

# SLIDING DOOR: ASSEMBLY INSTRUCTION

SERIES 800

DIVIDING RAIL AND HANDLE

Version 1.7 (2019-02-07)

4.022.1.c

easy

medium

difficult

Assemble



Subject to technical changes.

**raumplus**

# CONTENT AND TOOLS

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## SYSTEM:

max. element width:	<b>1300 mm</b>
max. element height:	<b>3500 mm</b>
max. element weight:	<b>180 kg</b>

### Special notes:

The panel channel ( 10 mm ) serves to simplify the assembly.  
For this purpose, a stabilizing panel ( **8 mm** ) can be installed.  
The panel is required in slanted doors for stability purposes.  
Adhesion of the **4 mm** glass panel incl. splinter guard foil (PE) with adhesive tape.  
One-sided or double-sided adhesion is possible.  
A slanted door guide is only possible with one-sided adhesion.

### Note!

Do not use transparent glass panels!  
All profiles have two visible positioning grooves for the adhesive tape.  
We recommend to test the adhesion

## TOOLS:

(without claim of completeness)

- |                    |                           |
|--------------------|---------------------------|
| ■ Hack saw         | ■ (Wire cutting pliers)   |
| ■ Allen key set    | ■ Rubber hammer           |
| ■ Drilling machine | ■ Cutter / knife          |
| ■ Drill set metal  | ■ Small pinch roller      |
| ■ Screwdriver set  | ■ Large pinch roller      |
| ■ Pencil           | ■ Vacuum cup glass lifter |
| ■ Straight edge    |                           |

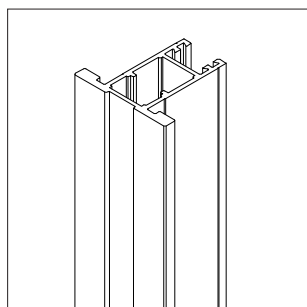


### VERSION INFORMATION:

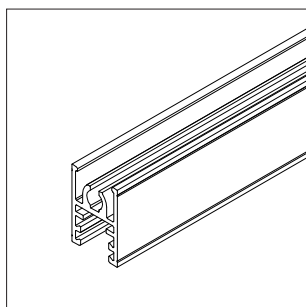
Version 1.3: new adhesive system  
1.4: cleaner changed  
1.7: item number handle changed

# ACCESSORIES

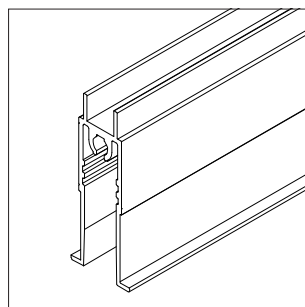
For colored surfaces please ask your dealer.



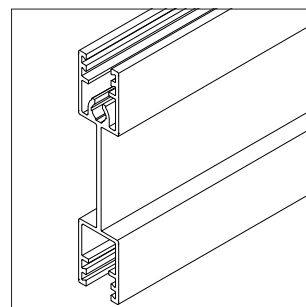
1\_ 19.01.0xx



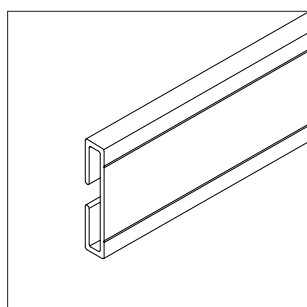
2\_ 19.12.0xx



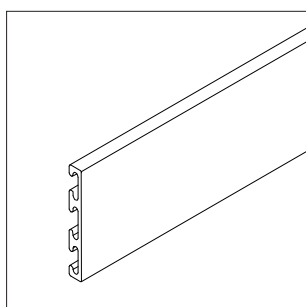
3\_ 19.14.0xx



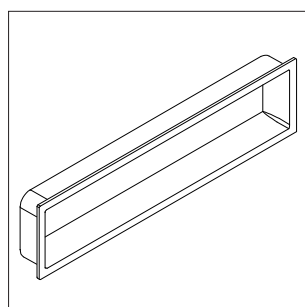
4\_ 19.22.0xx



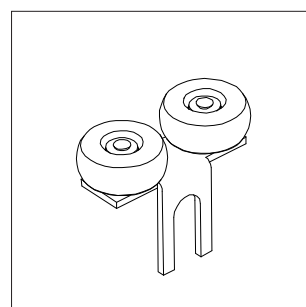
5\_ 19.23.020



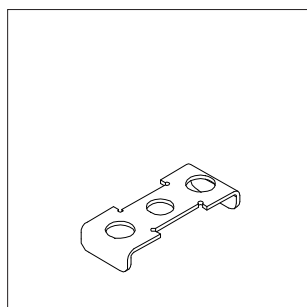
6\_ 19.24.0xx



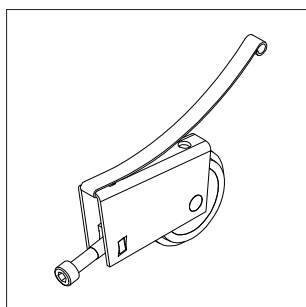
7\_ 10.01.29x



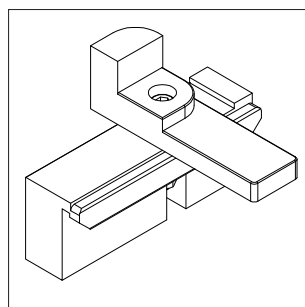
8\_ 10.01.015



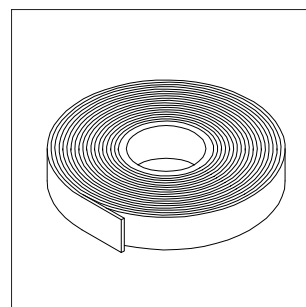
9\_ 10.01.808



10\_ 10.01.120



11\_ 30.03.012 / 30.03.013



12\_ 25.12.047

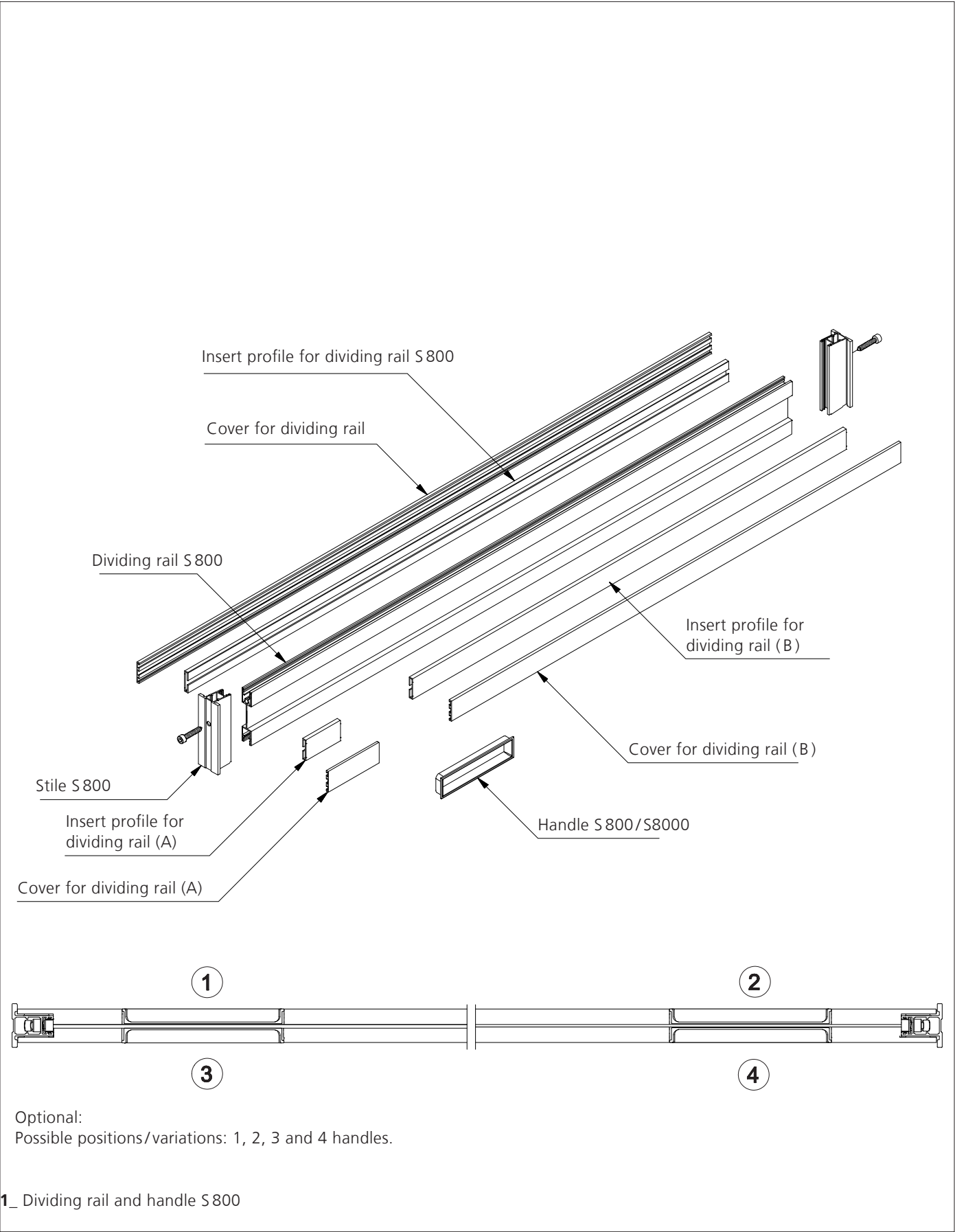
- 1\_ Stile S 800
- 2\_ Top rail S 800
- 3\_ Bottom rail S 800
- 4\_ Dividing rail S 800
- 5\_ Insert profile for dividing rail S 800
- 6\_ Cover for dividing rail S 800
- 7\_ Handle insert S 800/S8000/AIR
- 8\_ Top roller S 800
- 9\_ Security clips S 800
- 10\_ Bottom roller S 800
- 11\_ Assembly tool S 800 for anodized profiles  
Assembly tool S 800 for powder coated profiles
- 12\_ Double sided tape S 800

## w/o illustration

- 13\_ Cleaner
- 14\_ Primer / Promoter
- 15\_ Plugs for punching holes (10.07.05x)
- 16\_ Pressure roller S 800 (30.15.025)
- 17\_ Pressure roller S 800 (30.15.026)
- 18\_ Drilling template (30.14.001)
- 19\_ Hinge for angle door (10.01.060)
- 20\_ Punching tool (30.11.031)
- 21\_ Screw for dividing rail (10.07.008)
- 22\_ 8 mm gasket (10.07.034)
- 23\_ Frame screws 6,3 x 32 mm (10.07.012)

