate with the general contractor any sequence with other trades which offset curtain wall installation (i.e. fire proofing, back-up walls, partitions, ceilings, mechanical ducts, converters, etc.)

12. **CARE AND MAINTENANCE.** Final cleaning of exposed aluminum surfaces should be done in accordance with AAMA 609.1 for anodized aluminum and 610.1 for painted aluminum.

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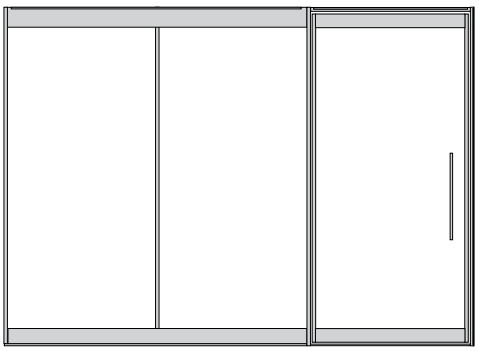
FABRICATION CALCULATIONS

FABRICATION DEDUCTIONS:

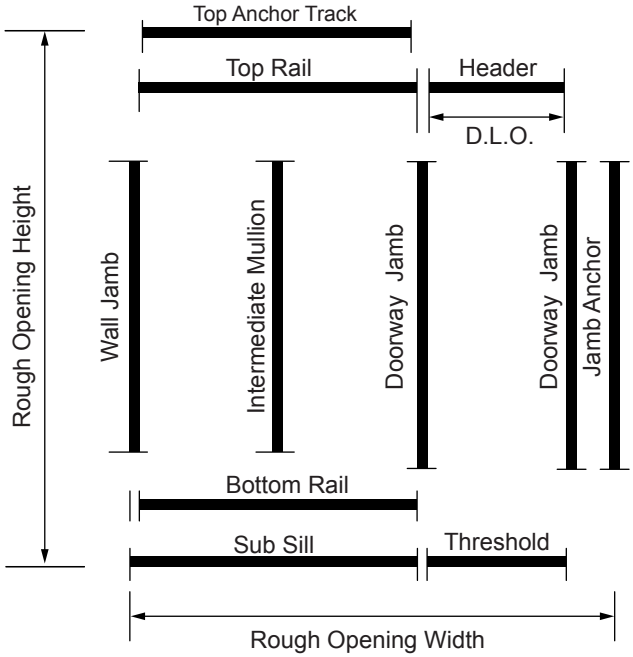
Wall Jamb	R.O. Height Minus 1-3/32” (27.8 mm)
Intermediate Vertical Mullion	R.O. Height Minus 9-13/32” (238.9 mm)
Doorway Jamb	R.O. Height Minus 1/2” (12.7 mm)
Sub Sill	R.O. Width Minus 1/2” (12.7 mm)
Top Anchor Track and Sidelite Rail (Wall to Doorway)	Minus 2-5/8” (66.7 mm)
Top Anchor Track and Sidelite Rail (Wall to Wall)	Minus 3” (76.2 mm)

DOOR SIZE:

Door Height with Standard Header and Threshold	R.O. Height Minus 1-5/16” (33.3 mm)
Door Height with Recessed Flush Header (for Overhead Closer) and Threshold	R.O. Height Minus 27/32” (21.4 mm)
Door Width	D.L.O. Minus 1/4” (6.4 mm)

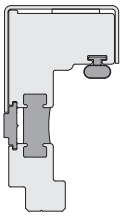
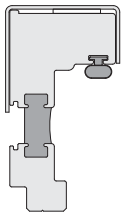
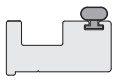
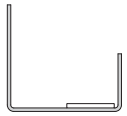
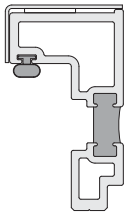
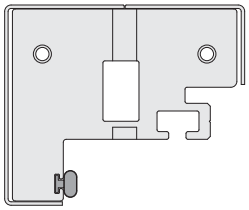
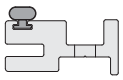
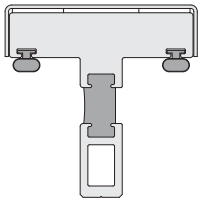
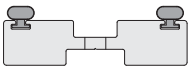
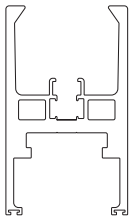
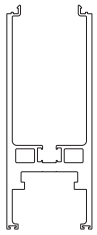
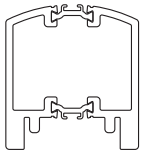
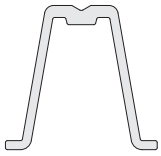
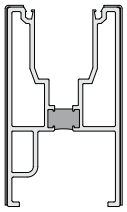
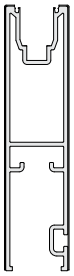
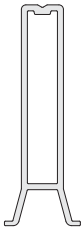
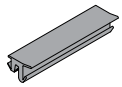
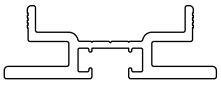
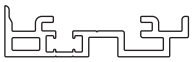
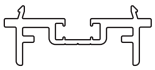


Door with Sidelite and Fixed Lite



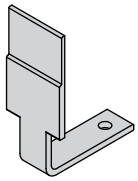
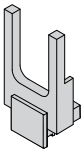
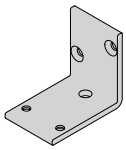
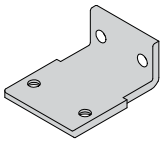
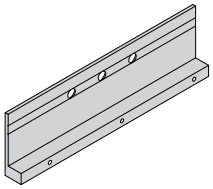
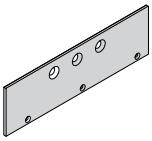
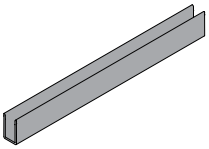
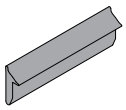
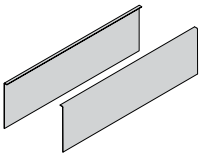
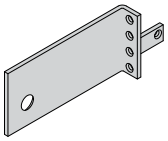
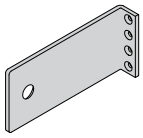
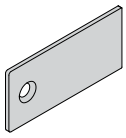
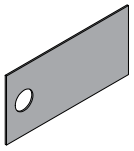
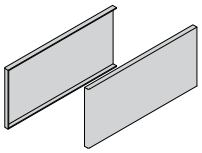
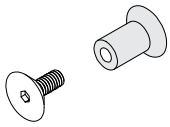
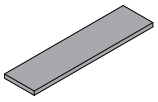
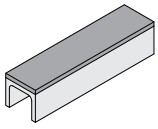
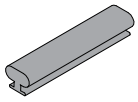
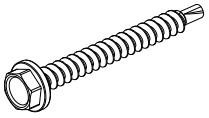
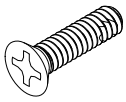
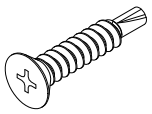
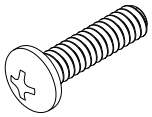
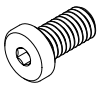
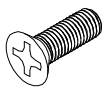
NOTE: R.O. = Rough Opening
D.L.O. = Daylight Opening

PARTS IDENTIFICATION

 Transom Doorway Jamb Main Body	 Transom Jamb Main Body	 Transom Jamb / Doorway Jamb Removable Stop	 Transom Doorway Jamb Removable Stop Clad	 Transom Jamb Removable Stop Clad
 Wall Jamb Main Body	 Transom Header Main Body	 Wall Jamb / Transom Header Removable Stop	 Wall Jamb / Transom Header Removable Stop Clad	 Intermediate Vertical/ Horizontal Main Body
 Intermediate Vertical/ Horizontal Removable Stop	 Intermediate Vertical/ Horizontal Removable Stop Clad	 4” Square Door Rail	 10” Door Rail	 2-5/8” Door Stile
 4” Sidelite Rail	 4” Sidelite Rail Fastening Clip	 10” Sidelite Rail	 10” Sidelite Rail Fastening Clip	Cat. No. NP238  Gasket for Sidelite Rail
 Half Saddle Threshold Offset Pivot	 Saddle Threshold Offset Pivot	 Saddle Threshold Center Pivot	 Half Saddle Threshold Center Pivot	 Threshold Offset Pivot End Cap
 Door / Wall Jamb Mount	 Sidelite Rail Exterior Bottom Anchor	 Sidelite Rail Exterior and Interior Top Anchor	 Sidelite Rail Exterior Top Anchor / Interior Bottom Anchor	 Shear Clip Aluminum Clad OR Stainless Steel Clad

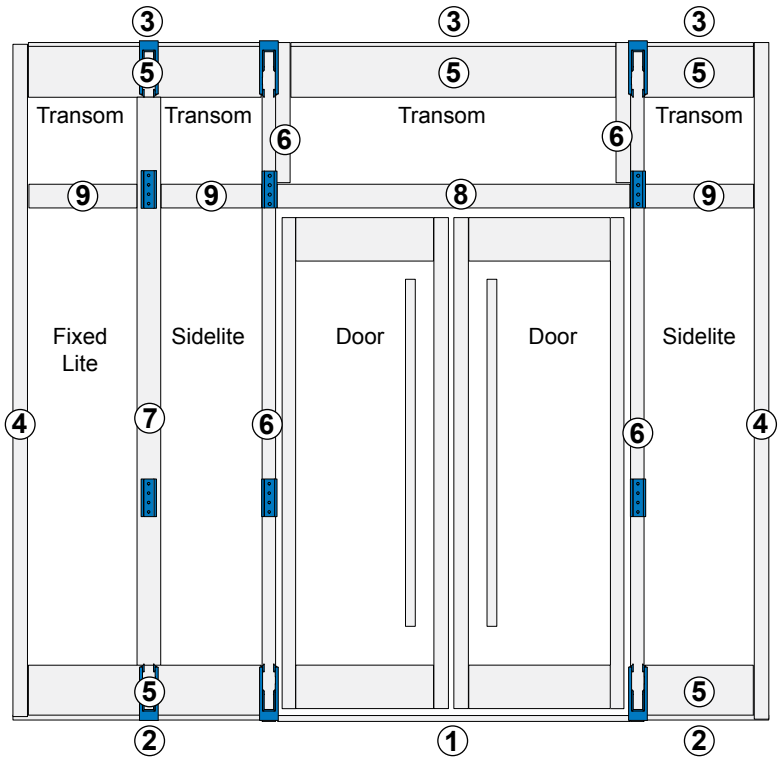
For replacement parts, please contact Technical Sales at (800) 582-7501.

PARTS IDENTIFICATION (CONTINUED)

 Vertical Shear Clip	 Recessed Shear Clip	 Horizontal Mounting Clip	 Horizontal Mounting Clip at Doorway Jamb	 Top / Bottom Fin Mounting Bracket
 Top / Bottom Fin Clamping Plate	 Top / Bottom Fin Interior Gasket	 Top / Bottom Fin Exterior Gasket	 Top / Bottom Fin Cover	 Support Fin Mounting Bracket
 Mid Fin Mounting Bracket	 Mid Fin Spacer	 Support / Mid Fin Clamping Plate	 Support / Mid Fin Interior Gasket	 Support / Mid Fin Cover
 Plastic Gromet	 Sex Bolt	 Neoprene Edge Block	 Setting Block	Cat. No. GH342  Gasket for Removable Stop
Cat. No. 20092003  10-16 x 5/8” Hex Washer Self Drilling Screw for Removable Stop	Cat. No. 10X112HHDTEK  10 x 1-1/2” Hex Washer Self Drilling Screw	 10-24 x 3/4”PFH Thread-Locking Screw for Transom Jamb/Doorway Jamb Removable Stop	 #8x 1/2” FH Drilling Screw for Horizontal Mounting Clip	 #10 x 1” FH Drilling Screw Support Fin
 10-24 x 3/4” PHPMS for Transom Jamb to Transom Doorway Jamb	 10-32 x 3/8” Socket Head for Rails to Doorway Jamb	 10-24 x 1/2” PFH Thread-Locking Screw to attach Mid Fin Mount	 1/4”-28 x 3/4” SS FHPMS to assemble Top/Bottom Fin Mount	

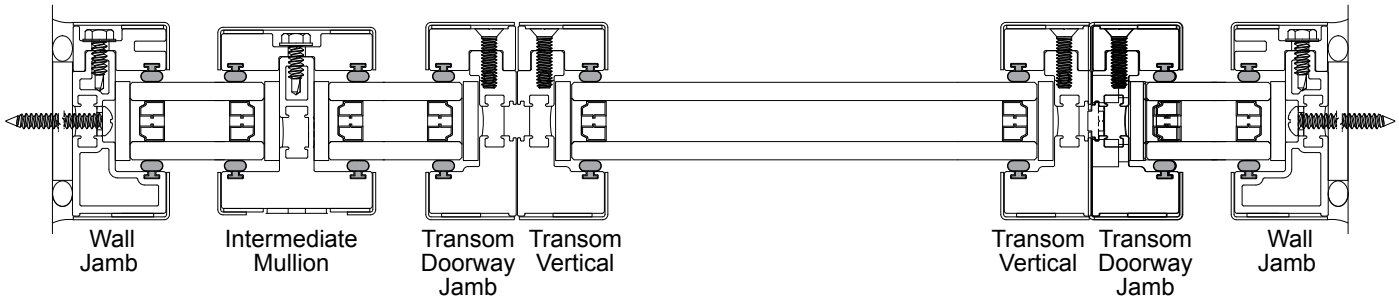
For replacement parts, please contact Technical Sales at (800) 582-7501.

CLEAR FIN TRANSOM DOOR INSTALLATION



Clear Fin Transom Door Installation Order

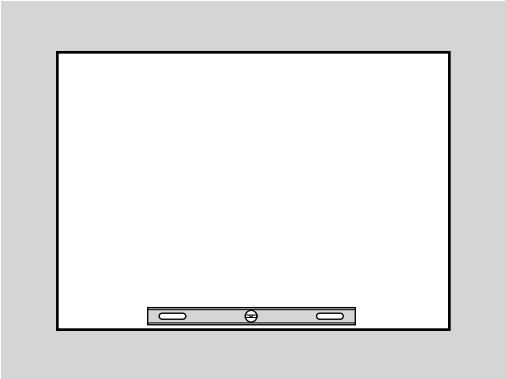
Exterior at Transom



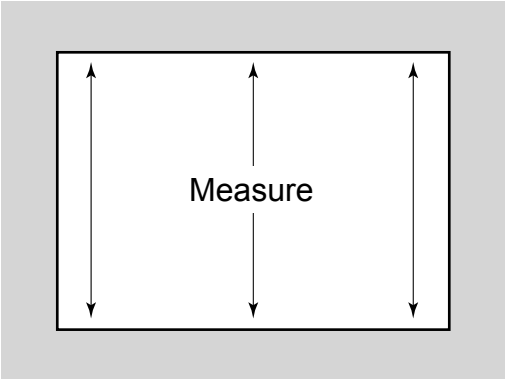
Exterior at Door

SITE PREPARATION

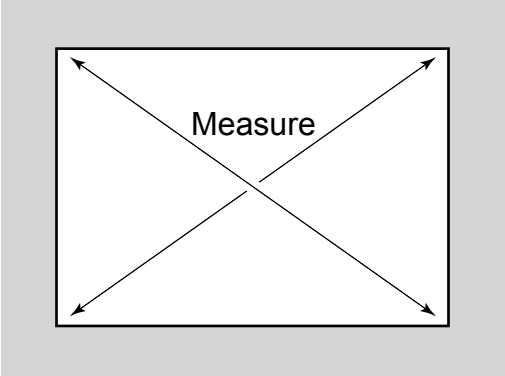
1. Review and measure the opening.
2. Verify rough window opening size 1/2” (12.7) clearance in both width and height to the window. Verify framing is plumb, straight, and true around window opening. Measure opening at each end and at center vertically and horizontally. Make corrections to openings as required. Measure opening diagonally to check squareness. Chip concrete high points to flush and rounded corners to square.



