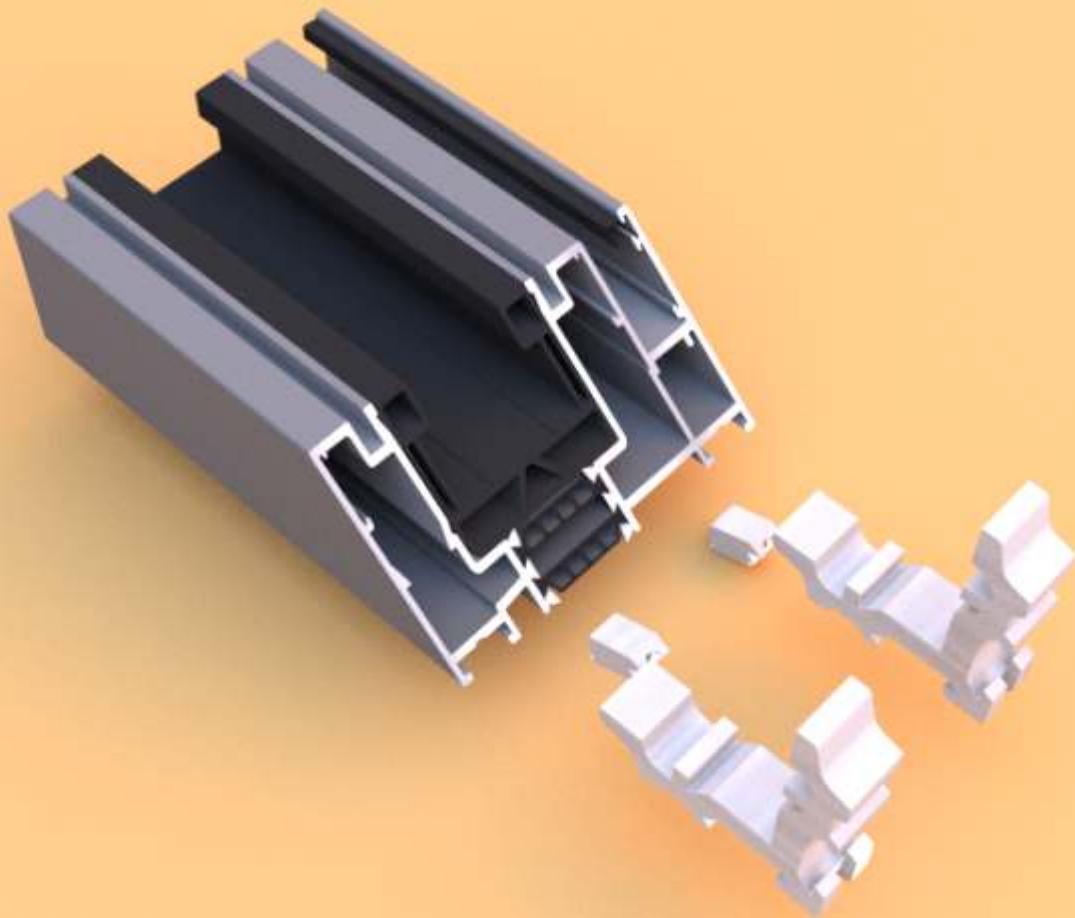


Penthouse Plus

Assembly Guide



DURATION
WINDOWS



Contents

- 3** Box Contents
- 4** Channel Infills
- 5** Assembling Outerframe
- 6** Installing Outerframe
- 7** Installation of Door Sashes
- 8** Anti Lift Blocks
- 9** Interlock Mullion
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Box Contents

