System 25 Hi/Hi+ Lift and Slide Door

INDEX

Issue Date: 25/07/2022

Specification

System 25 Hi/Hi+
LIFT AND SLIDE DOOR
2T 3T

The Metal Technology System 25Hi+ Lift and Slide Door has been designed to offer the specifier a sliding opener with pleasing sight lines and all the benefits of weather performance, thermal enhancement and security.

Introduction
Metal Technology's high performance System 25 Hi/Hi+ offers a unique thermal solution to sliding doors. By introducing a polyamide thermal barrier across the frame, issues of longitudinal thermal losses, associated with traditional sliding door construction, are addressed. Because the line of the thermal break in the frame changes planes to match the sashes, there is no thermal short circuit. As with all Metal Technology systems, the Lift and Slide Door System has been designed and engineered to exacting standards creating a high performance product, offering slim sight lines and low U values that will deliver many years of trouble-free operation.

Materials
Aluminium profiles are extruded from aluminium alloy 6060T6, T5, or T4 complying with the recommendations of BS EN 12020-2 / BS EN 755-Parts 1 to 9. Polyamide thermal breaks are produced from glass reinforced nylon sections designed to withstand temperatures in excess of 200°C, allowing the sections to be powder coated after thermally breaking.

Finishes
The range of sections can be provided in either of the following range of finishes:
1. Anodised to BS EN ISO 7599 or BS 3987
2. Powder organic coated to BS EN 12206-1
The system 25 Hi/Hi+ Lift and Slide Door can accommodate a different colour/finish internally to that used externally.

Construction
Frame members are mitre cut at 45°, corners are reinforced with corner braces and mechanical cleats. All frame joints are sealed during construction against entry of water.

Glazing
The system can accommodate up to 55mm glazing units. Glass is set against a captive gasket in the sash frame with a co-extruded wedge fitted internally. Special bridging setting / location blocks are provided to fit into the sections.

Installation
Detailed installation instructions are provided within this manual which should be strictly followed.

Lift and Slide Door Fittings
The sections are designed to suit Lift and Slide fittings. Metal Technology is able to supply a full range of fittings and accessories. See the relevant section of this manual for details of gearing options for specific door sizes.

Metal Technology should be contacted for any special operating requirements.

Size Limits

	Door sash width	Door sash height
Maximum	2100	2800
Minimum	800	950

Maximum door sash weight is 200 Kg.

For complete details of maximum/ minimum sizes and weight restrictions see the size limitation chart in section 3 of this manual.

Performance
Metal Technology's lift and slide door provides high levels of air and water resistance by the use of compression gaskets, and an innovative integral drainage system. Air infiltration is minimized by the same components that provide water resistance.

The Lift and Slide system has been designed to achieve:
Air permeability - BS 6375
test pressure 600 Pa.
Watertightness - BS 6375
test pressure 600 Pa.
Wind resistance - BS 6375
test pressure 2400 Pa.
These levels of performance should be sufficient for any location within the UK and Ireland. However should higher levels of performance be required for any reason Metal Technology's advice should be sought.
Cycle testing to BS EN 1191, 50,000 cycles

Security
System 25 Hi/Hi+ Door with applicable ironmongery has been tested to the relevant standards as generally accepted on Secure by Design projects. To conform, the door must be in accordance with the samples tested, with ironmongery options as detailed in section 3 of this manual.

In order to comply with PAS 24, doorsets should be glazed in accordance with the methods in BS 6262 and BS 8000-7.
The units should also be sealed conforming to BS EN 1279 and incorporating glass conforming to BS EN 356 Class P1A minimum.

Security products should be labelled by the fabricator in accordance with BS 4873.

Development
Our policy is to continually research the market for new and improved products. We must therefore retain the right to amend specifications without prior notice. It is recognised at Metal Technology that in some instances special sections may be required for particular projects. When this occurs it may be possible to produce special sections subject to there being sufficient quantity and adequate time.

Specification

Thermal Performance

Metal Technology's THERMAL range, in conjunction with the correct glass specification, is designed to aid compliance with the latest thermal requirements of the current building regulations.

The polyamide thermal break profiles have been specifically designed to minimise heat transfer across the door profiles. This innovative and advanced thermal break technology provides the basis of the 25Hi+ system.

Thermal performance is further improved through the introduction of specially designed foam profiles. These reduce radiation heat loss across the air cavities within the door profiles to provide additional thermal enhancement.

The 25Hi+ system offers significantly improved U-frame values over more traditional thermally broken aluminium door systems.

	U-frame values	
	25Hi	25Hi+
Double Track Lift and Slide door perimeter	2.86W / m²K	2.45W / m²K
Double Track door interlock	3.68W / m²K	2.67W / m²K
Triple Glazed Lift and Slide door perimeter	3.47W / m²K	2.69W / m²K
Triple Glazed Lift and Slide door interlock	3.99W / m²K	2.97W / m²K
Triple Track Lift and Slide door perimeter	3.04W / m²K	2.48W / m²K
Triple Track Lift and Slide door interlock	3.68W / m²K	2.67W / m²K

The following table, based on a standard double track door in accordance with BS EN 14351 (2000mm x 2180mm) and warm edge spacers, demonstrates how such improved U-frame values then contribute to improving the overall thermal performance of a complete door.

Achievable whole window U-values	Centre pane U-value	
	1.0W/m²K	0.5W/m²K
System 25Hi Lift and Slide door	1.63W / m²K	1.26W / m²K
System 25Hi+ Lift and Slide door	1.49W / m²K	1.11W / m²K

The following table, based on a triple track door (3000mm x 2180mm) and warm edge spacers, demonstrates how such improved U-frame values then contribute to improving the overall thermal performance of a complete door.

Achievable whole window U-values	Centre pane U-value
	1.0W/m²K
System 25Hi Lift and Slide door	1.65W / m²K
System 25Hi+ Lift and Slide door	1.48W / m²K

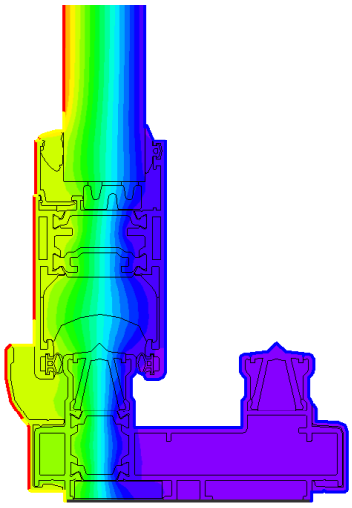
Metal Technology can provide tailored U-value calculations using their dedicated estimating software to calculate overall project average door U-values for their full range of systems.

Door Energy Rating

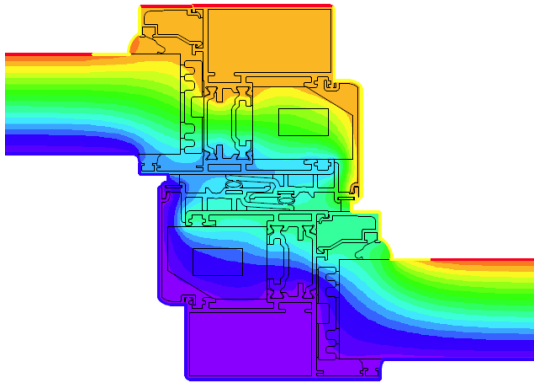
Metal Technology's 25Hi+ System has been assessed by an approved simulator in accordance with the BFRC's guidelines, using their official Door Energy Rating software, and has been proven to be capable of achieving a 'B' rating.

EWER Rating Scale	Door Rating
A+	B
A	
B	
C	
D	
E	
F	

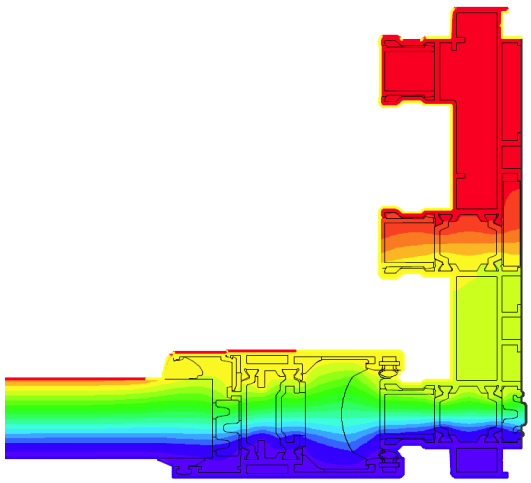
25Hi+ Lift and Slide Double Glazed Door Perimeter



25Hi+ Triple Glazed Lift and Slide Door Interlock



25Hi+ Triple Track Lift and Slide Door Perimeter

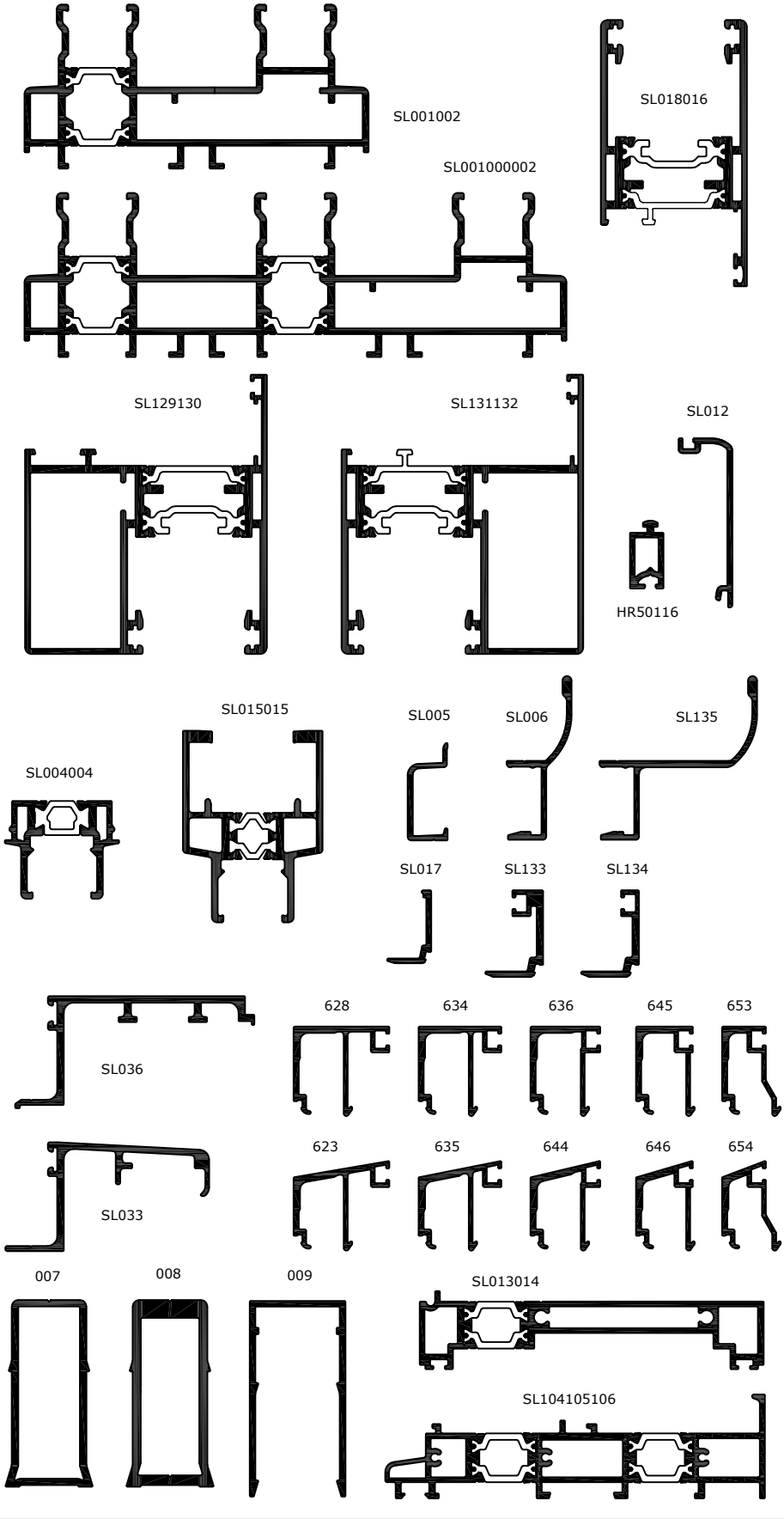


Profile Index

System 25 Hi/Hi+

LIFT AND SLIDE DOOR

2T 3T

PROFILE ILLUSTRATION	SHEET REF NUMBER	COMPUTER REF NUMBER	PERIMETER mm
	25Hi+/1/30	007	166
	25Hi+/1/30	008	166
	25Hi+/1/30	009	302
	25Hi+/1/40	623	182
	25Hi+/1/40	628	196
	25Hi+/1/40	634	188
	25Hi+/1/40	635	175
	25Hi+/1/40	636	169
	25Hi+/1/40	644	159
	25Hi+/1/40	645	160
	25Hi+/1/40	646	149
	25Hi+/1/40	653	154
	25Hi+/1/40	654	143
	25Hi+/1/40	HR50116	78
	25Hi+/1/11	SL000 SL001 SL002	355 162 421
	25Hi+/1/10	SL001 SL002	162 421
	25Hi+/1/20	SL004 SL004	95 95
	25Hi+/1/20	SL005	104
	25Hi+/1/10	SL006	151
	25Hi+/1/20	SL012	156
	25Hi+/1/30	SL013 SL014	111 231
	25Hi+/1/20	SL015 SL015	192 192
	25Hi+/1/40	SL017	74
	25Hi+/1/10	SL018 SL016	263 209
	25Hi+/1/20	SL033	253
	25Hi+/1/11	SL036	275
	25Hi+/1/30	SL104 SL105 SL106	137 182 149
	25Hi+/1/15	SL129 SL130	278 285
	25Hi+/1/15	SL131 SL132	337 210
	25Hi+/1/40	SL133	120
	25Hi+/1/40	SL134	107
	25Hi+/1/15	SL135	208

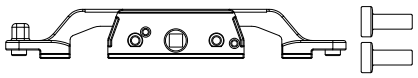
Scale 1:2

Component Identification

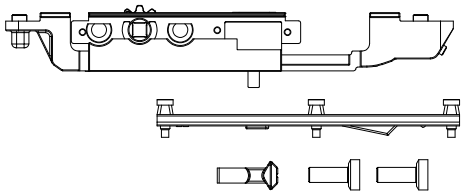
System 25 Hi/Hi+

LIFT AND SLIDE DOOR

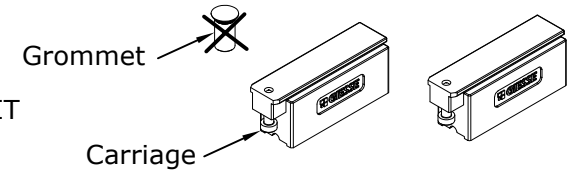
2T 3T



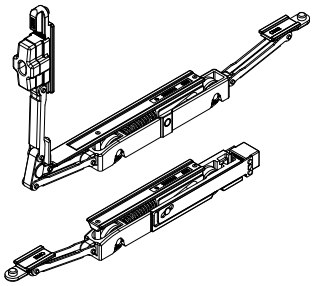
SL054
SPINDLE DRIVE KIT



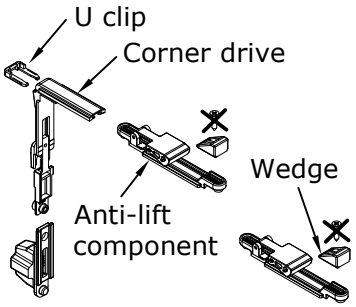
SL053
SPINDLE DRIVE KIT WITH INTEGRAL CAM AND KEEP



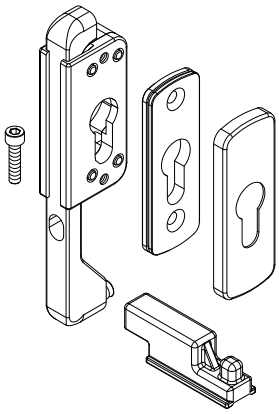
SL065 *
FIXED SASH KIT



SL050A *
LIFT AND SLIDE MECHANISM

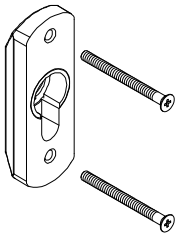


SL060
ANTI-LIFT KIT



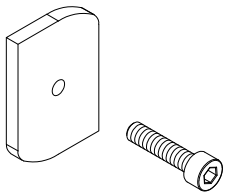
SL063C *
LOCKING MECHANISM WITH CYLINDER ESCUTCHEON

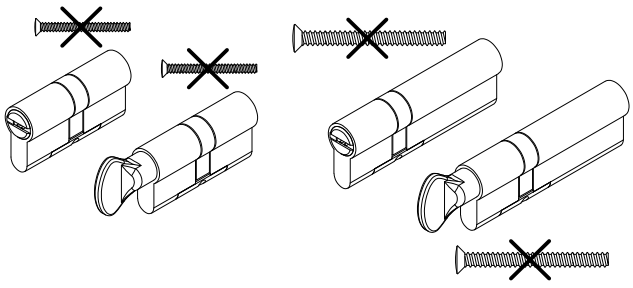
SL089
PACKER FOR EXTERNAL CYLINDER COVER



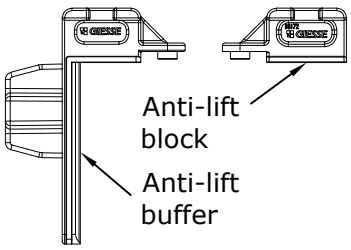
SL062 *
EXTERNAL CYLINDER COVER

SL056 *
CENTRAL PROFILE FIXING PLATE





SL077 STANDARD CYLINDER
SL156 THUMBTURN CYLINDER
SL157 EXTENDED CYLINDER
SL158 EXTENDED THUMBTURN CYLINDER

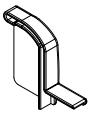


SL067
SINGLE SHOCK ABSORBER AND LIFT PROOF KIT

SL069
DRAINAGE CHANNEL END CAPS

SL151A
DRAINAGE CHANNEL END CAP

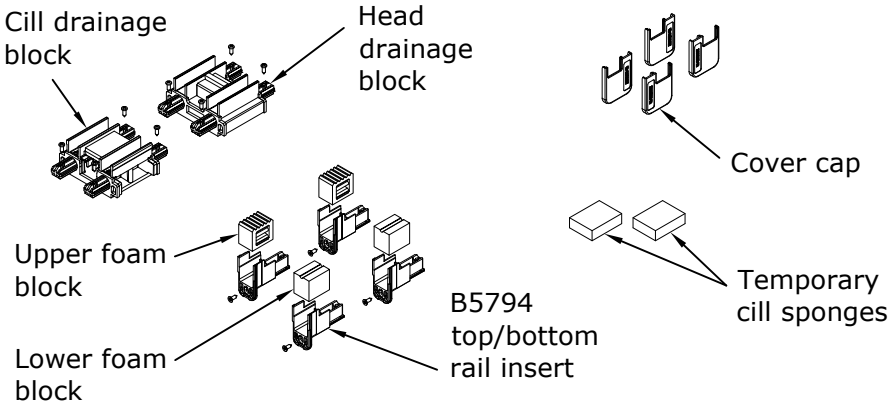
SL151B
DRAINAGE CHANNEL END CAP



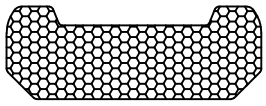
***** Denotes screws included with component

Not to scale

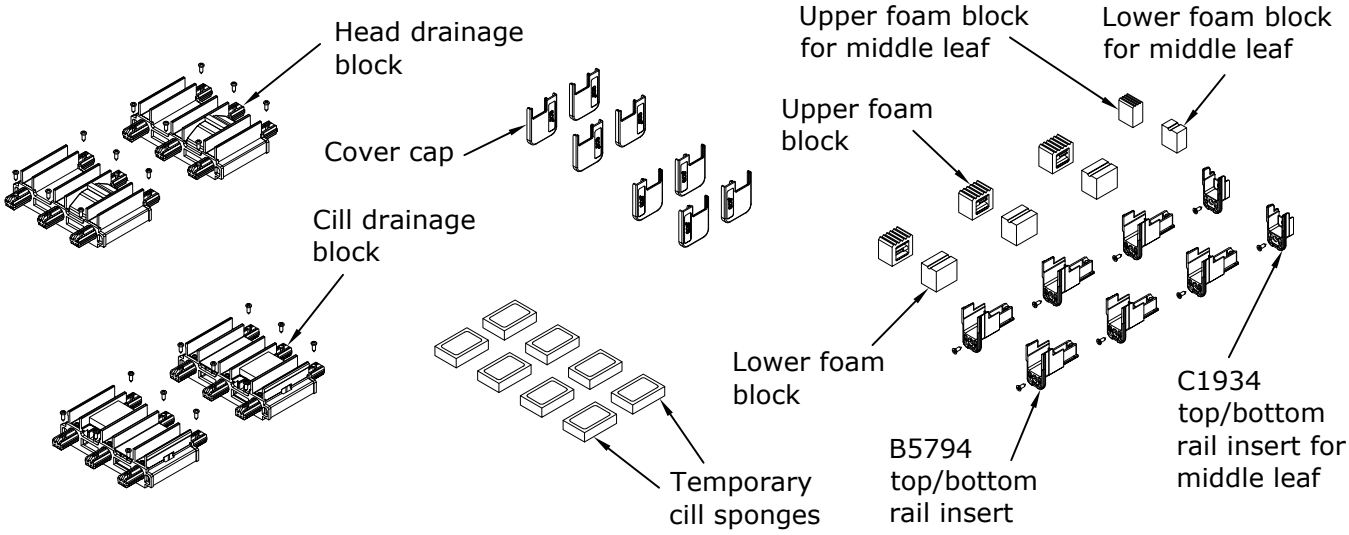
Component Identification



SL058A *
INTERLOCK KIT - DOUBLE TRACK LIFT AND SLIDE



6728
THERMAL
FOAM INSERT



SL155 *
INTERLOCK KIT - TRIPLE TRACK LIFT AND SLIDE

***** Denotes screws included with component

Not to scale

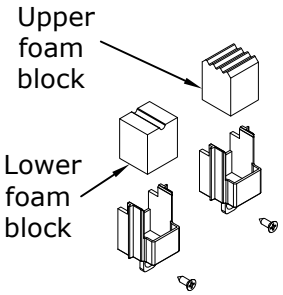
Component Identification

System 25 Hi/Hi+

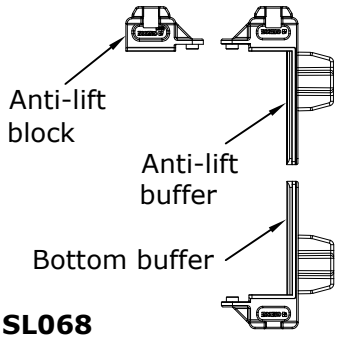
LIFT AND SLIDE DOOR

2T 3T

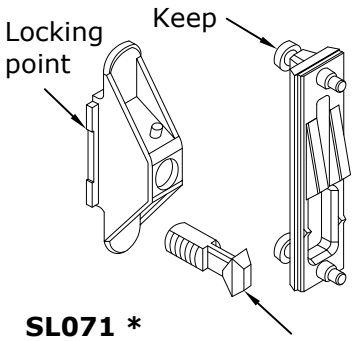
Items printed in blue are required in security applications only.



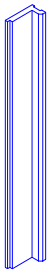
SL055 *
SASH PLUG KIT



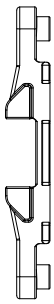
SL068
DOUBLE SHOCK ABSORBER AND LIFT PROOF KIT



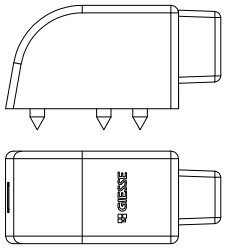
SL071 *
LOCKING KIT



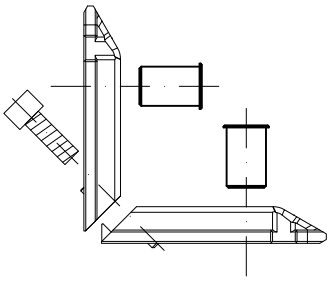
SL079
SECURITY REINFORCEMENT



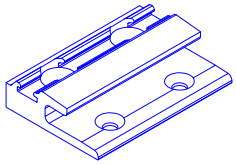
SL075
FIXED SASH ROD DRIVE



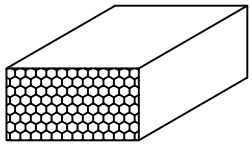
SL082 *
DOOR STOP



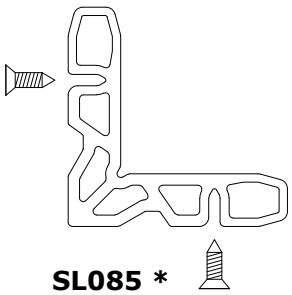
SL084 *
SASH CLEAT



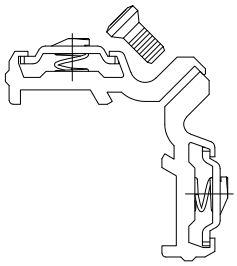
SL076
SECURITY INTERLOCK (BLACK ANODISED)



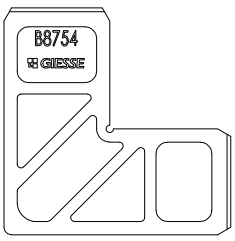
CW32
OUTER FRAME TRIM END SEAL



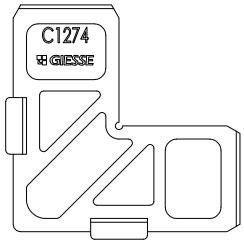
SL085 *
FRAME ALIGNMENT CLEAT



SL086 *
FRAME CLEAT

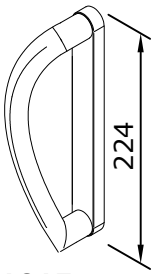


SL087
CORNER ALIGNMENT CHEVRON

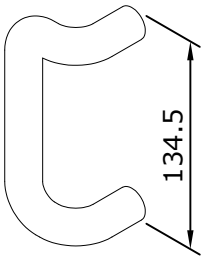


SL088
CORNER SASH GUIDE CHEVRON

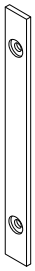
SL150 - Cut @ 27.35
CORNER CLEAT



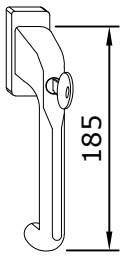
SL101E
PULL HANDLE (SILVER PAINT FINISH)



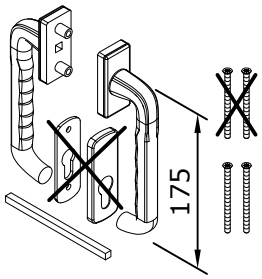
SL102A
PULL HANDLE (HARDEX SATIN FINISH)



SL103A
PULL HANDLE FIXING PLATE



SL051
SL072
LOCKING HANDLE (SILVER CHROME FINISH)



TTGEAR615 *
LEVER HANDLE SET (SATIN PAINTED FINISH)

* Denotes screws included with component

Not to scale

Component Identification

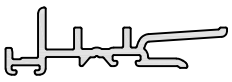
System 25 Hi/Hi+

LIFT AND SLIDE DOOR

2T 3T

Item printed in blue is required in security applications only.

SL020
HEAD AND
JAMB CLOSER



SL021
MEETING STILE
LOCKING PIECE

SL022
CILL CLOSER

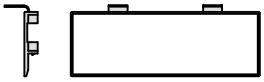
SL023
LINK ROD
(Unit = 200 metre roll)

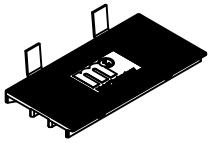
Made to measure link rod kits can be supplied under the following codes:

	Internal handle SL051 or SL072	Internal and external handles TTGEAR615	Security
Double track 2-pane	SL041A	SL125B	SL113B
Double track 3-pane	SL043A	SL126B	-
Double track 4-pane	SL045A	SL127B	-
Triple track 3-pane	SL162	SL163	SL166

SL049
GLAZING SUPPORT

745
GLAZING SUPPORT





6745
GLAZING SUPPORT BLOCK
(28mm to 47mm glazing)

6748
GLAZING SUPPORT BLOCK
(48mm to 55mm glazing)

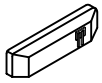
WEDGES

CA26		Orange
CA27		White
CA29		Black
066		Grey
PTT36		Red

CAPTIVE GASKETS

CA25		Red
CA25A		Black
PCD82		Black
6080		Purple
6081		Black

SL099
FOAM FILLER



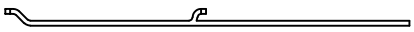
7434
DRAINAGE CAP

SL037
BUBBLE GASKET

SL035
WOOLPILE

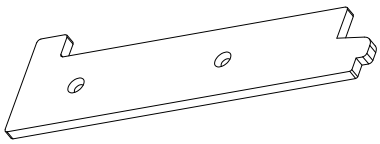
VS118A
WOOLPILE

SL047 STANDARD



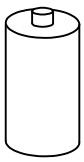
SL048 EXTENDED

FIXING LUGS (Galvanised steel)



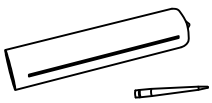
SL107
THERMAL END CAP FOR SL104105106 CILL
(Black, Unit=Pair)

MT1803
2-PART ADHESIVE
(grey, white)



MT60
SURFACE CLEANER

7400A
GASKET SPRAY



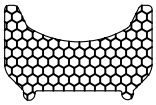
HR50328A
BLACK GASKET
ADHESIVE/SEALANT

Not to scale

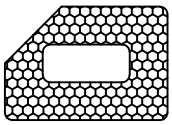
Component Identification

COMPONENTS REQUIRED FOR 25Hi+ VARIATION ONLY

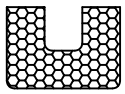
SL091
SELF-ADHESIVE OUTER FRAME FOAM



SL092
SASH THERMAL FOAM

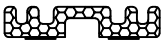


SL098
SASH MEETING RAIL FOAM



SL097
SASH HEAD FOAM

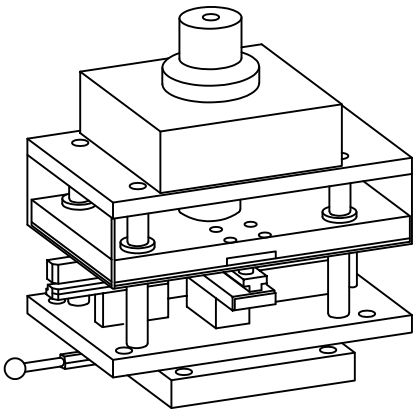
6743
SELF ADHESIVE THERMAL D.G.U. FOAM



6727
GLAZING UNIT PERIMETER FOAM

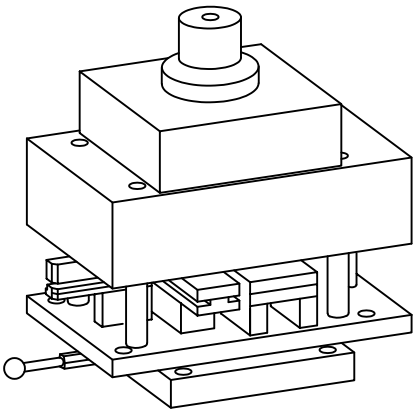
Not to scale

Component Identification

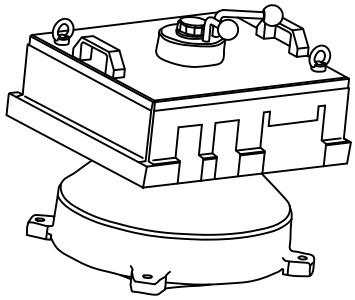


JIG25001-2
DOUBLE TRACK OUTER FRAME AND HEAD/CILL COVER PUNCH

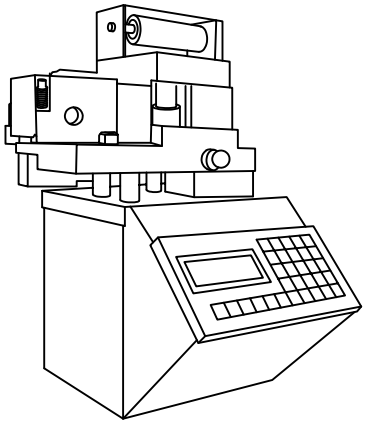
JIG25001-3
DOUBLE AND TRIPLE TRACK OUTER FRAME AND HEAD/CILL COVER PUNCH



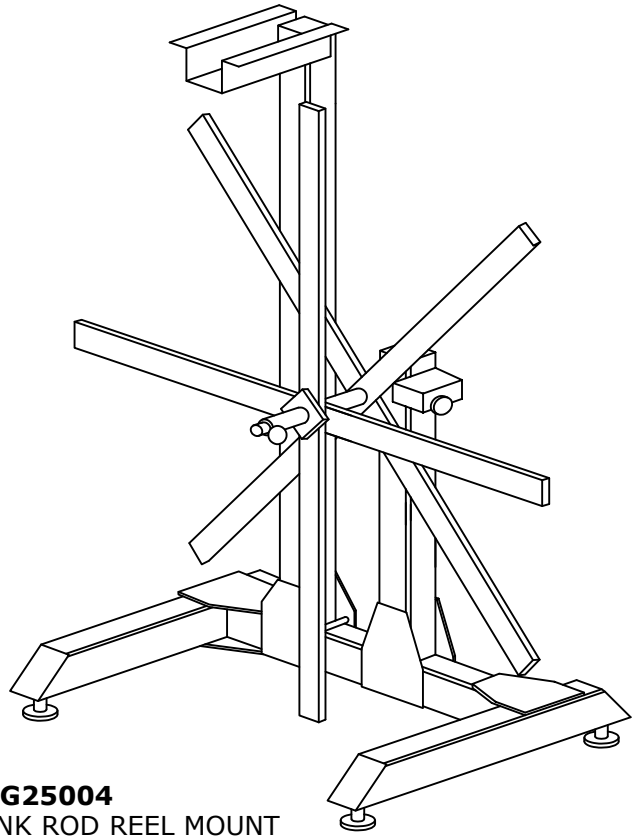
JIG25002
DOOR SASH FRAME AND COVER FOR INTERLOCK PUNCH



1A373900
TRIPLE GLAZE SASH PUNCH TOOL

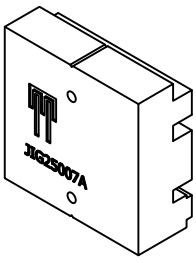


JIG25003
LINK ROD PREP AND CUTTING MACHINE

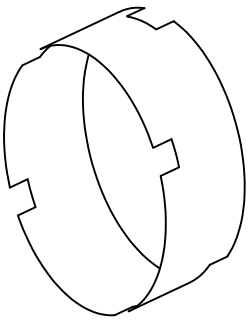


JIG25004
LINK ROD REEL MOUNT

JIG25006
SUPPORT MACHINE / STAND



JIG25007A
JAMB EXTENSION JIG



JIG25005
LINK ROD REEL ADAPTOR

Not to scale

Component Identification

7204
No 8 x 16mm countersunk self tap screw

7209
M5 countersunk aluminium rivnut

7210
M5 x 25mm countersunk machine screw

7211
M5 x 30mm countersunk machine screw

7216
No 10 x 13mm socket head self tap screw

7218
No 10 x 45mm pan head self tap screw

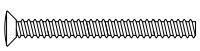
7231
No 8 x 19mm countersunk self tap screw

7234
No 10 x 19mm countersunk self tap screw

7235
No 8 x 38mm pan head self tap screw

7248
No 10 x 38mm countersunk self tap screw

7260
M6 x 14 x 1.6mm washer



7272
M5 x 50mm countersunk machine screw

7275
No 8 x 32mm countersunk self tap screw

7276
No 8 x 45mm countersunk self tap screw

7287
No 8 x 60mm countersunk self tap screw

7292
No 4 x 9.5mm countersunk head self tap screw

7295
M5 x 8mm hex head machine screw

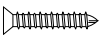
7301
M4 x 20mm pan head machine screw

7305
No 8 x 16mm pan head self drill screw

BF126
M6 x 90mm countersunk machine screw

LV038
Aluminium pop rivet

SL039
No 8 x 3/8" countersunk truncated type B screw



SL108
No 7 x 25mm countersunk hi lo self drill screw

SL121
No 10 x 9.5mm countersunk truncated type B screw

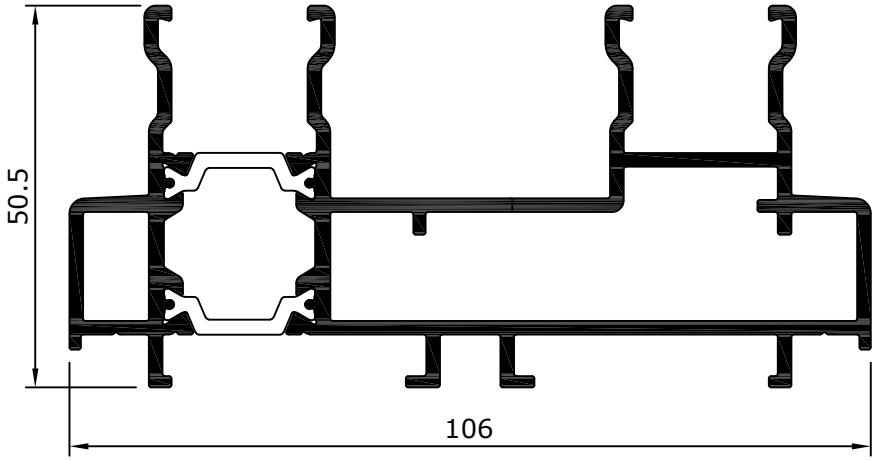
SL152
M5 x 60mm countersunk machine screw

SL159
M5 x 16mm hex head machine screw

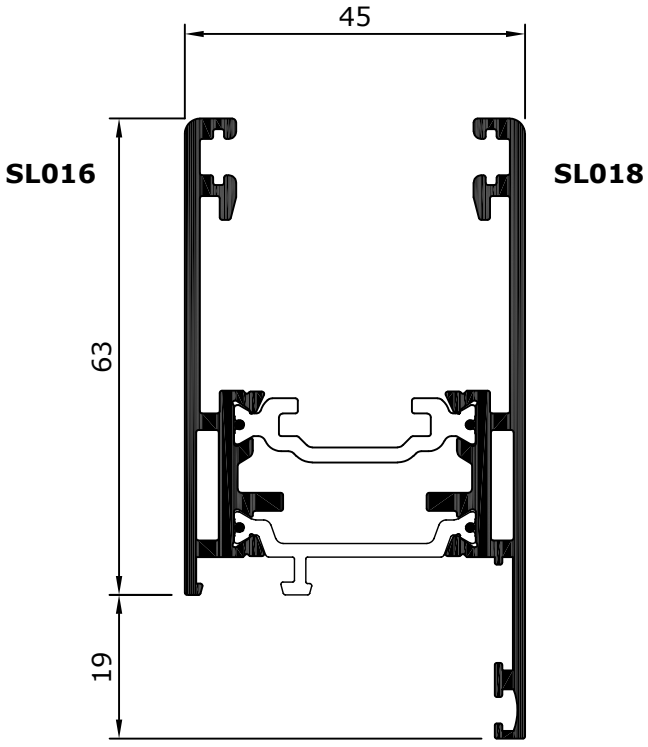
Not to scale

Section Drawings

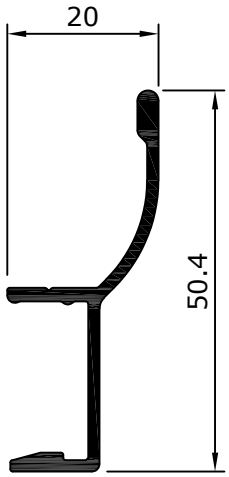
SL001 **SL002**



SL001002
OUTER FRAME



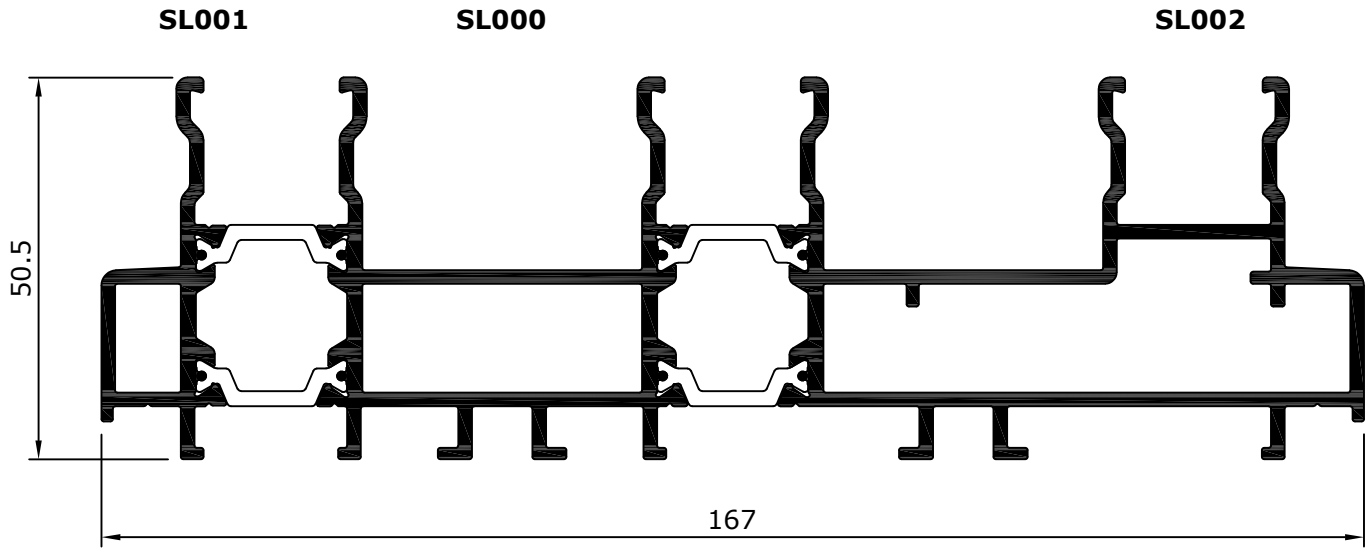
SL018016
BEADED DOOR SASH FRAME



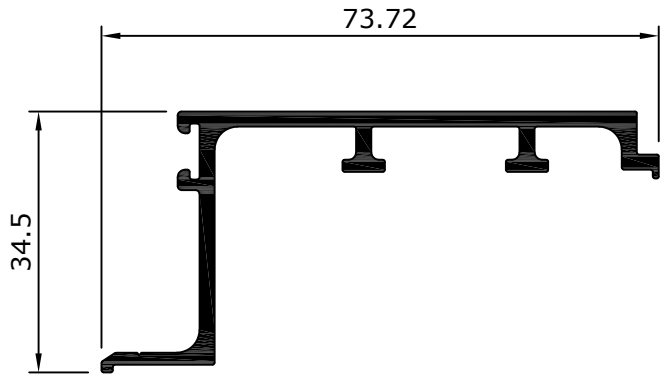
SL006
HEAD/CILL EXTENDED COVER

Scale 1:1

Section Drawings



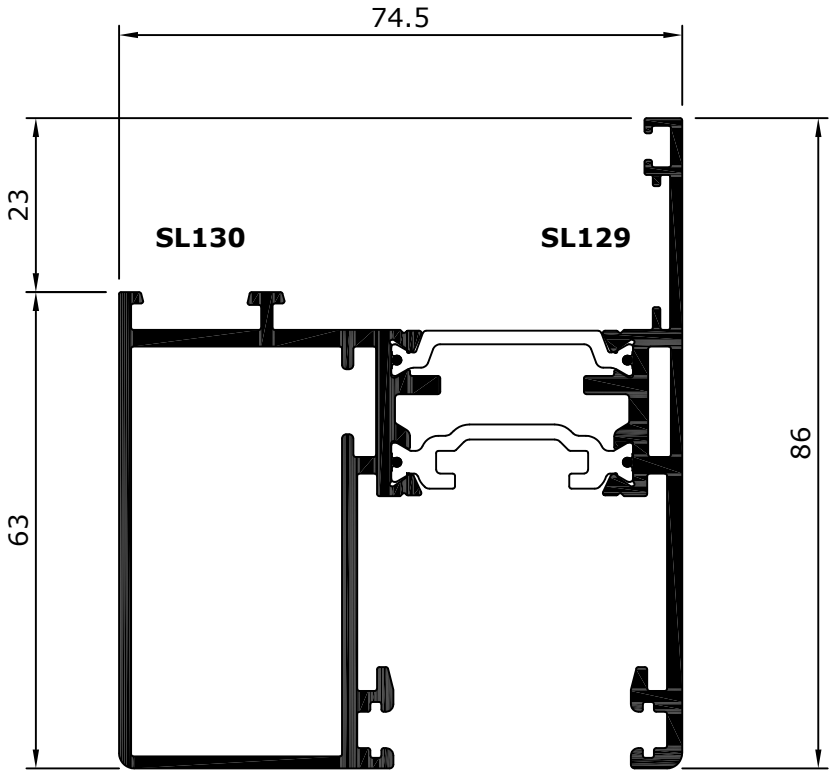
SL001000002
TRIPLE TRACK OUTER FRAME



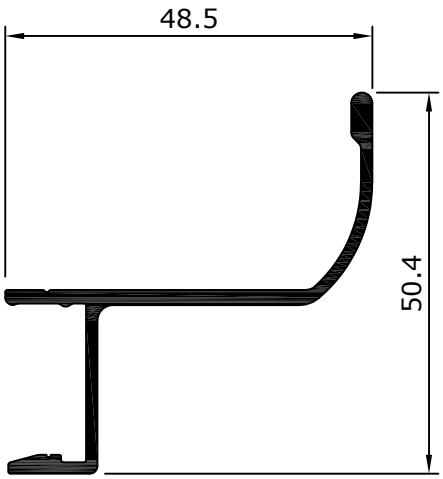
SL036
TRIPLE TRACK INFILL

Scale 1:1

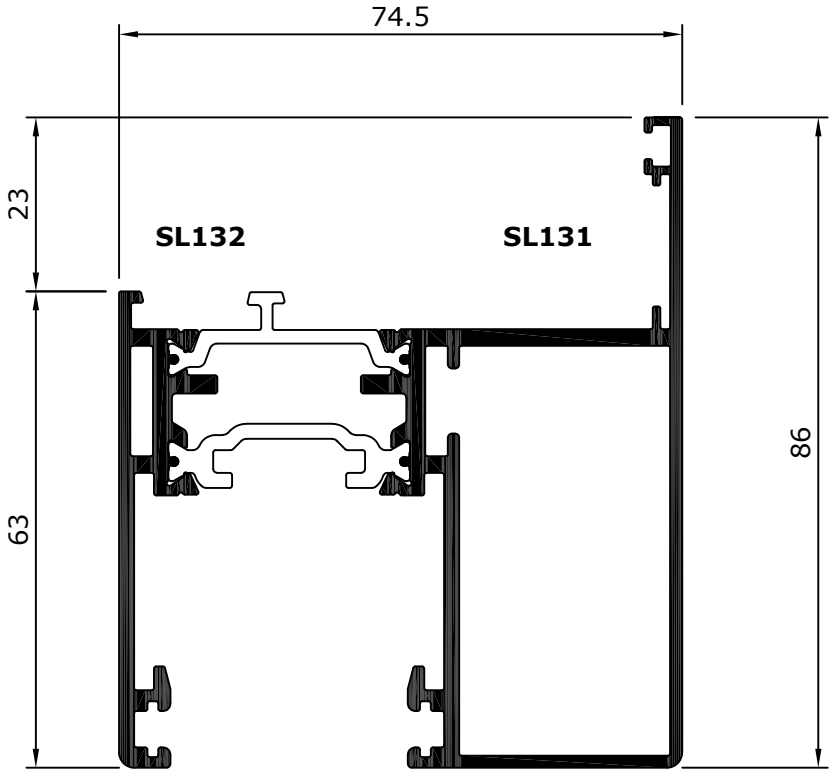
Section Drawings



SL129130
INTERNAL TRACK BEADED
DOOR SASH FRAME



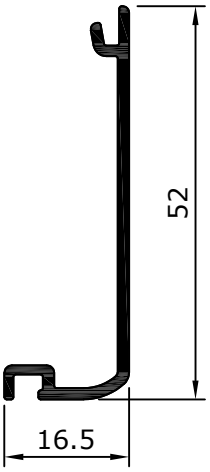
SL135
HEAD/CILL EXTENDED COVER



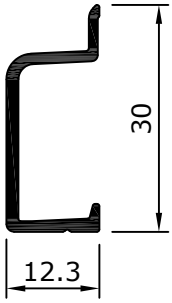
SL131132
EXTERNAL TRACK BEADED
DOOR SASH FRAME

Scale 1:1

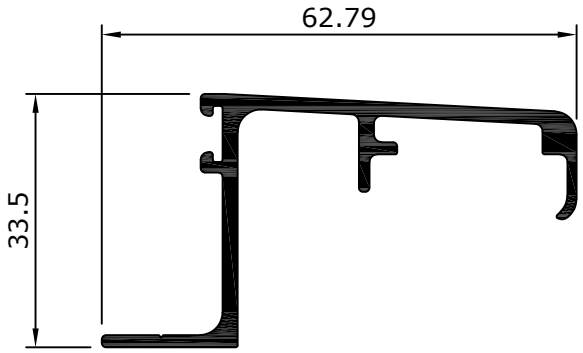
Section Drawings



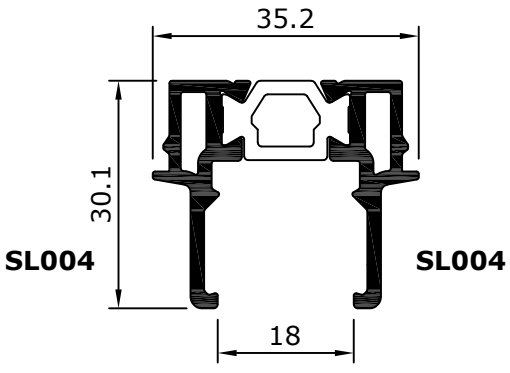
SL012
COVER FOR INTERLOCK



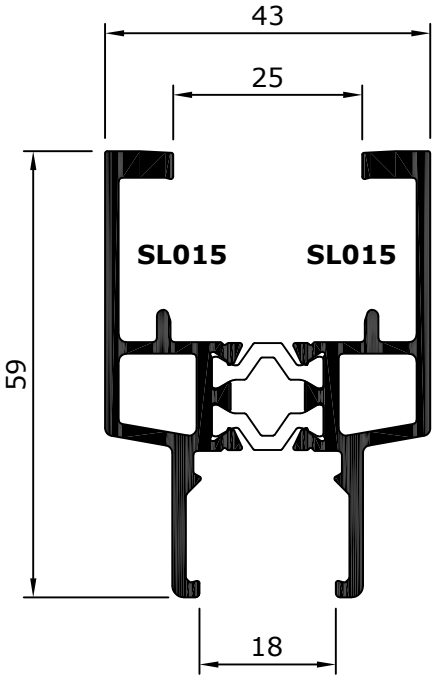
SL005
HEAD/CILL COVER



SL033
OUTER FRAME TRIM



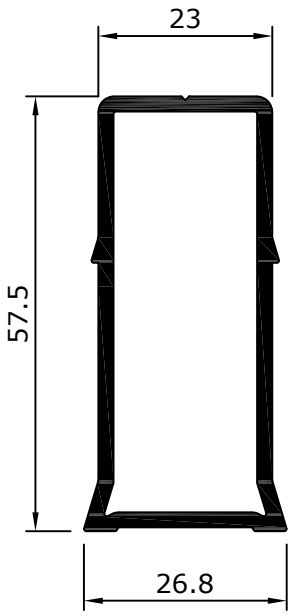
SL004004
LOCKING PROFILE
(FOR 3 AND 4 PANE SLIDER)



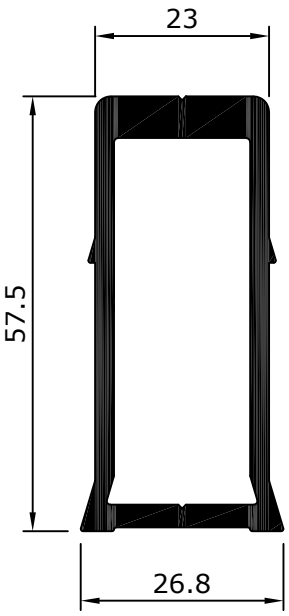
SL015015
JAMB EXTENSION

Scale 1:1

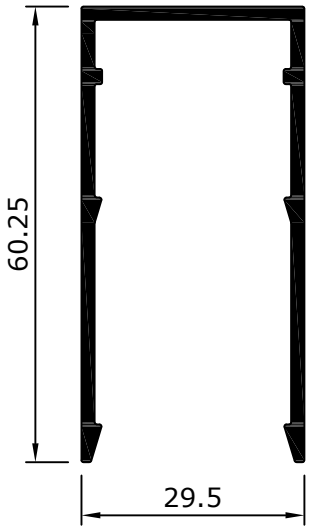
Section Drawings



007
SMALL MULLION STIFFENER

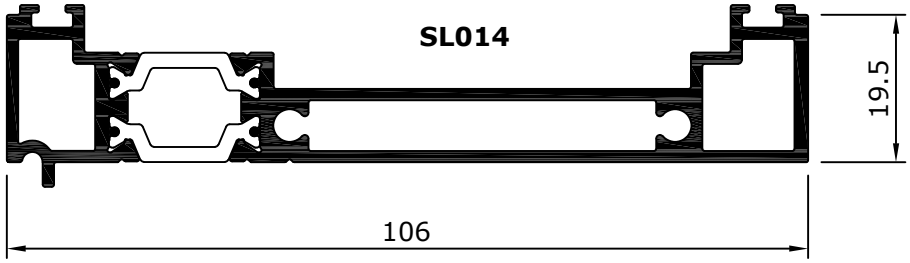


008
LARGE MULLION STIFFENER

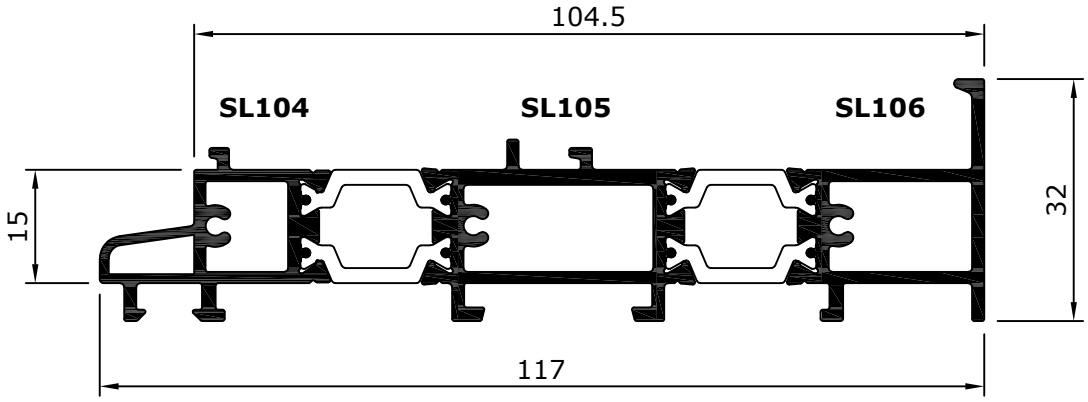


009
MULLION STIFFENER SHEATH

SL013



SL013014
COUPLING MULLION/TRANSOM



SL104105106
CILL

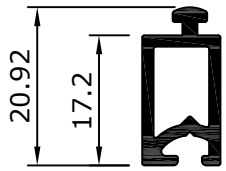
Scale 1:1

Section Drawings

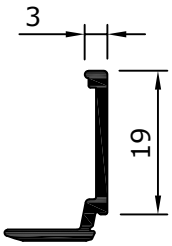
System 25 Hi/Hi+

LIFT AND SLIDE DOOR

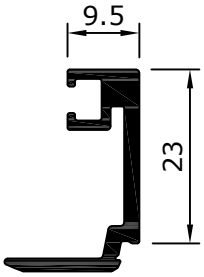
2T 3T



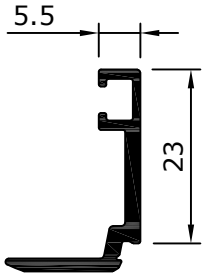
HR50116
17mm ADAPTOR PROFILE



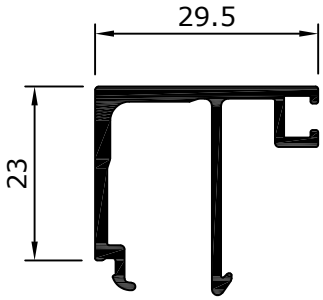
SL017
GLAZING BEAD



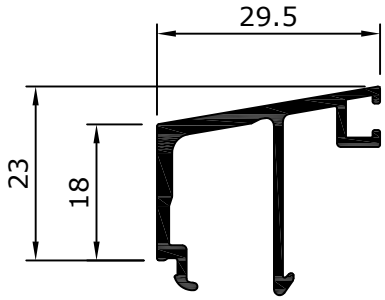
SL133
GLAZING BEAD



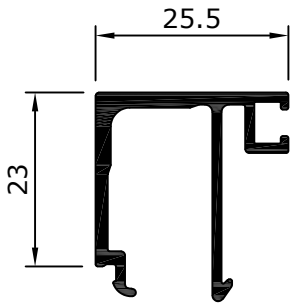
SL134
GLAZING BEAD



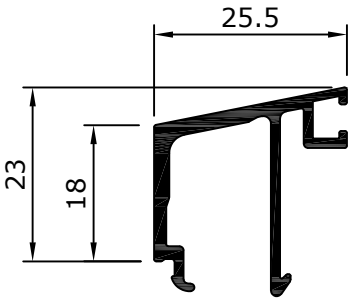
628
SQUARE GLAZING BEAD



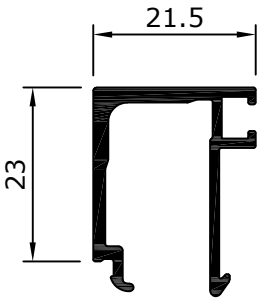
623
RAKED GLAZING BEAD



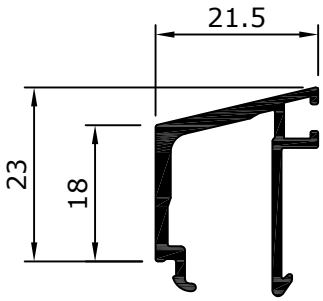
634
SQUARE GLAZING BEAD



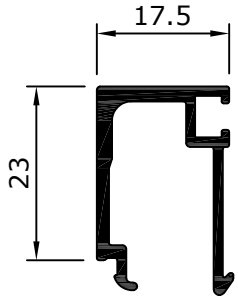
635
RAKED GLAZING BEAD



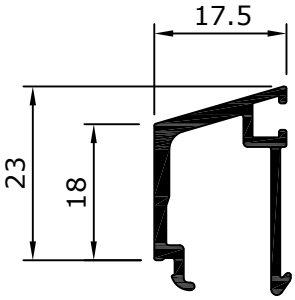
636
SQUARE GLAZING BEAD



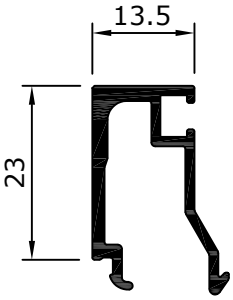
644
RAKED GLAZING BEAD



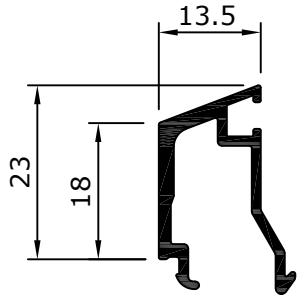
645
SQUARE GLAZING BEAD



646
RAKED GLAZING BEAD



653
SQUARE GLAZING BEAD

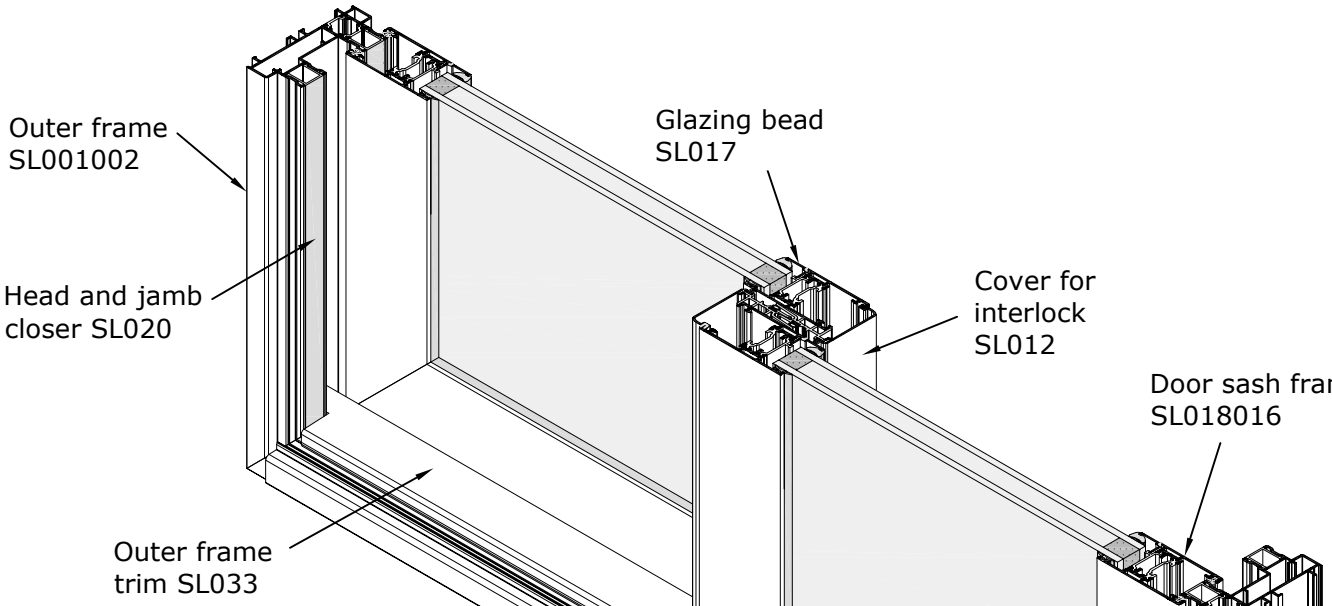


654
RAKED GLAZING BEAD

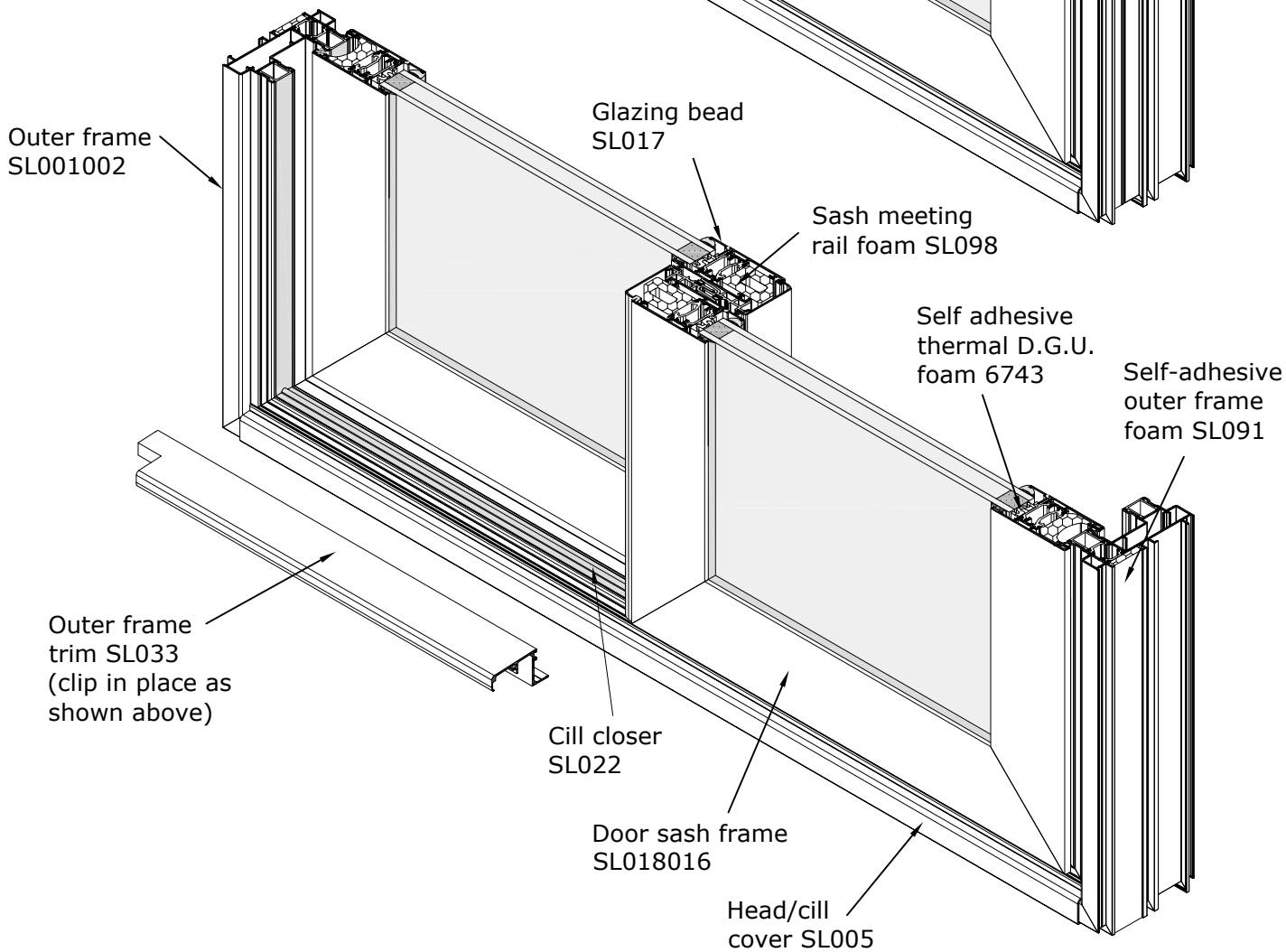
Scale 1:1

General Arrangement

25Hi 3-Dimensional Assembly Detail



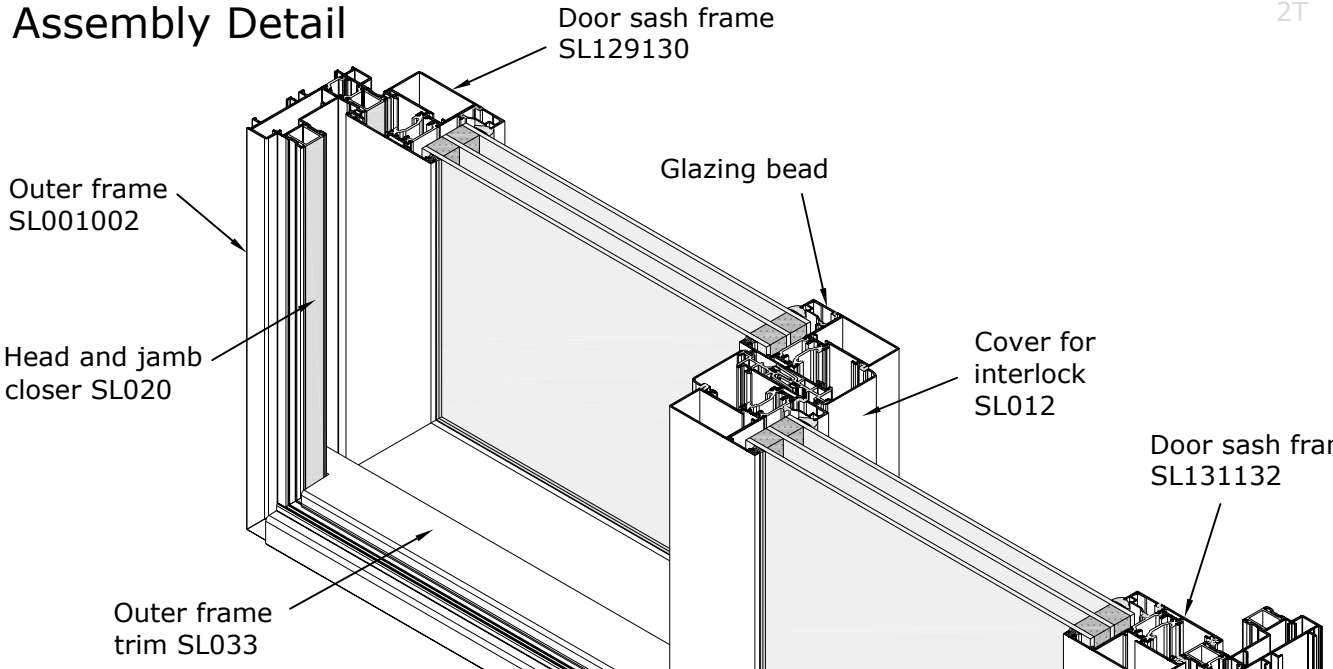
25Hi+ 3-Dimensional Assembly Detail



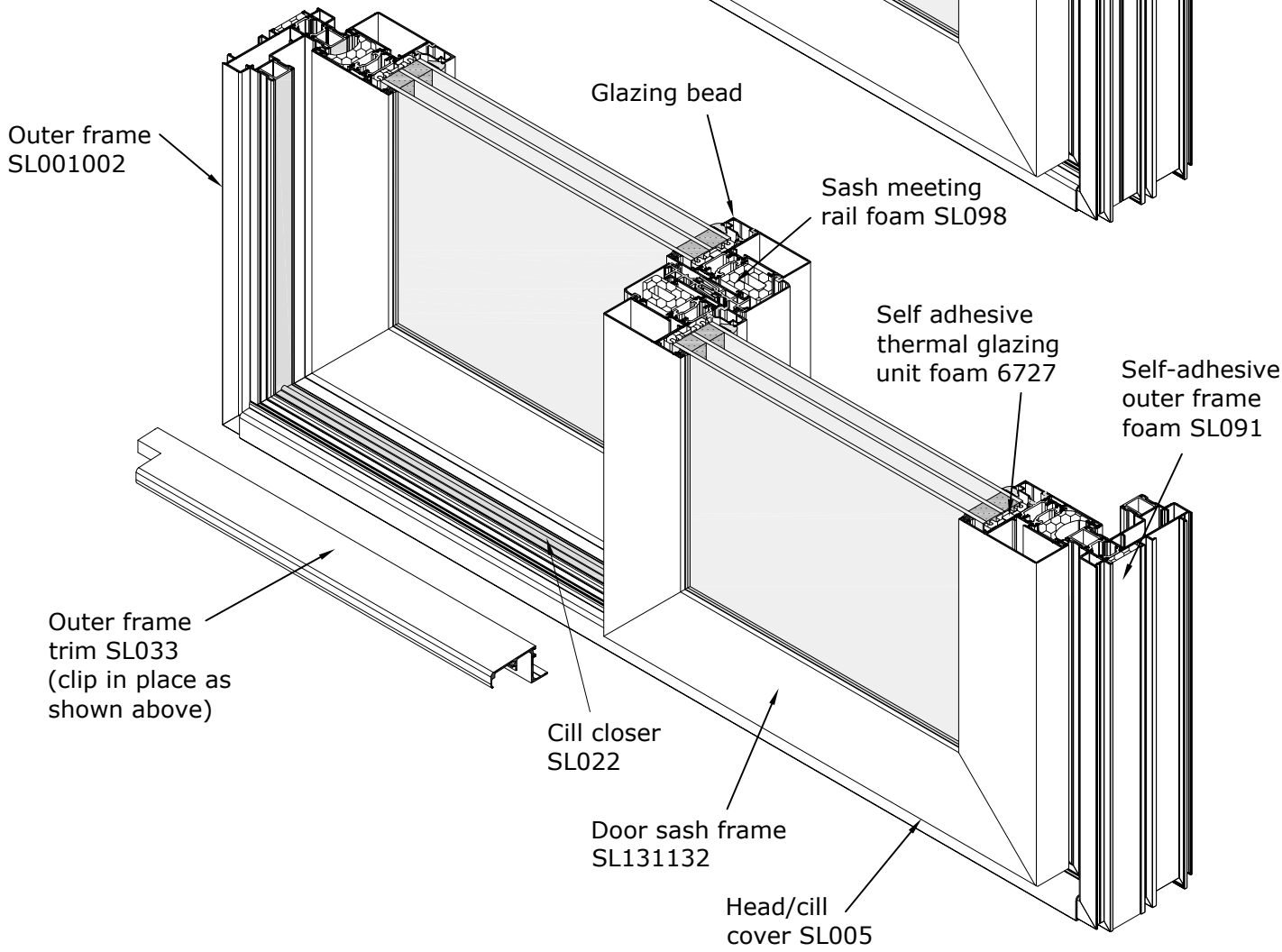
Not to scale

General Arrangement

25Hi 3-Dimensional Assembly Detail



25Hi+ 3-Dimensional Assembly Detail



Not to scale

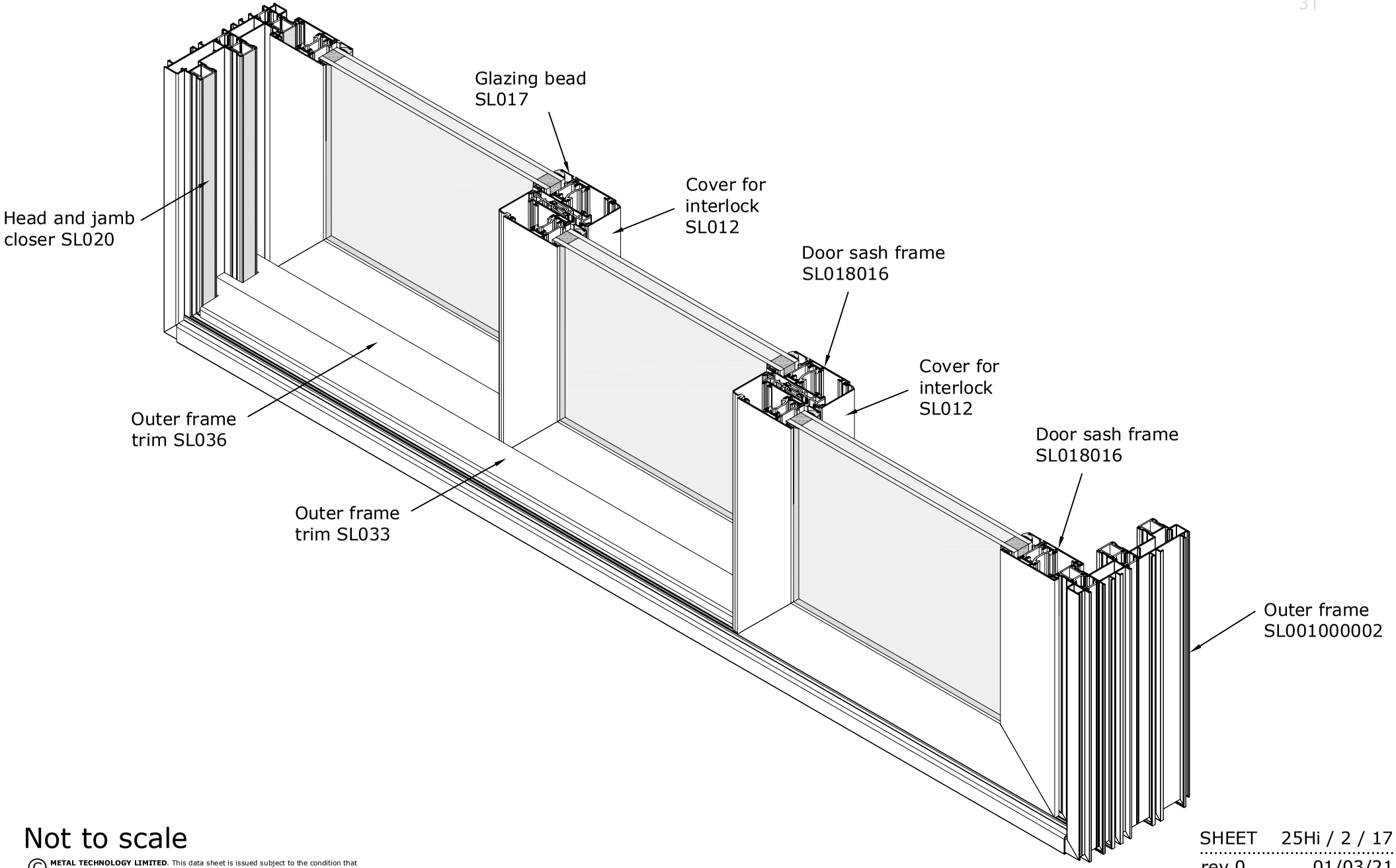
General Arrangement

25Hi 3-Dimensional Assembly Detail

System 25 Hi/Hi+

LIFT AND SLIDE DOOR

3T



Not to scale

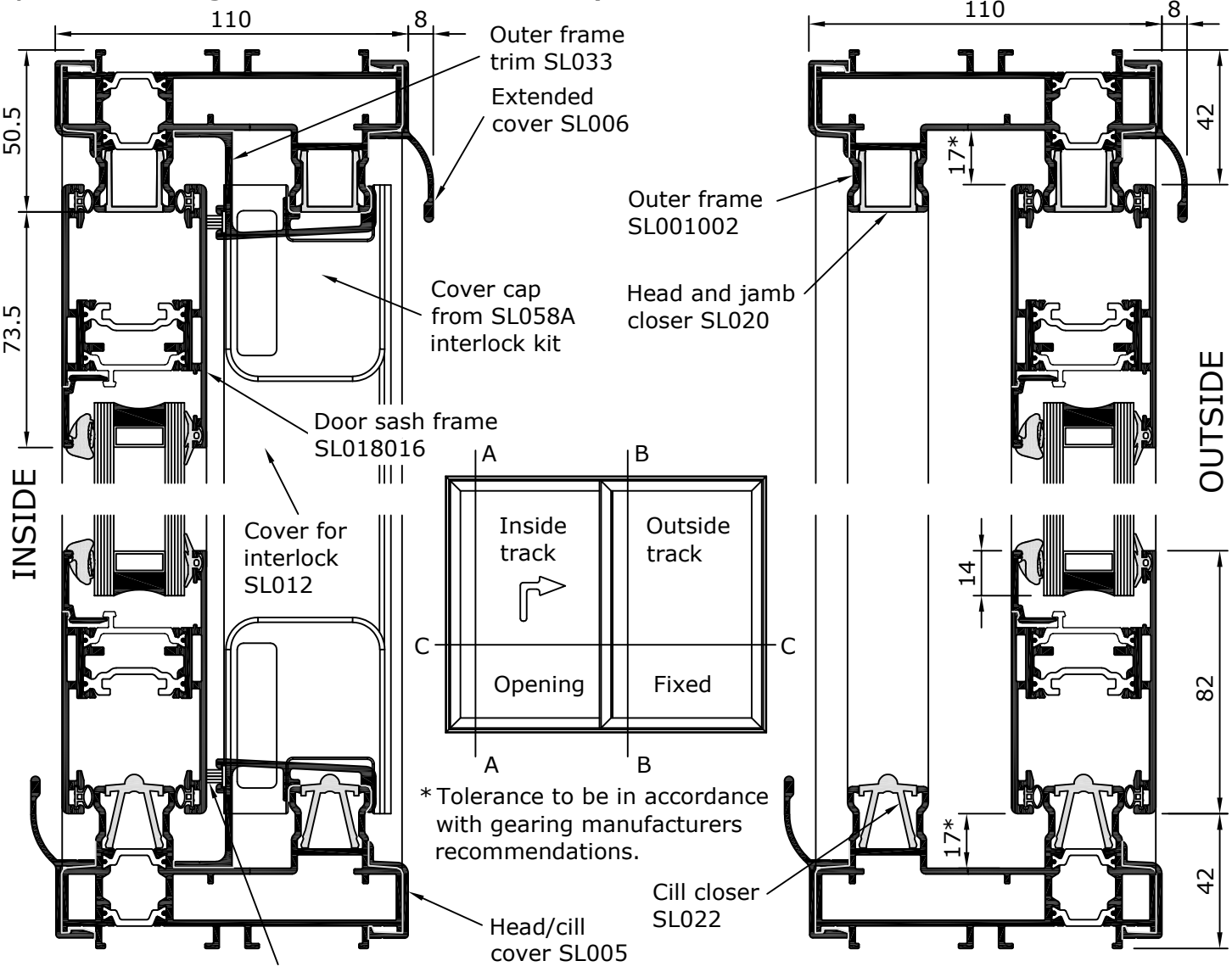
General Arrangement

1 Pane Lift and Slide / 1 Pane Fixed (Inside pane sliding with internal handle)

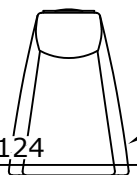
System 25 Hi

LIFT AND SLIDE DOOR

2T



SECTION A-A



Woolpile SL035

Internal handle SL051

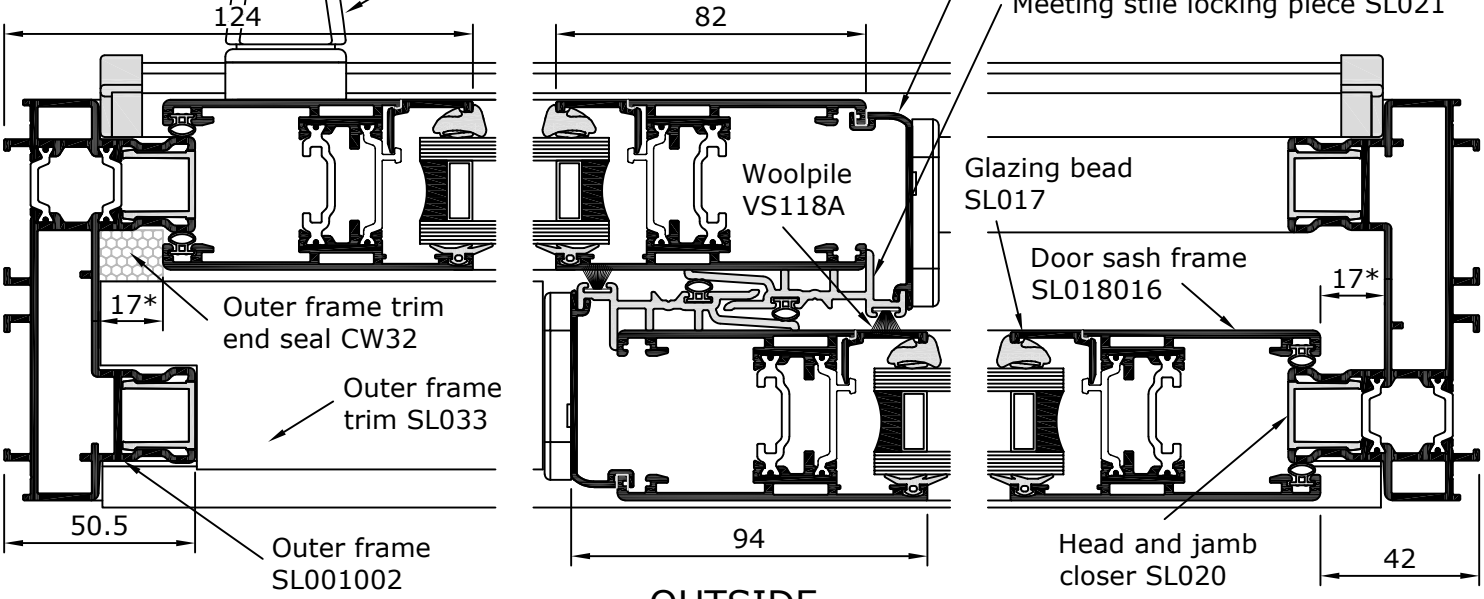
SECTION B-B

INSIDE

Cover for interlock SL012

Meeting stile locking piece SL021

SECTION C-C



OUTSIDE

Scale 1:2

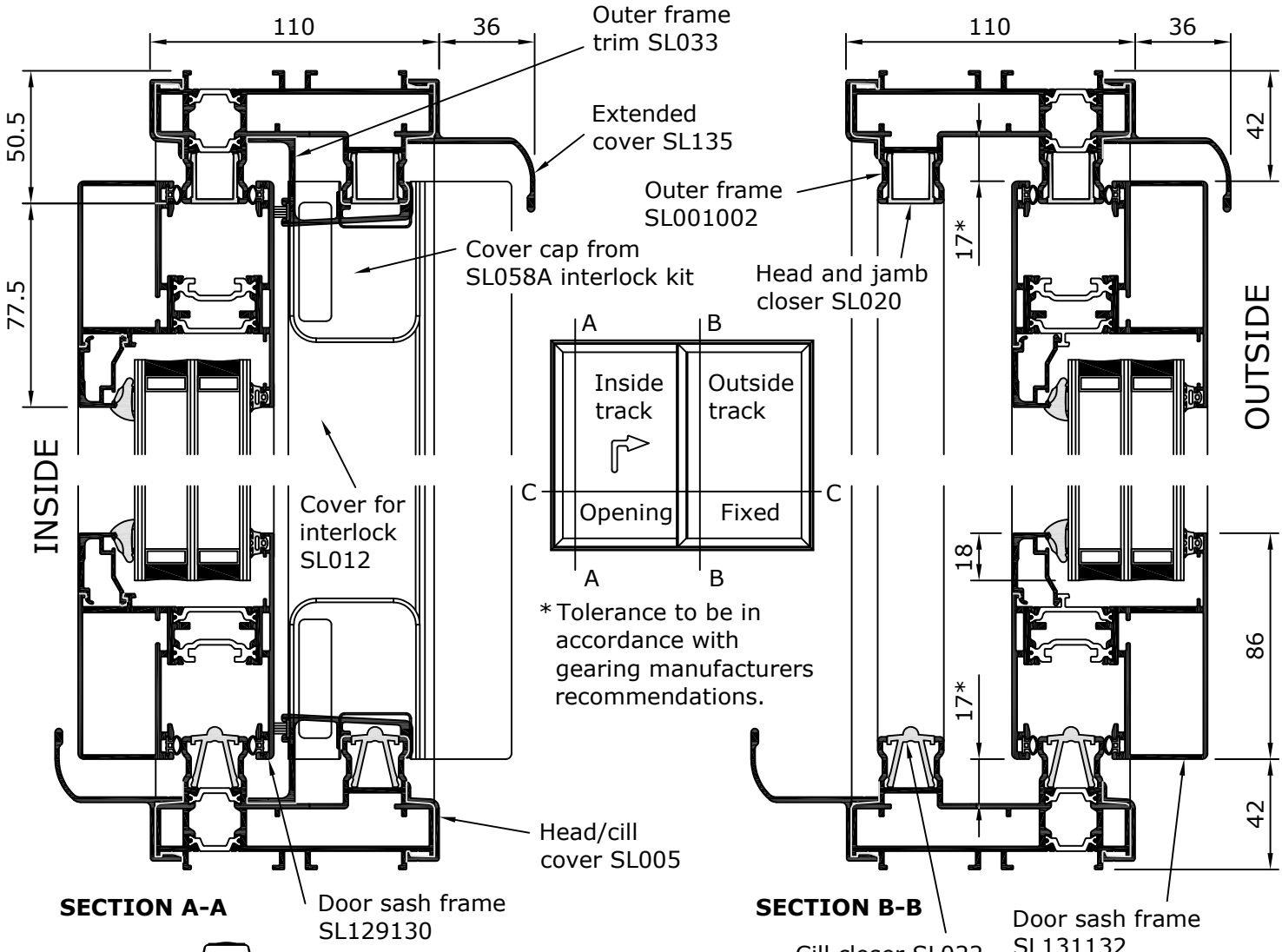
General Arrangement

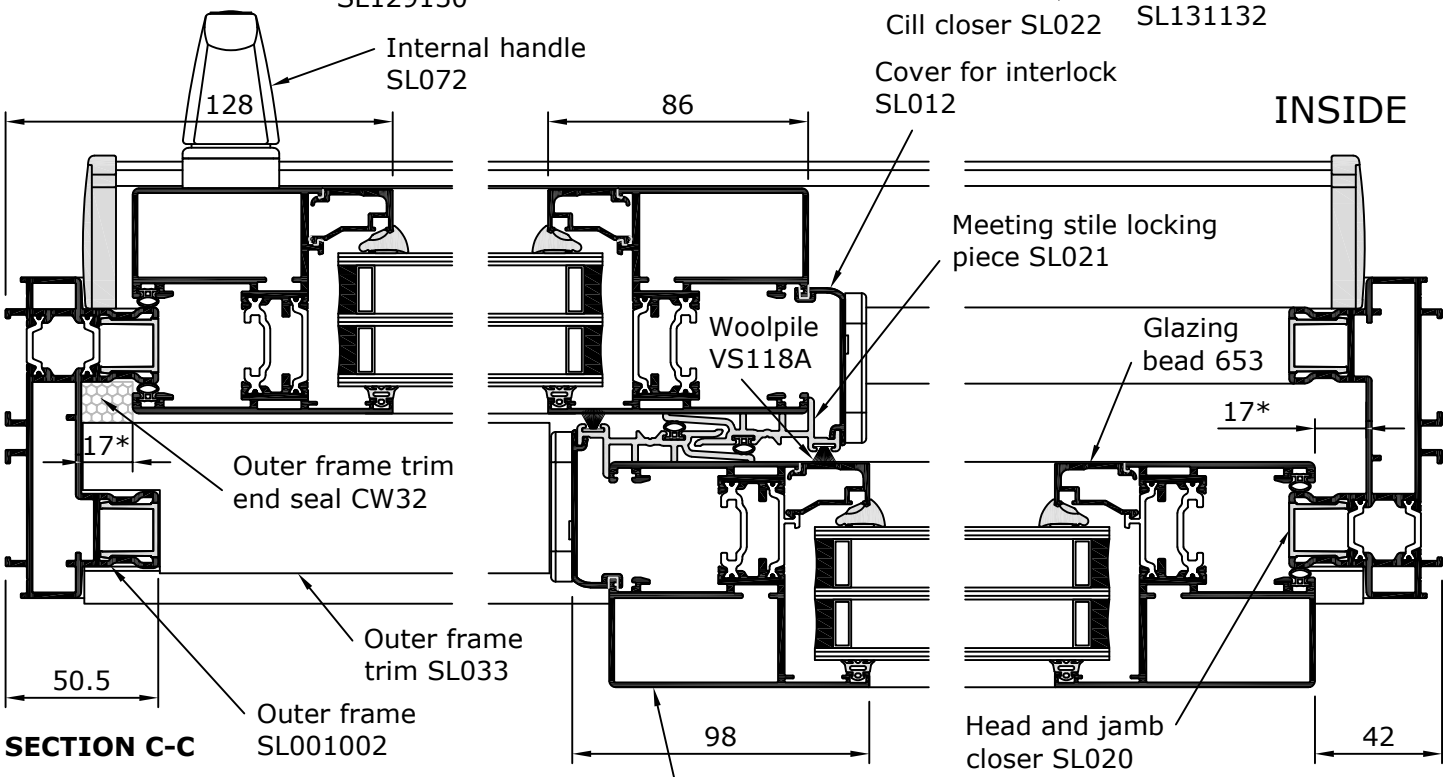
1 Pane Lift and Slide / 1 Pane Fixed (Inside pane sliding with internal handle)

System 25 Hi

LIFT AND SLIDE DOOR

2T





Not to Scale

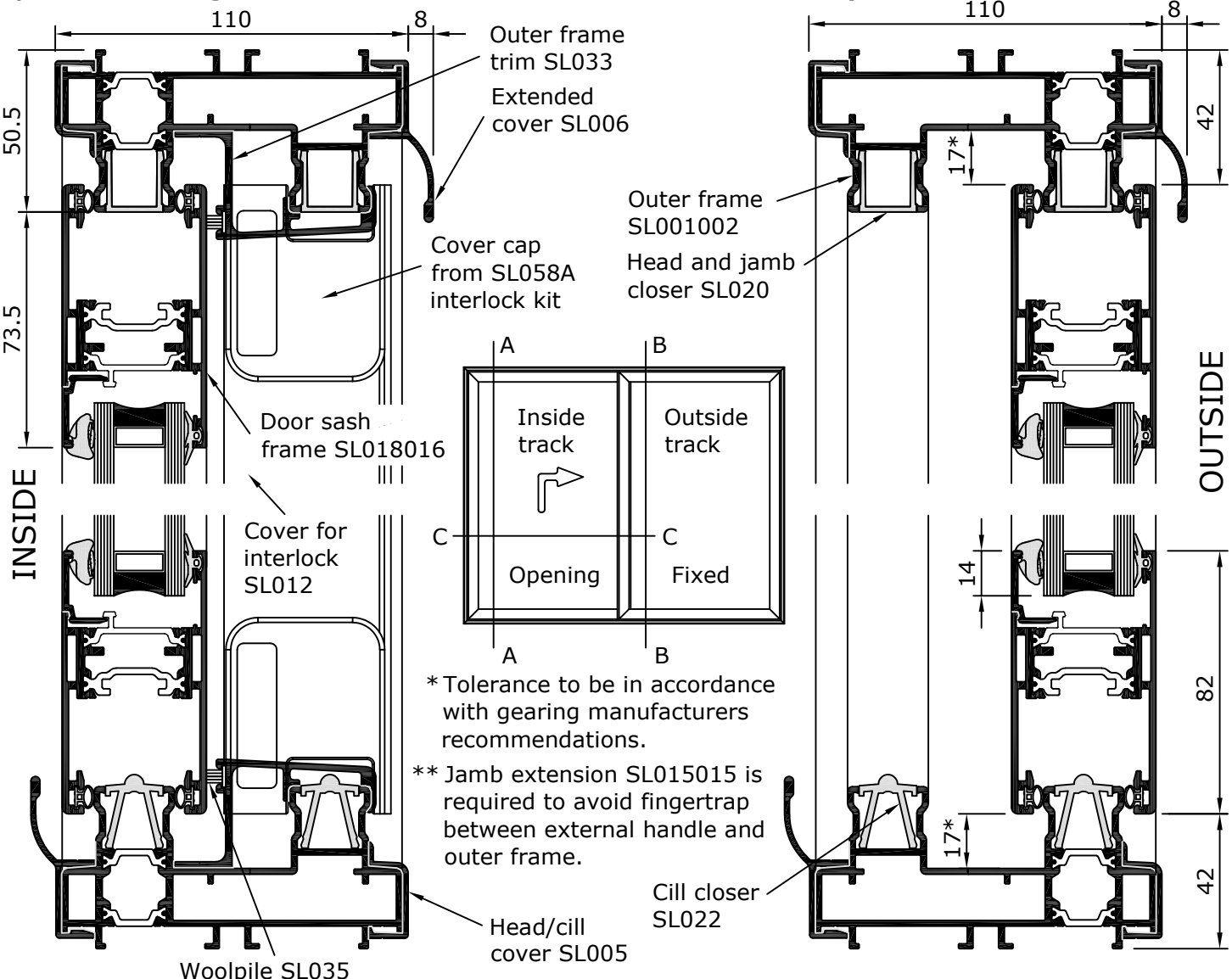
General Arrangement

1 Pane Lift and Slide / 1 Pane Fixed (Inside pane sliding with internal and external handles)

System 25 Hi

LIFT AND SLIDE DOOR

2T



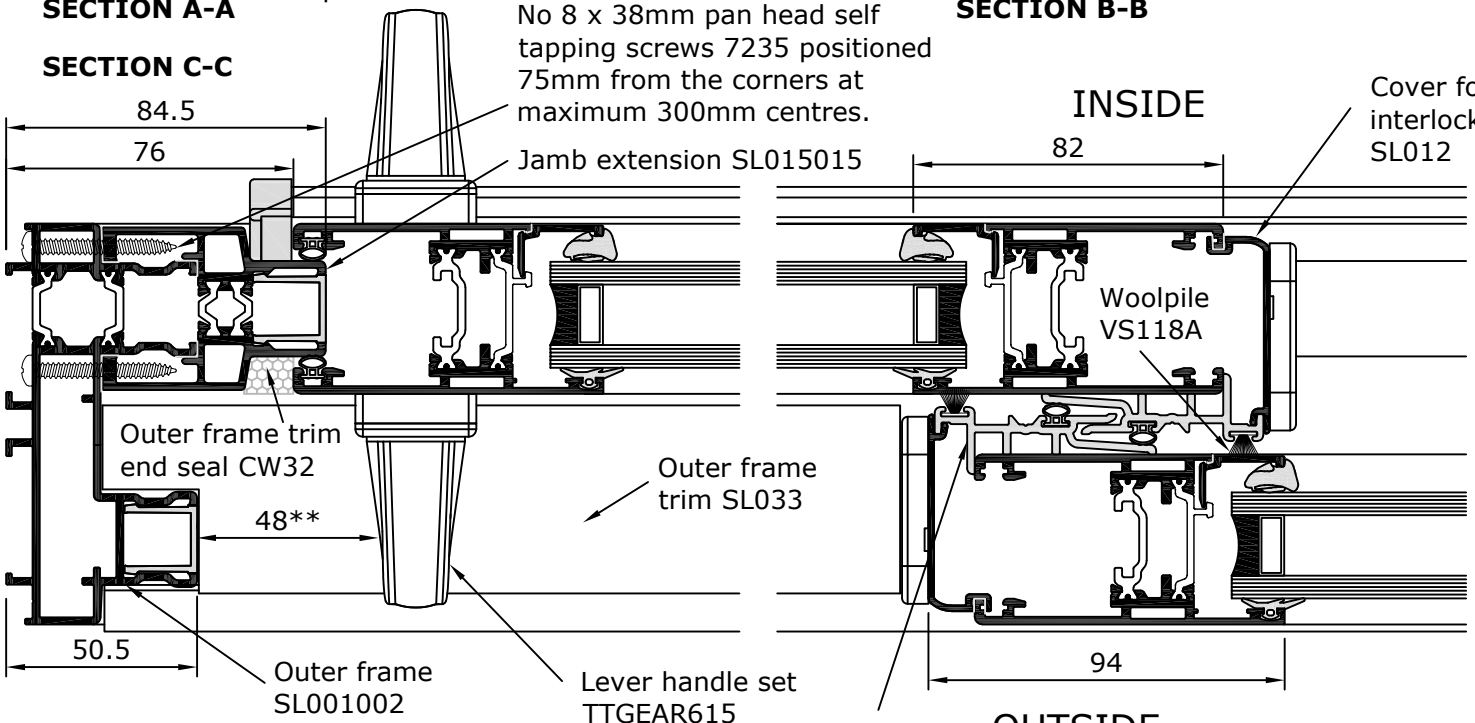
* Tolerance to be in accordance with gearing manufacturers recommendations.

** Jamb extension SL015015 is required to avoid fingertrap between external handle and outer frame.

SECTION A-A

SECTION B-B

SECTION C-C



Scale 1:2

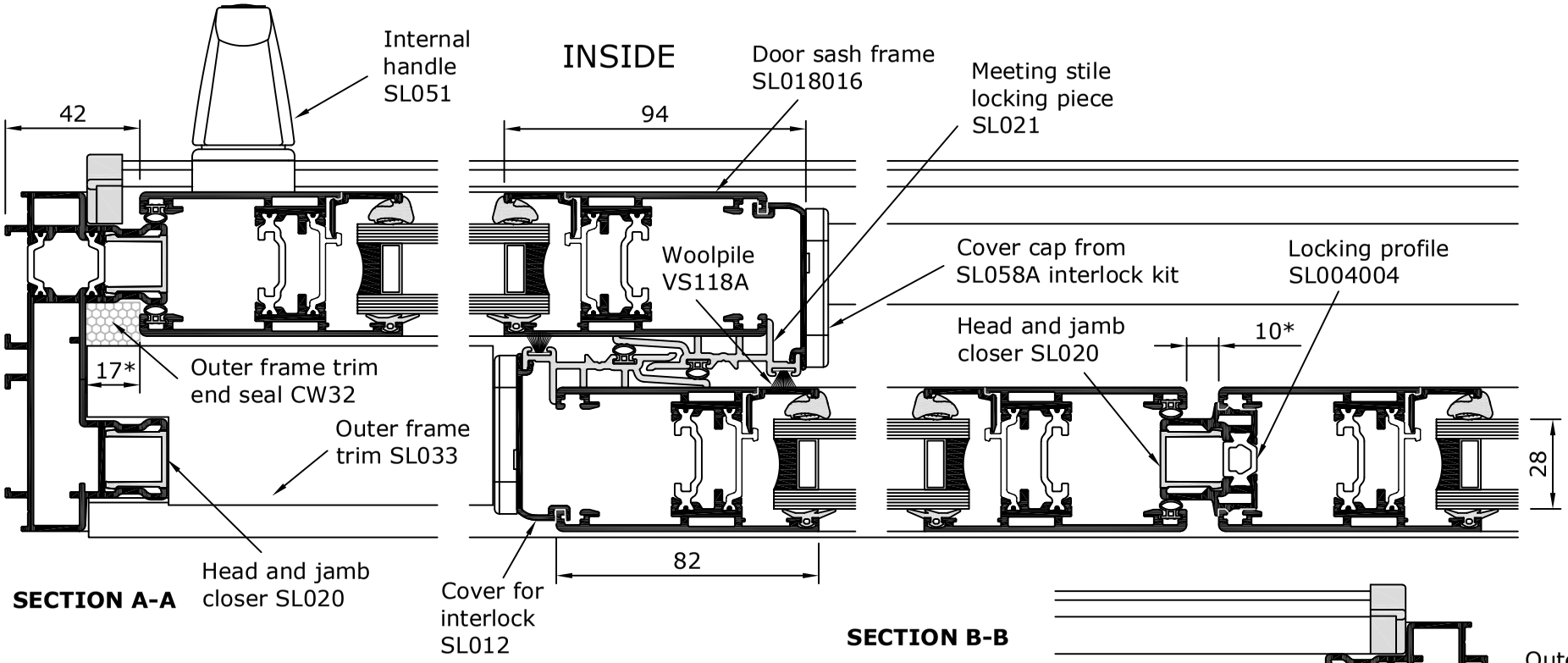
General Arrangement

Lift and Slide / Fixed / Fixed (Inside pane sliding with internal handle)

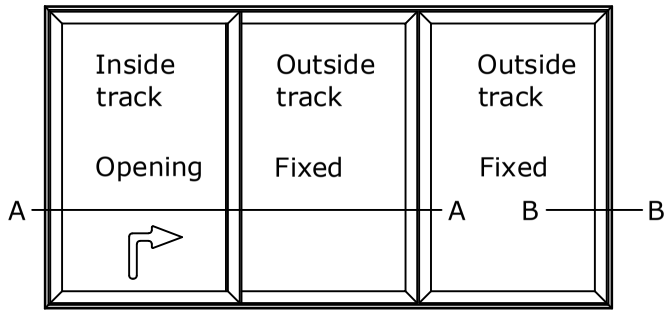
System 25 Hi

LIFT AND SLIDE DOOR

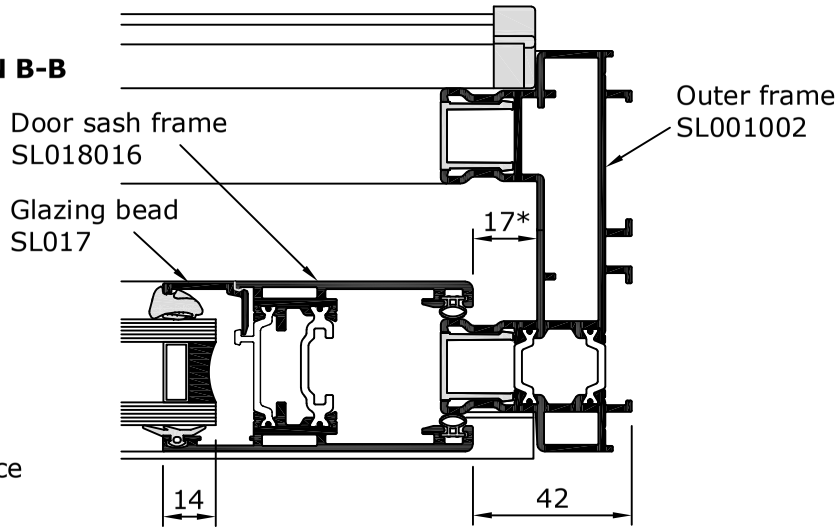
2T



SECTION A-A



SECTION B-B



*Tolerance to be in accordance with gearing manufacturers recommendations.

OUTSIDE

Scale 1:2

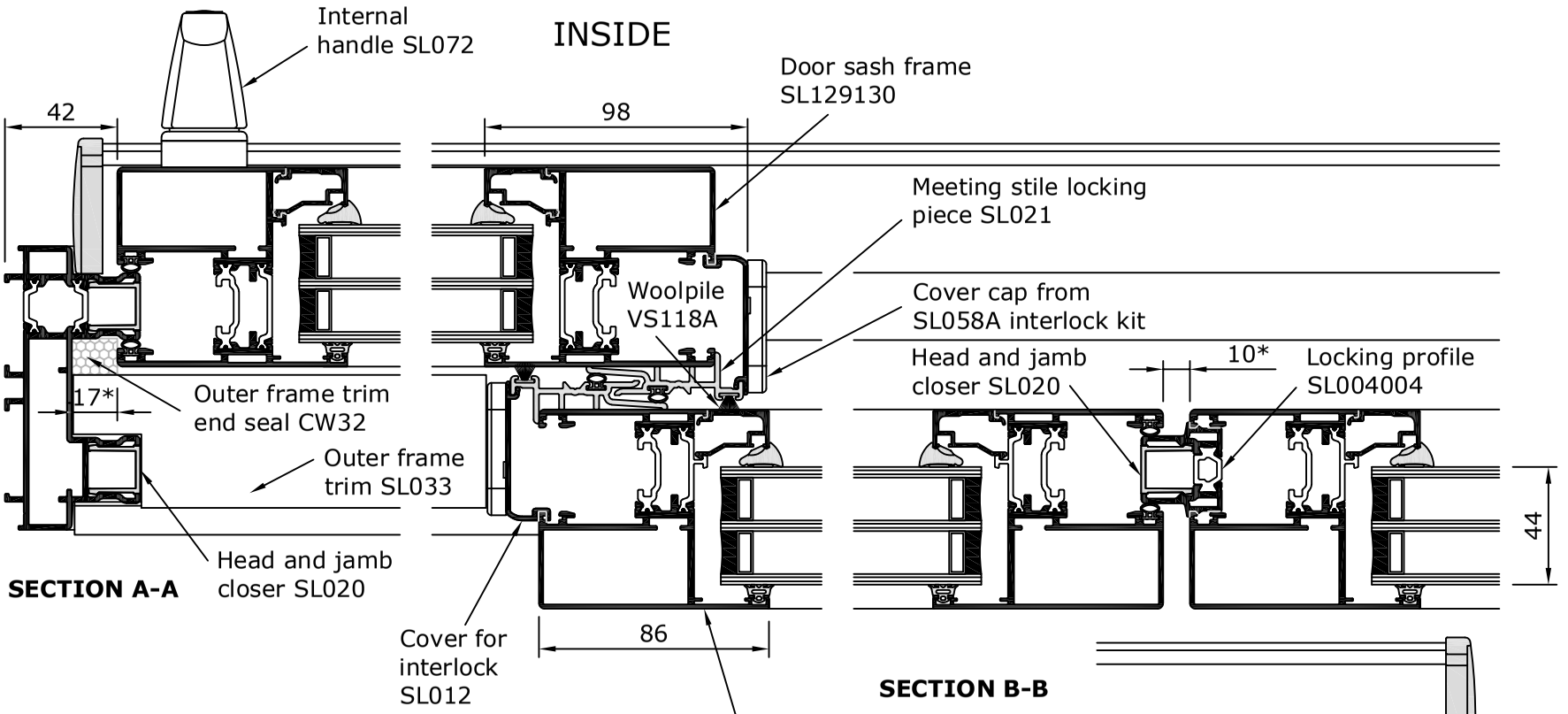
General Arrangement

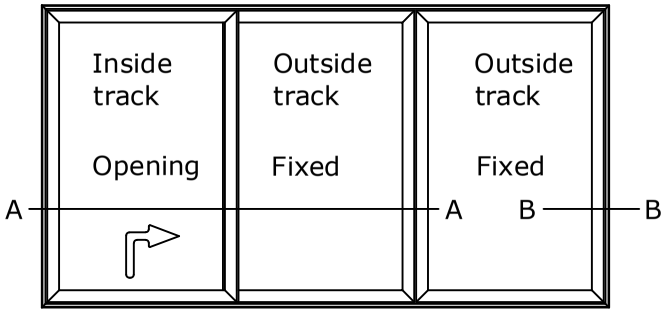
Lift and Slide / Fixed / Fixed (Inside pane sliding with internal handle)

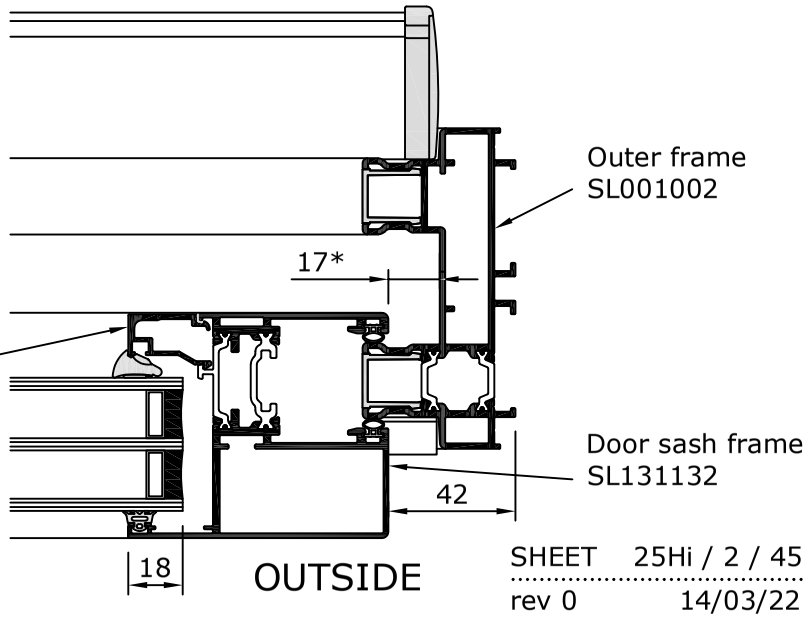
System 25 Hi

LIFT AND SLIDE DOOR

2T







* Tolerance to be in accordance with gearing manufacturers recommendations.

Not to Scale

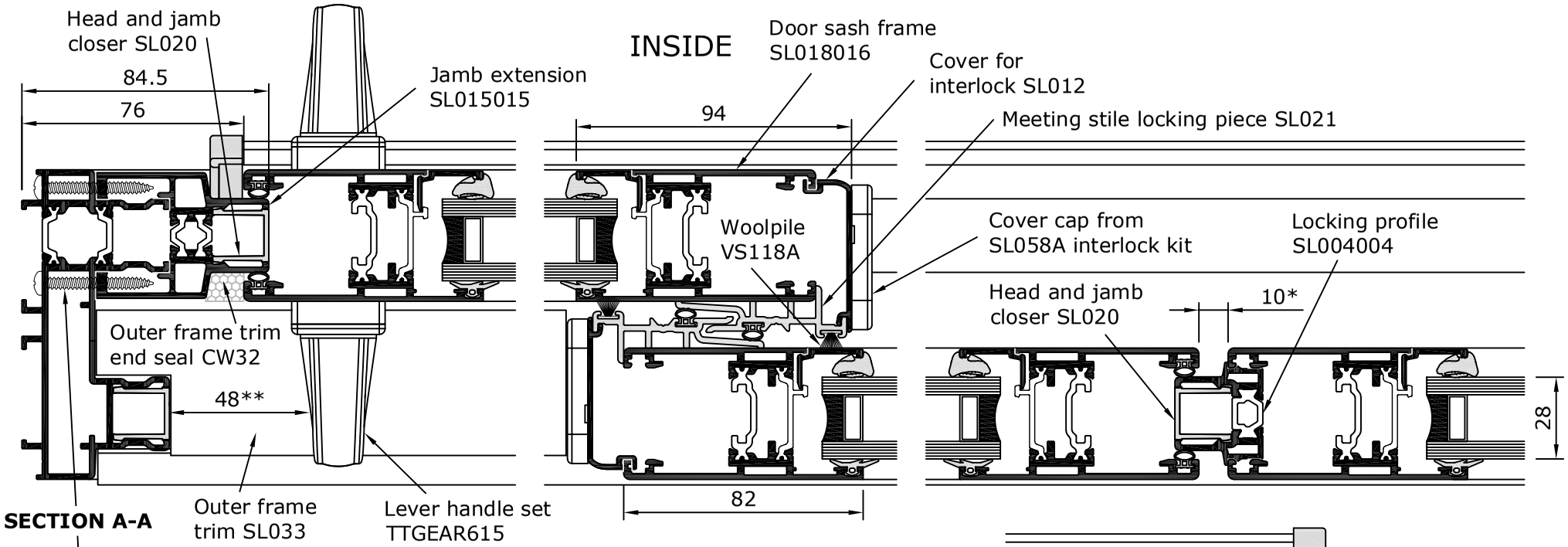
General Arrangement

Lift and Slide / Fixed / Fixed (Inside pane sliding with internal and external handles)

System 25 Hi

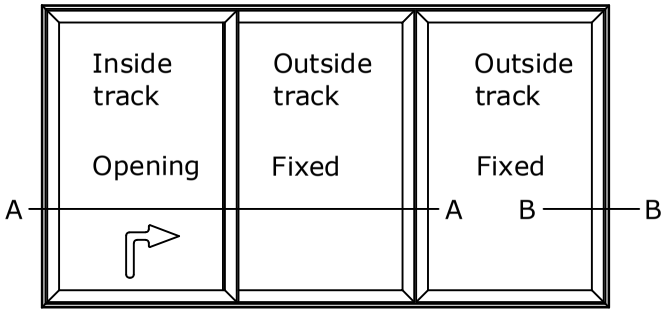
LIFT AND SLIDE DOOR

2T

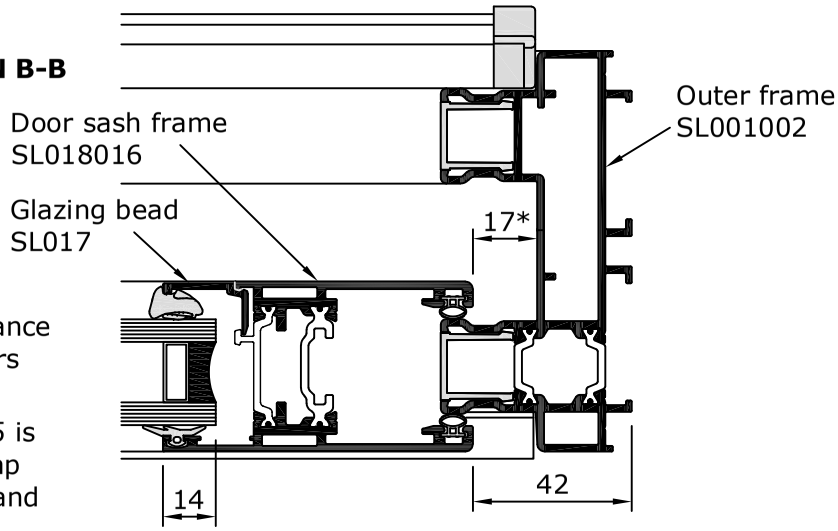


SECTION A-A

No 8 x 38mm pan head self tapping screws 7235 positioned 75mm from the corners at maximum 300mm centres.



SECTION B-B



* Tolerance to be in accordance with gearing manufacturers recommendations.

** Jamb extension SL015015 is required to avoid fingertrap between external handle and outer frame.

OUTSIDE

Scale 1:2

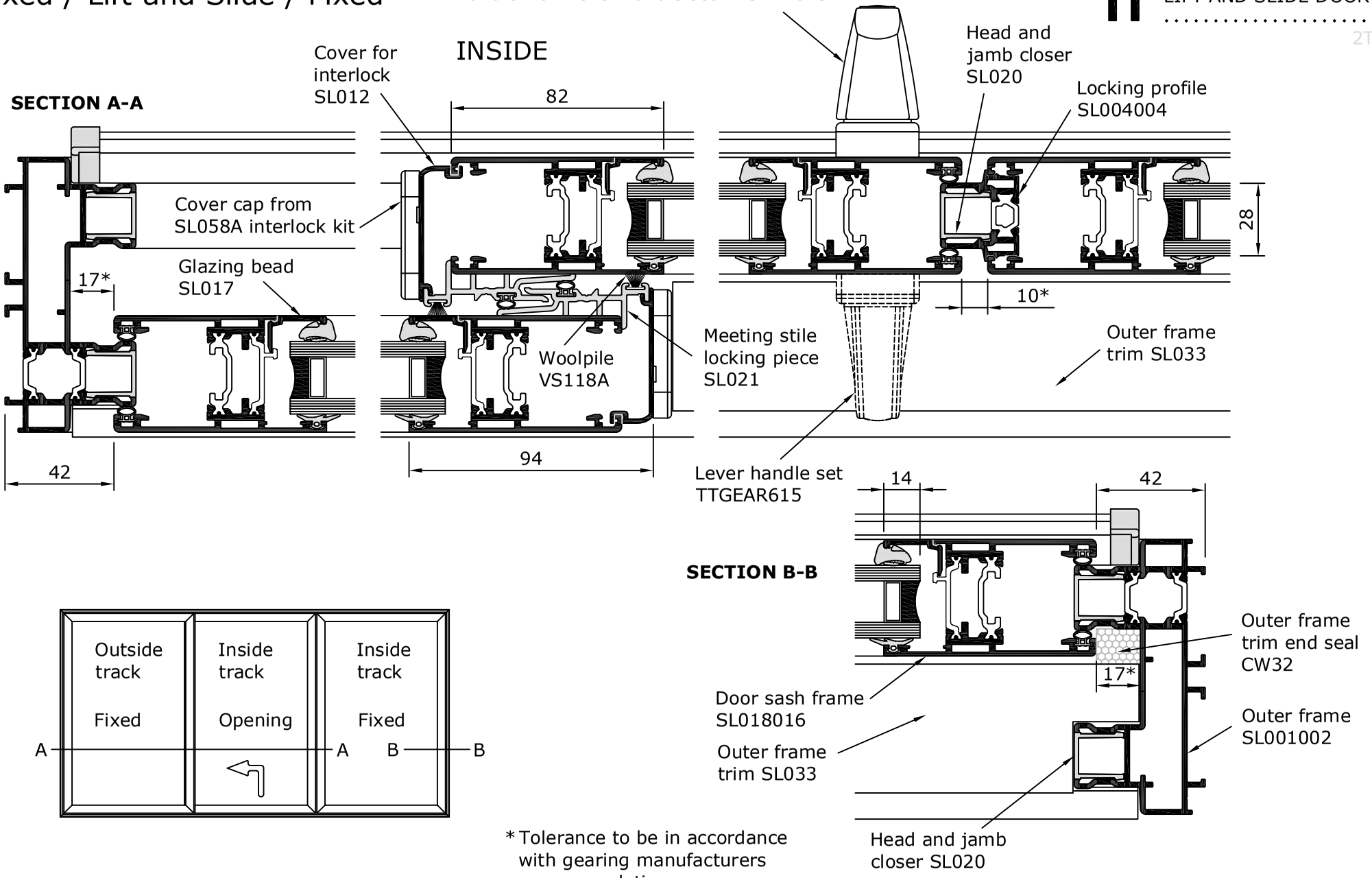
General Arrangement

Fixed / Lift and Slide / Fixed

System 25 Hi

LIFT AND SLIDE DOOR

2T



*Tolerance to be in accordance with gearing manufacturers recommendations.

Scale 1:2

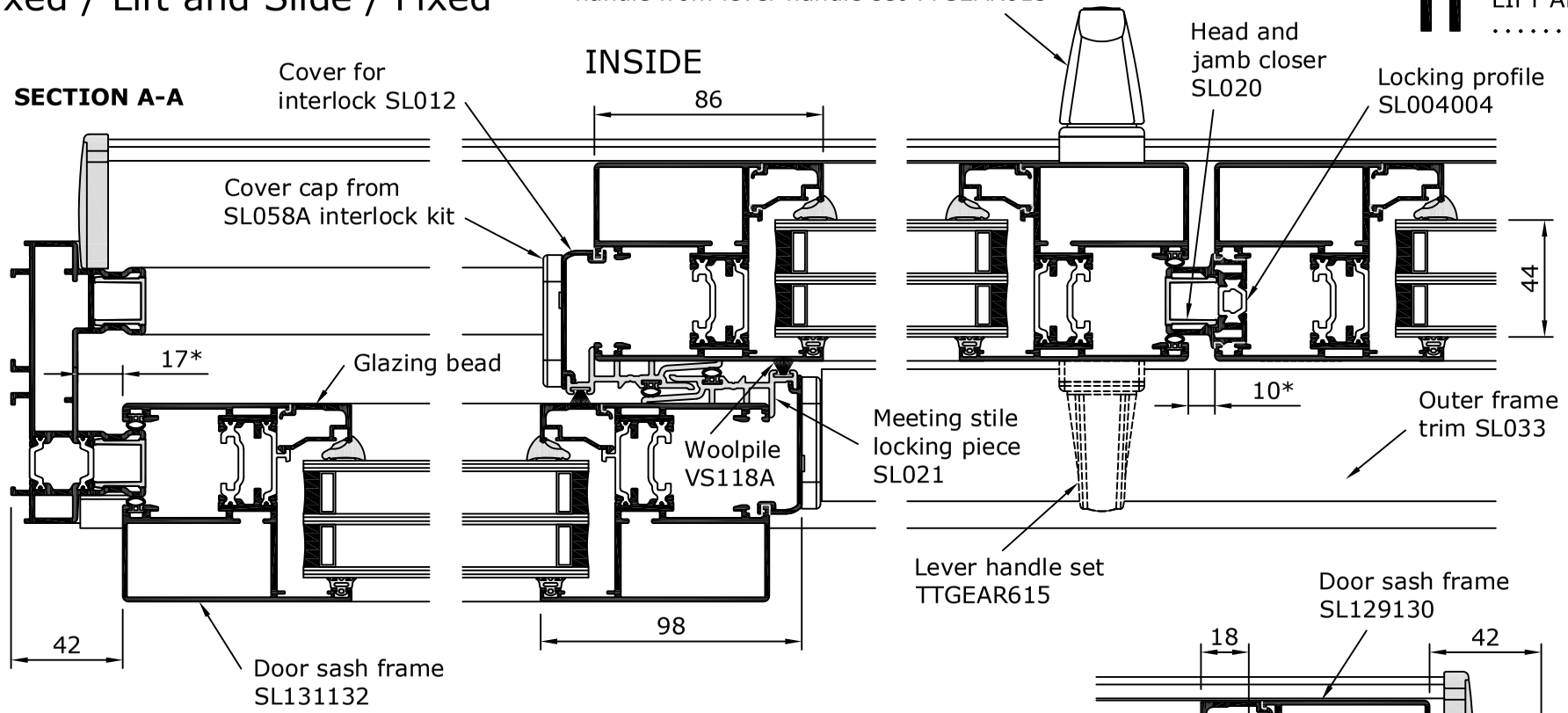
General Arrangement

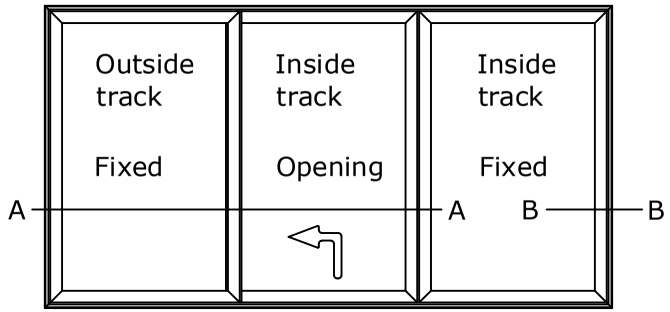
Fixed / Lift and Slide / Fixed

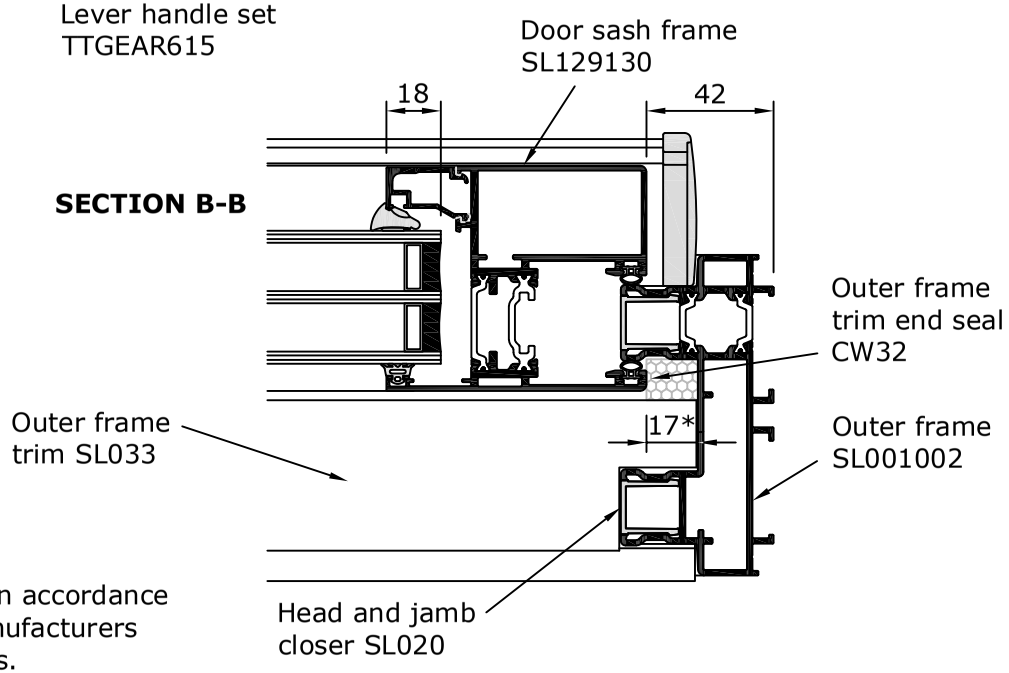
System 25 Hi

LIFT AND SLIDE DOOR

2T







*Tolerance to be in accordance with gearing manufacturers recommendations.