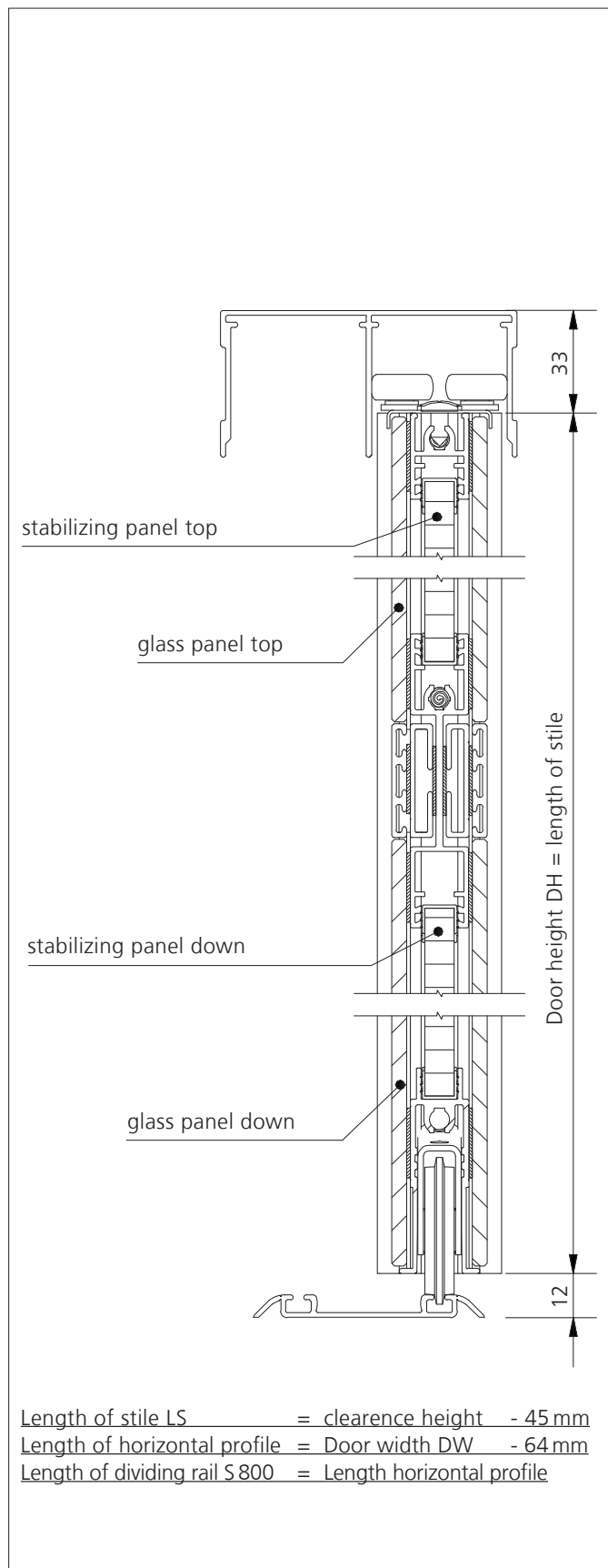
# DETAIL DRAWING

## EXPLODED DRAWING DIVIDING RAIL S 800

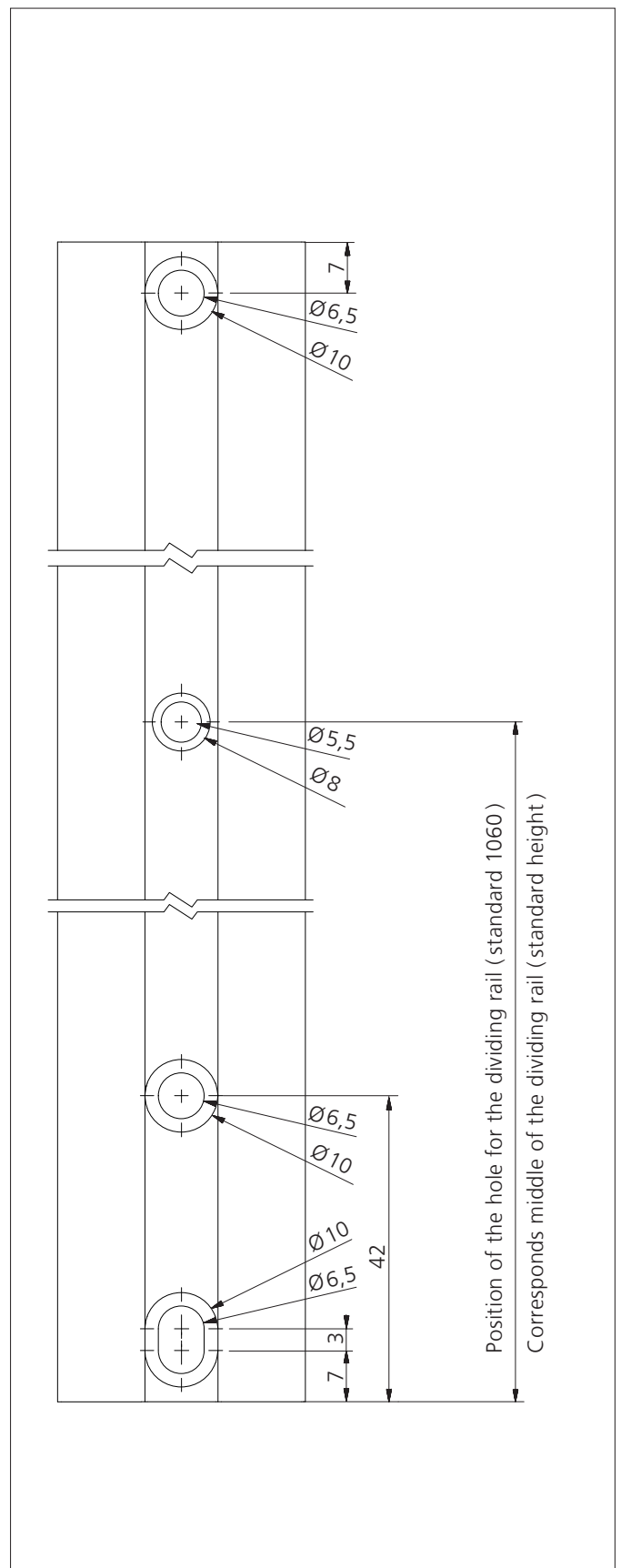


# CUTTING DIMENSION

## VERTICAL SECTION



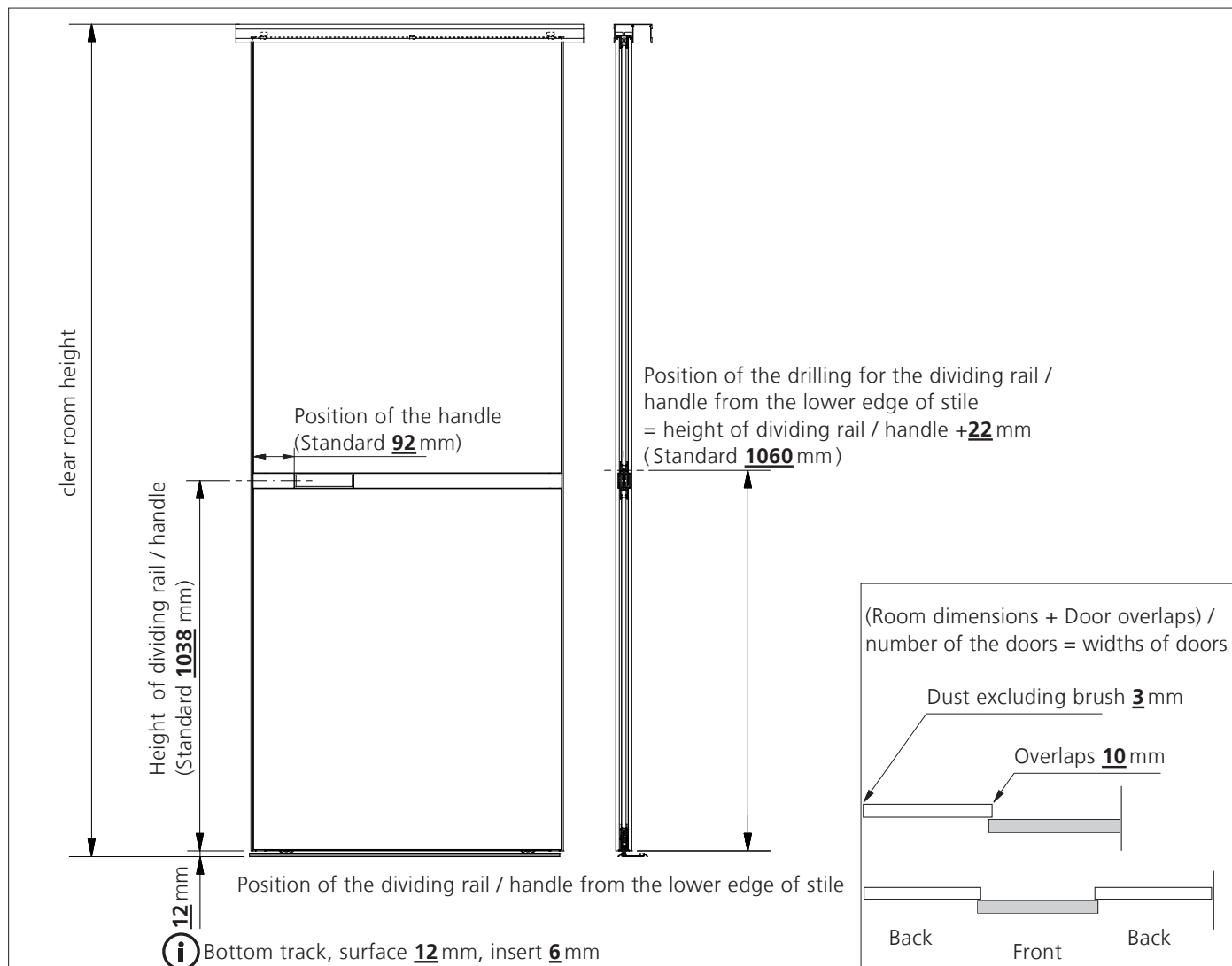
2\_ Cross section vertical / cutting dimension



