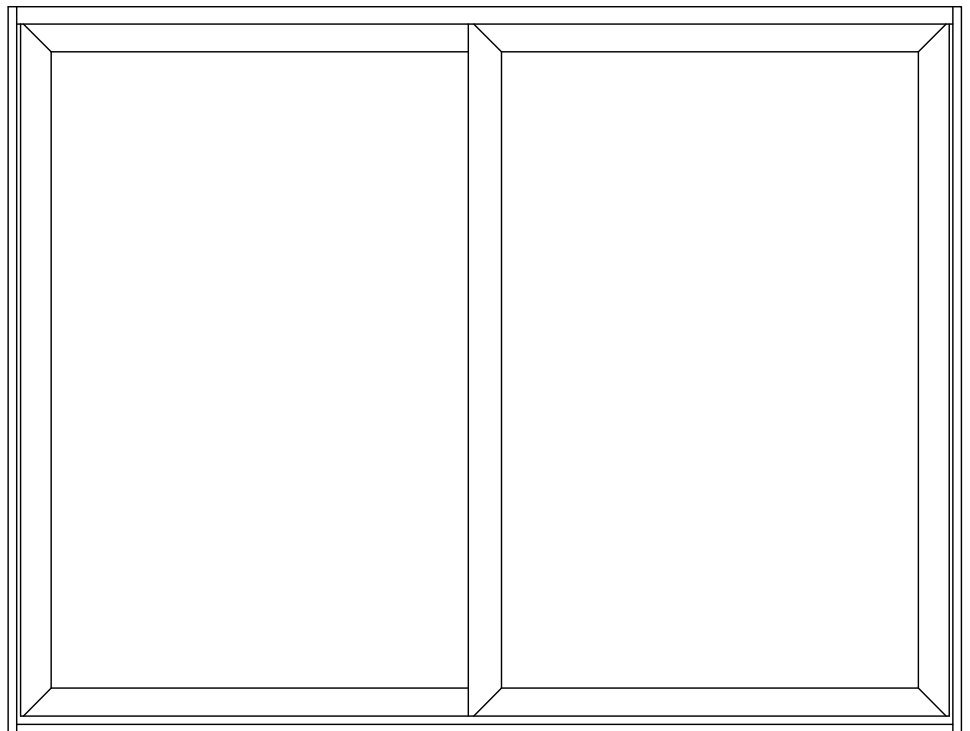


EXTERNAL ALUMINIUM INLINE SLIDING PATIO DOORS

Assembly Instructions
Bespoke and Standard Sizes



About your Inline Sliding Patio Door Set

All products must be installed in accordance with accepted good trade practice (and in accordance with supplied instructions where applicable), and maintained in accordance with these procedures or else the warranty shall be void.

Important Information

We recommend that a competent trades person installs this product. A single person must NEVER carry out the installation, as some of the components are heavy.

All of our external aluminium sliding doors and frames, powder coating finish, glazed units and hardware components are guaranteed for a full 15 years against the occurrence of manufacturing faults, all subject to correct installation, regular maintenance and care in use as detailed below.

Powder Coating Finish and Maintenance

All our aluminium sliding door sets are supplied fully powder coated in a satin finish providing a high quality and durable finish, unless otherwise stated.

Our standard range of colours are Anthracite grey RAL 7016, Jet black RAL 9005 and Gloss white. If you have selected an alternative custom colour option and require the colour and RAL code please contact us.

To maintain the external aluminium powder-coated finish, wash regularly with soapy water and then dry off with a soft lint-free cloth. As a minimum, the external surfaces must be washed at least every three months, and monthly if within five miles of the sea or in an industrial area. Our general recommendation would be to wash the external aluminium every time you clean your windows, which should normally be more regularly than the minimum requirement.

The powder coating is not guaranteed unless the doors are installed at least 800 metres away from the sea.

We cannot accept any claims for damages, including scratches to the powder coating and aluminium reported 72 hours following delivery, and / or after installation has commenced.

Installation

This door set is designed to be installed by competent trades persons with good knowledge and previous experience of installing sliding doors.

Our aluminium doors are supplied with all the essential items, most hardware factory fitted and everything pre-machined. This design allows for simple on-site assembly by experienced trades persons.

The outer frame needs to be securely fixed into the opening perfectly square and level on all planes. The aluminium sliding doors are bottom hung, the weight of the doors is supported via the sliding hardware and threshold. **Importantly: the threshold must be sufficiently packed to ensure there are no dips or rises along the full length of the bottom tracks. When fixing the frame head, ensure there is no bowing.**

Glazing Units

To reduce carbon emissions from the home and to keep heating and cooling bills down, the government has recommended that all manufacturers use a special Low E thermal glass within the sealed units to comply with Building Regulations Part L.

This glass is coated with a special substance to comply with the above and occasionally, and in certain light conditions, may produce transient visual effects, this can sometimes look like a transparent film or haze, and make the glass appear cloudy. This is very infrequent and only affects a minority of door sets. As a company, we do have to comply with the new regulations which are for the benefit of all, and this is not a defect.

Due to demands for better thermal efficiency, it is normal for condensation to form on the outside of the glazing units, to the exterior side of the property. This demonstrates that the glass is performing as it should by reducing the transfer of heat from the internal side of the property to the external side of the property, this is not a defect. For any condensation forming to the inside of the property, this is normally due to high levels of moisture in the air and / or insufficient ventilation in the room, the moisture is then forming on the cold surface. If condensation is forming inside the glazing unit (between the panes of glass) it is likely that the glazing seal has been compromised.

Tempered glass means it has been toughened to be up to five times stronger than normal glass. It is unusual to break such strong glass, but sharp objects hitting the glass at certain points can cause breakage. Tempered glass is also known as safety glass. This means that if it breaks it will shatter into smaller fragments which are less likely to cause injury, unlike non-tempered glass which breaks into large, sharp fragments.

