



**TECHNICAL
MANUAL**
THE PATIO DOOR
SPECIALIST



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PROPERTIES
SYSTEMS TECH


IN-LINE SLIDING PATIO DOOR

Issue: 27
Date: 19/10/2020
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In-Line Sliding Patio Door Contents



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In-Line Sliding Patio Door

Introduction



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The In-line Sliding Patio Door uses a dedicated 86mm deep frame profile which reduces to 70mm deep at the rear which makes it compatible with the full range of 70mm ancillary profiles, add-ons, cills etc. from Profile 22.

The system also offers a choice of 60mm deep sash profiles (chamfered and feature), provided with co-extruded glazing gasket. 28mm glazing is offered as standard using 2365 (bevelled) & 2395 (feature) glazing beads. Unfortunately triple glazing above 28mm cannot be accommodated.

A number of door options are available, where the minimum/maximum sash width/height is 785/1816mm and 1500/2274mm respectively.

White and a number of popular foiled finishes are available from stock. Additional non-stock foiled finishes are also available via our foilexpress service. For a full list of foil finishes and their availability please refer to the PatioMaster Palette brochure.

A bi-parting 6 point lock as standard. Handle finishes are White, Gold, Chrome, Black, Satin Silver, Athracite Grey, Bronze and Graphite.

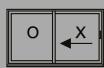
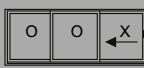

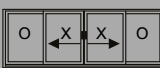
A thermally broken low threshold (Black or White painted) is available. This incorporates a black PVC-U threshold and is suitable for sheltered external applications.

Enhanced security performance is available for 2-pane doors only. For full details please refer to the PAS24 details contained in this manual.

In-Line Sliding Patio Door Parts Breakdown/Deduction Chart



SECTION	DATE	ISS	REFERENCE	PAGE
DEDUCTIONS & PARTS BREAKDOWN	OCTOBER 2020	27	TM-0002	4

PART NO.	DESCRIPTION	 2 PANE		 3 PANE END SLIDER		 3 PANE CTR. SLIDER		 4 PANE	
		DEDUCTION	QTY	DEDUCTION	QTY	DEDUCTION	QTY	DEDUCTION	QTY
1200	OUTER FRAME WIDTH	OW	2	OW	2	OW	2	OW	2
	OUTER FRAME HEIGHT-MECH. JOINTED TO CILL ONLY (LOW THRESHOLD)	OH-11	2	OH-11	2	OH-11	2	OH-11	2
	OUTER FRAME HEIGHT-MECH. JOINT	OH-52	2	OH-52	2	OH-52	2	OH-52	2
	OUTER FRAME HEIGHT -WELDED	OH	2	OH	2	OH	2	OH	2
1251/1252*	SASH WIDTH	(OW/2)-2	4	(OW/3)+25	6	(OW/3)-3	6	(OW/4)+18	8
	SASH HEIGHT (STD THRESHOLD)	OH-84	4	OH-84	6	OH-84	6	OH-84	8
	SASH HEIGHT (LOW THRESHOLD)	OH-58	4	OH-58	4	OH-58	4	OH-58	4
1262 (see note 5.)	O/FRAME REINFORCEMENT WIDTH & HEIGHT -WELDED	OW-80	2	OW-80	2	OW-80	2	OW-80	2
	O/FRAME REINFORCEMENT HEIGHT -MECH. JOINT	OH-200	2	OH-200	2	OH-200	2	OH-200	2
1257 (see note 4.)	SASH REINFORCEMENT WIDTH	SW-136	2	SW-136	2	SW-136	2	SW-136	4
	SASH REINFORCEMENT HEIGHT	SH-136	2	SH-136	4	SH-136	3	SH-136	4
1289	COVER PROFILE	SH	1	SH	2	SH	1	SH	2
	COVER PROFILE (TO THRESHOLD ONLY)	SH-21	1	SH-21	2	SH-21	1	SH-21	2
1204	DISTANCE PROFILE 300mm LTH	-	8	-	12	-	16	-	16
1253	JAMB & HEAD TRIM-HEAD	(OW/2)-93	1	(OW/3)-62	3	((OW/3)x2)-89	1	(OW/2)-120	1
	JAMB & HEAD TRIM-LOCK JAMB (USING 1263)	OH-57	1	OH-57	1	-	-	-	-
	JAMB & HEAD TRIM- FIXED JAMB (USING 1263)	OH-57	1	OH-57	1	OH-57	1	OH-57	1
	JAMB & HEAD TRIM-LOCK JAMB (USING L1335)	OH-39	1	OH-39	1	-	-	-	-
	JAMB & HEAD TRIM- FIXED JAMB (USING L1335)	OH-39	1	OH-39	1	OH-39	1	OH-39	1
1254	CLOSURE PROFILE -HEAD	OW-250	1	2xOW/3) -266	1	(2xOW/3) -216	1	OW-395	1
	CLOSURE PROFILE -LOCK JAMB	(OH/2)-514	2	(OH/2)-514	2	(OH/2)-514	2	(OH/2)-514	2
1255	DRAINAGE TRIM	(OW/2)-83	1	(OW/3)-110	1	(OW/3)-80	1	(OW/4)-57	2
1256	SASH MEETING PROFILE	N/A	-	N/A	1	SH-32	1	SH-32	1
1474/1	DOOR INTERLOCK	SH	2	SH	4	SH	2	SH	4
1261	TRACK	OW-250	1	(2xOW/3) -266	1	(2xOW/3) -216	1	OW-395	1
1263	THRESHOLD- ALU' BOTTOM	(OW/2)-93	1	(OW/3)-62	1	(2xOW/3)-89	1	(OW/2)-120	1
1351	BRUSH SEAL	CUT TO LTH	-	CUT TO LTH	-	CUT TO LTH	-	CUT TO LTH	-
1273	INTERLOCK BRUSH SEAL (12mm)	SH	2	SH	4	SH	2	SH	4
22480	MIDRAIL -MECH. JOINTED	SW-116	2	SW-116	3	SW-116	3	SW-116	4
2365 & 2395	BEAD	CUT TO LTH	8	CUT TO LTH	12	CUT TO LTH	12	CUT TO LTH	16
(L) 1334	T/BROKEN LOW THRESHOLD	OW	1	OW	1	OW	1	OW	1
L 1335	T/BROKEN LOW THRESHOLD TRIM	(OW/2)-93	1	(OW/3)-62	1	(2xOW/3)-89	1	(OW/2)-120	1

-	EQUAL GLASS WIDTH DEDUCTION	OW-270/2	-	OW-324/3	-	OW-408/3	-	OW-460/4	-
-	SASH WIDTH GLASS DEDUCTION	SW-133	-	SW-133	-	SW-133	-	SW-133	-
-	SASH HEIGHT GLASS DEDUCTION	SH-133	-	SH-133	-	SH-133	-	SH-133	-
-	MIDRAIL GLASS DEDUCTION STD. THRESHOLD	SMH-152.5	-	SMH-152.5	-	SMH-152.5	-	SMH-152.5	-
-	MIDRAIL GLASS DEDUCTION LOW THRESHOLD	SMH-126.5	-	SMH-126.5	-	SMH-126.5	-	SMH-126.5	-
-	ABOVE MIDRAIL GLASS WIDTH DEDUCTION	(OH-SMH)-152.5	-	(OH-SMH)-152.5	-	(OH-SMH)-152.5	-	(OH-SMH)-152.5	-

Notes:

Width deductions are based on equal glass sizes.

Max. Sash height must not exceed 2.5 x sash width.

On a 4 pane slider the master door is the left hand sash when viewed from inside.

SMH - Standard Midrail Height

Dimensions in MM
All dimensions are nominal.
DO NOT SCALE

Handles:

Left Hand - view from inside, door sliding to the left.


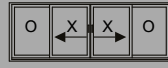
Right Hand - view from inside, door sliding to the right.

*For simplicity 1252 feature sash will not be referred to within this manual as all technical details are the same as 1251. Where details differ this will be clearly identified.

In-Line Sliding Patio Door Parts Breakdown



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PART NO	DESCRIPTION	   			
		2 PANE	3 PANE END SLIDER	3 PANE CTR. SLIDER	4 PANE
QUANTITY	QUANTITY	QUANTITY	QUANTITY	QUANTITY	
1270	END CAP FOR 1256	N/A	N/A	2	2
1272	DUST PLUG	2	2	2	4
1268	JOINTING CLEAT-1200	4	4	4	4
1480	PATIO DOOR MAIN LOCK	1	1	1	1
1482	STAINLESS KEEP	1	1	1	1
(D)(H)(L)(T) 1460L	KEY-KEY HANDLE LH	1	1	1	1
(D)(H)(L)(T)(AG)(BZ)(GP) 1460R	KEY-KEY HANDLE RH	1	1	1	1
(D)(H)(L)(T)(AG)(BZ)(GP) 1461	BLANK-BLANK HANDLE	N/A	N/A	N/A	1
(D)(H)(L)(T) 1462	KEY-BLANK HANDLE	1	1	1	1
(D)(H)(L)(T) 1463	HANDLE BLANK PLATE	N/A	N/A	N/A	1
(S)(D)1477EN	40/40 EURO CYLINDER	1	1	1	1
(S)(D)1478EN	40/40 EURO THUMBTURN CYLINDER	1	1	1	1
(S)(D)1479EN	40/10 EURO HALF CYLINDER	1	1	1	1
1350	ANTI-LIFT BRACKET	1	1	1	2
1486	ROLLERS -LOW PROFILE	2	2	2	4
1473	BUMP STOP 1 PAIR	1	1	1	2
1258	ROUTED STEEL FOR SASH LOCK JAMB	1	1	1	2
1260	OUTER KEEP REIF. LENGTH =1760mm	1	1	N/A	N/A
1266	ALUMINIUM REINFORCEMENT SASH MEETING PROFILE	N/A	N/A	1	1
7756	22480 MIDRAIL MECH. JOINT -50mm LG	2 PER MIDRAIL	2 PER MIDRAIL	2 PER MIDRAIL	2 PER MIDRAIL
1375	LETTER PLATE	1	1	1	1
1287	SASH TO FRAME SCREW 82mm LG	6	10	10	12
F7851030	LOCK/SASH	10	10	10	10
F7600038	KEEP/OUTER	10	10	10	10
F7851016	ROLLER/SASH	4	4	4	8
F7851030	INTERLOCK/SASH	8	16	8	16
F7851030	ANTI-LIFT BRACKET	3	3	3	6
F7757050	CLEAT/OUTER FRAME (HEAD & CILL)	8	8	8	8
F7660016	CLEAT/OUTER FRAME (JAMBS)	8	8	8	8

Notes:

- OH = Outer Frame Height
OW = Outer Frame Width
SH = Sash Height
SW = Sash Width

- All Deductions exclude weld allowance.
- Vertical deductions exclude optional cill.

- Fully reinforce sliding sashes and only interlock jambs on fixed sashes.

Use 1258 to lock jamb. A standard height sash reinforcement of 1828mm can be used with sashes which fall within the height of 1960mm-2274mm.

- Do not reinforce white, cream foil & white foil outer frames.

- All other foiled outer frames and fixed/sliding sashes must be fully reinforced.

In-Line Sliding Patio Door Patio Style Assembly Section Reference



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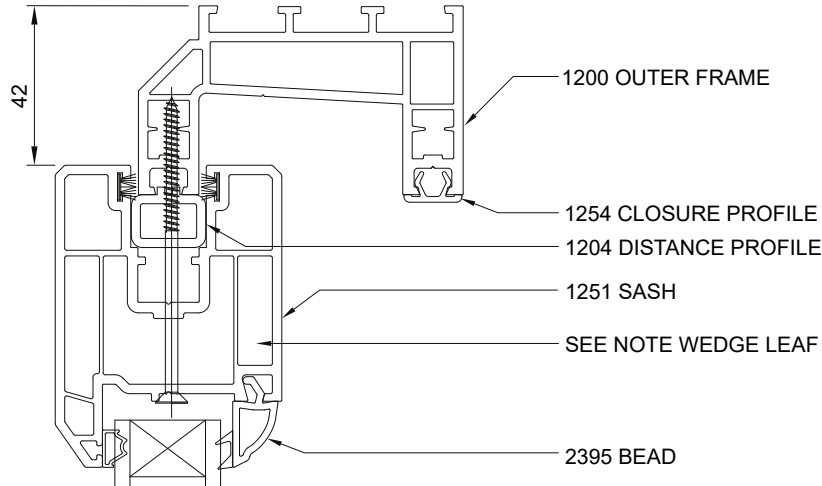
<p>2 PANE END SLIDER</p>	
<p>3 PANE CENTRE SLIDER</p>	
<p>3 PANE END SLIDER</p>	
<p>4 PANE SLIDER</p>	

In-Line Sliding Patio Door Assembly Sections A, B and C



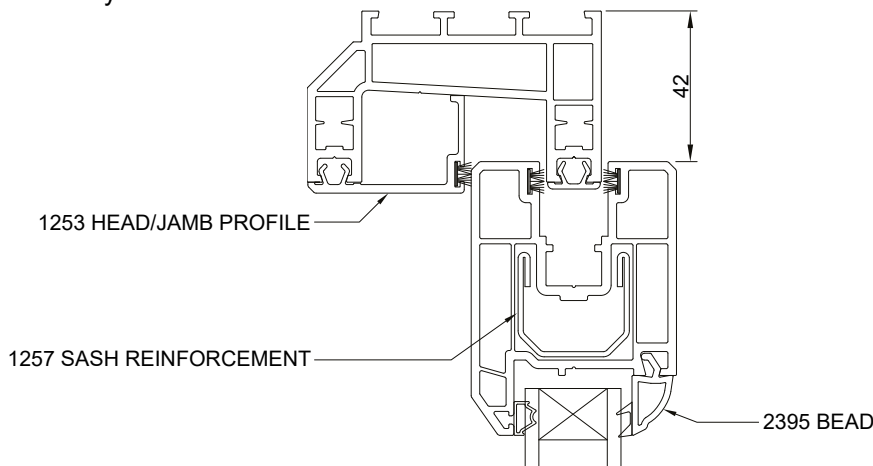
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Assembly Section A



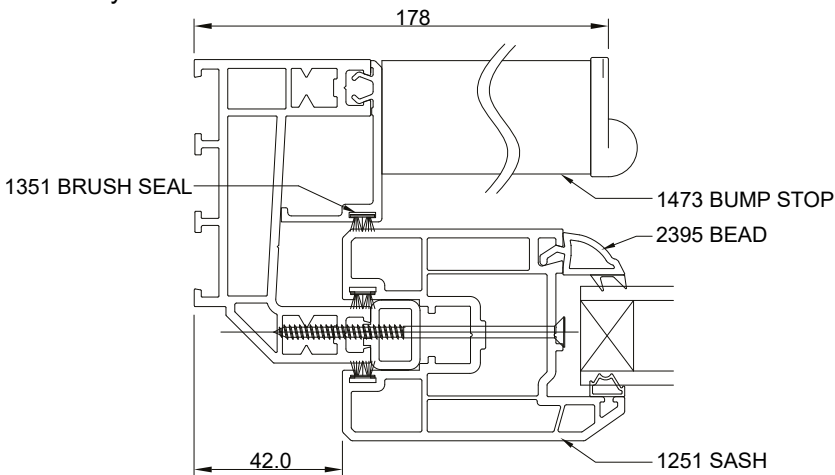
APPLICABLE TO	
	2 PANE END SLIDER
	3 PANE END SLIDER
	3 PANE CTR. SLIDER
	4 PANE SLIDER

Assembly Section B



APPLICABLE TO	
	2 PANE END SLIDER
	3 PANE END SLIDER
	3 PANE CTR. SLIDER
	4 PANE SLIDER

Assembly Section C



APPLICABLE TO	
	2 PANE END SLIDER
	3 PANE END SLIDER
	4 PANE SLIDER

Note:
When positioning the fixed leaf, wedge the leaf towards the outside of the door before fixing to optimise the clearance between the and sliding leaf.

Dimensions in MM
All dimensions are nominal.
DO NOT SCALE

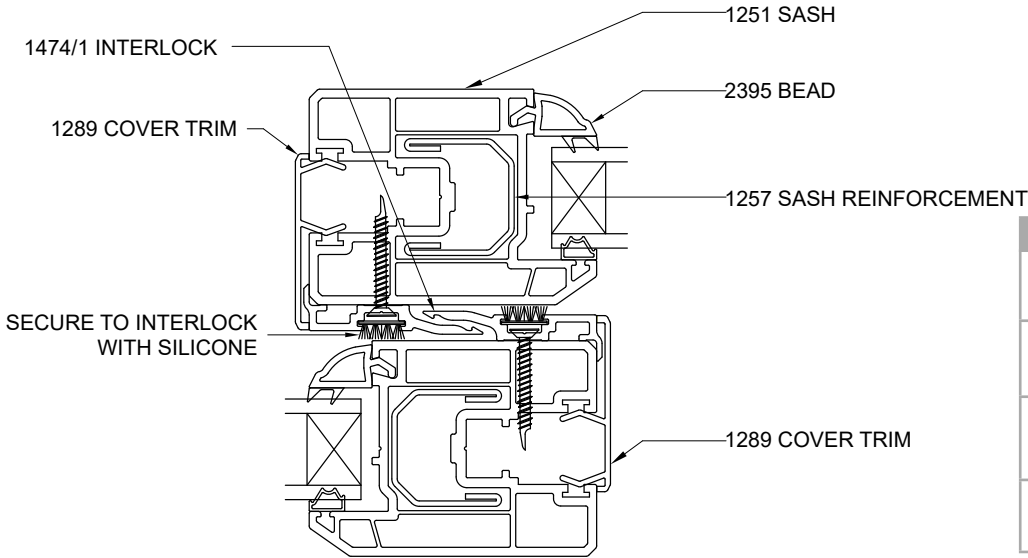
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In-Line Sliding Patio Door Assembly Sections D and E



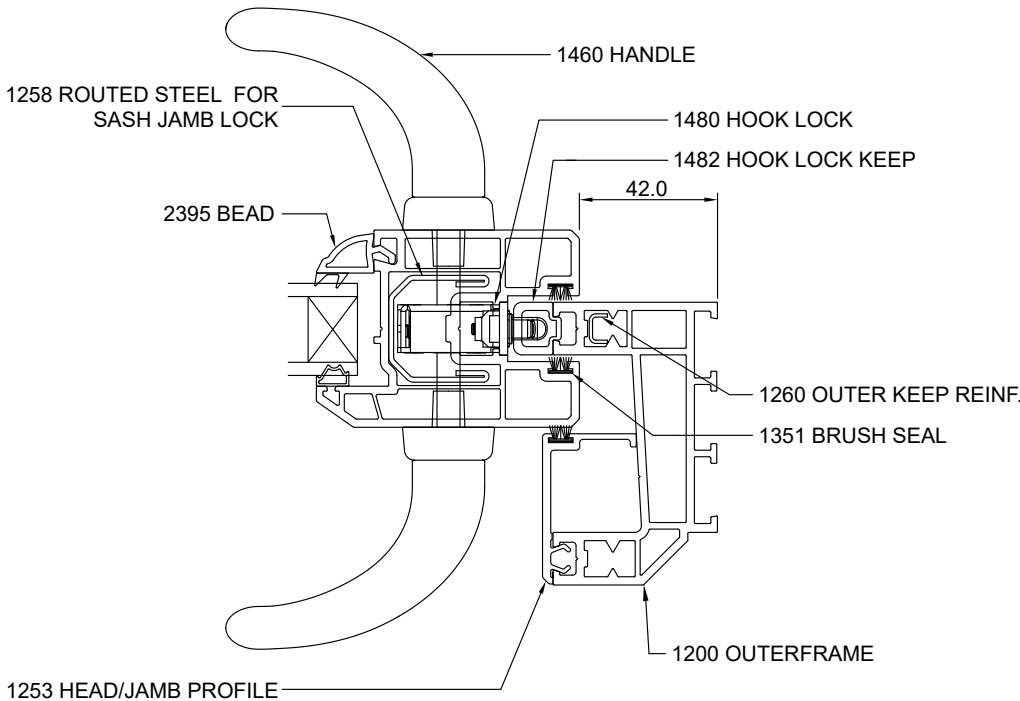
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Assembly Section D



APPLICABLE TO	
	2 PANE END SLIDER
	3 PANE END SLIDER
	3 PANE CTR. SLIDER
	4 PANE SLIDER

Assembly Section E



APPLICABLE TO	
	2 PANE END SLIDER
	3 PANE END SLIDER

Dimensions in MM
All dimensions are nominal.
DO NOT SCALE

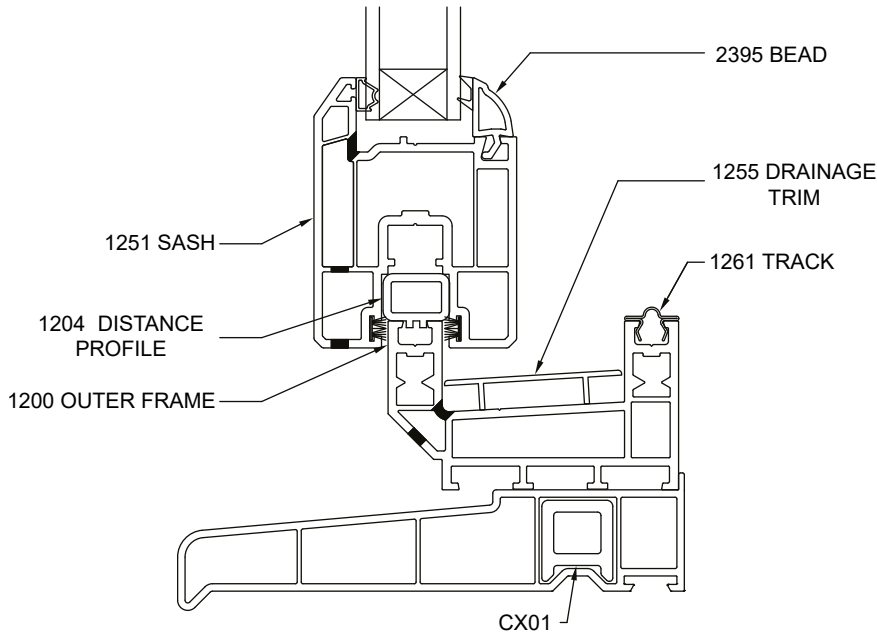
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In-Line Sliding Patio Door Assembly Sections F and G



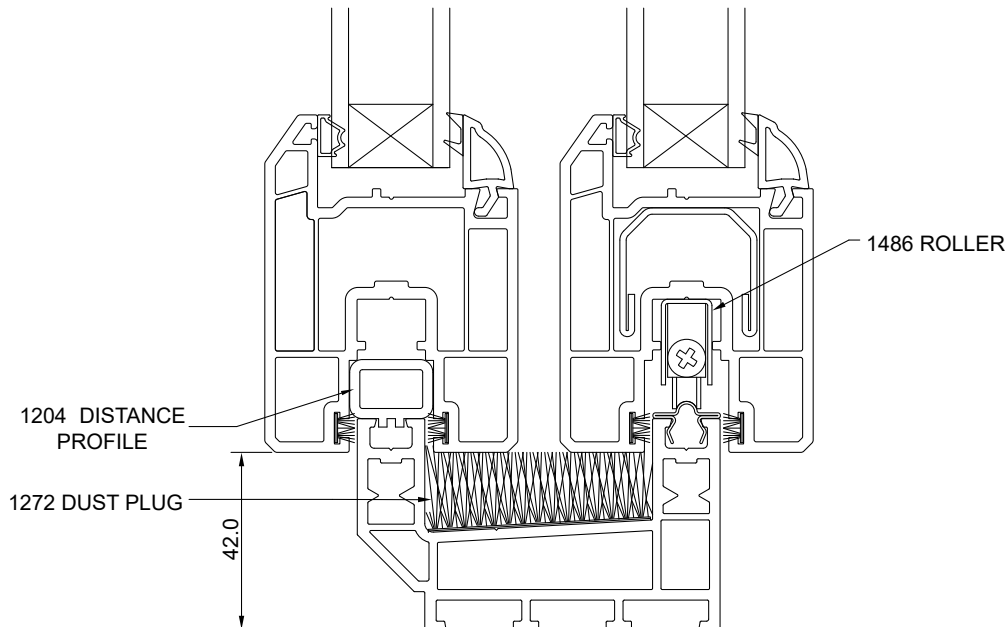
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Assembly Section F



APPLICABLE TO	
	2 PANE END SLIDER
	3 PANE END SLIDER
	3 PANE CTR. SLIDER
	4 PANE SLIDER

Assembly Section G



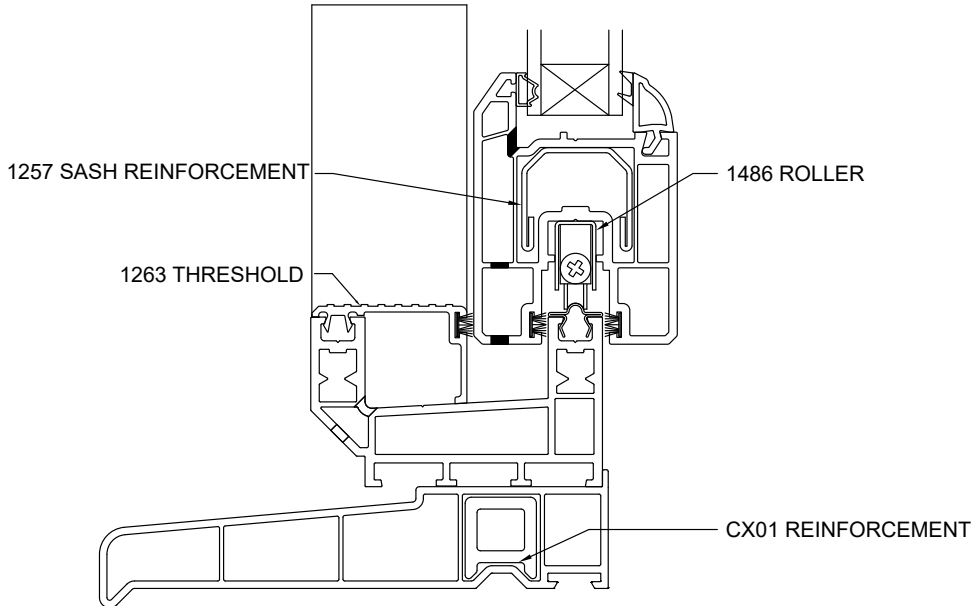
APPLICABLE TO	
	2 PANE END SLIDER
	3 PANE END SLIDER
	3 PANE CTR. SLIDER
	4 PANE SLIDER

In-Line Sliding Patio Door Assembly Sections H and J



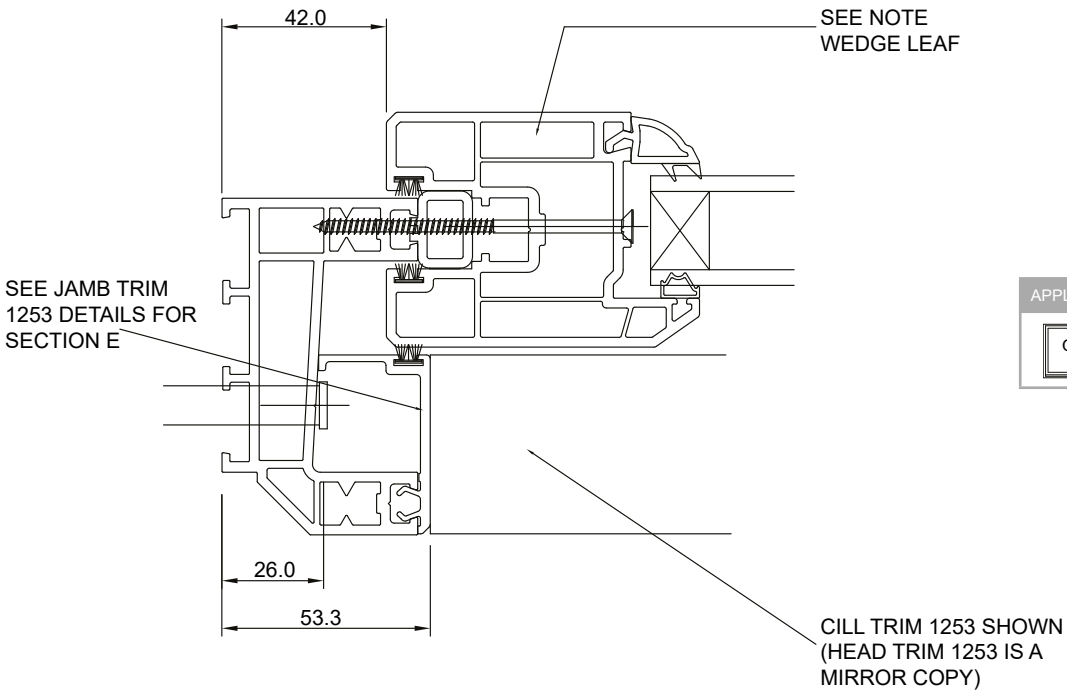
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Assembly Section H



APPLICABLE TO	
	2 PANE END SLIDER
	3 PANE END SLIDER
	3 PANE CTR. SLIDER
	4 PANE SLIDER

Assembly Section J



APPLICABLE TO	
	3 PANE END SLIDER

Note:
When positioning the fixed leaf, wedge the leaf towards the outside of the door before fixing to optimise the clearance between the fixed and sliding leaf.

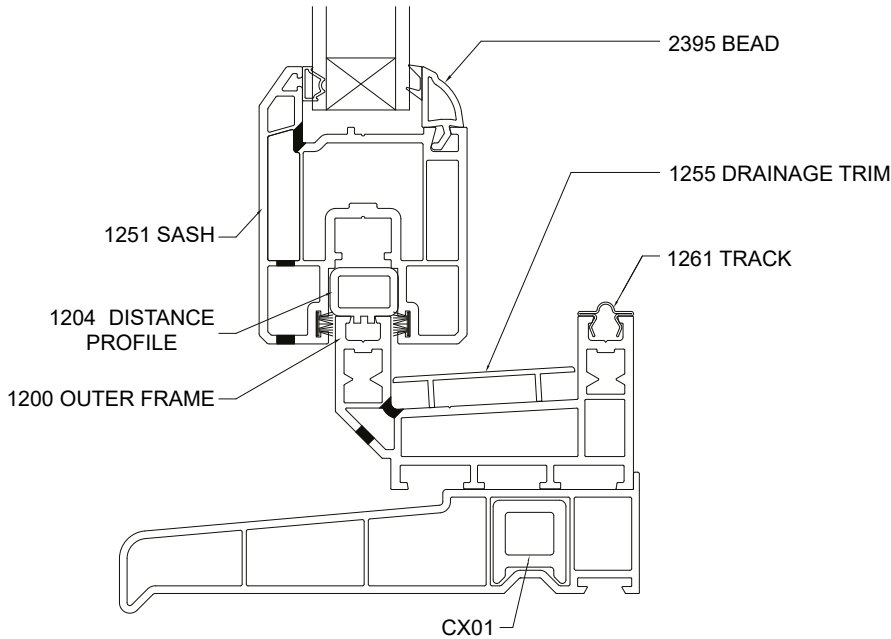
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DO NOT SCALE

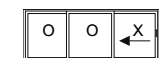
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In-Line Sliding Patio Door Assembly Sections K and L

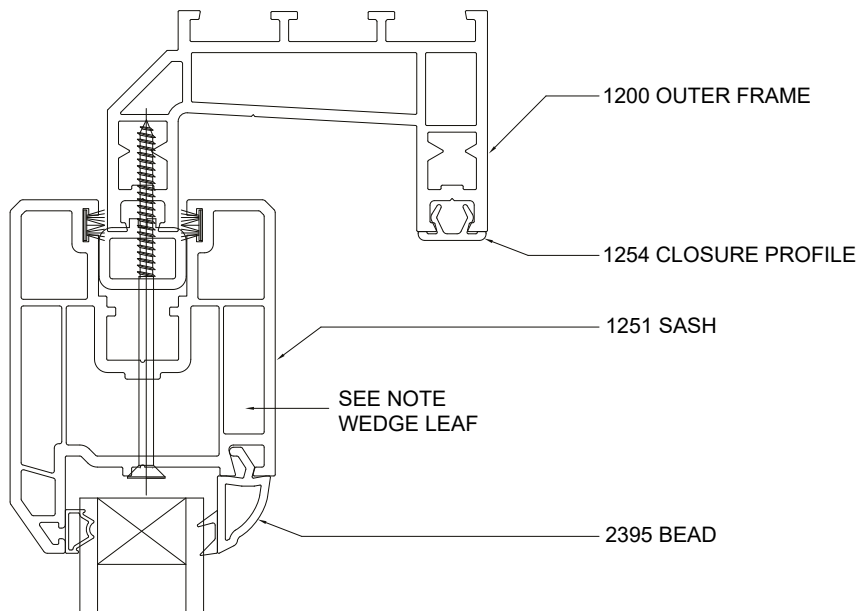
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Assembly Section K



APPLICABLE TO	
	3 PANE END SLIDER

Assembly Section L



APPLICABLE TO	
	3 PANE END SLIDER

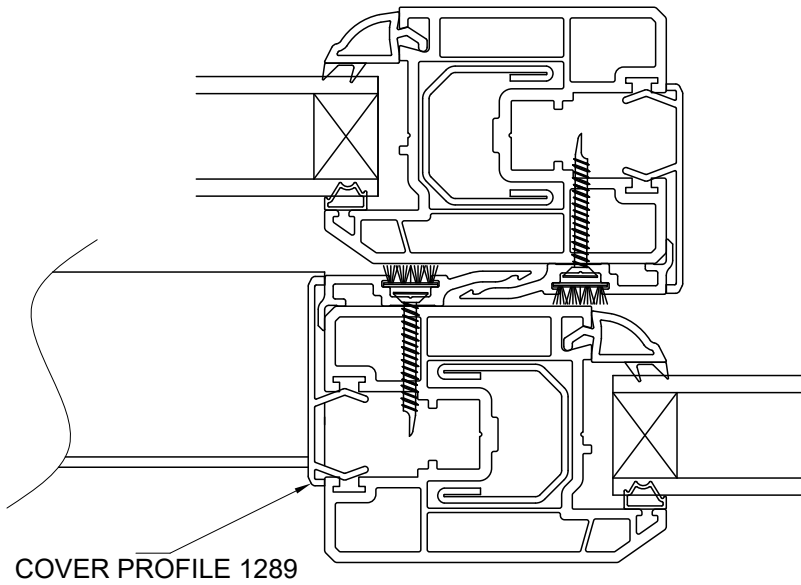
Note:
When positioning the fixed leaf, wedge the leaf towards the outside of the door before fixing to optimise the clearance between the fixed and sliding leaf.

In-Line Sliding Patio Door Assembly Sections M and N



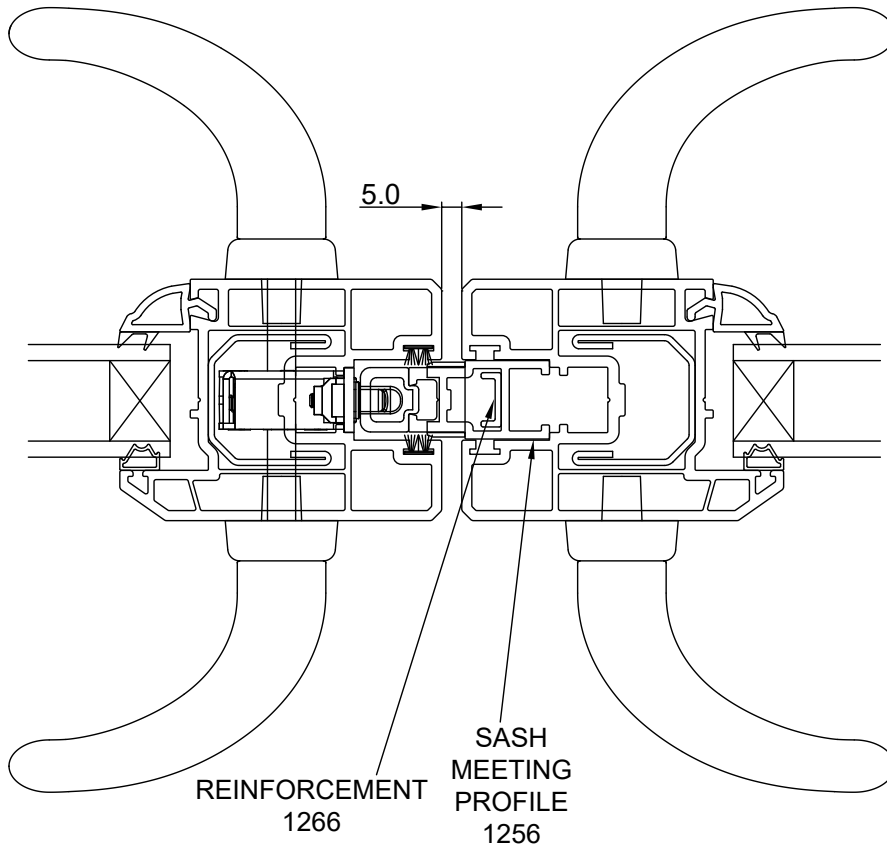
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Assembly Section M



APPLICABLE TO	
	3 PANE END SLIDER

Assembly Section N



APPLICABLE TO	
	4 PANE SLIDER

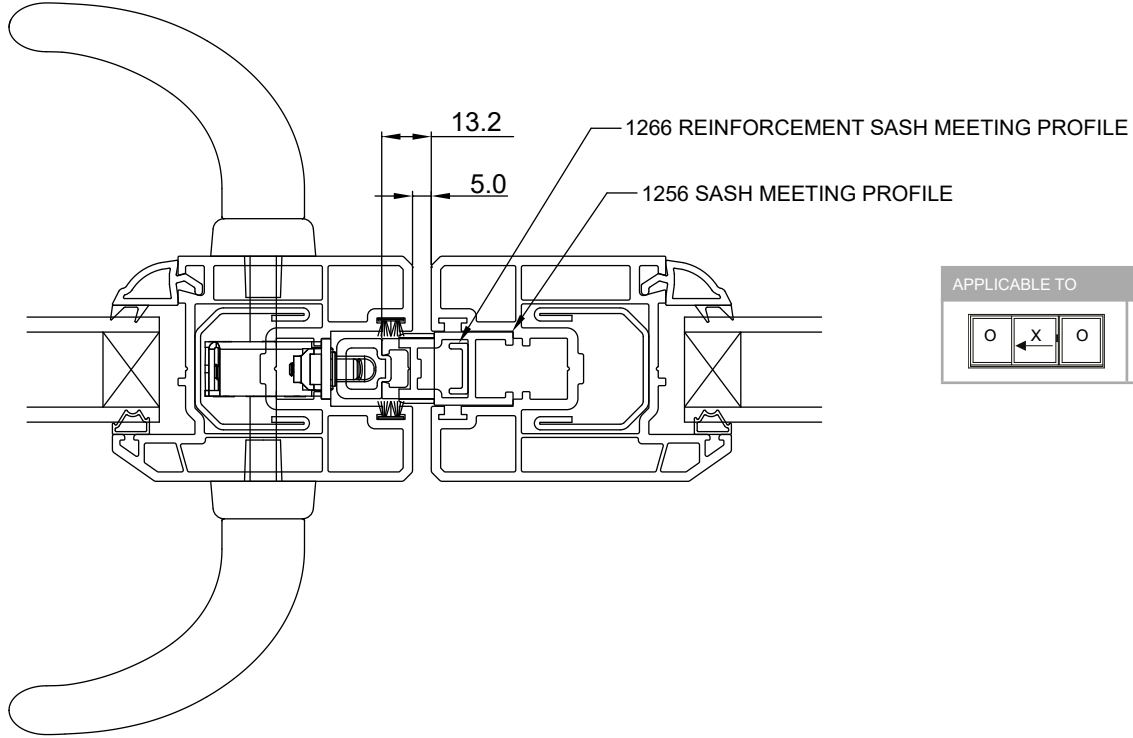
Dimensions in MM
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DO NOT SCALE

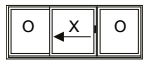
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In-Line Sliding Patio Door Assembly Sections P and Q

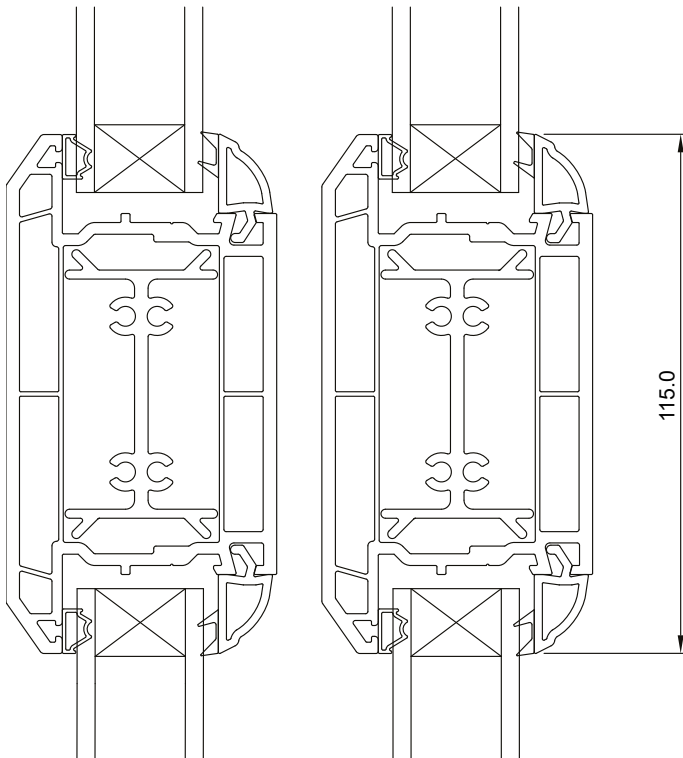
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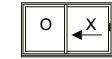
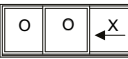
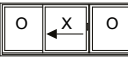
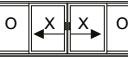
Assembly Section P



APPLICABLE TO	
	3 PANE CTR. SLIDER

Assembly Section Q



APPLICABLE TO	
	2 PANE END SLIDER
	3 PANE END SLIDER
	3 PANE CTR. SLIDER
	4 PANE SLIDER

Dimensions in MM
All dimensions are nominal.
DO NOT SCALE

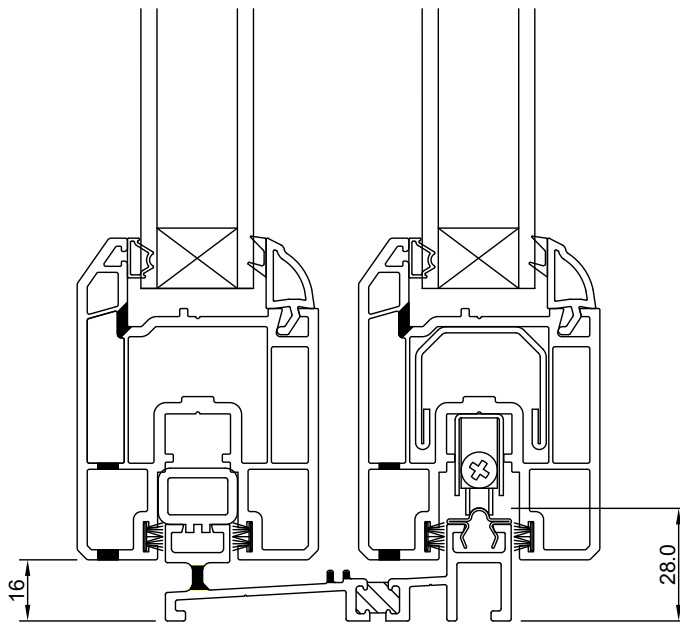
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In-Line Sliding Patio Door Assembly Sections R