Cleats

Wedge Gasket

Packers

Keys

Assembly Guide

Anti Lift Blocks

Cover Caps

Cill End Caps

IMPORTANT: Ensure that the frame is fitted plumb, square & level with no bows



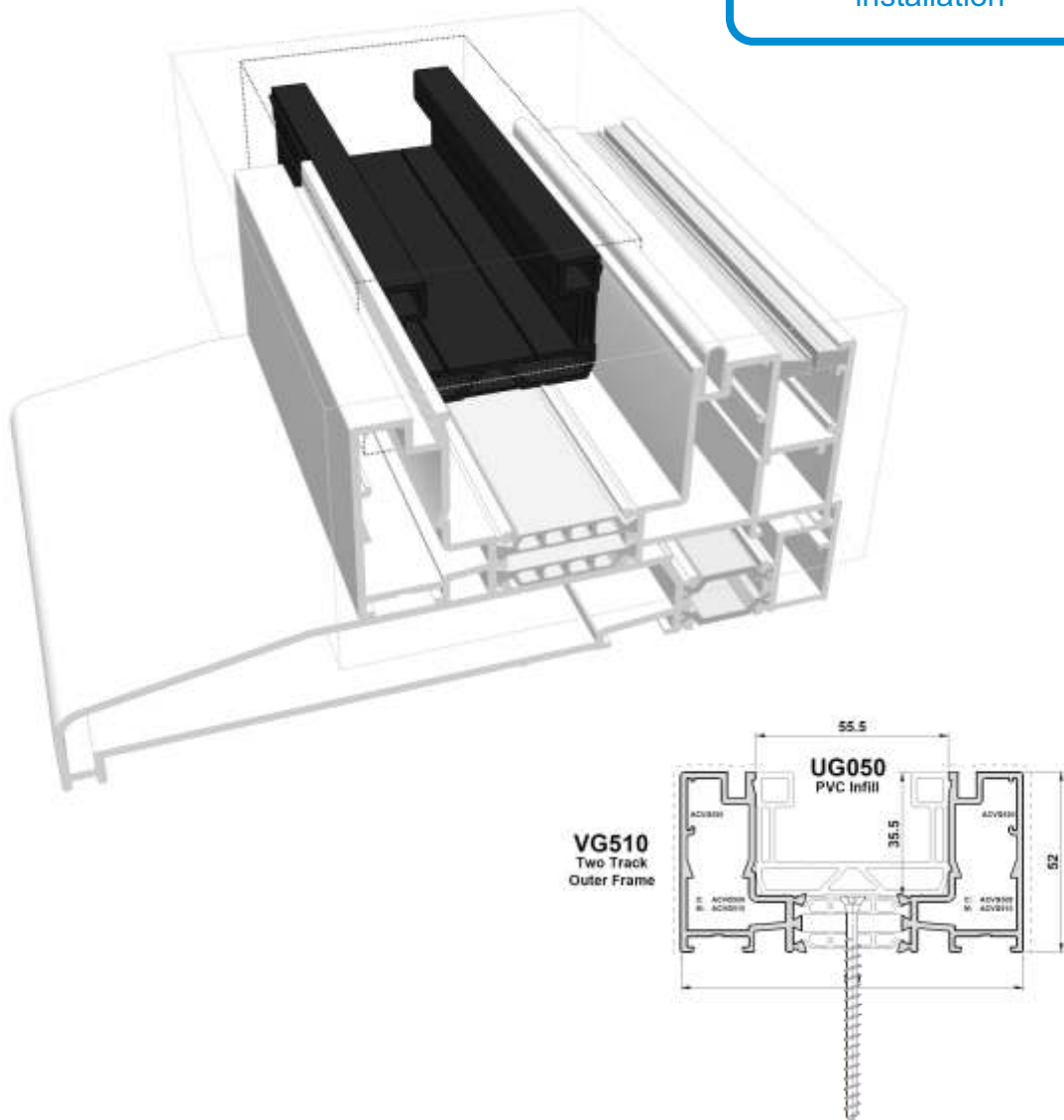
We reserve the right to make changes to the product specification as technical developments dictate, and without prior notice. Pictures shown are for illustrative purposes and are not binding in detail, colour or specification.

Channel Infills

Prior to frame assembly, to hide fixings:

- Slide out UG050 infill (note position)
- Fix Frame
- Replace UG050 infill

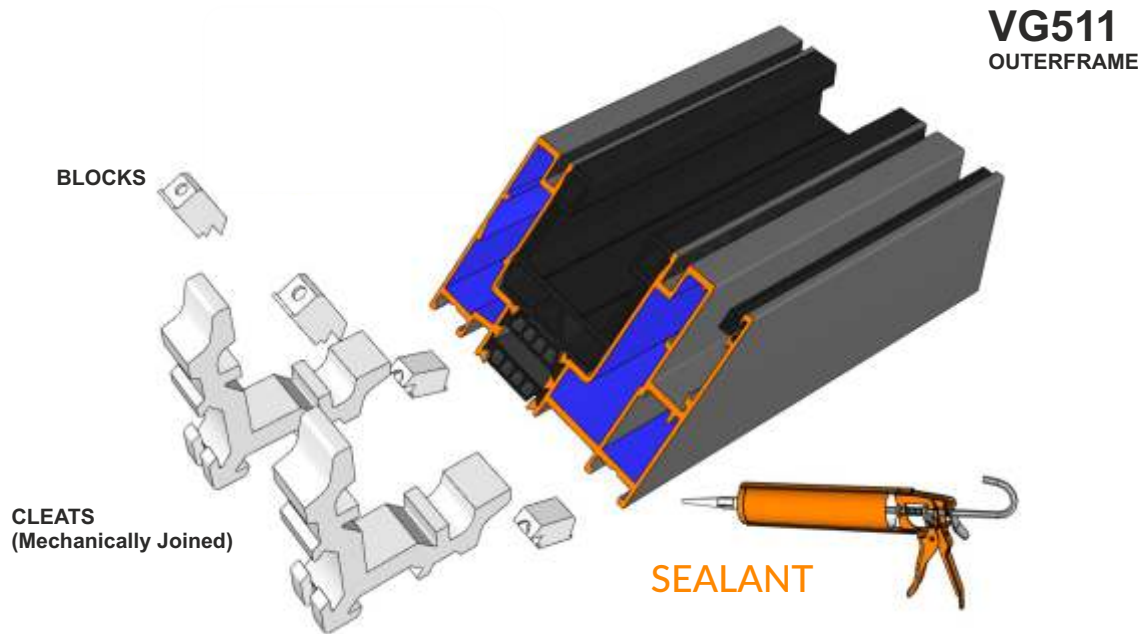
GLAZING :Sashes are internally beaded allowing glazing to be completed after installation



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Frame

Assembling The Frame



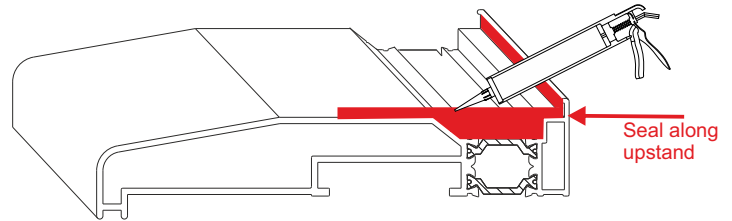
- Degrease the saw cut
- Using a suitable small gap sealer, seal the cut faces to be joined.
- Apply suitable sealant into the cleat chamber.
- Insert corner cleats. Line slot in cleat with hole in frame.
- Bring two mitred ends together.
- Insert blocks and tighten with 2.5mm hexagonal or 3mm allen key.
- Repeat for all four corners.