Laminated glass is also called safety glass and comprises of multiple layers of glass sandwiched together. Due to its high strength, this prevents the glass from breaking into large pieces. If the glass breaks, it will produce a 'spider web' effect similar to what is commonly seen in shattered car windscreens. Laminated glass will also increase the sound rating insulation.

Glass must be regularly maintained and cleaned to stop break down of the glass or seals. This can be done using a mild solution such as washing-up liquid diluted in water. Do not use abrasive cleaning solutions as this may cause scratching.

Visual distortions caused by reflections in toughened glazing units are a natural phenomenon and not a fault.

Laminated, toughened or coated glass is acceptable if bubbles or blisters, fine scratches no more than 2.5cm long and / or minute particles are neither obtrusive or bunched. The glass used in sealed units is processed glass, therefore

About your Inline Sliding Patio Door Set (cont)

certain blemishes are unavoidable. More blemishes may be visible in laminated glass due to its layered construction.

For carrying out glass inspections, stand at least 3 metres away from the glazing, view at a 90 degree angle and look directly through the sealed unit(s). The glass must be viewed in natural daylight but not with the sun directly on it. Any moisture must be removed from the surface of the glass before inspecting.

Hardware Components

The exterior hardware in your sliding door set can deteriorate from everyday use, and also because of the weather and local environment. That's why regular maintenance of your door hardware is even more important if you live in severe environments like coastal / marine areas and some industrial locations.

We require that the below minimum maintenance is carried out as often as necessary to prevent deterioration. As a guideline, we recommend that this maintenance is done every three months if you live in a marine environment, or every six months if you live in a more general location, otherwise your guarantee will not be valid.

Tracks and bearings

Once your installation has been completed, and before fully operating your door set, please carefully remove any debris / swarf from the top and bottom tracks to ensure nothing comes into contact with any moving components. After cleaning the tracks, using a microfibre cloth, apply a small amount of lubricant such as a silicone spray to the inner lip of each side of the track.

Extra lubricant can be added around the bearings. Adding lubricant in this way reduces wear, improves smoothness and gives additional protection against corrosion of track and bearings.

Locks and handles

Your inline sliding door is opened and closed by raising and lowering the handle, and locked using the key. The lock should operate just as smooth with the access door in the open position as what it does when it is fully closed. It is important that if you feel any excessive resistance when operating the handle, you do not continue to operate the doors as this may eventually cause the lock to fail and will invalidate your guarantee.

All moving parts should be lubricated using a silicone spray. The handles should be regularly cleaned with a soft damp microfibre cloth to remove any dust or grime taking care not to scratch the surface.

If you experience problems with locking or unlocking the doors, first eliminate actual locking problems by opening the access door and pulling the handle downwards and then turning the key. If this can be done, the lock is operating normally, and the problem is likely to be due to incorrect door alignment / adjustment.

Door Operation

Sliding door sets have become more popular due to customers wanting to maximise the size of each glazed panel, giving more light and fewer interrupted views. The bigger the glass area the heavier the individual panels will be, which in turn will cause extra resistance when operating the heavier doors.

All our pre-glazed aluminium sliding door sets have been pre-assembled in our factory. They are installed into a steel framed testing rig where they are glazed and then fully operated, including checking the doors lock and unlock smoothly. The door sets are then part dismantled, packaged up ready for dispatch and onsite assembly.

If you experience any difficulty operating your doors, including opening, closing, sliding and locking, do not continue to use your doors as this may cause further issues and damages. Please contact a member of our customer service team so we can assist you further.

Introduction to Assembly - Quick Guide

How your aluminium inline sliding patio door set arrives on site will depend on the size ordered, however as a rough guide;

Outer Frame

If the outer frame is 3 metres or more, it will likely be supplied with the frame in loose sections. Outer frames under 3 metres will likely be supplied built up.

Glass

If your door set is over 3 metres, the glazing will likely be supplied loose. 3 metres and under will likely be supplied with the doors pre-glazed.

These guidelines are to ensure the safety of those handling our products, as well as ensuring they arrive to you in the best possible condition. Our team will contact you in advance of dispatch to discuss your individual delivery arrangements.

These fitting instructions will cover the installation of both standard sized and bespoke Inline sliding door sets, with sections covering assembly of frames that are supplied loose and built up, and door leaves that are pre-glazed as well as supplied with glass loose.

IMPORTANT- Glass lifters / suction cups must be used during the installation of these doors (not supplied)

DOORS-

Supplied pre-glazed or with loose glass, depending on order

FRAME-

Comprises of frame head, jambs and threshold. Supplied built-up or loose depending on order

OPTIONAL EXTRAS

CILL-

Optional. Supplied loose

TRICKLE VENTS-

Optional. Supplied fitted in frame head add-on

STRENGTHENING BAR-

Optional. Supplied fitted

FIXING KIT-

- HSS drill bit 6.5mm x 100mm - Qty 1
- Masonry drill bit 6.5mm x 160mm - Qty 1
- 1/4 hex pozi no. 2 bit - Qty 1
- 92mm direct frame fixing screws - Qty 30
- Low modulus silicone - Qty 1
- Assorted packers - Qty 1 bag

UNASSEMBLED FRAMES ONLY-

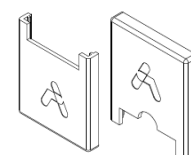
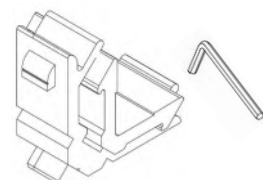
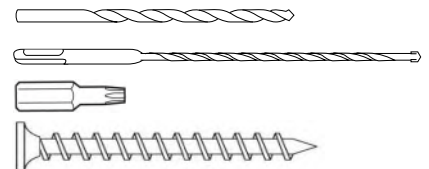
- Corner cleats. Qty 8 for double track / Qty 12 for triple track door sets
- 4mm Allen key - Qty 1

