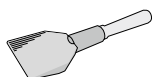
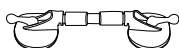


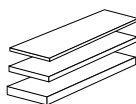
## Tools:



**1. Glass adjustment tool**

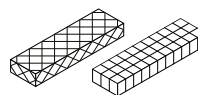


**2. Glass lifter**



**3. Spacer distance plates (1/2/3 mm).**

Required quantity included in delivery



**4. Supporting distance plates. Hard plastic, 3/5 mm**

Required quantity included in delivery



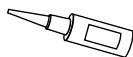
**5. Joint glue (eg. Viscoseal 6958R).**

Not included in delivery



**6. Sealing compound for PX insulation Sikasil WT-40 Black.**

Included in delivery



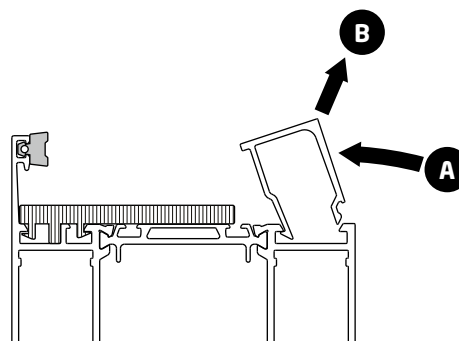
**7. P/N 12220 glue for RC2/RC3 class.**

Included in delivery

## Step 1 Remove the glazing beads from the product

**A.** Push glazing bead towards to the glass unit in order to free up glazing bead.

**B.** Take it out.



**Step 2** Position supporting distance plates into the frame/sash according to scheme.

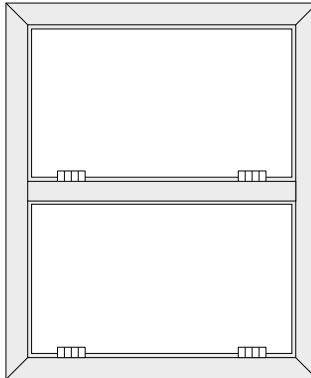
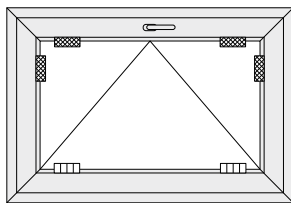
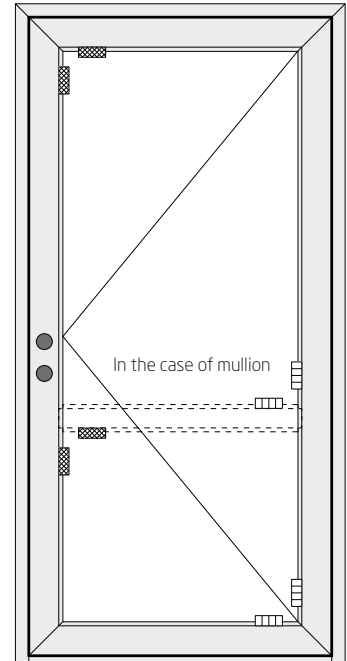
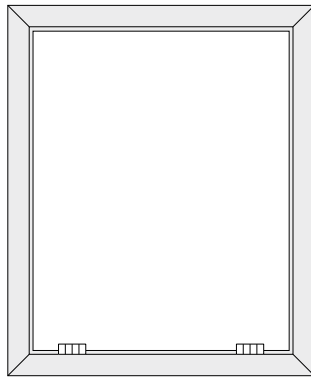
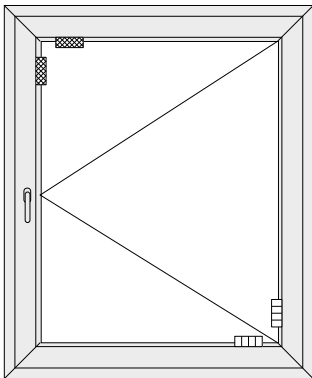
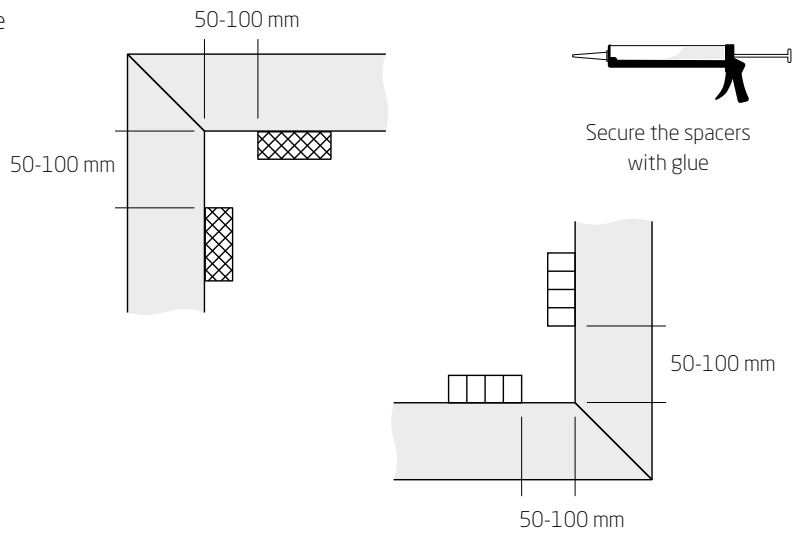
 3 mm hard plastic supporting distance plates