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Assembly Section R

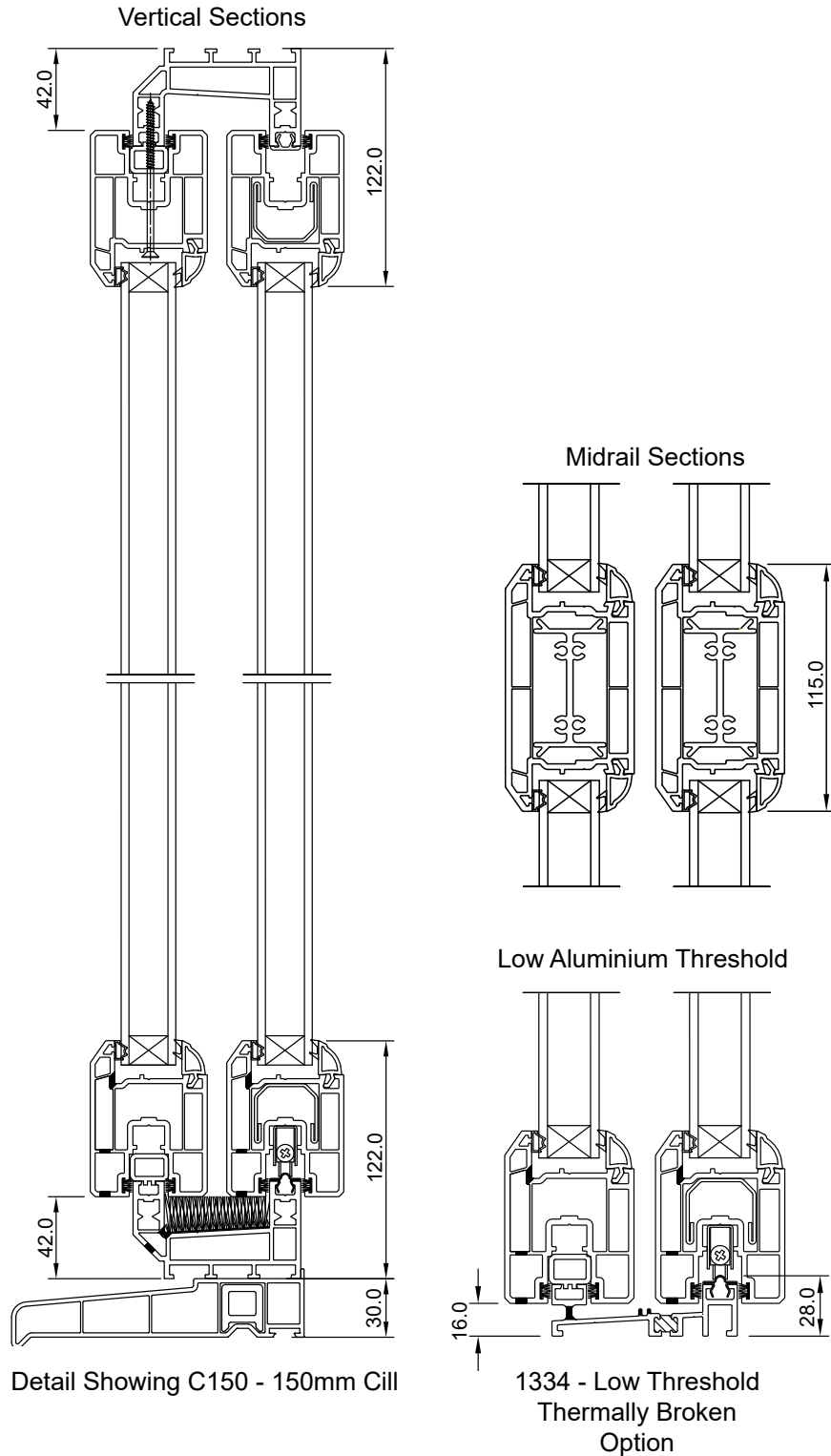


1334 - Low Threshold
Thermally Broken Option

APPLICABLE TO	
	2 PANE END SLIDER
	3 PANE END SLIDER
	3 PANE CTR. SLIDER
	4 PANE SLIDER

In-Line Sliding Patio Door Vertical Sections

SECTION	DATE	ISS	REFERENCE	PAGE
ASSEMBLY SECTION DRAWINGS	OCTOBER 2020	27	TM-0002	15

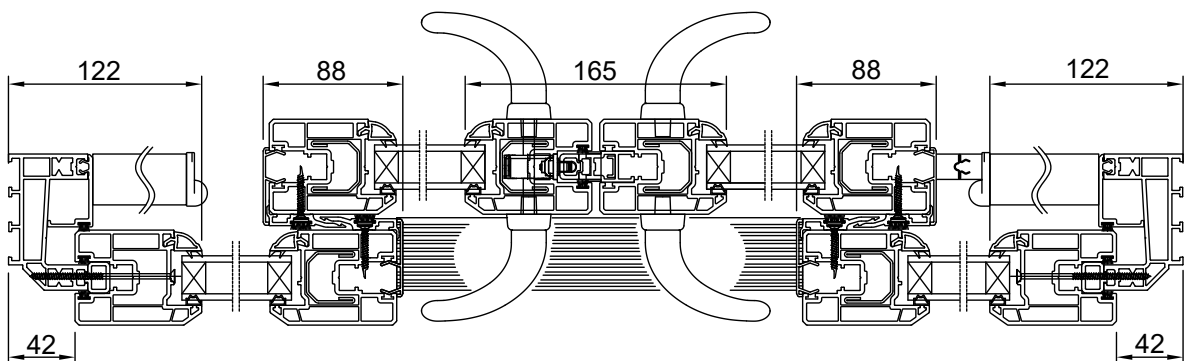
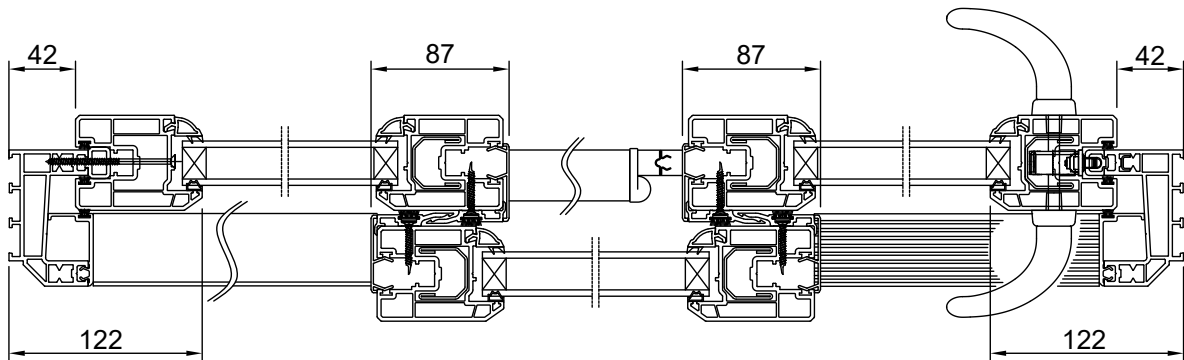
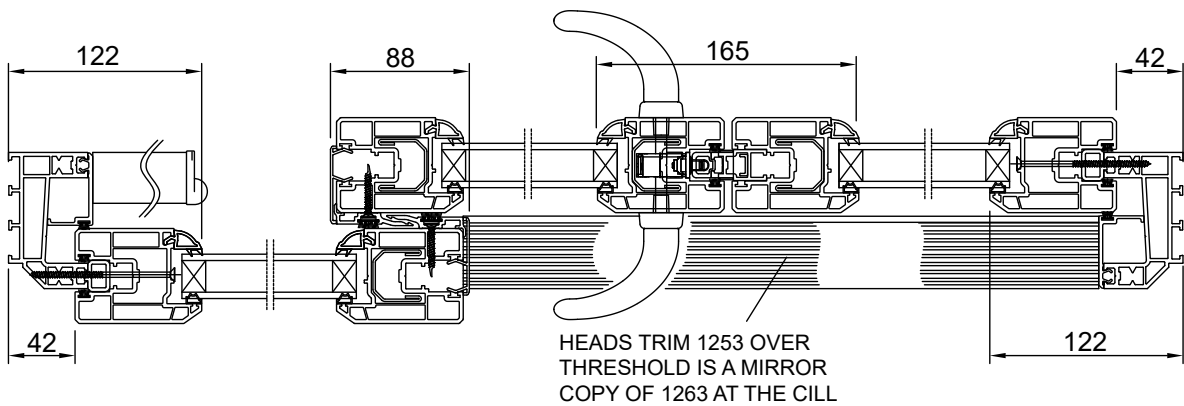
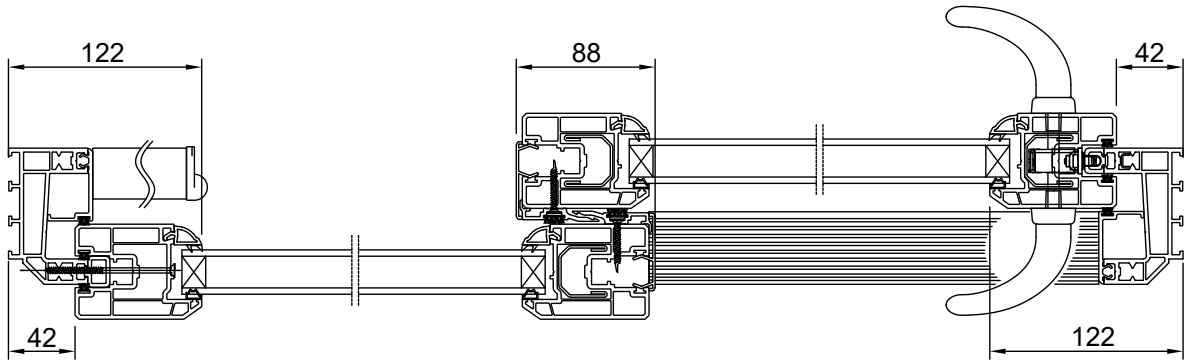


In-Line Sliding Patio Door Horizontal Sections



SECTION	DATE	ISS	REFERENCE	PAGE
ASSEMBLY SECTION DRAWINGS	OCTOBER 2020	27	TM-0002	16

Horizontal Sections



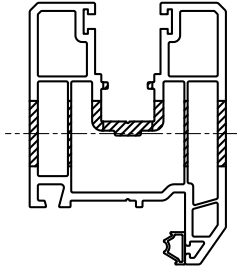
Dimensions in MM
All dimensions are nominal.
DO NOT SCALE

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In-Line Sliding Patio Door Handed Lock Routing

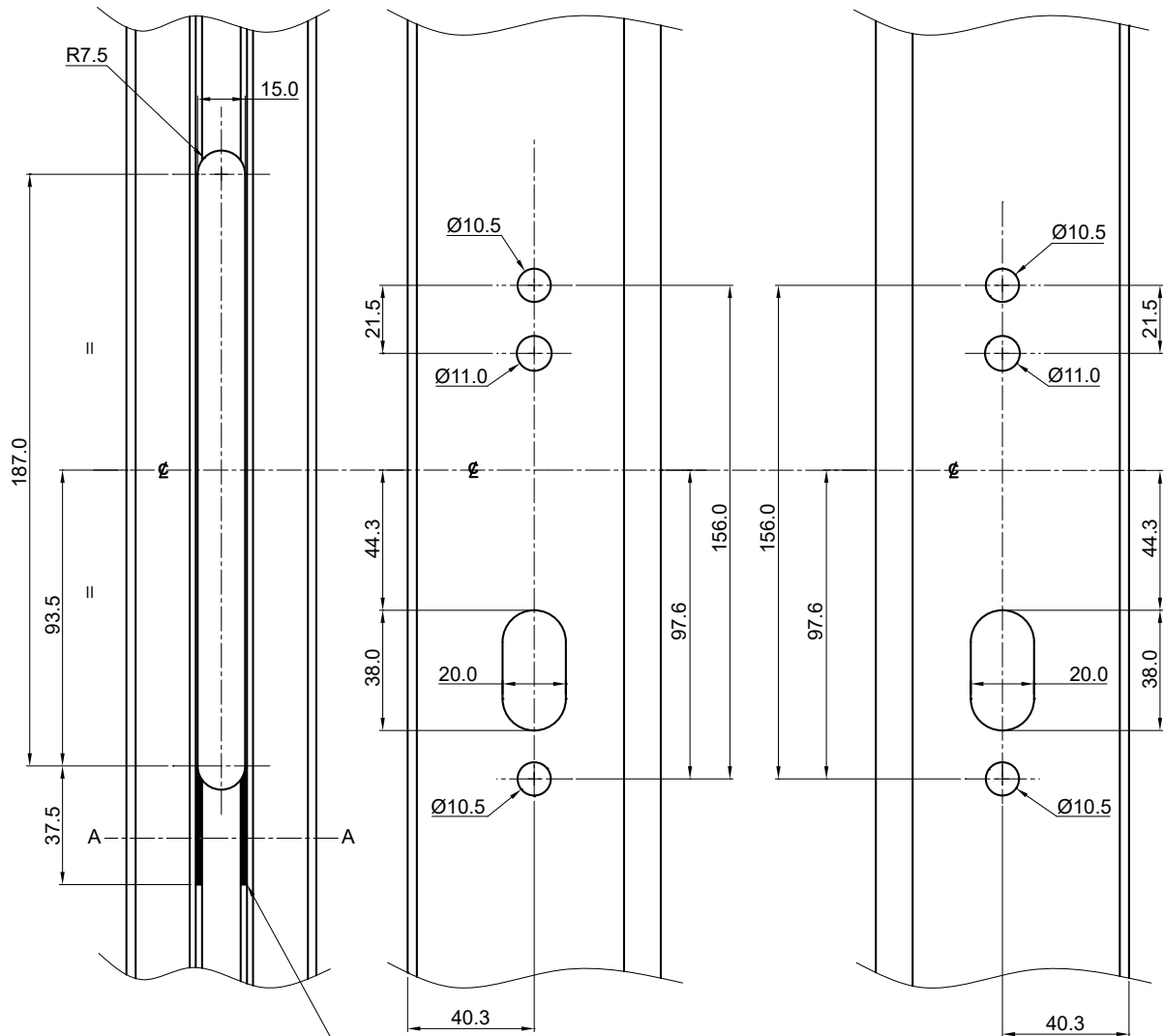
SECTION	DATE	ISS	REFERENCE	PAGE
ROUTING	OCTOBER 2020	27	TM-0002	17

1460 Handed Lock Routing



Right Hand Prep

Left Hand Prep



REMOVE MATERIAL SHOWN 37.5MM BELOW THE MAIN LOCK PREP TO ALLOW CLEARANCE FOR THE DRIVE ROD CONNECTOR BLOCK

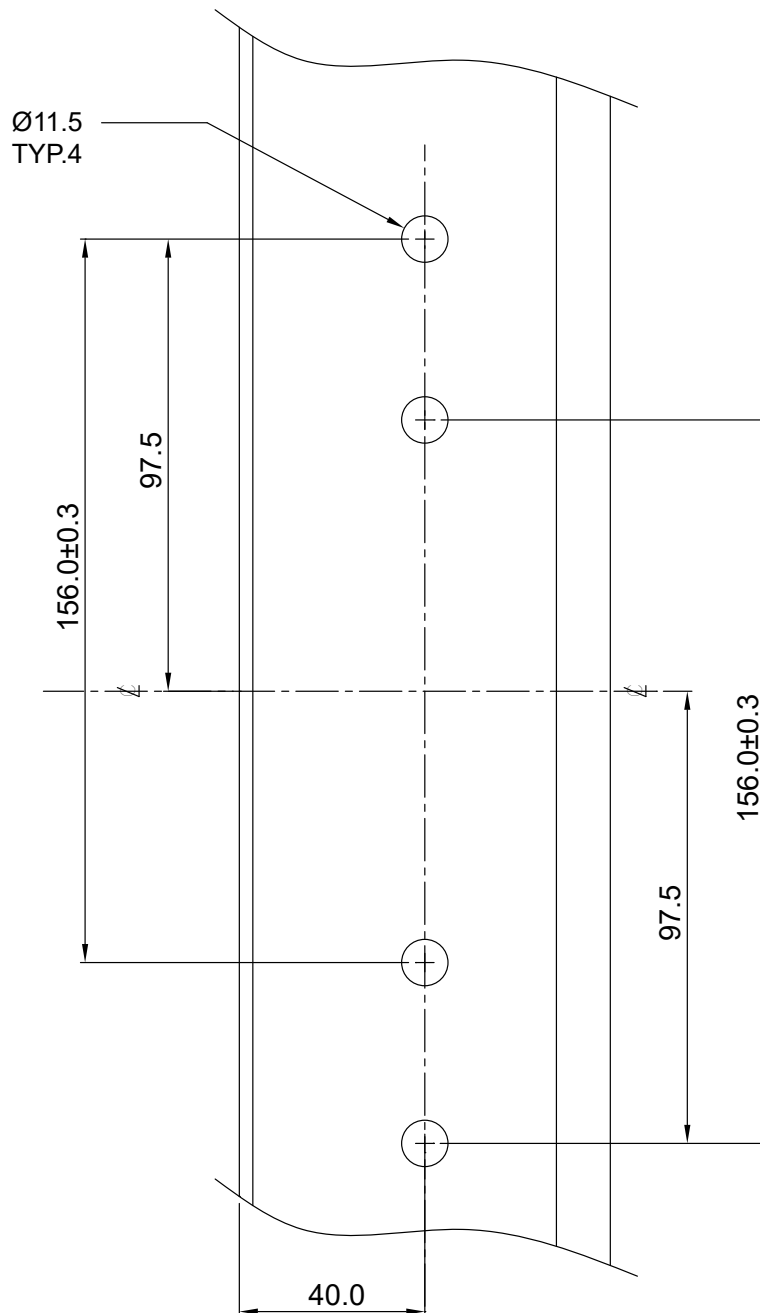
Note:

1. Tolerance ± 1 mm unless otherwise stated.
2. Holes to take handle fixing boss has been sized to minimize movement of the handle in operation. Powder coated handles will fit tighter than other handles due to a build up of paint on the locating boss.

In-Line Sliding Patio Door Blank Handle Routing

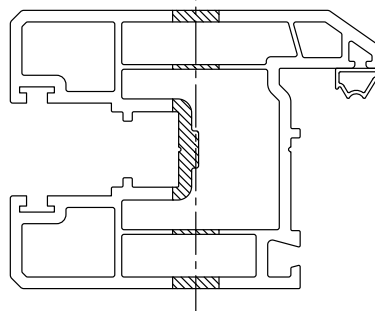
SECTION	DATE	ISS	REFERENCE	PAGE
ROUTING	OCTOBER 2020	27	TM-0002	18

Blank Handle Routing



Note:

1. Tolerance ± 1 mm unless otherwise stated.
2. Holes to take handle fixing boss has been sized to minimize movement of the handle in operation. Powder coated handles will fit tighter than other handles due to a build up of paint on the locating boss.



In-Line Sliding Patio Door Sash/Outer Frame Drainage

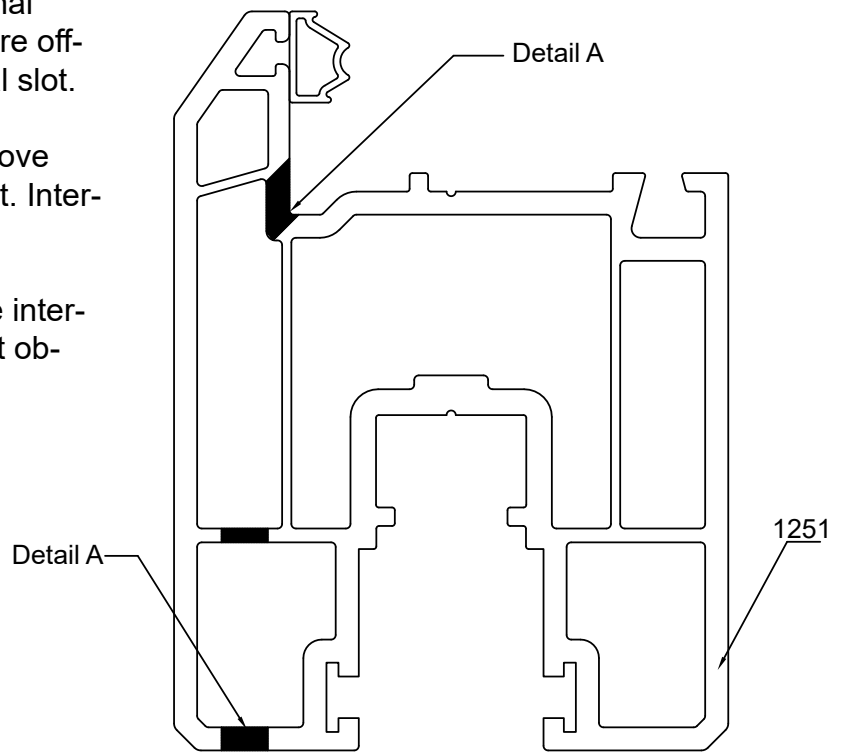
SECTION	DATE	ISS	REFERENCE	PAGE
DRAINAGE	OCTOBER 2020	27	TM-0002	19

Sash Drainage

For a sash width of 785-1100mm 2 internal drain slots are required., External slots are off-set a minimum of 50mm from the internal slot.

For a sash width of 1101-1500mm as above plus one on the centre External drain slot. Internal drain slot offset as above.

Position the internal drain as close to the internal sash corners as possible - But do not obstruct with glazing bridge.



Detail A = Slot 25 x 5mm

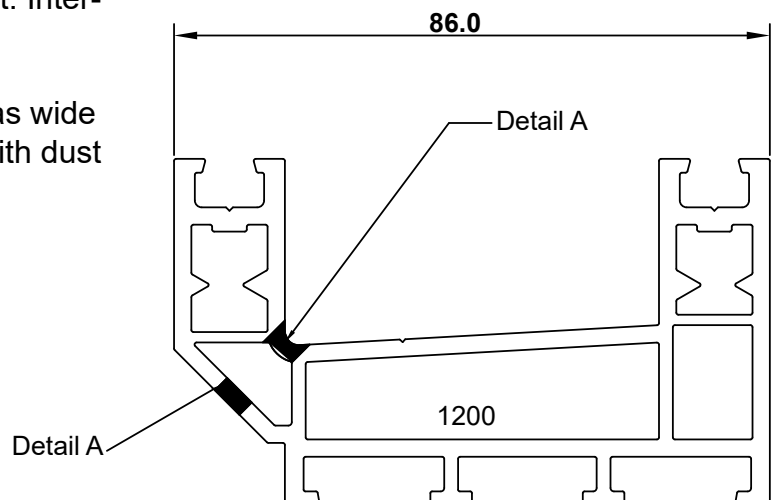
Outer Frame Drainage

Each sash outer frame segment is to be drained separately.

For a sash width of 785-1100mm, 2 internal drain slots are required. External slots are off-set a minimum of 50mm from the internal slot.

For a sash width of 1101-1500mm as above plus one on the centre External drain slot. Internal slot offset as above.

Internal drain slots are to be positioned as wide apart as possible - But do not obstruct with dust plug adjacent to interlock.

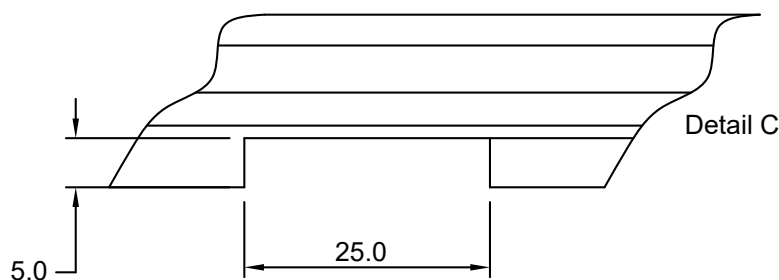
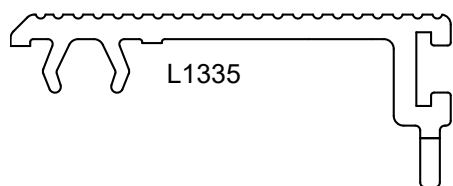
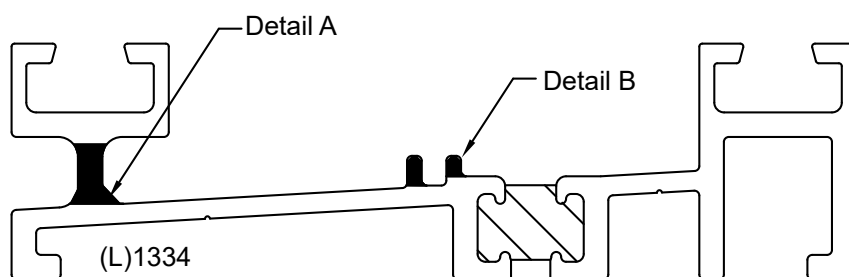


In-Line Sliding Patio Door Low Threshold Drainage

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DRAINAGE	OCTOBER 2020	27	TM-0002	20

Low Threshold (L) 1334

(L) 1334 see diagram and for all other detail as above for outframe drainage. Additionally remove feature (see detail B in diagram) at positions offset a minimum of 50mm from external drain slots. Threshold trim (L1335) also to be notched (detail C) at points coincident with detail B.



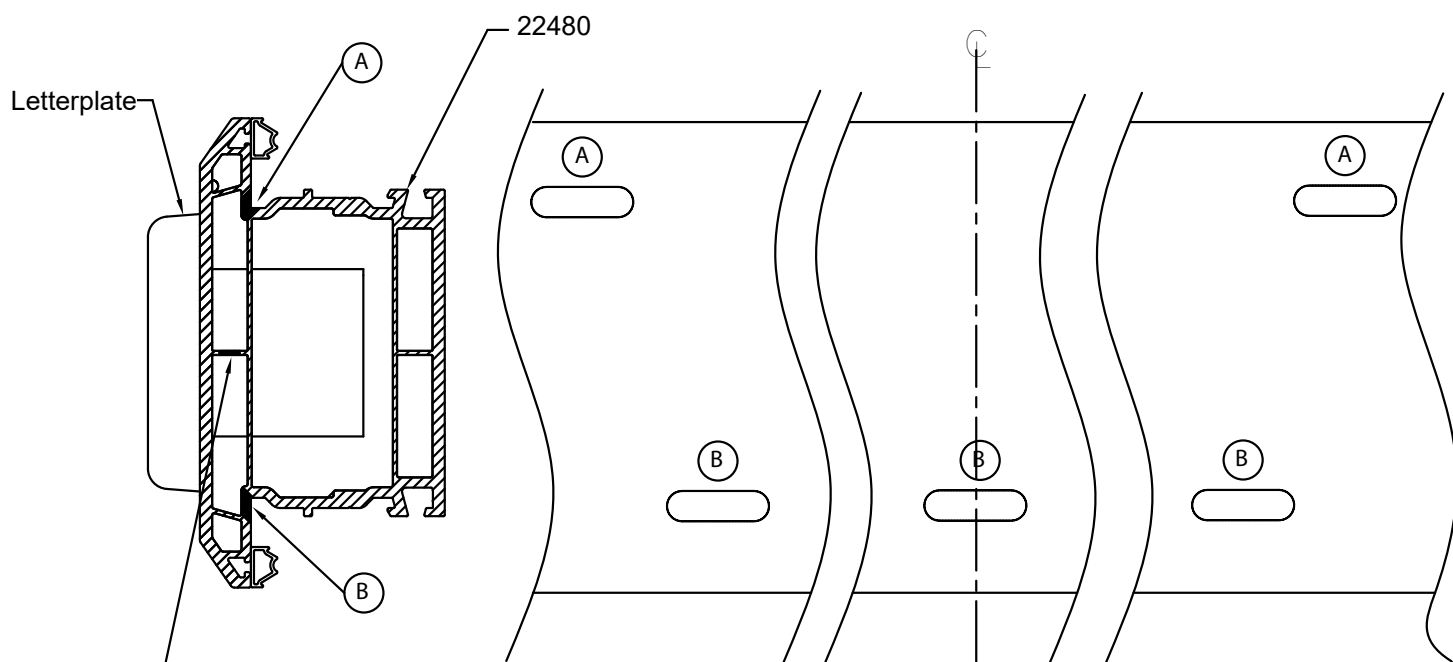
In-Line Sliding Patio Door Midrail Drainage

SECTION	DATE	ISS	REFERENCE	PAGE
DRAINAGE	OCTOBER 2020	27	TM-0002	21

Midrail Drainage

Note.

1. For use on midrails with letterplates only.
2. 2 internal/external drain slots, minimum 50 offset positioned close to end of midrail but not obstructed by glazing packers etc.
3. 1 External drain slot, on centre with letter plate routing as Ⓑ.
4. For midrails with no letter plate omit on centre external drain slot.



Relieve inner web at the end of the mid-rail ensuring silicone sealant applied an assembly does not block drainage path

Ⓐ= Slot 25x5

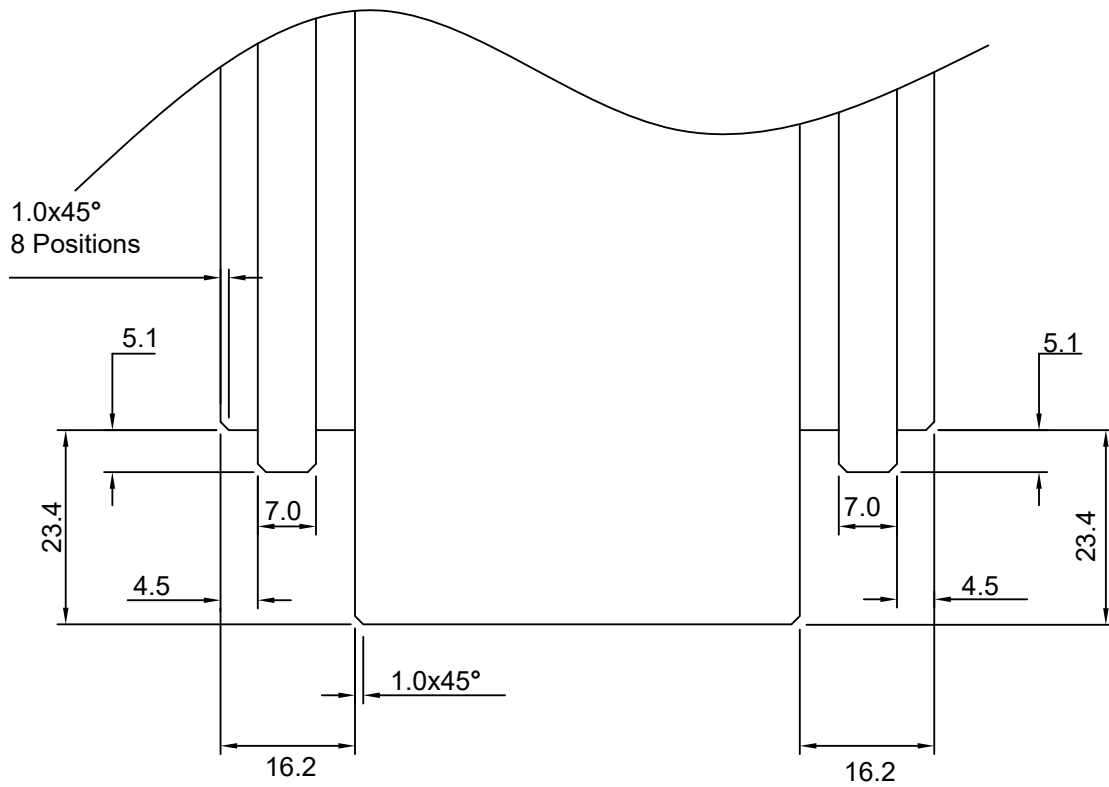
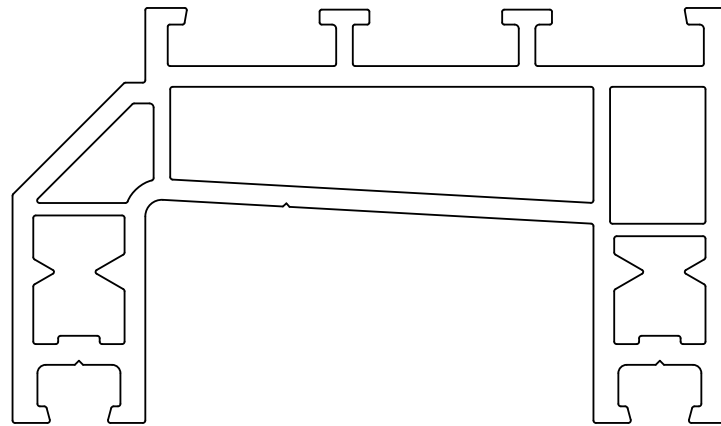
Ⓑ= Slot 25x5

In-Line Sliding Patio Door End Preparation 1200



SECTION	DATE	ISS	REFERENCE	PAGE
FRAME JOINTING & PREPARATION	OCTOBER 2020	27	TM-0002	22

End Preparation 1200



Dimensions in MM
All dimensions are nominal.
DO NOT SCALE

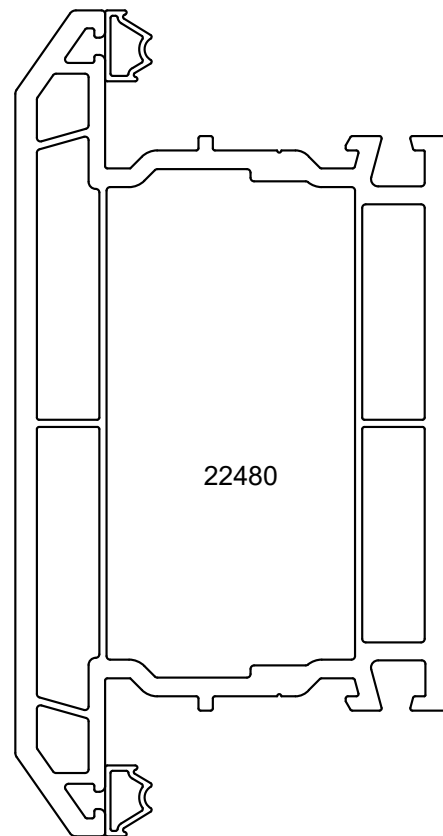
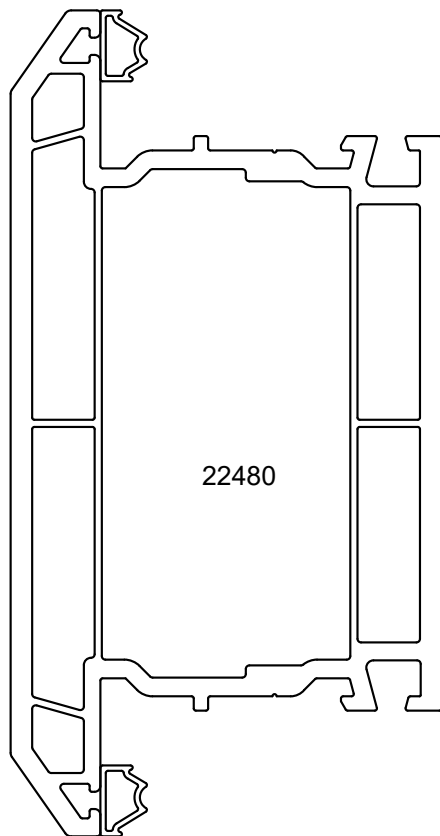
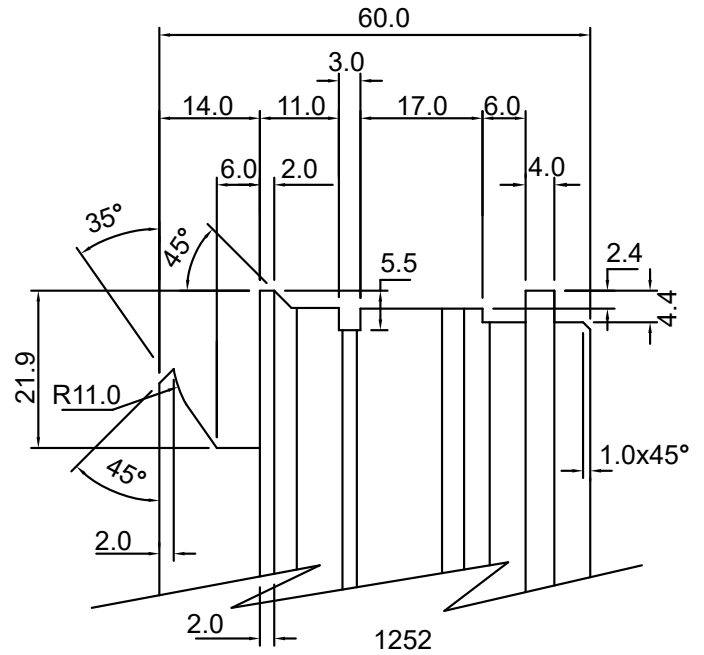
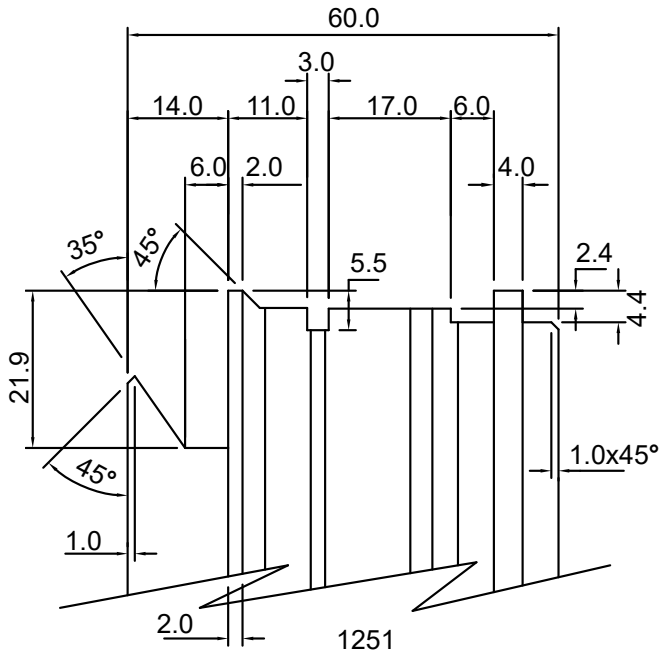
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In-Line Sliding Patio Door End Preparation 22480 - 1251/1252



SECTION	DATE	ISS	REFERENCE	PAGE
FRAME JOINTING & PREPARATION	OCTOBER 2020	27	TM-0002	23

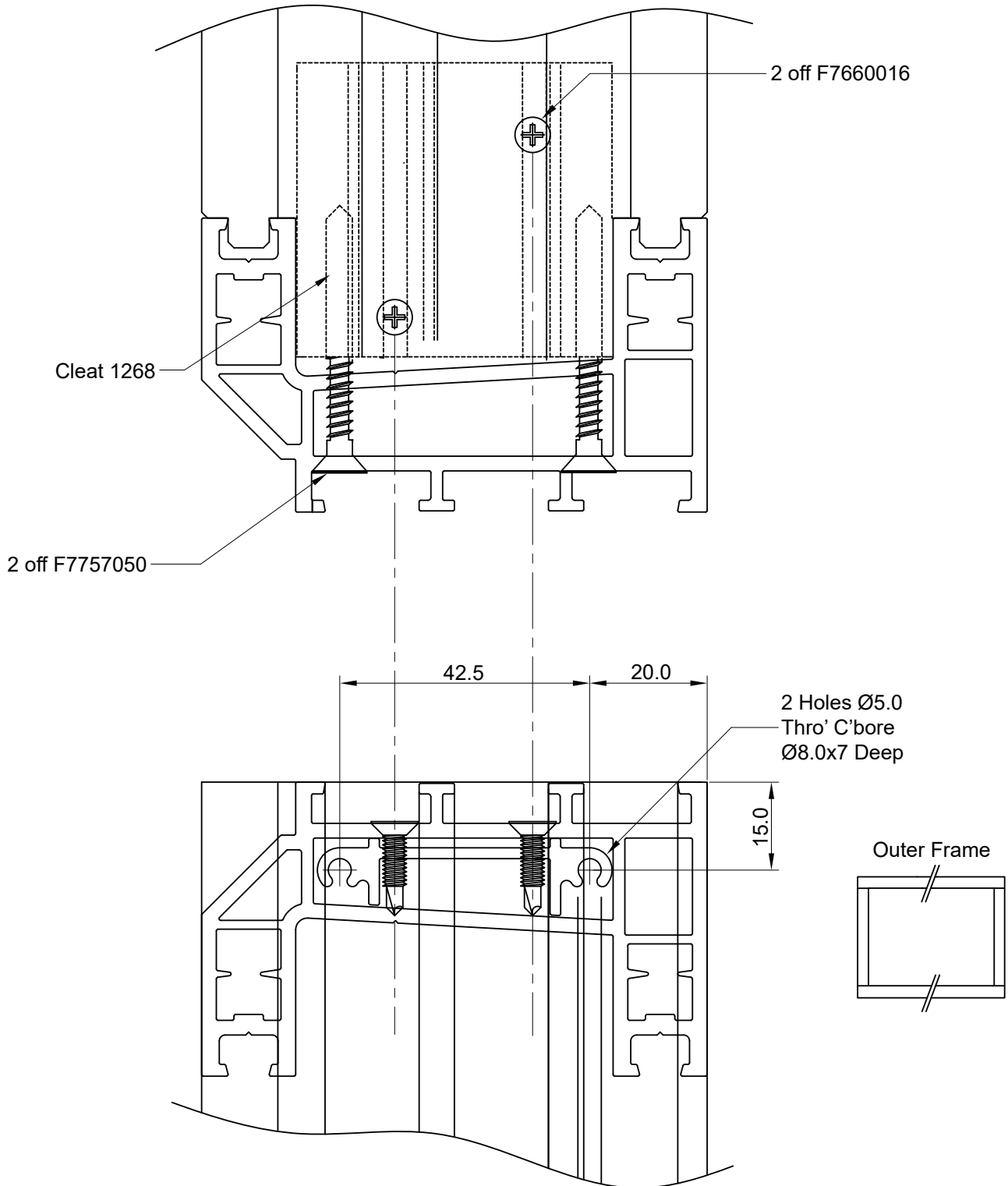
End Preparation 22480 - 1251/1252



In-Line Sliding Patio Door Jointing 1200

SECTION	DATE	ISS	REFERENCE	PAGE
FRAME JOINTING & PREPARATION	OCTOBER 2020	27	TM-0002	24

Jointing 1200



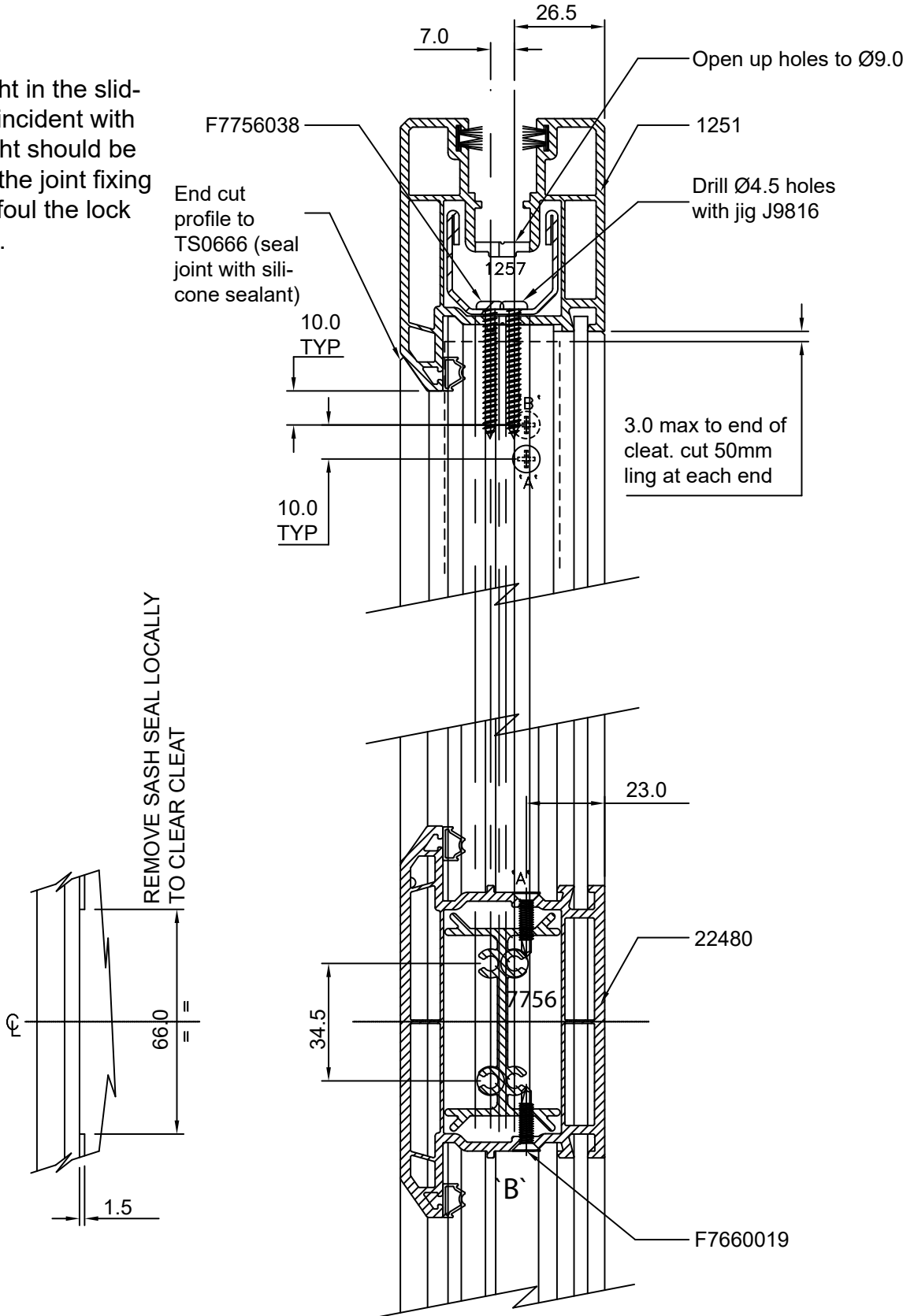
In-Line Sliding Patio Door Jointing 22480/7756/1251

SECTION	DATE	ISS	REFERENCE	PAGE
FRAME JOINTING & PREPARATION	OCTOBER 2020	27	TM-0002	25

Jointing22480/7756/1251

Note.