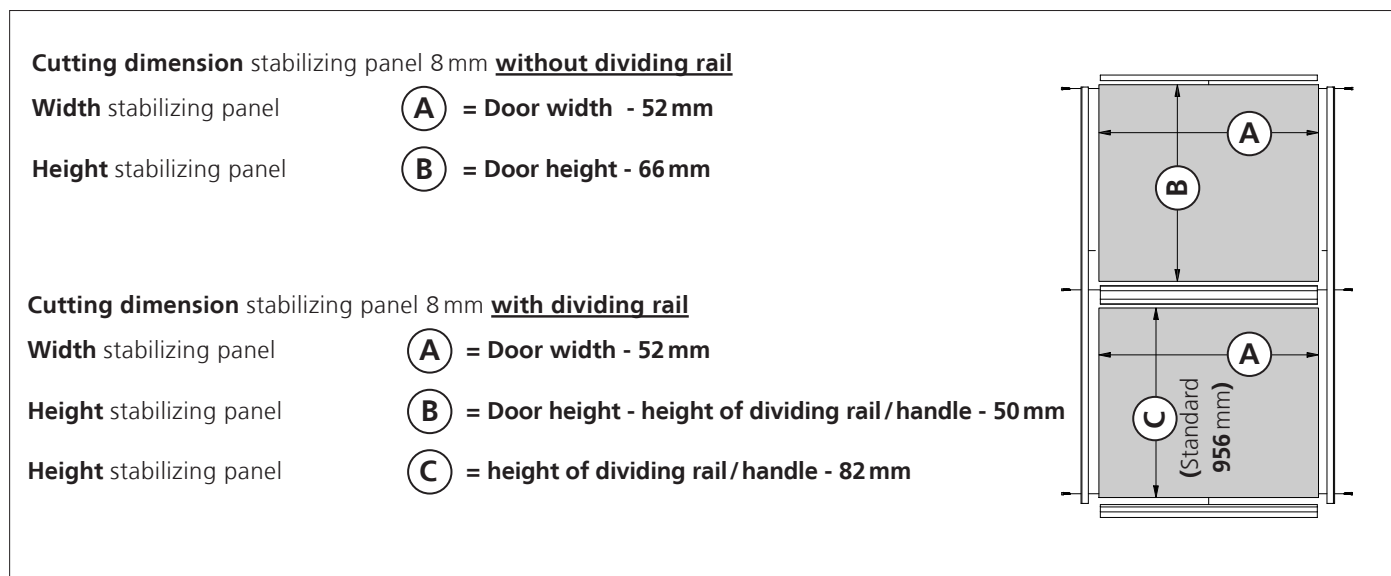
3\_ Drill hole in vertical profile

# CUTTING DIMENSION

## DIVIDING RAIL / HANDLE S 800



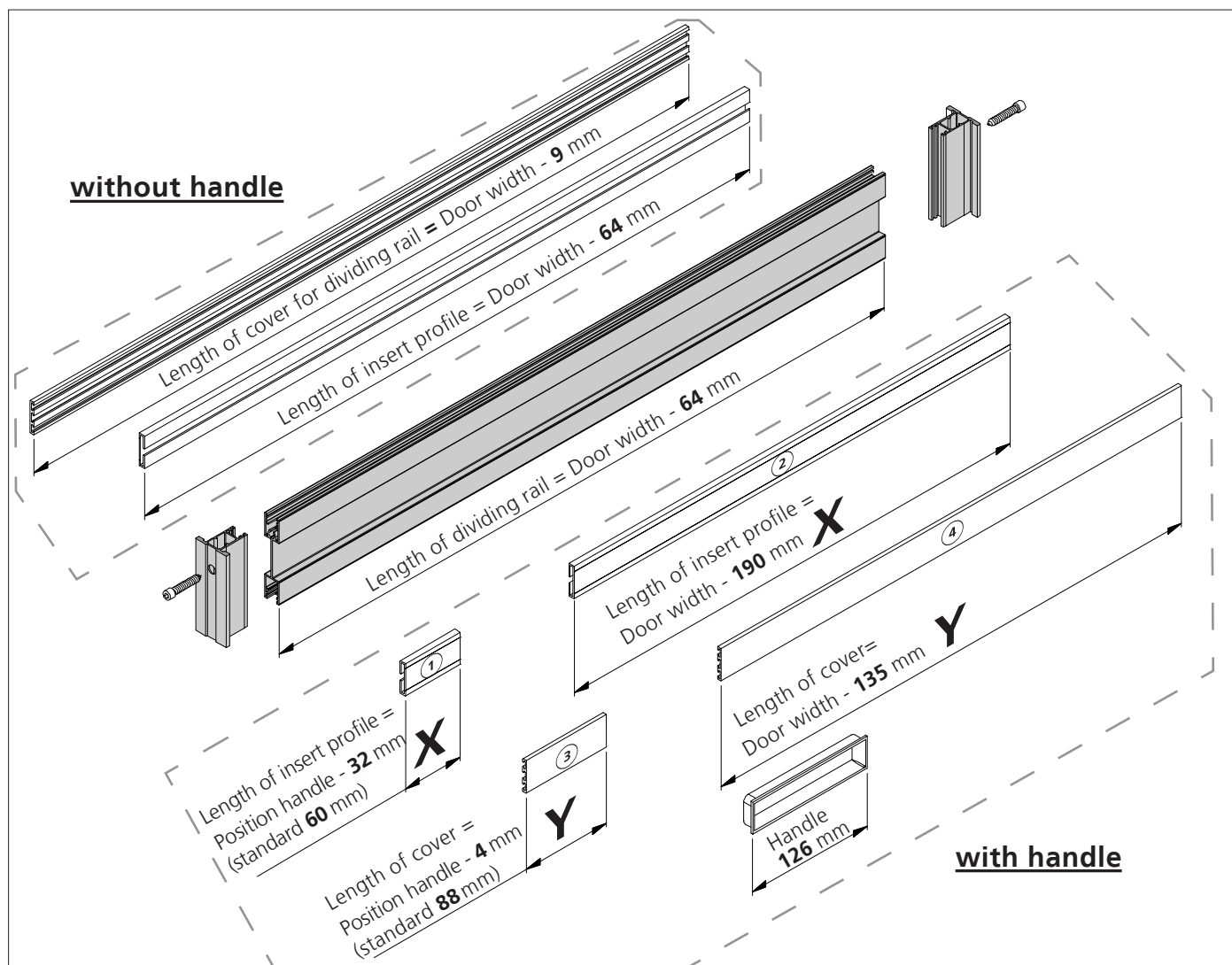
### 4\_ Position of the dividing rail and handle



### 5\_ Stabilizing panel

# CUTTING DIMENSION

## DIVIDING RAIL / HANDL S 800



2\_ Cutting dimensions for handle and dividing rail

**Cutting dimensions** for glass panel 4 mm **without dividing rail**

**Width** glass panel      (A) = Door width - 9 mm

**Height** glass panel      (B) = Door height - 3 mm

**Cutting dimensions** for glass panel 4 mm **with dividing rail**

**Width** glass panel      (A) = Door width - 9 mm

**Height** glass panel      (B) = Door height - height of dividing rail / handle - 17 mm

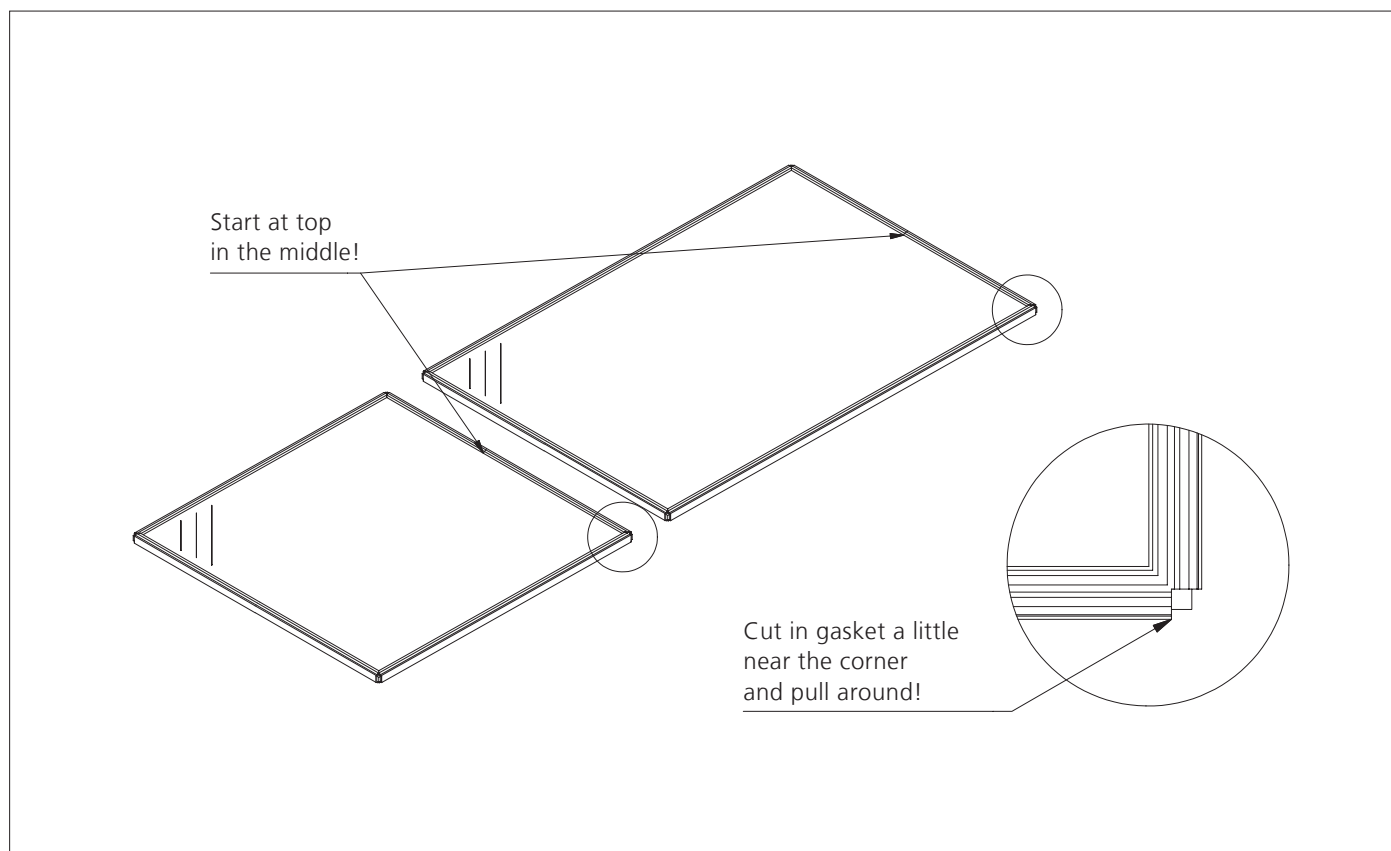
**Height** glass panel      (C) = Height of dividing rail / handle - 18 mm

(Standard 1006 mm)