 5mm hard plastic supporting distance plates

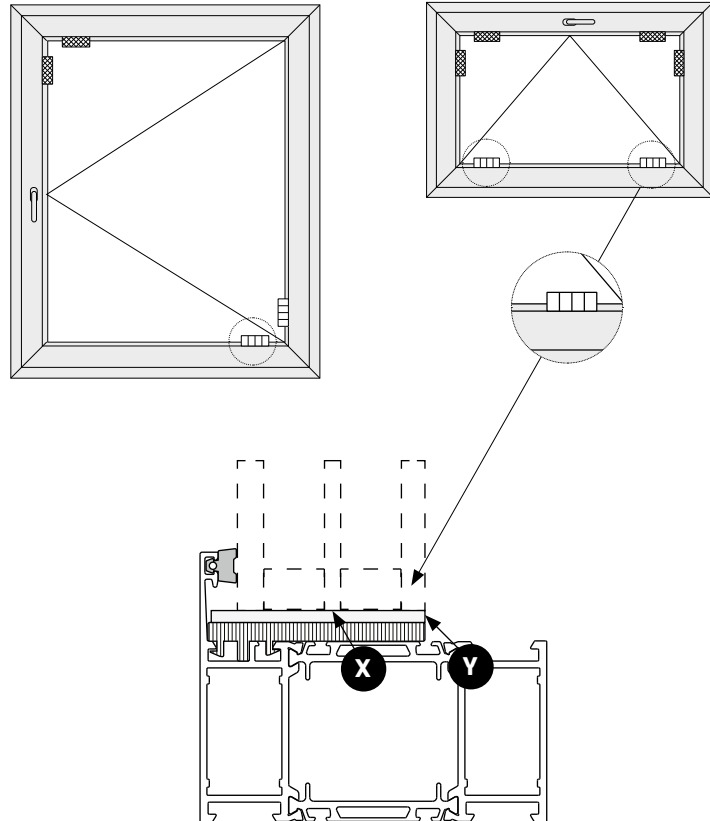
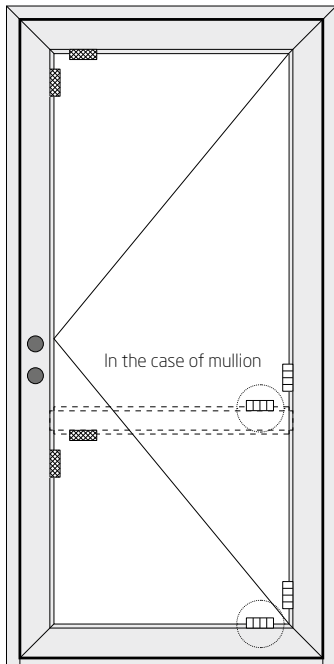
Use glue to attach supporting distance plates on the sides and top (eg: Viscoseal 6958R).

The edge of the supporting distance plate is placed 50-100mm from the glass corner in the sash.

Fixed glazed elements are only provided with two supporting distance plates at the bottom.



**Step 3** Place 3mm spacer distance plate on the supporting distance plate, at the bottom (applies only for sashes: not required for fixed glazed elements).