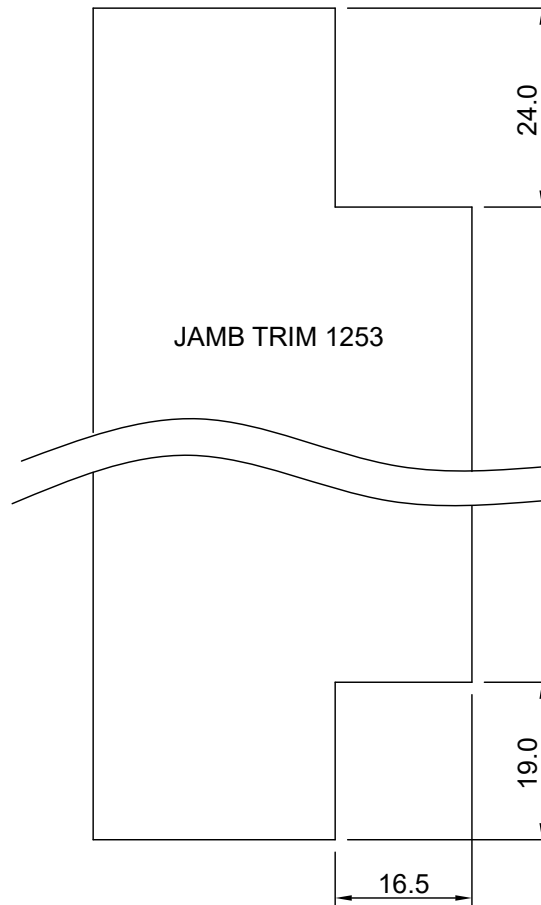
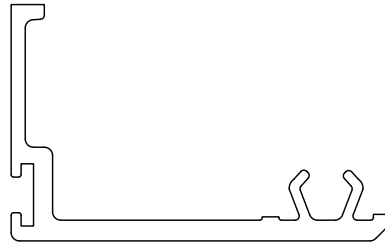
Midrail height in the sliding sash coincident with handle height should be avoided as the joint fixing screws will foul the lock centre case.



In-Line Sliding Patio Door Jamb Trim Preparation

SECTION	DATE	ISS	REFERENCE	PAGE
FRAME JOINTING & PREPARATION	OCTOBER 2020	27	TM-0002	26

Jamb Trim Preparation

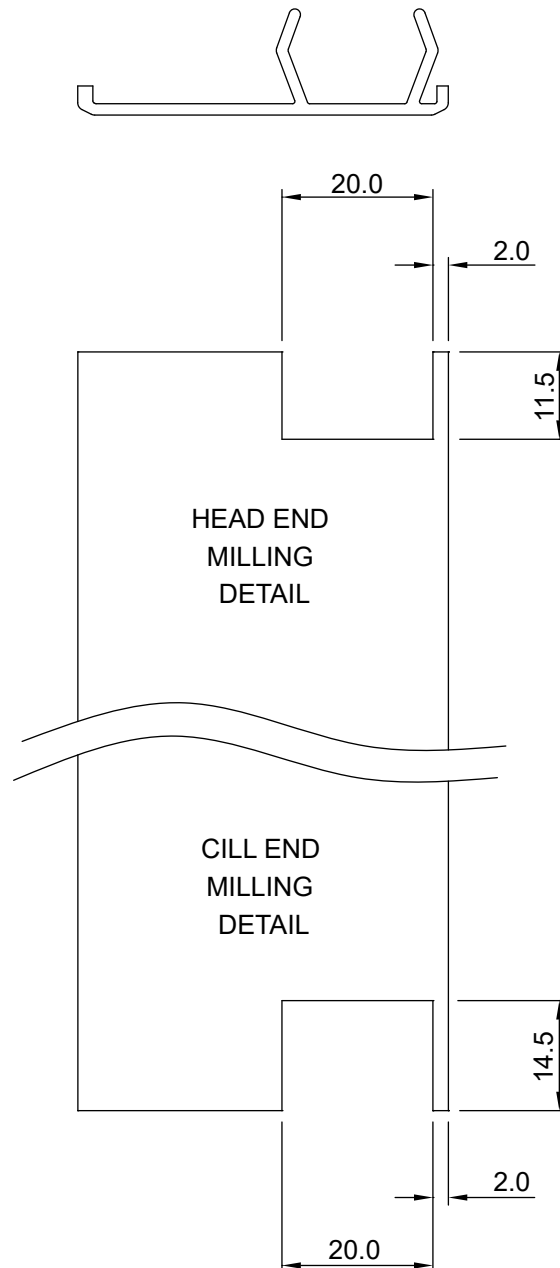


In-Line Sliding Patio Door Jamb Trim Preparation

SECTION	DATE	ISS	REFERENCE	PAGE
FRAME JOINTING & PREPARATION	OCTOBER 2020	27	TM-0002	27

Jamb Trim Preparation

JAMB TRIM 1253



In-Line Sliding Patio Door 1204 Fixing Details

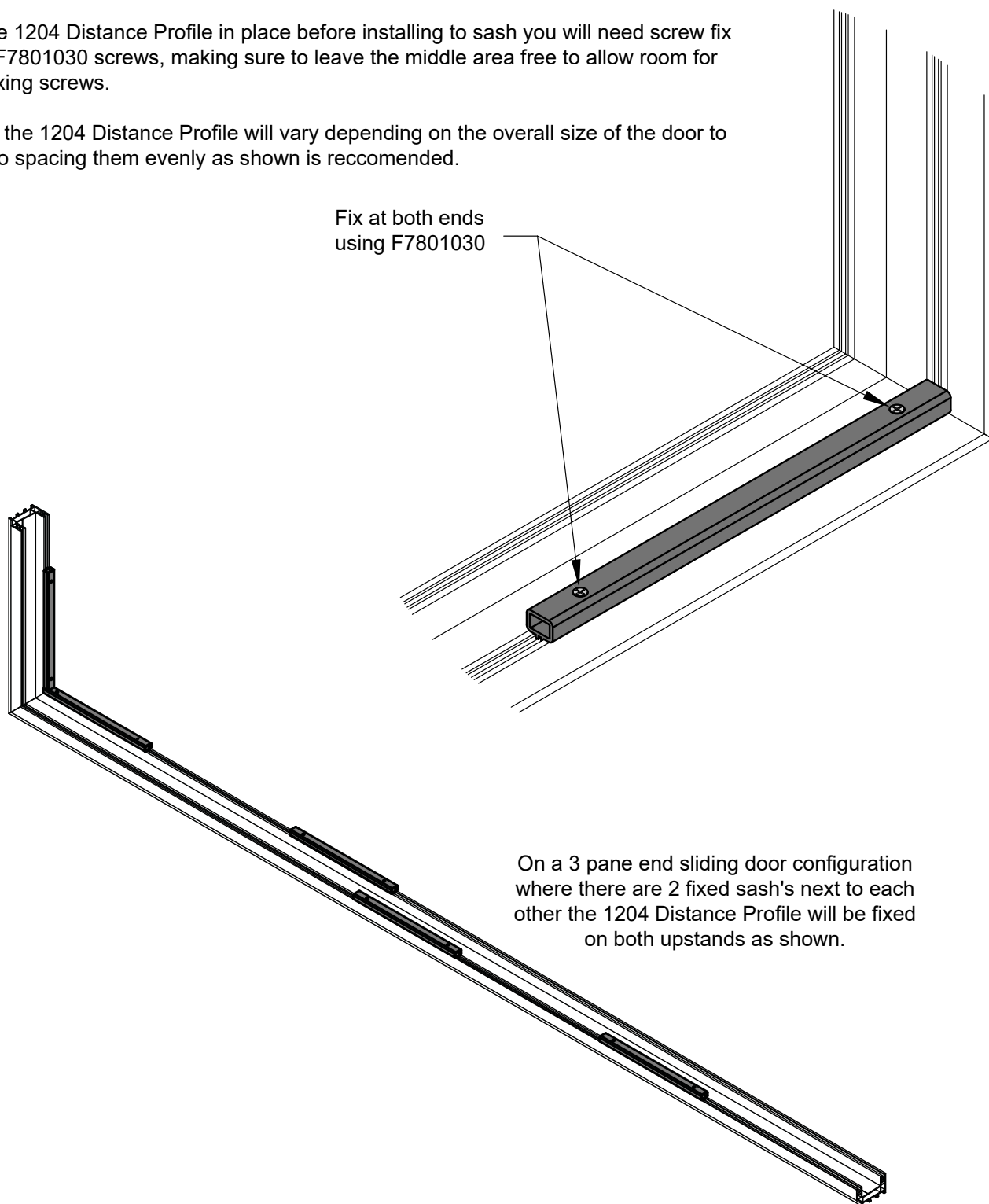
SECTION	DATE	ISS	REFERENCE	PAGE
ASSEMBLY	OCTOBER 2020	27	TM-0002	28

1204 Fixing Details

When installing the fixed sash, the 1204 Distance Profile must be used to ensure correct positioning of the sash.

To keep the 1204 Distance Profile in place before installing to sash you will need screw fix using two F7801030 screws, making sure to leave the middle area free to allow room for the sash fixing screws.

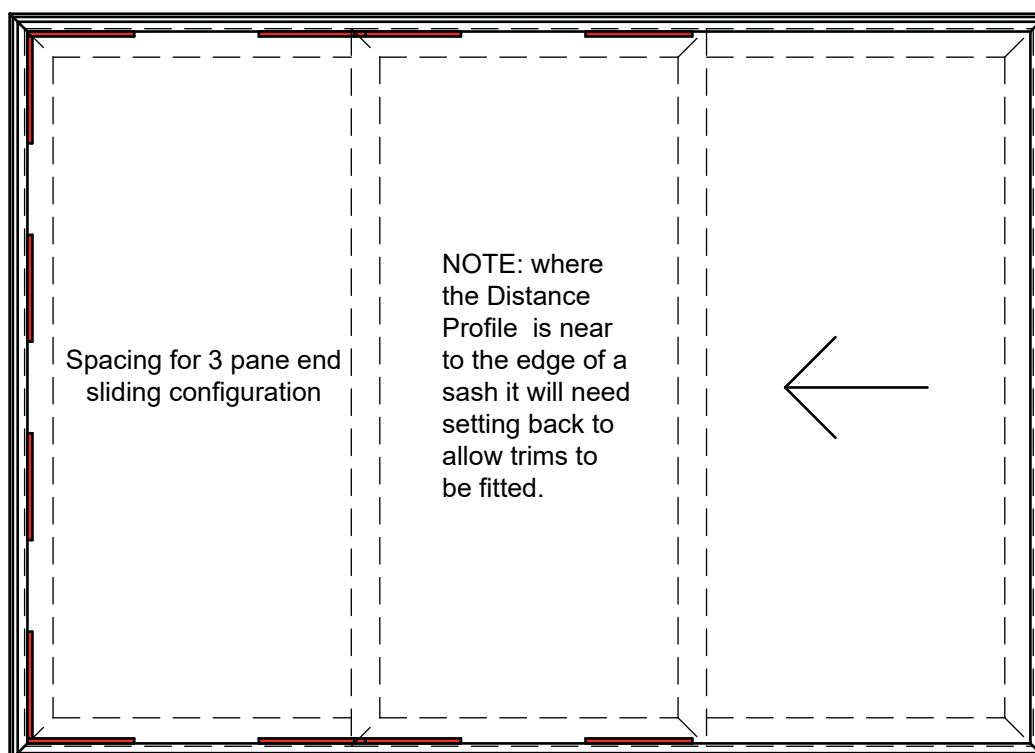
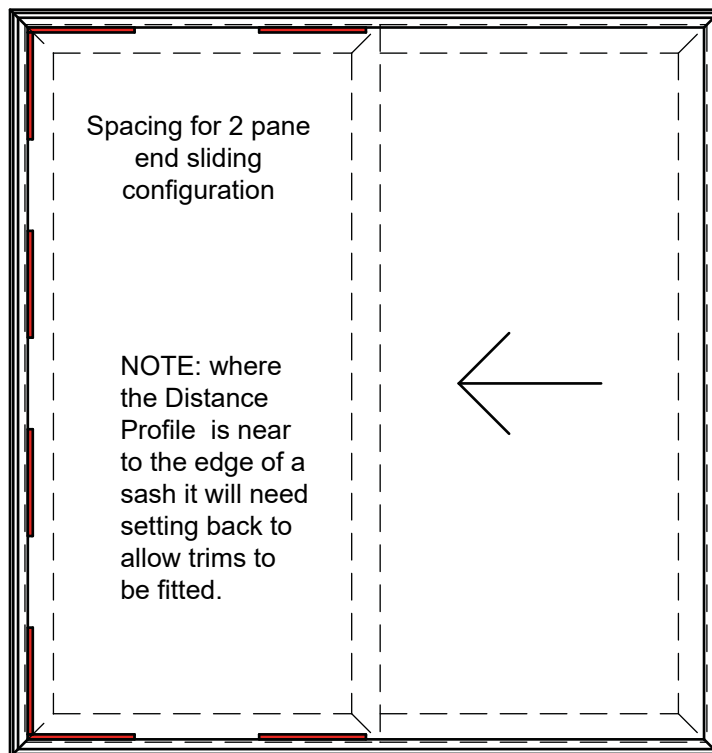
Spacing of the 1204 Distance Profile will vary depending on the overall size of the door to be made so spacing them evenly as shown is recommended.



In-Line Sliding Patio Door 1204 Fixing Details

SECTION	DATE	ISS	REFERENCE	PAGE
ASSEMBLY	OCTOBER 2020	27	TM-0002	29

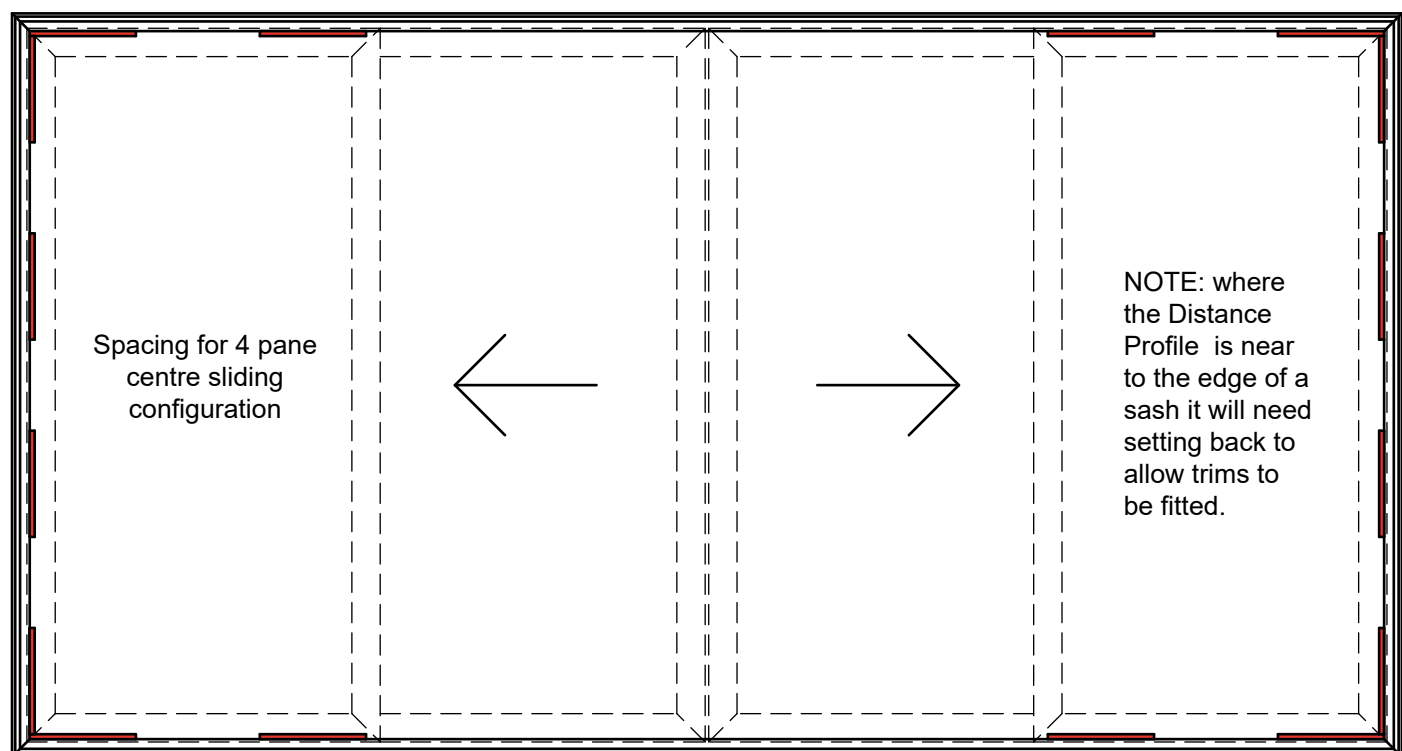
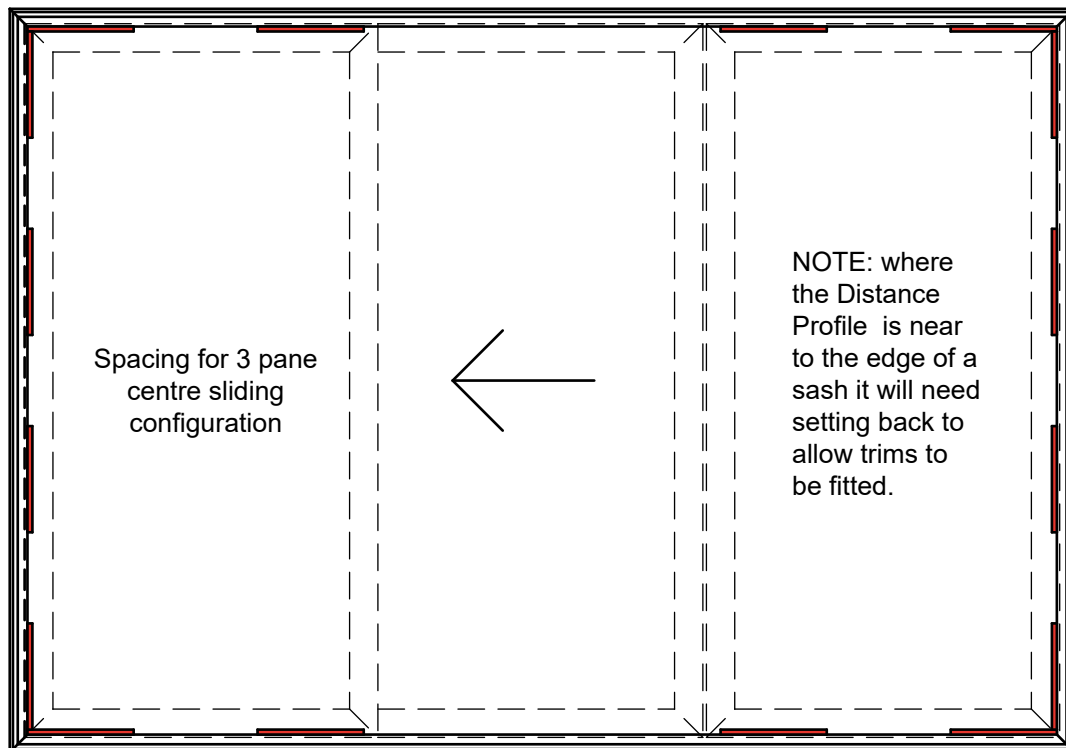
1204 Fixing Details



In-Line Sliding Patio Door 1204 Fixing Details

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ASSEMBLY	OCTOBER 2020	27	TM-0002	30

1204 Fixing Details



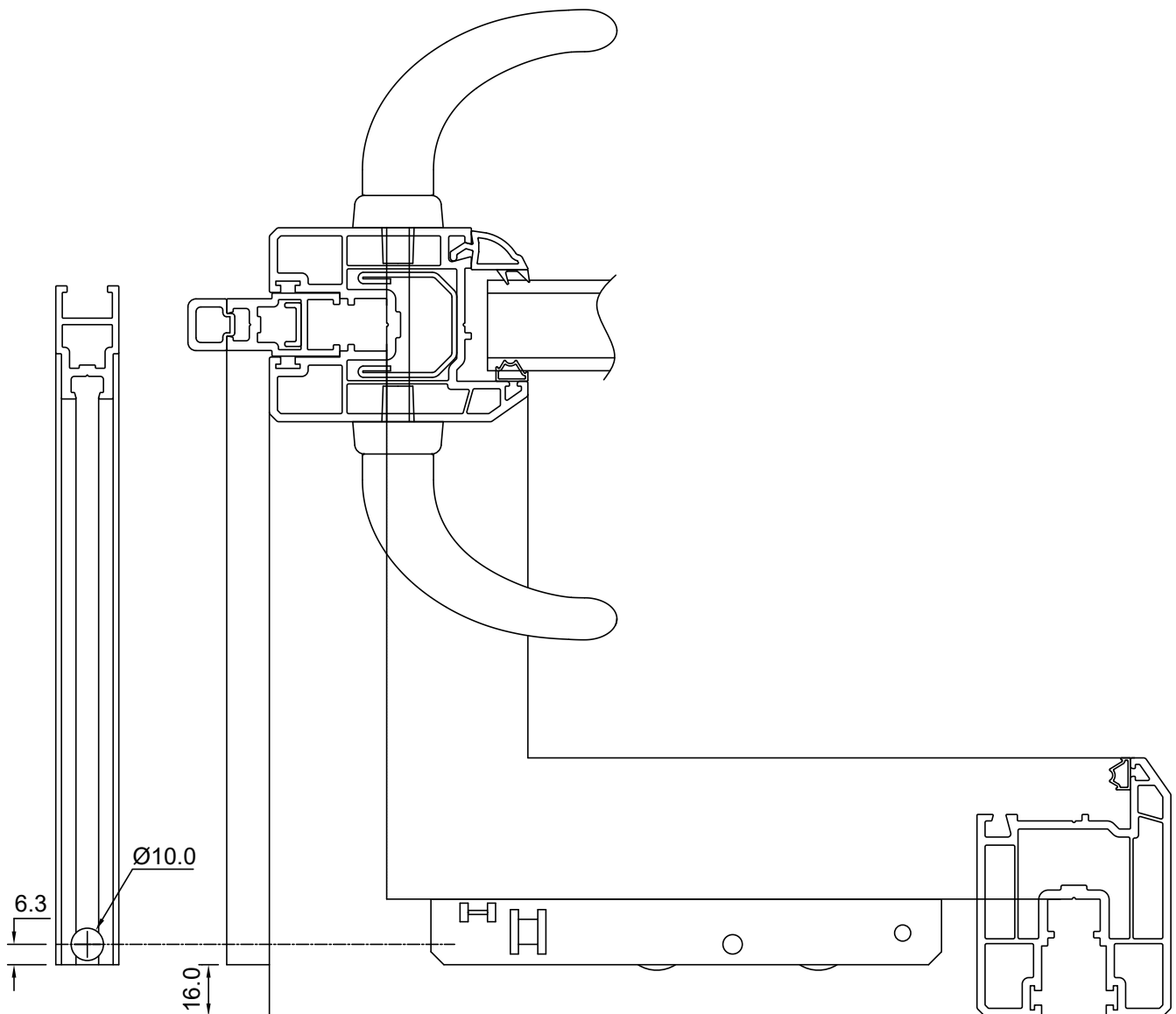
In-Line Sliding Patio Door 1256 Pre Drilling For Roller Adjustment



SECTION	DATE	ISS	REFERENCE	PAGE
ASSEMBLY	OCTOBER 2020	27	TM-0002	31

1256 Pre Drilling for Roller Adjustment

To allow slave sash roller adjustment without the need to remove the meeting style it is recommended that the 1256 be pre-drilled as shown below.



In-Line Sliding Patio Door Sash Meeting Profile Fixing

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ASSEMBLY	OCTOBER 2020	27	TM-0002	32

Patio Sash Meeting Profile Fixing

STEP 1

Fit and fix aluminium reinforcement 1266 with screw

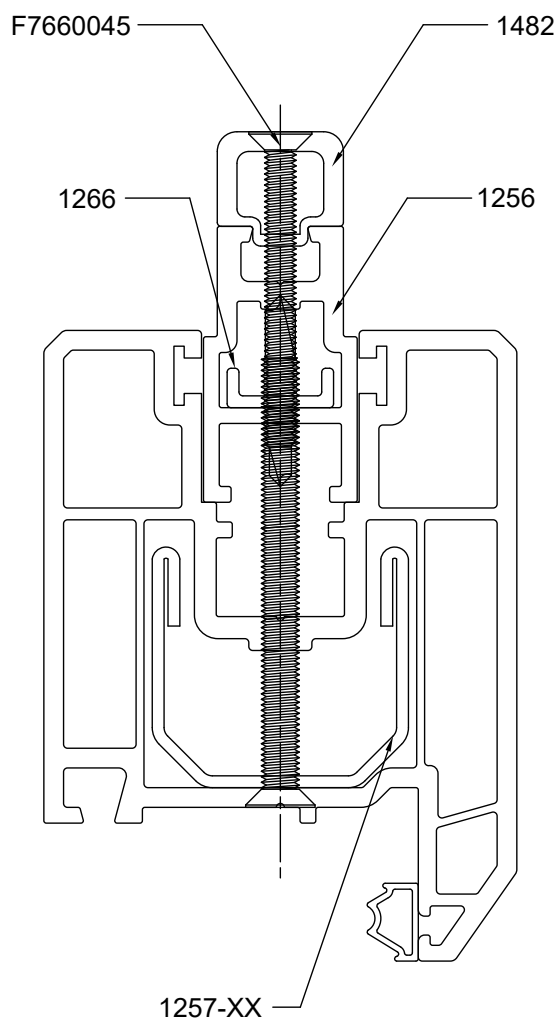
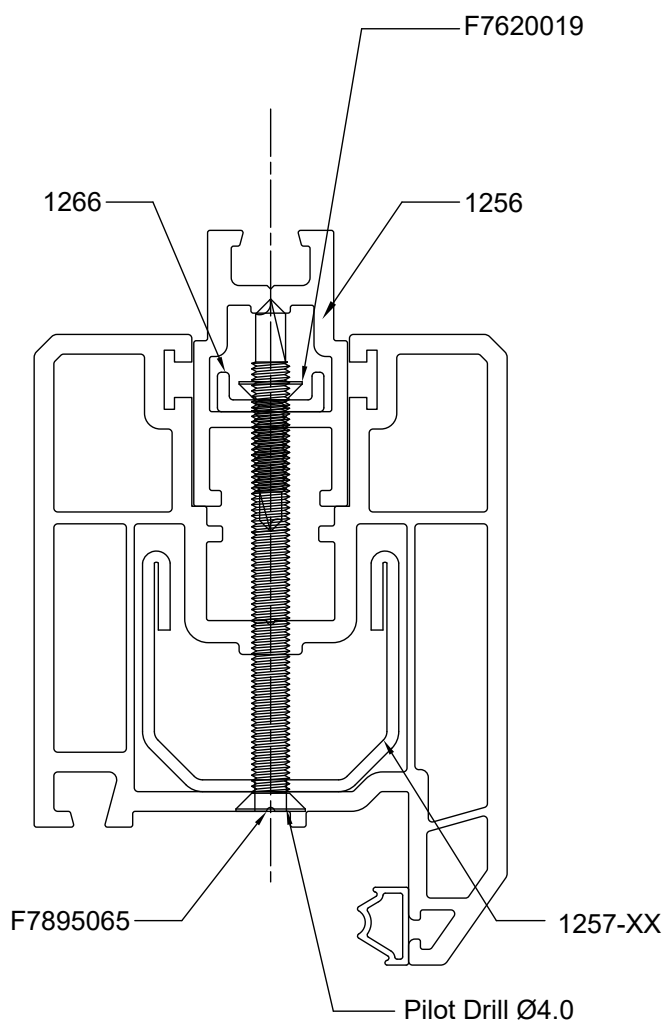
F7620019, drilling through 1256 so that head of screw clamps 1266. (Ensure that keep rail covers holes).

Pilot drill through sash 1251 and steel 1257 using $\text{Ø}4.0\text{mm}$ drill.

Then fix with screw F7895065 as shown.

STEP 2

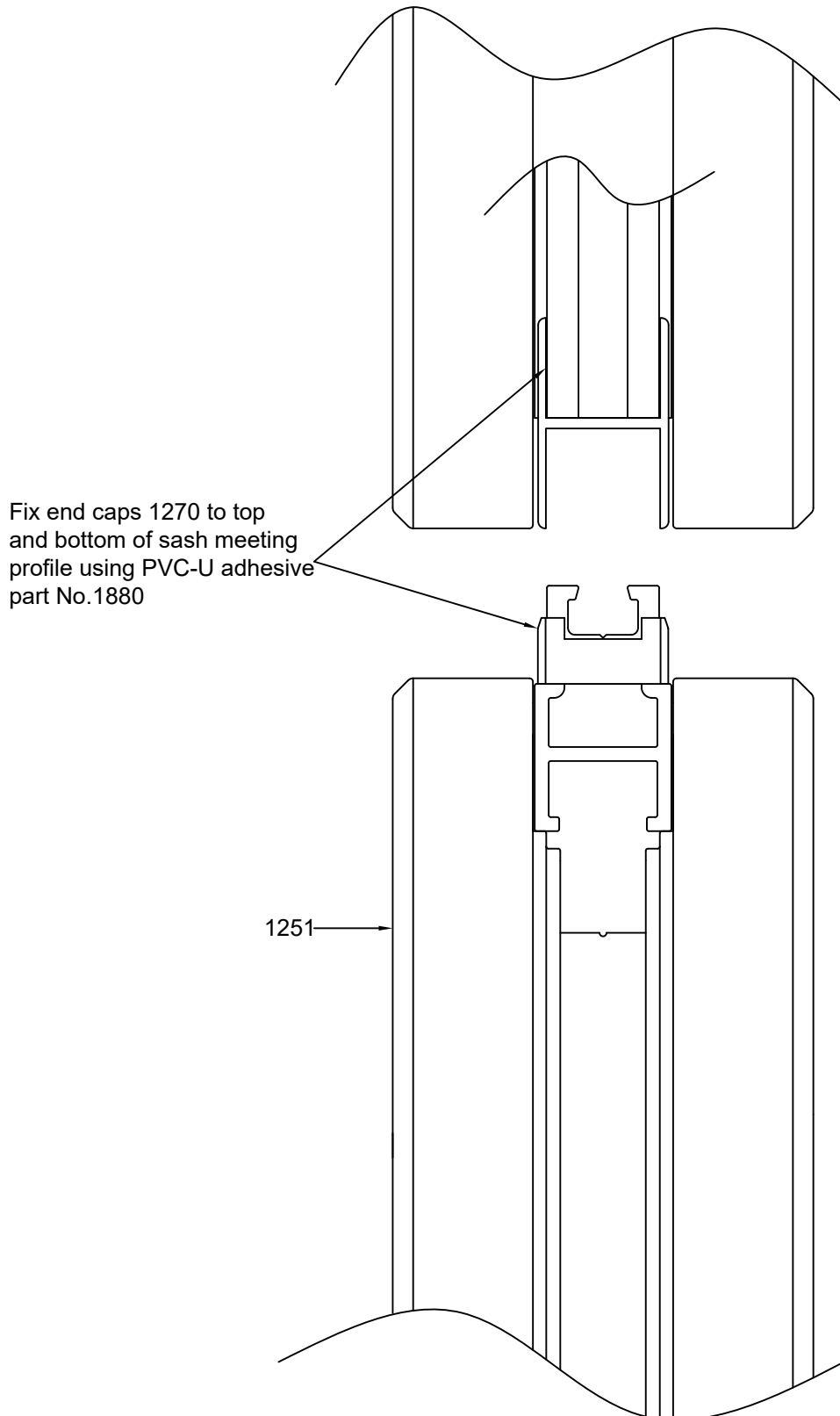
Fix keep 1482 using screw F7660045.



In-Line Sliding Patio Door Sash Meeting Profile End Cap Fixing

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Sash Meeting Profile End Cap Fixing

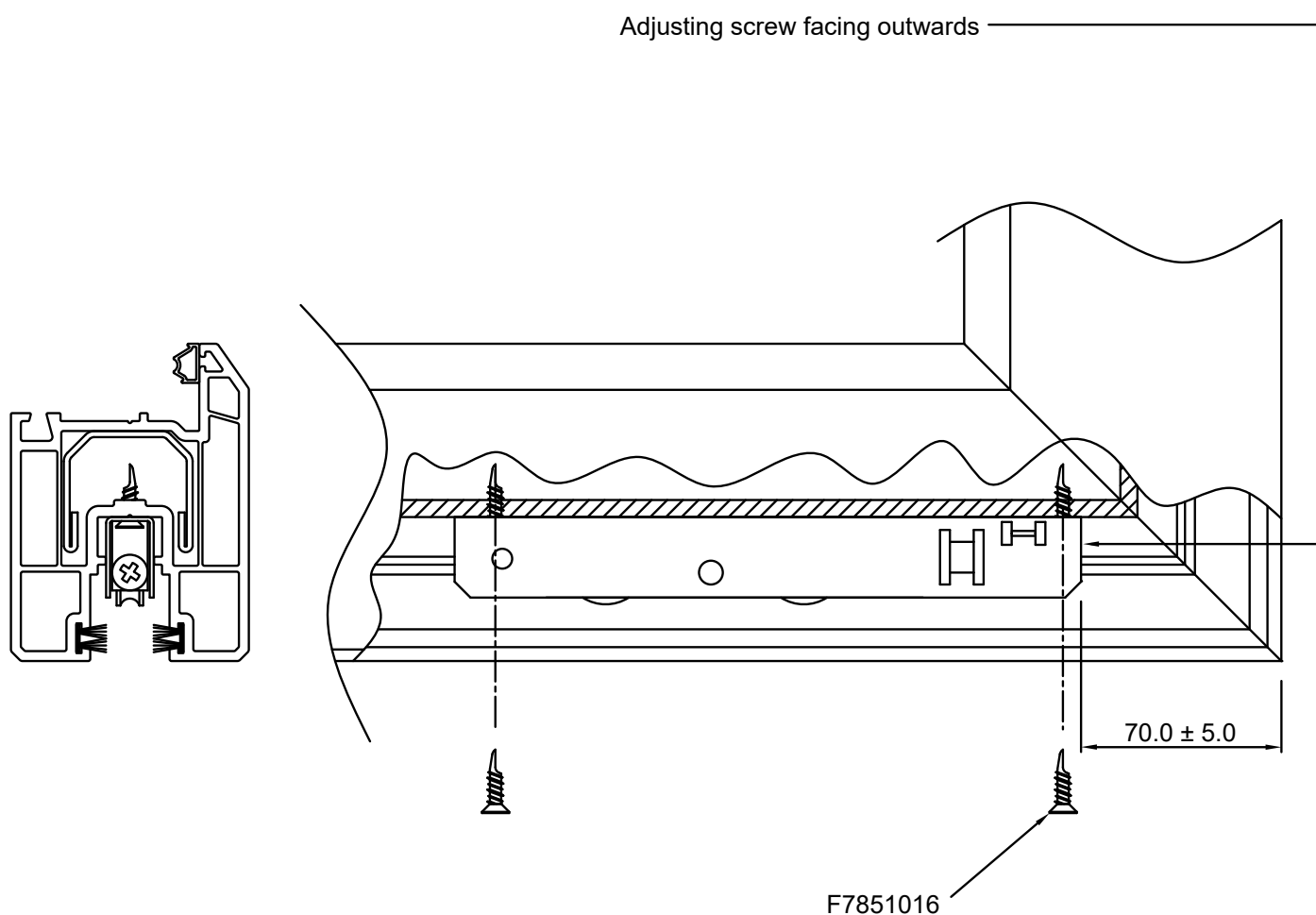


In-Line Sliding Patio Door Roller Fixing

SECTION	DATE	ISS	REFERENCE	PAGE
ASSEMBLY	OCTOBER 2020	27	TM-0002	34

Roller Fixing

2 rollers part no. 1486 positioned as shown below from each end of the sliding sash and fixed with screws part no. F7851016.

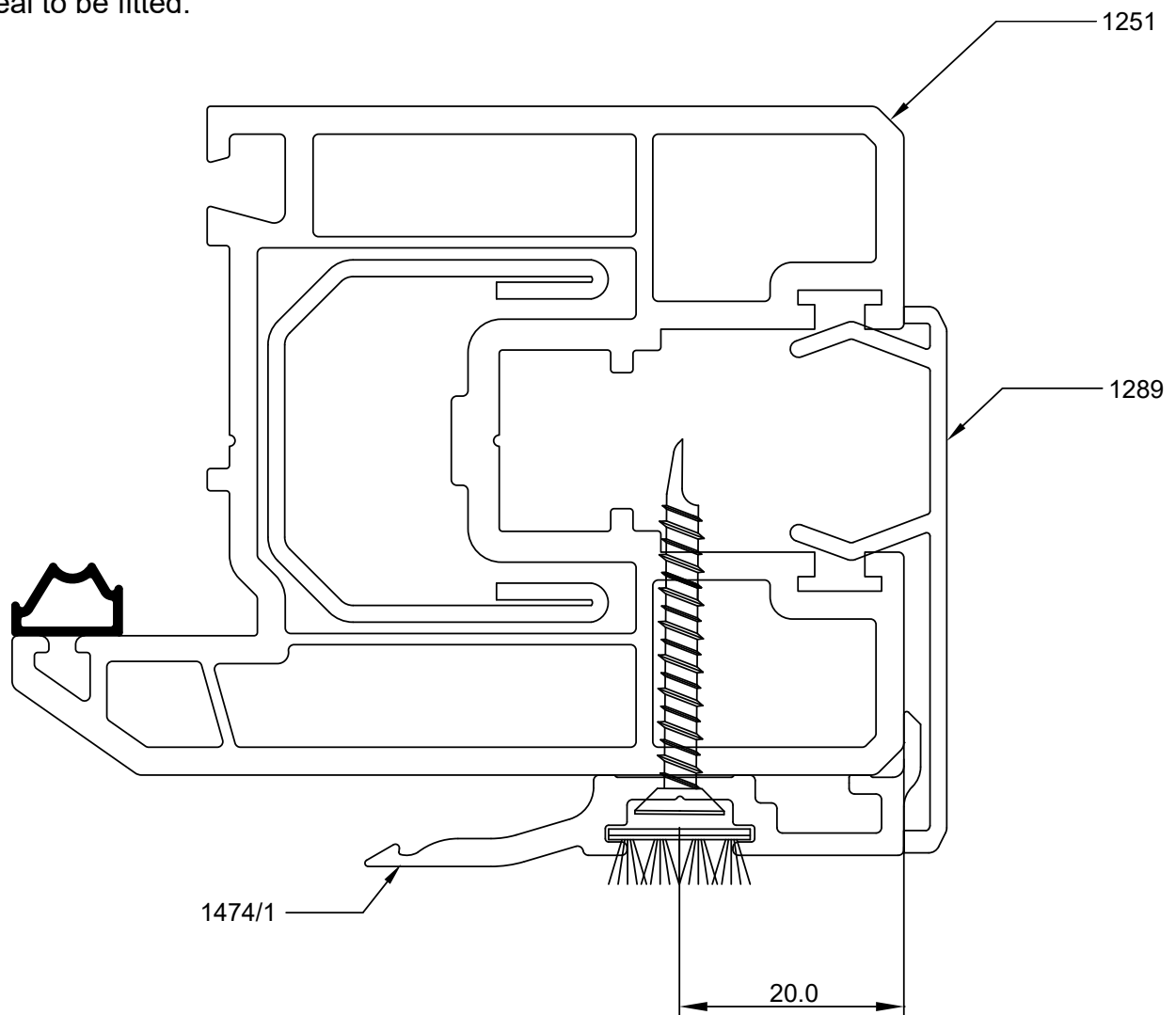


In-Line Sliding Patio Door Interlock Positioning

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ASSEMBLY	OCTOBER 2020	27	TM-0002	35

Interlock Positioning

Fix the interlock in position shown using screws part no. F7851030, position 140mm in from the top of the sash and 100mm from the bottom of the sash and equi-spaced over the length of the interlock with a max. 300mm pitch. Pre-drill $\text{\O}5\text{mm}$ holes in interlock and countersink to allow the 1273 interlock brush seal to be fitted.



In-Line Sliding Patio Door Anti-Lift Bracket

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In-Line Sliding Patio Door Anti-Lift Bracket

The security of the In-Line Sliding Patio Doors has now been enhanced with the introduction of Anti-Lift Bracket (1350). This maximises security by minimising the clearance at the top of the sliding sash and reducing the risk of it being lifted off the bottom rollers.

The bracket is factory fitted in the euro-groove in a 'retracted' state on sides opposing the lock for all sliding panes. It requires final adjustment to locate into the outer frame (head of door) to reduce clearance but allowing for expansion etc. throughout the life of the door.

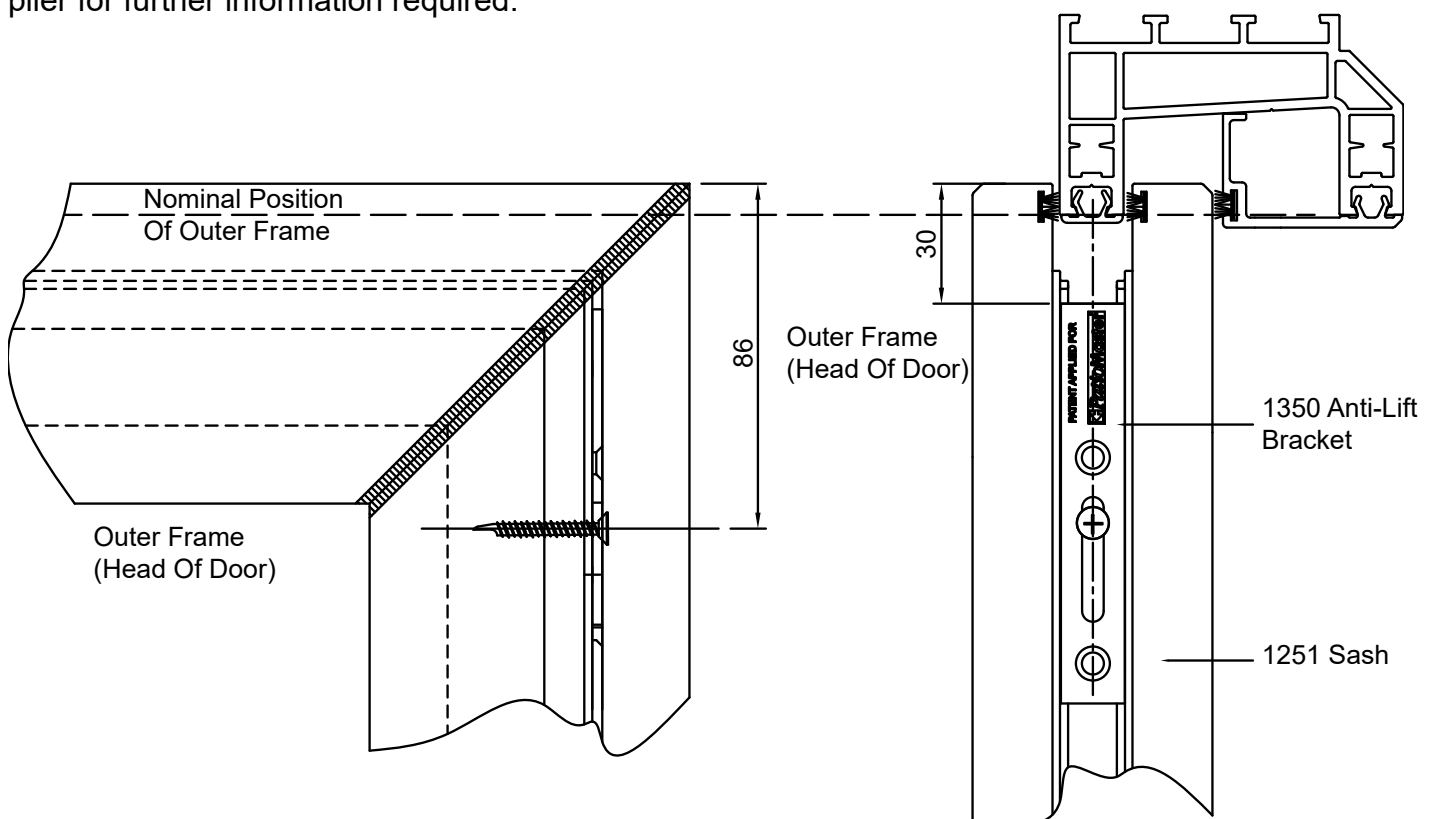
Secure position with two screws (supplied). This is done on-site in situ after installation of the sliding door.

Contact your In-Line Sliding Patio Door Supplier for further information required.

Factory Fitted Position of The Anti-Lift Bracket

Note: Bracket is fixed temporarily with one screw F7851030.

1. Anti-lift bracket to be factory fitted and adjusted on site.
2. To be fitted on side opposing lock on all sliding panes.
3. Two screws per bracket F7851030 to be included in door pack for final fix.