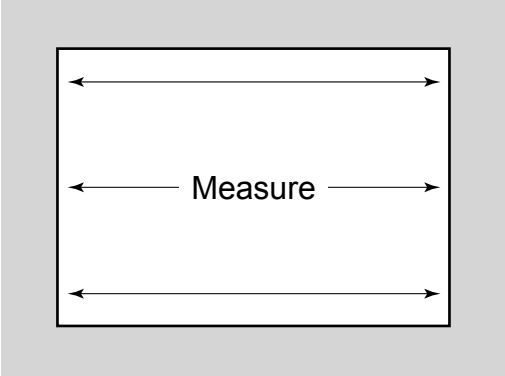
LEVEL



VERTICAL DIMENSION



SQUARE

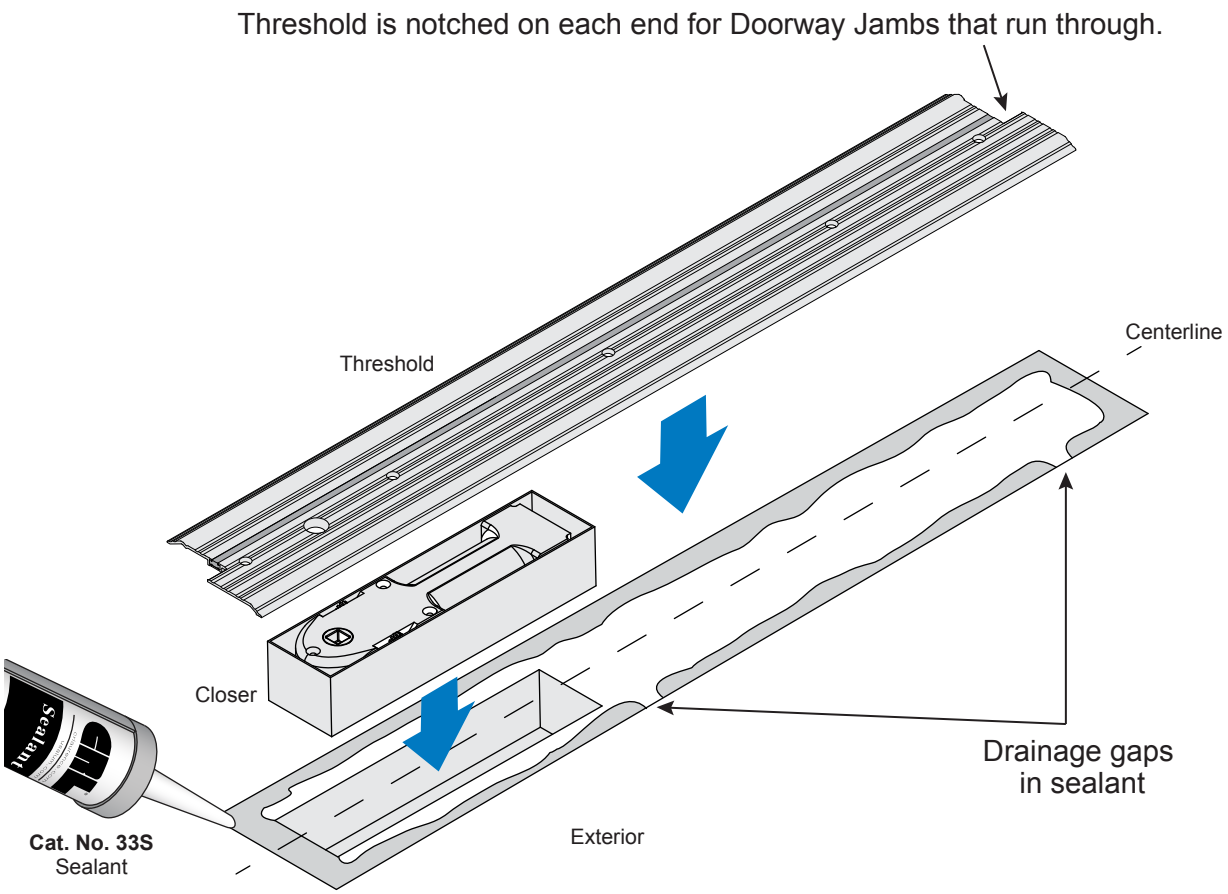


HORIZONTAL DIMENSION

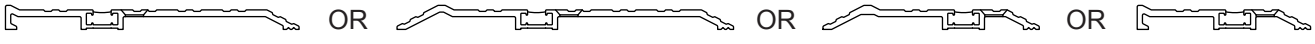
THRESHOLD INSTALLATION

1. Determine the perimeter centerline of the opening and location of the bottom door spindle from the shop drawings.
2. Install the cement box and closer if applicable.
3. Apply a continuous bead of **Cat. No. 33S** Sealant to the floor substrate around the perimeter line below the threshold. Leave two weep gaps for water drainage and set threshold while sealant is wet.
4. Fasten the threshold to the floor with the appropriate fasteners as specified in the engineering requirements. Cover fastener heads with **Cat. No. 33S** Sealant.

NOTE: For installations with doors, the threshold must be installed first to determine the location of the other components.



Threshold Options



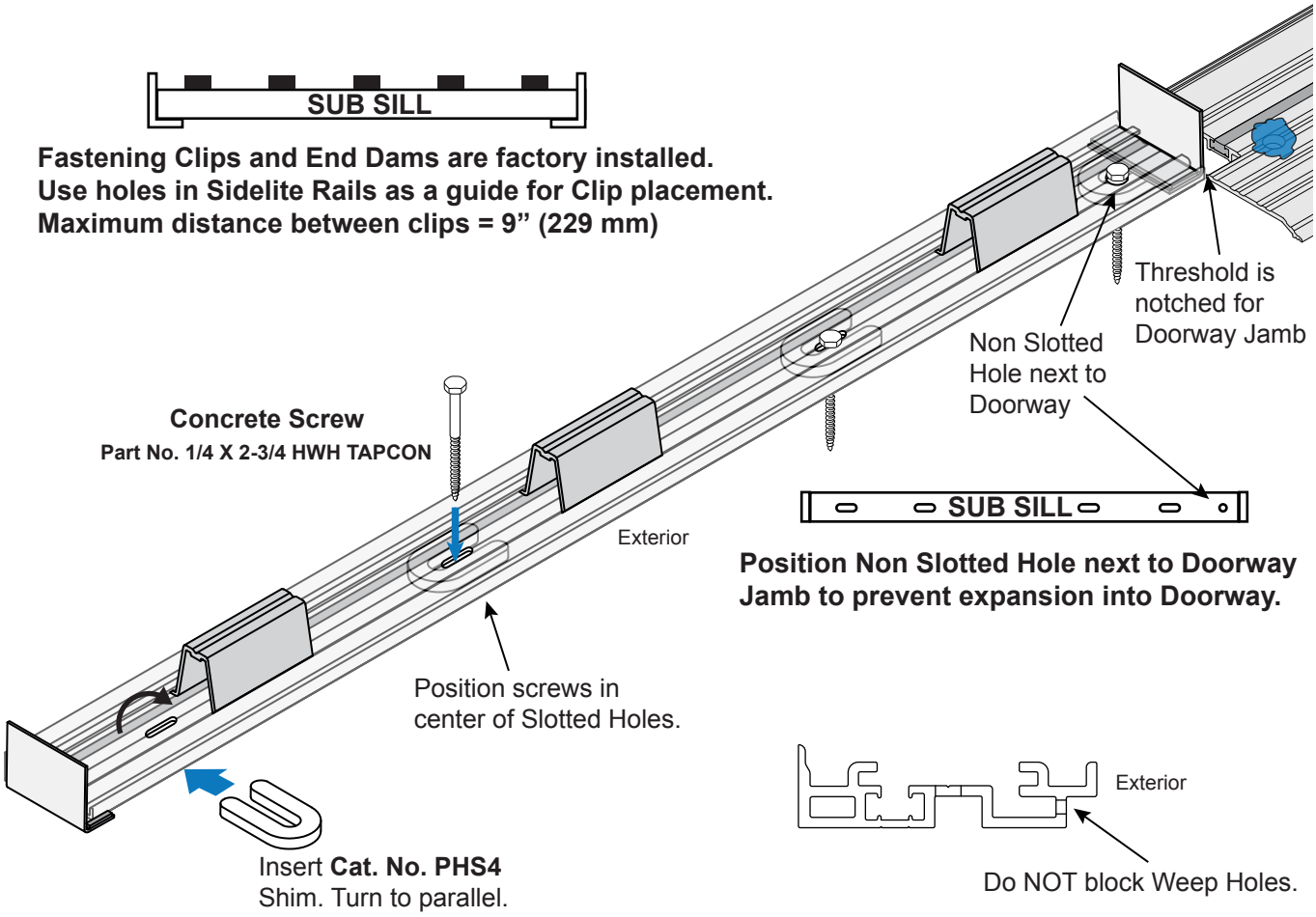
Half Saddle Threshold Offset Pivot | OR | Saddle Threshold Offset Pivot | OR | Saddle Threshold Center Pivot | OR | Half Saddle Threshold Center Pivot

NOTE: Saddle Threshold Offset Pivot shown in illustrations.

SUB SILL TRACK INSTALLATION

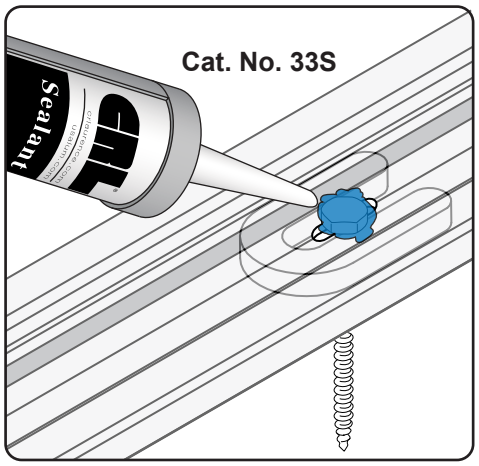
NOTE: Sub Sills are shipped with Fastening Clips installed in the track and End Dams sealed at each end.

1. Shim at each screw with **Cat. No. PHS4** Horseshoe Shims turned parallel to Sub Sill. Position screws in center of slotted hole to allow for expansion.



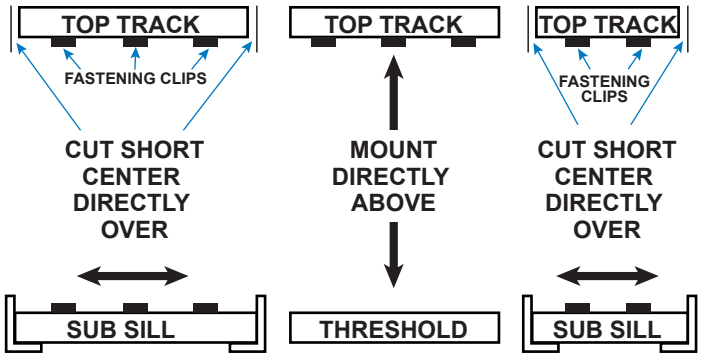
2. Seal over screw heads with **Cat. No. 33S** Sealant.

NOTE: Do NOT block Weep Holes in Sub Sill.

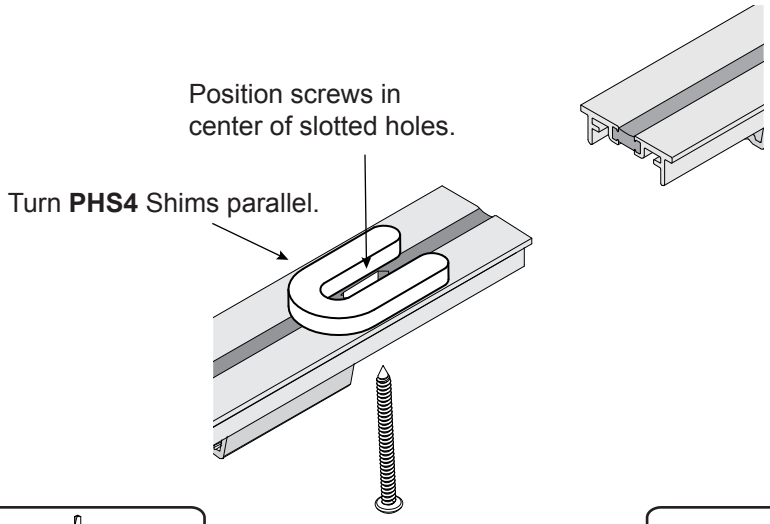


TOP TRACK INSTALLATION

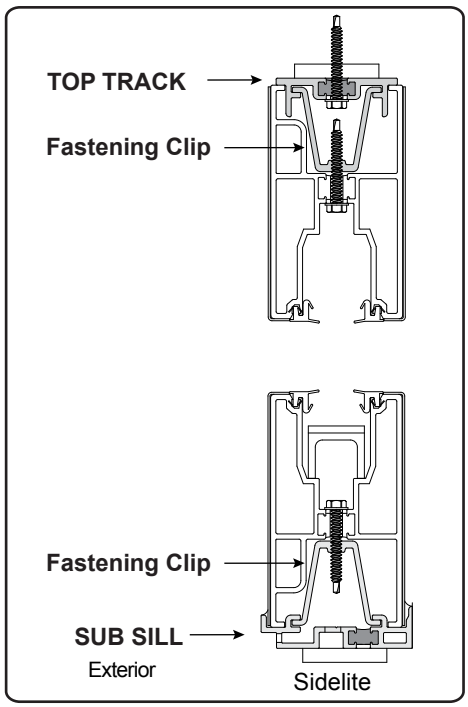
Fastening Clips must be installed before Sidelite Rails. Use holes in Sidelite Rails as a guide for placement. Maximum distance between clips = 9” (229 mm)

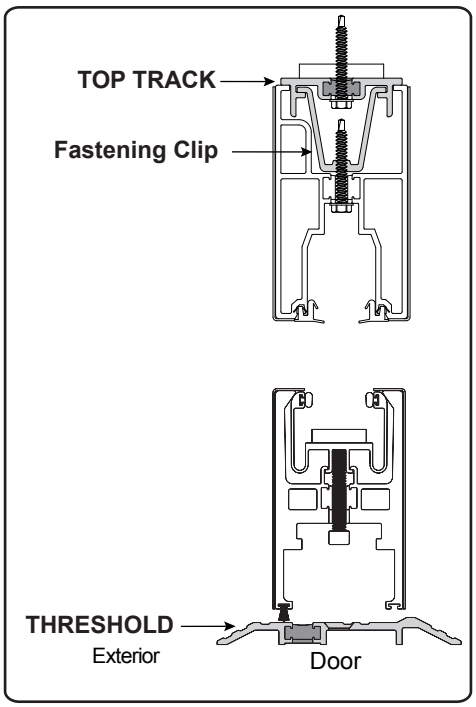


1. Level and mount Header directly above Threshold.
2. Slide Fastening Clips into each top track. Mount track directly above Sub Sill. Secure with screws centered in slots.