UNGLAZED DOORS ONLY-

- Wedge gasket - Qty 1 roll

INTERSECTION COVER SETS-

Qty 1 top & 1 bottom supplied per non-locking door edge. Supplied loose

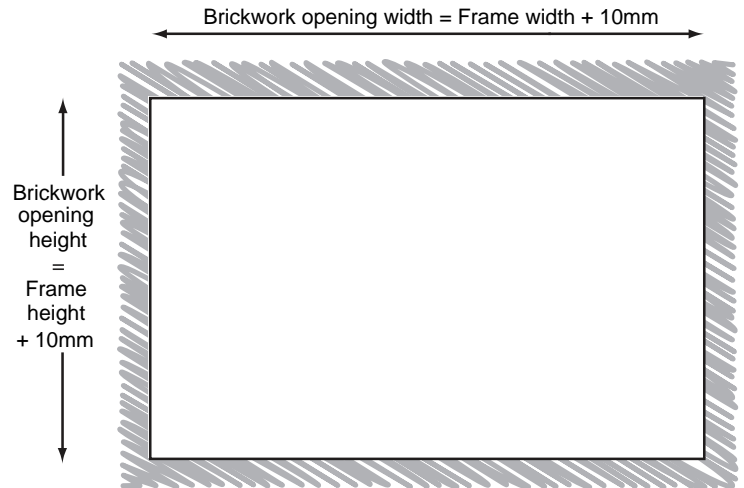


Preparing the site

Brickwork opening:

When preparing the site please prepare the brickwork opening to be 10mm more in height and width than the outside assembled frame size of the Inline sliding door frame.

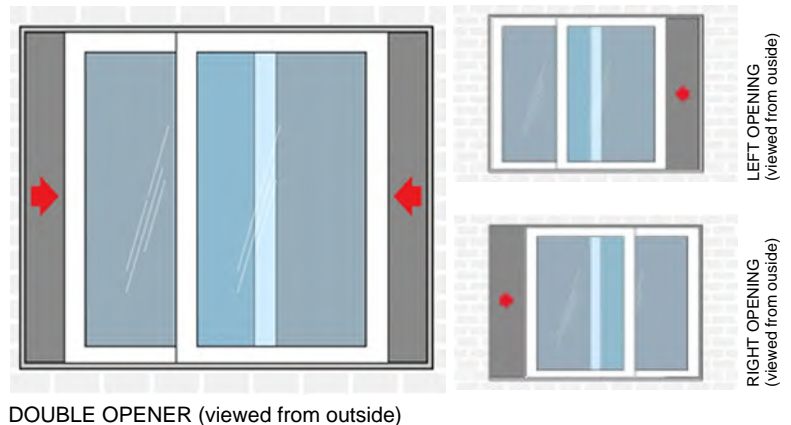
It is essential that all 4 internal surfaces of the brickwork be levelled before installation. Please ensure that all dimensions are correct for installation before proceeding, as the outer frame must be installed square and level into the opening.



Dimensions for standard sized Inline Sliders

Outer Frame (Width x height)	Brickwork Opening (Width x height)
1790mm x 2090mm	1800mm x 2100mm
2090mm x 2090mm	2100mm x 2100mm
2390mm x 2090mm	2400mm x 2100mm
2690mm x 2090mm	2700mm x 2100mm
2990mm x 2090mm	3000mm x 2100mm
3590mm x 2090mm	3600mm x 2100mm
3990mm x 2090mm	4000mm x 2100mm
4990mm x 2090mm	5000mm x 2100mm

As standard, our Inline slider will be a 2 door 'Double Opening' sliding door, meaning both doors can be opened. Other configurations can be special ordered.



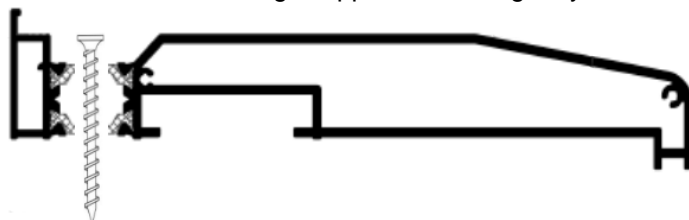
Fitting the optional drip cill

The easiest way to install the frame with a cill is to level the cill in the opening first, temporarily fixing this in place and then lift the assembled frame on top.

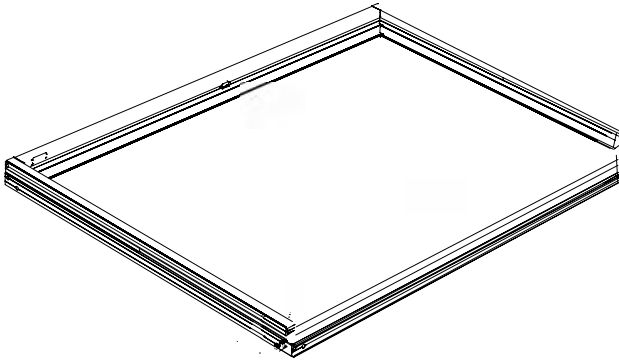
If you have selected an Inline sliding door with an optional drip cill, first place the cill into the bottom of the brickwork opening ensuring the frame jambs will sit a maximum of 5-20mm back from the face of the brickwork. **Most importantly the frame jambs must be securely fixed, the bottom track must be fully supported from front to back, and levelled without dips or raises, with the cill overhanging the brickwork for drainage.**

Using a long spirit level, ensure the cill is sitting level in the opening, using the packers supplied if needed to level it. As this door is bottom rolling, it is vitally important the cill is fully supported from front to back. Packers can be kept in place using the silicone supplied.

Once the cill position is level and fully supported, use the HSS drill provided to drill a hole at each end of the cill through the thermal break. Use the SDS masonry drill supplied to drill through these holes into the masonry. Finally fix the cill in place using 2 of the direct frame fixings supplied, ensuring they are silicone dipped.