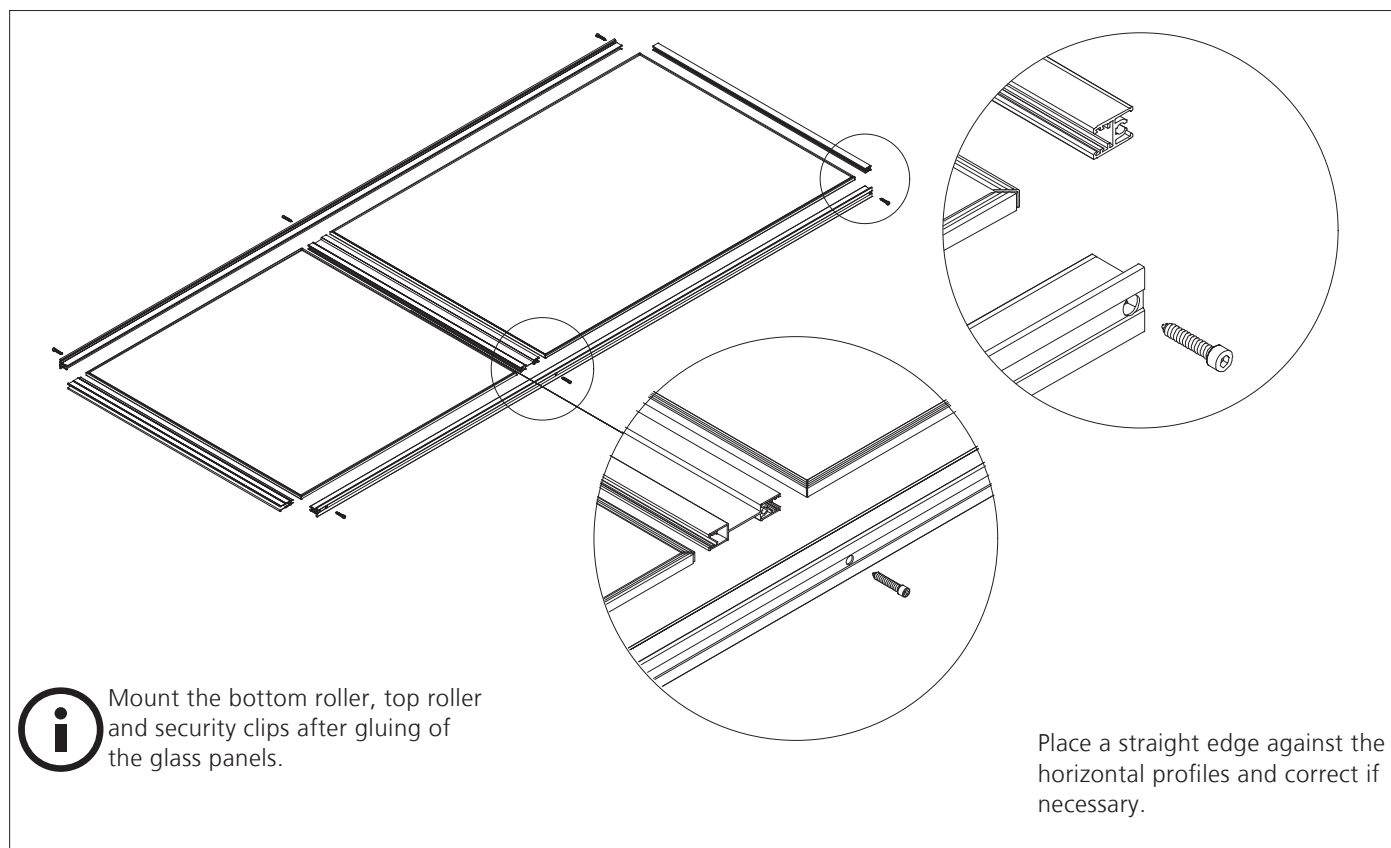
3\_ Glass panel

# ASSEMBLY INSTRUCTIONS

## STABILIZING PANEL



1\_ Place panel on a table, affix gasket

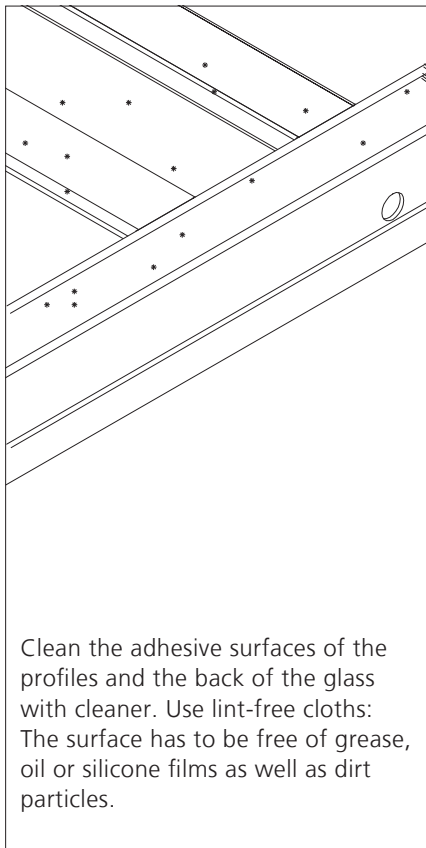


2\_ Attach the vertical profile and the cross profiles, pound it well with the rubber hammer