 # 10 Fastener appropriate for substrate

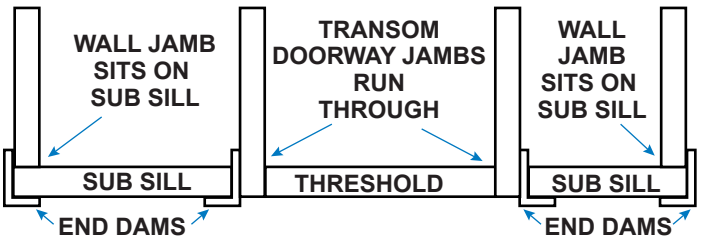


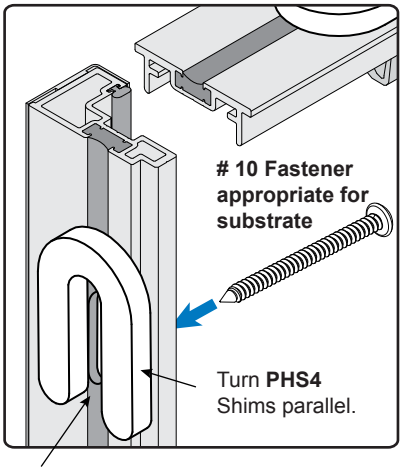


WALL JAMB INSTALLATION

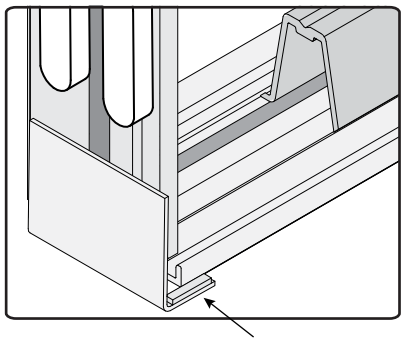
1. Fit the Wall Jamb Main Body on the Sub Sill and push tight against End Dam and wall.
2. Shim and fasten to the wall.

NOTE: Cladded side faces interior.





Position screws in center of slotted holes.



Wall Jamb sits on Sub Sill tight against End Dam.

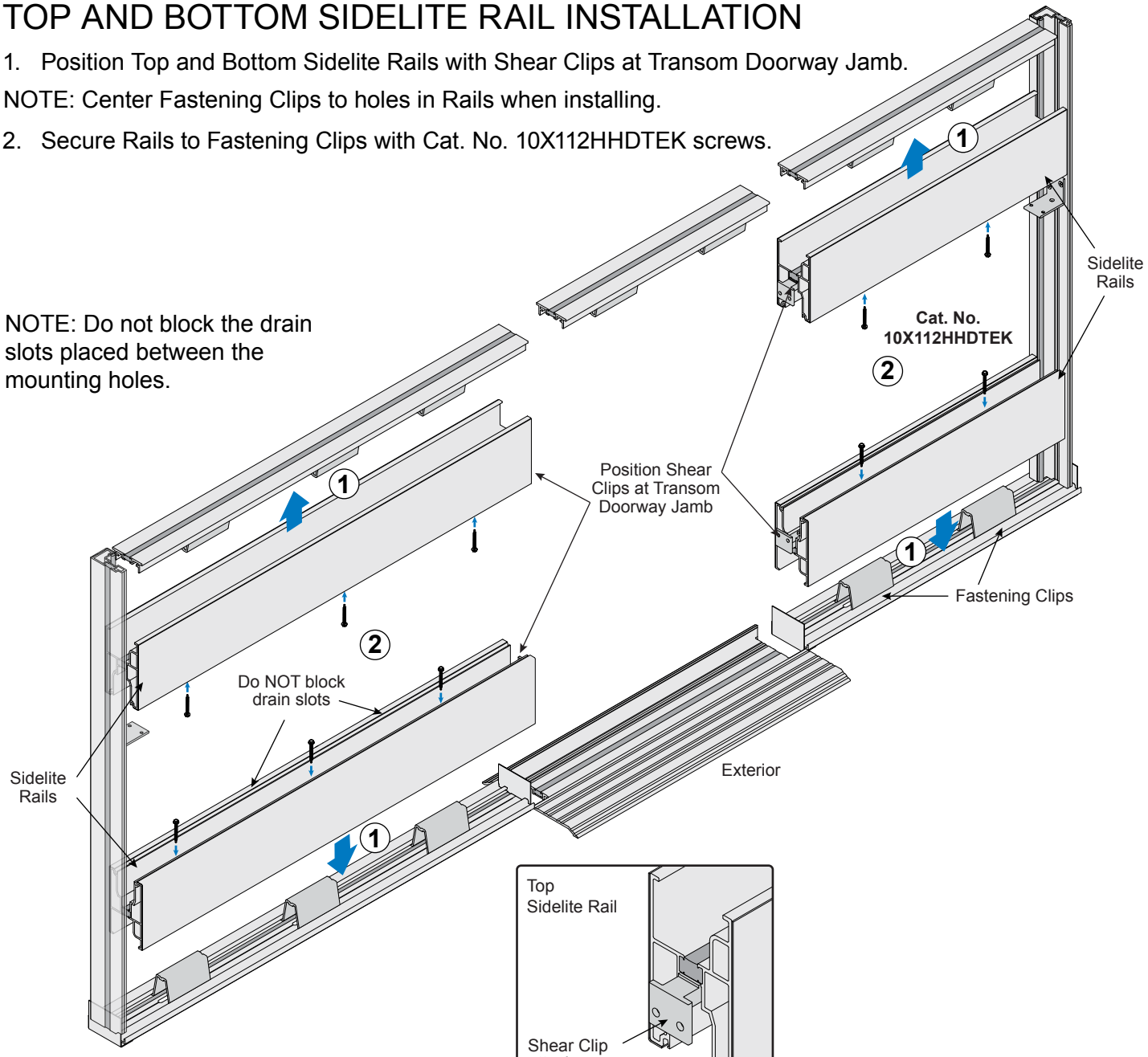
TOP AND BOTTOM SIDELITE RAIL INSTALLATION

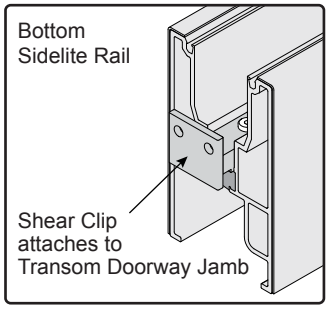
1. Position Top and Bottom Sidelite Rails with Shear Clips at Transom Doorway Jamb.

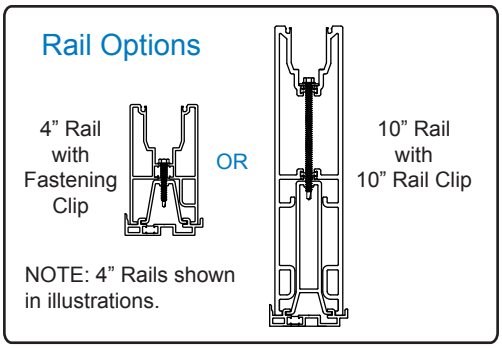
NOTE: Center Fastening Clips to holes in Rails when installing.

2. Secure Rails to Fastening Clips with Cat. No. 10X112HHDTEK screws.

NOTE: Do not block the drain slots placed between the mounting holes.



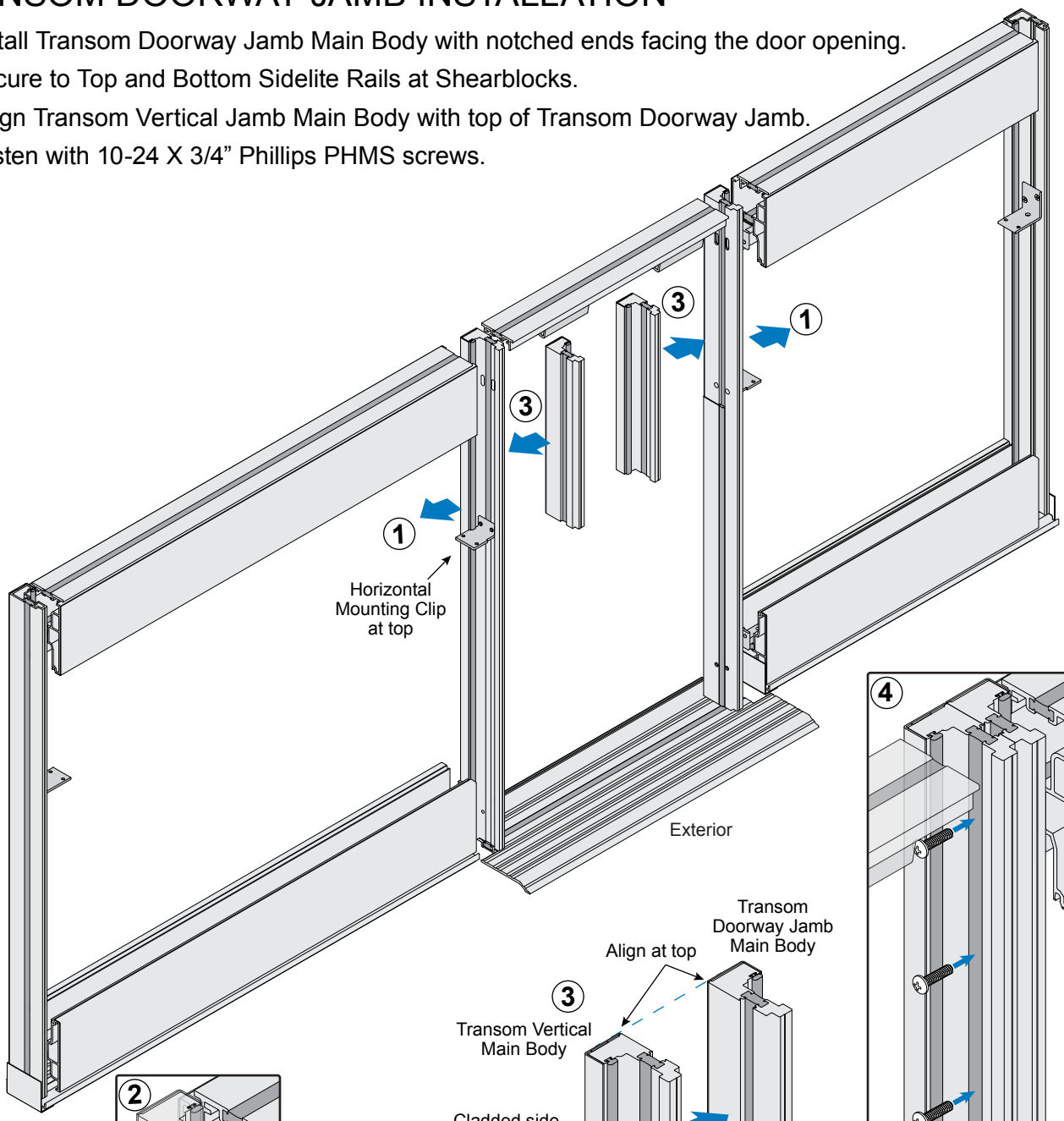




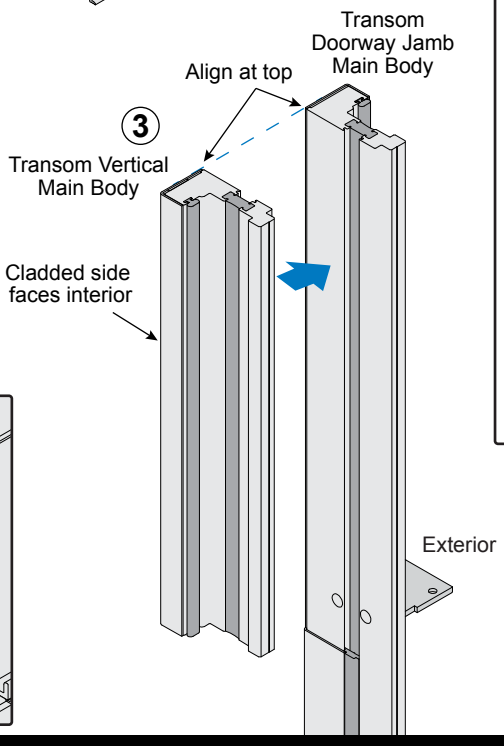
NOTE: Shear Clips also act as spacers for cladding. These clips are used only where the Rail butts against a Doorway Jamb.

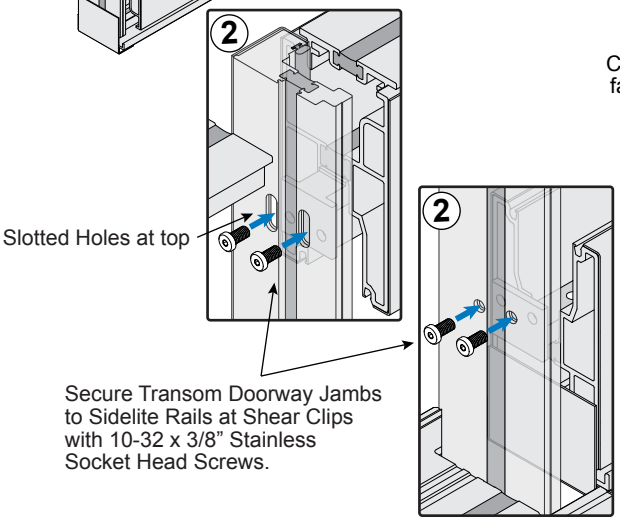
TRANSOM DOORWAY JAMB INSTALLATION

1. Install Transom Doorway Jamb Main Body with notched ends facing the door opening.
2. Secure to Top and Bottom Sidelite Rails at Shearblocks.
3. Align Transom Vertical Jamb Main Body with top of Transom Doorway Jamb.
4. Fasten with 10-24 X 3/4” Phillips PHMS screws.



Secure with 10-24 X 3/4” PHMS Screws.