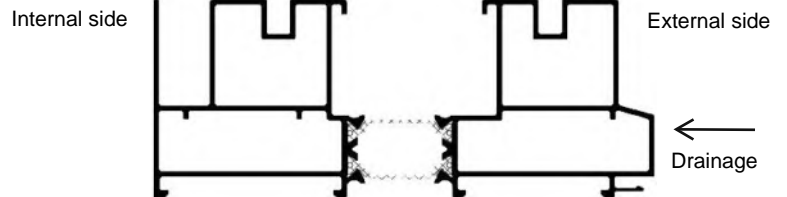
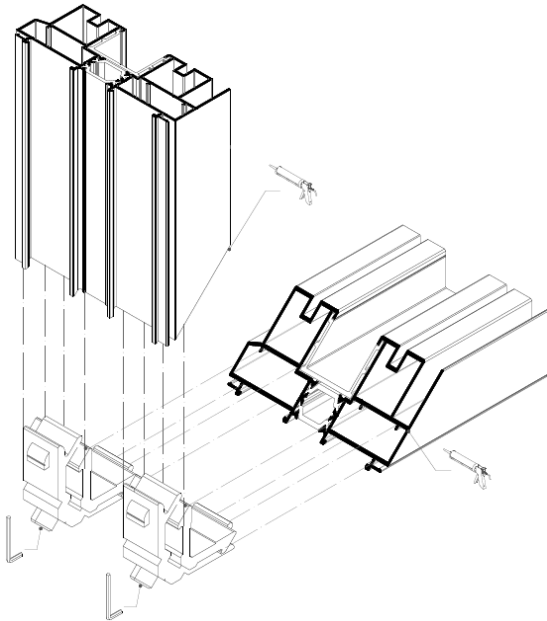


Assembling the outer frame



If your outer frame has been supplied loose, lay the 4 pcs of frame on the floor on top of cardboard or similar protective covering to prevent damage to the aluminium powder coating.

Take care to ensure you've correctly assembled the frame. The sections will be labelled during production as 'top, bottom, left & right' on the outside faces and should be assembled so accordingly.



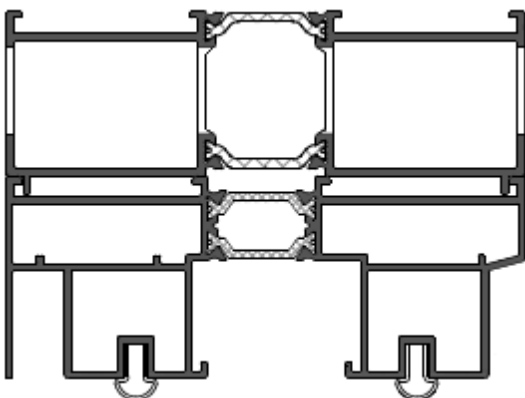
Firstly apply silicone sealant to all touching faces.

Assemble the complete frame by fixing the jambs to the head and bottom rail using the corner cleats provided, **ensuring the lugs locate when inserting them into the sections.**

Finally, in stages tighten with the 4mm Allen key provided.

IMPORTANT: Take care to ensure the drainage channels remain clear.

Optional trickle vent add-on



If you have chosen to add trickle ventilation to your sliding door, these are supplied in an aluminium add-on which sits on top of the frame head. The add-on will be pre-fitted to the frame head when it arrives with you.

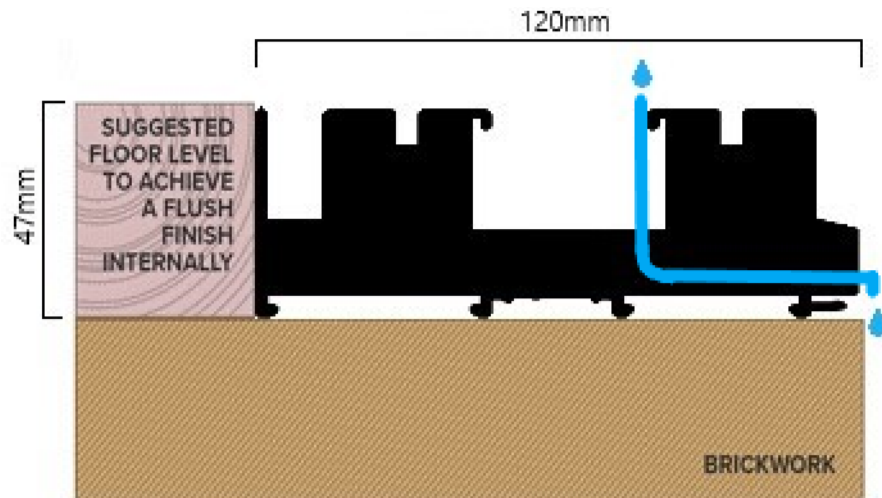
When assembling the frame and tightening the corner chevrons, you may need to angle the Allen key to gain the access required.

Ensure the canopies of the trickle vents are on the external side of the frame.

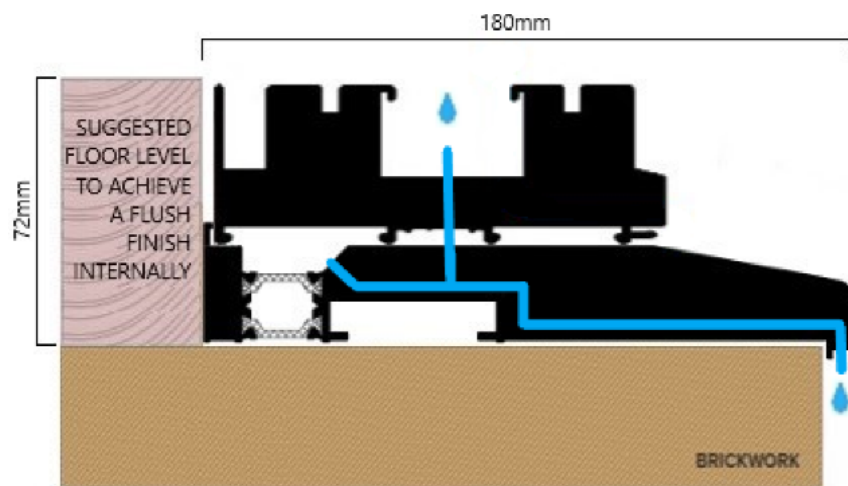
Installing the assembled frame

Please refer to the below for diagrams detailing the dimensions of the frame and cill sections, when considering finished floor heights.