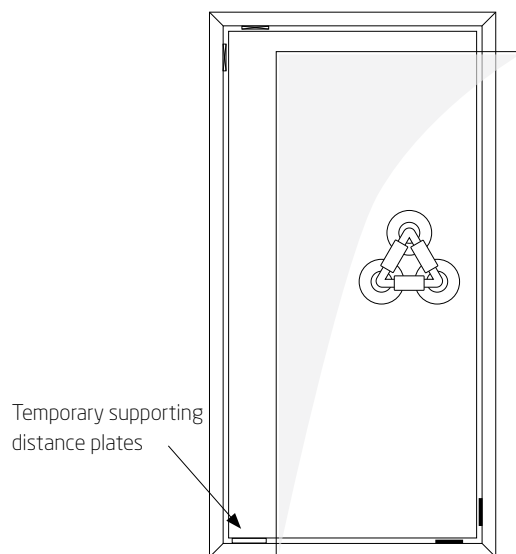


- X** Supporting distance plate and spacer distance plate should cover the entire glass edge. It may crossover the glass edge all the way towards the frame.
- Y** Supporting distance plate and spacer distance plate should be placed flush/flat with the inside surface of the glass.

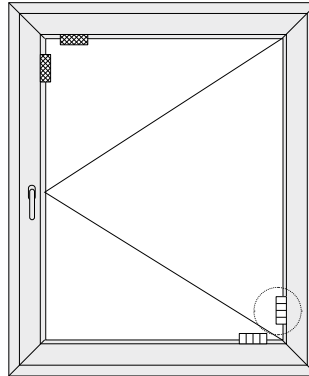
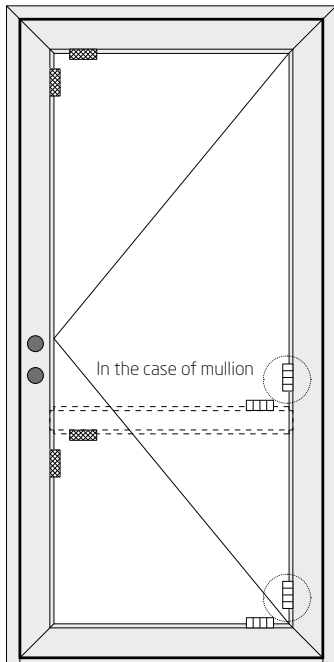
**Step 4** Lift the glass into place

**NB:**

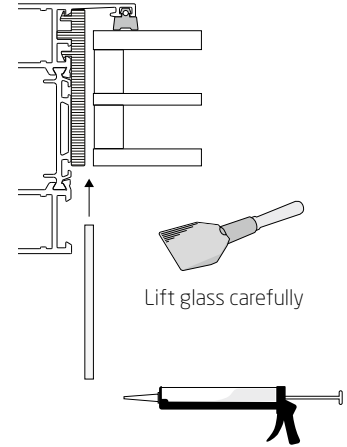
- Be careful and do not touch the aluminium profiles with the glass unit. Glass can easily break due to contact with metal.
- We recommend adding a temporary spacer distance plate at the non-hinge side, on the bottom, when glazing sashes. Please follow the example.
- The temporary spacer distance plate must be removed following completion of glass installation!



**Step 5** Place 3mm spacer distance plate on supporting distance plate at the bottom (applies only for sashes; this is not necessary for fixed glazed elements). Please follow the scheme for correct placement of plates according to STEP 1.3.

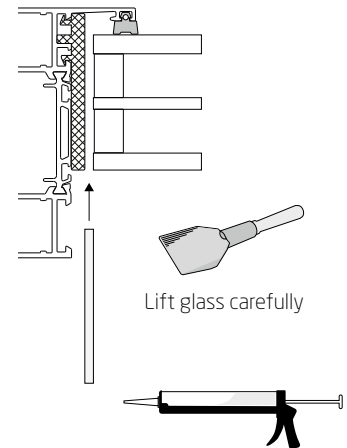
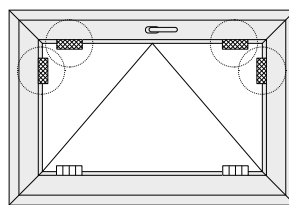
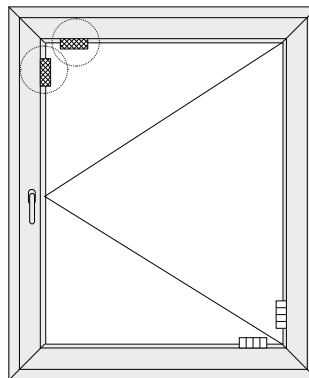
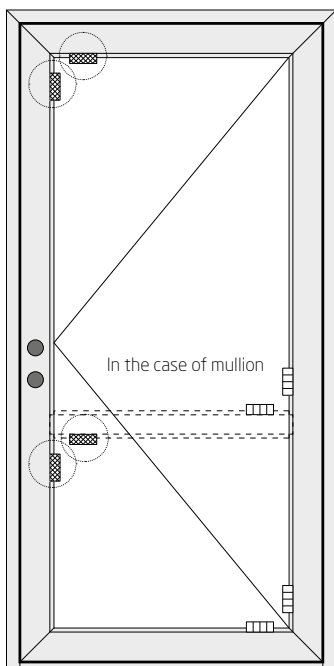