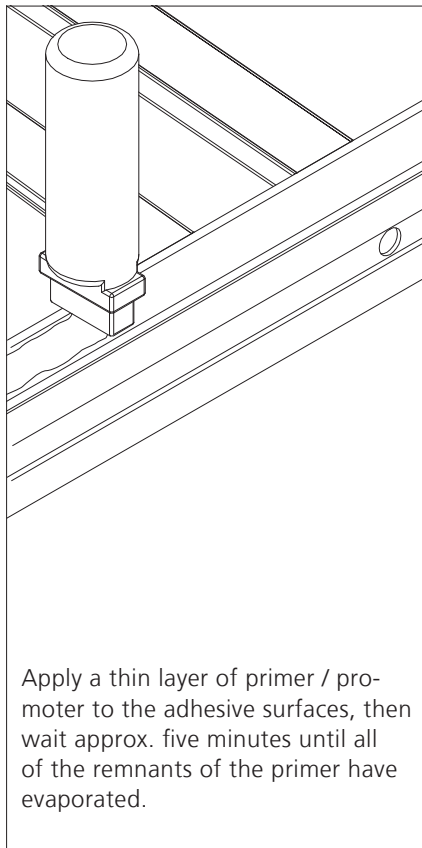


# ASSEMBLY INSTRUCTIONS

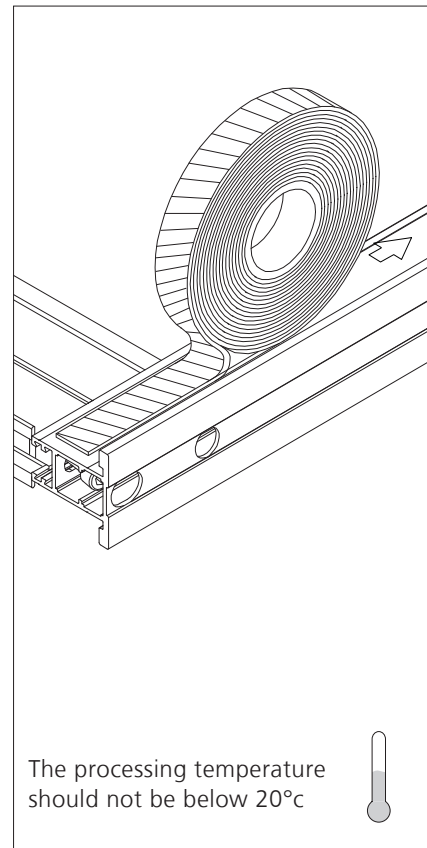
## PREPARATION OF ADHESIVE SURFACES



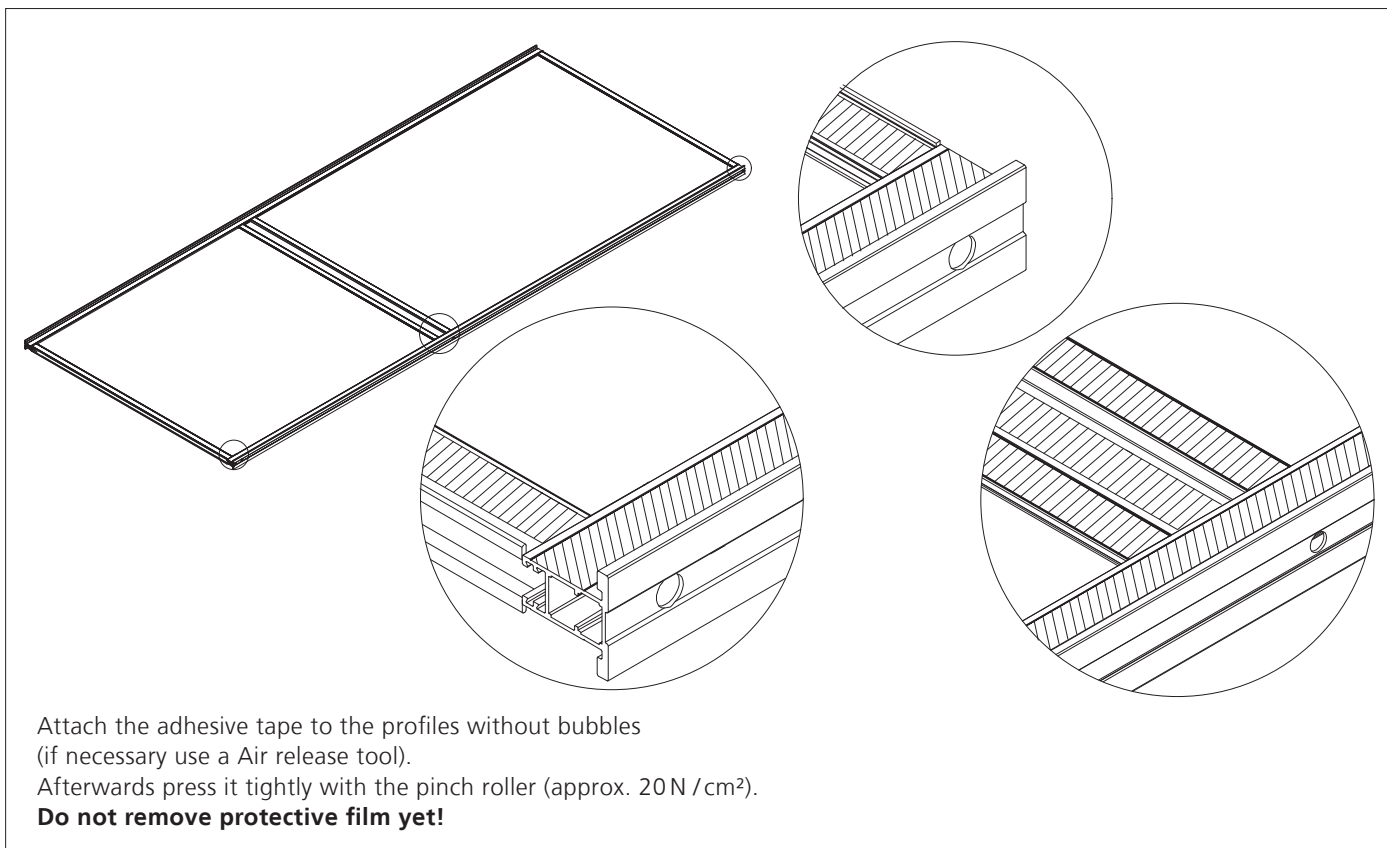
3\_ Cleaner



4\_ Primer / Promoter



5\_ Adhesive tape

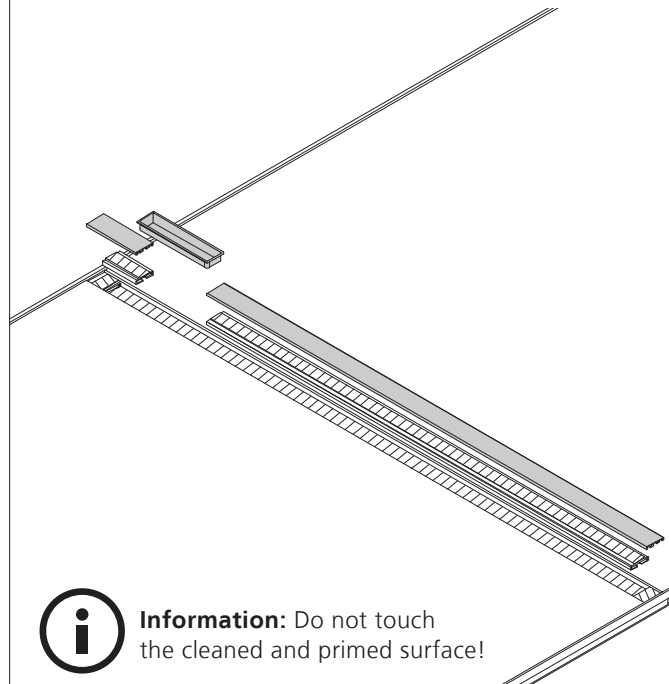


6\_ Press on tape

# ASSEMBLY INSTRUCTIONS

## GLUING THE GLASS PANEL

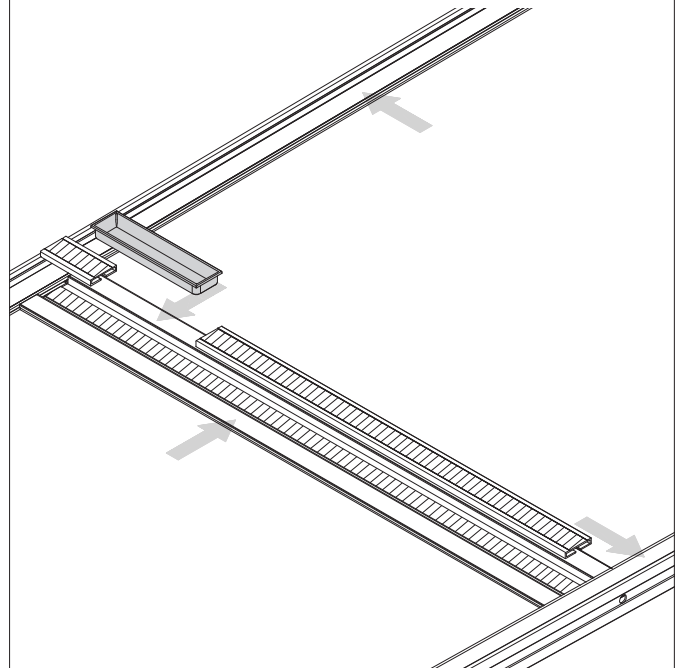
Place the glass panel, insert profile for dividing rail, cover for dividing rail and handle on the frame as a test and if necessary align the frame again.



7\_ Preparation of gluing

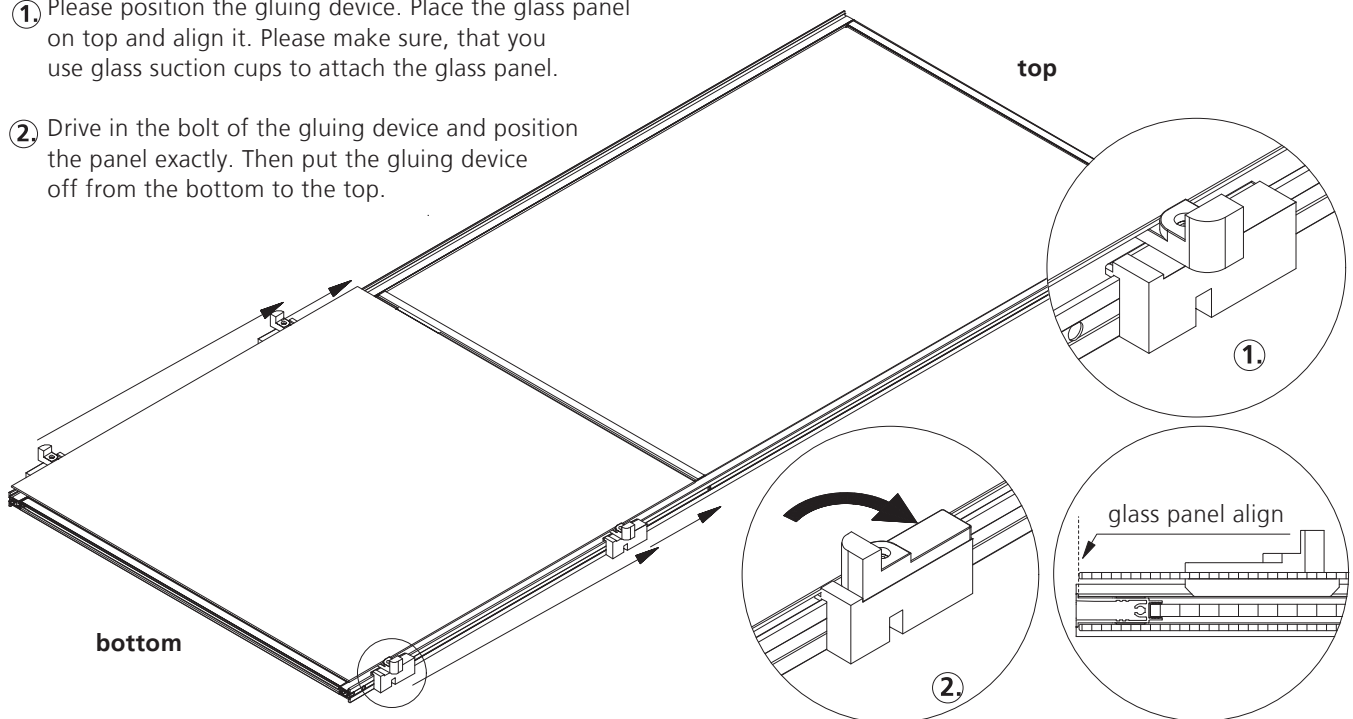
Clean and treat the adhesive surface with primer, before gluing the glass panel. Remove the protective film from the vertical profile, horizontal bottom and top profile and the dividing rail.

**Do not remove** the protective film for **dividing rail, insert profile, cover and handle!**



8\_ Preparation of gluing

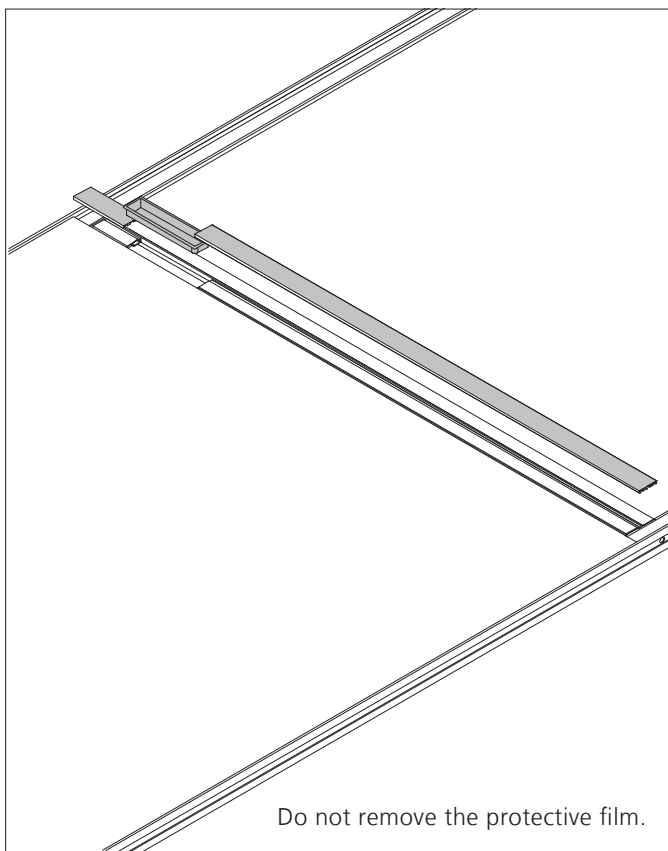
1. Please position the gluing device. Place the glass panel on top and align it. Please make sure, that you use glass suction cups to attach the glass panel.
2. Drive in the bolt of the gluing device and position the panel exactly. Then put the gluing device off from the bottom to the top.



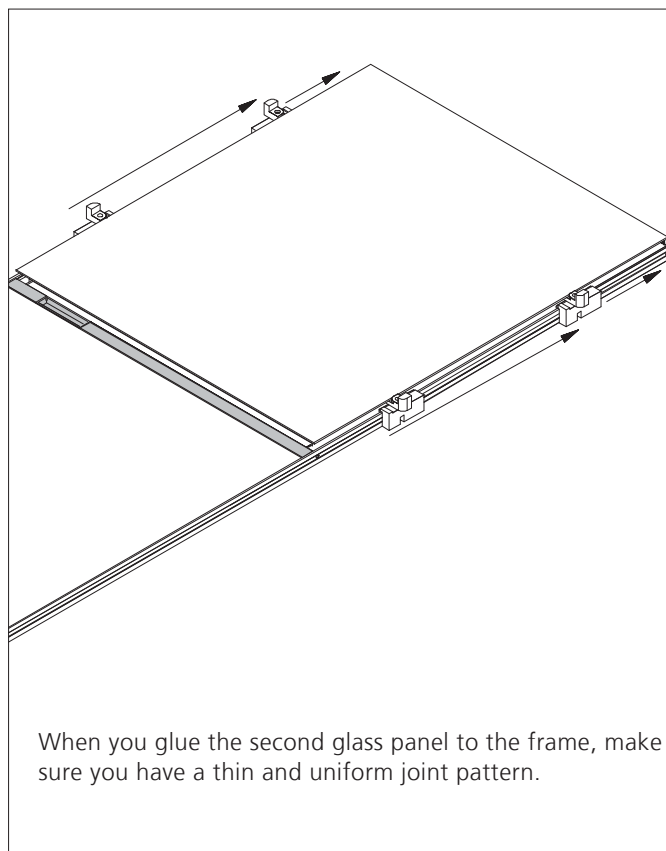
9\_ Perform this workstep by two persons. Precision work is very important!