INTERMEDIATE VERTICAL MULLION INSTALLATION

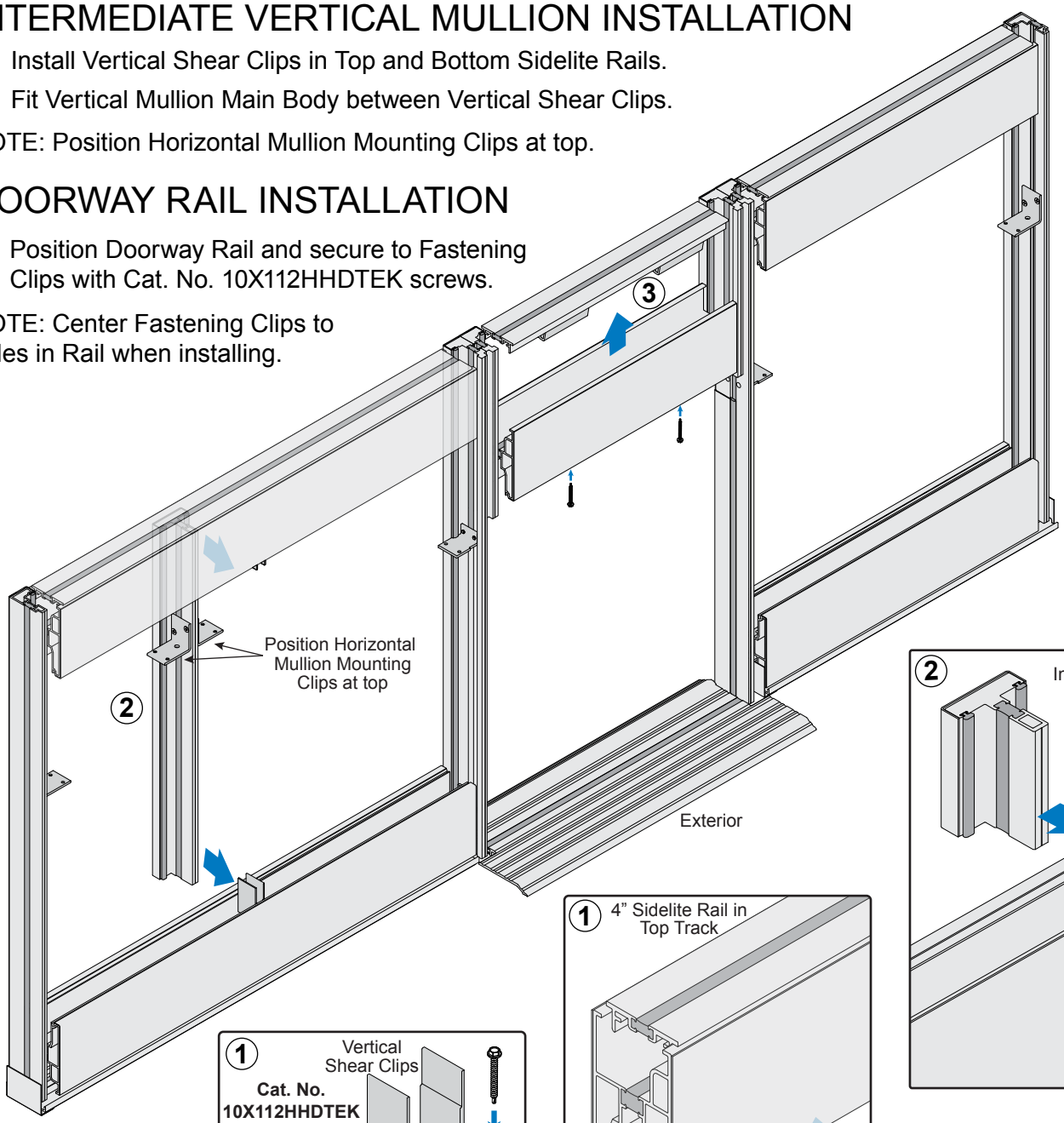
1. Install Vertical Shear Clips in Top and Bottom Sidelite Rails.
2. Fit Vertical Mullion Main Body between Vertical Shear Clips.

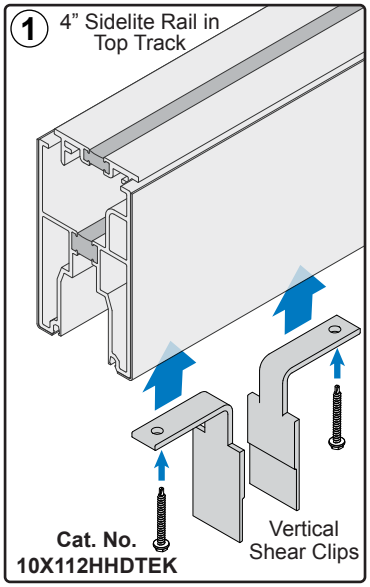
NOTE: Position Horizontal Mullion Mounting Clips at top.

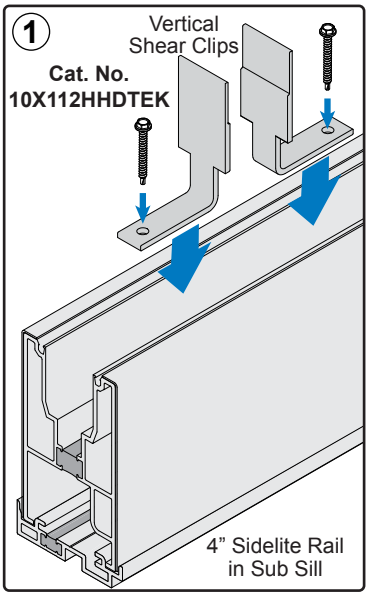
DOORWAY RAIL INSTALLATION

3. Position Doorway Rail and secure to Fastening Clips with Cat. No. 10X112HHDTEK screws.

NOTE: Center Fastening Clips to holes in Rail when installing.

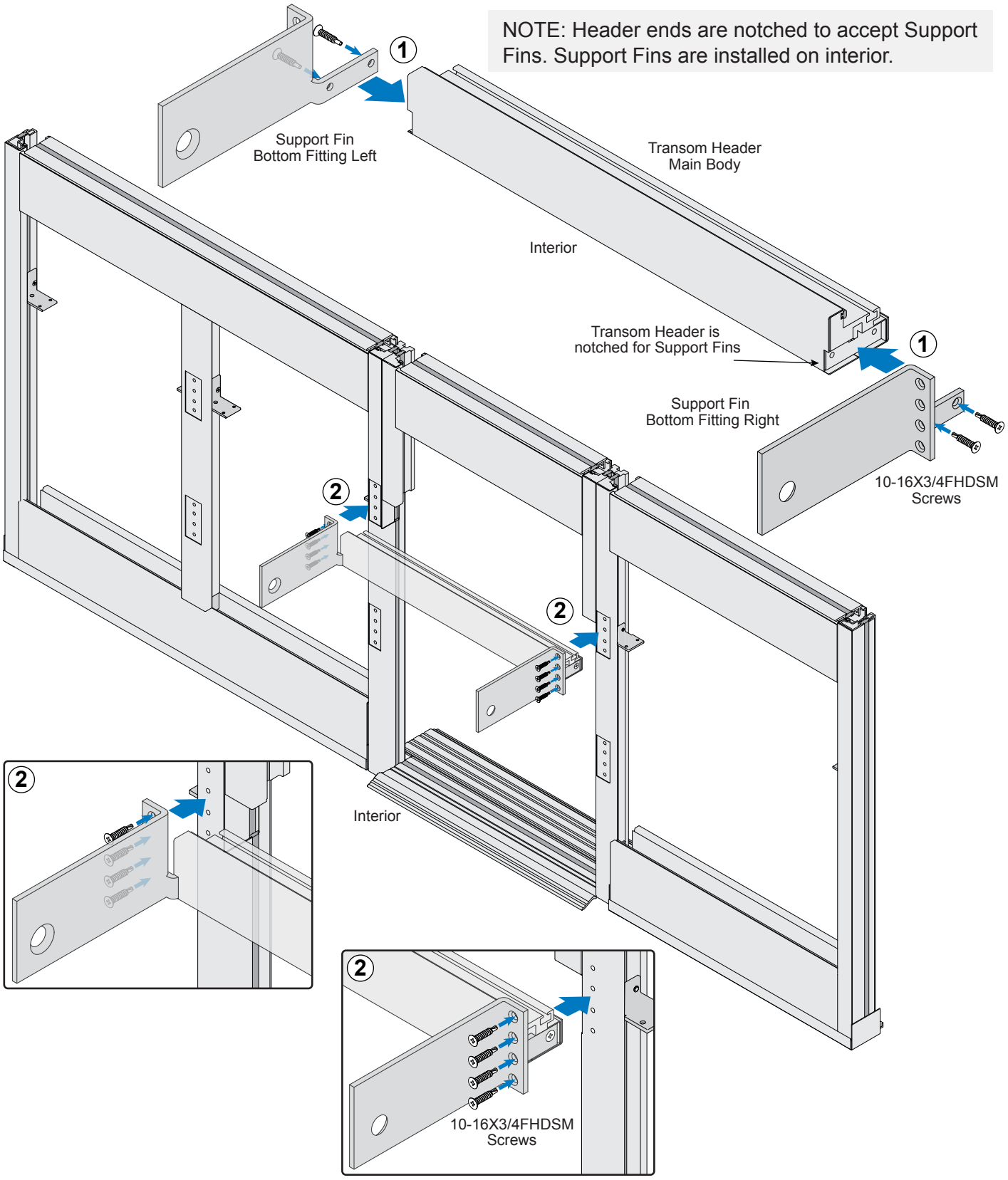






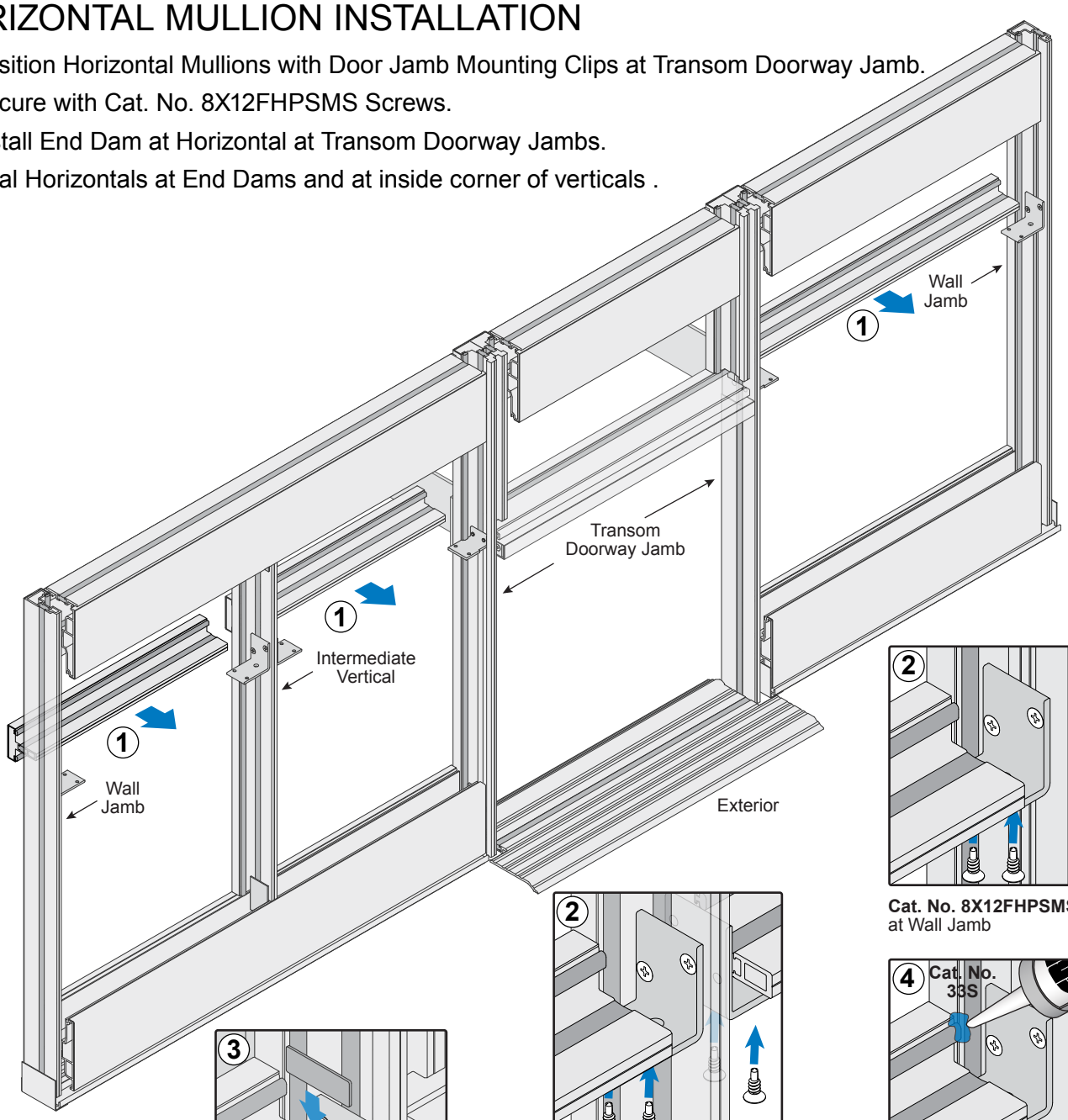
TRANSOM HEADER INSTALLATION

1. Attach Left and Right Support Fin Bottom Fittings to each end of Transom Header Main Body.
2. Match holes on Transom Doorway Jambs with holes of Support Fin Fitting and secure with screws.



HORIZONTAL MULLION INSTALLATION

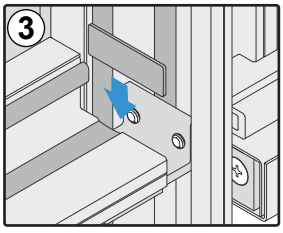
1. Position Horizontal Mullions with Door Jamb Mounting Clips at Transom Doorway Jamb.
2. Secure with Cat. No. 8X12FHPSMS Screws.
3. Install End Dam at Horizontal at Transom Doorway Jambs.
4. Seal Horizontals at End Dams and at inside corner of verticals .