**NB:** It is recommended that glue be used on the spacer distance plate to ensure that it cannot fall out of position.



Secure the spacers with glue

**Step 6** Insert 1/2/3mm spacer distance plate on supporting distance plate at the top and to the side (applies only for sashes; this is not necessary for fixed glazed elements). Select the appropriate thickness of spacer distance plate to achieve correct diagonal placement. Please follow the scheme for correct placement of the plates according to STEP 3.

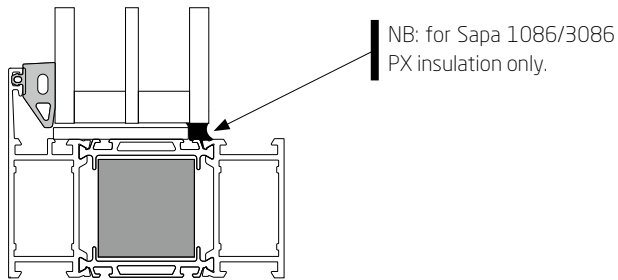


Secure the spacers with glue

**NB:** It is recommended that glue be used on the spacer distance plate to ensure that it cannot fall out of position.

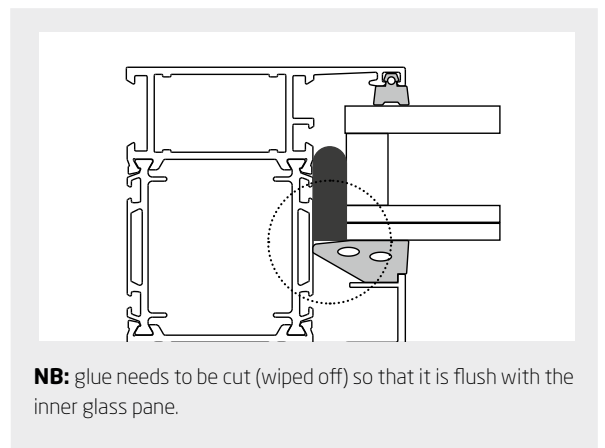
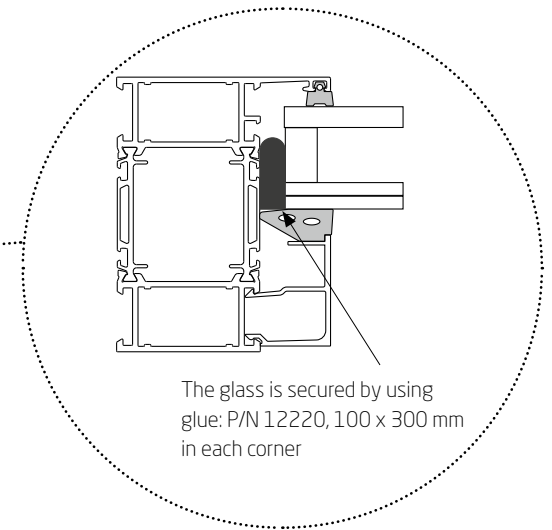
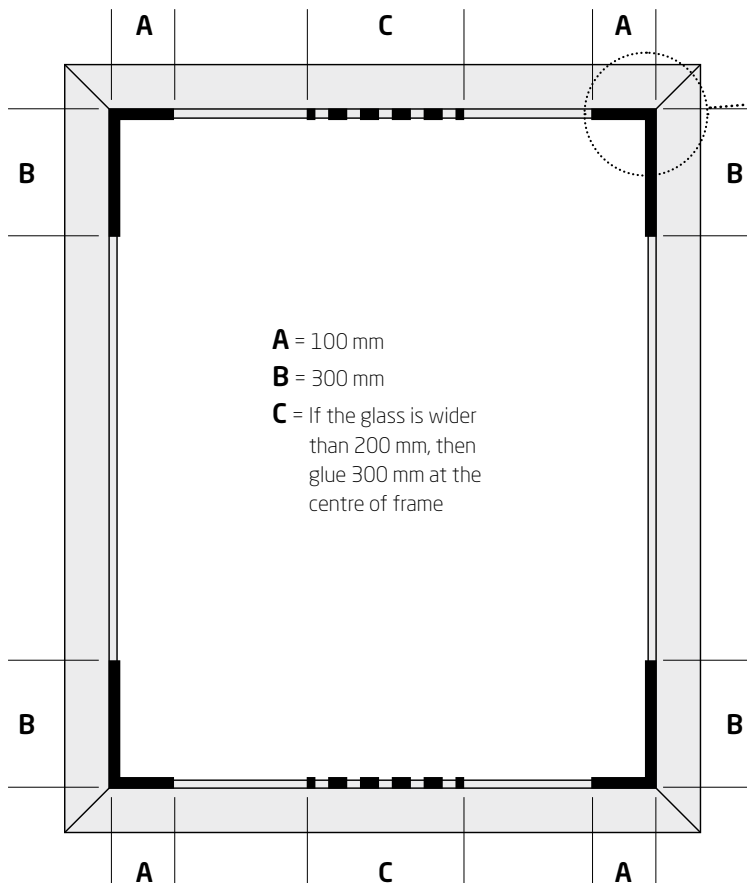
**NB: for Sapa 1086/3086 PX insulation only.**