Not to Scale

OUTSIDE

SHEET 25Hi / 2 / 65

rev 1 14/03/22

General Arrangement

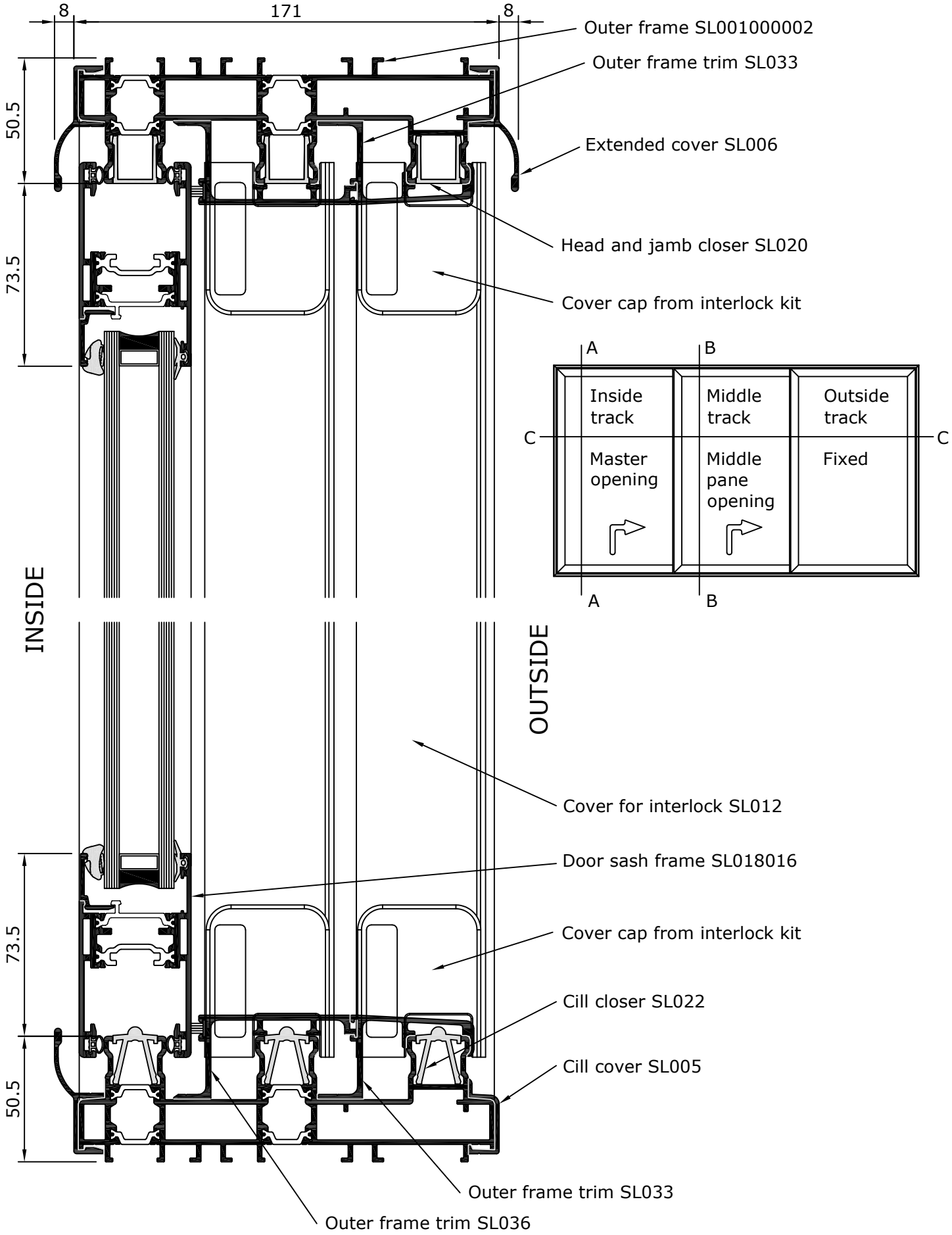
Triple Track Lift and Slide Door

System 25 Hi

LIFT AND SLIDE DOOR

3T

SECTION A-A



Scale 1:2

General Arrangement

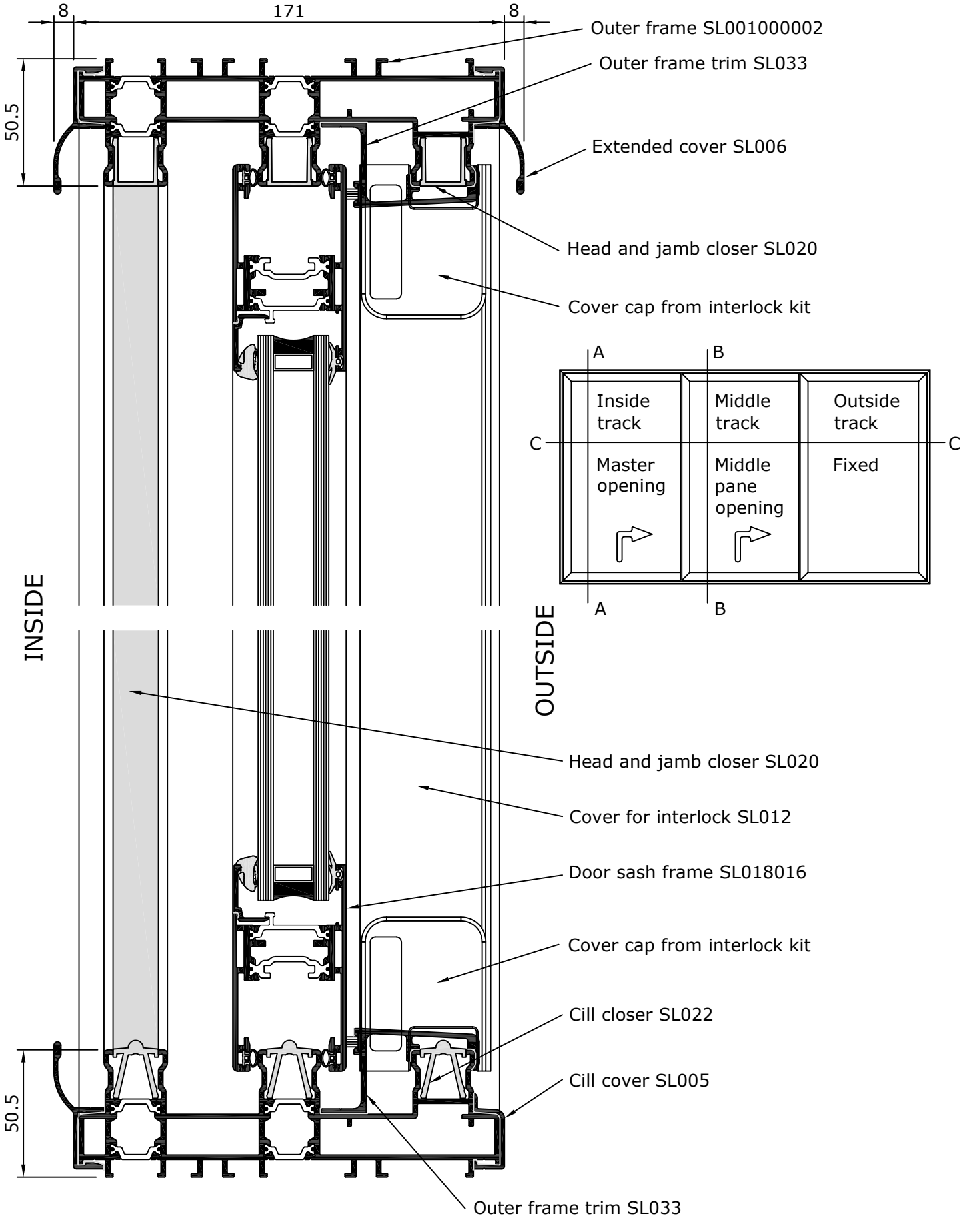
Triple Track Lift and Slide Door

System 25 Hi

LIFT AND SLIDE DOOR

3T

SECTION B-B

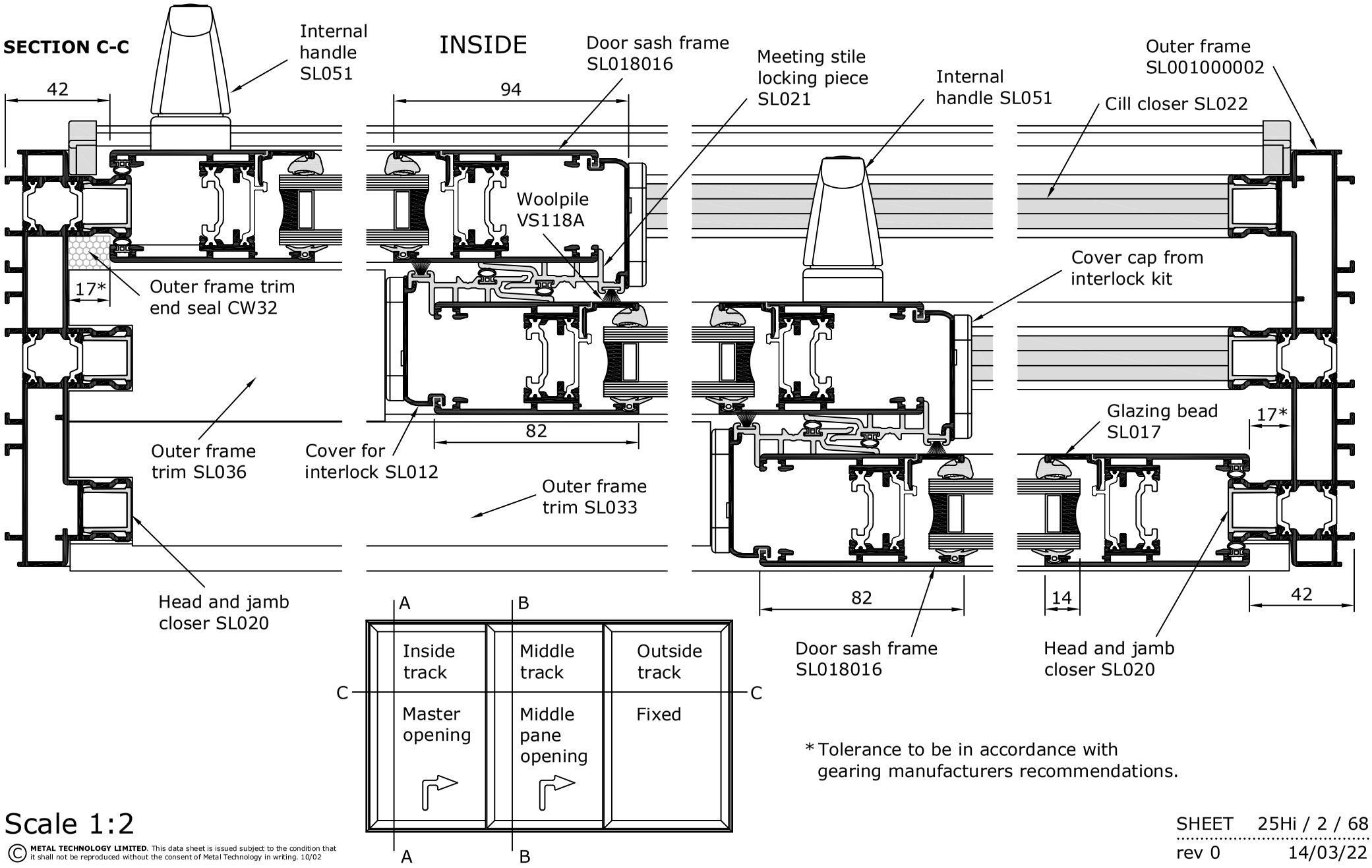


Scale 1:2

General Arrangement

Triple Track Lift and Slide Door (Internal handle)

System 25 Hi
LIFT AND SLIDE DOOR
3T



* Tolerance to be in accordance with gearing manufacturers recommendations.

Scale 1:2

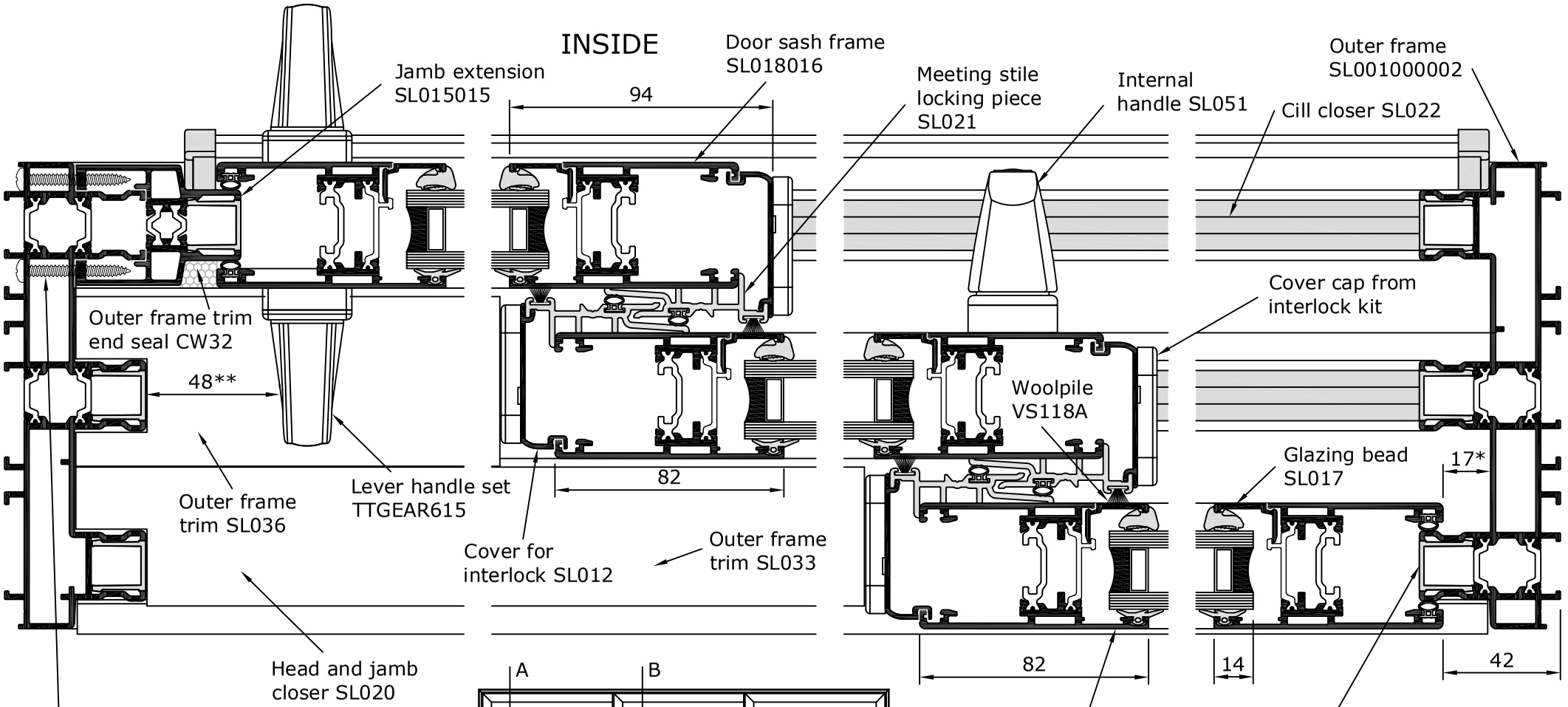
General Arrangement

Triple Track Lift and Slide Door (Internal and external handles)

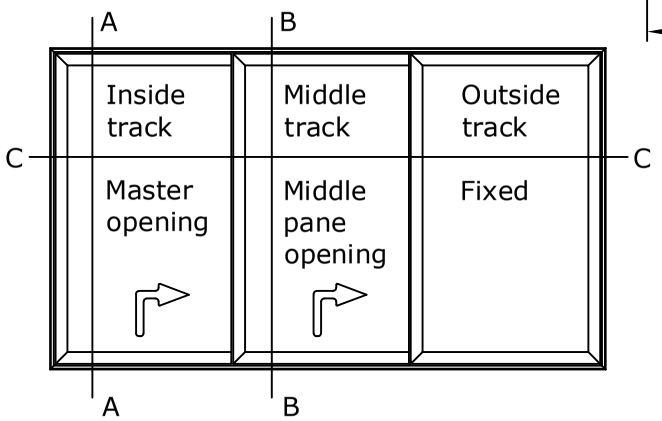
System 25 Hi

LIFT AND SLIDE DOOR

3T



No 8 x 38mm pan head self tapping screws 7235 positioned 75mm from the corners at maximum 300mm centres.



* Tolerance to be in accordance with gearing manufacturers recommendations.

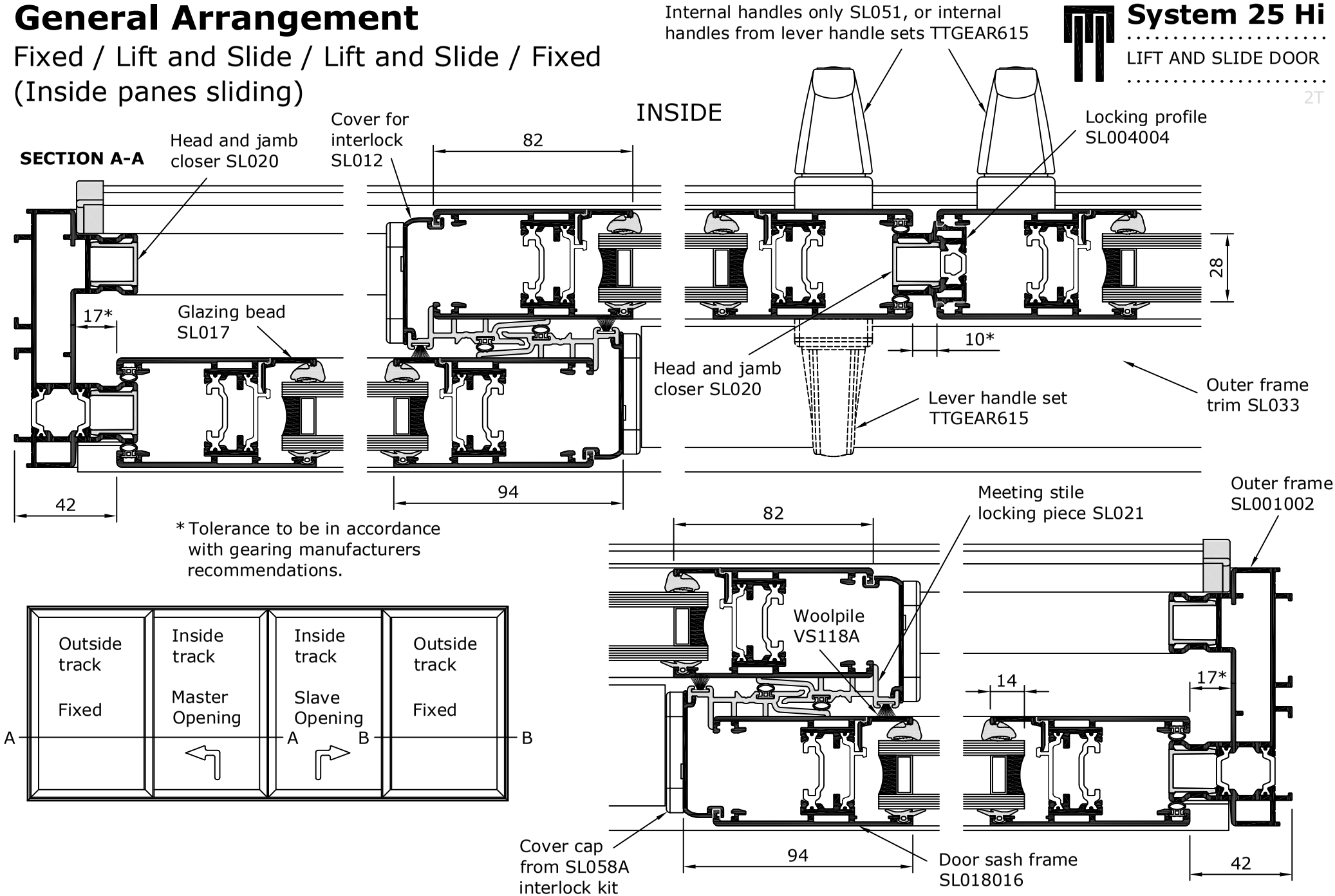
** Jamb extension SL015015 is required to avoid fingertrap between external handle and outer frame.

Scale 1:2

General Arrangement

Fixed / Lift and Slide / Lift and Slide / Fixed
(Inside panes sliding)

System 25 Hi
LIFT AND SLIDE DOOR
2T



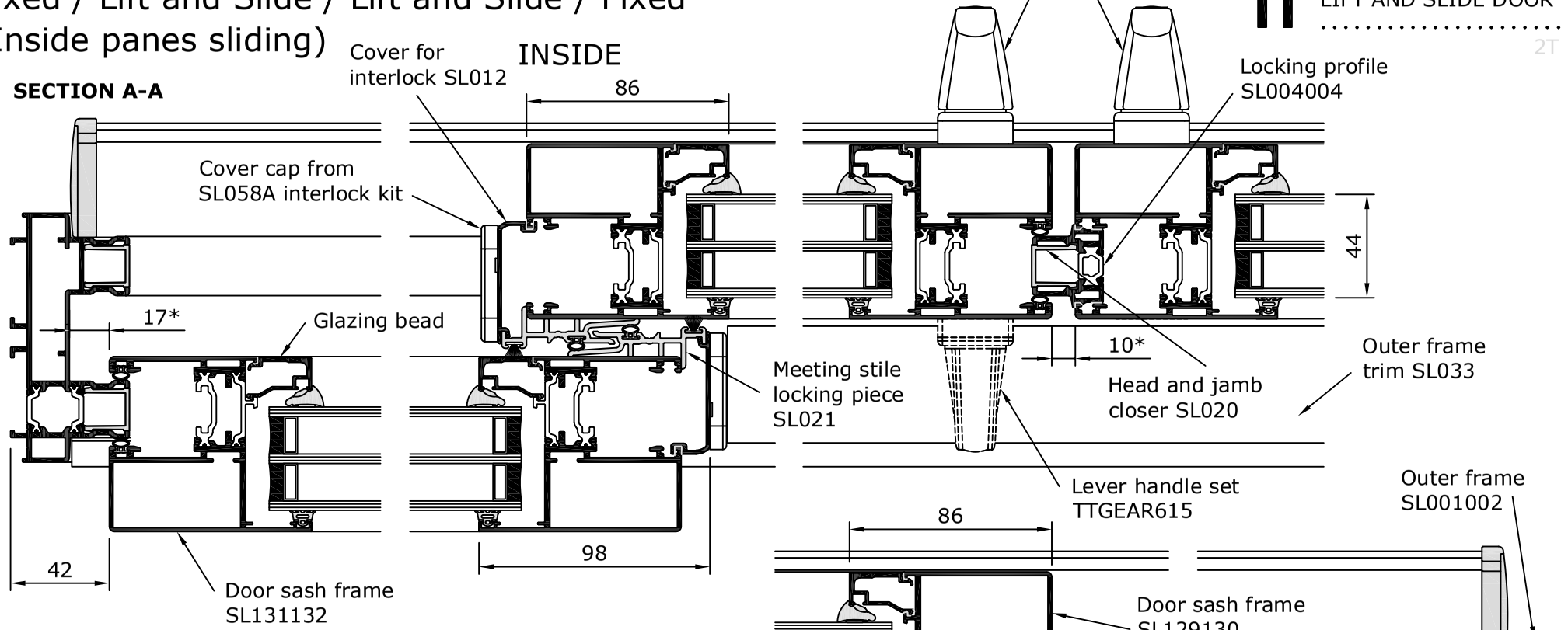
Scale 1:2

General Arrangement

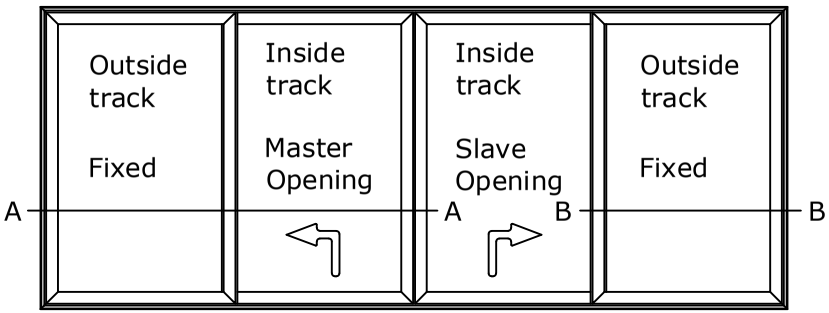
Fixed / Lift and Slide / Lift and Slide / Fixed
(Inside panes sliding)

System 25 Hi
LIFT AND SLIDE DOOR
2T

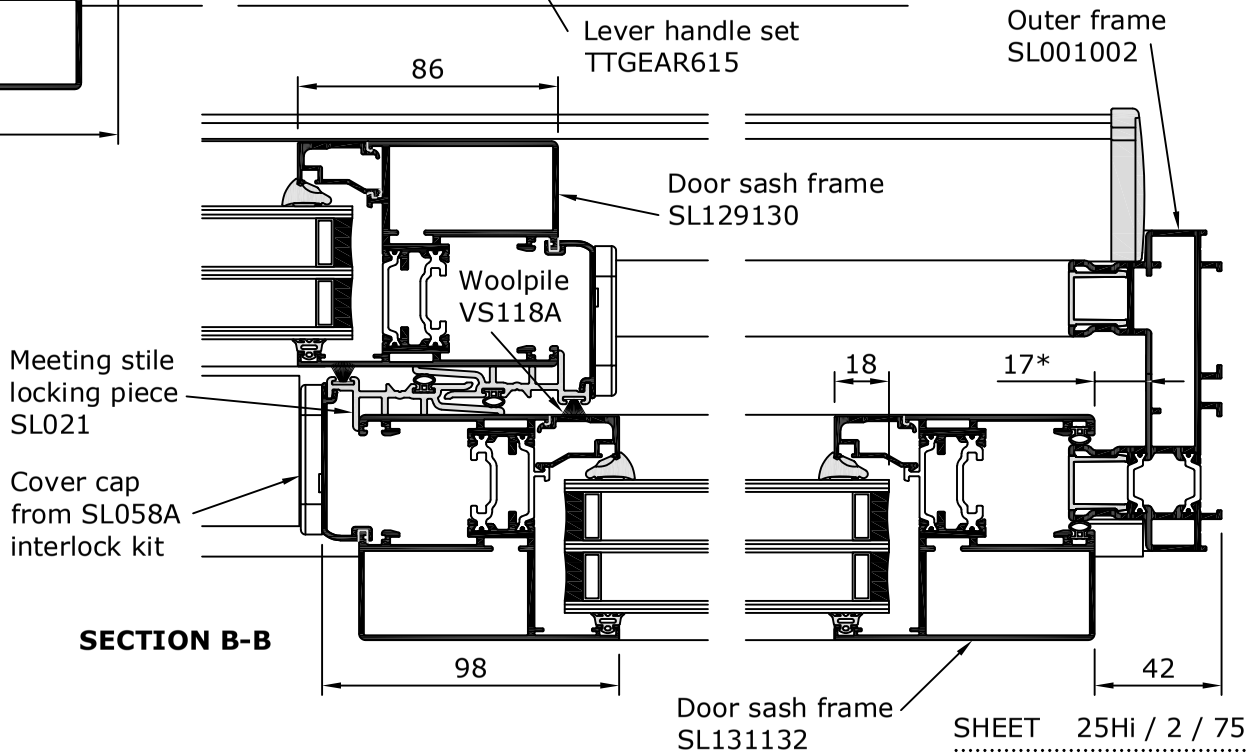
SECTION A-A



* Tolerance to be in accordance with gearing manufacturers recommendations.



SECTION B-B

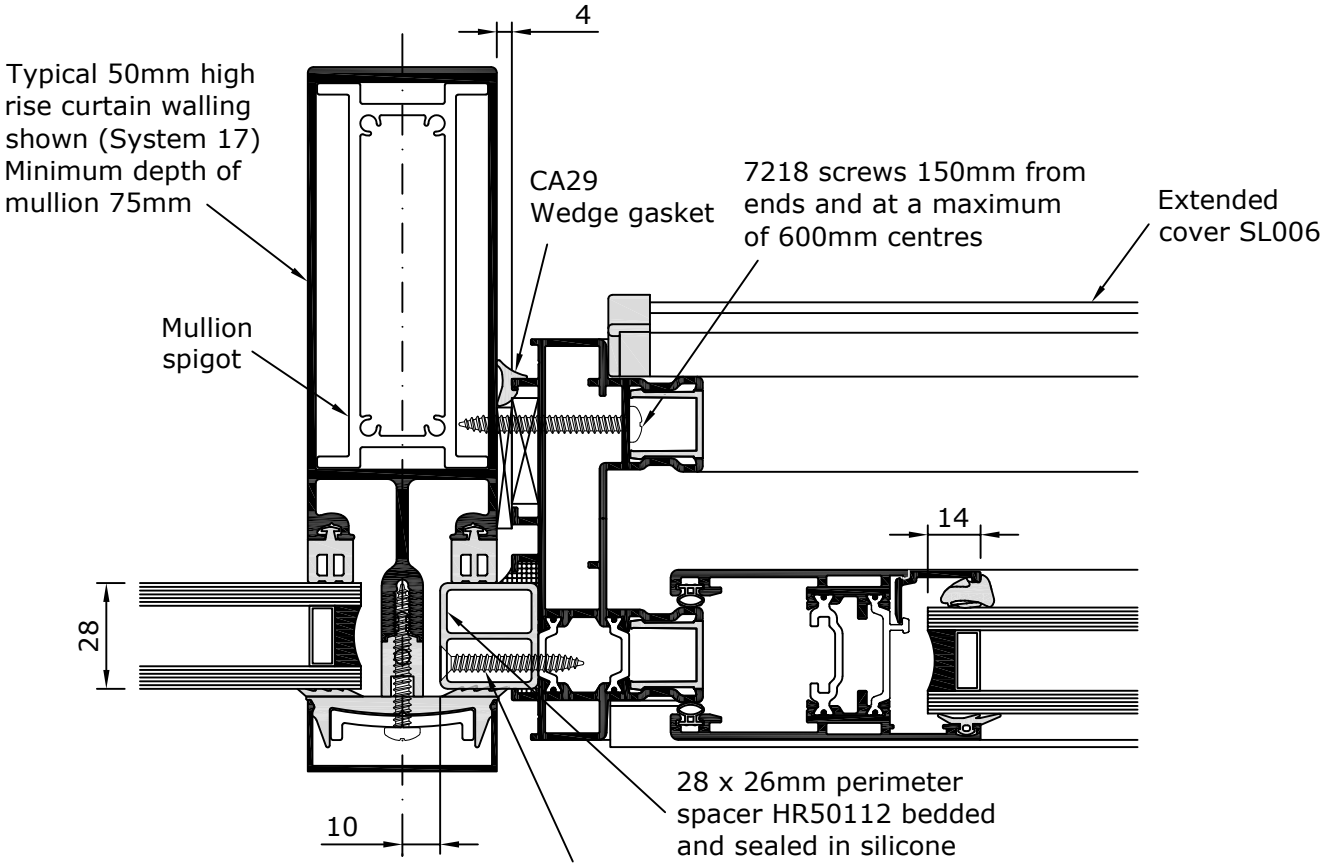


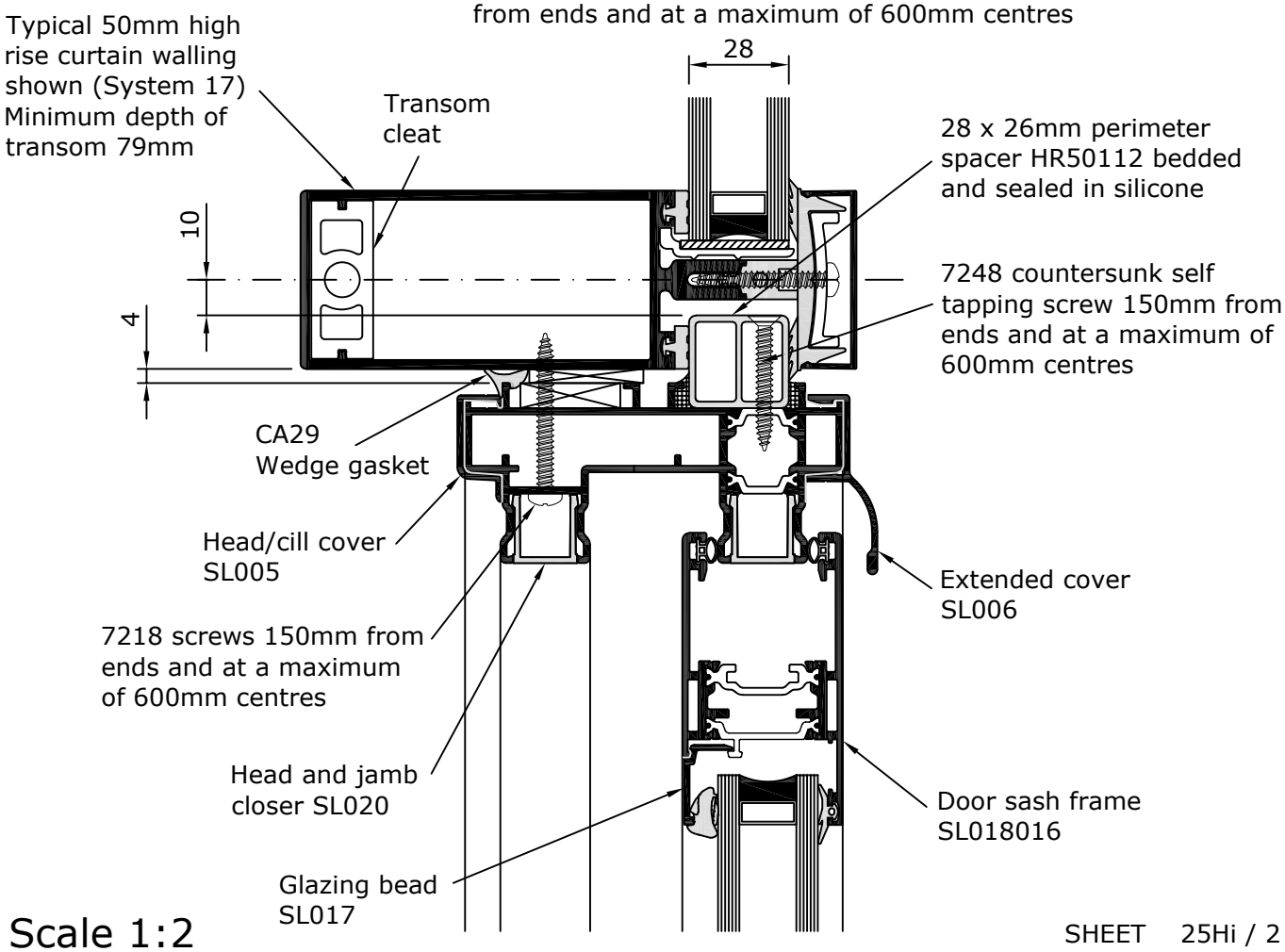
Not to Scale

General Arrangement

Curtain Wall Insert

Refer also to "Typical Fixing Details - Curtain Walling" in Section 8 of this manual for cill detail and structural considerations.





Scale 1:2

General Arrangement

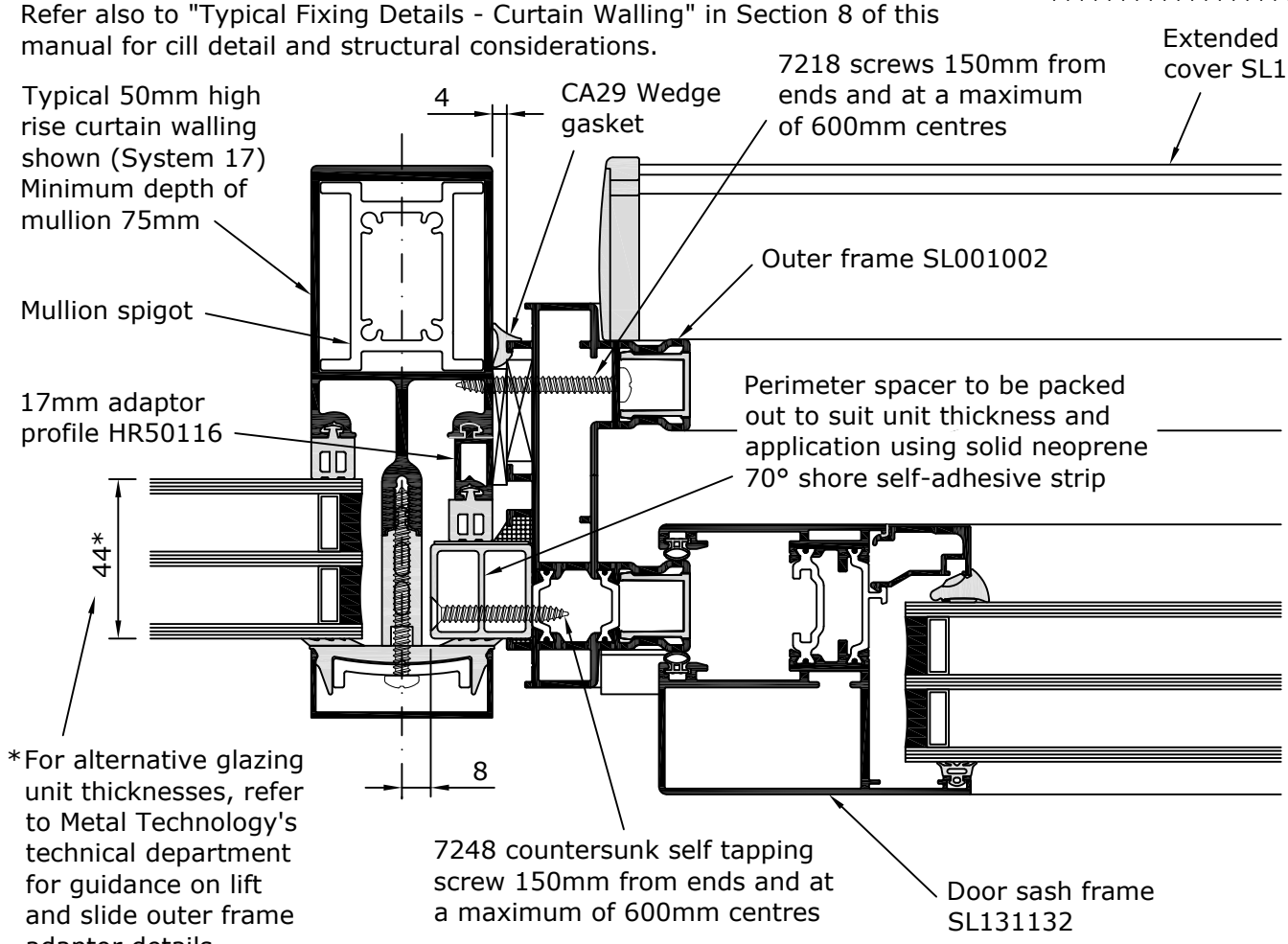
Curtain Wall Insert

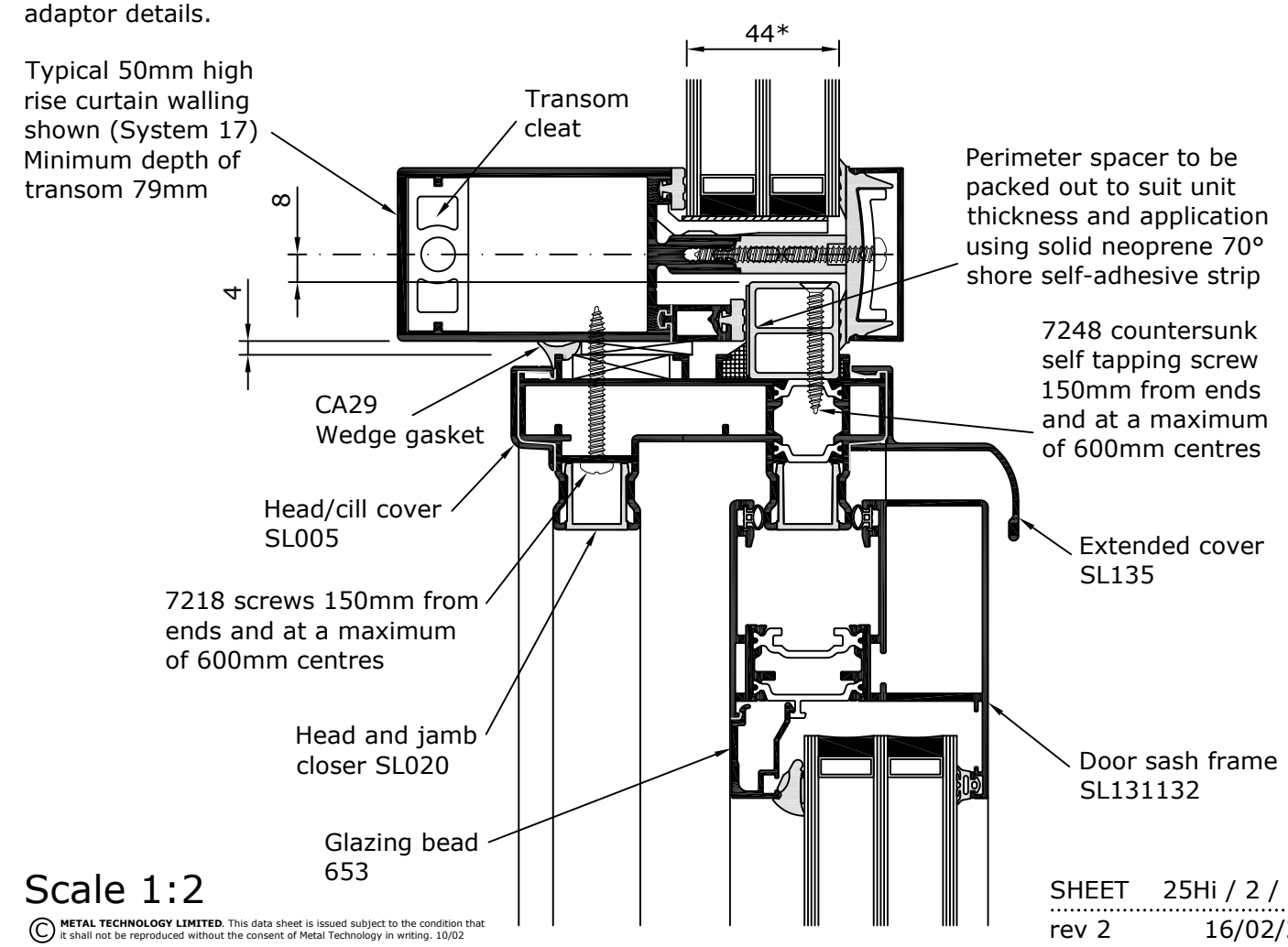
System 25 Hi

LIFT AND SLIDE DOOR

2T

Refer also to "Typical Fixing Details - Curtain Walling" in Section 8 of this manual for cill detail and structural considerations.





Scale 1:2

General Arrangement

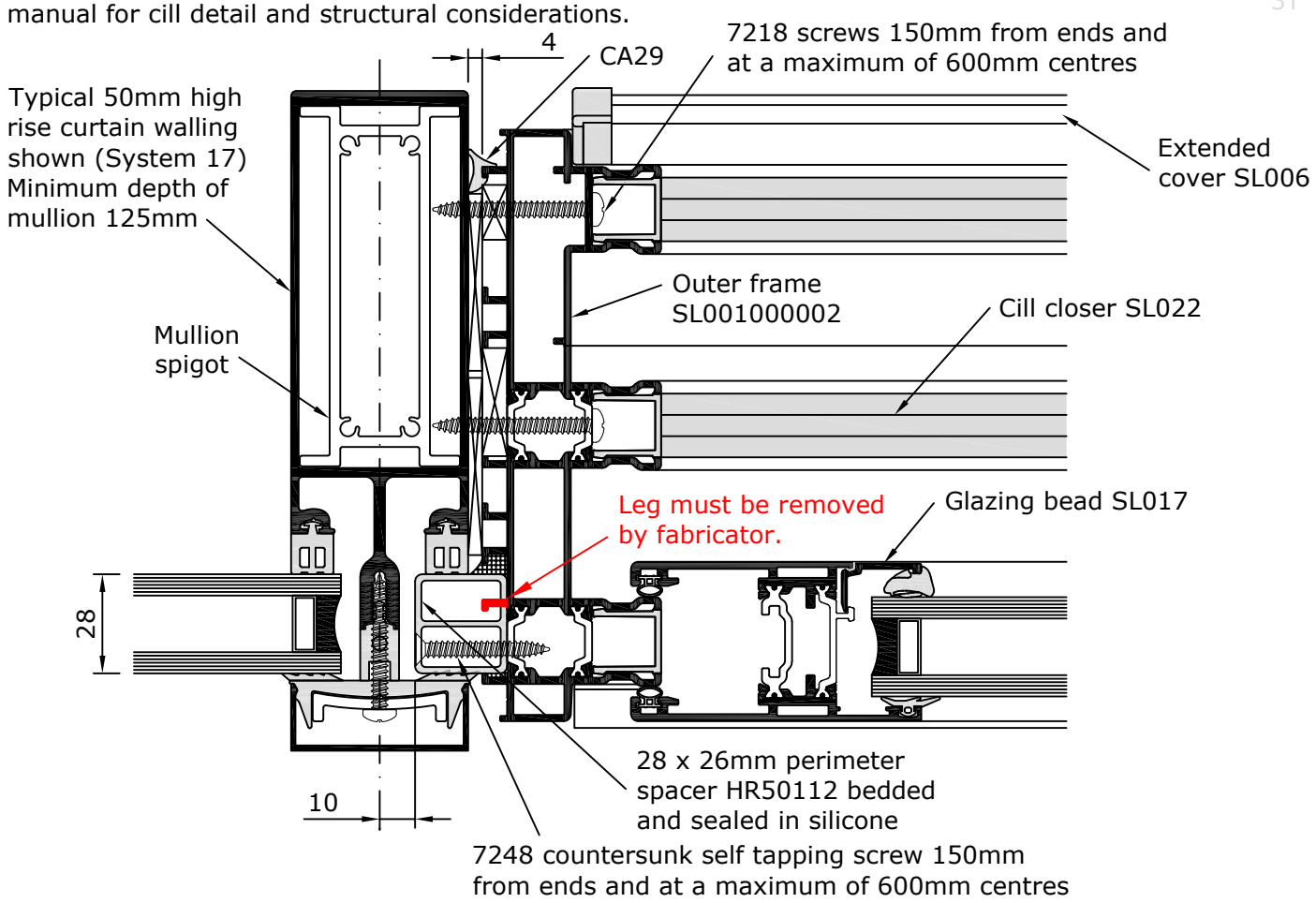
Curtain Wall Insert

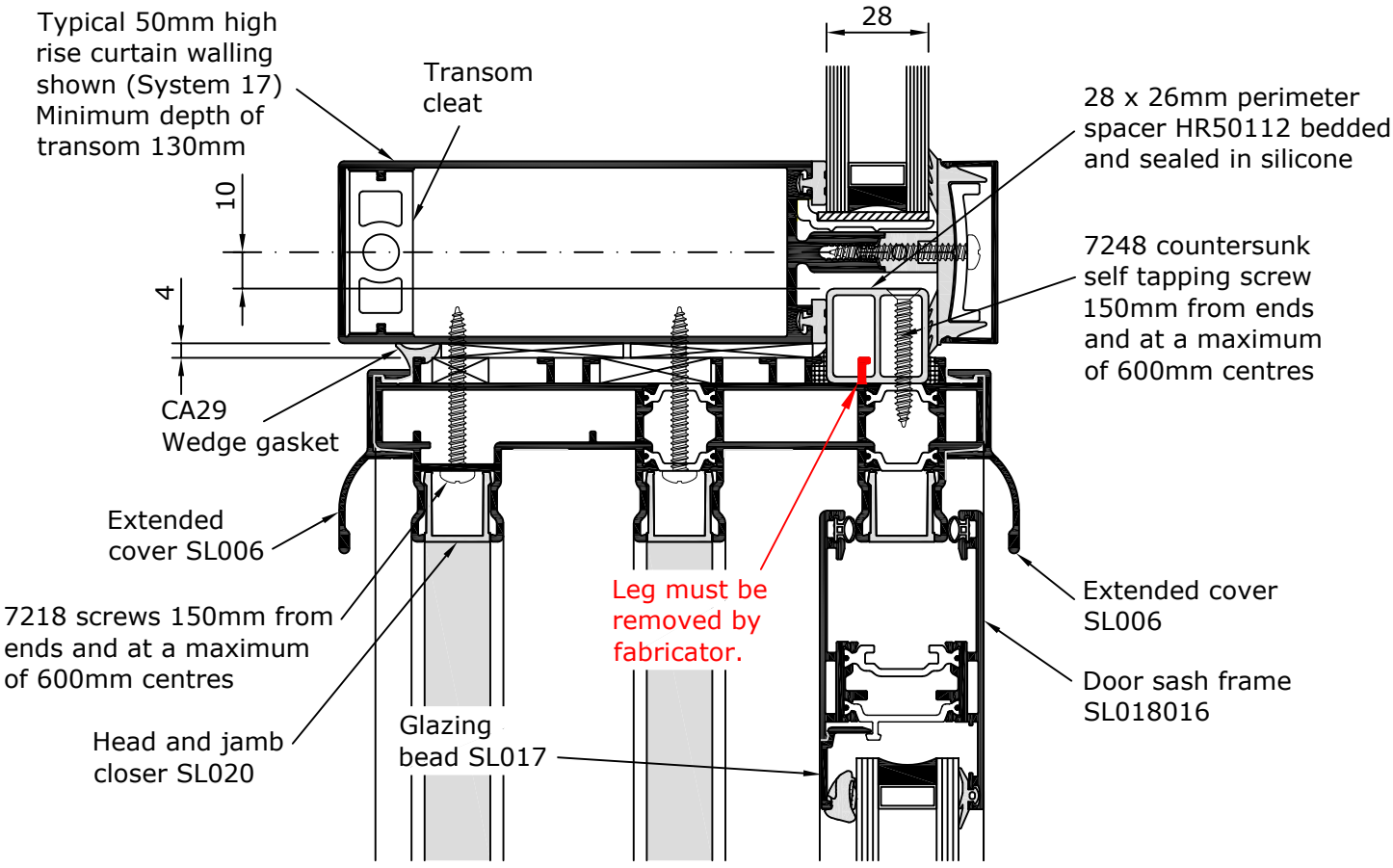
Refer also to "Typical Fixing Details - Curtain Walling" in Section 8 of this manual for cill detail and structural considerations.

System 25 Hi

LIFT AND SLIDE DOOR

3T





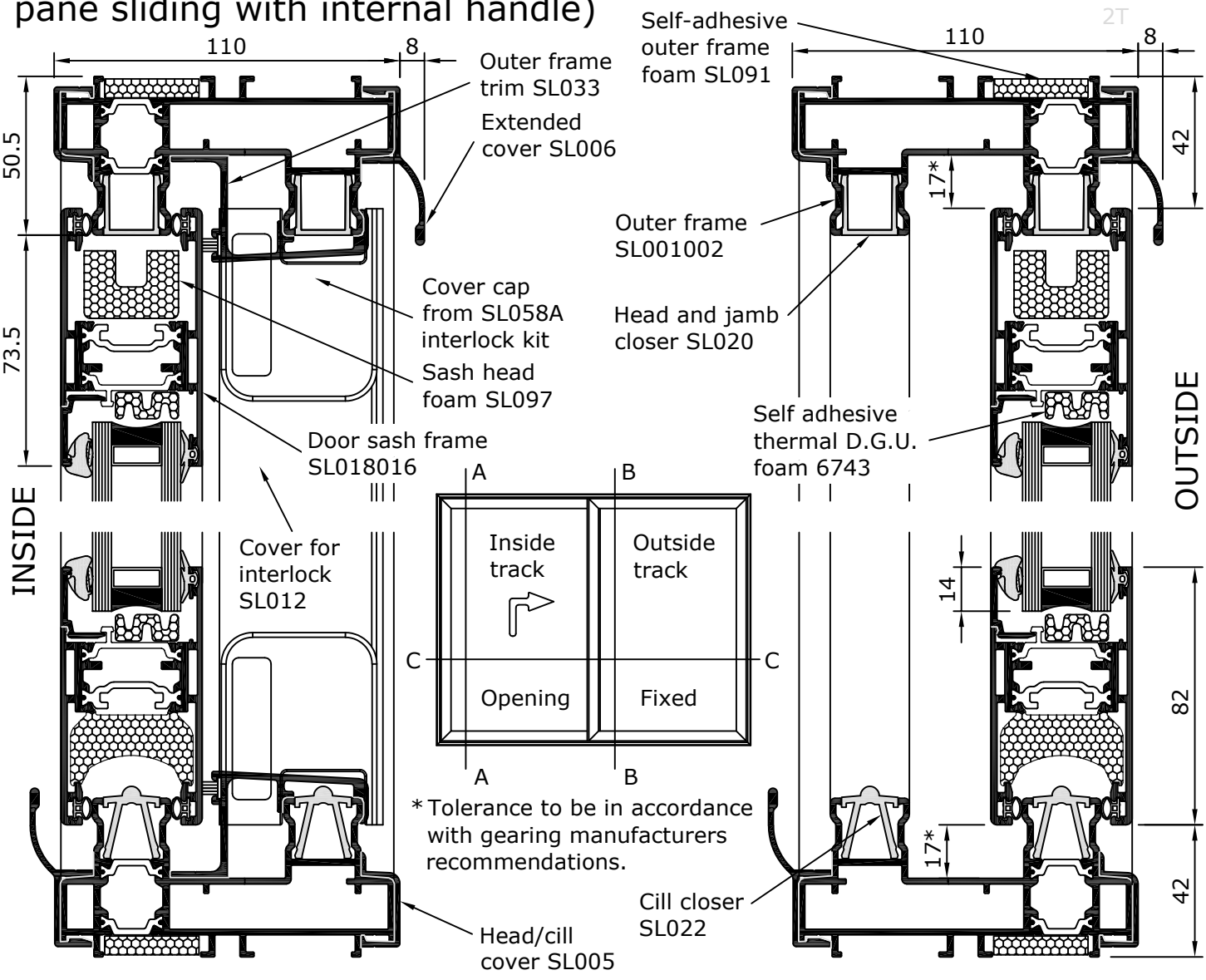
Scale 1:2

General Arrangement

1 Pane Lift and Slide / 1 Pane Fixed (Inside pane sliding with internal handle)

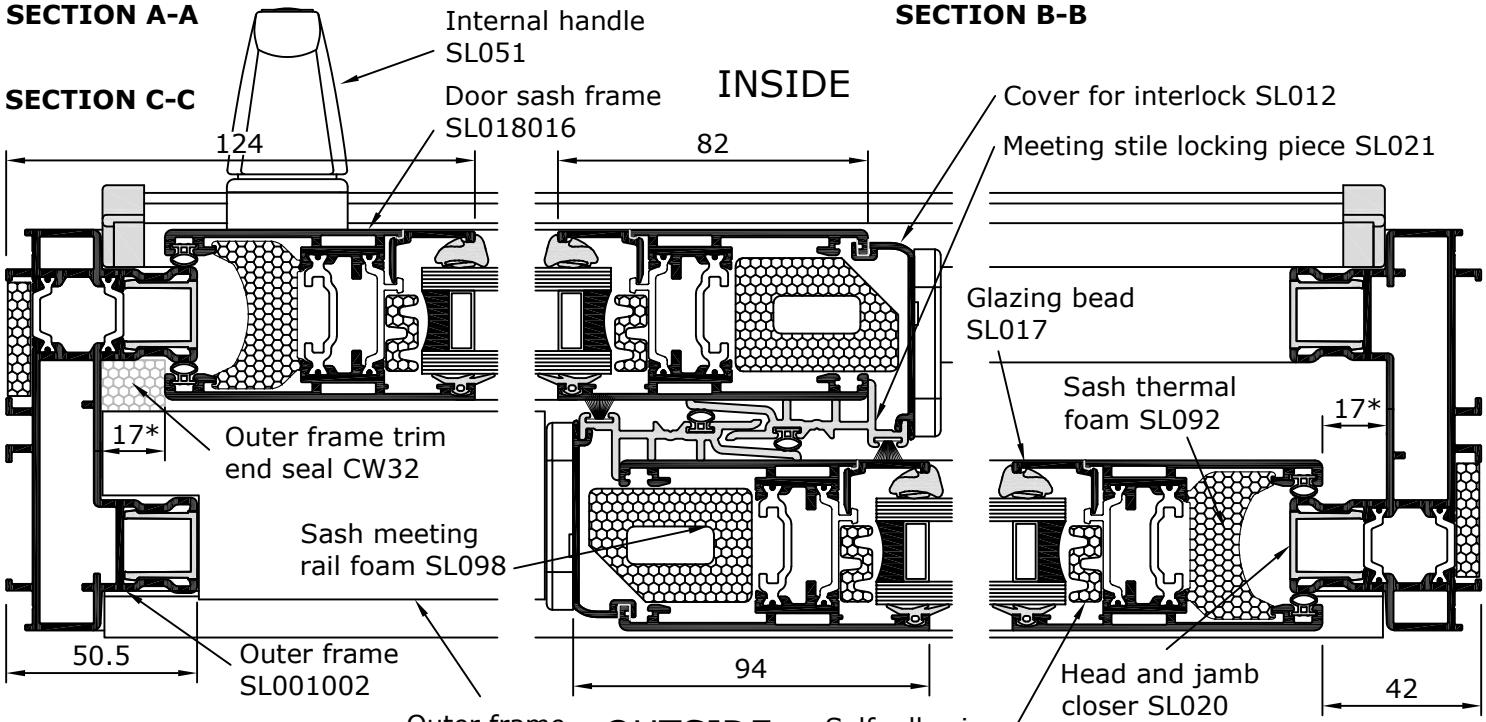
System 25 Hi+

LIFT AND SLIDE DOOR



SECTION A-A

SECTION C-C



SECTION B-B

Scale 1:2

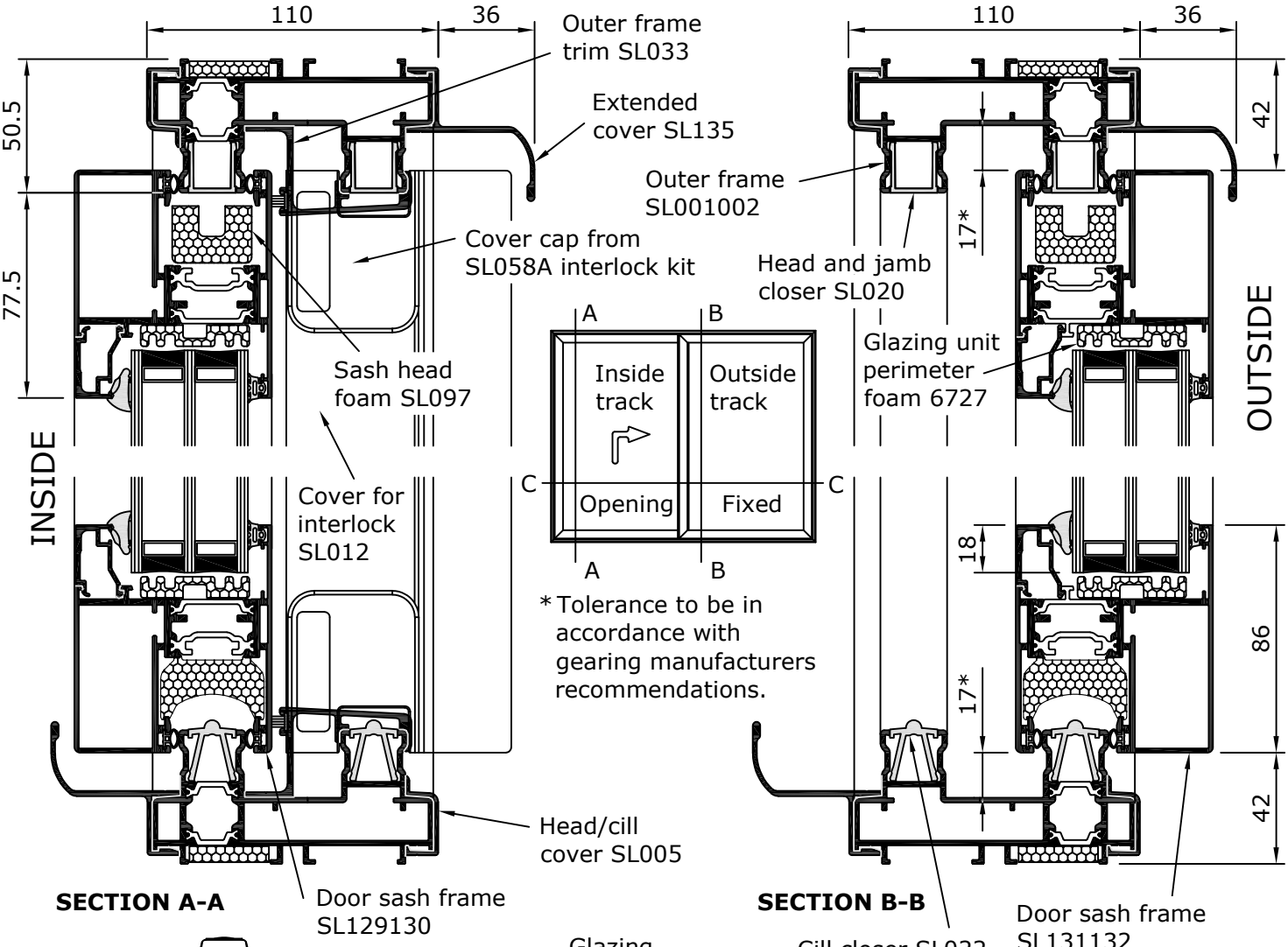
General Arrangement

1 Pane Lift and Slide / 1 Pane Fixed (Inside pane sliding with internal handle)

System 25 Hi+

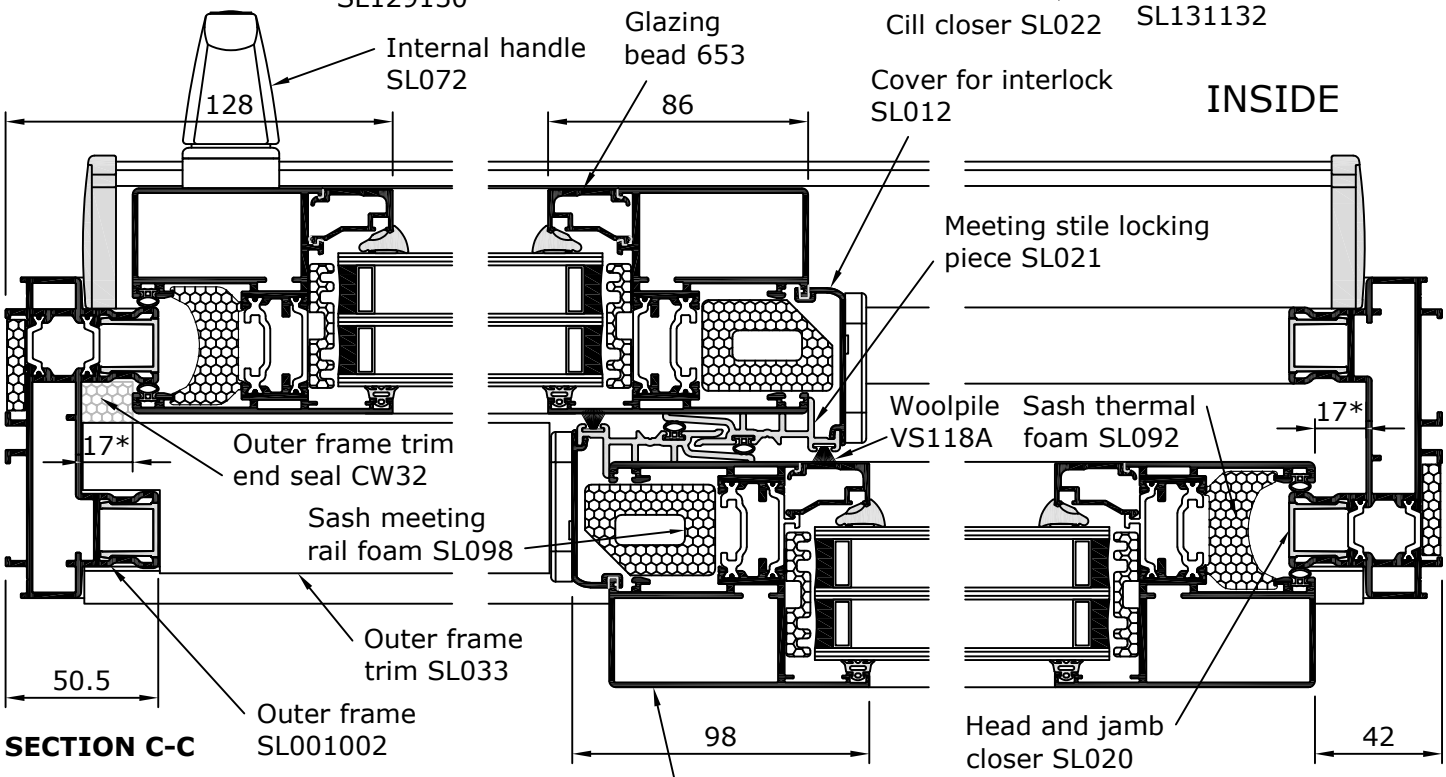
LIFT AND SLIDE DOOR

2T



SECTION A-A

SECTION B-B



SECTION C-C

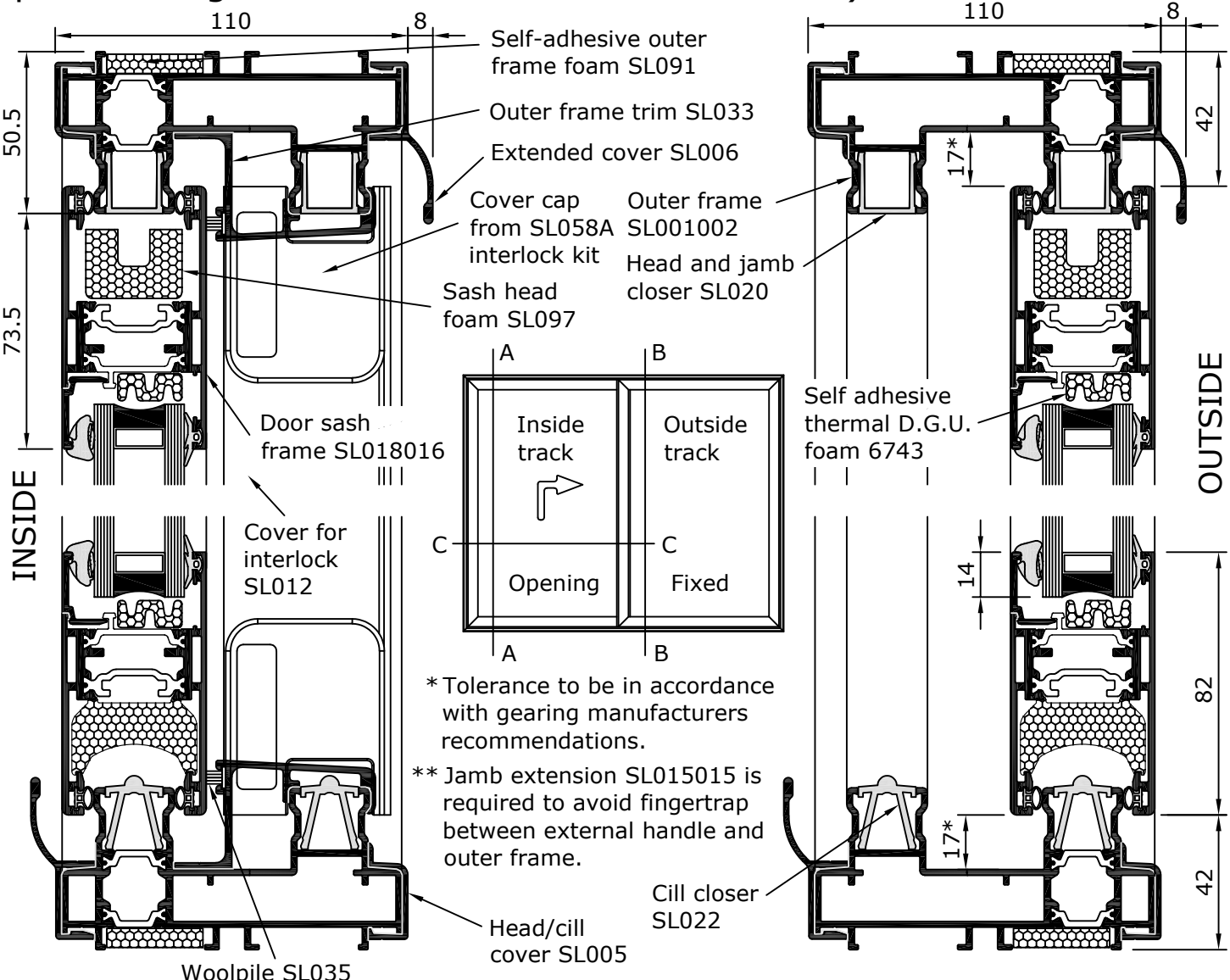
Not to Scale

General Arrangement

1 Pane Lift and Slide / 1 Pane Fixed (Inside pane sliding with internal and external handles)

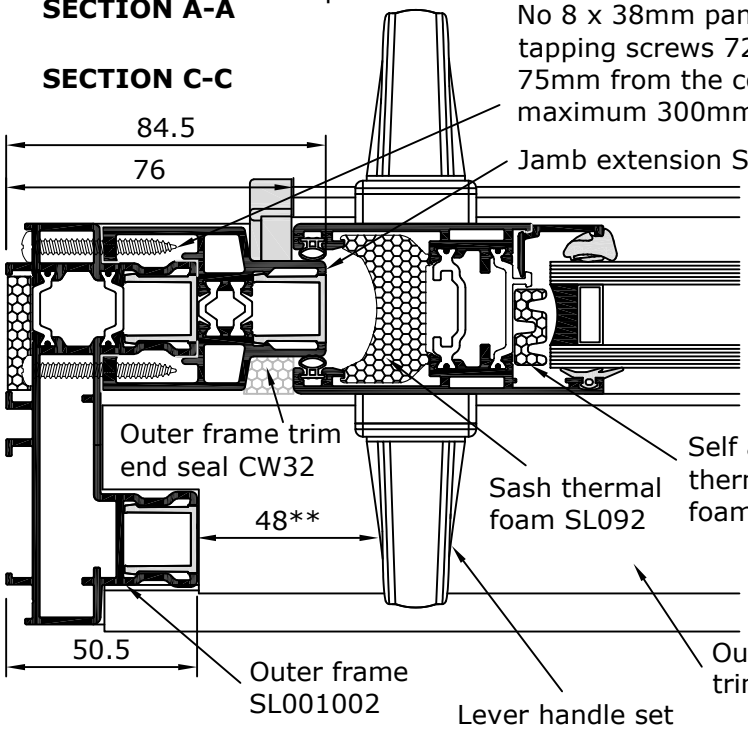
System 25 Hi+

LIFT AND SLIDE DOOR

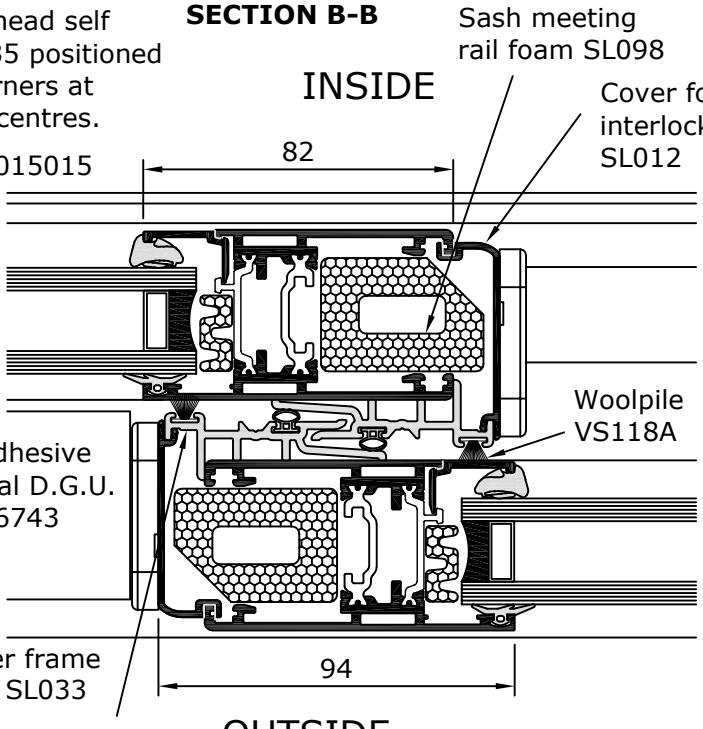


SECTION A-A

SECTION C-C



SECTION B-B



Scale 1:2

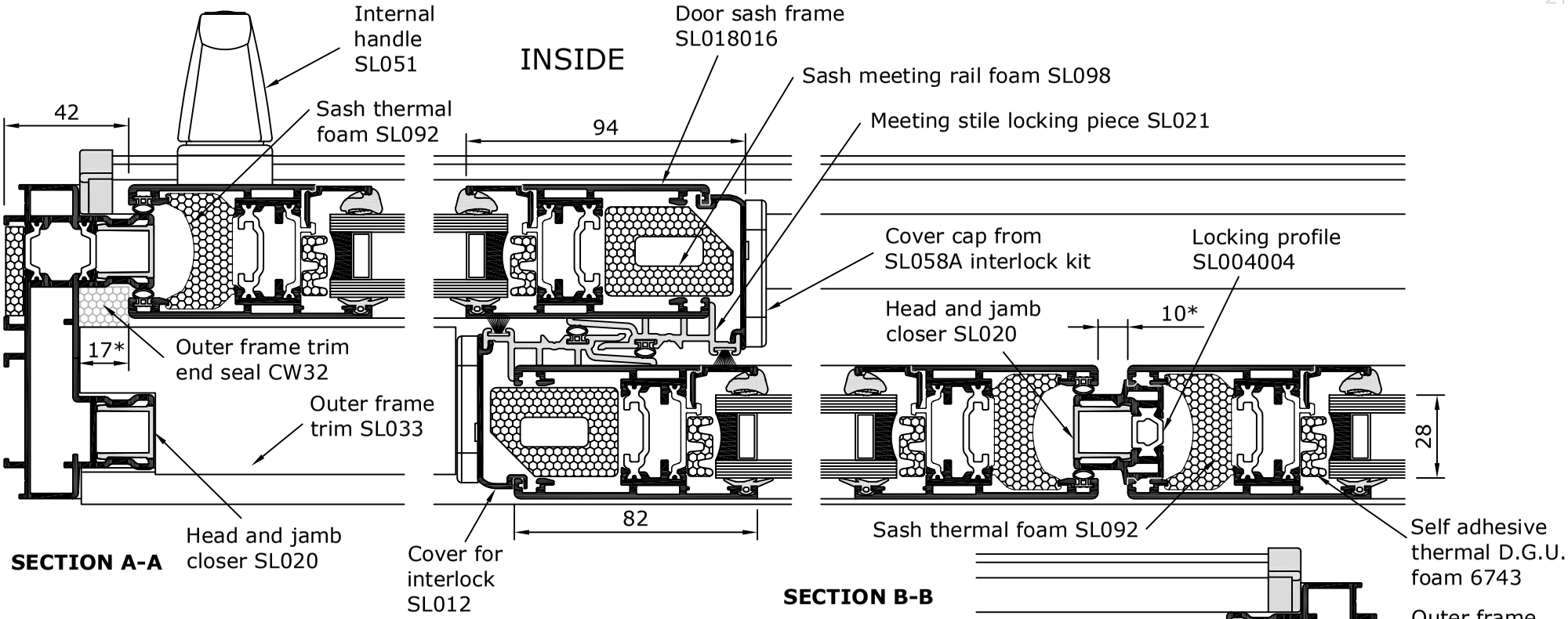
General Arrangement

Lift and Slide / Fixed / Fixed (Inside pane sliding with internal handle)

System 25 Hi+

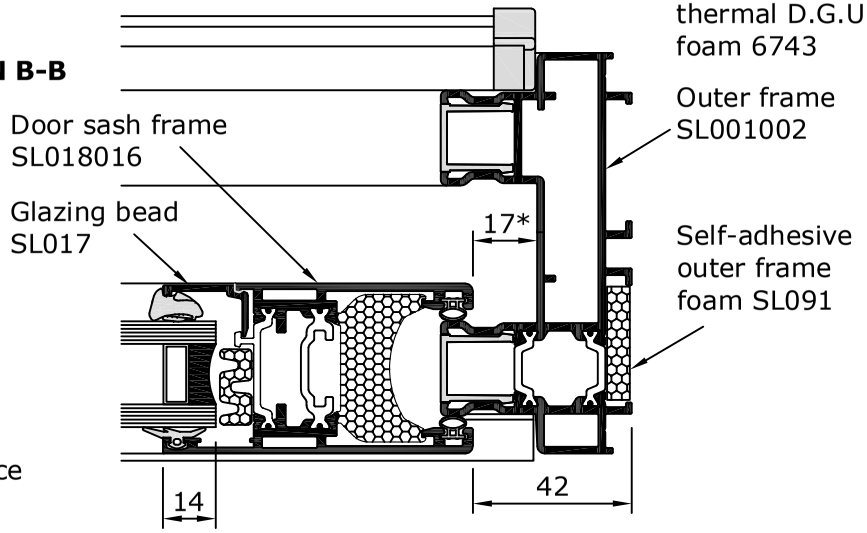
LIFT AND SLIDE DOOR

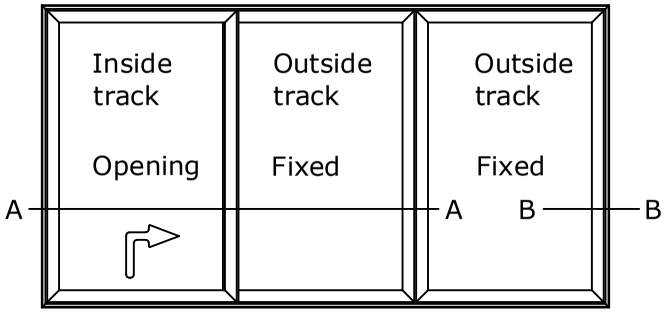
2T



SECTION A-A

SECTION B-B





*Tolerance to be in accordance with gearing manufacturers recommendations.

OUTSIDE

Scale 1:2

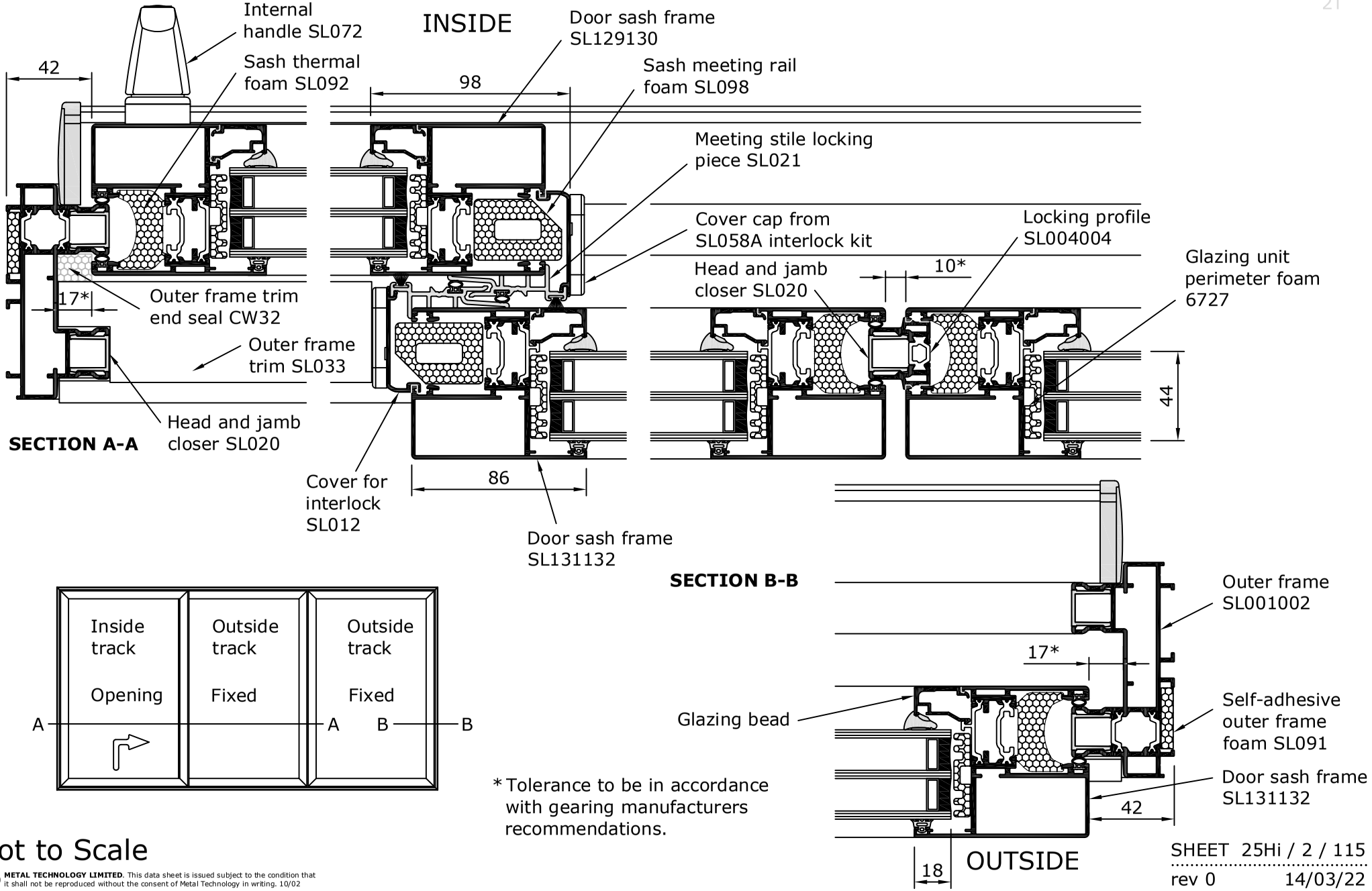
General Arrangement

Lift and Slide / Fixed / Fixed (Inside pane sliding with internal handle)

System 25 Hi+

LIFT AND SLIDE DOOR

2T



* Tolerance to be in accordance with gearing manufacturers recommendations.

Not to Scale

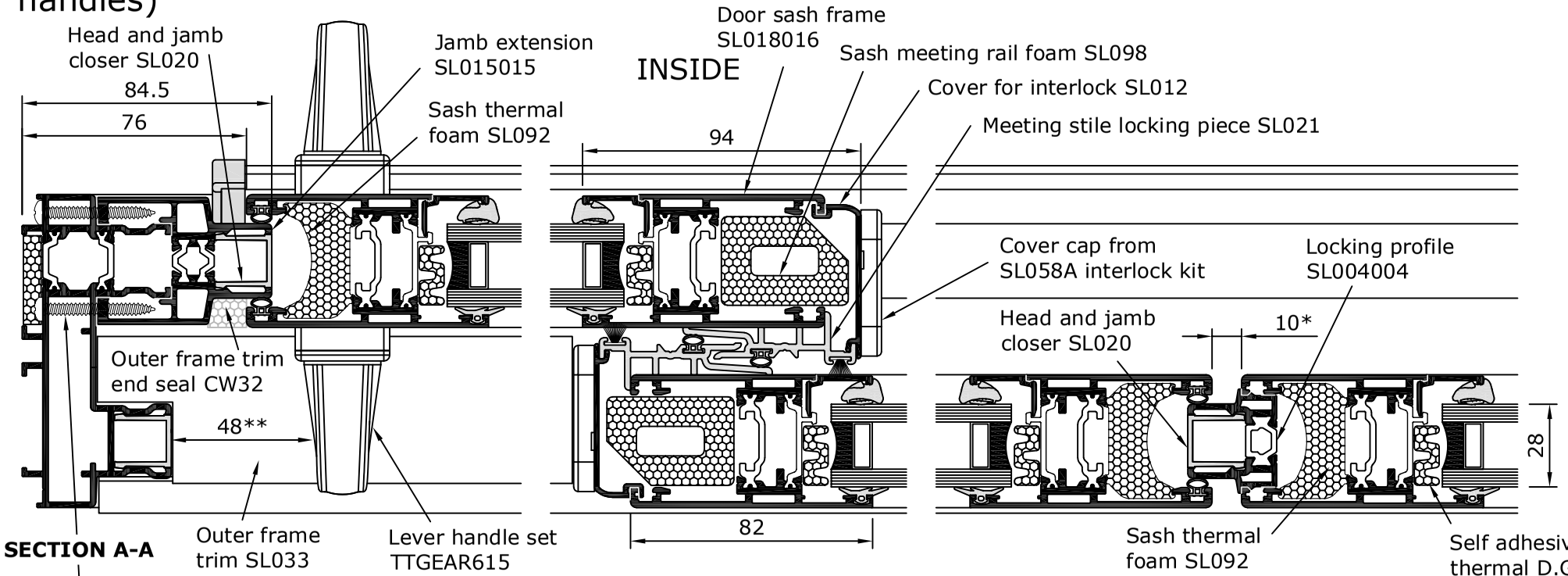
General Arrangement

Lift and Slide / Fixed / Fixed (Inside pane sliding with internal and external handles)

System 25 Hi+

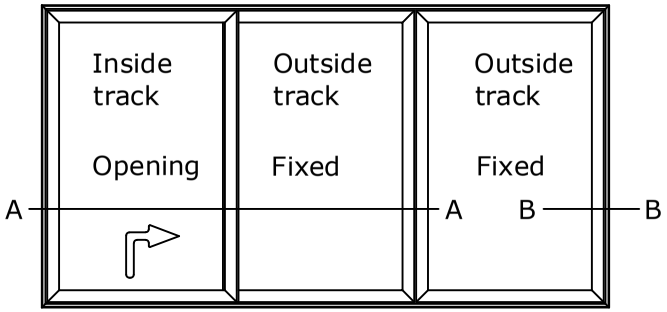
LIFT AND SLIDE DOOR

2T

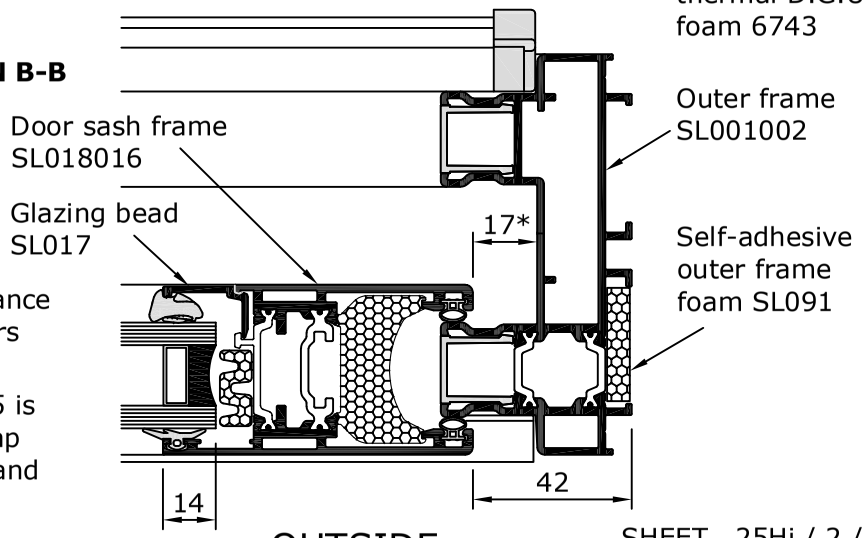


SECTION A-A

No 8 x 38mm pan head self tapping screws 7235 positioned 75mm from the corners at maximum 300mm centres.



SECTION B-B



* Tolerance to be in accordance with gearing manufacturers recommendations.

** Jamb extension SL015015 is required to avoid fingertrap between external handle and outer frame.

Scale 1:2

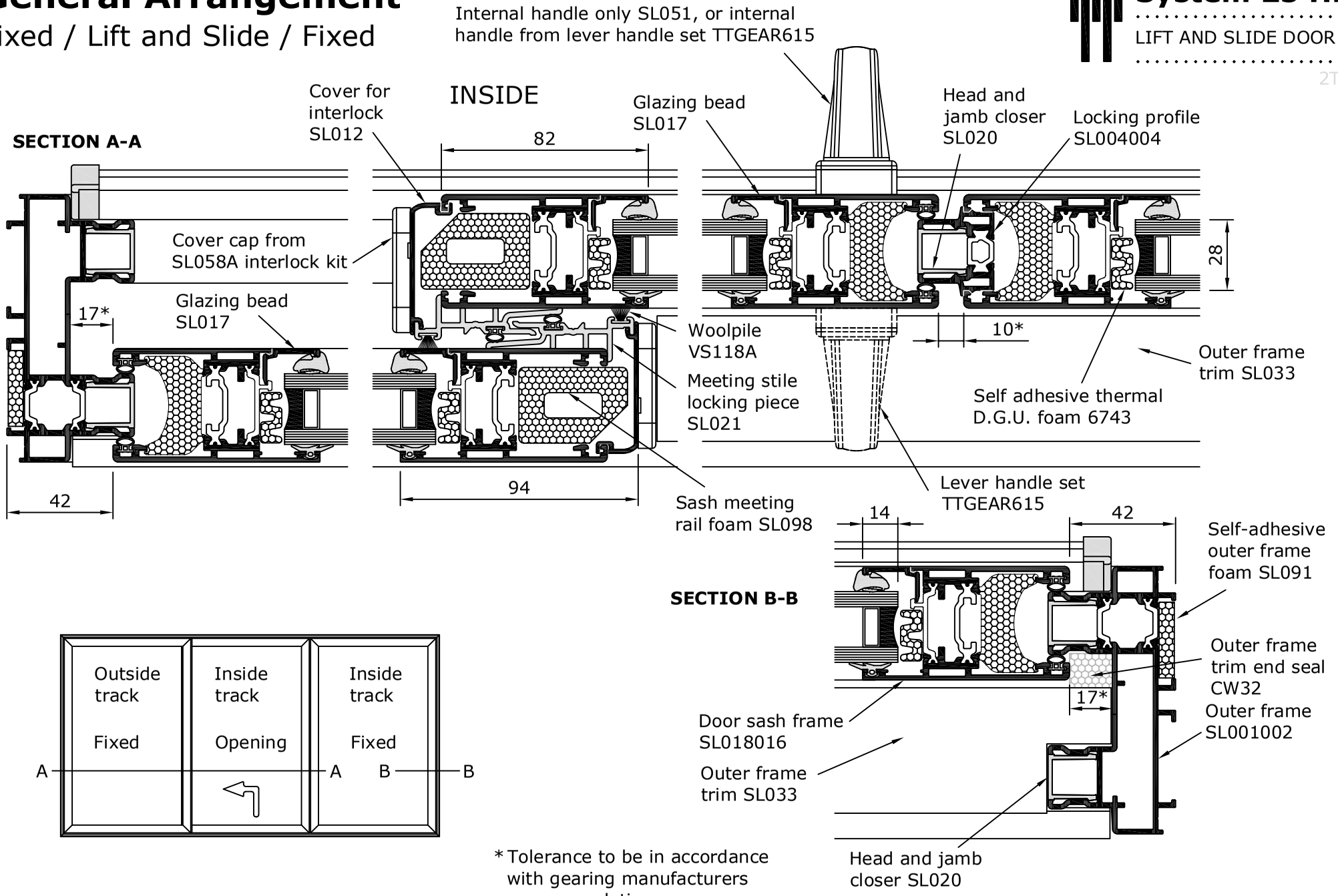
General Arrangement

Fixed / Lift and Slide / Fixed

System 25 Hi+

LIFT AND SLIDE DOOR

2T



*Tolerance to be in accordance with gearing manufacturers recommendations.

Scale 1:2

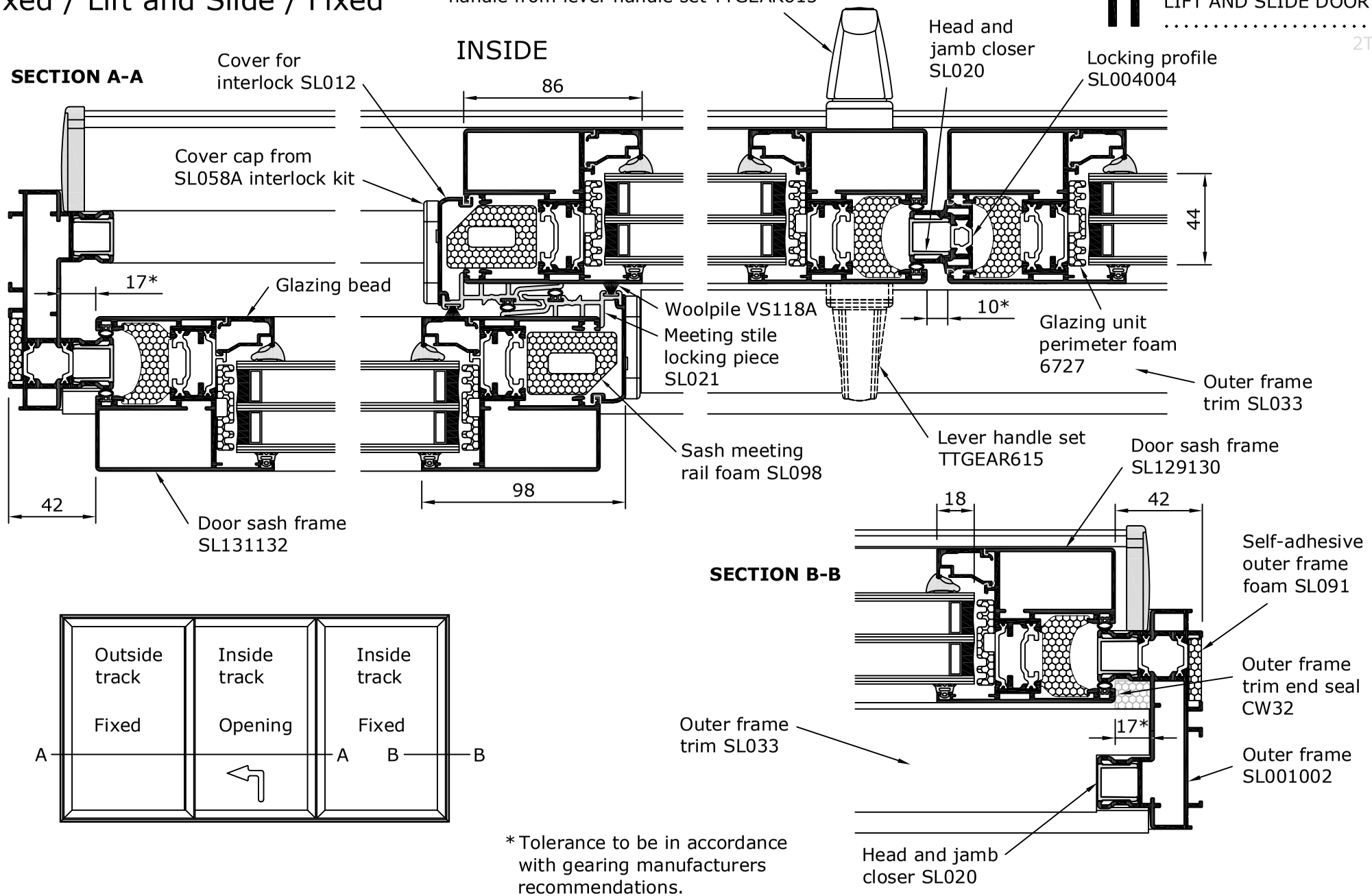
General Arrangement

Fixed / Lift and Slide / Fixed

System 25 Hi+

LIFT AND SLIDE DOOR

2T



*Tolerance to be in accordance with gearing manufacturers recommendations.

Not to Scale

General Arrangement

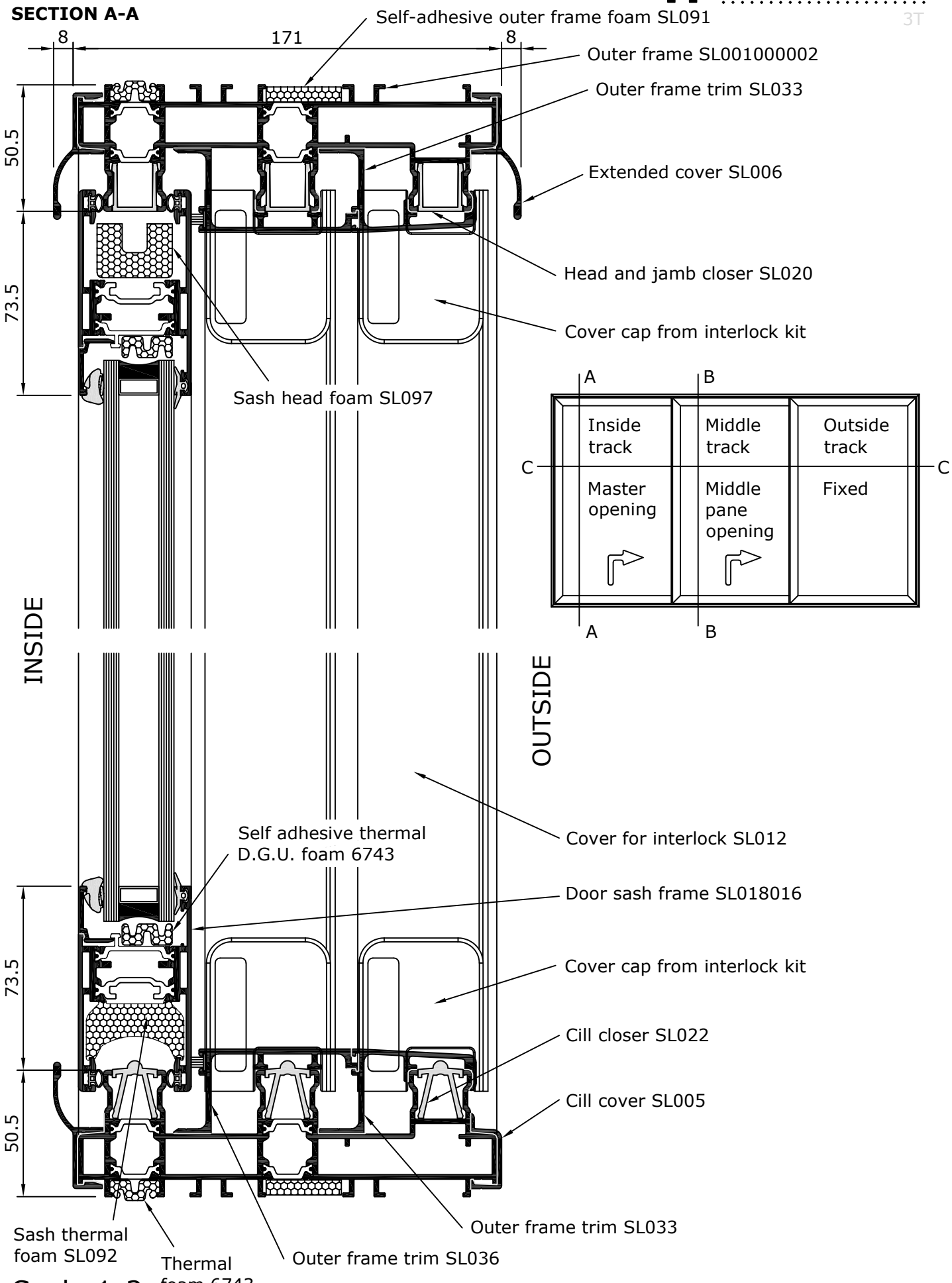
Triple Track Lift and Slide Door

System 25 Hi+

LIFT AND SLIDE DOOR

3T

SECTION A-A



Scale 1:2

General Arrangement

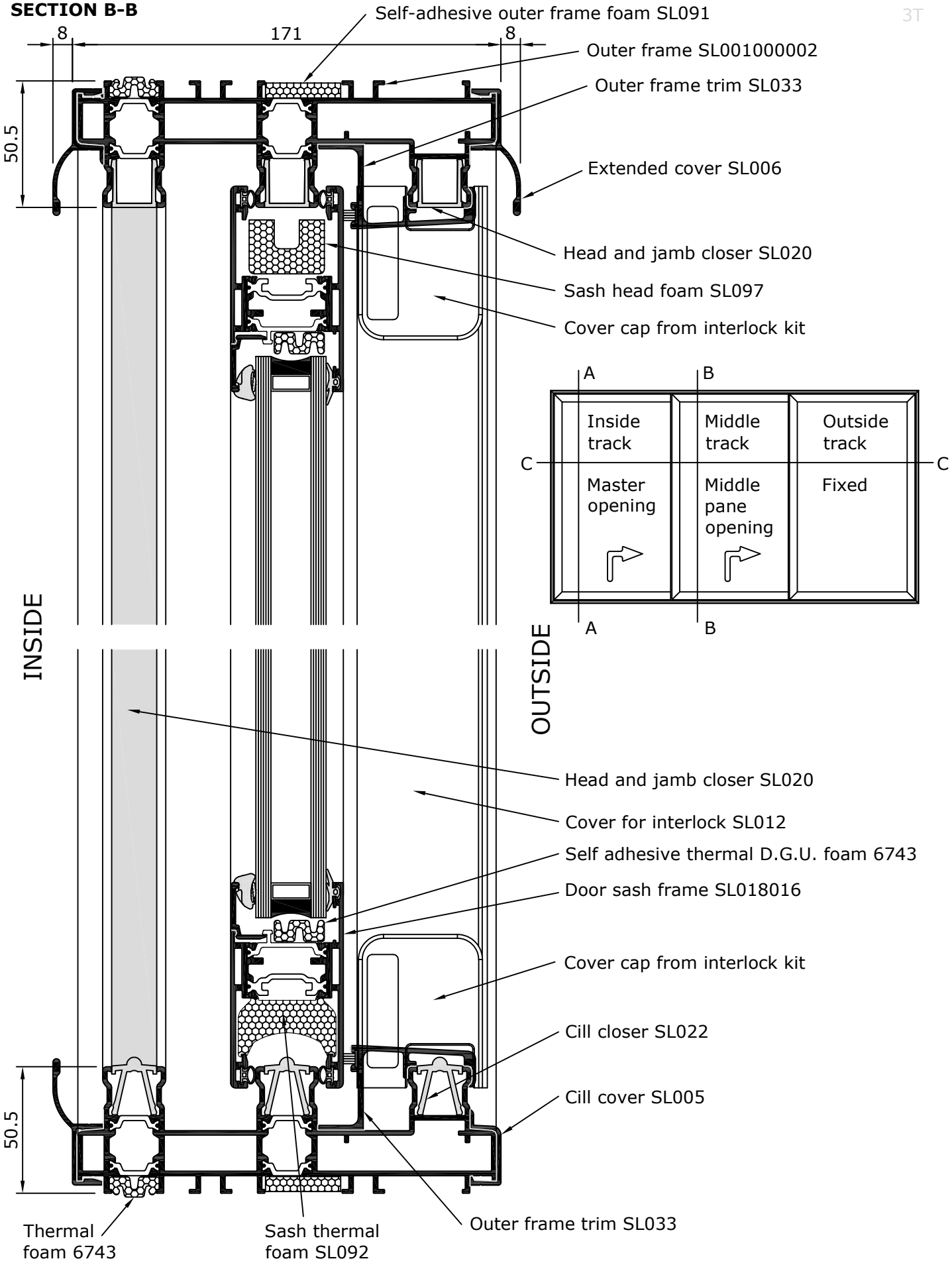
Triple Track Lift and Slide Door

System 25 Hi+

LIFT AND SLIDE DOOR

3T

SECTION B-B



Scale 1:2

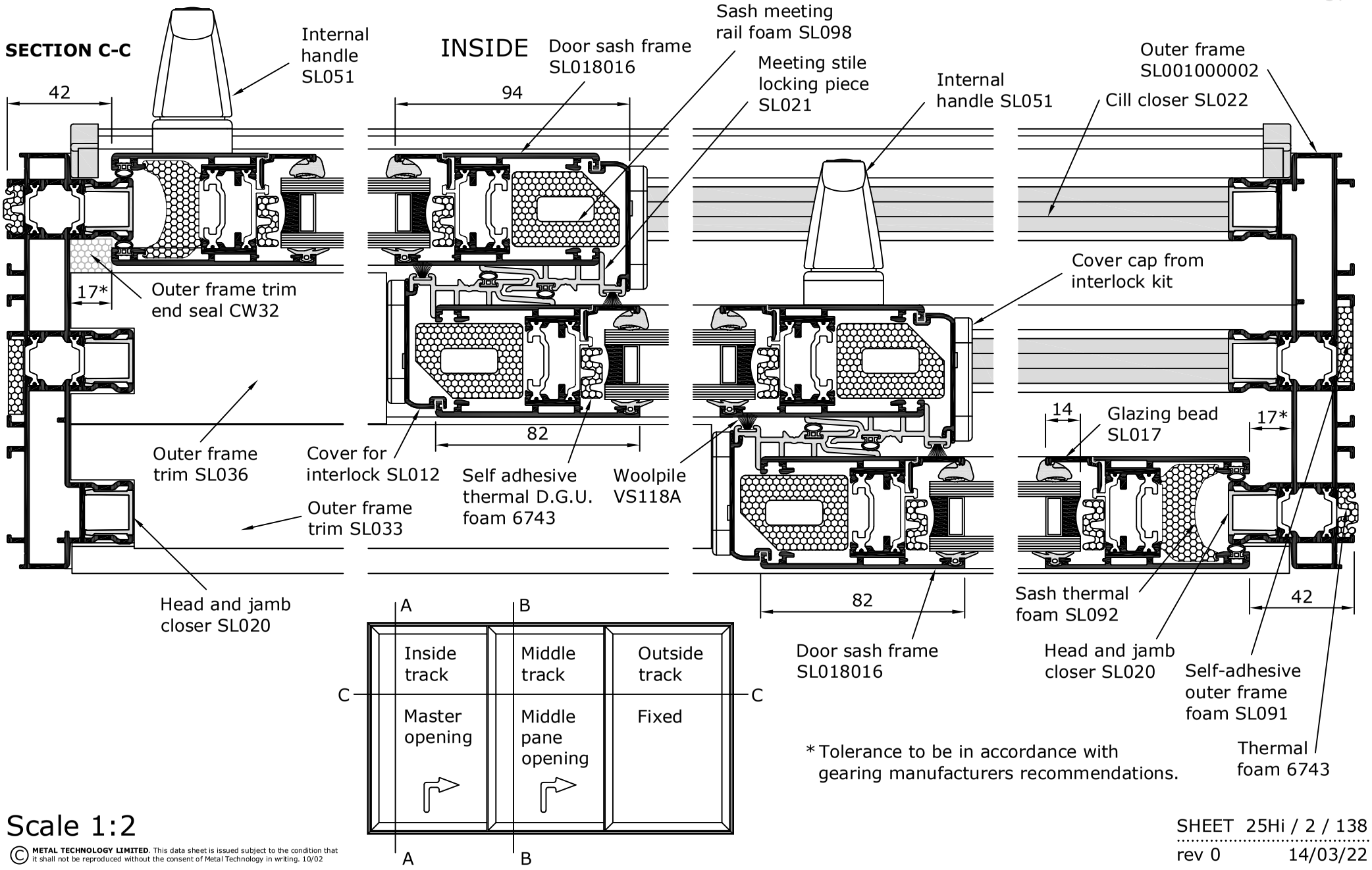
General Arrangement

Triple Track Lift and Slide Door (Internal handle)

System 25 Hi+

LIFT AND SLIDE DOOR

3T



*Tolerance to be in accordance with gearing manufacturers recommendations.

Scale 1:2

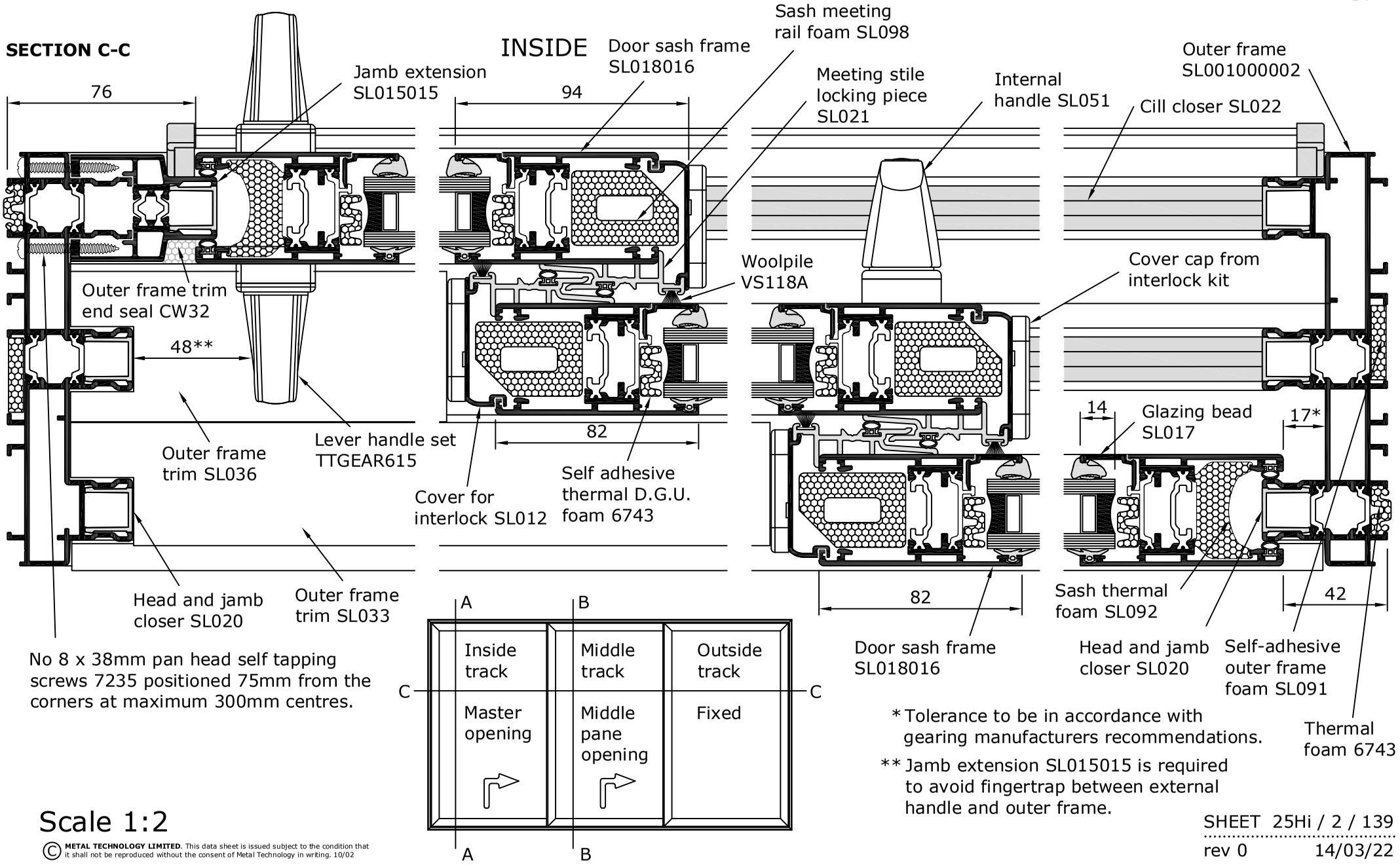
General Arrangement

Triple Track Lift and Slide Door (Internal and external handles)

System 25 Hi+

LIFT AND SLIDE DOOR

3T



* Tolerance to be in accordance with gearing manufacturers recommendations.

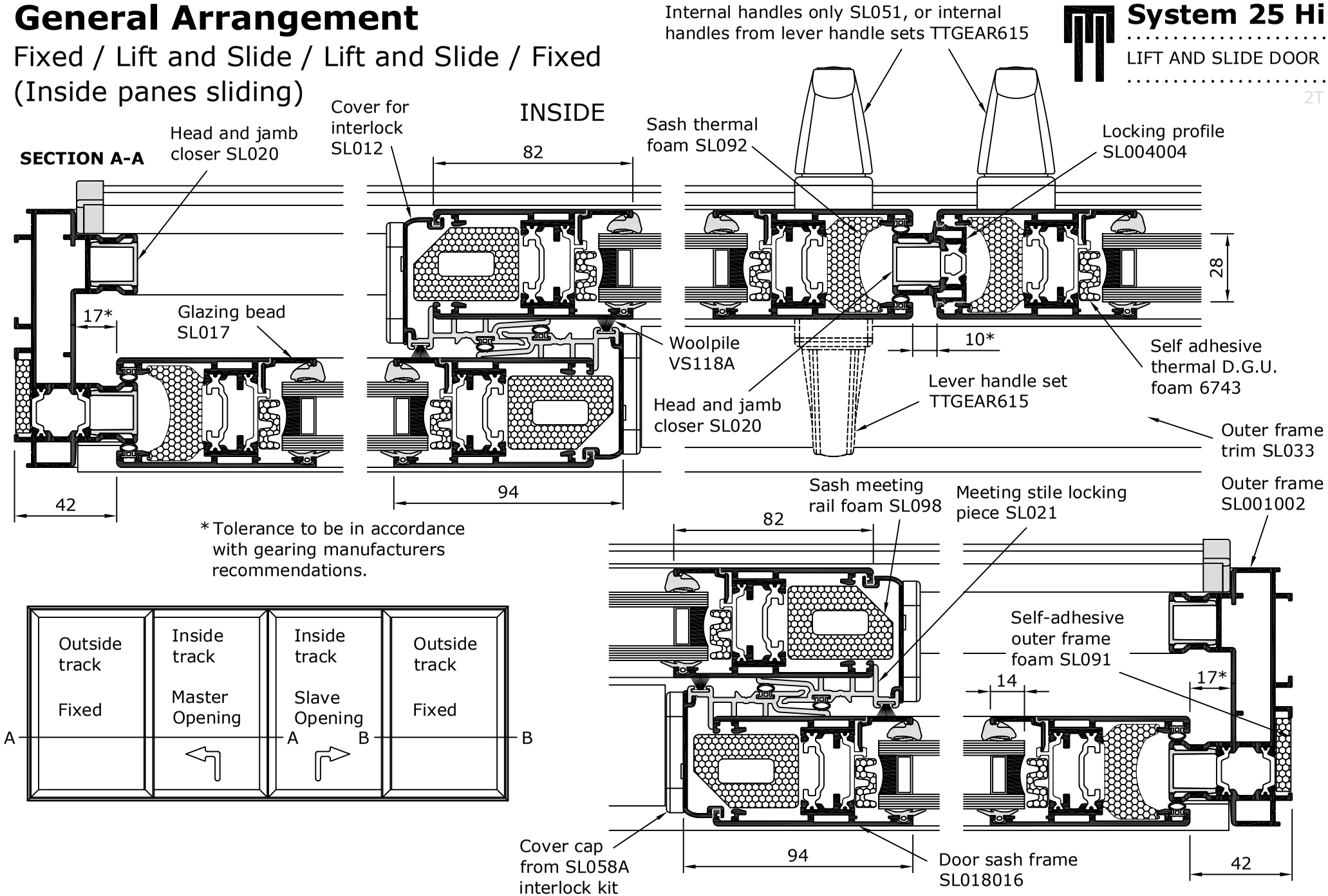
** Jamb extension SL015015 is required to avoid fingertrap between external handle and outer frame.

Scale 1:2

General Arrangement

Fixed / Lift and Slide / Lift and Slide / Fixed
(Inside panes sliding)

System 25 Hi+
LIFT AND SLIDE DOOR
2T



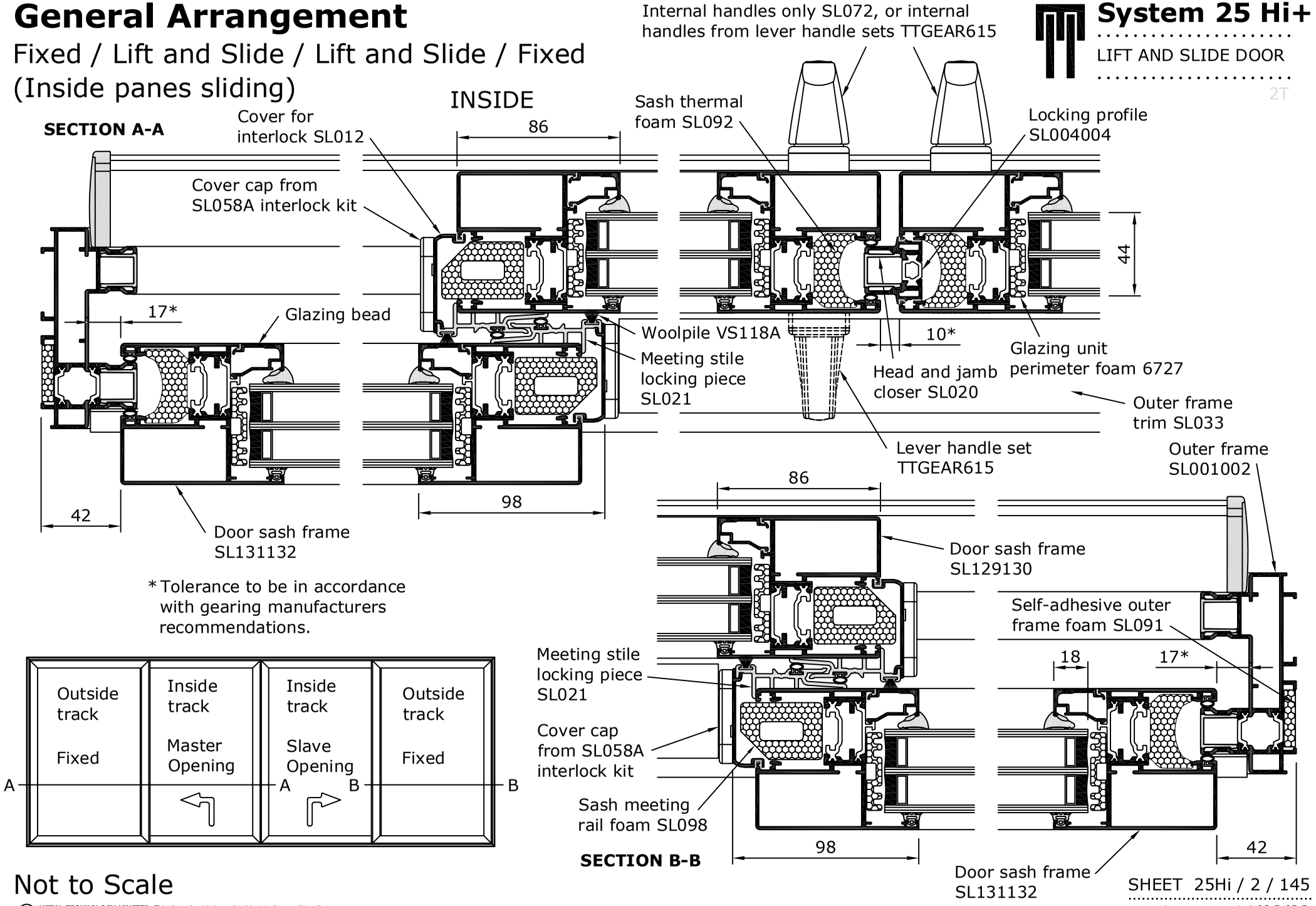
* Tolerance to be in accordance with gearing manufacturers recommendations.

Scale 1:2

General Arrangement

Fixed / Lift and Slide / Lift and Slide / Fixed
(Inside panes sliding)

System 25 Hi+
LIFT AND SLIDE DOOR
2T



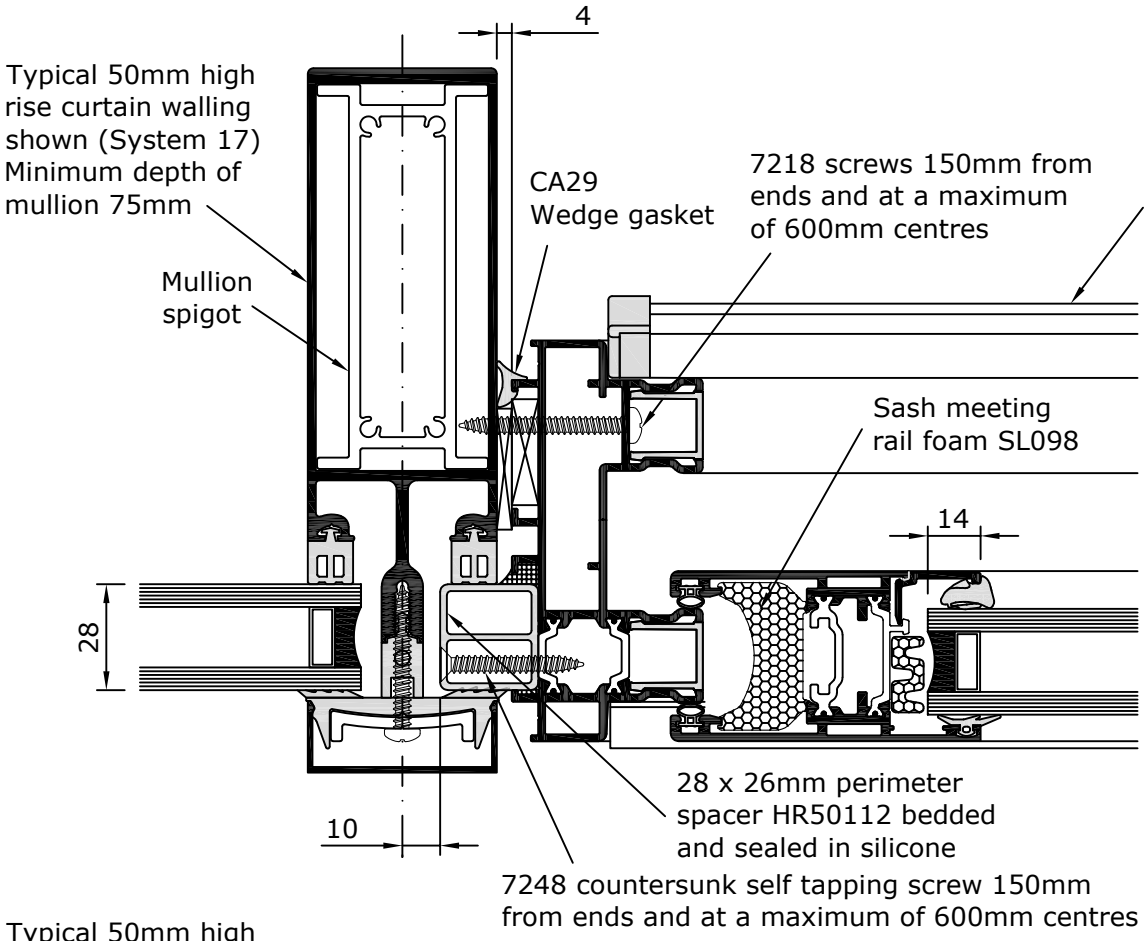
* Tolerance to be in accordance with gearing manufacturers recommendations.

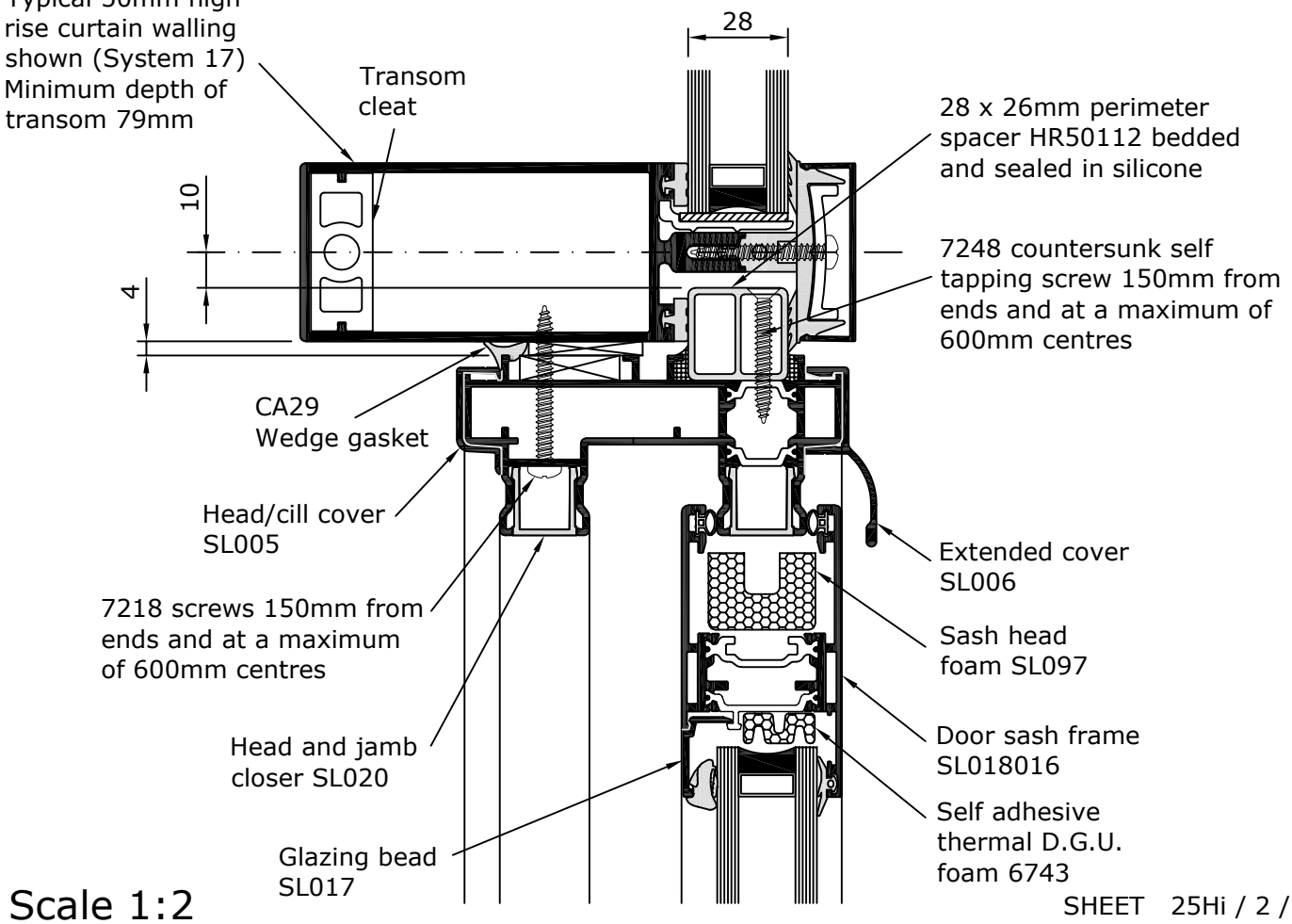
Not to Scale

General Arrangement

Curtain Wall Insert

Refer also to "Typical Fixing Details - Curtain Walling" in Section 8 of this manual for cill detail and structural considerations.



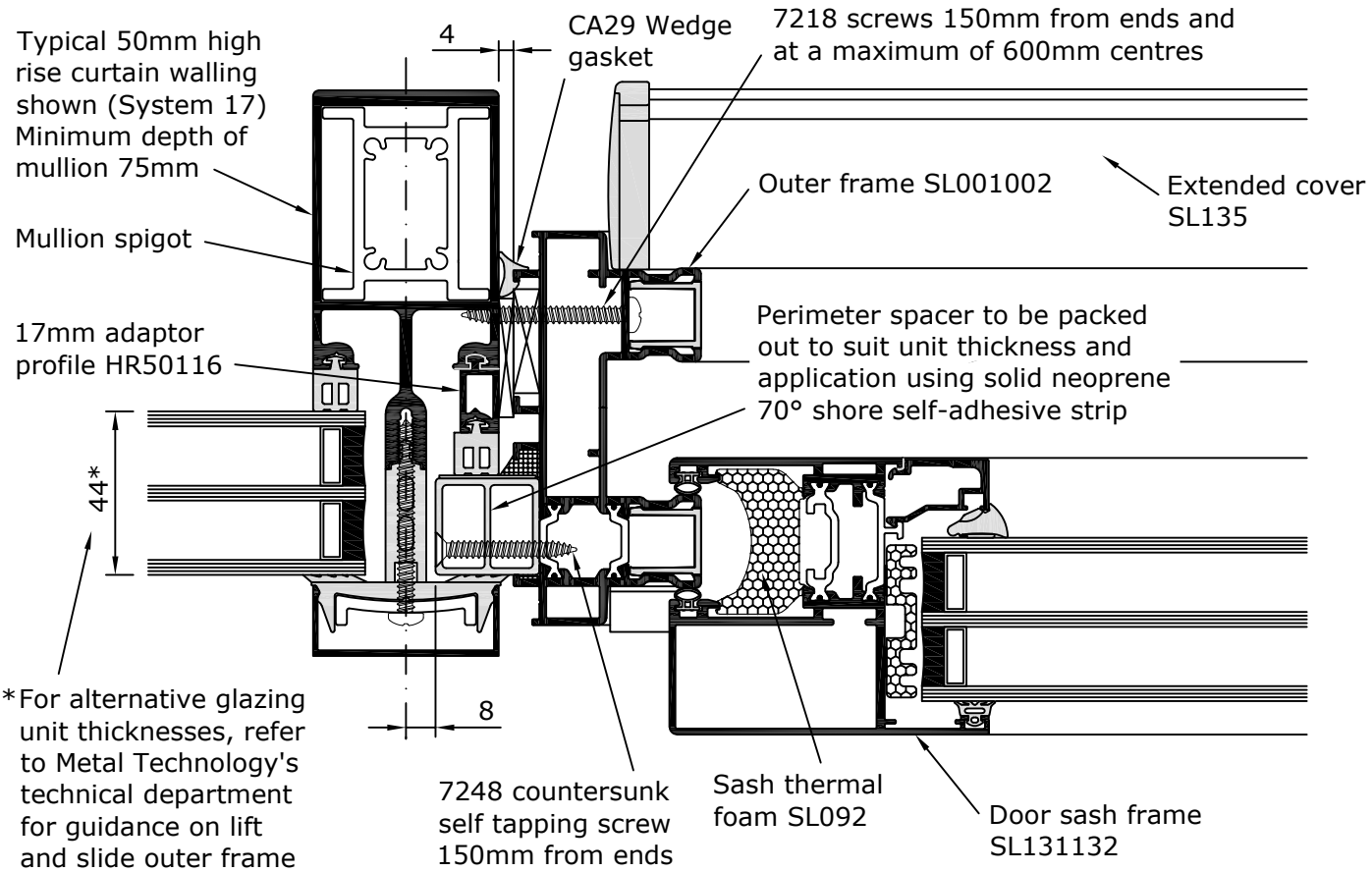


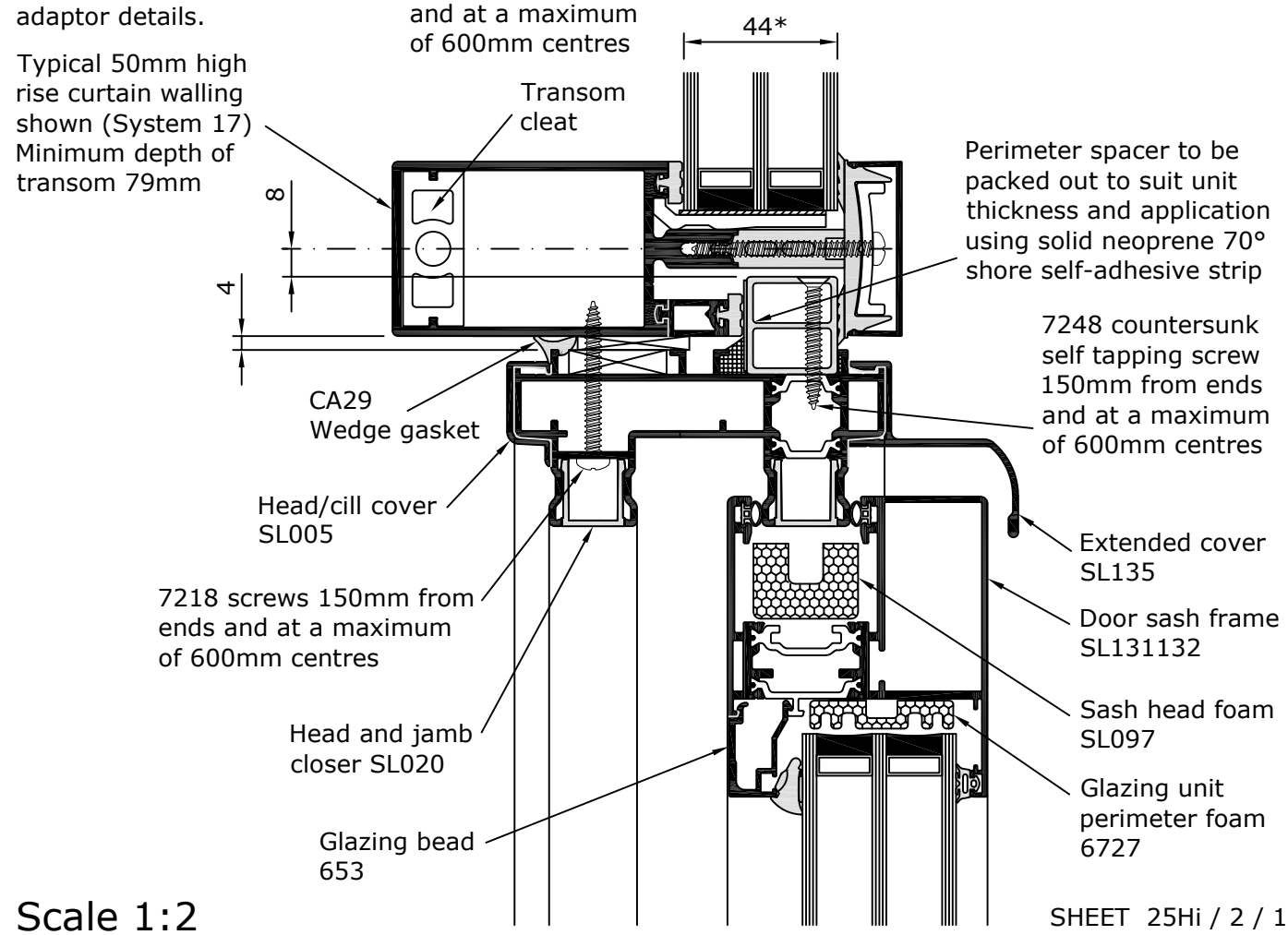
Scale 1:2

General Arrangement

Curtain Wall Insert

Refer also to "Typical Fixing Details - Curtain Walling" in Section 8 of this manual for cill detail and structural considerations.