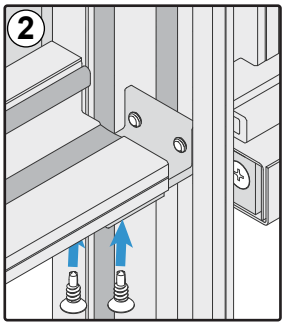
Cat. No. 8X12FHPSMS
at Wall Jamb

Cat. No. 8X12FHPSMS
at Intermediate Vertical

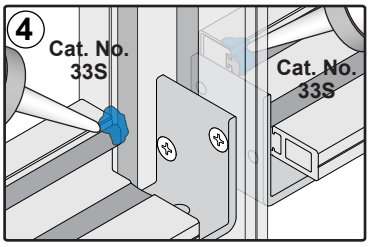
Silicone at Wall Jamb



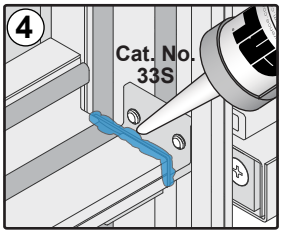
End Dam at Transom Doorway Jamb



Cat. No. 8X12FHPSMS
at Transom Doorway Jamb



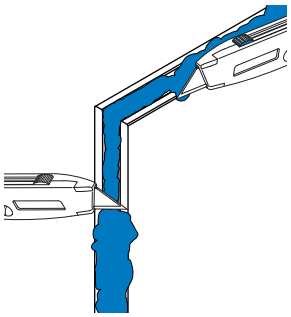
Silicone at Intermediate Vertical



Silicone at Transom Doorway Jamb

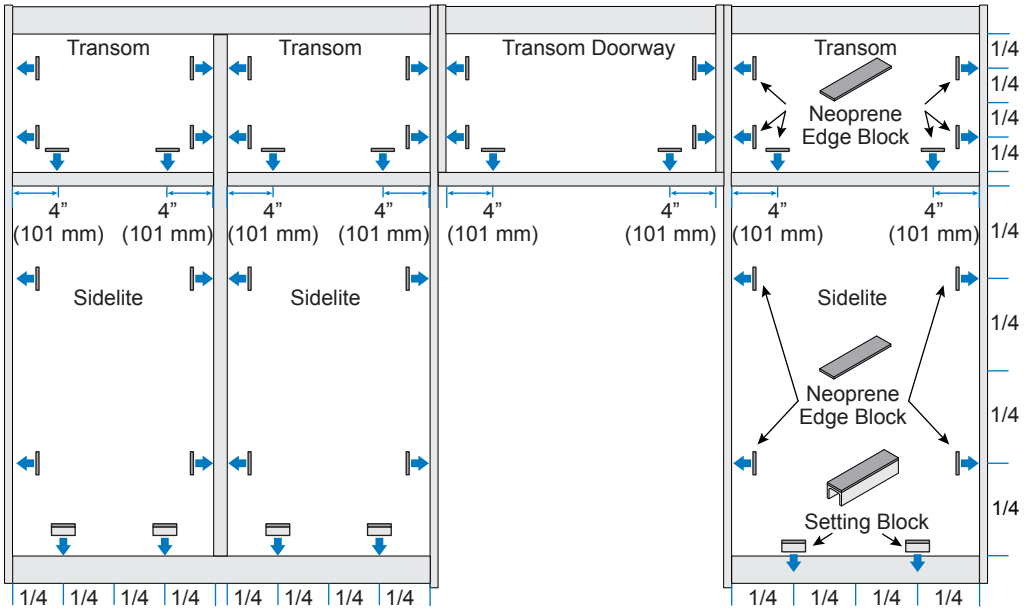
SIDELITE AND TRANSOM GLASS INSTALLATION

1 Prepare Glass Panels.

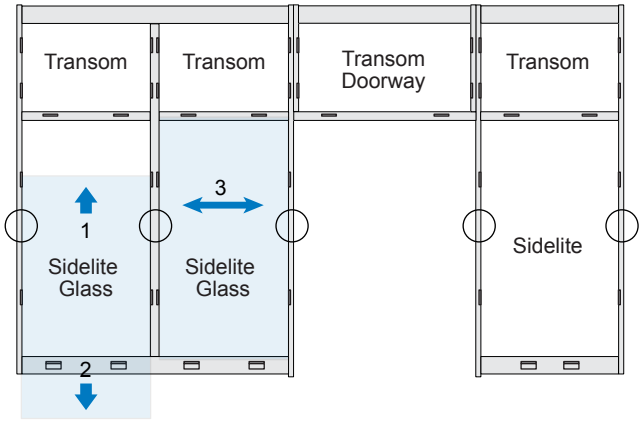


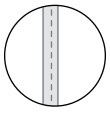
Trim edges of the glass at face and sides with a sharp utility knife to remove any excess Silicone Sealant.

2 Install Setting and Edge Blocks.



3 Install Sidelite Glass.



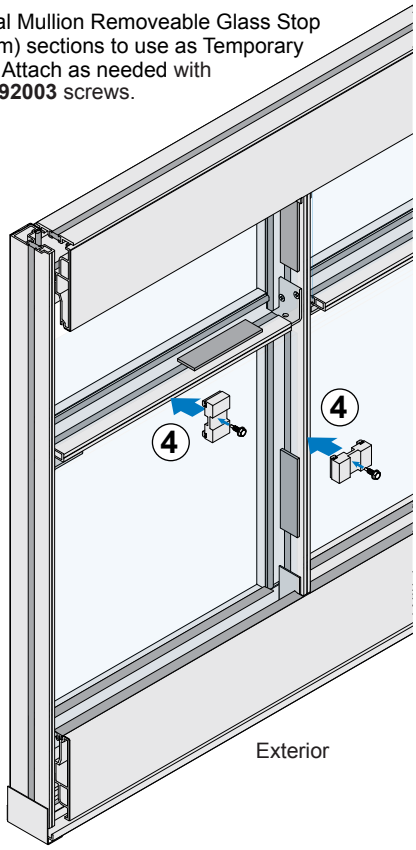


1/2" (5 mm) Minimum Glass Bite CRITICAL

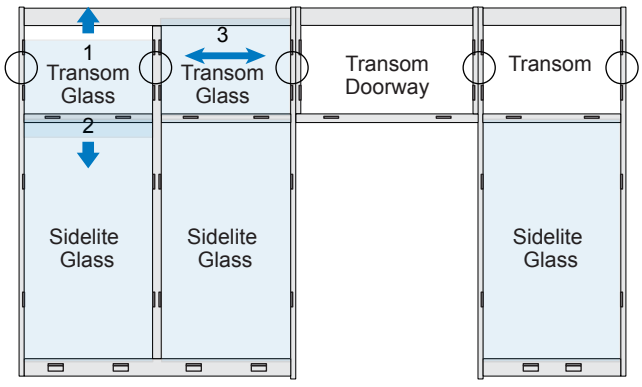
Lift and set each Sidelite Glass panel into Bottom Rail. Center between verticals with at least 1/2" (5 mm) Glass Bite on each side.

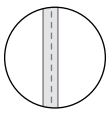
4 Install Temporary Glass Stops.

Cut Horizontal Mullion Removeable Glass Stop into 1" (25 mm) sections to use as Temporary Glass Stops. Attach as needed with **Cat. No. 20092003** screws.



5 Install Transom Glass.



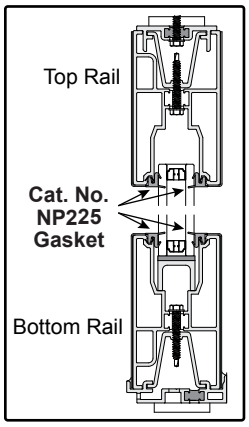


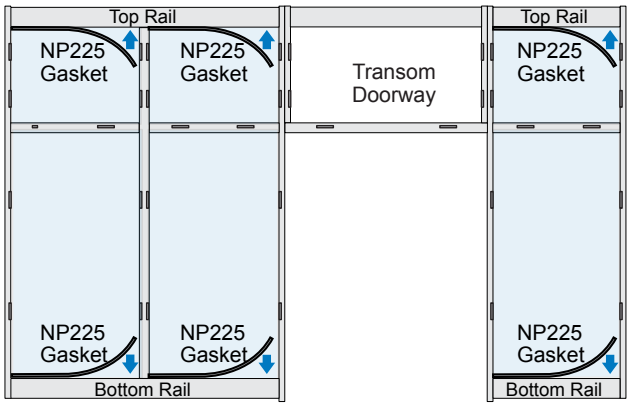
1/2" (5 mm) Minimum Glass Bite CRITICAL

Lift Transom Glass panel into Top Rail and set on Horizontal Mullion. Center between verticals with at least 1/2" (5 mm) Glass Bite on each side.

SIDELITE AND TRANSOM GLASS INSTALLATION (CONTINUED)

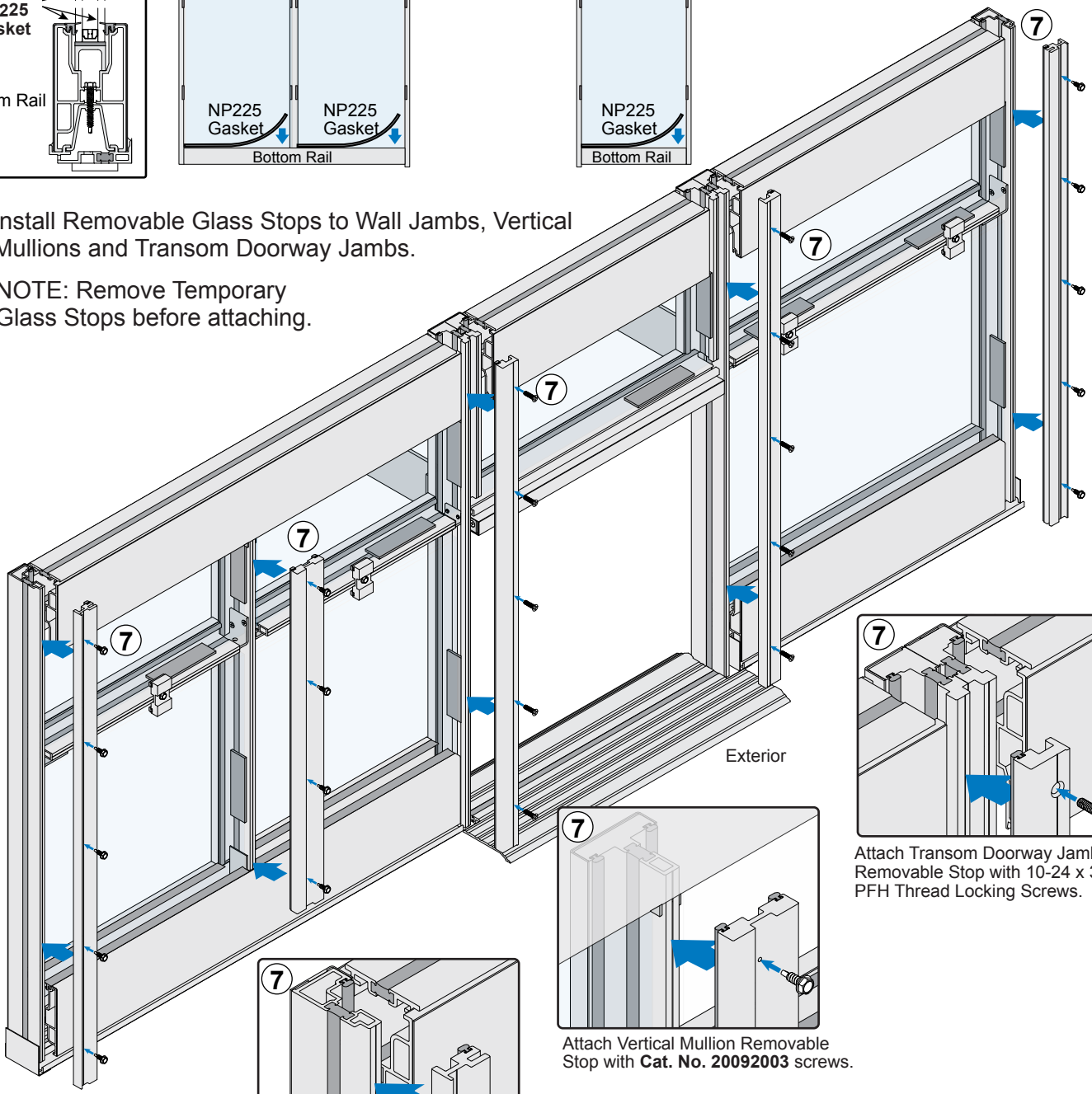
⑥ Role NP225 Gaskets in both sides of Top and Bottom Rails.





⑦ Install Removable Glass Stops to Wall Jambs, Vertical Mullions and Transom Doorway Jambs.

NOTE: Remove Temporary Glass Stops before attaching.



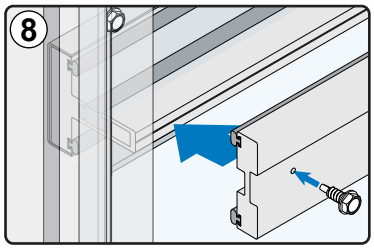
Attach Transom Doorway Jamb Removable Stop with 10-24 x 3/4" PFH Thread Locking Screws.

Attach Vertical Mullion Removable Stop with **Cat. No. 20092003** screws.

Attach Wall Jamb Removable Stop with **Cat. No. 20092003** screws.

SIDELITE AND TRANSOM GLASS INSTALLATION (CONTINUED)

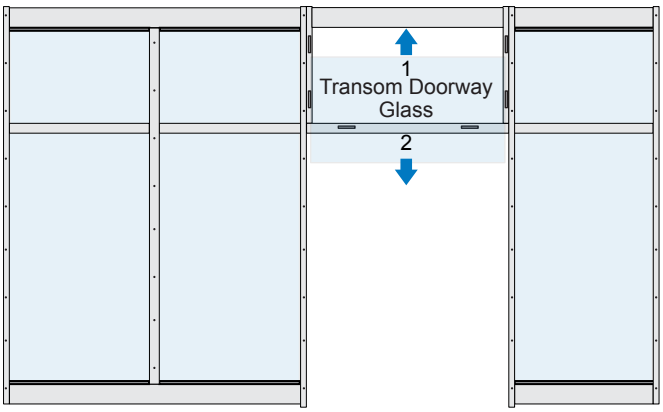
⑧ Install Removable Glass Stops to Horizontal Mullions.
NOTE: Remove Temporary Glass Stops before attaching.

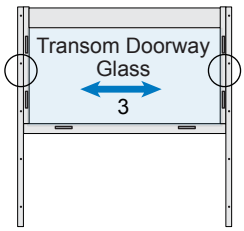


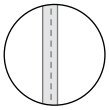
Attach Horizontal Mullion Removable Stops with **Cat. No. 20092003** screws.

TRANSOM DOORWAY GLASS INSTALLATION

⑨ Install Transom Doorway Glass.





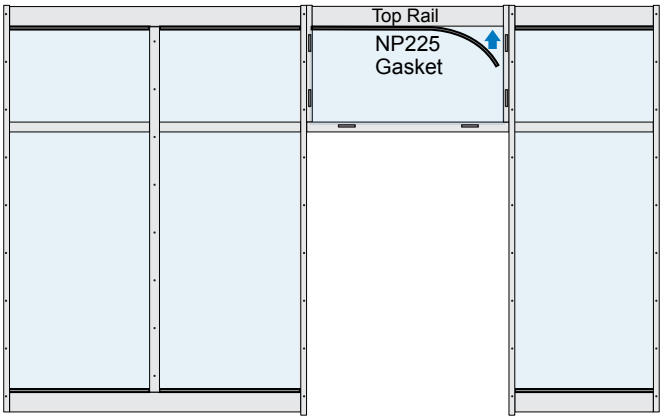


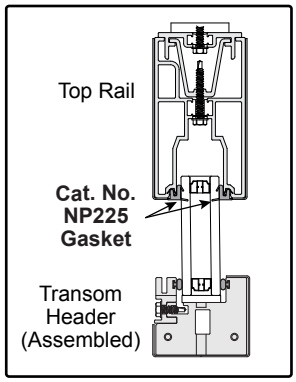
1/2” (5 mm)
Minimum Glass Bite
CRITICAL

Lift Transom Doorway Glass into Top Rail and set on Transom Header. Center between verticals with at least 1/2” (5 mm) Glass Bite on each side.