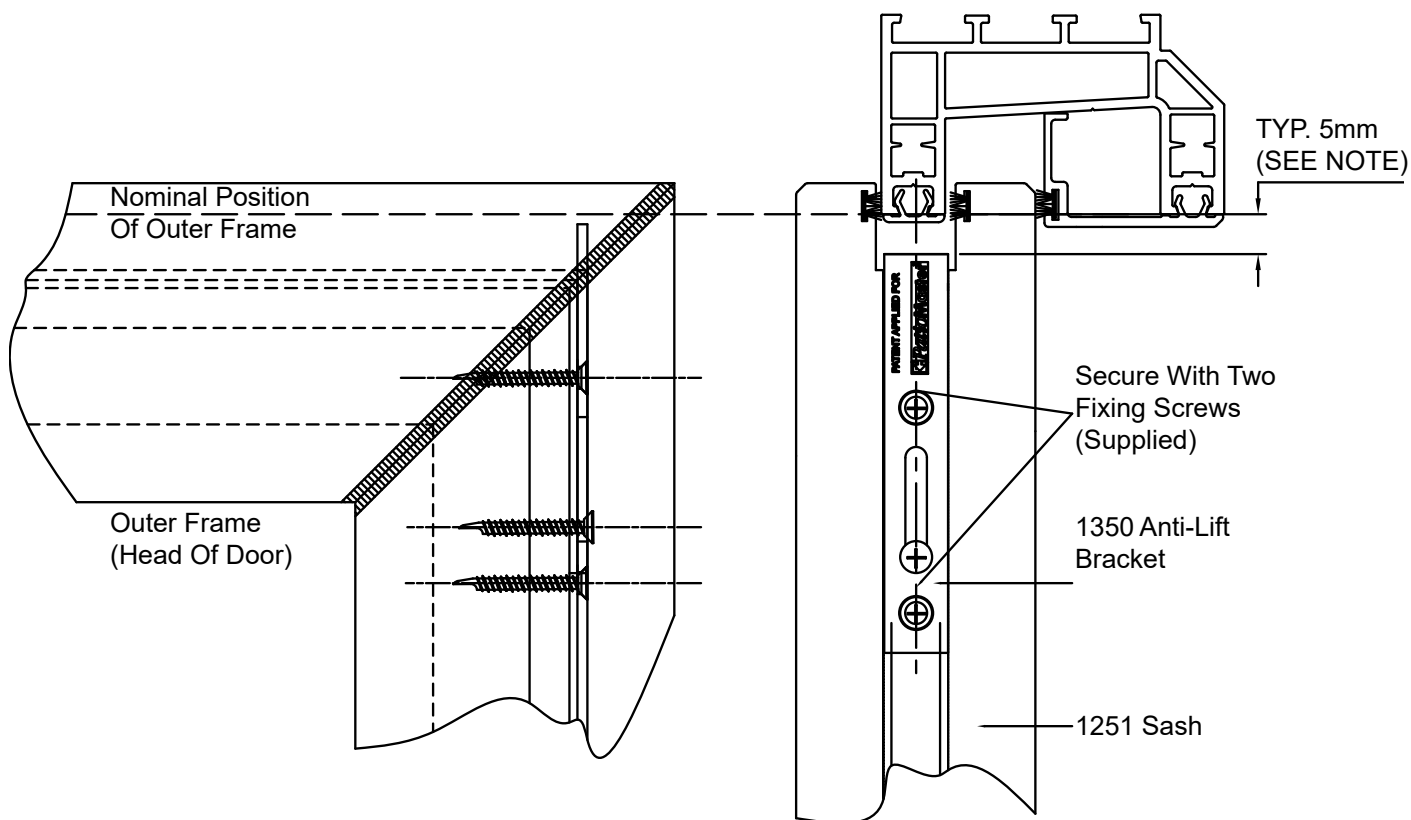
In-Line Sliding Patio Door Anti-Lift Bracket

SECTION	DATE	ISS	REFERENCE	PAGE
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In-Line Sliding Patio Door Anti-Lift Bracket Continued

Position of The Anti-Lift Bracket On The Door After installation

Note: Two additional fixing screws used for final fix F7851030 adjust anti-lift bracket after installation to reduce clearance allowing for expansion etc. throughout life of door.

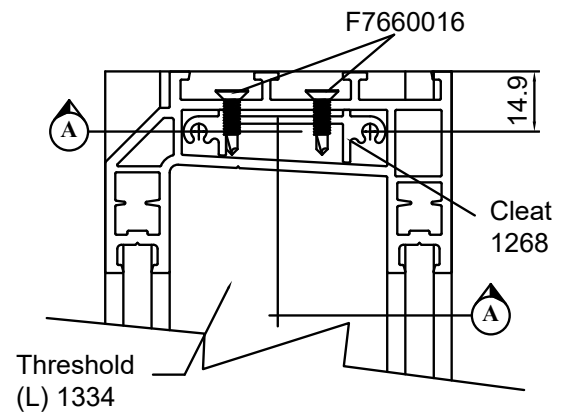
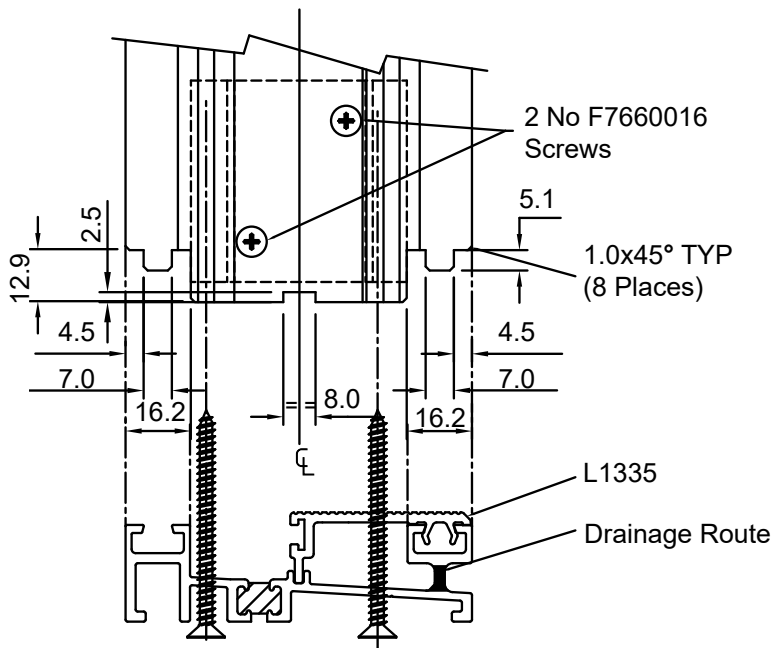
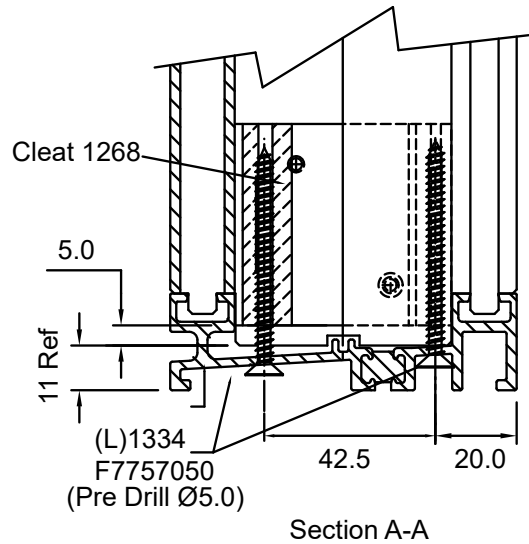
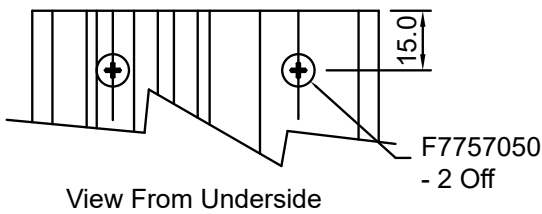


In-Line Sliding Patio Door Thermally Broken Low Threshold Assembly



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THRESHOLD	OCTOBER 2020	27	TM-0002	38

Thermally Broken Low Threshold Assembly



Note:

The T/B low threshold is designed primarily for use in sheltered external applications.

Fix cleat 1278, seal joint and tighten up.

Fit threshold trim L1335.

Do not fit drainage trim 1255.

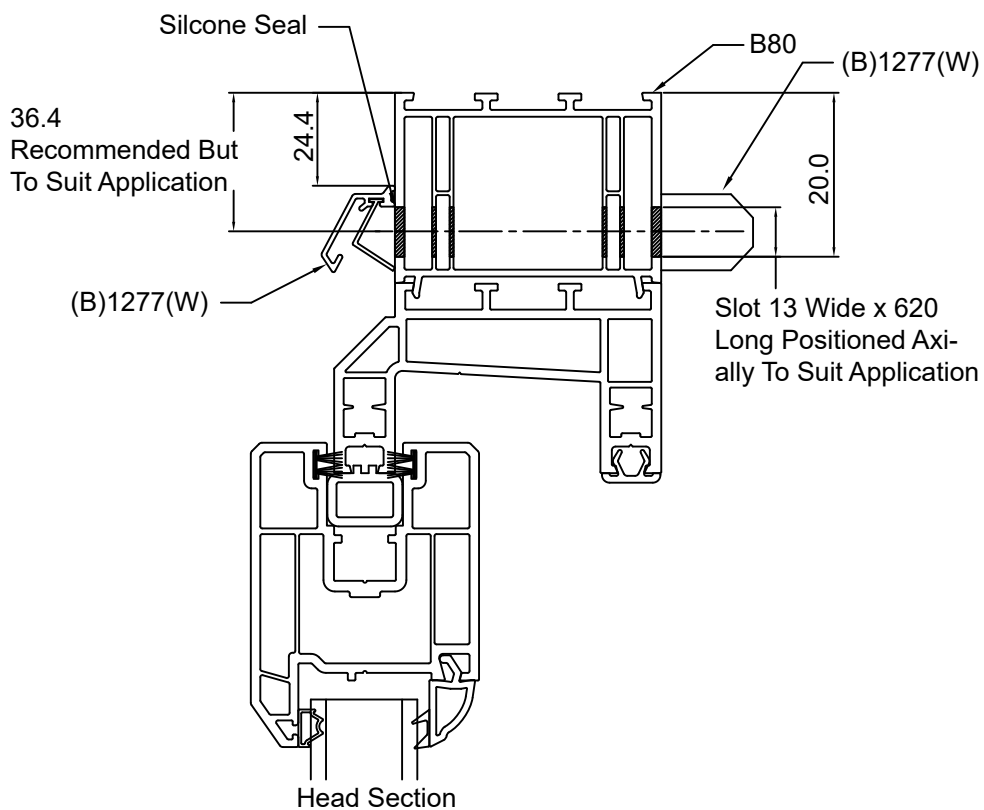
Dimensions in MM
All dimensions are nominal.
DO NOT SCALE

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In-Line Sliding Patio Door Frame Venting

SECTION	DATE	ISS	REFERENCE	PAGE
VENTING	OCTOBER 2020	27	TM-0002	39

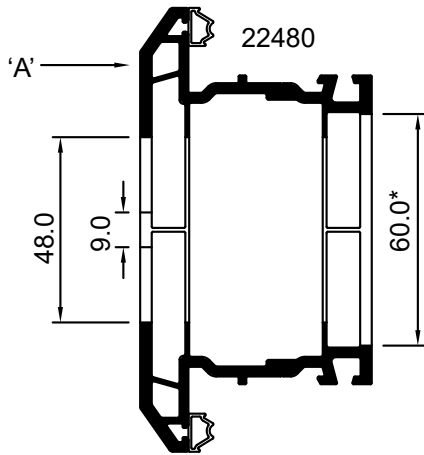
Frame Venting



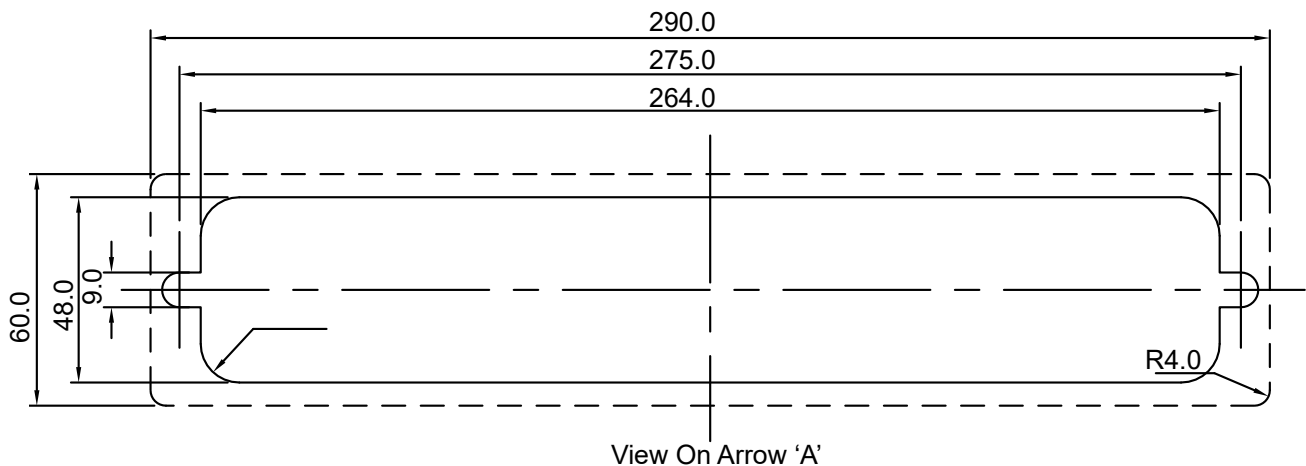
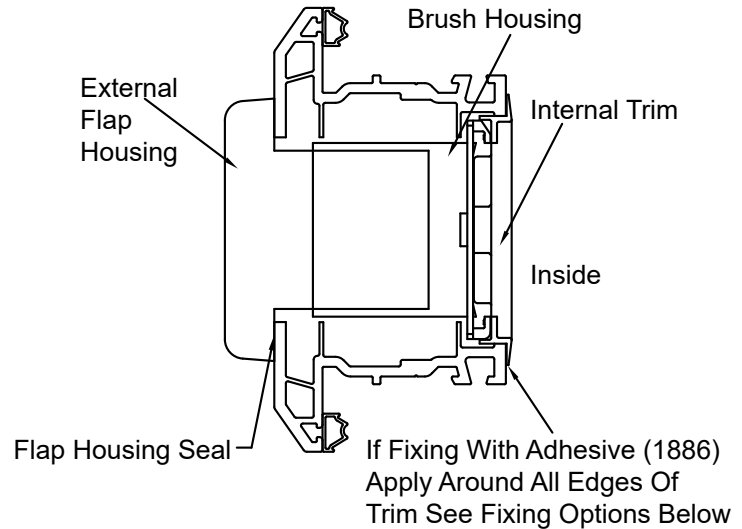
In-Line Sliding Patio Door Letterplate Fixing - 1375 - 12"

SECTION	DATE	ISS	REFERENCE	PAGE
LETTER PLATE ROUTING	OCTOBER 2020	27	TM-0002	40

Routing Detail - 1375



*Ensure That This Dimension Breaks Through Outer Wall Only



ASSEMBLY

1. Prepare the Midrail as per routing detail.
2. Insert brush housing into internal aperture.
3. Insert flap housing into external aperture and interlock with brush housing (ensure seal is in position as (shown)).
4. Ensure both housings are sitting flush against the profile.
5. Hold internal trim in place to check alignment.
6. Once visual alignment is complete, fix the assembly using one of the options below.

Fixing - Option 1

7. Secure the external flap/brush housing from the inside with two screws (supplied with kit) then apply adhesive (1886) around edges of internal trim and place in position.

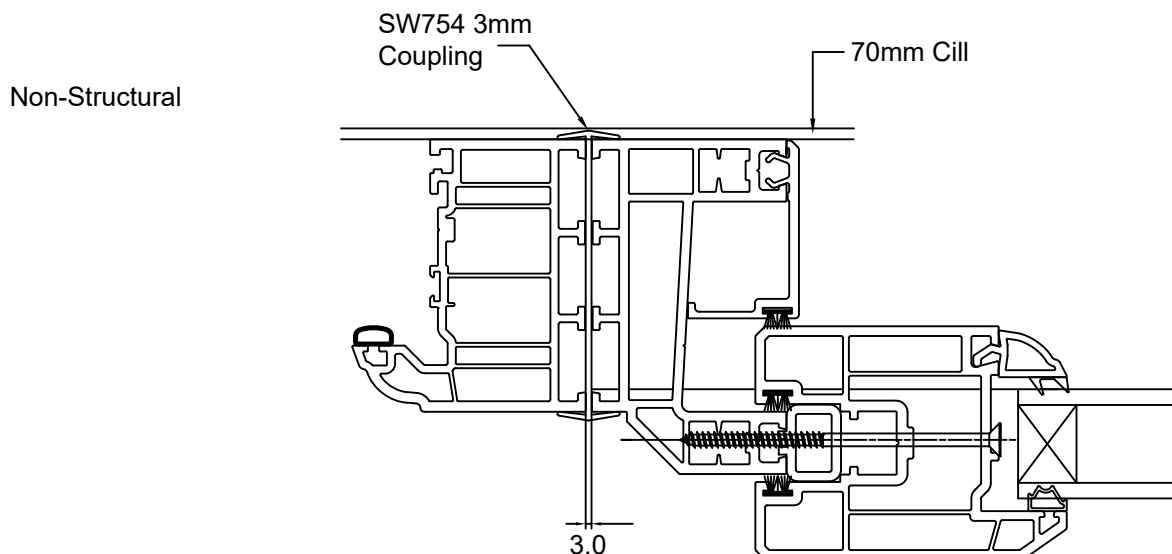
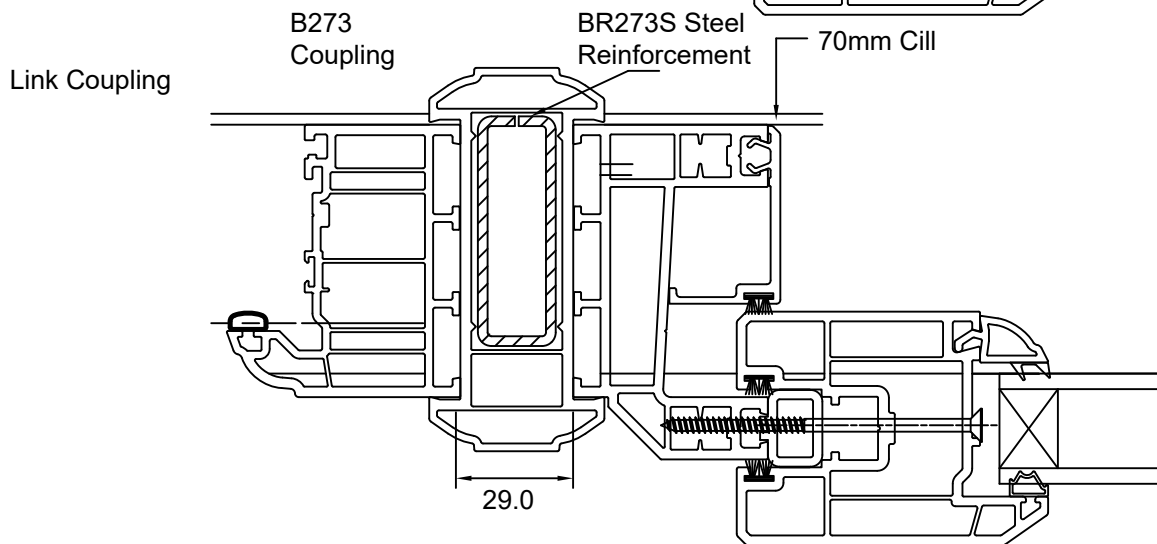
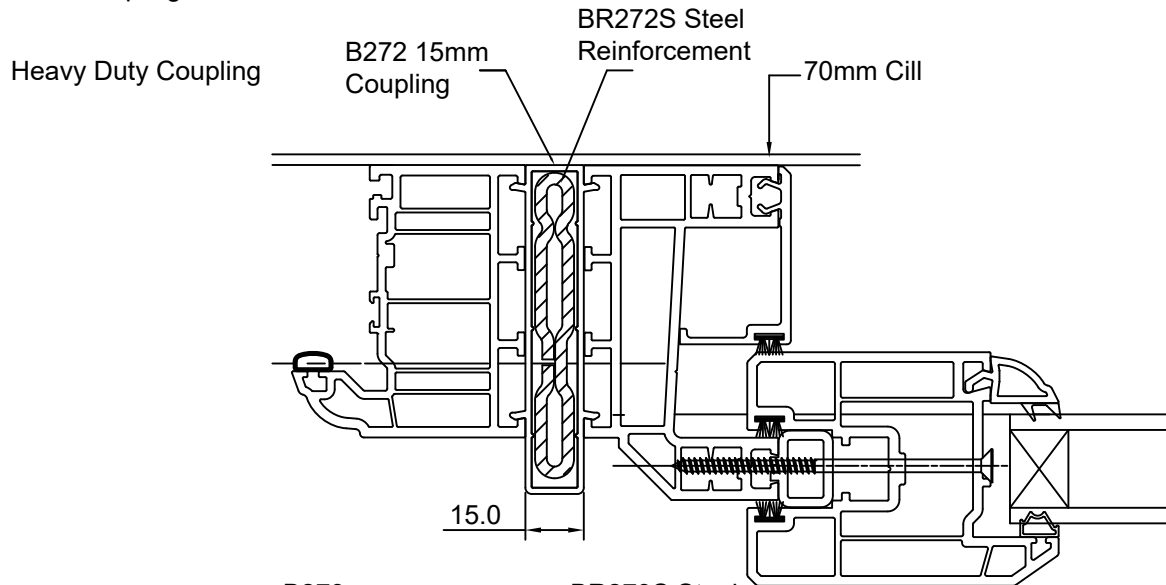
Fixing - Option 2

8. Secure the external flap/brush housing/internal trim from the inside using two screws (supplied with kit) into the bosses of the flap housing. Take care not to overtighten the screws. Note: Break through the blind holes on the internal trim to access screw fixing.

In-Line Sliding Patio Door Frame Coupling - 70mm

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FRAME COUPLING	OCTOBER 2020	27	TM-0002	41

Frame Coupling - 70mm

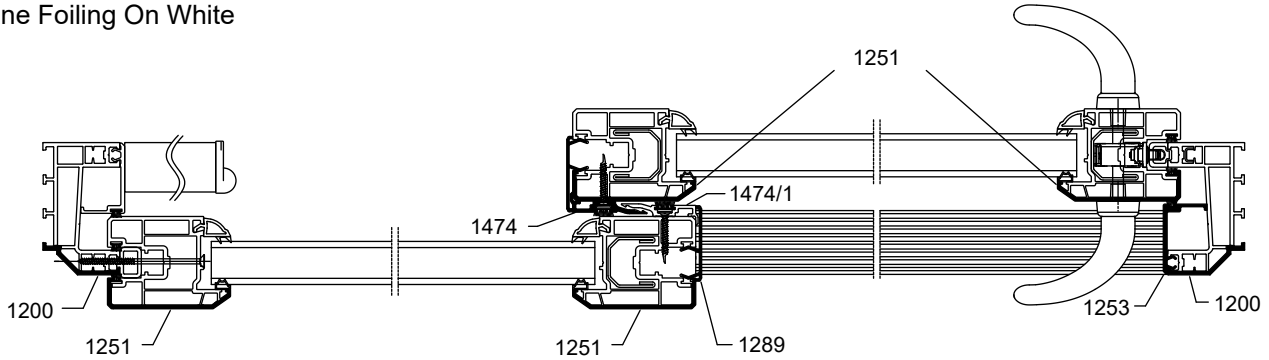


In-Line Sliding Patio Door Foiling Position

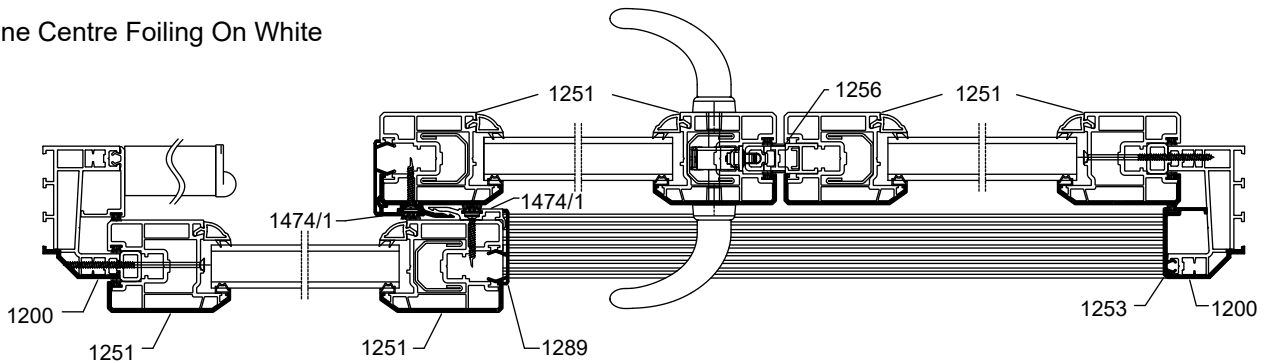
SECTION	DATE	ISS	REFERENCE	PAGE
FOILING POSITION	OCTOBER 2020	27	TM-0002	42

Parts identified are required to be coloured to suit the external colour. All other parts will be white.

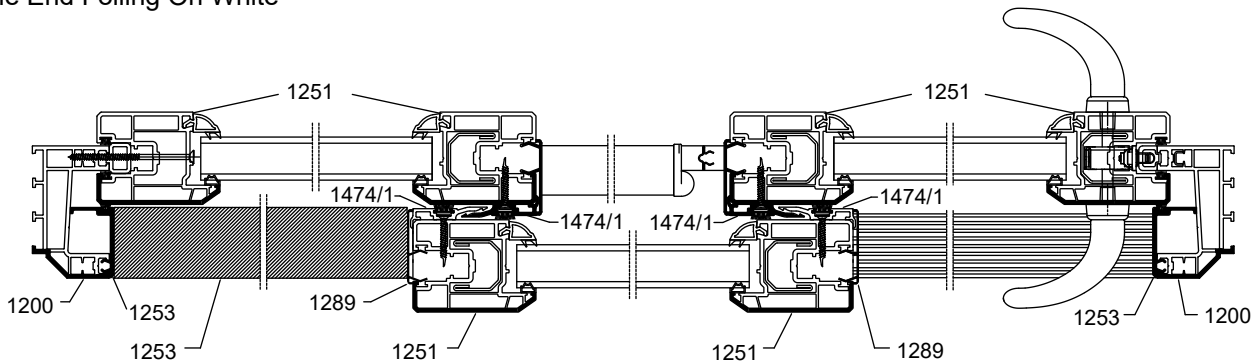
2 Pane Foiling On White



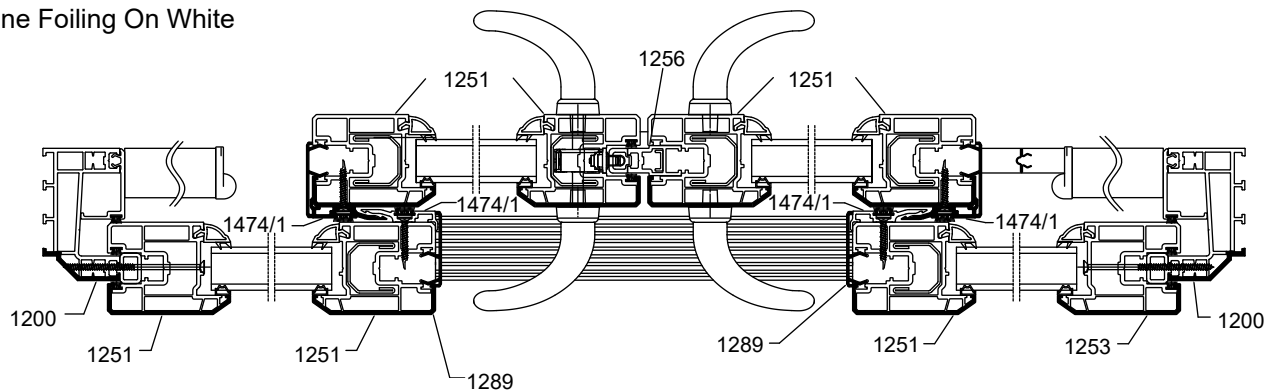
3 Pane Centre Foiling On White



3 Pane End Foiling On White



4 Pane Foiling On White



Note:

Head Trim = 1253

Dimensions in MM
All dimensions are nominal.
DO NOT SCALE

All information in this publication is provided for guidance only and is given in good faith. As it is company policy to continually improve products, methods and materials, change of specification may be from time to time without prior notice. This statement does not affect your statutory rights ©SBP LTD.

In-Line Sliding Patio Door

PAS24 Security - Introduction



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Introduction

This section specifies the build requirements for PAS24 Security 2 and 3 Pane Sliding Patio Doors, designed to comply with the requirements of:

BS6375: General Performance Requirements for Door Assemblies
PAS 24: Enhanced Security Performance Requirements for Door Assemblies

Although both of the above standards relate to product as manufactured and before installation, it is recommended that on installation, the guidelines given in British standard BS8213-4:2007 code of practice for the Survey & Installation of windows & external door sets.

Each glazed area shall include at least one pane of laminated glass meeting the requirements of BS EN 356:2000, Class P1A, and be glazed in accordance with BS 6262.

Note that all doors manufactured in accordance with this document can be classified as DK (key-key) to clause 4.4.4 of PAS24:2016. I.e. doors can be fitted with a key-key cylinder where appropriate.

PVC-U Welds

No compromises. Weld strengths to be optimum achievable i.e. watch cleanliness, no tape in welds etc.
Sizes

Sizes must be as close to nominal as possible (See deductions page). Larger than nominal cavity sizes equates to larger clearances. A maximum tolerance of $\pm 1\text{mm}$ is allowable on sash & frame finished sizes.

Reinforcing

It is essential that hardware is fixed back to steel reinforcement and so approximate reinforcement length is not acceptable. The length of reinforcement relative to profile length needs to be right. Fixing of reinforcement is crucial, over fix rather than under fix. For guidelines on the use of reinforcement see BPF document 323/1 - "The Reinforcement of High Impact Modified PVC-U Windows and Doorsets."

Routing

Routing detail must be to the drawing. Excessive routing weakens the section

Hardware

Check that the product is to the latest specification. No compromises allowed.

Screws

Query every screw before using it. Is it the correct one? If you're not sure ask!

Framing (For PAS 24 Testing)

Assemble the door into it's timber frame and where clearances exist, pack the door to the frame. This is very important at locking points.

Screw fix the door to the frame - over fix rather than under fix. Use minimum No.10 wood screws.

Glazing

Glass Packing is crucial.

In addition to normal glass packing the clearance between PVC-U/glass/Panel should be minimized at/and adjacent to each locking point. Remember loads can be applied in any one of 3 directions so location packers need fitting so that loads can be taken by the glass/panel without distorting the PVC-U.

Note: All glazing must be made secure by use of security glazing clips.

Final check

Stand the completed assembly vertical and check:-

1. Free operation of hardware.
2. Squareness of frame.
3. Cover of leaf/frame on all 4 sides.

GENERAL

The testing regime is very demanding & so an extra degree of care and attention needs to be exercised during manufacture.

SECURED BY DESIGN

Contact with the local Police ALO/CPDA is advisable at an early stage to agree the technical requirements for a particular installation.

In addition to compliance with this document, SBD specify additional requirements for doors. As specifications may change, it is recommended that www.securedbydesign.com is accessed for the latest specifications.

In-Line Sliding Patio Door

PAS24 Security - Product Build Specifications



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Product Build Specification

The following specifies the range of product that can be made and that will satisfy the requirements of PAS24 Security Patio Doors.

All component parts are supplied by Profile22/ Safeware - alternatives are not acceptable. The requirements of both standards are very demanding - no deviations from this specification are allowable.

ITEM	DESCRIPTION							
STYLE	2 Pane Sliding Patio Door Without Midrail.No Letter Plate.	3 Pane End Sliding Patio Door Without Midrail. No Letterplate.						
MAXIMUM FRAME SIZE	2400 x 2200mm	3518 x 2200mm						
MAXIMUM SASH SIZE	1198 x 2116mm	1198 x 2116mm						
MIN FRAME SIZE	1984mm	1984mm						
MIN SASH HEIGHT	1900mm	1900mm						
PROFILES	Outer Frame 1200 Threshold 1200 Leaf 1251							
REINFORCEMENTS	Outer Frame Lock Jamb Part No. 1260 (full length) All Frame Members Part No. 1262							
	Leaf - Sliding Lock Stile Part No. 1258 Head & Cill / Interlock Stile Part No. 1257 Interlock Reinforcement Part No. QX32/1	Leaf - Fixed Interlock Stile Part No. 1257 Interlock Reinforcement Part No. QX32/1						
GLAZING	Glazing is internally beaded using any BS EN 12608 approved bead compatible with 28mm units. All glazing must be made secure by the use of security glazing clips. All glazing must be to BS EN 6262. Also see BS 6262 Part 4 - "Safety related to human impact."							
WEATHERSEALS	Bubblex Applies Throughout							
HARDWARE	Enhanced Security Specific Parts Are: Cylinders (only the following cylinders shall be used)							
	<table border="1"> <thead> <tr> <th>TYPE</th> <th>PART NO.</th> </tr> </thead> <tbody> <tr> <td>KEY-KEY</td> <td>S1477TS</td> </tr> <tr> <td>THUMB TURN</td> <td>S1478TS</td> </tr> </tbody> </table>			TYPE	PART NO.	KEY-KEY	S1477TS	THUMB TURN
TYPE	PART NO.							
KEY-KEY	S1477TS							
THUMB TURN	S1478TS							
FIXING SCREWS	6 Point Lock - 1480 Security Keep - 1481 PAS24 Kit Standard Threshold - 1483 Patio Interlock - 1474/1 Handle - 1464							
	6 Point Lock Security Keep: Security Keep Rail Head: Interlock:	Part No. F7851030 F7895038 F7885038 F7875050	Description 4.3 x 030 CSK PZ YD SP 4.8 x 038 CSK PZ BZ TP 4.8 x 038 CSK PZ YD SP 4.5 x 050 CSK PZ YD SP					
The recommended screw MUST be used; alternative equivalent screws are NOT acceptable.								
Screws must be secure, but stripped screws are NOT acceptable. For general guidelines on the use of screws see BPF document 335/3, "Specification and guidelines for the selection and application of fasteners for the manufacture of PVC-U Windows and doors.								

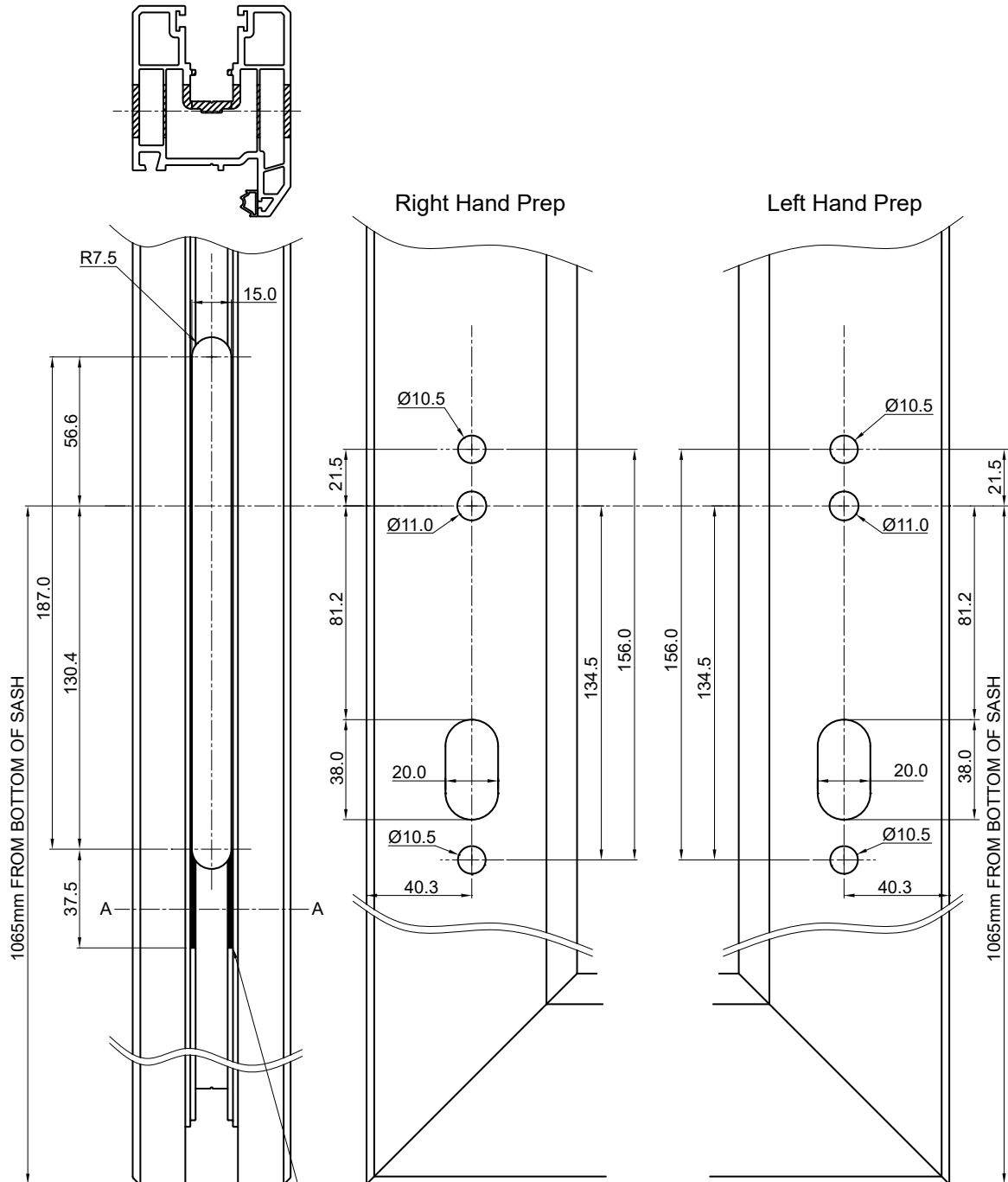
In-Line Sliding Patio Door

PAS24 Security - Security Handle Preparation



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1464 Handle Routing



REMOVE MATERIAL SHOWN 37.5MM BELOW THE MAIN LOCK PREP TO ALLOW CLEARANCE FOR THE DRIVE ROD CONNECTOR BLOCK

Note:

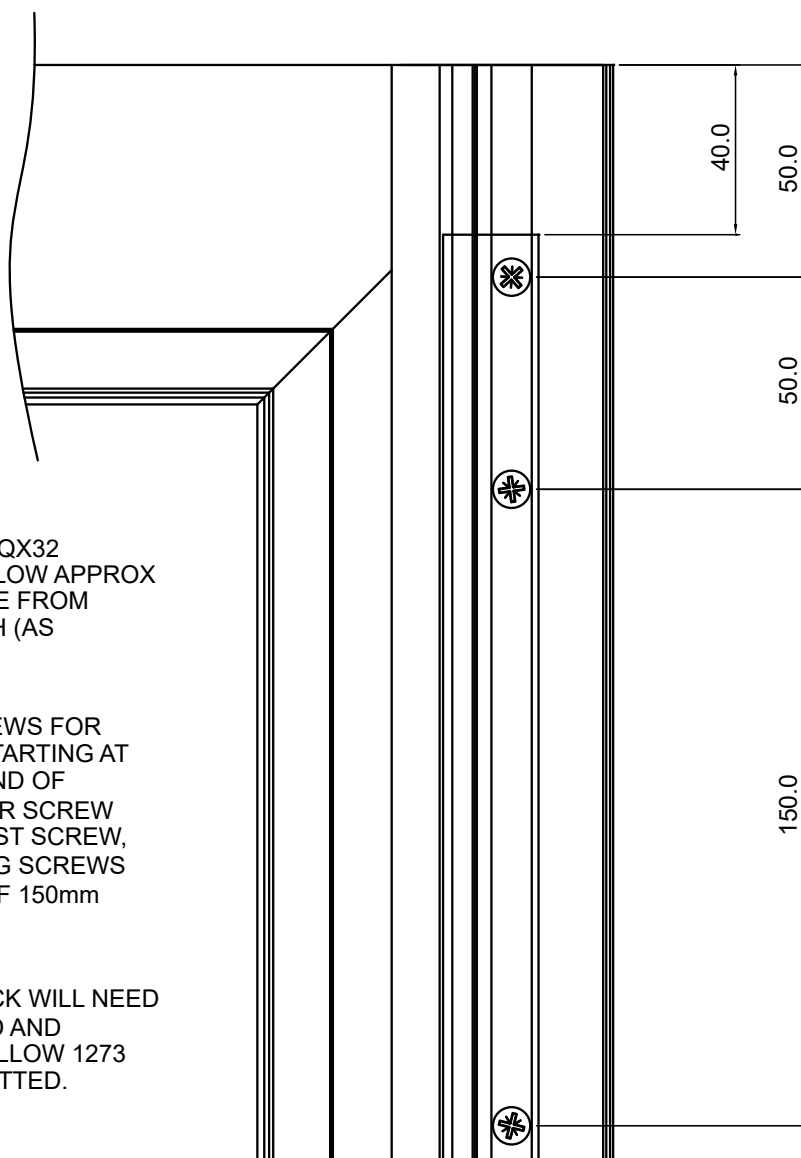
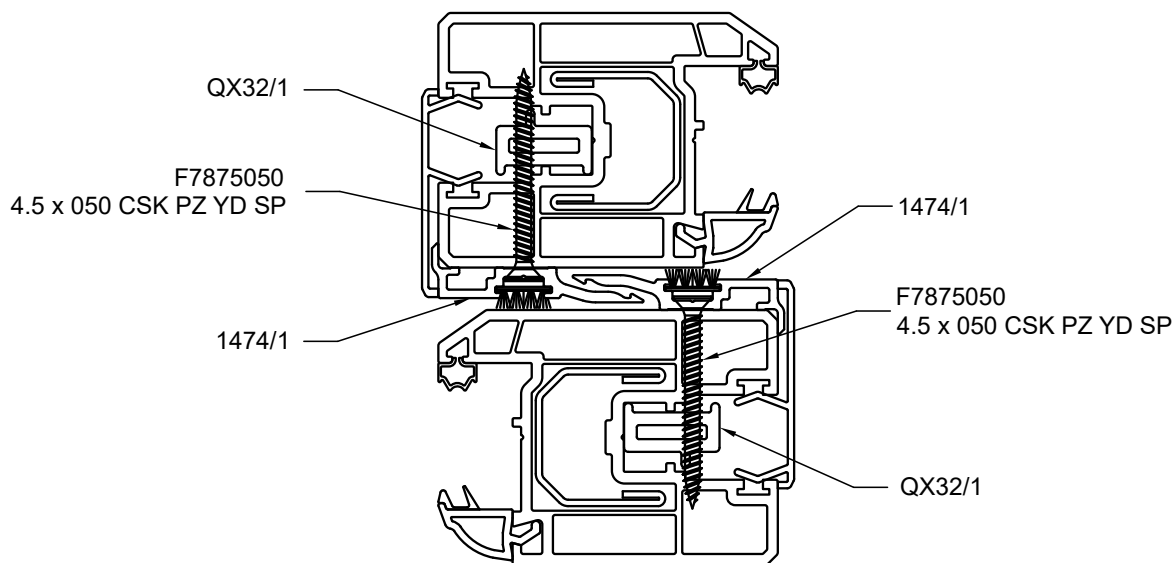
1. Tolerance $\pm 1\text{mm}$ unless otherwise stated.
2. Holes to take handle fixing boss has been sized to minimize movement of the handle in operation. Powder coated handles will fit tighter than other handles due to a build up of paint on the locating boss.

In-Line Sliding Patio Door

PAS24 Security - 1474 Interlock Fitting



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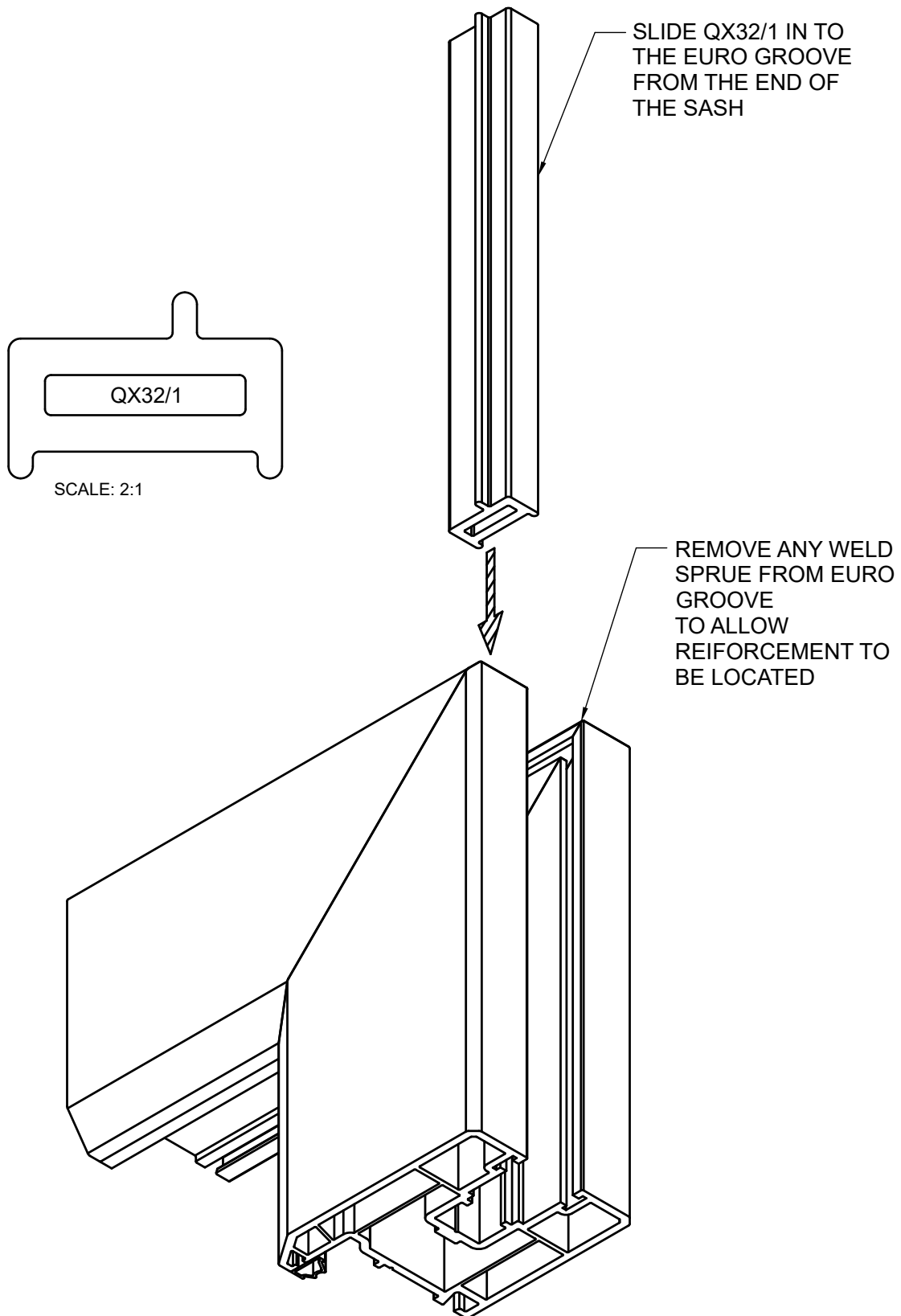
NOTE:
WHEN CUTTING THE QX32
REINFORCEMENT ALLOW APPROX
40MM OF CLEARANCE FROM
EITHER END OF SASH (AS
SHOWN).