Fitting the frame correctly will ensure the correct operation of the door and panels.

Installing A Cill & Frame

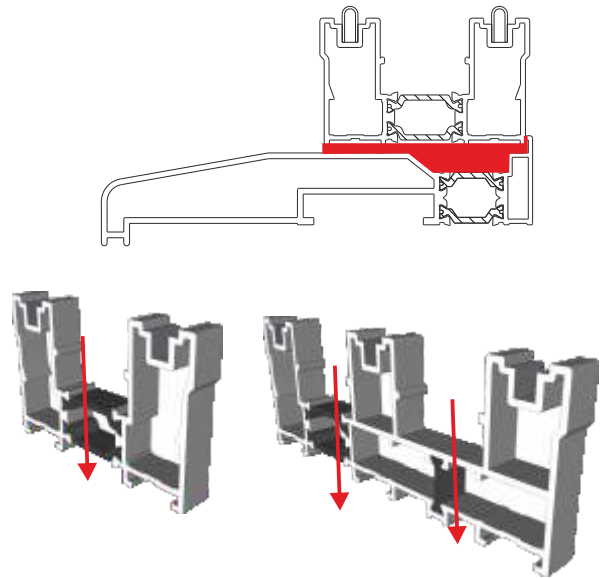
Step One

- Bed projection cill down on silicone.
- Screw fit into position.
- Silicone join all screws to the base for water protection.
- Seal along the sides of the cill as much as possible to create a dam.



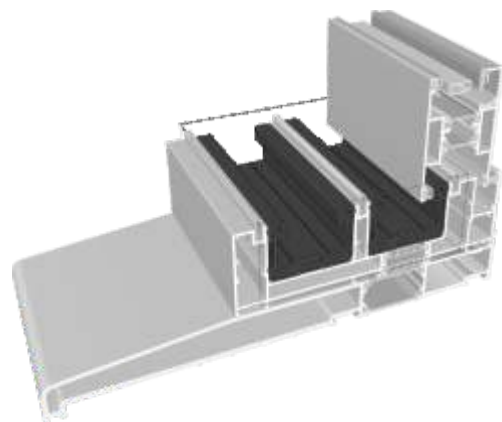
Step Two

- Once the projection cill is screwed down you are now ready for the frame.
- Seal using silicone along the back of the projection cill up stand to protect from water ingress.
- Lift frame into position.
- Fix all sides of the frame.
- See image to right for fixing areas - to be used on all 4 sides of the product.
- Please take care to fit the frame and cill completely level, plumb and square to ensure the product operates correctly when finished.



Step Three

- Once the frame is fully fixed into position and you are happy it is completely level, plumb and square you are then ready to clip the channel infills back into place.
- Make sure these are clipped back into the same position as they were removed.



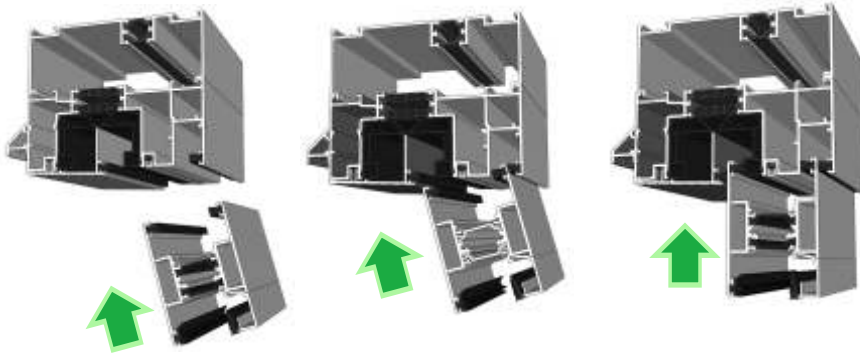
IMPORTANT: Ensure that the frame is fitted plumb, square & level with no bows



Sashes

Installing Door Sashes

Figure 1



Sliding door is fitted to the inside as standard

GLAZING :Sashes are internally beaded allowing glazing to be completed after installation

- Locate top of door sash to head of outerframe (figure 1).
- Check the angle of insertion, too big or too small will result in damage.
- Insert Sash into outerframe head
- Swing bottom of sash into lower outerframe track.(figure 2).

REMOVE ANTI LIFT

If anti lift already fitted:

- Remove panels from frame
- Remove woolpile from interlock
- Unscrew woolpile carrier
- Unclip VG530