TRANSOM DOORWAY GLASS INSTALLATION (CONTINUED)

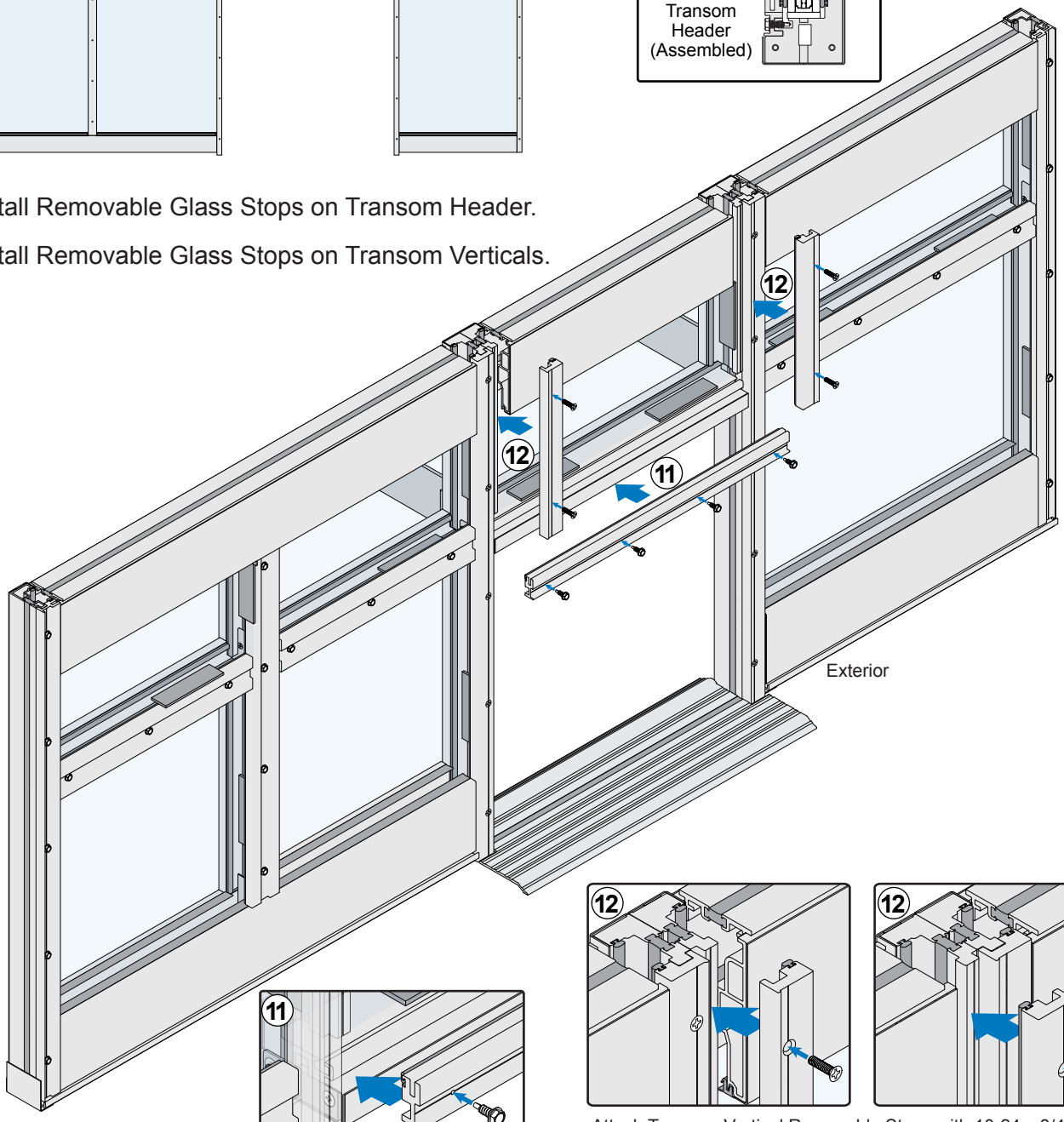
⑩ Role NP225 Gaskets in both sides of Top Rail.





⑪ Install Removable Glass Stops on Transom Header.

⑫ Install Removable Glass Stops on Transom Verticals.



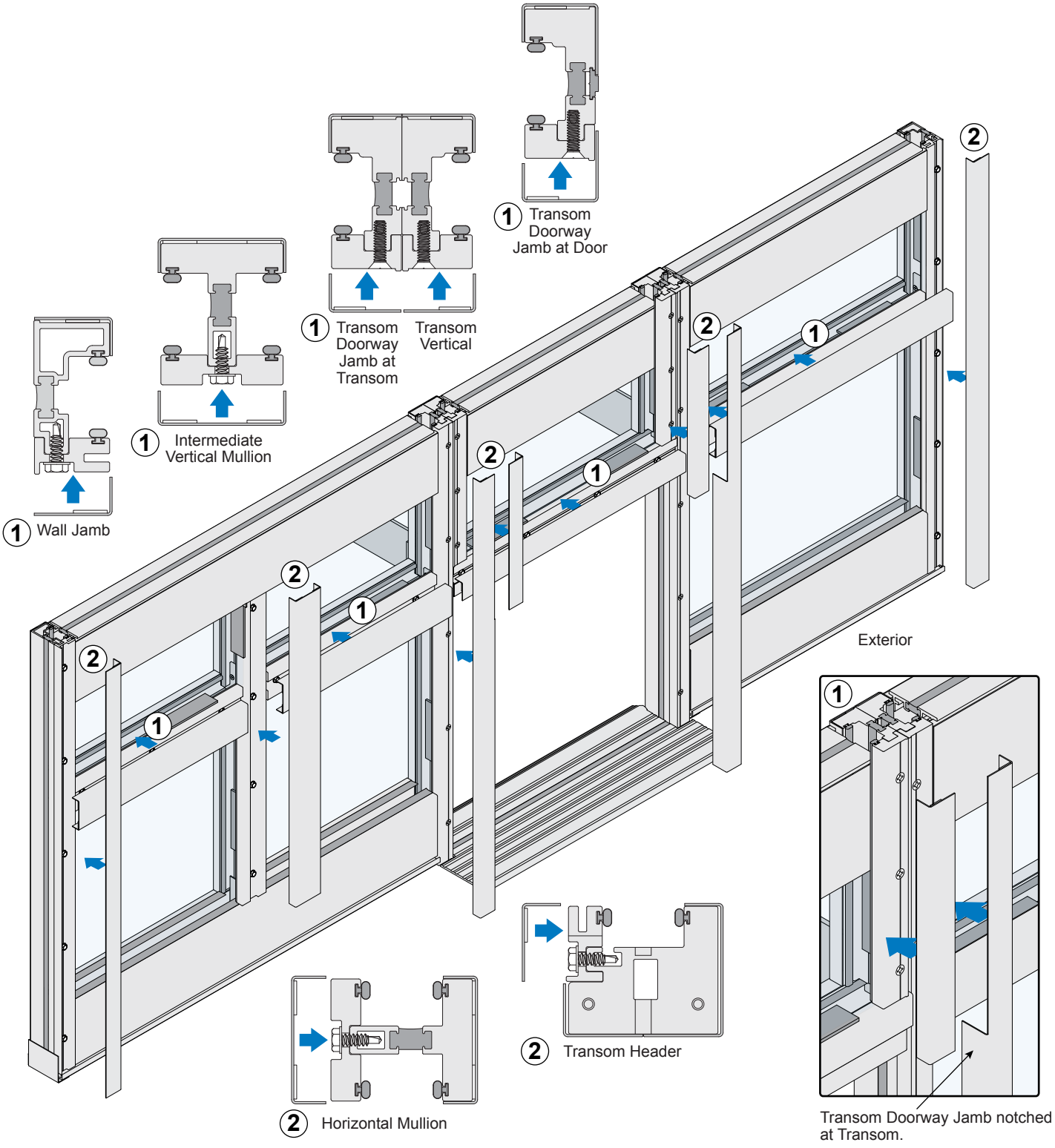
Attach Transom Header Removable Stop with **Cat. No. 20092003** screws.

Attach Transom Vertical Removable Stops with 10-24 x 3/4" PFH Thread Locking Screws.

CLADDING INSTALLATION

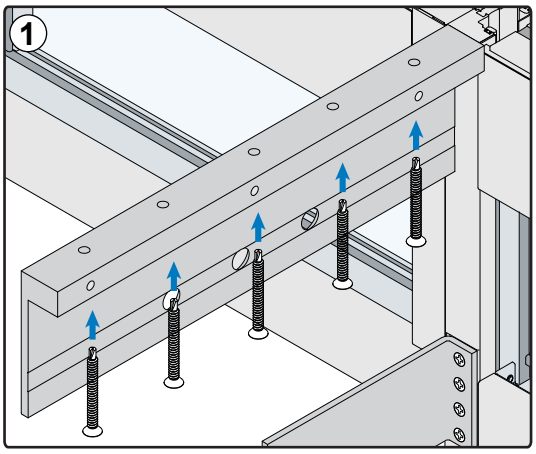
1. Install Horizontal Clad.
2. Install Vertical Clad.

NOTE: Remove liner from VHB Tape to apply Cladding. Roll On Pressure = 15 Pounds Per Linear Inch.



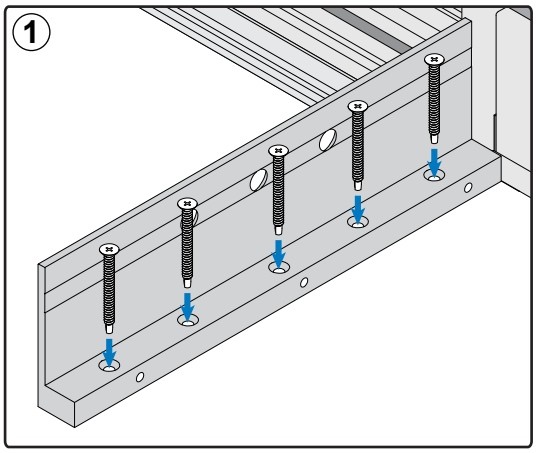
SUPPORT FIN INSTALLATION

1. Attach Top and Bottom Fin Mounting Brackets.
2. Attach Mid Fin Mounting Brackets with Spacers.

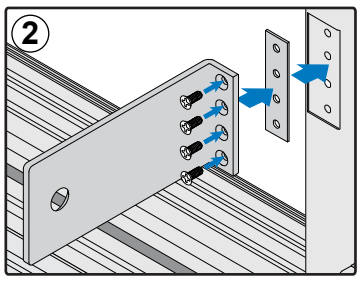


Attach Top Fin Mounting Bracket with 1/4” Flat Head Screws suitable for substrate.

Interior



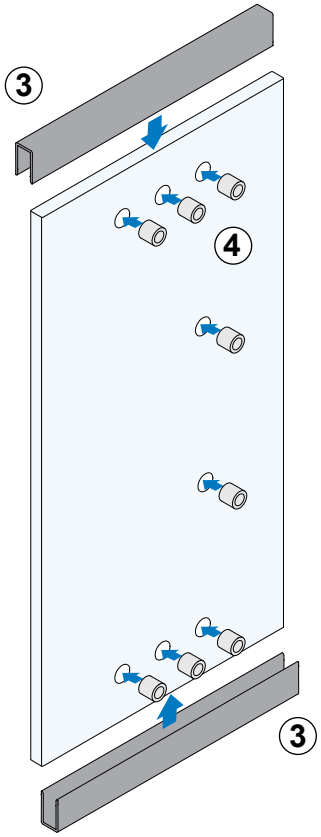
Attach Bottom Fin Mounting Bracket with 1/4” Flat Head Screws suitable for substrate.

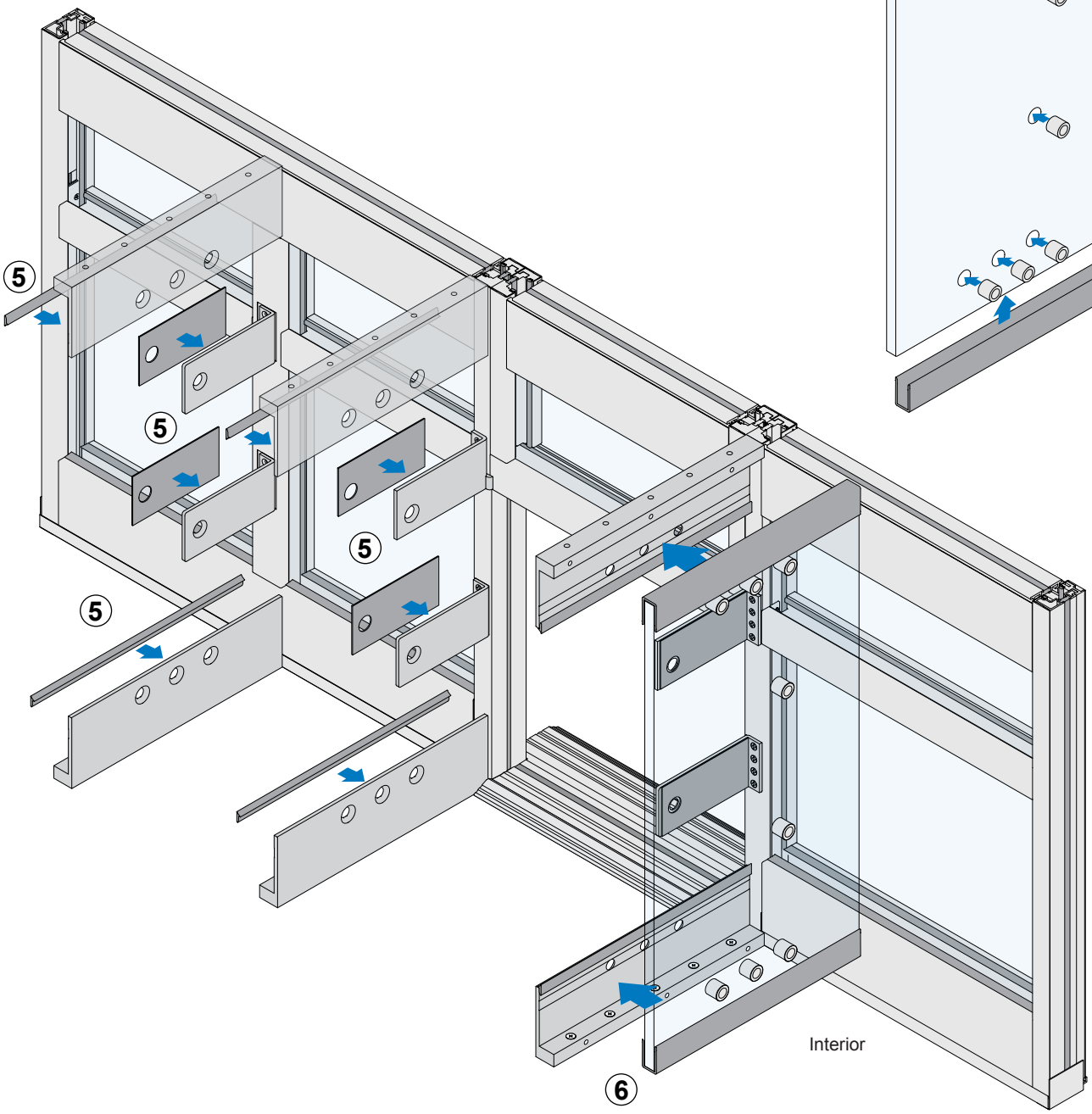


Attach Mid Fin Mounting Bracket with spacer and #10-24 x 1/2” Phillips Thread-Locking Flat Head Screws

SUPPORT FIN INSTALLATION (CONTINUED)

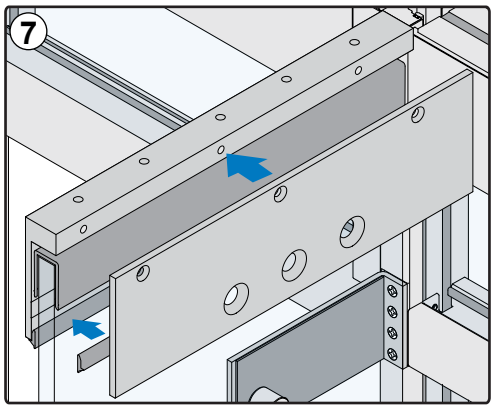
3. Fit Gasket on top and bottom Fin Glass.
4. Place Plastic Gromet in each hole.
5. Place Gasket on Mounting Brackets.
6. Install Fin Glass.