LOCATE FIXING SCREWS FOR
1474/1 INTERLOCK STARTING AT
50mm FROM EACH END OF
SASH, THEN ANOTHER SCREW
50mm FROM THE FIRST SCREW,
THEN THE REMAINING SCREWS
AT MINIMUM PITCH OF 150mm
(AS SHOWN).

THE 1474/1 INTERLOCK WILL NEED
TO BE PILOT DRILLED AND
COUNTERSUNK TO ALLOW 1273
BRUSH PILE TO BE FITTED.

In-Line Sliding Patio Door PAS24 Security - 1474 Interlock Fitting

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In-Line Sliding Patio Door Lock Fitting

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Ensure corners of profile are clean, fit top and bottom locking corners. Check they move fully and smoothly, then secure with F7851030 4.3x030 CSK PZ YD SP screws.

With lock and corner in unlocked position, please measure dimension 'X'.

With lock and corner in fully thrown position, please push/tap the drive link into the eurogroove and secure to the bar with the screws supplied.

With lock and corner in fully thrown position, please move the flag into position and tighten the screw with the 2mm Allen key (take care not to overtighten). Test operation of cylinder.

2mm fitting adjustment available

Line up serrated drive with serrated shoe and locate together. Test operation of the lock and cylinder.

Crop drive link assembly.

Remove black setting block and deburr if required.

Crop drive link assembly.

Remove black setting block and deburr if required.

Fit bar to sash, fit handle and cylinder. Test operation of lock and cylinder. Secure the bar with F7851030 4.3x030 CSK PZ YD SP screws.

2mm fitting adjustment available

In-Line Sliding Patio Door PAS24 Security - Security Keep Rail Fitting

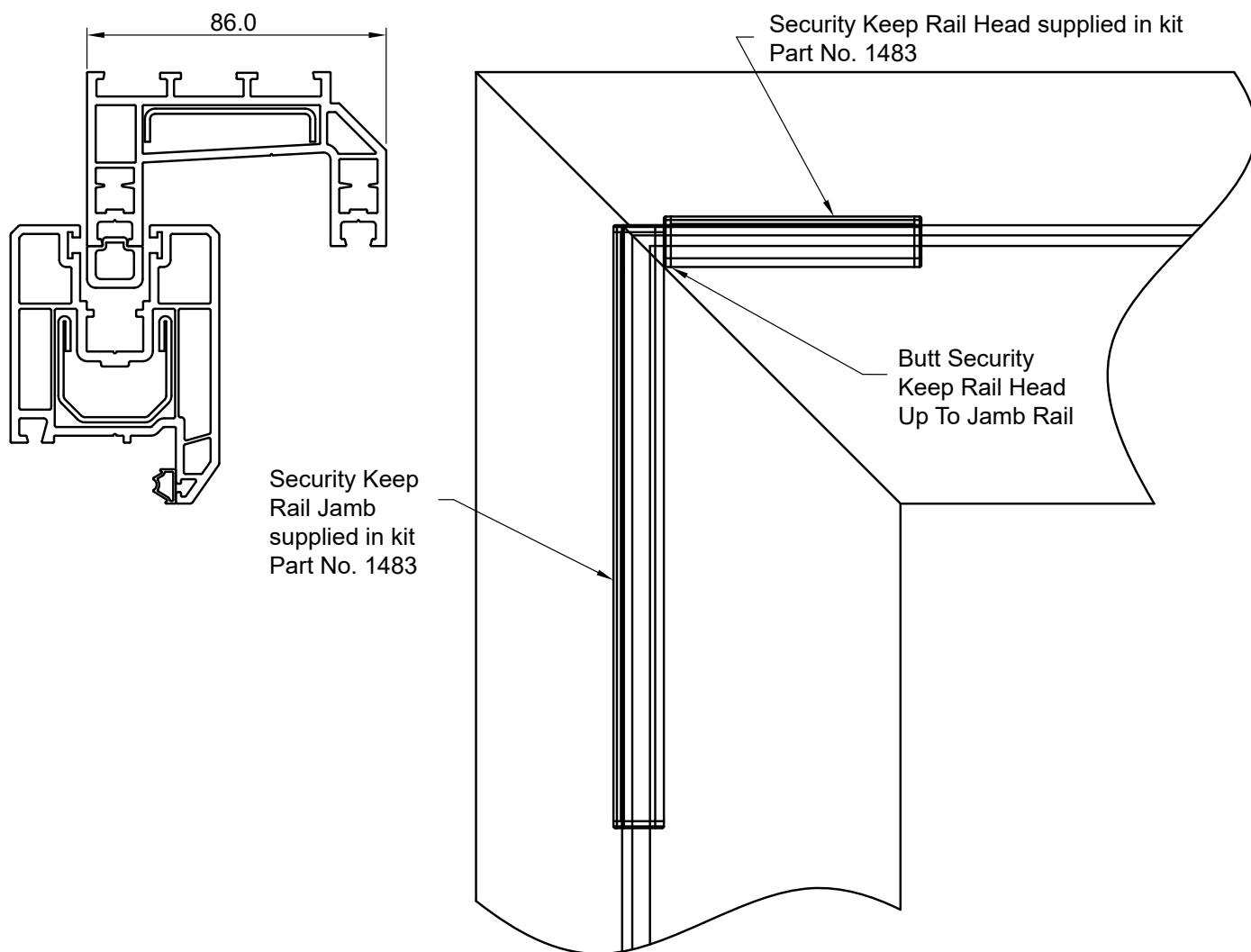
SECTION	DATE	ISS	REFERENCE	PAGE
PAS24 SECURITY	OCTOBER 2020	27	TM-0002	49

Security Keep Rail Fitting

Butt security keep rail jamb into corner of outer frame to give good support for the sash at the head. Fix with screws shown in the screw fixing table.

Butt security keep rail head against jamb keep rail.

Note: This part may have to be fitted, be removed & re-fixed after installation.

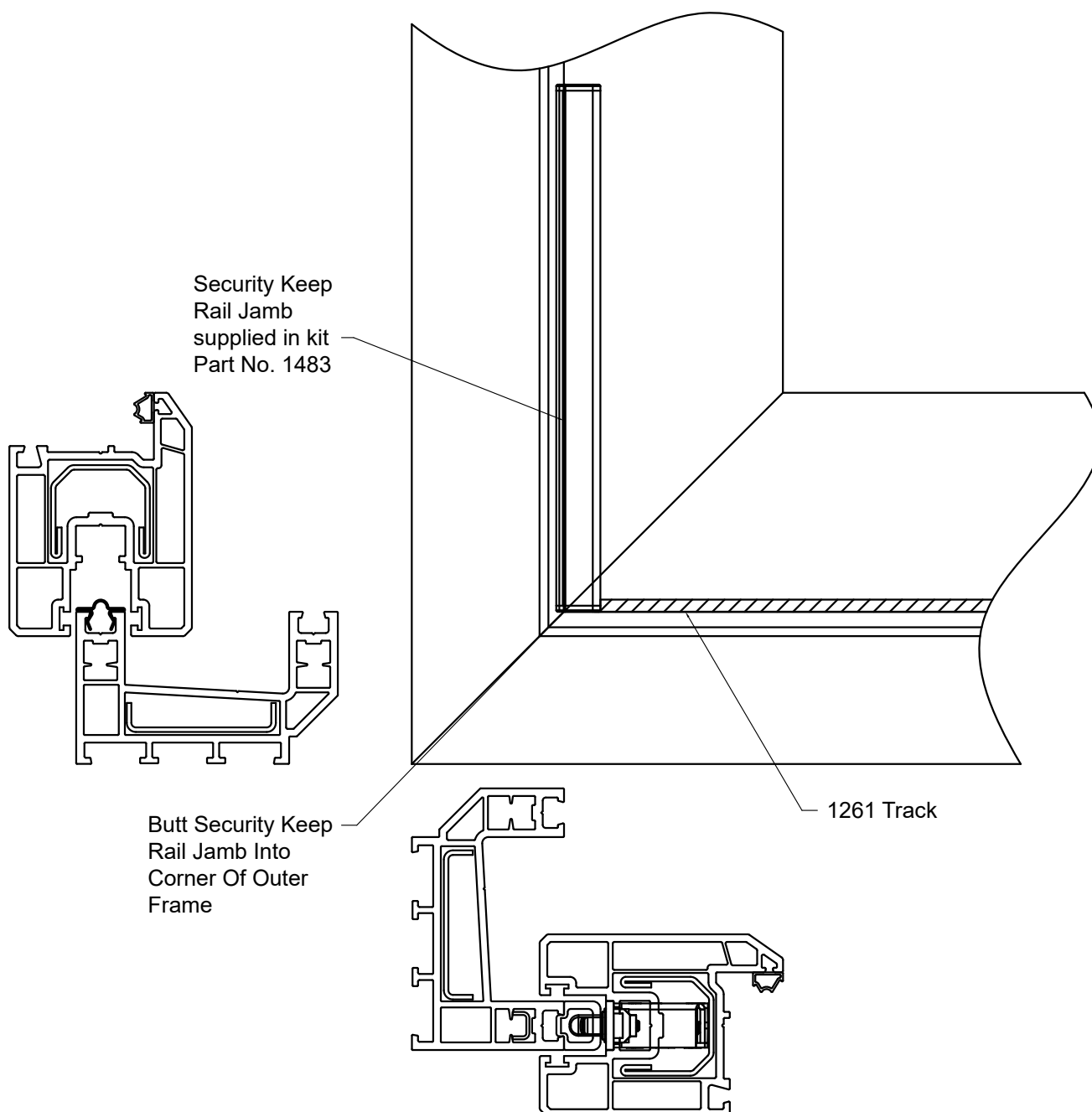


In-Line Sliding Patio Door PAS24 Security - Security Keep Rail Fitting

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PAS24 SECURITY	OCTOBER 2020	27	TM-0002	50

Security Keep Rail Fitting Continued

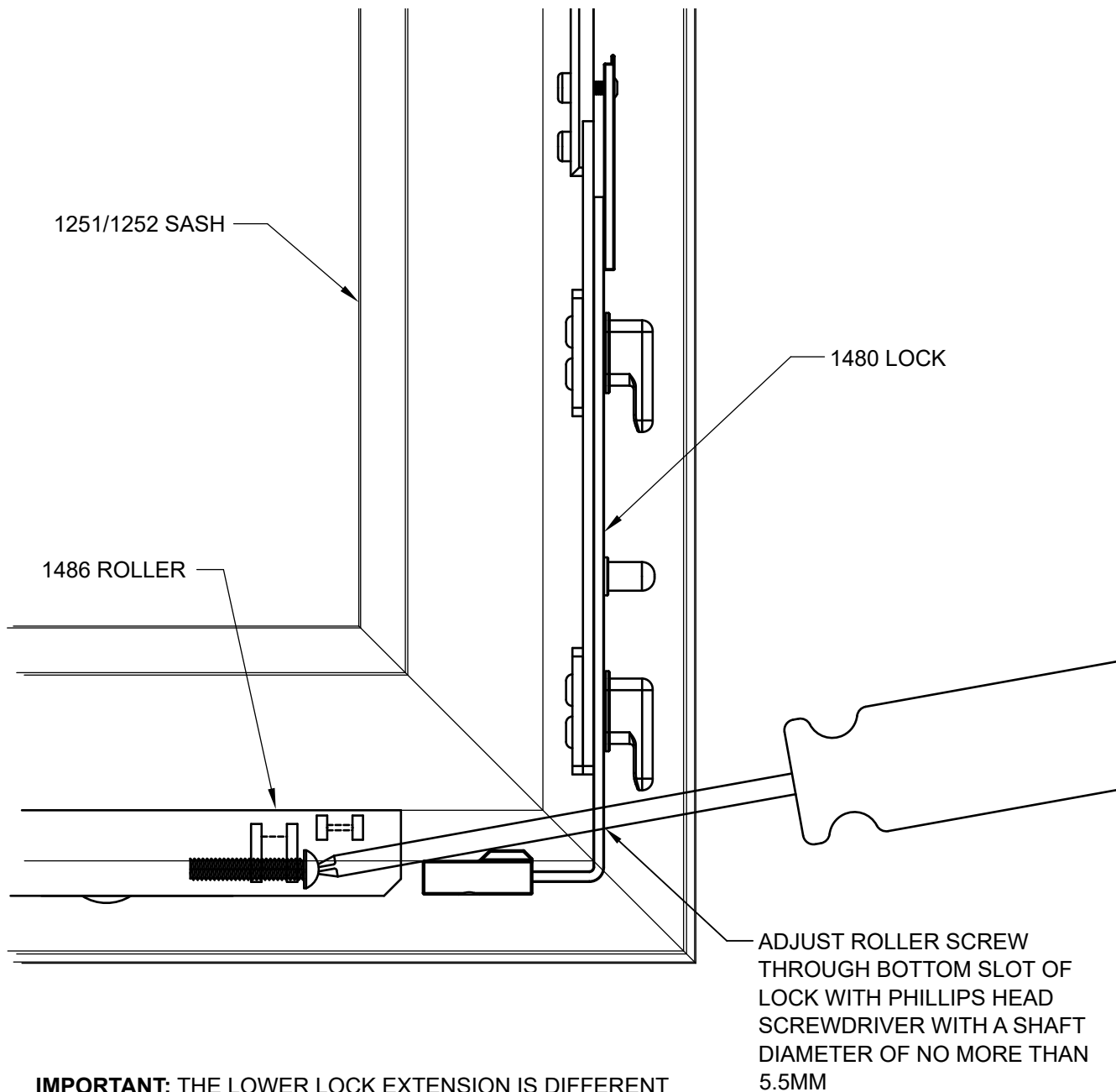
Fit security keep rail jamb, ensure keep butt's into bottom corner of outer frame and sits tight against head rail. Fix with screws shown in the screw fixing table.



In-Line Sliding Patio Door PAS24 Security - Roller Adjustment

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Roller Adjustment



IMPORTANT: THE LOWER LOCK EXTENSION IS DIFFERENT TO THE TOP LOCK EXTENSION. THIS IS TO ALLOW ACCESS TO THE ROLLER ADJUSTMENT SCREW. PLEASE ENSURE THEY ARE PUT AT THE CORRECT ENDS OF THE SASH.

In-Line Sliding Patio Door PAS24 Security - Security Glazing Clips



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PAS24 SECURITY	OCTOBER 2020	27	TM-0002	52

MANUFACTURING PROCESS FABRICATION (P2920) STANDARD SECURITY

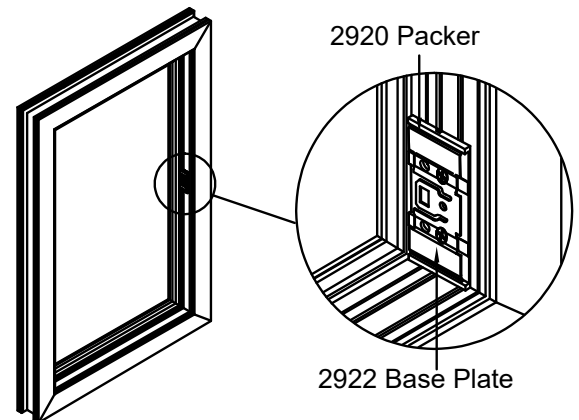
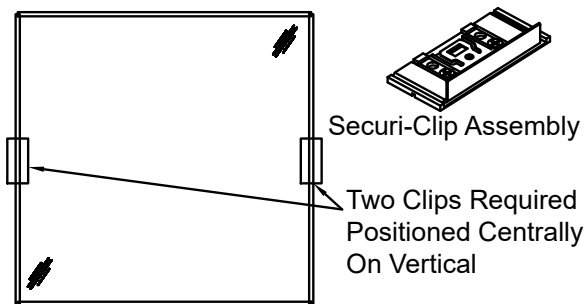
Security Glazing Clips

The fitting of security clips is required on doors using 28mm glazing. If required the following procedure must be followed.

During the fabrication process, apply each Base Packer at the centre of each vertical. Fix with F7660019 screws for reinforced profile, or F7801016 screws for un-reinforced profile. (2 screws per base packer).

INTERNAL GLAZING

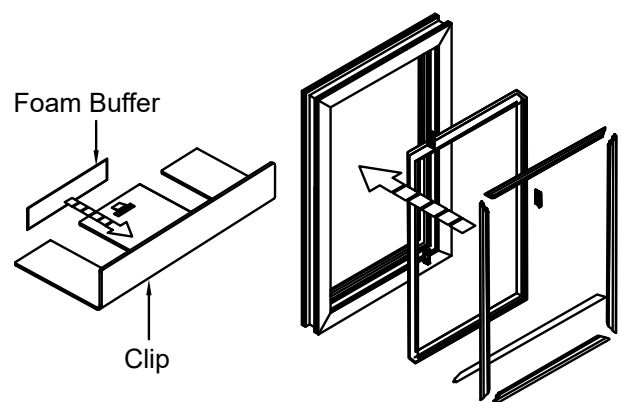
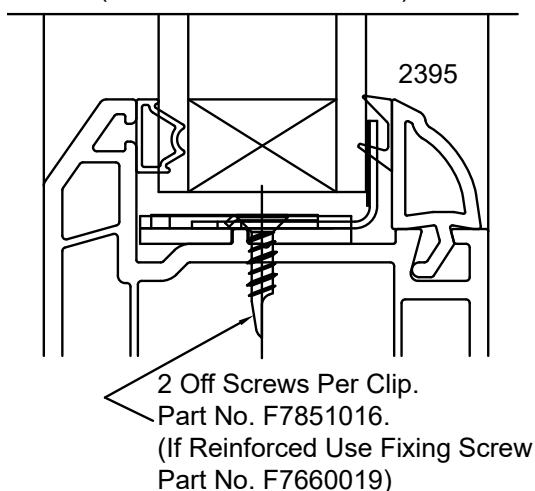
Fit two clips as shown, always position centrally on the vertical or as close to centre as possible avoiding glass packing. Conventional glass packing to be inboard of security clips.



GLAZING (P2928)

It is recommended that the 'SECURI-CLIPS' are fitted when the glass is finally installed on site after the glass unit has been correctly packed. Apply the 'foam-buffer pad' to the glass facing edge of the Securi-clips. Clip the Securi-clips into the basepackers and finally clip the beads into position.



(28mm Glass Unit Shown)



In-Line Three Track Sliding Patio Door Parts Breakdown/Deduction Chart



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DEDUCTIONS & PARTS BREAKDOWN	OCTOBER 2020	27	TM-0002	53

PART NO.	DESCRIPTION	 3 PANE END SLIDER		 6 PANE CTR SLIDER	
		DEDUCTION	QTY	DEDUCTION	QTY
1200	OUTER FRAME WIDTH	OW	2	OW	2
	OUTER FRAME HEIGHT - MECH. JOINT	OH - 52	2	OW - 52	2
	OUTER FRAME HEIGHT - WELDED	OH	2	OH	2
1251/1252*	SASH WIDTH	(OW/3) + 25	6	(OW/6) + 38	12
	SASH HEIGHT (STD THRESHOLD)	OH - 84	6	OH - 84	12
1262 (SEE NOTE 4.)	O/FRAME REINFORCEMENT WIDTH & HEIGHT - WELDED	OW - 80	2	OW - 80	2
	O/FRAME REINFORCEMENT HEIGHT - MECH. JOINT	OH - 200	2	OH - 200	2
1257 (SEE NOTE 4.)	SASH REINFORCEMENT WIDTH	SW - 136	4	SW - 136	8
	SASH REINFORCEMENT HEIGHT	SH - 136	4	SH - 136	8
1289	COVER PROFILE	SH	4	SH	8
	COVER PROFILE (TO THRESHOLD ONLY)	SH - 21	4	SH - 21	8
1204	DISTANCE PROFILE 300mm LTH	-	8	-	16
1254	CLOSURE PROFILE - HEAD (OUTER TRACK)	OW - 100	1	OW - 100	1
	CLOSURE PROFILE - HEAD (CENTRE TRACK)	(2 x SW) - 88	1	(2 x SW) - 88	2
	CLOSURE PROFILE - LOCK JAMB	(OH/2) - 514	2	(OH/2) - 514	2
1255	DRAINAGE TRIM - CILL (OUTER TRACK)	(2 x SW) - 92	1	(2 x SW) - 156	2
	DRAINAGE TRIM - CILL (CENTRE TRACK)	SW - 92	1	SW - 92	2
	DRAINAGE TRIM - HEAD (OUTER TRACK)	(2 x SW) - 92	1	(2 x SW) - 92	2
	DRAINAGE TRIM - HEAD (CENTRE TRACK)	SW - 92	1	SW - 92	2
1338	DOUBLE SIDED FOAM TAPE	TO SUIT 1255 TRIMS	8	TO SUIT 1255 TRIMS	16
1256	SASH MEETING PROFILE	N/A	-	SH - 32	2
1474/1	DOOR INTERLOCK	SH	4	SH	8
1261	TRACK (OUTER TRACK)	OW - 108	1	OW - 108	1
	TRACK (CENTRE TRACK)	(2 x SW) - 102	1	(2 x SW) - 89	2
1351	BRUSH SEAL	CUT TO LTH	-	CUT TO LTH	-
1273	INTERLOCK BRUSH SEAL (12mm)	SH	4	SH	8
22480	MIDRAIL - MECH. JOINTED	SW - 116	3	SW - 116	6
2365 & 2395	BEAD	CUT TO LTH	12	CUT TO LTH	24
1330	OUTER FRAME TRACK EXTENSION - HEIGHT	OH-110	2	OH-110	2
	OUTER FRAME TRACK EXTENSION - WIDTH	OW-10	2	OW-10	2
1253	HEAD TRIM INNER TRACK	(SWx2)-168	1	(SWx4) - 314	1
	HEAD TRIM - CENTRE TRACK	SW-88	1	(SWx2)-154	1
	JAMB TRIM	OH-57	4	OH-57	4
1321	COVER INFIL - HEAD	SW-88	1	(SWx2)-154	1
	COVER INFIL - JAMBS	OH-57	2	OH-57	2
1263	THRESHOLD (ALU) - INNER TRACK	(SWx2)-168	1	(SWx4) - 314	1
	THRESHOLD (ALU) - CENTRE TRACK	SW-88	1	(SWx2)-154	1
1320	THRESHOLD COVER INFIL - CENTRE TRACK	SW-88	1	(SWx2)-154	1
SWR272	ALUMINIUM CILL PACKER	OW		OW	

Notes:

Width deductions are based on equal glass sizes.

Max. Sash height must not exceed 2.5 x sash width.

On a 4 pane slider the master door is the left hand sash when viewed from inside.

SMH - Standard Midrail Height

Dimensions in MM
All dimensions are nominal.
DO NOT SCALE

Handles:

Left Hand - view from inside, door sliding to the left.

Right Hand - view from inside, door sliding to the right.

*For simplicity 1252 feature sash will not be referred to within this manual as all technical details are the same as 1251. Where details differ this will be clearly identified.

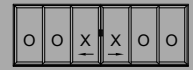
In-Line Three Track Sliding Patio Door Parts Breakdown



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DEDUCTIONS & PARTS BREAKDOWN	OCTOBER 2020	27	TM-0002	54



3 PANE END SLIDER



6 PANE CTR SLIDER

PART NO	DESCRIPTION	QUANTITY	QUANTITY
-	EQUAL GLASS WIDTH DEDUCTION	OW-323/3	OW-570/6
-	SASH WIDTH GLASS DEDUCTION	SW-133	SW-133
-	SASH HEIGHT GLASS DEDUCTION	SH-133	SH-133
-	MIDRAIL GLASS DEDUCTION STD. THRESHOLD	SMH-152.5	SMH-152.5
-	MIDRAIL GLASS DEDUCTION LOW THRESHOLD	SMH-126.5	SMH-126.5
-	ABOVE MIDRAIL GLASS WIDTH DEDUCTION	(OH-SMH)-152.5	(OH-SMH)-152.5
1270	END CAP FOR 1256	N/A	N/A
1272	DUST PLUG	1	2
1339	PATIO INTERLOCK SEAL	2	4
1268	JOINTING CLEAT-1200	4	4
1331	EXTENSION JOINT	4	4
1480	PATIO DOOR MAIN LOCK	1	1
1482	STAINLESS KEEP	1	1
(D)(H)(L)(T) 1460L	KEY-KEY HANDLE LH	1	1
(D)(H)(L)(T)(AG)(BZ)(GP) 1460R	KEY-KEY HANDLE RH	1	1
(D)(H)(L)(T)(AG)(BZ)(GP) 1461	BLANK-BLANK HANDLE	N/A	1
(D)(H)(L)(T) 1462	KEY-BLANK HANDLE	1	1
(D)(H)(L)(T) 1463	HANDLE BLANK PLATE	N/A	1
(S)(D) 1477EN	40/40 EURO CYLINDER	1	1
(S)(D) 1478EN	40/40 EURO CYLINDER	1	1
(S)(D) 1479EN	40/10 EURO HALF CYLINDER	1	1
1350	ANTI-LIFT BRACKET	1	1
1486	ROLLERS - LOW PROFILE	4	8
700065	PATIO DOOR STOP	4	8
1258	ROUTED STEEL FOR SASH LOCK JAMB	1	1
1260	OUTER KEEP REIF. LENGTH =1760mm	1	2
1266	ALUMINIUM REINFORCEMENT SASH MEETING PROFILE	N/A	1
7756	22480 MIDRAIL MECH. JOINT -50mm LG	2 PER MIDRAIL	2 PER MIDRAIL
1375	LETTER PLATE	1	1
1287	SASH TO FRAME SCREW 82mm LG	6	12
1322	INFIL END CAP (LH/RH PAIR)	1	1 PAIR
F7851030	LOCK/SASH	10	10
F7600038	KEEP/OUTER	10	10
F7851016	ROLLER/SASH	4	16
F7851030	INTERLOCK/SASH	8	16
F7851030	ANTI-LIFT BRACKET	3	6
F7757050	CLEAT/OUTER FRAME (HEAD & CILL)	8	8
F7660016	CLEAT/OUTER FRAME (JAMBS)	8	8
F7895065	SASH MEETING PROFILE TO SASH FRAME FIXING	N/A	8
F7660045	KEEP TO SASH MEETING PROFILE FIXING	N/A	10
F7851030	SHOOTBOLT/SASH	2	2
F7600038	SHOOTBOLT/KEEP	2	2

Notes:

- OH = Outer Frame Height
OW = Outer Frame Width
SH = Sash Height
SW = Sash Width

- All Deductions exclude weld allowance.
- Vertical deductions exclude optional cill.

- Fully reinforce sliding sashes and only interlock jamb, head and cill on fixed sashes. Use 1258 to lock jamb. A standard height sash reinforcement of 1828mm can be used with sashes which fall within the height of 1960mm-2274mm.
- Do not reinforce white, cream foil & white foil outer frames.
- All other foiled outer frames and fixed/sliding sashes must be fully reinforced.

Dimensions in MM
All dimensions are nominal.
DO NOT SCALE

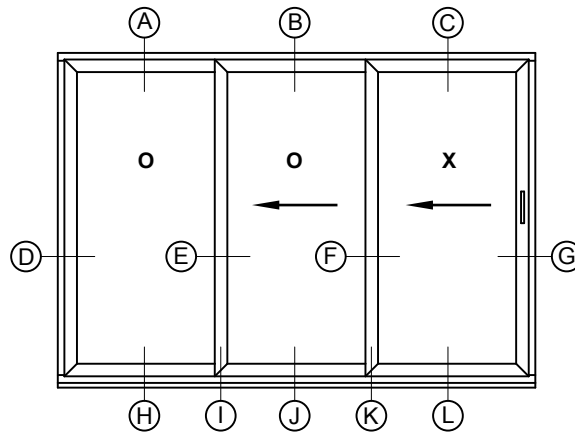
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In-Line Three Track Sliding Patio Door Patio Style Assembly Section Reference

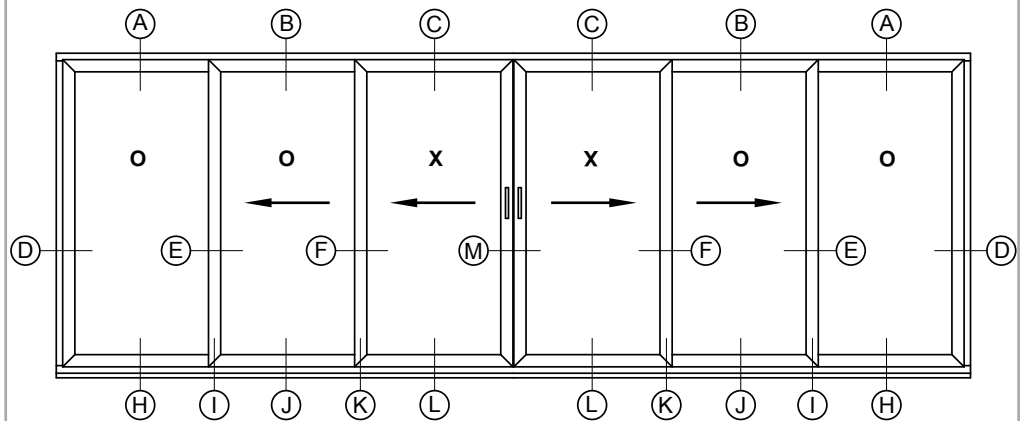


SECTION	DATE	ISS	REFERENCE	PAGE
ASSEMBLY SECTION DRAWINGS	OCTOBER 2020	27	TM-0002	55

3 PANE END SLIDER



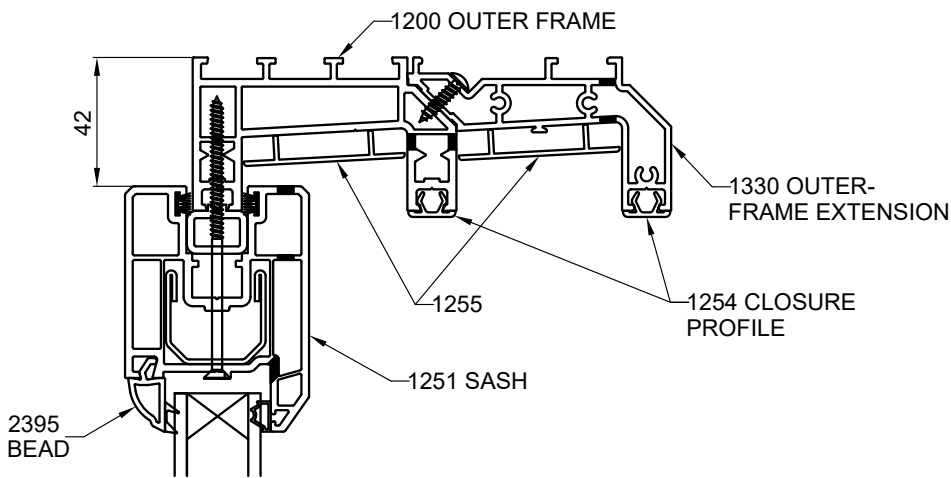
6 PANE CENTRE SLIDER



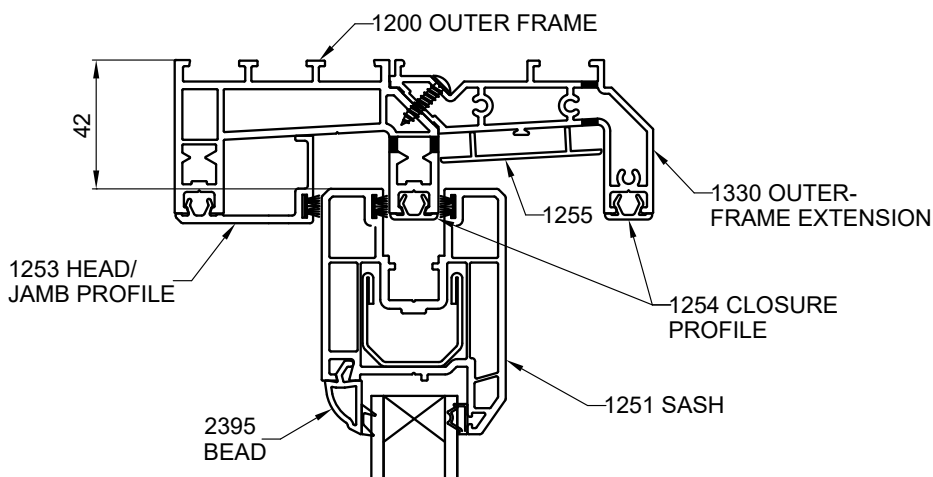
In-Line Three Track Sliding Patio Door Assembly Sections A, B and C



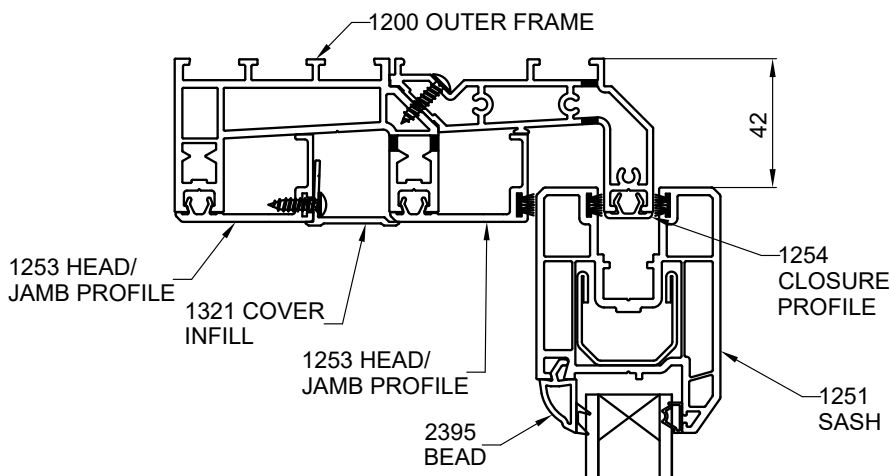
SECTION	DATE	ISS	REFERENCE	PAGE
ASSEMBLY SECTION DRAWINGS	OCTOBER 2020	27	TM-0002	56



APPLICABLE TO	
	3 PANE END SLIDER
	6 PANE CENTRE SLIDER



APPLICABLE TO	
	3 PANE END SLIDER
	6 PANE CENTRE SLIDER



APPLICABLE TO	
	3 PANE END SLIDER
	6 PANE CENTRE SLIDER

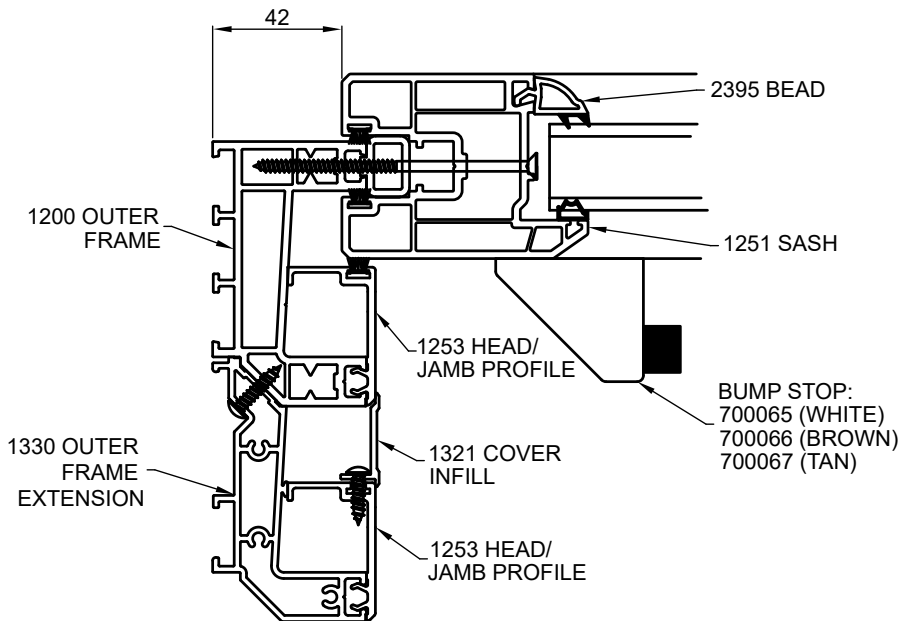
Note:
When positioning the fixed leaf, wedge the leaf towards the outside of the door before fixing to optimise the clearance between the fixed and sliding leaf.

Dimensions in MM
All dimensions are nominal.
DO NOT SCALE

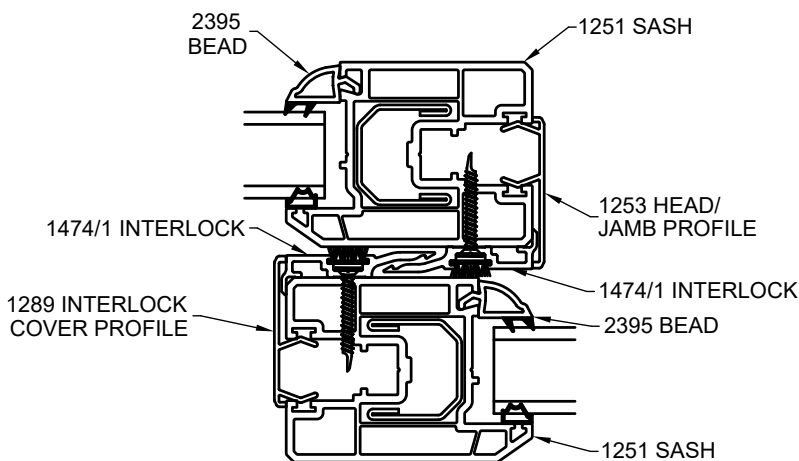
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In-Line Three Track Sliding Patio Door Assembly Sections D, E and F

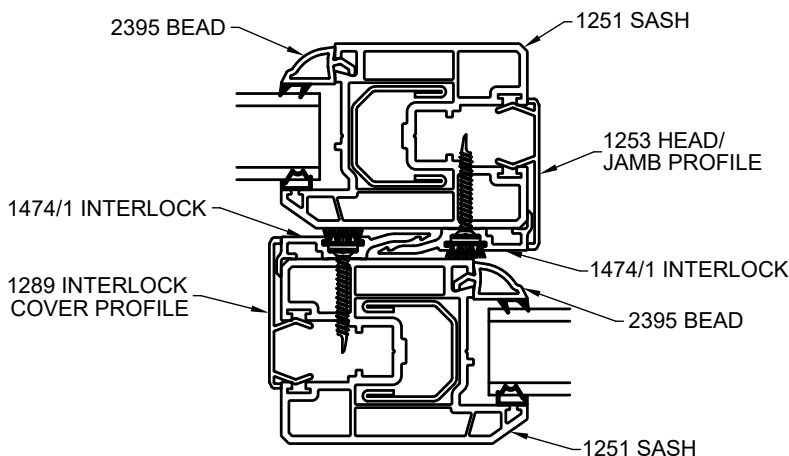
SECTION	DATE	ISS	REFERENCE	PAGE
ASSEMBLY SECTION DRAWINGS	OCTOBER 2020	27	TM-0002	57



APPLICABLE TO	
	3 PANE END SLIDER
	6 PANE CENTRE SLIDER



APPLICABLE TO	
	3 PANE END SLIDER
	6 PANE CENTRE SLIDER



APPLICABLE TO	
	3 PANE END SLIDER
	6 PANE CENTRE SLIDER

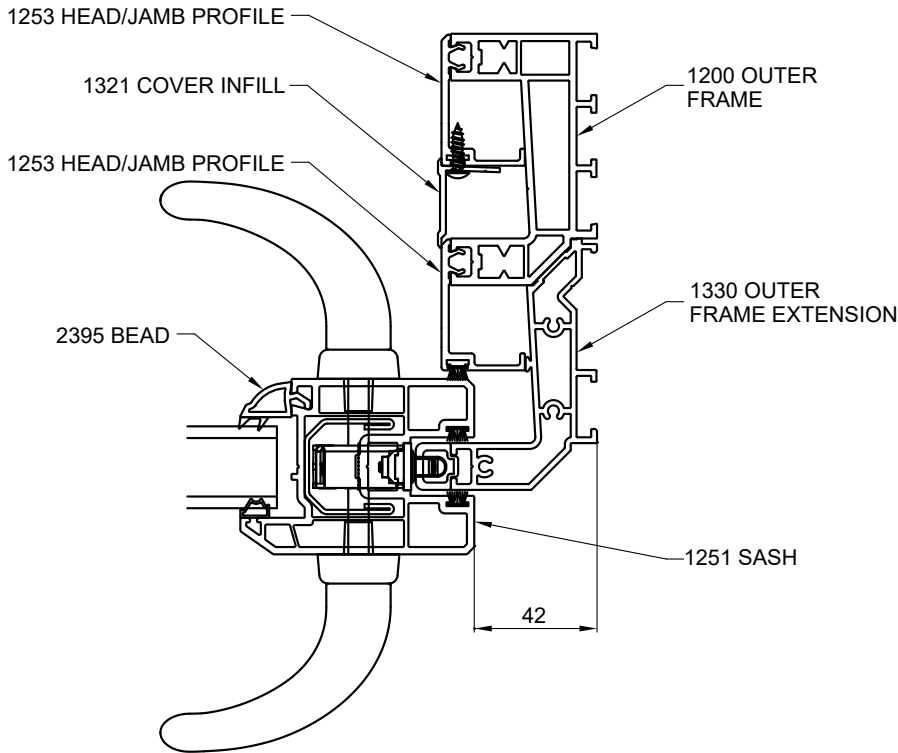
Note:
When positioning the fixed leaf, wedge the leaf towards the outside of the door before fixing to optimise the clearance between the and sliding leaf.

Dimensions in MM
All dimensions are nominal.
DO NOT SCALE

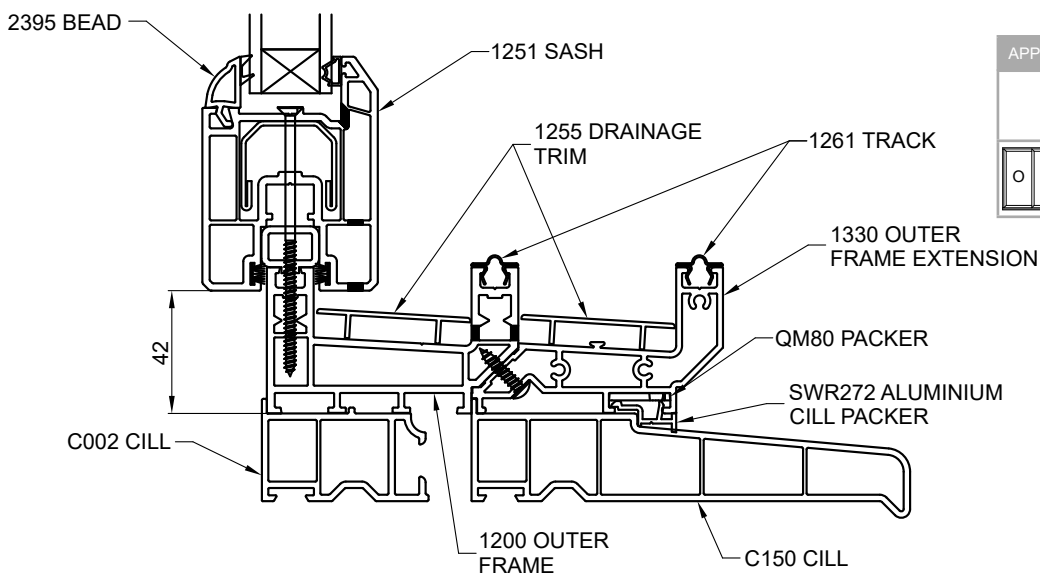
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In-Line Three Track Sliding Patio Door Assembly Sections G and H

SECTION	DATE	ISS	REFERENCE	PAGE
ASSEMBLY SECTION DRAWINGS	OCTOBER 2020	27	TM-0002	58



APPLICABLE TO	
	3 PANE END SLIDER
	6 PANE CENTRE SLIDER



APPLICABLE TO	
	3 PANE END SLIDER
	6 PANE CENTRE SLIDER

Note:
When positioning the fixed leaf, wedge the leaf towards the outside of the door before fixing to optimise the clearance between the fixed and sliding leaf.