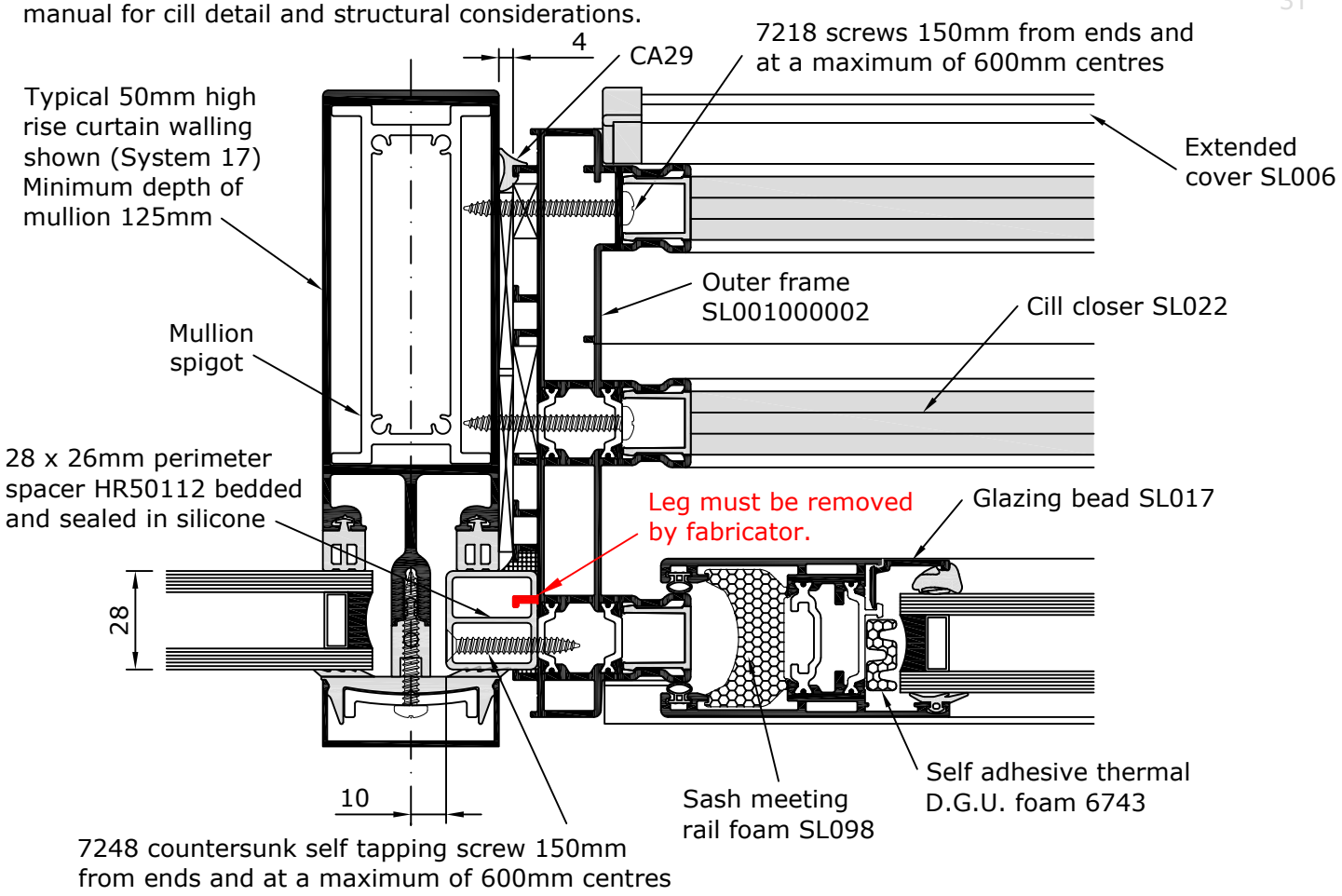


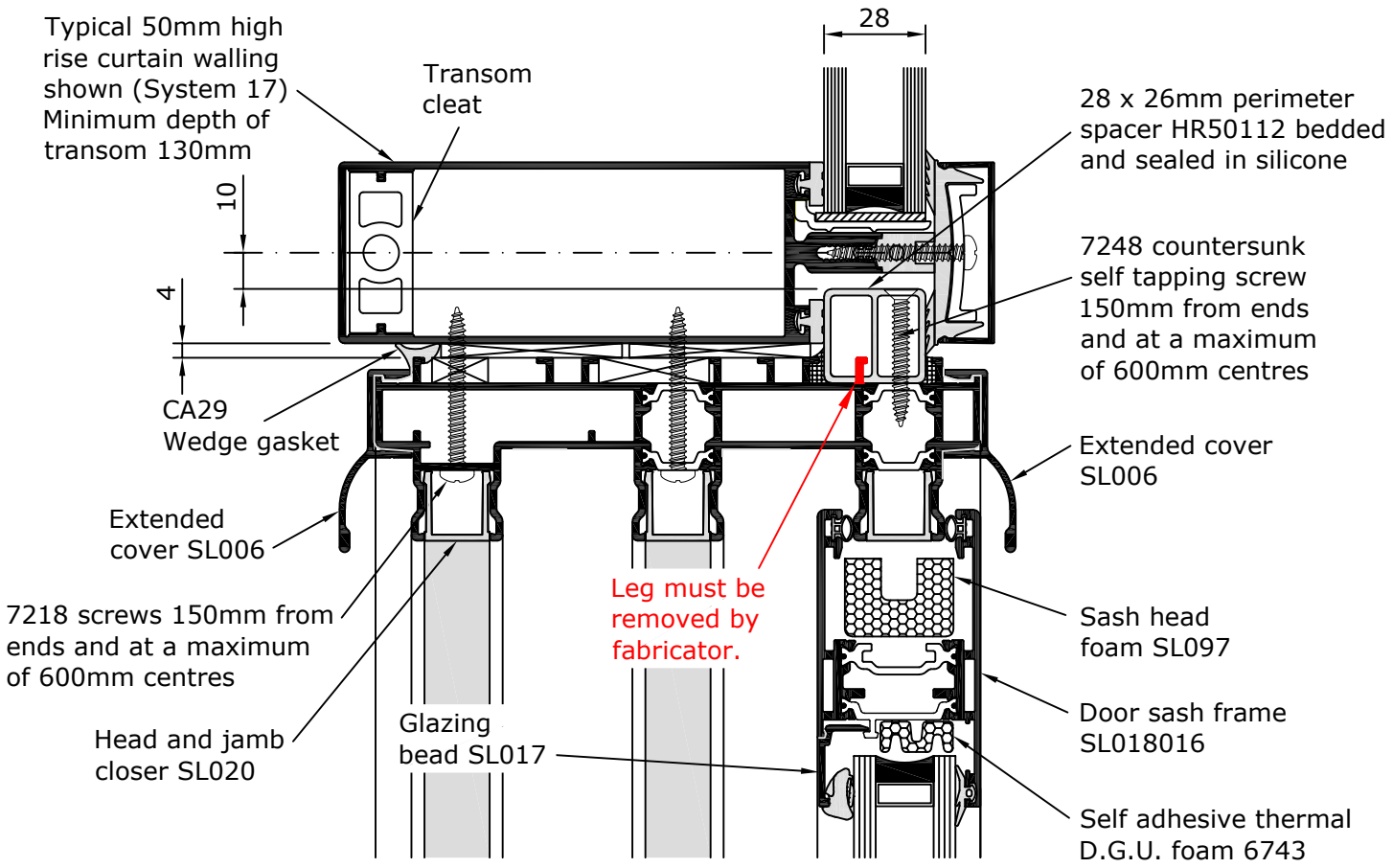
Scale 1:2

General Arrangement

Curtain Wall Insert

Refer also to "Typical Fixing Details - Curtain Walling" in Section 8 of this manual for cill detail and structural considerations.





Scale 1:2

Mullion Stiffener

For Double Track 2, 3 and 4 Pane Doors

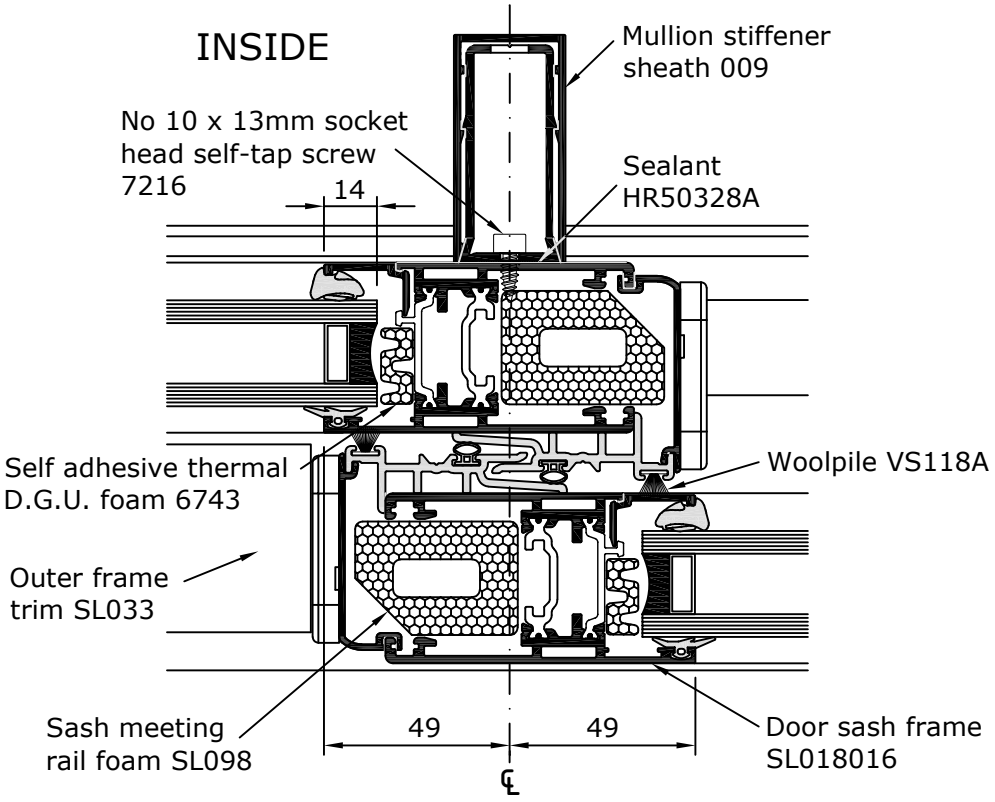
System 25 Hi/Hi+

LIFT AND SLIDE DOOR

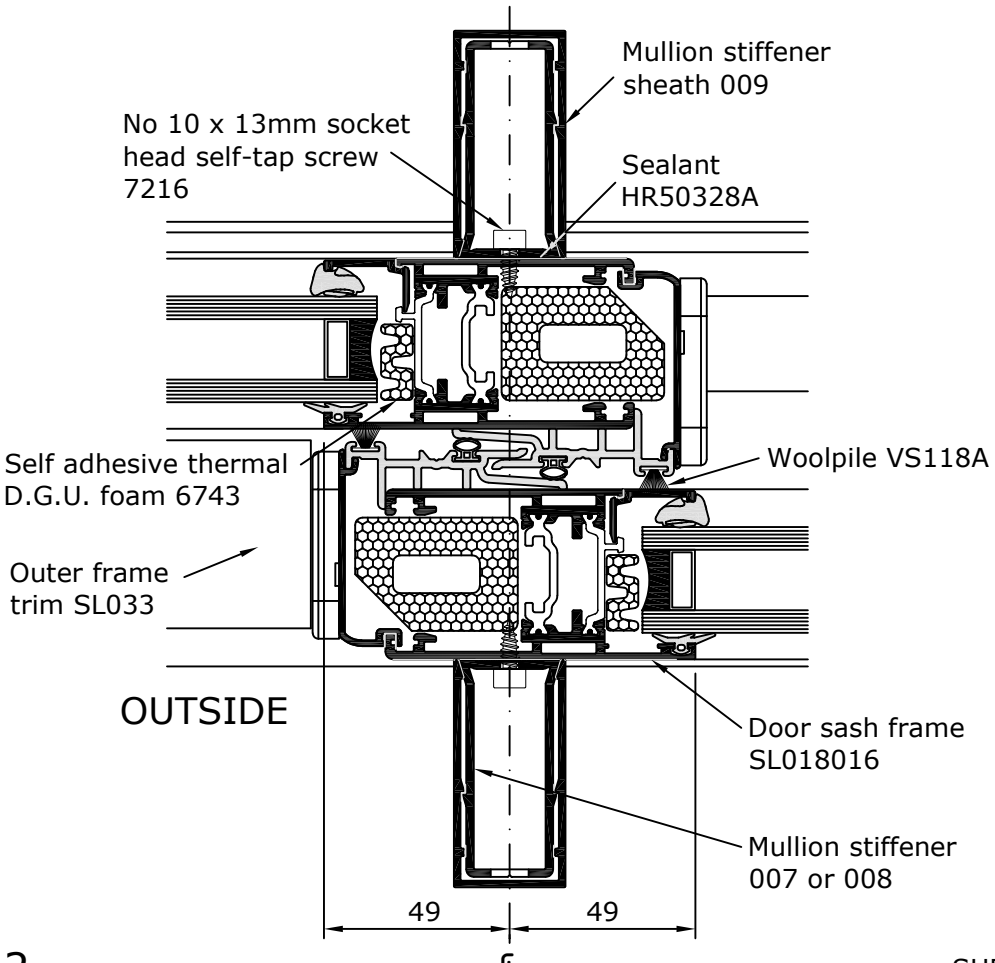
2T

MULLION STIFFENER TO INSIDE

Stiffener may alternatively be fitted to outside only.



MULLION STIFFENER TO INSIDE AND OUTSIDE



Scale 1:2

Mullion Stiffener

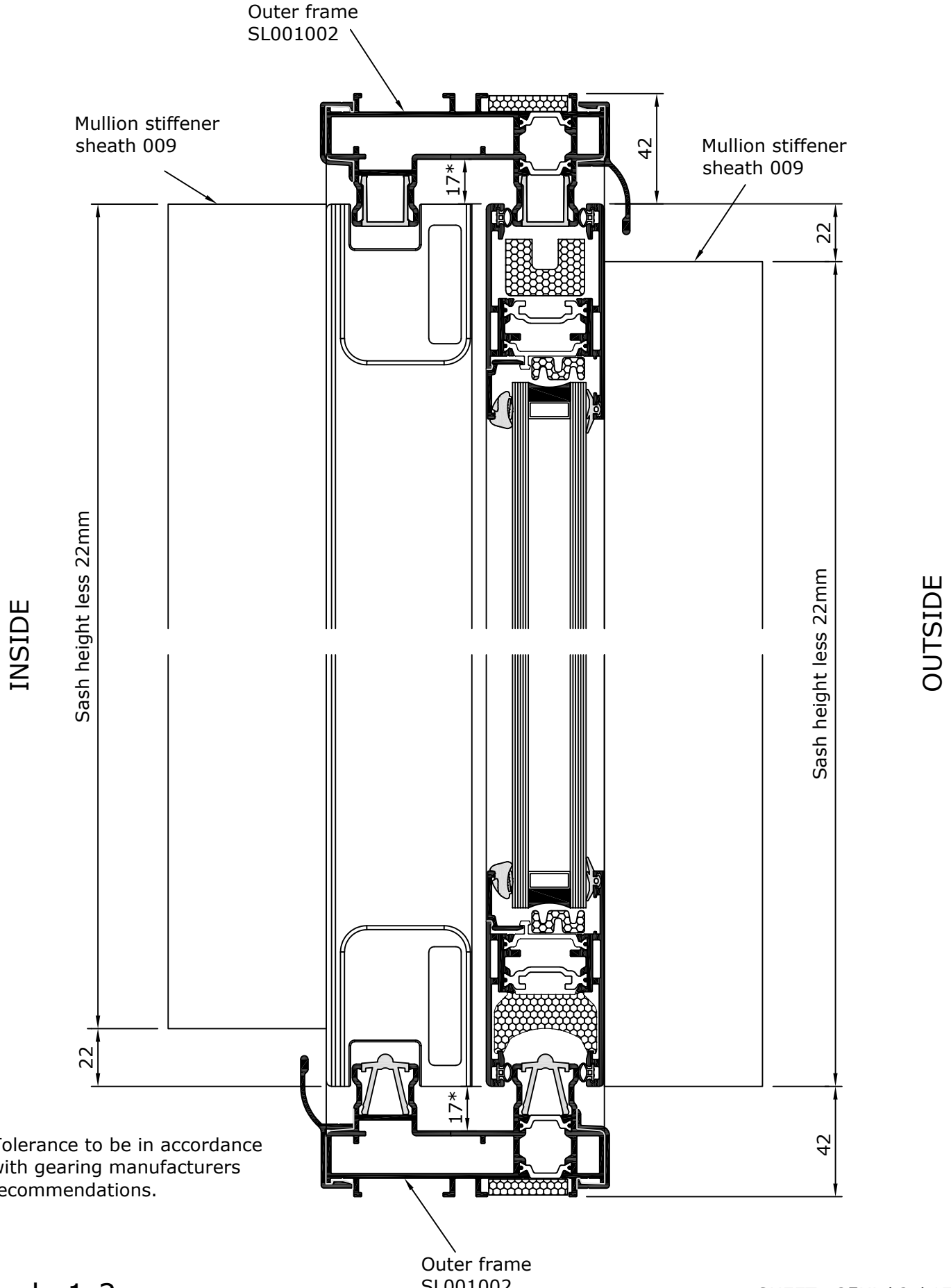
For Double Track 2, 3 and 4 Pane Doors

System 25 Hi/Hi+

LIFT AND SLIDE DOOR

2T

To be read in conjunction with previous sheet.



* Tolerance to be in accordance with gearing manufacturers recommendations.

Scale 1:2

Mullion Stiffener

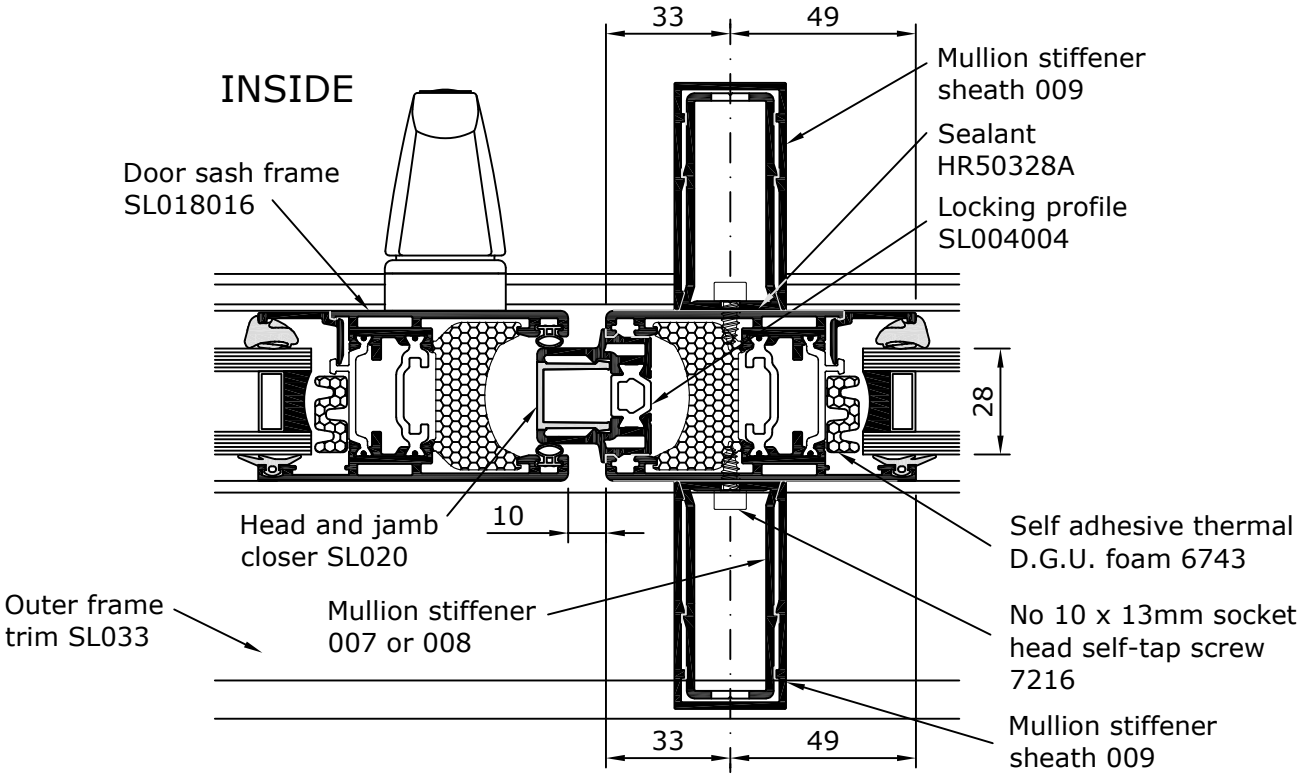
For Double Track 3 and 4 Pane Doors

System 25 Hi/Hi+

LIFT AND SLIDE DOOR

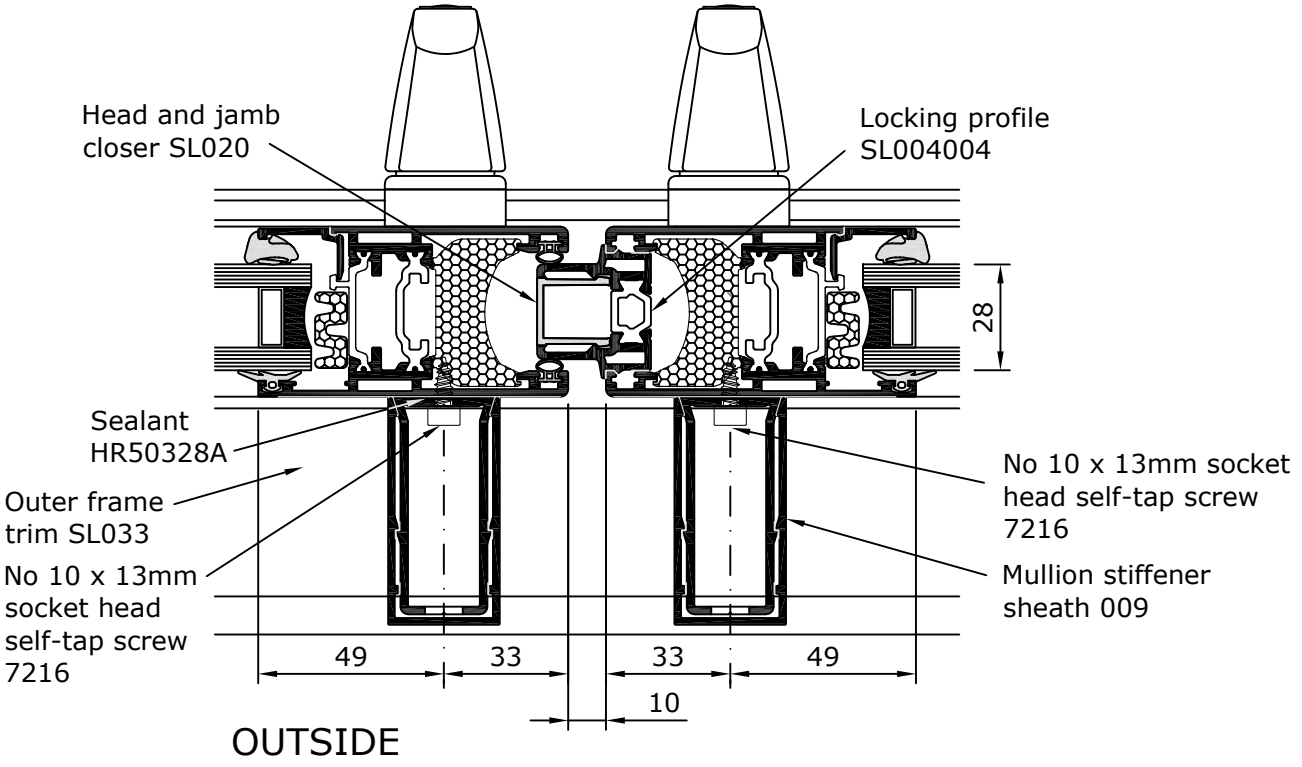
2T

MULLION STIFFENER TO INSIDE AND OUTSIDE FOR 3 PANE DOORS



MULLION STIFFENER TO OUTSIDE FOR 4 PANE DOORS

Not suitable for use with external handles.



Scale 1:2

Mullion Stiffener

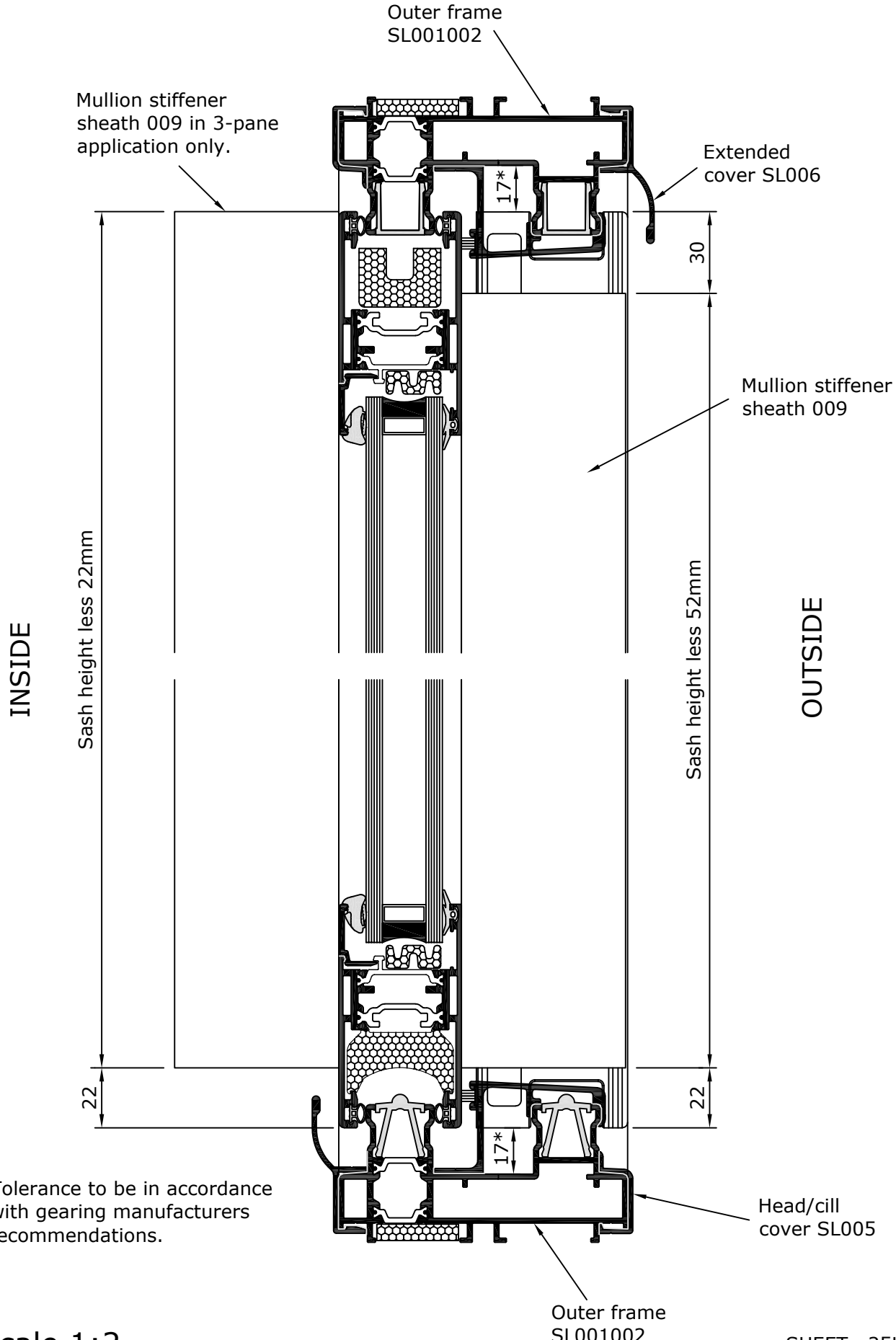
For Double Track 3 and 4 Pane Doors

System 25 Hi/Hi+

LIFT AND SLIDE DOOR

2T

To be read in conjunction with previous sheet.



* Tolerance to be in accordance with gearing manufacturers recommendations.

Scale 1:2

Mullion Stiffener

For Triple Track 3 Pane Doors

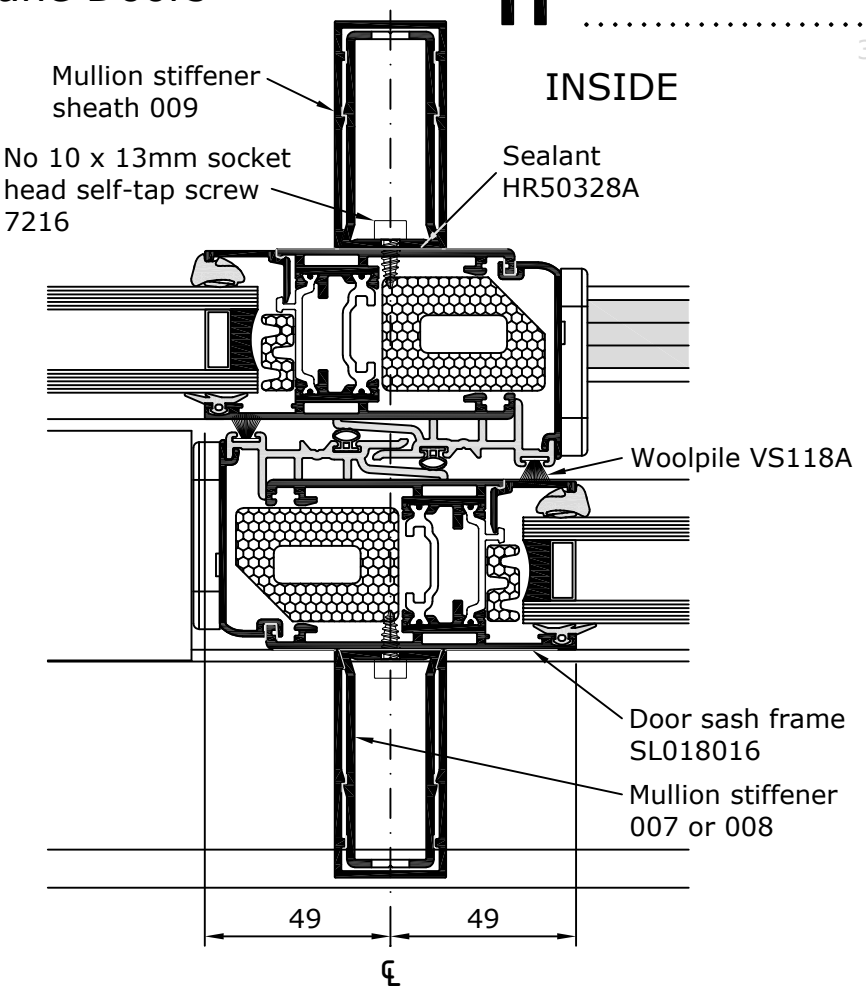
System 25 Hi/Hi+

LIFT AND SLIDE DOOR

3T

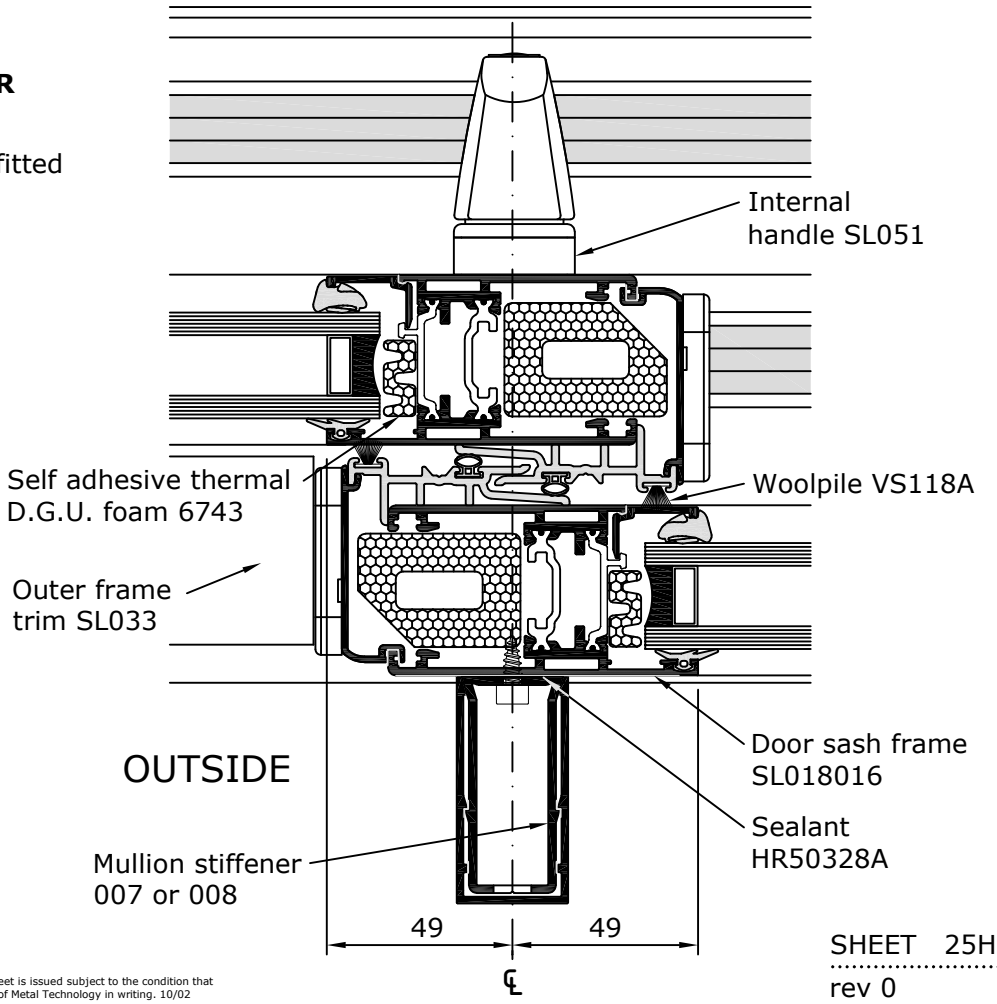
MULLION STIFFENER TO INSIDE AND OUTSIDE

Stiffener may alternatively be fitted to inside only or outside only.



MULLION STIFFENER TO OUTSIDE

Stiffener must not be fitted to inside of the middle pane where handle is situated.



Scale 1:2

Mullion Stiffener

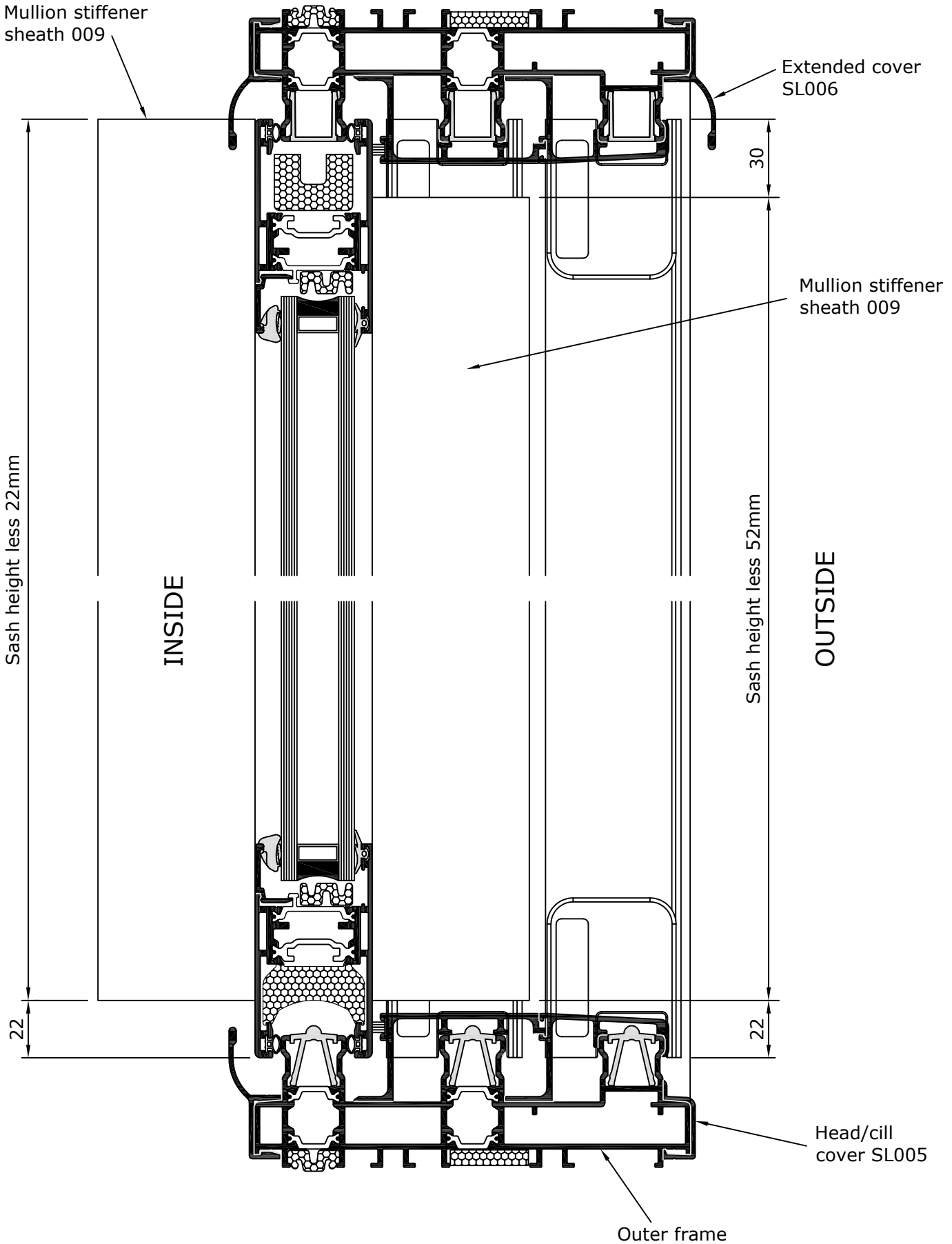
For Triple Track 3 Pane Doors

To be read in conjunction with previous sheet.

System 25 Hi/Hi+

LIFT AND SLIDE DOOR

3T



Scale 1:2

Mullion Stiffener

For Triple Track 3 Pane Doors

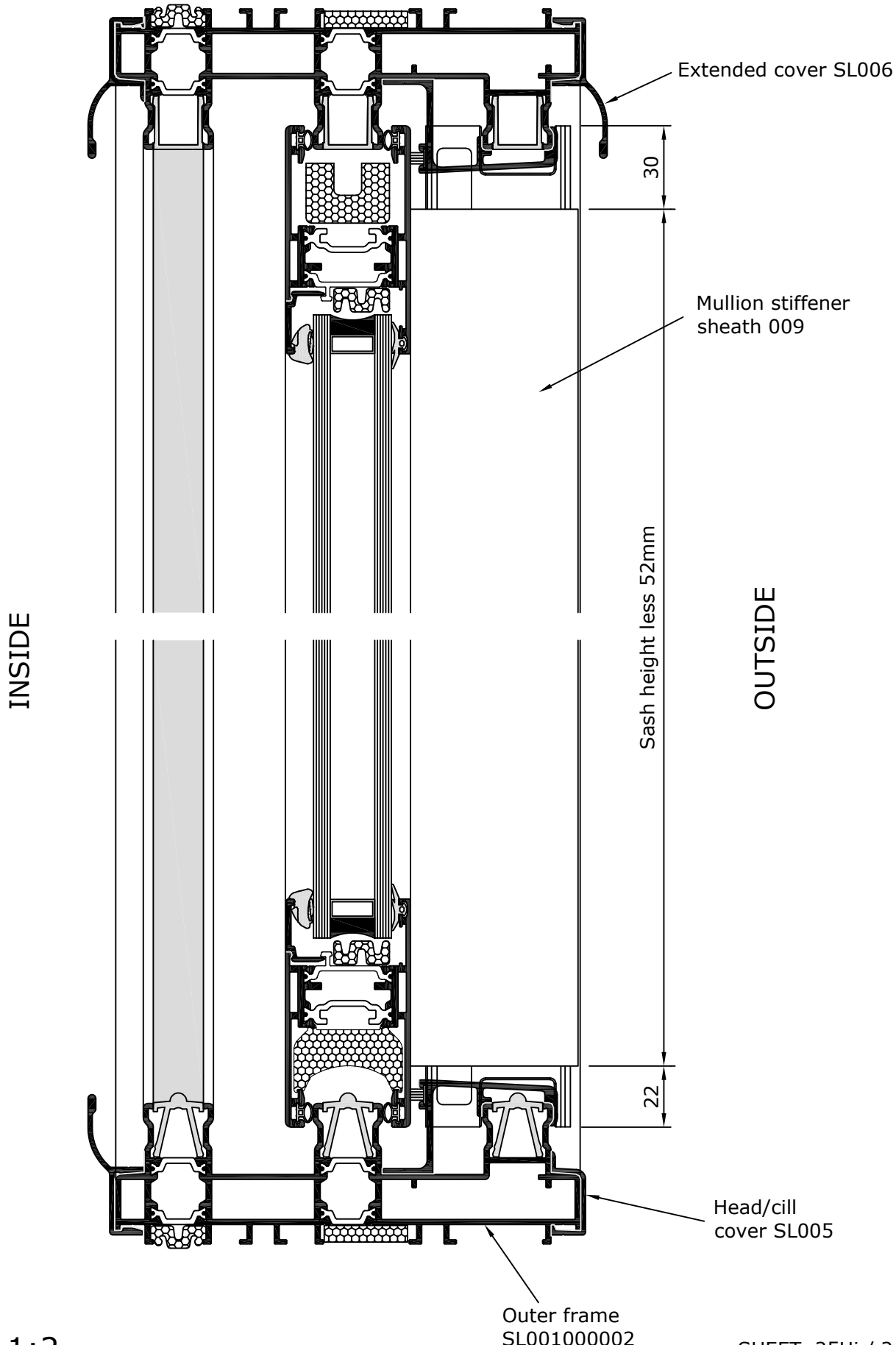
System 25 Hi/Hi+

LIFT AND SLIDE DOOR

3T

To be read in conjunction with previous sheets.

Stiffener must not be fitted to inside of the middle pane where handle is situated.



Scale 1:2

Coupling Detail

System 25 Hi/Hi+

LIFT AND SLIDE DOOR

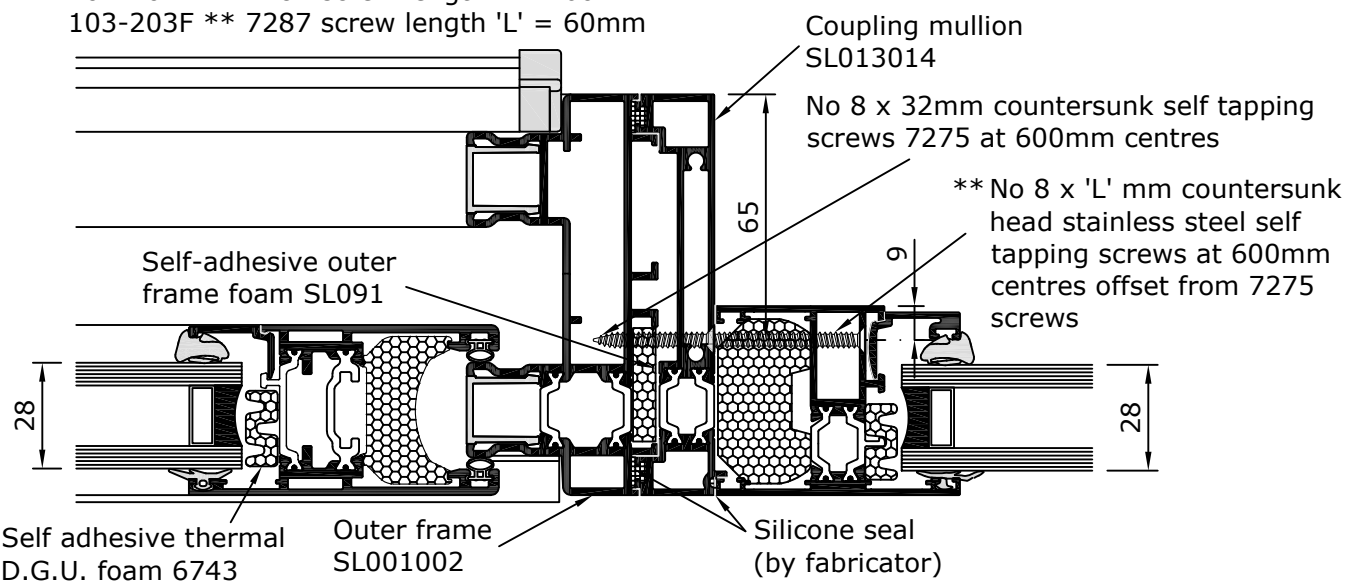
2T

SL013014 is designed to couple System 25 to variety of adjacent window configurations, subject to structural capabilities. Therefore the fabricator must ensure that the window design can adequately accommodate the anticipated expansion and contraction. The coupling detail provides a tight butt joint. For further advice please contact Metal Technology's Technical Department.

Windows/doors to be screw fixed to coupling mullion at 600mm centres with additional door fixings 25mm above and below hinge positions. Coupling mullion to be lug fixed back to structure at head and cill using plates/straps (by fabricator) fixed to integral screwports within SL013014 profile. Metal Technology recommend that the SL013014 coupling mullion to be sealed and secured to the SL001002 outer frame, as indicated, prior to installation on site.

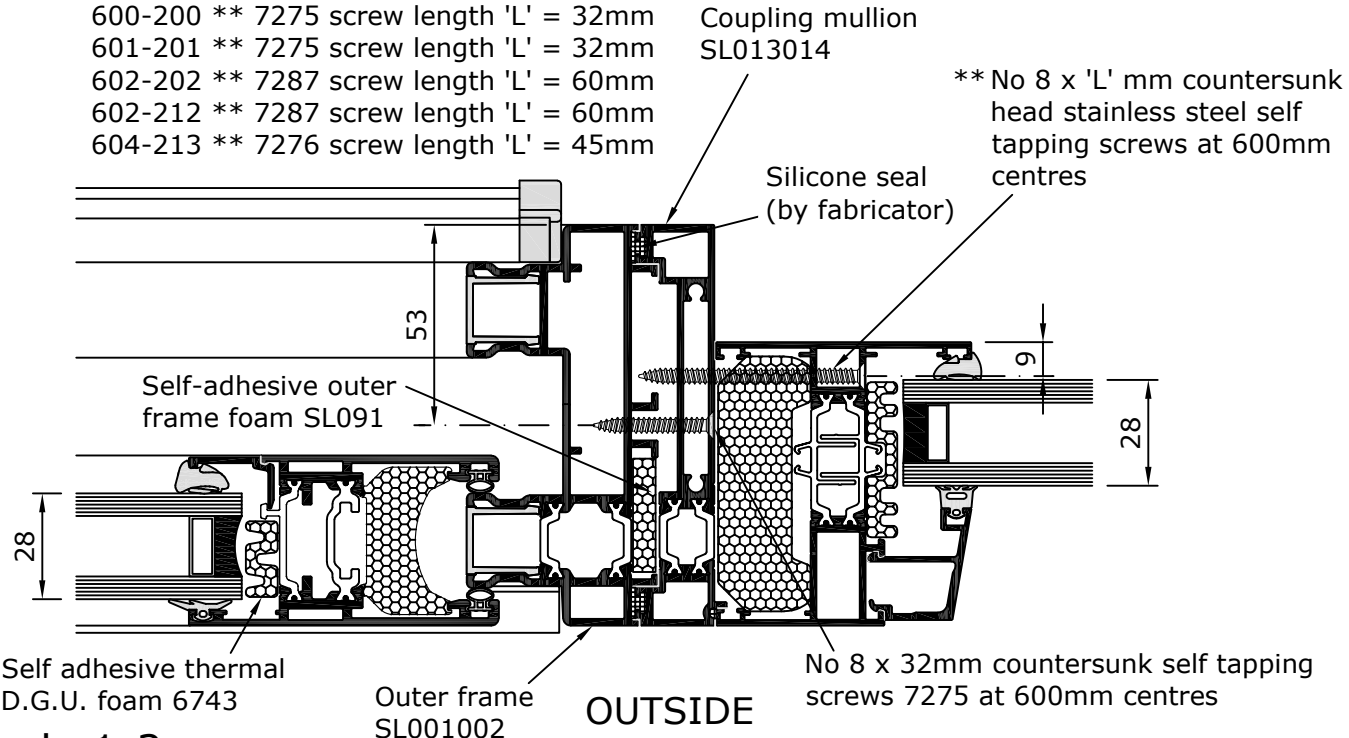
OUTER FRAME COUPLED WITH 4-20Hi+/5-20Hi+ OUTER FRAMES

Outer frame
100-200F ** 7275 screw length 'L' = 32mm
101-201F ** 7275 screw length 'L' = 32mm
102-202F ** 7287 screw length 'L' = 60mm
103-203F ** 7287 screw length 'L' = 60mm



OUTER FRAME COUPLED WITH 4-35Hi+/5-35Hi+ OUTER FRAMES

Outer frame
600-200 ** 7275 screw length 'L' = 32mm
601-201 ** 7275 screw length 'L' = 32mm
602-202 ** 7287 screw length 'L' = 60mm
602-212 ** 7287 screw length 'L' = 60mm
604-213 ** 7276 screw length 'L' = 45mm



Scale 1:2

Coupling Detail

System 25 Hi/Hi+

LIFT AND SLIDE DOOR

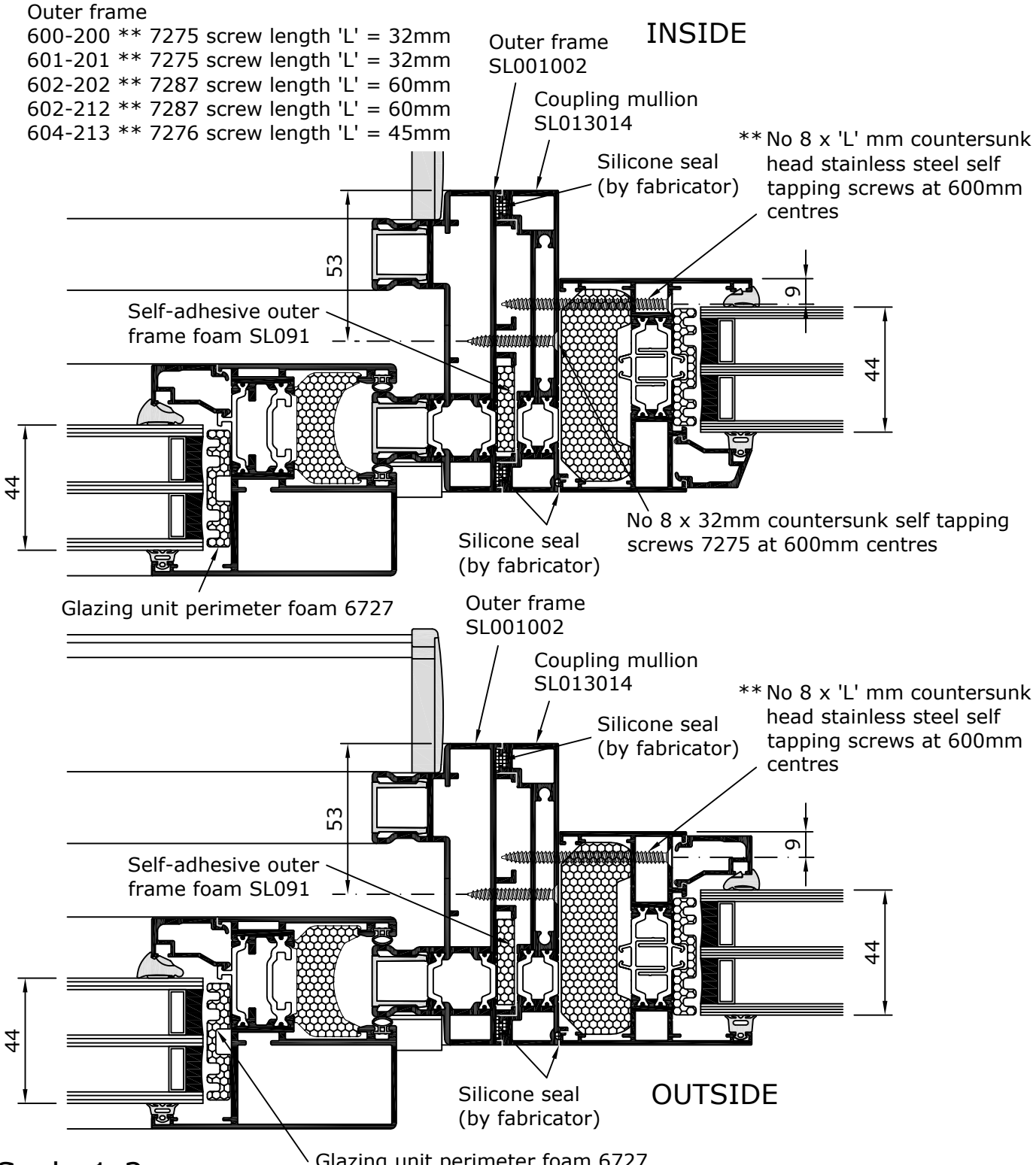
2T

SL013014 is designed to couple System 25 to variety of adjacent window configurations, subject to structural capabilities. Therefore the fabricator must ensure that the window design can adequately accommodate the anticipated expansion and contraction. The coupling detail provides a tight butt joint. For further advice please contact Metal Technology's Technical Department.

Windows/doors to be screw fixed to coupling mullion at 600mm centres with additional door fixings 25mm above and below hinge positions. Coupling mullion to be lug fixed back to structure at head and cill using plates/straps (by fabricator) fixed to integral screwports within SL013014 profile. Metal Technology recommend that the SL013014 coupling mullion to be sealed and secured to the SL001002 outer frame, as indicated, prior to installation on site.

OUTER FRAME COUPLED WITH 4-35Hi+/5-35Hi+ OUTER FRAMES

Outer frame
600-200 ** 7275 screw length 'L' = 32mm
601-201 ** 7275 screw length 'L' = 32mm
602-202 ** 7287 screw length 'L' = 60mm
602-212 ** 7287 screw length 'L' = 60mm
604-213 ** 7276 screw length 'L' = 45mm



Scale 1:2

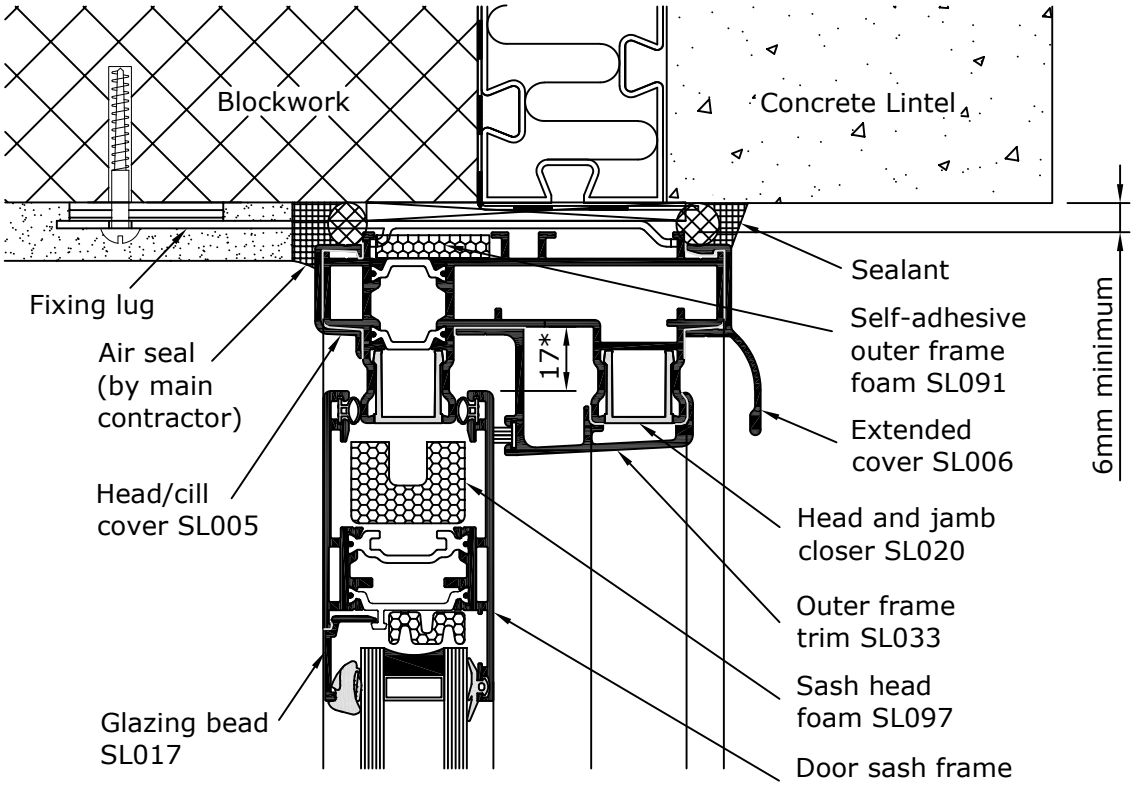
Cill and Head Options

System 25 Hi/Hi+

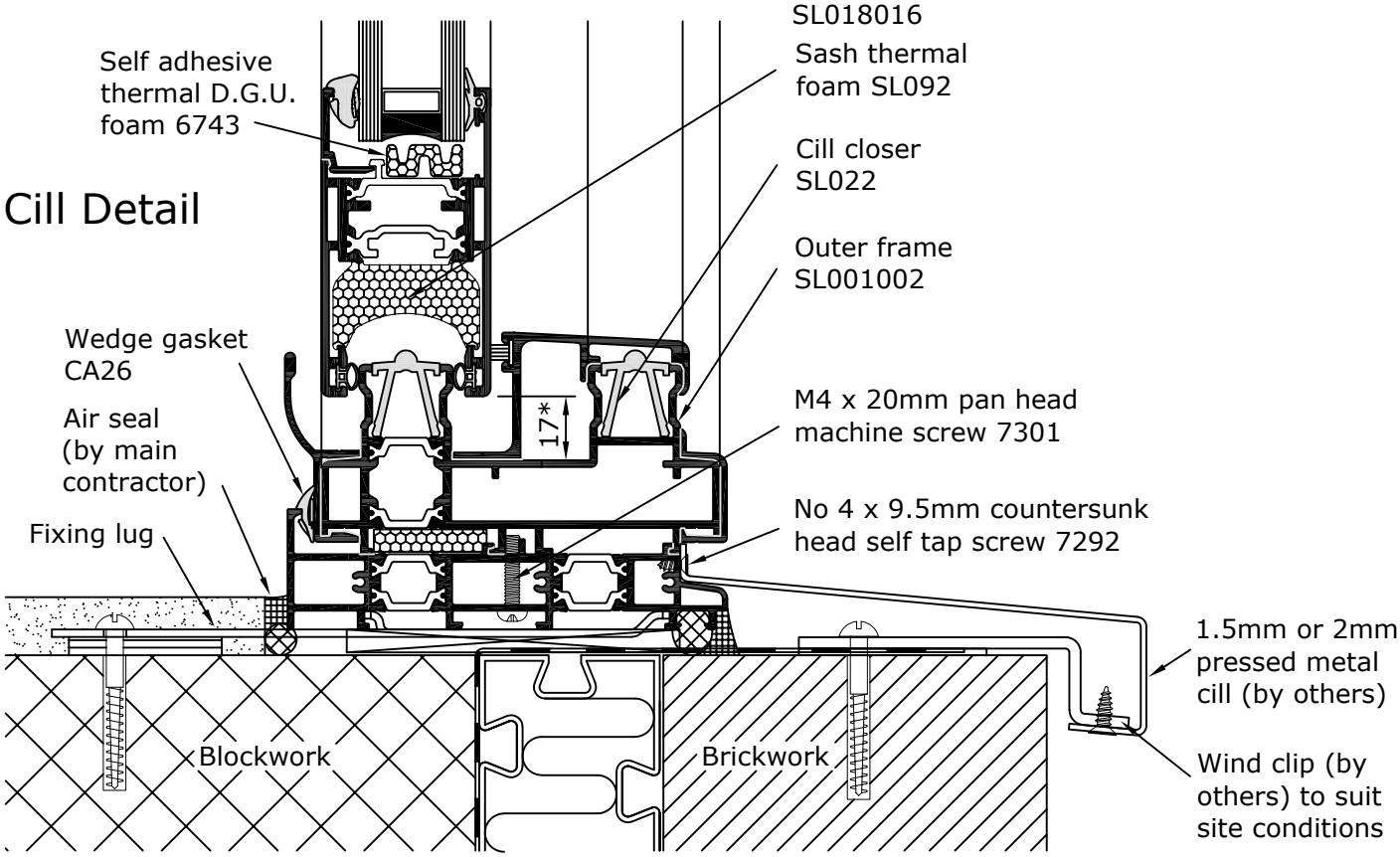
LIFT AND SLIDE DOOR

2T

Head Detail



Cill Detail



*Tolerance to be in accordance with gearing manufacturers recommendations.

Scale 1:2

Ironmongery
General Cautionary Notes

Sheets labelled Hi/Hi+ are applicable to both variations of the system. Where fabrication details have no impact on the thermal gaskets/foams, these have been omitted for clarity. Where sheets refer to Hi or Hi+ only, details shown apply accordingly.

The fabricator must ensure all doors, their operation and all other associated ironmongery are in accordance with the size and weight restrictions within this manual and any applicable British and European standards, building regulations, disabled access and Health and Safety requirements.

Fabricators should look at each application in relation to the sections used and the ironmongery required in order to determine compatibility (i.e that there is sufficient depth of section to accommodate the combination of profiles in conjunction with the ironmongery, handles and drainage requirements). Similar consideration should be given to door perimeter structural interface details. Metal Technology recommend that each application is drawn out with all structure, profiles, ironmongery and fixing details applied in order to determine compatibility.

For the purposes of this manual Metal Technology has assumed that the master sliding leaf is the internal door leaf. Should there be a requirement to open the external leaf, the SL015015 jamb extension profile must be fitted in order to avoid a finger trap. In double track 2 and 3-pane applications Metal Technology do not recommend that more than one pane opens. When fitting external handles, SL015015 jamb extension must always be used when master leaf is closing against the jamb.

In multi-light applications, when coupling fixed lights to a door, fabricator must take into consideration the loads applied and carry out application-specific structural analysis.

Fabricators and installers should be aware that the height of the structural opening may vary due to settlement of the lintel. Therefore the height of the doors should be manufactured to the lowest point, with added clearance to facilitate silicone pointing. In new build situations the lintel may continue to deflect over a period of time. Should the lintel settle, this will cause the outer frame to bow and may cause the doors to jam. The maximum permissible lintel deflection after the doors have been installed is 3mm. Additional clearance should be incorporated between the outer frame and the structural opening at the head so that the outer frame can be re-adjusted retrospectively if required.

Fabricators should be aware that when working with large doors the maintenance of tight tolerances of ±1mm is critical to maintenance of the correct gasket cover around the door. The gasket cover around the sash must be centralized. All fixings must be sealed in place using a suitable sealant. All fixings must be compatible with the materials into which they are fastened. i.e. when attaching into aluminum, austenitic A2 or A4 x class 70 stainless steel fixings are recommended. Fabricators must ensure that all adhesives, sealants and lubricants are fully compatible with the glass, materials and finish they are to be in contact with. Metal Technology recommend that fabricators sample all proposed adhesives and sealants to ensure compatibility on a project-by-project basis. Frames should be set aside after gluing to allow glue to harden.

Fabricator should be aware of available finishes for each handle type. When combining internal and external handle options, and/or handles from another system, it may not be possible to match the finishes and/or aesthetic for each handle type. In such situations Metal Technology recommend obtaining prior client approval.

For fixed and opening sash configurations not detailed in this manual contact Metal Technology's Technical Department.

Thermal Foams

Thermal foams should not be exposed to UV light, and must be kept in a clean, dry, and dust-free environment at between 5° and 35°C. Minimum recommended application temperature for adhesive thermal foams is 20°C and therefore these should be applied in clean, dry and dust-free factory conditions. Before applying self-adhesive foams ensure all surfaces are free from grease or dust. Clean all mating surfaces with suitable cleaning agent. Fabricators should minimise the exposure period of the foams to the elements and provide additional on-site protection to prevent depositing of builders debris.

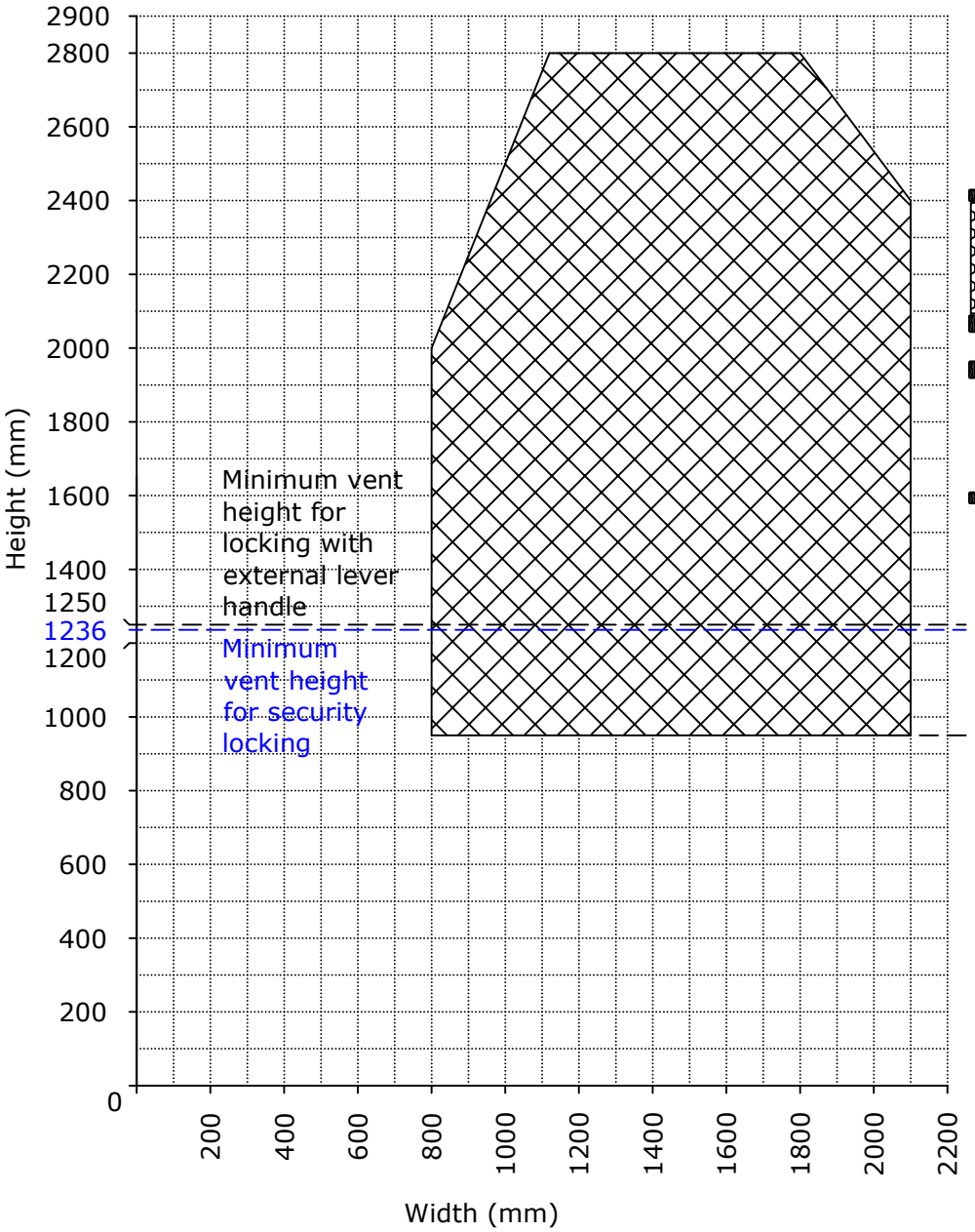
Vent Size Limitation Chart

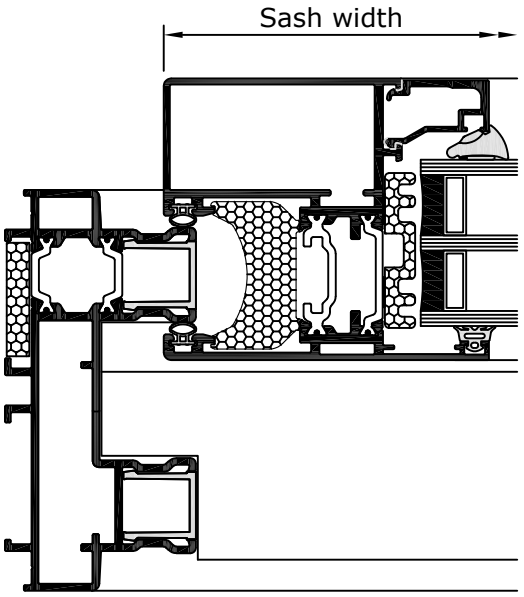
Lift and Slide Door Sashes SL018016, SL129130, and SL131132

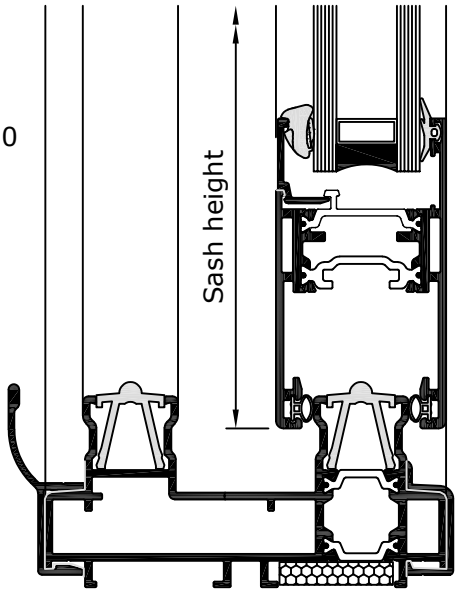
System 25 Hi/Hi+

LIFT AND SLIDE DOOR

2T 3T





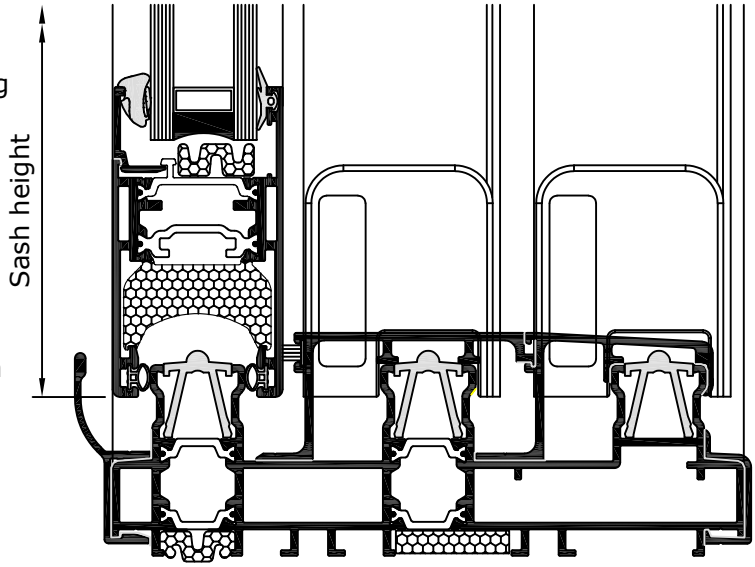


Maximum sash weight for lift and slide sash = 200Kg
Maximum sash weight for fixed sash = 200Kg

Lift and Slide opening sash

Width of fixed sash should not be less than the adjacent lift and slide opening sash.

Minimum sash width for lift and slide door = 800mm
Minimum sash height = 950mm



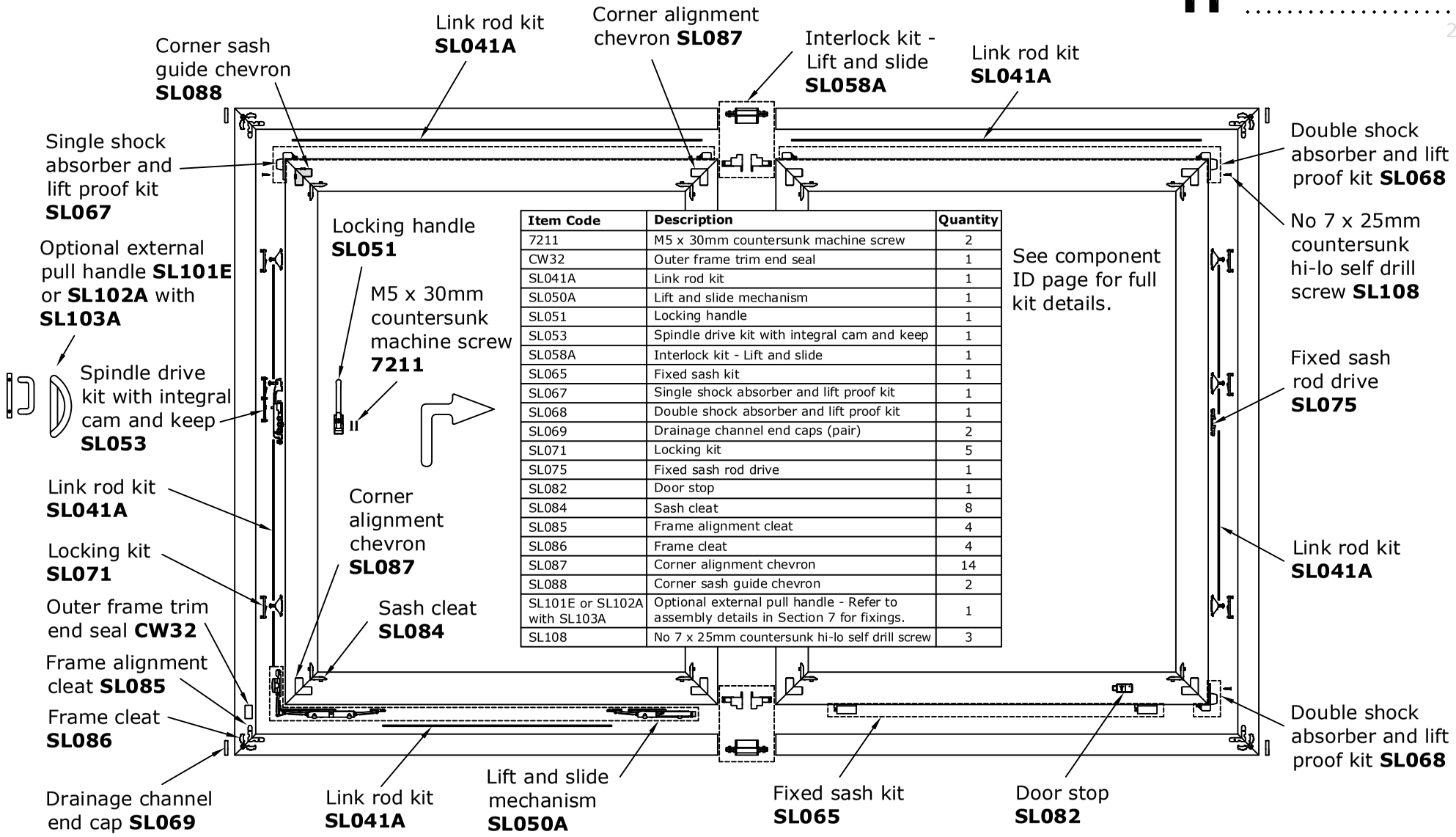
Lift and Slide / Fixed (2 Pane) - Sash SL018016

Kitting List (Standard Locking, Internal Pane Sliding, Internal Lever Handle)

System 25 Hi/Hi+

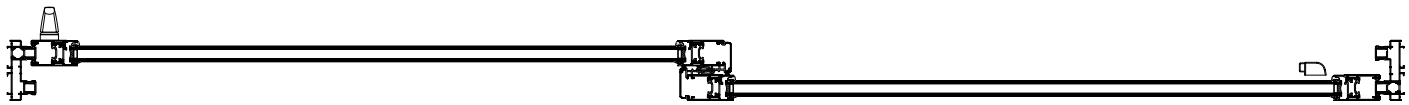
LIFT AND SLIDE DOOR

2T



Item Code	Description	Quantity
7211	M5 x 30mm countersunk machine screw	2
CW32	Outer frame trim end seal	1
SL041A	Link rod kit	1
SL050A	Lift and slide mechanism	1
SL051	Locking handle	1
SL053	Spindle drive kit with integral cam and keep	1
SL058A	Interlock kit - Lift and slide	1
SL065	Fixed sash kit	1
SL067	Single shock absorber and lift proof kit	1
SL068	Double shock absorber and lift proof kit	1
SL069	Drainage channel end caps (pair)	2
SL071	Locking kit	5
SL075	Fixed sash rod drive	1
SL082	Door stop	1
SL084	Sash cleat	8
SL085	Frame alignment cleat	4
SL086	Frame cleat	4
SL087	Corner alignment chevron	14
SL088	Corner sash guide chevron	2
SL101E or SL102A with SL103A	Optional external pull handle - Refer to assembly details in Section 7 for fixings.	1
SL108	No 7 x 25mm countersunk hi-lo self drill screw	3

See component ID page for full kit details.



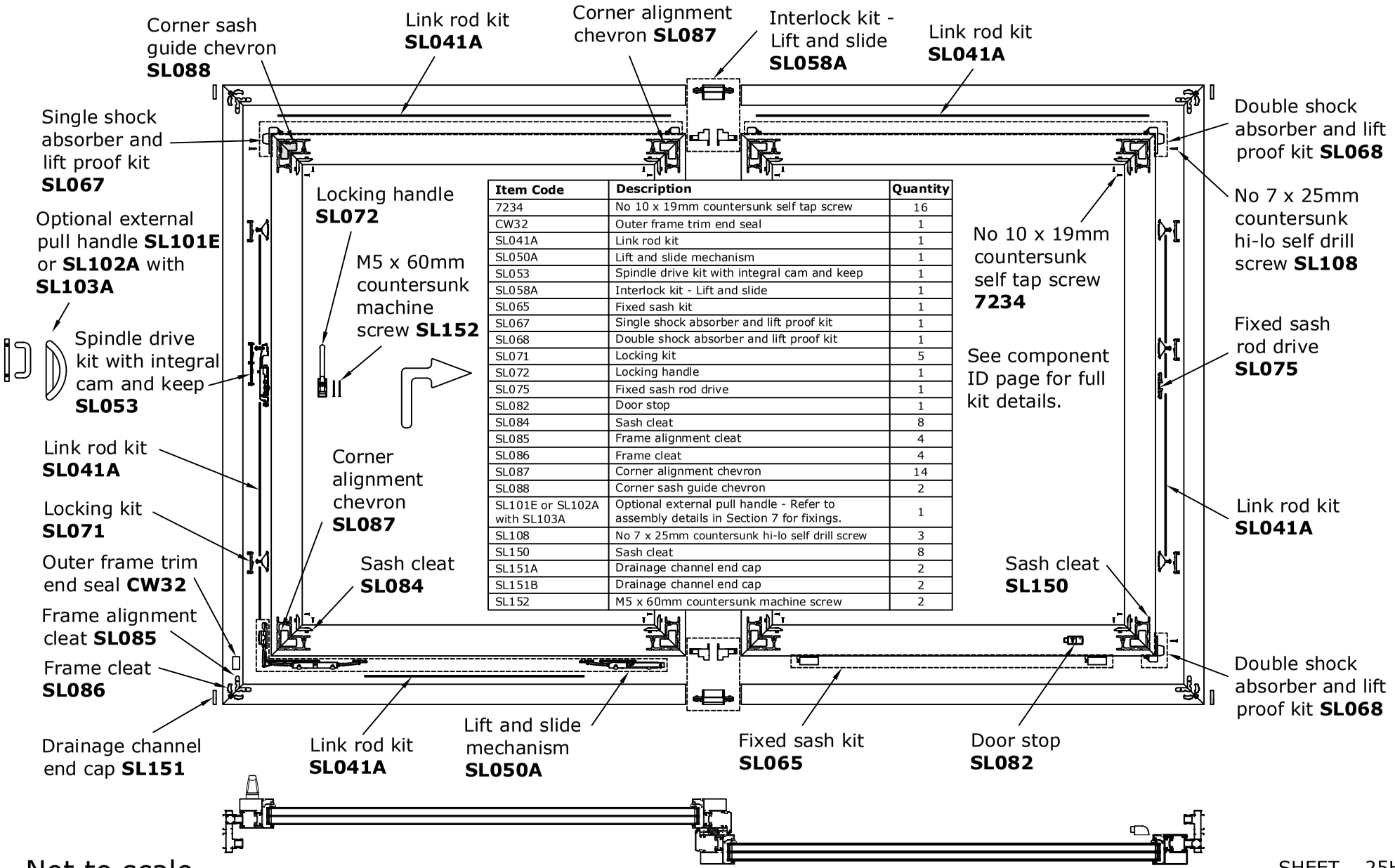
Not to scale

OUTSIDE

Lift and Slide / Fixed (2 Pane) - Sashes
SL129130/SL131132

Kitting List (Standard Locking, Internal Pane Sliding, Internal Lever Handle)

System 25 Hi/Hi+
LIFT AND SLIDE DOOR
2T



Item Code	Description	Quantity
7234	No 10 x 19mm countersunk self tap screw	16
CW32	Outer frame trim end seal	1
SL041A	Link rod kit	1
SL050A	Lift and slide mechanism	1
SL053	Spindle drive kit with integral cam and keep	1
SL058A	Interlock kit - Lift and slide	1
SL065	Fixed sash kit	1
SL067	Single shock absorber and lift proof kit	1
SL068	Double shock absorber and lift proof kit	1
SL071	Locking kit	5
SL072	Locking handle	1
SL075	Fixed sash rod drive	1
SL082	Door stop	1
SL084	Sash cleat	8
SL085	Frame alignment cleat	4
SL086	Frame cleat	4
SL087	Corner alignment chevron	14
SL088	Corner sash guide chevron	2
SL101E or SL102A with SL103A	Optional external pull handle - Refer to assembly details in Section 7 for fixings.	1
SL108	No 7 x 25mm countersunk hi-lo self drill screw	3
SL150	Sash cleat	8
SL151A	Drainage channel end cap	2
SL151B	Drainage channel end cap	2
SL152	M5 x 60mm countersunk machine screw	2

Not to scale

OUTSIDE

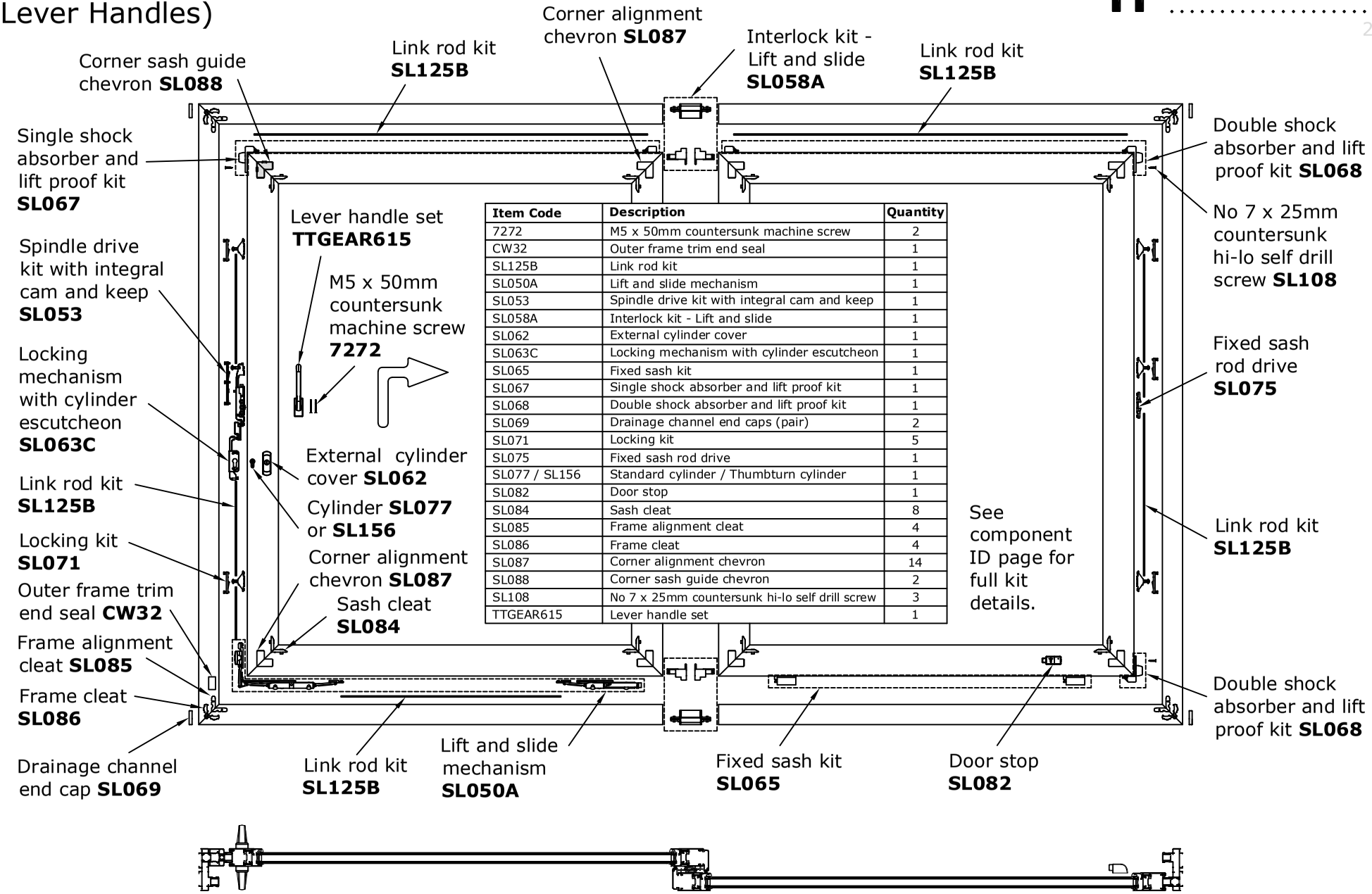
Lift and Slide / Fixed (2 Pane) - Sash SL018016

Kitting List (Standard Locking, Internal Pane Sliding, Internal and External Lever Handles)

System 25 Hi/Hi+

LIFT AND SLIDE DOOR

2T



Item Code	Description	Quantity
7272	M5 x 50mm countersunk machine screw	2
CW32	Outer frame trim end seal	1
SL125B	Link rod kit	1
SL050A	Lift and slide mechanism	1
SL053	Spindle drive kit with integral cam and keep	1
SL058A	Interlock kit - Lift and slide	1
SL062	External cylinder cover	1
SL063C	Locking mechanism with cylinder escutcheon	1
SL065	Fixed sash kit	1
SL067	Single shock absorber and lift proof kit	1
SL068	Double shock absorber and lift proof kit	1
SL069	Drainage channel end caps (pair)	2
SL071	Locking kit	5
SL075	Fixed sash rod drive	1
SL077 / SL156	Standard cylinder / Thumbturn cylinder	1
SL082	Door stop	1
SL084	Sash cleat	8
SL085	Frame alignment cleat	4
SL086	Frame cleat	4
SL087	Corner alignment chevron	14
SL088	Corner sash guide chevron	2
SL108	No 7 x 25mm countersunk hi-lo self drill screw	3
TTGEAR615	Lever handle set	1

See component ID page for full kit details.

Not to scale

OUTSIDE

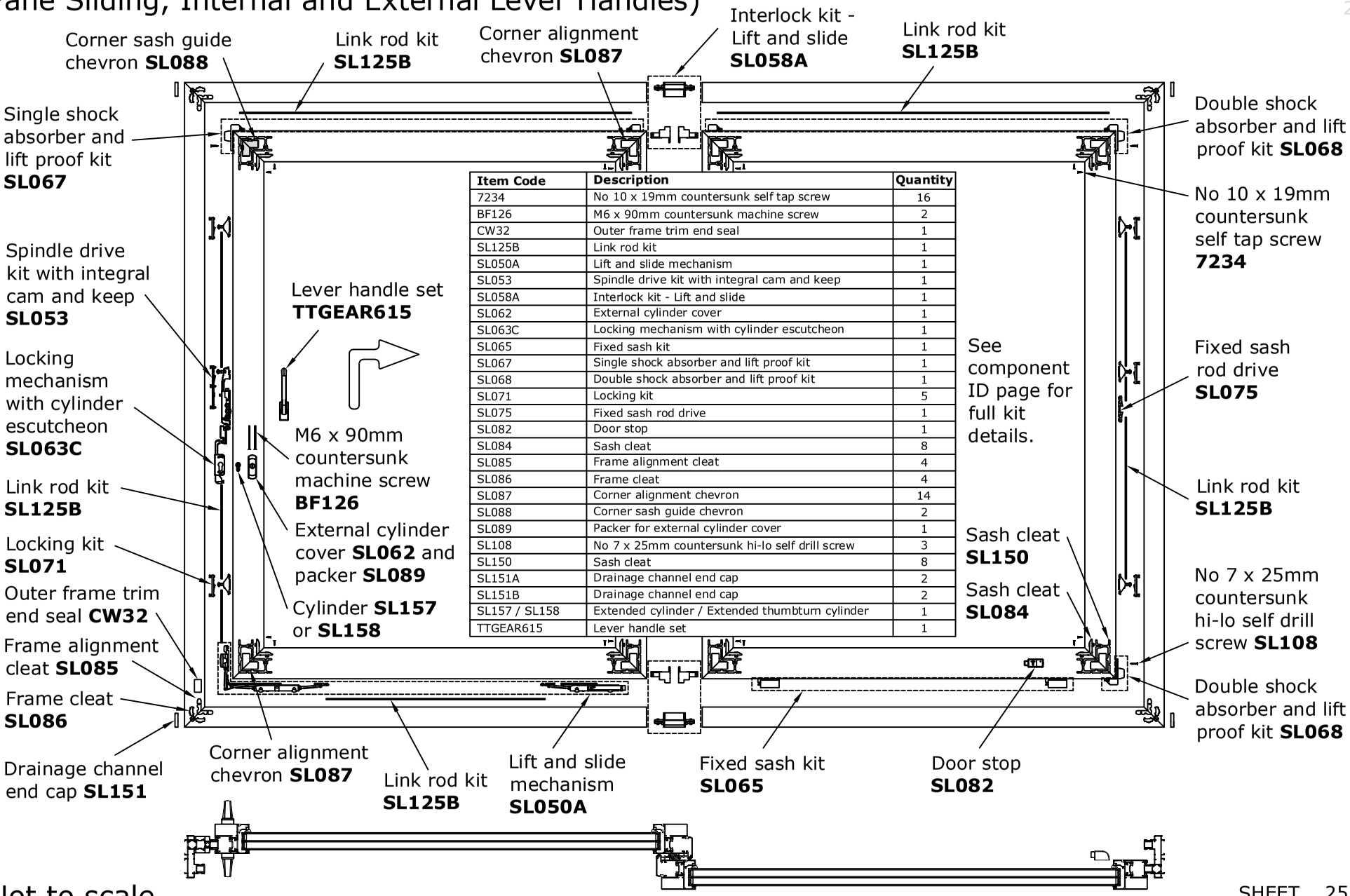
Lift and Slide / Fixed (2 Pane) - Sashes

SL129130/SL131132 Kitting List (Standard Locking, Internal Pane Sliding, Internal and External Lever Handles)

System 25 Hi/Hi+

LIFT AND SLIDE DOOR

2T



Item Code	Description	Quantity
7234	No 10 x 19mm countersunk self tap screw	16
BF126	M6 x 90mm countersunk machine screw	2
CW32	Outer frame trim end seal	1
SL125B	Link rod kit	1
SL050A	Lift and slide mechanism	1
SL053	Spindle drive kit with integral cam and keep	1
SL058A	Interlock kit - Lift and slide	1
SL062	External cylinder cover	1
SL063C	Locking mechanism with cylinder escutcheon	1
SL065	Fixed sash kit	1
SL067	Single shock absorber and lift proof kit	1
SL068	Double shock absorber and lift proof kit	1
SL071	Locking kit	5
SL075	Fixed sash rod drive	1
SL082	Door stop	1
SL084	Sash cleat	8
SL085	Frame alignment cleat	4
SL086	Frame cleat	4
SL087	Corner alignment chevron	14
SL088	Corner sash guide chevron	2
SL089	Packer for external cylinder cover	1
SL108	No 7 x 25mm countersunk hi-lo self drill screw	3
SL150	Sash cleat	8
SL151A	Drainage channel end cap	2
SL151B	Drainage channel end cap	2
SL157 / SL158	Extended cylinder / Extended thumbturn cylinder	1
TTGEAR615	Lever handle set	1

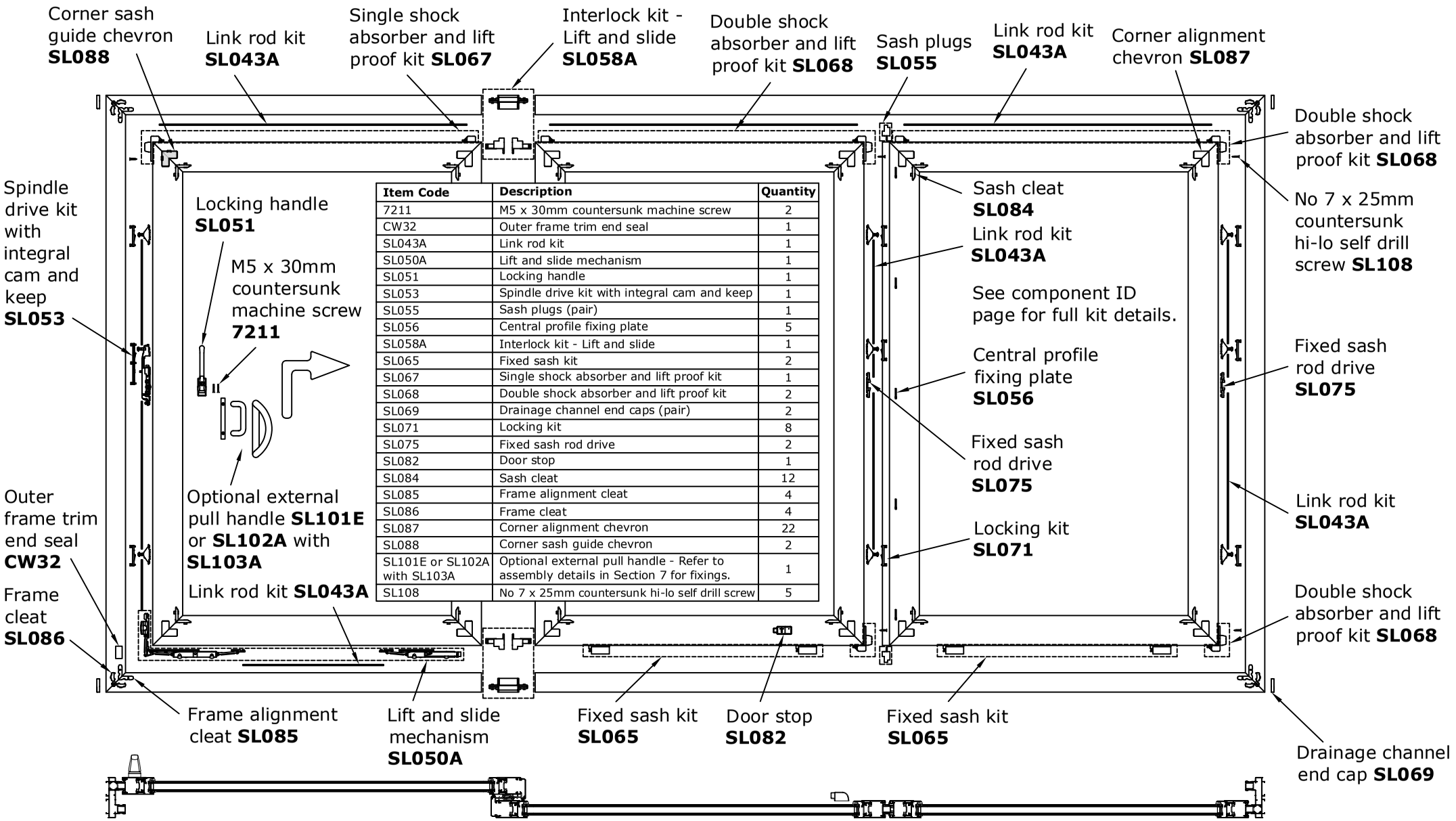
Not to scale

OUTSIDE

Lift and Slide / Fixed / Fixed (3 Pane) - Sash SL018016

Kitting List (Standard Locking, Internal Pane Sliding, Internal Lever Handle)

System 25 Hi/Hi+
LIFT AND SLIDE DOOR
2T



Item Code	Description	Quantity
7211	M5 x 30mm countersunk machine screw	2
CW32	Outer frame trim end seal	1
SL043A	Link rod kit	1
SL050A	Lift and slide mechanism	1
SL051	Locking handle	1
SL053	Spindle drive kit with integral cam and keep	1
SL055	Sash plugs (pair)	1
SL056	Central profile fixing plate	5
SL058A	Interlock kit - Lift and slide	1
SL065	Fixed sash kit	2
SL067	Single shock absorber and lift proof kit	1
SL068	Double shock absorber and lift proof kit	2
SL069	Drainage channel end caps (pair)	2
SL071	Locking kit	8
SL075	Fixed sash rod drive	2
SL082	Door stop	1
SL084	Sash cleat	12
SL085	Frame alignment cleat	4
SL086	Frame cleat	4
SL087	Corner alignment chevron	22
SL088	Corner sash guide chevron	2
SL101E or SL102A with SL103A	Optional external pull handle - Refer to assembly details in Section 7 for fixings.	1
SL108	No 7 x 25mm countersunk hi-lo self drill screw	5

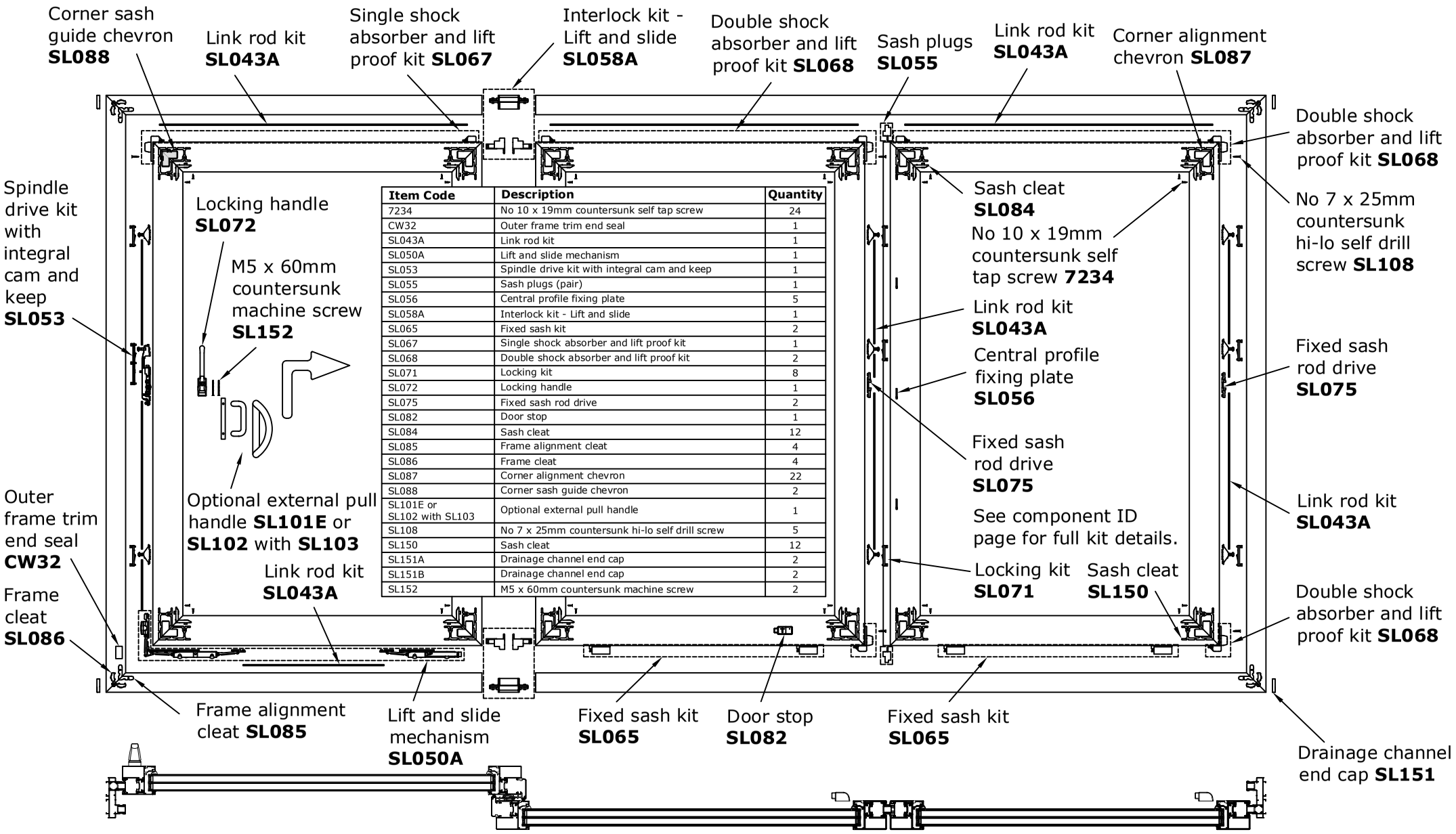
Not to scale

OUTSIDE

Lift and Slide / Fixed / Fixed (3 Pane) - Sashes SL129130/SL131132

Kitting List (Standard Locking, Internal Pane Sliding, Internal Lever Handle)

System 25 Hi/Hi+
LIFT AND SLIDE DOOR
2T



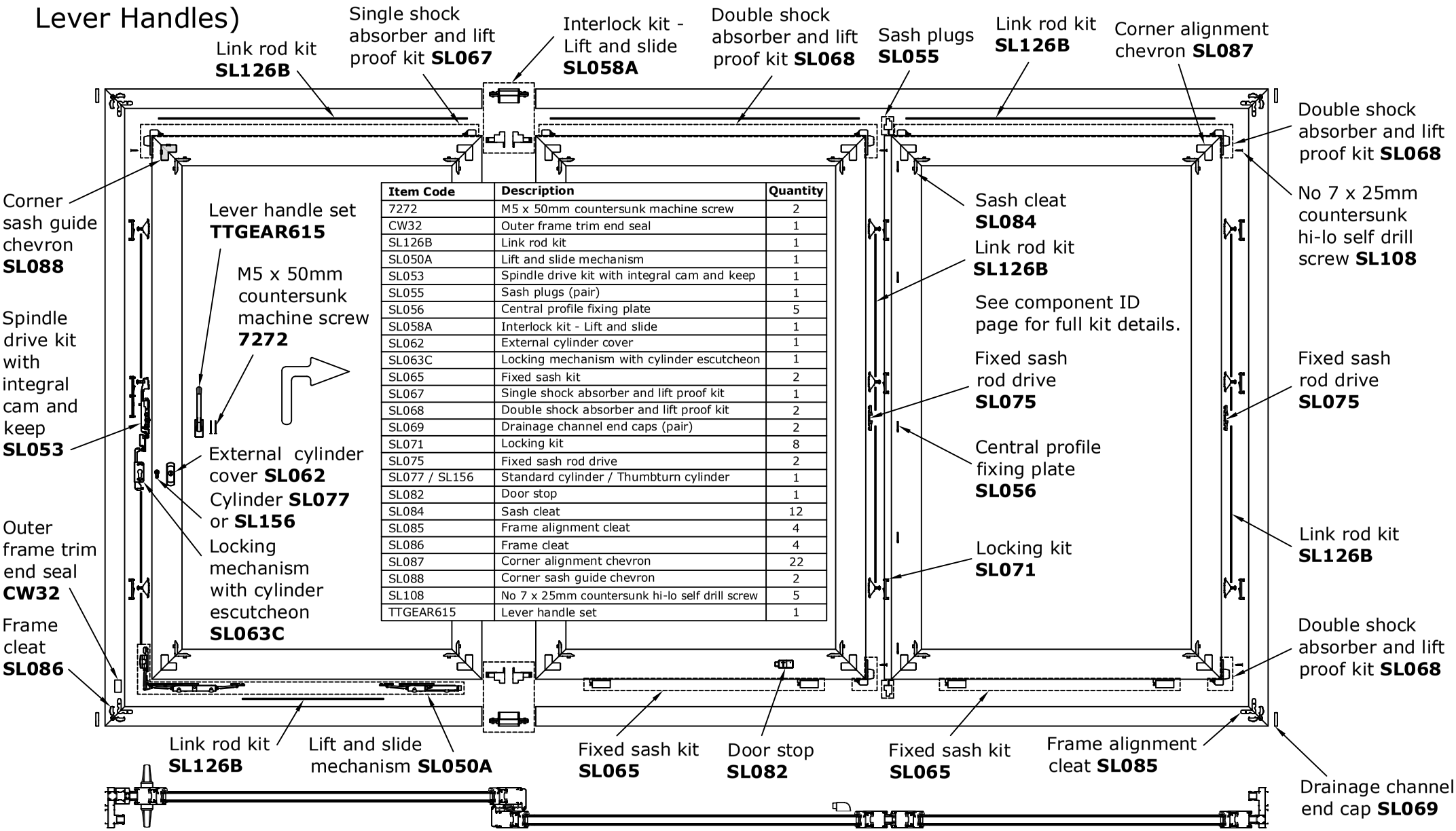
Item Code	Description	Quantity
7234	No 10 x 19mm countersunk self tap screw	24
CW32	Outer frame trim end seal	1
SL043A	Link rod kit	1
SL050A	Lift and slide mechanism	1
SL053	Spindle drive kit with integral cam and keep	1
SL055	Sash plugs (pair)	1
SL056	Central profile fixing plate	5
SL058A	Interlock kit - Lift and slide	1
SL065	Fixed sash kit	2
SL067	Single shock absorber and lift proof kit	1
SL068	Double shock absorber and lift proof kit	2
SL071	Locking kit	8
SL072	Locking handle	1
SL075	Fixed sash rod drive	2
SL082	Door stop	1
SL084	Sash cleat	12
SL085	Frame alignment cleat	4
SL086	Frame cleat	4
SL087	Corner alignment chevron	22
SL088	Corner sash guide chevron	2
SL101E or SL102 with SL103	Optional external pull handle	1
SL108	No 7 x 25mm countersunk hi-lo self drill screw	5
SL150	Sash cleat	12
SL151A	Drainage channel end cap	2
SL151B	Drainage channel end cap	2
SL152	M5 x 60mm countersunk machine screw	2

Not to scale

Lift and Slide / Fixed / Fixed (3 Pane) - Sash SL018016

Kitting List (Standard Locking, Internal Pane Sliding, Internal and External Lever Handles)

System 25 Hi/Hi+
LIFT AND SLIDE DOOR
2T



Item Code	Description	Quantity
7272	M5 x 50mm countersunk machine screw	2
CW32	Outer frame trim end seal	1
SL126B	Link rod kit	1
SL050A	Lift and slide mechanism	1
SL053	Spindle drive kit with integral cam and keep	1
SL055	Sash plugs (pair)	1
SL056	Central profile fixing plate	5
SL058A	Interlock kit - Lift and slide	1
SL062	External cylinder cover	1
SL063C	Locking mechanism with cylinder escutcheon	1
SL065	Fixed sash kit	2
SL067	Single shock absorber and lift proof kit	1
SL068	Double shock absorber and lift proof kit	2
SL069	Drainage channel end caps (pair)	2
SL071	Locking kit	8
SL075	Fixed sash rod drive	2
SL077 / SL156	Standard cylinder / Thumbturn cylinder	1
SL082	Door stop	1
SL084	Sash cleat	12
SL085	Frame alignment cleat	4
SL086	Frame cleat	4
SL087	Corner alignment chevron	22
SL088	Corner sash guide chevron	2
SL108	No 7 x 25mm countersunk hi-lo self drill screw	5
TTGEAR615	Lever handle set	1

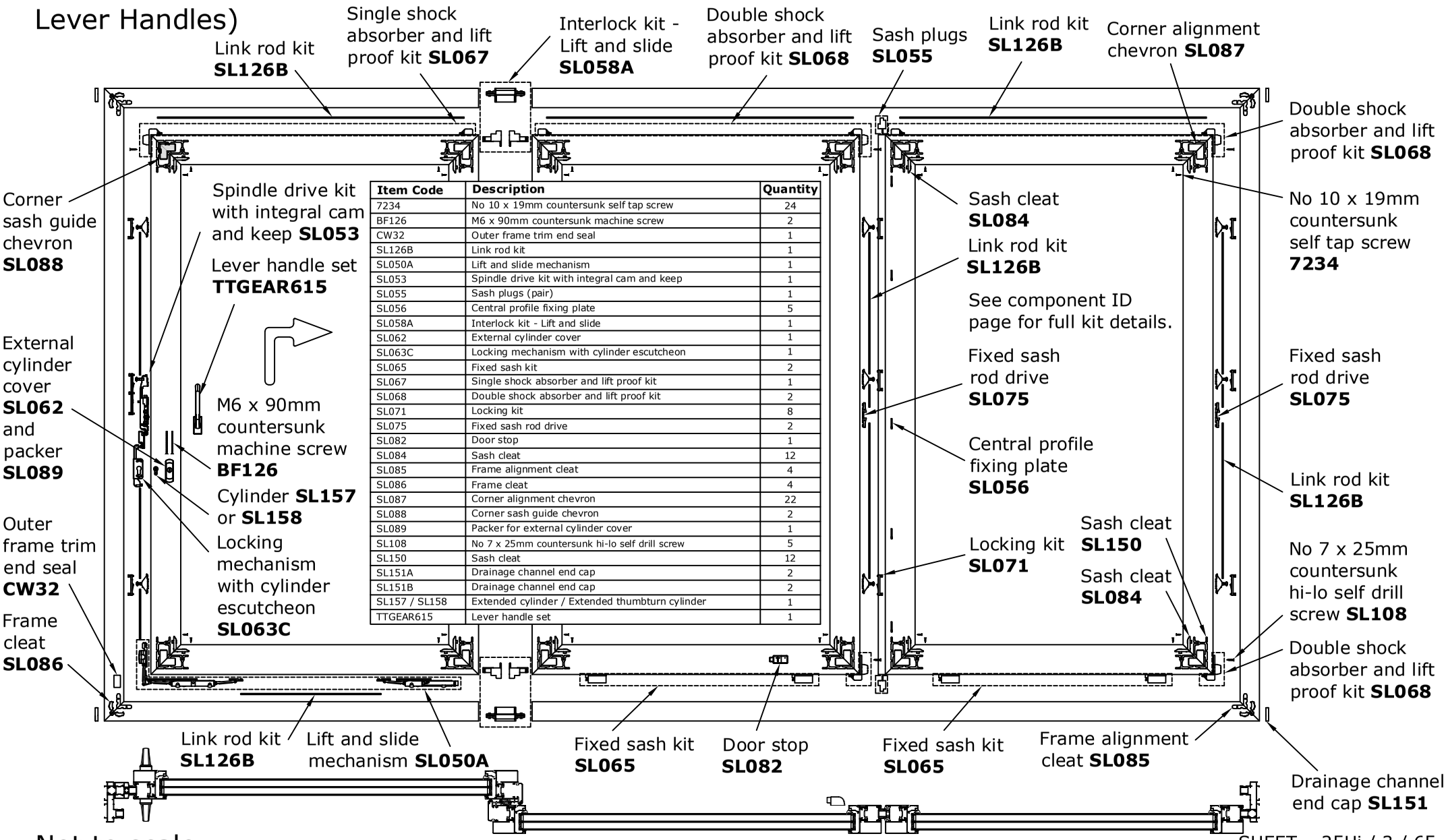
Not to scale

OUTSIDE

Lift and Slide / Fixed / Fixed (3 Pane) - Sashes SL129130/SL131132

Kitting List (Standard Locking, Internal Pane Sliding, Internal and External Lever Handles)

System 25 Hi/Hi+
LIFT AND SLIDE DOOR
2T



Item Code	Description	Quantity
7234	No 10 x 19mm countersunk self tap screw	24
BF126	M6 x 90mm countersunk machine screw	2
CW32	Outer frame trim end seal	1
SL126B	Link rod kit	1
SL050A	Lift and slide mechanism	1
SL053	Spindle drive kit with integral cam and keep	1
SL055	Sash plugs (pair)	1
SL056	Central profile fixing plate	5
SL058A	Interlock kit - Lift and slide	1
SL062	External cylinder cover	1
SL063C	Locking mechanism with cylinder escutcheon	1
SL065	Fixed sash kit	2
SL067	Single shock absorber and lift proof kit	1
SL068	Double shock absorber and lift proof kit	2
SL071	Locking kit	8
SL075	Fixed sash rod drive	2
SL082	Door stop	1
SL084	Sash cleat	12
SL085	Frame alignment cleat	4
SL086	Frame cleat	4
SL087	Corner alignment chevron	22
SL088	Corner sash guide chevron	2
SL089	Packer for external cylinder cover	1
SL108	No 7 x 25mm countersunk hi-lo self drill screw	5
SL150	Sash cleat	12
SL151A	Drainage channel end cap	2
SL151B	Drainage channel end cap	2
SL157 / SL158	Extended cylinder / Extended thumbturn cylinder	1
TTGEAR615	Lever handle set	1

Not to scale

OUTSIDE

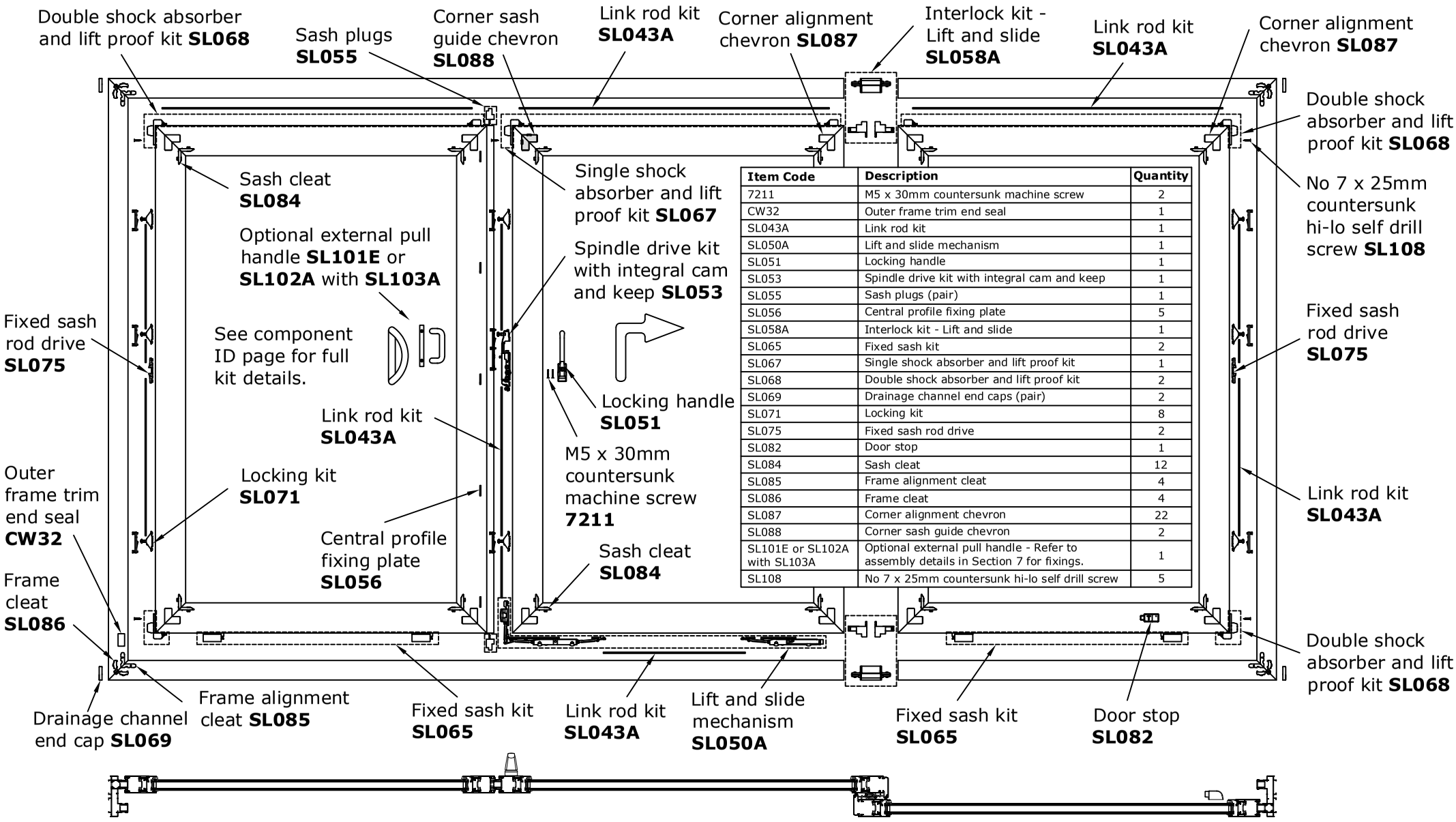
Fixed / Lift and Slide / Fixed (3 Pane) - Sash SL018016

Kitting List (Standard Locking, Internal Pane Sliding, Internal Lever Handle)

System 25 Hi/Hi+

LIFT AND SLIDE DOOR

2T



Item Code	Description	Quantity
7211	M5 x 30mm countersunk machine screw	2
CW32	Outer frame trim end seal	1
SL043A	Link rod kit	1
SL050A	Lift and slide mechanism	1
SL051	Locking handle	1
SL053	Spindle drive kit with integral cam and keep	1
SL055	Sash plugs (pair)	1
SL056	Central profile fixing plate	5
SL058A	Interlock kit - Lift and slide	1
SL065	Fixed sash kit	2
SL067	Single shock absorber and lift proof kit	1
SL068	Double shock absorber and lift proof kit	2
SL069	Drainage channel end caps (pair)	2
SL071	Locking kit	8
SL075	Fixed sash rod drive	2
SL082	Door stop	1
SL084	Sash cleat	12
SL085	Frame alignment cleat	4
SL086	Frame cleat	4
SL087	Corner alignment chevron	22
SL088	Corner sash guide chevron	2
SL101E or SL102A with SL103A	Optional external pull handle - Refer to assembly details in Section 7 for fixings.	1
SL108	No 7 x 25mm countersunk hi-lo self drill screw	5

OUTSIDE

Not to scale

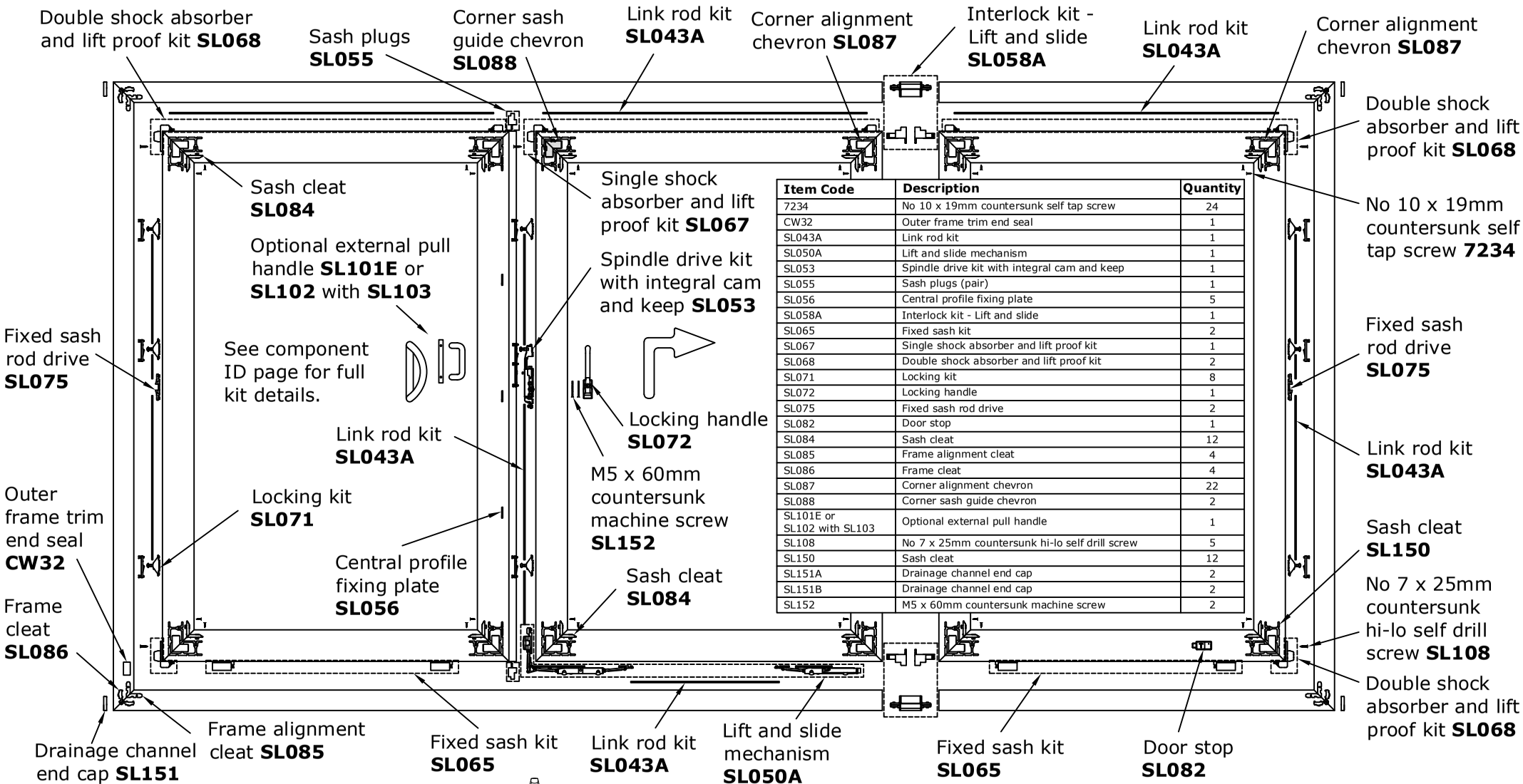
Fixed / Lift and Slide / Fixed (3 Pane) - Sash SL129130/SL131132

Kitting List (Standard Locking, Internal Pane Sliding, Internal Lever Handle)

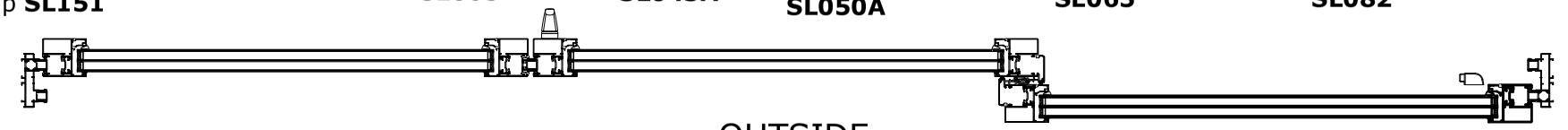
System 25 Hi/Hi+

LIFT AND SLIDE DOOR

2T



Item Code	Description	Quantity
7234	No 10 x 19mm countersunk self tap screw	24
CW32	Outer frame trim end seal	1
SL043A	Link rod kit	1
SL050A	Lift and slide mechanism	1
SL053	Spindle drive kit with integral cam and keep	1
SL055	Sash plugs (pair)	1
SL056	Central profile fixing plate	5
SL058A	Interlock kit - Lift and slide	1
SL065	Fixed sash kit	2
SL067	Single shock absorber and lift proof kit	1
SL068	Double shock absorber and lift proof kit	2
SL071	Locking kit	8
SL072	Locking handle	1
SL075	Fixed sash rod drive	2
SL082	Door stop	1
SL084	Sash cleat	12
SL085	Frame alignment cleat	4
SL086	Frame cleat	4
SL087	Corner alignment chevron	22
SL088	Corner sash guide chevron	2
SL101E or SL102 with SL103	Optional external pull handle	1
SL108	No 7 x 25mm countersunk hi-lo self drill screw	5
SL150	Sash cleat	12
SL151A	Drainage channel end cap	2
SL151B	Drainage channel end cap	2
SL152	M5 x 60mm countersunk machine screw	2



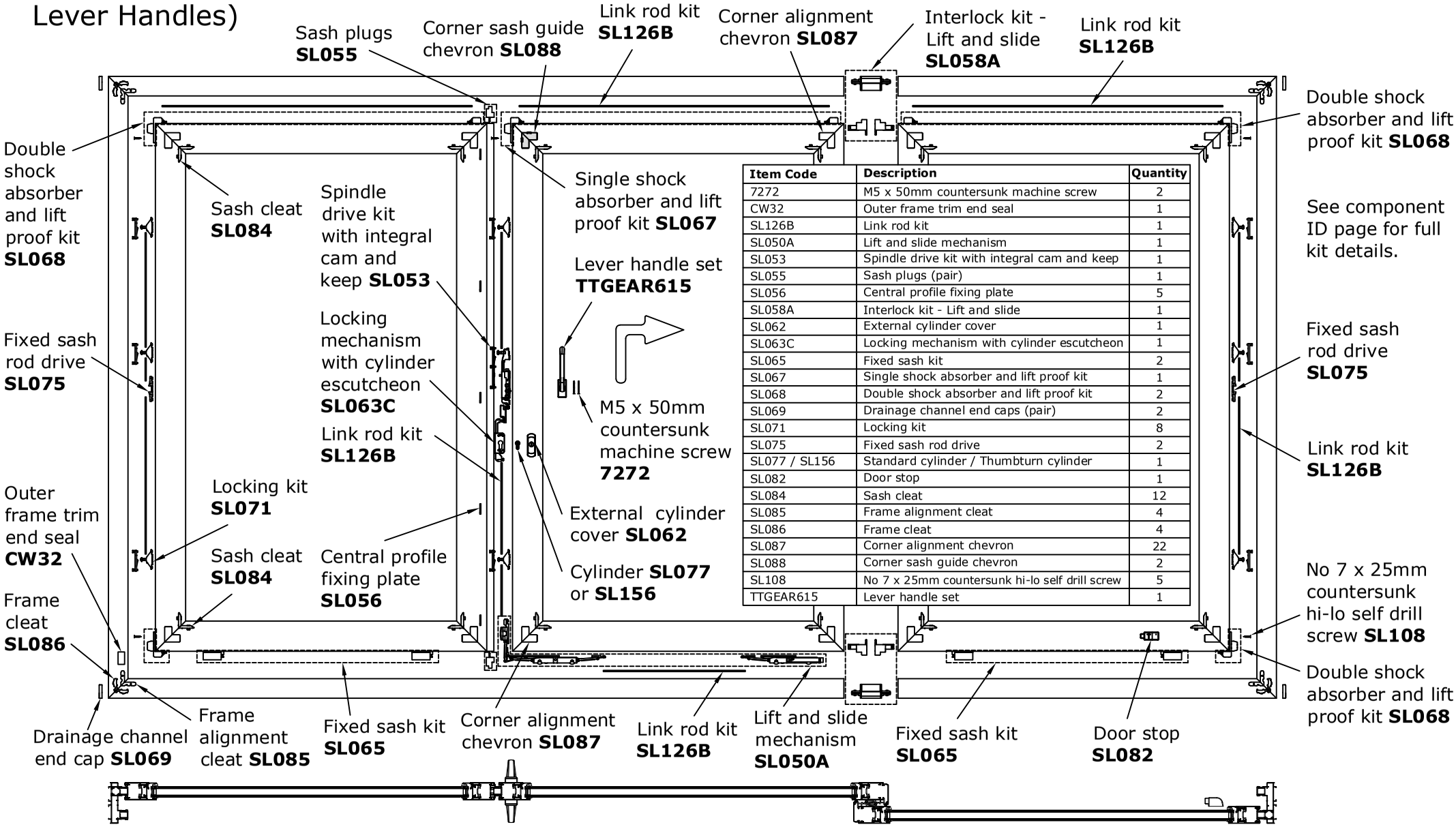
OUTSIDE

Not to scale

Fixed / Lift and Slide / Fixed (3 Pane) - Sash SL018016

Kitting List (Standard Locking, Internal Pane Sliding, Internal and External Lever Handles)

System 25 Hi/Hi+
LIFT AND SLIDE DOOR
2T



Item Code	Description	Quantity
7272	M5 x 50mm countersunk machine screw	2
CW32	Outer frame trim end seal	1
SL126B	Link rod kit	1
SL050A	Lift and slide mechanism	1
SL053	Spindle drive kit with integral cam and keep	1
SL055	Sash plugs (pair)	1
SL056	Central profile fixing plate	5
SL058A	Interlock kit - Lift and slide	1
SL062	External cylinder cover	1
SL063C	Locking mechanism with cylinder escutcheon	1
SL065	Fixed sash kit	2
SL067	Single shock absorber and lift proof kit	1
SL068	Double shock absorber and lift proof kit	2
SL069	Drainage channel end caps (pair)	2
SL071	Locking kit	8
SL075	Fixed sash rod drive	2
SL077 / SL156	Standard cylinder / Thumbturn cylinder	1
SL082	Door stop	1
SL084	Sash cleat	12
SL085	Frame alignment cleat	4
SL086	Frame cleat	4
SL087	Corner alignment chevron	22
SL088	Corner sash guide chevron	2
SL108	No 7 x 25mm countersunk hi-lo self drill screw	5
TTGEAR615	Lever handle set	1

See component ID page for full kit details.

