

Assembly Instruction

FOPPE Craftmann's lift-slide | series Alcoa RT 135



Assembly Instructions

General Information

Congratulations!

You have selected a high-quality FOPPE Metallbaumodule GmbH product.

To ensure, that you have the utmost pleasure from the product, thoroughly read these assembly instructions.

Necessary installation material

Begin by checking the profiles and surfaces for any evidence of damage and check the accessories for completeness by using the job order for reference.



Further information of operation and maintenance for the Craftmann's lift-slide is available as download on our homepage. Visit us at www.foppe.de.

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1

Begin by Assembly of the wings.

Mix the adhesive as specified on the cartridge. Be sure to observe the handling instructions provided on the cartridge. They specify the curing times which must be adhered to strictly. Any subsequent correction of the corners is hard to accomplish once the adhesive has set. Use a commercial available silicon gun to spread the adhesive in the hollow chambers of the profiles.



2

Put the corner cleats (Part No. 233945, No. 233946) and the corner reinforcement (Part No. 218722) into the adhesive in the top and bottom wing frame.



3

Proceed to assemble the wing frame for the active leaf. To do so, fit the top and bottom profiles with the corner cleats inserted into the side wing profile.

Caution: Take care to position the wing with the handle cut-out in the correct side.



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- 4** Drive the 8 x 10 mm aluminium nails into the prepunched holes of the wing profiles.



- 5** Align the glued corners and carefully wipe off the adhesive. Repeat this operation several times.



- 6** Now install the glazing bridges. The active leaf has eight pieces. In each corner one piece vertical and one piece horizontal. The inactive leaf has six pieces. In each of the bottom corners one piece vertical and one piece horizontal, at the top on either side one piece vertical.



- 7** Then insert the glass contact seal into the wing frame.



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Complete the assembly of the wing frame by finally installing the glazing beads. Note that the beads have been cut with approx. 2 mm oversize each and must be fitted in precisely.

Lay the horizontal glazing beads first, then position the vertical glazing beads. For cutting to length and fitting in of the glazing beads, use should be made of an appropriate saw.



9

Then insert the rebate seal (Part No. 233902) into either wing frame.

Active leaf: Handle side, top and bottom

Inactive leaf: Side facing active leaf, top and bottom

Mitre cut the seals at the corners and glue them together by means of superfast adhesive.



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For installing of the fittings, use the enclosed drawing No. 00157 as a reference. See **appendix 1**.



11

Screw up the spacer in a vertical position at the front of the carriage using the 4.8 x 10 mm flat-head tapping screw.



12

Insert the carriage at the front and fasten it by means of M5 x 20 mm countersunk-head screws.



13

After the carriage has been installed at the front, fasten the galvanized steel connecting rod, $d = 8$ mm, which has already been cut to length. Then insert the carriage at the rear onto the connecting rod and into the profile and fasten it by means of the inserted grub screws.



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Proceed to press the five spacers into the lifting gear as follows: 1 each into the bottom mounting hole, 2 each into the 2 top mounting holes, 1 each into the mounting hole above the case of the lock.



15

Assemble the lifting gear with the carriage and slide it into the wing profile.



16

The lifting gear with the carriage is then screwed up with the wing. The operation requires predrilling at $d = 4.2$ mm for the 4.8 x 60 mm flat-head tapping screw.



17

Next, fit the cylinder into the gear lock that is already mounted.



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Fit the hand lever with the spindle into the gear.



19

Then insert the glass contact seal into the wing frame.



20

Slide the cover over the lever and in the base structure of the hand lever.



21

Press the cover onto the base structures of the hand lever until it engages.



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Next, mount the plastic beads for the labyrinth profile to the active leaf.



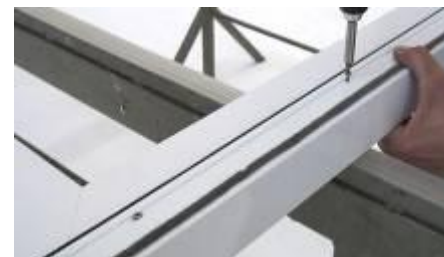
23

Install the predrilled labyrinth profile on the active leaf. Refer to drawing No. 00154



24

Screw up the predrilled labyrinth profile at the active leaf using 3.9 x 22 mm flat-head self-tapping screws. Refer to drawing No. 00154.