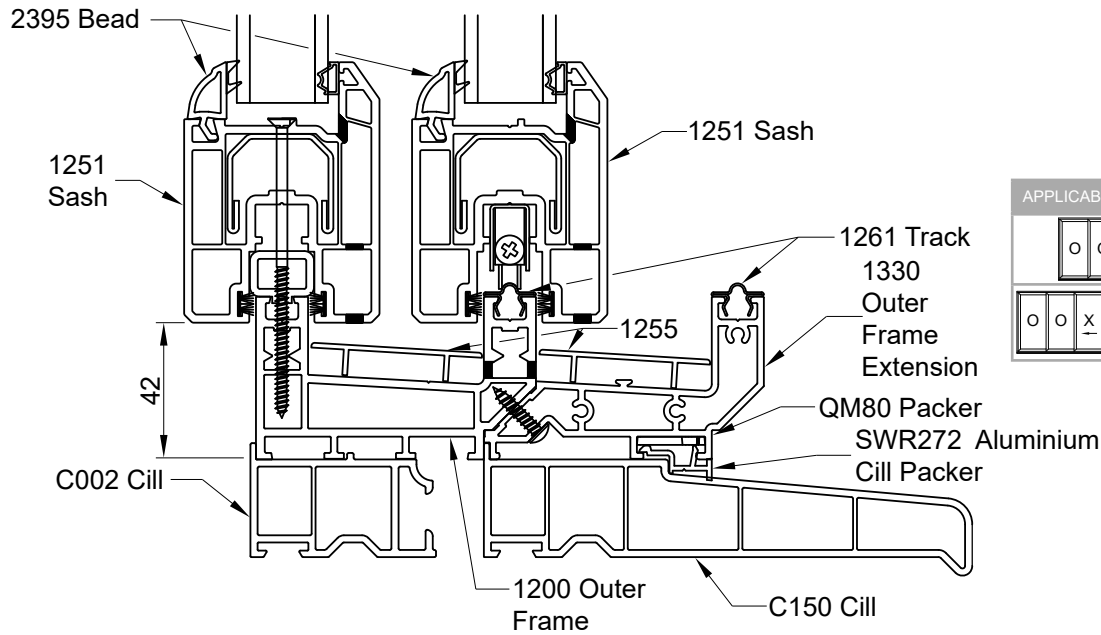
Dimensions in MM
All dimensions are nominal.
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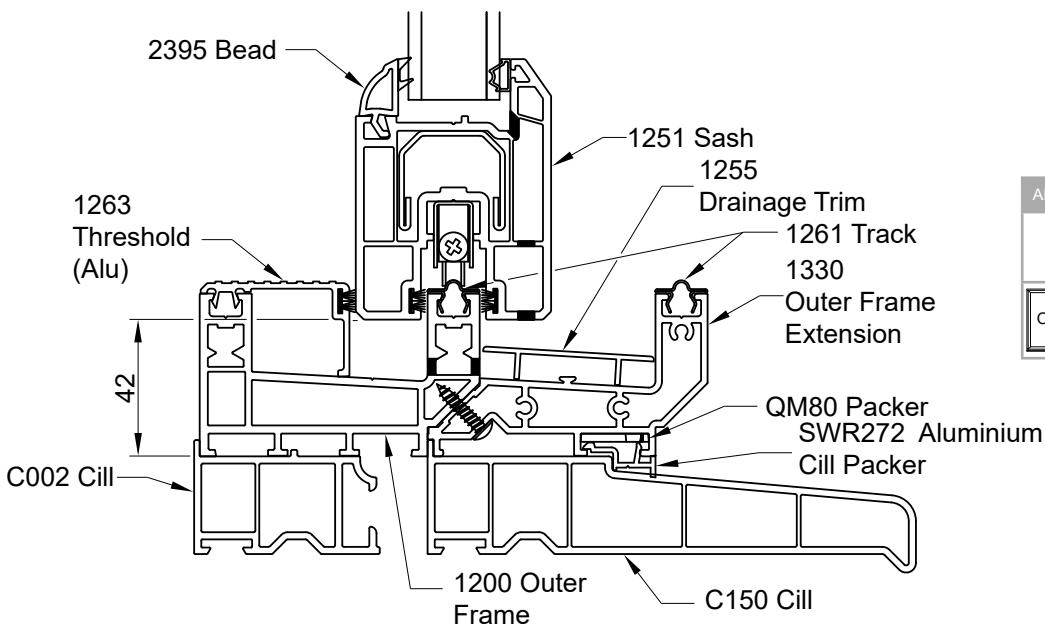
In-Line Three Track Sliding Patio Door Assembly Sections I and J



SECTION	DATE	ISS	REFERENCE	PAGE
ASSEMBLY SECTION DRAWINGS	OCTOBER 2020	27	TM-0002	59



APPLICABLE TO	
	3 PANE END SLIDER
	6 PANE CENTRE SLIDER



APPLICABLE TO	
	3 PANE END SLIDER
	6 PANE CENTRE SLIDER

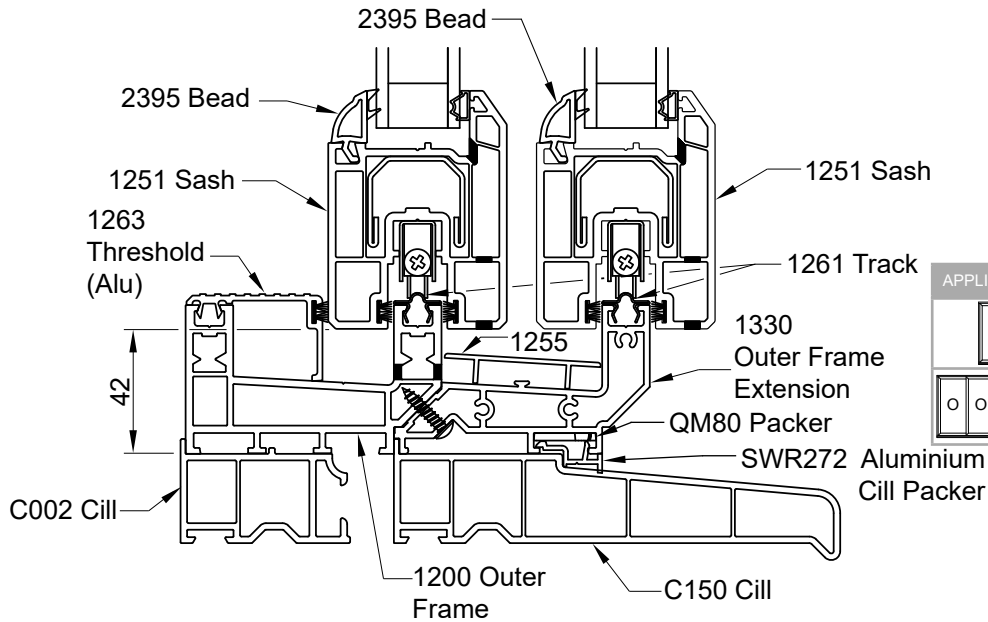
Note:
When positioning the fixed leaf, wedge the leaf towards the outside of the door before fixing to optimise the clearance between the fixed and sliding leaf.

Dimensions in MM
All dimensions are nominal.
DO NOT SCALE

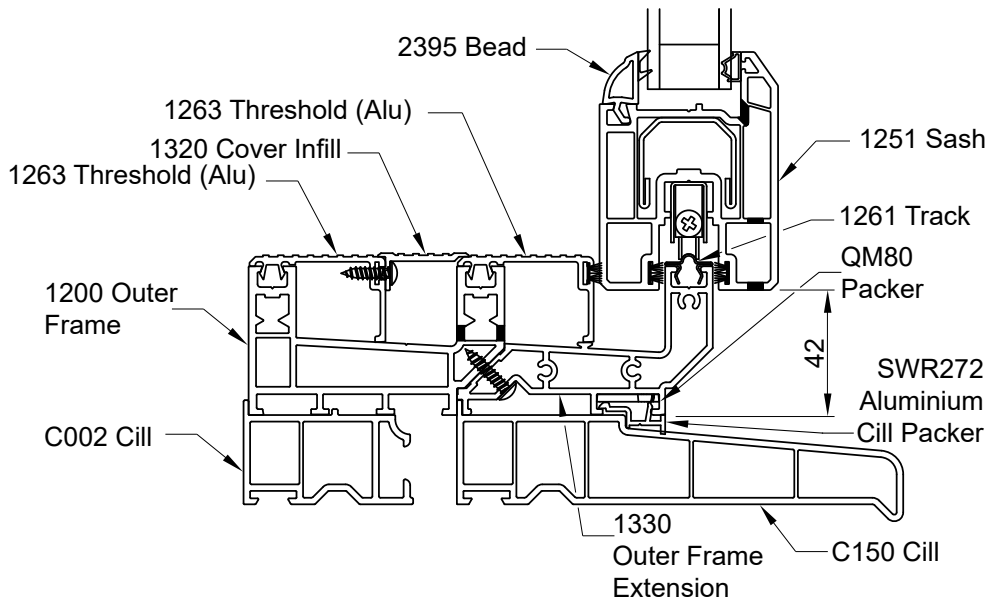
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In-Line Three Track Sliding Patio Door Assembly Sections K and L

SECTION	DATE	ISS	REFERENCE	PAGE
ASSEMBLY SECTION DRAWINGS	OCTOBER 2020	27	TM-0002	60



APPLICABLE TO	
	3 PANE END SLIDER
	6 PANE CENTRE SLIDER



APPLICABLE TO	
	3 PANE END SLIDER
	6 PANE CENTRE SLIDER

Note:
When positioning the fixed leaf, wedge the leaf towards the outside of the door before fixing to optimise the clearance between the fixed and sliding leaf.

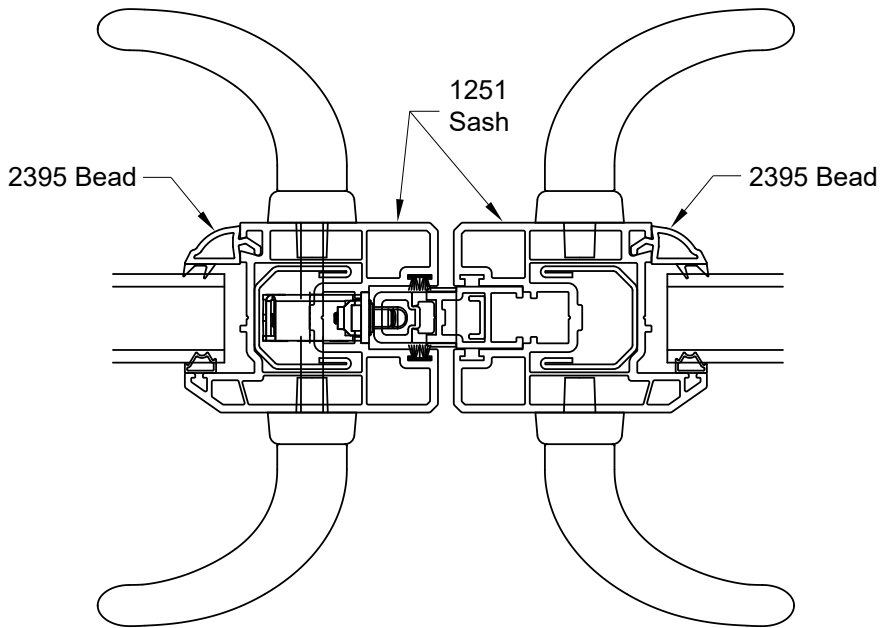
Dimensions in MM
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In-Line Three Track Sliding Patio Door Assembly Sections M



SECTION	DATE	ISS	REFERENCE	PAGE
ASSEMBLY SECTION DRAWINGS	OCTOBER 2020	27	TM-0002	61



APPLICABLE TO					
O	O	X	X	O	O
6 PANE CENTRE SLIDER					

Note:
When positioning the fixed leaf, wedge the leaf towards the outside of the door before fixing to optimise the clearance between the and sliding leaf.

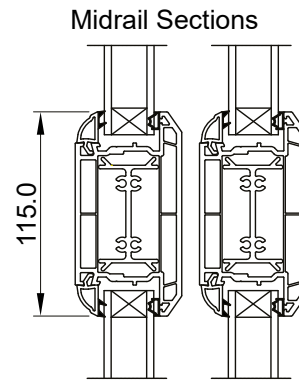
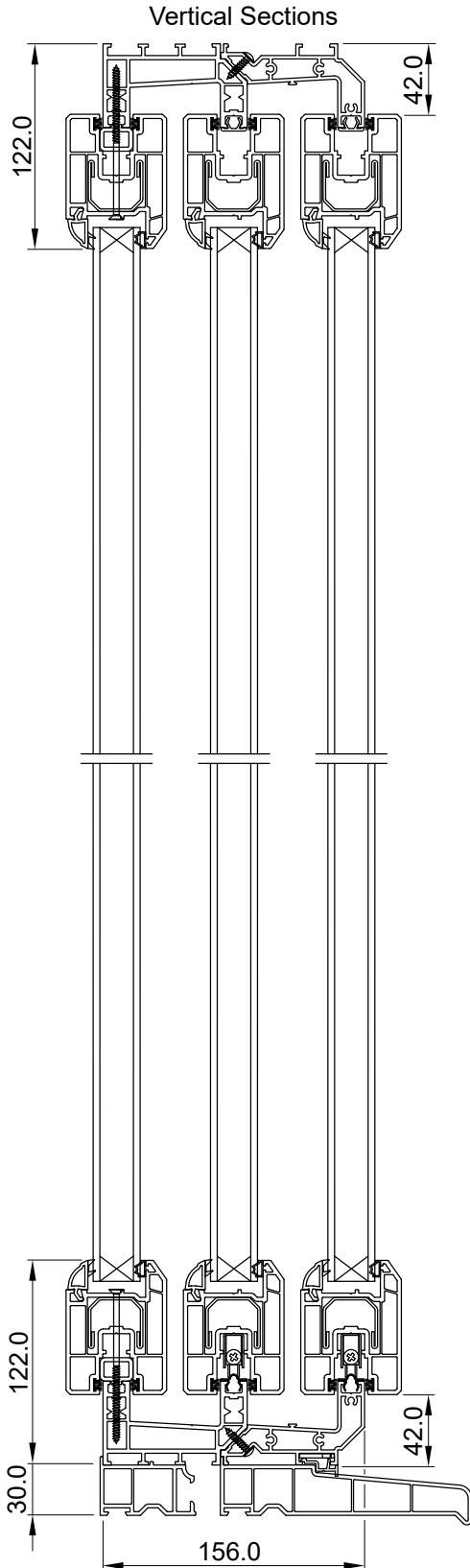
Dimensions in MM
All dimensions are nominal.
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In-Line Three Track Sliding Patio Door Vertical Sections



SECTION	DATE	ISS	REFERENCE	PAGE
ASSEMBLY SECTION DRAWINGS	OCTOBER 2020	27	TM-0002	62



Detail Showing C002 & C150 - 150mm Cill

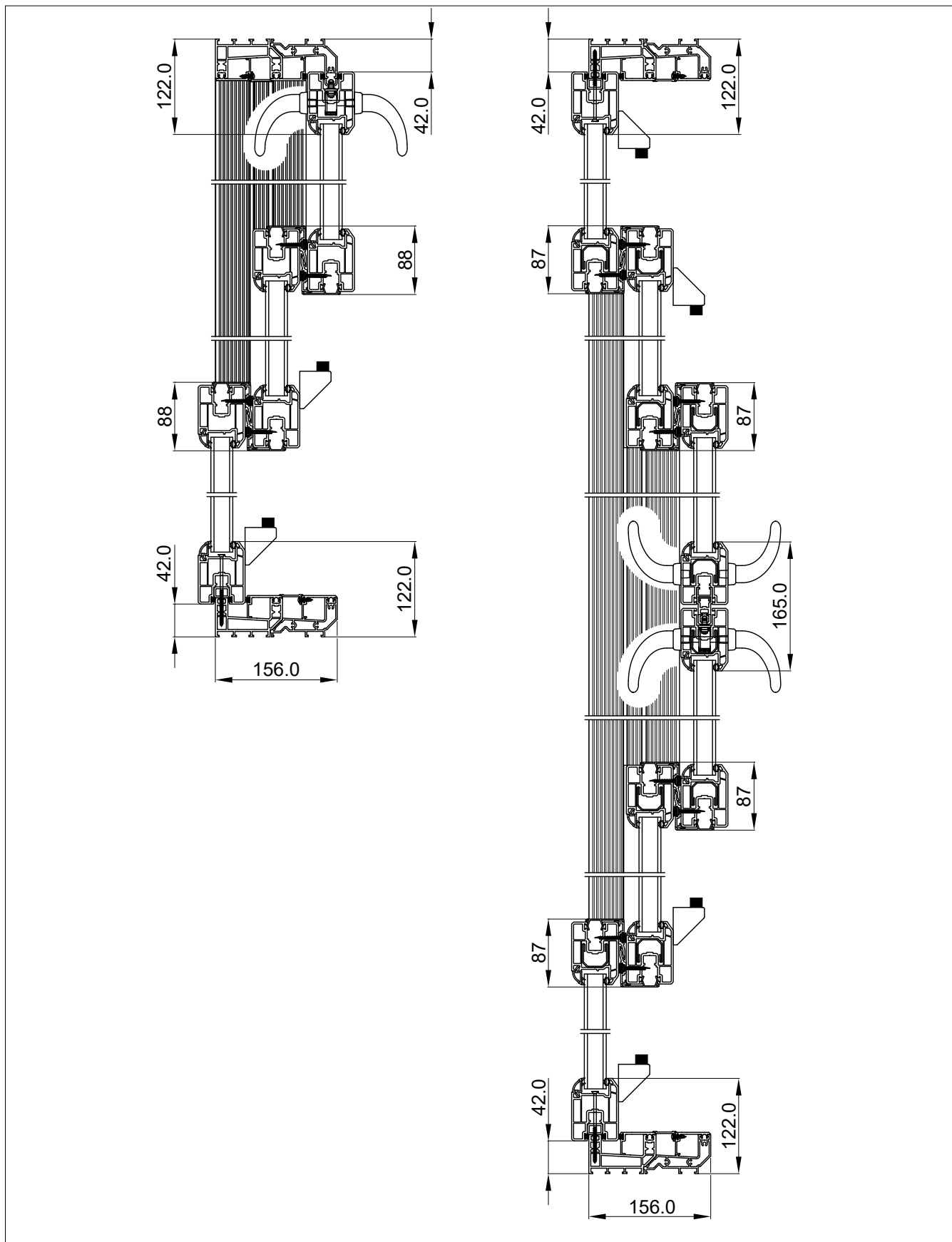
Dimensions in MM
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DO NOT SCALE

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In-Line Three Track Sliding Patio Door Horizontal Sections



SECTION	DATE	ISS	REFERENCE	PAGE
ASSEMBLY SECTION DRAWINGS	OCTOBER 2020	27	TM-0002	63



Dimensions in MM
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In-Line Three Track Sliding Patio Door Sash/Outer Frame Drainage

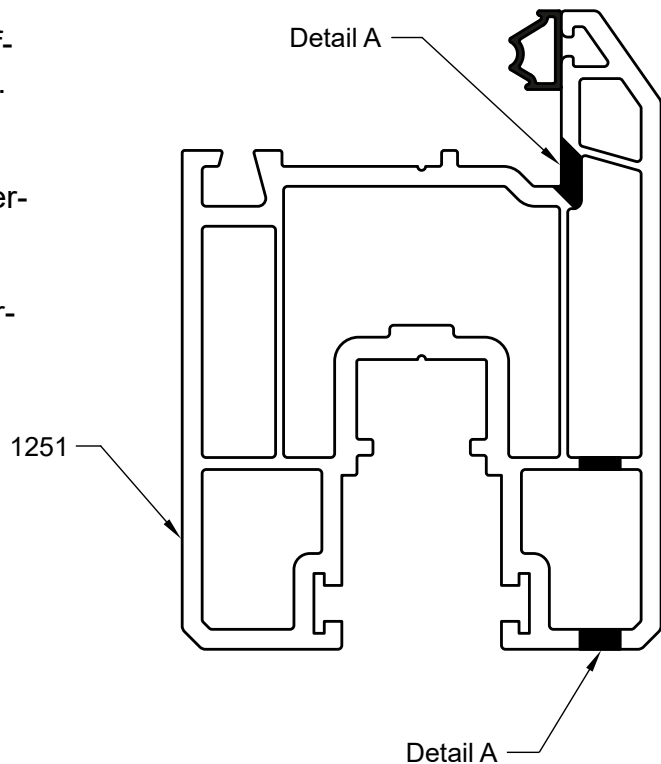
SECTION	DATE	ISS	REFERENCE	PAGE
ASSEMBLY SECTION DRAWINGS	OCTOBER 2020	27	TM-0002	64

Sash Drainage

For a sash width of 785-1100mm 2 internal drain slots are required., External slots are off-set a minimum of 50mm from the internal slot.

For a sash width of 1101-1500mm as above plus one on the centre external drain slot. Internal drain slot offset as above.

Position the internal drain as close to the internal sash corners as possible - But do not obstruct with glazing bridge.



Outer Frame Drainage

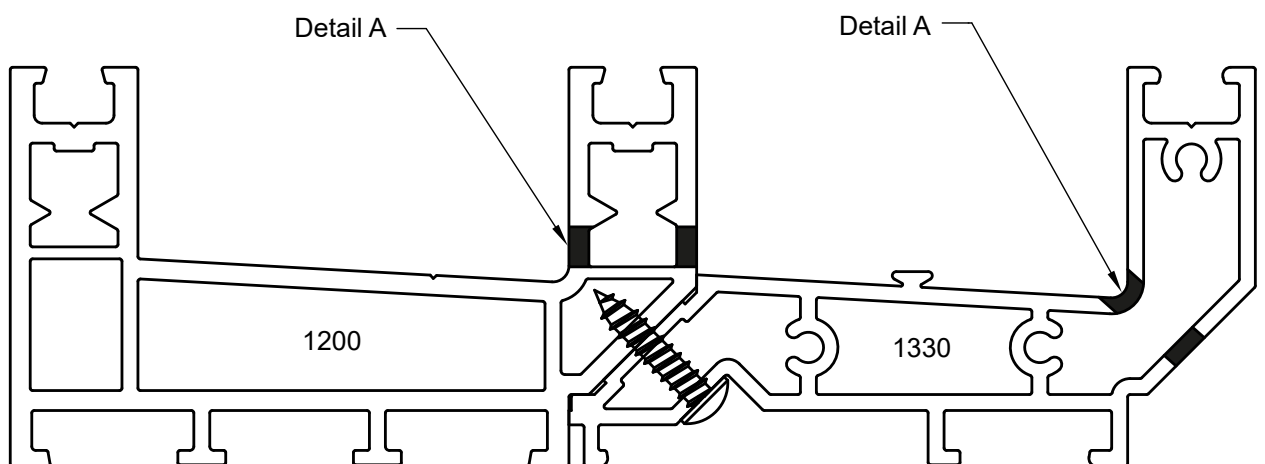
Each sash outer frame segment is to be drained separately.

For a sash width of 785-1100mm, 2 internal drain slots are required. External slots are off-set a minimum of 50mm from the internal slot.

For a sash width of 1101-1500mm as above plus one on the centre external drain slot. Internal slot offset as above.

Internal drain slots are to be positioned as wide apart as possible - But do not obstruct with dust plug adjacent to interlock.

Detail A = Slot 25 x 5mm

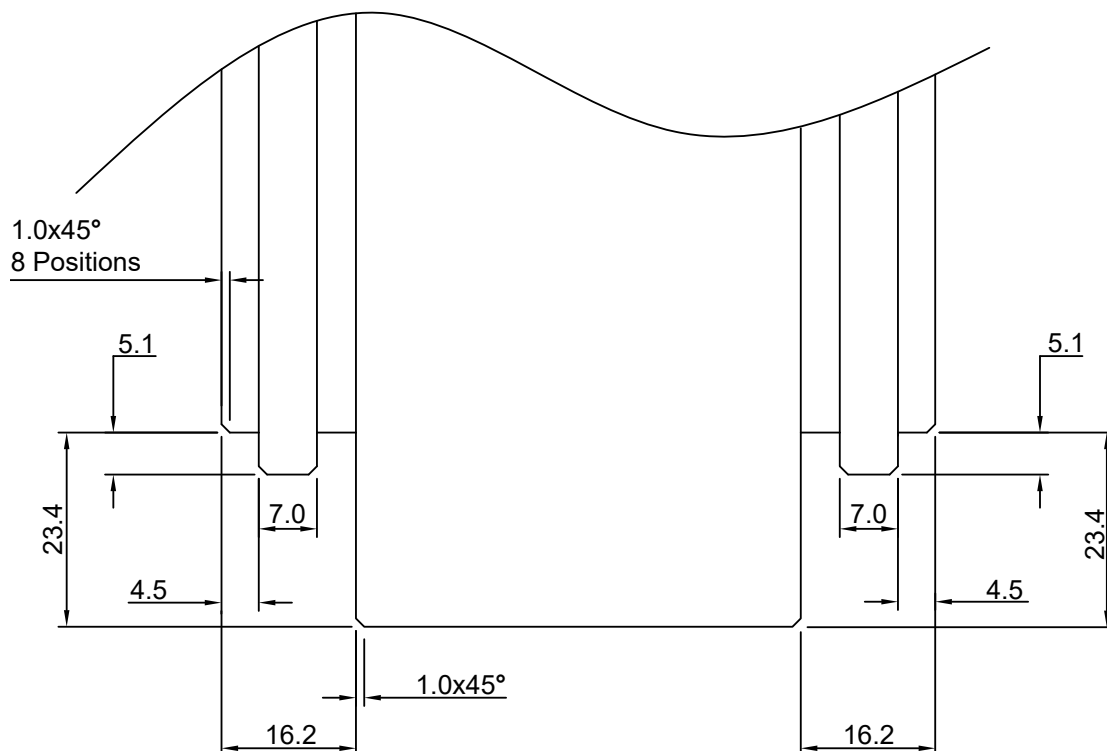
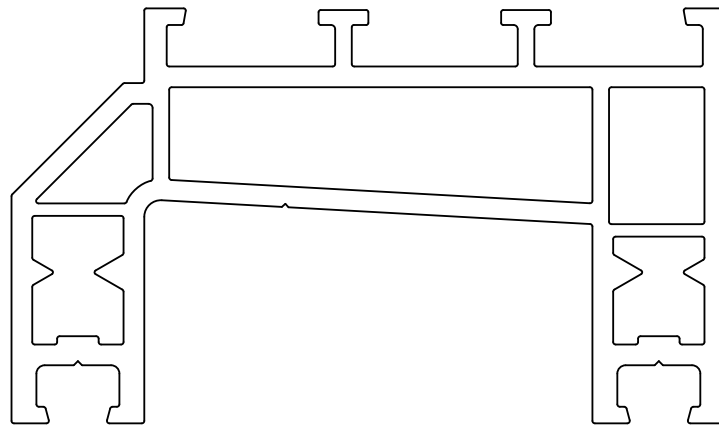


In-Line Three Track Sliding Patio Door End Preparation 1200



SECTION	DATE	ISS	REFERENCE	PAGE
FRAME JOINTING & PREPARATION	OCTOBER 2020	27	TM-0002	65

End Preparation 1200



Dimensions in MM
All dimensions are nominal.
DO NOT SCALE

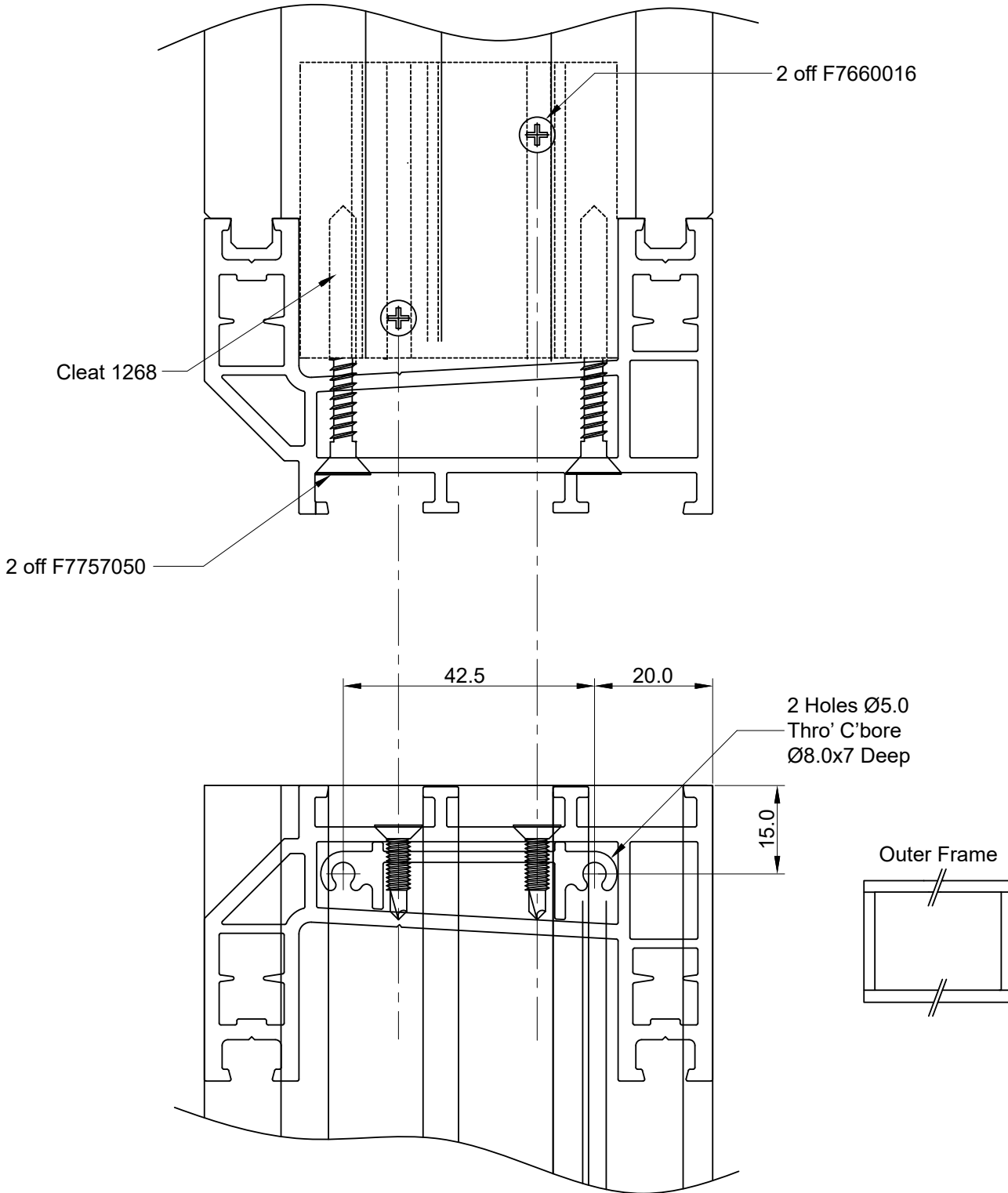
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In-Line Three Track Sliding Patio Door Jointing 1200



SECTION	DATE	ISS	REFERENCE	PAGE
FRAME JOINTING & PREPARATION	OCTOBER 2020	27	TM-0002	66

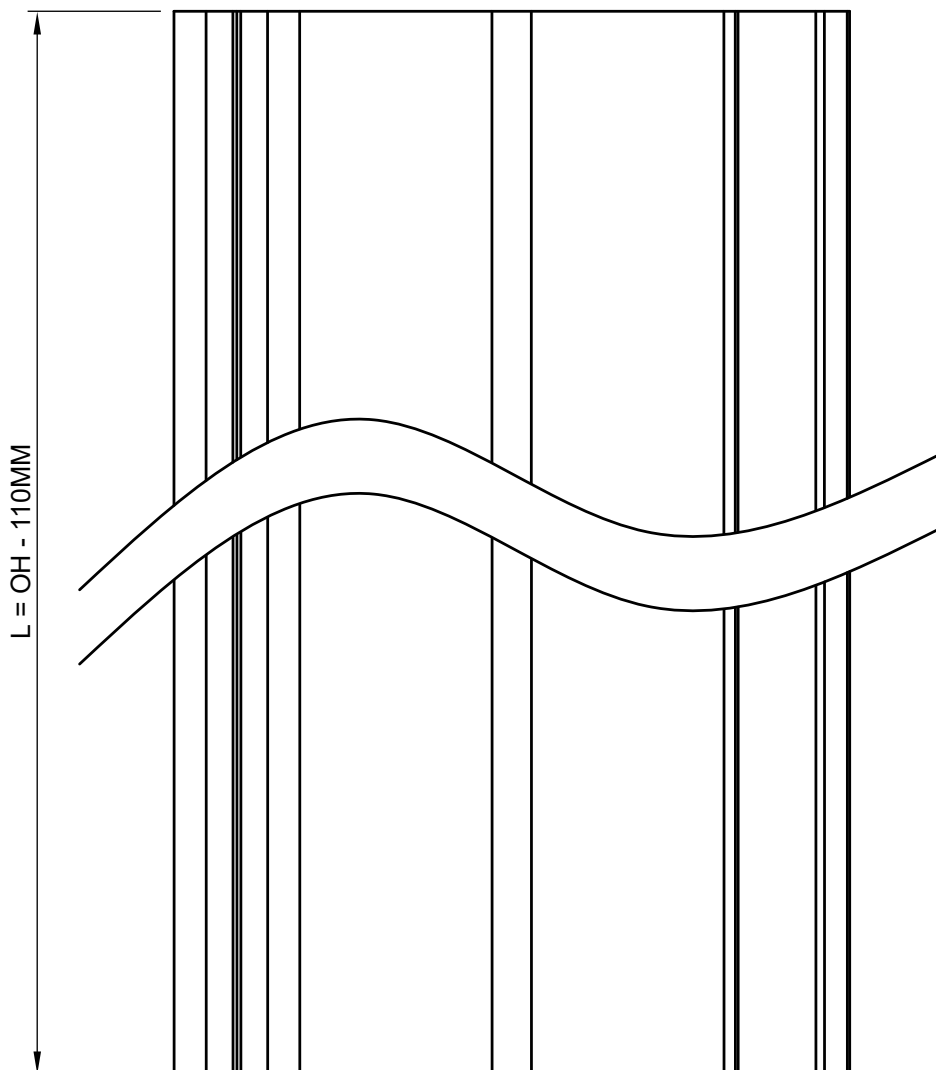
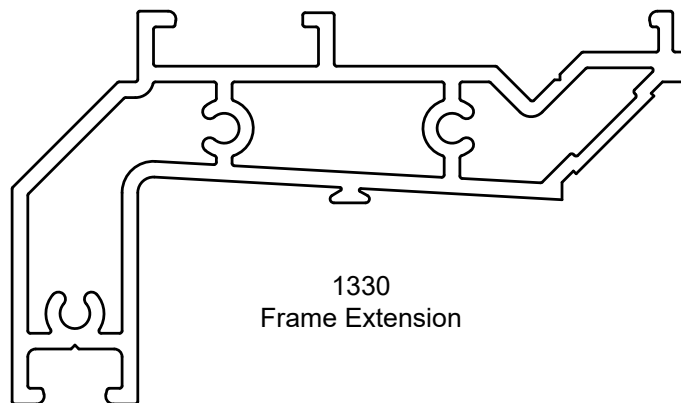
Jointing 1200



In-Line Three Track Sliding Patio Door End Preparation 1330

SECTION	DATE	ISS	REFERENCE	PAGE
FRAME JOINTING & PREPARATION	OCTOBER 2020	27	TM-0002	67

End Preparation 1330

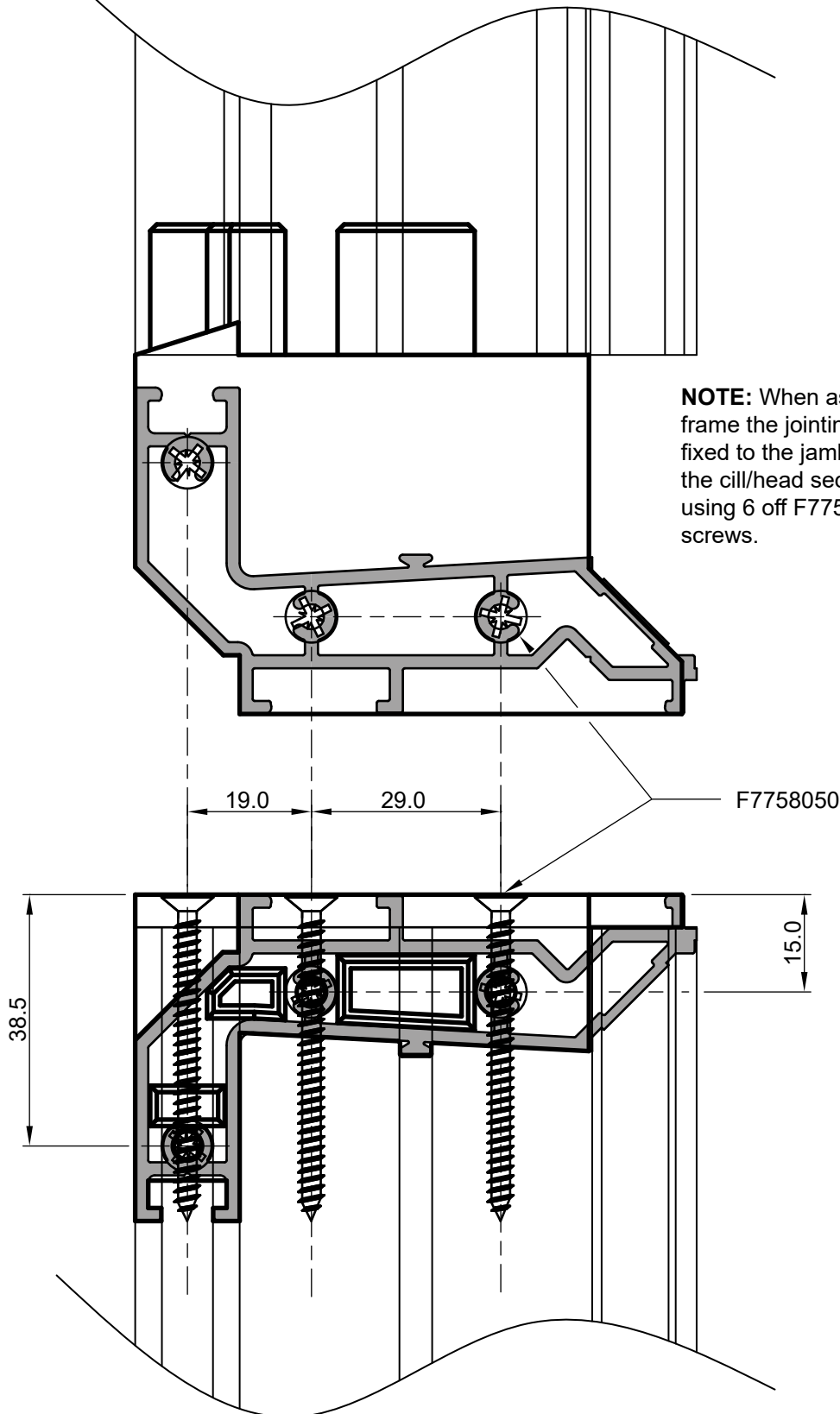


The 1330 Track Extension is to be square cut at 90° which will allow it to butt up cleanly to the 1331 Extension Joint Cleat as shown on the following page.

In-Line Three Track Sliding Patio Door Jointing 1330

SECTION	DATE	ISS	REFERENCE	PAGE
FRAME JOINTING & PREPARATION	OCTOBER 2020	27	TM-0002	68

Jointing 1330

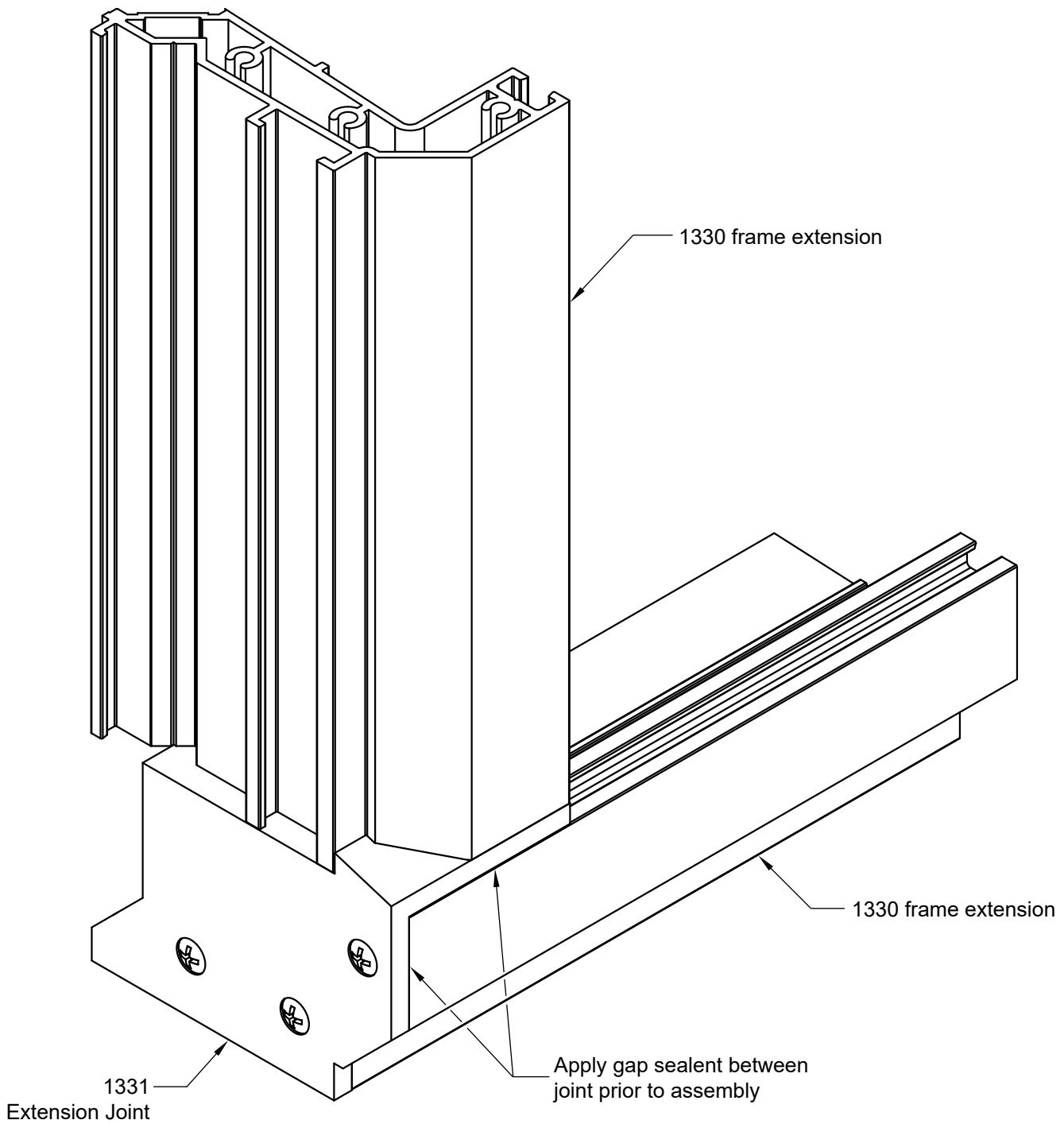


NOTE: When assembling the outer frame the jointing cleat will need to be fixed to the jamb sections first, then to the cill/head sections. Fixing is done using 6 off F7758050 50mm Stainless screws.