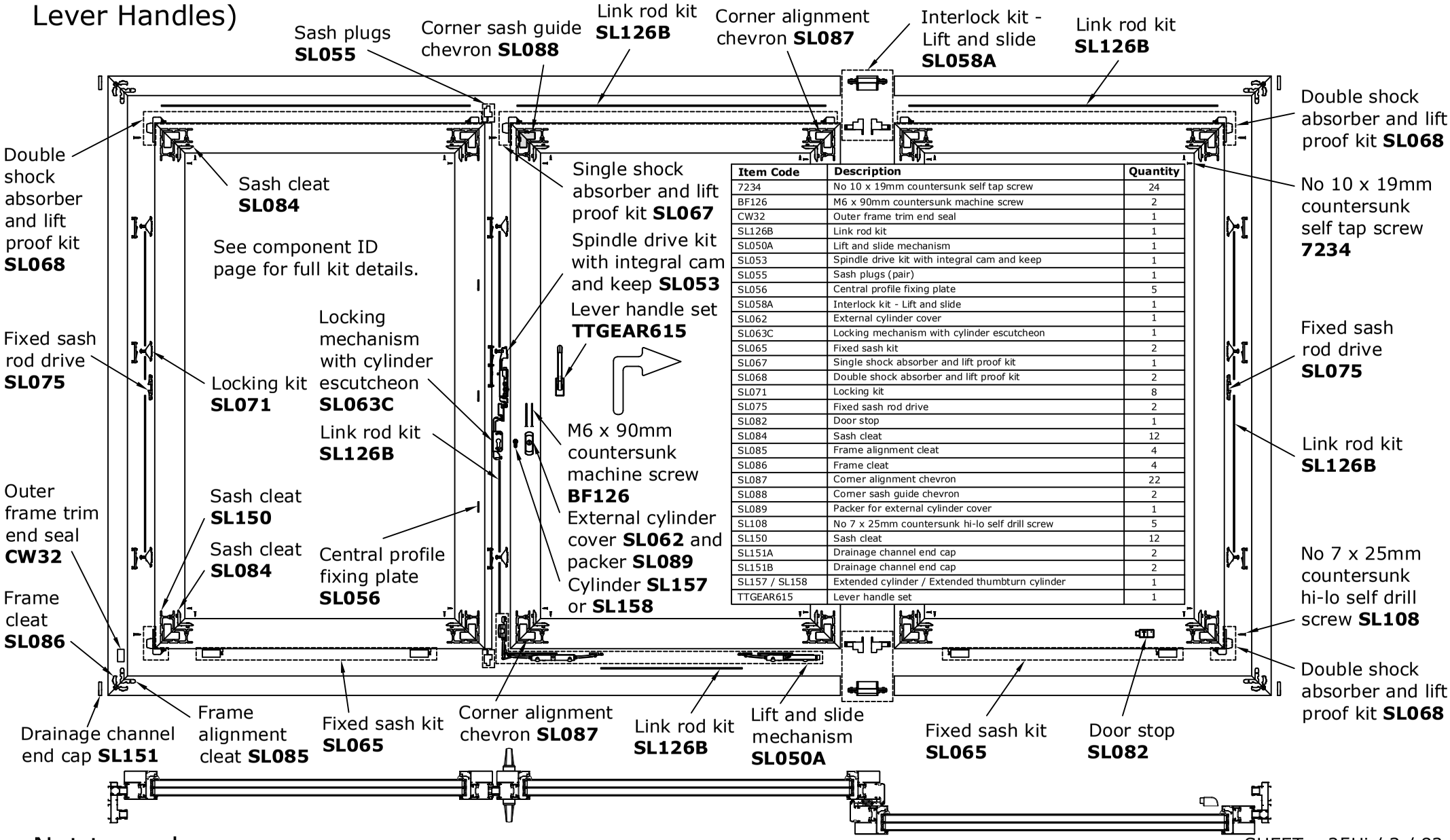
Not to scale

OUTSIDE

Fixed / Lift and Slide / Fixed (3 Pane) - Sashes SL129130/SL131132

Kitting List (Standard Locking, Internal Pane Sliding, Internal and External Lever Handles)

System 25 Hi/Hi+
LIFT AND SLIDE DOOR
2T



Item Code	Description	Quantity
7234	No 10 x 19mm countersunk self tap screw	24
BF126	M6 x 90mm countersunk machine screw	2
CW32	Outer frame trim end seal	1
SL126B	Link rod kit	1
SL050A	Lift and slide mechanism	1
SL053	Spindle drive kit with integral cam and keep	1
SL055	Sash plugs (pair)	1
SL056	Central profile fixing plate	5
SL058A	Interlock kit - Lift and slide	1
SL062	External cylinder cover	1
SL063C	Locking mechanism with cylinder escutcheon	1
SL065	Fixed sash kit	2
SL067	Single shock absorber and lift proof kit	1
SL068	Double shock absorber and lift proof kit	2
SL071	Locking kit	8
SL075	Fixed sash rod drive	2
SL082	Door stop	1
SL084	Sash cleat	12
SL085	Frame alignment cleat	4
SL086	Frame cleat	4
SL087	Corner alignment chevron	22
SL088	Corner sash guide chevron	2
SL089	Packer for external cylinder cover	1
SL108	No 7 x 25mm countersunk hi-lo self drill screw	5
SL150	Sash cleat	12
SL151A	Drainage channel end cap	2
SL151B	Drainage channel end cap	2
SL157 / SL158	Extended cylinder / Extended thumbturn cylinder	1
TTGEAR615	Lever handle set	1

Not to scale

OUTSIDE

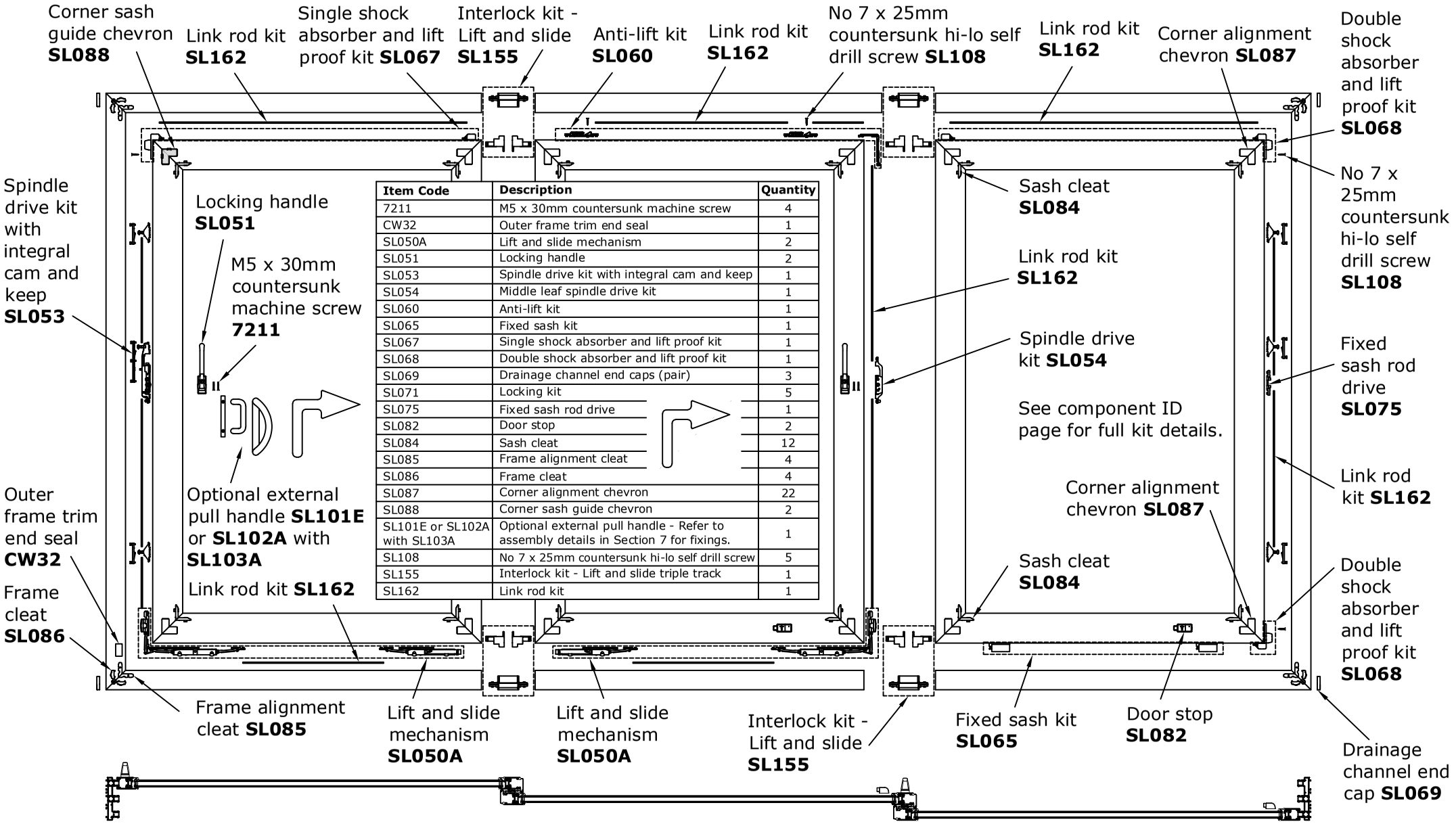
Lift and Slide / Lift and Slide / Fixed (Triple Track 3 Pane) - Sash SL018016

Kitting List (Standard Locking, Internal Panes Sliding, Internal Lever Handles)

System 25 Hi/Hi+

LIFT AND SLIDE DOOR

3T



Item Code	Description	Quantity
7211	M5 x 30mm countersunk machine screw	4
CW32	Outer frame trim end seal	1
SL050A	Lift and slide mechanism	2
SL051	Locking handle	2
SL053	Spindle drive kit with integral cam and keep	1
SL054	Middle leaf spindle drive kit	1
SL060	Anti-lift kit	1
SL065	Fixed sash kit	1
SL067	Single shock absorber and lift proof kit	1
SL068	Double shock absorber and lift proof kit	1
SL069	Drainage channel end caps (pair)	3
SL071	Locking kit	5
SL075	Fixed sash rod drive	1
SL082	Door stop	2
SL084	Sash cleat	12
SL085	Frame alignment cleat	4
SL086	Frame cleat	4
SL087	Corner alignment chevron	22
SL088	Corner sash guide chevron	2
SL101E or SL102A with SL103A	Optional external pull handle - Refer to assembly details in Section 7 for fixings.	1
SL108	No 7 x 25mm countersunk hi-lo self drill screw	5
SL155	Interlock kit - Lift and slide triple track	1
SL162	Link rod kit	1

Not to scale

OUTSIDE

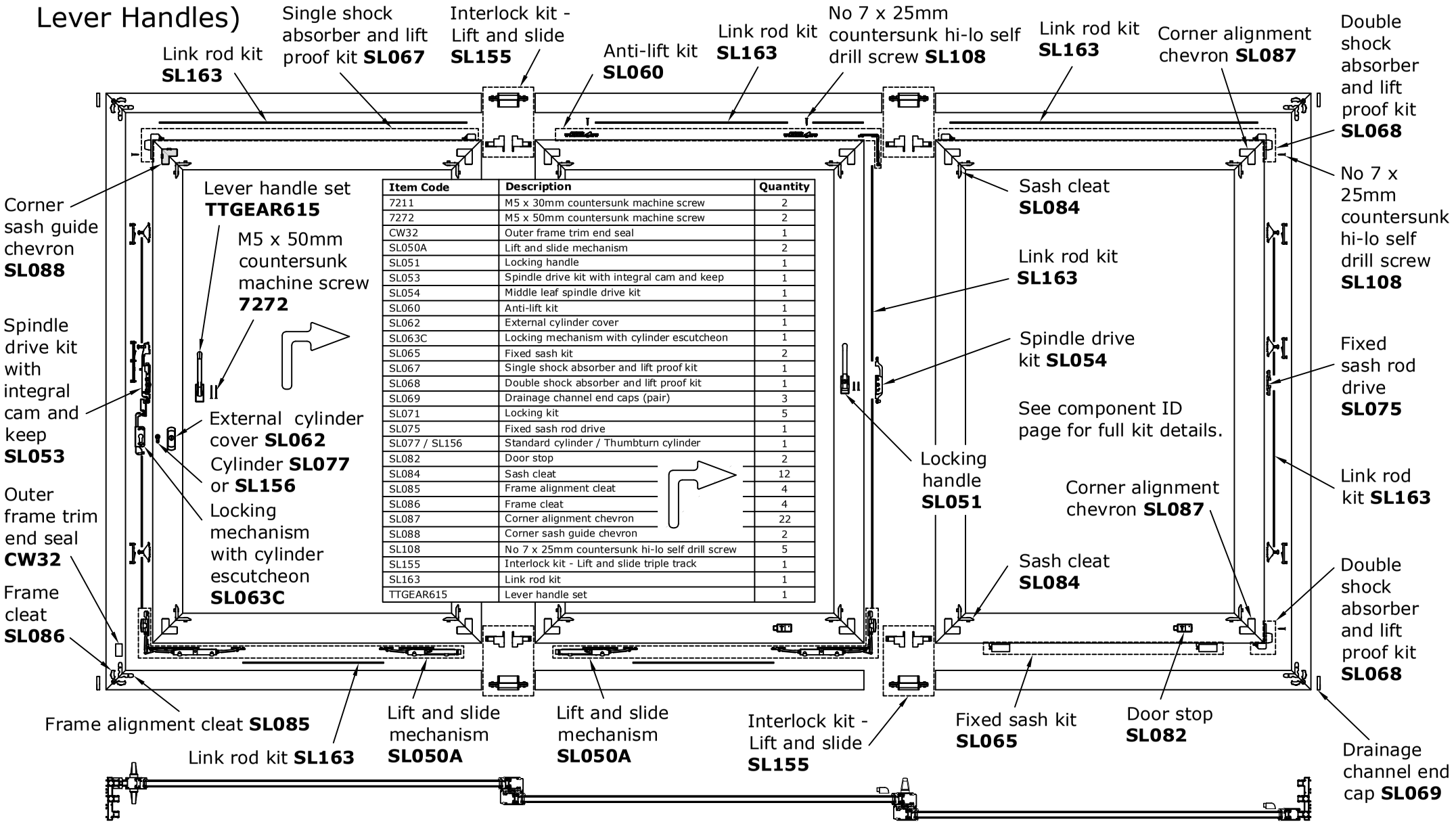
Lift and Slide / Lift and Slide / Fixed (Triple Track 3 Pane) - Sash SL018016

Kitting List (Standard Locking, Internal Panes Sliding, Internal and External Lever Handles)

System 25 Hi/Hi+

LIFT AND SLIDE DOOR

3T



Item Code	Description	Quantity
7211	M5 x 30mm countersunk machine screw	2
7272	M5 x 50mm countersunk machine screw	2
CW32	Outer frame trim end seal	1
SL050A	Lift and slide mechanism	2
SL051	Locking handle	1
SL053	Spindle drive kit with integral cam and keep	1
SL054	Middle leaf spindle drive kit	1
SL060	Anti-lift kit	1
SL062	External cylinder cover	1
SL063C	Locking mechanism with cylinder escutcheon	1
SL065	Fixed sash kit	2
SL067	Single shock absorber and lift proof kit	1
SL068	Double shock absorber and lift proof kit	1
SL069	Drainage channel end caps (pair)	3
SL071	Locking kit	5
SL075	Fixed sash rod drive	1
SL077 / SL156	Standard cylinder / Thumbturn cylinder	1
SL082	Door stop	2
SL084	Sash cleat	12
SL085	Frame alignment cleat	4
SL086	Frame cleat	4
SL087	Corner alignment chevron	22
SL088	Corner sash guide chevron	2
SL108	No 7 x 25mm countersunk hi-lo self drill screw	5
SL155	Interlock kit - Lift and slide triple track	1
SL163	Link rod kit	1
TTGEAR615	Lever handle set	1

Not to scale

OUTSIDE

SHEET 25Hi / 3 / 87

rev 0 26/04/22

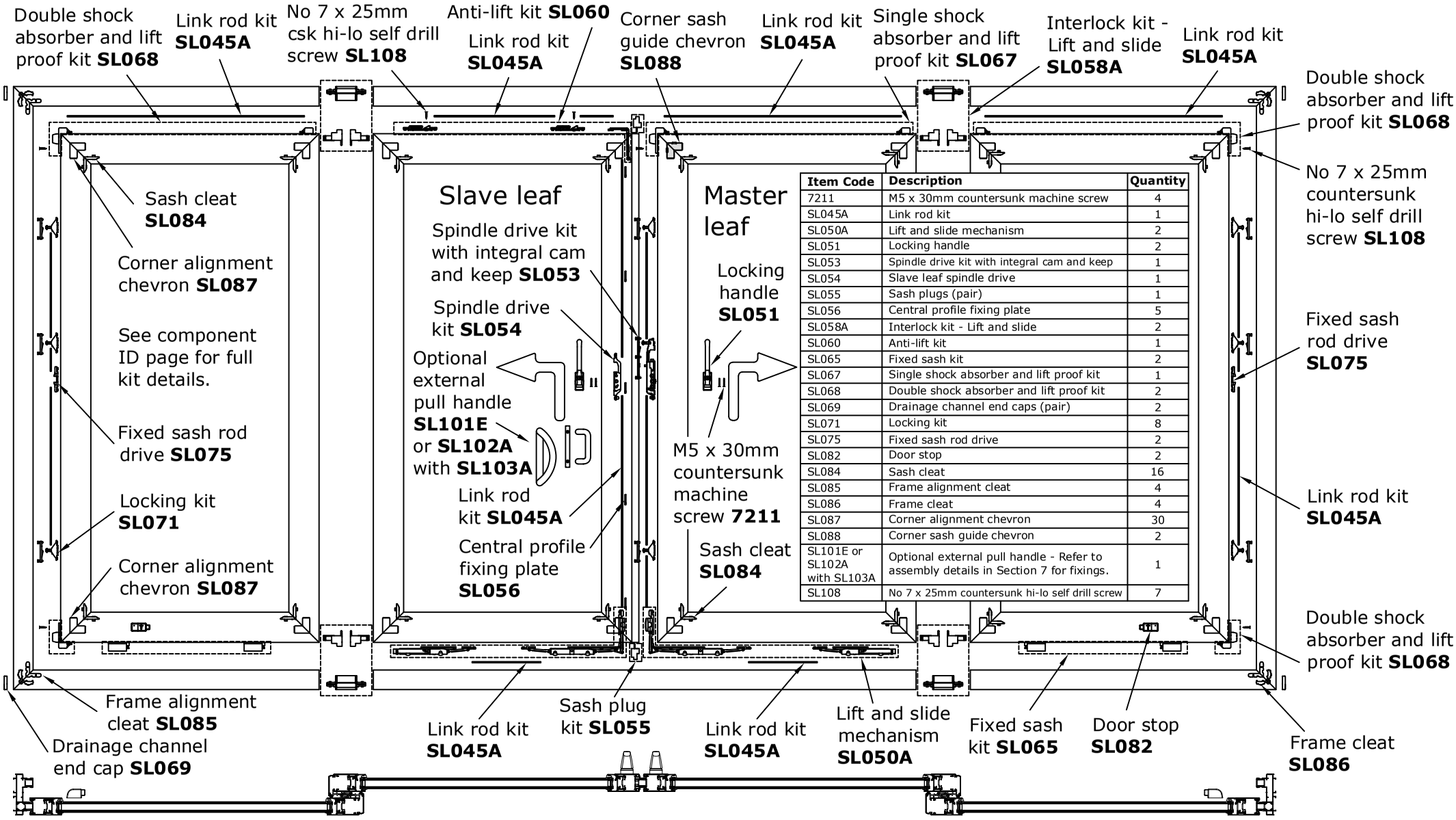
Fixed / Lift and Slide / Lift and Slide / Fixed (4 Pane) - Sash SL018016

Kitting List (Standard Locking, Internal Panes Sliding, Internal Lever Handles)

System 25 Hi/Hi+

LIFT AND SLIDE DOOR

2T



Item Code	Description	Quantity
7211	M5 x 30mm countersunk machine screw	4
SL045A	Link rod kit	1
SL050A	Lift and slide mechanism	2
SL051	Locking handle	2
SL053	Spindle drive kit with integral cam and keep	1
SL054	Slave leaf spindle drive	1
SL055	Sash plugs (pair)	1
SL056	Central profile fixing plate	5
SL058A	Interlock kit - Lift and slide	2
SL060	Anti-lift kit	1
SL065	Fixed sash kit	2
SL067	Single shock absorber and lift proof kit	1
SL068	Double shock absorber and lift proof kit	2
SL069	Drainage channel end caps (pair)	2
SL071	Locking kit	8
SL075	Fixed sash rod drive	2
SL082	Door stop	2
SL084	Sash cleat	16
SL085	Frame alignment cleat	4
SL086	Frame cleat	4
SL087	Corner alignment chevron	30
SL088	Corner sash guide chevron	2
SL101E or SL102A with SL103A	Optional external pull handle - Refer to assembly details in Section 7 for fixings.	1
SL108	No 7 x 25mm countersunk hi-lo self drill screw	7

OUTSIDE

Not to scale

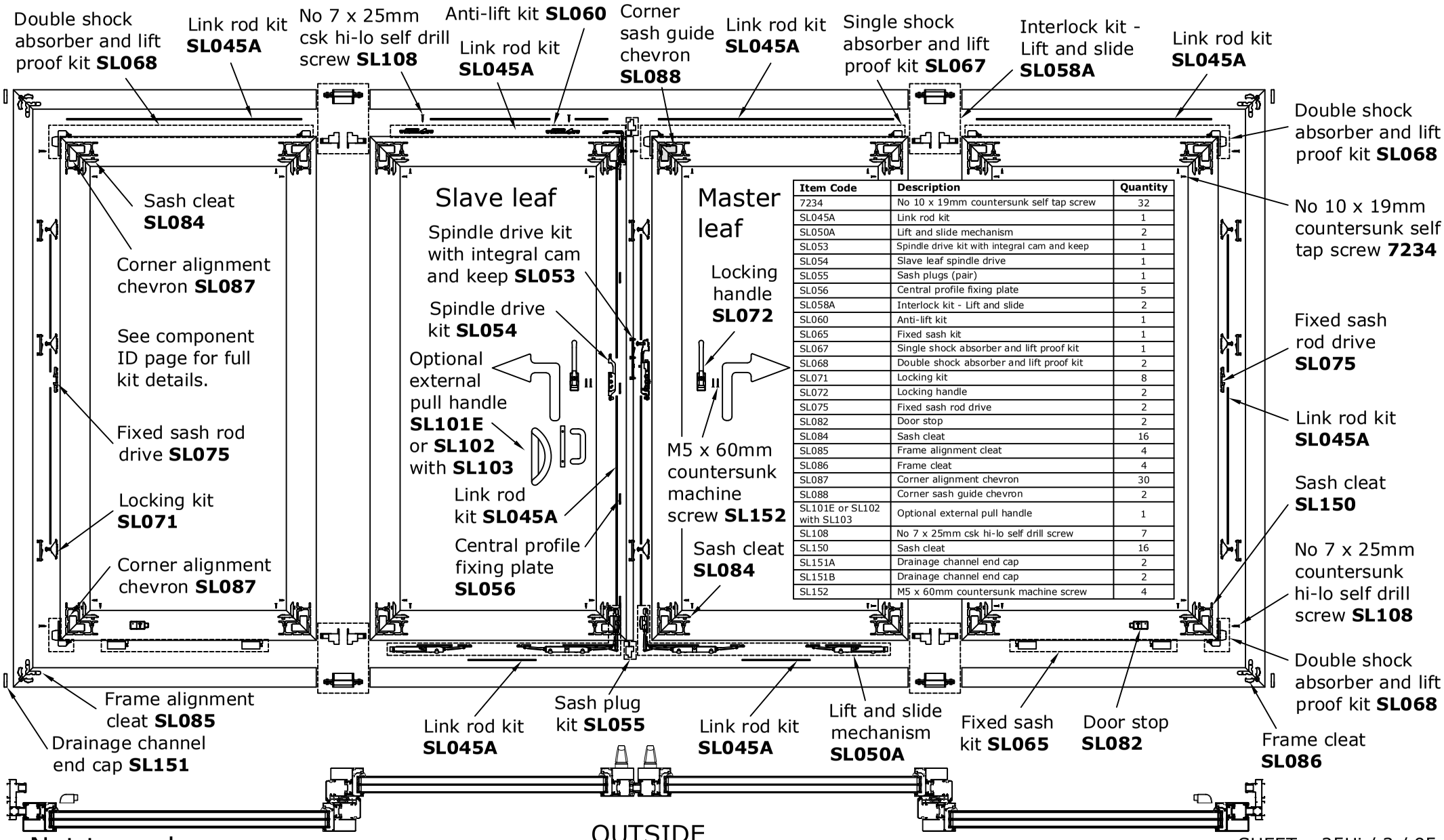
Fixed / Lift and Slide / Lift and Slide / Fixed (4 Pane) - Sash SL129130/SL131132

Kitting List (Standard Locking, Internal Panes Sliding, Internal Lever Handles)

System 25 Hi/Hi+

LIFT AND SLIDE DOOR

2T



Item Code	Description	Quantity
7234	No 10 x 19mm countersunk self tap screw	32
SL045A	Link rod kit	1
SL050A	Lift and slide mechanism	2
SL053	Spindle drive kit with integral cam and keep	1
SL054	Slave leaf spindle drive	1
SL055	Sash plugs (pair)	1
SL056	Central profile fixing plate	5
SL058A	Interlock kit - Lift and slide	2
SL060	Anti-lift kit	1
SL065	Fixed sash kit	1
SL067	Single shock absorber and lift proof kit	1
SL068	Double shock absorber and lift proof kit	2
SL071	Locking kit	8
SL072	Locking handle	2
SL075	Fixed sash rod drive	2
SL082	Door stop	2
SL084	Sash cleat	16
SL085	Frame alignment cleat	4
SL086	Frame cleat	4
SL087	Corner alignment chevron	30
SL088	Corner sash guide chevron	2
SL101E or SL102 with SL103	Optional external pull handle	1
SL108	No 7 x 25mm csk hi-lo self drill screw	7
SL150	Sash cleat	16
SL151A	Drainage channel end cap	2
SL151B	Drainage channel end cap	2
SL152	M5 x 60mm countersunk machine screw	4

Not to scale

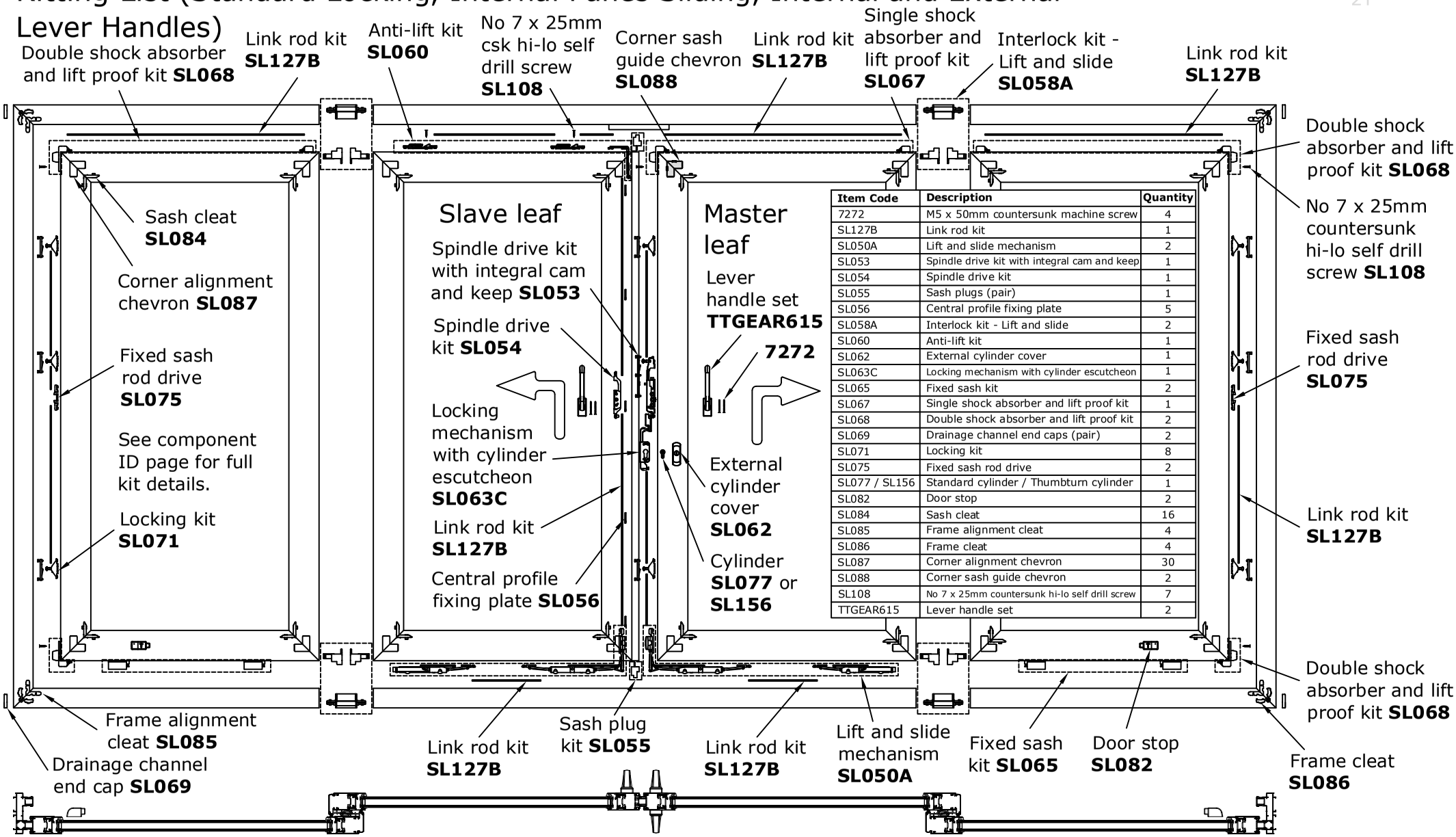
Fixed / Lift and Slide / Lift and Slide / Fixed (4 Pane) - Sash SL018016

System 25 Hi/Hi+

LIFT AND SLIDE DOOR

2T

Kitting List (Standard Locking, Internal Panes Sliding, Internal and External Lever Handles)



Item Code	Description	Quantity
7272	M5 x 50mm countersunk machine screw	4
SL127B	Link rod kit	1
SL050A	Lift and slide mechanism	2
SL053	Spindle drive kit with integral cam and keep	1
SL054	Spindle drive kit	1
SL055	Sash plugs (pair)	1
SL056	Central profile fixing plate	5
SL058A	Interlock kit - Lift and slide	2
SL060	Anti-lift kit	1
SL062	External cylinder cover	1
SL063C	Locking mechanism with cylinder escutcheon	1
SL065	Fixed sash kit	2
SL067	Single shock absorber and lift proof kit	1
SL068	Double shock absorber and lift proof kit	2
SL069	Drainage channel end caps (pair)	2
SL071	Locking kit	8
SL075	Fixed sash rod drive	2
SL077 / SL156	Standard cylinder / Thumbturn cylinder	1
SL082	Door stop	2
SL084	Sash cleat	16
SL085	Frame alignment cleat	4
SL086	Frame cleat	4
SL087	Corner alignment chevron	30
SL088	Corner sash guide chevron	2
SL108	No 7 x 25mm countersunk hi-lo self drill screw	7
TTGEAR615	Lever handle set	2

Not to scale

OUTSIDE

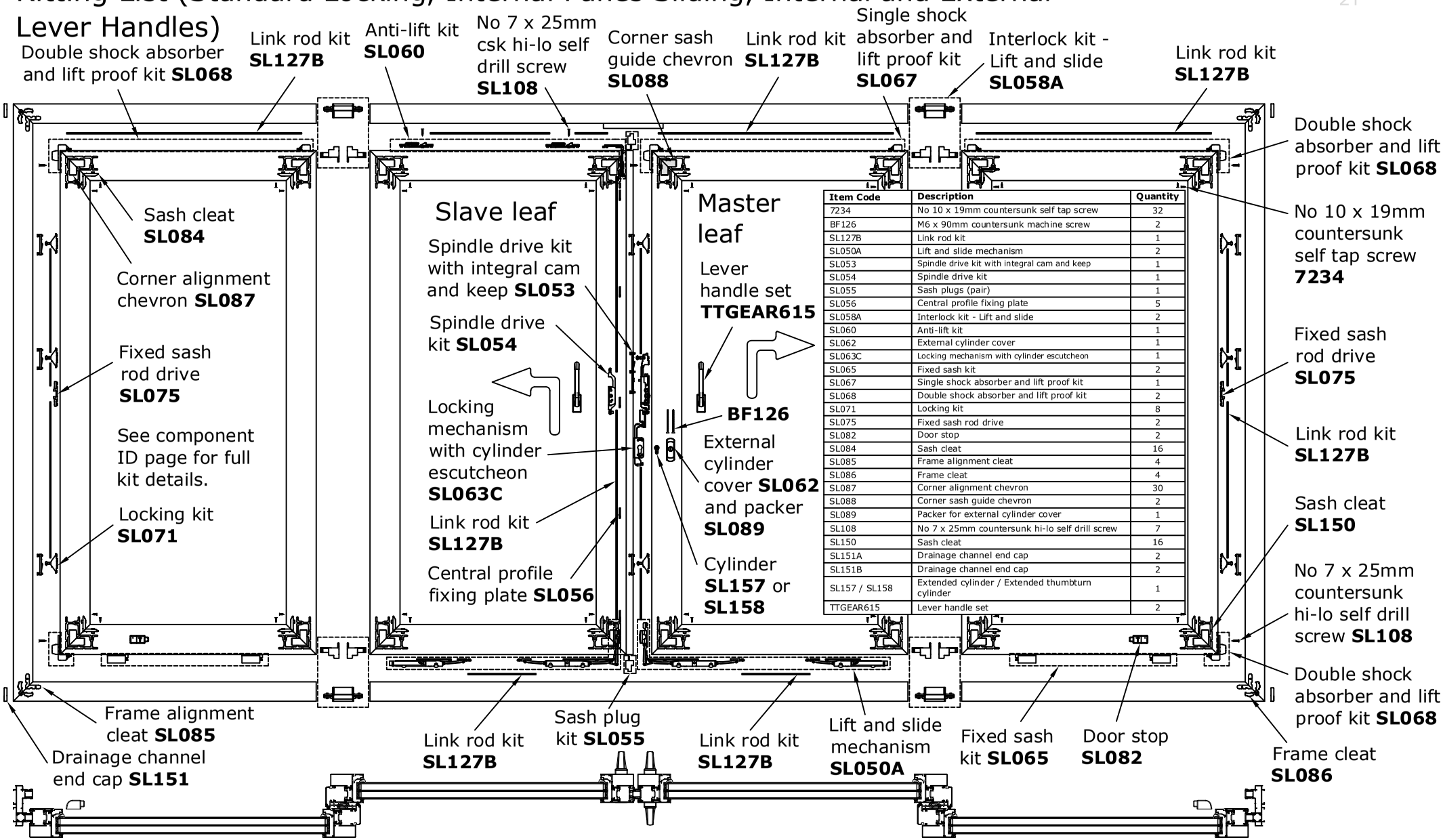
Fixed / Lift and Slide / Lift and Slide / Fixed (4 Pane) - Sashes SL129130/SL131132

System 25 Hi/Hi+

LIFT AND SLIDE DOOR

2T

Kitting List (Standard Locking, Internal Panes Sliding, Internal and External Lever Handles)



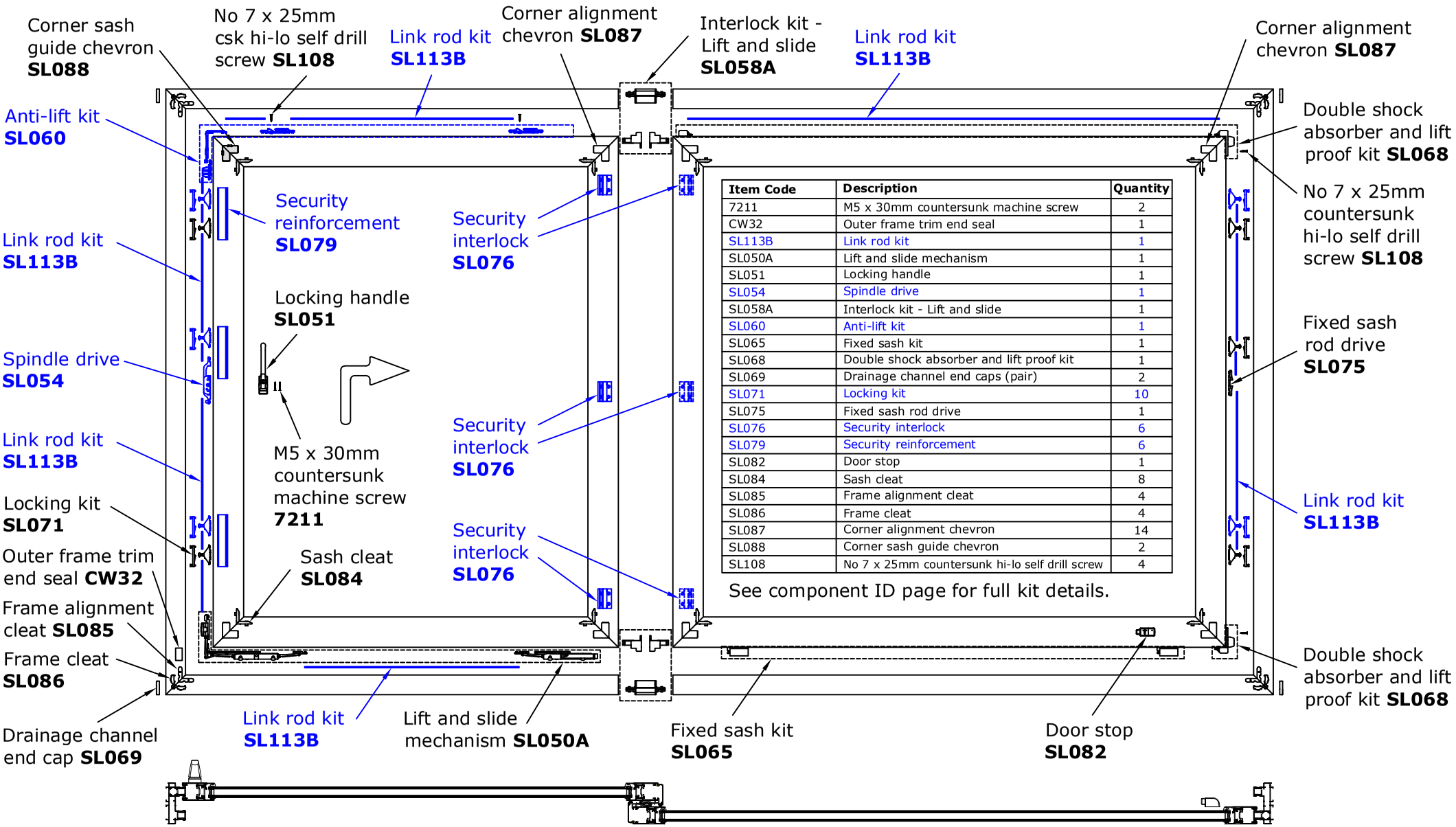
Item Code	Description	Quantity
7234	No 10 x 19mm countersunk self tap screw	32
BF126	M6 x 90mm countersunk machine screw	2
SL127B	Link rod kit	1
SL050A	Lift and slide mechanism	2
SL053	Spindle drive kit with integral cam and keep	1
SL054	Spindle drive kit	1
SL055	Sash plugs (pair)	1
SL056	Central profile fixing plate	5
SL058A	Interlock kit - Lift and slide	2
SL060	Anti-lift kit	1
SL062	External cylinder cover	1
SL063C	Locking mechanism with cylinder escutcheon	1
SL065	Fixed sash kit	2
SL067	Single shock absorber and lift proof kit	1
SL068	Double shock absorber and lift proof kit	2
SL071	Locking kit	8
SL075	Fixed sash rod drive	2
SL082	Door stop	2
SL084	Sash cleat	16
SL085	Frame alignment cleat	4
SL086	Frame cleat	4
SL087	Corner alignment chevron	30
SL088	Corner sash guide chevron	2
SL089	Packer for external cylinder cover	1
SL108	No 7 x 25mm countersunk hi-lo self drill screw	7
SL150	Sash cleat	16
SL151A	Drainage channel end cap	2
SL151B	Drainage channel end cap	2
SL157 / SL158	Extended cylinder / Extended thumbturn cylinder	1
TTGEAR615	Lever handle set	2

Not to scale

Lift and Slide / Fixed (2 Pane) - Security - Sash SL018016

Kitting List (Security Locking, Internal Pane Sliding, Internal Lever Handle)

System 25 Hi/Hi+
LIFT AND SLIDE DOOR
2T



Item Code	Description	Quantity
7211	M5 x 30mm countersunk machine screw	2
CW32	Outer frame trim end seal	1
SL113B	Link rod kit	1
SL050A	Lift and slide mechanism	1
SL051	Locking handle	1
SL054	Spindle drive	1
SL058A	Interlock kit - Lift and slide	1
SL060	Anti-lift kit	1
SL065	Fixed sash kit	1
SL068	Double shock absorber and lift proof kit	1
SL069	Drainage channel end caps (pair)	2
SL071	Locking kit	10
SL075	Fixed sash rod drive	1
SL076	Security interlock	6
SL079	Security reinforcement	6
SL082	Door stop	1
SL084	Sash cleat	8
SL085	Frame alignment cleat	4
SL086	Frame cleat	4
SL087	Corner alignment chevron	14
SL088	Corner sash guide chevron	2
SL108	No 7 x 25mm countersunk hi-lo self drill screw	4

See component ID page for full kit details.

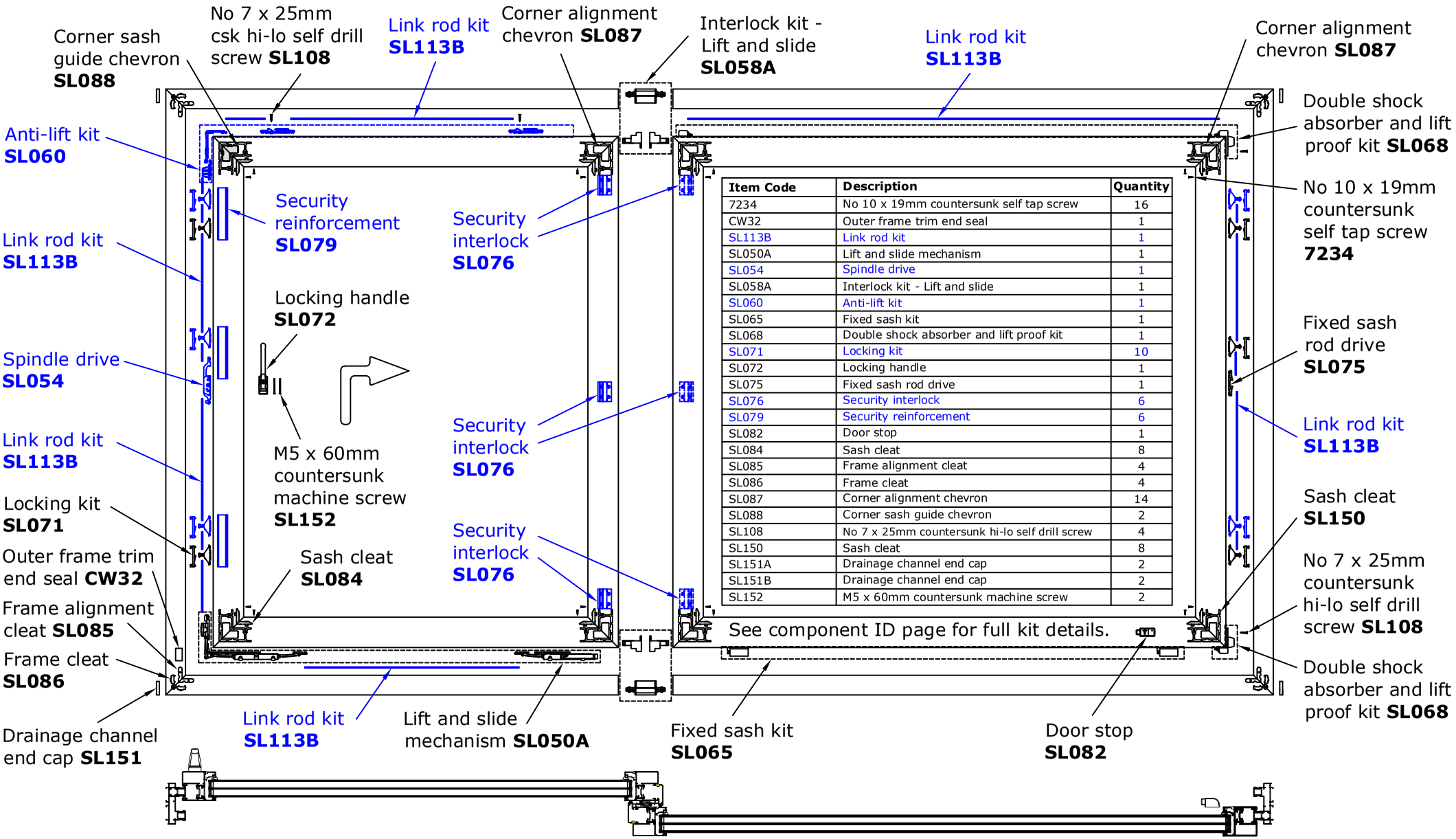
Not to scale

OUTSIDE

Lift and Slide / Fixed (2 Pane) - Security - Sashes SL129130/SL131132

Kitting List (Security Locking, Internal Pane Sliding, Internal Lever Handle)

System 25 Hi/Hi+
LIFT AND SLIDE DOOR
2T



Item Code	Description	Quantity
7234	No 10 x 19mm countersunk self tap screw	16
CW32	Outer frame trim end seal	1
SL113B	Link rod kit	1
SL050A	Lift and slide mechanism	1
SL054	Spindle drive	1
SL058A	Interlock kit - Lift and slide	1
SL060	Anti-lift kit	1
SL065	Fixed sash kit	1
SL068	Double shock absorber and lift proof kit	1
SL071	Locking kit	10
SL072	Locking handle	1
SL075	Fixed sash rod drive	1
SL076	Security interlock	6
SL079	Security reinforcement	6
SL082	Door stop	1
SL084	Sash cleat	8
SL085	Frame alignment cleat	4
SL086	Frame cleat	4
SL087	Corner alignment chevron	14
SL088	Corner sash guide chevron	2
SL108	No 7 x 25mm countersunk hi-lo self drill screw	4
SL150	Sash cleat	8
SL151A	Drainage channel end cap	2
SL151B	Drainage channel end cap	2
SL152	M5 x 60mm countersunk machine screw	2

See component ID page for full kit details.

Not to scale

OUTSIDE

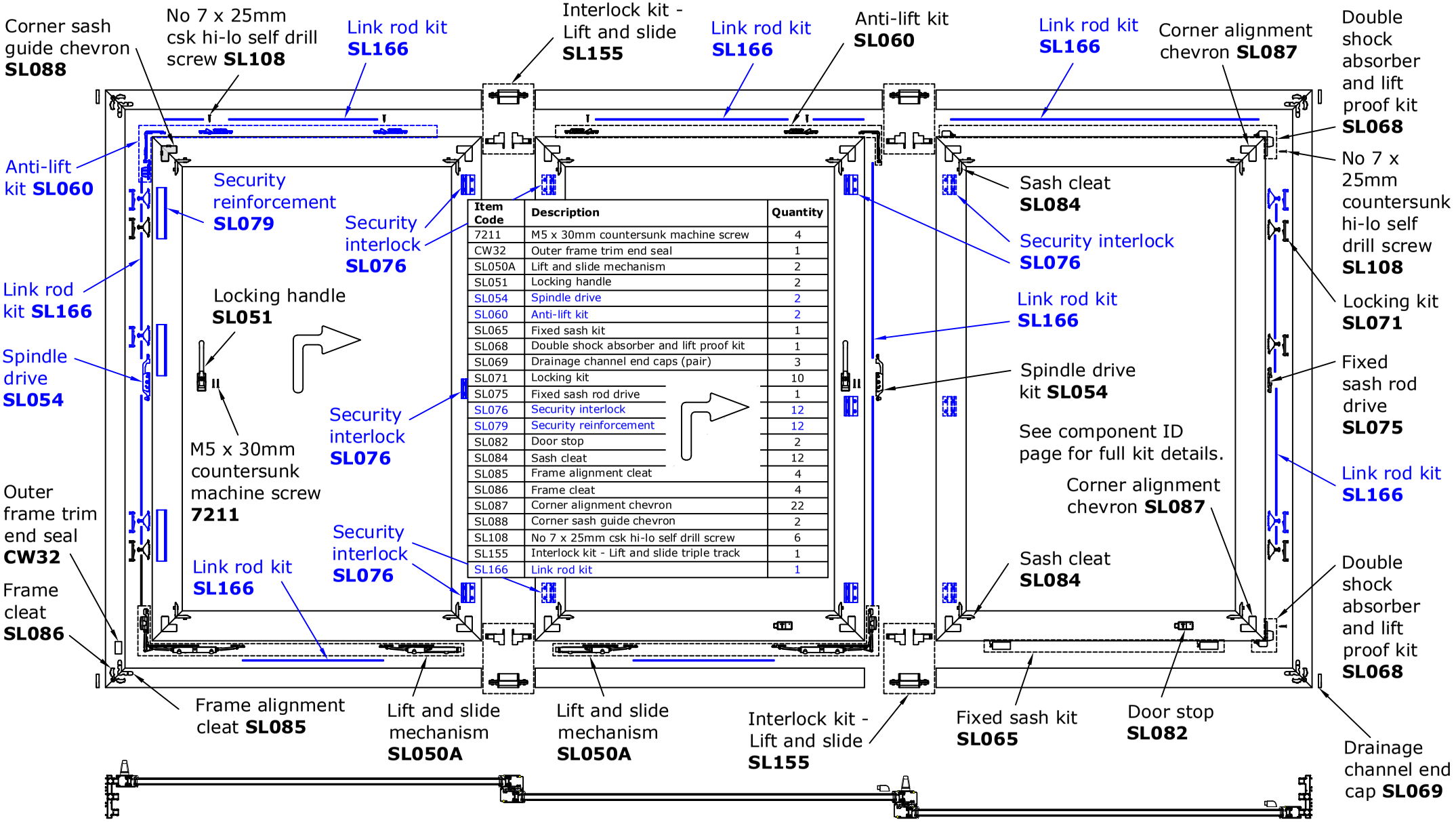
Lift and Slide / Lift and Slide / Fixed (Triple Track 3 Pane) - Security Sash SL018016

Kitting List (Security Locking, Internal Panes Sliding, Internal Lever Handles)

System 25 Hi/Hi+

LIFT AND SLIDE DOOR

3T



Item Code	Description	Quantity
7211	M5 x 30mm countersunk machine screw	4
CW32	Outer frame trim end seal	1
SL050A	Lift and slide mechanism	2
SL051	Locking handle	2
SL054	Spindle drive	2
SL060	Anti-lift kit	2
SL065	Fixed sash kit	1
SL068	Double shock absorber and lift proof kit	1
SL069	Drainage channel end caps (pair)	3
SL071	Locking kit	10
SL075	Fixed sash rod drive	1
SL076	Security interlock	12
SL079	Security reinforcement	12
SL082	Door stop	2
SL084	Sash cleat	12
SL085	Frame alignment cleat	4
SL086	Frame cleat	4
SL087	Corner alignment chevron	22
SL088	Corner sash guide chevron	2
SL108	No 7 x 25mm csk hi-lo self drill screw	6
SL155	Interlock kit - Lift and slide triple track	1
SL166	Link rod kit	1

Not to scale

OUTSIDE

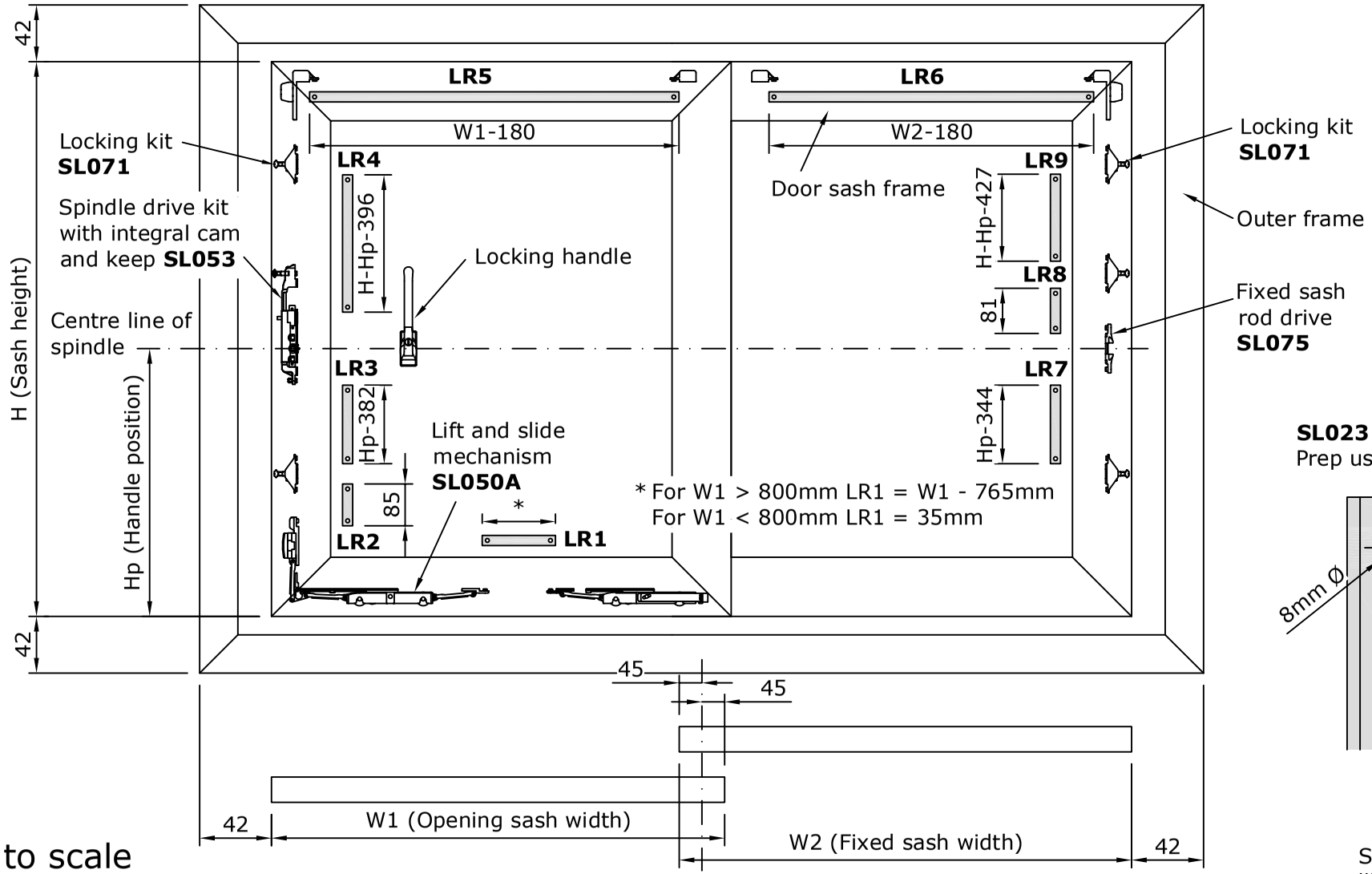
Lift and Slide / Fixed (2 Pane)

Link Rod Details (Standard Locking, Internal Pane Sliding, Internal Lever Handle)

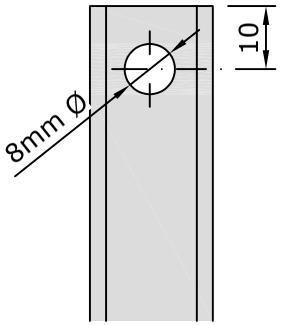
System 25 Hi/Hi+
LIFT AND SLIDE DOOR

If link rod SL023 is purchased in rolls the following cutting dimensions should be used. Tooling is available for automated cutting and prepping of link rods (JIG25003, JIG25004, JIG25005, JIG25006). Alternatively Metal Technology can supply made to measure kits for individual door sizes. Refer to Vent Size Limitation Chart.

For doors with overall outer frame height of greater than 1900mm, link rod dimensions are based on handle height of 1 metre from bottom of outer frame.
For overall outer frame height of less than 1900mm link rod dimensions are based on handle fitted centrally.



SL023 Link rod end prep.
Prep using jig JIG25003



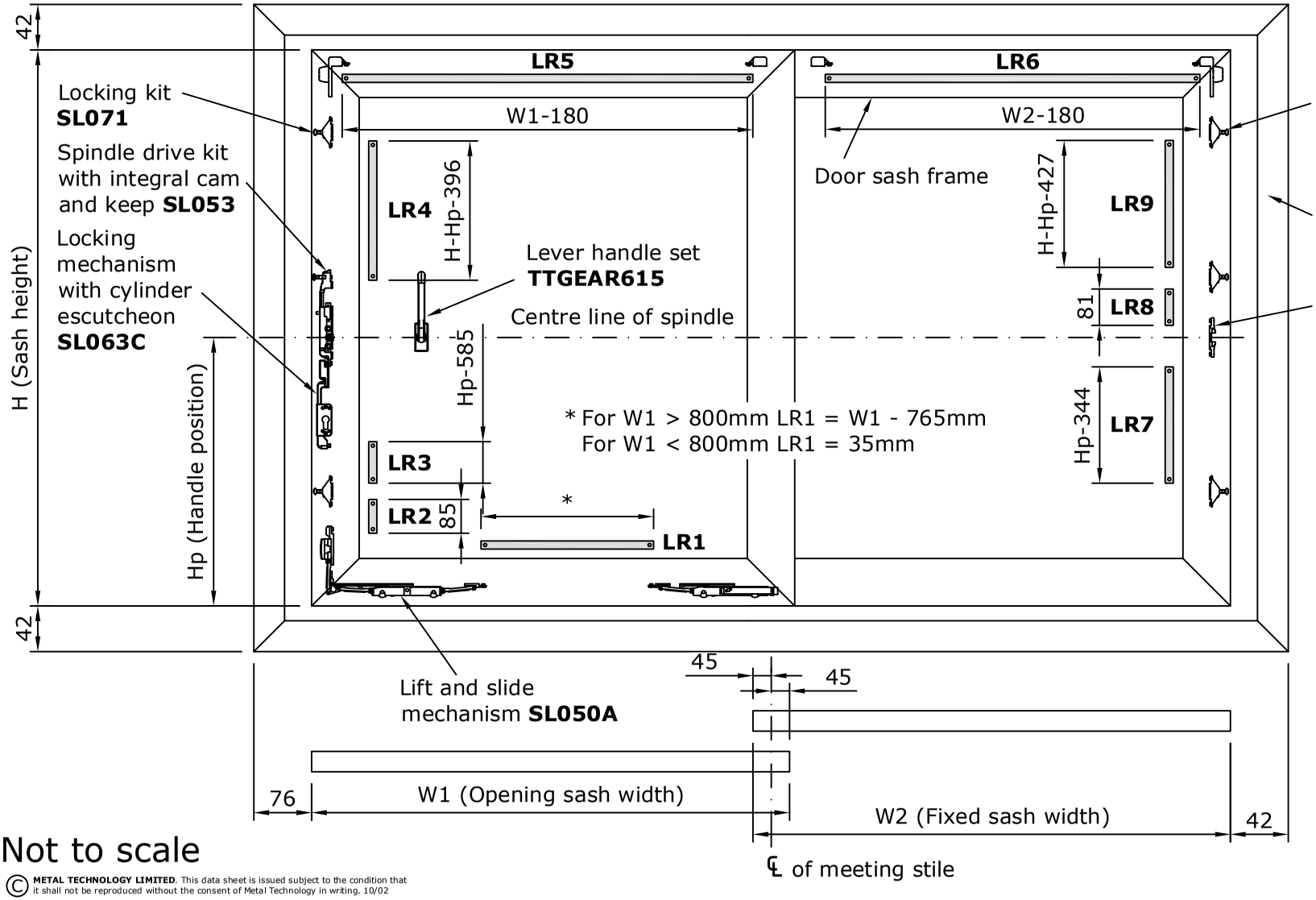
Not to scale

Lift and Slide / Fixed (2 Pane)

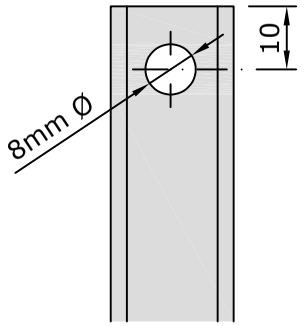
Link Rod Details (Standard Locking, Internal Pane Sliding, Internal and External Lever Handles)

If link rod SL023 is purchased in rolls the following cutting dimensions should be used. Tooling is available for automated cutting and prepping of link rods (JIG25003, JIG25004, JIG25005, JIG25006). Alternatively Metal Technology can supply made to measure kits for individual door sizes. Refer to Vent Size Limitation Chart.

For doors with overall outer frame height of greater than 1900mm, link rod dimensions are based on handle height of 1 metre from bottom of outer frame. For overall outer frame height of less than 1900mm link rod dimensions are based on handle fitted centrally.



SL023 Link rod end prep.
Prep using jig JIG25003



Not to scale

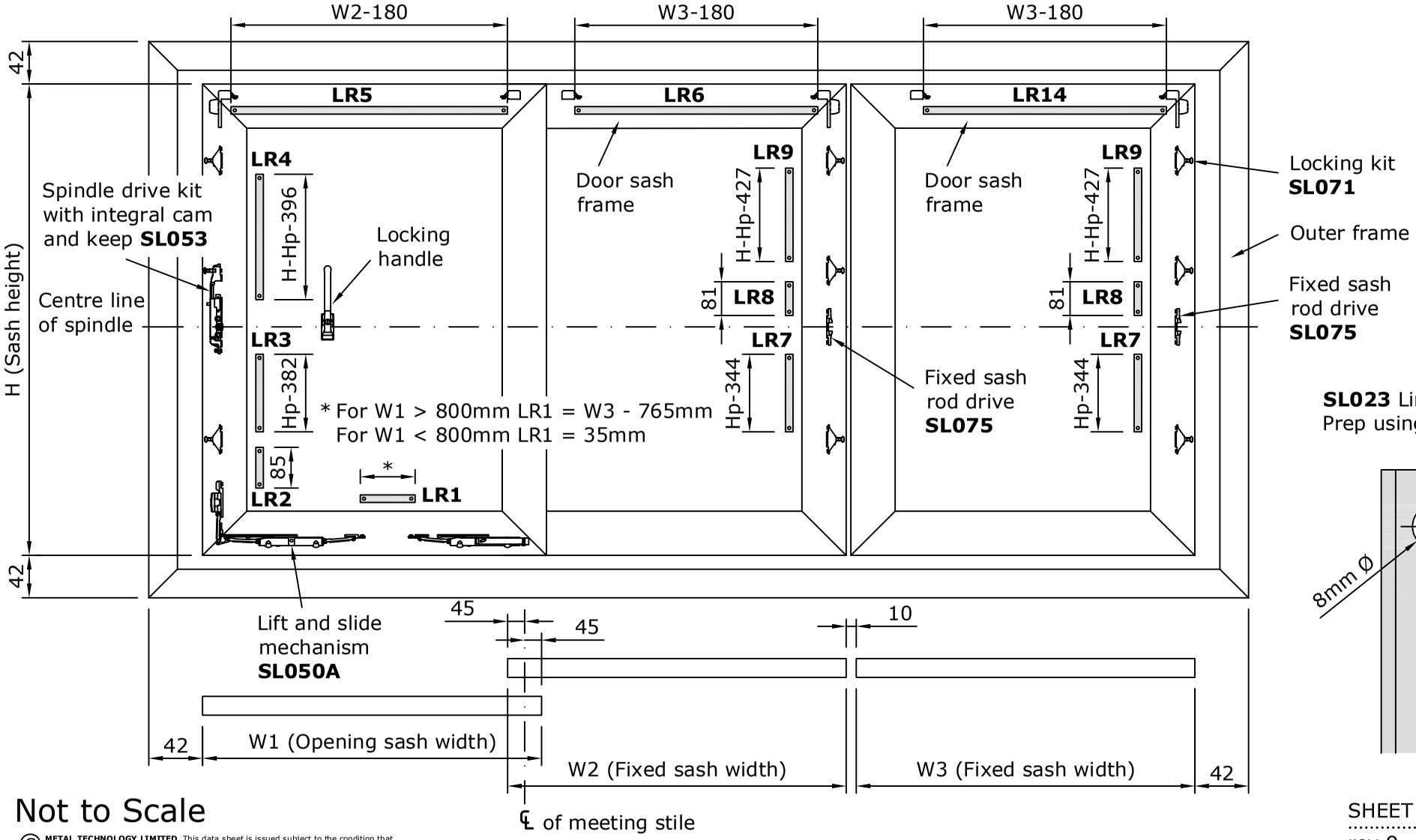
Lift and Slide / Fixed / Fixed (3 Pane)

Link Rod Details (Standard Locking, Internal Pane Sliding, Internal Lever Handle)

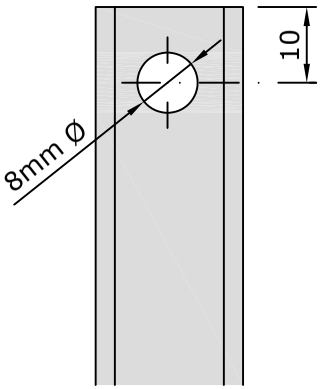
System 25 Hi/Hi+
LIFT AND SLIDE DOOR
2T

If link rod SL023 is purchased in rolls the following cutting dimensions should be used. Tooling is available for automated cutting and prepping of link rods (JIG25003, JIG25004, JIG25005, JIG25006). Alternatively Metal Technology can supply made to measure kits for individual door sizes. Refer to Vent Size Limitation Chart.

For doors with overall outer frame height of greater than 1900mm, link rod dimensions are based on handle height of 1 metre from bottom of outer frame. For overall outer frame height of less than 1900mm link rod dimensions are based on handle fitted centrally.



SL023 Link rod end prep.
Prep using jig JIG25003



Not to Scale

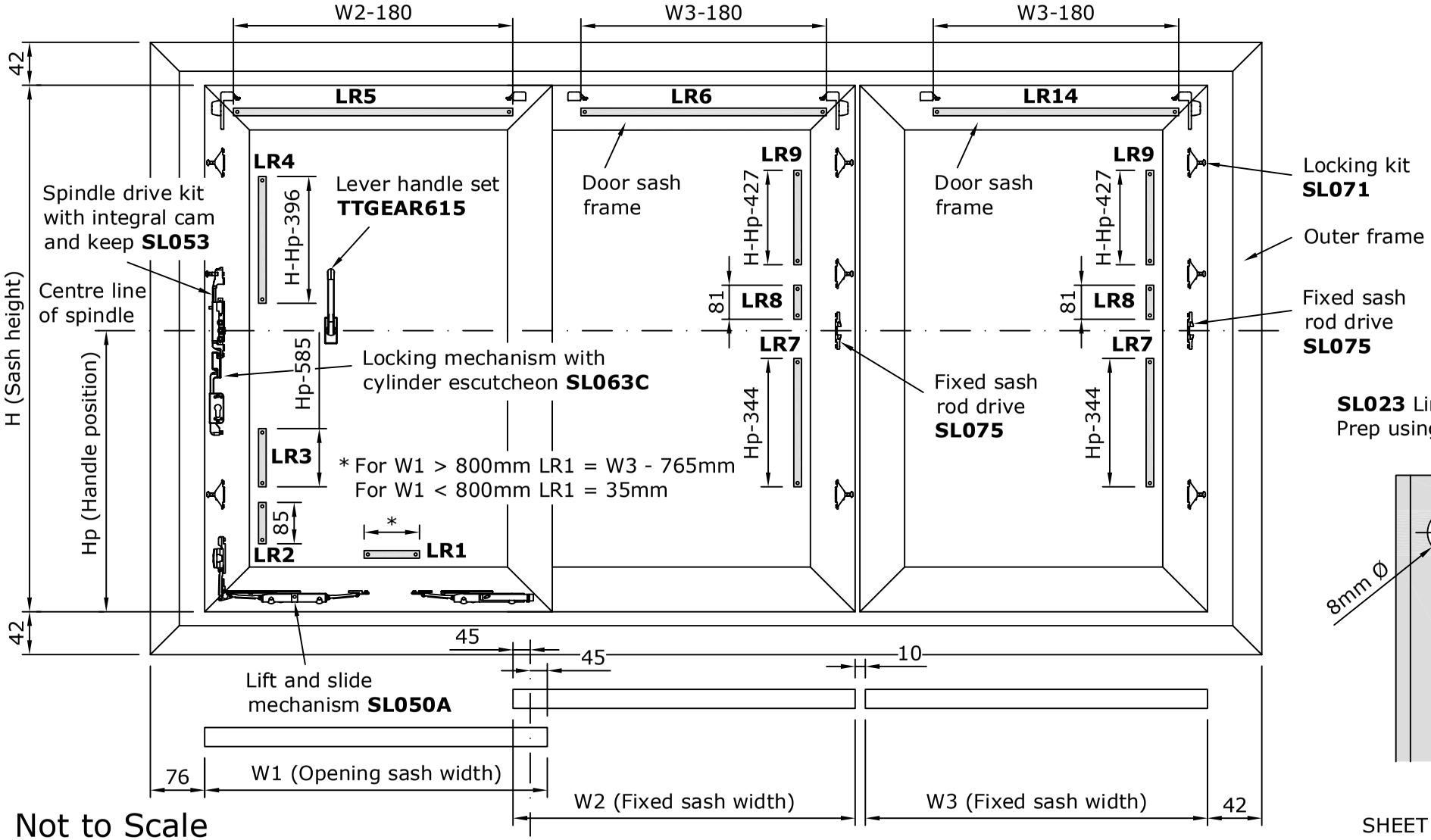
Lift and Slide / Fixed / Fixed (3 Pane)

Link Rod Details (Standard Locking, Internal Pane Sliding, Internal and External Lever Handles)

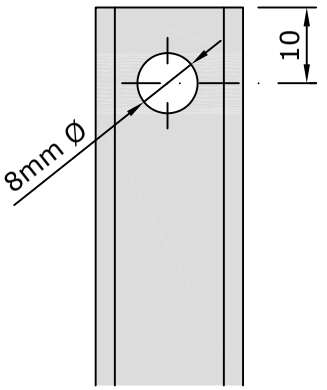
System 25 Hi/Hi+
LIFT AND SLIDE DOOR

If link rod SL023 is purchased in rolls the following cutting dimensions should be used. Tooling is available for automated cutting and prepping of link rods (JIG25003, JIG25004, JIG25005, JIG25006). Alternatively Metal Technology can supply made to measure kits for individual door sizes. Refer to Vent Size Limitation Chart.

For doors with overall outer frame height of greater than 1900mm, link rod dimensions are based on handle height of 1 metre from bottom of outer frame. For overall outer frame height of less than 1900mm link rod dimensions are based on handle fitted centrally.



SL023 Link rod end prep.
Prep using jig JIG25003



Not to Scale

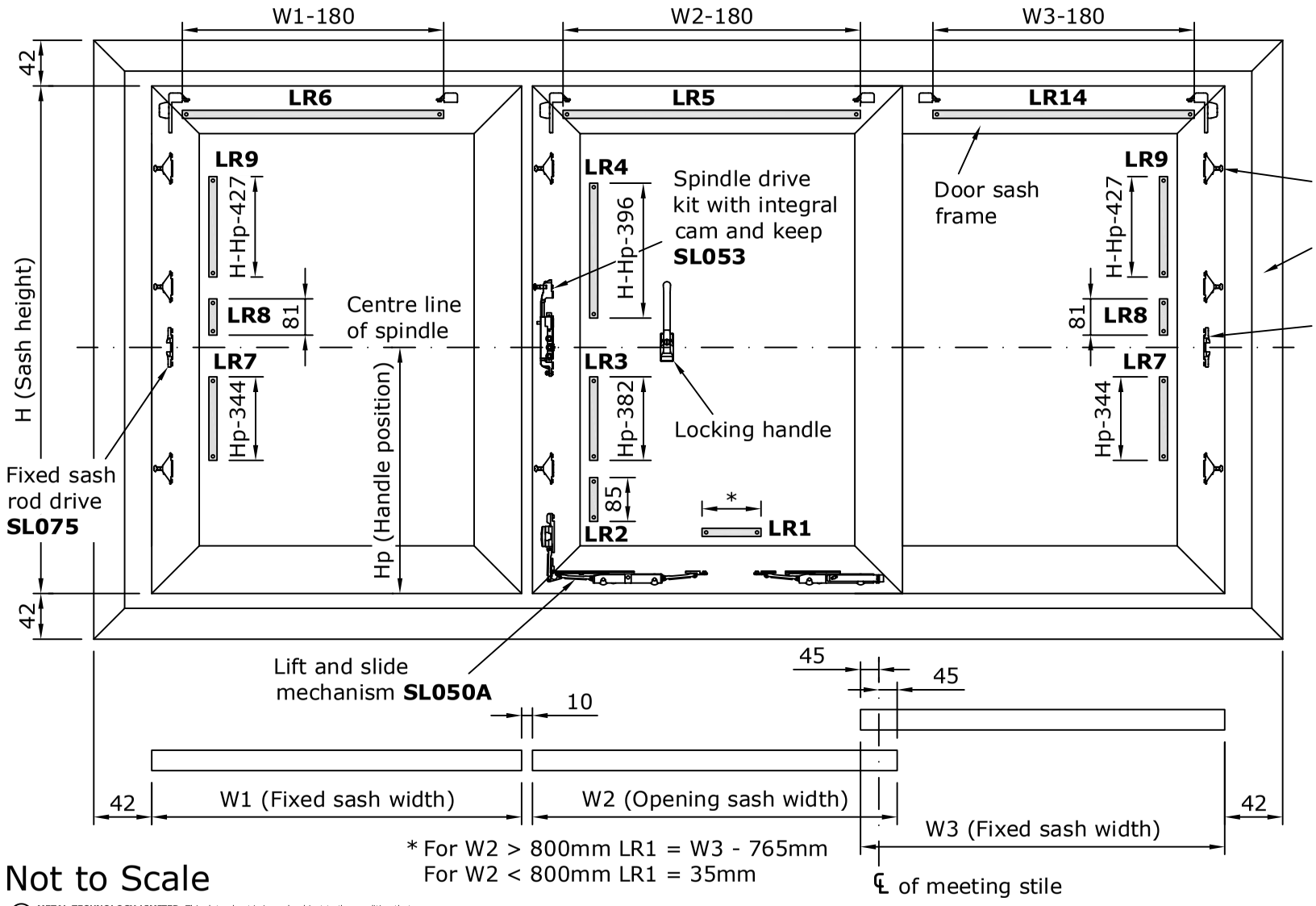
Fixed / Lift and Slide / Fixed (3 Pane)

Link Rod Details (Standard Locking, Internal Pane Sliding, Internal Lever Handle)

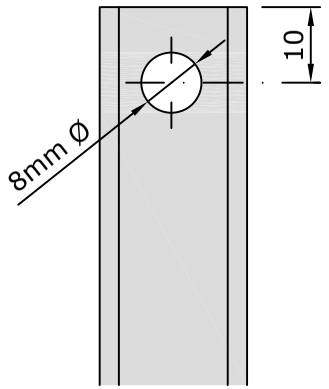
System 25 Hi/Hi+
LIFT AND SLIDE DOOR
2T

If link rod SL023 is purchased in rolls the following cutting dimensions should be used. Tooling is available for automated cutting and prepping of link rods (JIG25003, JIG25004, JIG25005, JIG25006). Alternatively Metal Technology can supply made to measure kits for individual door sizes. Refer to Vent Size Limitation Chart.

For doors with overall outer frame height of greater than 1900mm, link rod dimensions are based on handle height of 1 metre from bottom of outer frame. For overall outer frame height of less than 1900mm link rod dimensions are based on handle fitted centrally.



SL023 Link rod end prep.
Prep using jig JIG25003



Not to Scale

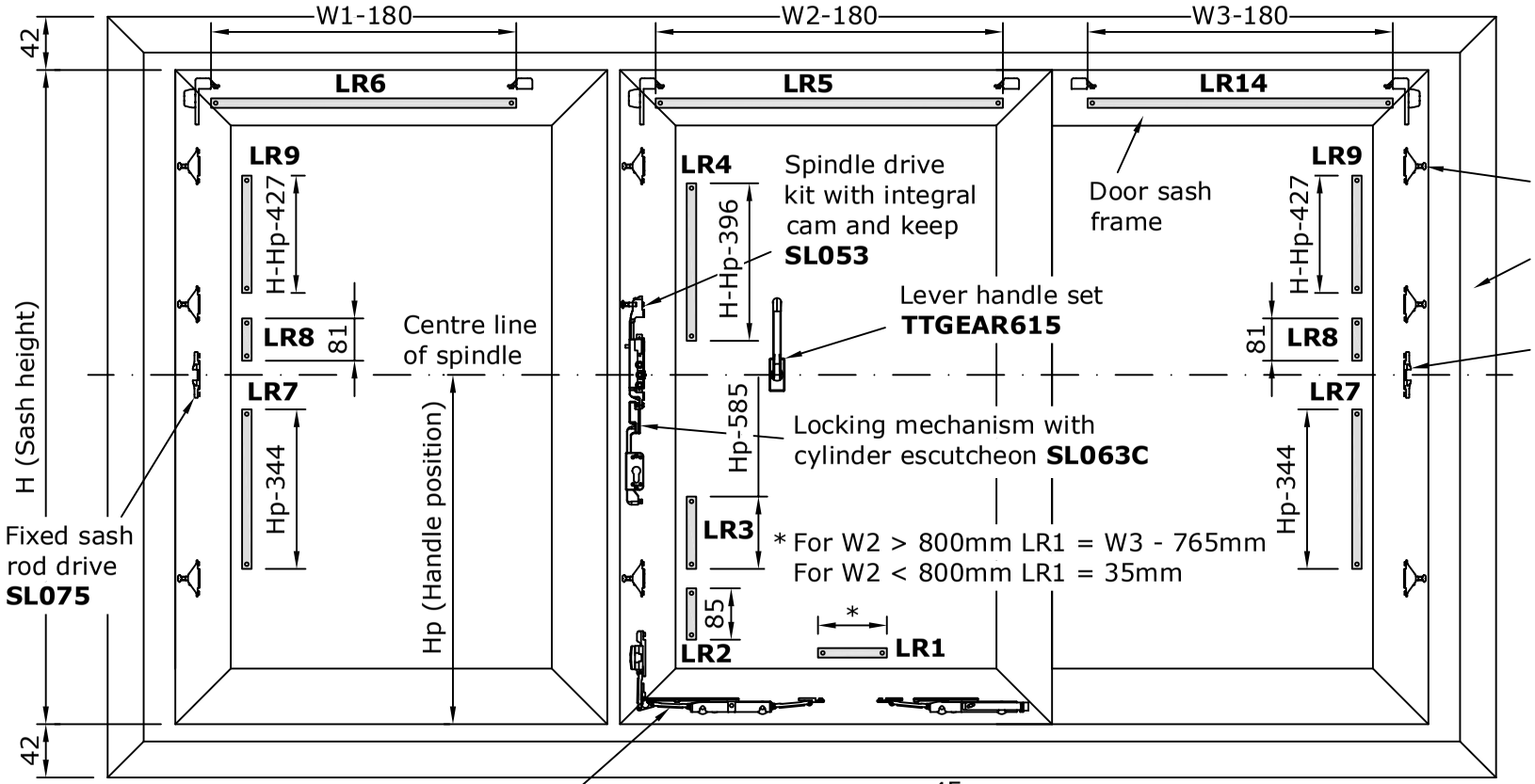
Fixed / Lift and Slide / Fixed (3 Pane)

Link Rod Details (Standard Locking, Internal Pane Sliding, Internal and External Lever Handles)

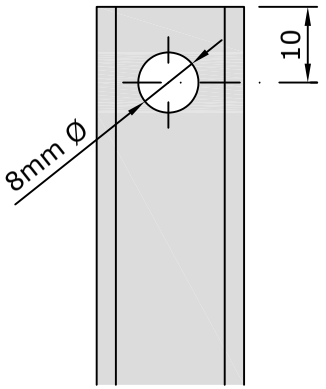
System 25 Hi/Hi+
LIFT AND SLIDE DOOR

If link rod SL023 is purchased in rolls the following cutting dimensions should be used. Tooling is available for automated cutting and prepping of link rods (JIG25003, JIG25004, JIG25005, JIG25006). Alternatively Metal Technology can supply made to measure kits for individual door sizes. Refer to Vent Size Limitation Chart.

For doors with overall outer frame height of greater than 1900mm, link rod dimensions are based on handle height of 1 metre from bottom of outer frame. For overall outer frame height of less than 1900mm link rod dimensions are based on handle fitted centrally.



SL023 Link rod end prep.
Prep using jig JIG25003



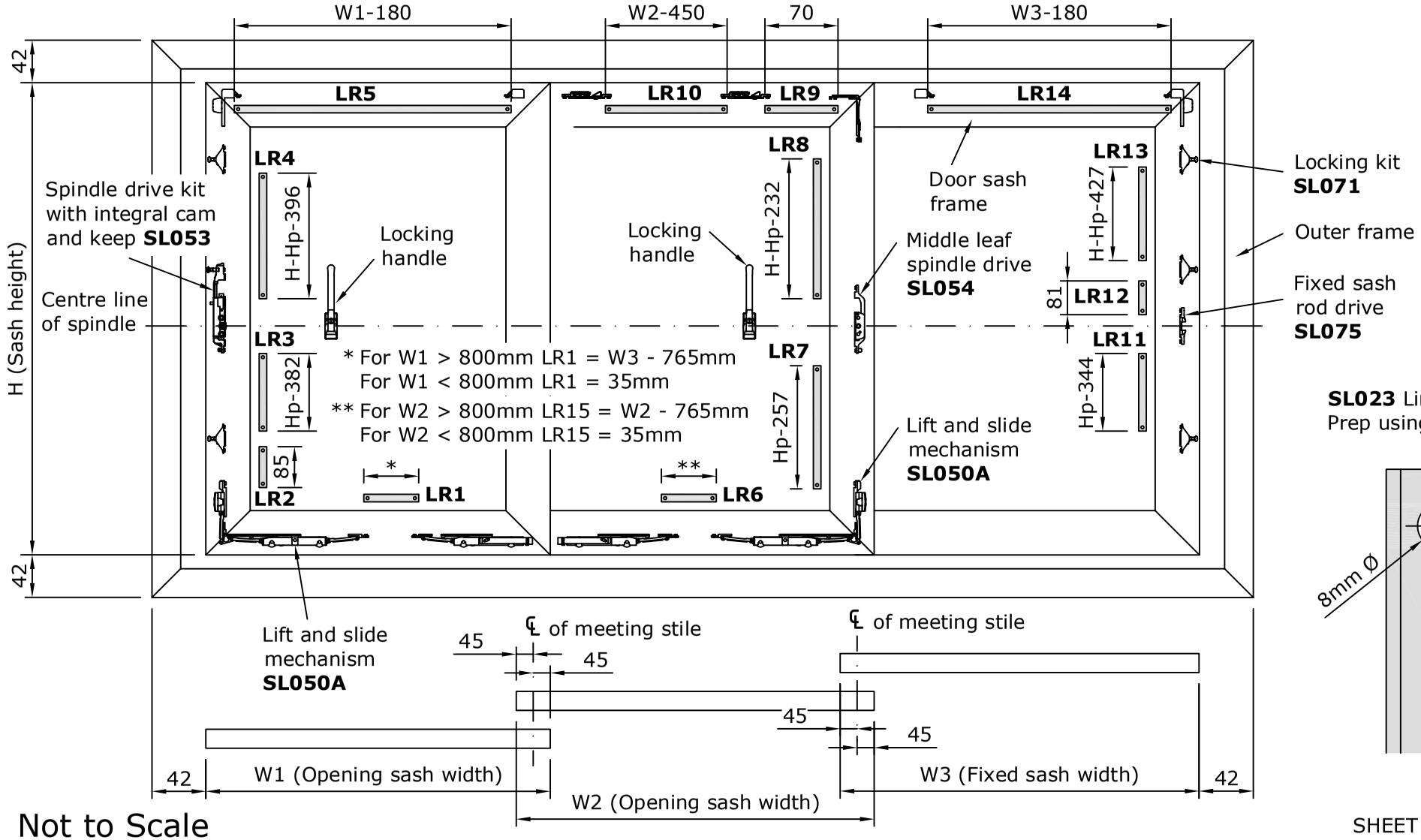
Not to Scale

Lift and Slide / Lift and Slide / Fixed (Triple Track 3 Pane) Link Rod Details (Standard Locking, Internal Panes Sliding, Internal Lever Handles)

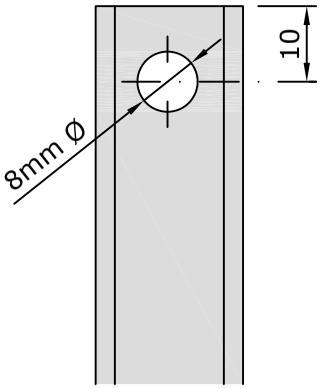
System 25 Hi/Hi+
LIFT AND SLIDE DOOR

If link rod SL023 is purchased in rolls the following cutting dimensions should be used. Tooling is available for automated cutting and prepping of link rods (JIG25003, JIG25004, JIG25005, JIG25006). Alternatively Metal Technology can supply made to measure kits for individual door sizes. Refer to Vent Size Limitation Chart.

For doors with overall outer frame height of greater than 1900mm, link rod dimensions are based on handle height of 1 metre from bottom of outer frame. For overall outer frame height of less than 1900mm link rod dimensions are based on handle fitted centrally.



SL023 Link rod end prep.
Prep using jig JIG25003



Not to Scale

Lift and Slide / Lift and Slide / Fixed (Triple Track 3 Pane)

Link Rod Details (Standard Locking, Internal Panes Sliding, Internal and External Lever Handles)

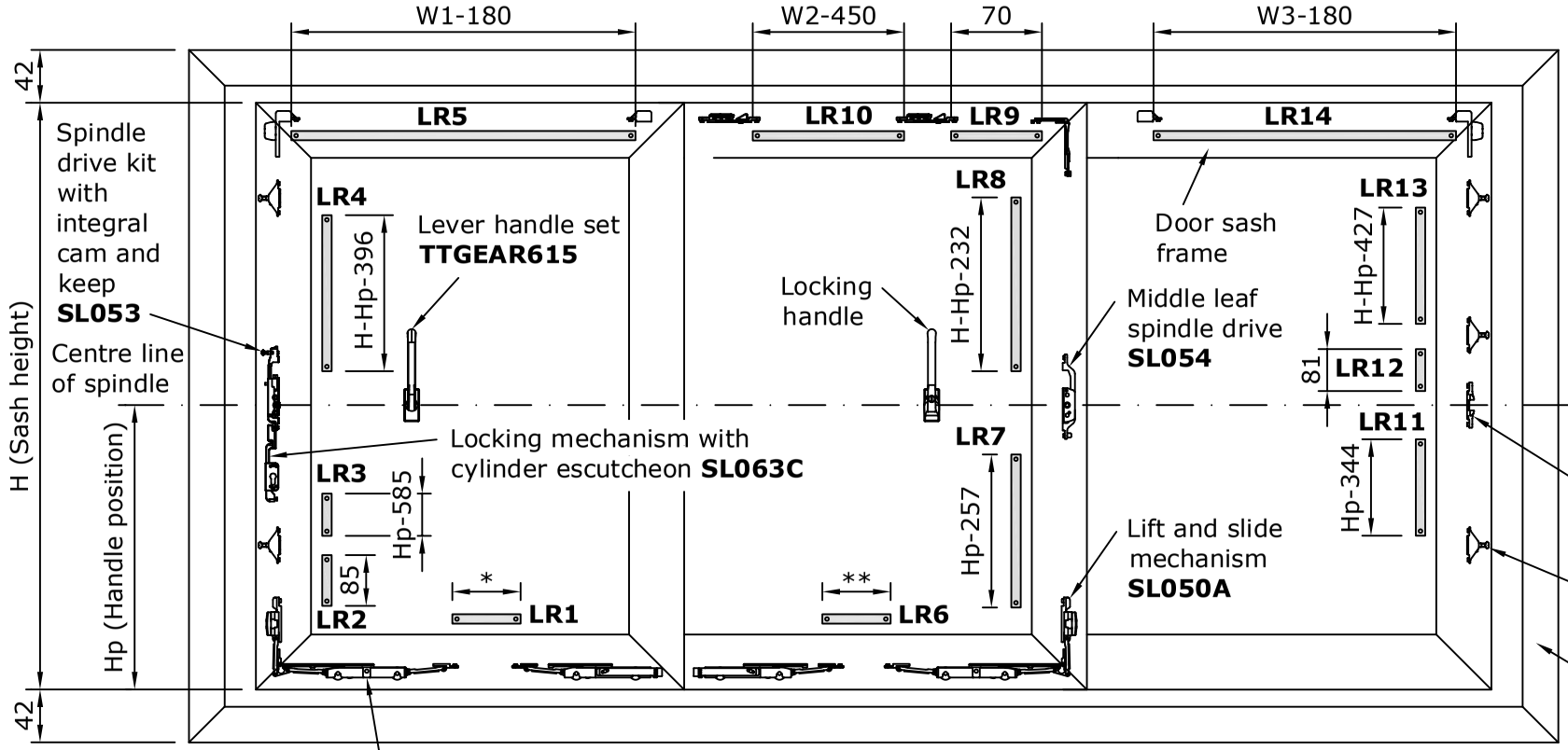
System 25 Hi/Hi+

LIFT AND SLIDE DOOR

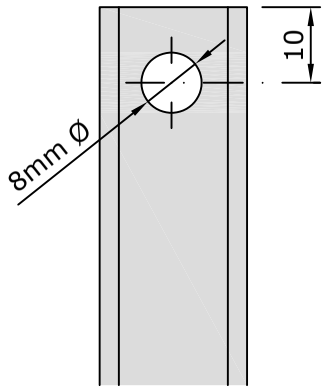
If link rod SL023 is purchased in rolls the following cutting dimensions should be used.

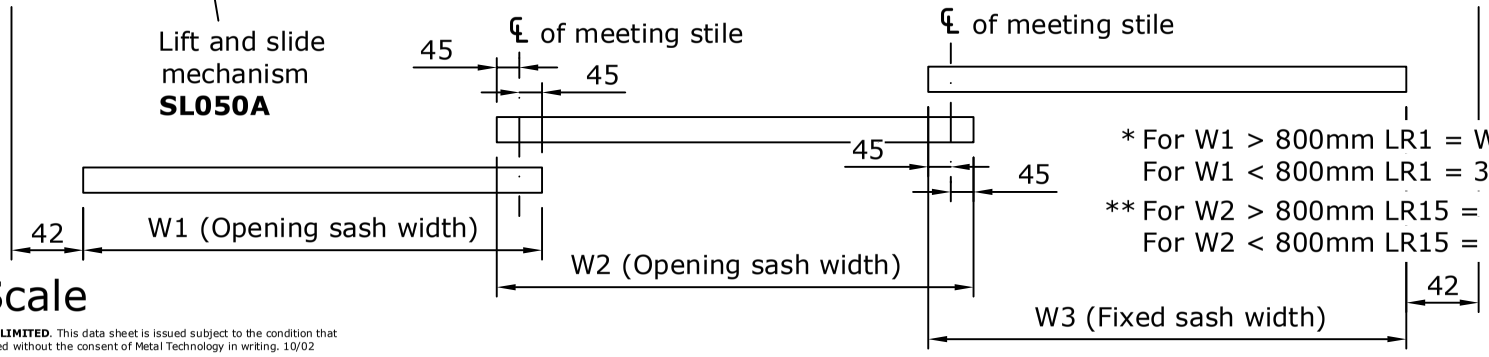
Tooling is available for automated cutting and prepping of link rods (JIG25003, JIG25004, JIG25005, JIG25006). Alternatively Metal Technology can supply made to measure kits for individual door sizes. Refer to Vent Size Limitation Chart.

For doors with overall outer frame height of greater than 1900mm, link rod dimensions are based on handle height of 1 metre from bottom of outer frame.
For overall outer frame height of less than 1900mm link rod dimensions are based on handle fitted centrally.



SL023 Link rod end prep.
Prep using jig JIG25003





* For W1 > 800mm LR1 = W3 - 765mm
For W1 < 800mm LR1 = 35mm

** For W2 > 800mm LR15 = W2 - 765mm
For W2 < 800mm LR15 = 35mm

Not to Scale

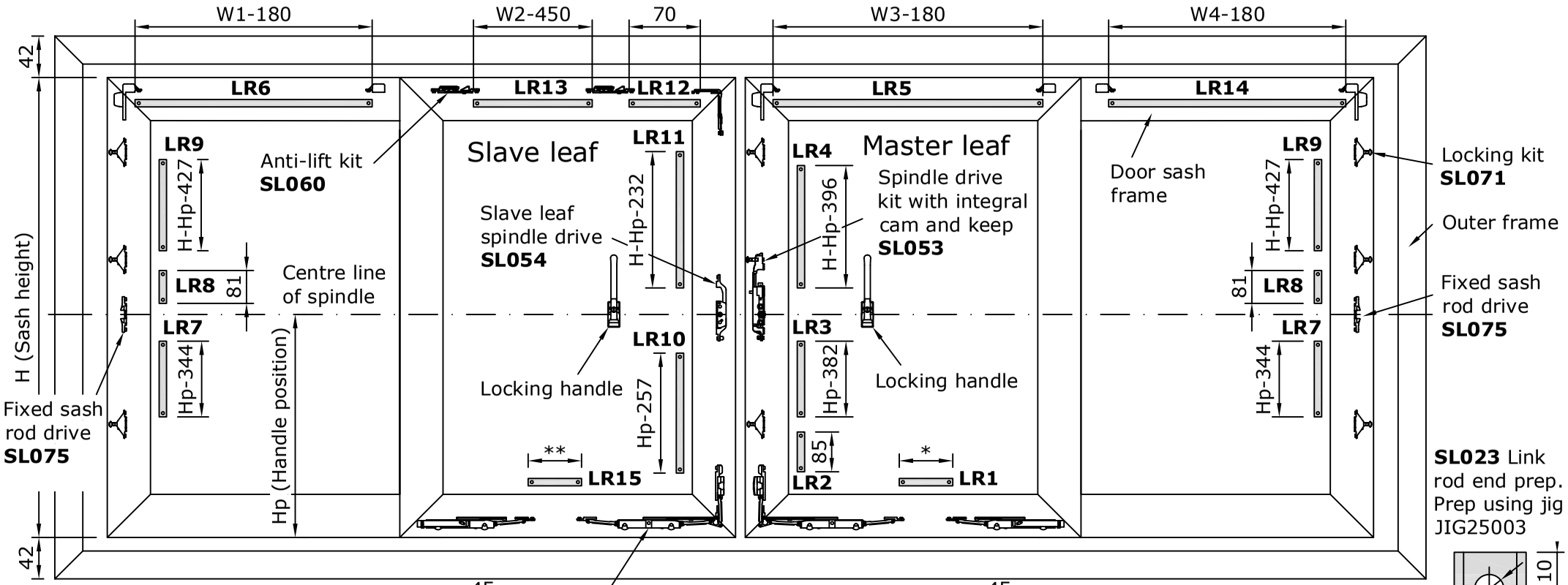
Fixed / Lift and Slide / Lift and Slide / Fixed (4 Pane)

Link Rod Details (Standard Locking, Internal Panes Sliding, Internal Lever Handle)

System 25 Hi/Hi+
LIFT AND SLIDE DOOR
2T

If link rod SL023 is purchased in rolls the following cutting dimensions should be used. Tooling is available for automated cutting and prepping of link rods (JIG25003, JIG25004, JIG25005, JIG25006). Alternatively Metal Technology can supply made to measure kits for individual door sizes. Refer to Vent Size Limitation Chart.

For doors with overall outer frame height of greater than 1900mm, link rod dimensions are based on handle height of 1 metre from bottom of outer frame. For overall outer frame height of less than 1900mm link rod dimensions are based on handle fitted centrally.



* For W3 > 800mm LR1 = W3 - 765mm
For W3 < 800mm LR1 = 35mm

** For W2 > 800mm LR15 = W3 - 765mm
For W2 < 800mm LR15 = 35mm

℄ of meeting stile

℄ of meeting stile

Not to Scale

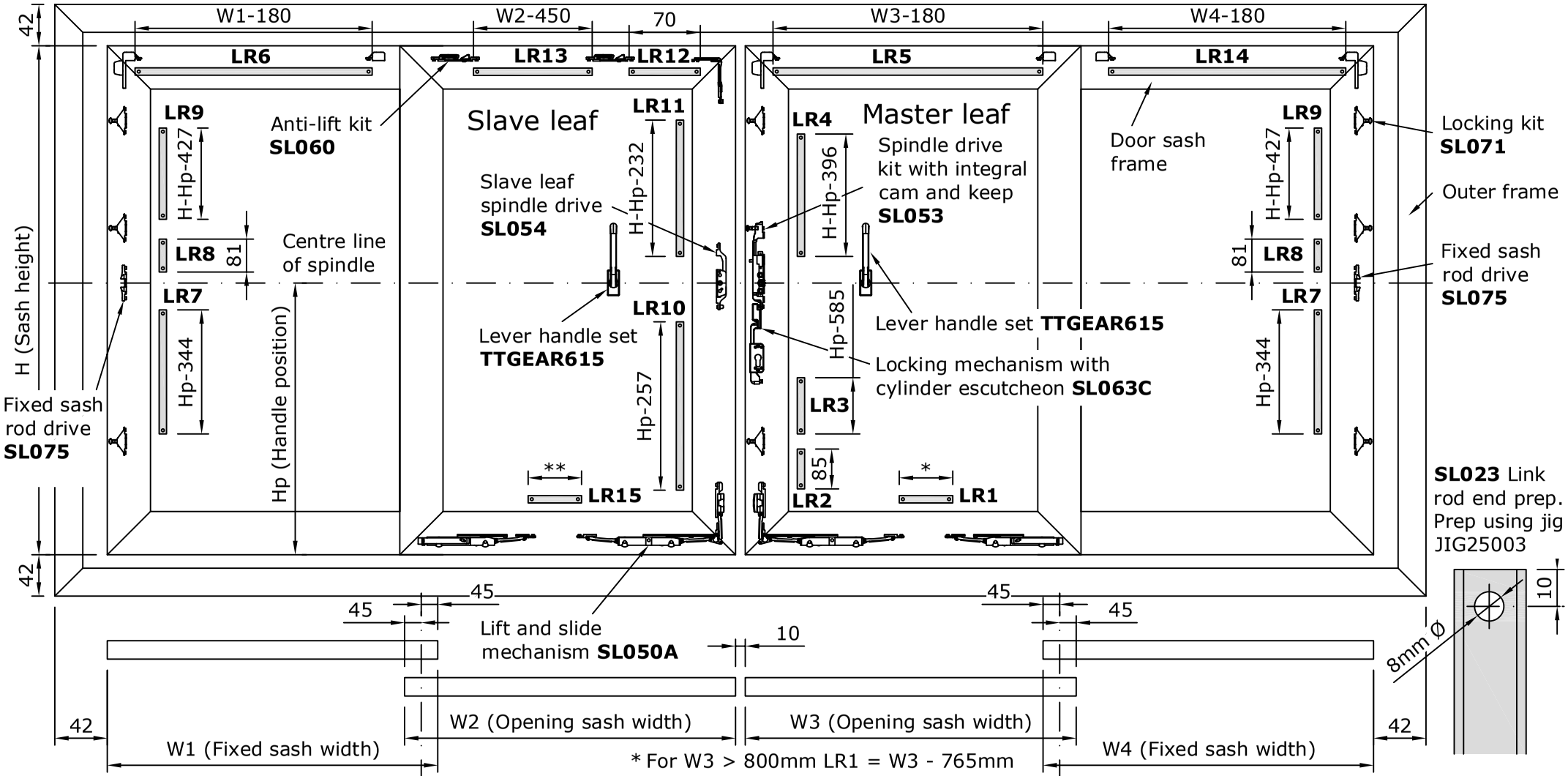
Fixed / Lift and Slide / Lift and Slide / Fixed (4 Pane)

Link Rod Details (Standard Locking, Internal Panes Sliding, Internal and External Lever Handles)

System 25 Hi/Hi+
LIFT AND SLIDE DOOR
2T

If link rod SL023 is purchased in rolls the following cutting dimensions should be used. Tooling is available for automated cutting and prepping of link rods (JIG25003, JIG25004, JIG25005, JIG25006). Alternatively Metal Technology can supply made to measure kits for individual door sizes. Refer to Vent Size Limitation Chart.

For doors with overall outer frame height of greater than 1900mm, link rod dimensions are based on handle height of 1 metre from bottom of outer frame. For overall outer frame height of less than 1900mm link rod dimensions are based on handle fitted centrally.



Not to Scale

* For W3 > 800mm LR1 = W3 - 765mm
For W3 < 800mm LR1 = 35mm

** For W2 > 800mm LR15 = W2 - 765mm
For W2 < 800mm LR15 = 35mm

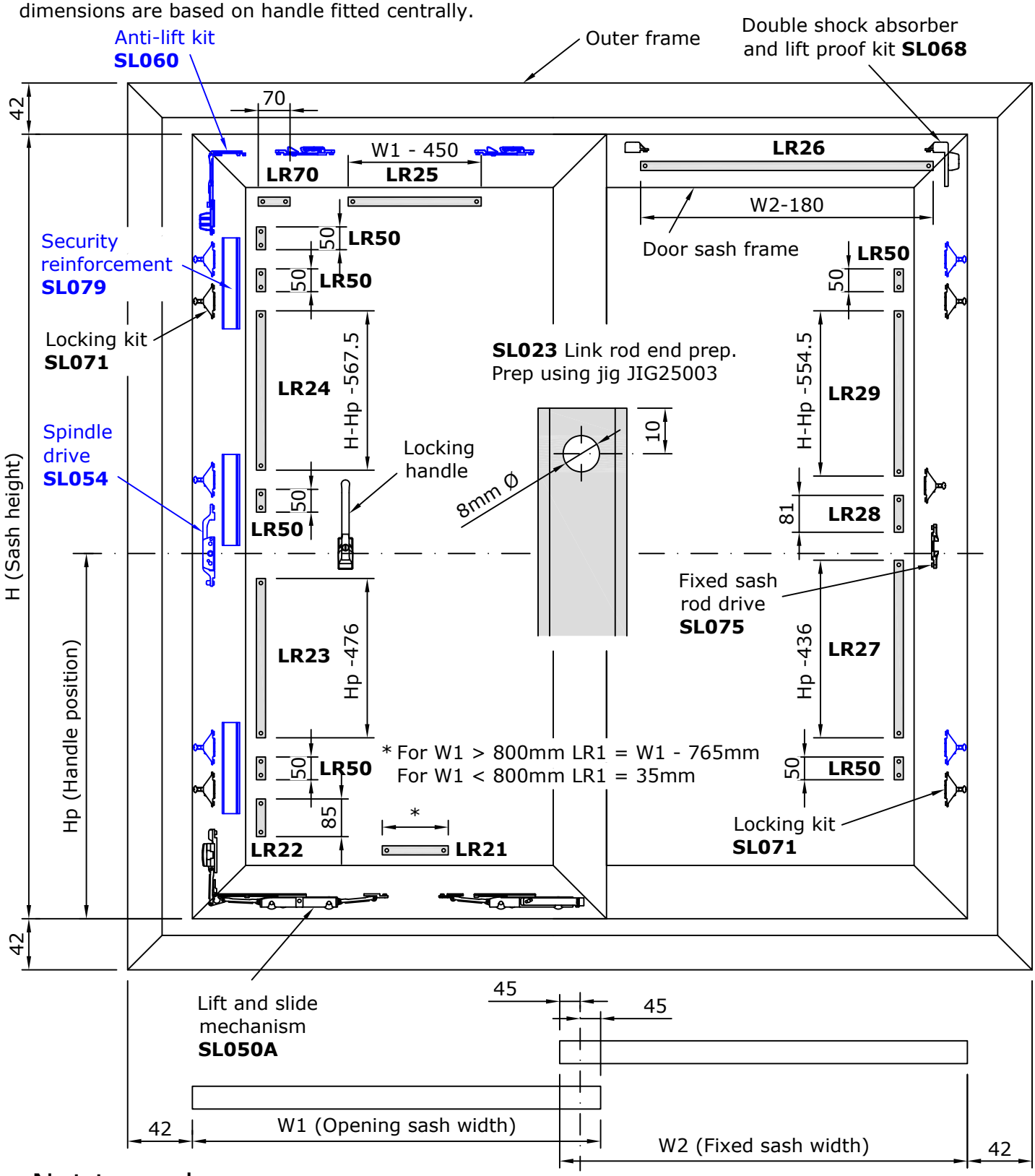
Lift and Slide / Fixed (2 Pane) - Security

System 25 Hi/Hi+
LIFT AND SLIDE DOOR
2T

Link Rod Details (Security Locking, Internal Pane Sliding, Internal Lever Handle)

If link rod SL023 is purchased in rolls the following cutting dimensions should be used. Tooling is available for automated cutting and prepping of link rods (JIG25003, JIG25004, JIG25005, JIG25006). Alternatively Metal Technology can supply made to measure kits for individual door sizes. Refer to Vent Size Limitation Chart.

For doors with overall outer frame height of greater than 1900mm, link rod dimensions are based on handle height of 1 metre from bottom of outer frame. For overall outer frame height of less than 1900mm link rod dimensions are based on handle fitted centrally.



Not to scale

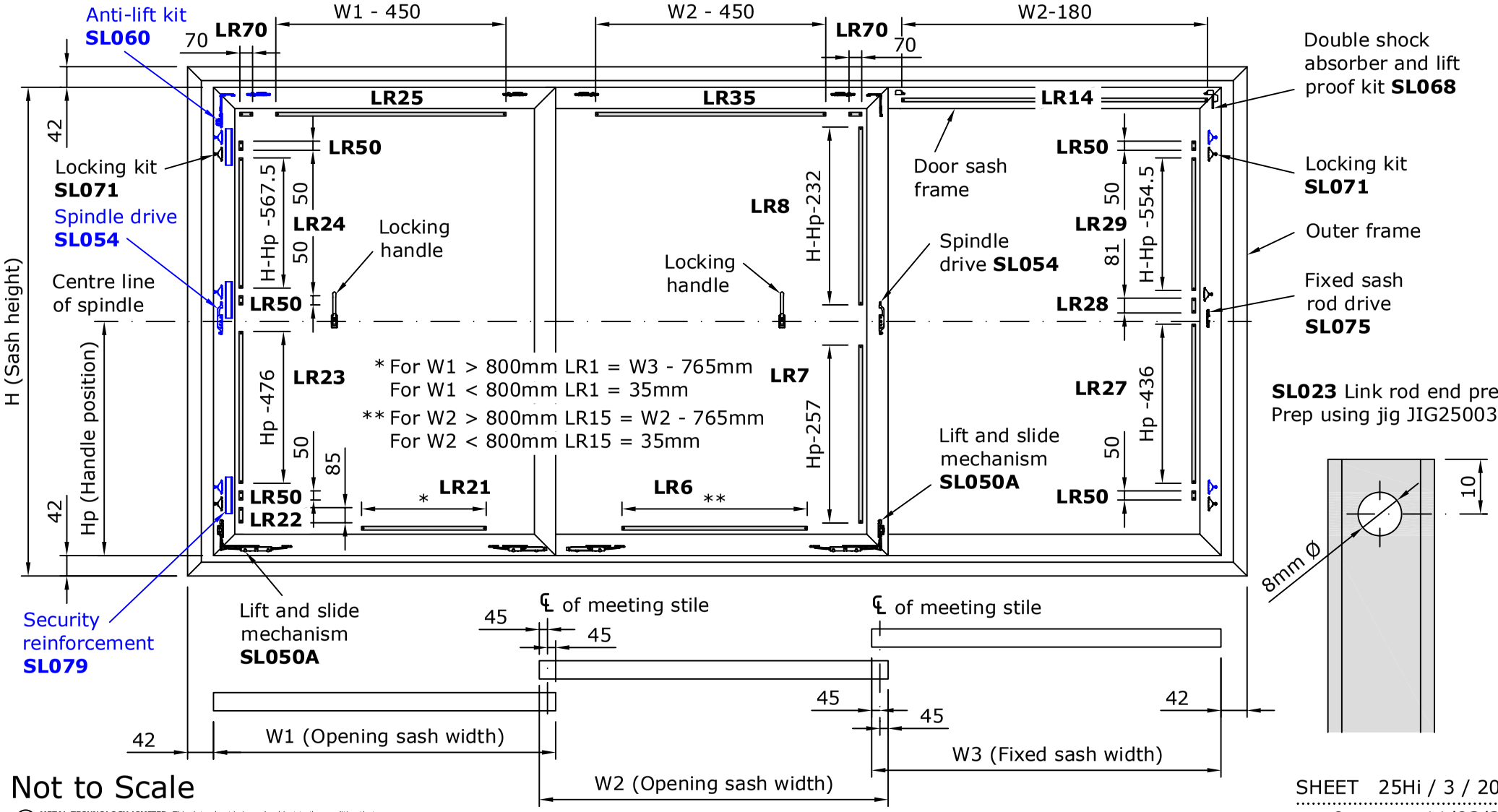
Lift and Slide / Lift and Slide / Fixed (Triple Track 3 Pane) - Security

Link Rod Details (Security Locking, Internal Panes Sliding, Internal Lever Handles)

System 25 Hi/Hi+
LIFT AND SLIDE DOOR

If link rod SL023 is purchased in rolls the following cutting dimensions should be used. Tooling is available for automated cutting and prepping of link rods (JIG25003, JIG25004, JIG25005, JIG25006). Alternatively Metal Technology can supply made to measure kits for individual door sizes. Refer to Vent Size Limitation Chart.

For doors with overall outer frame height of greater than 1900mm, link rod dimensions are based on handle height of 1 metre from bottom of outer frame. For overall outer frame height of less than 1900mm link rod dimensions are based on handle fitted centrally.



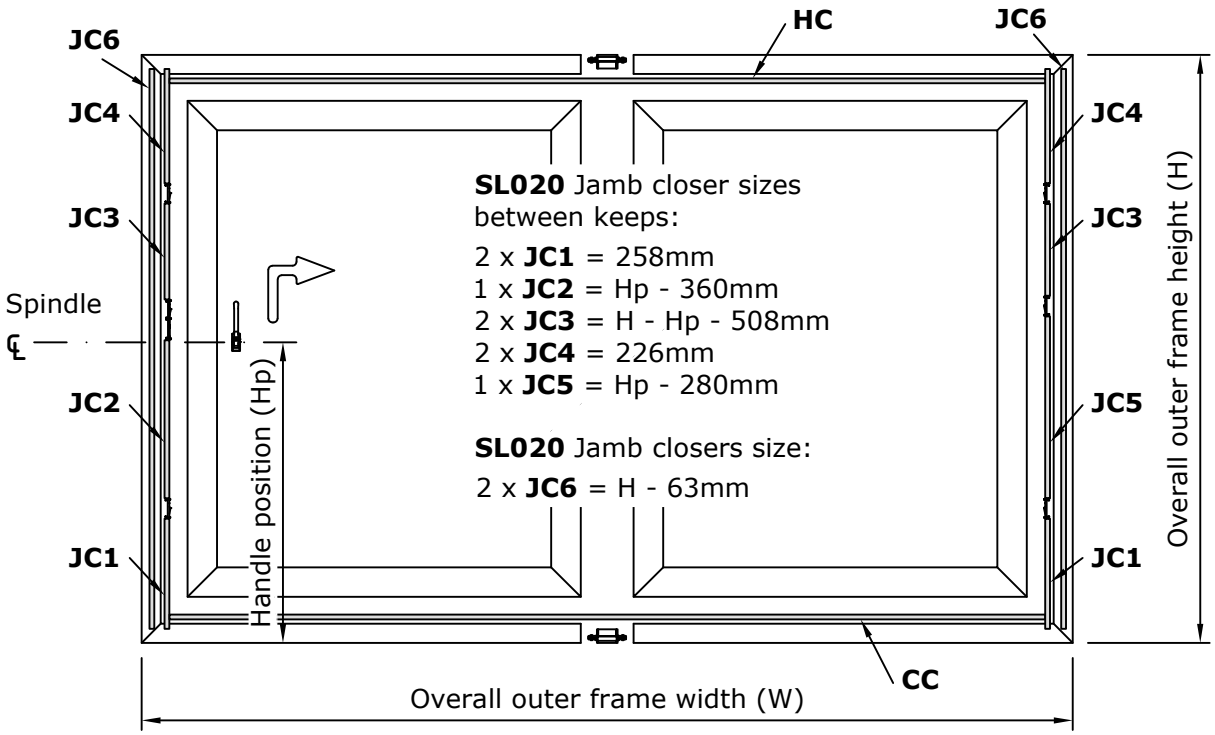
SL023 Link rod end prep.
Prep using jig JIG25003

Not to Scale

Cill, Head and Jamb Closer Sizes

For doors with overall outer frame height of greater than 1900mm, jamb closer dimensions are based on handle height of 1 metre from bottom of outer frame. For overall outer frame height of less than 1900mm jamb closer dimensions are based on handle fitted centrally.

Lift and Slide / Fixed (2 Pane)



SL020 Head closers size:
2 x **HC** = W - 102mm*

SL022 Cill closers size:
2 x **CC** = W - 102mm*

*If jamb extension is being used:

SL020 Head closers size:
1 x **HC** = W - 102mm
1 x **HC** = W - 136mm

SL022 Cill closers size:
1 x **CC** = W - 102mm
1 x **CC** = W - 136mm

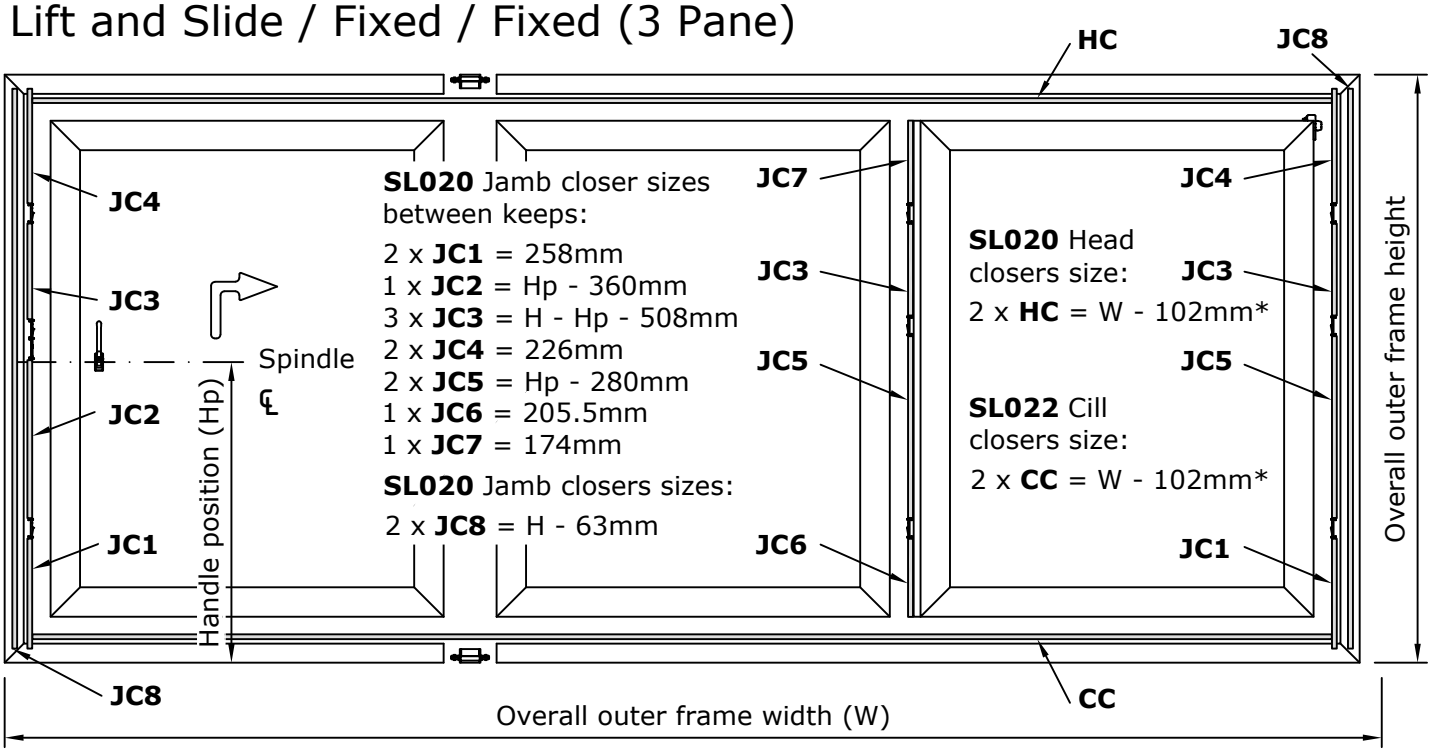
Not to Scale

Cill, Head and Jamb Closer Sizes

System 25 Hi/Hi+
LIFT AND SLIDE DOOR
2T

For doors with overall outer frame height of greater than 1900mm, jamb closer dimensions are based on handle height of 1 metre from bottom of outer frame. For overall outer frame height of less than 1900mm jamb closer dimensions are based on handle fitted centrally.

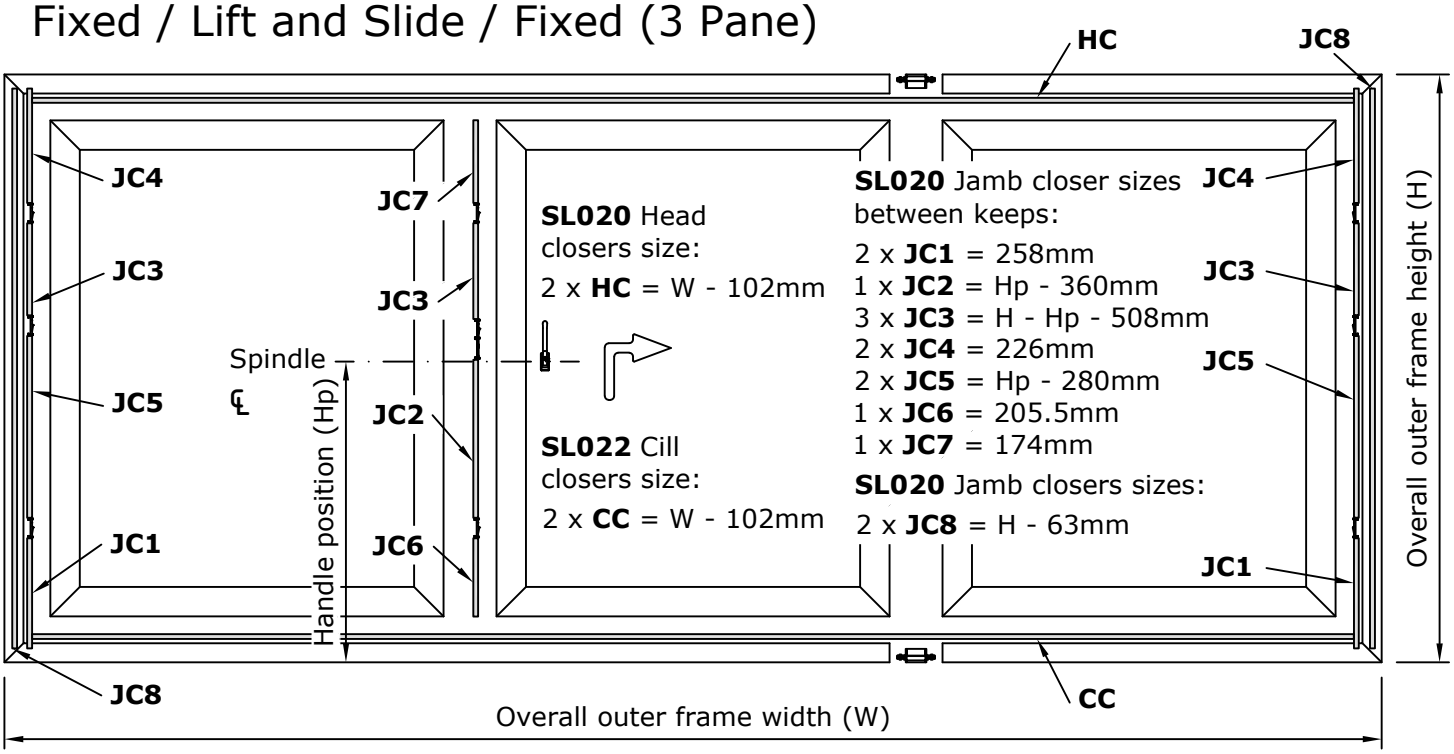
Lift and Slide / Fixed / Fixed (3 Pane)



*If jamb extension is being used:

SL020 Head closers size:	**SL022** Cill closers size:
1 x **HC** = W - 102mm	1 x **CC** = W - 102mm
1 x **HC** = W - 136mm	1 x **CC** = W - 136mm

Fixed / Lift and Slide / Fixed (3 Pane)

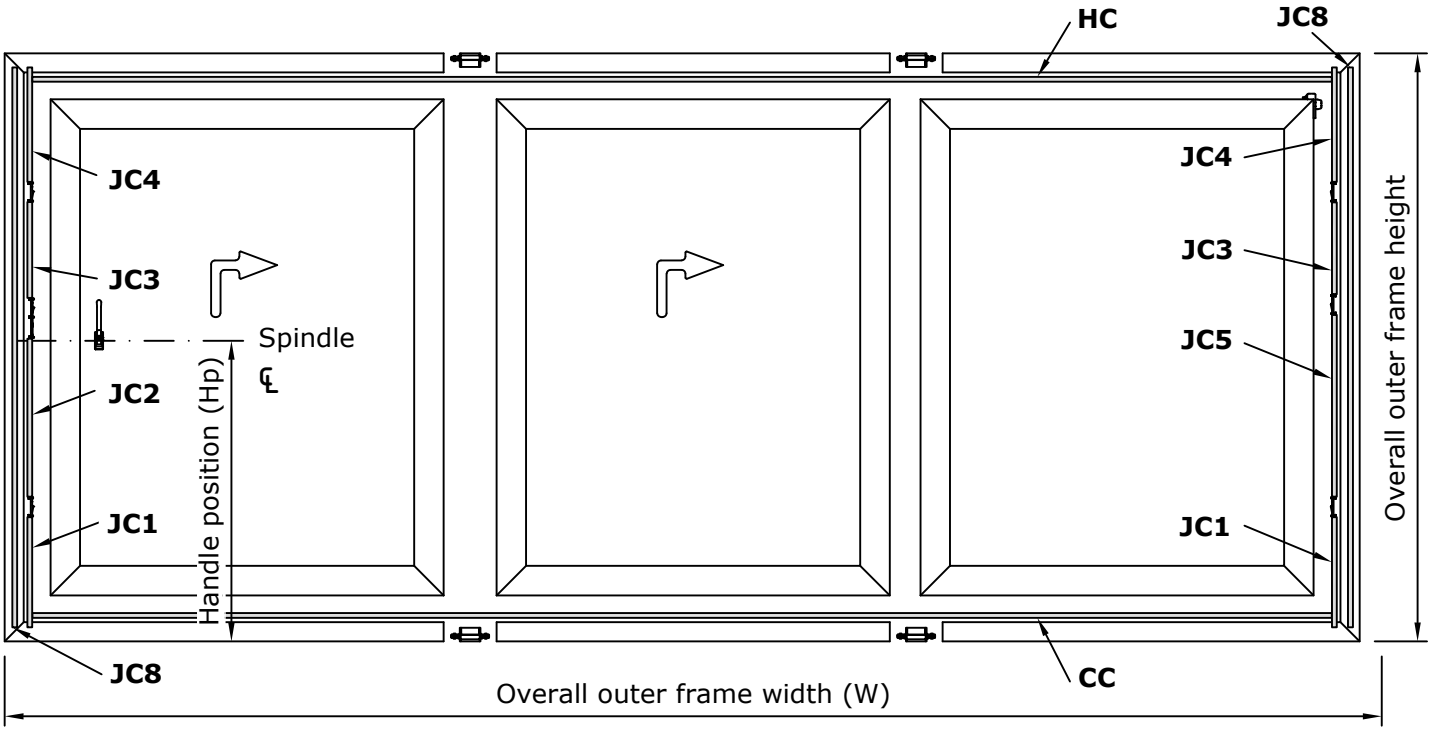


Not to Scale

Cill, Head and Jamb Closer Sizes - Triple Track

For doors with overall outer frame height of greater than 1900mm, jamb closer dimensions are based on handle height of 1 metre from bottom of outer frame. For overall outer frame height of less than 1900mm jamb closer dimensions are based on handle fitted centrally.

Lift and Slide / Lift and Slide / Fixed (Triple track application)



SL020 Jamb closer sizes between keeps:

2 x **JC1** = 258mm
1 x **JC2** = Hp - 360mm
2 x **JC3** = H - Hp - 508mm
2 x **JC4** = 226mm
1 x **JC5** = Hp - 280mm

SL020 Jamb closers sizes:

4 x **JC8** = H - 63mm

SL020 Head closers size:

3 x **HC** = W - 102mm

SL022 Cill closers size:

3 x **CC** = W - 102mm

Not to Scale

Cill, Head and Jamb Closer Sizes

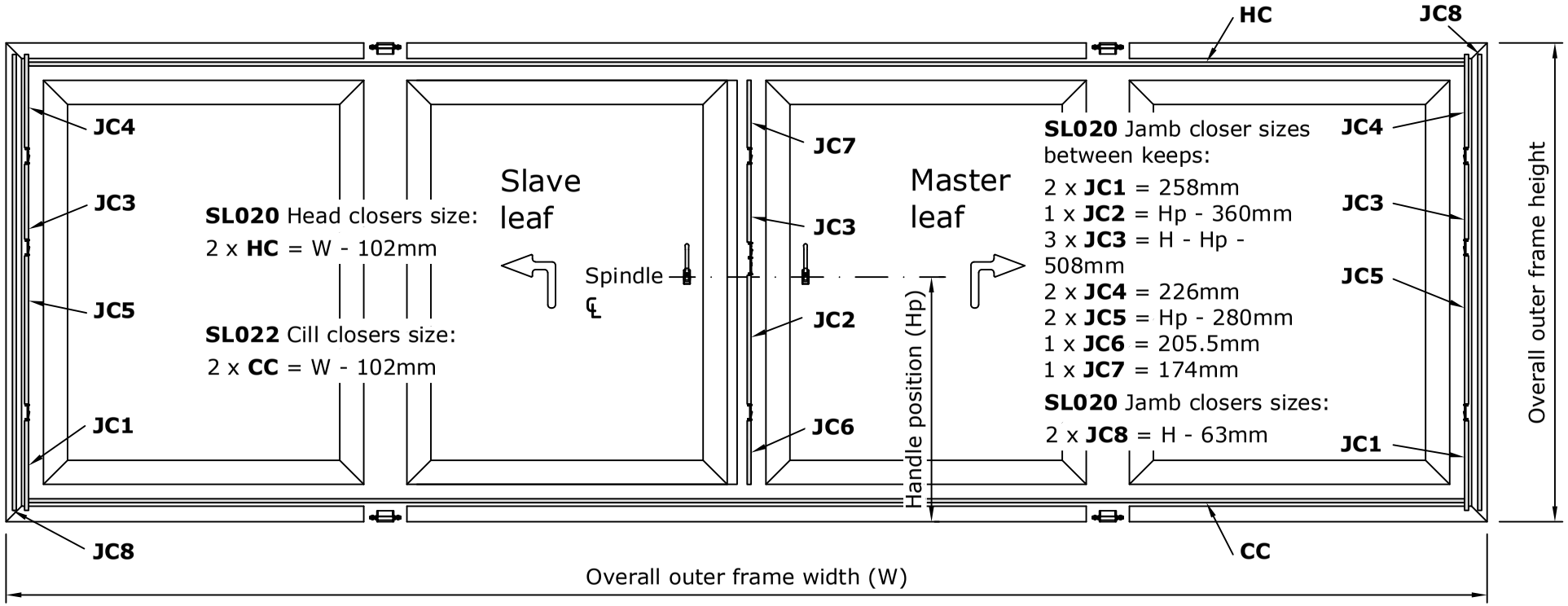
System 25 Hi/Hi+

LIFT AND SLIDE DOOR

2T

For doors with overall outer frame height of greater than 1900mm, jamb closer dimensions are based on handle height of 1 metre from bottom of outer frame. For overall outer frame height of less than 1900mm jamb closer dimensions are based on handle fitted centrally.