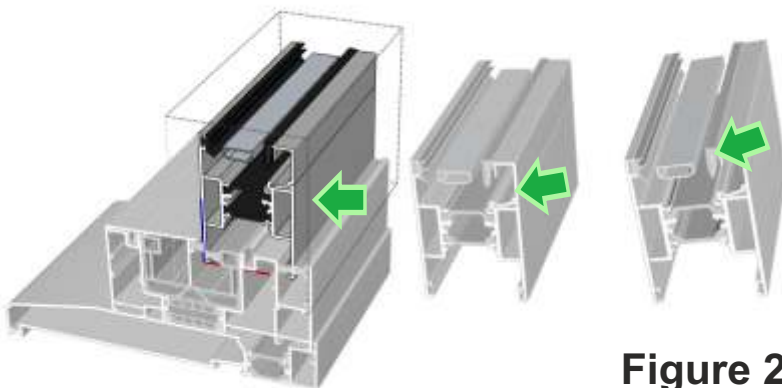


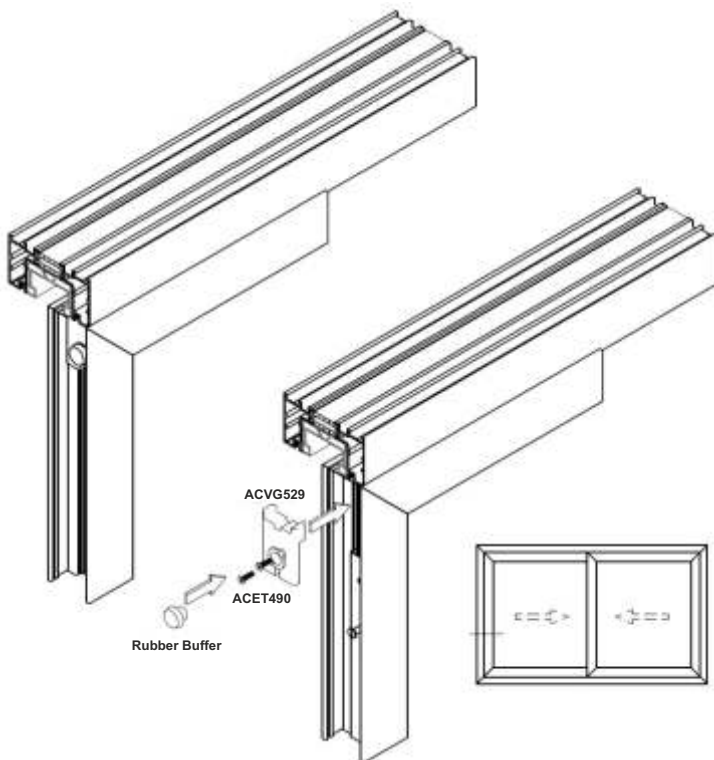
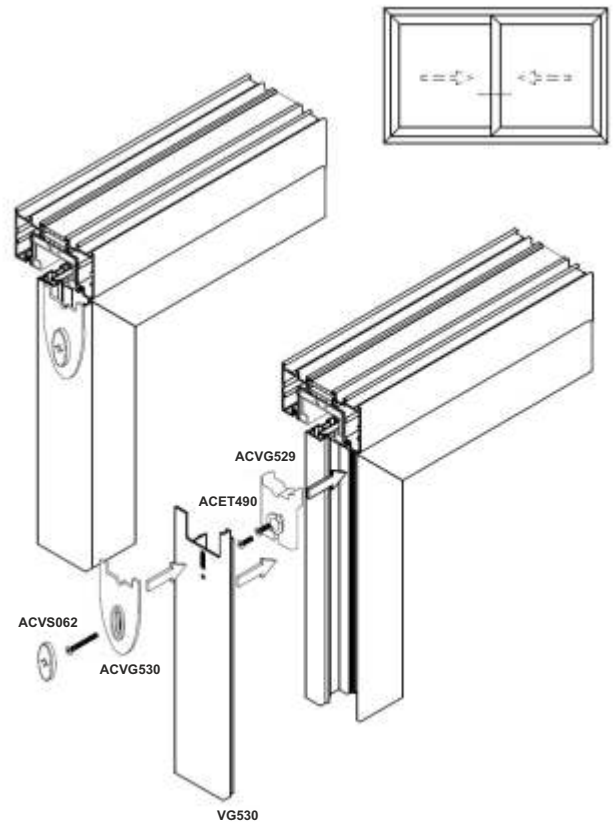
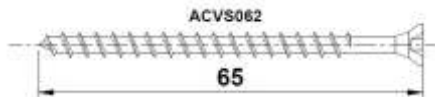
Figure 2

Sash Installation

Anti-Lift Blocks

Steps

- With Sash already fitted into the outerframe:
- Fit ACVG529 to the head & cill using ACET490 screws
- Clip VG530 into position
- Fix ACVG530 onto VG530 at head & cill using ACVS062 polyamide screw and clip on screw cover cap.



Steps

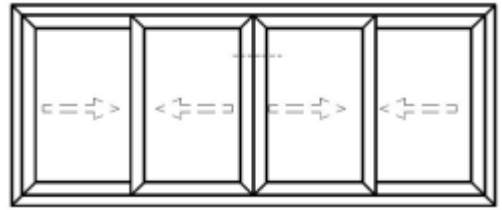
- With Sash already fitted into the outerframe:
- Fit ACVG529 to the head & cill using ACET490 screws
- Push fit the rubber buffers into both ACVG529's

Interlock Mullion

Meeting Stile Adaptor Preparation

Fitting

- Ensure brush and end caps are fitted to meeting stile.



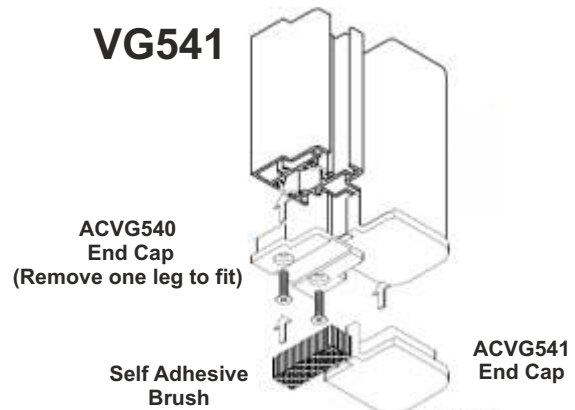
IMPORTANT: VG540/VG541 must be fitted after sashes have been positioned in track.