In-Line Three Track Sliding Patio Door Jointing 1330

SECTION	DATE	ISS	REFERENCE	PAGE
FRAME JOINTING & PREPARATION	OCTOBER 2020	27	TM-0002	69

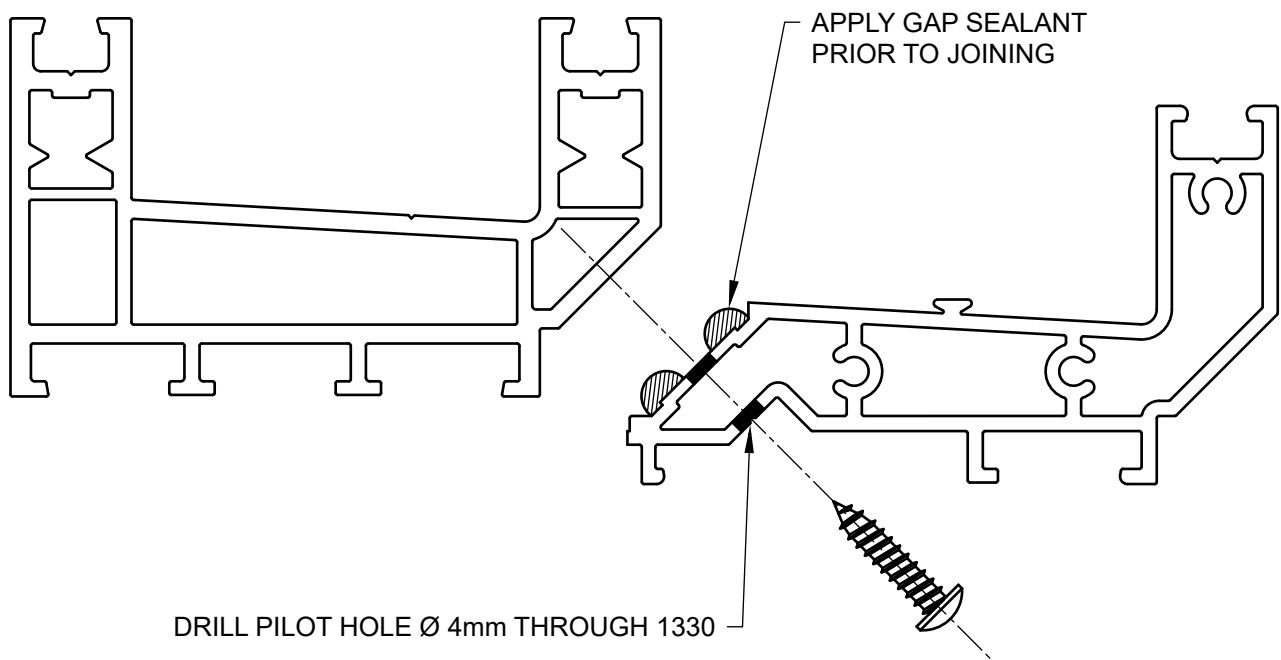
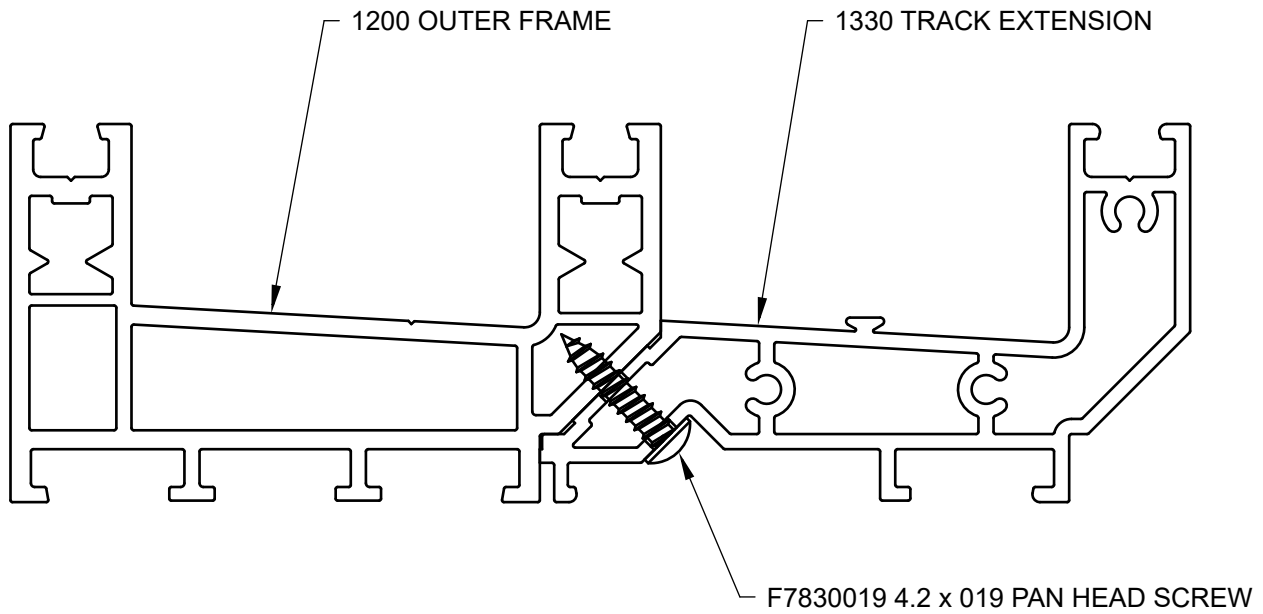
Jointing 1330



In-Line Three Track Sliding Patio Door Jointing 1200 & 1330

SECTION	DATE	ISS	REFERENCE	PAGE
FRAME JOINTING & PREPARATION	OCTOBER 2020	27	TM-0002	70

Jointing 1200 & 1330

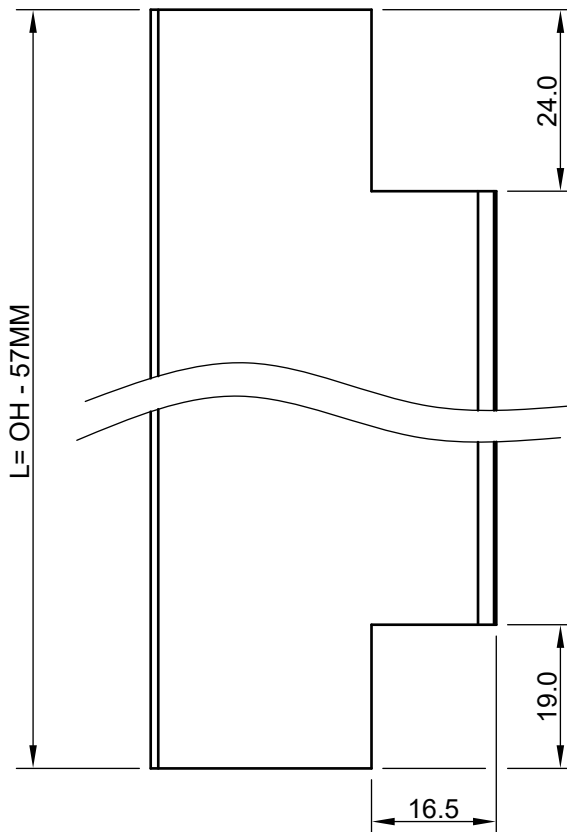
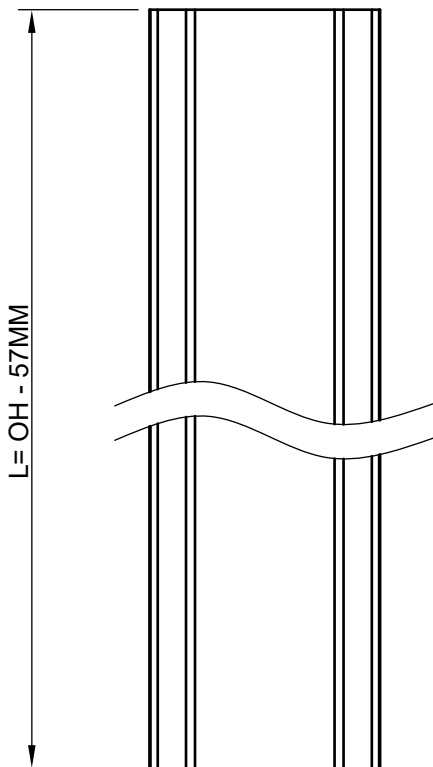
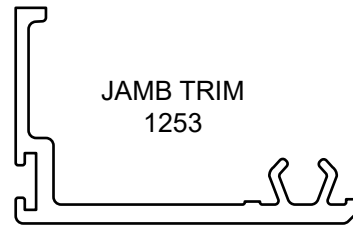
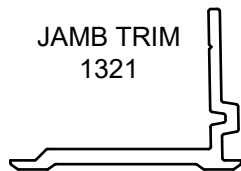
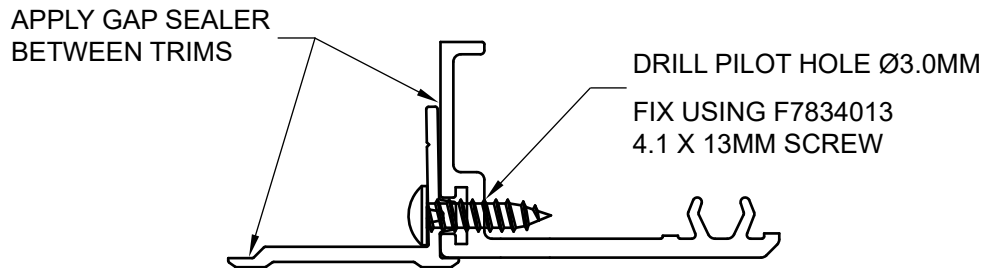


NOTE: WHEN FIXING 1330 TO 1200 SCREW CENTRES SHOULD BE NO GREATER THAN 300MM APART.

In-Line Three Track Sliding Patio Door Jamb Trim Preparation

SECTION	DATE	ISS	REFERENCE	PAGE
JAMB TRIM PREPARATION	OCTOBER 2020	27	TM-0002	71

Jamb Trim Preparation



In-Line Three Track Sliding Patio Door Threshold Trim Preparation

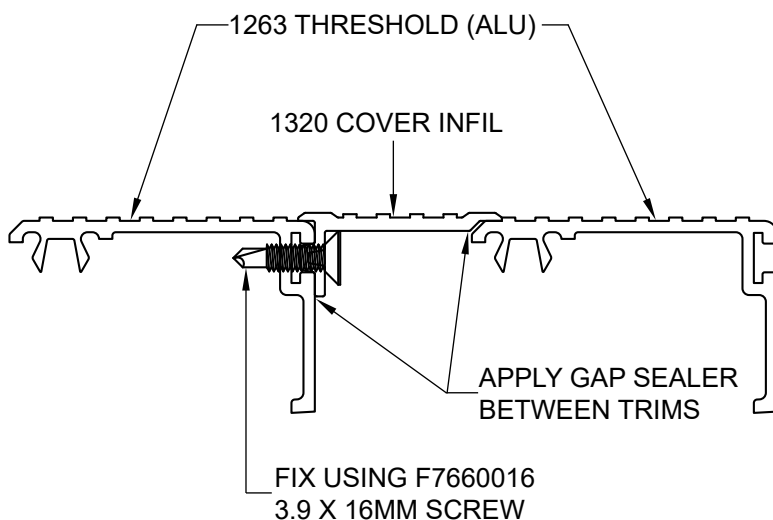
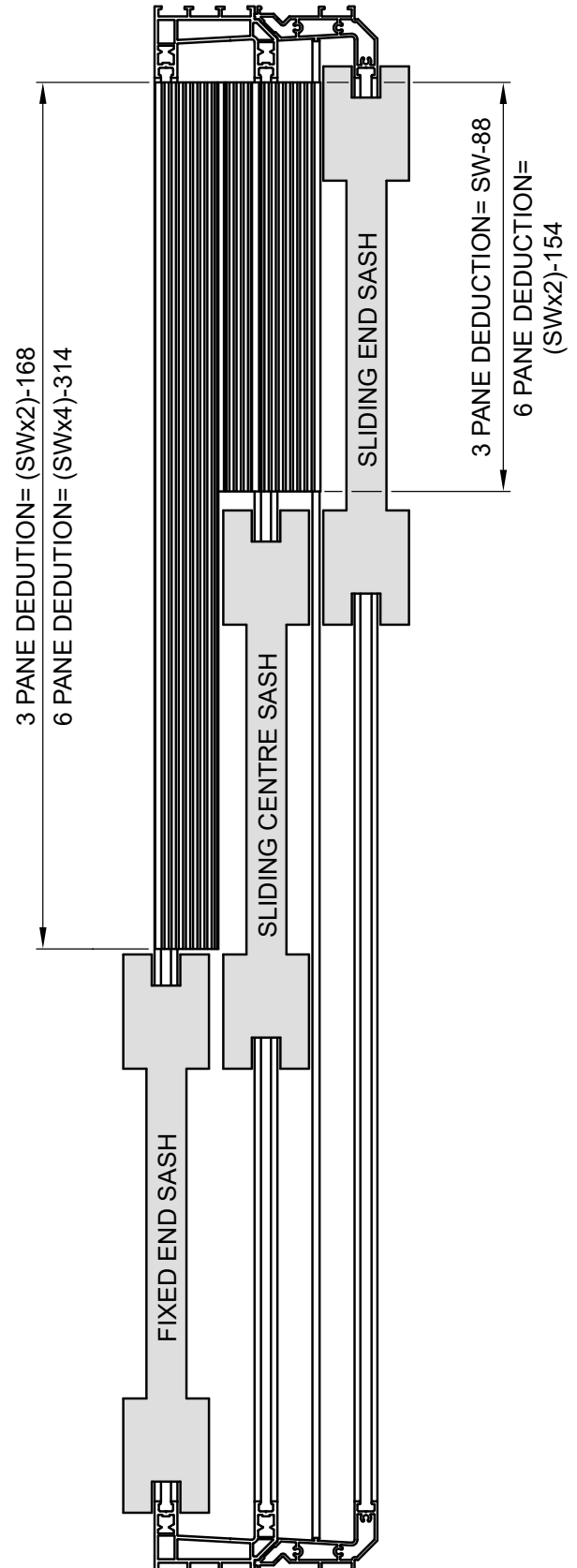
SECTION	DATE	ISS	REFERENCE	PAGE
THRESHOLD TRIM PREPARATION	OCTOBER 2020	27	TM-0002	72

Threshold Trim Preparation

The 1263 threshold trim is used in two places on the threshold. The first is positioned on the inner side of the door and cut using the deductions for either 3 pane or 6 pane as shown. The second is fitted in the centre of the threshold and is cut using the deductions for either 3 pane or 6 pane as shown. Between the two lengths of 1263 is the 1320 Cover Infil which cut using the same deduction as the 1263 centre trim as shown.

The trims are assembled as shown in the diagram below using F7660016 screw and gap sealer between trims.

The cover trims 1253 and 1321 in the head of the outer frame are cut using the same deductions as the threshold trims and assembled using the same methods.



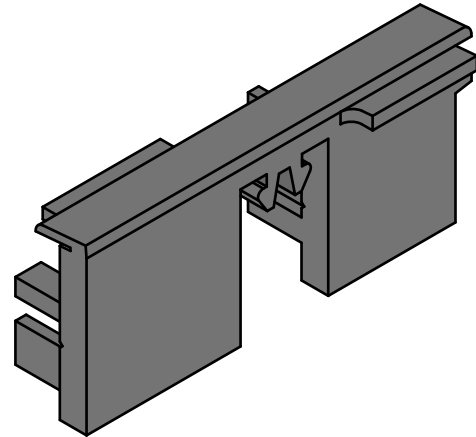
In-Line Three Track Sliding Patio Door 1322 & 1339 Mouldings



SECTION	DATE	ISS	REFERENCE	PAGE
Mouldings	OCTOBER 2020	27	TM-0002	73

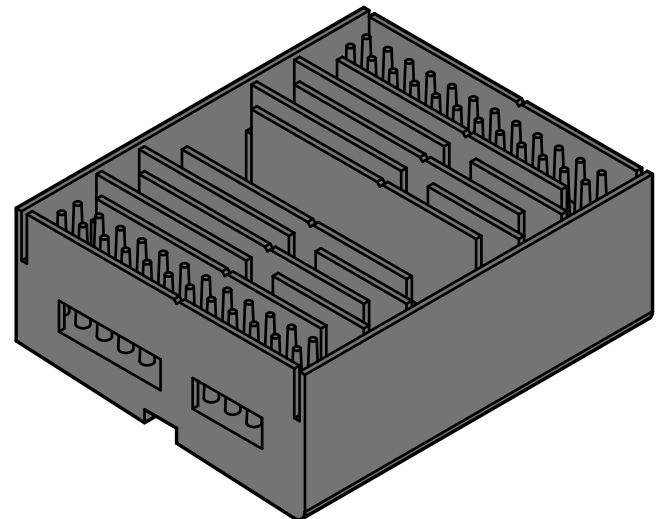
1322 Infil End Cap-

The end cap is a rubber moulding used to seal the threshold trims (1263 and 1320) and head trims (1253 and 1321). Gap sealer should be used to seal between the end cap and trims. Fitting is shown on page 84.



1339 Patio Interlock Seal-

The interlock seal is also a rubber moulding that sits in the drainage channel of the inner track to provide an effective seal between the outer frame and sliding sash. Gap sealer should be applied beneath the moulding and secured in place with F7660019 M3.9 x 019 countersunk drill point screw. Fitting details are shown on page 85.



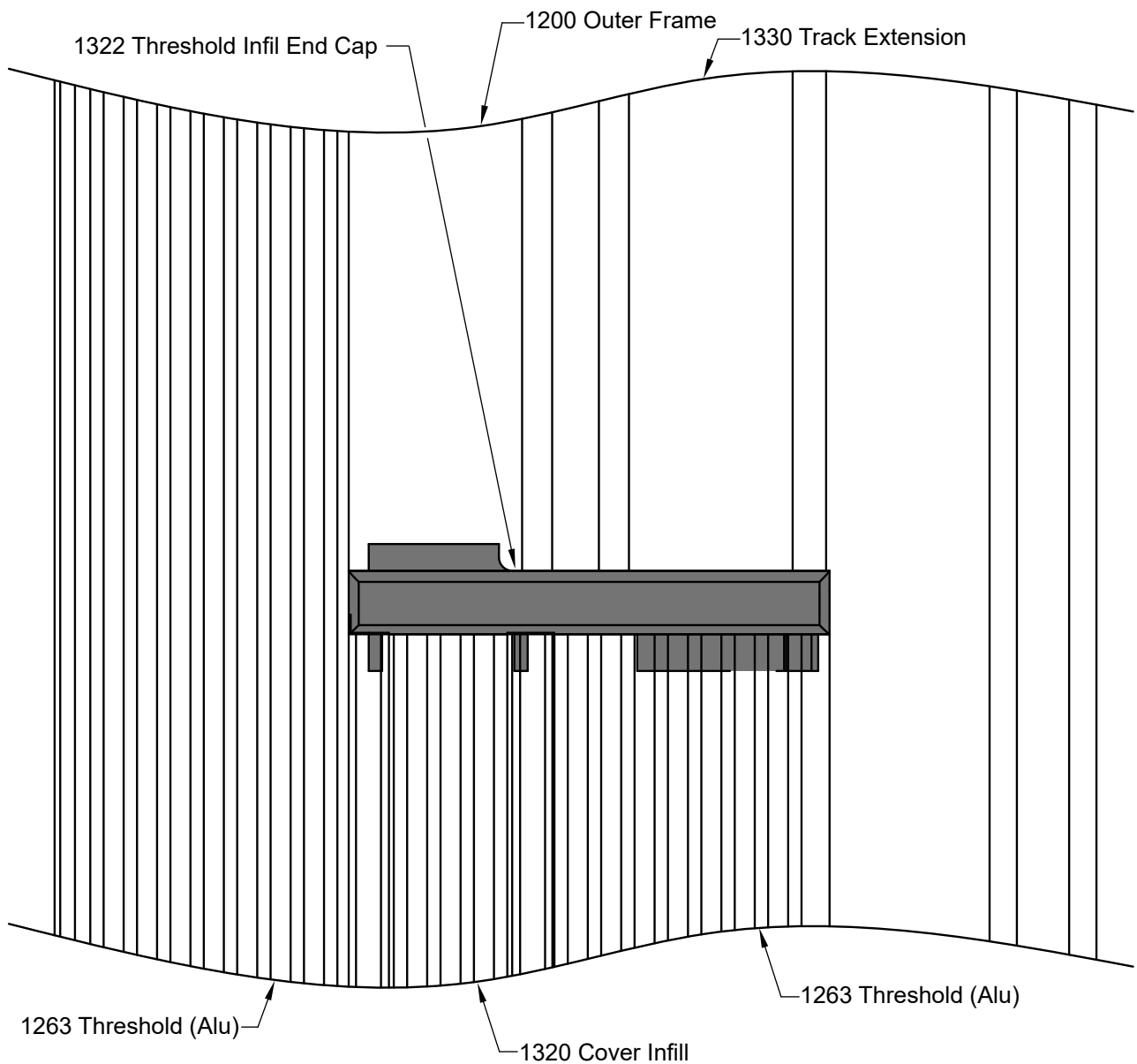
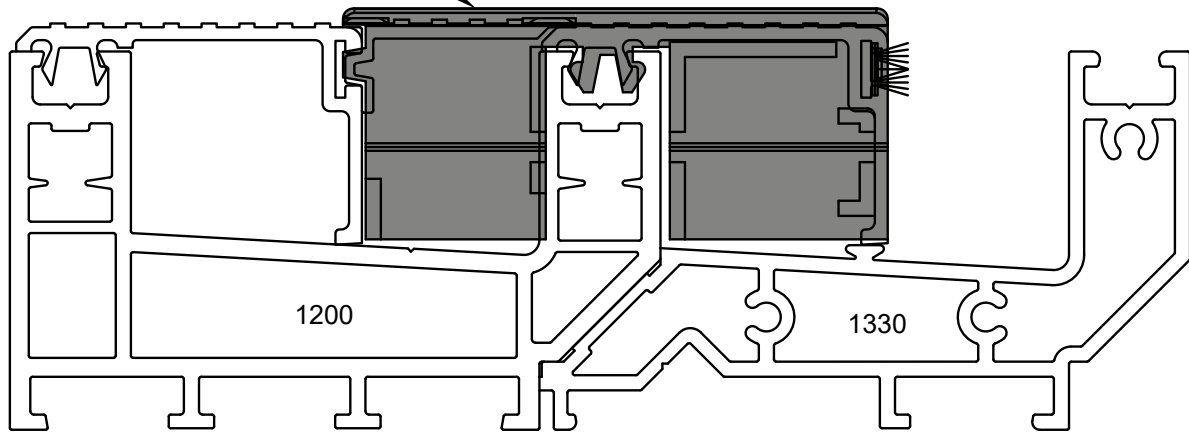
In-Line Three Track Sliding Patio Door

1322 Threshold Infil End Cap



SECTION	DATE	ISS	REFERENCE	PAGE
1322 Threshold Infil End Cap Fitting	OCTOBER 2020	27	TM-0002	74

1322 Threshold Infil End Cap

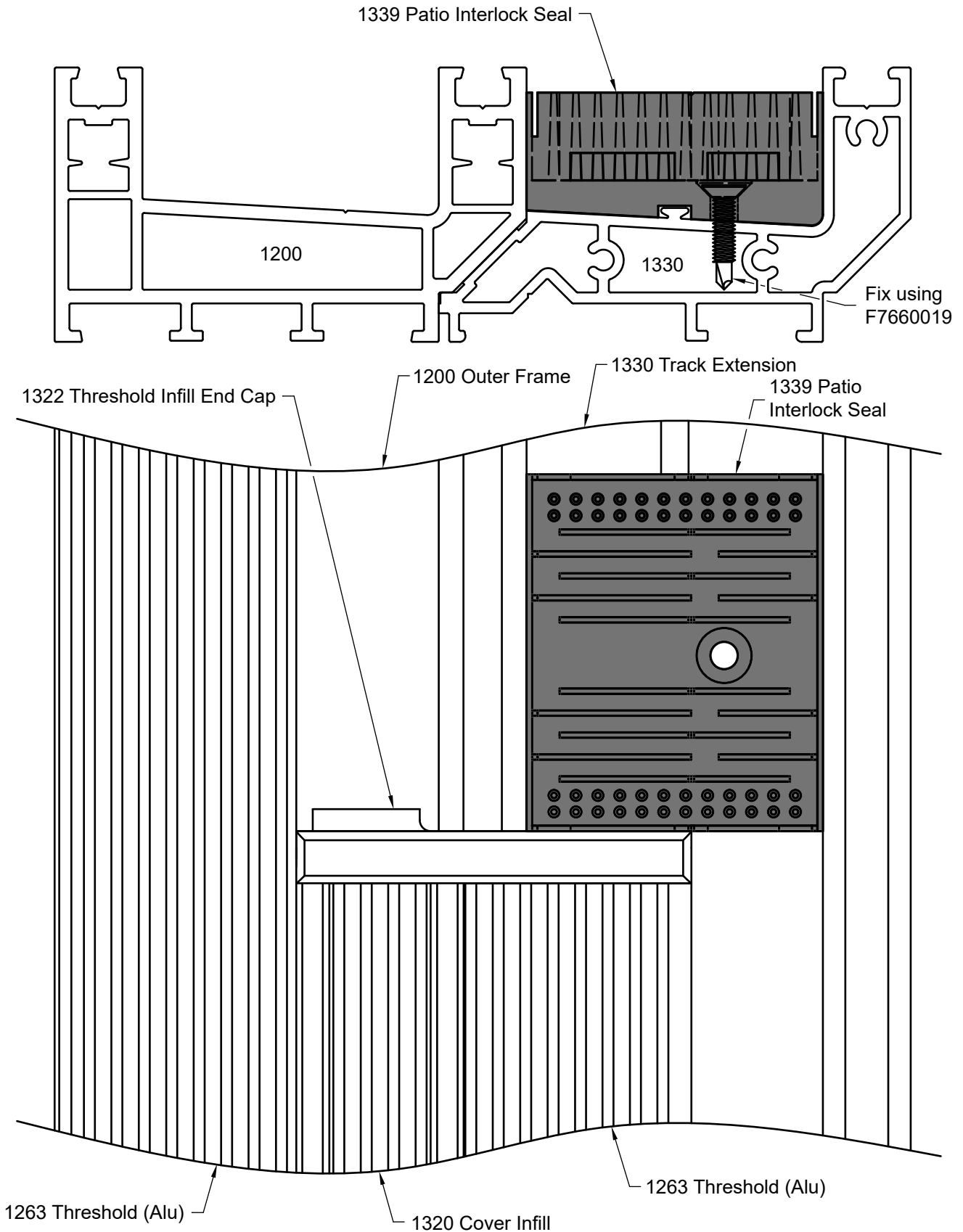


Dimensions in MM
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In-Line Three Track Sliding Patio Door 1339 Patio Interlock Seal

SECTION	DATE	ISS	REFERENCE	PAGE
1339 Patio Interlock Seal	OCTOBER 2020	27	TM-0002	75



Dimensions in MM
All dimensions are nominal.
DO NOT SCALE

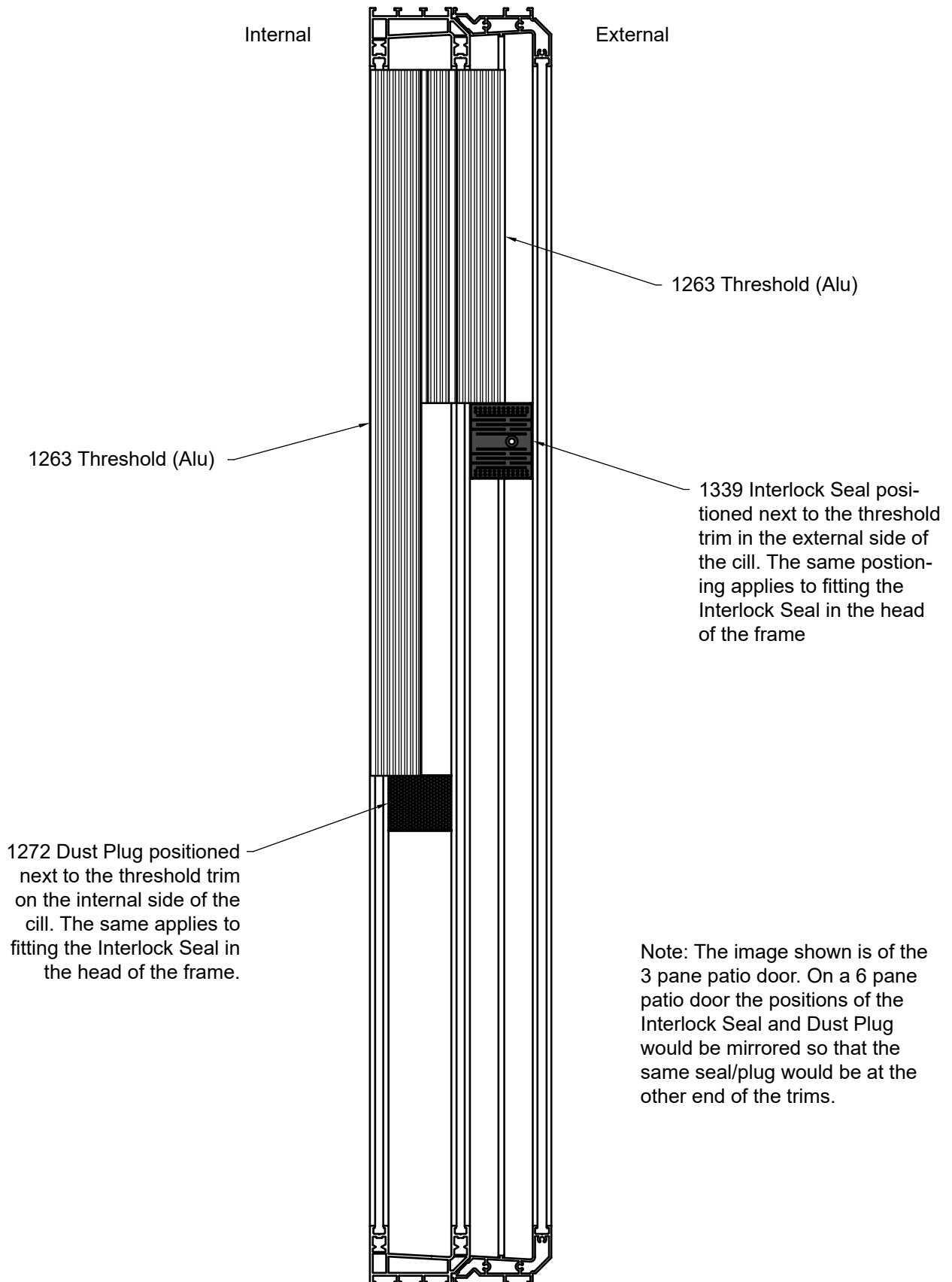
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In-Line Three Track Sliding Patio Door

1339 Patio Interlock Seal & 1272 Dust Plug



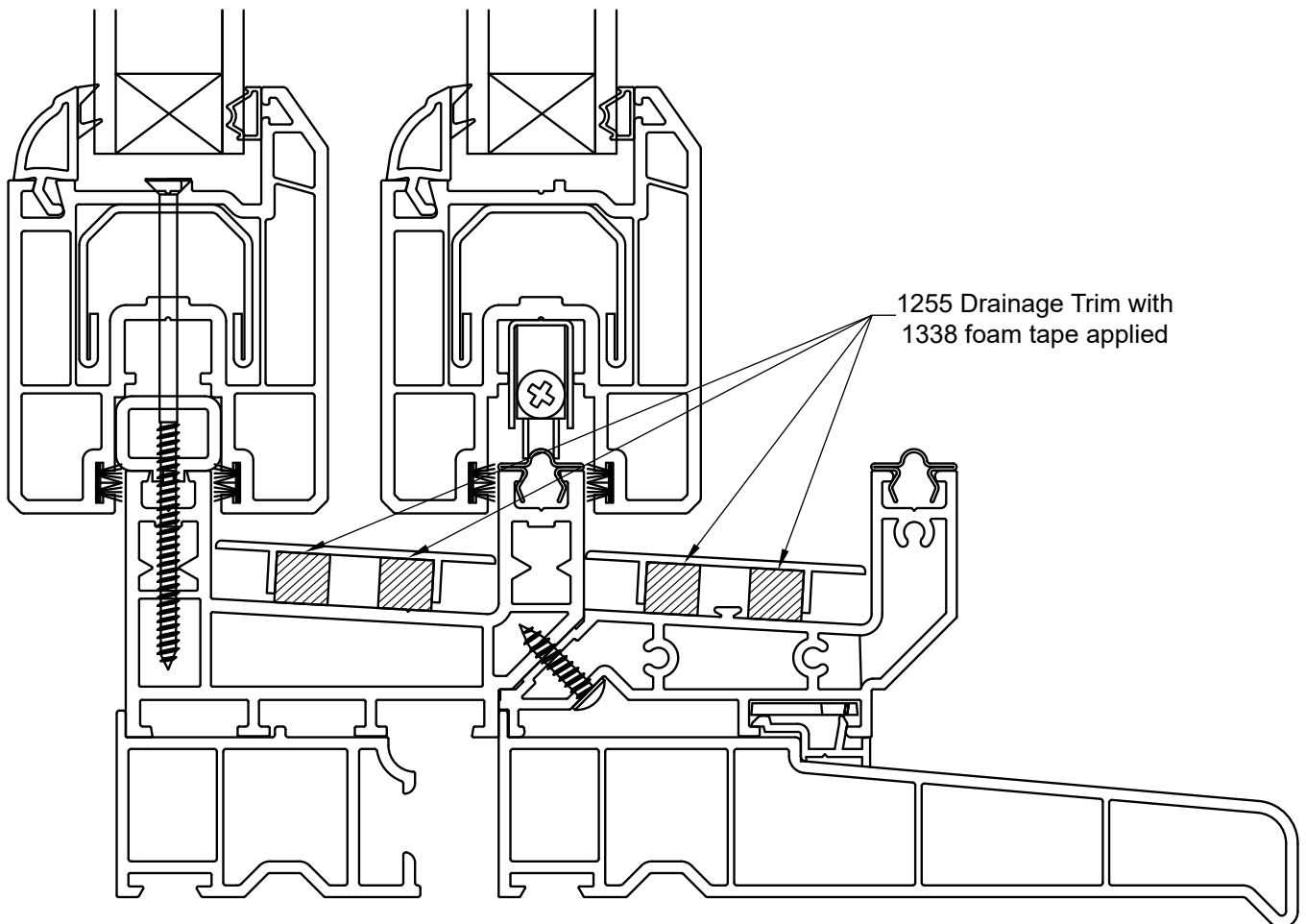
SECTION	DATE	ISS	REFERENCE	PAGE
1339 Patio Interlock Seal & 1272 Dust Plug Positions	OCTOBER 2020	27	TM-0002	76



In-Line Three Track Sliding Patio Door 1255 Drainage Trim

SECTION	DATE	ISS	REFERENCE	PAGE
1255 Drainage Trim With Double Sided Tape	OCTOBER 2020	27	TM-0002	77

1255 Drainage Trim is to be positioned in the head and cill of the outer frames to cover the inner section of the frame. Fixing of the trim is done using 1338 double sided foam tape as shown in the diagram below. The tape is to be applied to the trim first in the factory, then the trim with tape applied can be stuck to the outer frame on site once the sashes have been fitted. Ensure the surface of the frame and trim are wiped clean before applying the tape to ensure good adhesion. Application of the tape is to be done at temperatures of no less than 5°C to ensure good adhesion. Applying the tape at less than 5°C will run the risk of peeling of due to condensation.



In-Line Three Track Sliding Patio Door Patio Door Stop

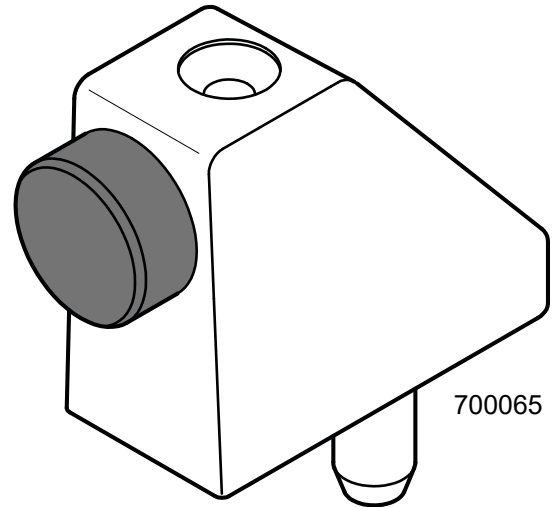


SECTION	DATE	ISS	REFERENCE	PAGE
700065 Patio Door Stop	OCTOBER 2020	27	TM-0002	78

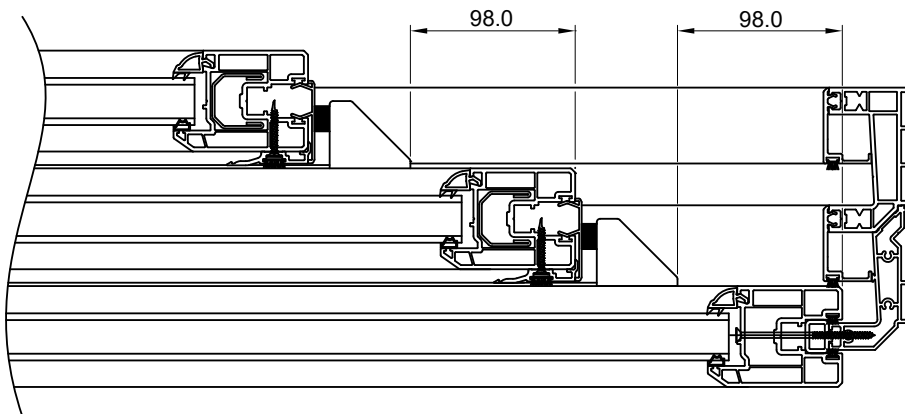
The door stops are fitted in unhandled pairs at the top and bottom of the sash, meaning that a 3 pane door will need 4 door stops and a 6 pane door will need 8 doors stops. Part No. 700065 refers to the white bump stop, but these are also available in Brown (700066), Tan (700067), Grey (700065/7016M), Black Brown (700065/8022M) & Cream (700065/9001M).

To ensure good screw retention the bump stop will need to be fixed back to reinforcing. This will require the adding of 1257 steel to the sash head & cill members of the fixed sash.

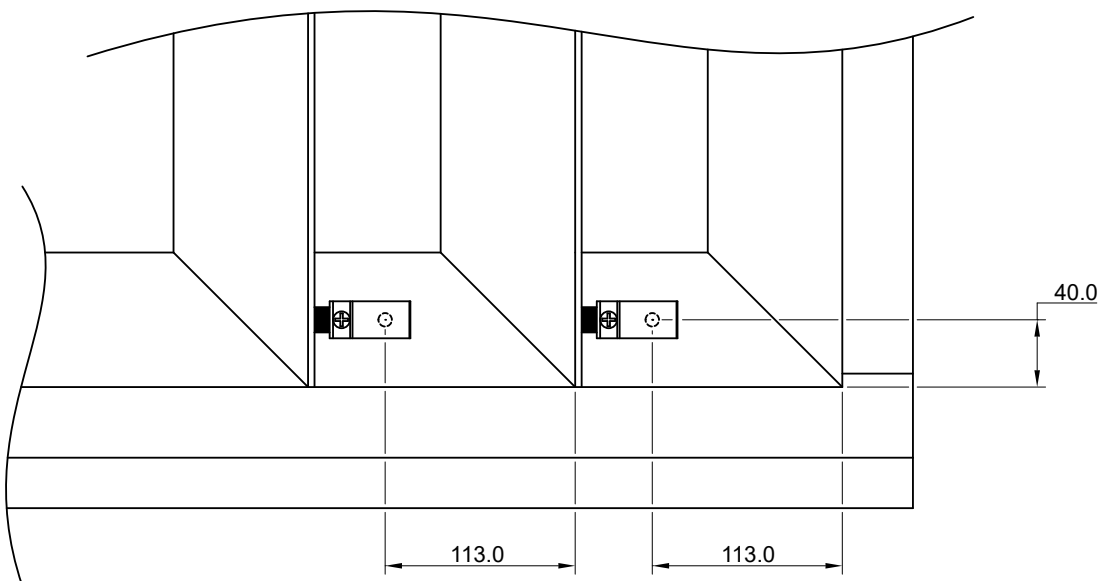
Positioning of the door stop should be 98mm from the edge of the sash. This is attained by drilling an 8mm spigot hole into the sash & steel 113mm from the edge of the sash jamb and 40mm from the top/bottom of the door sash as shown in the diagram below. The bump stop should be fixed in place using F7895065 4.8 x 065 screw.



NOTE: ENSURE DOOR STOP IS FIXED BACK TO STEEL



Spigot Hole Position



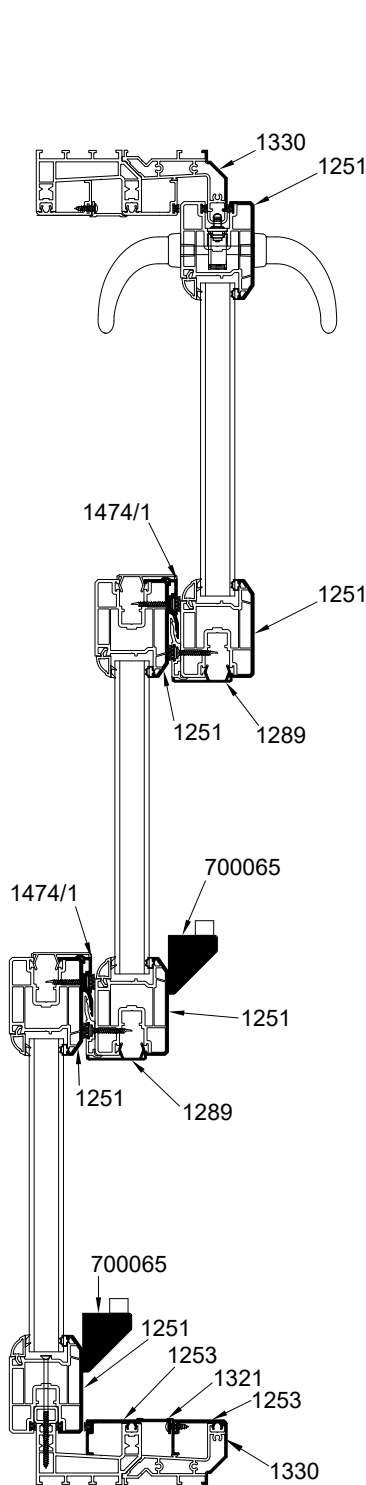
In-Line Three Track Sliding Patio Door Foiling Position



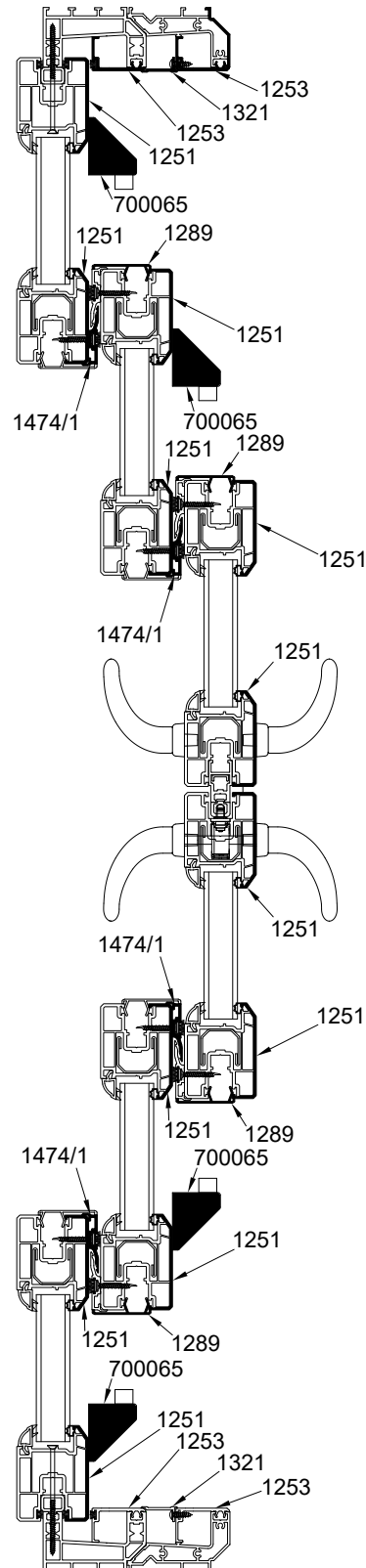
SECTION	DATE	ISS	REFERENCE	PAGE
FOILING POSITION	OCTOBER 2020	27	TM-0002	79

Parts identified are required to be coloured to suit the external colour. All other parts will be white.

3 PANE FOILING ON WHITE



6 PANE FOILING ON WHITE



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In-Line Sliding Patio Door Technical Specification



SECTION	DATE	ISS	REFERENCE	PAGE
TECHNICAL SPECIFICATION	OCTOBER 2020	27	TM-0002	80

SCOPE

- This specification defines materials, construction and size limitations of the In-Line Sliding Patio Door system, manufactured from Profile 22 products.
- In-Line Sliding Patio Doors are suitable for installation into new building work, or as replacements in existing buildings, being designed for fitting direct to masonry.
- The patio system is also compatible with Profile 22 window and door systems, ideal for use in conservatories.

MATERIALS

- PVC-U profiles are extruded from impact modified unplasticised polyvinyl chloride, extruded to conform to BS EN 12608.
- Fire resistance to BS 476, part 7, class one.
- Steel reinforcing is roll formed hot dipped galvanised mild steel to FePo2GZ275NA or equivalent.
- Aluminium sections are extruded from HE9TE or HE9TF, complying with BS 1474.
- PVC-U profiles are multi-chambered and have a main wall thickness of between 2.5mm and 3.0mm.
- Sash glazing and bead gasket is co-extruded and meets BS 7412.
- Weatherseals are woven pile weatherstripping.

QUALITY

- Profile 22 Systems are a BS EN ISO 9001 registered company Certificate No: FM09180.

CONSTRUCTION

- Outer frames are mitre cut at 45° and then heat welded or alternatively mechanically jointed. White doors are shadow grooved and foiled doors are knife seamed. Foiled on white doors are combinations of both.
- Midrails are mechanically jointed N.B.: ALL MECHANICAL JOINTS SHOULD BE SEALED AGAINST THE INGRESS OF WATER.
- Sash profiles are mitre cut at 45° and then heat welded. Joints finished as outer frames.