Fixed / Lift and Slide / Lift and Slide / Fixed (4 Pane)

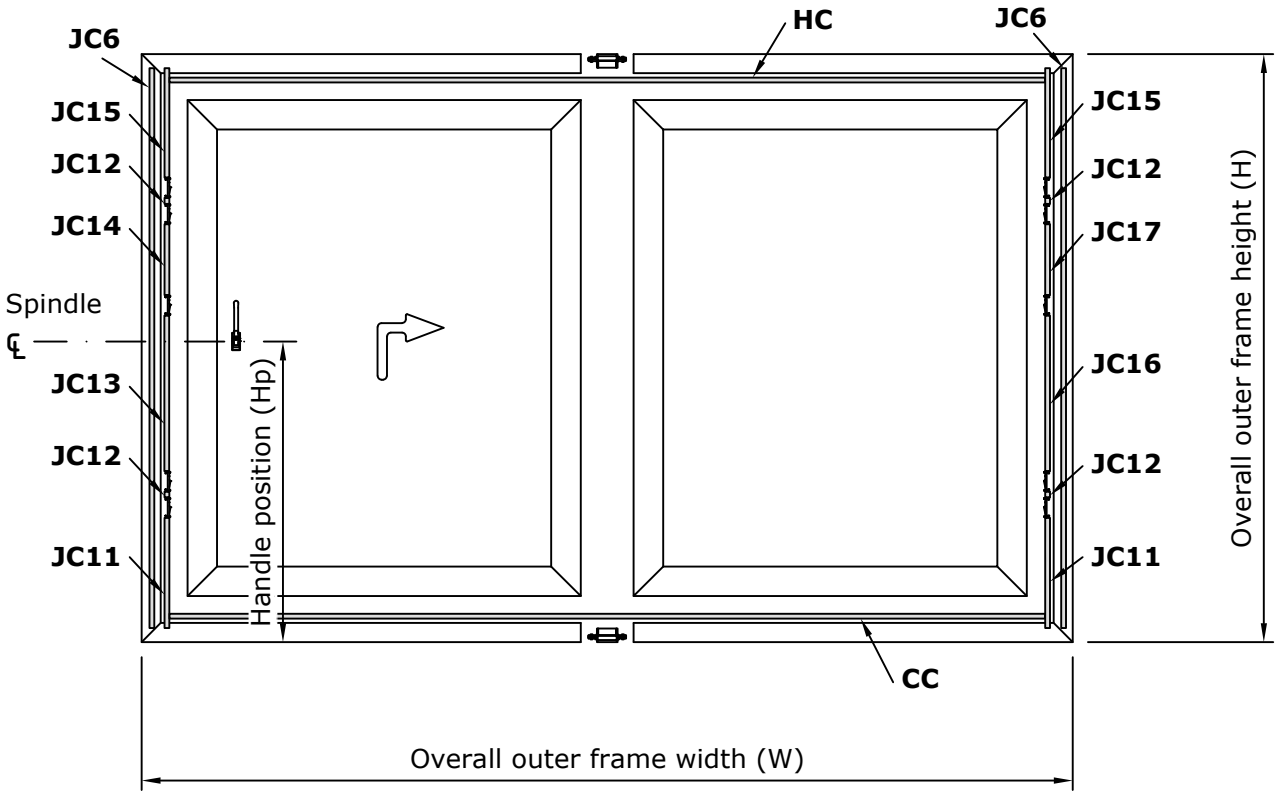


Not to Scale

Cill, Head and Jamb Closer Sizes - Security

For doors with overall outer frame height of greater than 1900mm, jamb closer dimensions are based on handle height of 1 metre from bottom of outer frame. For overall outer frame height of less than 1900mm jamb closer dimensions are based on handle fitted centrally.

Lift and Slide / Fixed (2 Pane)



SL020 Head closers size:
2 x **HC** = W - 102mm

SL022 Cill closers size:
2 x **CC** = W - 102mm

SL020 Jamb closer sizes between keeps:
2 x **JC11** = 258mm
4 x **JC12** = 12mm
1 x **JC13** = Hp - 360mm
1 x **JC14** = H - Hp - 647.5mm
2 x **JC15** = 262mm
1 x **JC16** = Hp - 373mm
1 x **JC17** = H - Hp - 634.5mm

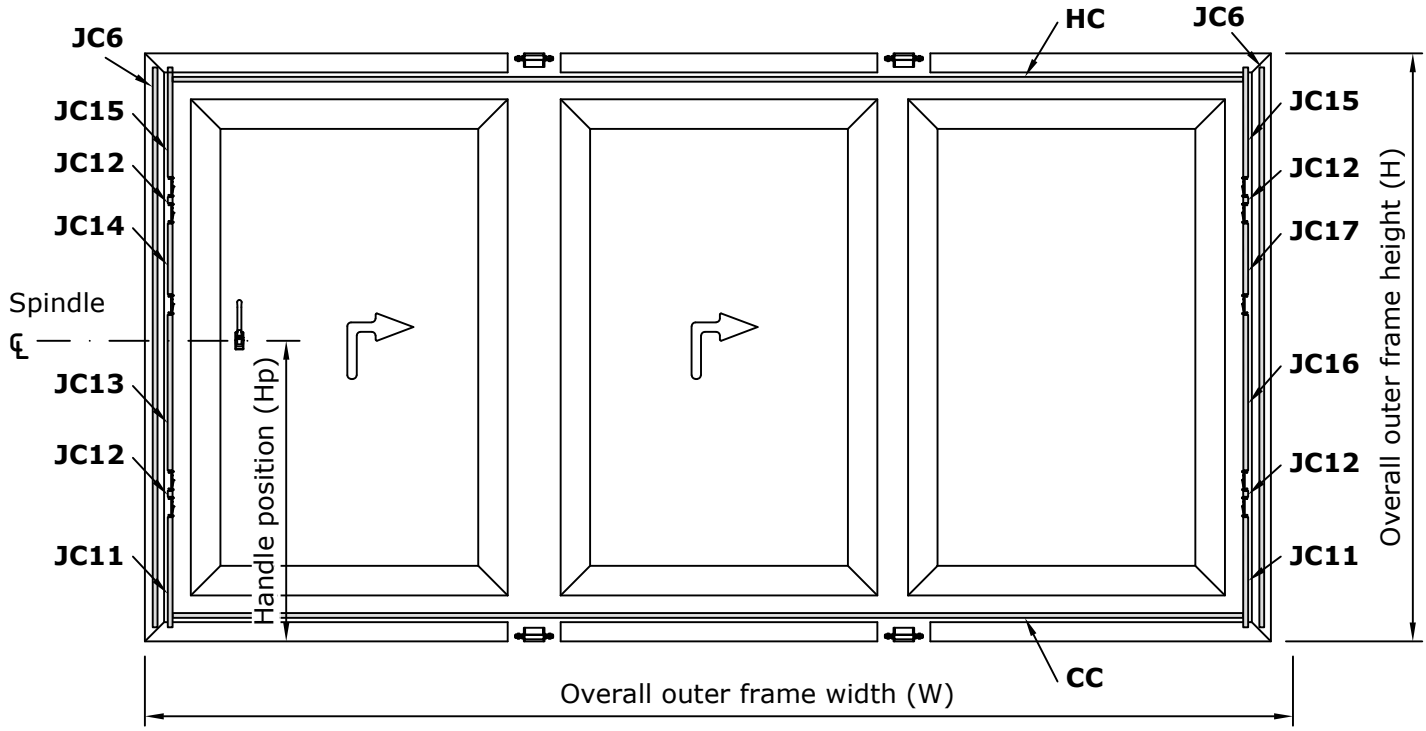
SL020 Jamb closers size:
2 x **JC6** = H - 63mm

Not to Scale

Cill, Head and Jamb Closer Sizes - Security

For doors with overall outer frame height of greater than 1900mm, jamb closer dimensions are based on handle height of 1 metre from bottom of outer frame. For overall outer frame height of less than 1900mm jamb closer dimensions are based on handle fitted centrally.

Lift and Slide / Lift and Slide / Fixed (Triple Track 3 Pane)



SL020 Jamb closer sizes between keeps:

2 x **JC11** = 258mm
4 x **JC12** = 12mm
1 x **JC13** = Hp - 360mm
1 x **JC14** = H - Hp - 647.5mm
2 x **JC15** = 262mm
1 x **JC16** = Hp - 373mm
1 x **JC17** = H - Hp - 634.5mm

SL020 Jamb closers size:

4 x **JC6** = H - 63mm

SL020 Head closers size:

3 x **HC** = W - 102mm

SL022 Cill closers size:

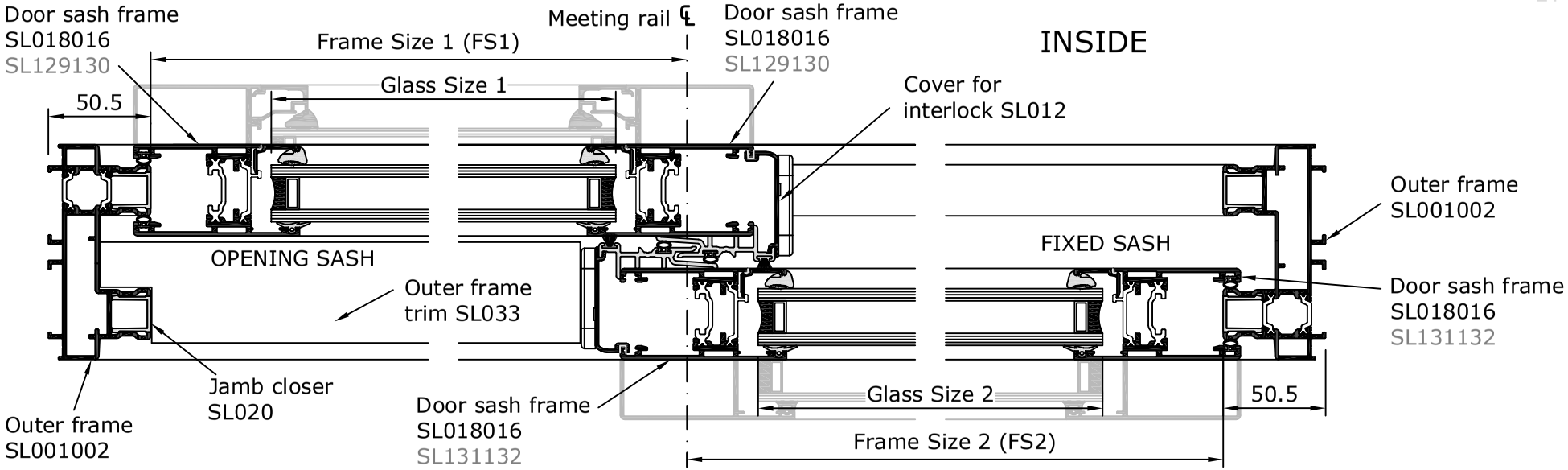
3 x **CC** = W - 102mm

Not to Scale

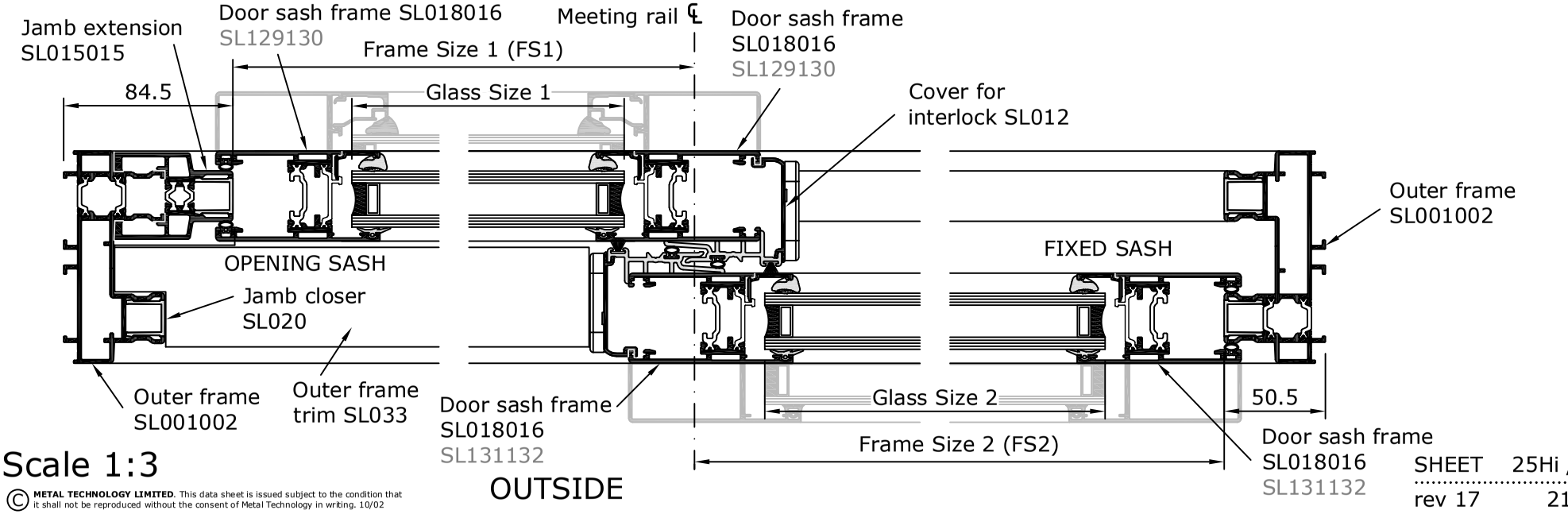
Bar Cutting Sizes

All cutting sizes in this range are calculated from the Frame Sizes (FS) as illustrated below.

Standard 2 Pane (Inside pane sliding with internal handle)



2 Pane with Jamb Extension (Inside pane sliding with internal and external handles)



Scale 1:3

Fabrication and Cutting Sizes (2 Pane) - Sash SL018016

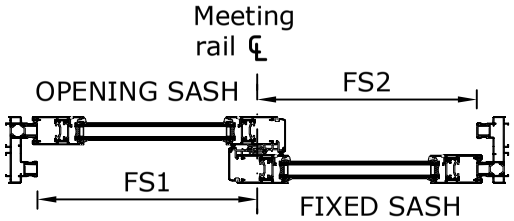
1 Pane Lift and Slide / 1 Pane Fixed

System 25 Hi/Hi+

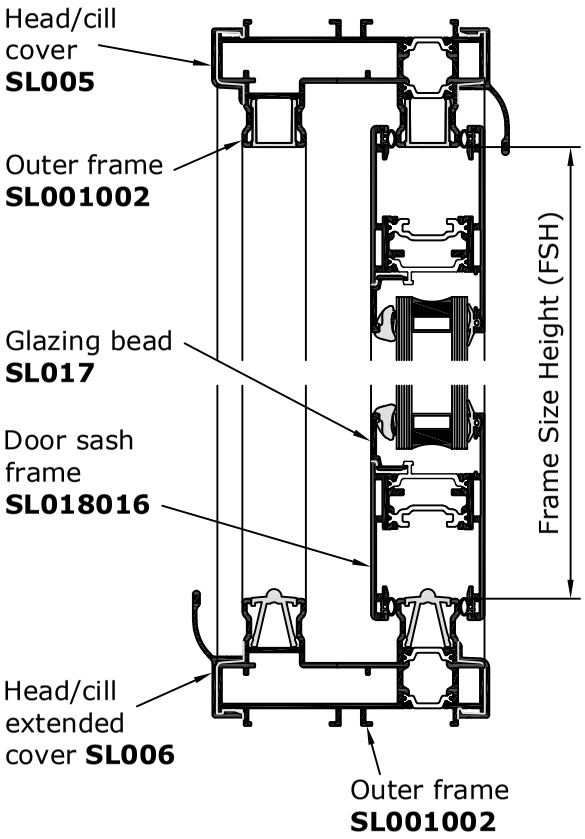
LIFT AND SLIDE DOOR

2T

INSIDE



OUTSIDE



DESCRIPTION	QUANTITY	LENGTH	SECTION	PREPARATION
OUTER FRAME 1 (HEAD)	ONE	FS1 PLUS 13.5mm	SL001002	SQUARE / 45° MITRE
OUTER FRAME 1 (CILL)	ONE	FS1 PLUS 13.5mm	SL001002	45° MITRE / SQUARE
OUTER FRAME 2 (HEAD)	ONE	FS2 PLUS 13.5mm	SL001002	SQUARE / 45° MITRE
OUTER FRAME 2 (CILL)	ONE	FS2 PLUS 13.5mm	SL001002	45° MITRE / SQUARE
OUTER FRAME (JAMB)	TWO	FSH PLUS 101mm	SL001002	45° MITRE BOTH ENDS
DOOR SASH FRAME 1 (HEAD/CILL)	TWO	FS1 PLUS 41.5mm	SL018016	45° MITRE BOTH ENDS
DOOR SASH FRAME 2 (HEAD/CILL)	TWO	FS2 PLUS 41.5mm	SL018016	45° MITRE BOTH ENDS
DOOR SASH FRAME (JAMB)	FOUR	FSH PLUS 17mm	SL018016	45° MITRE BOTH ENDS
GLAZING BEAD 1 (HEAD/CILL)	TWO	FS1 LESS 84.5mm	SL017	ENDS CUT SQUARE
GLAZING BEAD 1 (JAMB)	TWO	FSH LESS 147mm	SL017	ENDS CUT SQUARE
GLAZING BEAD 2 (HEAD/CILL)	TWO	FS2 LESS 84.5mm	SL017	ENDS CUT SQUARE
GLAZING BEAD 2 (JAMB)	TWO	FSH LESS 147mm	SL017	ENDS CUT SQUARE
COVER FOR INTERLOCK	TWO	FSH PLUS 17mm	SL012	ENDS CUT SQUARE - SEE DETAIL
HEAD/CILL EXTENDED COVER	TWO	FS1 PLUS FS2 PLUS 44mm	SL006	ENDS CUT SQUARE
HEAD/CILL COVER	TWO	FS1 PLUS FS2 PLUS 49mm	SL005	ENDS CUT SQUARE
MEETING STILE LOCKING PIECE	TWO	FSH PLUS 17mm	SL021	ENDS CUT SQUARE
OUTER FRAME TRIM	TWO	FS1 LESS 18mm*	SL033	ENDS CUT SQUARE - SEE DETAIL
GLASS SIZE - SASH 1	ONE	FSH LESS 119mm FS1 LESS 94.5mm		
GLASS SIZE - SASH 2	ONE	FSH LESS 119mm FS2 LESS 94.5mm		

*SL033 has been calculated 10mm oversize, and must be trimmed on site during installation to suit resultant opening, subject to site adjustment and tolerance.

Attention should be paid to the orientation of the thermal break in relation to the straight and mitred corner cuts. Refer to "Handing of Outer Frame Profiles" sheet.

All bead lengths are tight sizes. Clearance of not more than 0.5mm should be allowed at each end of the glazing bead.

Not to Scale

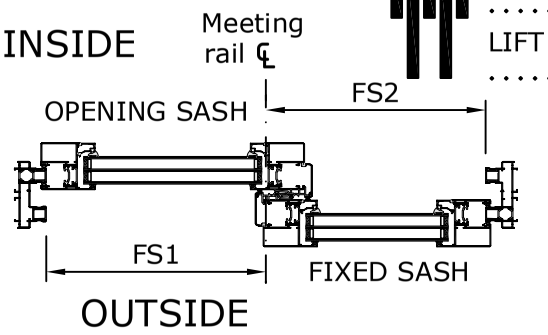
Fabrication and Cutting Sizes (2 Pane) - Sashes
SL129130/SL131132

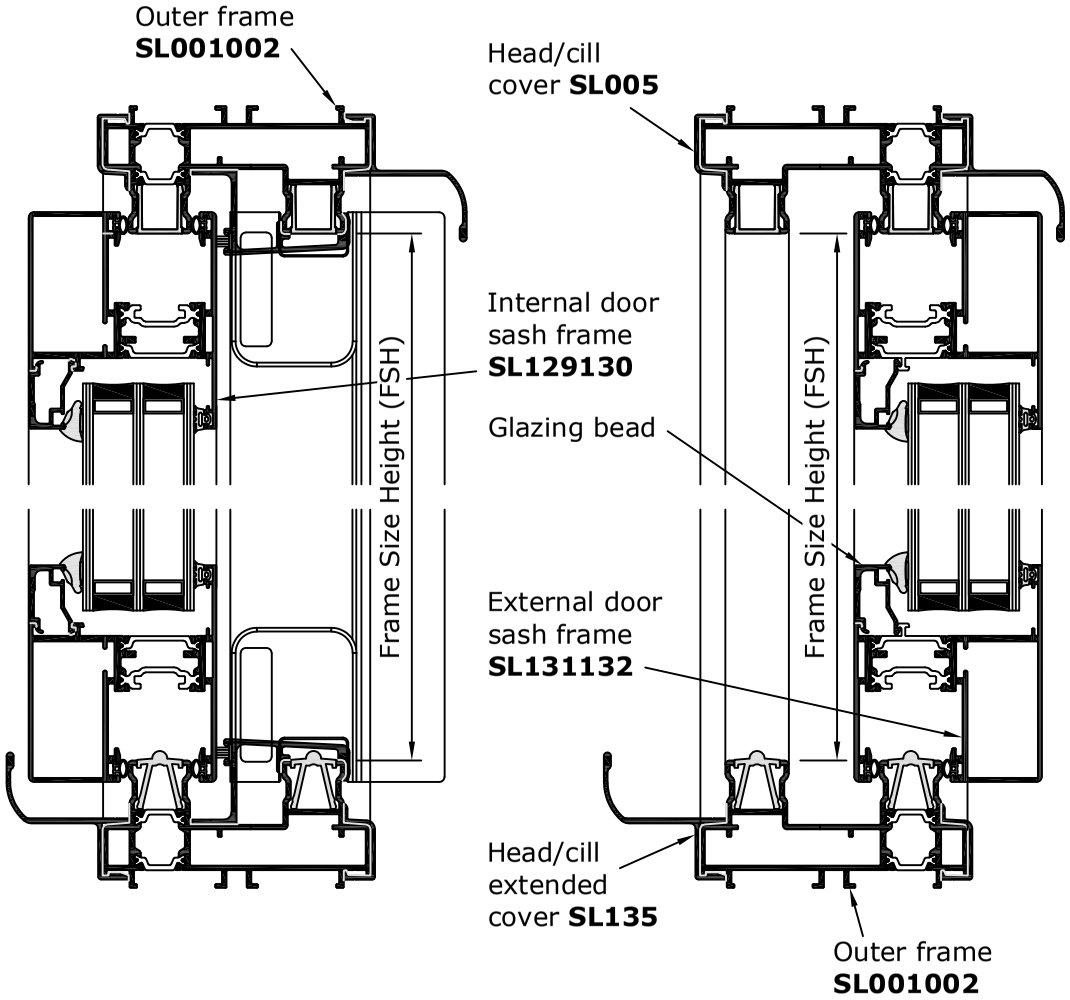
1 Pane Lift and Slide / 1 Pane Fixed

System 25 Hi/Hi+

LIFT AND SLIDE DOOR

2T





DESCRIPTION	QUANTITY	LENGTH	SECTION	PREPARATION
OUTER FRAME 1 (HEAD)	ONE	FS1 plus 13.5mm	SL001002	SQUARE / 45° MITRE
OUTER FRAME 1 (CILL)	ONE	FS1 plus 13.5mm	SL001002	45° MITRE / SQUARE
OUTER FRAME 2 (HEAD)	ONE	FS2 plus 13.5mm	SL001002	SQUARE / 45° MITRE
OUTER FRAME 2 (CILL)	ONE	FS2 plus 13.5mm	SL001002	45° MITRE / SQUARE
OUTER FRAME (JAMB)	TWO	FSH plus 101mm	SL001002	45° MITRE BOTH ENDS
DOOR SASH FRAME 1 (HEAD/CILL)	TWO	FS1 plus 41.5mm	SL129130	45° MITRE BOTH ENDS
DOOR SASH FRAME 2 (HEAD/CILL)	TWO	FS2 plus 41.5mm	SL131132	45° MITRE BOTH ENDS
DOOR SASH FRAME 1 (JAMB)	TWO	FSH plus 17mm	SL129130	45° MITRE BOTH ENDS
DOOR SASH FRAME 2 (JAMB)	TWO	FSH plus 17mm	SL131132	45° MITRE BOTH ENDS
GLAZING BEAD 1 (HEAD/CILL)	TWO	FS1 less 84.5mm	VARIOUS	ENDS CUT SQUARE
GLAZING BEAD 1 (JAMB)	TWO	FSH less 155mm	VARIOUS	ENDS CUT SQUARE
GLAZING BEAD 2 (HEAD/CILL)	TWO	FS2 less 84.5mm	VARIOUS	ENDS CUT SQUARE
GLAZING BEAD 2 (JAMB)	TWO	FSH less 155mm	VARIOUS	ENDS CUT SQUARE
COVER FOR INTERLOCK	TWO	FSH plus 17mm	SL012	ENDS CUT SQUARE - SEE DETAIL
HEAD/CILL EXTENDED COVER	TWO	FS1 plus FS2 plus 44mm	SL135	ENDS CUT SQUARE
HEAD/CILL COVER	TWO	FS1 plus FS2 plus 49mm	SL005	ENDS CUT SQUARE
MEETING STILE LOCKING PIECE	TWO	FSH plus 17mm	SL021	ENDS CUT SQUARE
OUTER FRAME TRIM	TWO	FS1 less 18mm*	SL033	ENDS CUT SQUARE - SEE DETAIL
GLASS SIZE - SASH 1	ONE	FSH less 119mm; FS1 less 94.5mm		
GLASS SIZE - SASH 2	ONE	FSH less 119mm; FS2 less 94.5mm		

*SL033 has been calculated 10mm oversize, and must be trimmed on site during installation to suit resultant opening, subject to site adjustment and tolerance.

Attention should be paid to the orientation of the thermal break in relation to the straight and mitred corner cuts. Refer to "Handing of Outer Frame Profiles" sheet.

All bead lengths are tight sizes. Clearance of not more than 0.5mm should be allowed at each end of the glazing bead.

Not to Scale

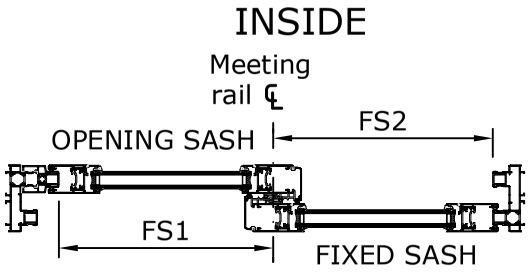
Fabrication and Cutting Sizes (2 Pane with Jamb Extension) - Sash SL018016

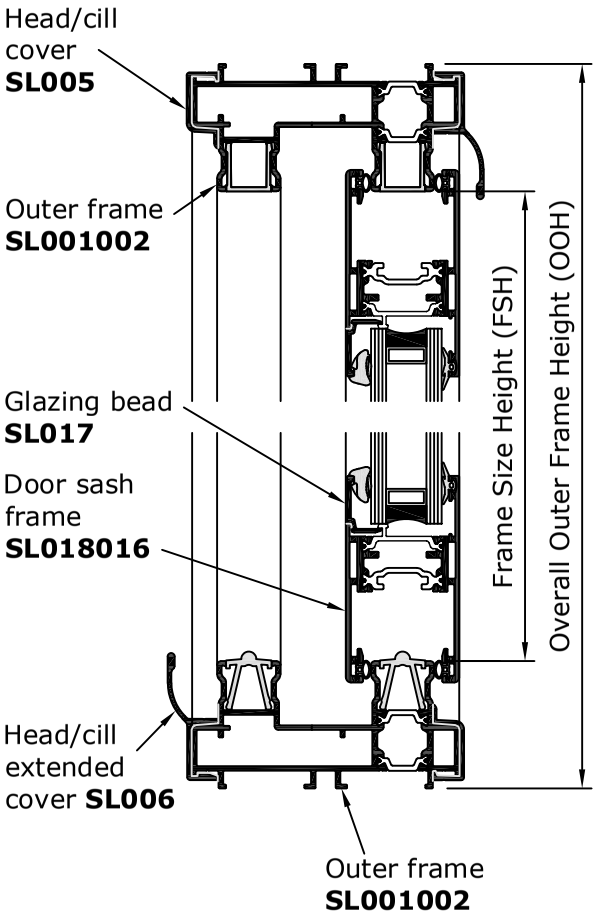
1 Pane Lift and Slide / 1 Pane Fixed

System 25 Hi/Hi+

LIFT AND SLIDE DOOR

2T





DESCRIPTION	QUANTITY	LENGTH	SECTION	PREPARATION
JAMB EXTENSION	ONE	OOH LESS 52mm	SL015015	ENDS CUT SQUARE - SEE DETAIL
OUTER FRAME AT EXTENSION SIDE (HEAD)	ONE	FS1 PLUS 47.5mm	SL001002	SQUARE / 45° MITRE
OUTER FRAME AT EXTENSION SIDE (CILL)	ONE	FS1 PLUS 47.5mm	SL001002	45° MITRE / SQUARE
OUTER FRAME 2 (HEAD)	ONE	FS2 PLUS 13.5mm	SL001002	SQUARE / 45° MITRE
OUTER FRAME 2 (CILL)	ONE	FS2 PLUS 13.5mm	SL001002	45° MITRE / SQUARE
OUTER FRAME (JAMB)	TWO	FSH PLUS 101mm	SL001002	45° MITRE BOTH ENDS
DOOR SASH FRAME 1 (HEAD/CILL)	TWO	FS1 PLUS 41.5mm	SL018016	45° MITRE BOTH ENDS
DOOR SASH FRAME 2 (HEAD/CILL)	TWO	FS2 PLUS 41.5mm	SL018016	45° MITRE BOTH ENDS
DOOR SASH FRAME (JAMB)	FOUR	FSH PLUS 17mm	SL018016	45° MITRE BOTH ENDS
GLAZING BEAD 1 (HEAD/CILL)	TWO	FS1 LESS 84.5mm	SL017	ENDS CUT SQUARE
GLAZING BEAD 1 (JAMB)	TWO	FSH LESS 147mm	SL017	ENDS CUT SQUARE
GLAZING BEAD 2 (HEAD/CILL)	TWO	FS2 LESS 84.5mm	SL017	ENDS CUT SQUARE
GLAZING BEAD 2 (JAMB)	TWO	FSH LESS 147mm	SL017	ENDS CUT SQUARE
COVER FOR INTERLOCK	TWO	FSH PLUS 17mm	SL012	ENDS CUT SQUARE - SEE DETAIL
HEAD EXTENDED COVER	ONE	FS1 PLUS FS2 PLUS 39mm	SL006	ENDS CUT SQUARE
CILL COVER	ONE	FS1 PLUS FS2 PLUS 44mm	SL005	ENDS CUT SQUARE
CILL EXTENDED COVER	ONE	FS1 PLUS FS2 PLUS 78mm	SL006	ENDS CUT SQUARE
HEAD COVER	ONE	FS1 PLUS FS2 PLUS 83mm	SL005	ENDS CUT SQUARE
MEETING STILE LOCKING PIECE	TWO	FSH PLUS 17mm	SL021	ENDS CUT SQUARE
OUTER FRAME TRIM	TWO	FS1 PLUS 16mm*	SL033	ENDS CUT SQUARE - SEE DETAIL
GLASS SIZE - SASH 1	ONE	FSH LESS 119mm FS1 LESS 94.5mm		
GLASS SIZE - SASH 2	ONE	FSH LESS 119mm FS2 LESS 94.5mm		

*SL033 has been calculated 10mm oversize, and must be trimmed on site during installation to suit resultant opening, subject to site adjustment and tolerance.

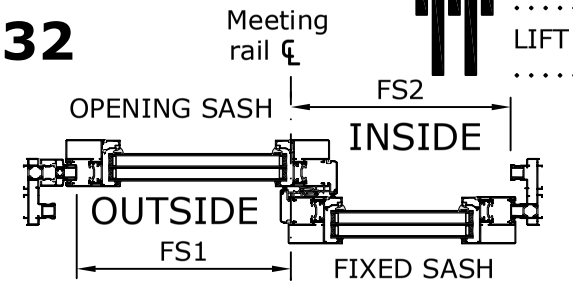
Attention should be paid to the orientation of the thermal break in relation to the straight and mitred corner cuts. Refer to "Handing of Outer Frame Profiles" sheet.

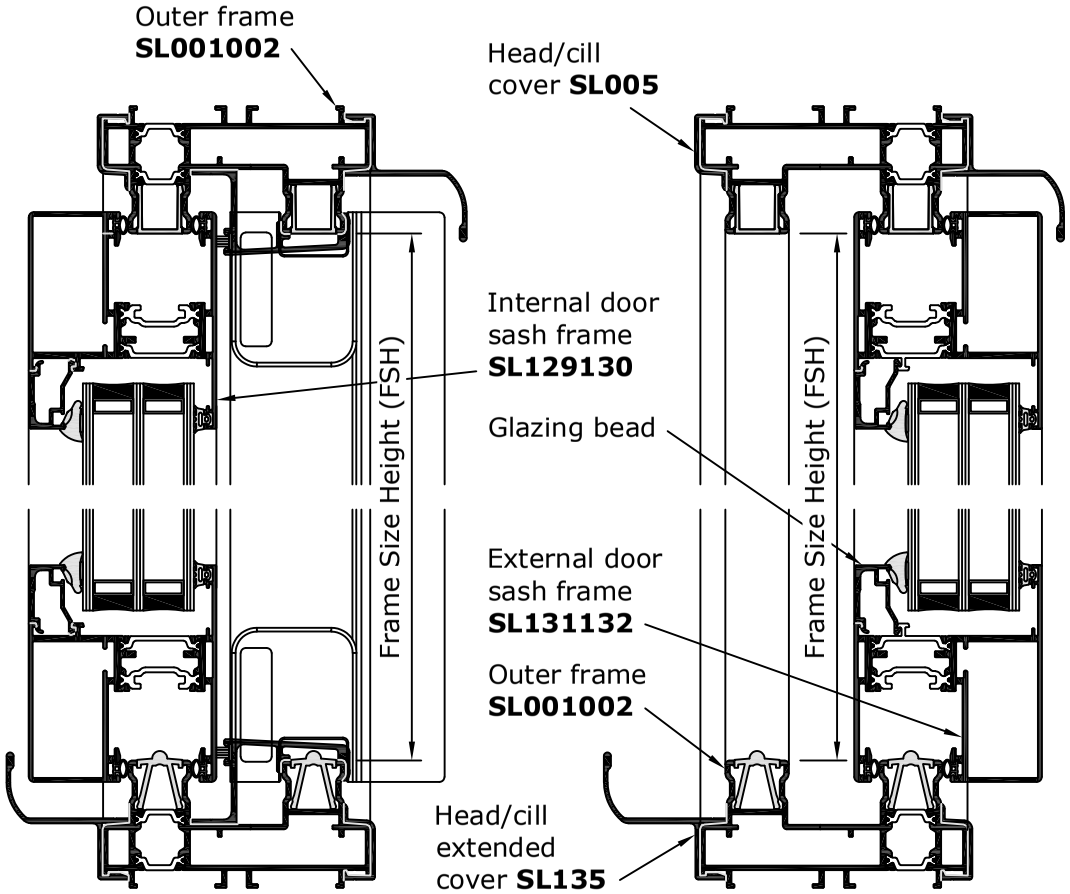
All bead lengths are tight sizes. Clearance of not more than 0.5mm should be allowed at each end of the glazing bead.

Not to Scale

Fabrication and Cutting Sizes (2 Pane with Jamb Extension) - Sashes SL129130/SL131132

1 Pane Lift and Slide / 1 Pane Fixed





DESCRIPTION	QUANTITY	LENGTH	SECTION	PREPARATION
JAMB EXTENSION	ONE	OOH less 52mm	SL015015	ENDS CUT SQUARE - SEE DETAIL
OUTER FRAME AT EXTENSION SIDE (HEAD)	ONE	FS1 plus 47.5mm	SL001002	SQUARE / 45° MITRE
OUTER FRAME AT EXTENSION SIDE (CILL)	ONE	FS1 plus 47.5mm	SL001002	45° MITRE / SQUARE
OUTER FRAME 2 (HEAD)	ONE	FS2 plus 13.5mm	SL001002	SQUARE / 45° MITRE
OUTER FRAME 2 (CILL)	ONE	FS2 plus 13.5mm	SL001002	45° MITRE / SQUARE
OUTER FRAME (JAMB)	TWO	FSH plus 101mm	SL001002	45° MITRE BOTH ENDS
DOOR SASH FRAME 1 (HEAD/CILL)	TWO	FS1 plus 41.5mm	SL129130	45° MITRE BOTH ENDS
DOOR SASH FRAME 2 (HEAD/CILL)	TWO	FS2 plus 41.5mm	SL131132	45° MITRE BOTH ENDS
DOOR SASH FRAME 1 (JAMB)	TWO	FSH plus 17mm	SL129130	45° MITRE BOTH ENDS
DOOR SASH FRAME 2 (JAMB)	TWO	FSH plus 17mm	SL131132	45° MITRE BOTH ENDS
GLAZING BEAD 1 (HEAD/CILL)	TWO	FS1 less 84.5mm	VARIOUS	ENDS CUT SQUARE
GLAZING BEAD 1 (JAMB)	TWO	FSH less 155mm	VARIOUS	ENDS CUT SQUARE
GLAZING BEAD 2 (HEAD/CILL)	TWO	FS2 less 84.5mm	VARIOUS	ENDS CUT SQUARE
GLAZING BEAD 2 (JAMB)	TWO	FSH less 155mm	VARIOUS	ENDS CUT SQUARE
COVER FOR INTERLOCK	TWO	FSH plus 17mm	SL012	ENDS CUT SQUARE - SEE DETAIL
HEAD EXTENDED COVER	ONE	FS1 plus FS2 plus 39mm	SL135	ENDS CUT SQUARE
CILL COVER	ONE	FS1 plus FS2 plus 44mm	SL005	ENDS CUT SQUARE
CILL EXTENDED COVER	ONE	FS1 plus FS2 plus 78mm	SL135	ENDS CUT SQUARE
HEAD COVER	ONE	FS1 plus FS2 plus 83mm	SL005	ENDS CUT SQUARE
MEETING STILE LOCKING PIECE	TWO	FSH plus 17mm	SL021	ENDS CUT SQUARE
OUTER FRAME TRIM	TWO	FS1 less 16mm*	SL033	ENDS CUT SQUARE - SEE DETAIL
GLASS SIZE - SASH 1	ONE	FSH less 119mm; FS1 less 94.5mm		
GLASS SIZE - SASH 2	ONE	FSH less 119mm; FS2 less 94.5mm		

*SL033 has been calculated 10mm oversize, and must be trimmed on site during installation to suit resultant opening, subject to site adjustment and tolerance.

Attention should be paid to the orientation of the thermal break in relation to the straight and mitred corner cuts. Refer to "Handing of Outer Frame Profiles" sheet.

All bead lengths are tight sizes. Clearance of not more than 0.5mm should be allowed at each end of the glazing bead.

Not to Scale

Bar Cutting Sizes

All cutting sizes in this range are calculated from the Frame Sizes (FS) as illustrated below.

System 25 Hi/Hi+

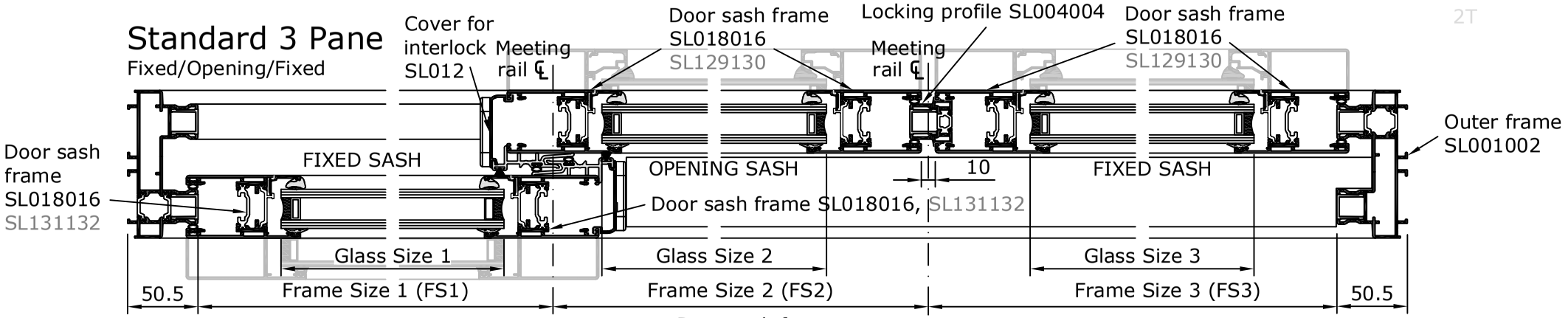
LIFT AND SLIDE DOOR

2T

INSIDE

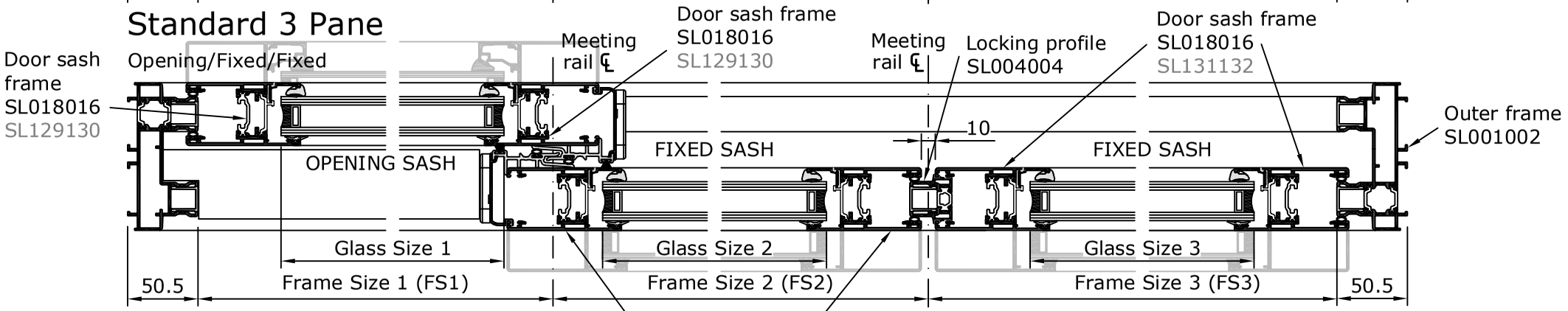
Standard 3 Pane

Fixed/Opening/Fixed



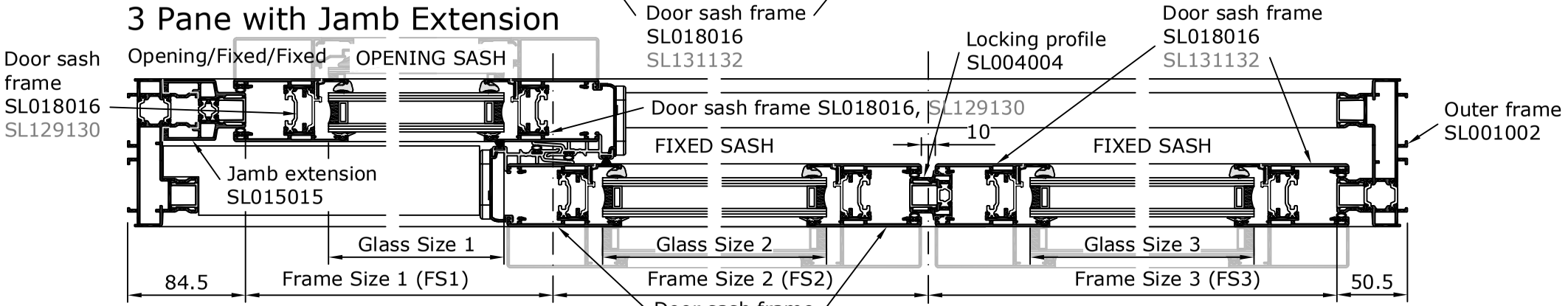
Standard 3 Pane

Opening/Fixed/Fixed



3 Pane with Jamb Extension

Opening/Fixed/Fixed



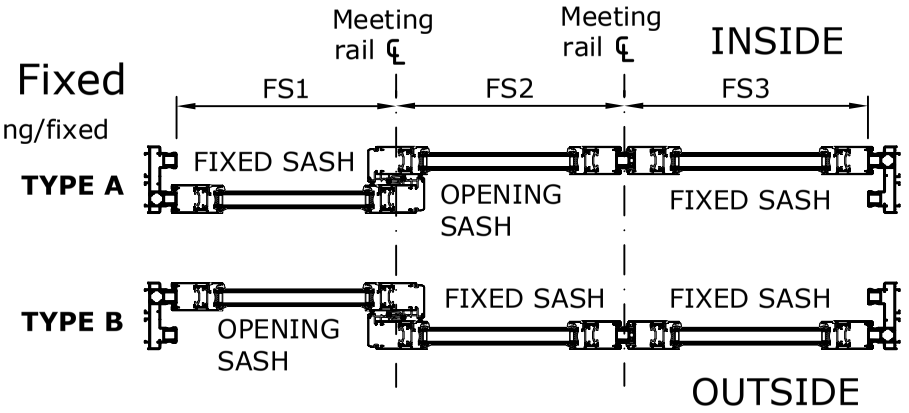
Scale 1:4

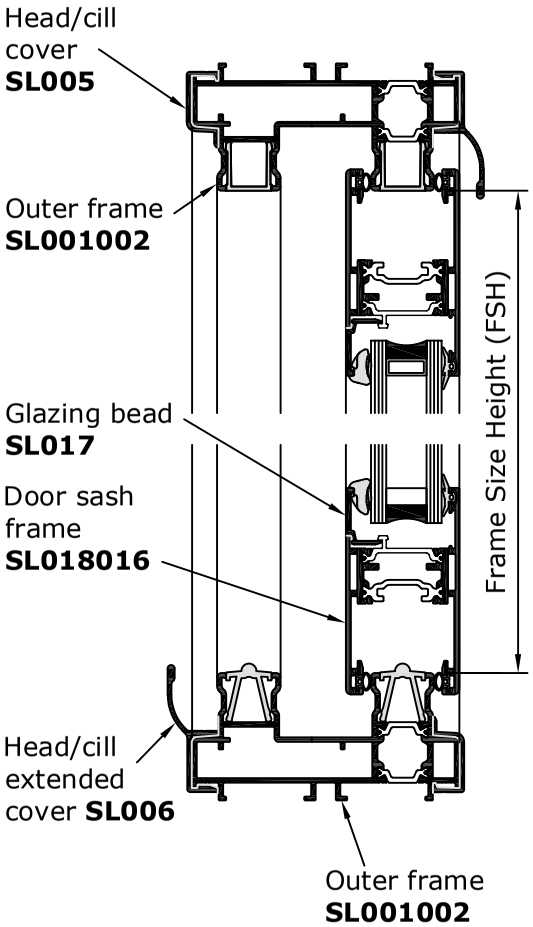
OUTSIDE

Fabrication and Cutting Sizes (3 Pane) - Sash SL018016

1 Pane Lift and Slide / 2 Pane Fixed

These calculations may be used for fixed/opening/fixed or opening/fixed/fixed combinations.





DESCRIPTION	QUANTITY	LENGTH	SECTION	PREPARATION
OUTER FRAME 1 (HEAD)	ONE	FS1 PLUS 13.5mm	SL001002	SQUARE / 45° MITRE
OUTER FRAME 1 (CILL)	ONE	FS1 PLUS 13.5mm	SL001002	45° MITRE / SQUARE
OUTER FRAME 2 (HEAD)	ONE	FS2 PLUS FS3 PLUS 13.5mm	SL001002	SQUARE / 45° MITRE
OUTER FRAME 2 (CILL)	ONE	FS2 PLUS FS3 PLUS 13.5mm	SL001002	45° MITRE / SQUARE
OUTER FRAME (JAMB)	TWO	FSH PLUS 101mm	SL001002	45° MITRE BOTH ENDS
SASH FRAME 1 (HEAD/CILL)	TWO	FS1 PLUS 41.5mm	SL018016	45° MITRE BOTH ENDS
SASH FRAME 2 (HEAD/CILL)	TWO	FS2 PLUS 28mm	SL018016	45° MITRE BOTH ENDS
SASH FRAME 3 (HEAD/CILL)	TWO	FS3 PLUS 3.5mm	SL018016	45° MITRE BOTH ENDS
DOOR SASH FRAME (JAMB)	SIX	FSH PLUS 17mm	SL018016	45° MITRE BOTH ENDS
GLAZING BEAD 1 (HEAD/CILL)	TWO	FS1 LESS 84.5mm	SL017	ENDS CUT SQUARE
GLAZING BEAD 2 (HEAD/CILL)	TWO	FS2 LESS 98mm	SL017	ENDS CUT SQUARE
GLAZING BEAD 3 (HEAD/CILL)	TWO	FS3 LESS 122.5mm	SL017	ENDS CUT SQUARE
GLAZING BEAD (JAMB)	SIX	FSH LESS 147mm	SL017	ENDS CUT SQUARE
COVER FOR INTERLOCK	TWO	FSH PLUS 17mm	SL012	ENDS CUT SQUARE - SEE DETAIL
HEAD/CILL EXTENDED COVER	TWO	FS1 PLUS FS2 PLUS FS3 PLUS 44mm	SL006	ENDS CUT SQUARE
HEAD/CILL COVER	TWO	FS1 PLUS FS2 PLUS FS3 PLUS 49mm	SL005	ENDS CUT SQUARE
MEETING STILE LOCKING PIECE	TWO	FSH PLUS 17mm	SL021	ENDS CUT SQUARE
LOCKING PROFILE	ONE	FSH LESS 67mm	SL004004	ENDS CUT SQUARE
OUTER FRAME TRIM - **TYPE A***	TWO	FS2 PLUS FS3 LESS 18mm**	SL033	ENDS CUT SQUARE - SEE DETAIL
OUTER FRAME TRIM - **TYPE B***	TWO	FS1 LESS 18mm**	SL033	ENDS CUT SQUARE - SEE DETAIL
GLASS SIZE 1	ONE	FSH LESS 119mm FS1 LESS 94.5mm		
GLASS SIZE 2	ONE	FSH LESS 119mm FS2 LESS 108mm		
GLASS SIZE 3	ONE	FSH LESS 119mm FS3 LESS 132.5mm		

* choose one of these two options:
  - **TYPE A** to be used in fixed/opening/fixed application
  - **TYPE B** to be used in opening/fixed/fixed application

** SL033 has been calculated 10mm oversize, and must be trimmed on site during installation to suit resultant opening, subject to site adjustment and tolerance.

The above cutting dimensions allow the fabricator to determine unequal sash widths. For equal widths:

$$\text{Sash} = \frac{\text{Overall width - 28mm}}{3}$$

Glass = Sash width - 136mm

Attention should be paid to the orientation of the thermal break in relation to the straight and mitred corner cuts. Refer to "Handing of Outer Frame Profiles" sheet.

All bead lengths are tight sizes. Clearance of not more than 0.5mm should be allowed at each end of the glazing bead.

Not to Scale

Fabrication and Cutting Sizes (3 Pane) - Sashes

SL129130/SL131132

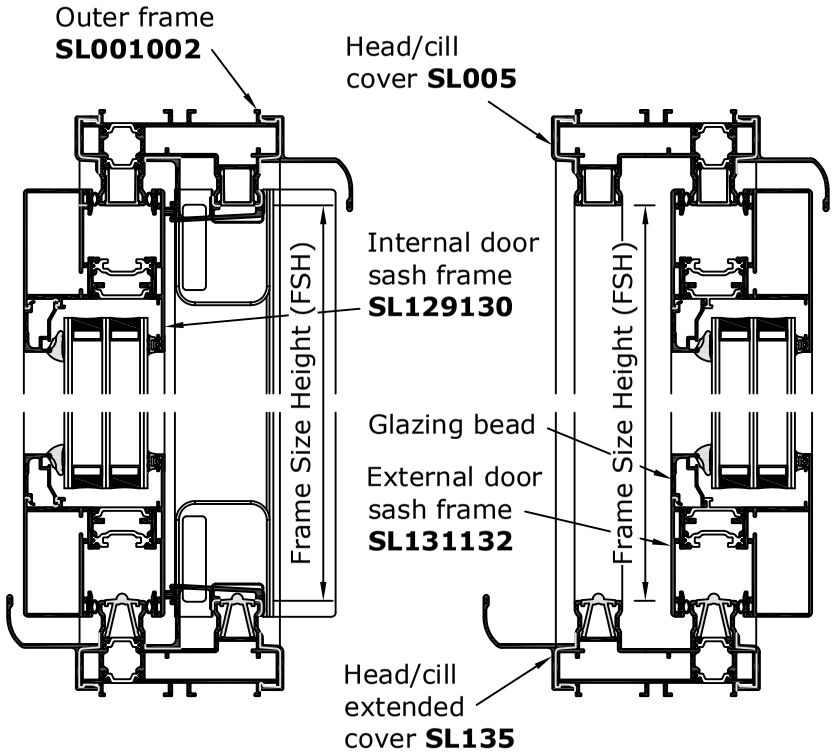
1 Pane Lift and Slide / 2 Pane Fixed

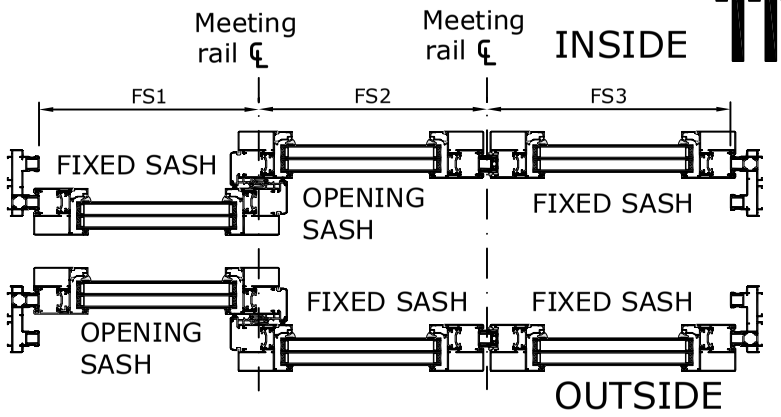
System 25 Hi/Hi+

LIFT AND SLIDE DOOR

2T

These calculations may be used for fixed/opening/fixed or opening/fixed/fixed combinations.





DESCRIPTION	QUANTITY	LENGTH	SECTION	PREPARATION
OUTER FRAME 1 (HEAD)	ONE	FS1 plus 13.5mm	SL001002	SQUARE / 45° MITRE
OUTER FRAME 1 (CILL)	ONE	FS1 plus 13.5mm	SL001002	45° MITRE / SQUARE
OUTER FRAME 2 (HEAD)	ONE	FS2 plus FS3 plus 13.5mm	SL001002	SQUARE / 45° MITRE
OUTER FRAME 2 (CILL)	ONE	FS2 plus FS3 plus 13.5mm	SL001002	45° MITRE / SQUARE
OUTER FRAME (JAMB)	TWO	FSH plus 101mm	SL001002	45° MITRE BOTH ENDS
DOOR SASH FRAME 1 (HEAD/CILL) - **TYPE A***	TWO	FS1 plus 41.5mm	SL131132	45° MITRE BOTH ENDS
DOOR SASH FRAME 1 (HEAD/CILL) - **TYPE B***	TWO	FS1 plus 41.5mm	SL129130	45° MITRE BOTH ENDS
DOOR SASH FRAME 2 (HEAD/CILL) - **TYPE A***	TWO	FS2 plus 28mm	SL129130	45° MITRE BOTH ENDS
DOOR SASH FRAME 2 (HEAD/CILL) - **TYPE B***	TWO	FS2 plus 28mm	SL131132	45° MITRE BOTH ENDS
DOOR SASH FRAME 3 (HEAD/CILL) - **TYPE A***	TWO	FS3 plus 3.5mm	SL129130	45° MITRE BOTH ENDS
DOOR SASH FRAME 3 (HEAD/CILL) - **TYPE B***	TWO	FS3 plus 3.5mm	SL131132	45° MITRE BOTH ENDS
DOOR SASH FRAME (JAMB) - **TYPE A***	TWO	FSH plus 17mm	SL131132	45° MITRE BOTH ENDS
DOOR SASH FRAME (JAMB) - **TYPE A***	FOUR	FSH plus 17mm	SL129130	45° MITRE BOTH ENDS
DOOR SASH FRAME (JAMB) - **TYPE B***	TWO	FSH plus 17mm	SL129130	45° MITRE BOTH ENDS
DOOR SASH FRAME (JAMB) - **TYPE B***	FOUR	FSH plus 17mm	SL131132	45° MITRE BOTH ENDS
GLAZING BEAD 1 (HEAD/CILL)	TWO	FS1 less 84.5mm	VARIOUS	ENDS CUT SQUARE
GLAZING BEAD 2 (HEAD/CILL)	TWO	FS2 less 98mm	VARIOUS	ENDS CUT SQUARE
GLAZING BEAD 3 (HEAD/CILL)	TWO	FS3 less 122.5mm	VARIOUS	ENDS CUT SQUARE
GLAZING BEAD (JAMB)	SIX	FSH less 155mm	VARIOUS	ENDS CUT SQUARE
COVER FOR INTERLOCK	TWO	FSH plus 17mm	SL012	ENDS CUT SQUARE - SEE DETAIL
HEAD/CILL EXTENDED COVER	TWO	FS1 plus FS2 plus FS3 plus 44mm	SL135	ENDS CUT SQUARE
HEAD/CILL COVER	TWO	FS1 plus FS2 plus FS3 plus 49mm	SL005	ENDS CUT SQUARE
MEETING STILE LOCKING PIECE	TWO	FSH plus 17mm	SL021	ENDS CUT SQUARE
LOCKING PROFILE	ONE	FSH less 67mm	SL004004	ENDS CUT SQUARE
OUTER FRAME TRIM - **TYPE A***	TWO	FS2 plus FS3 less 18mm**	SL033	ENDS CUT SQUARE - SEE DETAIL
OUTER FRAME TRIM - **TYPE B***	TWO	FS1 less 18mm**	SL033	ENDS CUT SQUARE - SEE DETAIL
GLASS SIZE - SASH 1	ONE	FSH less 119mm; FS1 less 94.5mm		
GLASS SIZE - SASH 2	ONE	FSH less 119mm; FS2 less 108mm		
GLASS SIZE - SASH 3	ONE	FSH less 119mm; FS3 less 132.5mm		

The above cutting dimensions allow the fabricator to determine unequal sash widths. For equal widths:

$$\text{Sash} = \frac{\text{Overall width - 28mm}}{3}$$

Glass = Sash width - 136mm

Attention should be paid to the orientation of the thermal break in relation to the straight and mitred corner cuts. Refer to "Handing of Outer Frame Profiles" sheet.

All bead lengths are tight sizes. Clearance of not more than 0.5mm should be allowed at each end of the glazing bead.

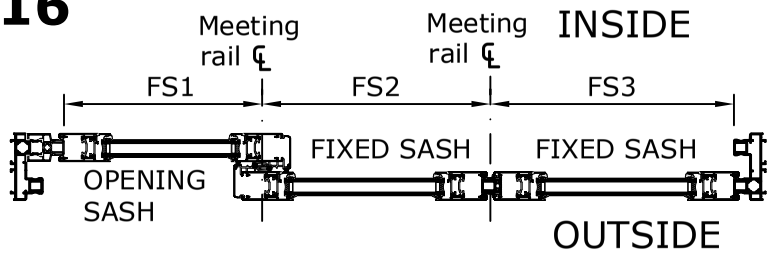
*choose one of these two options:
- **TYPE A** to be used in fixed/opening/fixed application
- **TYPE B** to be used in opening/fixed/fixed application

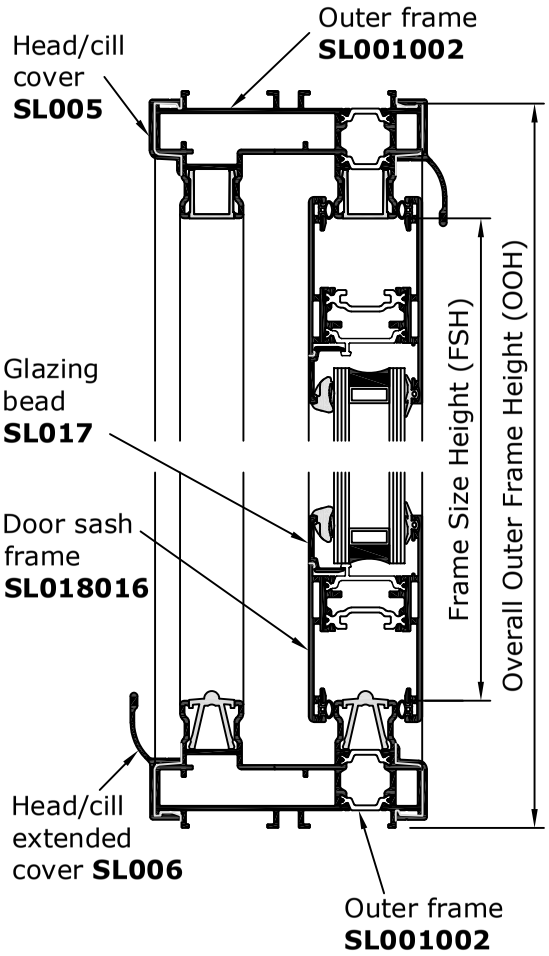
** SL033 has been calculated 10mm oversize, and must be trimmed on site during installation to suit resultant opening, subject to site adjustment and tolerance.

Scale 1:4

Fabrication and Cutting Sizes (3 Pane with Jamb Extension) - Sash SL018016

1 Pane Lift and Slide / 2 Pane Fixed





DESCRIPTION	QUANTITY	LENGTH	SECTION	PREPARATION
JAMB EXTENSION	ONE	OOH LESS 52mm	SL015015	ENDS CUT SQUARE - SEE DETAIL
OUTER FRAME AT EXTENSION SIDE (HEAD)	ONE	FS1 PLUS 47.5mm	SL001002	SQUARE / 45° MITRE
OUTER FRAME AT EXTENSION SIDE (CILL)	ONE	FS1 PLUS 47.5mm	SL001002	45° MITRE / SQUARE
OUTER FRAME 2 (HEAD)	ONE	FS2 PLUS FS3 PLUS 13.5mm	SL001002	SQUARE / 45° MITRE
OUTER FRAME 2 (CILL)	ONE	FS2 PLUS FS3 PLUS 13.5mm	SL001002	45° MITRE / SQUARE
OUTER FRAME (JAMB)	TWO	FSH PLUS 101mm	SL001002	45° MITRE BOTH ENDS
OPENING SASH FRAME (HEAD/CILL)	TWO	FS1 PLUS 41.5mm	SL018016	45° MITRE BOTH ENDS
FIXED SASH FRAME 1 (HEAD/CILL)	TWO	FS2 PLUS 28mm	SL018016	45° MITRE BOTH ENDS
FIXED SASH FRAME 2 (HEAD/CILL)	TWO	FS3 PLUS 3.5mm	SL018016	45° MITRE BOTH ENDS
DOOR SASH FRAME (JAMB)	SIX	FSH PLUS 17mm	SL018016	45° MITRE BOTH ENDS
OPENING SASH BEAD (HEAD/CILL)	TWO	FS1 LESS 84.5mm	SL017	ENDS CUT SQUARE
FIXED SASH BEAD 1 (HEAD/CILL)	TWO	FS2 LESS 98mm	SL017	ENDS CUT SQUARE
FIXED SASH BEAD 2 (HEAD/CILL)	TWO	FS3 LESS 122.5mm	SL017	ENDS CUT SQUARE
GLAZING BEAD (JAMB)	SIX	FSH LESS 147mm	SL017	ENDS CUT SQUARE
COVER FOR INTERLOCK	TWO	FSH PLUS 17mm	SL012	ENDS CUT SQUARE - SEE DETAIL
HEAD EXTENDED COVER	ONE	FS1 PLUS FS2 PLUS FS3 PLUS 39mm	SL006	ENDS CUT SQUARE
CILL COVER	ONE	FS1 PLUS FS2 PLUS FS3 PLUS 44mm	SL005	ENDS CUT SQUARE
CILL EXTENDED COVER	ONE	FS1 PLUS FS2 PLUS FS3 PLUS 78mm	SL006	ENDS CUT SQUARE
HEAD COVER	ONE	FS1 PLUS FS2 PLUS FS3 PLUS 83mm	SL005	ENDS CUT SQUARE
MEETING STILE LOCKING PIECE	TWO	FSH PLUS 17mm	SL021	ENDS CUT SQUARE
LOCKING PROFILE	ONE	FSH LESS 67mm	SL004004	ENDS CUT SQUARE
OUTER FRAME TRIM	TWO	FS1 PLUS 16mm*	SL033	ENDS CUT SQUARE - SEE DETAIL
GLASS SIZE - OPENING SASH	ONE	FSH LESS 119mm FS1 LESS 94.5mm		
GLASS SIZE - FIXED SASH 1	ONE	FSH LESS 119mm FS2 LESS 108mm		
GLASS SIZE - FIXED SASH 2	ONE	FSH LESS 119mm FS3 LESS 132.5mm		

*SL033 has been calculated 10mm oversize, and must be trimmed on site during installation to suit resultant opening, subject to site adjustment and tolerance.

The above cutting dimensions allow the fabricator to determine unequal sash widths. For equal widths:

$$\text{Sash} = \frac{\text{Overall width - 62mm}}{3}$$

Glass = Sash width - 136mm

Attention should be paid to the orientation of the thermal break in relation to the straight and mitred corner cuts. Refer to "Handing of Outer Frame Profiles" sheet.

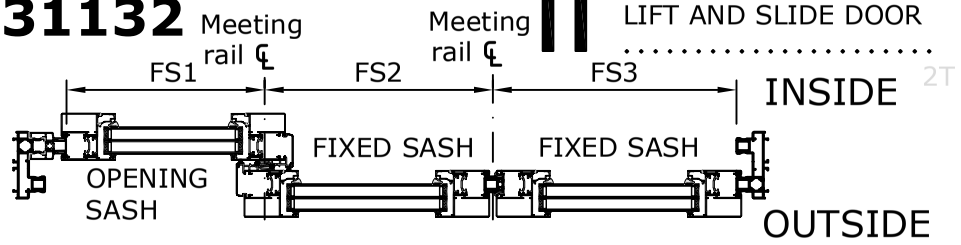
All bead lengths are tight sizes. Clearance of not more than 0.5mm should be allowed at each end of the glazing bead.

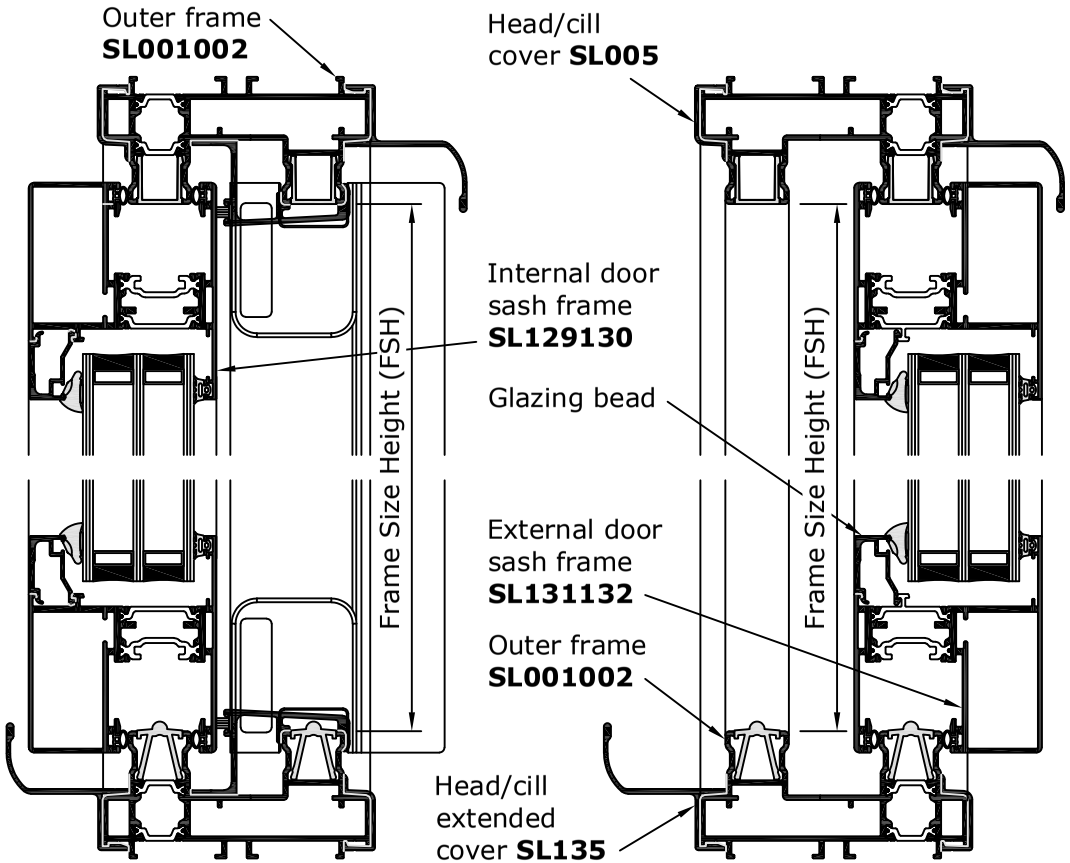
Not to Scale

Fabrication and Cutting Sizes (3 Pane with Jamb Extension) - Sashes SL129130/SL131132

1 Pane Lift and Slide / 2 Pane Fixed

System 25 Hi/Hi+
LIFT AND SLIDE DOOR





DESCRIPTION	QUANTITY	LENGTH	SECTION	PREPARATION
JAMB EXTENSION	ONE	OOH less 52mm	SL015015	ENDS CUT SQUARE - SEE DETAIL
OUTER FRAME AT EXTENSION SIDE (HEAD)	ONE	FS1 plus 47.5mm	SL001002	SQUARE / 45° MITRE
OUTER FRAME AT EXTENSION SIDE (CILL)	ONE	FS1 plus 47.5mm	SL001002	45° MITRE / SQUARE
OUTER FRAME 2 (HEAD)	ONE	FS2 plus FS3 plus 13.5mm	SL001002	SQUARE / 45° MITRE
OUTER FRAME 2 (CILL)	ONE	FS2 plus FS3 plus 13.5mm	SL001002	45° MITRE / SQUARE
OUTER FRAME (JAMB)	TWO	FSH plus 101mm	SL001002	45° MITRE BOTH ENDS
OPENING SASH FRAME (HEAD/CILL)	TWO	FS1 plus 41.5mm	SL129130	45° MITRE BOTH ENDS
OPENING SASH FRAME (JAMB)	TWO	FS1 plus 17mm	SL129130	45° MITRE BOTH ENDS
FIXED SASH FRAME 1 (HEAD/CILL)	TWO	FS2 plus 28mm	SL131132	45° MITRE BOTH ENDS
FIXED SASH FRAME 2 (HEAD/CILL)	TWO	FS3 plus 3.5mm	SL131132	45° MITRE BOTH ENDS
FIXED SASH FRAME (JAMB)	FOUR	FSH plus 17mm	SL131132	45° MITRE BOTH ENDS
OPENING SASH BEAD (HEAD/CILL)	TWO	FS1 less 84.5mm	VARIOUS	ENDS CUT SQUARE
FIXED SASH BEAD 1 (HEAD/CILL)	TWO	FS2 less 98mm	VARIOUS	ENDS CUT SQUARE
FIXED SASH BEAD 2 (HEAD/CILL)	TWO	FS3 less 122.5mm	VARIOUS	ENDS CUT SQUARE
GLAZING BEAD (JAMB)	SIX	FSH less 155mm	VARIOUS	ENDS CUT SQUARE
COVER FOR INTERLOCK	TWO	FSH plus 17mm	SL012	ENDS CUT SQUARE - SEE DETAIL
HEAD EXTENDED COVER	ONE	FS1 plus FS2 plus FS3 plus 39mm	SL135	ENDS CUT SQUARE
CILL COVER	ONE	FS1 plus FS2 plus FS3 plus 44mm	SL005	ENDS CUT SQUARE
CILL EXTENDED COVER	ONE	FS1 plus FS2 plus FS3 plus 78mm	SL135	ENDS CUT SQUARE
HEAD COVER	ONE	FS1 plus FS2 plus FS3 plus 83mm	SL005	ENDS CUT SQUARE
MEETING STILE LOCKING PIECE	TWO	FSH plus 17mm	SL021	ENDS CUT SQUARE
LOCKING PROFILE	ONE	FSH less 67mm	SL004004	ENDS CUT SQUARE
OUTER FRAME TRIM	TWO	FS1 less 16mm*	SL033	ENDS CUT SQUARE - SEE DETAIL
GLASS SIZE - OPENING SASH	ONE	FSH less 119mm; FS1 less 94.5mm		
GLASS SIZE - FIXED SASH 1	ONE	FSH less 119mm; FS2 less 108mm		
GLASS SIZE - FIXED SASH 2	ONE	FSH less 119mm; FS2 less 132.5mm		

*SL033 has been calculated 10mm oversize, and must be trimmed on site during installation to suit resultant opening, subject to site adjustment and tolerance.

The cutting dimensions allow the fabricator to determine unequal sash widths.

For equal widths: Sash = $\frac{\text{Overall width - 62mm}}{3}$; Glass = Sash width - 136mm

Attention should be paid to the orientation of the thermal break in relation to the straight and mitred corner cuts. Refer to "Handing of Outer Frame Profiles" sheet.

All bead lengths are tight sizes. Clearance of not more than 0.5mm should be allowed at each end of the glazing bead.

Not to Scale

Bar Cutting Sizes

System 25 Hi/Hi+

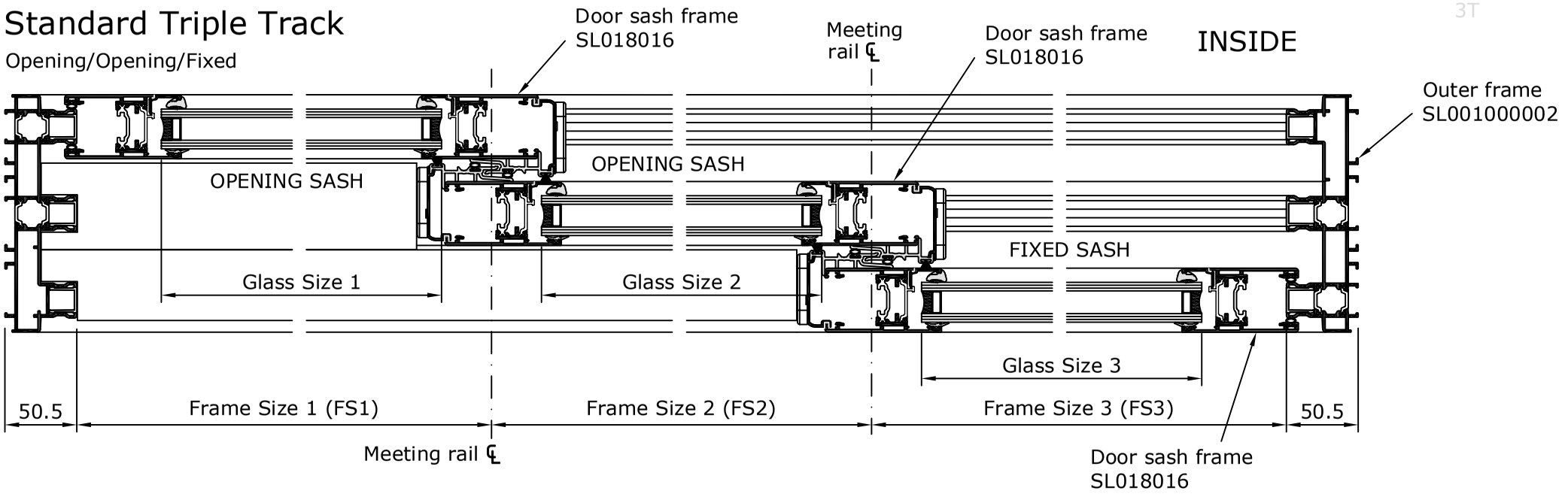
LIFT AND SLIDE DOOR

3T

All cutting sizes in this range are calculated from the Frame Sizes (FS) as illustrated below.

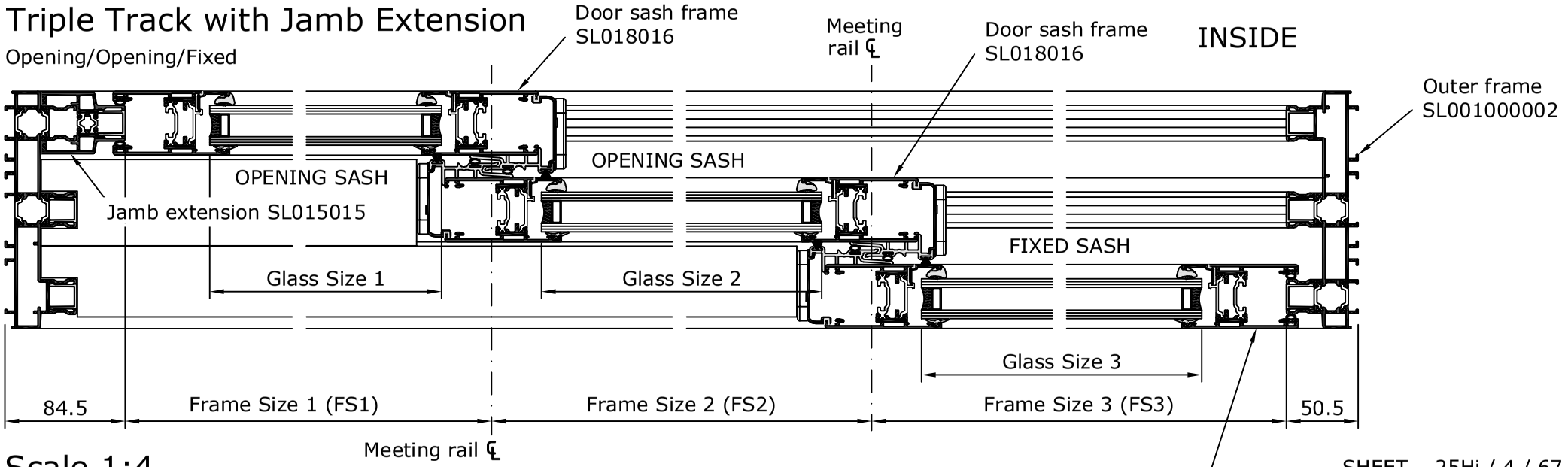
Standard Triple Track

Opening/Opening/Fixed



Triple Track with Jamb Extension

Opening/Opening/Fixed



Scale 1:4

OUTSIDE

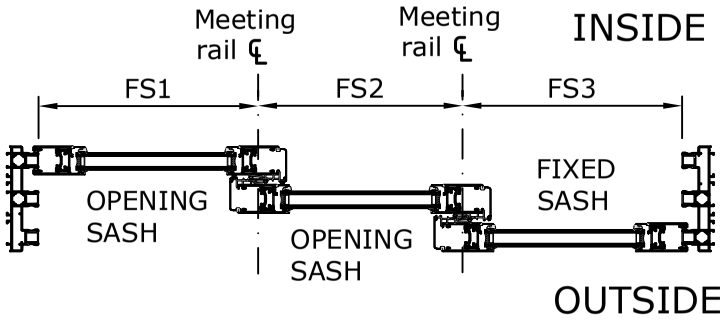
Fabrication and Cutting Sizes (Triple Track 3 Pane) - Sash SL018016

2 Pane Lift and Slide / 1 Pane Fixed

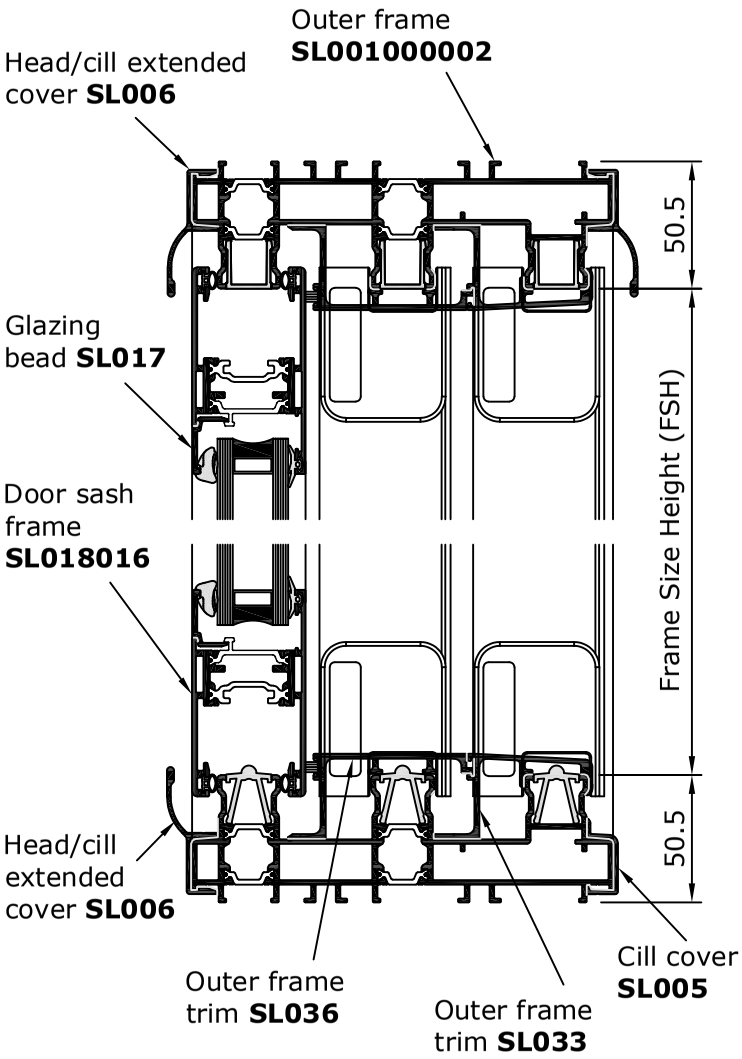
System 25 Hi/Hi+

LIFT AND SLIDE DOOR

3T



** SL033 and SL036 have been calculated 10mm oversize, and must be trimmed on site during installation to suit resultant opening, subject to site adjustment and tolerance.



DESCRIPTION	QUANTITY	LENGTH	SECTION	PREPARATION
OUTER FRAME 1 (HEAD)	ONE	FS1 plus 8.5mm	SL001000002	SQUARE / 45° MITRE
OUTER FRAME 1 (CILL)	ONE	FS1 plus 8.5mm	SL001000002	45° MITRE / SQUARE
OUTER FRAME 2 (HEAD)	ONE	FS2 less 84mm	SL001000002	ENDS CUT SQUARE
OUTER FRAME 2 (CILL)	ONE	FS2 less 84mm	SL001000002	ENDS CUT SQUARE
OUTER FRAME 3 (HEAD)	ONE	FS3 plus 8.5mm	SL001000002	SQUARE / 45° MITRE
OUTER FRAME 3 (CILL)	ONE	FS3 plus 8.5mm	SL001000002	45° MITRE / SQUARE
OUTER FRAME (JAMB)	ONE	FSH plus 101mm	SL001000002	45° MITRE BOTH ENDS
SASH FRAME 1 (HEAD/CILL)	TWO	FS1 plus 41.5mm	SL018016	45° MITRE BOTH ENDS
SASH FRAME 2 (HEAD/CILL)	TWO	FS2 plus 65.75mm	SL018016	45° MITRE BOTH ENDS
SASH FRAME 3 (HEAD/CILL)	TWO	FS3 plus 41.5mm	SL018016	45° MITRE BOTH ENDS
DOOR SASH FRAME (JAMB)	SIX	FSH plus 17mm	SL018016	45° MITRE BOTH ENDS
GLAZING BEAD 1 (HEAD/CILL)	TWO	FS1 less 84.5mm	SL017	ENDS CUT SQUARE
GLAZING BEAD 2 (HEAD/CILL)	TWO	FS2 less 60.25mm	SL017	ENDS CUT SQUARE
GLAZING BEAD 3 (HEAD/CILL)	TWO	FS3 less 84.5mm	SL017	ENDS CUT SQUARE
GLAZING BEAD (JAMB)	SIX	FSH less 147mm	SL017	ENDS CUT SQUARE
COVER FOR INTERLOCK	FOUR	FSH plus 17mm	SL012	ENDS CUT SQUARE - SEE DETAIL
HEAD/CILL EXTENDED COVER	THREE	FS1 plus FS2 plus FS3 plus 44mm	SL006	ENDS CUT SQUARE
CILL COVER	ONE	FS1 plus FS2 plus FS3 plus 49mm	SL005	ENDS CUT SQUARE
MEETING STILE LOCKING PIECE	FOUR	FSH plus 17mm	SL021	ENDS CUT SQUARE
OUTER FRAME TRIM	TWO	FS1 plus FS2 less 18mm**	SL033	ENDS CUT SQUARE - SEE DETAIL
OUTER FRAME TRIM	TWO	FS1 less 18mm**	SL036	ENDS CUT SQUARE - SEE DETAIL
GLASS SIZE 1	ONE	FSH less 119mm; FS1 less 94.5mm		
GLASS SIZE 2	ONE	FSH less 119mm; FS2 less 70.25mm		
GLASS SIZE 3	ONE	FSH less 119mm; FS3 less 94.5mm		

The above cutting dimensions allow the fabricator to determine unequal sash widths. For equal widths:
Sash = (Overall width plus 47.5mm) / 3
Glass = Sash width - 136mm

Attention should be paid to the orientation of the thermal break in relation to the straight and mitred corner cuts. Refer to "Handing of Outer Frame Profiles" sheet.

All bead lengths are tight sizes. Clearance of not more than 0.5mm should be allowed at each end of the glazing bead.

Not to Scale

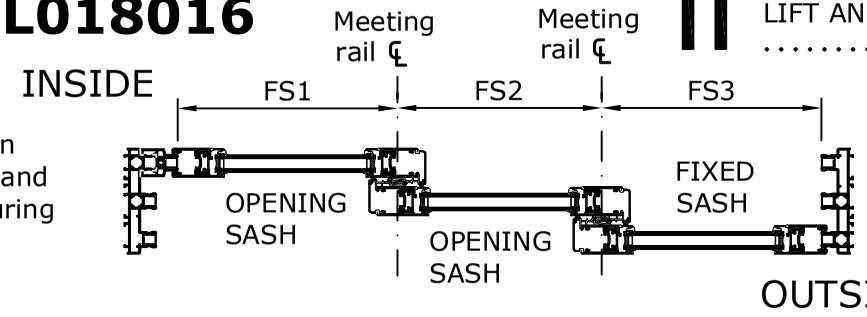
Fabrication and Cutting Sizes (Triple Track 3 Pane with Jamb Extension) - Sash SL018016

2 Pane Lift and Slide / 1 Pane Fixed

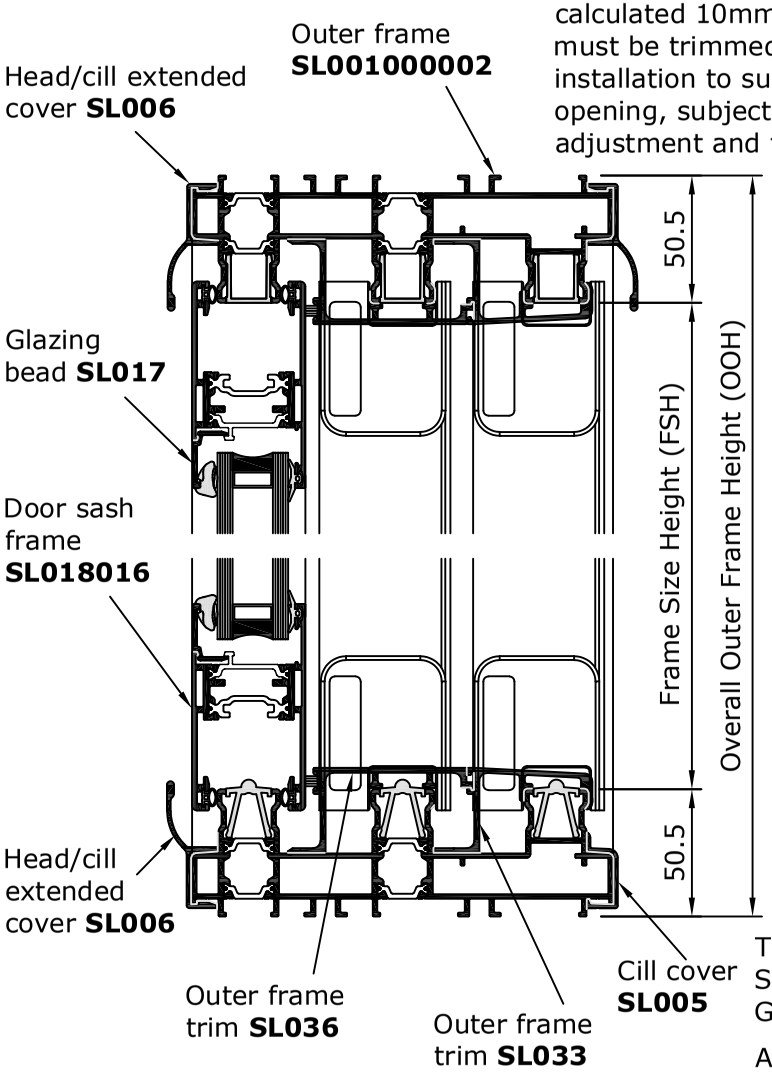
System 25 Hi/Hi+

LIFT AND SLIDE DOOR

3T



** SL033 and SL036 have been calculated 10mm oversize, and must be trimmed on site during installation to suit resultant opening, subject to site adjustment and tolerance.



DESCRIPTION	QUANTITY	LENGTH	SECTION	PREPARATION
JAMB EXTENSION	ONE	OOH LESS 52mm	SL015015	ENDS CUT SQUARE - SEE DETAIL
OUTER FRAME AT EXTENSION SIDE (HEAD)	ONE	FS1 plus 42.5mm	SL001000002	SQUARE / 45° MITRE
OUTER FRAME AT EXTENSION SIDE (CILL)	ONE	FS1 plus 42.5mm	SL001000002	45° MITRE / SQUARE
OUTER FRAME 2 (HEAD)	ONE	FS2 less 84mm	SL001000002	ENDS CUT SQUARE
OUTER FRAME 2 (CILL)	ONE	FS2 less 84mm	SL001000002	ENDS CUT SQUARE
OUTER FRAME 3 (HEAD)	ONE	FS3 plus 8.5mm	SL001000002	SQUARE / 45° MITRE
OUTER FRAME 3 (CILL)	ONE	FS3 plus 8.5mm	SL001000002	45° MITRE / SQUARE
OUTER FRAME (JAMB)	ONE	FSH plus 101mm	SL001000002	45° MITRE BOTH ENDS
SASH FRAME 1 (HEAD/CILL)	TWO	FS1 plus 41.5mm	SL018016	45° MITRE BOTH ENDS
SASH FRAME 2 (HEAD/CILL)	TWO	FS2 plus 65.75mm	SL018016	45° MITRE BOTH ENDS
SASH FRAME 3 (HEAD/CILL)	TWO	FS3 plus 41.5mm	SL018016	45° MITRE BOTH ENDS
DOOR SASH FRAME (JAMB)	SIX	FSH plus 17mm	SL018016	45° MITRE BOTH ENDS
GLAZING BEAD 1 (HEAD/CILL)	TWO	FS1 less 84.5mm	SL017	ENDS CUT SQUARE
GLAZING BEAD 2 (HEAD/CILL)	TWO	FS2 less 60.25mm	SL017	ENDS CUT SQUARE
GLAZING BEAD 3 (HEAD/CILL)	TWO	FS3 less 84.5mm	SL017	ENDS CUT SQUARE
GLAZING BEAD (JAMB)	SIX	FSH less 147mm	SL017	ENDS CUT SQUARE
COVER FOR INTERLOCK	FOUR	FSH plus 17mm	SL012	ENDS CUT SQUARE - SEE DETAIL
HEAD/CILL EXTENDED COVER - INTERNAL	TWO	FS1 plus FS2 plus FS3 plus 39mm	SL006	ENDS CUT SQUARE
HEAD EXTENDED COVER - EXTERNAL	ONE	FS1 plus FS2 plus FS3 plus 78mm	SL006	ENDS CUT SQUARE
CILL COVER	ONE	FS1 plus FS2 plus FS3 plus 83mm	SL005	ENDS CUT SQUARE
MEETING STILE LOCKING PIECE	FOUR	FSH plus 17mm	SL021	ENDS CUT SQUARE
OUTER FRAME TRIM	TWO	FS1 plus FS2 plus 16mm**	SL033	ENDS CUT SQUARE - SEE DETAIL
OUTER FRAME TRIM	TWO	FS1 plus 16mm**	SL036	ENDS CUT SQUARE - SEE DETAIL
GLASS SIZE 1	ONE	FSH less 119mm; FS1 less 94.5mm		
GLASS SIZE 2	ONE	FSH less 119mm; FS2 less 70.25mm		
GLASS SIZE 3	ONE	FSH less 119mm; FS3 less 94.5mm		

The above cutting dimensions allow the fabricator to determine unequal sash widths. For equal widths:
Sash = (Overall width plus 13.5mm) / 3
Glass = Sash width - 136mm

Attention should be paid to the orientation of the thermal break in relation to the straight and mitred corner cuts. Refer to "Handing of Outer Frame Profiles" sheet.

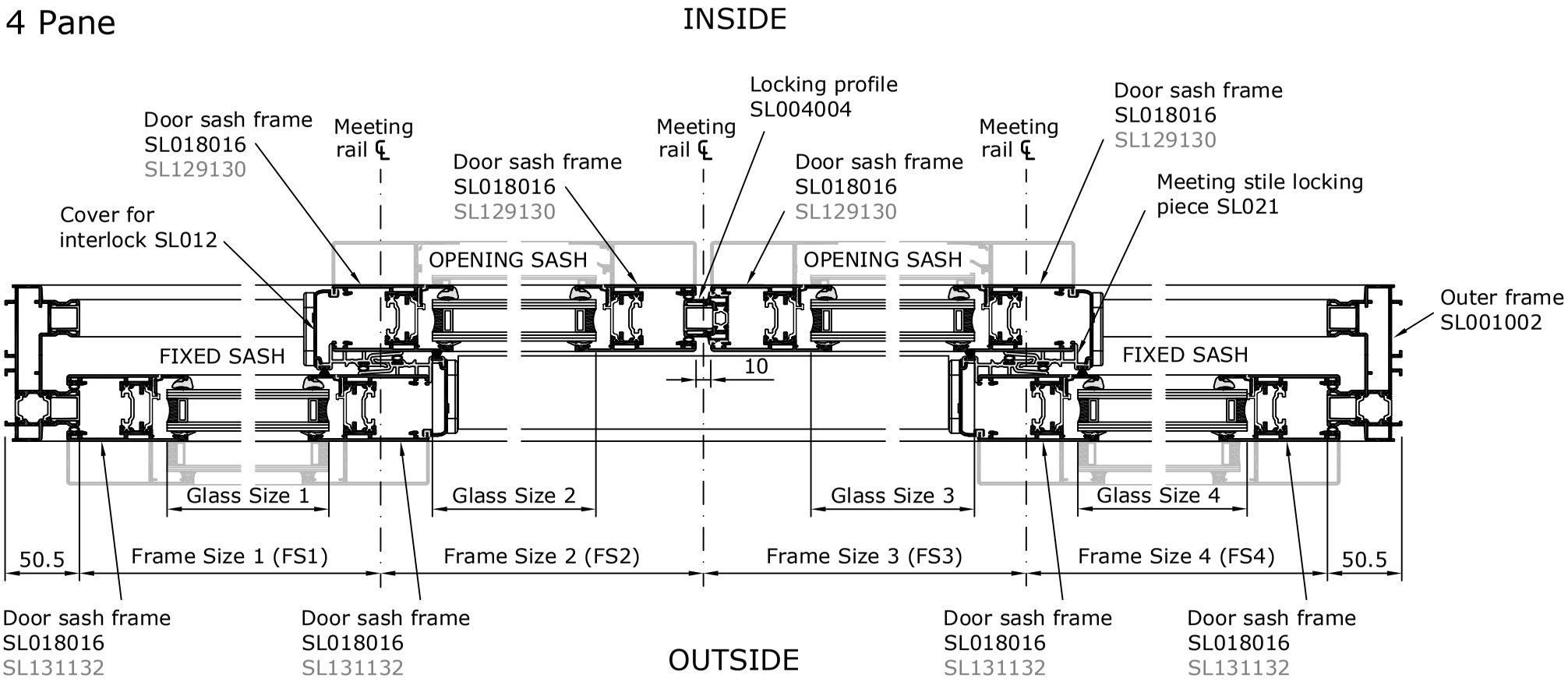
All bead lengths are tight sizes. Clearance of not more than 0.5mm should be allowed at each end of the glazing bead.

Not to Scale

Bar Cutting Sizes

All cutting sizes in this range are calculated from the Frame Sizes (FS) as illustrated below.

4 Pane



Scale 1:4

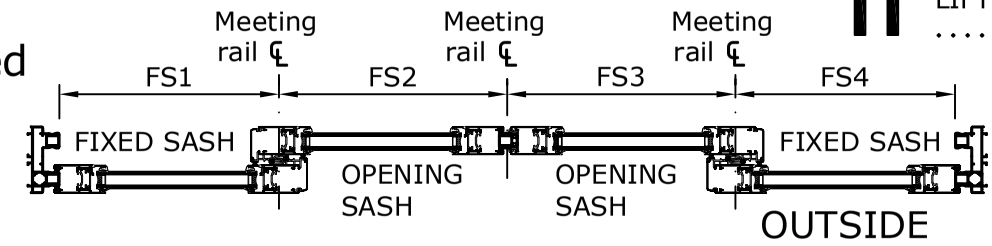
Fabrication and Cutting Sizes (4 Pane) - Sash
SL018016

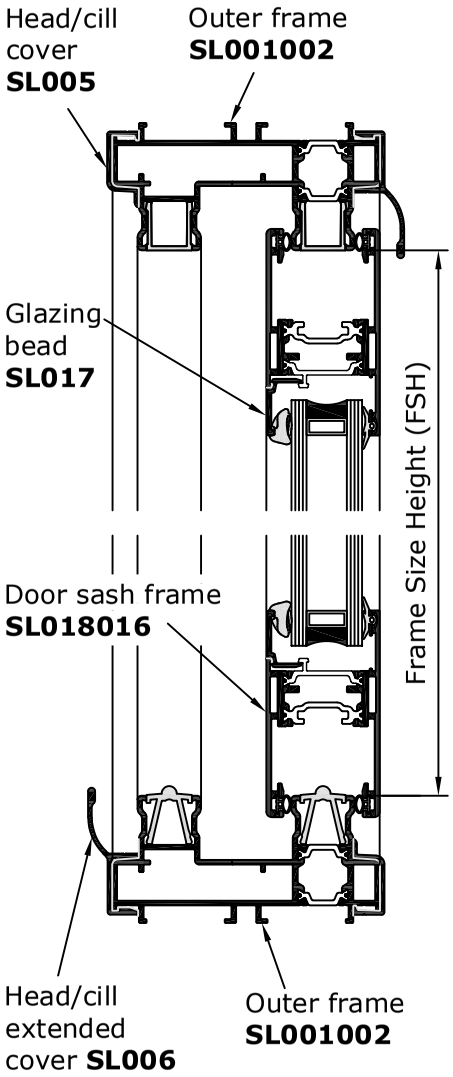
2 Pane Lift and Slide / 2 Pane Fixed

System 25 Hi/Hi+

LIFT AND SLIDE DOOR

2T





DESCRIPTION	QUANTITY	LENGTH	SECTION	PREPARATION
OUTER FRAME 1 (HEAD)	ONE	FS1 PLUS 13.5mm	SL001002	SQUARE / 45° MITRE
OUTER FRAME 1 (CILL)	ONE	FS1 PLUS 13.5mm	SL001002	45° MITRE / SQUARE
OUTER FRAME 2 (HEAD)	ONE	FS2 PLUS FS3 LESS 74mm	SL001002	ENDS CUT SQUARE
OUTER FRAME 2 (CILL)	ONE	FS2 PLUS FS3 LESS 74mm	SL001002	ENDS CUT SQUARE
OUTER FRAME 3 (HEAD)	ONE	FS4 PLUS 13.5mm	SL001002	SQUARE / 45° MITRE
OUTER FRAME 3 (CILL)	ONE	FS4 PLUS 13.5mm	SL001002	45° MITRE / SQUARE
OUTER FRAME (JAMB)	TWO	FSH PLUS 101mm	SL001002	45° MITRE BOTH ENDS
FIXED SASH FRAME 1 (HEAD/CILL)	TWO	FS1 PLUS 41.5mm	SL018016	45° MITRE BOTH ENDS
FIXED SASH FRAME 2 (HEAD/CILL)	TWO	FS4 PLUS 41.5mm	SL018016	45° MITRE BOTH ENDS
OPENING SASH FRAME 1 (HEAD/CILL)	TWO	FS2 PLUS 28mm	SL018016	45° MITRE BOTH ENDS
OPENING SASH FRAME 2 (HEAD/CILL)	TWO	FS3 PLUS 28mm	SL018016	45° MITRE BOTH ENDS
DOOR SASH FRAME (JAMB)	EIGHT	FSH PLUS 17mm	SL018016	45° MITRE BOTH ENDS
FIXED SASH BEAD 1 (HEAD/CILL)	TWO	FS1 LESS 84.5mm	SL017	ENDS CUT SQUARE
FIXED SASH BEAD 2 (HEAD/CILL)	TWO	FS4 LESS 84.5mm	SL017	ENDS CUT SQUARE
OPENING SASH BEAD 1 (HEAD/CILL)	TWO	FS2 LESS 98mm	SL017	ENDS CUT SQUARE
OPENING SASH BEAD 2 (HEAD/CILL)	TWO	FS3 LESS 98mm	SL017	ENDS CUT SQUARE
GLAZING BEAD (JAMB)	EIGHT	FSH LESS 147mm	SL017	ENDS CUT SQUARE
COVER FOR INTERLOCK	FOUR	FSH PLUS 17mm	SL012	ENDS CUT SQUARE - SEE DETAIL
HEAD/CILL EXTENDED COVER	TWO	FS1 PLUS FS2 PLUS FS3 PLUS FS4 PLUS 44mm	SL006	ENDS CUT SQUARE
HEAD/CILL COVER	TWO	FS1 PLUS FS2 PLUS FS3 PLUS FS4 PLUS 49mm	SL005	ENDS CUT SQUARE
MEETING STILE LOCKING PIECE	FOUR	FSH PLUS 17mm	SL021	ENDS CUT SQUARE
LOCKING PROFILE	ONE	FSH LESS 67mm	SL004004	ENDS CUT SQUARE
OUTER FRAME TRIM	TWO	FS2 PLUS FS3 LESS 95mm*	SL033	ENDS CUT SQUARE - SEE DETAIL
GLASS SIZE - FIXED SASH 1	ONE	FSH LESS 119mm FS1 LESS 94.5mm		
GLASS SIZE - FIXED SASH 2	ONE	FSH LESS 119mm FS4 LESS 94.5mm		
GLASS SIZE - OPENING SASH 1	ONE	FSH LESS 119mm FS2 LESS 108mm		
GLASS SIZE - OPENING SASH 2	ONE	FSH LESS 119mm FS3 LESS 108mm		

*SL033 has been calculated 10mm oversize, and must be trimmed on site during installation to suit resultant opening, subject to site adjustment and tolerance.

The above cutting dimensions allow the fabricator to determine unequal sash widths. For equal widths:

$$\text{Sash} = \frac{\text{Overall width} + 38\text{mm}}{4}$$

Glass = Sash width - 136mm

Attention should be paid to the orientation of the thermal break in relation to the straight and mitred corner cuts. Refer to "Handing of Outer Frame Profiles" sheet.

All bead lengths are tight sizes. Clearance of not more than 0.5mm should be allowed at each end of the glazing bead.

Not to Scale

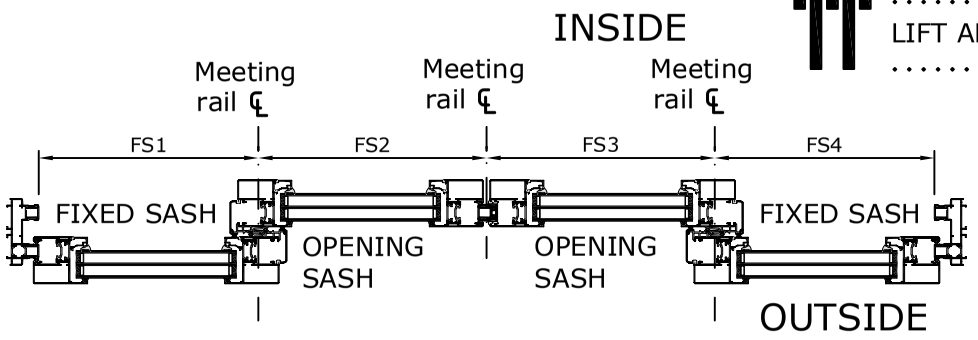
Fabrication and Cutting Sizes (4 Pane) - Sashes
SL129130/SL131132

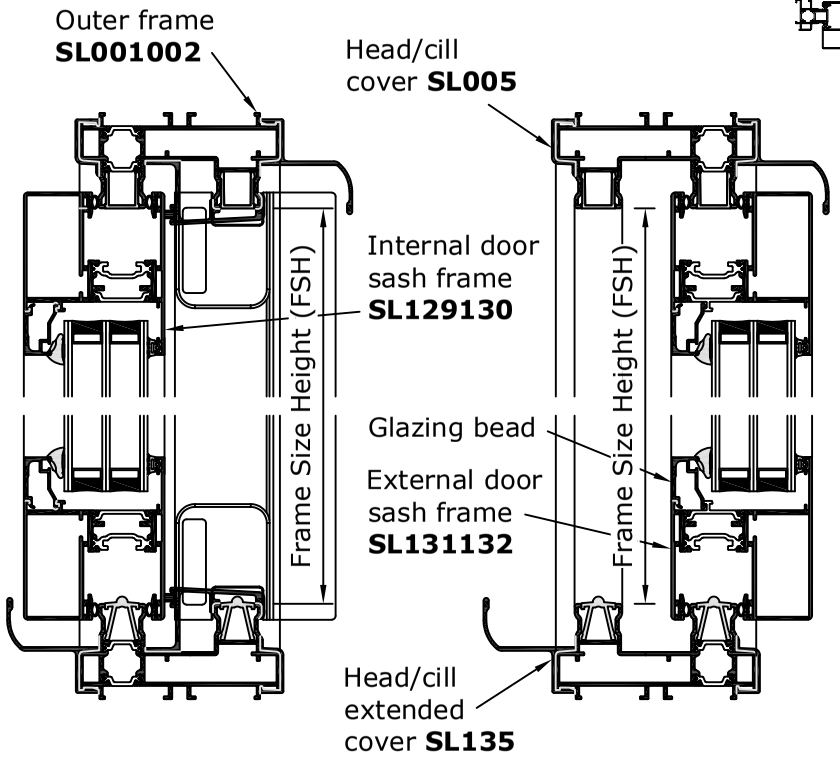
2 Pane Lift and Slide / 2 Pane Fixed

System 25 Hi/Hi+

LIFT AND SLIDE DOOR

2T





DESCRIPTION	QUANTITY	LENGTH	SECTION	PREPARATION
OUTER FRAME 1 (HEAD)	ONE	FS1 plus 13.5mm	SL001002	SQUARE / 45° MITRE
OUTER FRAME 1 (CILL)	ONE	FS1 plus 13.5mm	SL001002	45° MITRE / SQUARE
OUTER FRAME 2 (HEAD)	ONE	FS2 plus FS3 less 74mm	SL001002	ENDS CUT SQUARE
OUTER FRAME 2 (CILL)	ONE	FS2 plus FS3 less 74mm	SL001002	ENDS CUT SQUARE
OUTER FRAME 3 (HEAD)	ONE	FS4 plus 13.5mm	SL001002	SQUARE / 45° MITRE
OUTER FRAME 3 (CILL)	ONE	FS4 plus 13.5mm	SL001002	45° MITRE / SQUARE
OUTER FRAME (JAMB)	TWO	FSH plus 101mm	SL001002	45° MITRE BOTH ENDS
FIXED SASH FRAME 1 (HEAD/CILL)	TWO	FS1 plus 41.5mm	SL131132	45° MITRE BOTH ENDS
FIXED SASH FRAME 2 (HEAD/CILL)	TWO	FS4 plus 41.5mm	SL131132	45° MITRE BOTH ENDS
OPENING SASH FRAME 1 (HEAD/CILL)	TWO	FS2 plus 28mm	SL129130	45° MITRE BOTH ENDS
OPENING SASH FRAME 2 (HEAD/CILL)	TWO	FS3 plus 28mm	SL129130	45° MITRE BOTH ENDS
DOOR SASH FRAME (JAMB)	FOUR	FSH plus 17mm	SL129130	45° MITRE BOTH ENDS
DOOR SASH FRAME (JAMB)	FOUR	FSH plus 17mm	SL131132	45° MITRE BOTH ENDS
FIXED SASH BEAD 1 (HEAD/CILL)	TWO	FS1 less 84.5mm	VARIOUS	ENDS CUT SQUARE
FIXED SASH BEAD 2 (HEAD/CILL)	TWO	FS4 less 84.5mm	VARIOUS	ENDS CUT SQUARE
OPENING SASH BEAD 1 (HEAD/CILL)	TWO	FS2 less 98mm	VARIOUS	ENDS CUT SQUARE
OPENING SASH BEAD 2 (HEAD/CILL)	TWO	FS3 less 98mm	VARIOUS	ENDS CUT SQUARE
GLAZING BEAD (JAMB)	EIGHT	FSH less 155mm	VARIOUS	ENDS CUT SQUARE
COVER FOR INTERLOCK	FOUR	FSH plus 17mm	SL012	ENDS CUT SQUARE - SEE DETAIL
HEAD/CILL EXTENDED COVER	TWO	FS1 plus FS2 plus FS3 plus FS4 plus 44mm	SL135	ENDS CUT SQUARE
HEAD/CILL COVER	TWO	FS1 plus FS2 plus FS3 plus FS4 plus 49mm	SL005	ENDS CUT SQUARE
MEETING STILE LOCKING PIECE	FOUR	FSH plus 17mm	SL021	ENDS CUT SQUARE
LOCKING PROFILE	ONE	FSH less 67mm	SL004004	ENDS CUT SQUARE
OUTER FRAME TRIM	TWO	FS2 plus FS3 less 95mm*	SL033	ENDS CUT SQUARE - SEE DETAIL
GLASS SIZE - FIXED SASH 1	ONE	FSH less 119mm; FS1 less 94.5mm		
GLASS SIZE - FIXED SASH 2	ONE	FSH less 119mm; FS4 less 94.5mm		
GLASS SIZE - OPENING SASH 1	ONE	FSH less 119mm; FS2 less 108mm		
GLASS SIZE - OPENING SASH 2	ONE	FSH less 119mm; FS3 less 108mm		

The above cutting dimensions allow the fabricator to determine unequal sash widths. For equal widths:

$$\text{Sash} = \frac{\text{Overall width} + 38\text{mm}}{4}$$

Glass = Sash width - 136mm

Attention should be paid to the orientation of the thermal break in relation to the straight and mitred corner cuts. Refer to "Handing of Outer Frame Profiles" sheet.

All bead lengths are tight sizes. Clearance of not more than 0.5mm should be allowed at each end of the glazing bead.

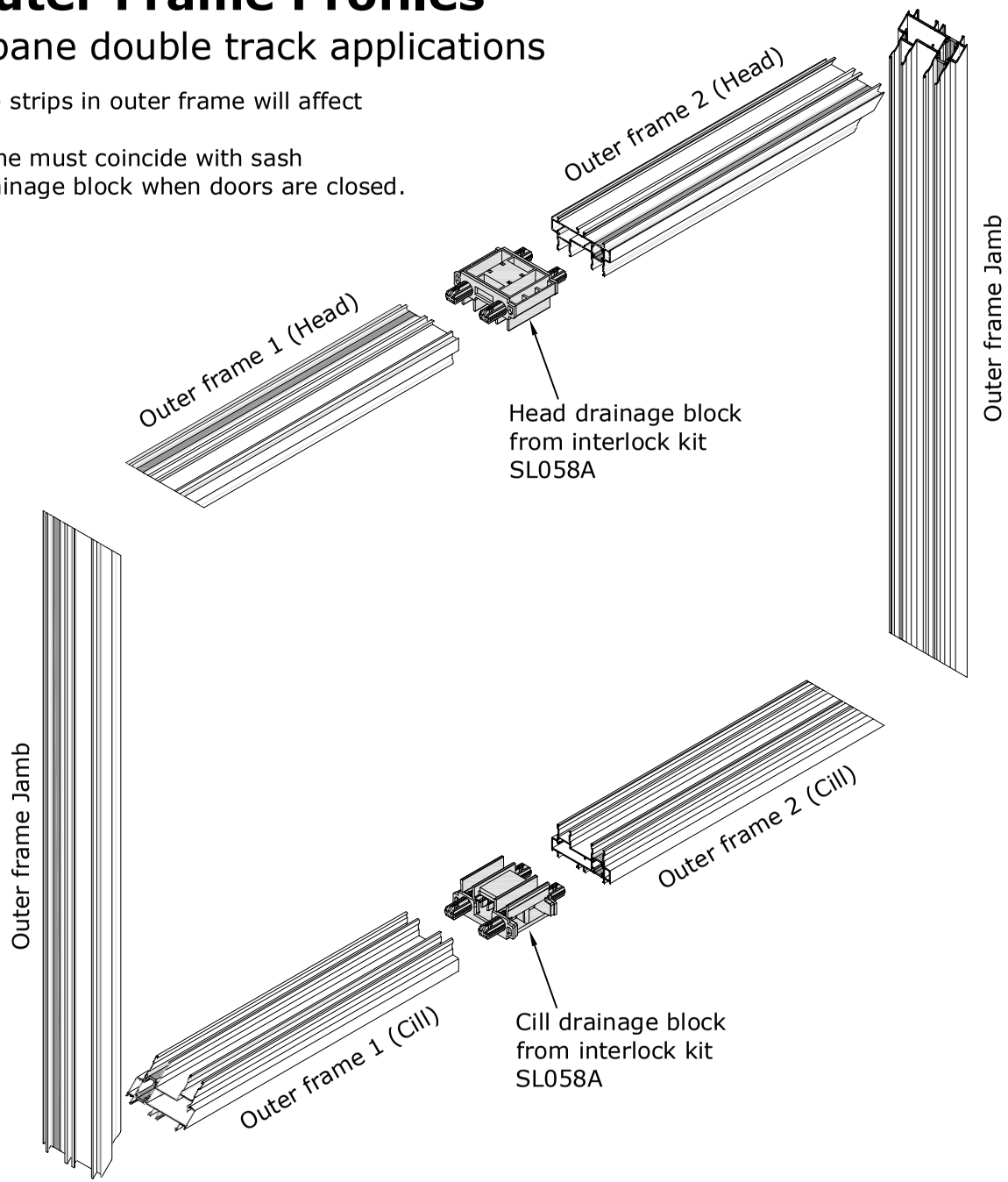
*SL033 has been calculated 10mm oversize, and must be trimmed on site during installation to suit resultant opening, subject to site adjustment and tolerance.

Scale 1:4

Handing of Outer Frame Profiles

For 2 pane and 3 pane double track applications

Note orientation of polyamide strips in outer frame will affect mitre cuts at head and cill.
Polyamide strips in outer frame must coincide with sash positions on either side of drainage block when doors are closed.

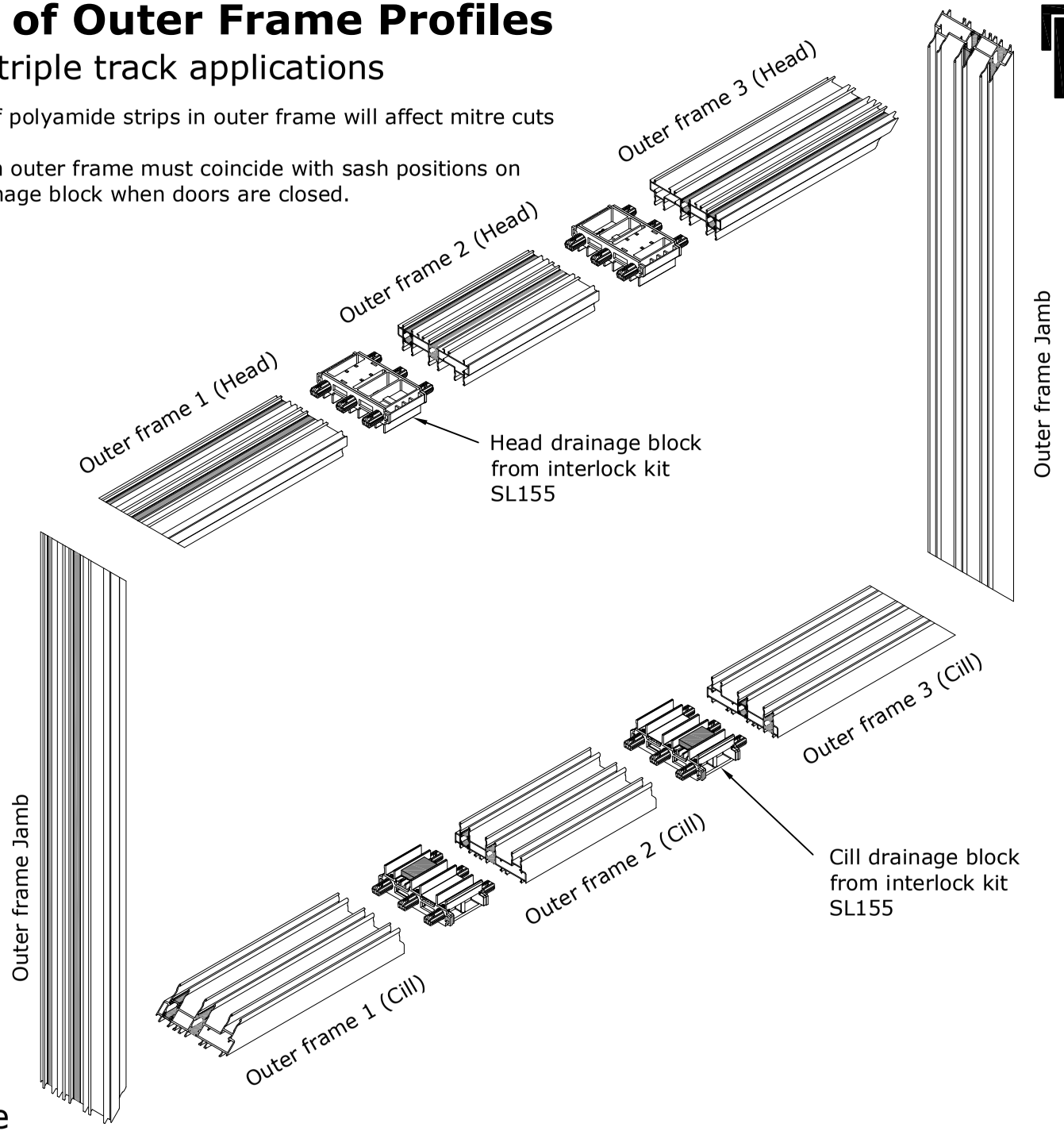


Not to Scale

Handing of Outer Frame Profiles

For 3 pane triple track applications

Note orientation of polyamide strips in outer frame will affect mitre cuts at head and cill.
Polyamide strips in outer frame must coincide with sash positions on either side of drainage block when doors are closed.

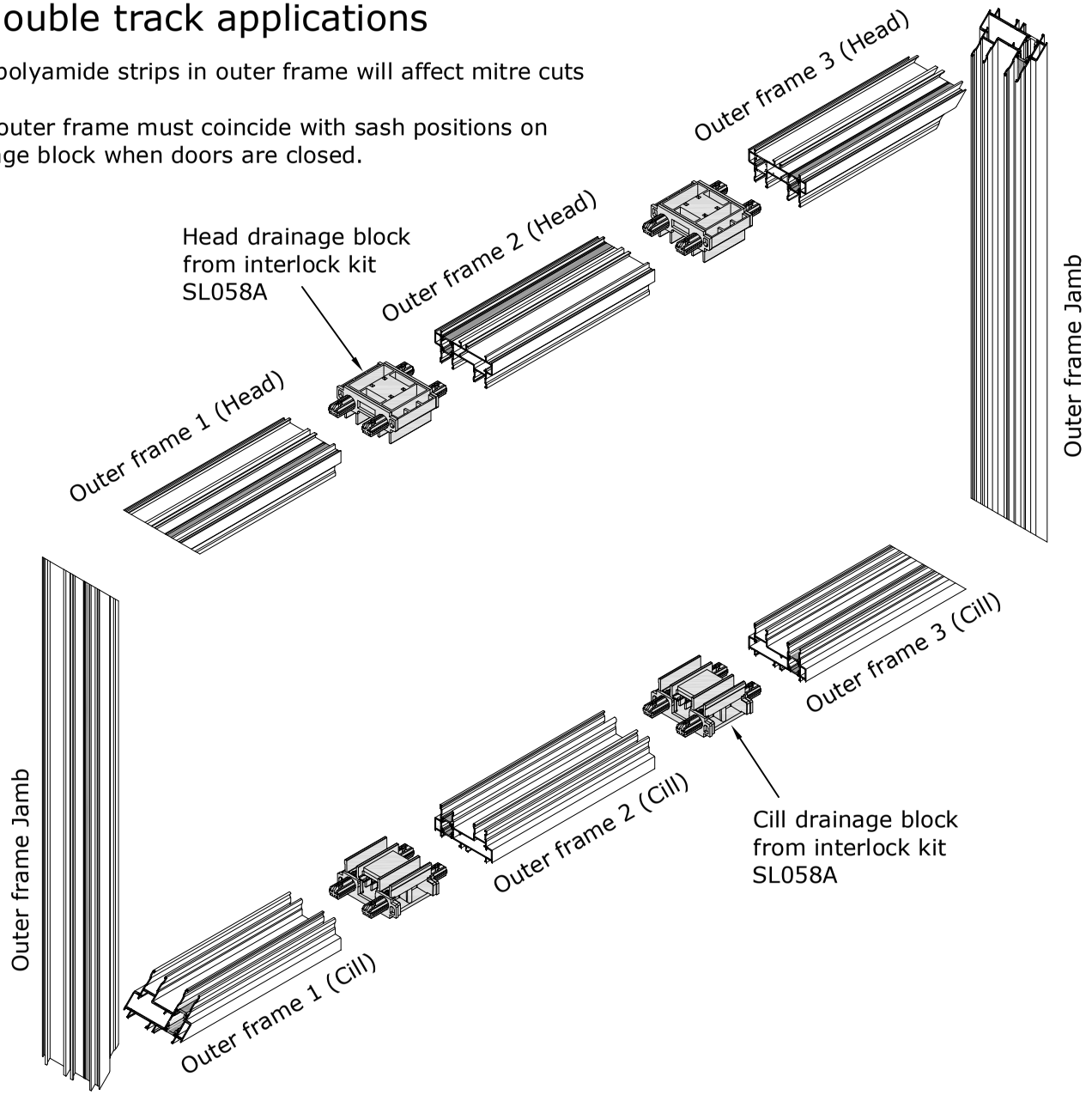


Not to Scale

Handing of Outer Frame Profiles

For 4 pane double track applications

Note orientation of polyamide strips in outer frame will affect mitre cuts at head and cill.
Polyamide strips in outer frame must coincide with sash positions on either side of drainage block when doors are closed.

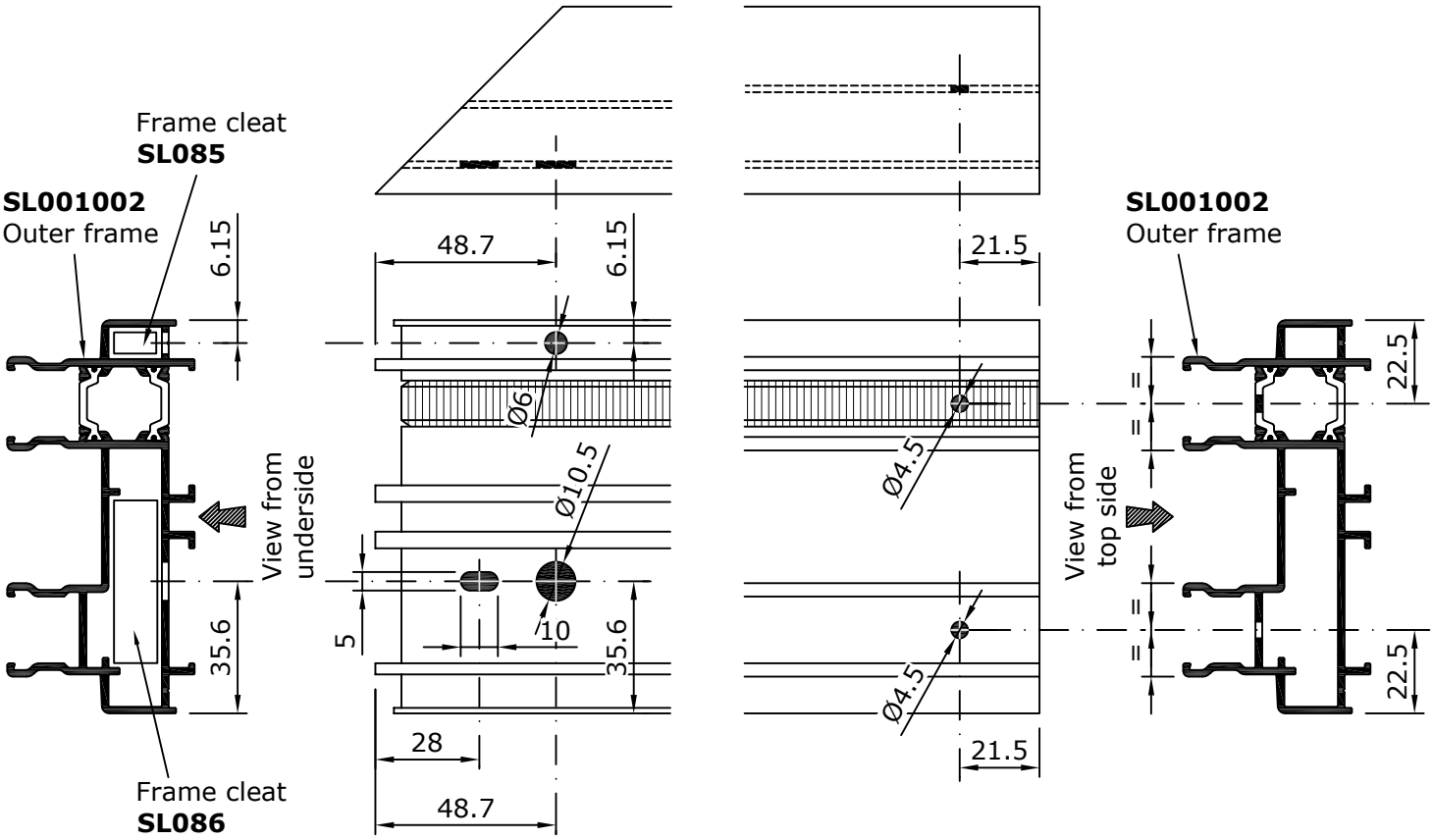


Not to Scale

SL001002 Outer Frame Prep Details

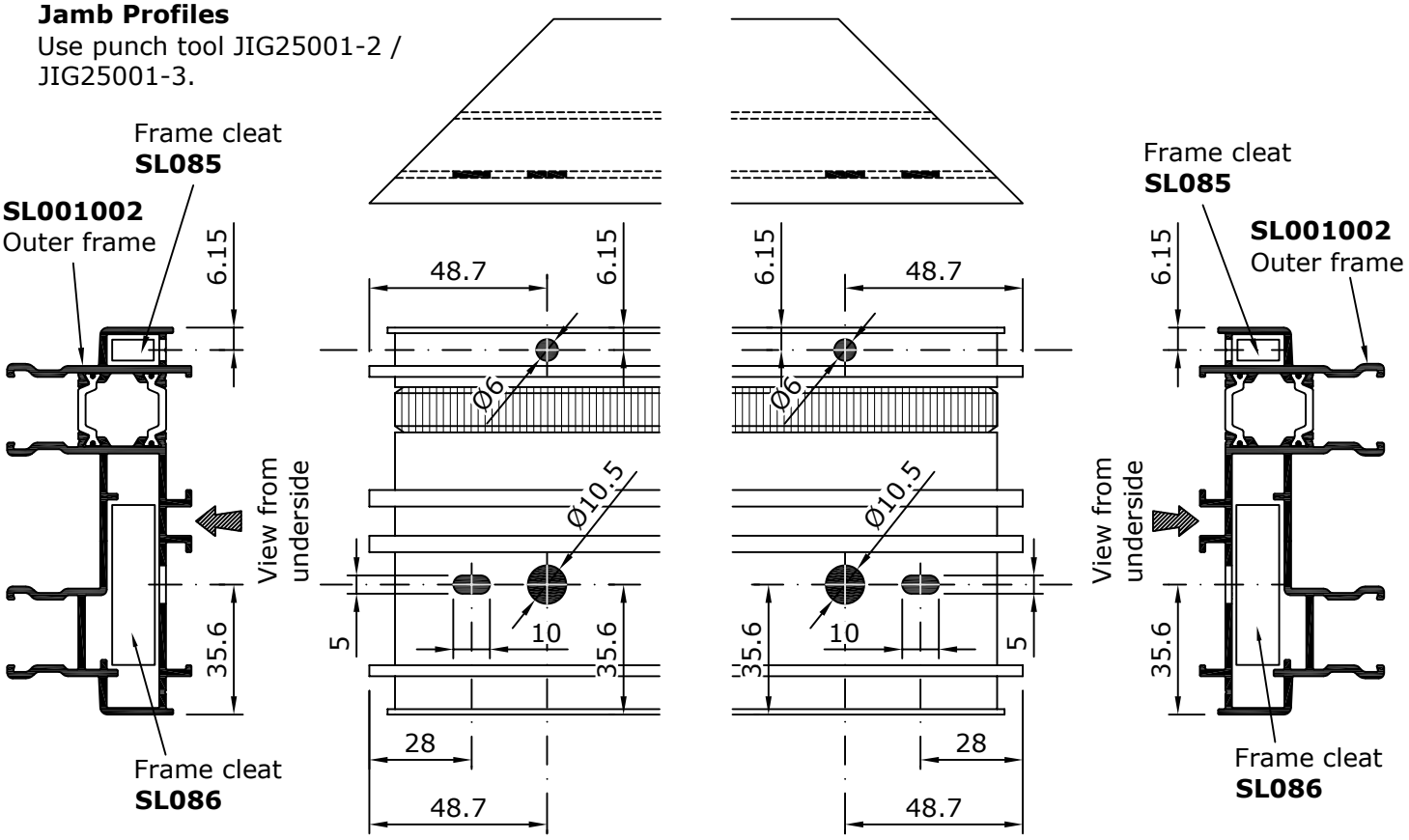
Head and Cill Profiles

Fabricator to be aware that head and cill profiles are handed and to prep accordingly, relative to opening sash. Use punch tool JIG25001-2 / JIG25001-3.