VG540



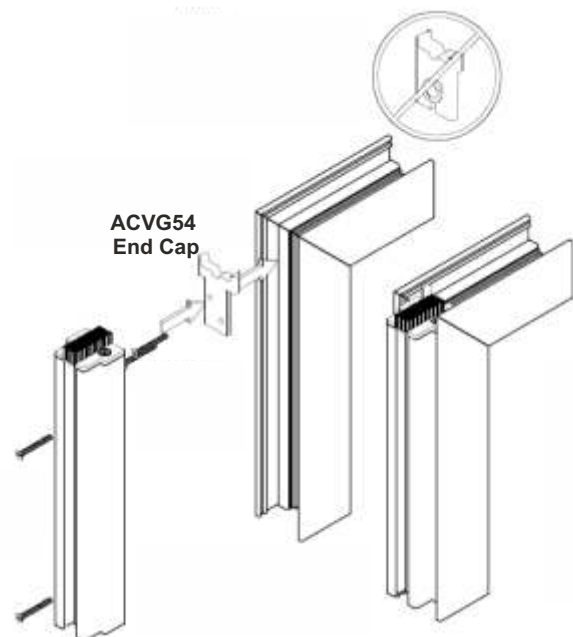
VG541



- Fit assembled meeting stiles onto sashes.

ACVG529 is not required on locking side of the secondary door sash.

ACVG545 must be used instead.



Slim Interlock - Tape Method

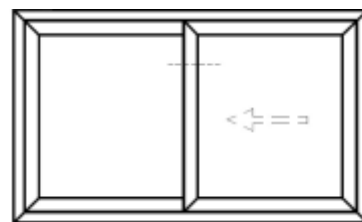
Slim Interlock Tape Method

IMPORTANT: It is recommended glazing the sash a day prior to installation to allow tape to cure



Preparation

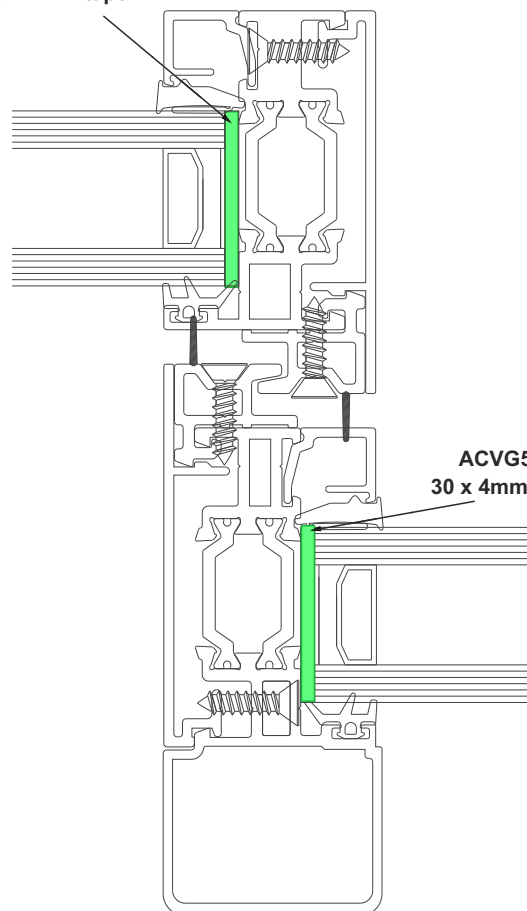
- Remove temporary protective tape from the glazed units.
- Use a suitable solvent cleaner and non abrasive cloth to remove any residue.
- Carefully remove the backing (usually yellow) of the adhesive tape which is located on the interlock.



Fitting

- Without touching the butyl, glass edge or adhesive face of the tape, pack glass correctly into sash.
- The adhesive tape requires 24 - 48 hours to fully cure. Do not operate door from interlock in this time.

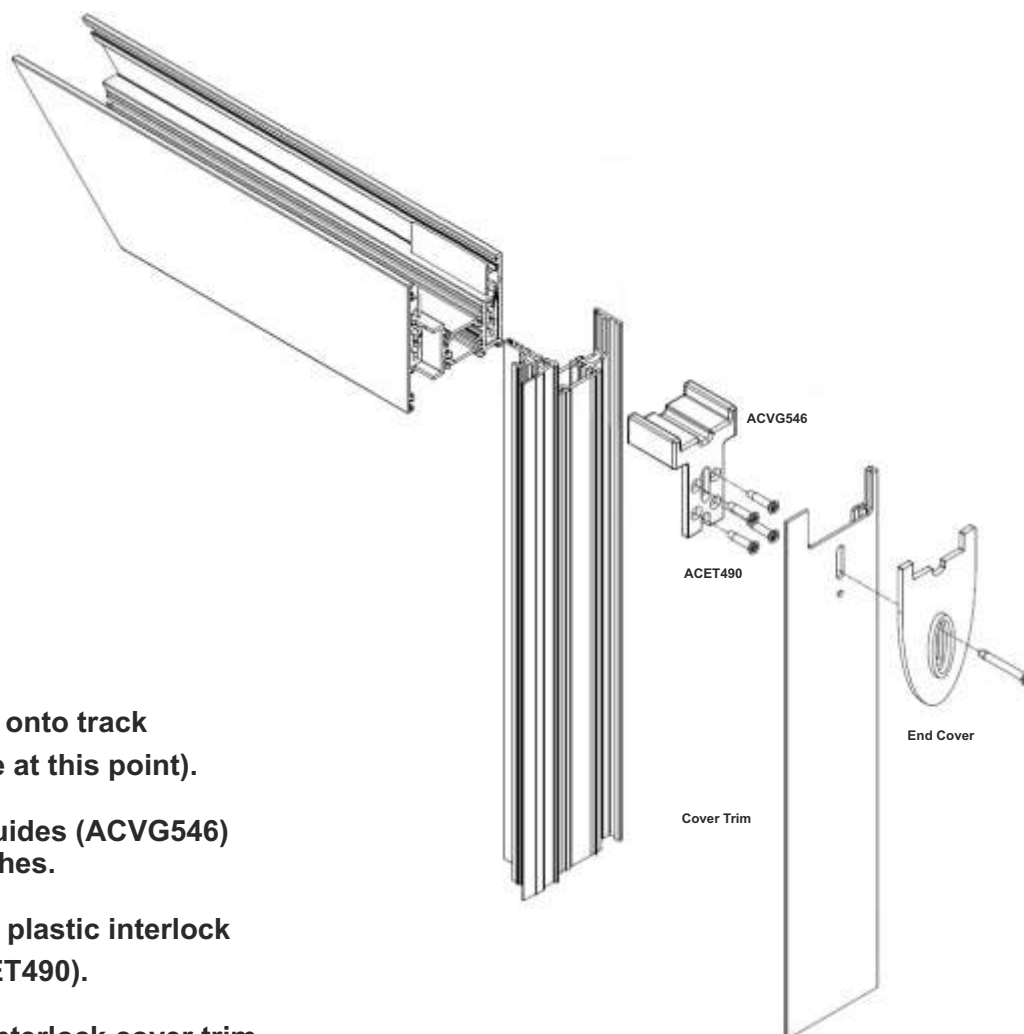
ACVG537
30 x 4mm tape.