THRESHOLD
ONLY

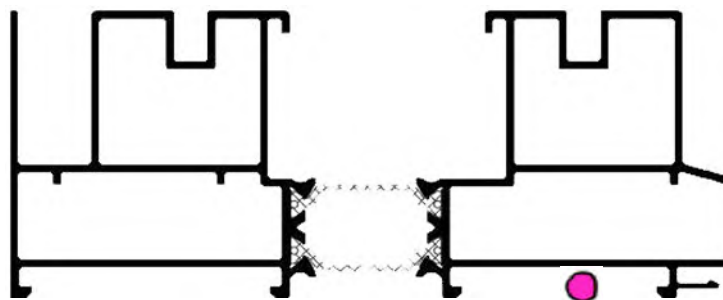


THRESHOLD
WITH
OPTIONAL
DRIP CILL



The outer frame should be positioned in the brickwork opening with the jambs to the outer edge, up to a maximum 5mm - 20mm back from the face of the brickwork. **Most importantly, the frame jambs should have a secure fixing, the bottom track should be fully supported from front to back, levelled without dips or raises, with the cill (if selected) overhanging the brickwork.**

Run a bead of silicone the length of the threshold, as shown below.



● Indicates Silicone Seal

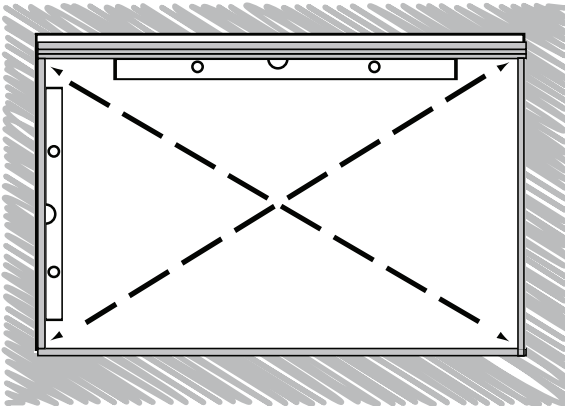
Installing the Assembled Frame

IMPORTANT: *It is critical that the frame is fitted square and level, and checked using a laser level.*

If you have already fitted a drip cill into the bottom of the brickwork opening, take care when lifting the outer frame on top not to damage the drip cill. You should have already levelled and fully supported your drip cill, meaning the threshold should automatically sit level on top.

Where no drip cill is being used, using the packers supplied, level the frame starting at the bottom and insert the first packer **DIRECTLY UNDER THE FRAME JAMB** starting at whichever side of the frame looks highest. Then continue to pack all around the frame.

Continually check the frame using a long spirit level as you go. It is very important the frame is installed into the brickwork opening completely upright, square and level in every plane. Measure diagonally across the frame and ensure the measurements are the same.



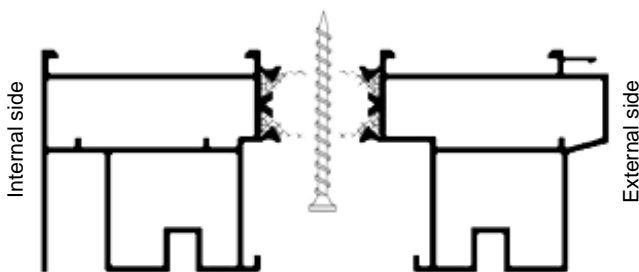
The diagonals must be the same

Do not proceed unless you are 100% happy the frame is in upright, square and level in every plane and checked using a laser level

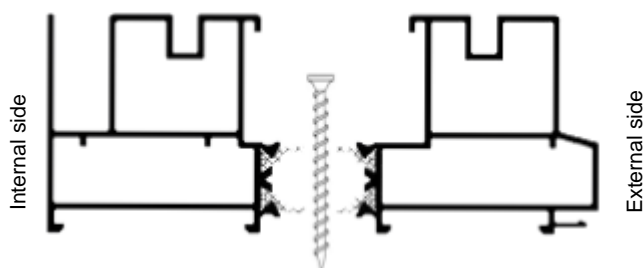
The door set uses a bottom rolling system so it is vitally important the bottom frame section (and drip cill if selected) is level and adequately supported from front to back, without dips or raises, all the way along using packers as necessary.

When the frame is in the opening square and level, drill fixing holes 150mm from each corner and then at 600mm centres. Use the HSS drill provided to drill the frame sections and the SDS masonry drill for the lintel / brickwork.

Finally fix in place with the direct frame fixings and T30 bit provided, through the thermal break, ensuring the fixings in the bottom section are silicone dipped.