- Reinforcing - white, white foiled and cream foiled doors = sliding sash fully reinforced, fixed sash meeting stile reinforced, all other doors = fully reinforced.
- Thermally Broken Low Threshold available for use in sheltered external applications only.

GLAZING (INTERNAL BEAD)

- The glass is set against a co-extruded sash gasket and backed up with a co-extruded knock-in bead on the room side of the patio sash frame.

GLAZING

- Glazing should be carried out in accordance with BS 6262.
- Glass should conform to the requirements of BS 6262 for thickness and type.
- The profiles within the patio system will accommodate glazing of 28mm in unit thickness.

INSTALLATION

- Detailed installation recommendations are provided in the technical manual which should be strictly followed.

PERFORMANCE (WEATHER)

- Full Threshold Patio Door tested to BS 6375-1:2009. Achieving a rating of 800Pa Wind Loading, 300Pa Air Permeability & 200Pa Water Tightness. Sample tested - 2 pane door 2400mm width x 2200mm height.
- Full Threshold Patio Door tested to BS 6375-1:2009. Achieving a rating of 400Pa Wind Loading, 300Pa Air Permeability & 100Pa Water Tightness. Sample tested - 4 pane door 2850mm width x 2200 height.
- Low Threshold (Thermally Broken with Threshold Trim) Patio Door tested to BS 6375-1:2009. Achieving a rating of 800Pa Wind Loading, 300Pa Air Permeability & 50Pa Water Tightness. Sample tested - 2 pane door 1800mm width x 2060mm height.

THREE TRACK PERFORMANCE (WEATHER)

- Full Threshold Triple Track Patio Door tested to BS 6375-1:2009. Achieving a rating of 800Pa Wind Loading, 300Pa Air Permeability & 200Pa Water Tightness. Sample tested - 3 pane door 2700mm width x 2080mm height.

In-Line Sliding Patio Door Technical Specification



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HARDWARE

- Lock - 6 hook opposing action, providing built in anti-lift, compliant with BS7412 and cycle tested to 50,000 cycles. One piece keep, anchored into steel reinforcing.
- Rollers/Tracking - steel tandem rollers, weight capacity of 120kgs/pair, cycle tested to 50,000 cycles. Tracking section is manufactured from stainless steel.
- Anti-lift is fitted as standard to all sliding sashes.

ENHANCED SECURITY (SECURED BY DESIGN)

- The Secured by Design in-line sliding door has enhanced security specification to allow it to meet the high standards of the Police Approved initiative.

STYLE AND SIZE LIMITATION

- Styles can be supplied in 2 pane, 3 pane, 4 pane and 6 pane configurations.
- Size limitations. The heights shown below do not include cills or add-on profiles.

VENTILATION

- Trickle ventilation is offered by means of a centrally controllable trickle ventilator positioned in an add-on profile above the head of the outer frame.
- Standard trickle ventilation is designed to provide a maximum air supply of 8000mm² (5000mm² equivalent air).
- Gas boiler specification: Compliance with Building Regulations (J9) and BS 5440 pt 2. In situations where increase air supply is required, optional ventilation can be supplied providing up to a maximum of 11,000 mm² constant air supply, suitable for a maximum input of 99000 BTUs per hour.

STYLE	MAX WIDTH	MAX HEIGHT	MIN WIDTH*	MIN HEIGHT*
2 PANE	3004	2360	1574	1900
3 PANE (CENTRE SLIDER)	4509	2360	2364	1900
3 PANE (END SLIDER)	4425	2360	2380	1900
4 PANE	5928	2360	3068	1900
3 PANE (3 TRACK END SLIDER)	4424	2360	2279	1900
6 PANE (3 TRACK CENTRE SLIDER)	5928	2360	4479	1900

* Minimum width and height: The above sizes given are guideline dimensions. These can be dependent upon building regulations and local planning law. In special applications for sizes required less than these please refer to the technical department.

In-Line Sliding Patio Door Survey & Installation



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General

BS 8213-4:2007 Code of Practice for the Survey and Installation of Windows and External Doorsets gives recommendations for the surveying and installation of non-load bearing windows and external doorsets, to be installed vertically (within 15°) into the external face of buildings.

It gives guidance on the good practices for successful surveying and installation. All aspects of this document should be followed with particular attention given to the product's suitability for its location and the presence of any dead loads. If you are at all unsure then please contact your PatioMaster dealer.

Survey Notes

The manufacturing sizes should be determined by measuring the structural opening using the methods described in BS 8213-4:2007 Code of Practice for the Survey and Installation of Windows and External Doorsets. However, the following fitting tolerances must be adhered to:

	DEDUCTION-WIDTH		DEDUCTION HEIGHT
PROFILE	up to 3m	3m to 6.0m	up to 2.4mm
WHITE	10mm	15mm	10mm
FOILED	15mm	22mm	15mm

Preparation of Structural Opening

Check that the opening is the correct size for the new frame (N.B.: For replacement work this should be done prior to removal). Check that any DPC's are sound and not "bridged" by any render or plaster. Check for the practicality of fixings to the lintels.

The base of the opening must be constructed of suitable structural material, e.g.: brick, block, stone, timber etc

In-Line Sliding Patio Door

Installing The Frame

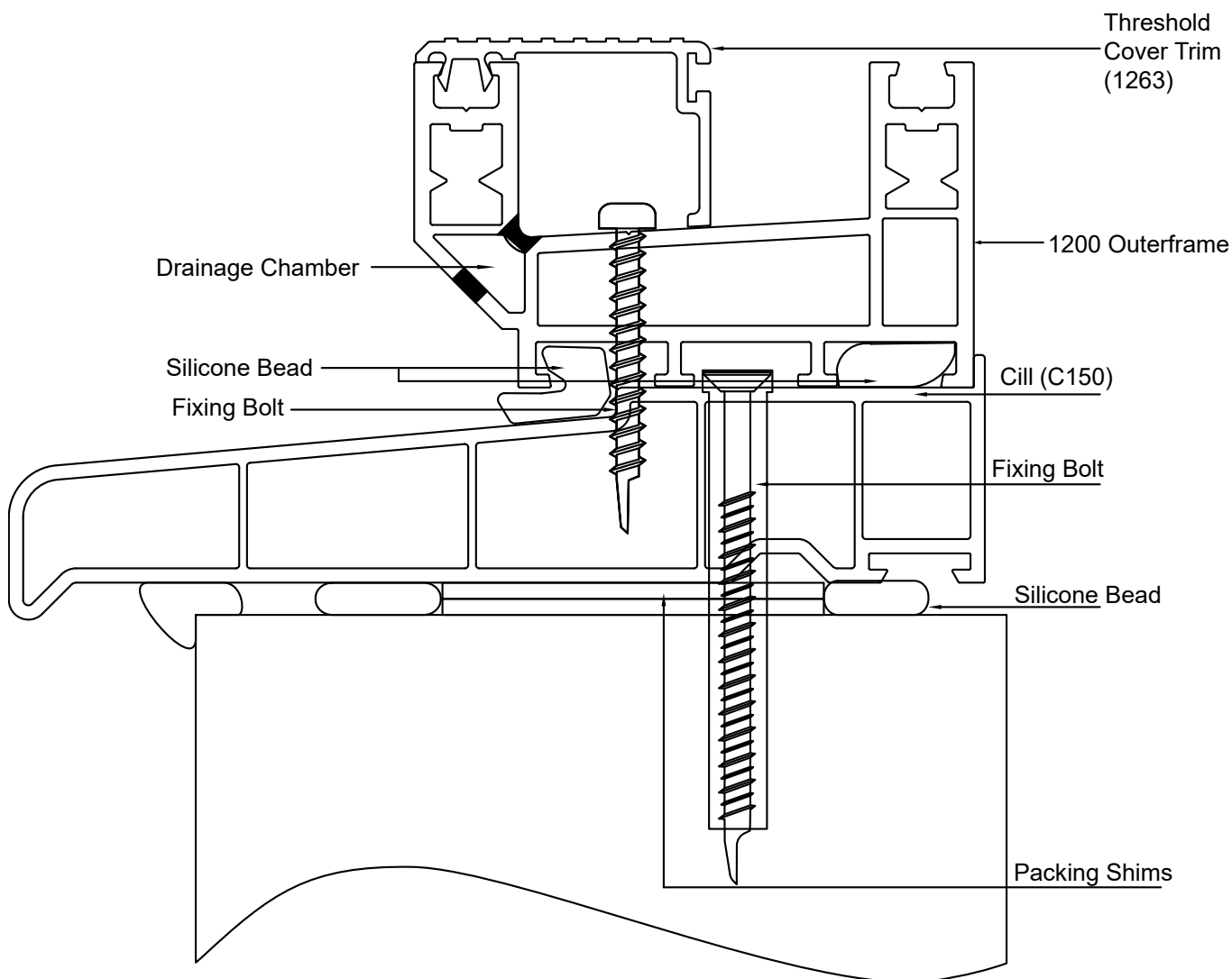
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Installing the Frame

Fixing the Cill :-The method shown requires the cill to be fitted to the base of the opening making sure that the base is clean of loose debris and the DPC is intact, apply silicone bed as shown, making sure that the cill is level. Then fix with the appropriate frame fixings 200mm from each end at a maximum of 600mm centres (In accordance with BS 8213-4:2007). Finally fix frame to cill using 50mm self tapping screws.

Note:- For PAS24 fixing centres should be reduced to 100mm from each end and at a maximum of 300mm pitch.

Fixings Through Cill



In-Line Sliding Patio Door

Installing The Frame



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Installing the Frame Continued

Fixing the Assembled Frame

N.B: It is better not to remove the fixed or sliding sashes from the outer frame prior to fixing. However on very large three or four pane units, it will make lifting easier if the sliding door/s are removed. The sash end cover profile (1289) will need to be removed in order to lift off the door/s.

IMPORTANT - Do not remove the fixed sashes, as these will not lift back in once the outer frame head and cill are fixed.

Carefully remove the outer frame cover trims to allow access for fixing bolts.

External (Outside the slider)

Remove head trim first using a sharp wide bladed tool to ease between the front lip and outer frame to gently work trim free. Remove jamb trim next working from the top. Finally remove aluminium threshold trim - N.B.: If this is removed before the jamb trim, it will scratch the surface of the plastic.

Internal (Inside the fixed sash)

Either - Remove bump stops and jamb trim OR unscrew fixed sash and slide back.

The cill should be packed and set level on a silicone or mortar bed and fixed to the base of the opening. Before doing this it is advisable to offer the frame in "dry" to ensure that there is sufficient tolerance to fit the frame square and plumb.

When ready to fit the frame, run a line of silicone to the top face of the cill and offer the frame back into position.

Use temporary wedges to set the frame square in the opening (use diagonal measurement across opposite corners of the outer frame to check).

Fix the bottom frame and cill first using fixing bolt centres.

Next pack and fix jambs plumb and true.

Fixings should be 200mm from top and bottom corners and no more than 600mm centres in between.

On the locking jambs, the intermediate fixings should be adjacent to the locking points.

The head can now be fixed using the same fixing distances as jambs. However, if head fixings are impracticable, and additional foam fixing is used (in accordance with BS 8214-4:2007), then fixings can be as described in 'Fixings Through Cill' section. Ensure that head is fixed level with no bow in either plane.

Re-fix the fixed sash/es if they were moved for jamb fixings. Ensure that the fixing to the head does not distort the frame, use packer (1204) between the fixed sash and outer frame.

Re-fit the jamb cover trims using the removal method in reverse. Cut and fit the drainage trim into the threshold behind the fixed sash.

Finally check that the door locks properly and is secure. Ensure that the location pin on the lock, just above the handle set, is centred on the hole provided in lock plate.

To check for plumb, slide the door almost closed, leaving a small gap. If the gap is not parallel, make any necessary adjustment by raising or lowering the rollers using a posidrive screwdriver, gaining access from the end of the sash (on the interlock side, part remove sash end cover).

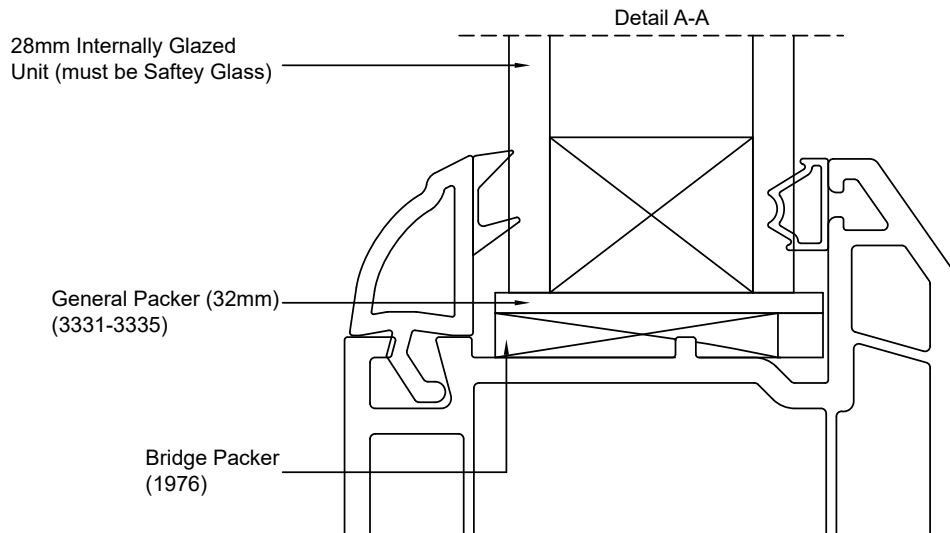
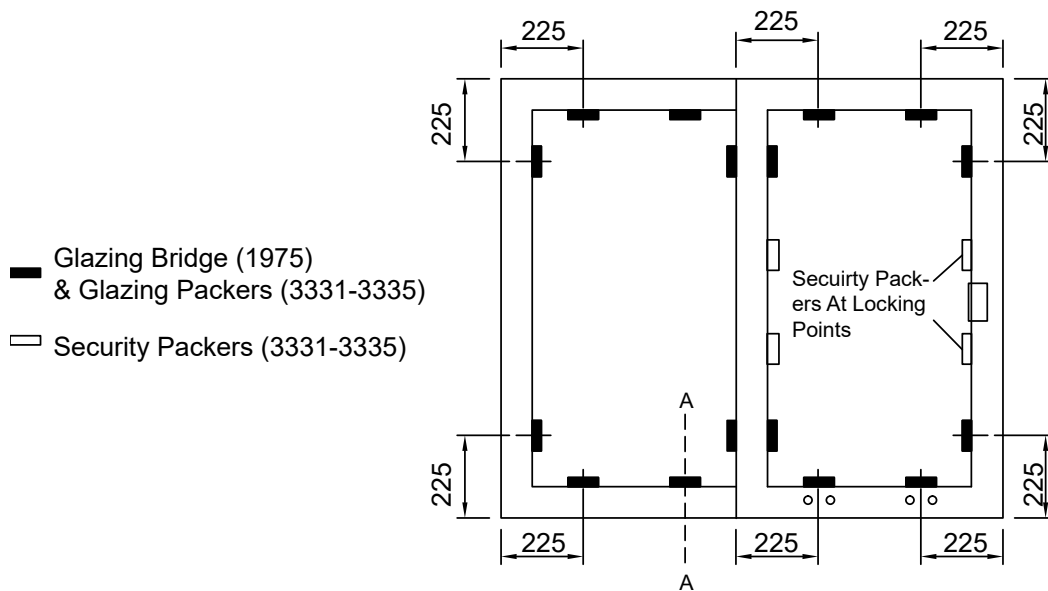
In-Line Sliding Patio Door Glazing

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Glazing

Bridge packers (1975) should be positioned and glazing packers should be glued into position as shown, also additional security packers should be glued in position to the back of the intermediate locking points. Care should be taken not to bow the stiles of the sashes. Glaze up the fixed panel first as access is required through the slider to bead up the interlock stile.

Location of Packers



In-Line Sliding Patio Door Perimeter Sealing

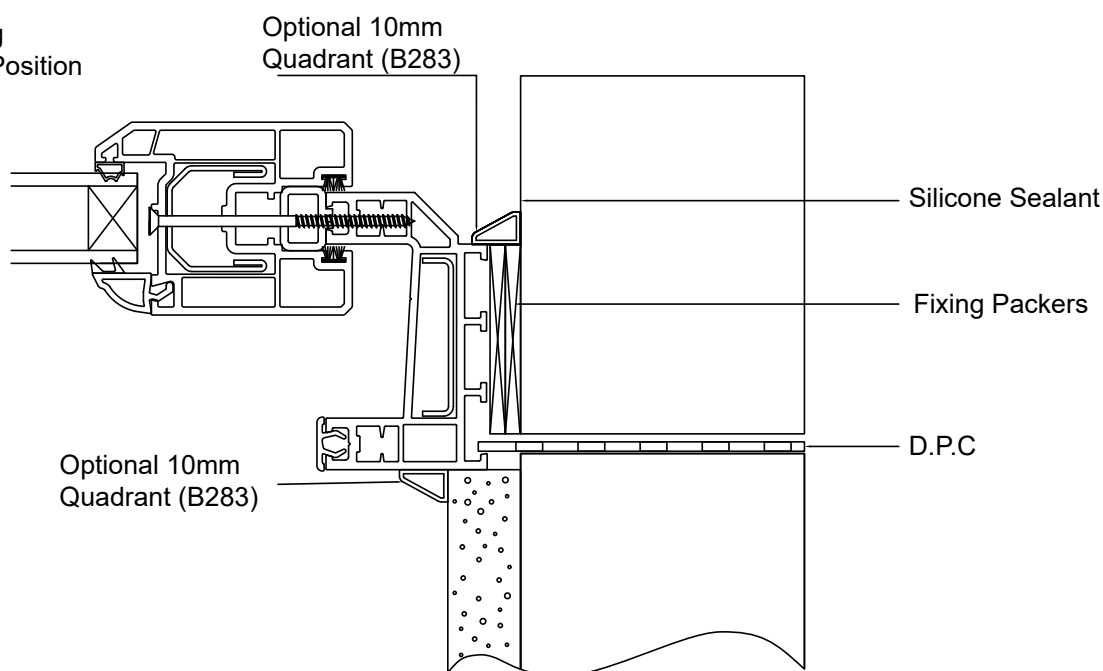
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Perimeter Sealing

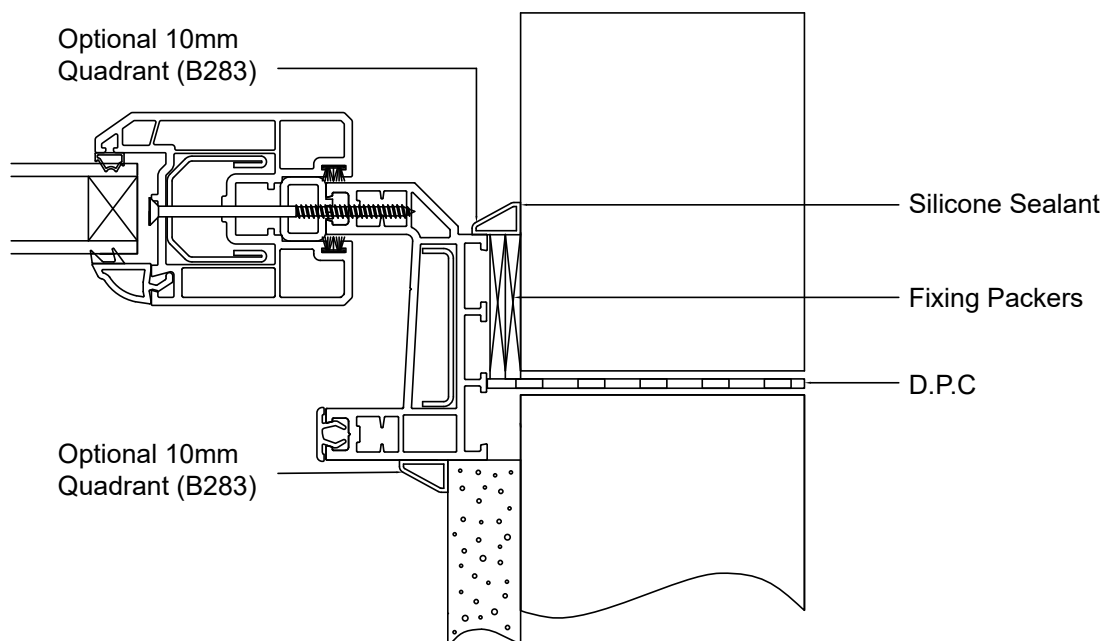
It is advisable to clean down the frame before sealing the perimeter.

The gap between the outer frame and structure must be sealed using a suitable external grade sealant. 5-6mm gaps can be filled with sealant alone, however larger gaps may require the use of foam backing strips.

Perimeter Sealing
Standard Fitting Position



Frame Rebate Over Plaster Line



In-Line Sliding Patio Door Assembling The Frame

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Assembling The Frame

Mechanically Jointed Option - Outer frames only

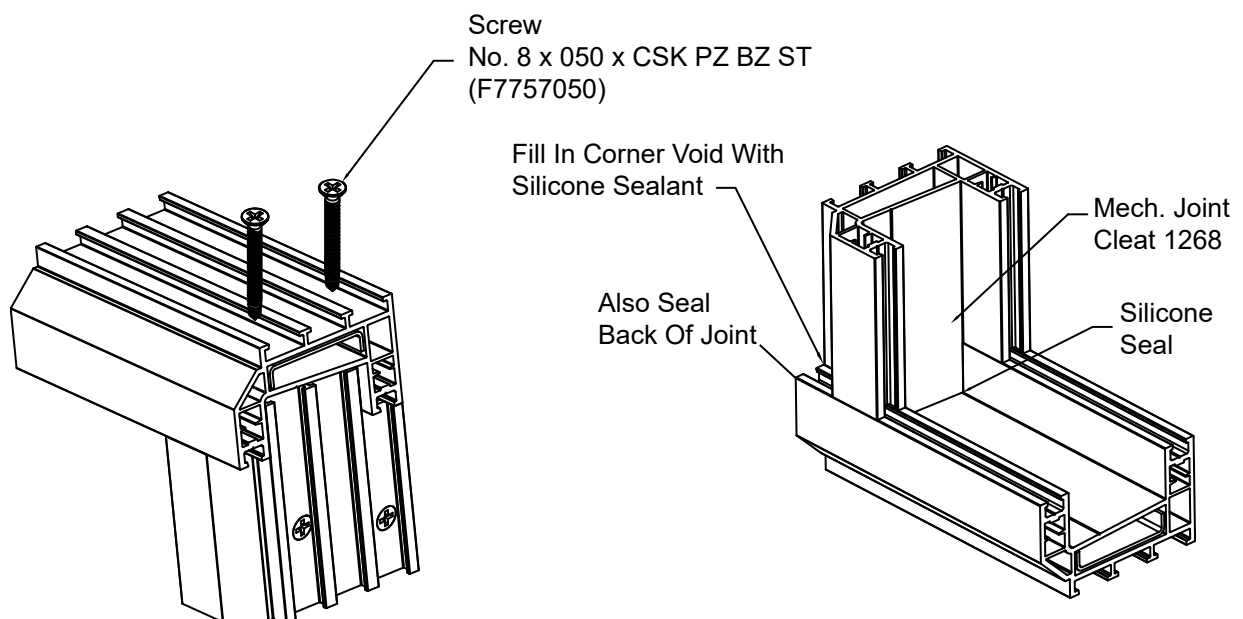
In most cases a patio requiring a mechanically jointed outer frame will be supplied fully fabricated. This ensures the patio is supplied complete and to the correct size and specification. It also avoids any unnecessary amount of on-site assembly and allows the installers to see how the finished product goes together. However, should a patio be supplied in kit form then refer to the following assembly instructions.

Secure & Sealing of Corners

Secure joint as shown.
Screw 2 off 50mm (F7757050) self tapping screws into cleat, pulling the corner tightly together.
Seal inside and outside of joint using clear silicone sealant.

Outer Frame Corner Cleat

The cleat is pre-assembled into the frame profile. Lay the outer frame down on a suitable surface, making sure the rebates (outside) are all to one side, and that on a two pane door the lock plate jamb is on the correct side. Offer one corner together making the ribs on the back of the jambs line up with the new head (or cill) profile.



In-Line Sliding Patio Door Assembling The Frame

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Assembling the Frame Continued

Fixed Sashes

Stand the frame up against a suitable wall, and lift in the fixed sash/es by “springing” the head and cill in the middle of the frame.

At this stage the assembled frame can be installed into the structural opening.

Once the frame has been fixed, the fixed sash/es can be screwed to the outer frame through the pre-drilled holes using the 100mm tapcon screws supplied. Fit the brush sealing pads into the outer frame, centred above and below where the sashes couple together.

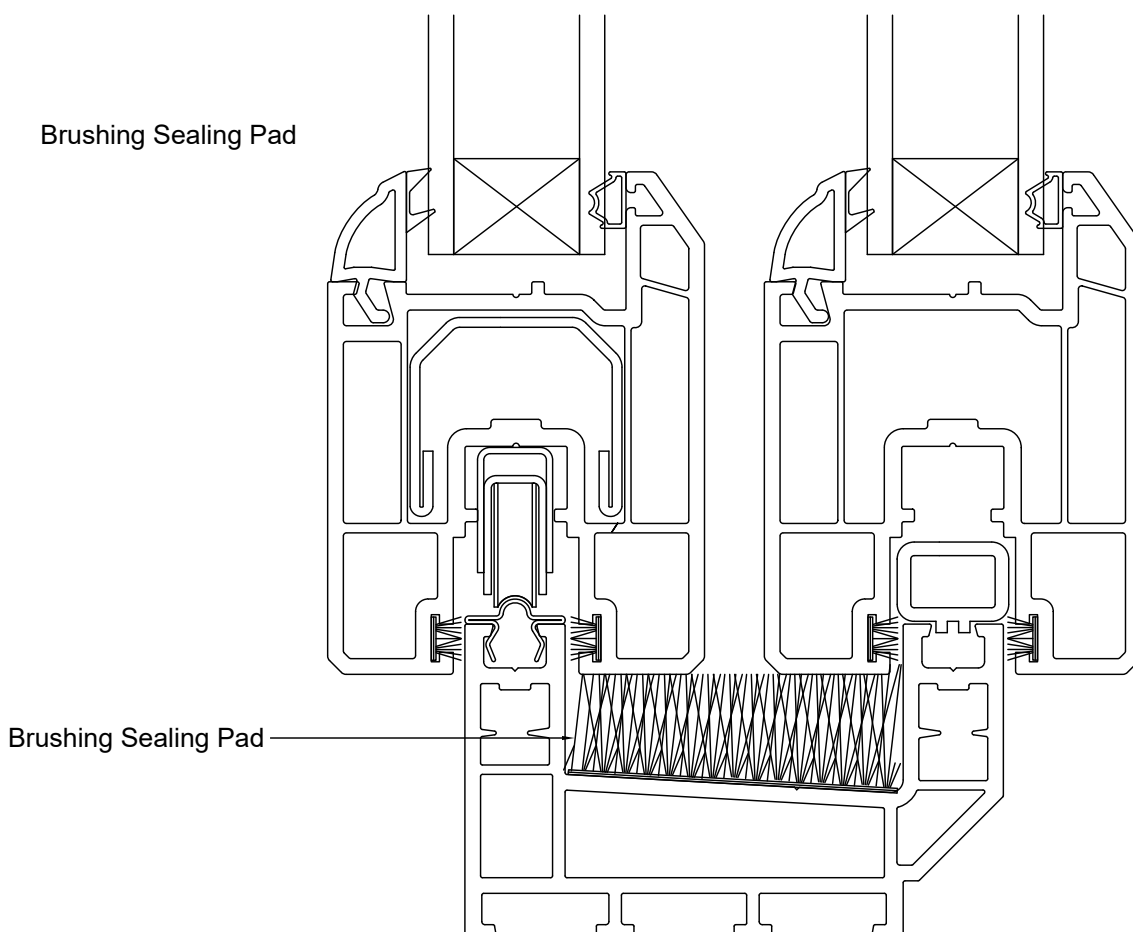
Bump Stops

Locate the back of the bump stop into the dovetail channel of the outer frame upstand and with a rubber mallet secure into position.

Trims

Fit the jamb cover (1253) trims first, then fit the head (1253) and black threshold (1263)* trims using a rubber mallet to tap trim into the outside dovetail. Next fit the dovetail closure profile (1254) to the inside head dovetail and fit the stainless steel track to the inside dovetail at the bottom using a rubber mallet. Finally to cover drainage hole detail - insert Drainage Cover Trim (1255) into the inside channel of the outer frame (Cill) section, behind the fixed panel.

*For (L) 1334 Low Threshold fit L1335 Threshold Trim.



In-Line Sliding Patio Door

Assembling The Frame

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Assembling the Frame Continued

Sliding Door(s)

Remove the sash end cover profile from the sash. Push the sash up into position at the head and lift the bottom over the track and let the sash drop into position on the track. Fit the handle set on the sash checking that the lock is in the unlocked position and the lever on the handle set is positioned as shown.

Once the final adjustments to the door have been completed and you have checked that the door locks correctly, you can replace the sash end cover profile.

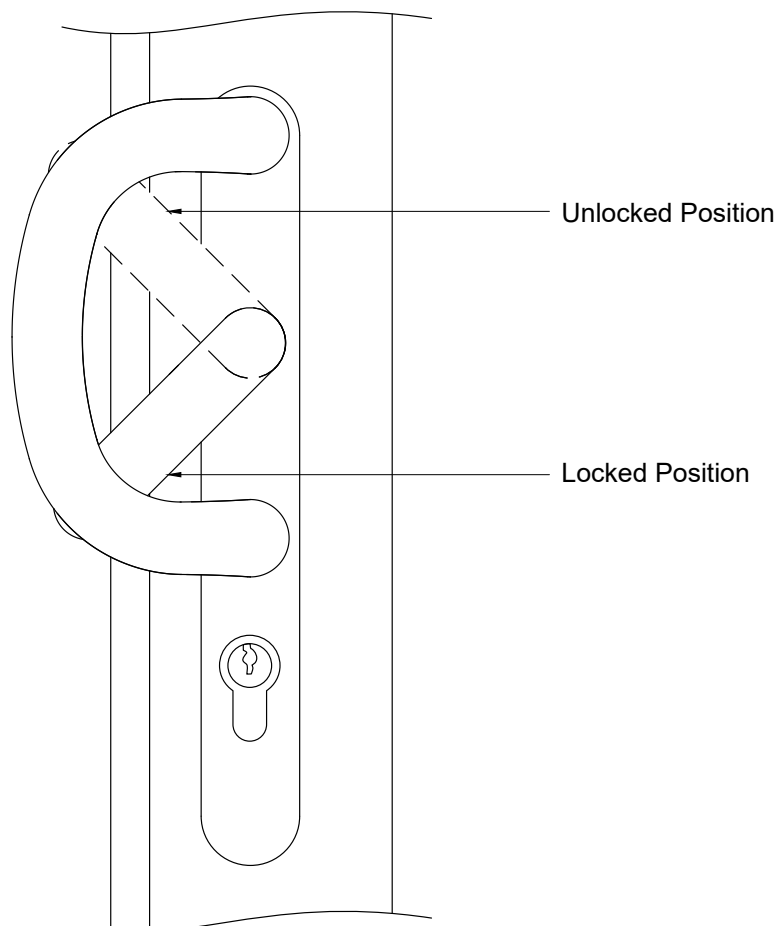
Meeting Profile (3 and 4 pane doors only)

Adjust both doors so that they are square and parallel with each other. Cut the meeting profile 16mm shorter than sash height. Fix centrally to meeting stile of slave door using 55mm screws supplied. Fit end caps (1270) to top and bottom of the sash meeting profile using a proprietary PVC-U glue. Fit lock plate as stated.

Lock Plate

Slide the door to a closed position. Mark the lock centre, as shown on the lock face plate, on the outer frame (for 3 and 4 pane doors see meeting profile) Offer the lock plate to the outer frame, making sure that the end caps are fitted, and line up the lock centre line with the horizontal line on the centre of the hook lock keep plate (keeping the words Patiomaster above and below the line. Fix using 8 off screws supplied. Fit closure profile (1254) above and below the lock plate.

Check that the door locks correctly and is square within the frame. Make any adjustments necessary by raising or lowering the rollers using a long shaft posidrive screwdriver, gaining access from the end of the sash. Fit the sash end closure profile.



In-Line Sliding Patio Door Maintenance



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INTRODUCTION

Patio doors are designed to be very low maintenance. The general service and maintenance tasks recommended are simple to carry out and do not require specialist skills, tools or equipment.

Precautions

When using cleaning and lubricating products always follow the manufacturer's instructions; take care not to use an excessive quantity. For cleaning products, always test a small area of the product in an obscure location first.

NOTE: Do not use solvent-based or abrasive cleaning products or products containing bleaching agents. Do not use metal polish or a wirebrush.

GLASS & WEATHERSEAL MAINTENANCE

Glass Cleaning

Float glass, used in most double glazed units, is easily scratched and it is therefore recommended that hand jewellery is removed prior to cleaning. Any proprietary household glass cleaner may be used with a soft cloth and it is recommended that heavy external grime be initially removed with a solution of soap and water.

Leaded Glass Cleaning

In this type of double glazing, lead strips are bonded to the inside/ outside of the outer pane of the unit in a variety of patterns. Take care when cleaning leaded lights as excessive pressure might dislodge the lead from the glass surface. The use of warm soapy water and a soft cloth, moderately applied, will prove an adequate cleaning method.

Note: external lead will oxidise, this is a natural phenomenon and cannot be avoided.

Weatherseals

During cleaning ensure that the weatherseals fitted to your products do not become dislodged from their grooves. Should this occur, slide back into position immediately, to avoid damage when the door is closed. If the weatherseals are broken or damaged and draughts are felt around the product, ensure prompt replacement by contacting your installer.

Following the initial installation the weatherseal may require bedding in; causing a slight resistance when operating the door, the application of a silicone spray will aid the smooth operation of the door during this period.

OUTER FRAME & SASH MAINTENANCE

Wash the frame with a soap and water solution, periodically as required, to remove any grime and atmospheric deposits. If required clean with a non-abrasive proprietary cleaner, suitable for plastics, using a soft cloth. Stubborn marks can be removed with a stronger, non-abrasive, proprietary cleaner such as a cream. Always take care not to disturb sealant.

At least every four months, clean the internal and external surfaces of the frame and glass (or glazed panel(s)) to remove atmospheric grime; always use a soft cloth with mild liquid detergent solution, rinse with water and dry off. Periodically check that visible external drainage holes are free from any obstruction; if blocked, remove obstruction and flush through with water to ensure correct drainage.

In-Line Sliding Patio Door Maintenance



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HARDWARE MAINTENANCE

All lock types

The key-way, latch and keeps should be kept free from dirt, debris and obstruction at all times. On an annual basis check operation of the key mechanism with the door leaf open. If the key requires excessive force to engage the lock mechanism then lubricate the key-way with a silicone based spray lubricant; do not use oil or grease. On an annual basis lubricate the bevelled or rounded face of the latch and the latch strike on the keep with a smear of petroleum jelly or grease.

Multi-point locks

On an annual basis apply a smear of petroleum jelly or grease to each side of each additional hook or bolt. Some multi-point locks are supplied with adjustable keeps. The Adjustment method is specific to the type of lock fitted, however, to achieve optimum performance lock keeps should be adjusted periodically.

TRACK

Clean and lightly grease the track bearing surface annually with petroleum jelly.

CYLINDER

Do not attempt to lubricate the locking cylinder.

FURNITURE & FITTINGS MAINTENANCE

Handles

On an annual basis clean and remove dirt and debris from moving parts. Lightly oil external moving parts with a light machine oil.

NOTE: Do not use a metal polish. Do not use any abrasive cleaning products or a wire brush.

Letterplates

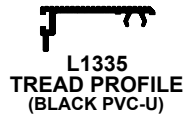
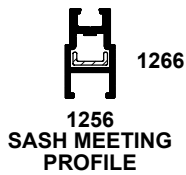
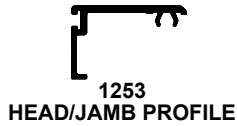
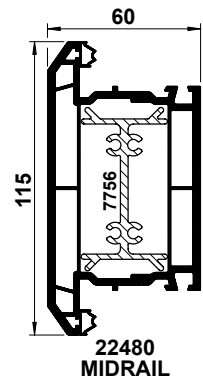
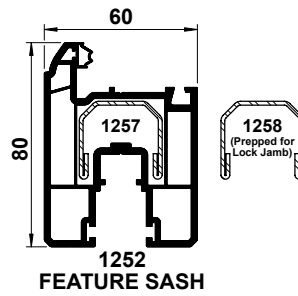
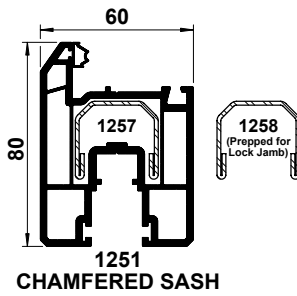
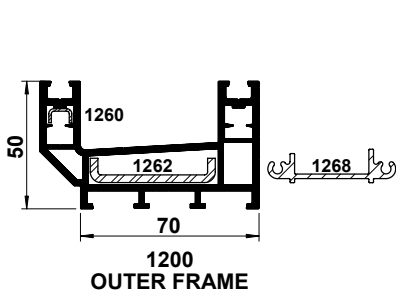
On an annual basis clean and remove dirt and debris from moving parts. Lightly oil external moving parts with a light machine oil.

NOTE: Letterplates with plastic torsion bars (visible when flap is lifted) do not require lubrication. For stubborn stains, use a soft cloth with mild liquid detergent solution, rinse with water and dry off. On an annual basis check that the external frame of the letterplate is flush with the face of the midrail. If evidence of a gap is found tighten the fixing screws located behind the internal flap; do not over-tighten screws. If a gap is still evident apply a small bead of a high modulus silicone around the full perimeter of the external frame.

Sliding Patio Door



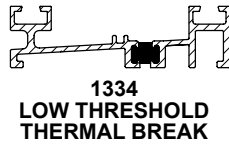
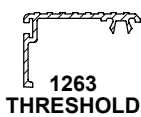
MAIN PROFILES



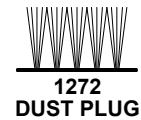
GLAZING BEADS



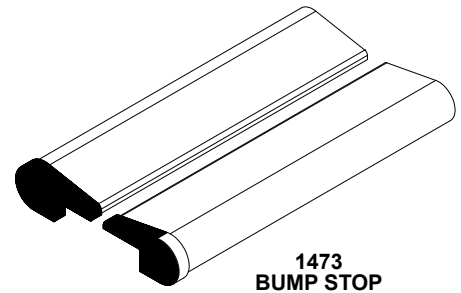
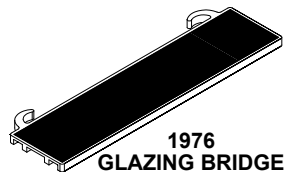
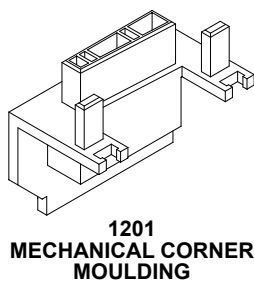
METAL SECTIONS



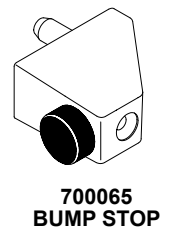
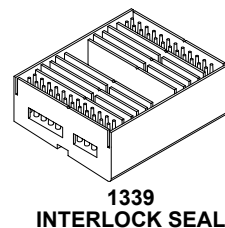
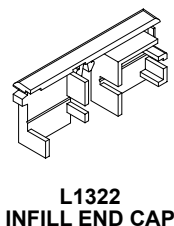
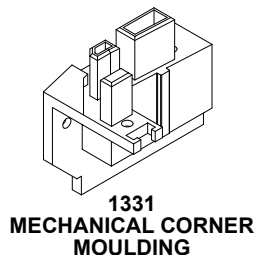
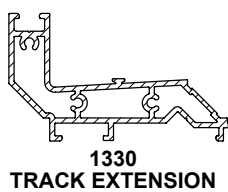
WEATHERSEALS



ANCILLARIES



3 TRACK COMPONENTS



In-Line Sliding Patio Door Technical Manual Issue Record



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ASSEMBLY SECTION DRAWINGS	OCTOBER 2020	27	TM-0002	93
Issue 1	09-02-10	Issue 12	22-10-15	
Issue 2	20-04-10	Updated 1263 Threshold	Page 11	
Added 'Enhanced Security' section	Page 46	Text Adjustment	Pages 44-45	
Issue 3	07-06-10	PAS24 Note Added	Page 59	
Changes made to 'Build Specification' section	Page 47	Updated Wallchart	Page 68	
Issue 4	30-08-10	Issue 13	25-07-16	
Changes made to 'Build Specification' section	Page 47	Up issue for new 1200 frame, 1268 cleat and 1262 steel.	Throughout	
Issue 5	14-09-11	Issue 14	30-08-16	
Section 1250 updated & bead 2369 removed	Throughout	Updated to cover typo's and foil changes	Throughout	
Additional deductions for part no. 1253 added	Page 5	Issue 15	07-09-16	
Part no. for Letter Plate removed from Deduction Chart	Page 6	Updated to cover foil changes	Throughout	
Re-ordered manual layout		Updated drawings to cover quatrant changes	Page 61	
Updated Wallchart	Page 67	Issue 16	19-10-16	
Issue 6	01-06-12	Part number change	Page 4	
Introduction re-written	Page 4	Issue 17	30-01-18	
Alteration made to equal glass width deduction & additional deductions added	Page 5	Changes made to securtiy glazing clips	Page 53	
Dimensional alterations to horizontal section drawings	Page 17	Issue 18	19-04-18	
End Prep. details added for 1252 sash	Page 25	Aluminium three track patio section added	Pages 64-89	
Updated Wallchart	Page 67	Issue 19	06/06/2018	
Issue 7	31-08-12	Page 3 updated to include the use of shootbolts on the silding sash of the 6 pane patio	Page 3	
Bead 2389 replaced by 2395	Throughout	Page 43 changed to include updated part numbers	Page 43	
Security handle part number change	Page 45	Page 55 updated to include min/max sizes for 3 and 6 pane 3 track patio doors	Page 55	
Updated handle part number in title	Page 46	Weather test results added for three track patio	Page 54	
Updated Wallchart	Page 67	1338 Drainage Trim Tape and applications changed	Page 88	
Issue 8	05-11-12	Issue 20	19/07/2018	
Updated manual to clarify enhanced security reinforcement & 53 details	Pages 52	Deduction for 1338 tape changed	Page 64	
Issue 9	24-04-13	Patio door stop fitting details changed	Page 90	
Additional deductions added	Page 5	SWR272 Patio Track Support removed	Pages 69,70,71,73,88,89	
Detail for 1256 pre drilling for roller adjustment added	Page 29	Note added to explain fitting details and screws for 1330	Page 79	
Updated manual to reflect the issue of PAS 24:2012 which now incorporates windows & doorsets	Page 45	1261 central track deductions updated	Page 64	
Enhanced security patio door size increased to 2400x2200mm	Page 46	Quantities updated in deduction section	Page 64	
Issue 10	05-02-14	1255 Drainage Trim added to Assembly Sections A & B	Page 67	
Amendments to paragraph for glass options for PAS24 doors	Page 45	Patio Door Stop information updated	Page 89	
Also to remove thumbturn as an option		Issue 21	20/09/2018	
Amend dimension on horizontal assembly section	Page 17	Up issued due to error with lifecycle and Epwin format only going up to issue 20. Now on Epwin format 1		
Issue 11	29-10-14	Issue 22	20/09/2018	
Updated Weather Performance Section	Page 56	Changes made to deductions for 1254 closure profile - head (centre track), 1255 drainage trims, 1253 trims, 1321 cover infill - head & jambs, 1263 threshold - inner & centre track, 1320 threshold cover infill	Page 64	
Updated Survey & Installation Section	Pages 58-60	Issue 23		
Updated Deductions & Parts Breakdown	Page 5	Patio assembly section drawings updated to reflect the correct measurements.		
Updated Enhanced Security Section	Page 45	Issue 24	04/10/2019	
Removed 1275 Letterplate Fixing Page	Page 40	Manual updated throughout to reflect change to ERA hardware and to show new 1474 PAS24 Interlock.		
Changed the word 'Enhanced' to 'PAS24'	Throughout	Issue 25	21/11/2019	
Amend typo error	Page 34	Handle and Gearbox routing details changed for PAS24 doors and non PAS24 doors	Pages 17 & 42	
Add Security Glazing Clips section	Page 55			

In-Line Sliding Patio Door Technical Manual Issue Record



SECTION	DATE	ISS	REFERENCE	PAGE
ASSEMBLY SECTION DRAWINGS	OCTOBER 2020	27	TM-0002	94

Issue 26 25-03-2020
1204 Distance Profile fixing details added Pages 28-29

Issue27 17/09/20
1474/1 Security Interlock added Throughout
QX32/1 added for use with the 1471/1 patio interlock Pages 46-47
Sash width and associated parts deductions updated Pages 4 and 53
Triple track depth dimension added Pages 62 and 63