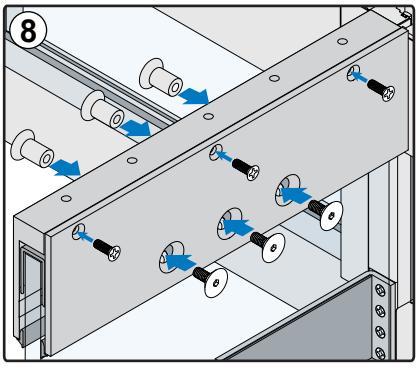


SUPPORT FIN INSTALLATION (CONTINUED)

7. Place Top and Bottom Fin Clamping Plates with Gaskets.
8. Secure with screws and Sex Bolts.
9. Place Mid Fin Clamping Plates with Gaskets.
10. Install Sex Bolts to secure.



Place Top and Bottom Fin Clamping Plates with Gaskets. (Top Fin shown)



Secure with 1/4" - 28 x 3/4" SS FHPMS and Sex Bolts.

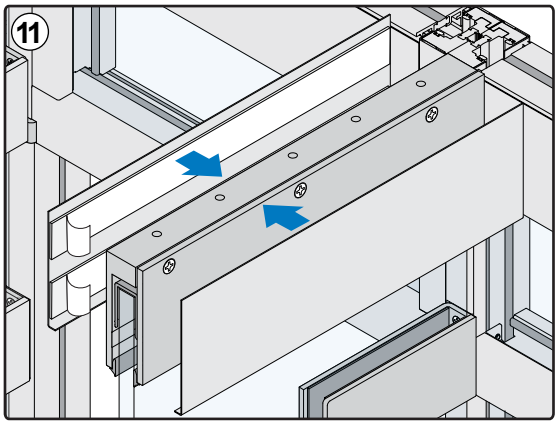
Place Mid Fin Clamping Plate and Gasket.

Secure with Sex Bolts.

SUPPORT FIN COVER INSTALLATION

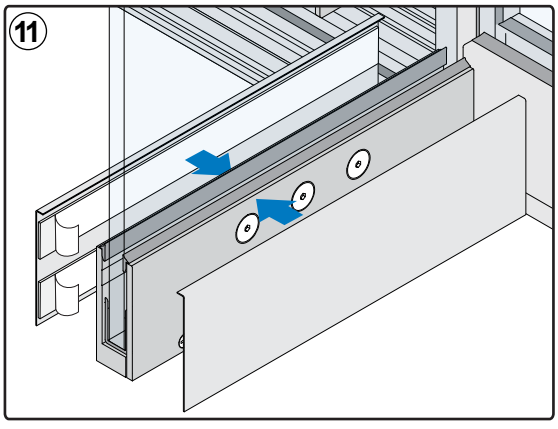
(11) Remove liner from VHB Tape and apply Covers for Top and Bottom Fin Mounts.

(12) Remove liner from VHB Tape and apply Covers for Mid Fin Mounts.

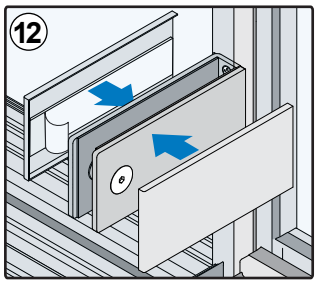


Install Top Fin Mount Covers.

Interior



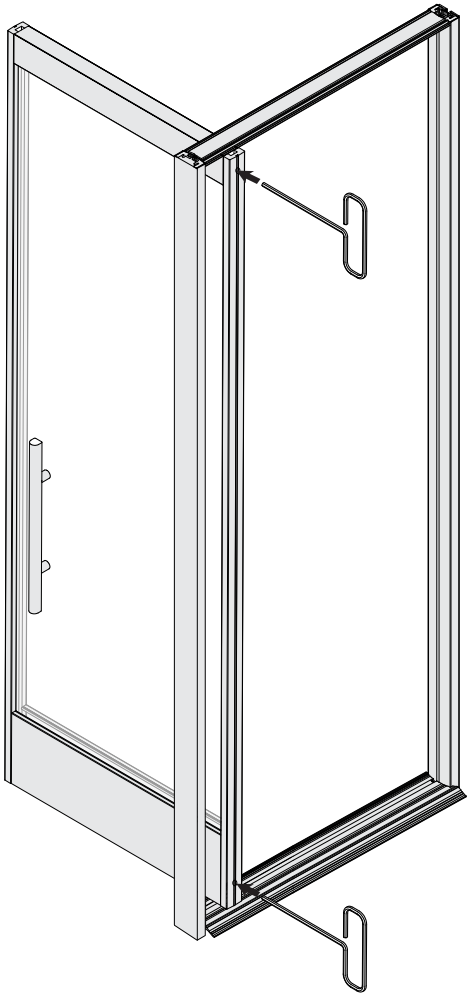
Install Bottom Fin Mount Covers.

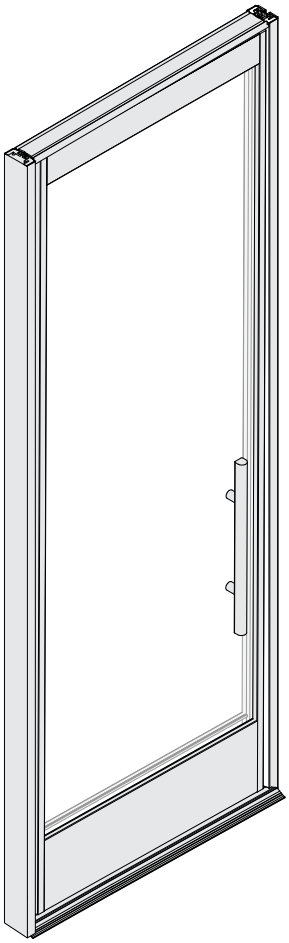


Install Mid Fin Mount Covers.

DOOR INSTALLATION

The doors for the Entice System are shipped fully assembled. Because of the weight of both the aluminum and the glass, it is advisable that two individuals are involved in moving and installing this door.
NOTE: Installation varies with hardware selection. Consult Installation Instructions in hardware packages.





Use included T-Handle Key to turn the adjustment screws on the top and bottom of the hinge side of the door.

With the door open, turn clockwise to adjust the Door Rail away from the jamb and counter-clockwise to adjust the Door Rail towards the jamb. Make sure the gaps are parallel and the correct size.

NOTE: A slight clicking noise may be heard. This sound is caused by our friction retention mechanism that will help prevent the screw from loosening out of alignment.

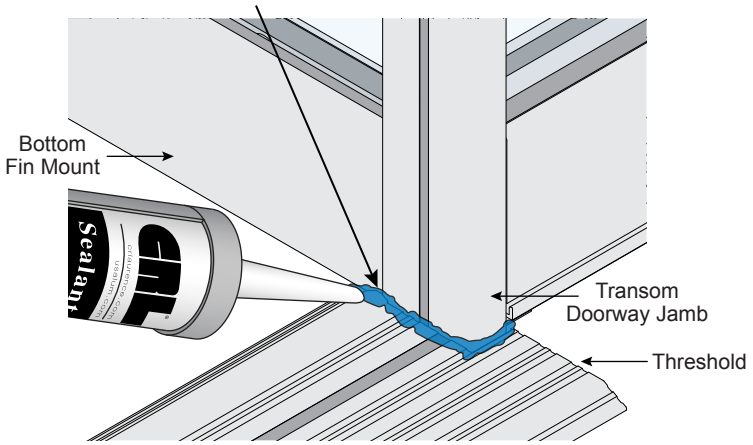
CENTER PIVOT DOORS:

To center the door, loosen the two Pan Head Phillips Screws holding the arm to the block, then adjust the two hex bolts at the end of each arm to slightly change the angle of the arm as it mounts in the Door Rail. Make sure that both hex bolts are tightened against the inside face of the Door Rail, and the two Pan Head Phillips Screws are tightened to the block when adjustment is complete to secure the adjustments into place.

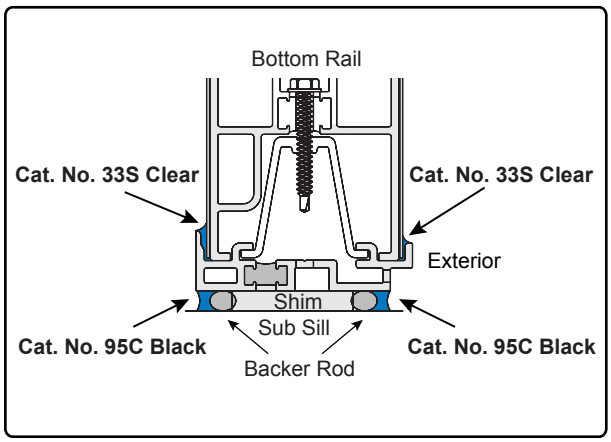
PERIMETER SEALING

1. Seal around Transom Doorway Jamb at Threshold.

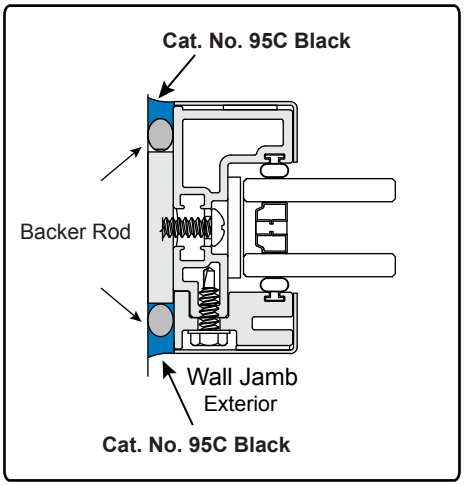
   Seal around Transom Doorway Jamb at notched Threshold with **Cat. No. 33S Clear Silicone**.



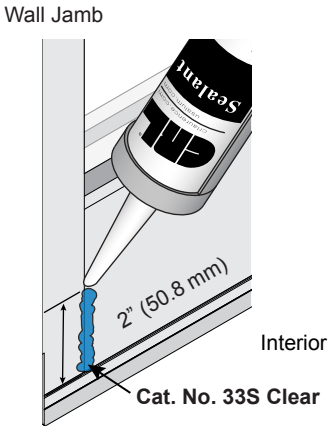
2. Seal joints between Bottom Rail and Sub Sill inside and outside.



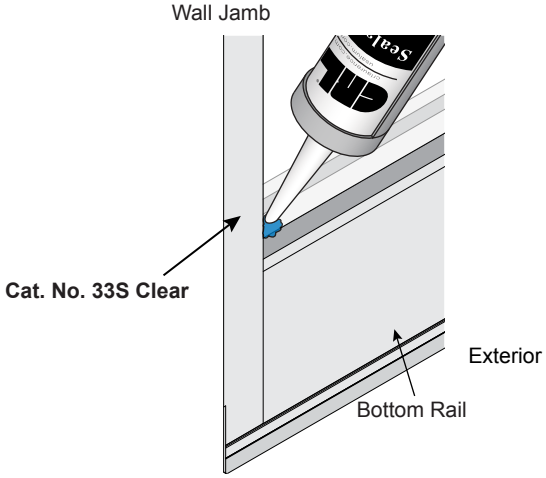
3. Install Backer Rod and seal perimeter with **Cat. No. 95C** Silicone Sealant at all shimmed areas inside and outside.

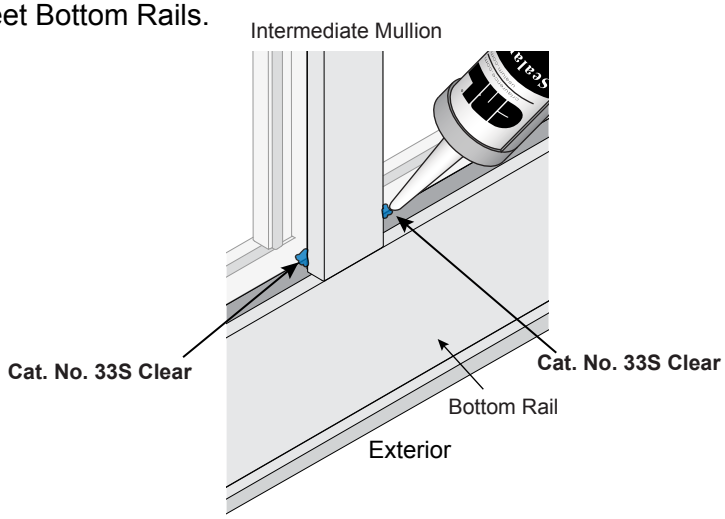


4. Seal interior perimeter at all verticals 2” (203 mm) up from ground where they meet Bottom Rails.



5. Seal outside bottom corners where all verticals meet Bottom Rails.

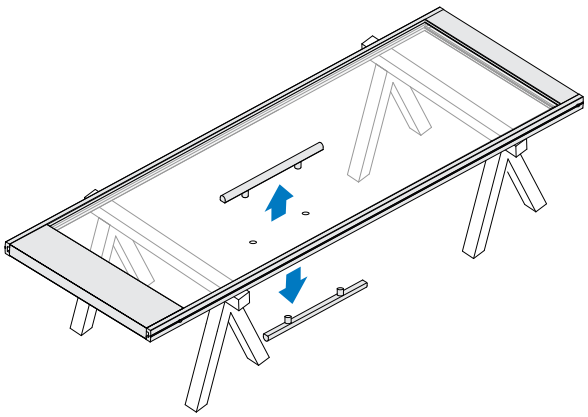




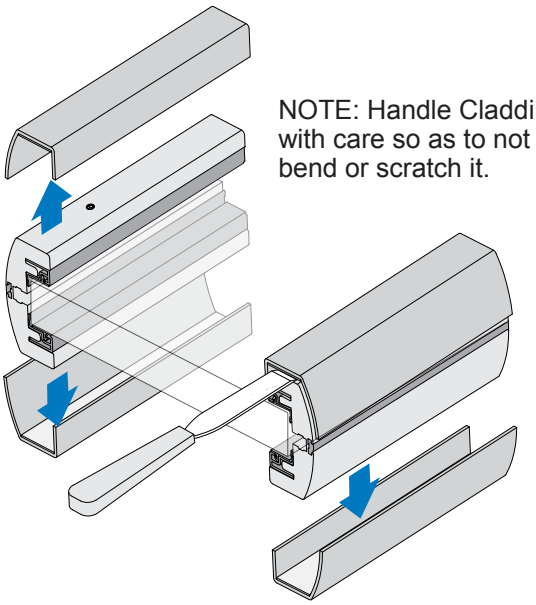
GLASS REPLACEMENT FOR DOORS

REMOVE DAMAGED GLASS

Support door on sturdy sawhorses.