# ASSEMBLY INSTRUCTIONS

## INSERT DIVIDING RAIL AND HANDLE

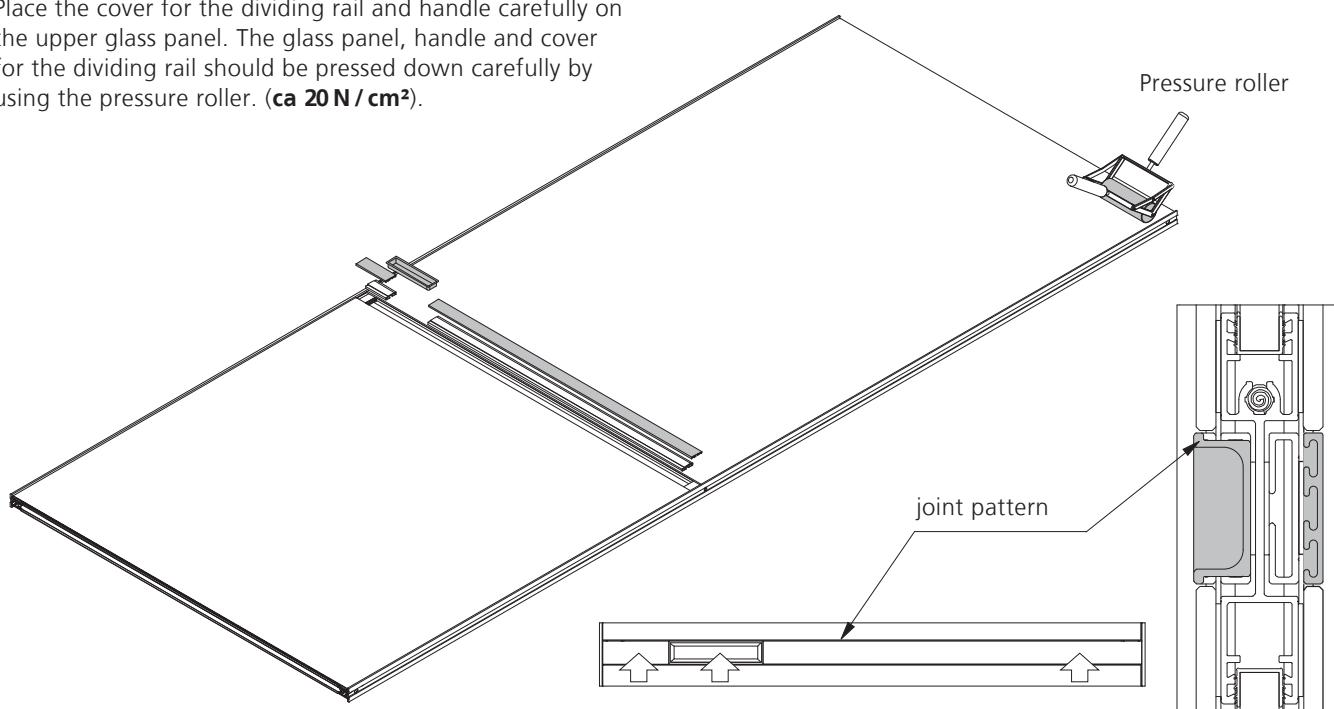


10\_ Insert the insert profile, cover and the handle. Do not glue.



11\_ Glue the second glass panel

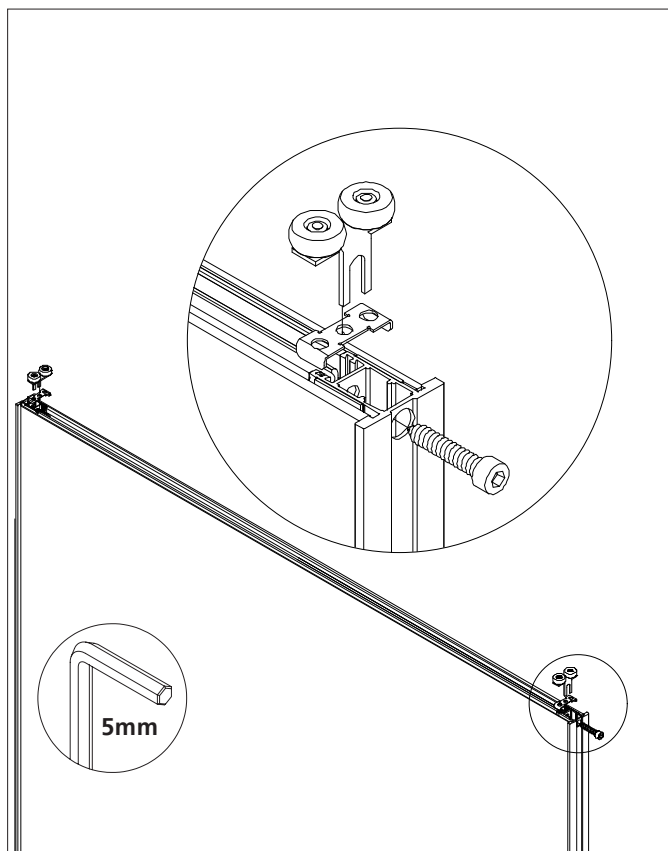
Place the cover for the dividing rail and handle carefully on the upper glass panel. The glass panel, handle and cover for the dividing rail should be pressed down carefully by using the pressure roller. (ca  $20 \text{ N} / \text{cm}^2$ ).



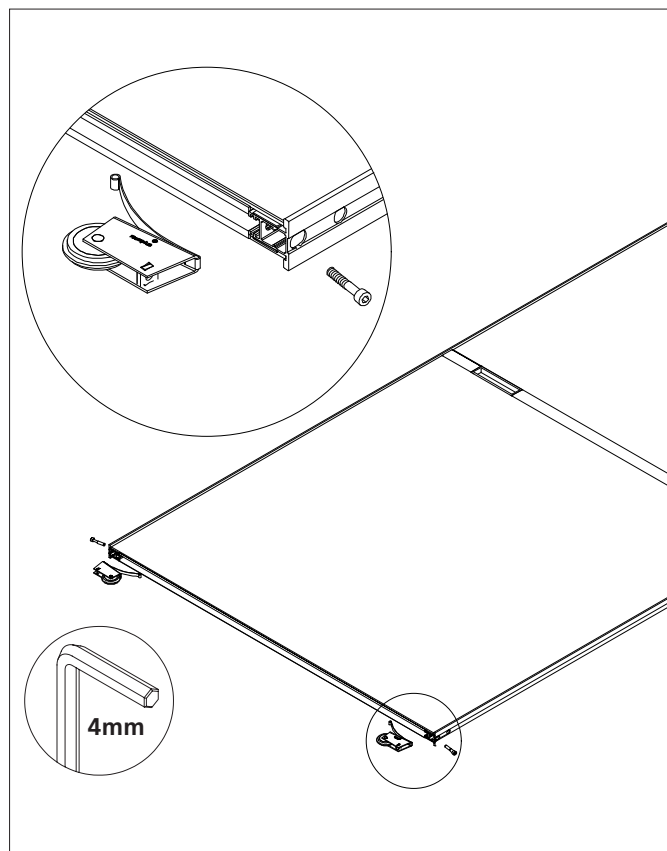
12\_ Use the insert profile for dividing rail, cover for dividing rail and the handle

## ASSEMBLY INSTRUCTIONS

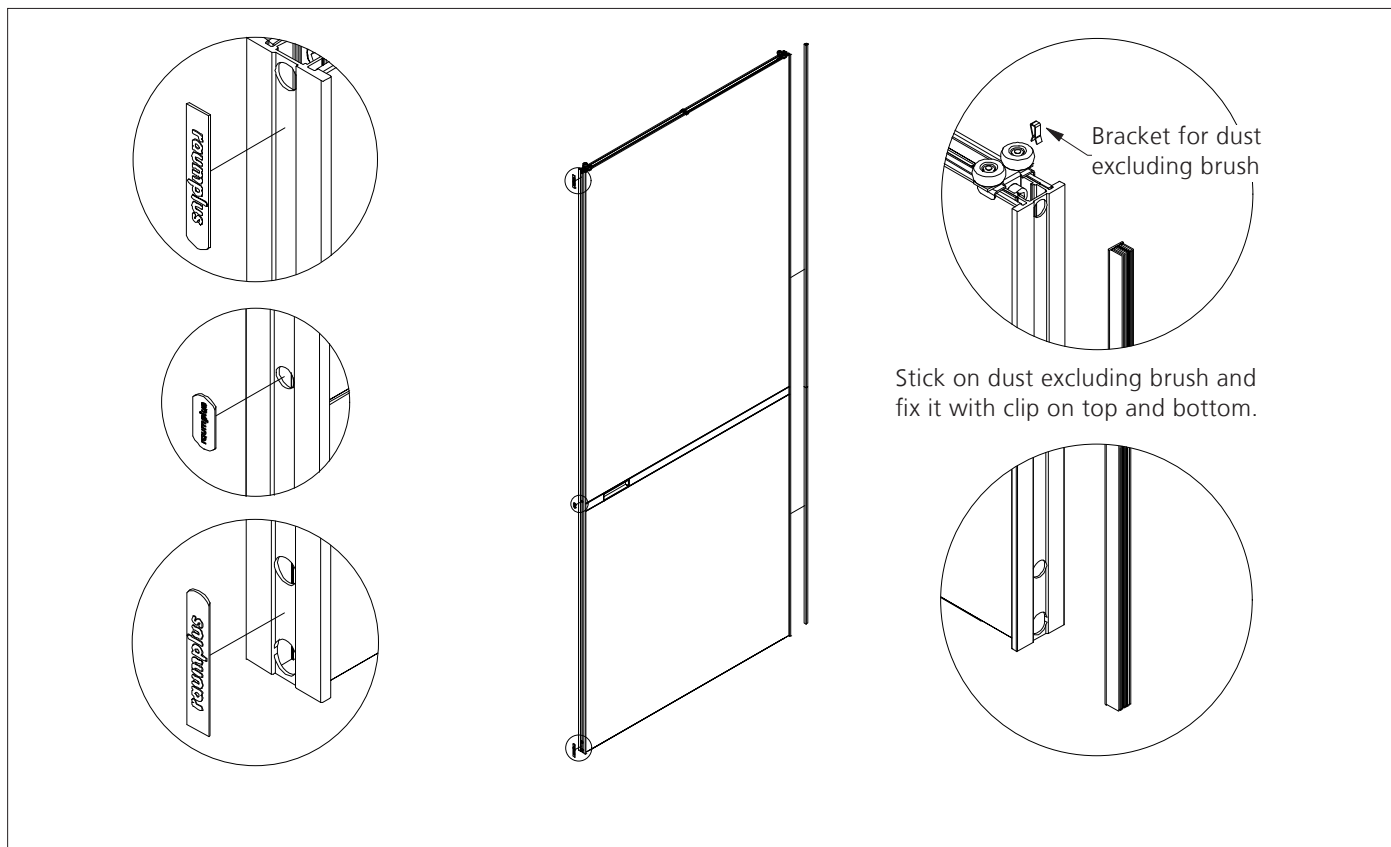
## USE OF THE ROLLERS



**13\_** Insert the top roller / security clips



**14\_** Insert the bottom roller.



**15\_** Stick the plugs for punching holes and / or dust excluding

# ADHESION TECHNIQUE

This instruction applies to the glass and aluminum gluing of the S 800 and the wooden material, glass and aluminum gluing of the S 8000

## General:

For safety reasons the back of the 4 mm glass panels must be covered with an adhesive safety backing (PE).