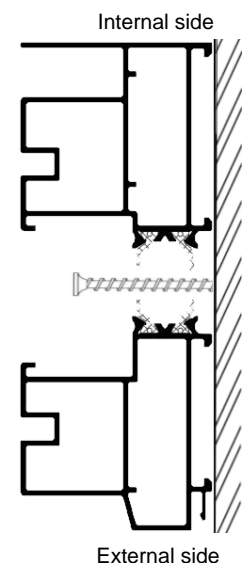
Frame head fixing point



Threshold frame fixing point

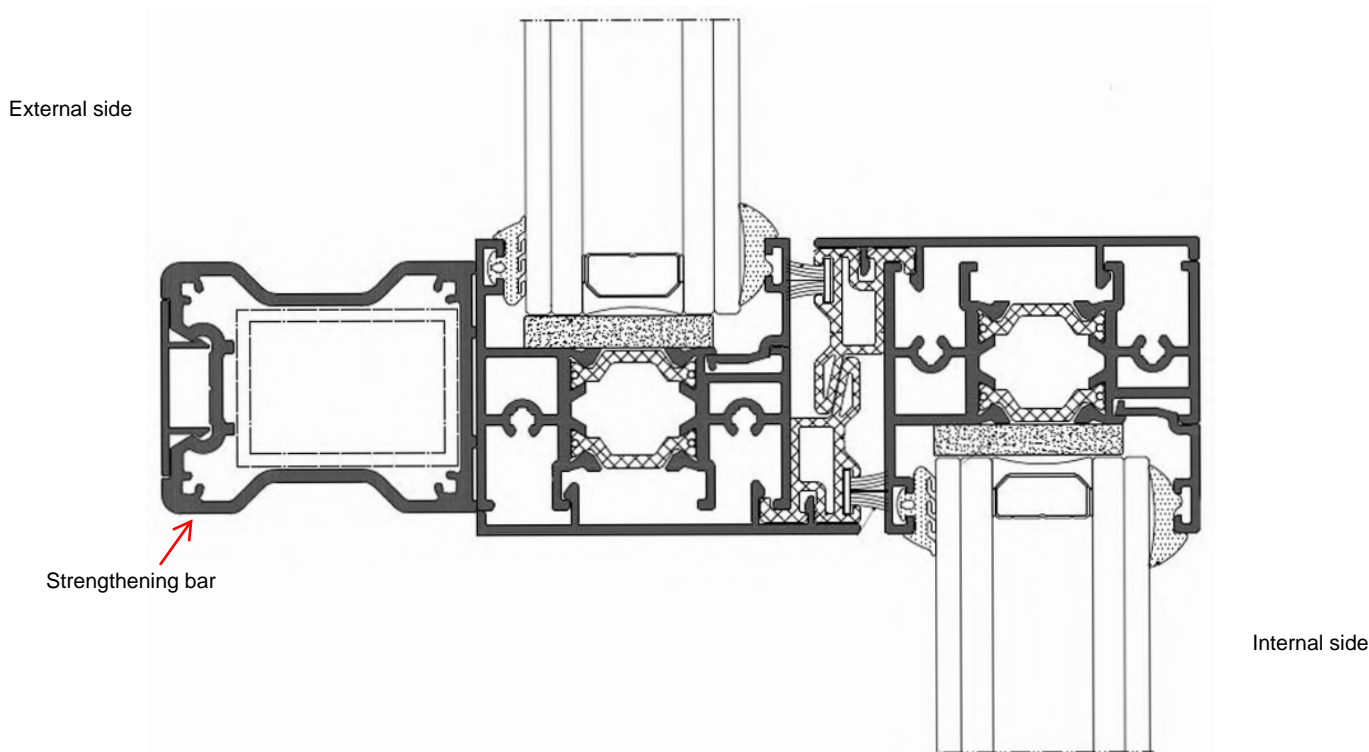
To fix through the frame jambs, again drill fixing holes 150mm from each corner and then 600mm centres. Use the HSS drill provided to drill the frame sections and the SDS masonry drill for the brickwork.

Frame jamb fixing point



Optional strengthening bar

If the optional strengthening bar has been chosen (custom orders only) for reinforcement, it will be pre-fitted during production and by default, will be on the outer face of the door set unless specifically requested otherwise during ordering.



Installation of the doors into the frame

Regardless of if your sliding door set is received glazed or unglazed, the doors should be installed in the frame next. The doors will be clearly marked to identify the Left and Right hand door on a 2 door sliding door set. On a 3 door sliding door set, they will be marked as Left, Mid and Right and should be installed accordingly when viewed from the outside.

Our standard sliding doors are 2 door sets, with both doors opening, however if you have ordered a custom sliding door set with a fixed panel, the fixed panel must be fitted first.

All drawings and instructions are looking from the outside towards the inside here after.

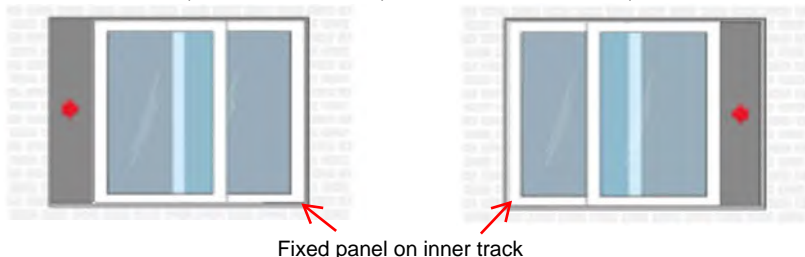
IMPORTANT: Glass lifters / suction cups must be used during the installation of these doors

FOR INSTALLING FIXED PANELS ONLY (CUSTOM ORDERS ONLY)

For custom sliding doors with a fixed panel, the fixed panel must be installed before the opening/ sliding one. Working from the outside, carefully lift the fixed door into the inner track of the frame head, and swing the bottom over bottom tracks until the wheels are correctly located onto the inner bottom tracks.