ACVG537
30 x 4mm tape.

Slim Interlock Assembly

Slim Interlock Assembly



Fitting

- Fit first door onto track (do not glaze at this point).
- Fit anti lift guides (ACVG546) onto the sashes.
- Unscrew the plastic interlock screws (ACET490).
- Clip on the interlock cover trim.
- Fit interlock end covers and screw into place.
- Re-fit interlock support screws.
- Carefully fit screws into glazing channel ensuring they do not penetrate the unit.

Interlock Seals

ACUG830 Fitting Detail

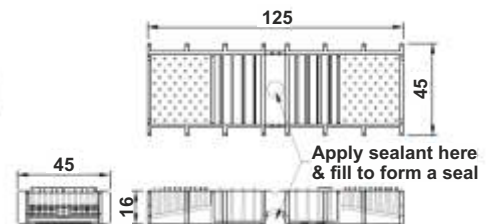
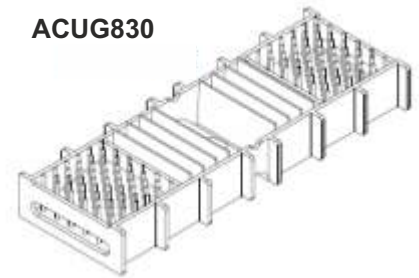
Interlock Seals

- Rubber seals are located on the top and bottom of all frames where interlocks meet. If fitting on site required, read the below.

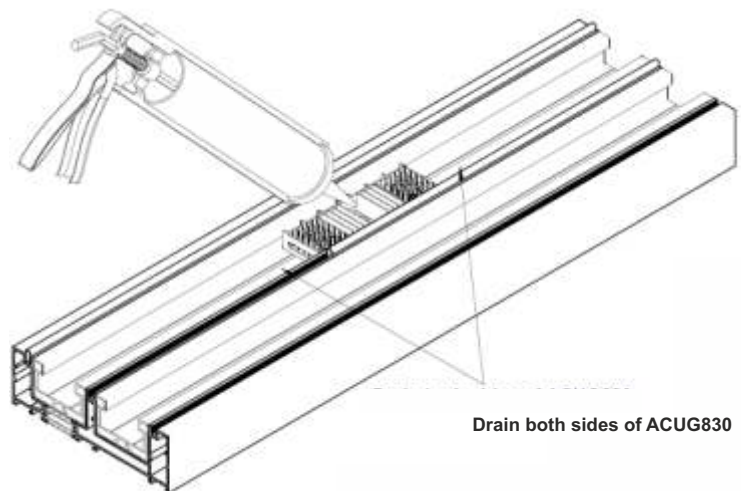
Fitting

- Ensure doors are fitted first.
- Close doors.
- Slide rubber closer into correct position (sitting equally underneath the interlocks).
- Apply sealant where indicated.

ACUG830



IMPORTANT: Whilst sealant sets, take extra care when sliding doors as seals may move.