Please adhere to manufacturers' processing guidelines and safety regulations.

## In order to ensure optimum adhesion you must adhere to the following steps!

The processing temperature must be above 20°C.

1\_Clean the adhesive surfaces using **3 m surface cleaner VBH**. Use a lint-free cloth for this purpose.

**The surfaces must be free of grease, oil or silicon films and dirt.**

2\_Following this, wait approx. five minutes until all cleaner residues have evaporated.

3\_Apply a thin film of **primer** to the adhesive surfaces (profiles and panels).

4\_Following this, wait approx. five minutes until all primer residues have evaporated.

5\_Apply the **tape** bubble-free adhesive tape to the profiles.

Following this use the pressure roller to roll it on firmly (approx. 20 N/cm<sup>2</sup>) and remove the protective film.

6\_Apply to the glass panel and press on firmly.

**Important: Do not touch surfaces which have been cleaned and primed.**

**The panels must be adjusted exactly before beginning the adhesion process.**

**The panel cannot be adjusted after adhesion!**

	<b>end adhesive force (100%)</b> at 20°C after 72 h		<b>adhesive force (50%)</b> at 20°C after 20 min
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7. After adhesion process and pressing of the components, it is advisable to store the element in a lying position until the final adhesive force has been reached.

## GLUING:

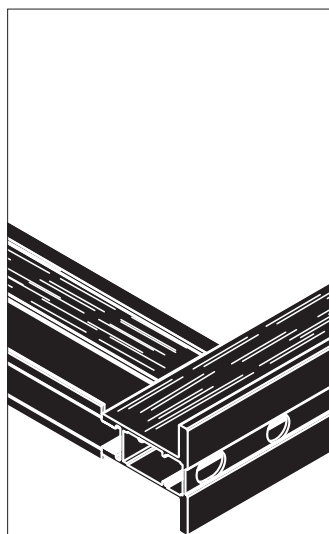
STANDARD		OPTIONAL
<b>tesa®</b>	⇐ <b>System</b> ⇒	<b>3 M™</b>
<b>Cleaner: 3 M - Surface Cleaner VBH</b> ( may be taken for all systems )		
<b>Promoter 60150</b>	⇐ <b>adhesive agent</b> ⇒	<b>Primer 94</b>
<b>ACX plus 7044</b>	⇐ <b>adhesive tape</b> ⇒	<b>4613F VHB™</b>

↓  
for **S 8000** this  
type of gluing is  
**essential!**

We reserve the right to make technical alterations. We recommend one attempt at fixing adhesive products.

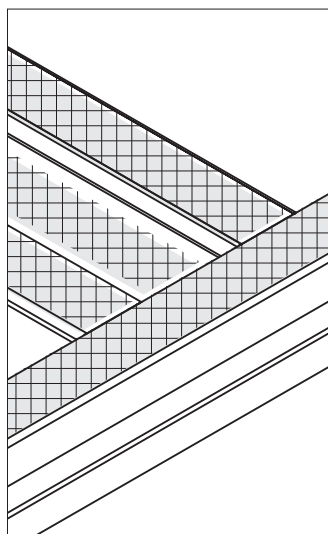
# ADHESION TECHNIQUE

## Preparation of adhesive surface



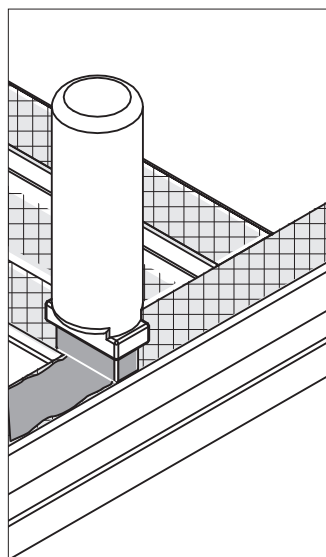
To increase the adhesive force at profiles with the surface: „**black mat**“. It is required to roughen theadherend (surface) with abrasive paper of grain size 100.

1\_ only surface: „**black mat**„



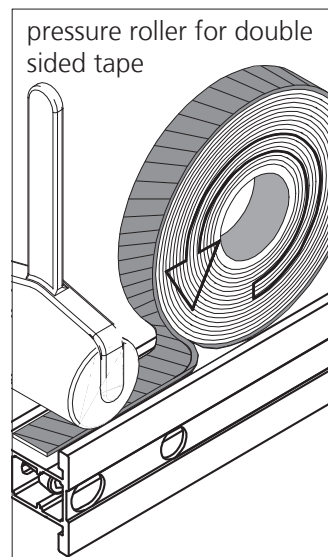
Clean the adhesive surfaces of the profiles and the back of the glass with cleaner. Use lint-free cloths: The surface has to be free of grease, oil or silicone films as well as dirt particles. **Wait approx. five minutes in order to give the solvents time to evaporate.**

2\_ cleaner



Apply a thin layer of primer / promoter to the adhesive surfaces. **Wait approx. five minutes in order to give the solvents time to evaporate.**

3\_ promoter/ primer



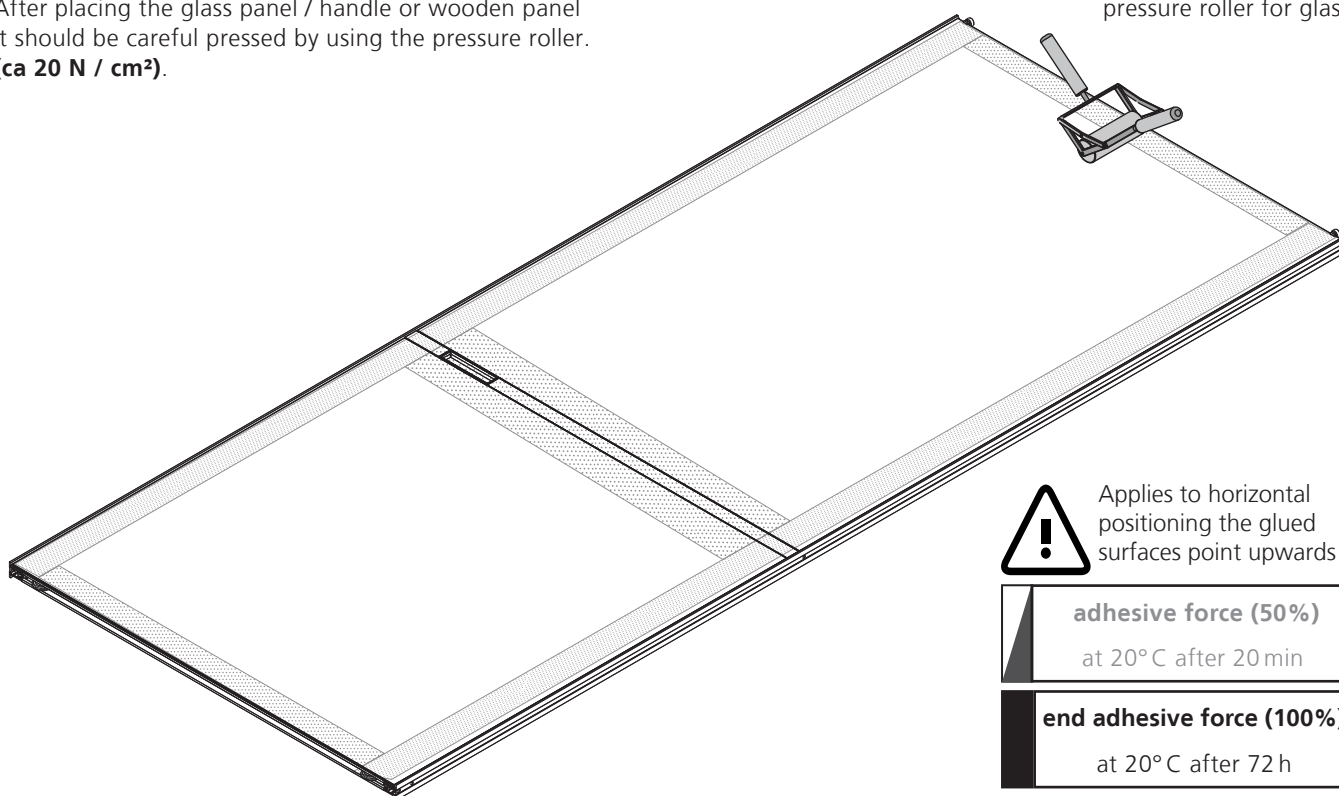
pressure roller for double sided tape

The processing temperature should not be below **20°C** pressure: **ca. 20 N / cm<sup>2</sup>**

4\_ adhesive tape

After placing the glass panel / handle or wooden panel it should be careful pressed by using the pressure roller. (**ca 20 N / cm<sup>2</sup>**).

