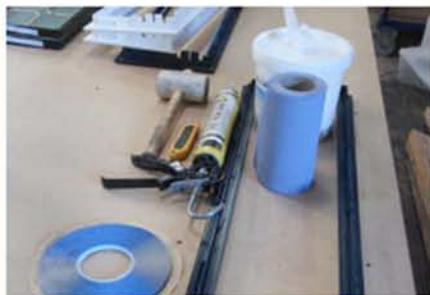


Cassette Fitting Guide (Snap Fit)

Step by Step Guide

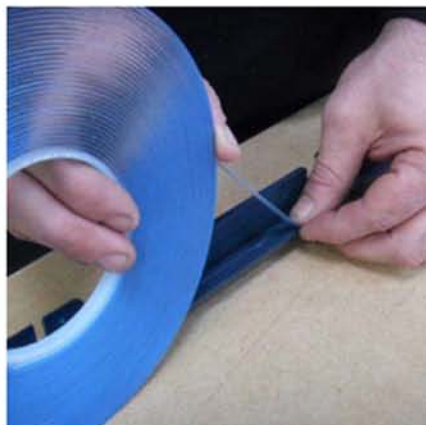
Step 1

Ensure all surface contact points are thoroughly clean, dust and grease free, and dry prior to applying adhesives. Use Wonder Wipes and dry off using industrial type paper roll. Ensure all glazing benches are protected and grit-free, ready to glaze onto a flat solid bench.



Step 2

Apply 1.5mm x 6mm clear Acrylic adhesive tape to the inner channel of both internal and external cassettes where it meets the glass, always apply the horizontal channels first, ensuring all vertical joints are butted together tight, gap free to create a weatherproof seal.



Step 3

Ensure glass adhesive contact points are clean, dust and grease free, and dry prior to applying cassette. You could use a high quality Isopropanol cleaning fluid or Wonder Wipes as this will evaporate, leaving no residue.



Step 4

Ensure the external face of the glass unit is facing up on the bench, present the external cassette to the outside face of the glass unit, check sight lines are OK and that the glass unit is square and sitting close to the female connectors, thus allowing room for the female connectors to locate over the male connectors on the opposing internal cassette. Then remove the adhesive tape protective release liner, start at the base and work round checking sight lines as you go, once complete apply an even amount of pressure to ensure adhesives have keyed well to both cassette and glass



Step 5

Turn the cassette and glass unit over, again checking that all adhesive contact points are clean and dry, then apply a full 6 to 8mm bead of clear adhesive to the outer channel of the external cassette. Apply a small amount of clear adhesive to the female connector, below the strap where the male connector locates behind.



Step 6

Ensure that the door internal and external adhesive points are clean and dry ready to glaze. Then lay the door (two man lift) over the external glazed cassette, ensuring that the cassette is a square and in line with all depression moulds.



Cassette Fitting Guide (Snap Fit)

Step by Step Guide

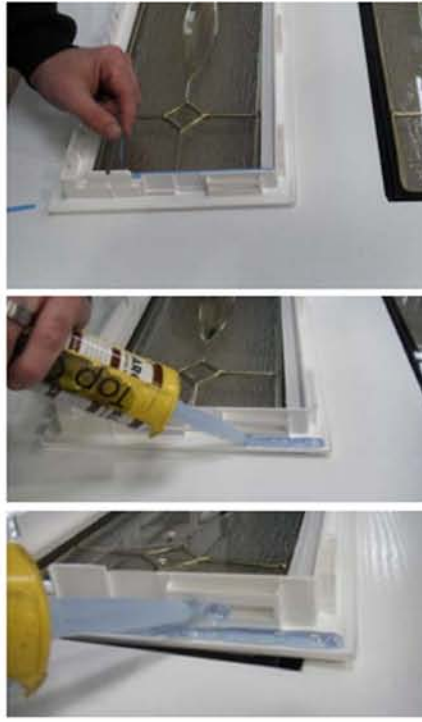
Step 7

Repeat cleaning process for the internal adhesive contact points, as per step 1 & 3. Good housekeeping will ensure optimum performance from the adhesives and create an excellent long term weather seal.



Step 8

Remove the adhesive tape release liners from the internal cassette. Apply a full 6 to 8mm bead of clear adhesive to the outer channel of the internal cassette; again apply a small amount of adhesive to the female connector, below the strap where the male connector locates behind.



Step 9

Offer the internal cassette over the external cassette, ensuring the correct male and female connectors are aligned. The apply pressure using the heel of your hand and working around the perimeter of the internal cassettes to locate fully into the external cassette, so that the male parts of both cassettes fully engage with the female receivers.



Step 10

With care and using a rubber head mallet, apply additional pressure to ensure all connectors have fully mated, and the cassette sits nice and flush with door face. Then remove any excess clear adhesive using a non-abrasive tool and clean using Wonder Wipes.



Step 11

Turn the door over (two man lift) and check that the external cassette has mated firmly, then repeat step 10 in its entirety. Once the door/cassette and glass has been fully cleaned and is completely dry, apply a fine neat bead of clear sealant to the bottom of the external cassette meeting the glass and 10mm up verticals at corners.



Cassette Cross Section