Jamb Profiles

Use punch tool JIG25001-2 / JIG25001-3.



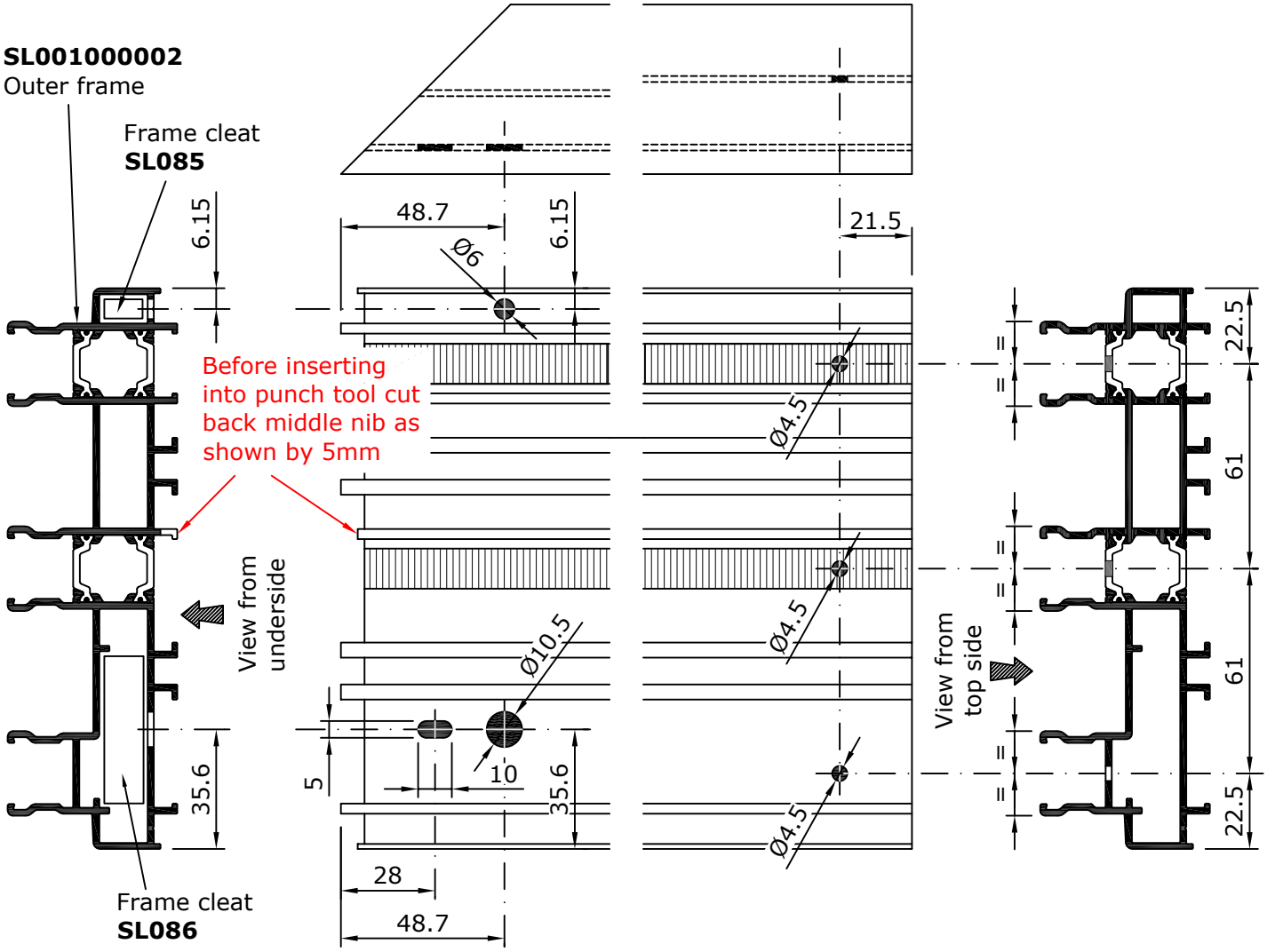
Scale 1:2

SL001000002 Triple Track Outer Frame Prep Details

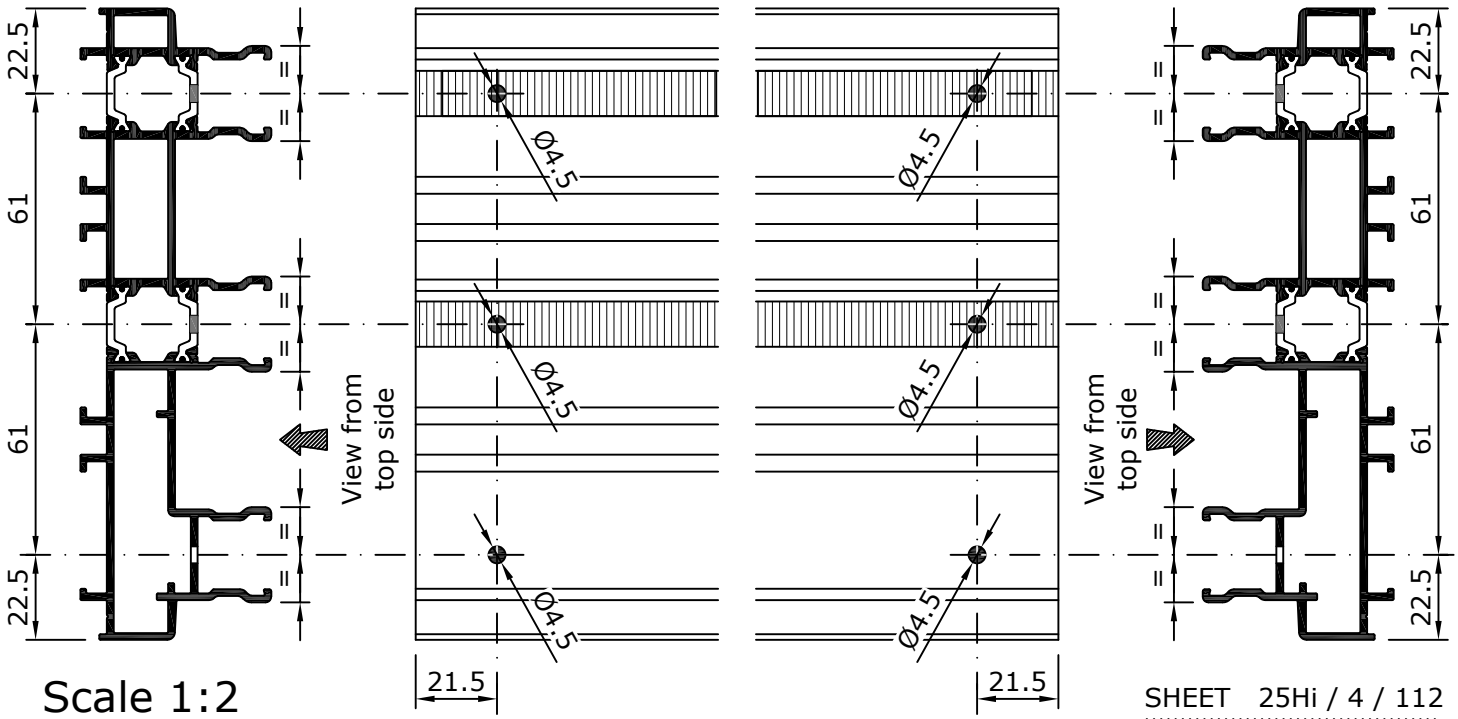
System 25 Hi/Hi+
LIFT AND SLIDE DOOR

Fabricator to be aware that head and cill profiles are handed and to prep accordingly, relative to opening sash. Use punch tool JIG25001-3.

Head and Cill Profiles at Mitred Corners (Outer frames 1 and Outer frames 3)



Head and Cill Middle Profiles (Outer frames 2)

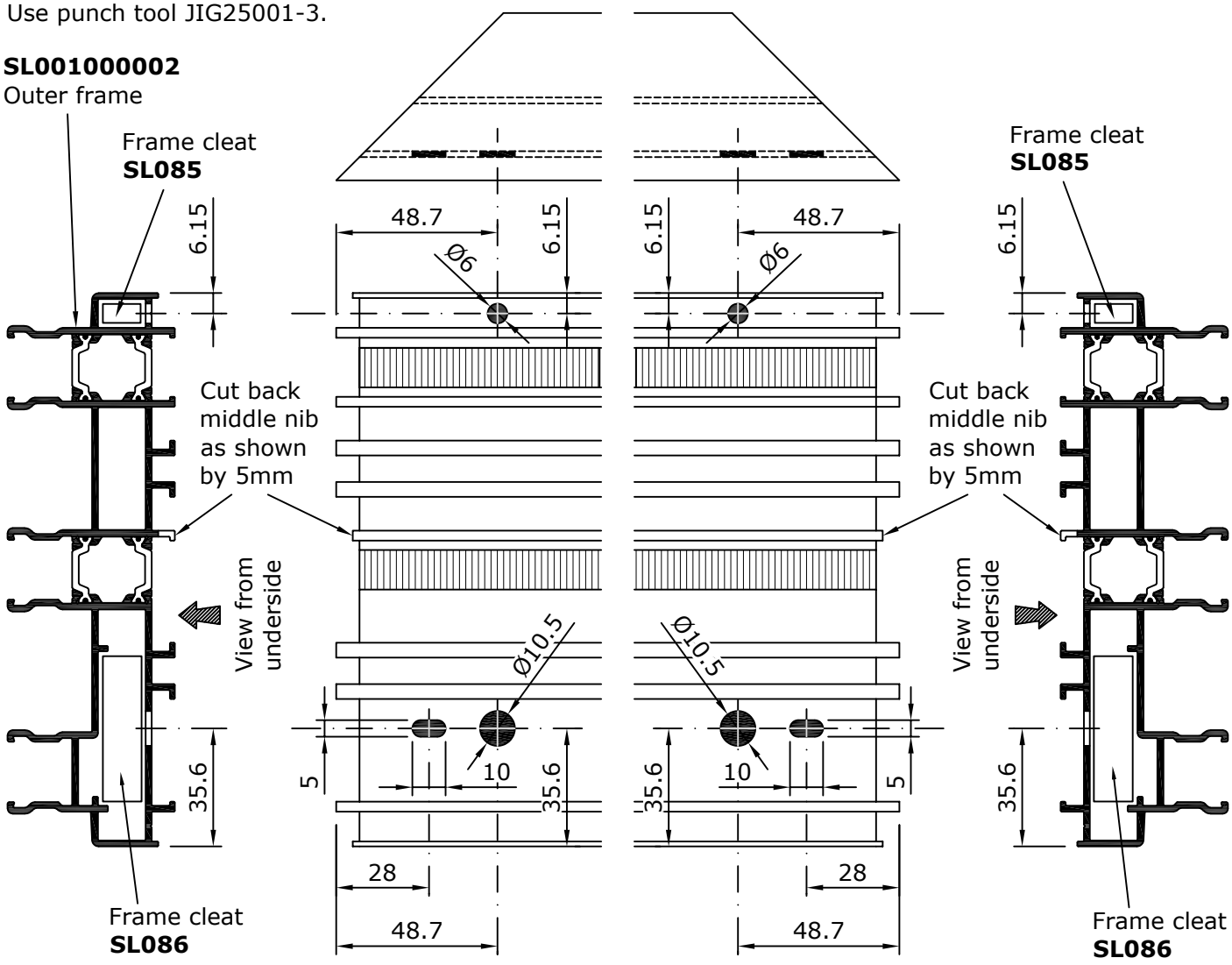


Scale 1:2

SL001000002 Triple Track Outer Frame Prep Details

Jamb Profiles
Use punch tool JIG25001-3.

SL001000002
Outer frame



Scale 1:2

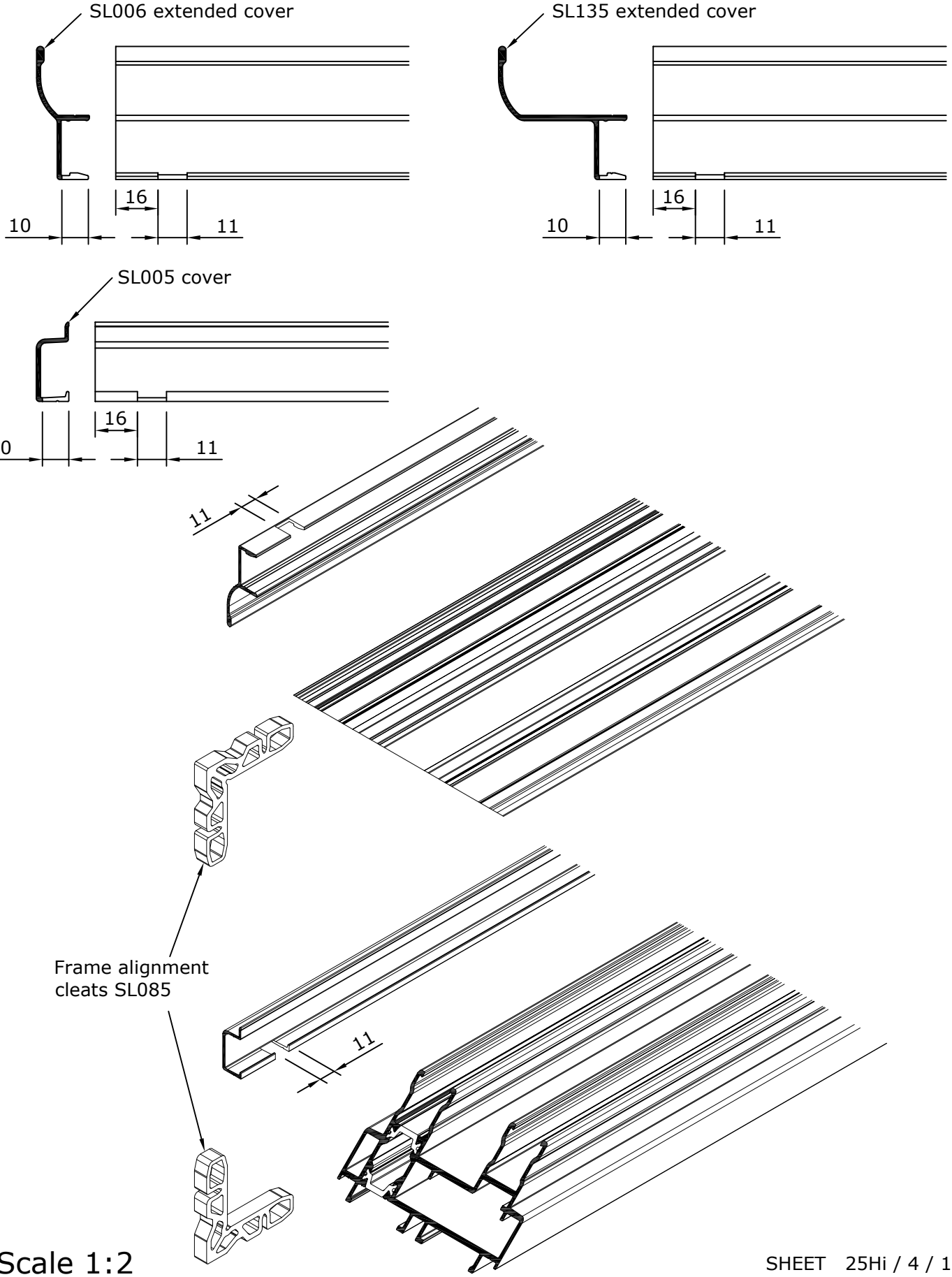
SL005, SL006/SL135 Cover Prep Details

System 25 Hi/Hi+

LIFT AND SLIDE DOOR

2T 3T

Fabricator to notch the ends of covers SL005, SL006/SL135 to access the fixing hole for the SL085 frame cleat. (Notch may be omitted if fabricator screw fixes SL085 frame cleat to head and cill outer frame profiles prior to fixing cover trims in place)



Scale 1:2

SL018016 Sash Prep Details

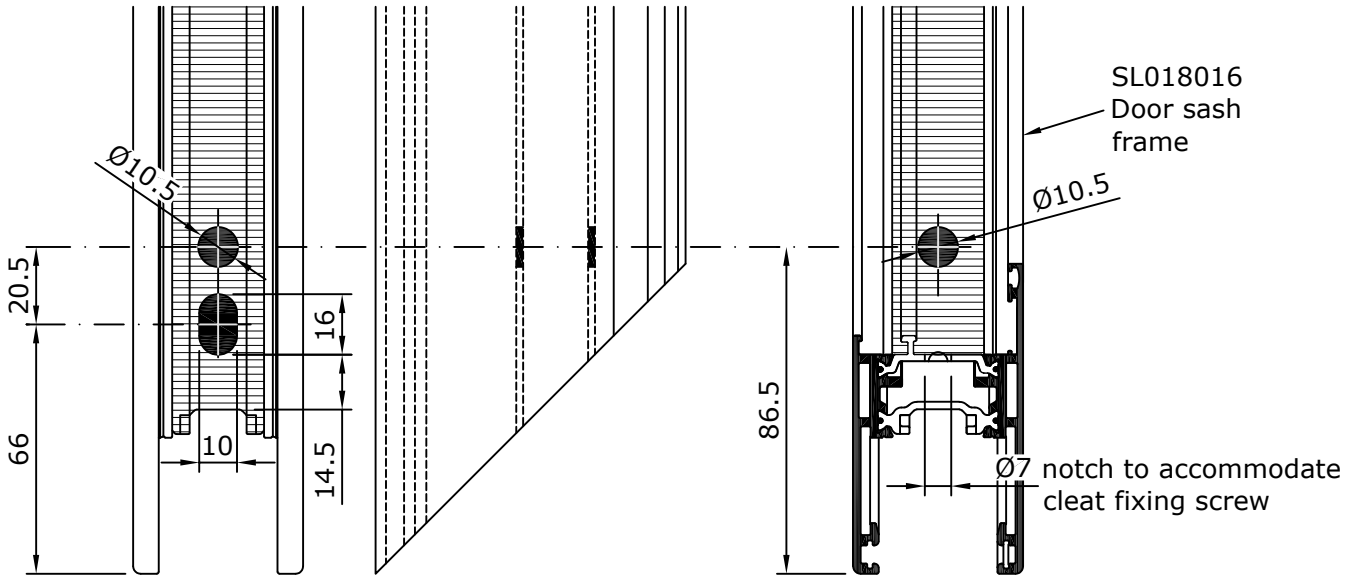
System 25 Hi/Hi+

LIFT AND SLIDE DOOR

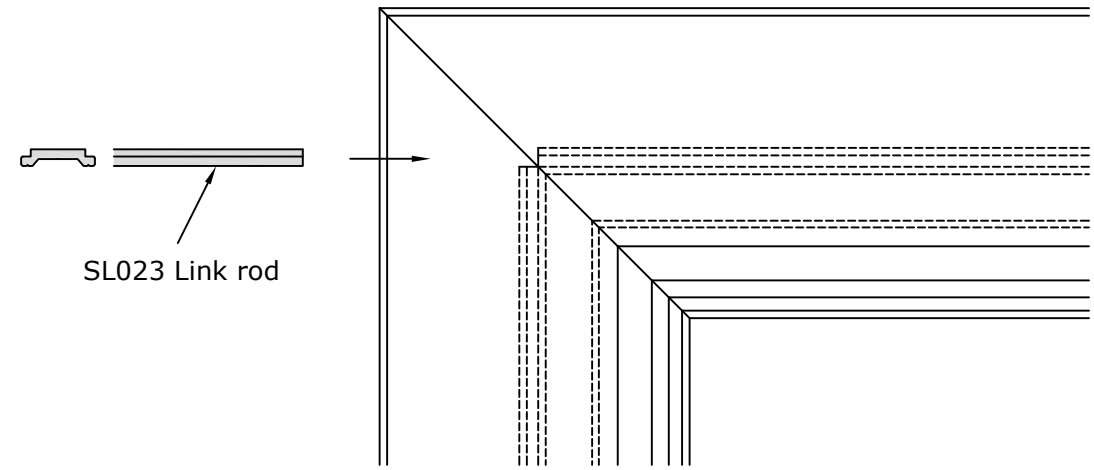
2T 3T

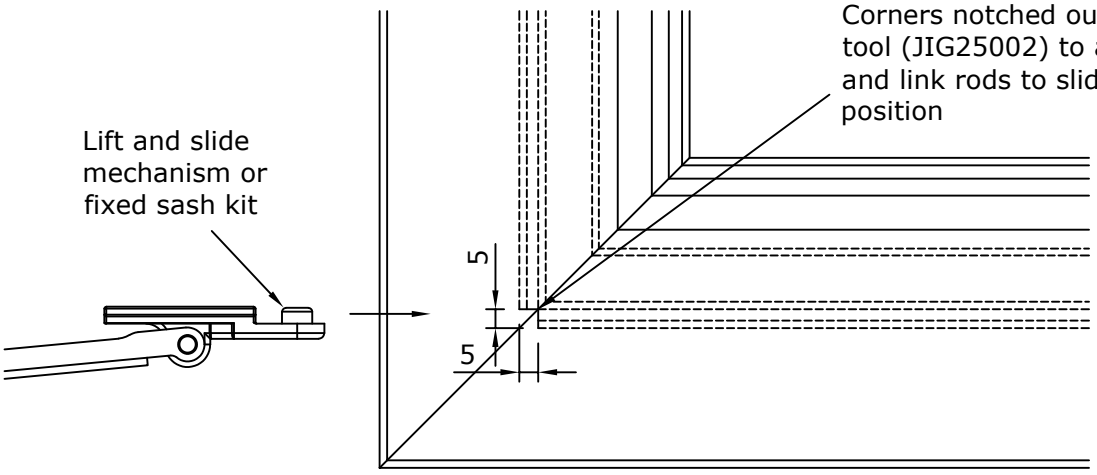
Metal Technology recommends that all four corners of all opening and fixed sashes are prepped as shown.

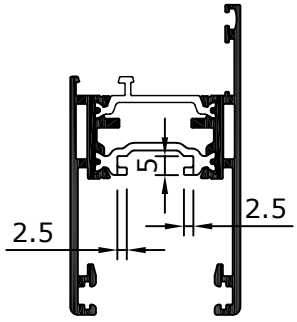
Slots for SL084 mechanical cleat (Punch tool ref JIG25002)



Slots for link rod / gearing







Door sash frame
SL018016

Scale 1:2

SL129130 Sash Prep Details

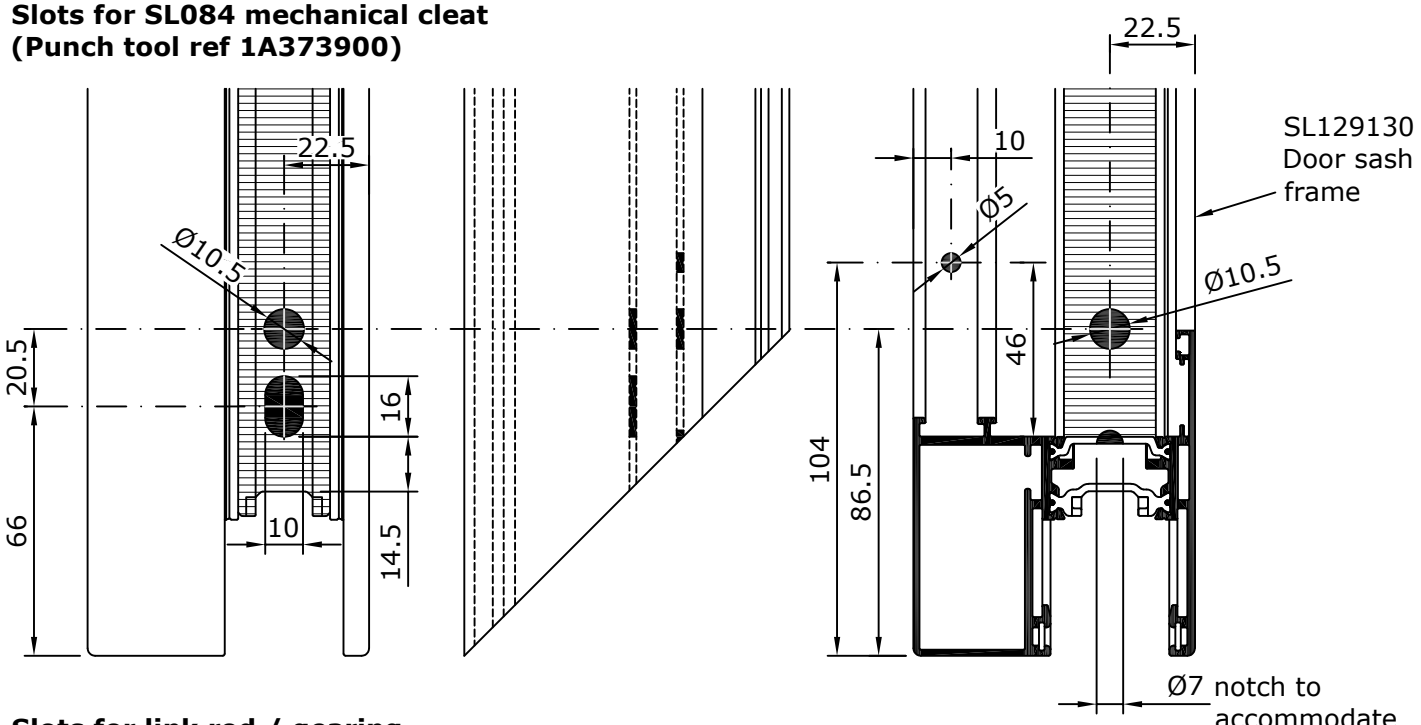
System 25 Hi/Hi+

LIFT AND SLIDE DOOR

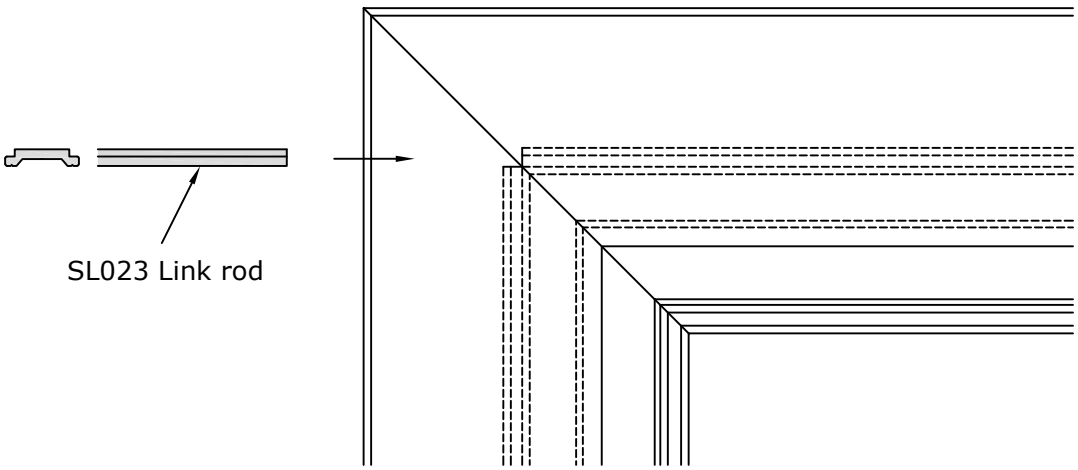
2T

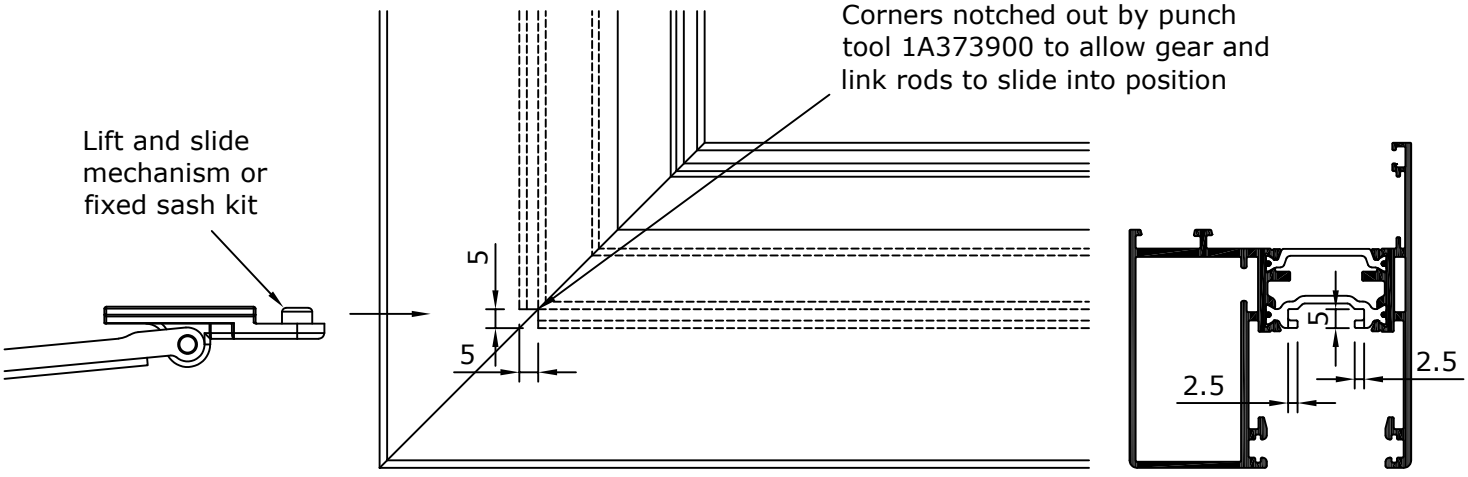
Metal Technology recommends that all four corners of all opening and fixed sashes are prepped as shown.

Slots for SL084 mechanical cleat (Punch tool ref 1A373900)



Slots for link rod / gearing





Door sash frame
SL129130

Scale 1:2

SL131132 Sash Prep Details

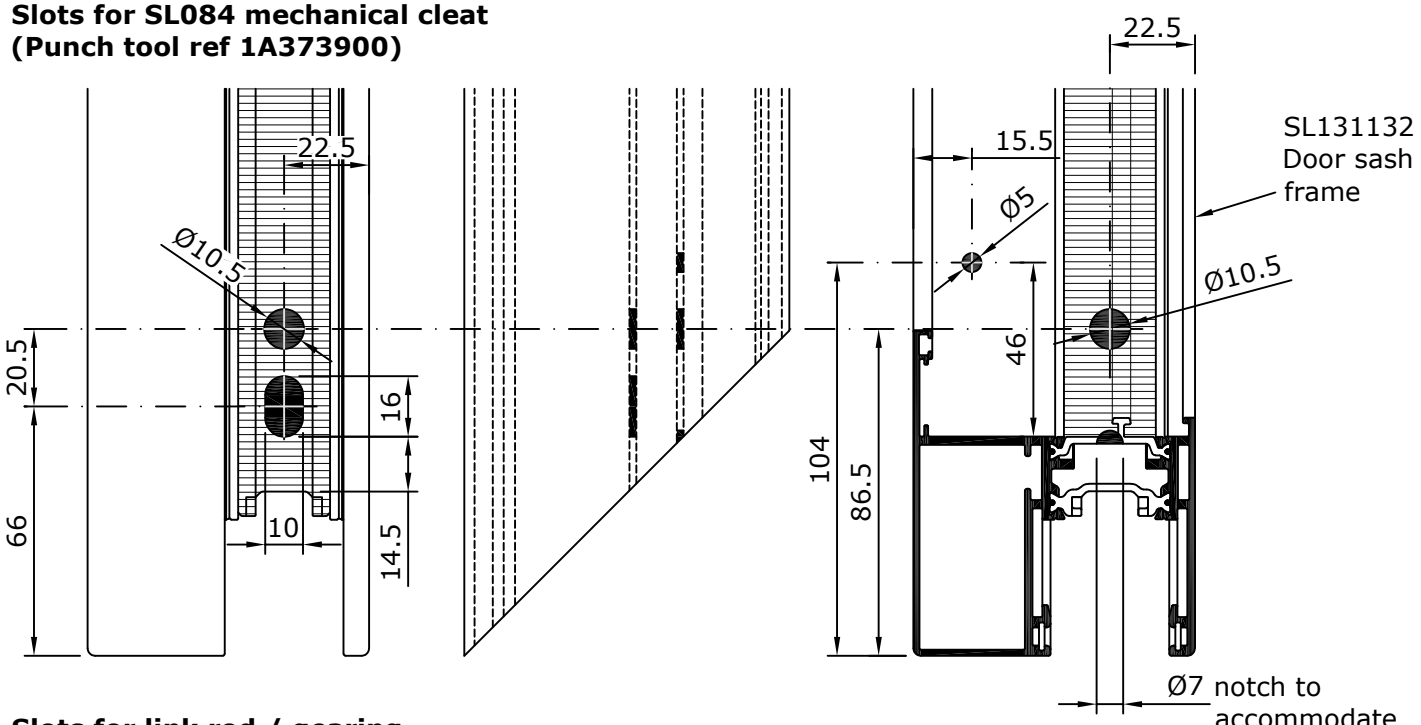
System 25 Hi/Hi+

LIFT AND SLIDE DOOR

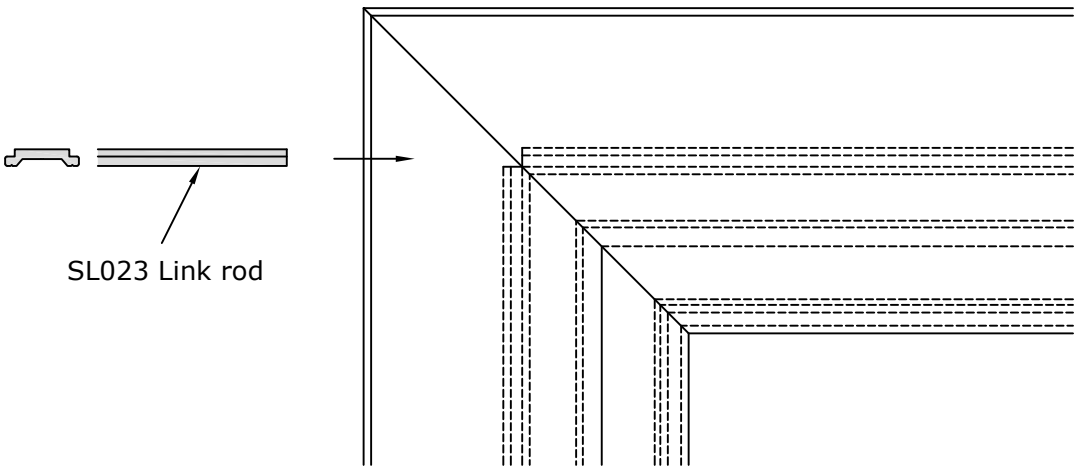
2T

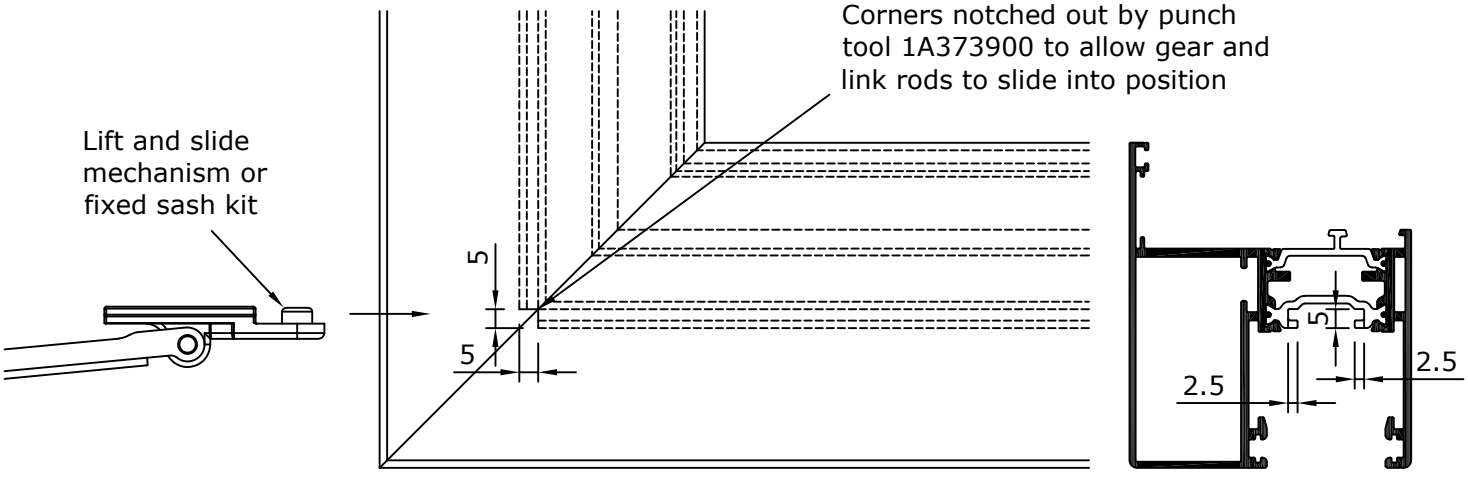
Metal Technology recommends that all four corners of all opening and fixed sashes are prepped as shown.

Slots for SL084 mechanical cleat (Punch tool ref 1A373900)



Slots for link rod / gearing





Door sash frame
SL131132

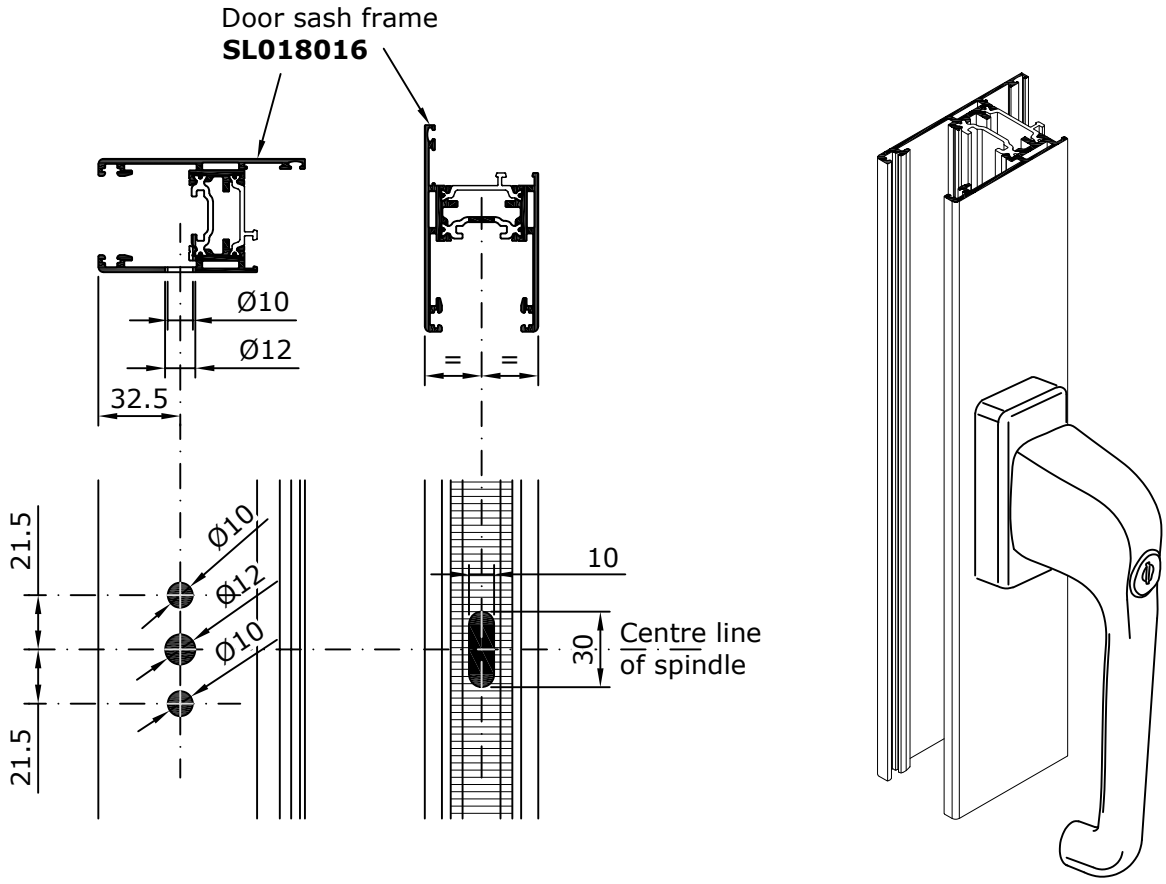
Scale 1:2

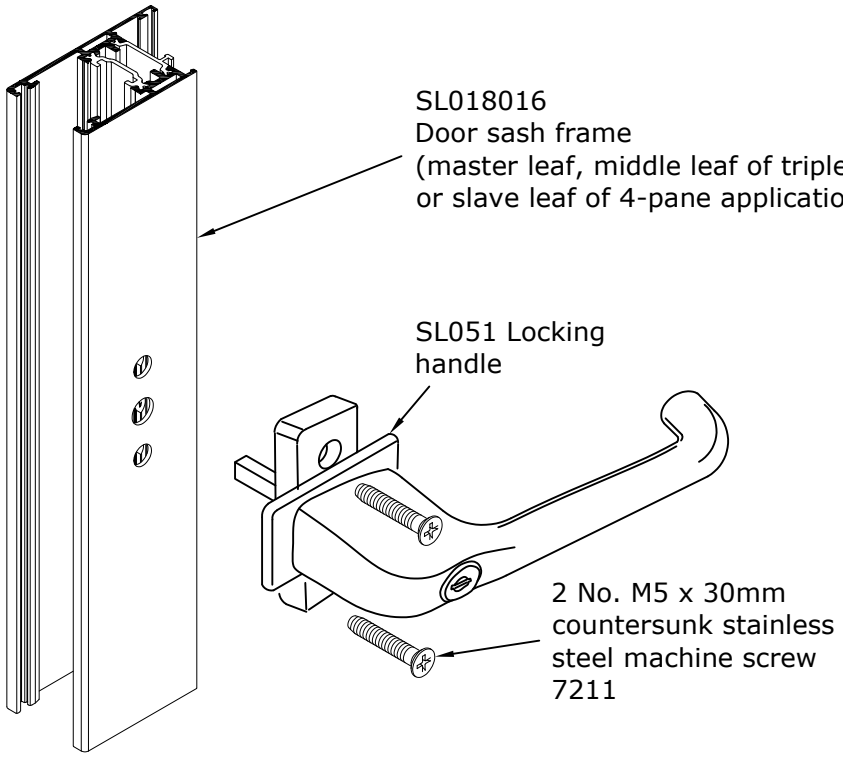
Sash Prep Details

SL051 Locking Handle

SL051 locking handle must be used when internal locking only is required.

Refer to "Link Rod Details" sheets in Section 3 of this manual for handle position.





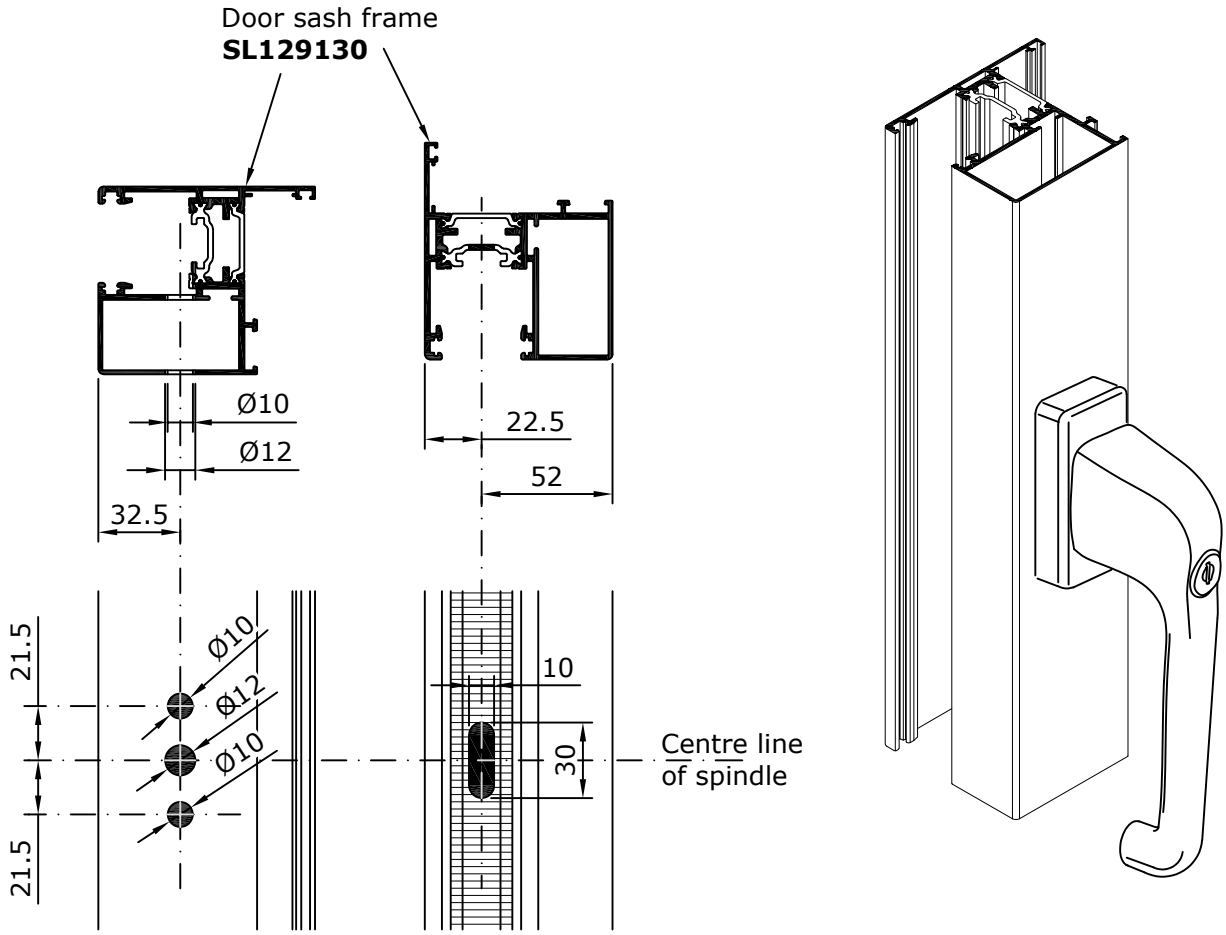
Scale 1:3

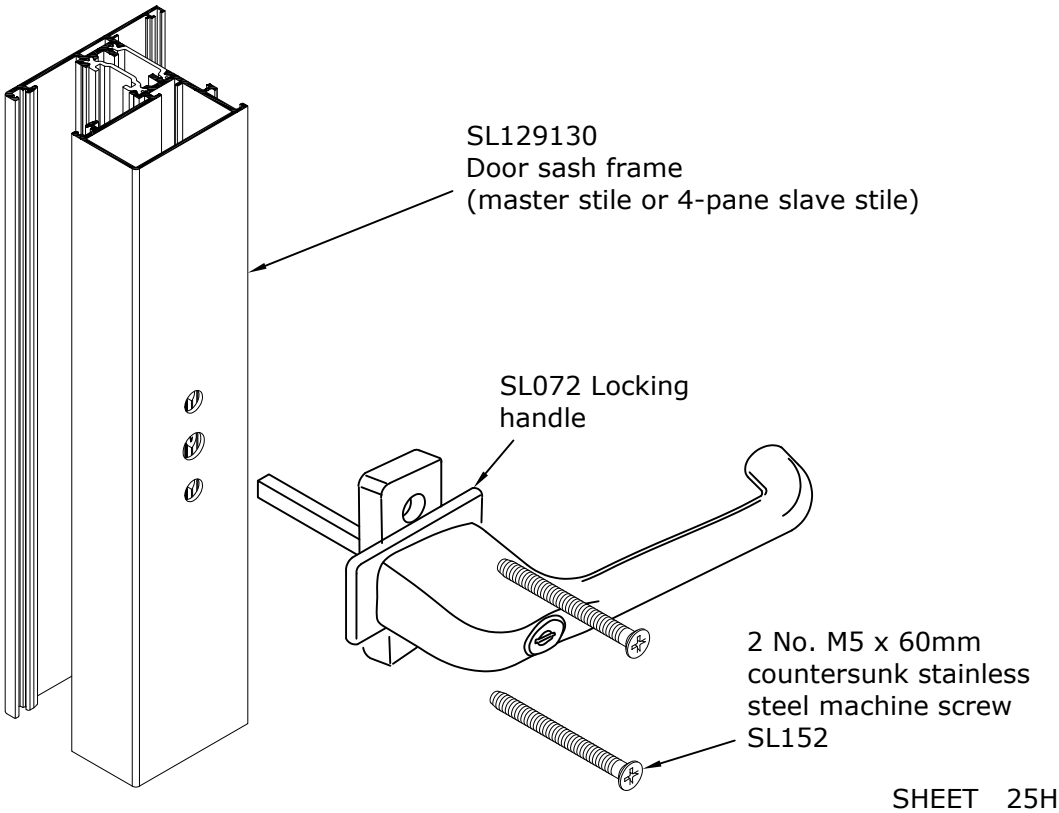
Sash Prep Details

SL072 Locking Handle

SL072 locking handle must be used when internal locking only is required.

Refer to "Link Rod Details" sheets in Section 3 of this manual for handle position.





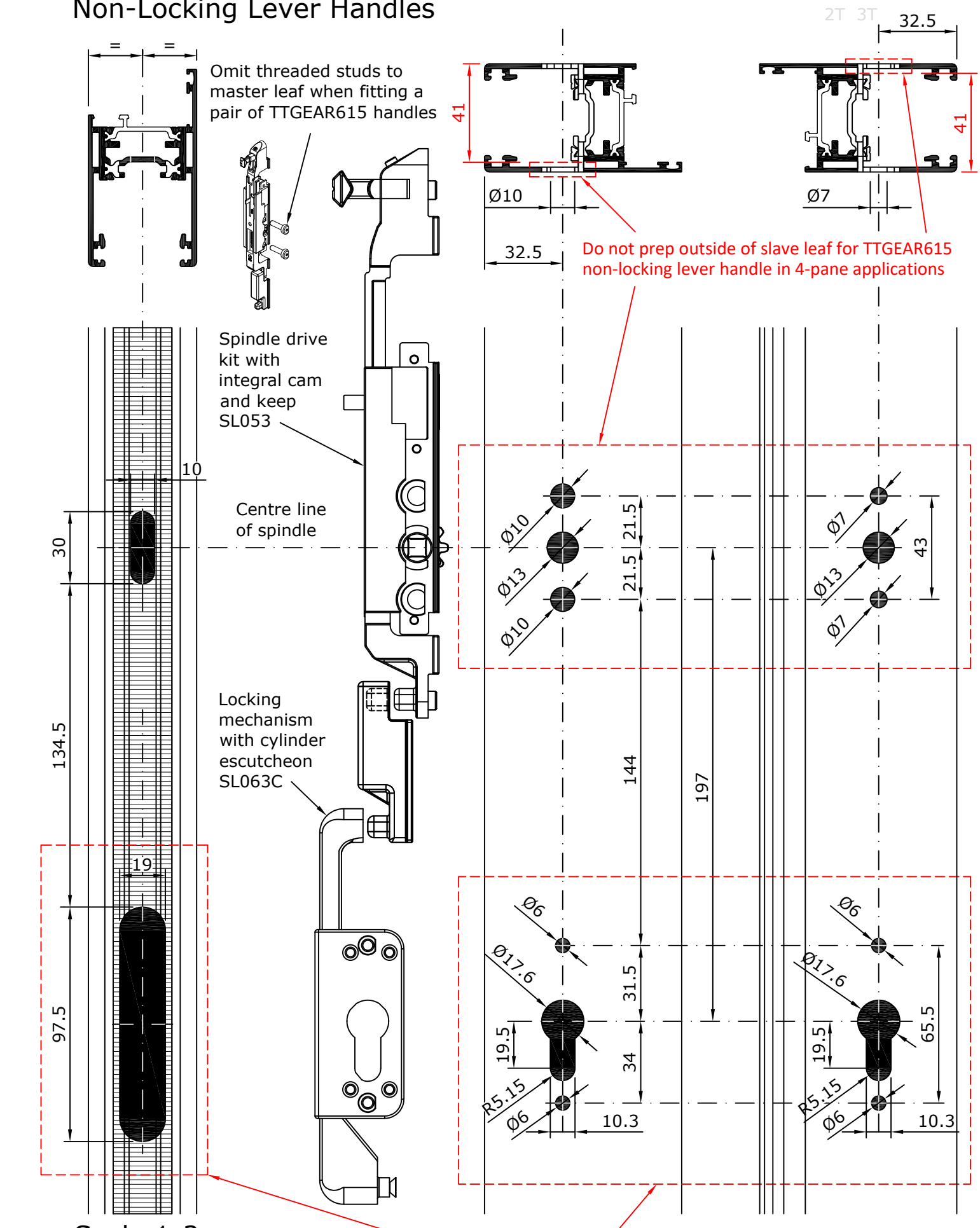
Scale 1:3

Sash Prep Details

SL053 and SL063C Preps for TTGEAR615 Non-Locking Lever Handles

System 25 Hi/Hi+

LIFT AND SLIDE DOOR



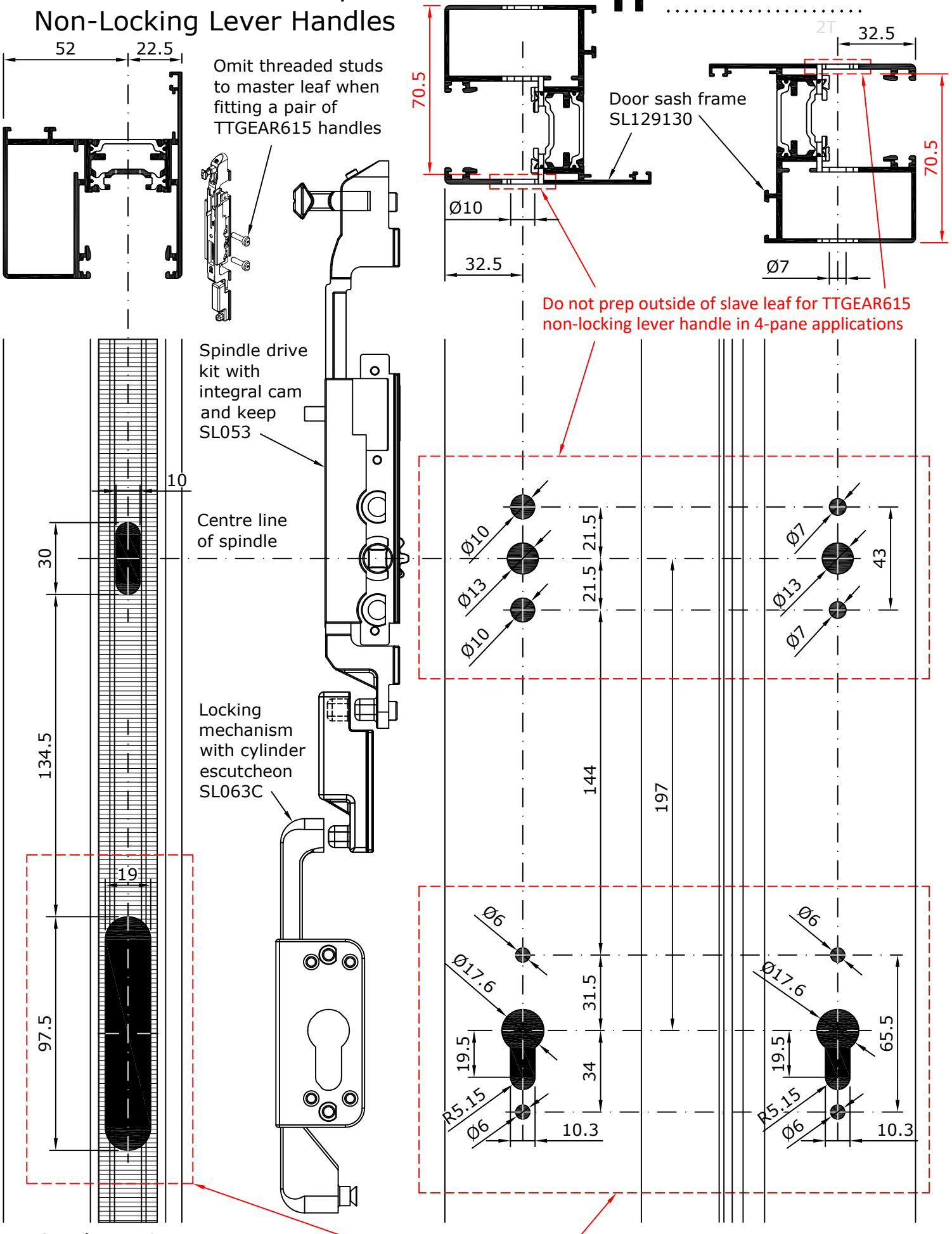
Scale 1:2

Sash Prep Details

SL053 and SL063C Preps for TTGEAR615 Non-Locking Lever Handles

System 25 Hi/Hi+

LIFT AND SLIDE DOOR



Scale 1:2

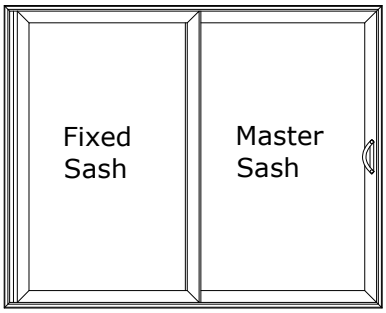
Sash Prep Details

SL101E External Pull Handle

System 25 Hi/Hi+

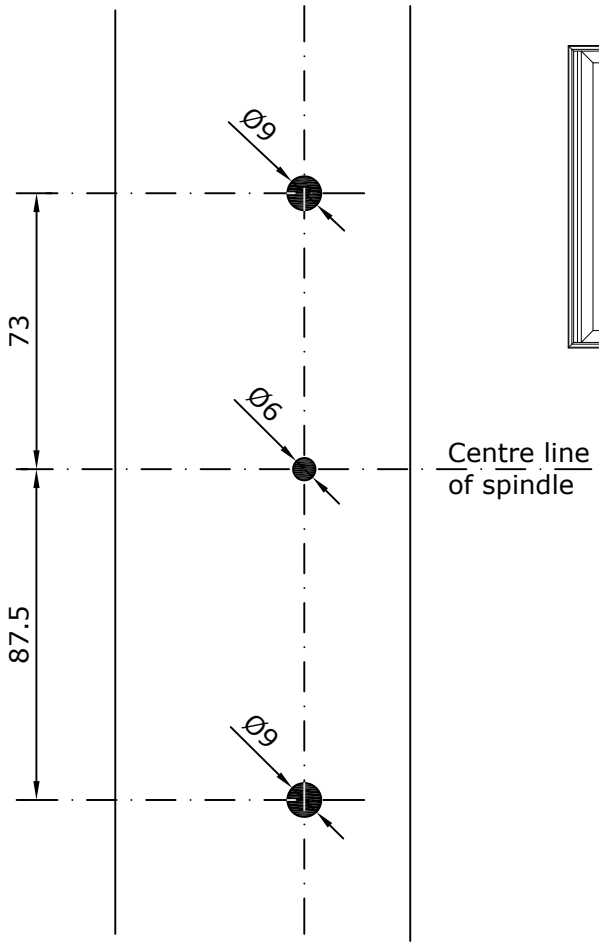
LIFT AND SLIDE DOOR

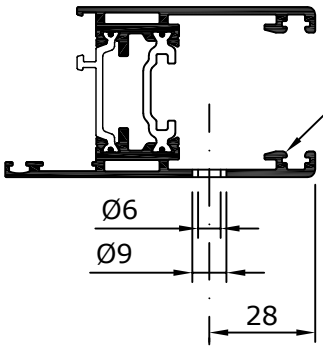
2T 3T

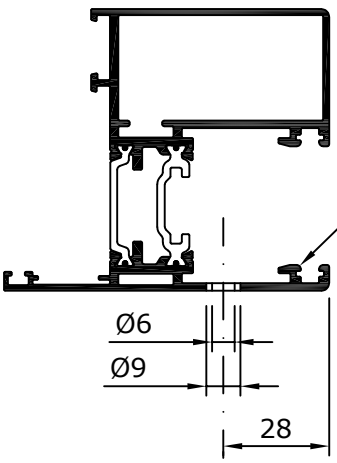


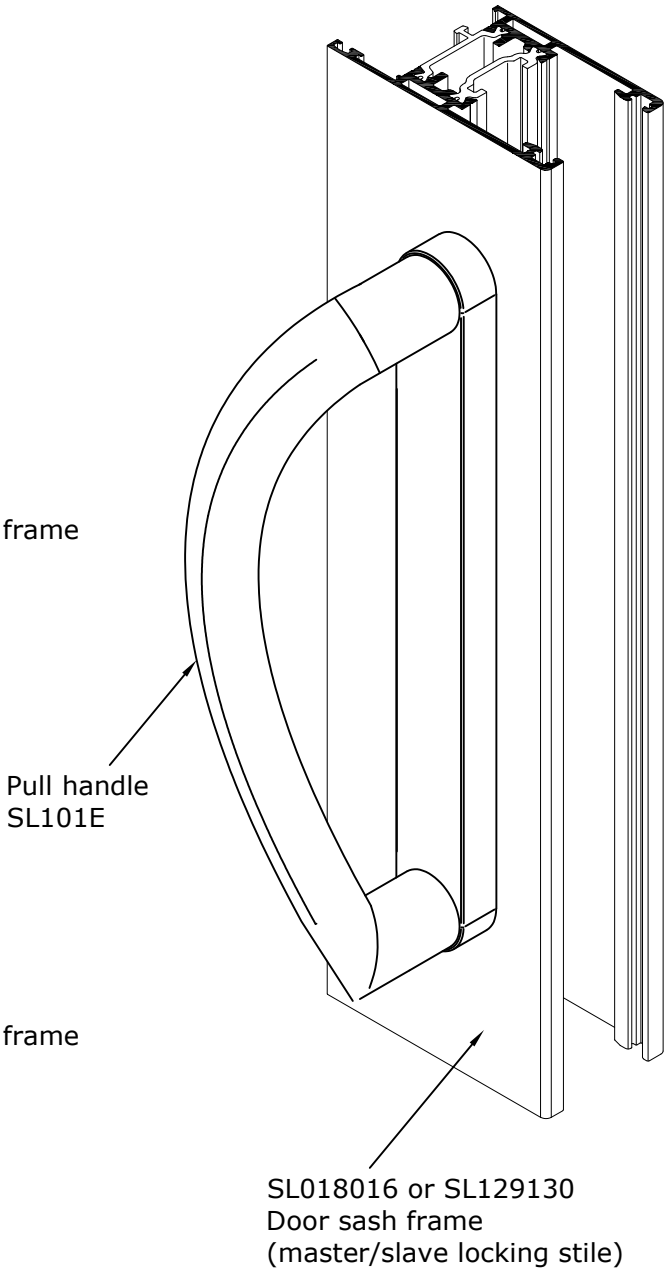
Viewed from outside

Determine handing of external pull handle. This sheet depicts a left hand handle.









Scale 1:2

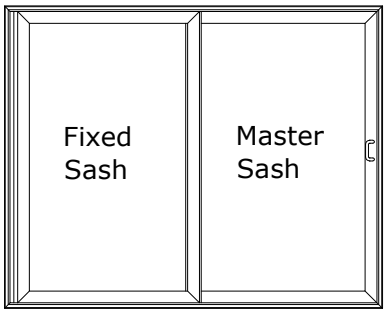
Sash Prep Details

SL102A External Pull Handle

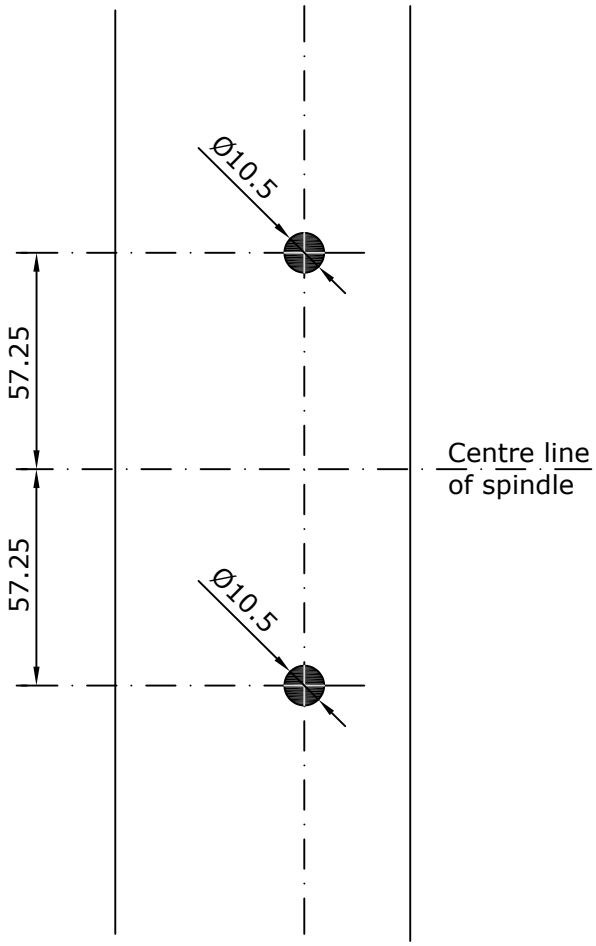
System 25 Hi/Hi+

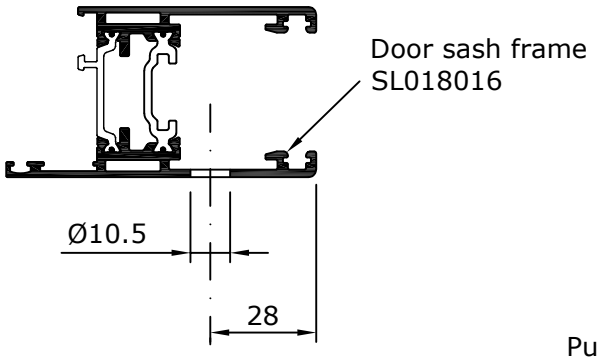
LIFT AND SLIDE DOOR

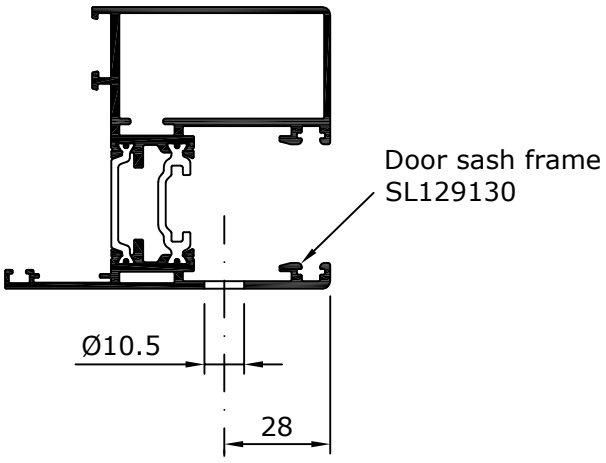
2T 3T

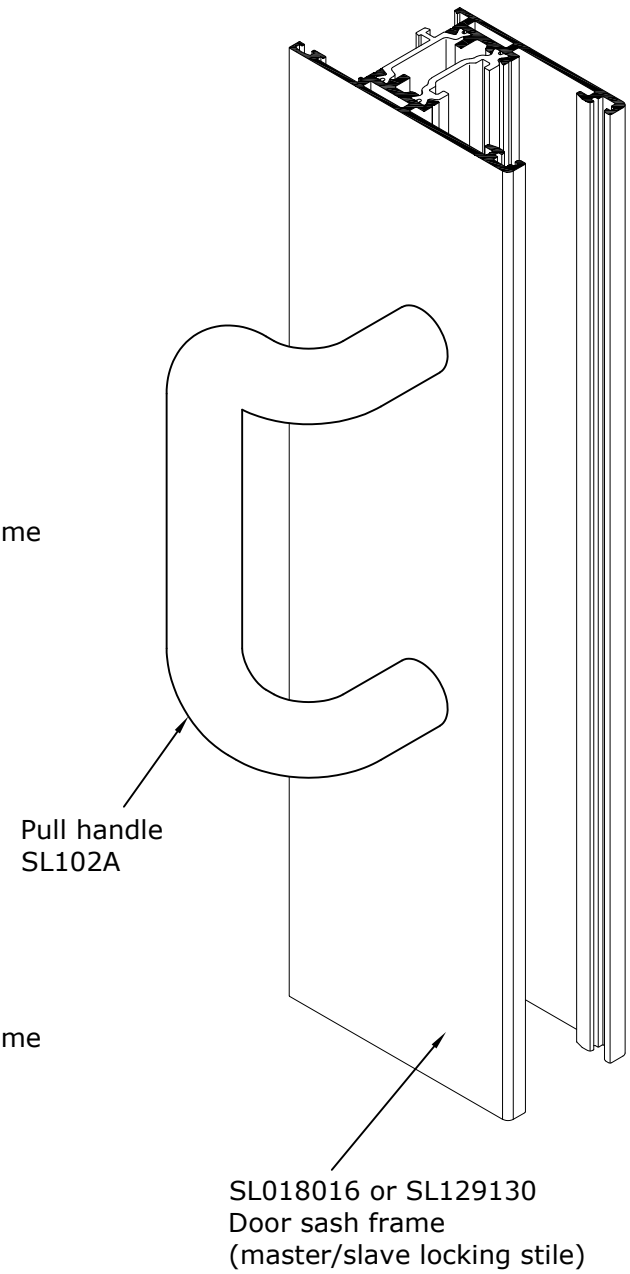


Viewed from outside









Scale 1:2

Sash Prep Details

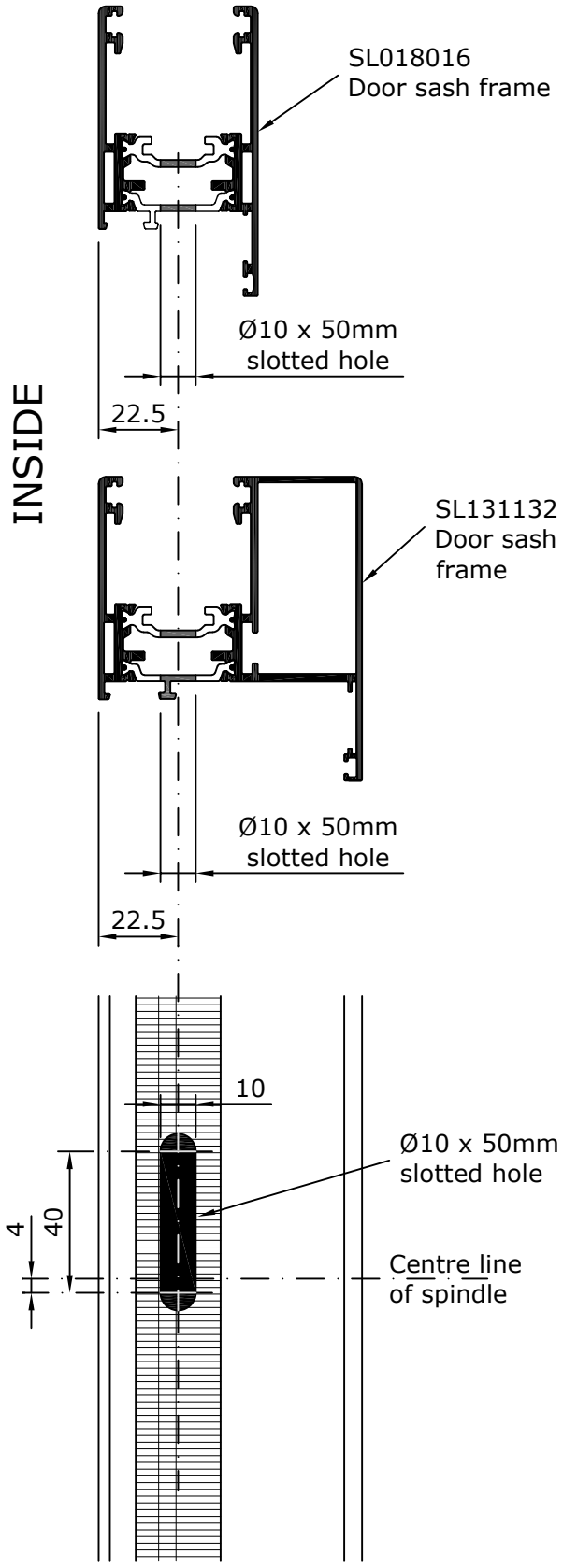
SL075 Fixed Sash Rod Drive

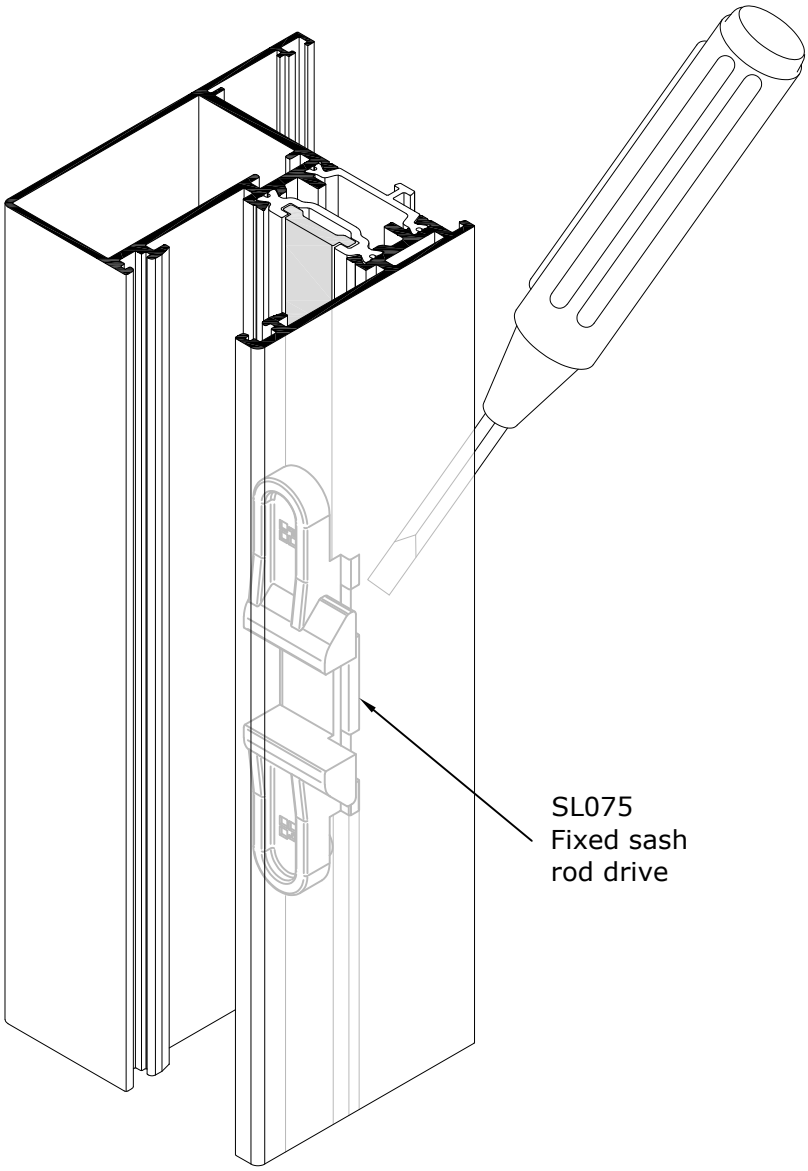
System 25 Hi/Hi+

LIFT AND SLIDE DOOR

2T 3T

Refer to "Link Rod Details" sheets, for setting out position of SL075 fixed sash rod drive.





Scale 1:2

Sash Prep Details

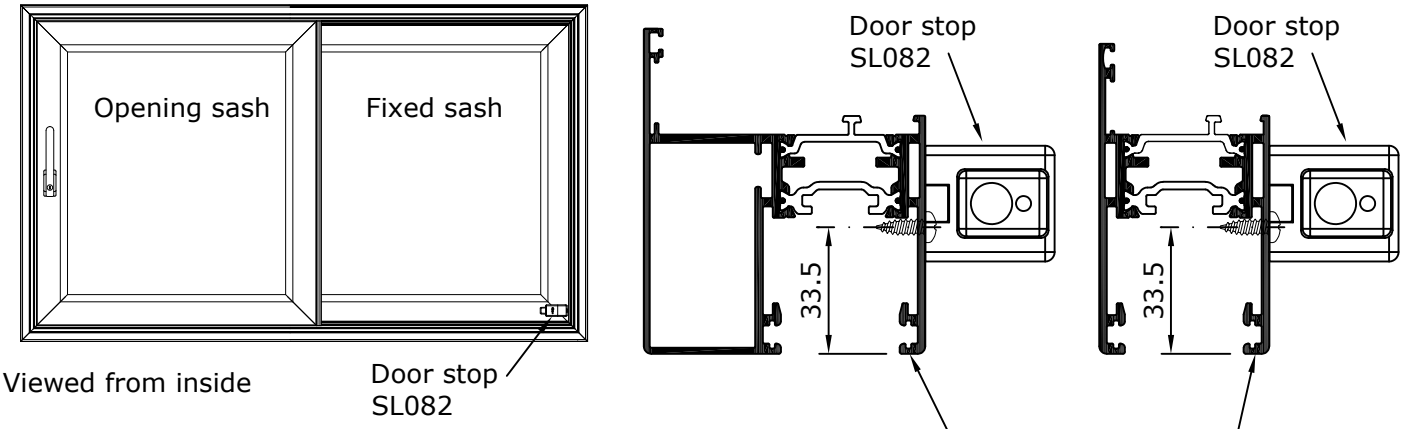
SL082 Door Stop

System 25 Hi/Hi+

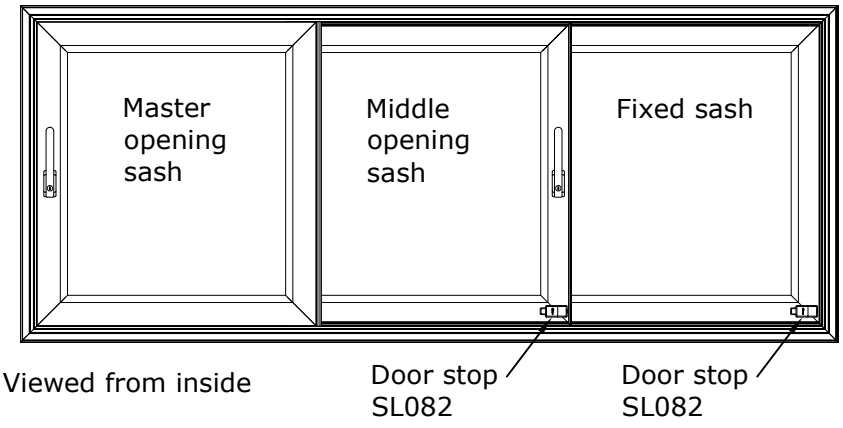
LIFT AND SLIDE DOOR

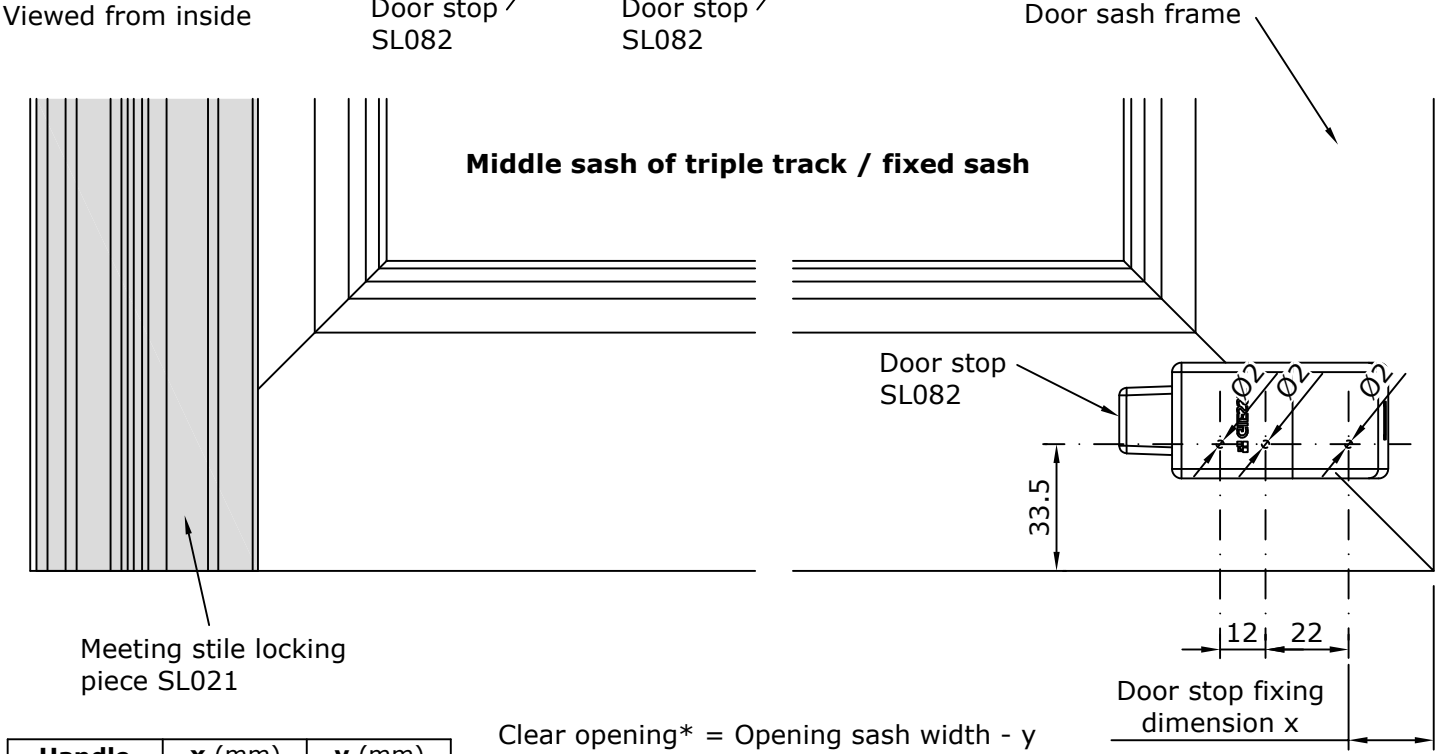
2T 3T

To suit 2, 3, and 4 pane double track applications.



To suit 3 pane triple track applications.





Handle	**x** (mm)	**y** (mm)
SL051	22.5	170
SL072	22.5	170
SL101E	52	200
SL102A	40	188
TTGEAR615	22.5	170

Clear opening* = Opening sash width - y

Door stop position is based on equal sash widths.
Handing of door stop dependant on handing of opening sash.

Where opening sash is > or < fixed sash width, door stop fixing dimension will need to be determined to suit.

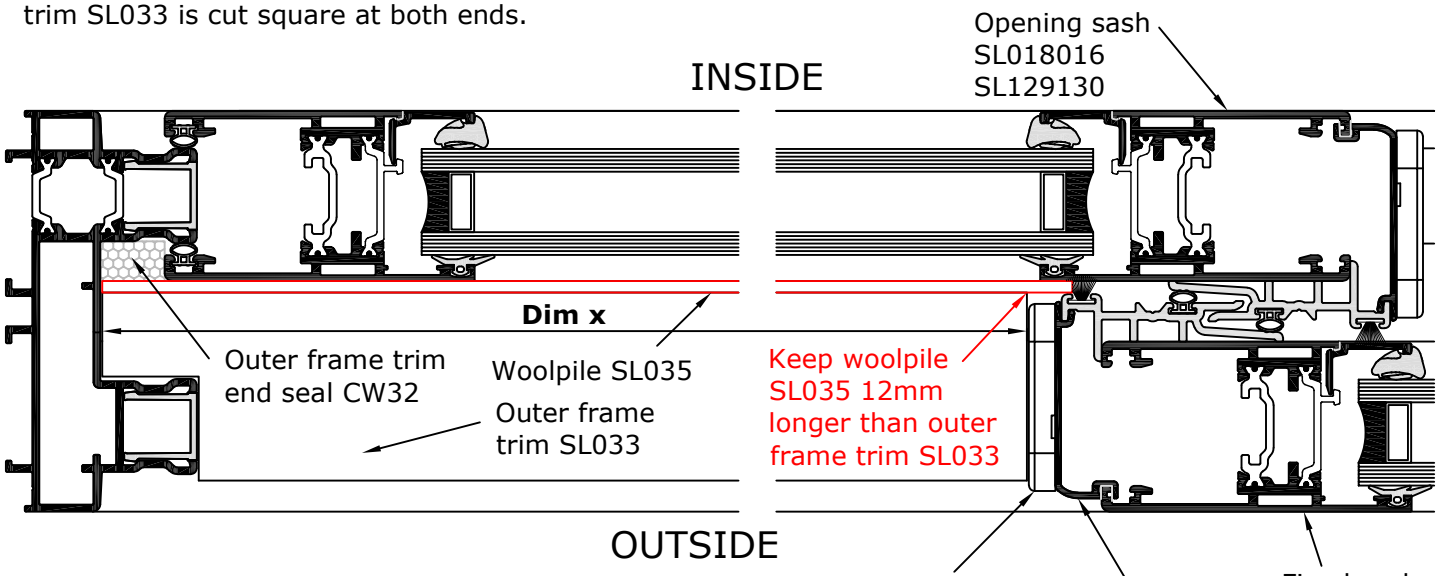
*When jamb extension is being used subtract 34mm from clear opening.

Scale 1:2

Outer Frame Trim SL033 Prep Details

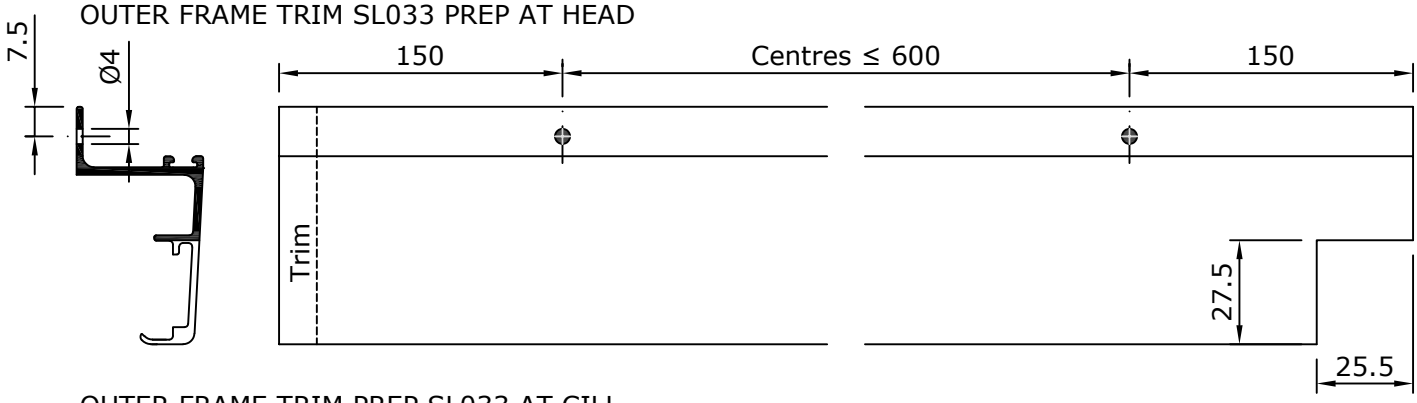
System 25 Hi/Hi+
LIFT AND SLIDE DOOR

This sheet to be read in conjunction with "Drainage Detail - Outer Frame - SL033 Outer Frame Trim" sheet. This detail is applicable to 2 and 3-pane applications. In 4-pane applications the outer frame trim SL033 is cut square at both ends.

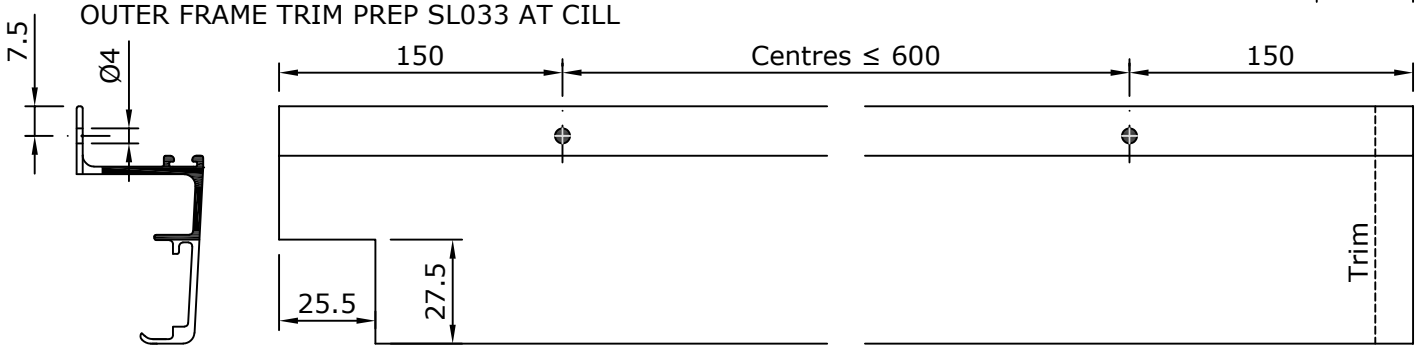


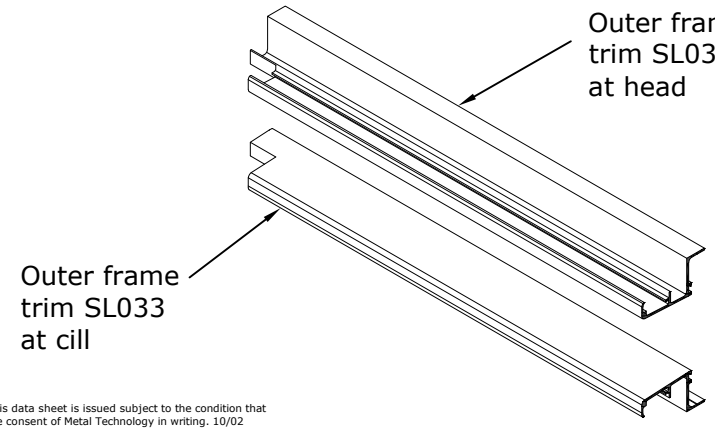
SL033 has been calculated 10mm oversize, and must be trimmed on site during installation to suit resultant opening, subject to site adjustment and tolerance.
Outer frame trim SL033 = **Dim x** less 1mm.

OUTER FRAME TRIM SL033 PREP AT HEAD



OUTER FRAME TRIM PREP SL033 AT CILL





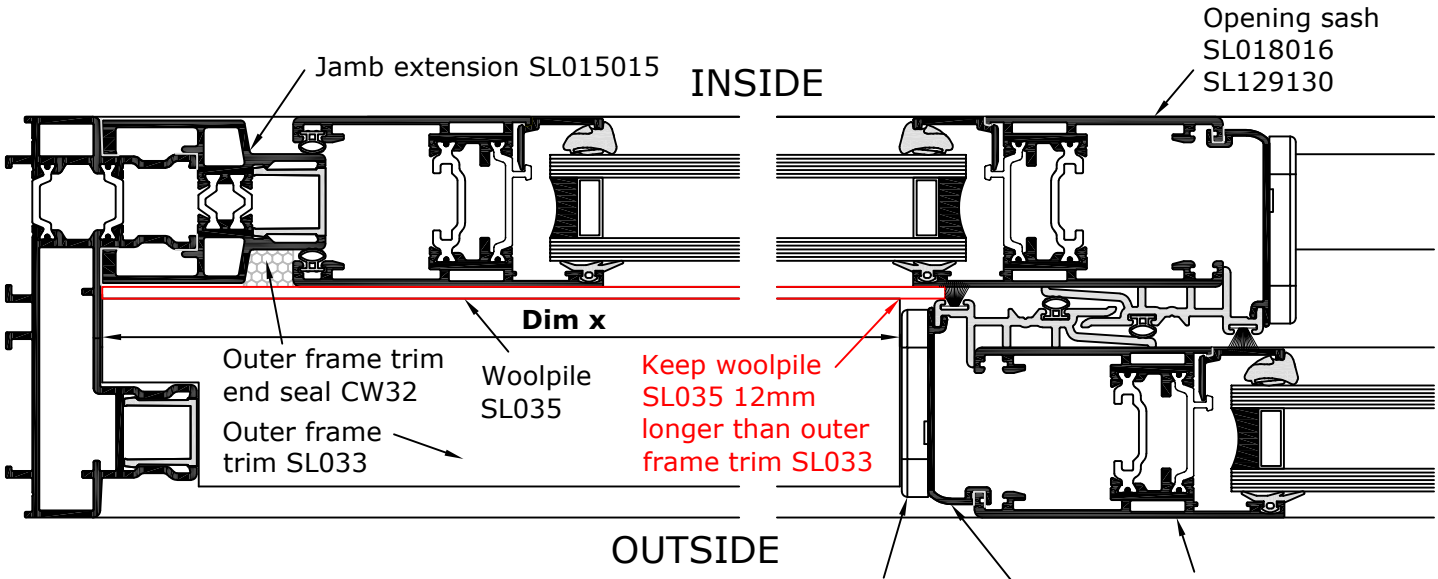
Scale 1:2

Outer Frame Trim SL033 Prep Details

System 25 Hi/Hi+
LIFT AND SLIDE DOOR
2T

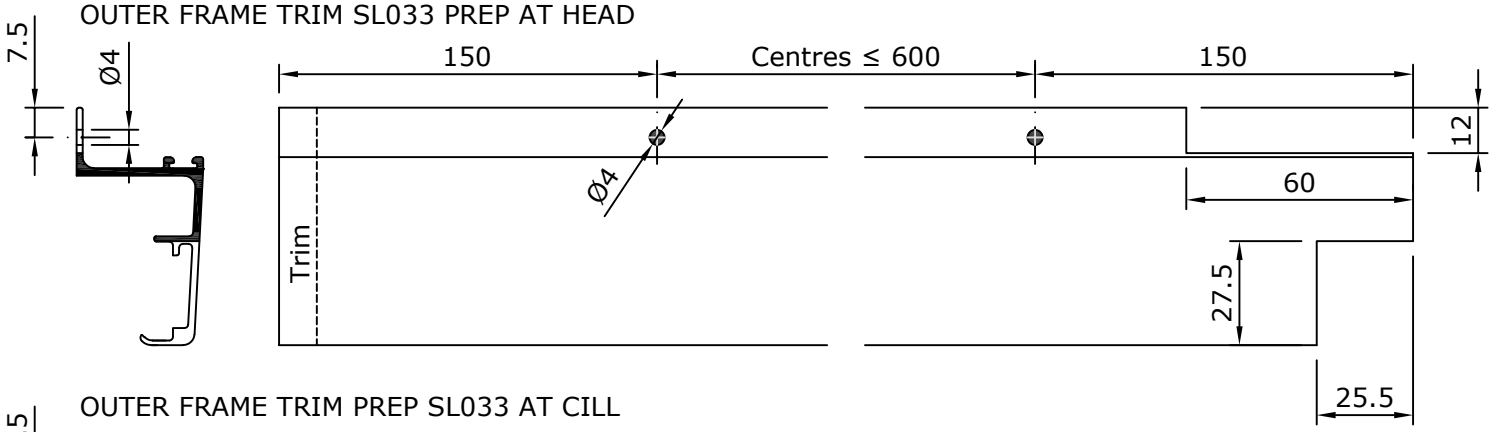
For Jamb Extension SL015015 Applications

This sheet to be read in conjunction with "Drainage Detail - Outer Frame - SL033 Outer Frame Trim" sheet.

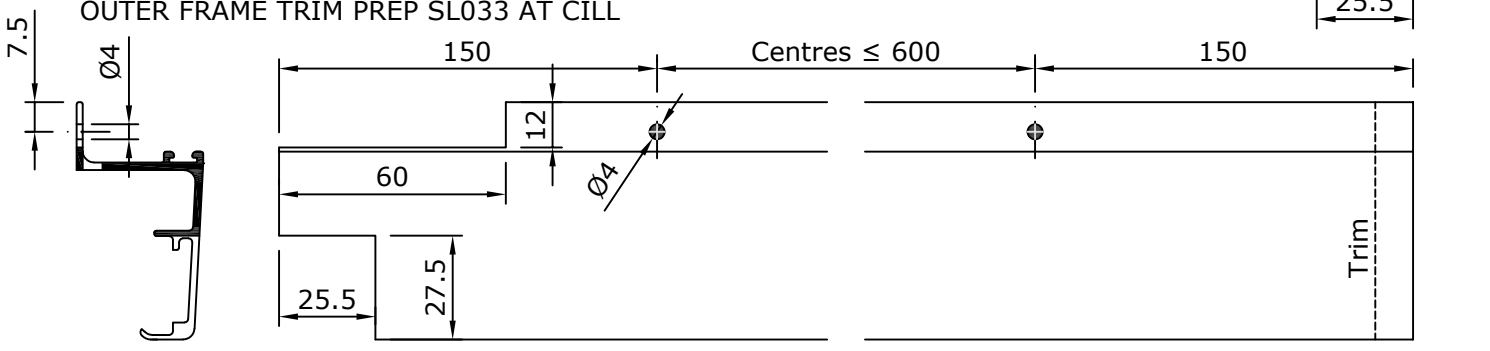


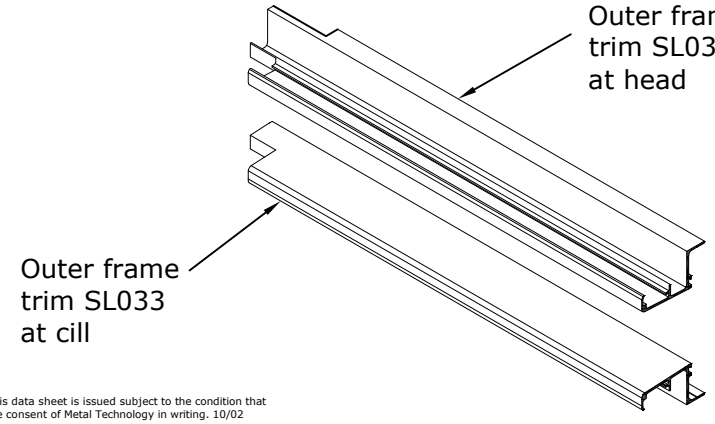
SL033 has been calculated 10mm oversize, and must be trimmed on site during installation to suit resultant opening, subject to site adjustment and tolerance.
Outer frame trim SL033 = **Dim x** less 1mm.

OUTER FRAME TRIM SL033 PREP AT HEAD



OUTER FRAME TRIM PREP SL033 AT CILL





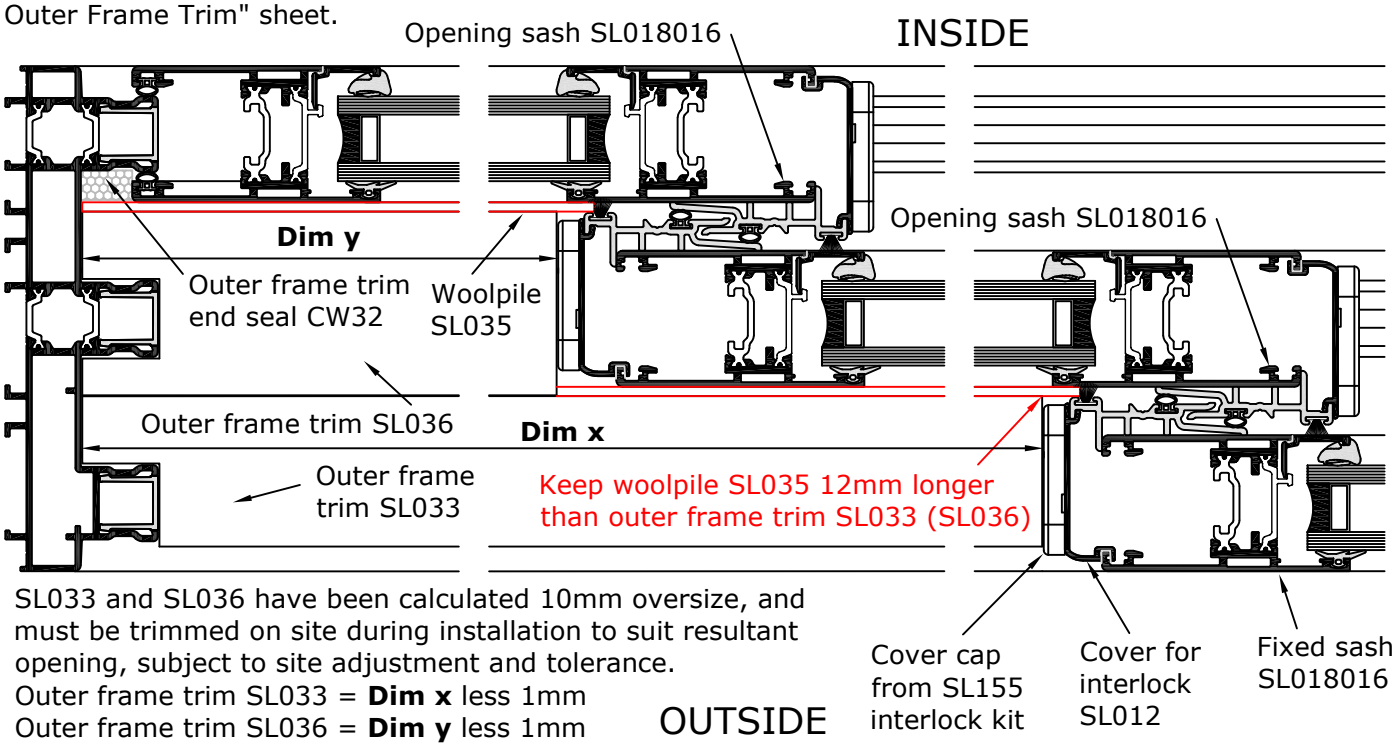
Scale 1:2

Outer Frame Trim SL033 and SL036 Prep Details

System 25 Hi/Hi+

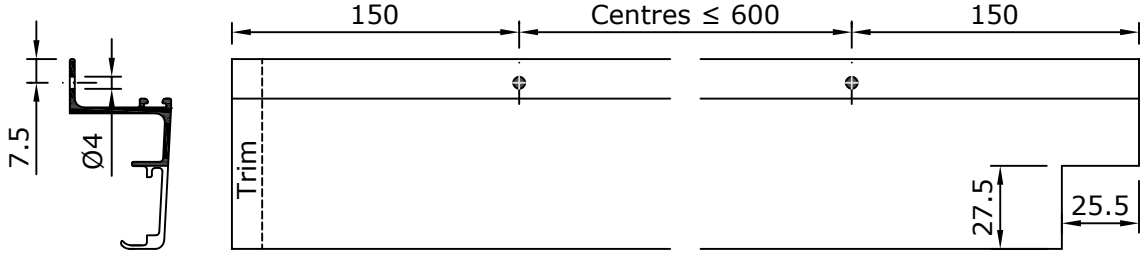
LIFT AND SLIDE DOOR

This sheet to be read in conjunction with "Drainage Detail - Outer Frame - SL033 and SL036 Outer Frame Trim" sheet.

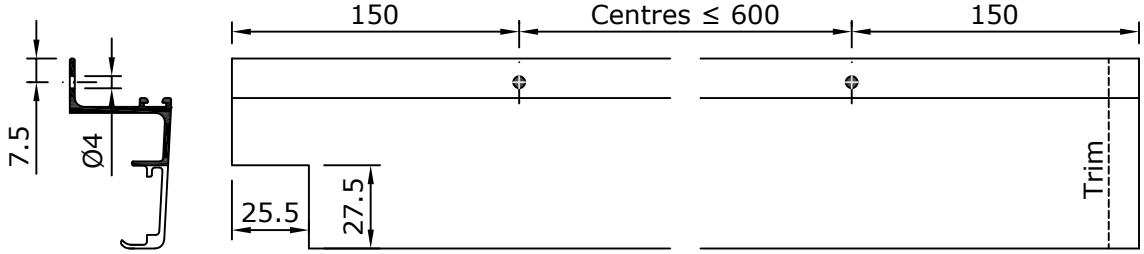


SL033 and SL036 have been calculated 10mm oversize, and must be trimmed on site during installation to suit resultant opening, subject to site adjustment and tolerance.
Outer frame trim SL033 = **Dim x** less 1mm
Outer frame trim SL036 = **Dim y** less 1mm

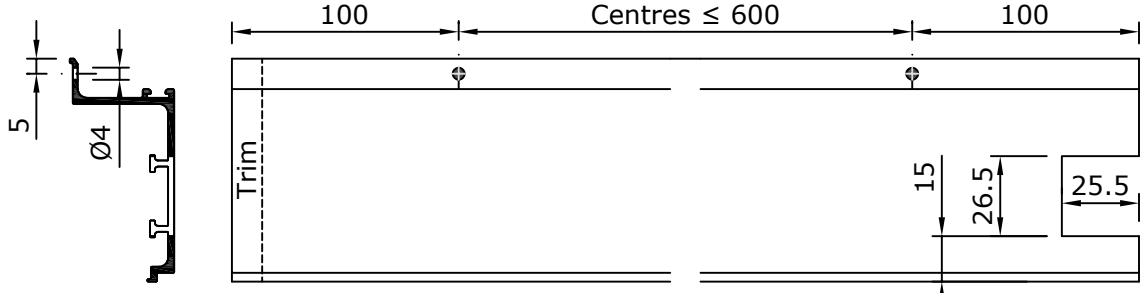
OUTER FRAME TRIM SL033 PREP AT HEAD



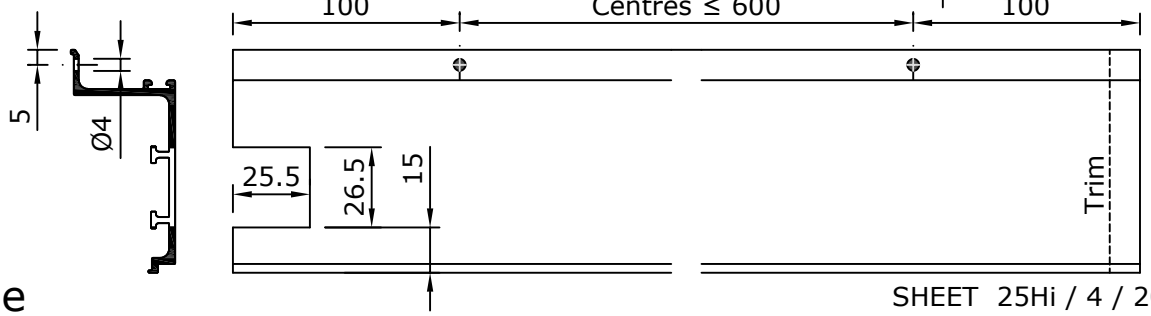
OUTER FRAME TRIM PREP SL033 AT CILL



OUTER FRAME TRIM SL036 PREP AT HEAD



OUTER FRAME TRIM SL036 PREP AT CILL



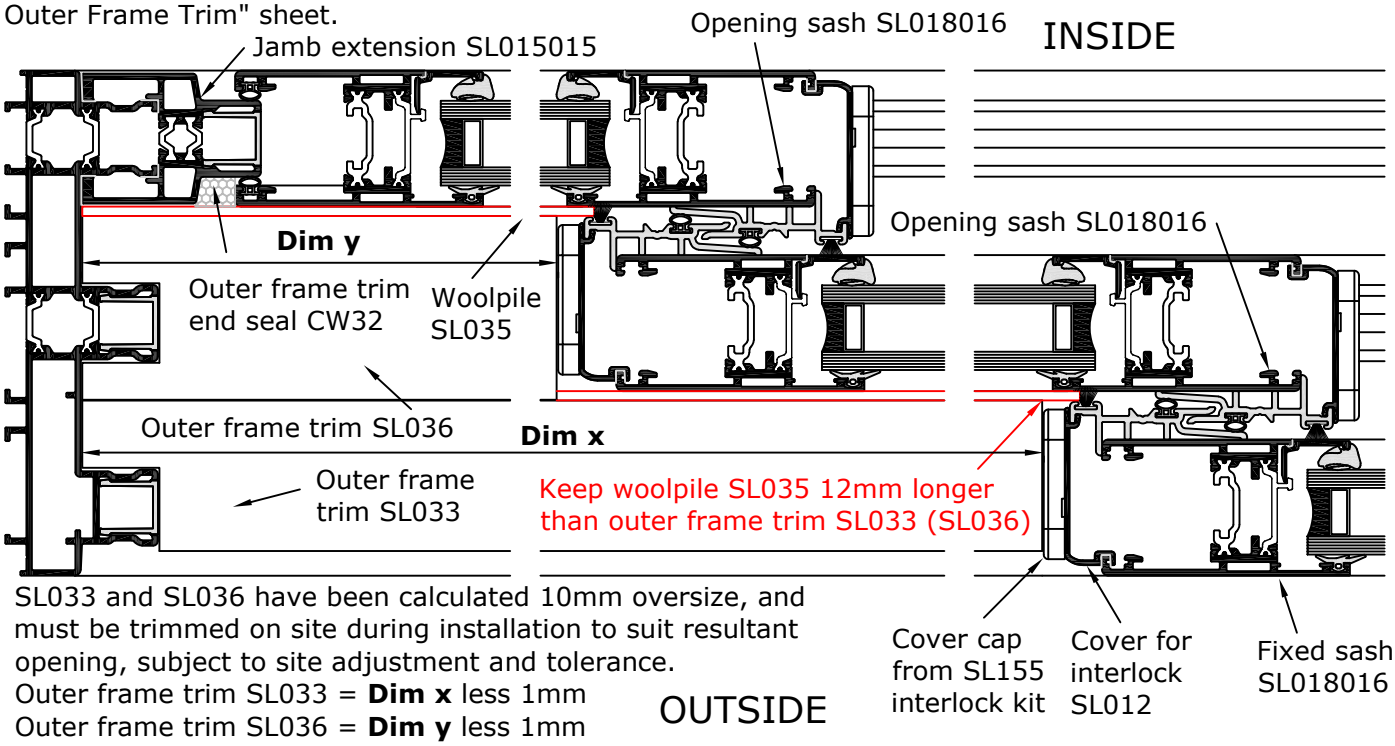
Not to Scale

Outer Frame Trim SL033 and SL036 Prep Details

System 25 Hi/Hi+
LIFT AND SLIDE DOOR

For Jamb Extension SL015015 Applications

This sheet to be read in conjunction with "Drainage Detail - Outer Frame - SL033 and SL036 Outer Frame Trim" sheet.



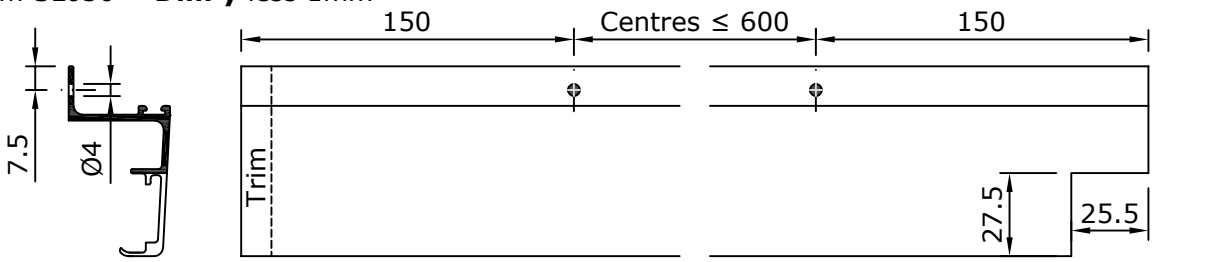
SL033 and SL036 have been calculated 10mm oversize, and must be trimmed on site during installation to suit resultant opening, subject to site adjustment and tolerance.

Outer frame trim SL033 = **Dim x** less 1mm

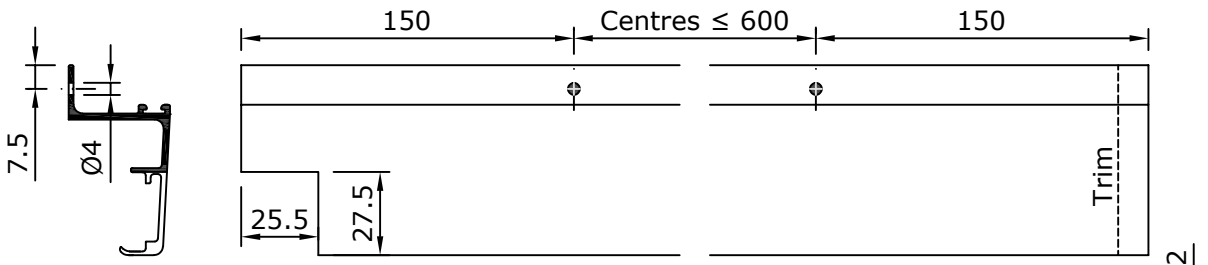
Outer frame trim SL036 = **Dim y** less 1mm

OUTSIDE

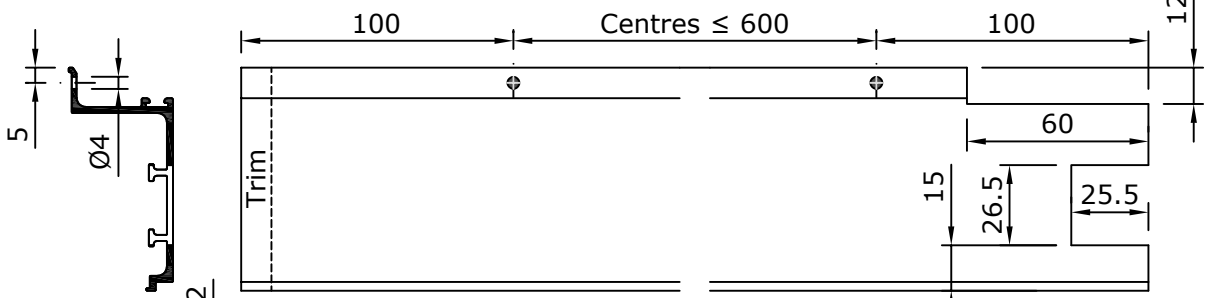
OUTER FRAME TRIM SL033 PREP AT HEAD



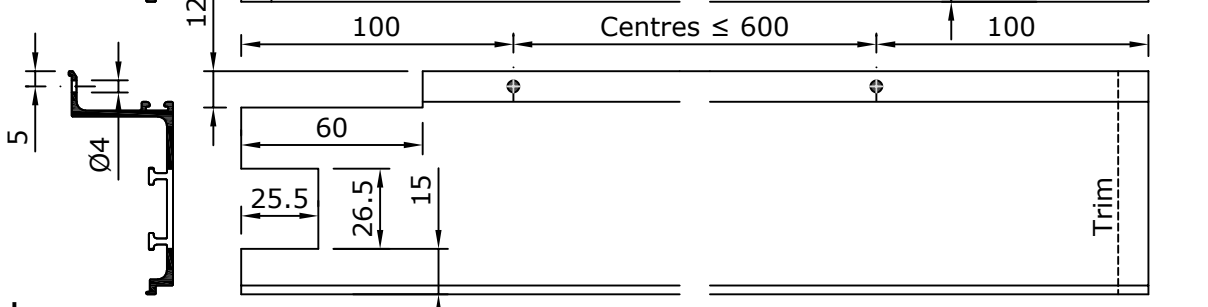
OUTER FRAME TRIM PREP SL033 AT CILL



OUTER FRAME TRIM SL036 PREP AT HEAD



OUTER FRAME TRIM SL036 PREP AT CILL



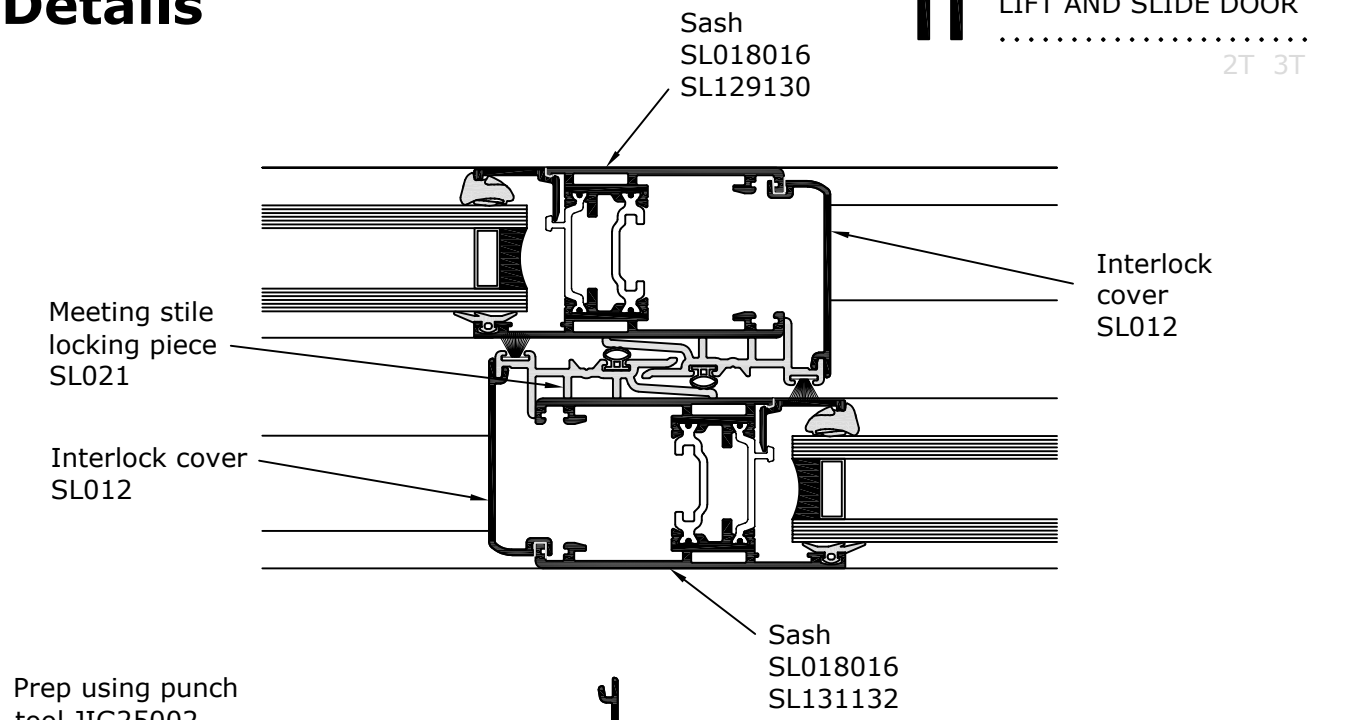
Not to Scale

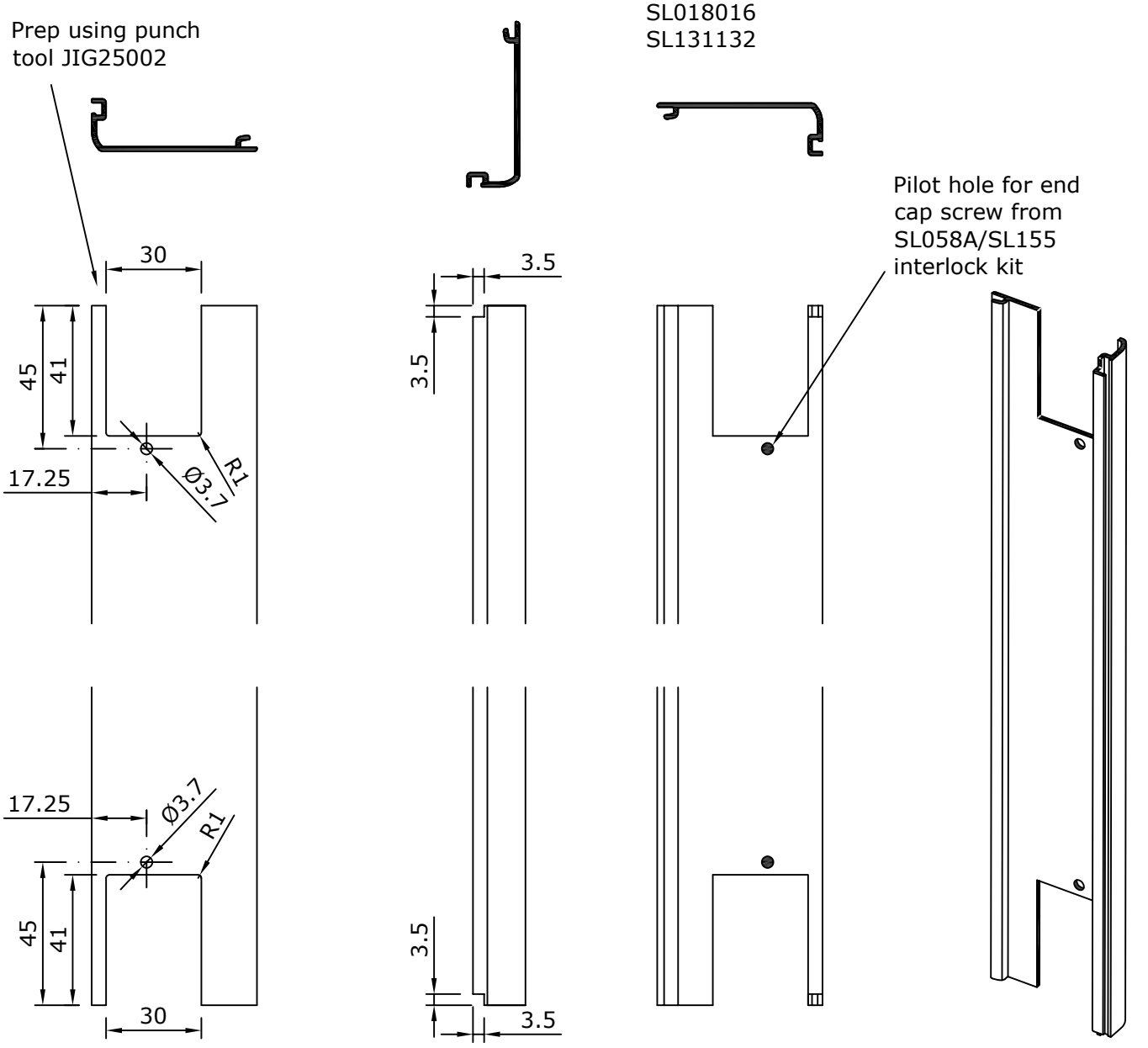
Interlock Cover SL012 Prep Details

System 25 Hi/Hi+

LIFT AND SLIDE DOOR

2T 3T



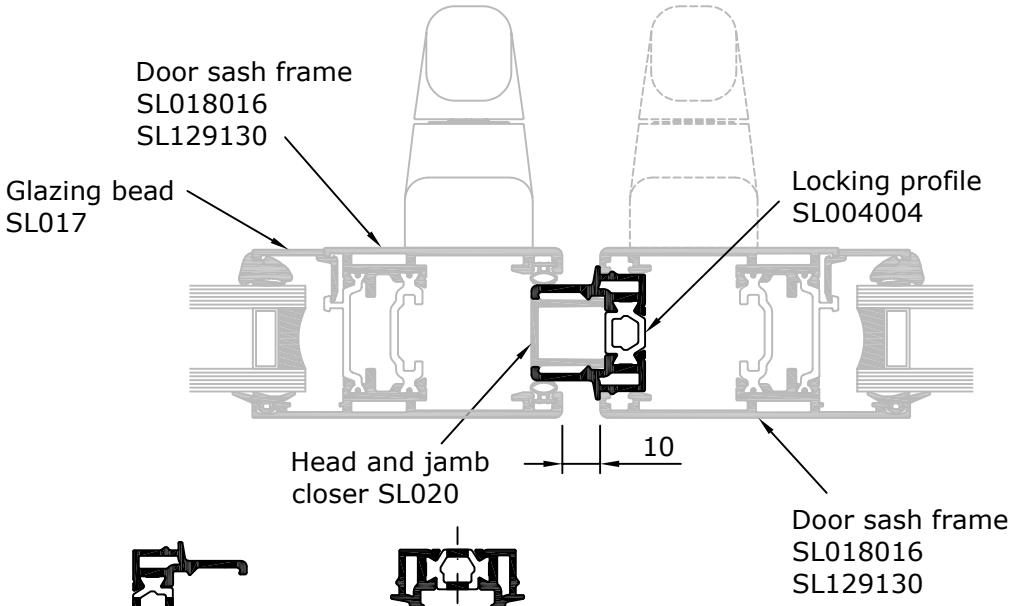


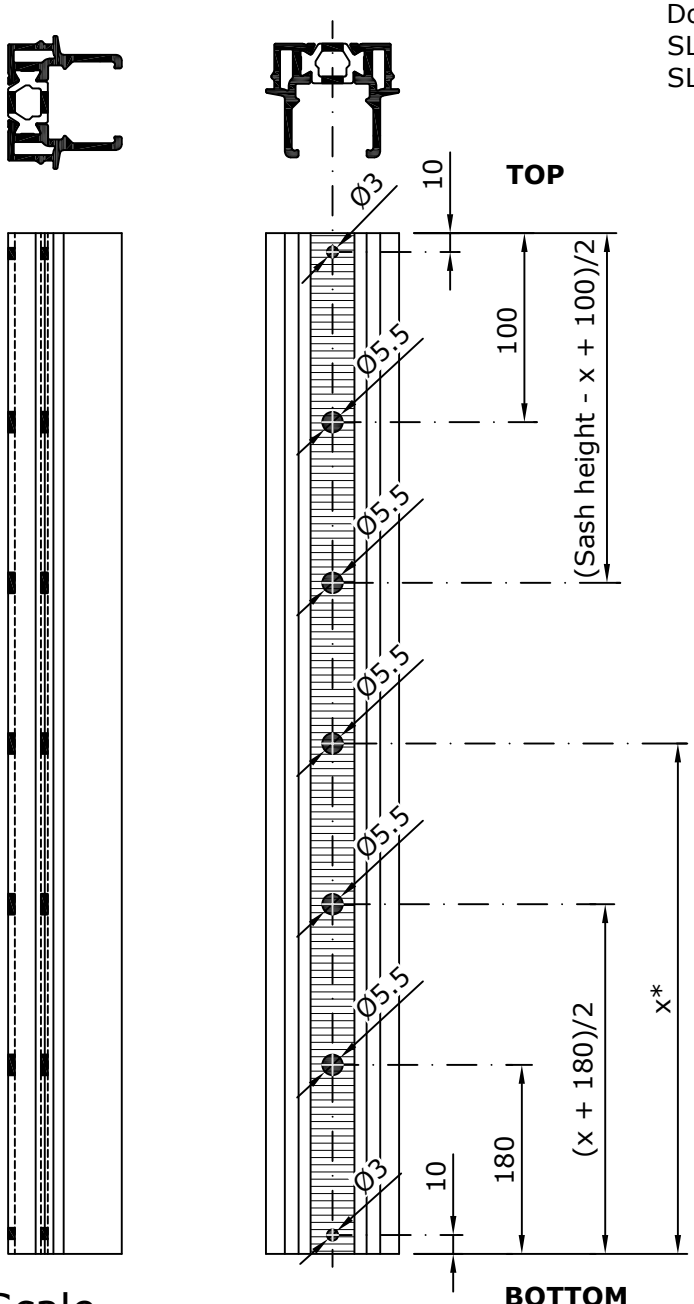
Scale 1:2

Locking Profile SL004004
Prep Details

System 25 Hi/Hi+
LIFT AND SLIDE DOOR
2T

Prep details are based on the centre line of the spindle positioned at 958mm from bottom of door sash.
When sash height is below 1816mm refer to Metal Technology's Technical Department.