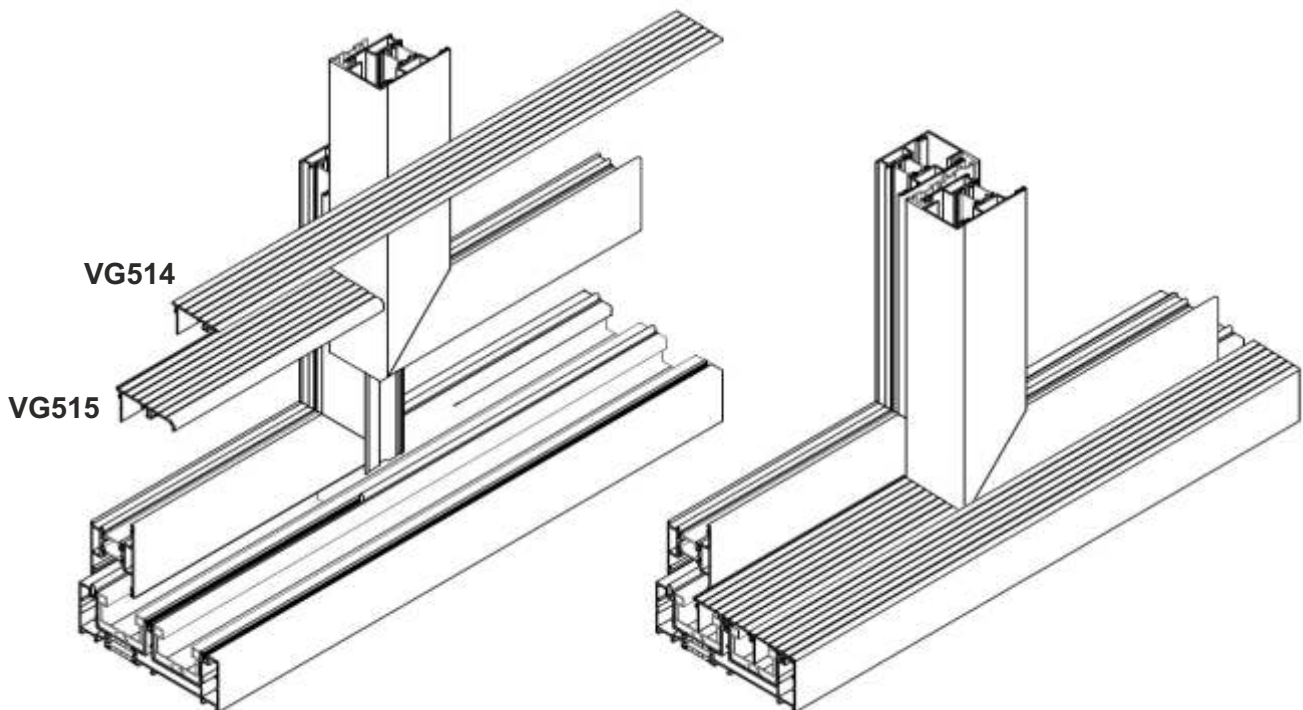
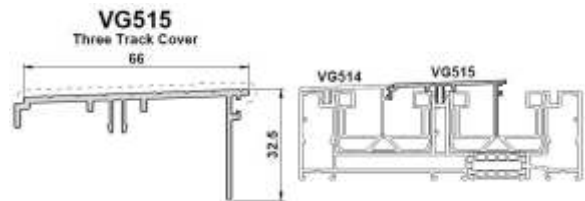
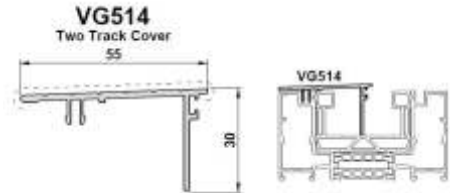


Cover Plates

VG514 (Two Track Cover) - VG515 (Three Track Cover)

Fitting

- These are supplied pre cut.
- Once installation is complete fit by gently tapping with a rubber mallet.
- Ensure a snug fit.
- Bottom tread will have notches for the drainage and notching locally to ACUG830 (see page 11).