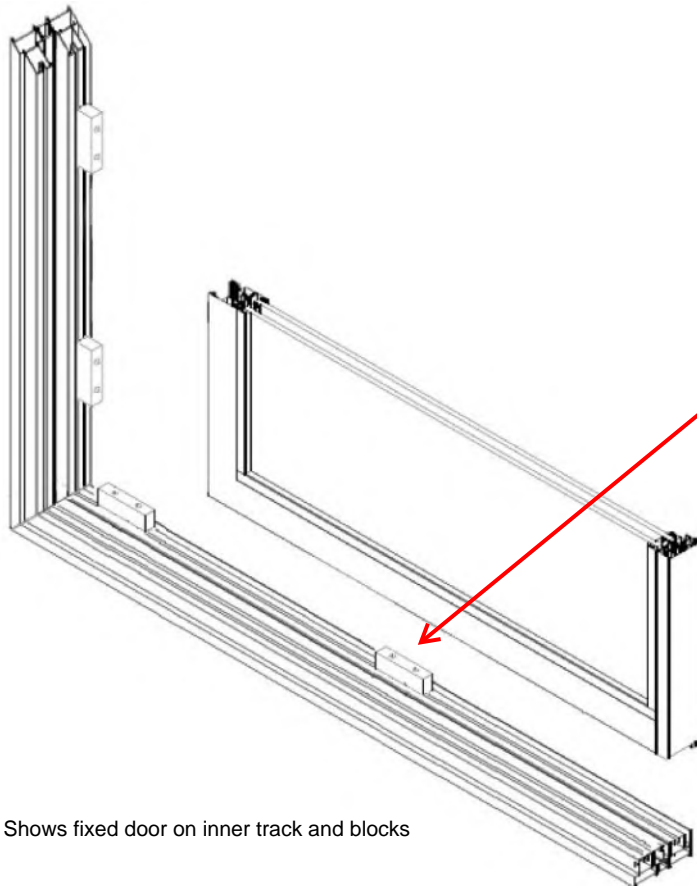
RIGHT OPENING (viewed from outside)

LEFT OPENING (viewed from outside)

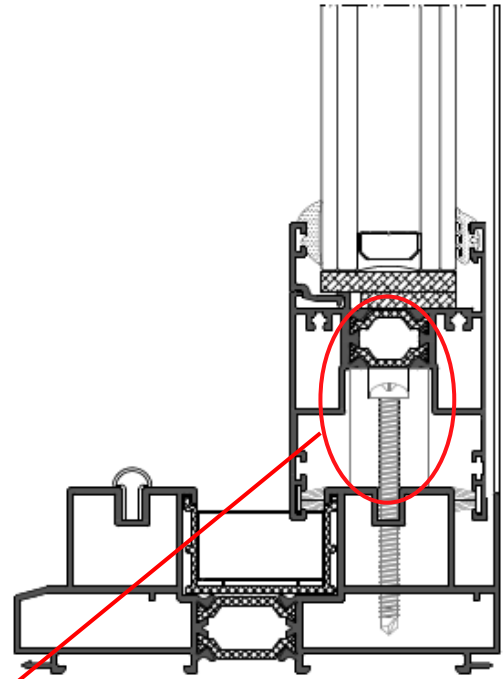


Installation of the doors into the frame (cont)

You will see there are blocks located in the outer frame where the fixed door locates, these will be on the inner track. Push the fixed door over the bottom blocks, whilst keeping the door lifted. Continue to lift and push until the door is pushed up tight against the blocks in the frame jamb.

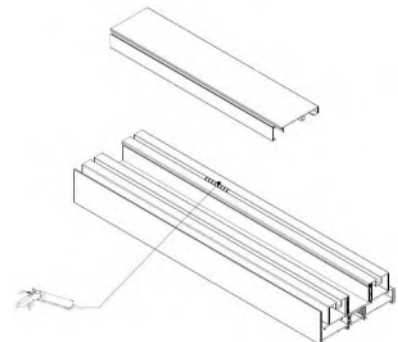


Shows fixed door on inner track and blocks



Sectional drawing of fixed door on inner track

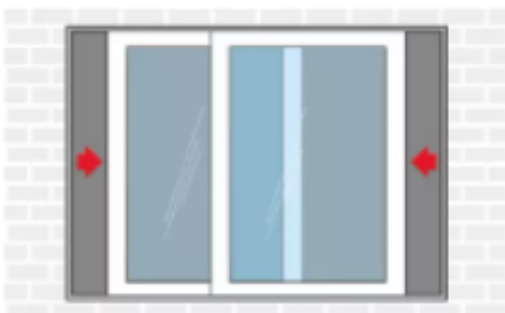
Once the fixed door is correctly located, clip the cover plate alongside the fixed door, tight up against it with a bead of silicone as shown below, in both top and bottom tracks.



FOR INSTALLING SLIDING PANELS ONLY

If you are fitting one of our standard 2 door double sliding door sets, the doors will be labelled as Left and Right, and should be positioned accordingly when viewed from the outside. Our standard configuration, when viewed from the outside, is left hand door on the inner track, and right hand door on the outer track.

STANDARD
DOUBLE
OPENING



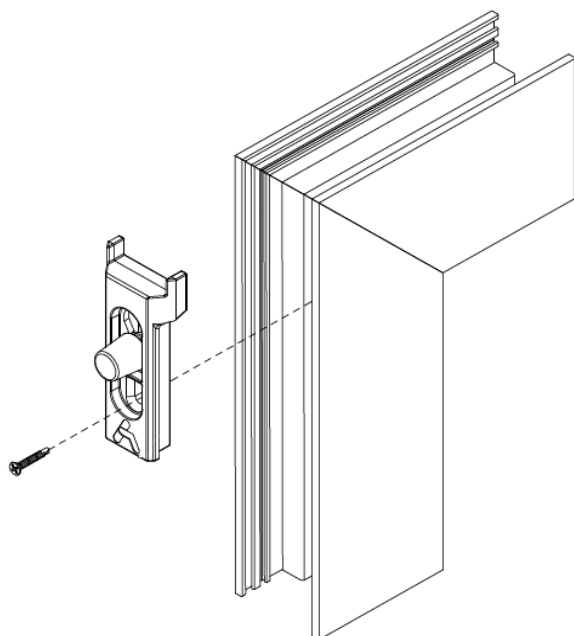
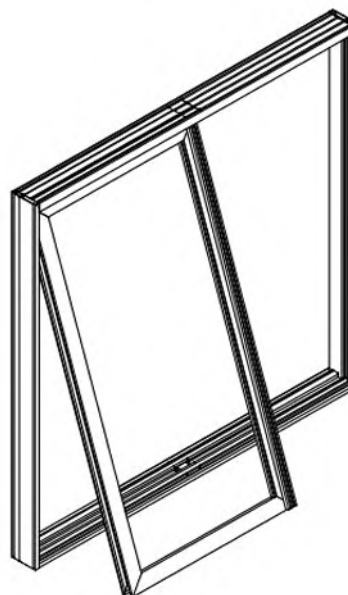
If you've ordered a bespoke 3 door sliding patio door set, they will be labelled Left, Mid and Right, and again should be positioned accordingly when viewed from the outside.