*For sash height ≤ 2316
x = 1158

For sash height > 2316
x = Sash height / 2

Not to Scale

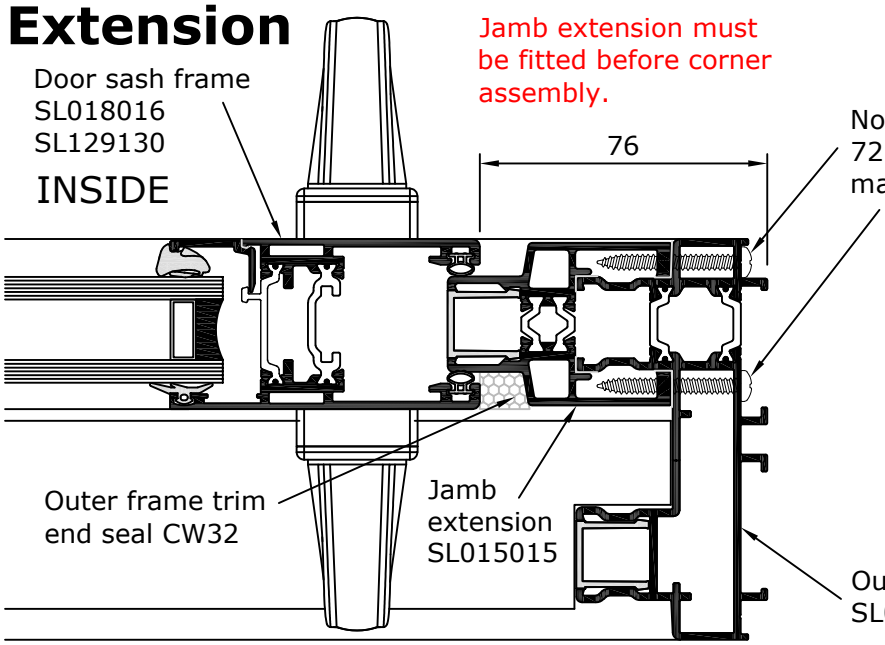
End Prep for SL015015 Jamb Extension

System 25 Hi/Hi+

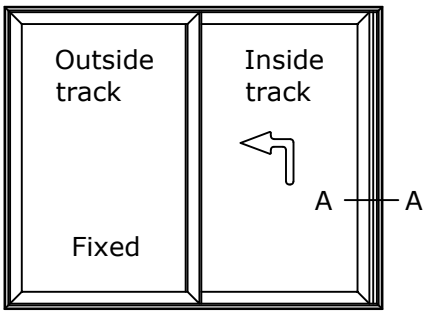
LIFT AND SLIDE DOOR

2T 3T

Jamb extension must be fitted before corner assembly.

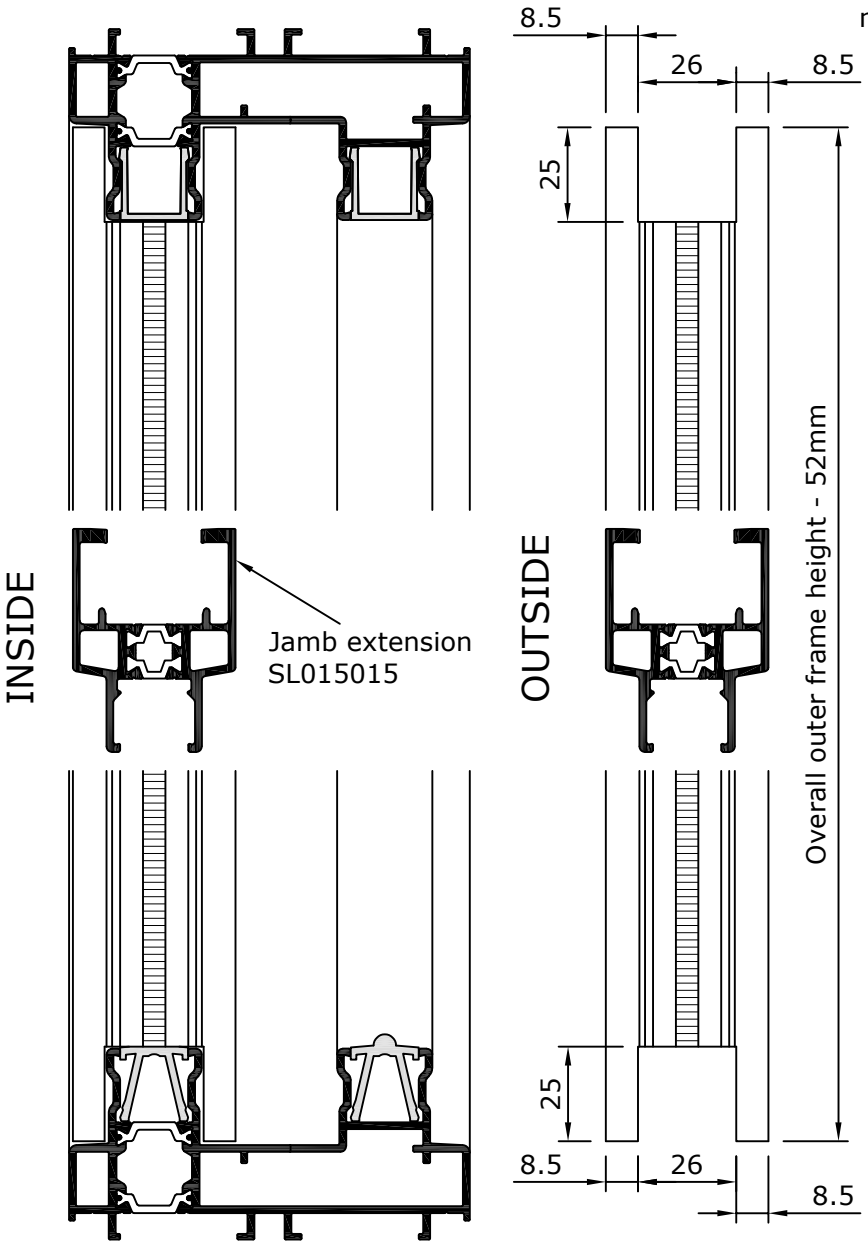


No 8 x 38mm pan head self tapping screws 7235 positioned 75mm from the corners at maximum 300mm centres.



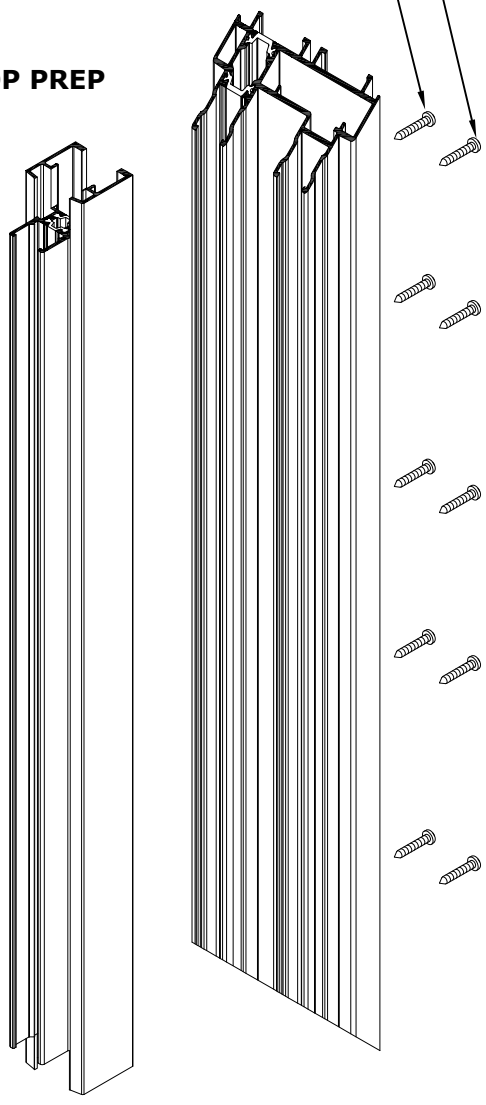
SECTION A-A

OUTSIDE



No 8 x 38mm pan head self tapping screws 7235 positioned 75mm from the corners at maximum 300mm centres.

TOP PREP



BOTTOM PREP

Not to Scale

Mullion Stiffener

007, 008 and 009 Prep Detail

System 25 Hi/Hi+

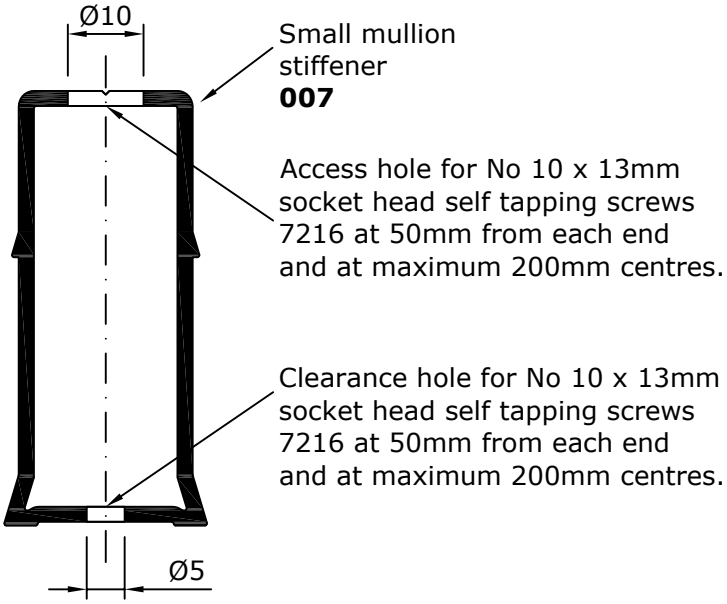
LIFT AND SLIDE DOOR

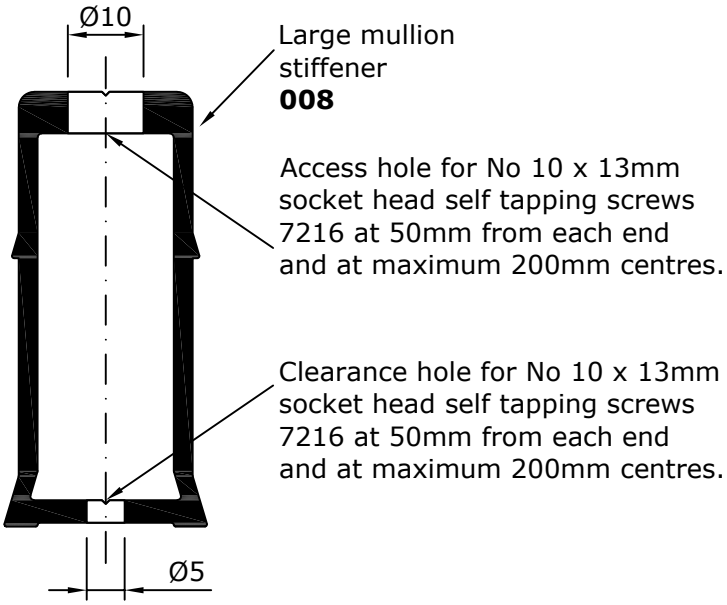
2T 3T

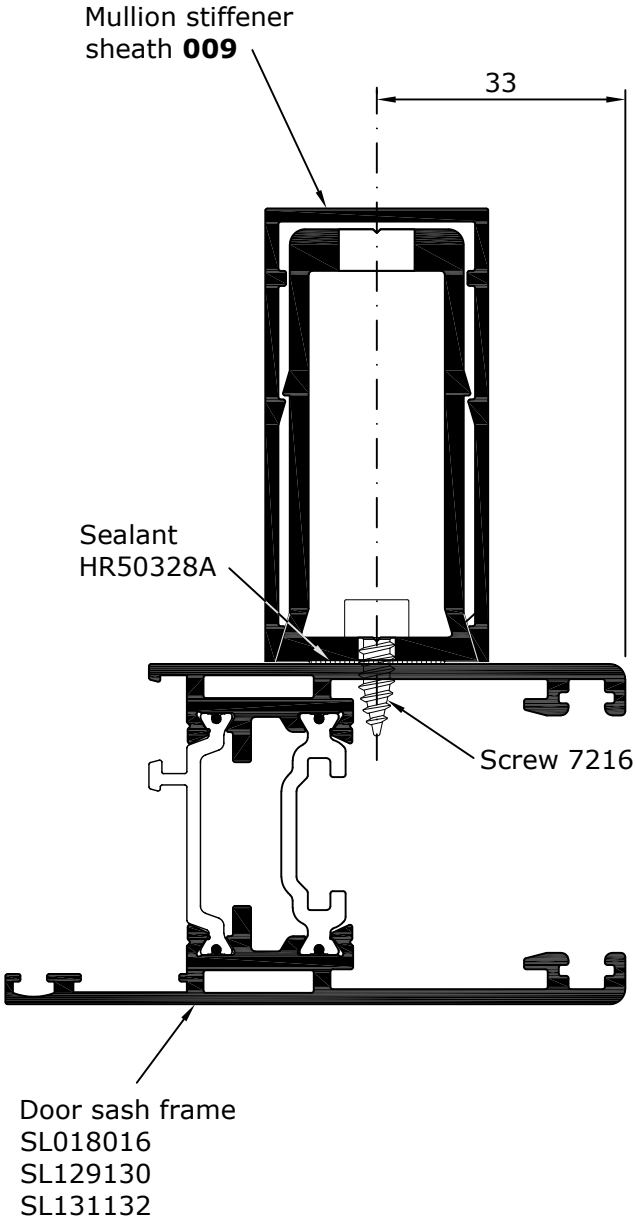
Metal Technology recommend that the No 10 x 13mm socket head self tapping screws 7216 are fixed at 200mm centres and sealed in position using HR50328A sealant. Variation from these centres will affect the structural performance of the combined mullion and must be checked and confirmed by a structural engineer.

Cutting sizes to be calculated based on sash height less 22mm, or sash height less 52mm when mullion stiffener is fitted to external surface of inner pane or internal surface of outer pane. Refer to "Mullion Stiffener" general arrangement drawings in Section 2 for further clarification.

Ensure outer frame trim SL033 is fitted prior to fixing 007 or 008 mullion stiffener to exterior of door sash in 3 and 4-pane applications.







Scale 1:1

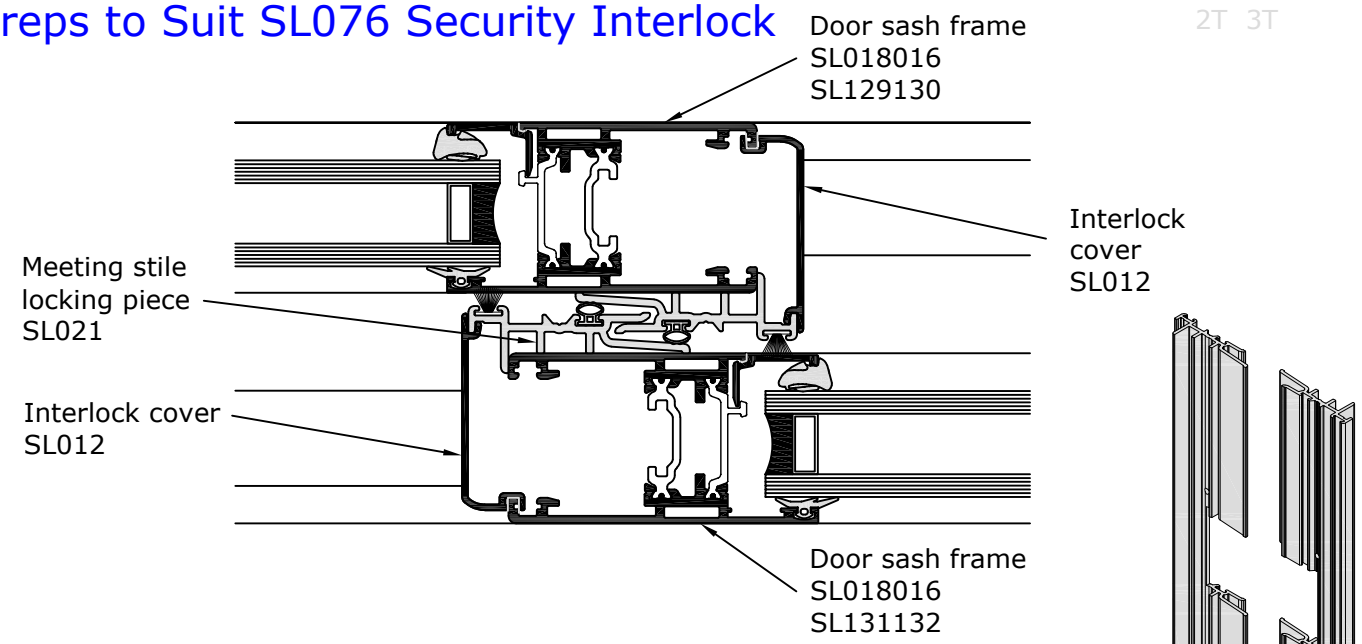
SL021 Meeting Stile Locking Piece Prep Details - Security

Preps to Suit SL076 Security Interlock

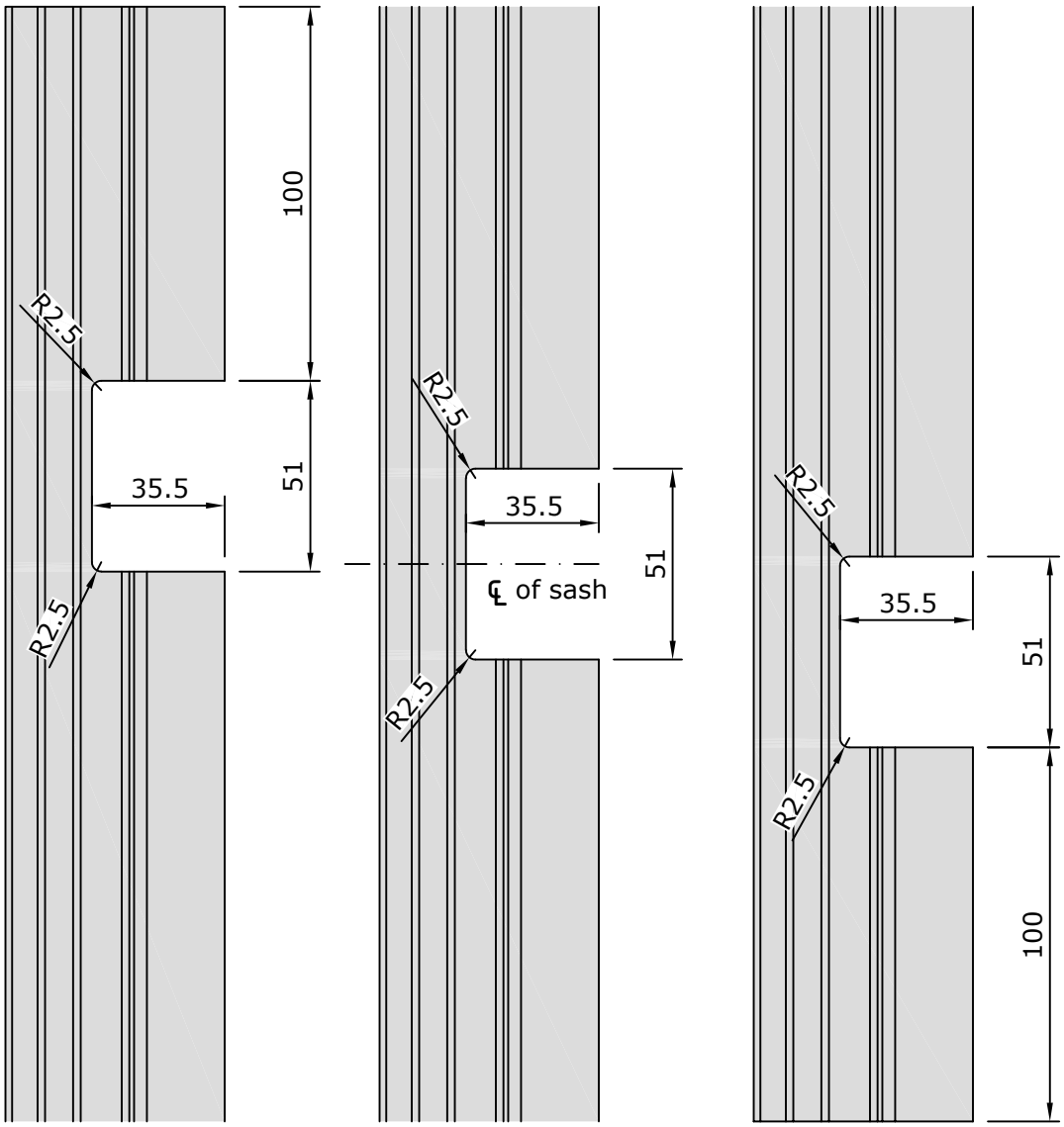
System 25 Hi/Hi+

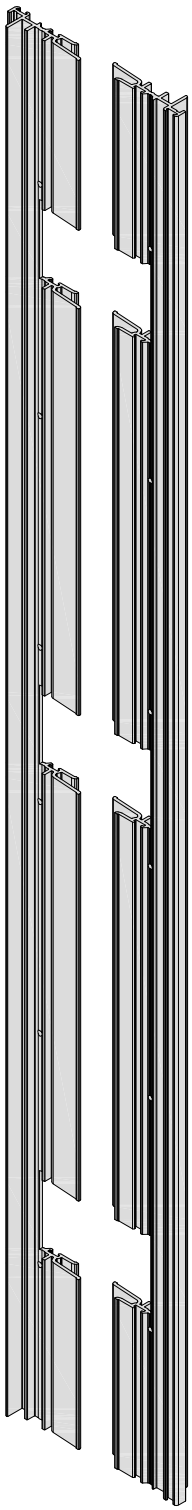
LIFT AND SLIDE DOOR

2T 3T



TOP





BOTTOM

Scale 1:2

Drainage Detail

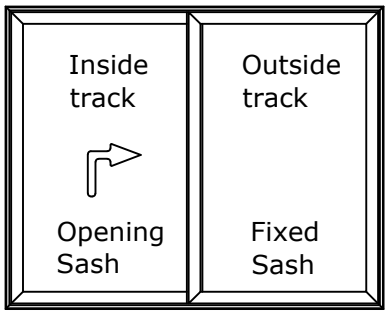
Opening Sash

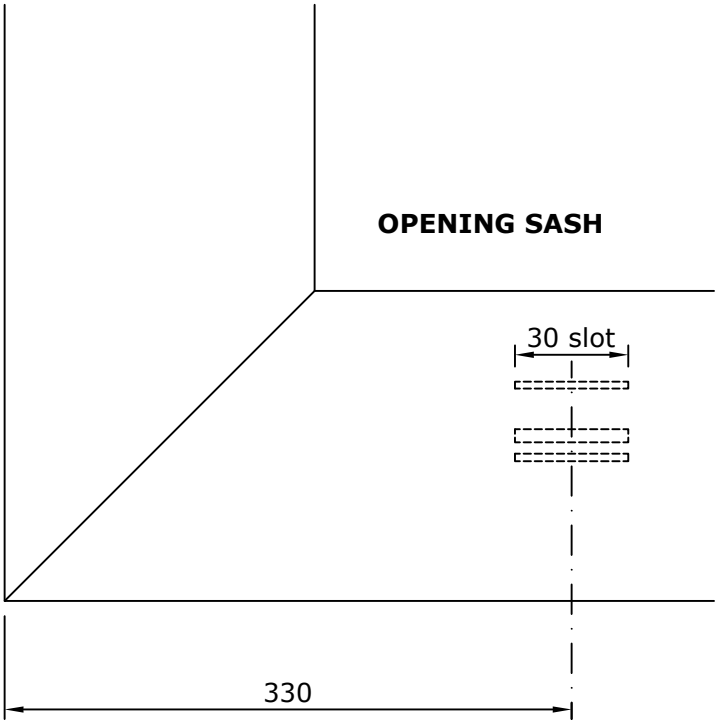
System 25 Hi

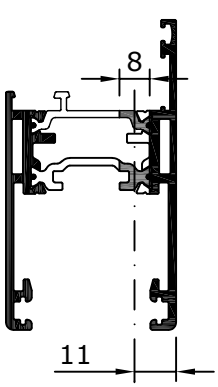
LIFT AND SLIDE DOOR

2T 3T

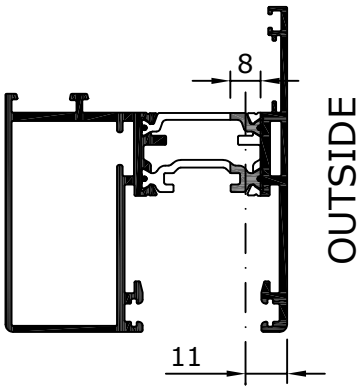
Positions of drainage slots are set to avoid interference with gearing.
These details apply to all lift and slide opening sashes in 2, 3 and 4-pane configurations.



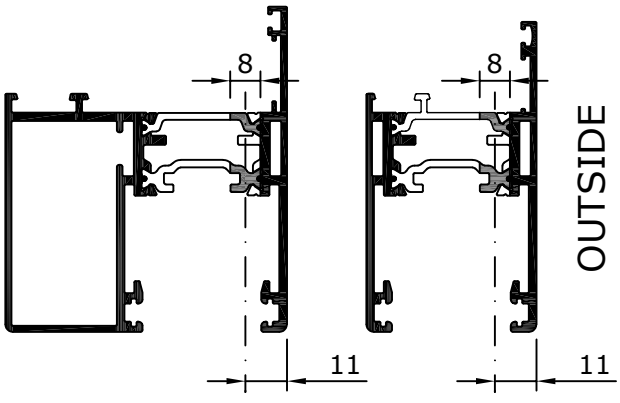




Door sash frame
SL018016

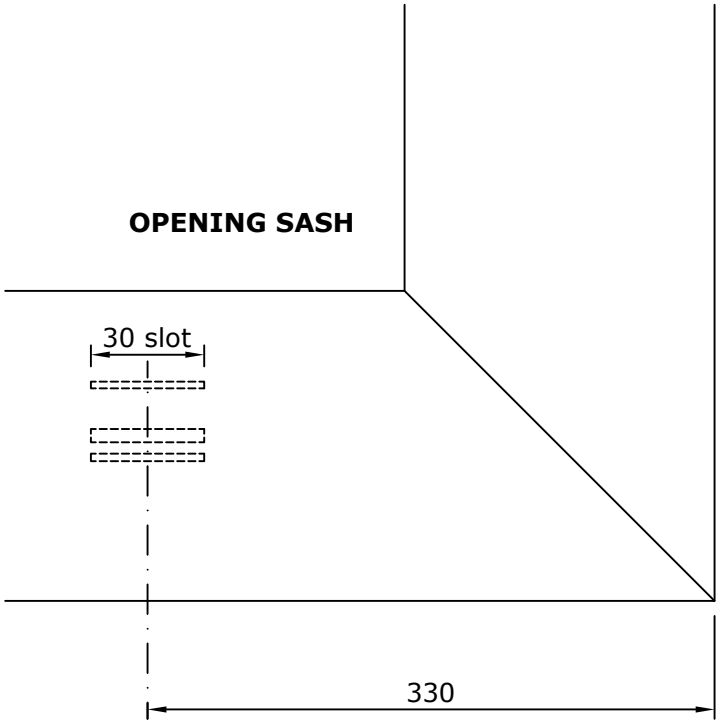


Door sash frame
SL129130



Door sash frame
SL129130

Door sash frame
SL018016

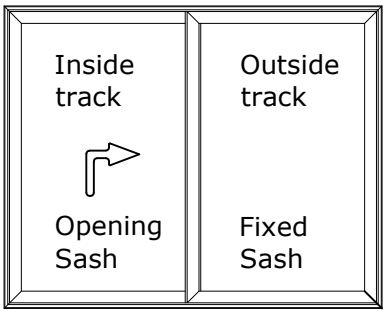


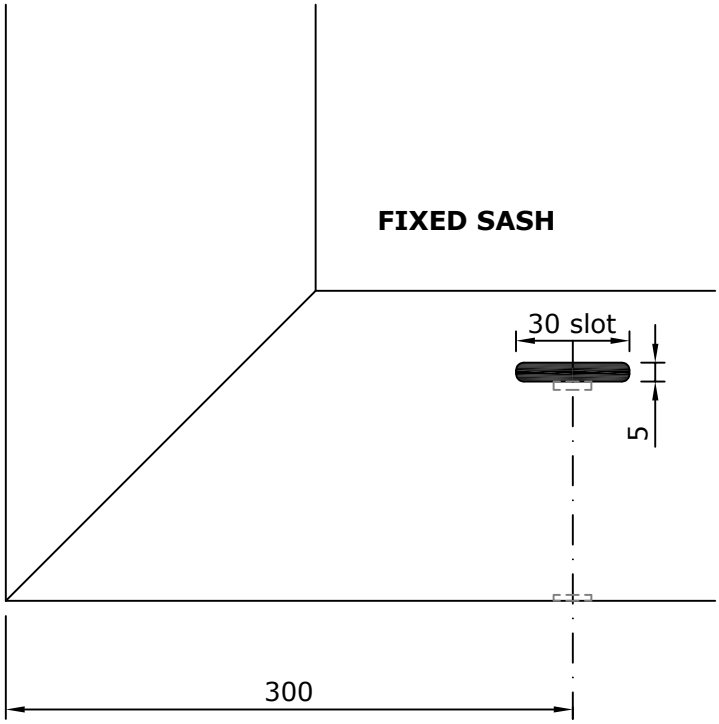
Scale 1:2

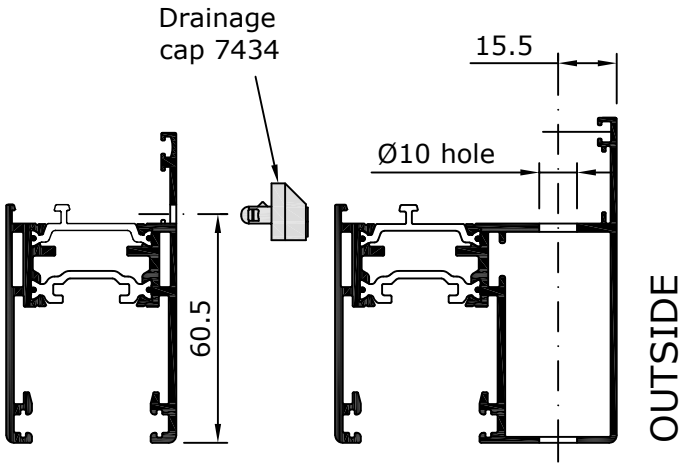
Drainage Detail
Fixed Sash

System 25 Hi
LIFT AND SLIDE DOOR
2T 3T

These details apply to all fixed sashes in 2, 3 and 4-pane configurations.

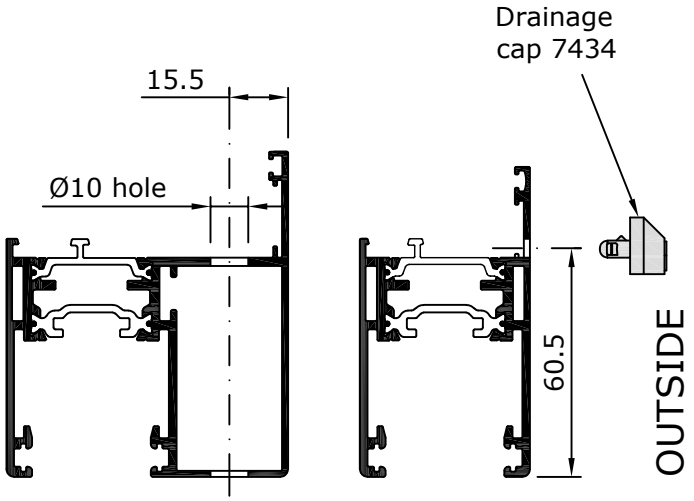






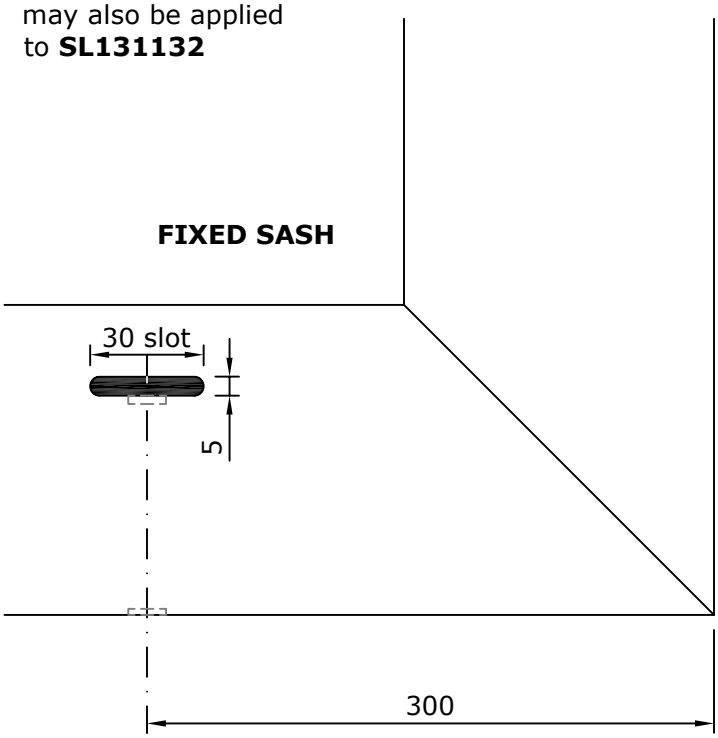
Door sash frame
SL018016
This drainage detail may also be applied to **SL131132**

Door sash frame
SL131132



Door sash frame
SL131132

Door sash frame
SL018016
This drainage detail may also be applied to **SL131132**



Concealed drainage for **SL131132**

Scale 1:2

Drainage Detail

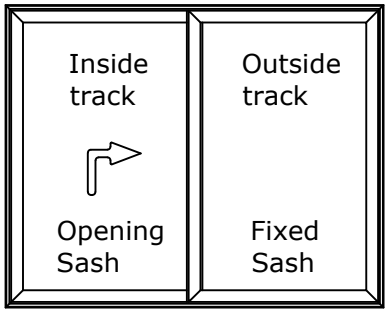
Opening Sash

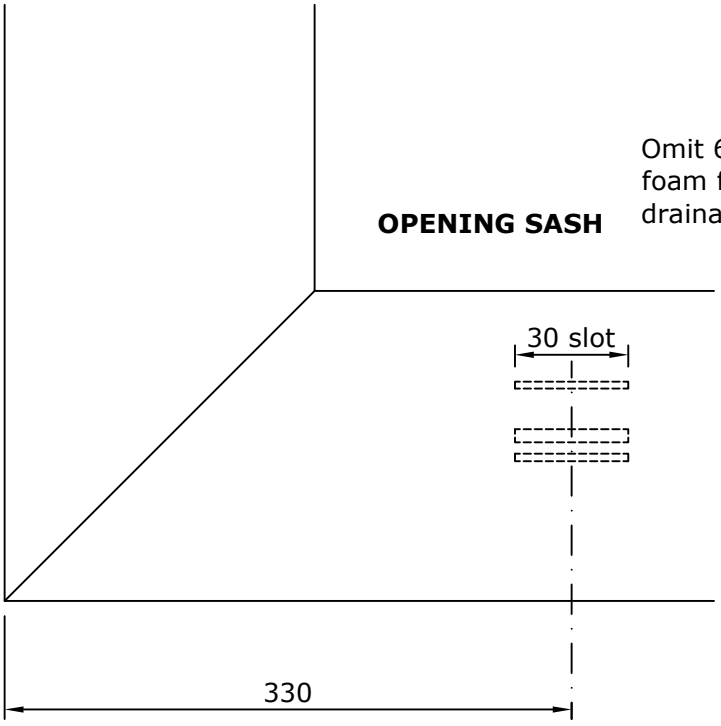
System 25 Hi+

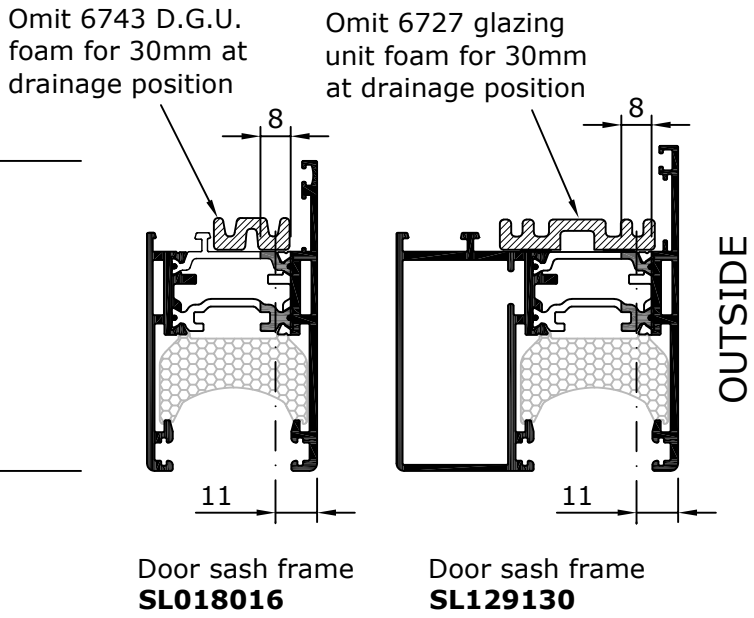
LIFT AND SLIDE DOOR

2T 3T

Positions of drainage slots are set to avoid interference with gearing.
These details apply to all lift and slide opening sashes in 2, 3 and 4-pane configurations.

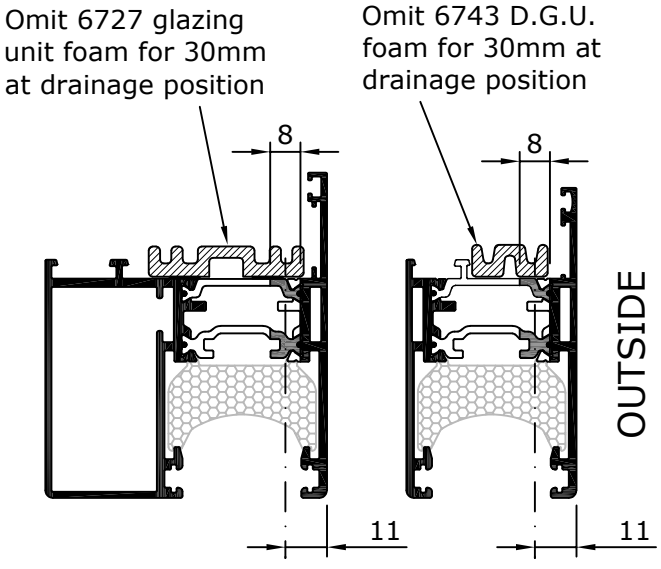






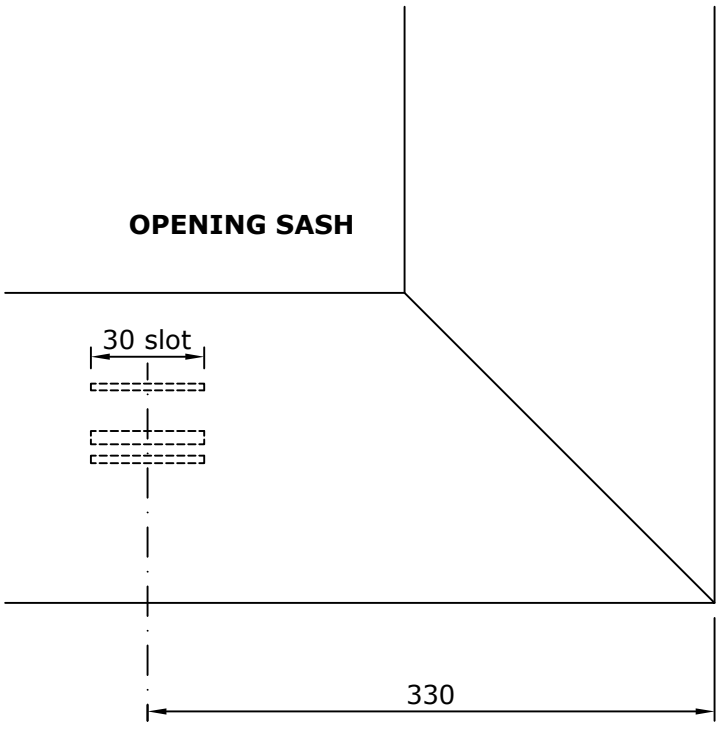
Door sash frame **SL018016**

Door sash frame **SL129130**



Door sash frame **SL129130**

Door sash frame **SL018016**



Scale 1:2

Drainage Detail

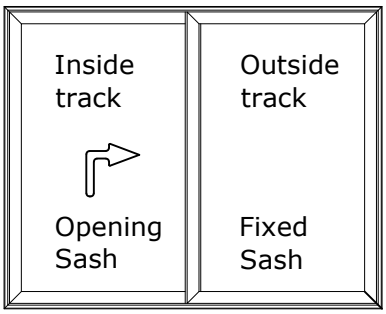
Fixed Sash

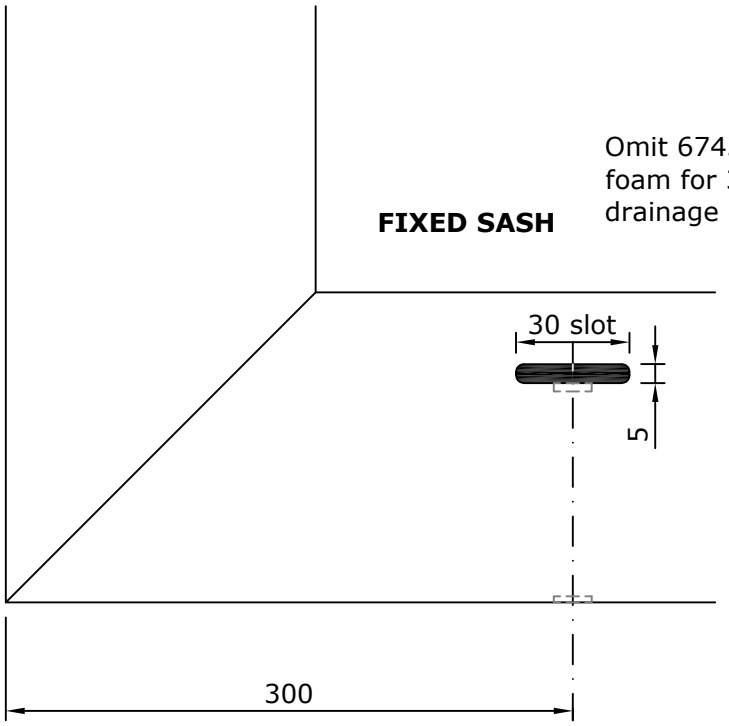
System 25 Hi+

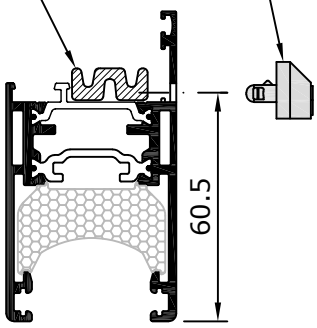
LIFT AND SLIDE DOOR

2T 3T

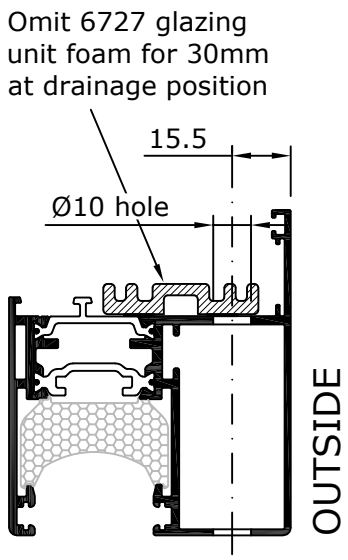
These details apply to all fixed sashes in 2, 3 and 4-pane configurations.



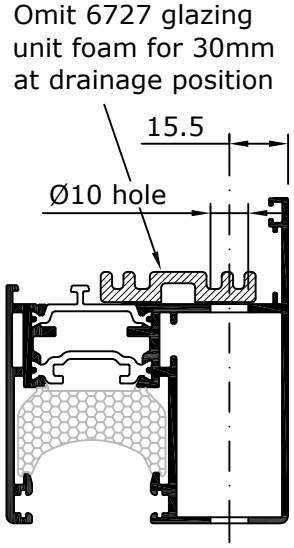




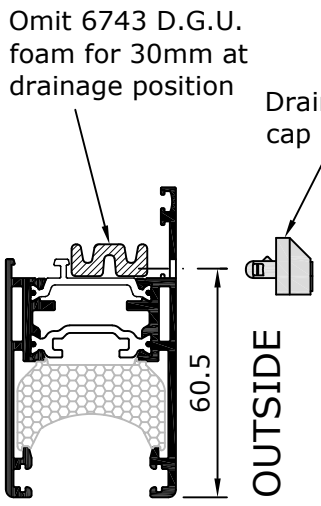
Door sash frame
SL018016
This drainage detail may also be applied to **SL131132**



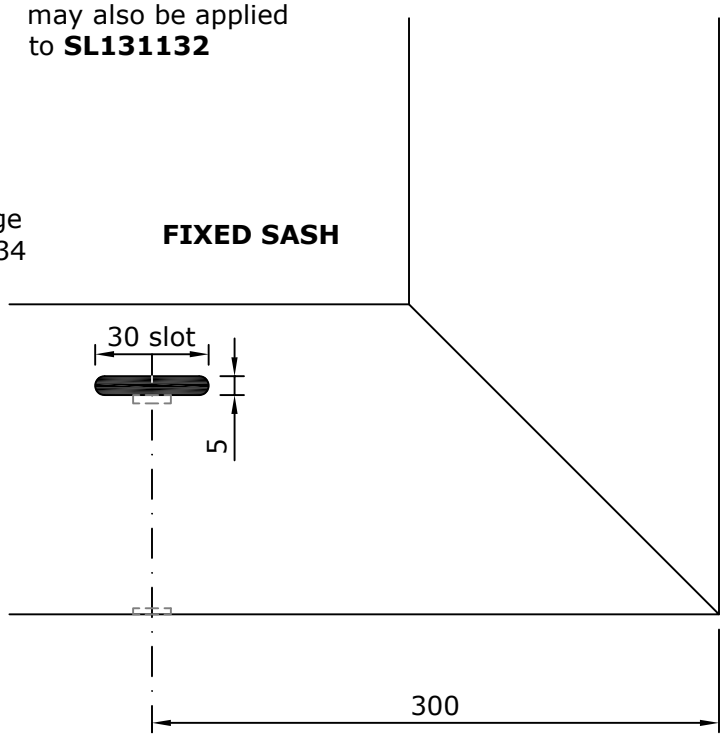
Door sash frame
SL131132



Door sash frame
SL131132



Door sash frame
SL018016
This drainage detail may also be applied to **SL131132**



Concealed drainage for **SL131132**

Scale 1:2

Drainage Detail

SL001002 Outer Frame - SL099 Foam Filler

System 25 Hi/Hi+

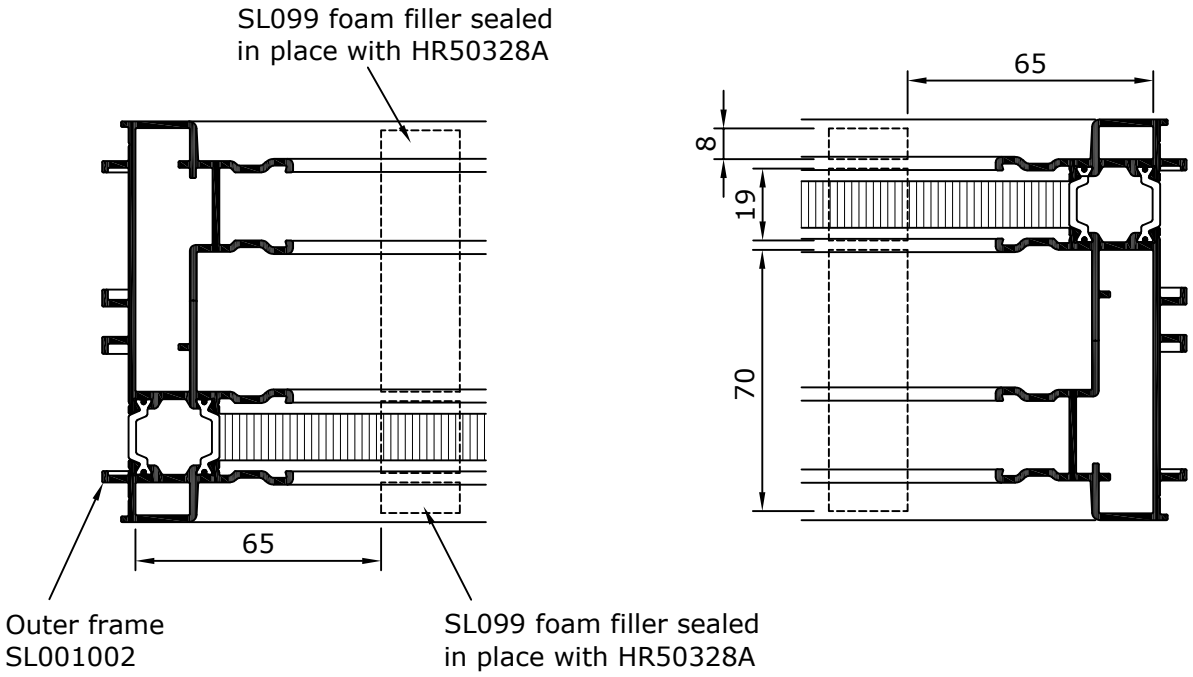
LIFT AND SLIDE DOOR

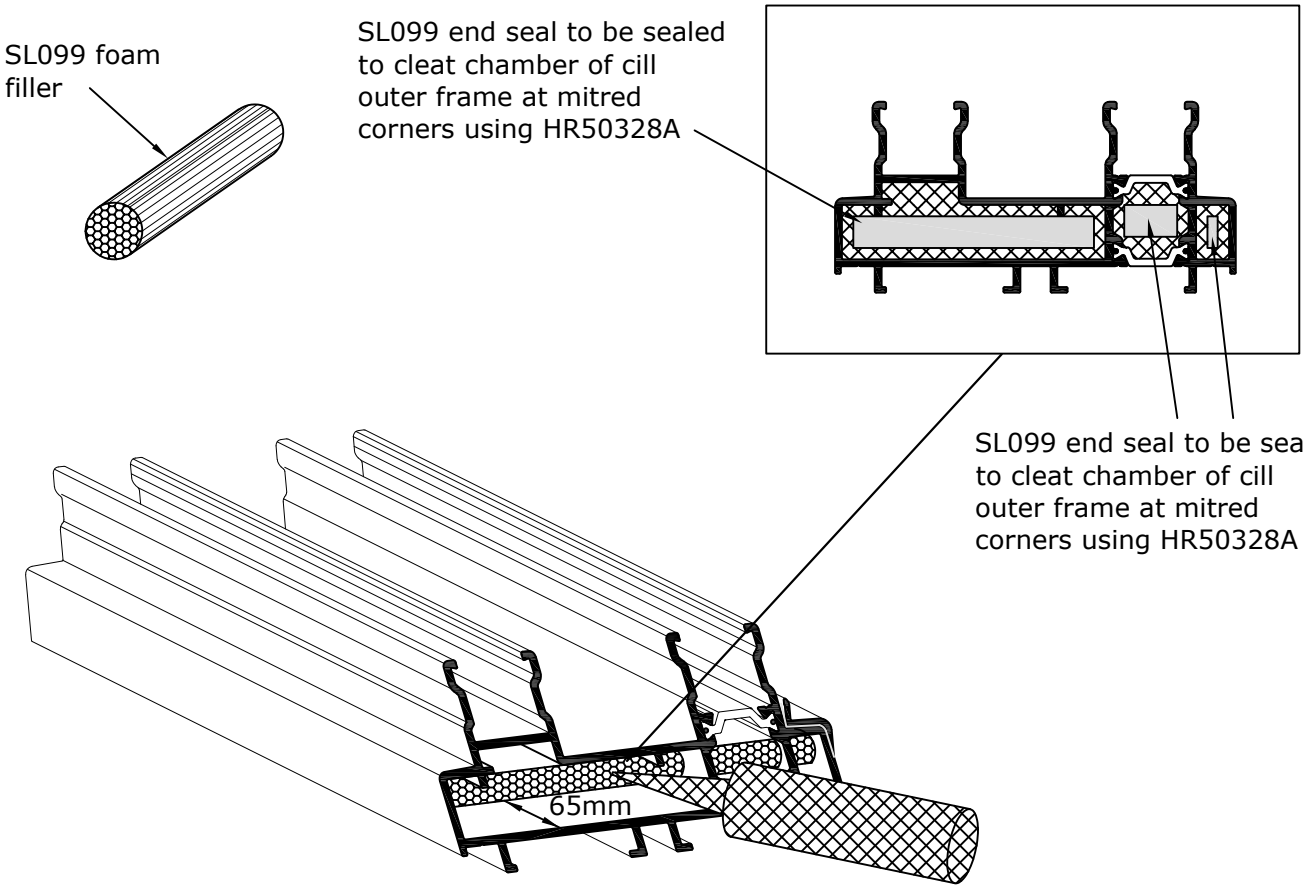
2T

SL099 foam filler is sold per metre. To be cut to size as shown below.

Drainage end seals, cut by fabricator from SL099 foam filler, should be fitted to outer frame cill member at mitred corners.

Upon completion, check seal by looking through profile against a light source.





Not to scale

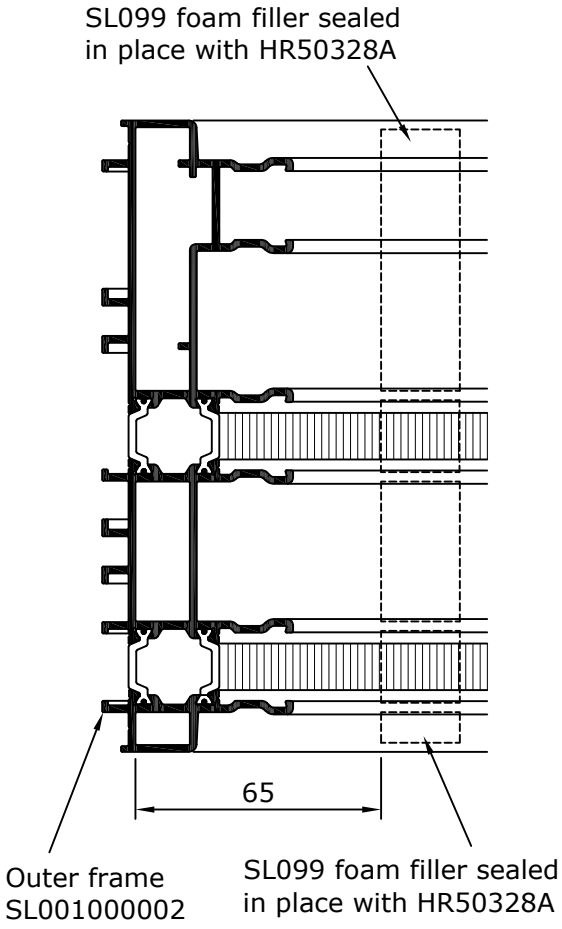
Drainage Detail

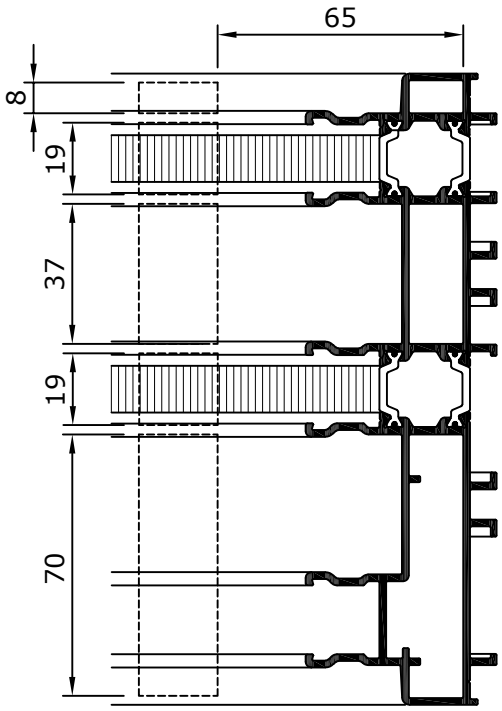
SL001000002 Outer Frame - SL099 Foam Filler

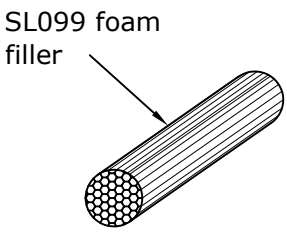
SL099 foam filler is sold per metre. To be cut to size as shown below.

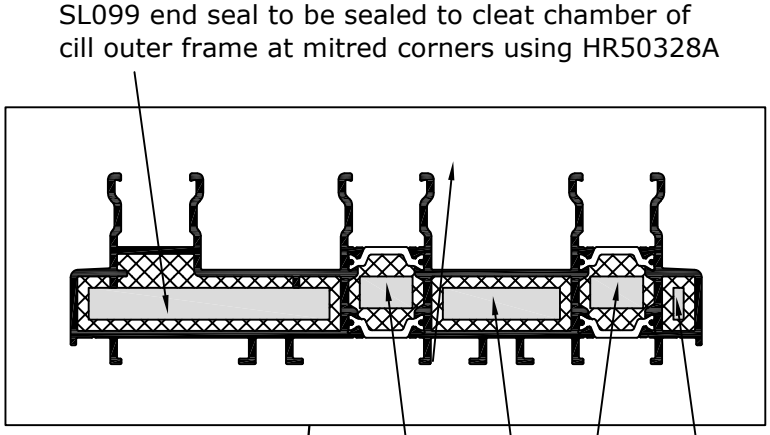
Drainage end seals, cut by fabricator from SL099 foam filler, should be fitted to outer frame cill member at mitred corners.

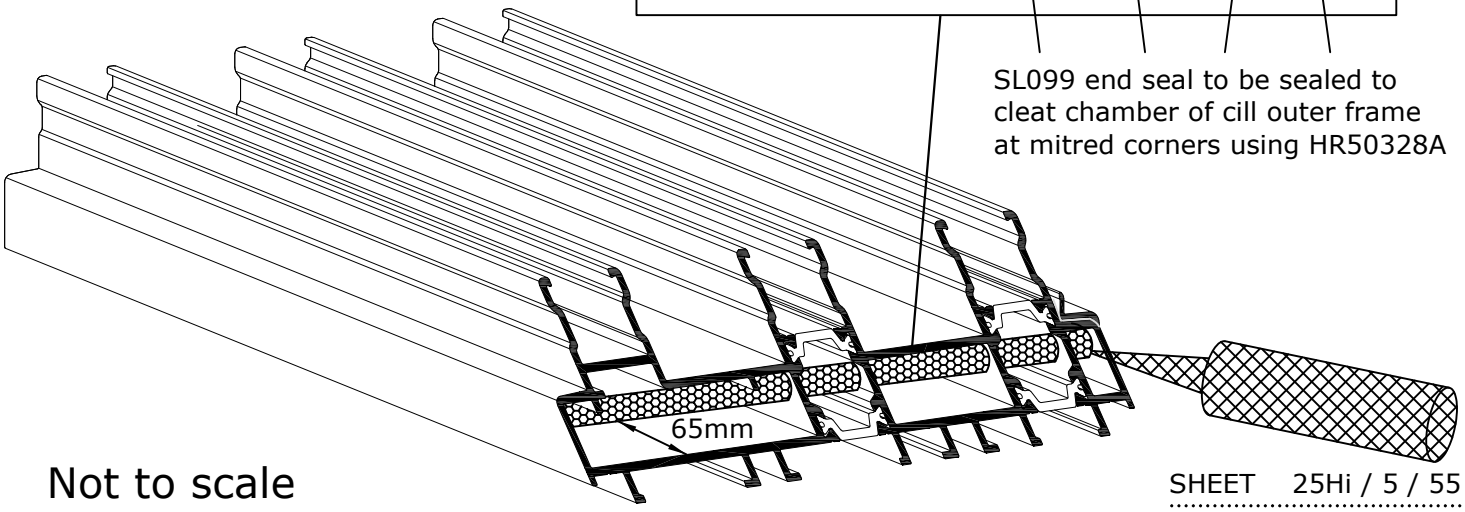
Upon completion, check seal by looking through profile against a light source.











Not to scale

Drainage Detail

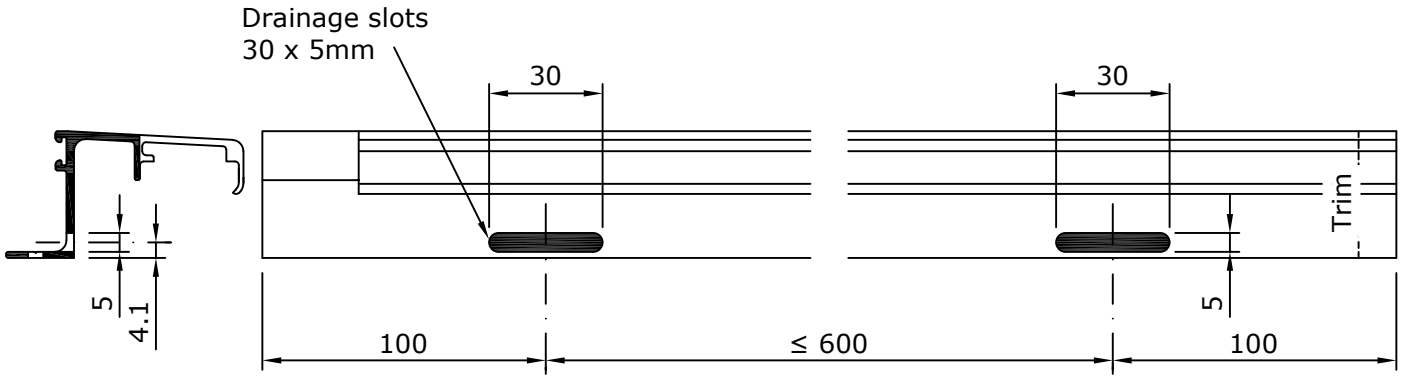
Outer Frame - SL033 Outer Frame Trim

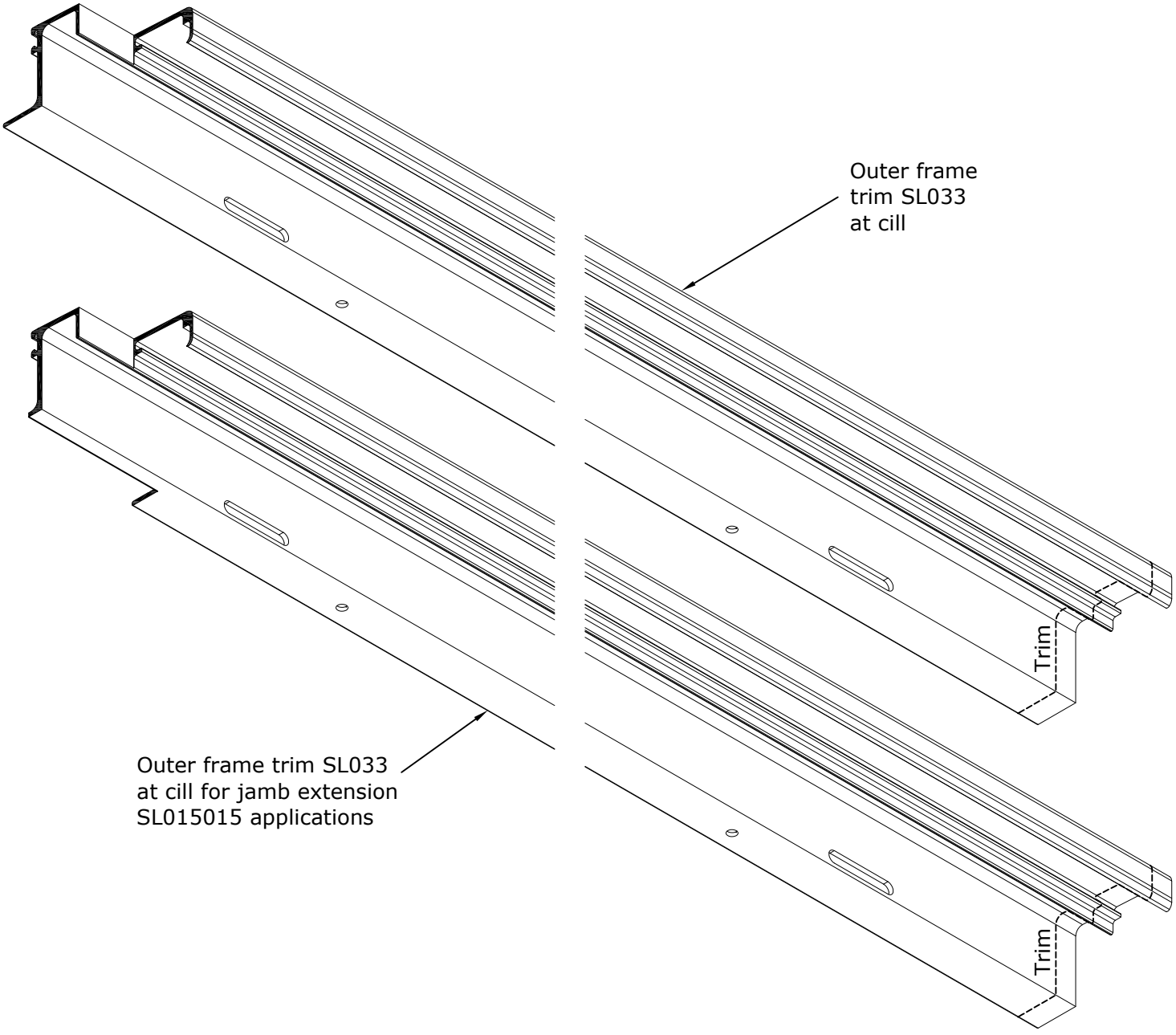
System 25 Hi/Hi+

LIFT AND SLIDE DOOR

2T 3T

This sheet to be read in conjunction with "Outer Frame Trim SL033 Prep Details" sheets.





Not to scale

Drainage Detail

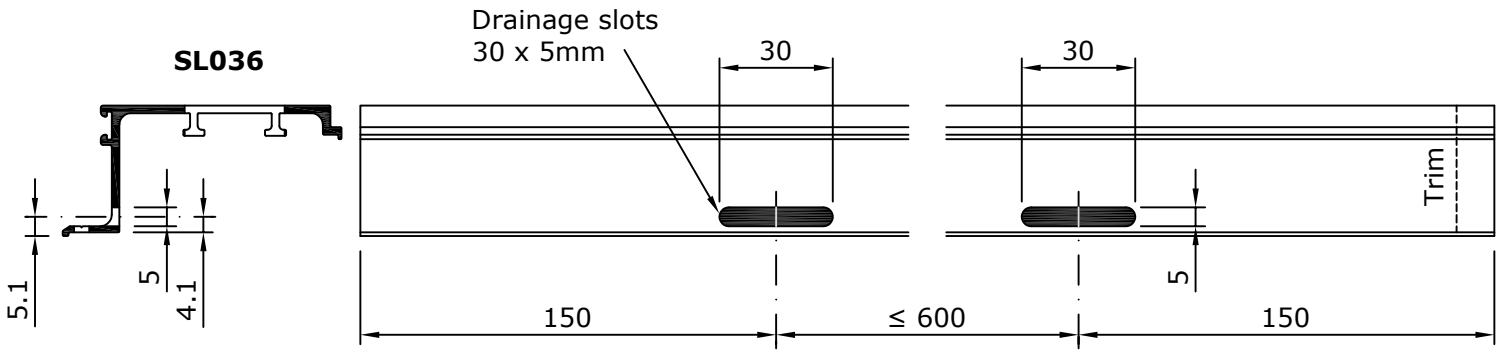
Outer Frame - SL033 and SL036 Outer Frame Trim

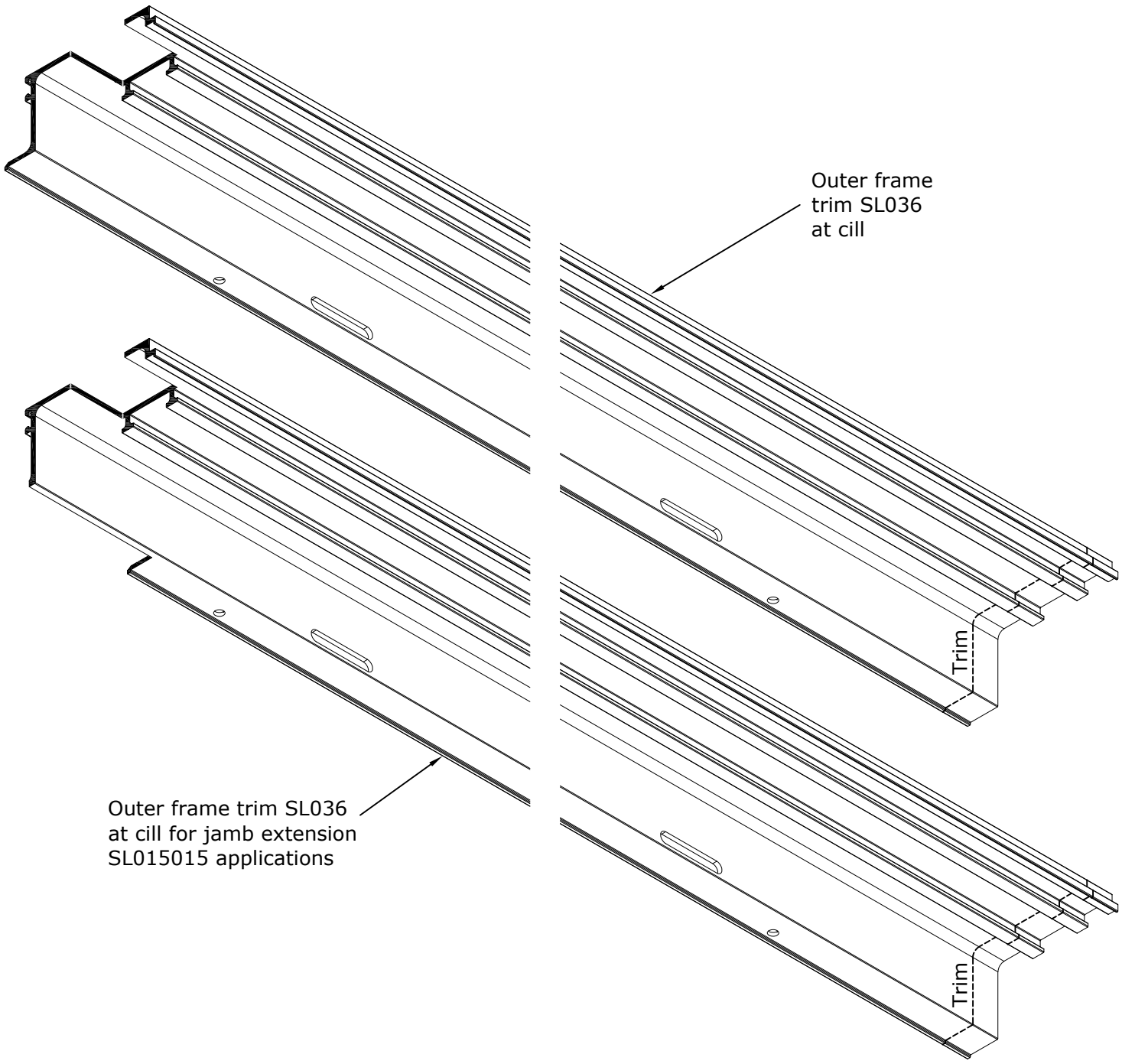
System 25 Hi/Hi+

LIFT AND SLIDE DOOR

3T

This sheet to be read in conjunction with "Outer Frame Trim SL033 and SL036 Prep Details" sheets.





Not to scale

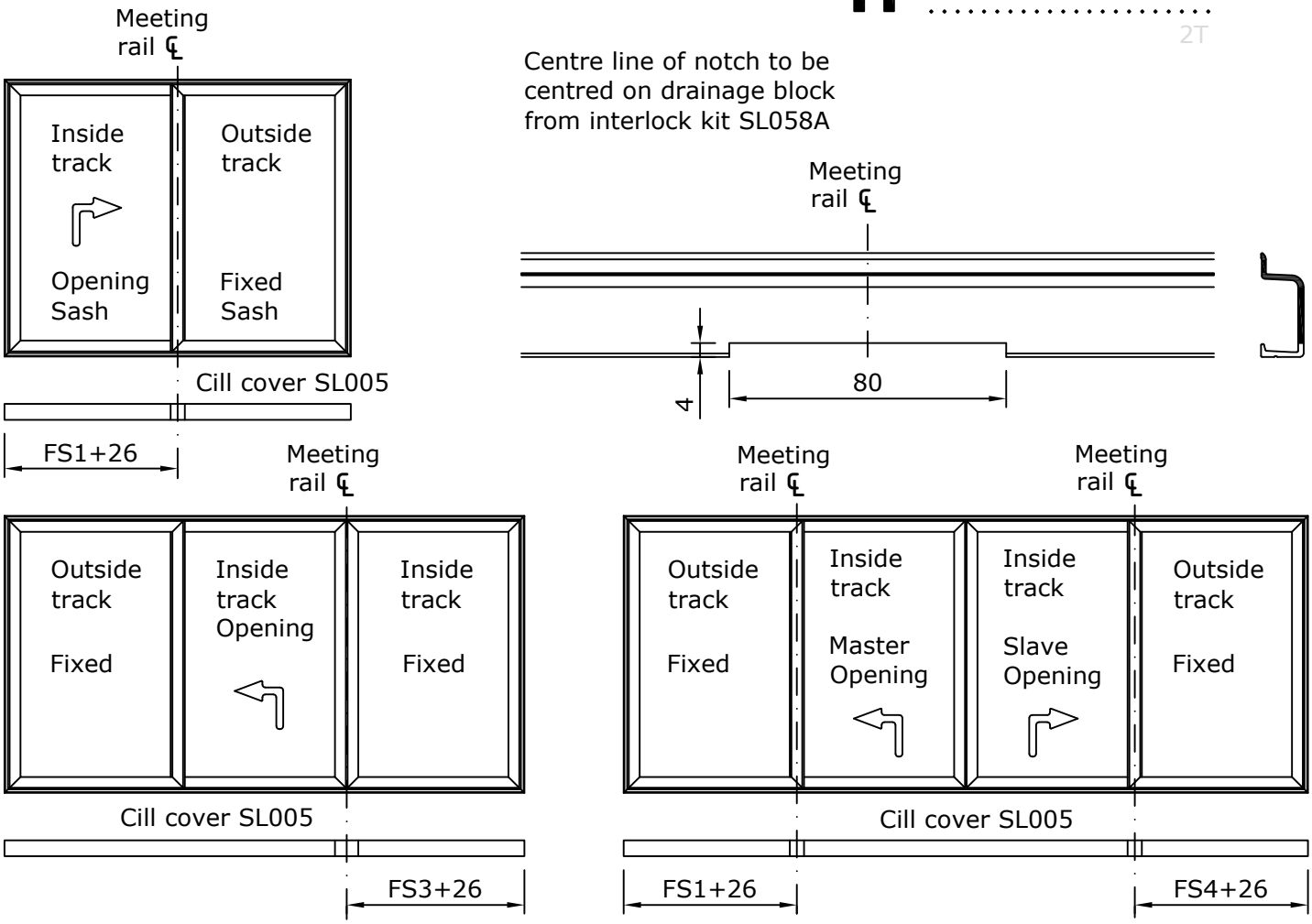
Drainage Detail

SL001002 Outer Frame - SL005 Cill Cover

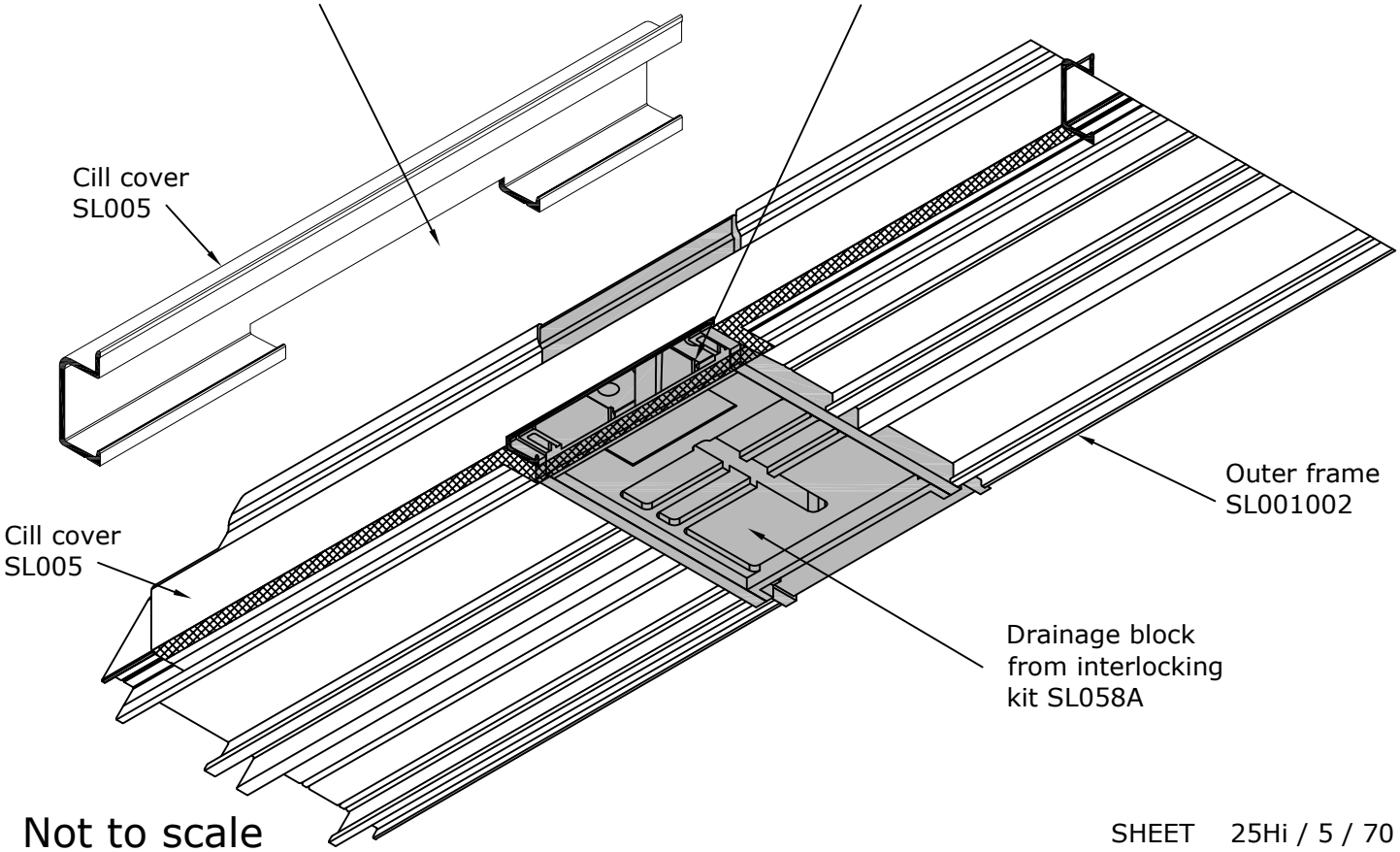
System 25 Hi/Hi+

LIFT AND SLIDE DOOR

2T



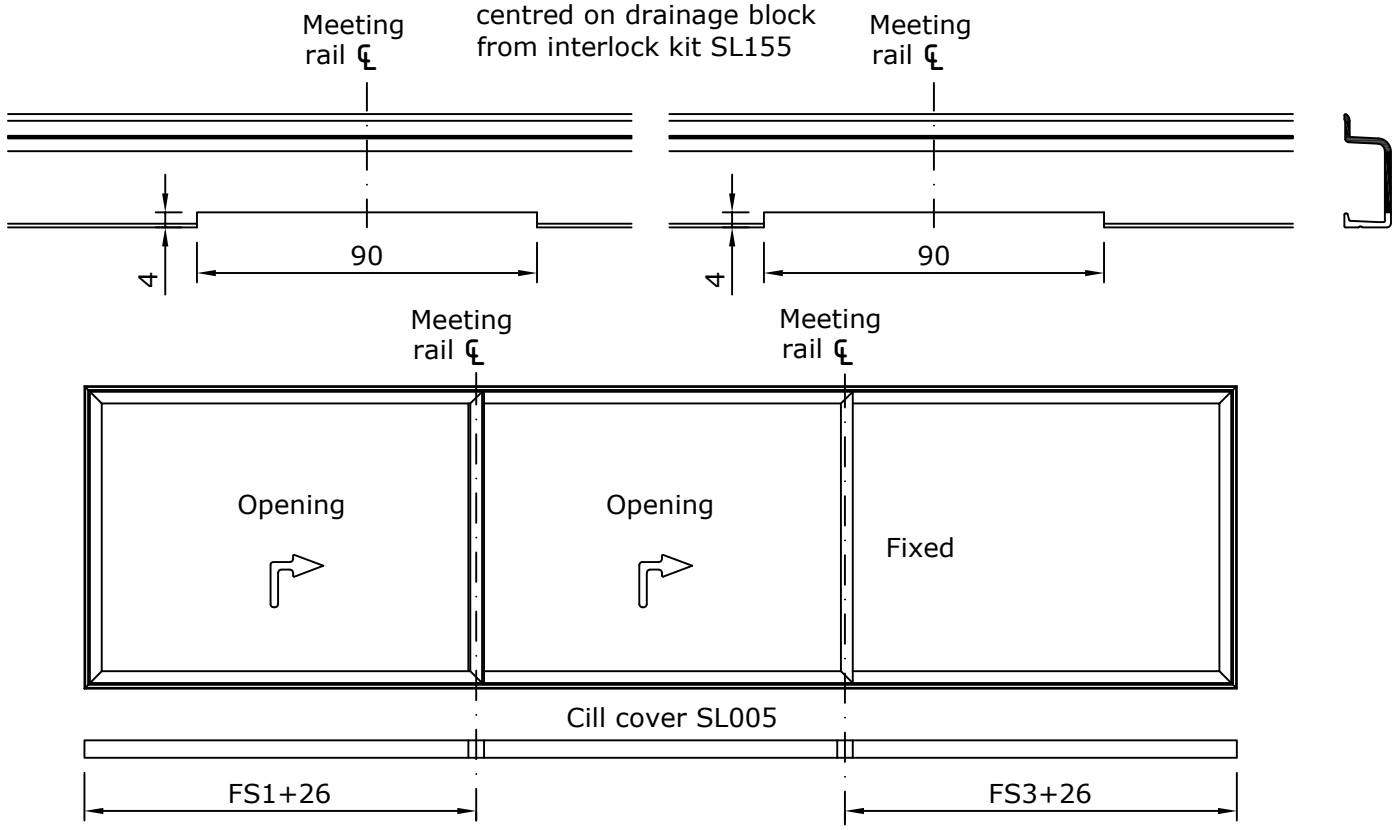
Outside cill piece notched for drainage (punch tool JIG25001-2 / JIG25001-3). Drawing illustrates position of notch centred on drainage block. Refer to "Head and Cill Profile Assembly" sheets in Section 6.



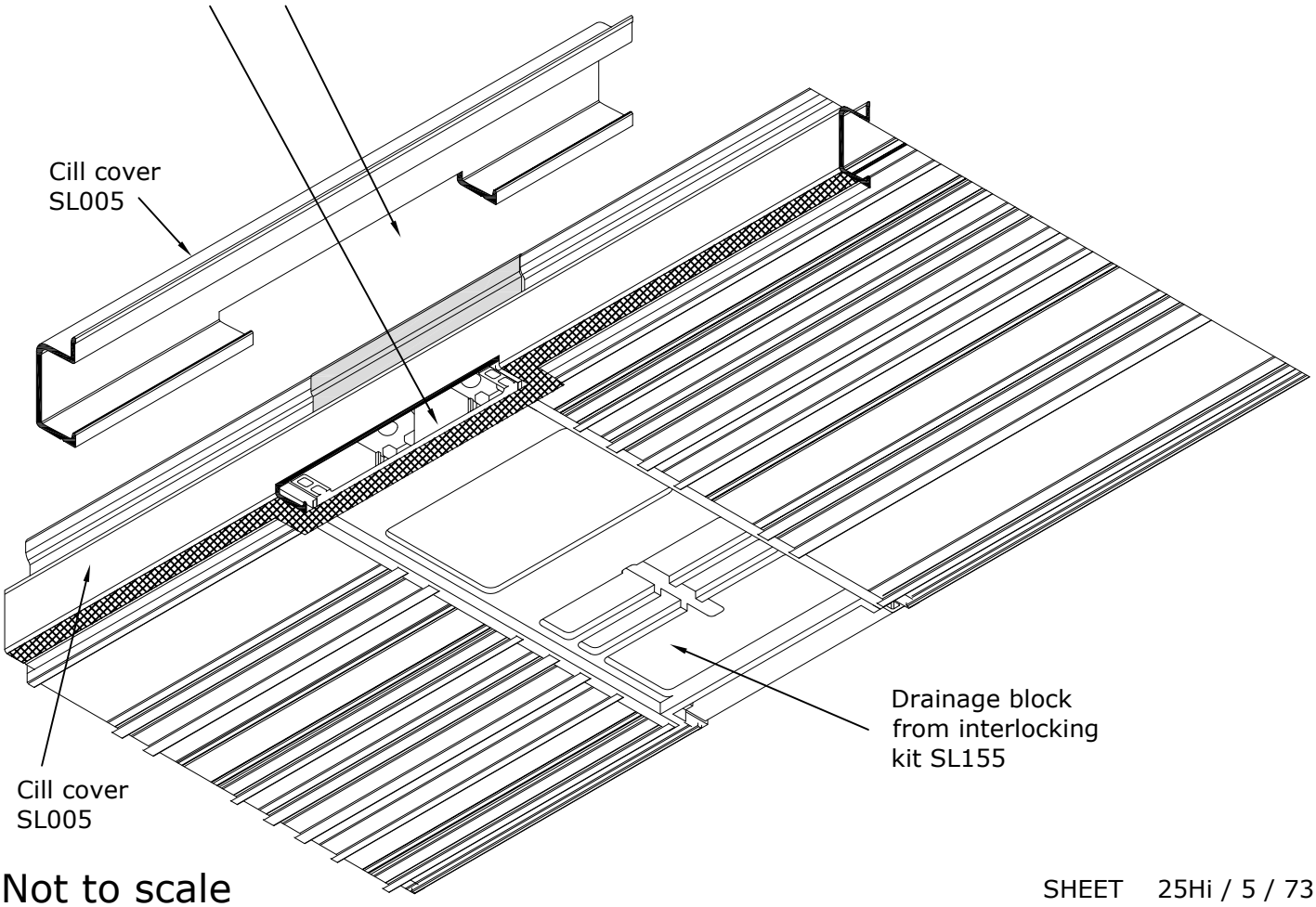
Not to scale

Drainage Detail

SL001000002 Triple Track Outer Frame - SL005 Cill Cover



Outside cill piece notched for drainage (punch tool JIG25001-3). Drawing illustrates position of notch centred on drainage block. Refer to "Head and Cill Profile Assembly" sheets in Section 6.



Not to scale

Head and Cill Profile Assembly

Drainage Block from SL058A Interlock Kit

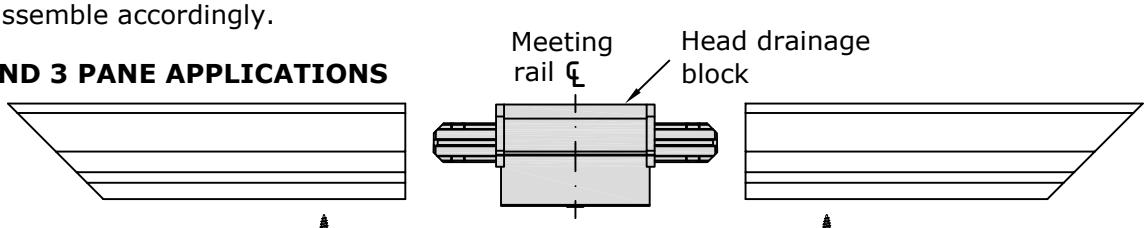
System 25 Hi/Hi+

LIFT AND SLIDE DOOR

2T

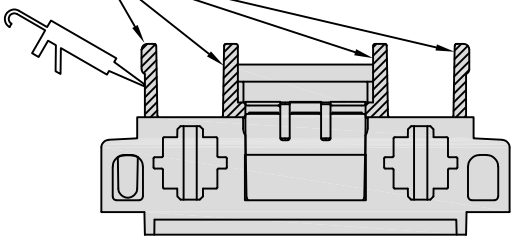
Fabricator to note position of polyamide strip relative to opening sash and to assemble accordingly.

2 AND 3 PANE APPLICATIONS

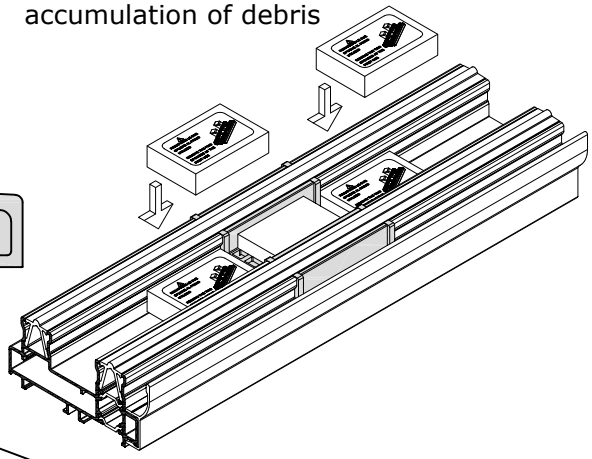


No 8 x 12mm screws to secure SL001002 outer frame to drainage block from SL058A interlock kit. 4 per joint.

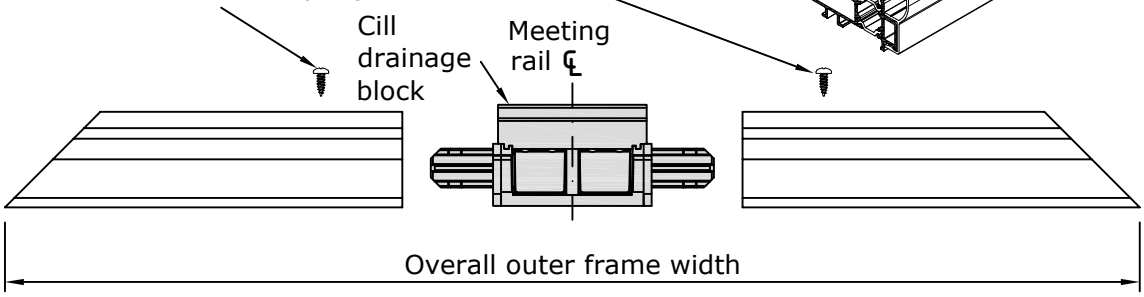
Silicone upper legs of drainage block from SL058A interlock kit prior to securing to outer frame



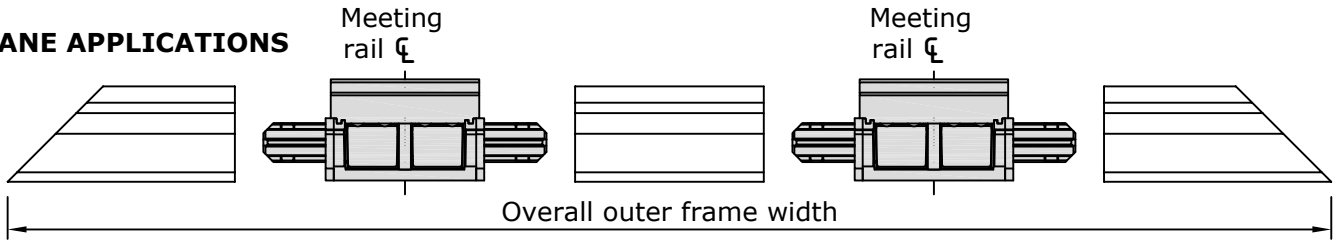
Temporarily fit "sponge" blocks as indicated to help protect cill drainage block from the accumulation of debris

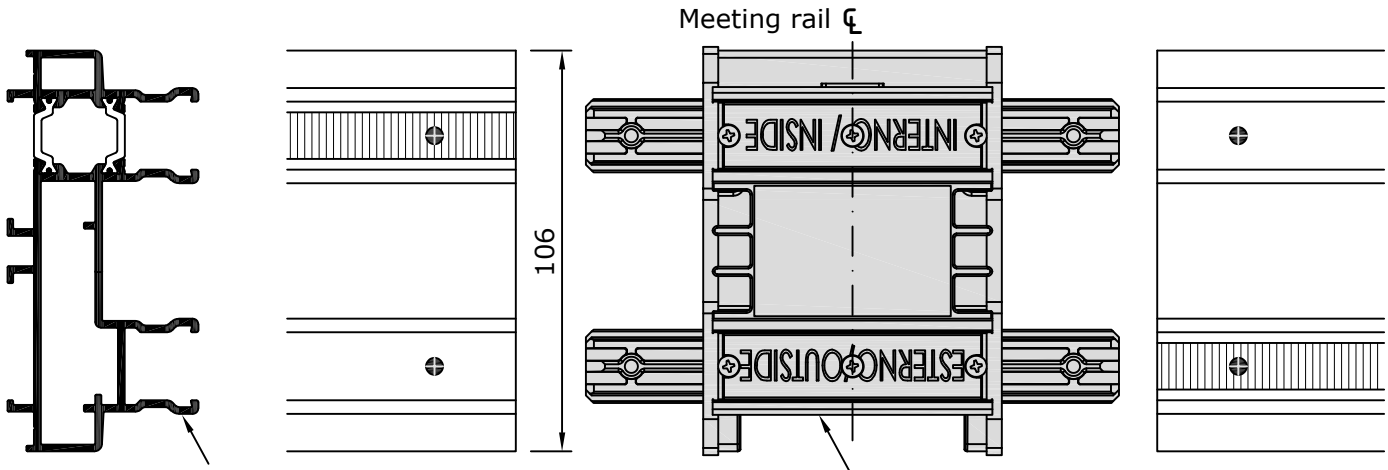


No 8 x 12mm screws to secure SL001002 outer frame to drainage block from SL058A interlock kit. 4 per joint.



4 PANE APPLICATIONS



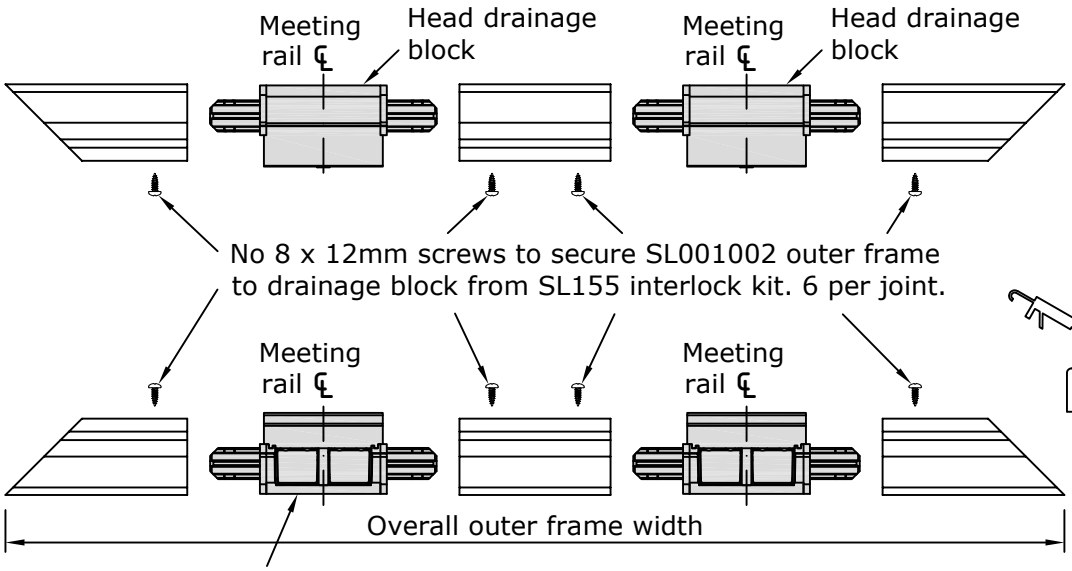


Not to Scale

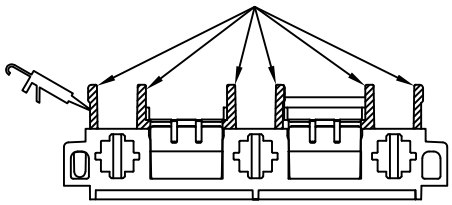
Head and Cill Profile Assembly

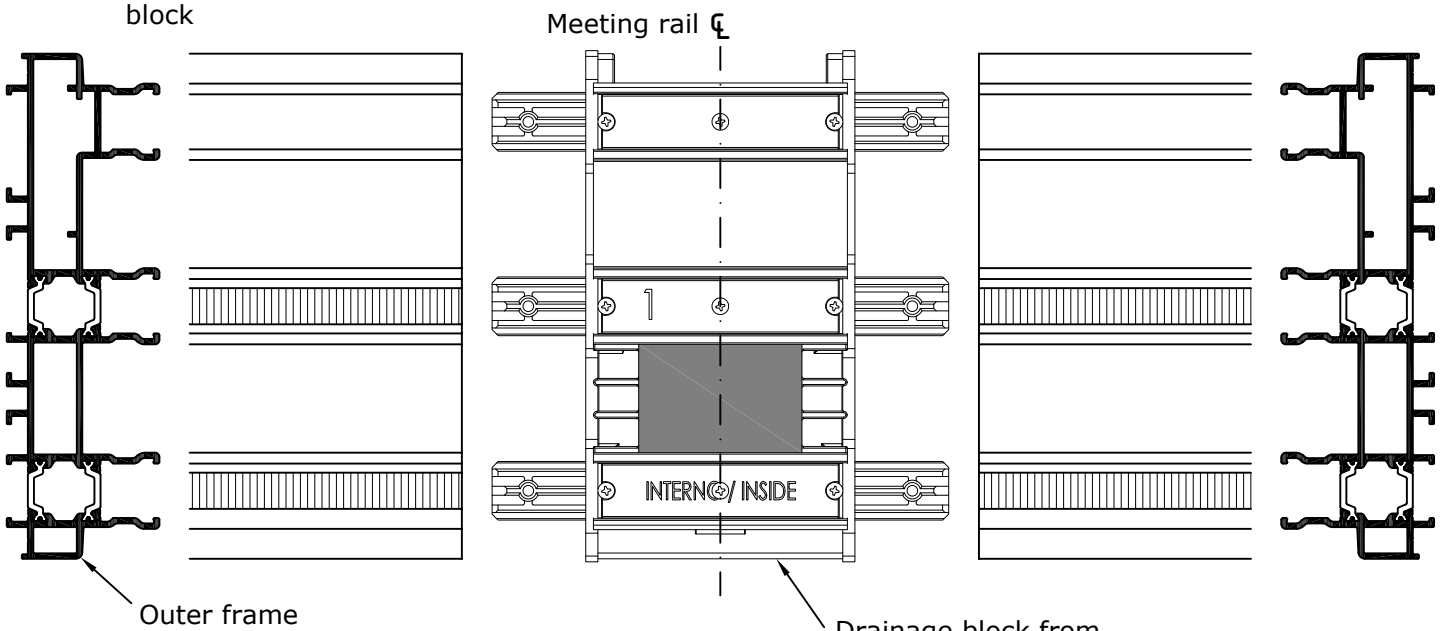
Drainage Block from SL155 Interlock Kit

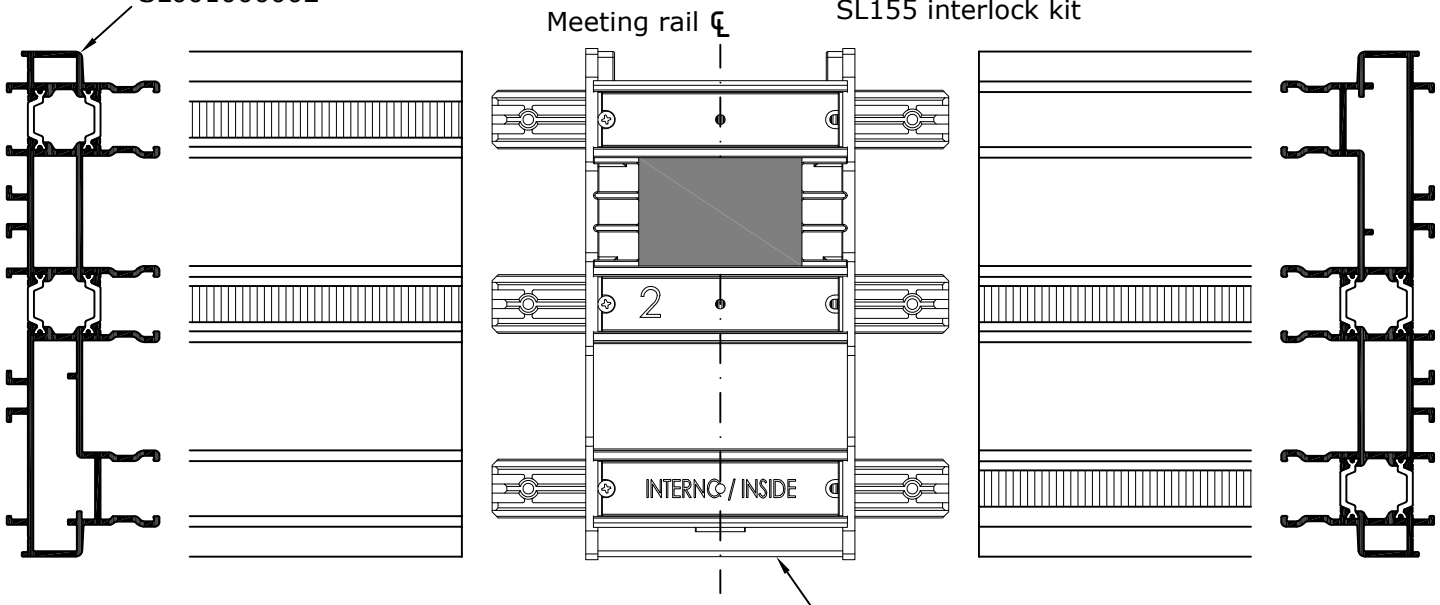
Fabricator to note position of polyamide strip relative to opening sash and to assemble accordingly.



Silicone upper legs of drainage block from SL155 interlock kit prior to securing to outer frame





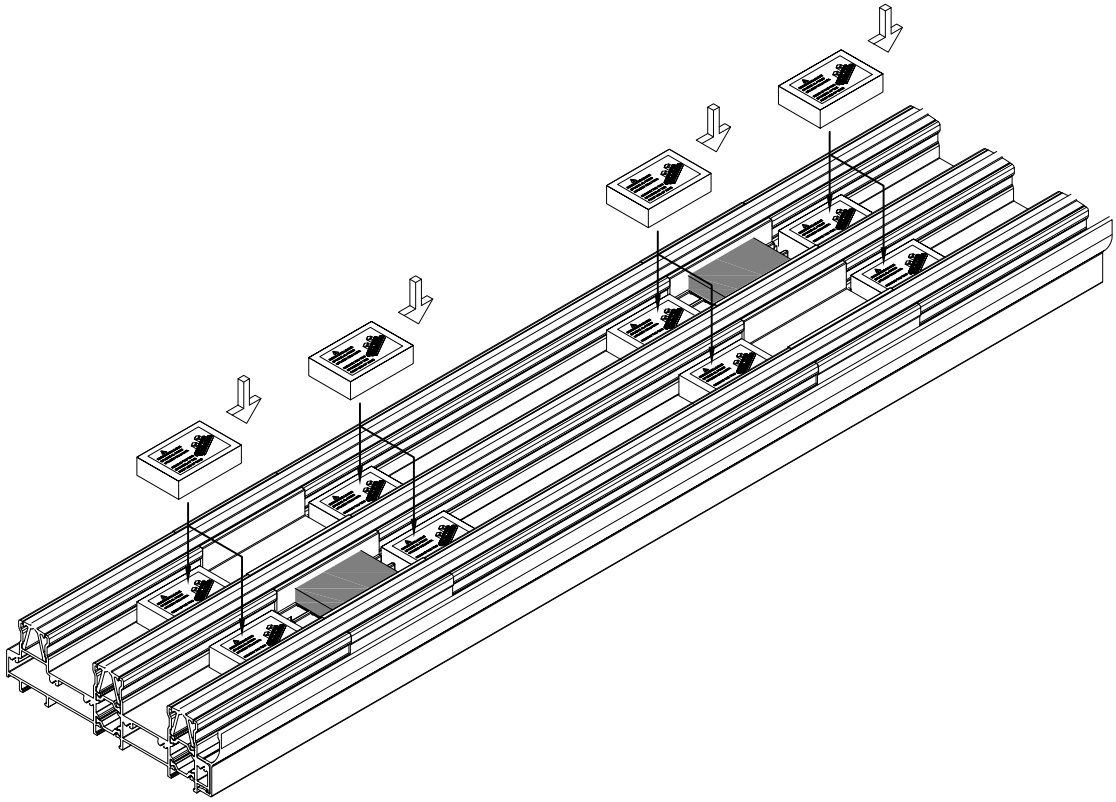


Not to Scale

Head and Cill Profile Assembly

Drainage Block from SL155 Interlock Kit

Temporarily fit "sponge" blocks as indicated to help protect cill drainage block from the accumulation of debris.



Not to Scale

Head and Cill Profile Assembly

Application of SL005 and SL006/SL135 to SL001002 Outer Frame

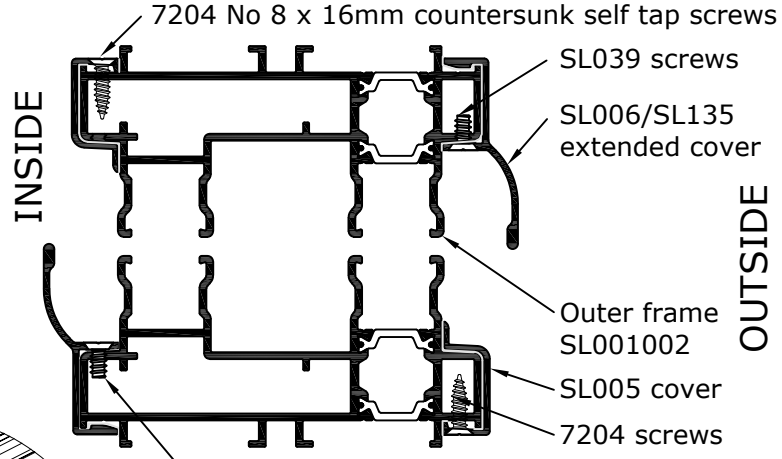
System 25 Hi/Hi+

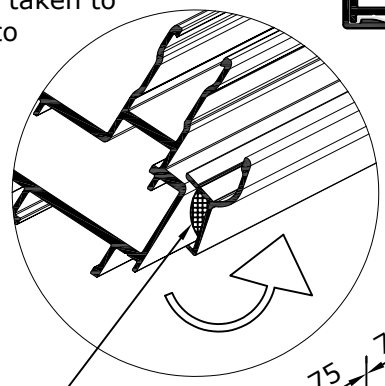
LIFT AND SLIDE DOOR

Fabricator to select SL006 or SL135 extended cover to suit sash profile. SL006 to be used with SL018016, SL135 to be used with sashes SL129130/SL131132.

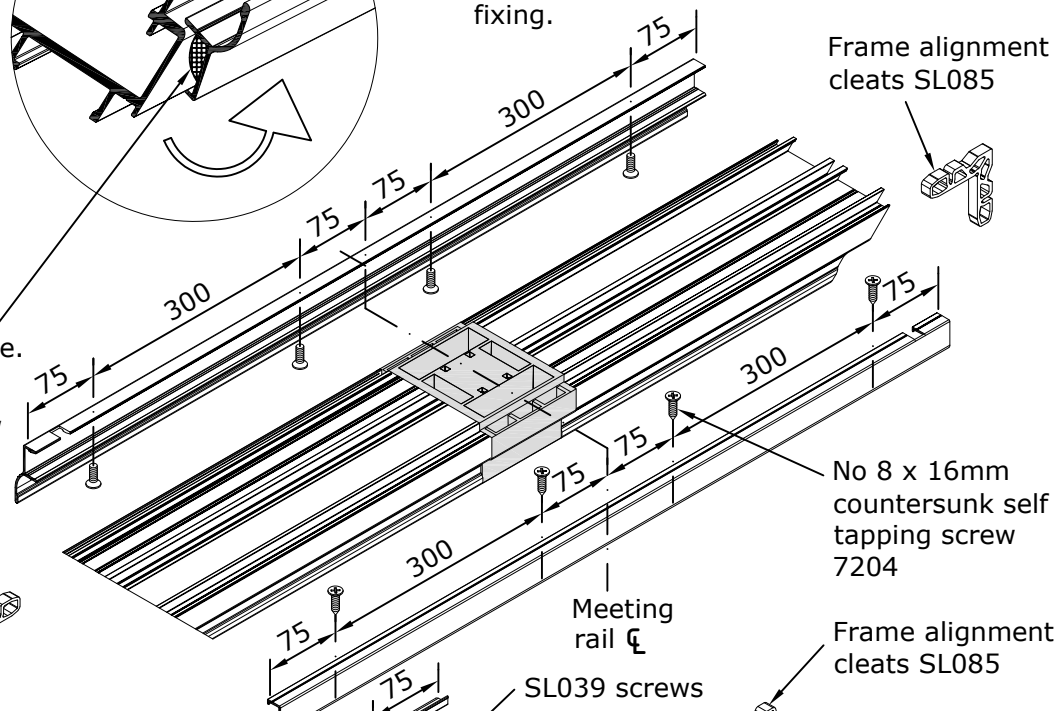
1. Apply sealant to full length of SL006/SL135 extended cover at cill only as shown.
2. Temporarily locate SL005 and SL006/SL135 covers centrally* on assembled outer frame head and cill profiles, orientated as shown.
3. Drill and countersink 3.5mm Ø pilot holes from directions shown, 75mm from each end and 75mm either side of the centre line of drainage blocks from SL058A interlock kit, and at not greater than 300mm centres.
4. Secure covers in place using screws as shown. Special care to be taken to seal SL039 screws at cill to ensure watertight fixing.

* If using SL015015 jamb extension, shorter lengths of SL005 and SL006/SL135 to be off-set by 65mm and 67.5mm respectively from the end of outer frame at the jamb extension side.

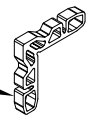


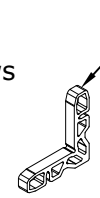


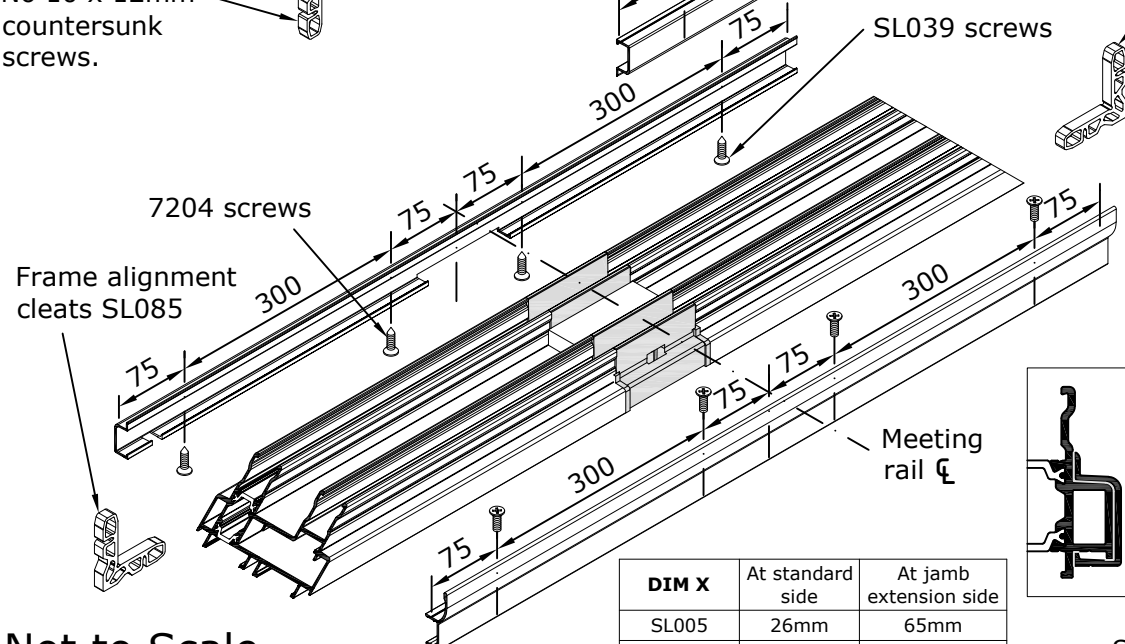
Apply sealant prior to locating SL006/SL135 cill cover, and rotate into place.

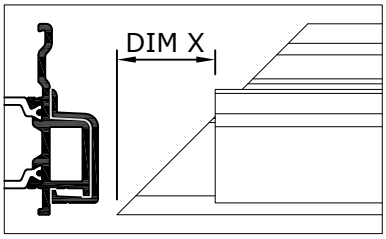


Prior to fitting SL005 and SL006/SL135 cover, screw fix frame alignment cleats SL085 into small cleat chambers in assembled head and cill outer frame through pre-punched 6mm Ø holes using No 10 x 12mm countersunk screws.







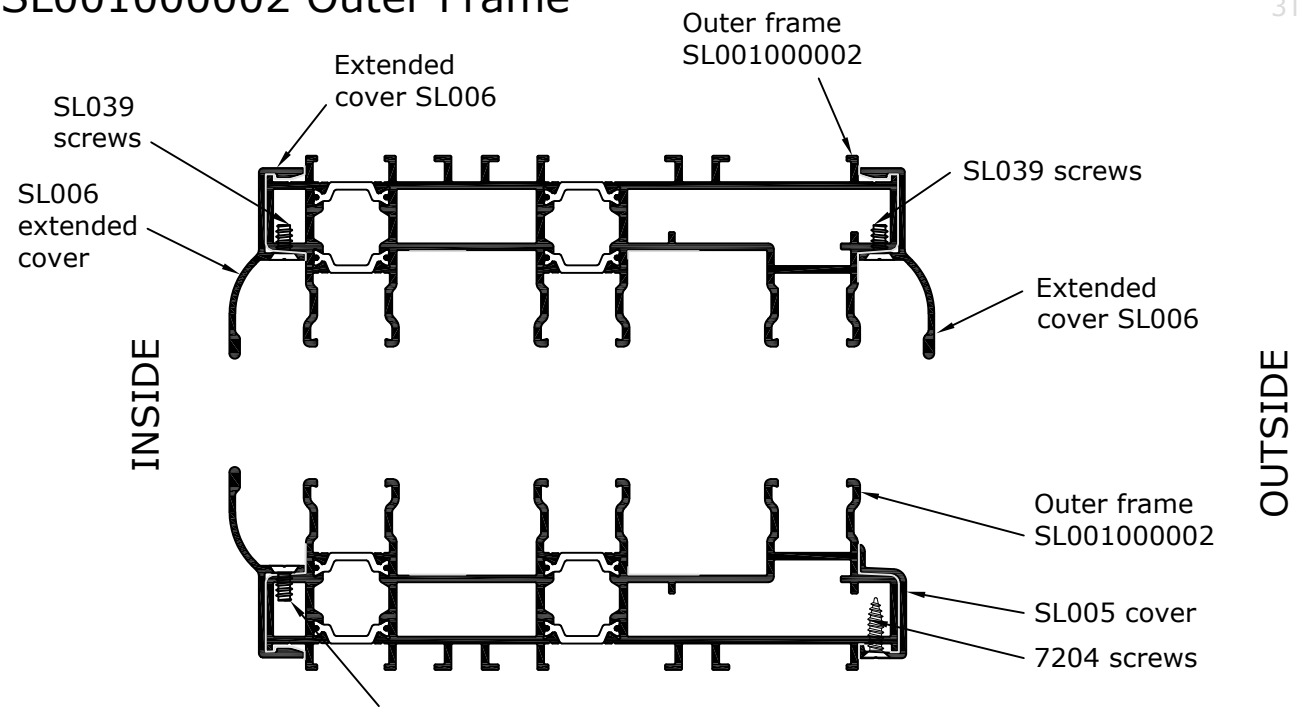


DIM X	At standard side	At jamb extension side
SL005	26mm	65mm
SL006 / SL135	28.5mm	67.5mm

Not to Scale

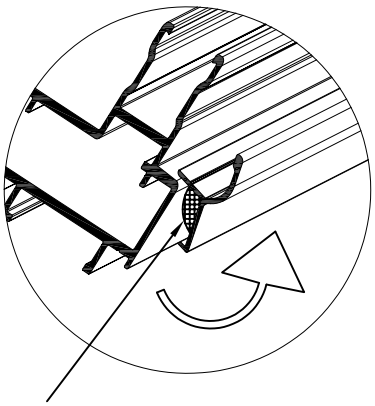
Head and Cill Profile Assembly

Application of SL005 and SL006 to SL001000002 Outer Frame

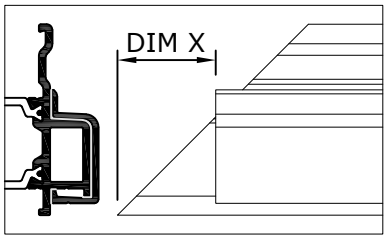


1. Apply sealant to full length of SL006 extended cover at cill only as shown.
2. Temporarily locate SL005 and SL006 covers centrally* on assembled outer frame head and cill profiles, orientated as shown.
3. Drill and countersink 3.5mm Ø pilot holes from directions shown, 75mm from each end and 75mm either side of the centre line of drainage blocks from SL155 interlock kit, and at not greater than 300mm centres.
4. Secure covers in place using screws as shown. Special care to be taken to seal SL039 screws at cill to ensure watertight fixing.

*If using SL015015 jamb extension, shorter lengths of SL005 and SL006 to be off-set by 65mm and 67.5mm respectively from the end of outer frame at the jamb extension side.



Apply sealant prior to locating SL006 cill cover, and rotate into place.



DIM X	At standard side	At jamb extension side
SL005	26mm	65mm
SL006	28.5mm	67.5mm

Scale 1:2

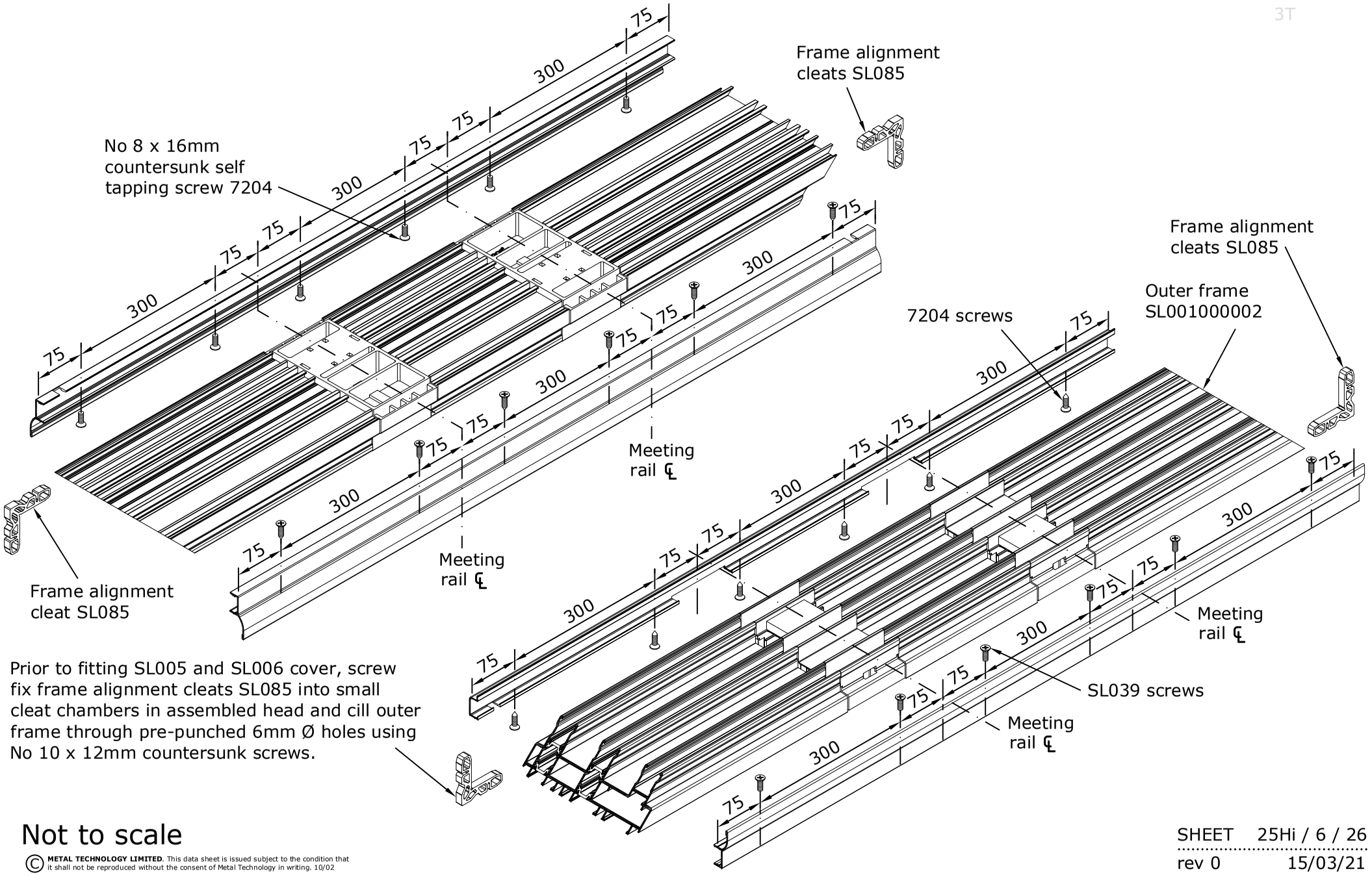
Head and Cill Profile Assembly

Application of SL005 and SL006 to SL001000002 Outer Frame

System 25 Hi/Hi+

LIFT AND SLIDE DOOR

3T



Prior to fitting SL005 and SL006 cover, screw fix frame alignment cleats SL085 into small cleat chambers in assembled head and cill outer frame through pre-punched 6mm Ø holes using No 10 x 12mm countersunk screws.

Not to scale

Corner Assembly Detail

Outer Frame SL001002

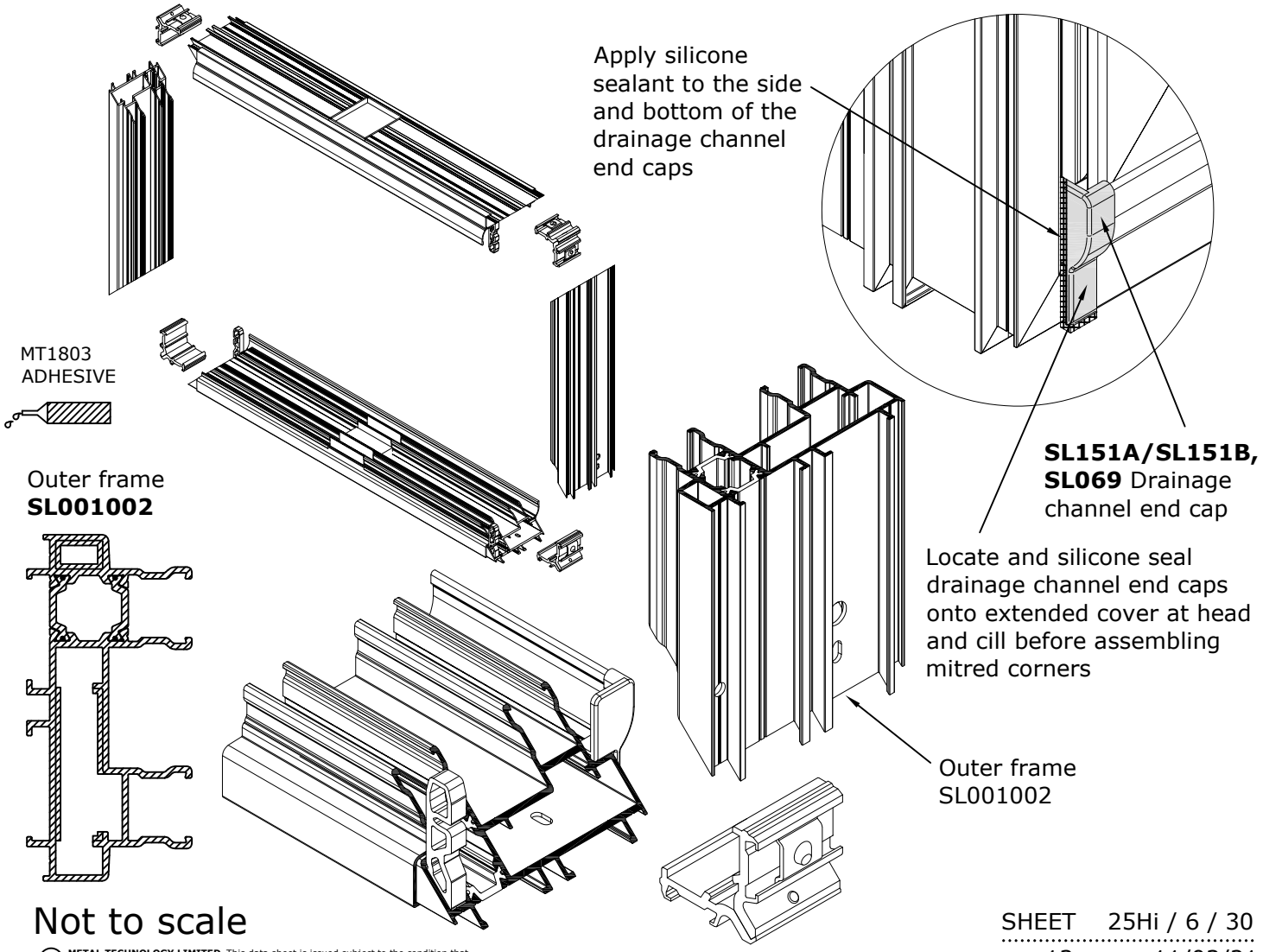
System 25 Hi/Hi+

LIFT AND SLIDE DOOR

IMPORTANT: PLEASE READ THESE NOTES BEFORE CORNER ASSEMBLY. 2T

METAL TECHNOLOGY RECOMMEND THE USE OF MT1803 ADHESIVE TO ENSURE THE STABILITY OF CORNER JOINTS. PARTICULAR ATTENTION SHOULD BE PAID TO THE BONDING OF THE CORNER CLEATS TO THE PROFILE.

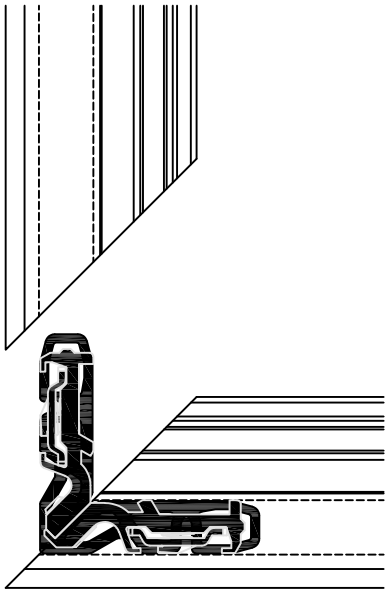
1. Prior to joining outer frame corners fabricator must assemble head and cill outer frame profiles using drainage block from SL058A interlock kit. Ensure ends of cill outer frame profile are sealed using SL099 foam filler, frame alignment cleats SL085 are fixed to head and cill, and SL005/SL006/SL135 covers are fitted.
2. Before applying MT1803 adhesive, ensure all surfaces to be glued are free from grease or dust. Clean all aluminium mating surfaces with MT60 surface cleaner and allow to dry. Fabricator must ensure MT60 surface cleaner is fully compatible with surface finish on a project-by-project basis.
3. Locate and silicone seal SL069 or SL151A/SL151B drainage channel end caps onto SL006 or SL135 extended cover at head and cill.
4. Apply MT1803 adhesive to the mating surfaces of the mitre cut aluminium and thermal break profiles. Adhesive need only be applied to one side of the mitred joint.
5. Apply MT1803 adhesive to the internal perimeter of the cleat chambers. This must be applied to both sides of the mitred joint and to sufficient depth to ensure full bonding/sealing of the cleats.
6. Insert SL086 mechanical cleats and push sections together. Ensure mitred joint is aligned and true.
7. Secure corners by tightening machine screw in mechanical cleat SL086 using 4mm allen key.
8. Secure SL085 alignment cleat to jambs using No 10 x 12mm countersunk screws through uncountersunk 6mm Ø hole in small cleat chamber.
9. Wipe away any excess adhesive from the mitred joint using MT60 surface cleaner and allow to dry. Ensure surfaces are clear of adhesive.
10. Seal access holes and slots for cleats with HR50328A sealant.
11. Check the mitre is tight on both sides and that there is no movement.
12. For larger doors fabricators may wish to assemble outer frame on site for ease of transport.