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Adjustable Wheels

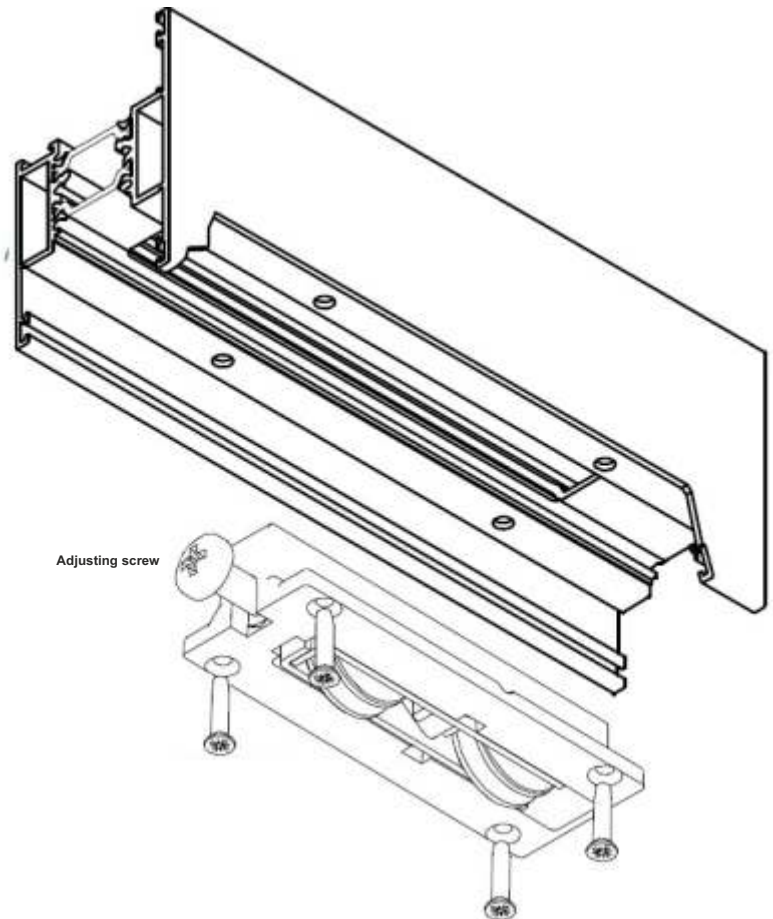
ACVG555 Adjustable Roller

WARNING: Be careful not to over adjust and damage the wheel



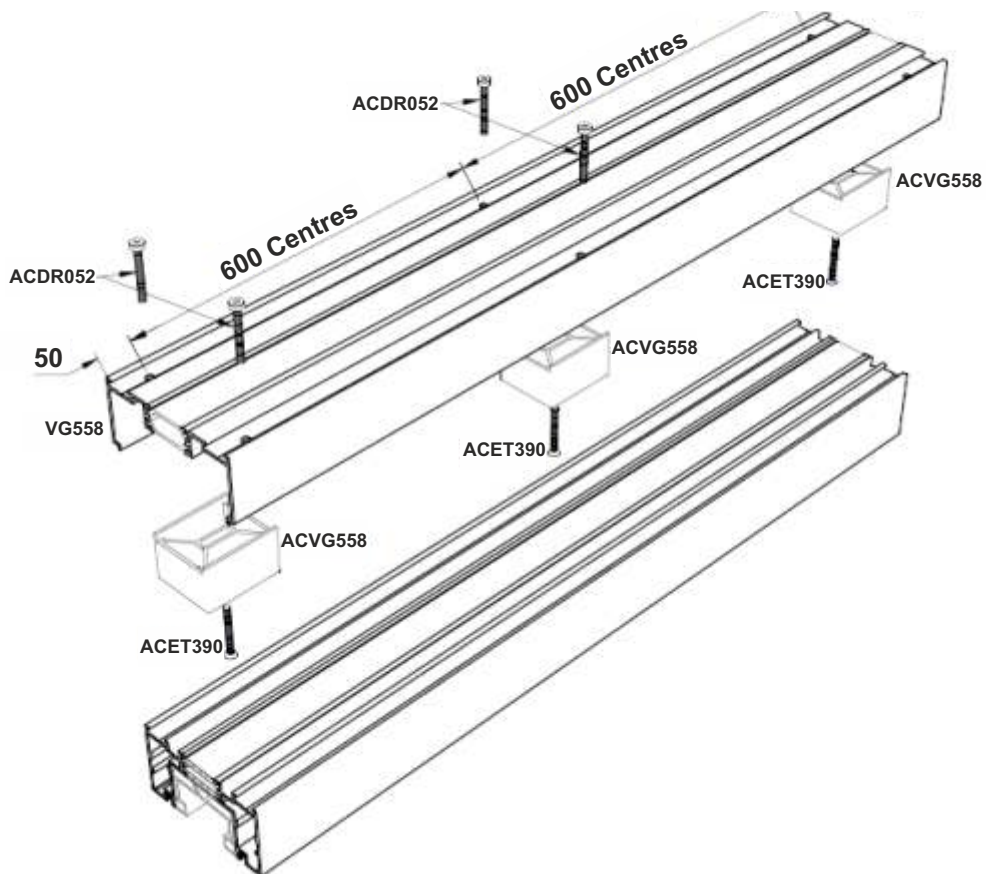
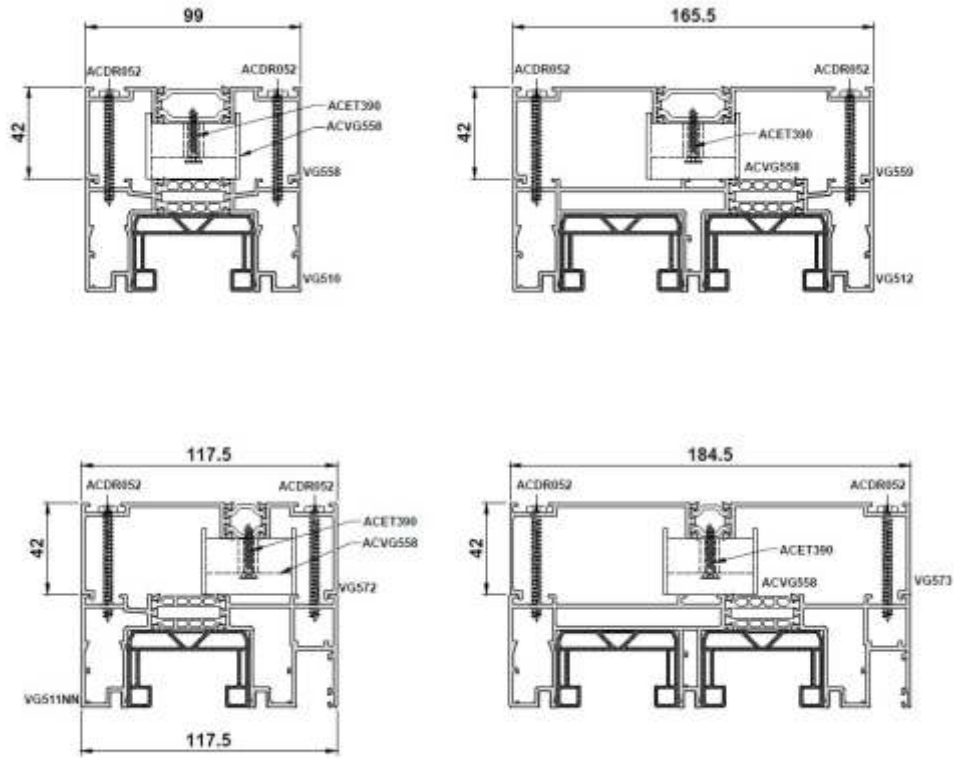
Adjusting

- ACVG555 Adjustable Roller allows for adjustments in height.
- A long range large PZ screwdriver is required.
- Open the slider to give access
- Remove anti-lift guides/interlock covers if fitted.
- Locate adjuster screw located between sash and track.
- Tighten to raise, loosen to lower



Head Extension

Head Extension Fitting Details



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