If you are fitting a sliding panel having fitted a fixed panel, the sliding panel should be located on the outer track.

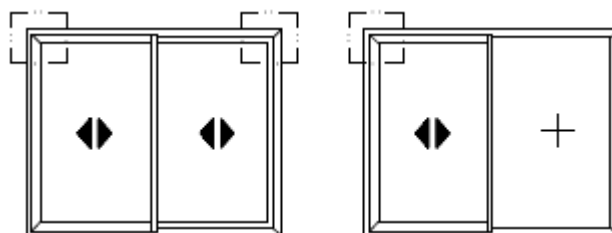
Installation of the doors into the frame (cont)

Working from the outside, carefully lift the door into the frame head and swing the bottom of the door over the bottom track, until the wheels are located correctly onto the bottom track. You may find this easier to offer the door up into the middle of the outer frame where possible, and then slide it to the side.

Repeat with the second sliding door panel if the configuration ordered calls for it.

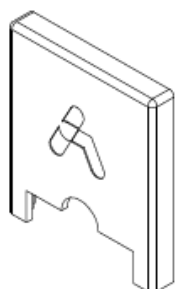


You will find a guide fork pre-fitted to the moving door(s) as indicated in the diagrams below.

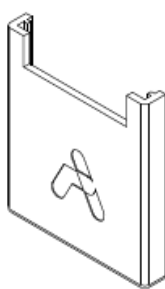


These guide forks will be slackened off when the doors arrive with you. Once the doors are fully positioned, slide the fork upwards so it engages into the track, and re-tighten the screw.

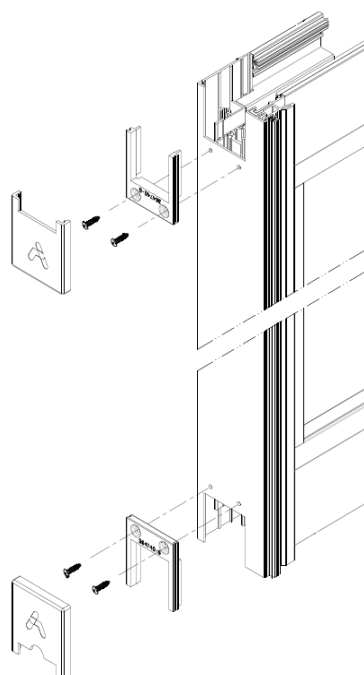
Finally, fit the intersection covers (supplied loose) to the top and bottom edge of the door(s)



Bottom intersection cover



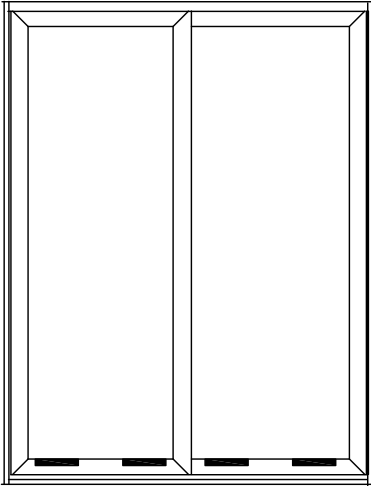
Top intersection cover



Glazing the doors

As a general rule, our Inline sliding doors over 3 metres in width will be supplied with the glazing loose, for the fitter to glaze on site. This is due to the weight of the glass, if preglazed, the joints of the door could be compromised during transportation.

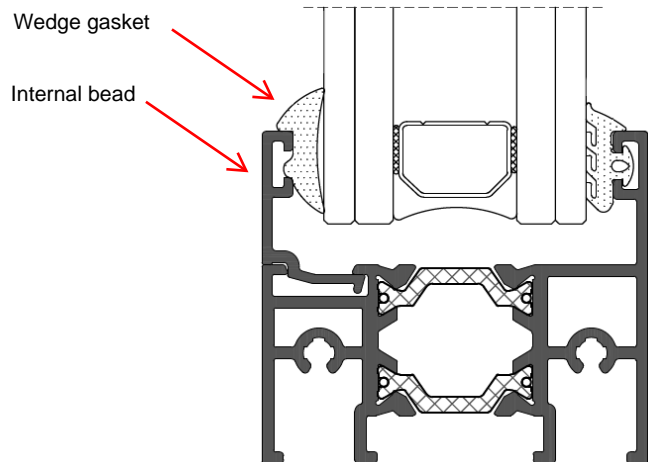
IMPORTANT: Glass lifters / suction cups must be used during the installation of these doors



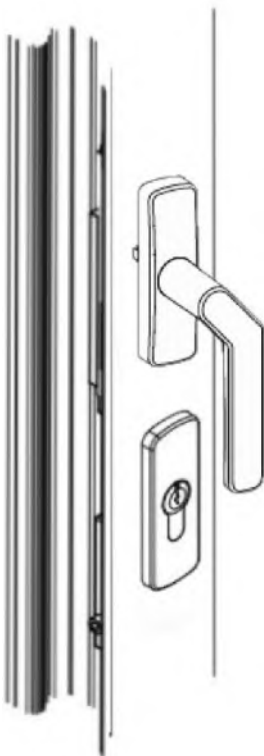
Qty 2 x 5mm bridging packers should be siliconed in place approximately 100 -150mm from the edges of each door. These packers should be placed on top of the pre-fitted foam section.

Using glass lifters / suction cups, fit the loose glass into the rebate on the door.

Locate the internal glazing bead and clip this into position. Finally, insert the internal wedge gasket to secure.



Operation of your Inline sliding patio door



In the closed position, the handle of your Inline sliding patio door will be facing down as shown opposite. The handle lifts to 90 degrees in the open position.