pressure roller for glass



Applies to horizontal positioning the glued surfaces point upwards

**adhesive force (50%)**

at 20° C after 20 min

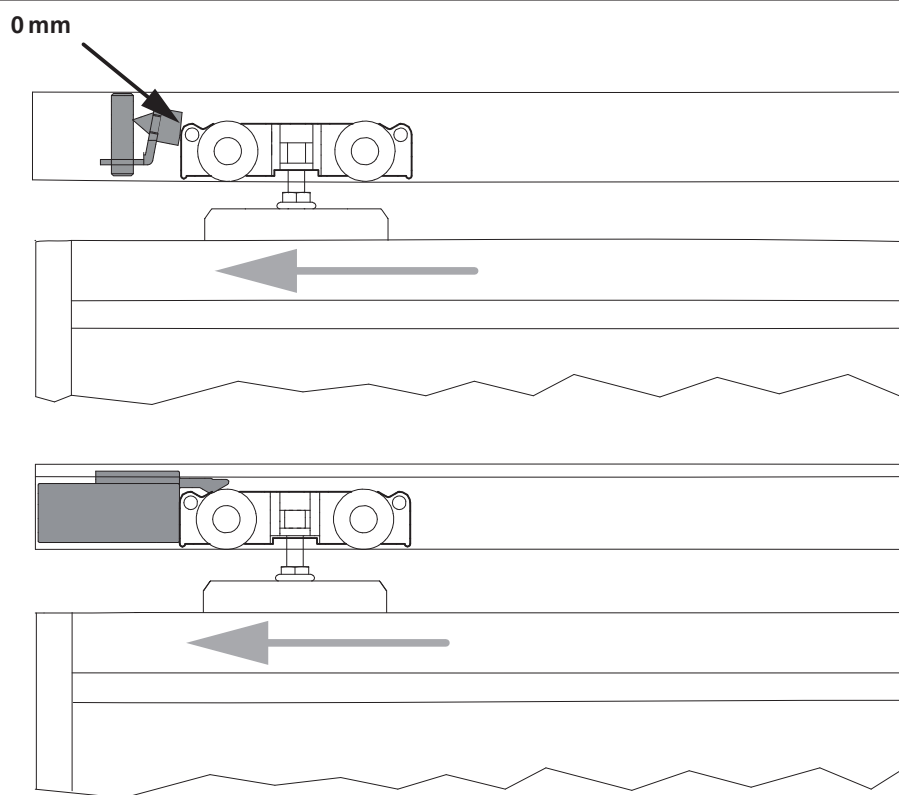
**end adhesive force (100%)**

at 20° C after 72 h

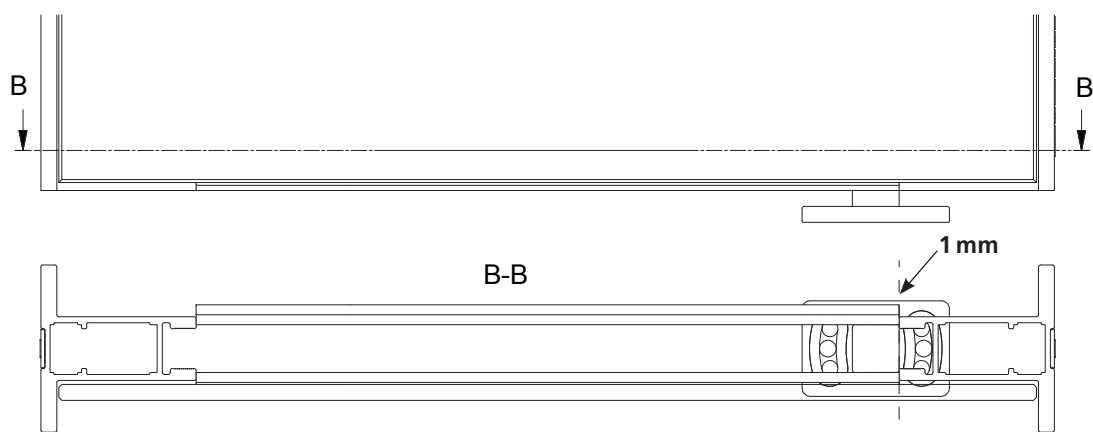
5\_ pressing the joining parts

# DETAIL DRAWING

## STOPPER FOR TOP ROLLER



**i** The door has to be pressed on the stoppoint at the installation.

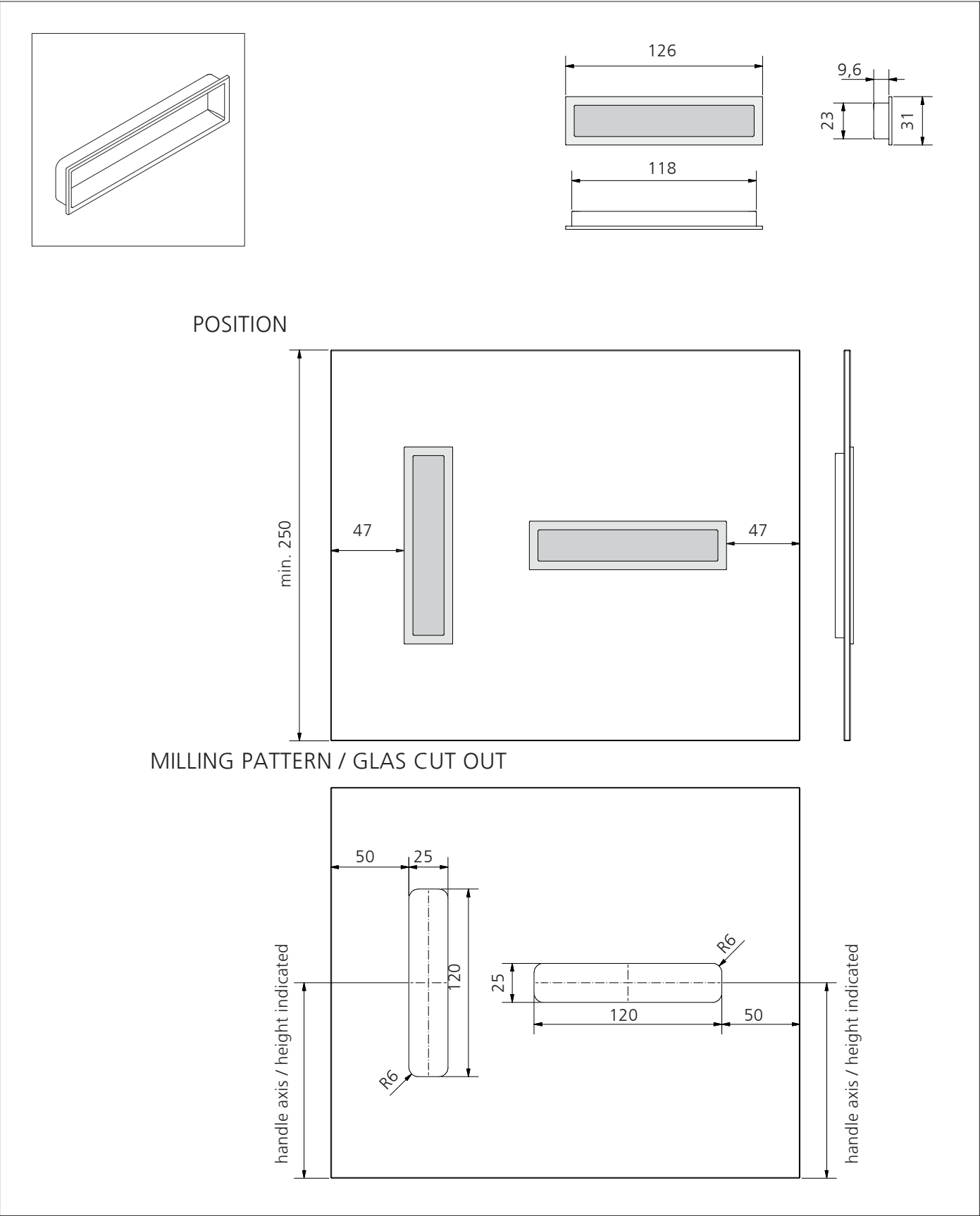


Attention! Risk of damage!

The stopper for top roller inside the top rail are meant to be stoppoint for the door.  
The bottom guiding are not meant to be the stoppoint for the door and always requires some space to the stile to prevent the bottom guiding from being damaged.

# DETAIL DRAWING

POSITION & MILLING PATTERN / HANDLE INSERT S800/S8000/AIR (10.01.29X)



11\_B0721  
Bonding with: „ SIKAFLEX “ construction adhesive.



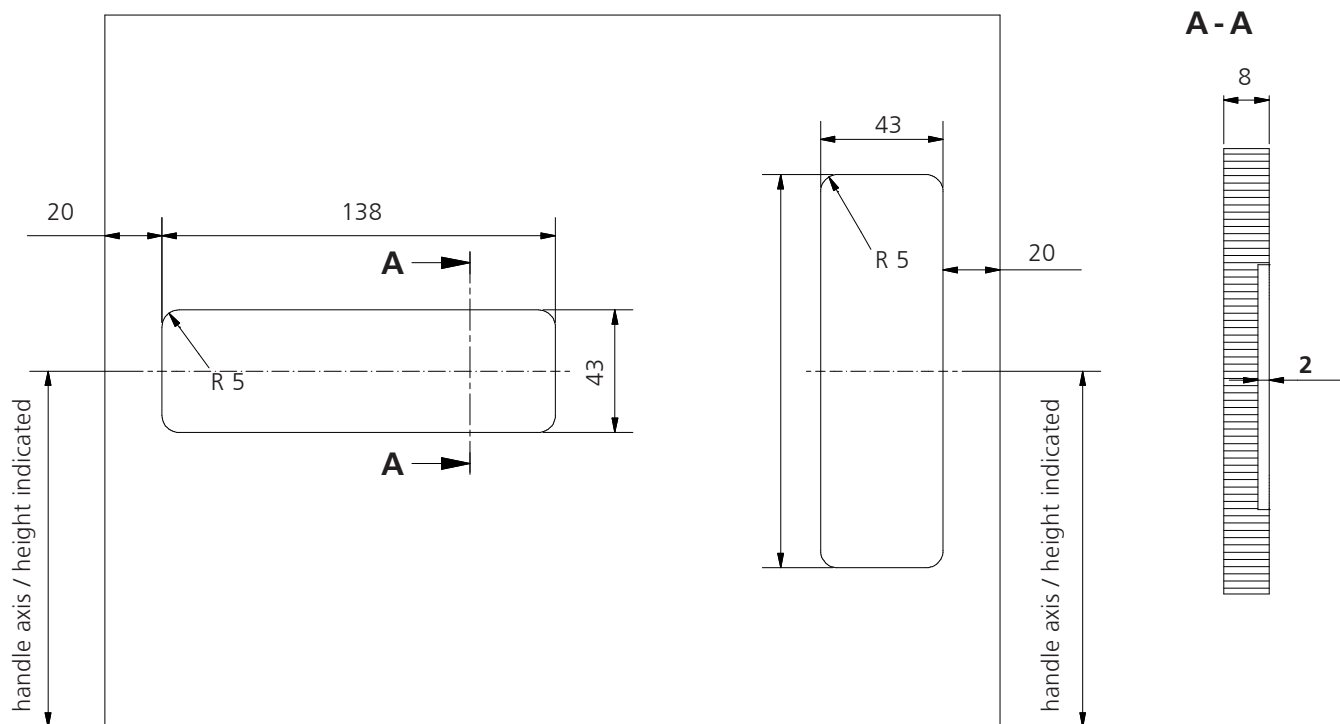
# DETAIL DRAWING

POSITION & MILLING PATTERN/STABILISATION PANEL/ HANDLE INSERT S800/S8000/AIR (10.01.29X)



This illustration refers to simply glass filling of the door.

For this application, the stabilization filling must be milled out!



1\_ XYZ