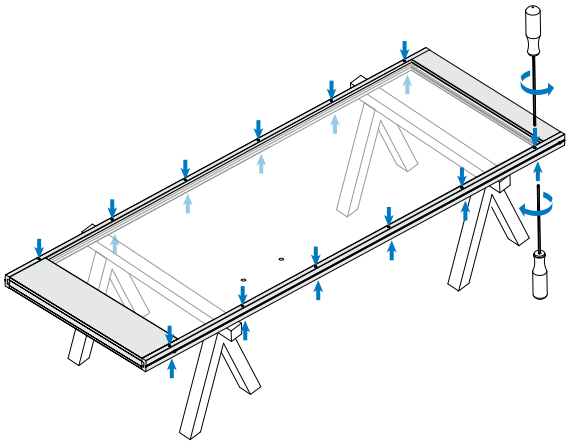


Remove door handles and panic or exit devices and store in a safe place.

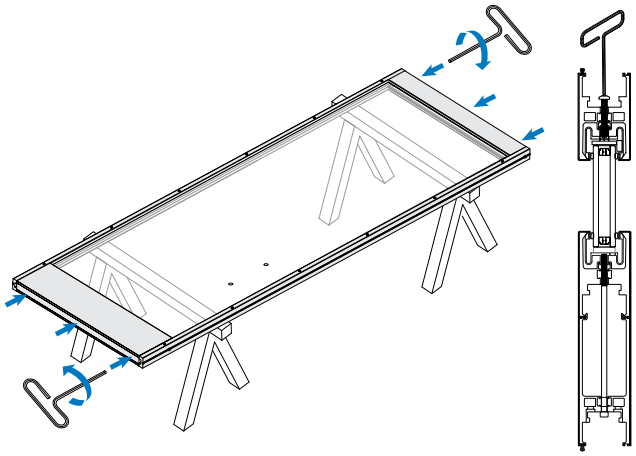


NOTE: Handle Cladding with care so as to not bend or scratch it.

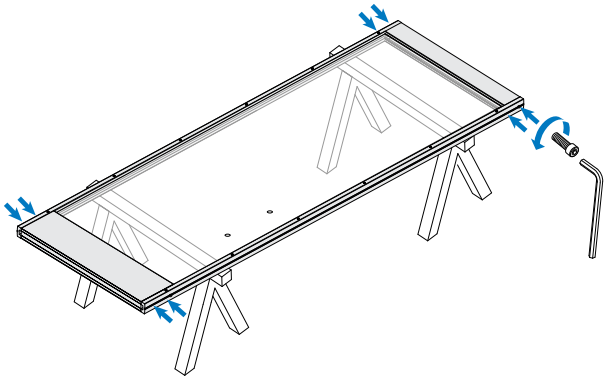
Remove Cladding from both sides of Vertical Stiles.



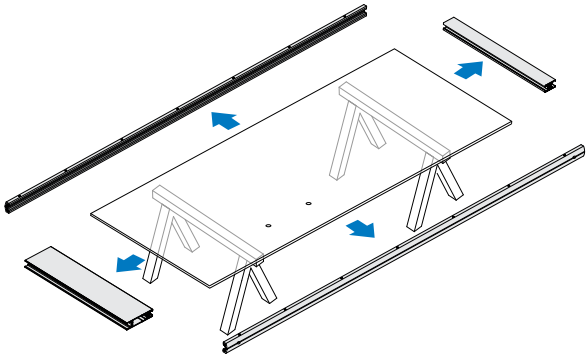
Loosen Set Screws on both sides of Vertical Stiles.



Back out Clamping Screws on Top and Bottom Rails.

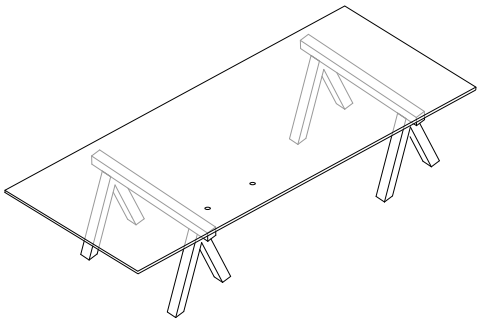


Remove Socket Head Cap Screws from each corner.

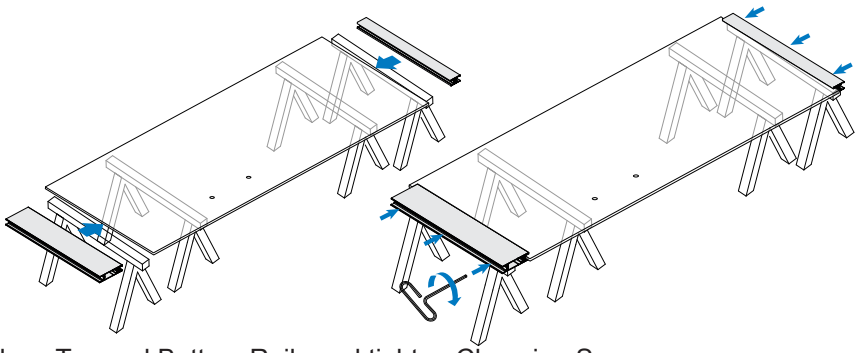


Remove Vertical Stiles and Top and Bottom Rails. If Gaskets are not in good condition, remove them. If replacing Top and Bottom Rail Cladding, do so now.

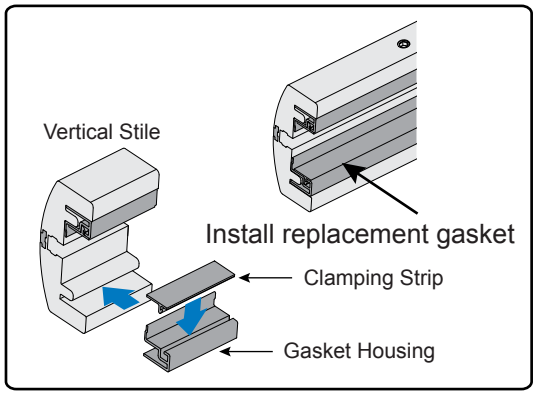
INSTALL REPLACEMENT GLASS



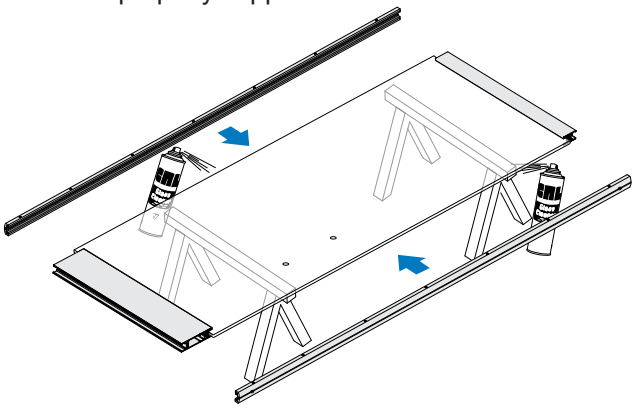
Verify replacement glass size and mounting hole placement for handles.



Place Top and Bottom Rails and tighten Clamping Screws.
NOTE: Ensure Rails are properly supported until secured to Vertical Stiles.

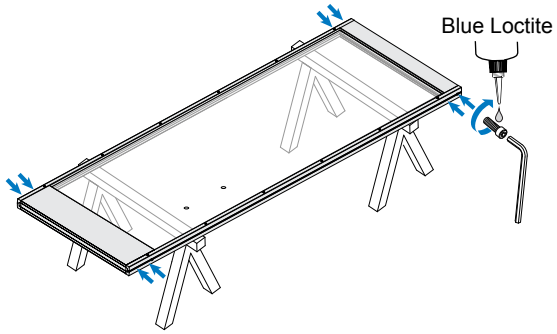


Replace Gaskets in Vertical Stiles if needed.

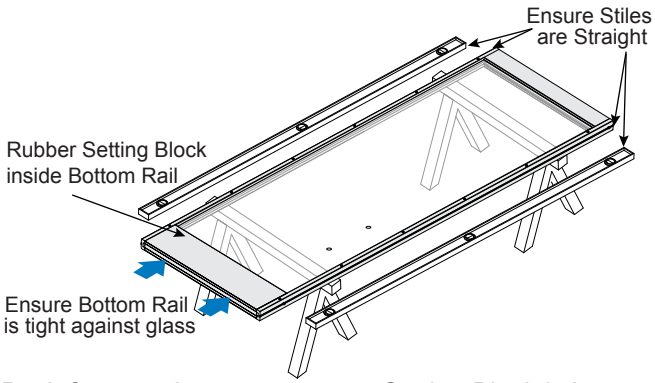


Spray glass edges with **Cat. No. 1973** to prevent Gaskets from binding and install Vertical Stiles.

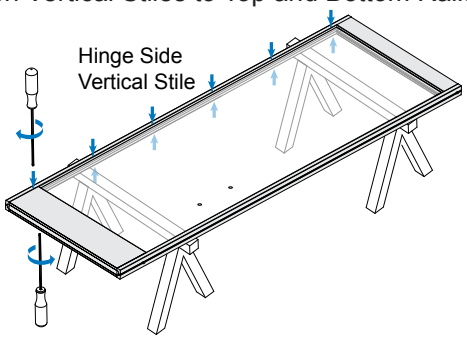
NOTE: The Vertical Stiles may be installed as three separate pieces. First apply the Clamping Strip to the glass, then fit the Gasket Housing over it and finally slide the Vertical Stile over it. This works well with oversized glass thickness.



Apply Blue Loctite to Socket Head Cap Screws and fasten Vertical Stiles to Top and Bottom Rails.

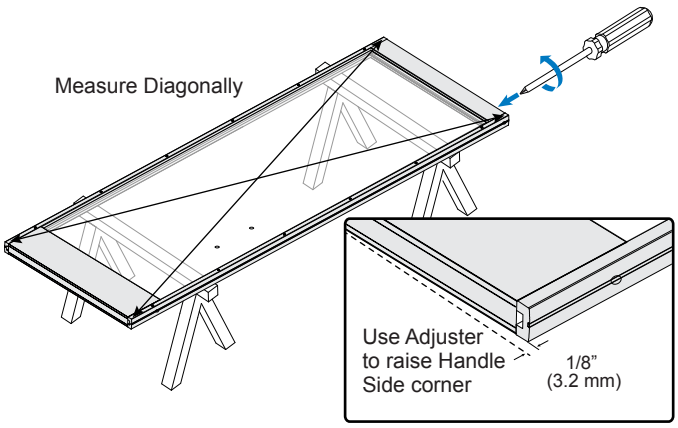


Push frame at bottom to ensure Setting Block is in contact with glass. Ensure Bottom Rail is tight against glass and Vertical Stiles are straight.

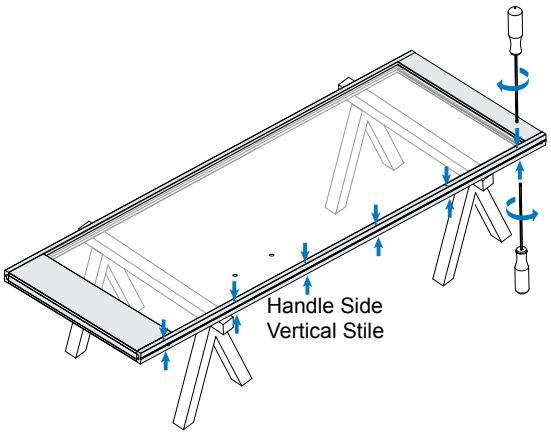


Tighten Set Screws evenly on Hinge Side of the Vertical Stiles. Torque 1/8 turn past tight.

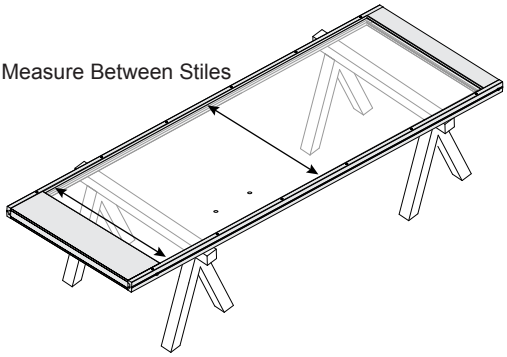
INSTALL REPLACEMENT GLASS (CONTINUED)



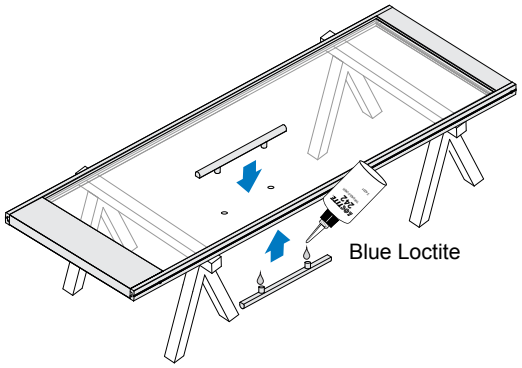
Turn Adjuster in Top Rail on Handle Side clockwise until it contacts glass. Measure diagonally to corners. If needed, turn Adjuster again to raise corner a maximum of 1/8" (3.2 mm) until door is square.



Tighten Set Screws evenly on Handle Side of the Vertical Stiles. Torque 1/8 turn past tight.

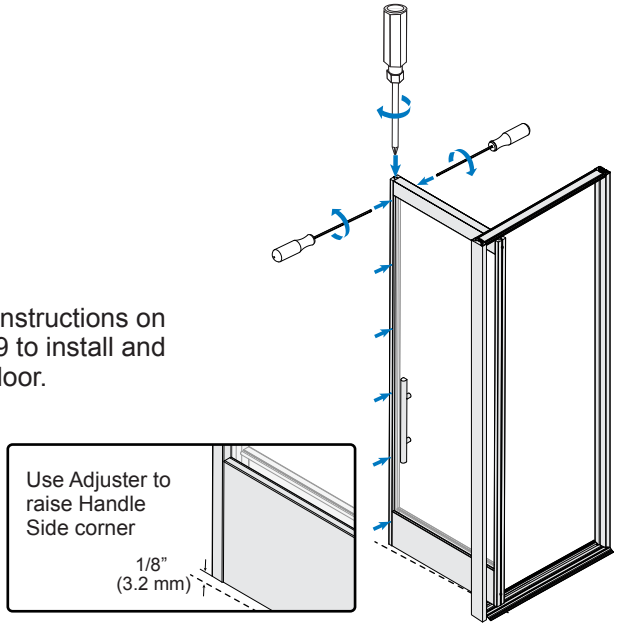


Measure between Vertical Stiles near Bottom Rail and again at middle to ensure Stiles are straight.

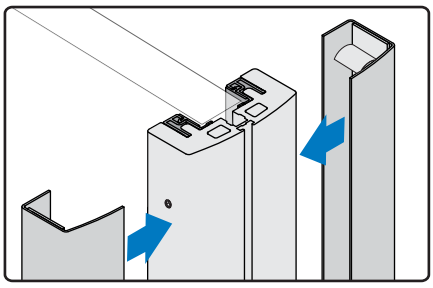


Apply Blue Loctite on all attachment fasteners and install door handles.

Follow instructions on Page 29 to install and adjust door.



NOTE: If Handle Side sags, loosen Set Screws and turn Adjuster to raise. Then tighten Set Screws.



Remove liner from VHS Tape and apply Cladding to Vertical Stiles.

Roll On Pressure = 15 Pounds Per Linear Inch