25

Use superfast adhesive to install the eight plastic guide pieces, Part No. 233 947, at the top of the active leaf as follows: On the right and on the left at a distance of 50 mm each, then distribute the other four pieces evenly in the intermediate space. Refer to drawing No. 00154



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Now assemble the door frame. Begin by removing the protective film from the joint seals on the two side door frame profiles. Before assembling the door frame, pay attention to the contours of the top and bottom frame profiles which match the joint seals on the side frame profiles.



27

Join up the side door frame profiles with the top and bottom door frame profiles.



28

Screw them up using special cheese-head screws, Part No. 219 569. Refer drawing No. 00154.



29

Place the door frame in an upright position (secure the frame to prevent it from falling down). Then take the inactive leaf, insert it into the door frame and screw it up at the support brackets already mounted in the door frame, using 4.8 x 50 mm oval-head tapping screws (2 x at the side / 2 x at the bottom).



Caution: When inserting the leaf, refer to the enclosed drawing No. 00154 to prevent the rebate seal from being forced out.

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Then fasten the plastic moulding to the inactive leaf using 4.2 x 19 mm oval-head tapping screw



31

Mount the plastic bead to the inactive leaf.



32

Then install the predrilled labyrinth profile and screw it down using 3.9 x 22 mm flat-head self-tapping screws. Refer to drawing No. 00154.



33

Now take the active leaf and insert it.

Caution: When inserting the leaf, refer to the enclosed drawing No. 00154 to prevent the rebate seal from being forced out, which would render the leaf hard to move.



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Should a stopper be desired, it can conveniently be mounted afterwards at the bottom of the inactive leaf.

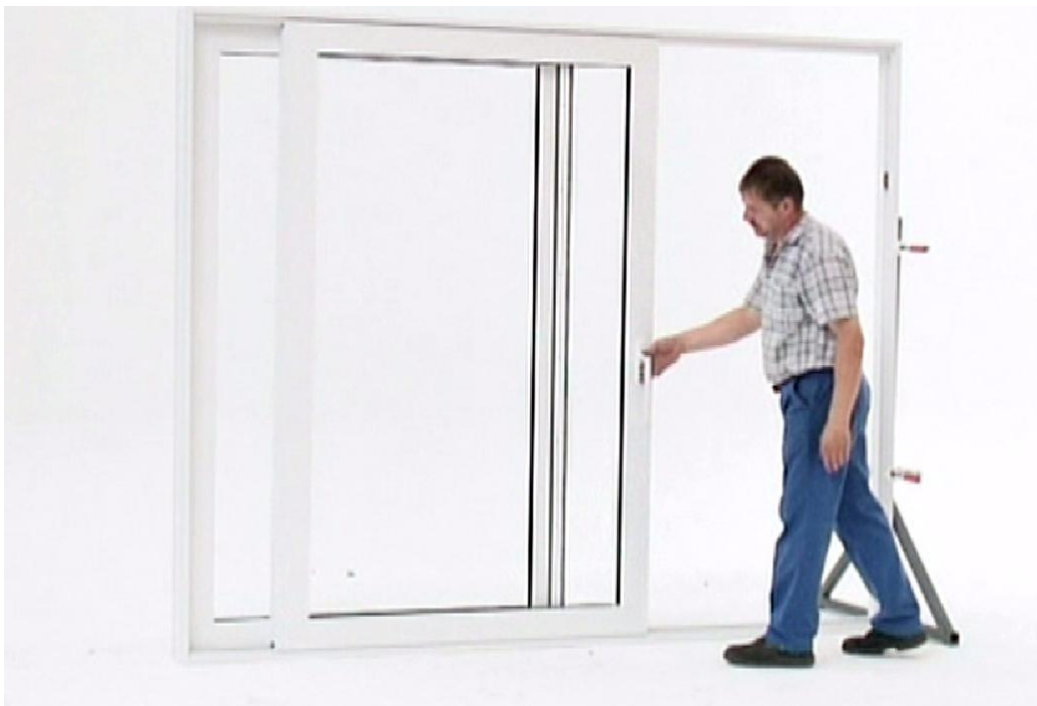


Functional Check

Finally, perform a functional check. Turn your attention to the necessary ease of movement in particular.

We hope you will enjoy assembling your craftsman's lift-slide door!

We would be delighted to support you.





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