If products arrived unglazed from the factory, additional sealing is needed. In order to meet air and water tightness performance levels, seal the gap between glass/infill panel and frame with a sealing compound: Sikasil WT-40 Black (included in delivery). Use sealing compound all the way around the perimeter of the glass/infill panel:



**NB: for windows and entrance doors of 1086/3086/2086 RC2/RC3 class only.**

The glass should be secured by using P/N 12220 glue, 100 x 300mm in each corner:



### Step 7

**1.** First install the horizontal glazing beads and horizontal gaskets (one-by-one).

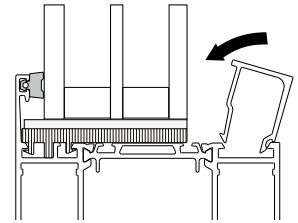
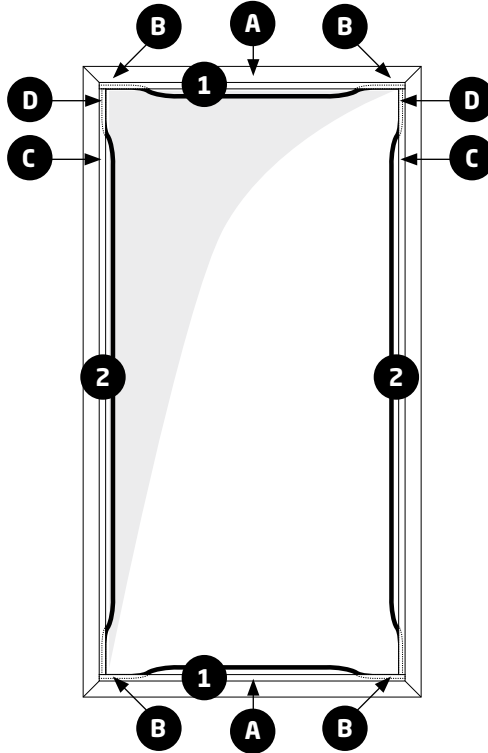
**2.** Afterwards install the vertical glazing beads and gaskets (one-by-one).

**A:** Install horizontal glazing beads

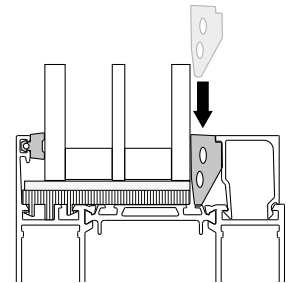
**B:** Press gasket ends into corners with added pressure to form a seal against the vertical section

**C:** Install vertical glazing bead

**D:** Install vertical gaskets as per B.



**A & C**  
Glazing bead installation section



**B & D**  
Glazing bead installation section (start by pressing down the gaskets in the corners)

### Step 8 Check functionality if a hinged product is involved.

**NB:** due to allowable tolerance levels in terms of width and height for glass units there may be a need to use different thickness combinations of supporting distance plates and spacer distance plates instead of the recommended articles. It is responsibility of the installers to achieve the correct diagonal for sashes.