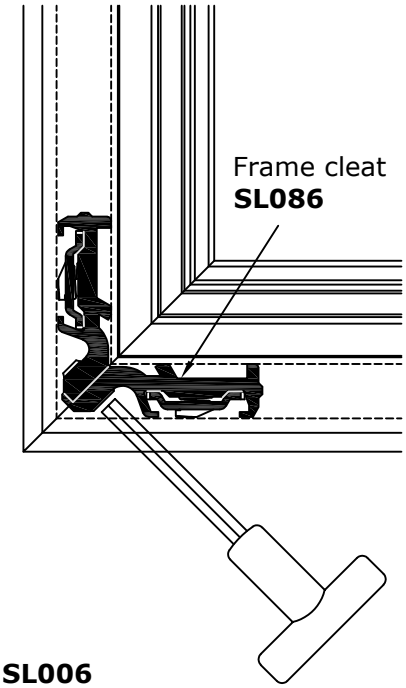


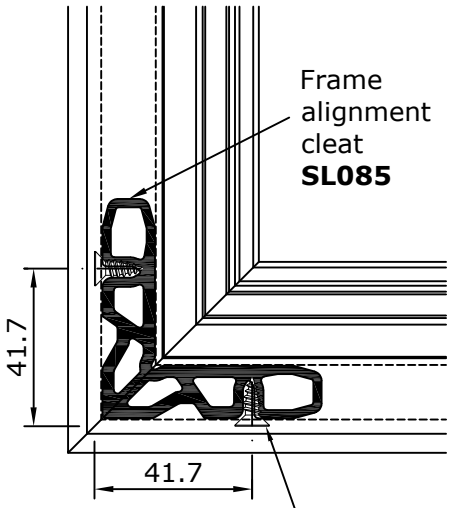
Not to scale

Corner Assembly Detail

Outer Frame SL001002





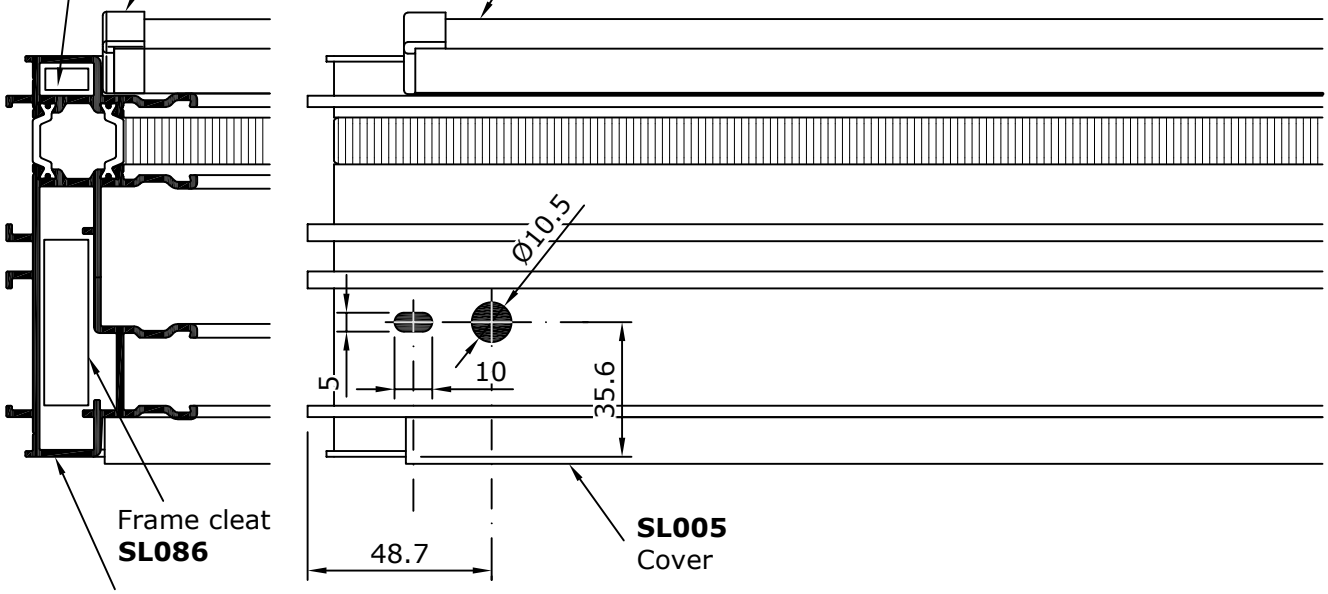


2 No 10 x 12mm countersunk screws per corner

Frame alignment cleat **SL085**

SL151A/SL151B, SL069 Drainage channel end cap

SL006 SL135 Extended cover



Frame cleat **SL086**

SL005 Cover

SL001002 Outer frame

Not to scale

Corner Assembly Detail

Outer Frame SL001000002

System 25 Hi/Hi+

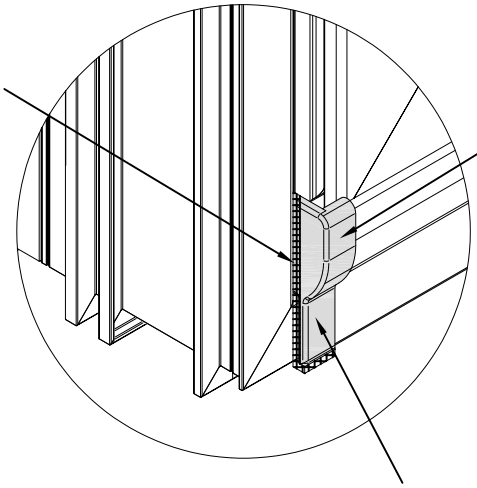
LIFT AND SLIDE DOOR

IMPORTANT: PLEASE READ THESE NOTES BEFORE CORNER ASSEMBLY.

METAL TECHNOLOGY RECOMMEND THE USE OF MT1803 ADHESIVE TO ENSURE THE STABILITY OF CORNER JOINTS. PARTICULAR ATTENTION SHOULD BE PAID TO THE BONDING OF THE CORNER CLEATS TO THE PROFILE.

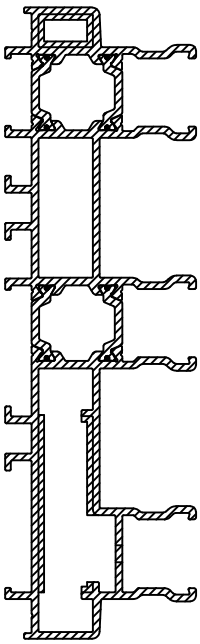
1. Prior to joining outer frame corners fabricator must assemble head and cill outer frame profiles using drainage block from SL155 interlock kit. Ensure ends of cill outer frame profile are sealed using SL099 foam filler, frame alignment cleats SL085 are fixed to head and cill, and SL005/SL006 covers are fitted.
2. Before applying MT1803 adhesive, ensure all surfaces to be glued are free from grease or dust. Clean all aluminium mating surfaces with MT60 surface cleaner and allow to dry. Fabricator must ensure MT60 surface cleaner is fully compatible with surface finish on a project-by-project basis.
3. Locate and silicone seal SL069 drainage channel end caps onto SL006 extended cover at head and cill.
4. Apply MT1803 adhesive to the mating surfaces of the mitre cut aluminium and thermal break profiles. Adhesive need only be applied to one side of the mitred joint.
5. Apply MT1803 adhesive to the internal perimeter of the cleat chambers. This must be applied to both sides of the mitred joint and to sufficient depth to ensure full bonding/sealing of the cleats.
6. Insert SL086 mechanical cleats and push sections together. Ensure mitred joint is aligned and true.
7. Secure corners by tightening machine screw in mechanical cleat SL086 using 4mm allen key.
8. Secure SL085 alignment cleat to jambs using No 10 x 12mm countersunk screws through uncountersunk 6mm Ø hole in small cleat chamber.
9. Wipe away any excess adhesive from the mitred joint using MT60 surface cleaner and allow to dry. Ensure surfaces are clear of adhesive.
10. Seal access holes and slots for cleats with HR50328A sealant.
11. Check the mitre is tight on both sides and that there is no movement.
12. For larger doors fabricators may wish to assemble outer frame on site for ease of transport.

Apply silicone sealant to the side and bottom of the drainage channel end caps



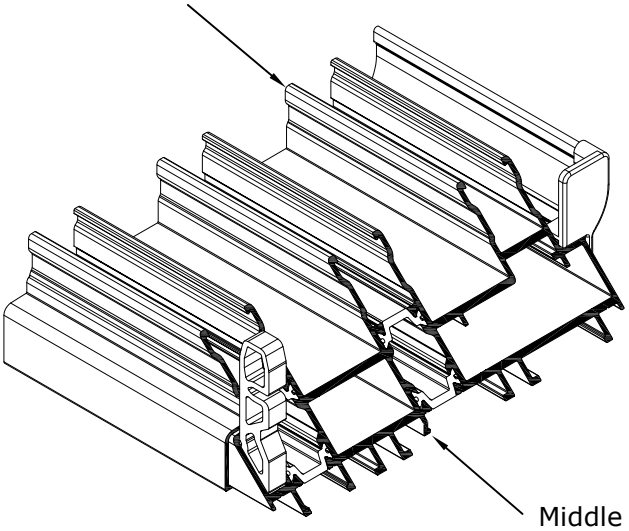
Locate and silicone seal drainage channel end caps onto extended cover at head and cill before assembling mitred corners

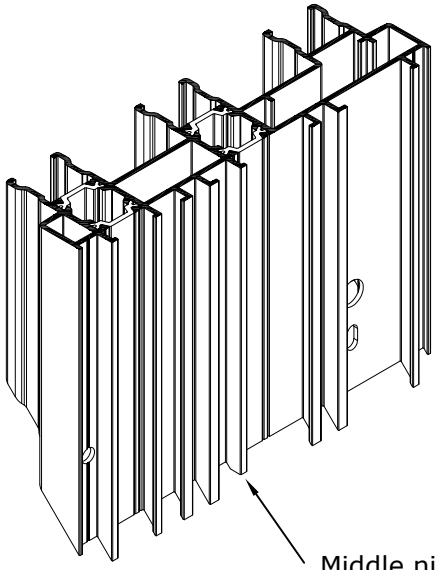
Outer frame
SL001000002



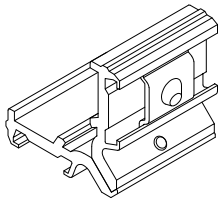
SL069 Drainage channel end cap

Outer frame
SL001000002





Middle nib cut back by 5mm



Middle nib cut back by 5mm

Not to scale

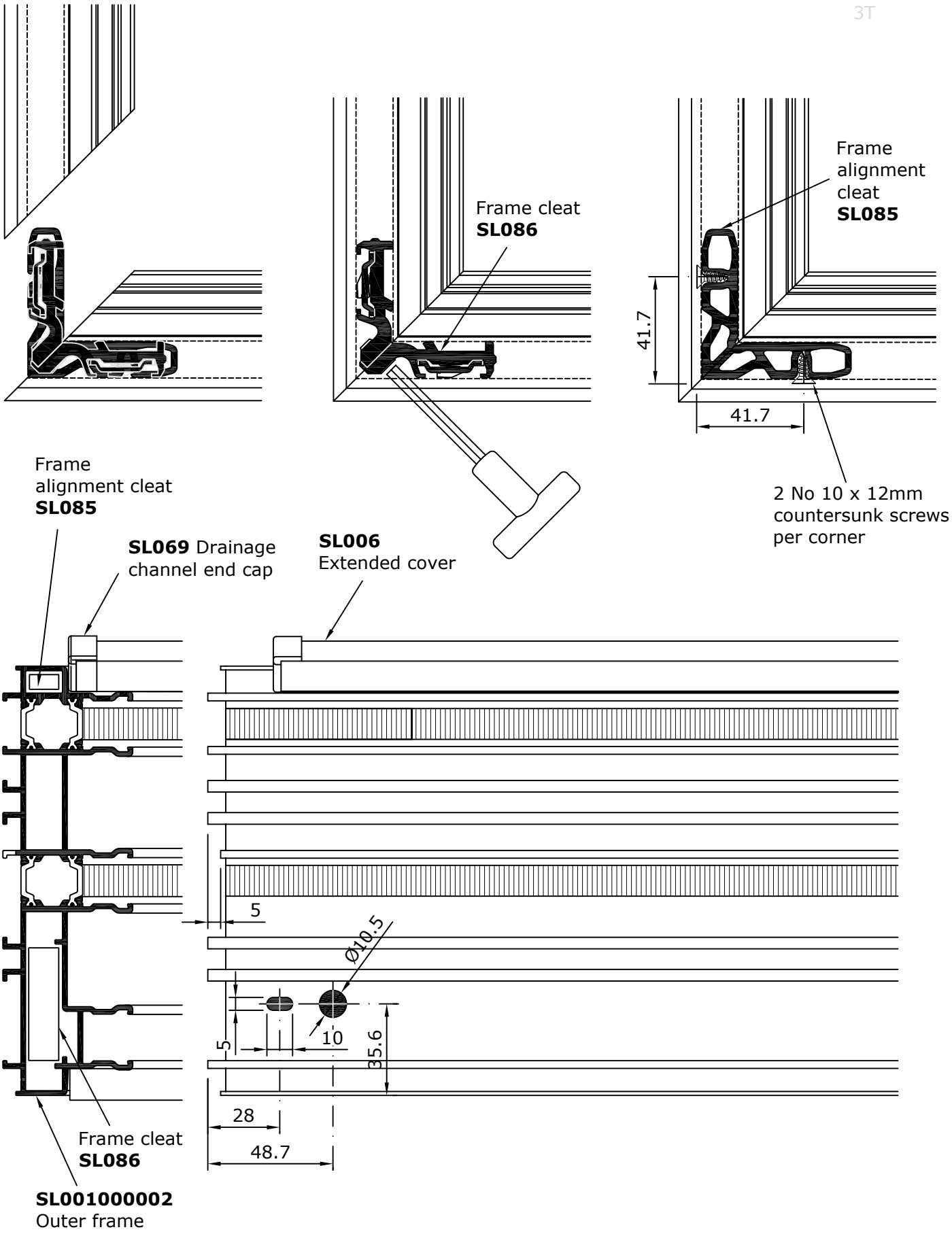
Corner Assembly Detail

Outer Frame SL001000002

System 25 Hi/Hi+

LIFT AND SLIDE DOOR

3T



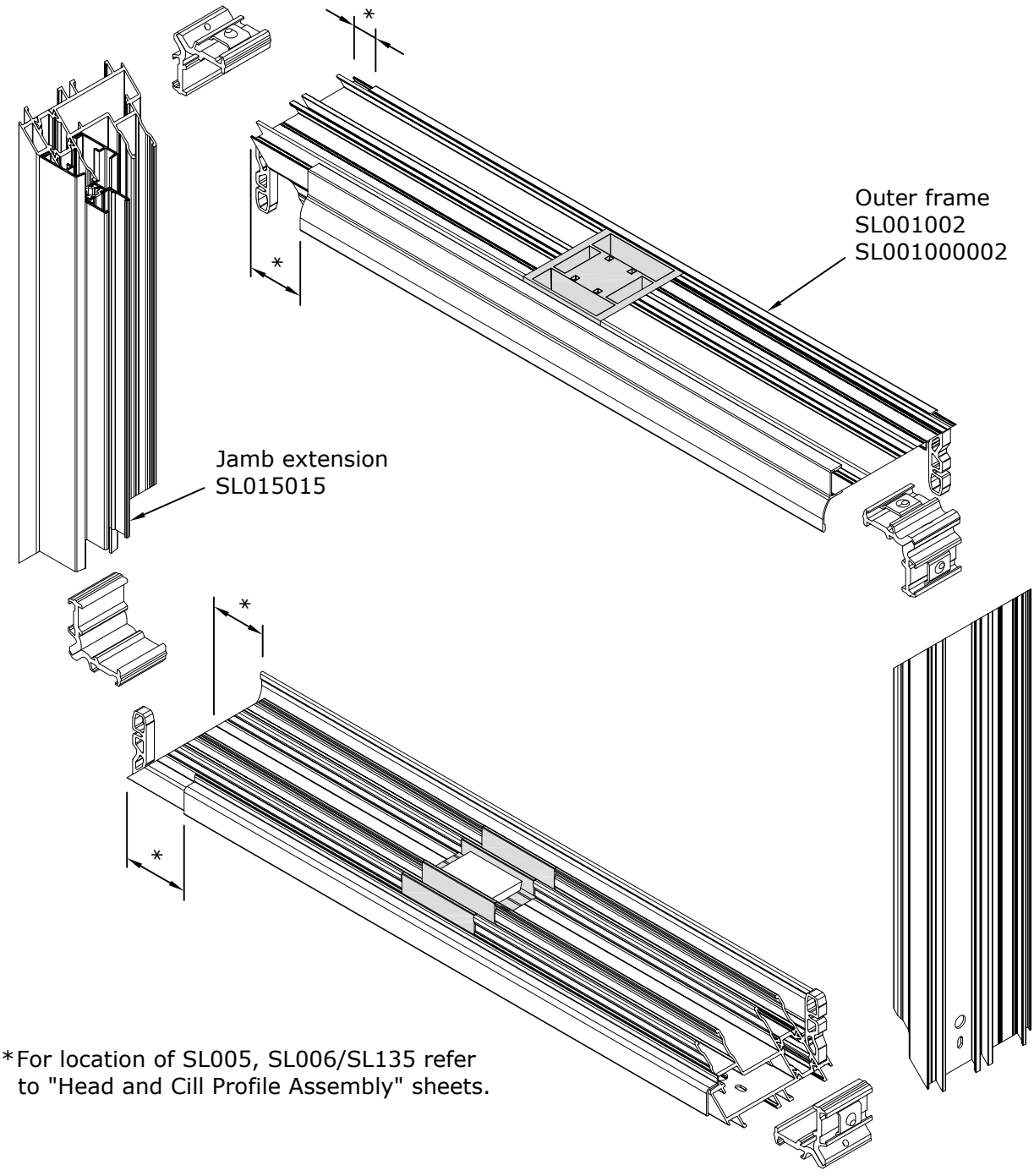
Not to scale

SL015015 Jamb Extension Assembly

IMPORTANT: PLEASE READ THESE NOTES BEFORE CORNER ASSEMBLY.

METAL TECHNOLOGY RECOMMEND THE USE OF MT1803 ADHESIVE TO ENSURE THE STABILITY OF CORNER JOINTS.

1. Prior to joining corners run bead of sealant along perimeter interface of outer frame with SL015015 jamb extension, as indicated on "Outer Frame Prep Details for SL015015 Jamb Extension" sheet.
2. Locate SL015015 jamb extension centrally onto jamb track.
3. Assemble and join outer frame corners in accordance with "Corner Assembly Detail" sheets.
4. Using JIG25007A drill 3.2mm Ø pilot holes through outer frame into SL015015 jamb extension, as indicated on "Outer Frame Prep Details for SL015015 Jamb Extension" sheet.
5. Remove jig and drill outer holes in outer frame to 4.5mm Ø clearance hole.
6. Secure SL015015 jamb extension to outer frame using No 8 x 38mm pan head self tapping screws 7235.



*For location of SL005, SL006/SL135 refer to "Head and Cill Profile Assembly" sheets.

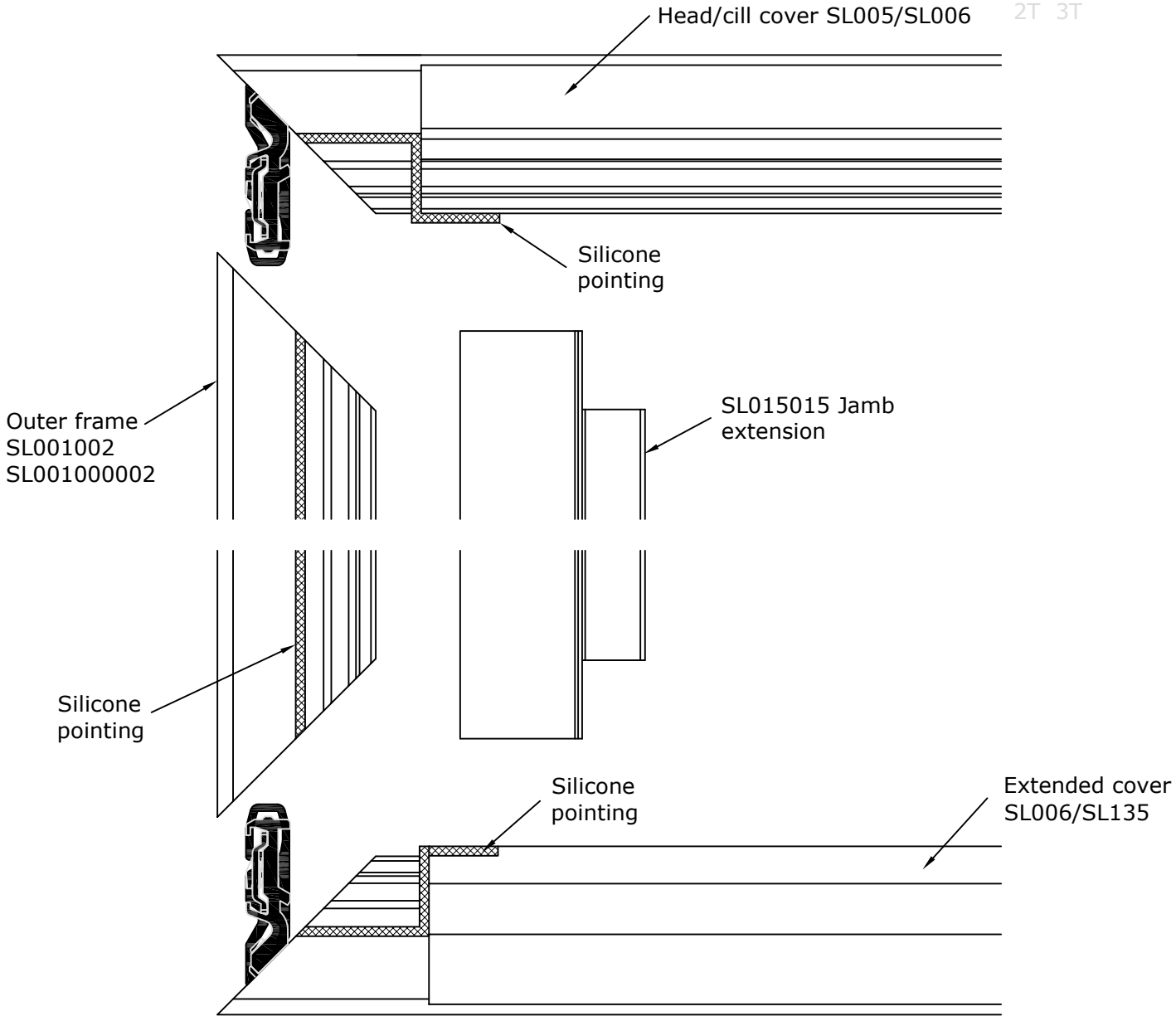
Not to Scale

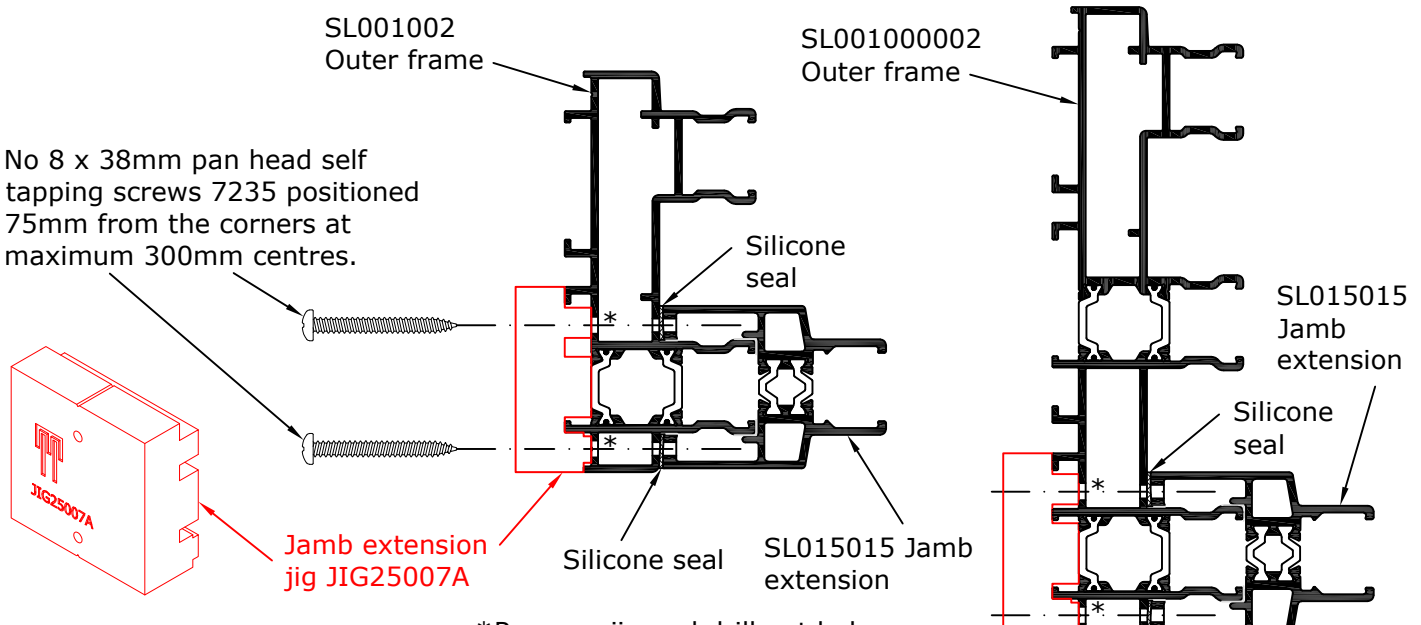
Outer Frame Prep Details for SL015015 Jamb Extension

System 25 Hi/Hi+

LIFT AND SLIDE DOOR

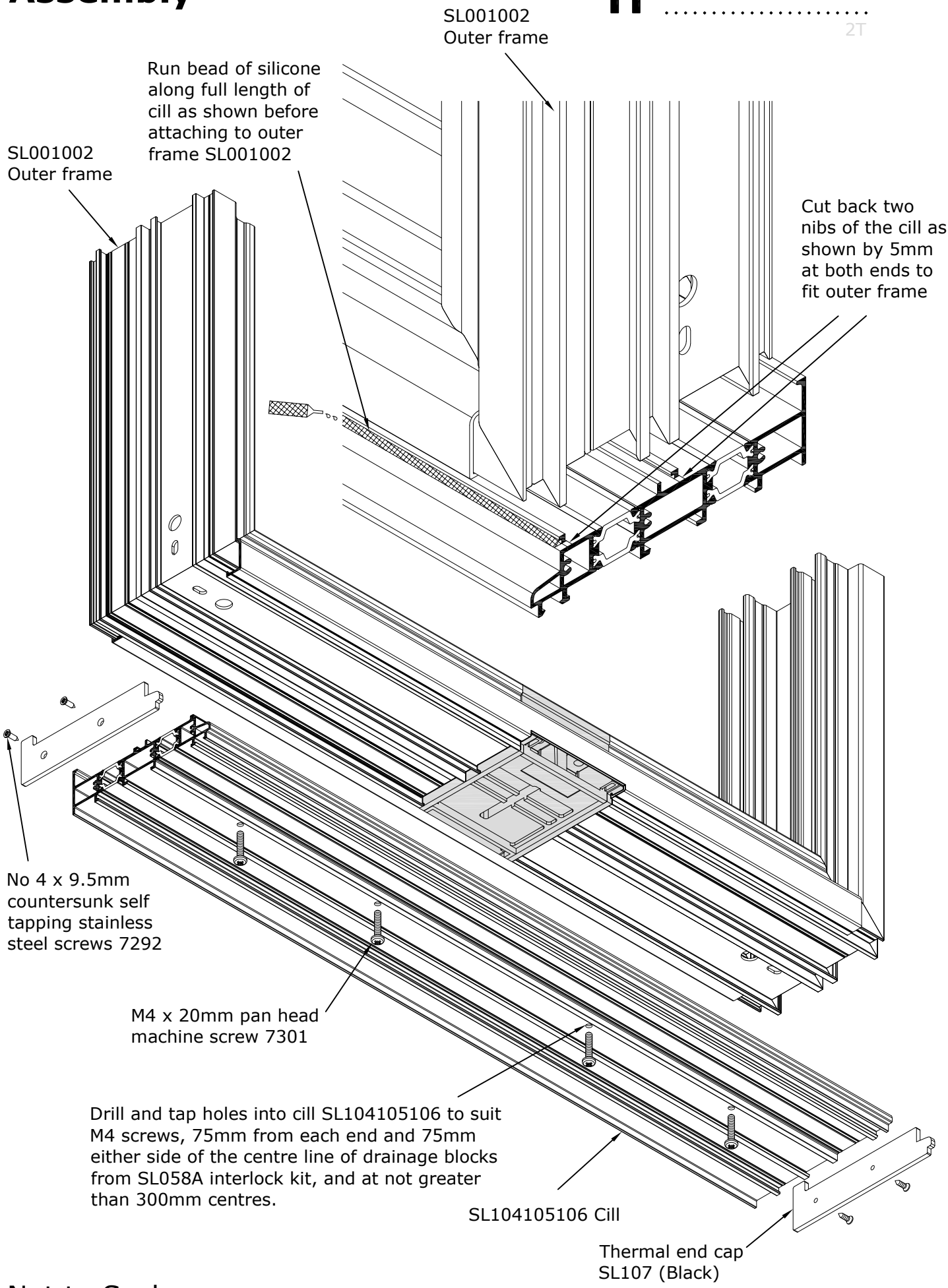
2T 3T





Scale 1:2

SL104105106 Sub-Cill Assembly



Not to Scale

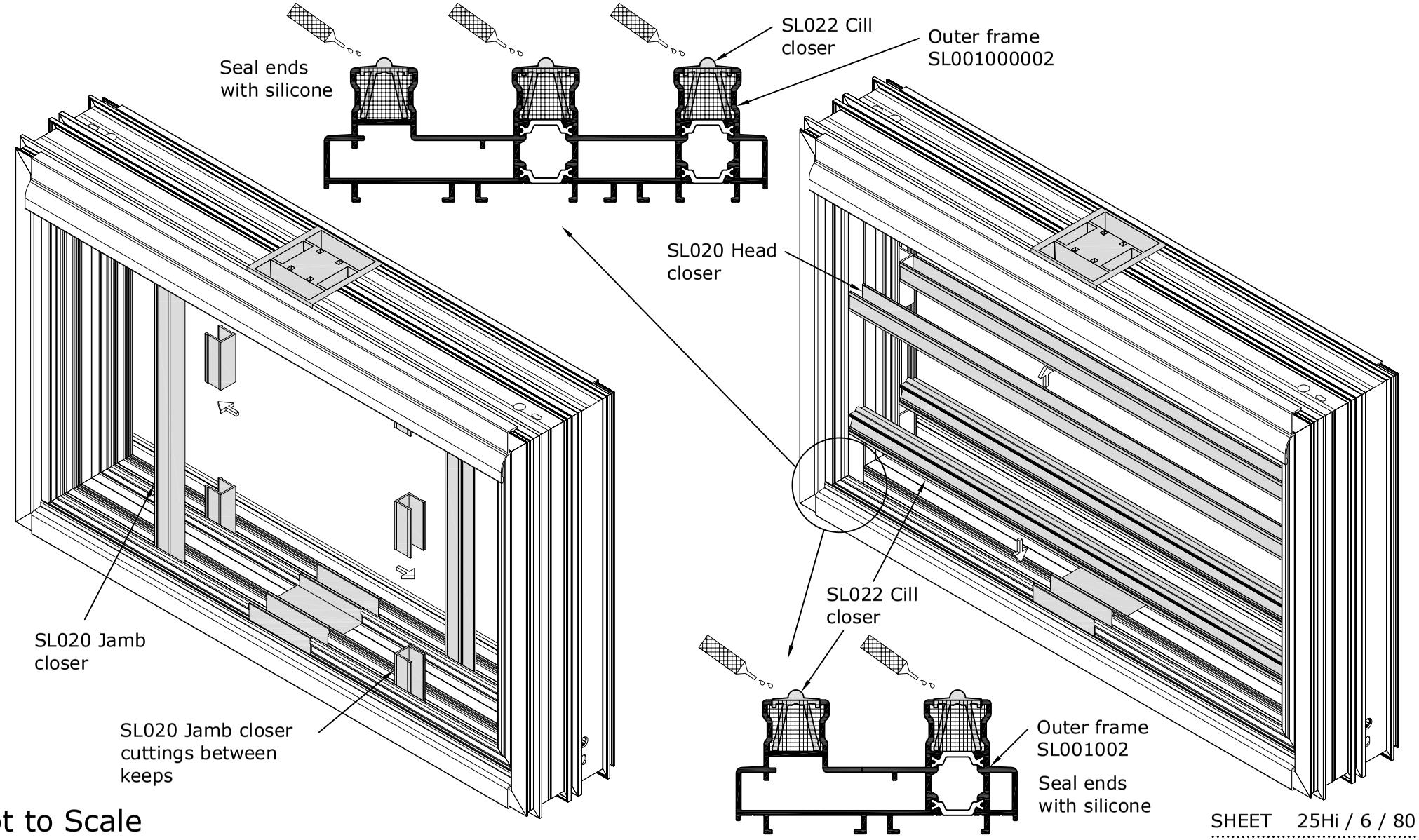
Head / Jamb and Cill Closer Application

System 25 Hi/Hi+

LIFT AND SLIDE DOOR

2T 3T

1. Fit jamb closer cuttings as per sheet "Cill, Head and Jamb Closer Sizes" to locking jambs of outer frame. Positioning of jamb closers should also correctly locate keep positions.
2. Fit full length jamb closers SL020 into remaining tracks within outer frame.
3. Fit full length SL020 closers to head.
4. Apply silicone sealant at mitred corners of cill outer frame SL001002/SL001000002 and fit full length SL022 cill closers to cill tracks.



Not to Scale

Corner Assembly Detail

Sash SL018016

System 25 Hi/Hi+

LIFT AND SLIDE DOOR

2T 3T

IMPORTANT: PLEASE READ THESE NOTES BEFORE CORNER ASSEMBLY.

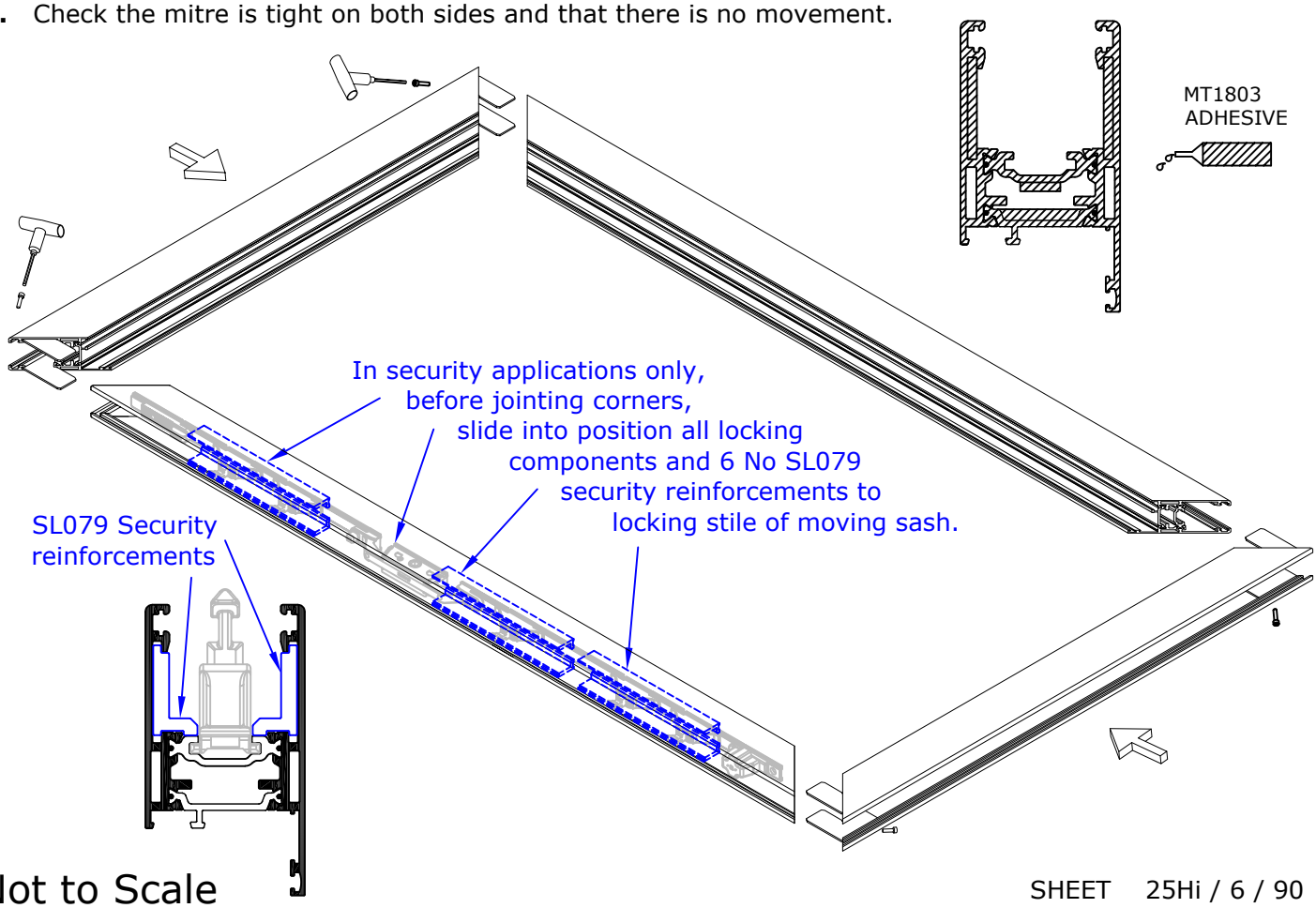
METAL TECHNOLOGY RECOMMEND THE USE OF MT1803 ADHESIVE TO ENSURE THE STABILITY OF CORNER JOINTS. PARTICULAR ATTENTION SHOULD BE PAID TO THE BONDING OF THE CORNER CHEVRONS TO THE PROFILE.

Fabricator to determine:

1. Moving sash or fixed sash.
2. Locking side, head, cill, locking/fixed stiles, meeting stile detail, head and cill profiles.

Once the above has been established the following steps must be undertaken in the following order:

1. Insert gaskets. Refer to "Sash Assembly - Gasket Application" sheet.
2. In security applications only, insert all locking components followed by SL079 security reinforcements to locking stile of moving sash. Refer to "Security Locking Gear Assembly to Lift and Slide Sash" sheet.
3. Before applying MT1803 adhesive, ensure all surfaces to be glued are free from grease or dust. Clean all aluminium mating surfaces with MT60 surface cleaner and allow to dry. Fabricator must ensure MT60 surface cleaner is fully compatible with surface finish on a project-by-project basis.
4. Apply MT1803 adhesive to the mating surfaces of the mitre cut aluminium and thermal break profiles. Adhesive need only be applied to one side of the mitred joint.
5. Apply MT1803 adhesive to the internal perimeter of the cleat chambers and corner chevron grooves of the frame sections. This must be applied to both sides of the mitred joint and to sufficient depth to ensure full bonding/sealing of the cleats and chevrons.
6. Referring to "Sash Assembly - SL087 and SL088 Corner Chevrons" and "Sash Assembly - SL084 Corner Cleat into SL018016" sheets insert corner cleat components and chevrons and push sections together. Ensure mitred joint is aligned and true. Secure mechanical cleats using allen key into socket head machine screw supplied with cleat.
7. Wipe away any excess adhesive from the mitred joint using MT60 surface cleaner and allow to dry. Ensure all bead and gasket recesses are clear of adhesive.
8. Seal access holes and slots for cleats with HR50328A sealant.
9. Check the mitre is tight on both sides and that there is no movement.



Not to Scale

Corner Assembly Detail

Sashes SL129130 and SL131132

System 25 Hi/Hi+

LIFT AND SLIDE DOOR

2T

IMPORTANT: PLEASE READ THESE NOTES BEFORE CORNER ASSEMBLY.

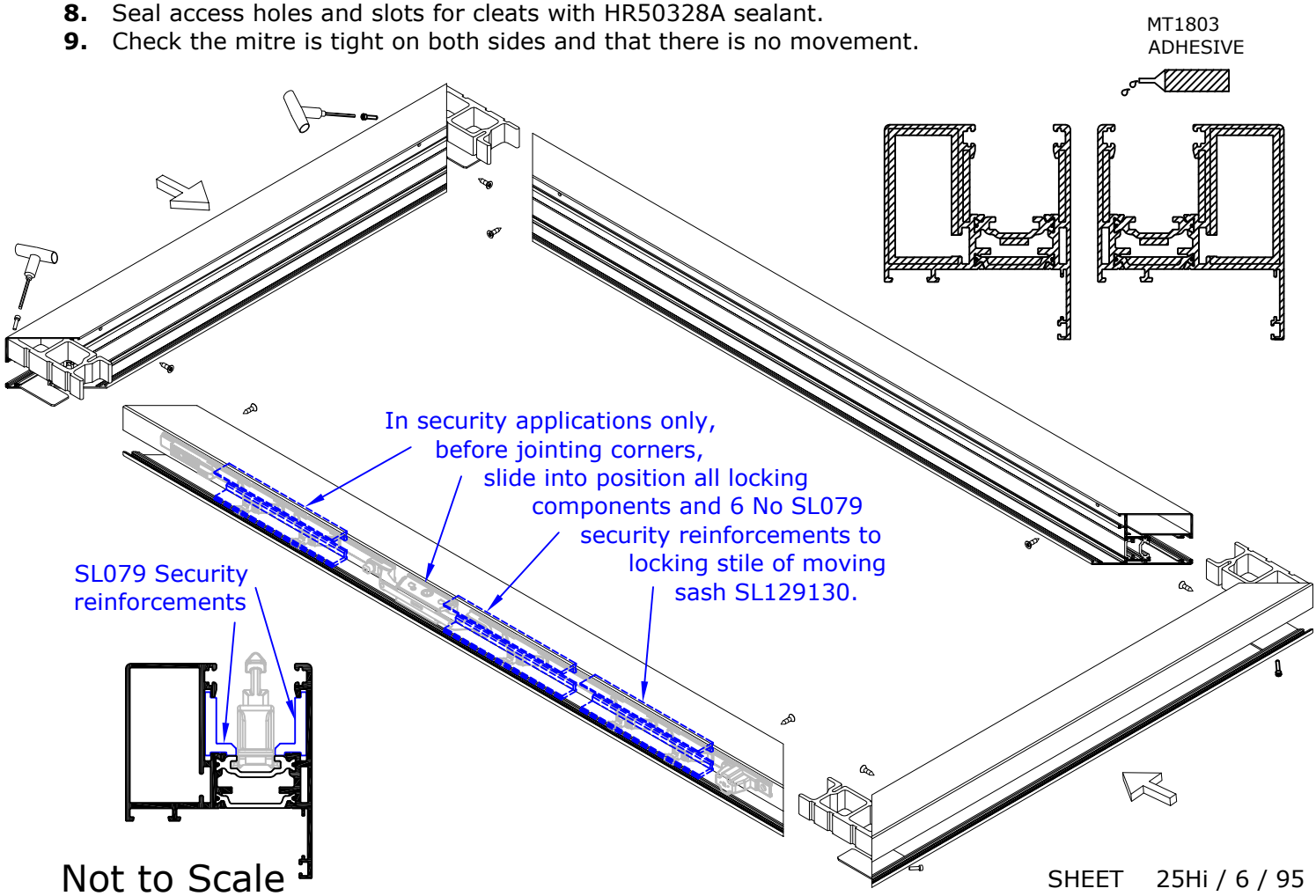
METAL TECHNOLOGY RECOMMEND THE USE OF MT1803 ADHESIVE TO ENSURE THE STABILITY OF CORNER JOINTS. PARTICULAR ATTENTION SHOULD BE PAID TO THE BONDING OF THE CORNER CHEVRONS TO THE PROFILE.

Fabricator to determine:

1. Moving sash or fixed sash.
2. Locking side, head, cill, locking/fixed stiles, meeting stile detail, head and cill profiles.

Once the above has been established the following steps must be undertaken in the following order:

1. Insert gaskets. Refer to "Sash Assembly - Gasket Application" sheet.
2. In security applications only, insert all locking components followed by SL079 security reinforcements to locking stile of moving sash. Refer to "Security Locking Gear Assembly to Lift and Slide Sash" sheet.
3. Before applying MT1803 adhesive, ensure all surfaces to be glued are free from grease or dust. Clean all aluminium mating surfaces with MT60 surface cleaner and allow to dry. Fabricator must ensure MT60 surface cleaner is fully compatible with surface finish on a project-by-project basis.
4. Apply MT1803 adhesive to the mating surfaces of the mitre cut aluminium and thermal break profiles. Adhesive need only be applied to one side of the mitred joint.
5. Apply MT1803 adhesive to the internal perimeter of the cleat chambers and corner chevron grooves of the frame sections. This must be applied to both sides of the mitred joint and to sufficient depth to ensure full bonding/sealing of the cleats and chevrons.
6. Referring to "Sash Assembly - SL087 and SL088 Corner Chevrons" and "Sash Assembly - SL084 and SL150 Corner Cleats into SL129130 and SL131132" sheets insert corner cleat components and chevrons and push sections together. Ensure mitred joint is aligned and true. Secure SL084 mechanical cleats using allen key into socket head machine screw supplied with cleat. Secure SL150 extruded cleats with 7234 No 10 x 19mm countersunk self tap screws.
7. Wipe away any excess adhesive from the mitred joint using MT60 surface cleaner and allow to dry. Ensure all bead and gasket recesses are clear of adhesive.
8. Seal access holes and slots for cleats with HR50328A sealant.
9. Check the mitre is tight on both sides and that there is no movement.



Not to Scale

Sash Assembly - Gasket Application

System 25 Hi/Hi+

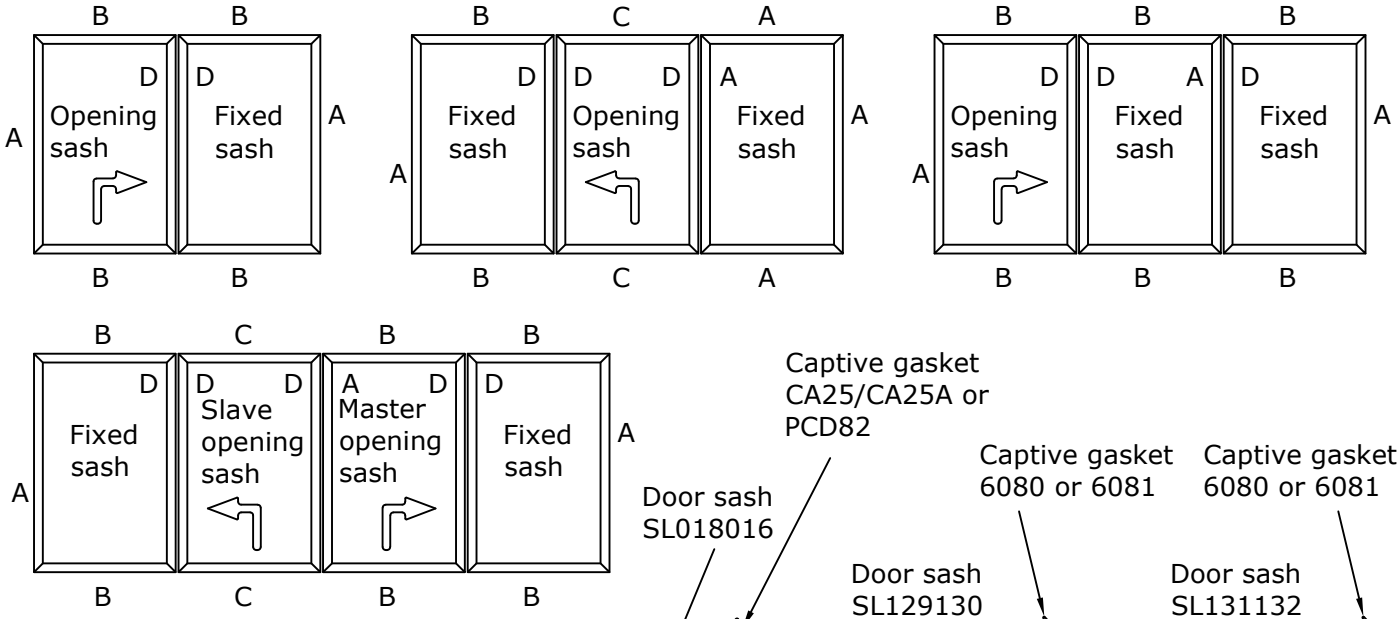
LIFT AND SLIDE DOOR

2T 3T

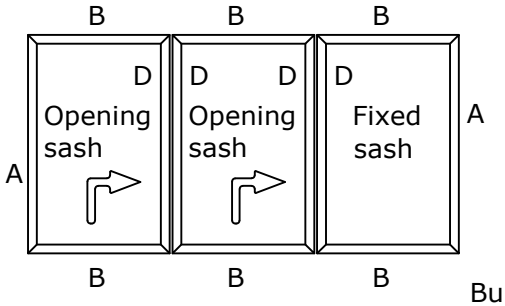
Prior to assembling door sash captive gasket CA25 and bubble seal SL037 to be cut and inserted into sash profiles as indicated below.

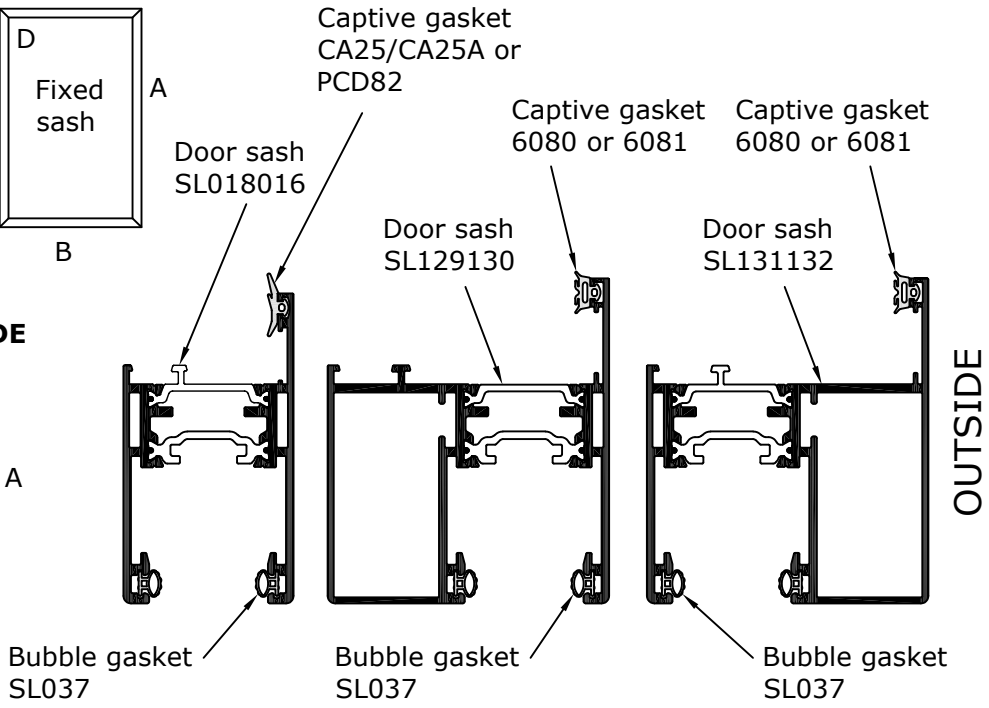
Gaskets must not be stretched and should be cut 1-3% oversize as required to accommodate shrinkage. When oversizing the gasket to accommodate any anticipated potential shrinkage, fabricators should ensure gasket is not installed so that it remains wrinkled. While it is preferable that gaskets be installed too long, rather than too short, excessive wrinkles or distortion should be avoided once the gasket has had an opportunity to settle into its natural state within its final intended environment.

DOUBLE TRACK LIFT AND SLIDE



TRIPLE TRACK LIFT AND SLIDE





For selection of captive gasket refer to "Weatherseal Application Details" sheet:

6080, 6081, CA25/CA25A or PCD82 captive gasket	mitre/mitre	applied to external side of all fixed and opening sashes

A	SL037 bubble gasket	mitre/mitre
B	SL037 bubble gasket	mitre/square — rebated meeting stile end
C	SL037 bubble gasket	square/square
D	No bubble seal into sash profile*	

* Refer to "Sash Assembly - SL012 and SL021 Meeting Stile Fixing Details" sheets for details of SL037 into SL021 meeting stile locking piece

Not to Scale

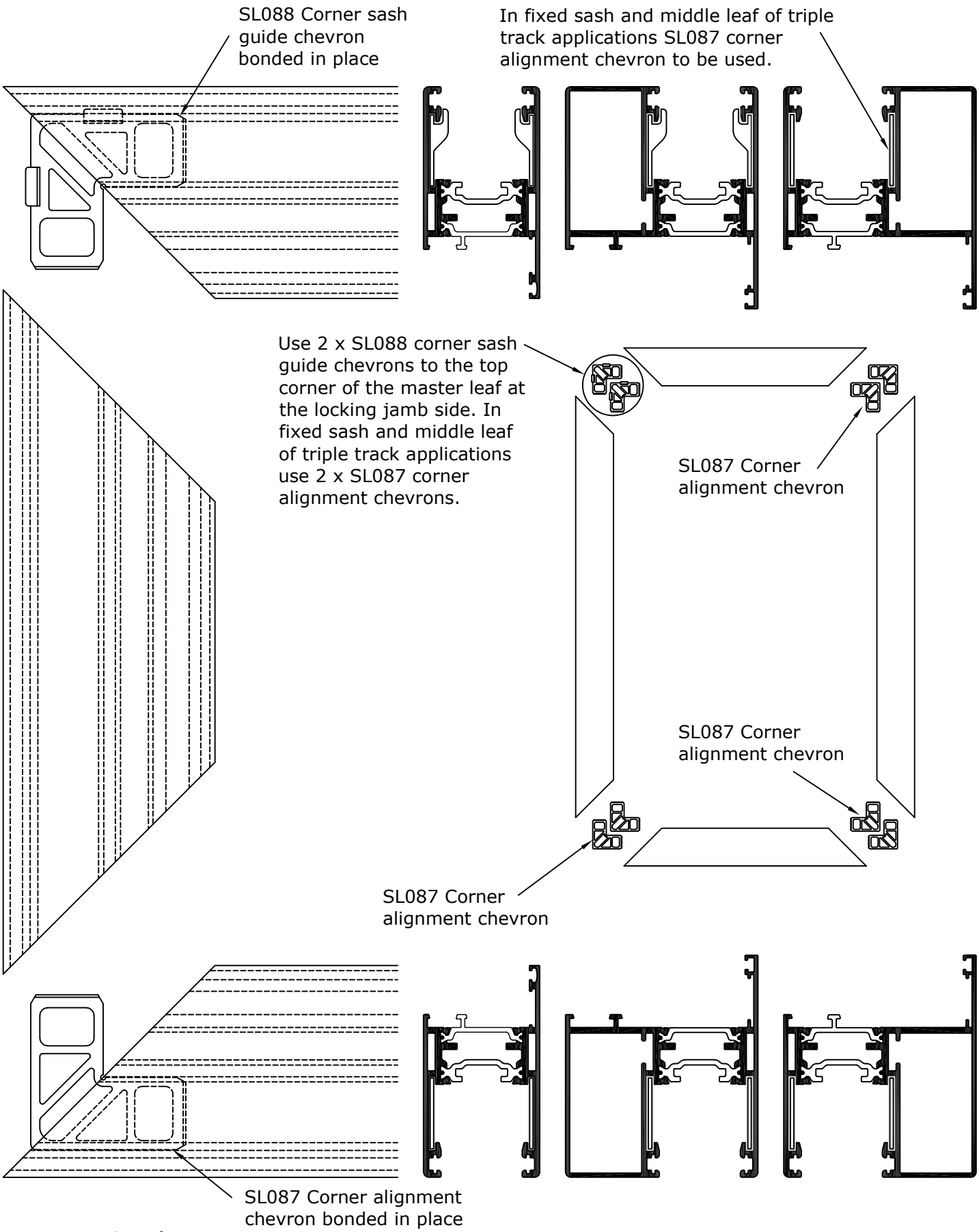
Sash Assembly - SL087 and SL088 Corner Chevrons

System 25 Hi/Hi+

LIFT AND SLIDE DOOR

2T 3T

Apply MT1803 adhesive to recessed surface of chevrons. Insert chevrons into head and cill sash profiles so that adhesive seals/bonds against wall of sash.



Not to Scale

Sash Assembly - SL084
Corner Cleat into SL018016

System 25 Hi/Hi+

LIFT AND SLIDE DOOR

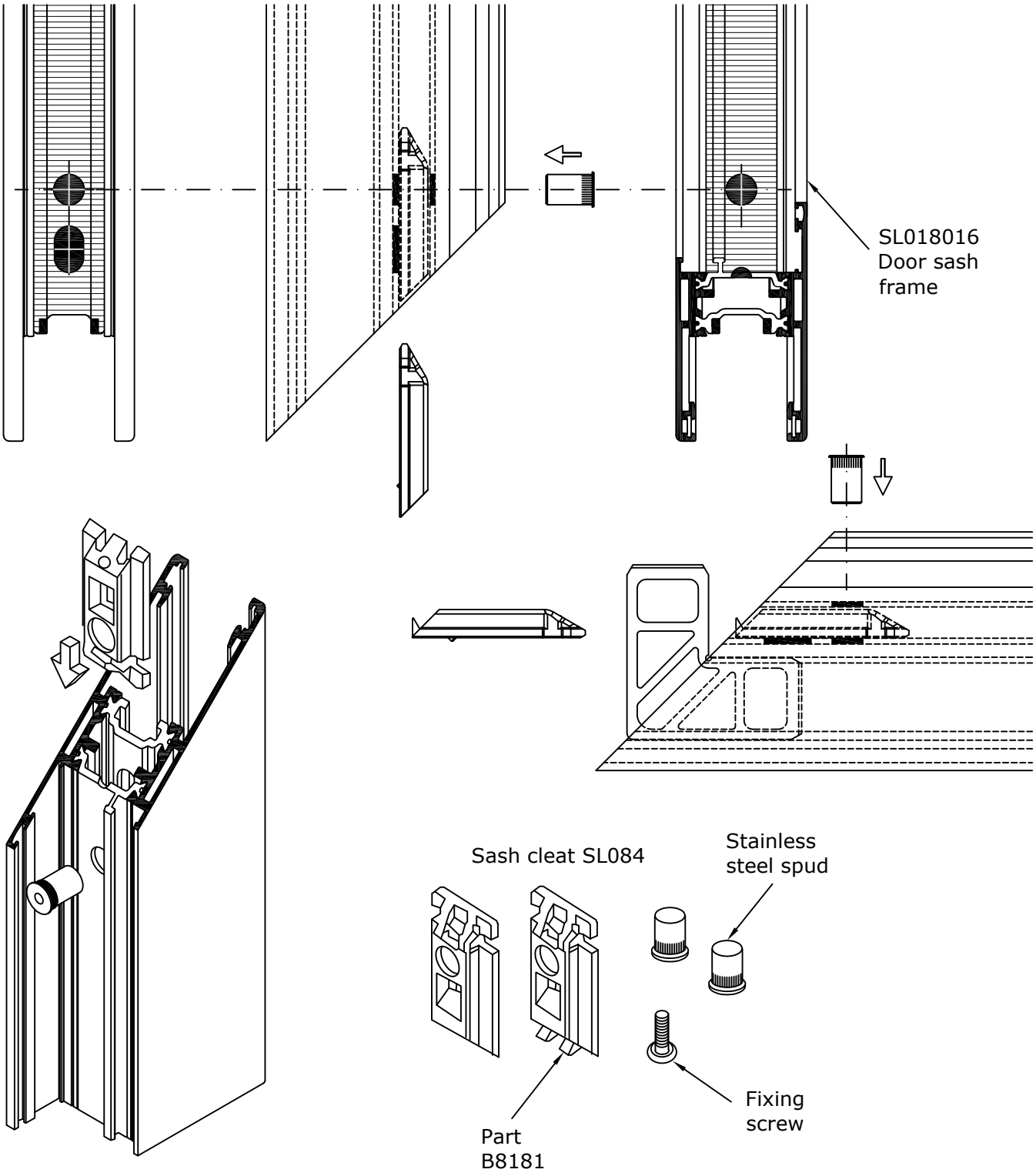
2T 3T

Refer to "SL018016 Sash Prep Details" sheet for details of sash prep to receive mechanical cleat, and "Corner Assembly Detail - Sash SL018016" for fabrication and adhesive/sealant application.

Push cast component of mechanical cleat into ends of profiles, making sure that part B8181 (which receives the head of the fixing screw) is inserted into the head /cill profile.

Secure cast components into profile by driving stainless steel spuds into hole in castings through polyamide strip. Ensure serrations on spud penetrate polyamide strip, and underside of spud head is hard against thermal break.

Assemble corner joint and secure sash and SL084 cleat components by tightening fixing screw.



Not to Scale

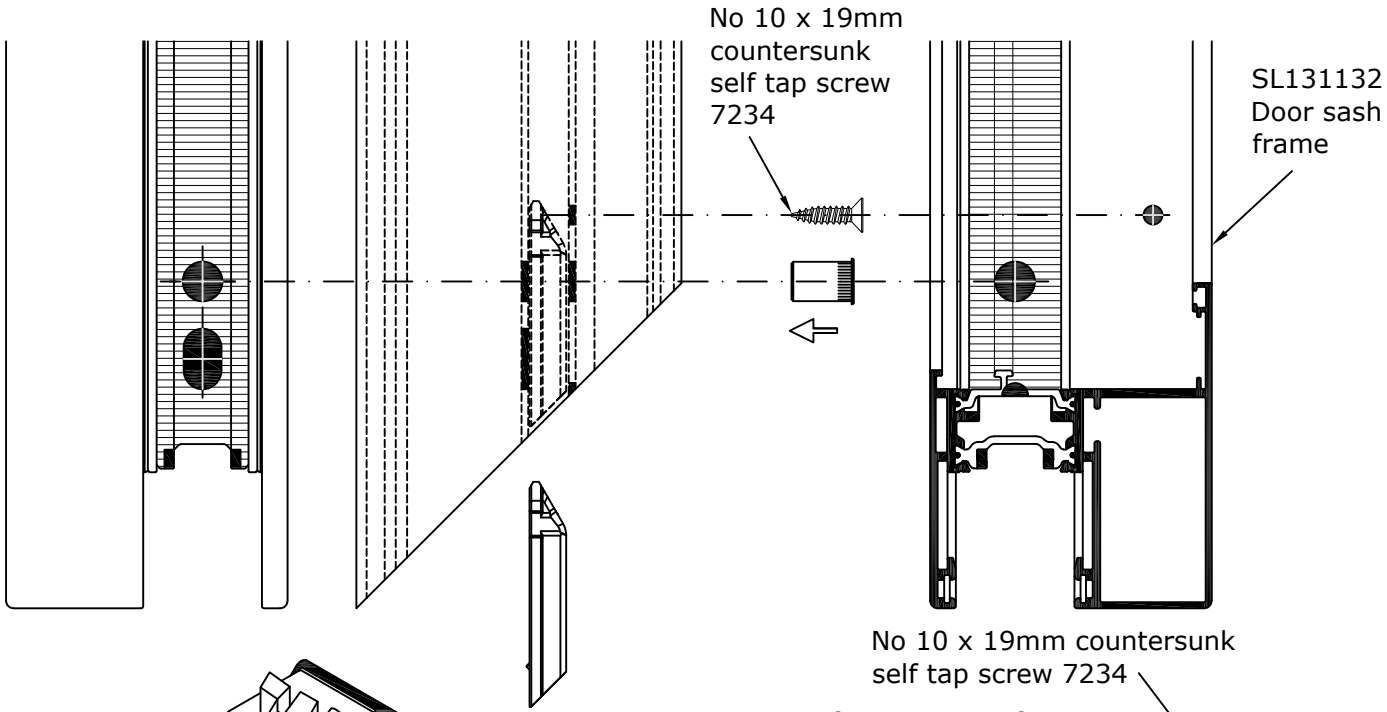
Sash Assembly - SL084 and SL150 Corner Cleats into SL129130 and SL131132

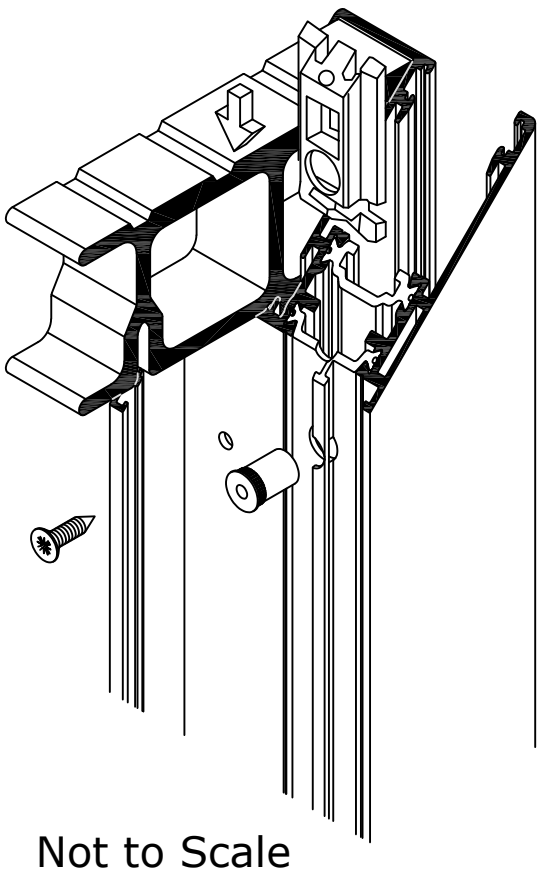
Refer to "SL129130 Sash Prep Details" and "SL131132 Sash Prep Details" sheets for details of sash prep to receive mechanical cleat, and "Corner Assembly Detail - Sashes SL129130 and SL131132" for fabrication and adhesive/sealant application.

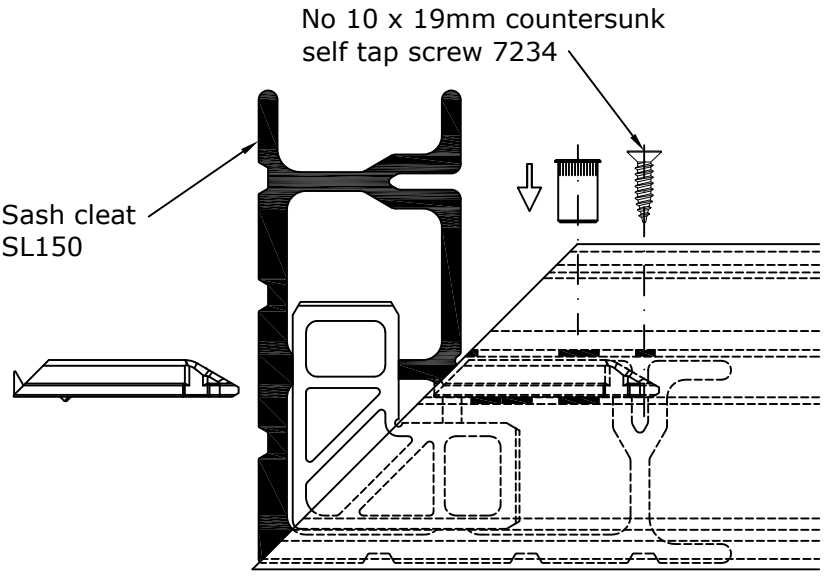
Push cast component of mechanical cleat into ends of profiles, making sure that part B8181 (which receives the head of the fixing screw) is inserted into the head /cill profile.

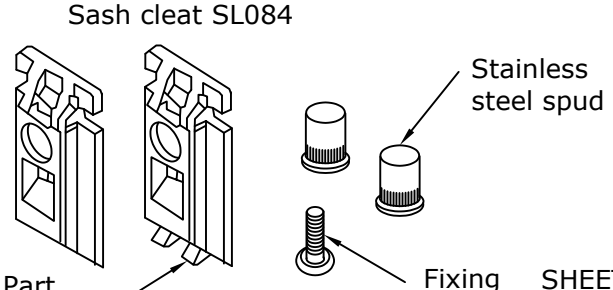
Secure cast components into profile by driving stainless steel spuds into hole in castings through polyamide strip. Ensure serrations on spud penetrate polyamide strip, and underside of spud head is hard against thermal break.

Assemble corner joint and secure sash and SL084 cleat components by tightening fixing screw. Secure SL150 extruded cleats with 7234 No 10 x 19mm countersunk self tap screws.









Not to Scale

Sash Assembly - SL012 and SL021 Meeting Stile Fixing Details

This method statement must be read in conjuction with the following sheet.

1. Identify meeting rail stiles of sashes, and moving / fixed sashes. SL021 meeting stile locking piece fixes to external surface of sliding sash and internal surface of fixed sash at jamb meeting rails.

2. If using SL098 sash meeting rail foam (for Hi+ applications only) position foam within the sash profile as indicated. Refer to "Interlock Thermal Foam" sheet for further details.

3. Apply HR50328A sealant along full length of SL021 as indicated.

4. Position SL021 meeting stile locking piece onto sash stile, orientated as indicated, and align with top and bottom edges of door sash.

5. Clamp SL021 meeting stile locking piece in place, and drill 3.5mm Ø pilot holes through SL021 and into door sash 50mm from top and bottom of profile, and at not greater than 300mm centres. Use v groove in countersunk screw groove in SL021 to position screws from edge of profile.

6. Secure SL021 meeting stile locking piece in place using No 8 x 19mm countersunk self-tap screws 7231.

7. Apply sealant and slide SL012 interlock cover into position as shown.

8. In security applications, using SL076 security interlocks as templates, drill holes in sash and fit interlocks in accordance with "Sash Assembly - SL076 Security Interlock Fixing Details" sheet.

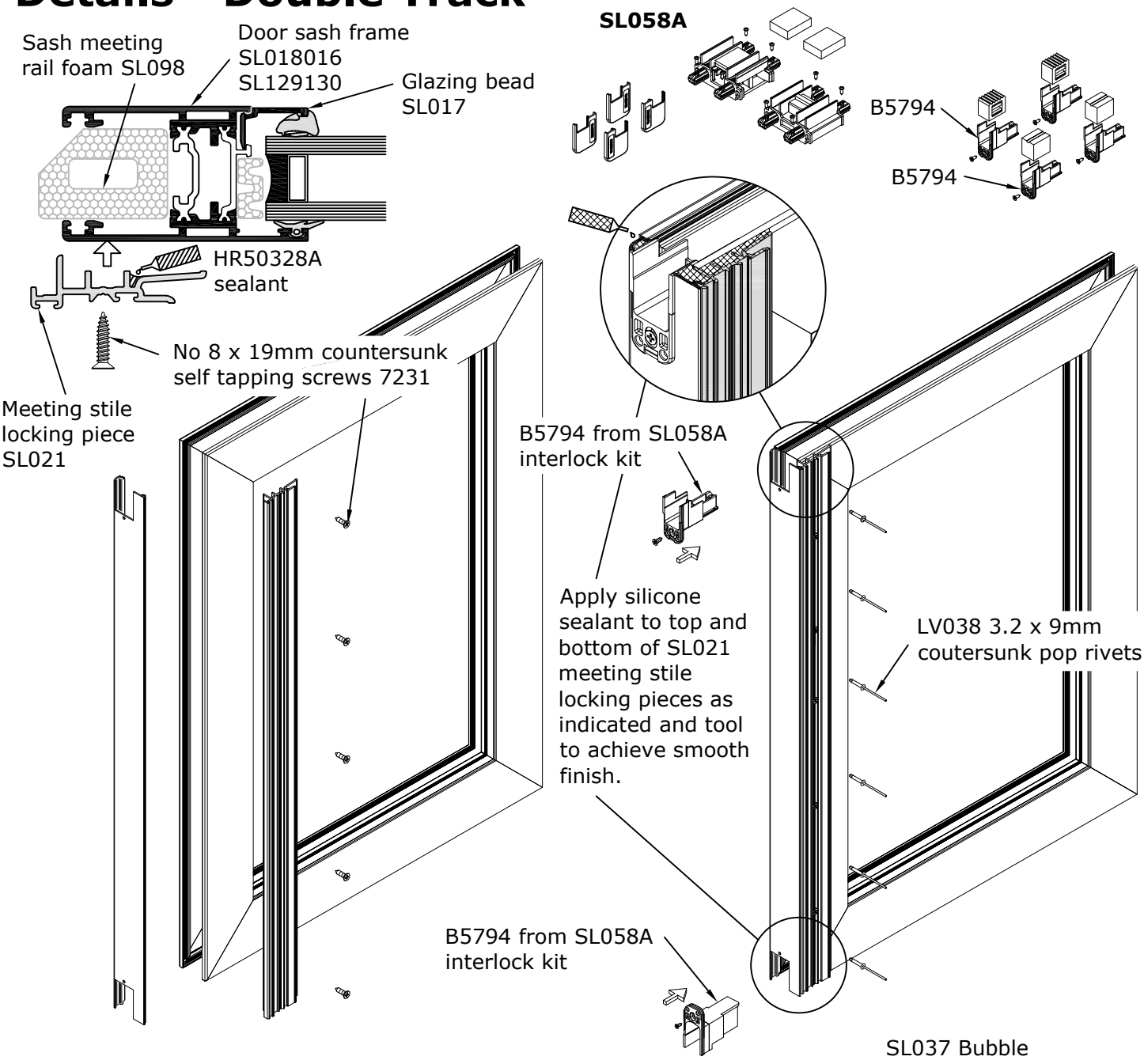
9. Drill second set of 3.5mm Ø pilot holes to leading edge of SL021 meeting stile locking piece to facilitate fixing using LV038 pop rivets. Position fixings 4.5mm in from edge as indicated, and at intermediate centres between original fixings.

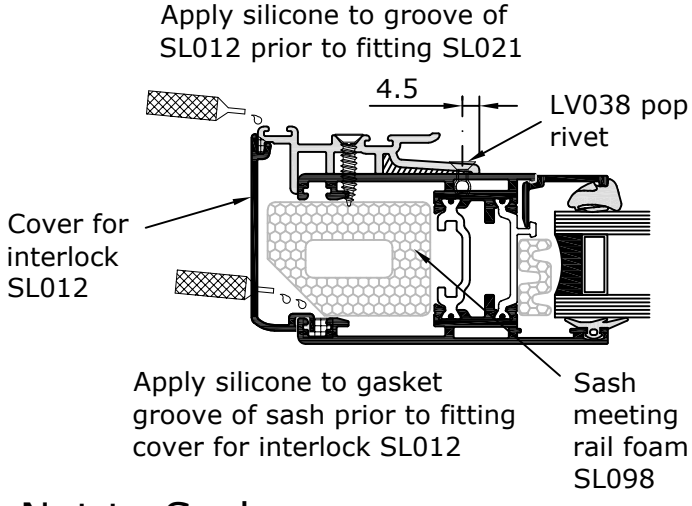
10. Slide VS118A woolpile and SL037 bubble gasket into full height of SL021 meeting stile locking piece as indicated. Bond in place using superglue.

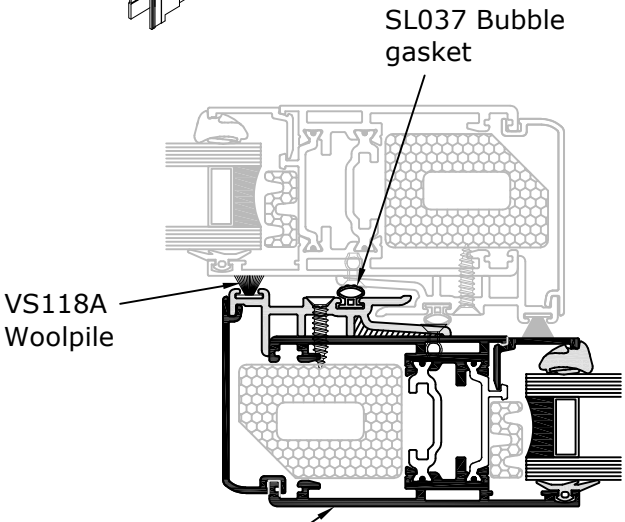
11. Secure component B5794 from interlock kit SL058A/SL155 onto SL012 interlock cover at top and bottom, using screw provided.

12. Apply silicone sealant to top and bottom of SL021 meeting stile locking pieces as indicated and tool to achieve smooth finish.

Sash Assembly - SL012 and SL021 Meeting Stile Fixing Details - Double Track







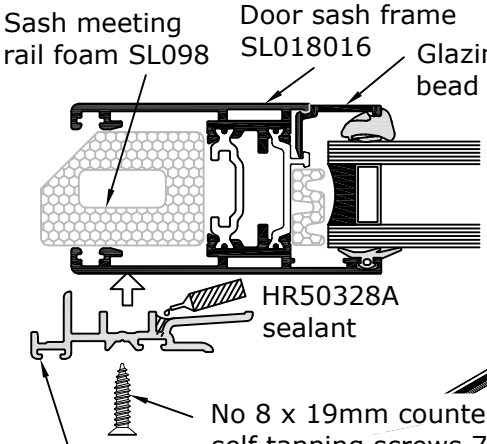
Not to Scale

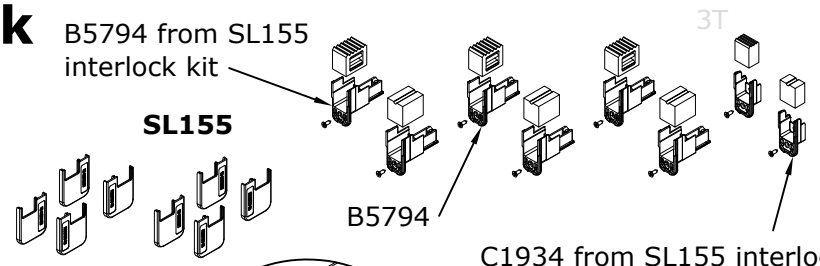
Sash Assembly - SL012 and SL021 Meeting Stile Fixing Details - Triple Track

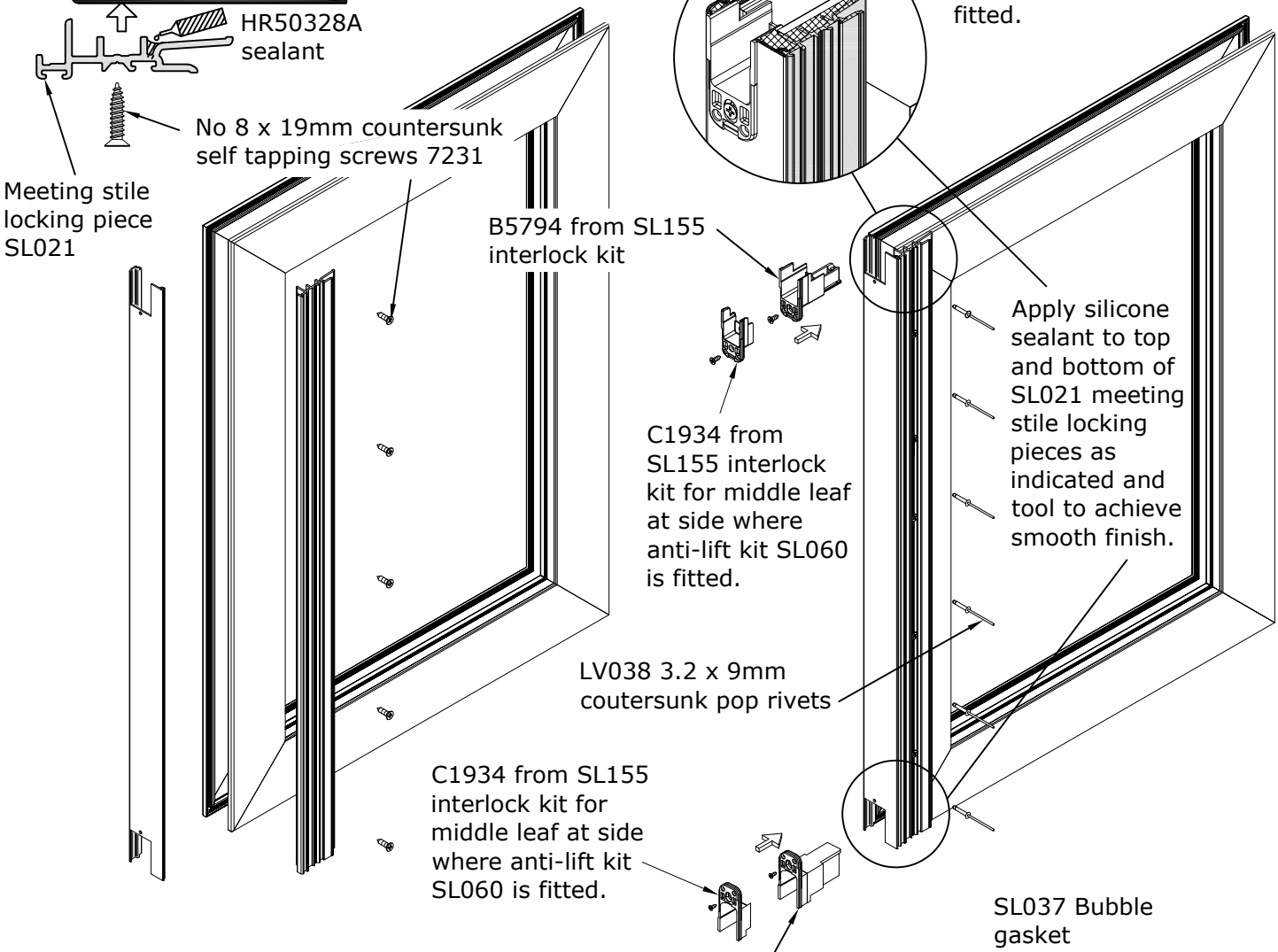
System 25 Hi/Hi+

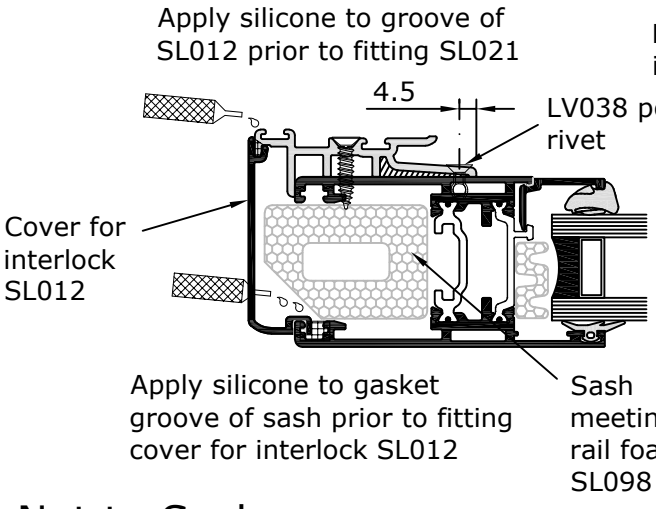
LIFT AND SLIDE DOOR

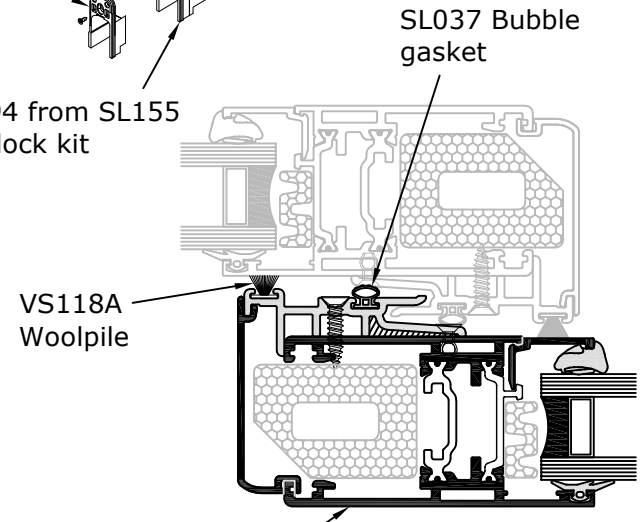
3T







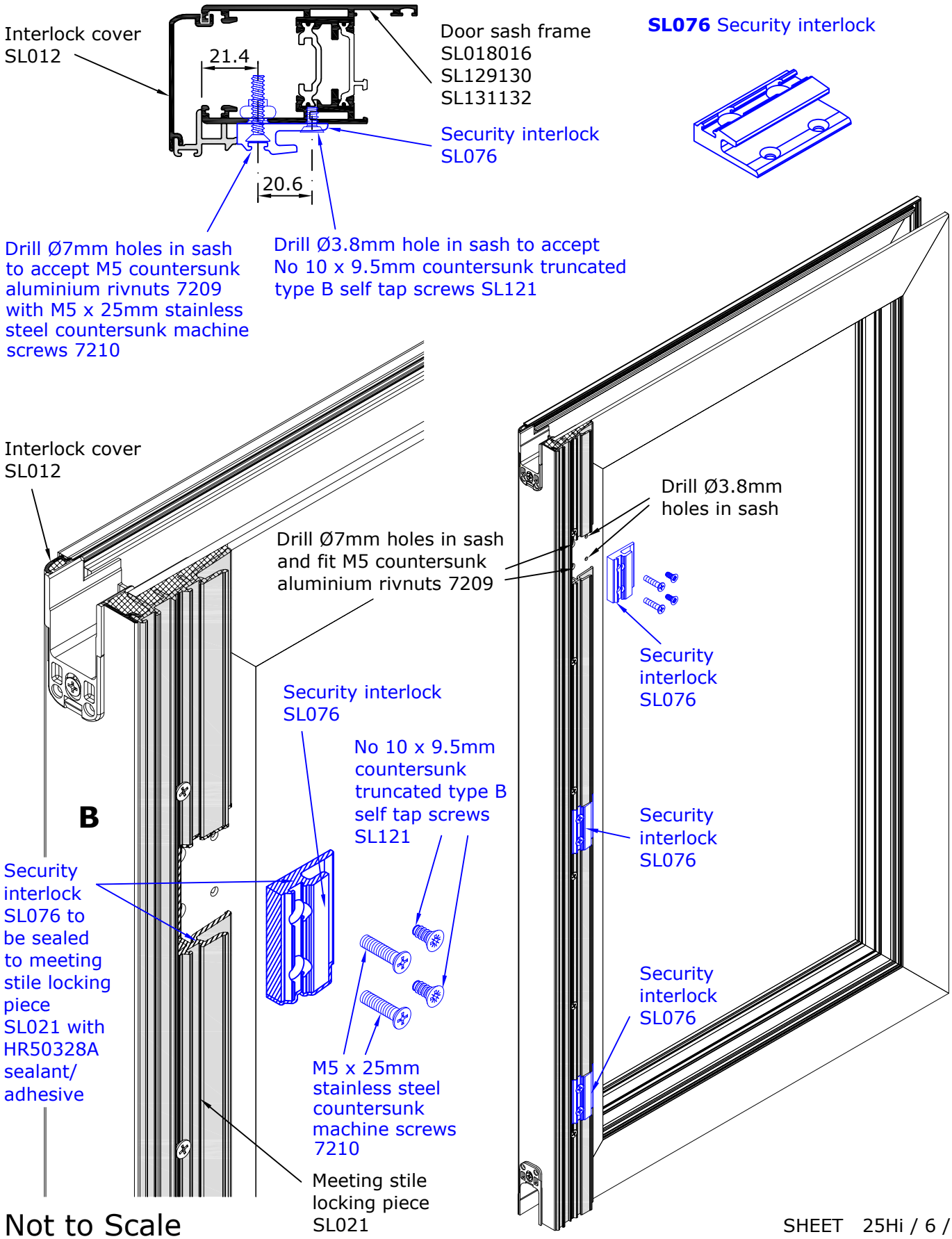




Not to Scale

Sash Assembly - SL076 Security Interlock Fixing Details

Read the following details in conjunction with "Sash Assembly - SL012 and SL021 Meeting Stile Fixing Details" sheets, and "SL021 Meeting Stile Locking Piece Prep Details - Security" sheet.



Not to Scale

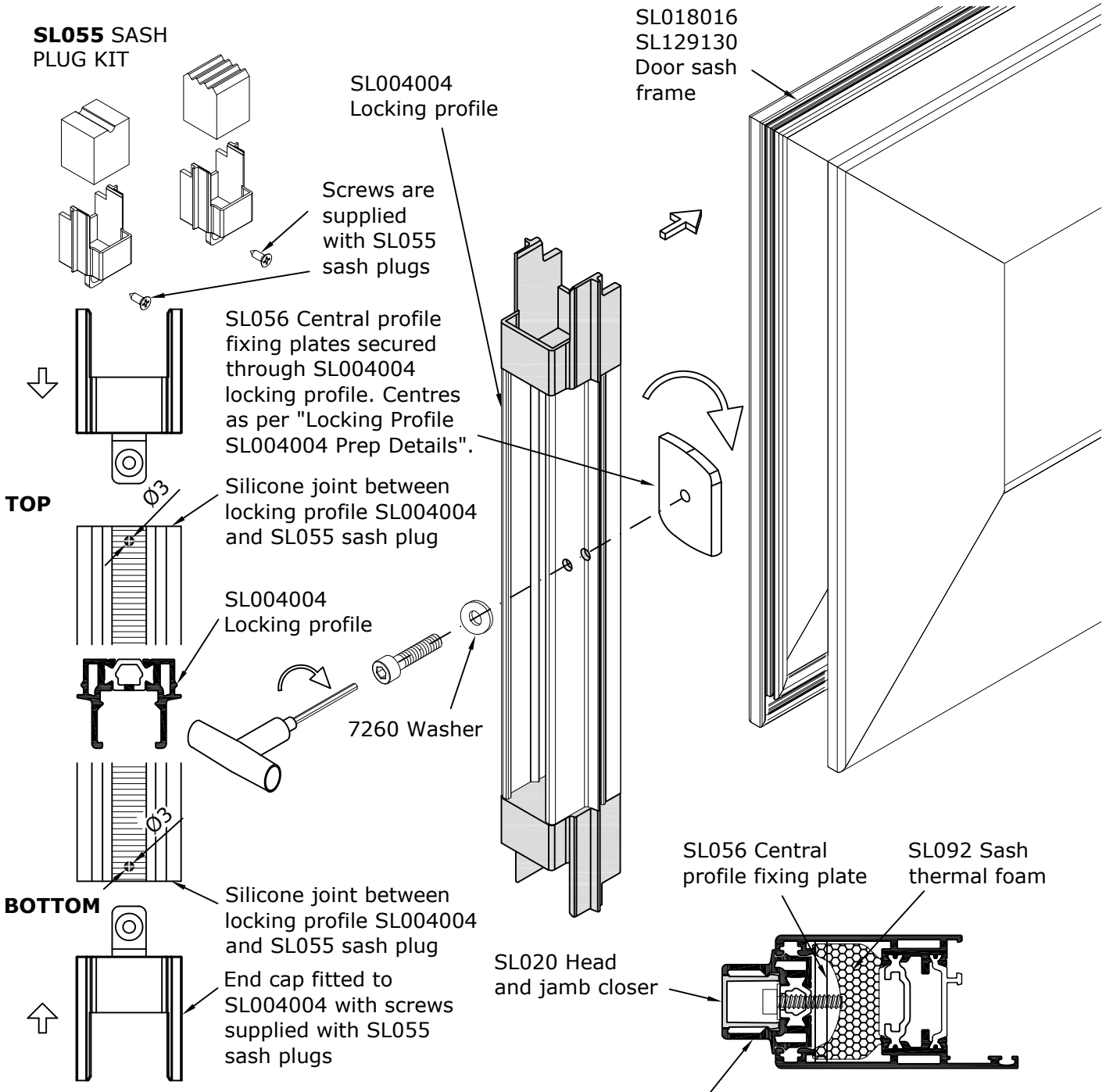
Sash Assembly - SL004004 Locking Profile Fixing Details

System 25 Hi/Hi+

LIFT AND SLIDE DOOR

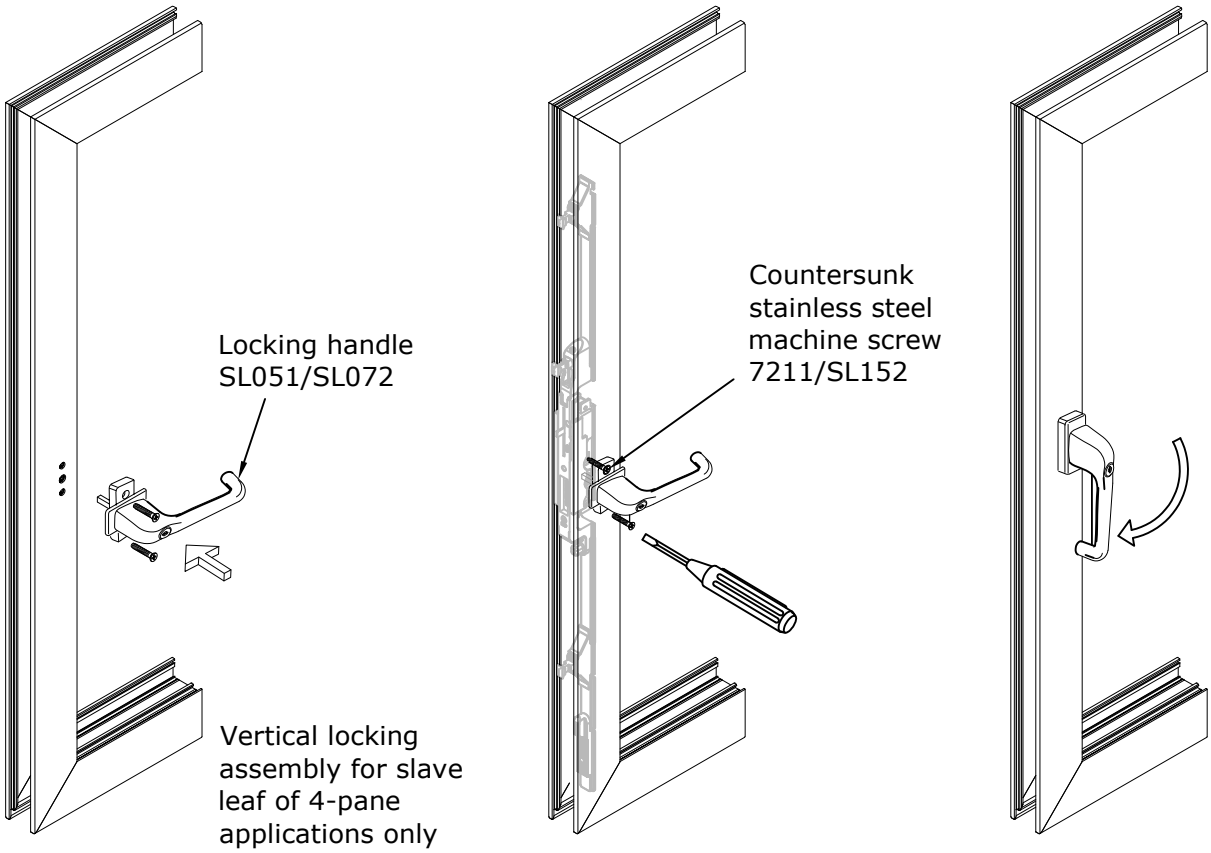
2T

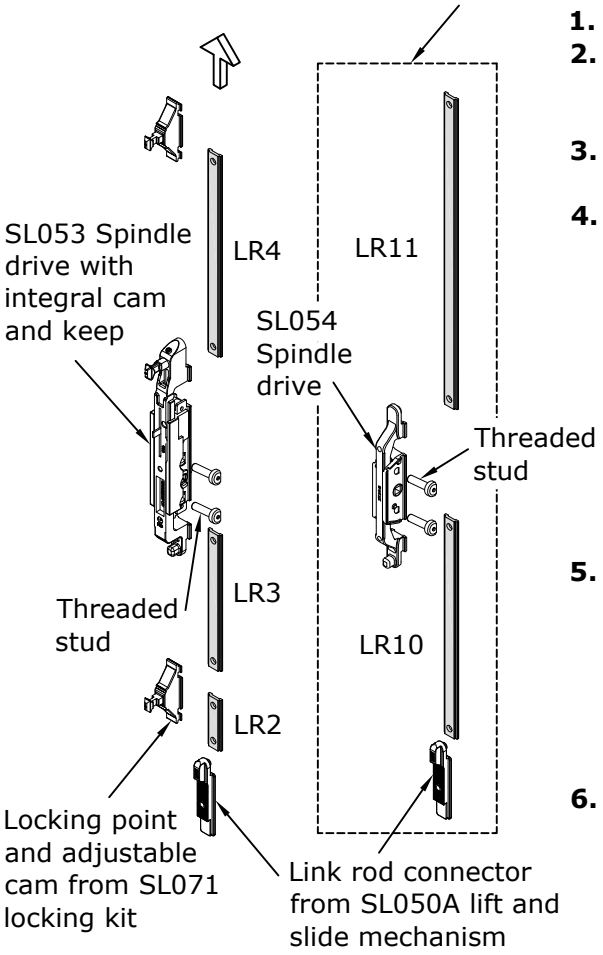
1. SL004004 locking profile is secured to the stile adjacent to the master locking stile in 3 and 4 pane applications. In 4-pane applications it must be applied after the carriages, vertical locking assembly, and anti-lift kit have been installed.
2. Using screws provided, fix plastic mouldings from SL055 sash plug kits to top and bottom of SL004004 locking profile, sealing mating surfaces with silicone.
3. Loosely connect all 5 x SL056 central profile fixing plates to SL004004 locking profile, orientated as shown using the machine screws supplied, and 7260 washers as indicated.
4. Align SL056 central profile fixing plates parallel to SL004004 locking profile so that edges of washers do not project beyond edges of SL004004 locking profile.
5. If using SL092 sash thermal foam (for Hi+ applications only) insert foam for the full length of the sash profile as indicated. Refer also to relevant "Thermal Foam" sheet.
6. Offer SL004004 locking profiles into SL018016 door sash frame, centering vertically.
7. Secure in place by tightening machine screws using allen key. This rotates the SL056 central profile fixing plates, locking SL004004 into place.



Not to Scale

Locking Gear Assembly to Double Track Lift and Slide Sash

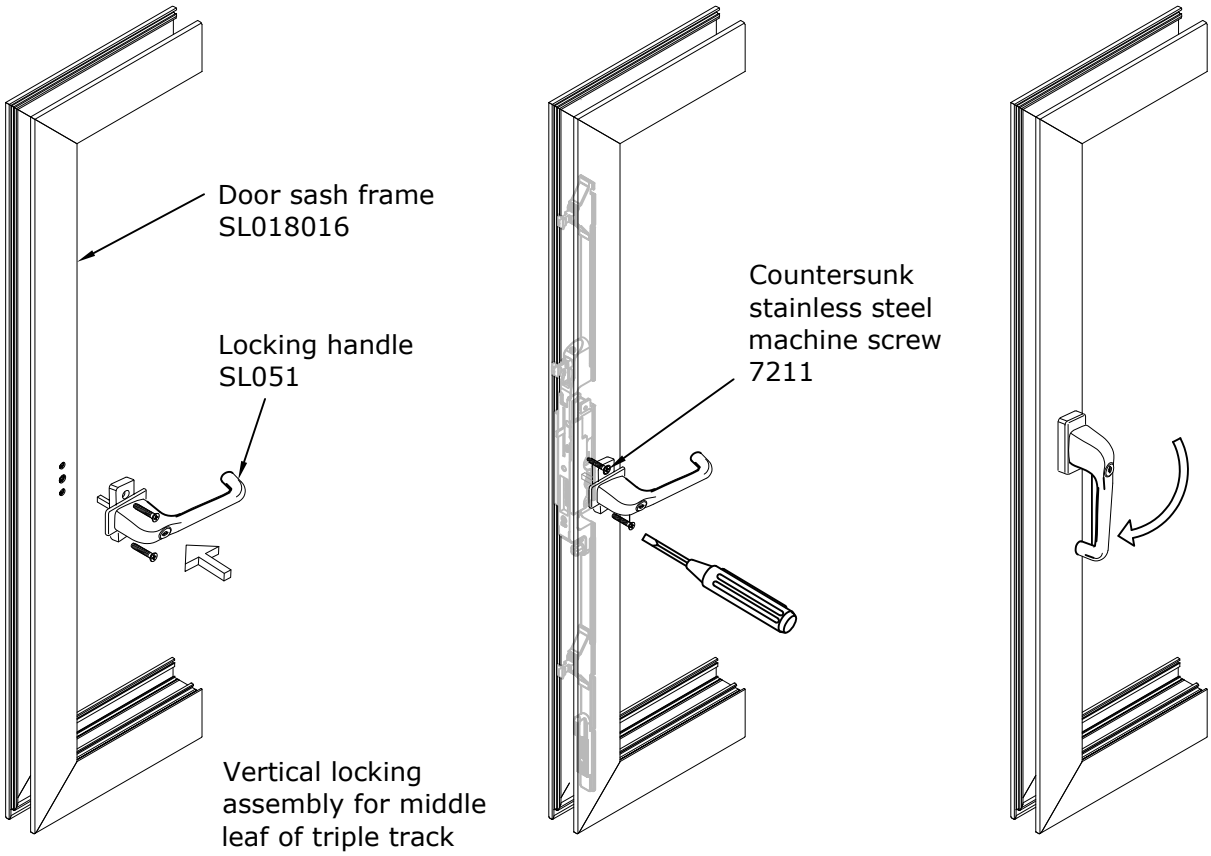


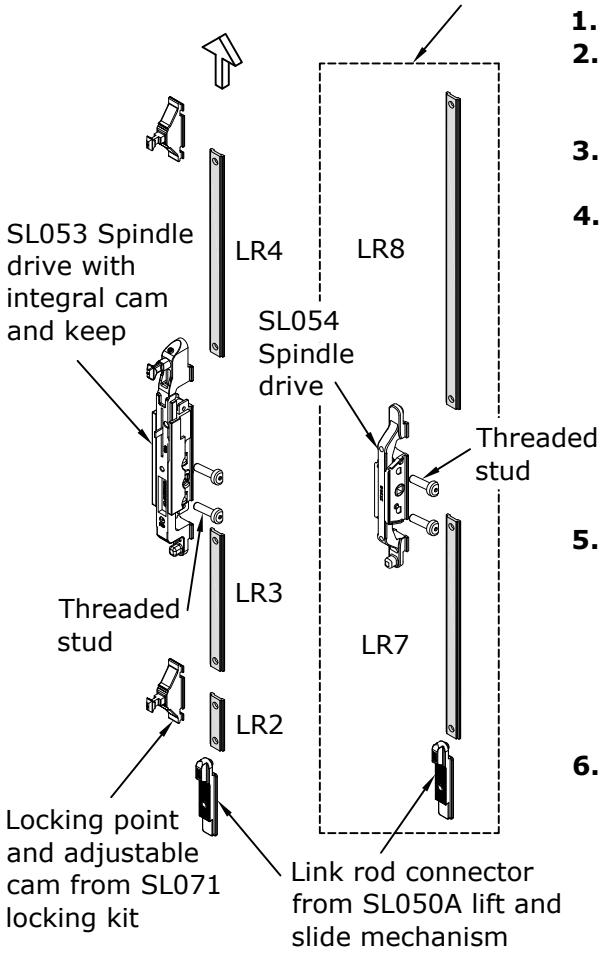


1. Identify locking stile of moving sash.
2. Ensure sash corners have been notched 5mm x 2.5mm as shown on "Sash Prep Details" sheets, using applicable punch tool JIG25002 or 1A373900.
3. If using external pull handle, this must be fitted prior to fitting vertical locking assembly to ensure access to its fixings.
4. For gear assembly to lift and slide sash, the following components will be required:
   7211 screws (handle SL051) or SL152 screws (handle SL072)
   SL050A Lift and Slide mechanism
   SL051 Locking handle (sash SL018016) or SL072 locking handle (sash SL129130)
   SL053 Spindle drive with integral cam and keep (or SL054 spindle drive for slave leaf of 4-pane)
   SL067 Single shock absorber and lift proof kit
   SL071 Locking kits
   SL023 Link rod
5. Set spindle drive to neutral position (no spindle drive cogs protruding at rear). Ensure threaded studs are located within spindle drive prior to inserting into sash profile. Head of studs to be located on same side of spindle drive as handle. Connect spindle drive, locking kits, link rod connector, and link rods and insert into groove in polyamide strip, from below, as indicated, to create vertical locking assembly.
6. Using 2 No countersunk stainless steel machine screws 7211/SL152, connect locking handle SL051/SL072 to threaded studs in spindle drive, ensuring lever is in horizontal position, as indicated. Secure machine screws and pull handle down into vertical position.

Not to Scale

Locking Gear Assembly to Triple Track Lift and Slide Sashes





1. Identify locking stile of moving sash.

2. Ensure sash corners have been notched 5mm x 2.5mm as shown on "SL018016 Sash Prep Details" sheet, using punch tool JIG25002.

3. If using external pull handle, this must be fitted prior to fitting vertical locking assembly to ensure access to its fixings.

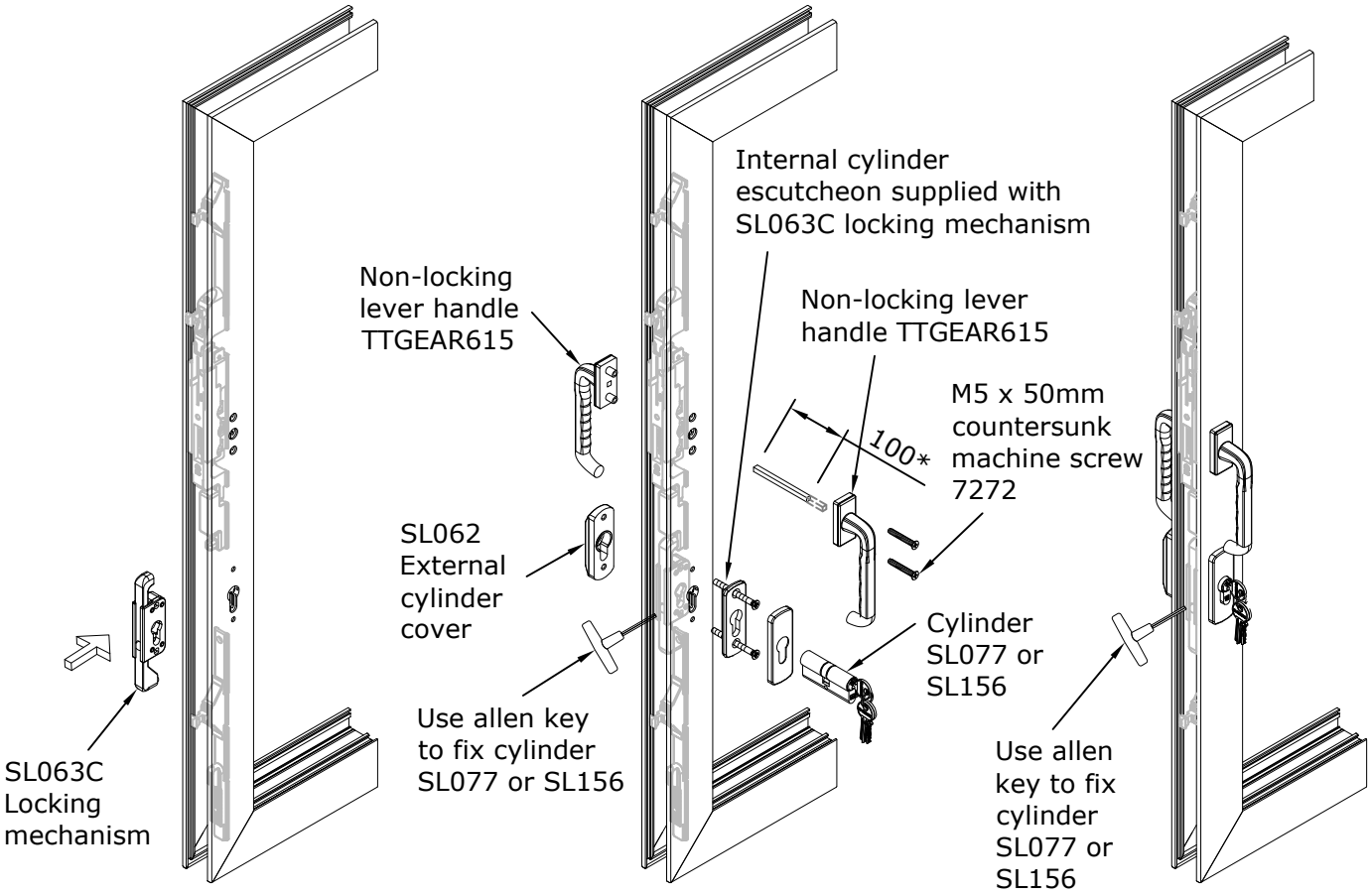
4. For gear assembly to lift and slide sash, the following components will be required:
- 7211 screws
- SL050A Lift and Slide mechanism
- SL051 Locking handle
- SL053 Spindle drive with integral cam and keep
- SL054 spindle drive for middle leaf of triple track
- SL067 Single shock absorber and lift proof kit
- SL071 Locking kits
- SL023 Link rod

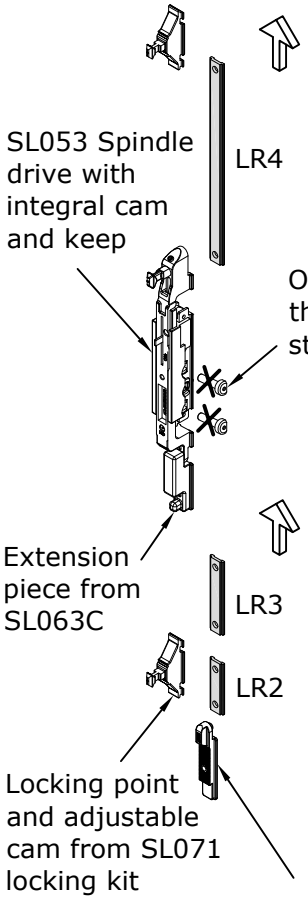
5. Set spindle drive to neutral position (no spindle drive cogs protruding at rear). Ensure threaded studs are located within spindle drive prior to inserting into sash profile. Head of studs to be located on same side of spindle drive as handle. Connect spindle drive, locking kits, link rod connector, and link rods and insert into groove in polyamide strip, from below, as indicated, to create vertical locking assembly.

6. Using 2 No countersunk stainless steel machine screws 7211, connect locking handle SL051 to threaded studs in spindle drive, ensuring lever is in horizontal position, as indicated. Secure machine screws and pull handle down into vertical position.

Not to Scale

Locking Gear Assembly to Master Leaf Lift and Slide Sash SL018016 with TTGEAR615 Handles





*Fabricator to cut spindle supplied with TTGEAR615 lever handle set to 100mm

1. Identify locking stile of master leaf sash.

2. Ensure sash corners have been notched 5mm x 2.5mm as shown on "SL018016 Sash Prep Details" sheet, using punch tool JIG25002.

3. Ensure sash is prepped as per "Sash Prep Details - SL053 and SL063C Preps for TTGEAR615 Non-locking Lever Handles" sheet.

4. For gear assembly to lift and slide sash, the following components will be required:

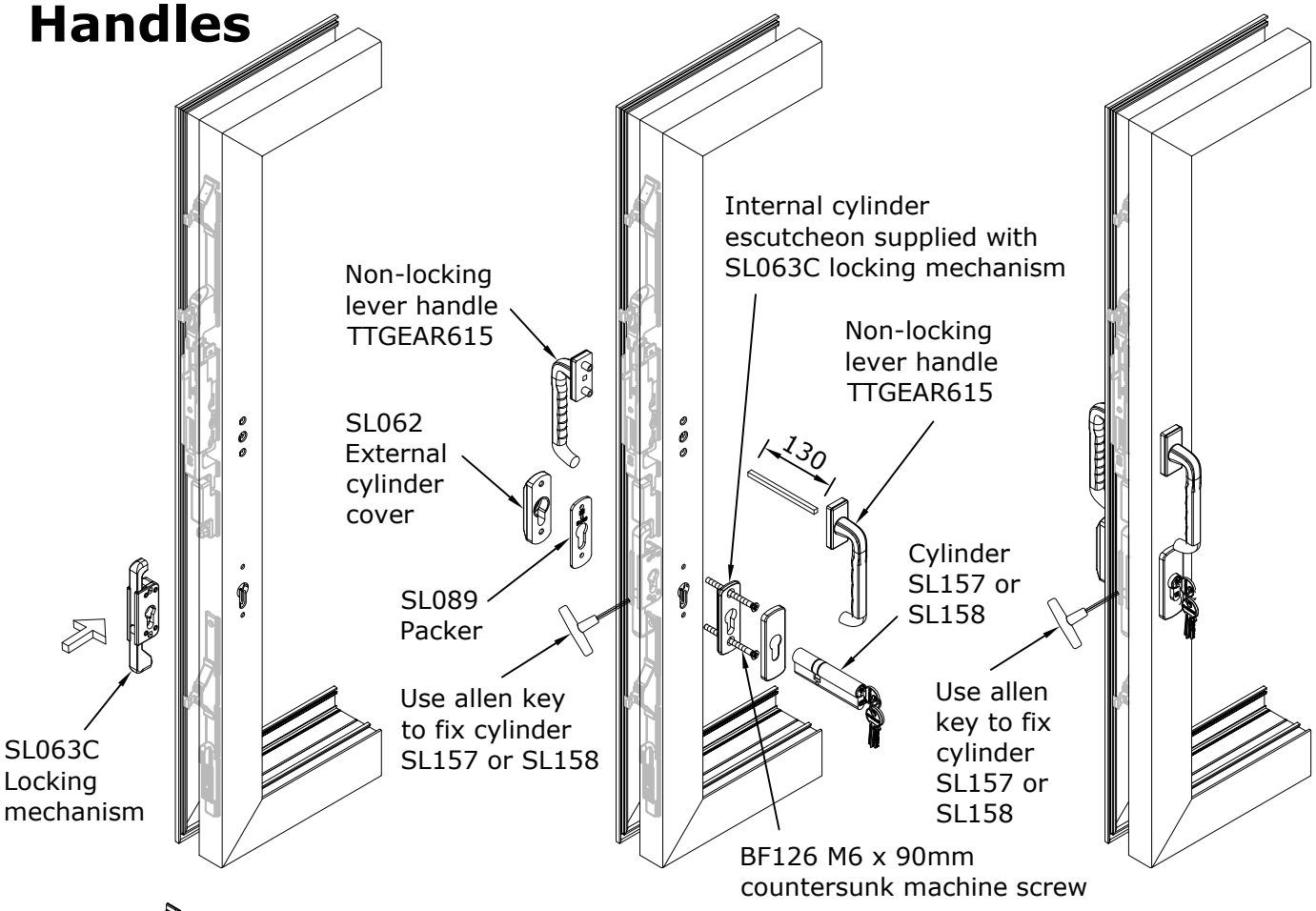
- 2 No 7272 M5 x 50mm countersunk machine screw
- SL023 Link rod
- SL050A Lift and Slide mechanism
- SL053 Spindle drive with integral cam and keep
- SL062 External cylinder cover
- SL063C Locking mechanism with cylinder escutcheon
- SL067 Single shock absorber and lift proof kit
- SL071 Locking kits
- SL077 or SL156 Cylinder
- TTGEAR615 Non-locking lever handles

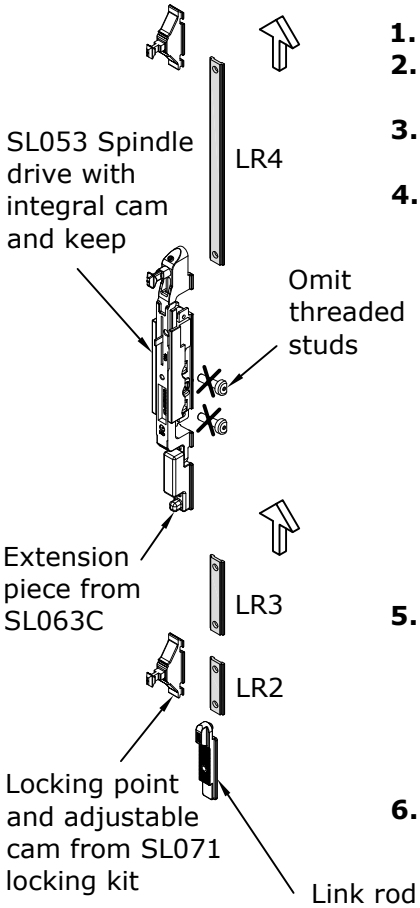
5. Set spindle drive to neutral position (no spindle drive cogs protruding at rear). Omitting threaded studs connect spindle drive, locking kits, link rod connector, link rods, and extension piece from SL063C, and insert into groove in polyamide strip, from below, as indicated, to create vertical locking assembly. Connect SL063C locking mechanism to LR3 link rod and spindle drive as shown.

6. Refer to "TTGEAR615 Handle Assembly Details - Master Leaf" and "SL062 External Cylinder Cover Assembly Details" sheets.

Not to Scale

Locking Gear Assembly to Master Leaf Double Track Lift and Slide Sash SL129130 with TTGEAR615 Handles





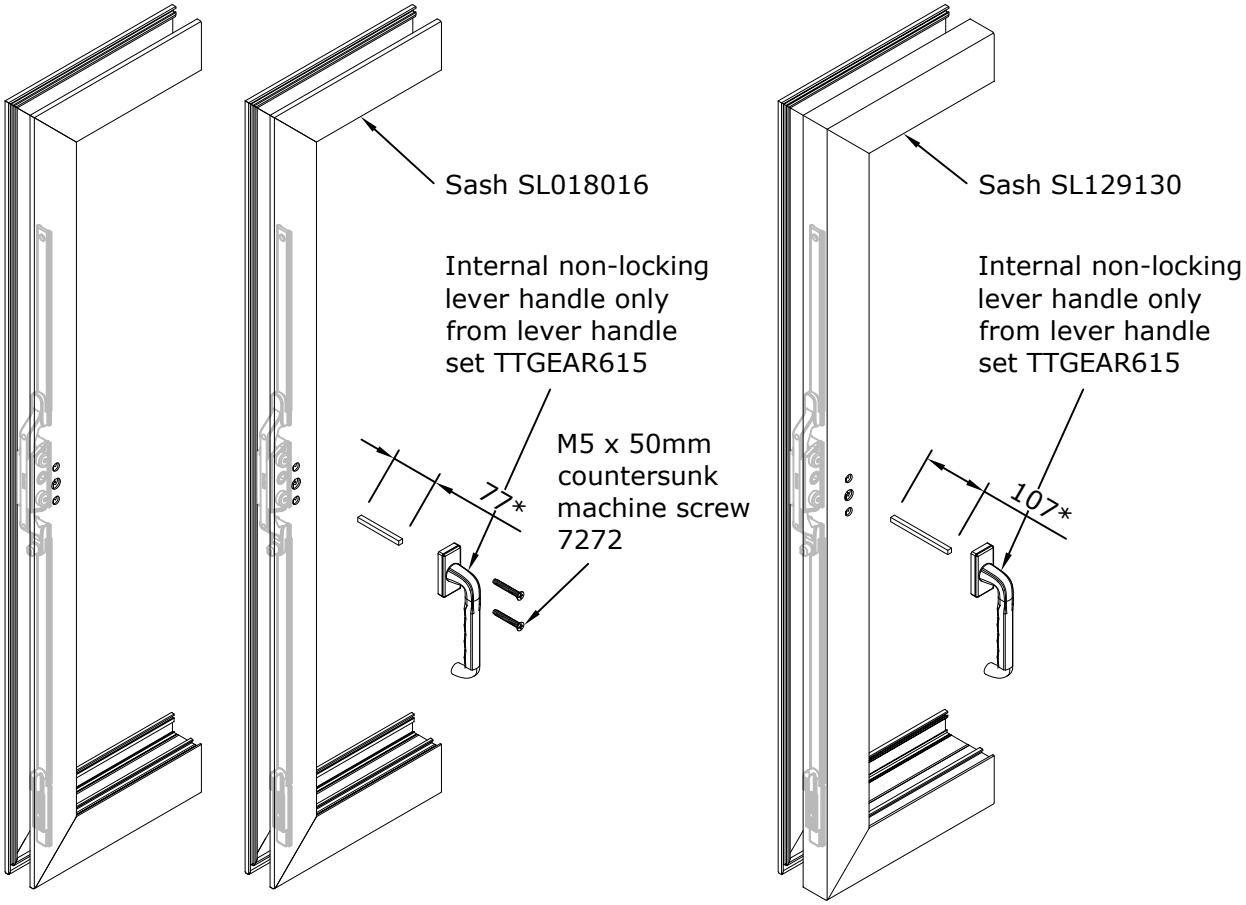
1. Identify locking stile of master leaf sash.
2. Ensure sash corners have been notched 5mm x 2.5mm as shown on "SL129130 Sash Prep Details" sheet, using punch tool 1A373900.
3. Ensure sash is prepped as per "Sash Prep Details - SL053 and SL063C Preps for TTGEAR615 Non-locking Lever Handles" sheet.
4. For gear assembly to lift and slide sash, the following components will be required:
- BF126 M6 x 90mm countersunk machine screw
- SL023 Link rod
- SL050A Lift and slide mechanism
- SL053 Spindle drive with integral cam and keep
- SL062 External cylinder cover
- SL063C Locking mechanism with cylinder escutcheon
- SL067 Single shock absorber and lift proof kit
- SL071 Locking kits
- SL089 Packer for external cylinder cover
- SL157 or SL158 Extended cylinder
- TTGEAR615 Non-locking lever handles

5. Set spindle drive to neutral position (no spindle drive cogs protruding at rear). Omitting threaded studs connect spindle drive, locking kits, link rod connector, link rods, and extension piece from SL063C, and insert into groove in polyamide strip, from below, as indicated, to create vertical locking assembly. Connect SL063C locking mechanism to LR3 link rod and spindle drive as shown.
6. Refer to "TTGEAR615 Handle Assembly Details - Master Leaf" and "SL062 External Cylinder Cover Assembly Details" sheets.

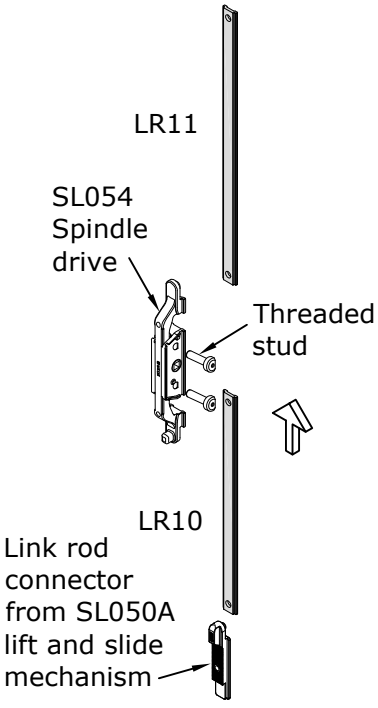
Not to Scale

Locking Gear Assembly to Slave Leaf Double Track Lift and Slide Sashes with TTGEAR615 Handles

4-Pane Applications



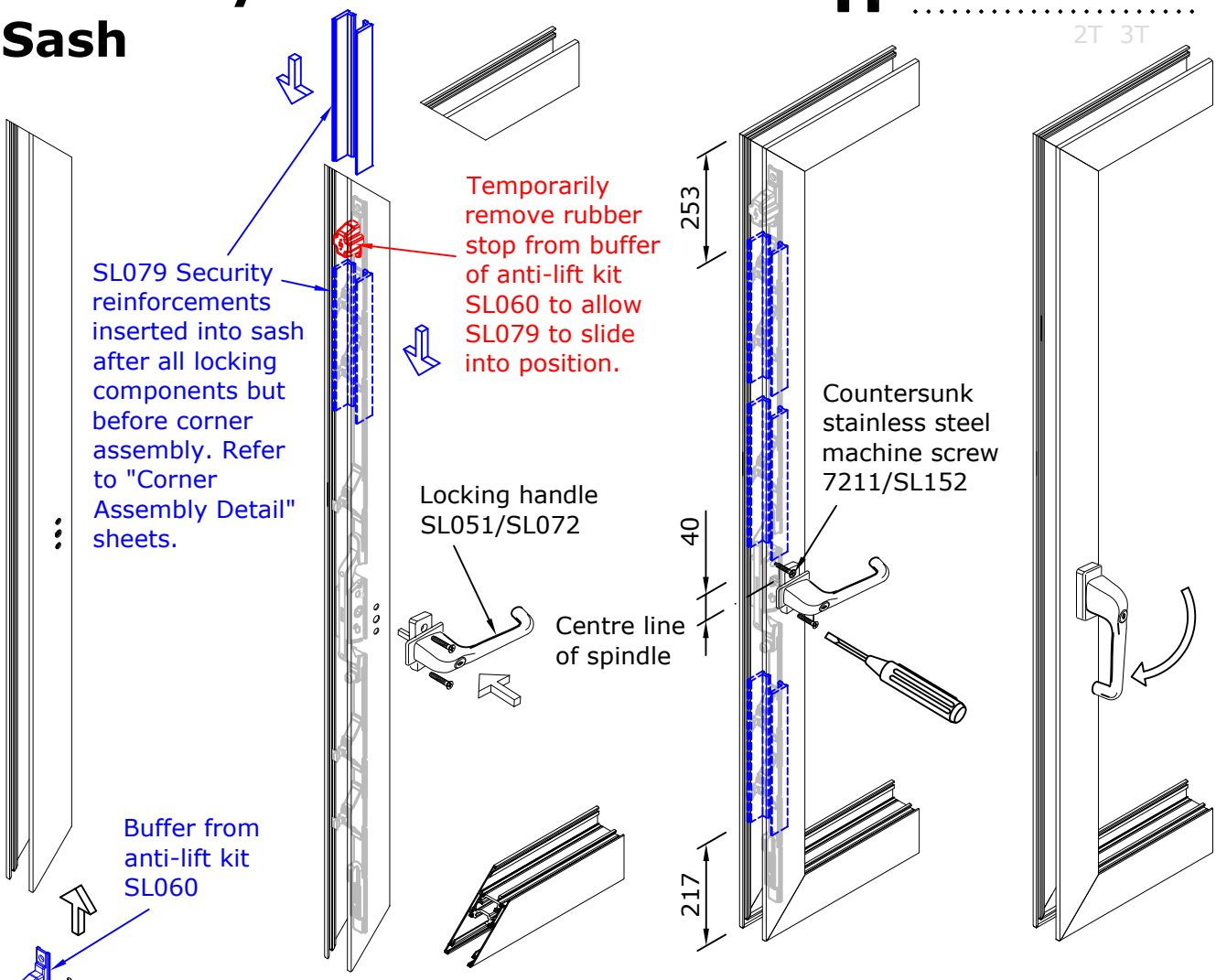
*Fabricator to cut spindle supplied with TTGEAR615 lever handle set to 77mm when using sash SL018016 and to 107mm when using sash SL129130.



1. Identify locking stile of slave leaf sash.
2. Ensure sash corners have been notched 5mm x 2.5mm as shown on "Sash Prep Details" sheets, using applicable punch tool JIG25002 or 1A373900.
3. Ensure sash is prepped as per "Sash Prep Details - SL053 and SL063C Preps for TTGEAR615 Non-locking Lever Handles" sheet. Note that slave leaf must only be prepped internally for handle, and not prepped for cylinder.
4. For gear assembly to slave leaf sash, the following components will be required:
   - 2 No 7272 M5 x 50mm countersunk machine screw (SL018016 sash only)
   - SL023 Link rod
   - SL050A Lift and Slide mechanism
   - SL054 Spindle drive for slave leaf
   - SL060 Anti-lift kit (Refer to "Anti-Lift Kit Assembly Double Track Lift and Slide Sash" for slave leaf of 4-pane applications and security applications sheet.)
   - TTGEAR615 Non-locking lever handle (internal handle only)
5. Set spindle drive to neutral position (no spindle drive cogs protruding at rear). Ensure threaded studs are located within spindle drive prior to inserting into sash profile. Connect spindle drive, link rod connector, and link rods, and insert into groove in polyamide strip, from below, as indicated, to create vertical locking assembly.
6. Refer to "TTGEAR615 Handle Assembly Details - Slave Leaf" sheet.

Not to Scale

Security Locking Gear Assembly to Lift and Slide Sash

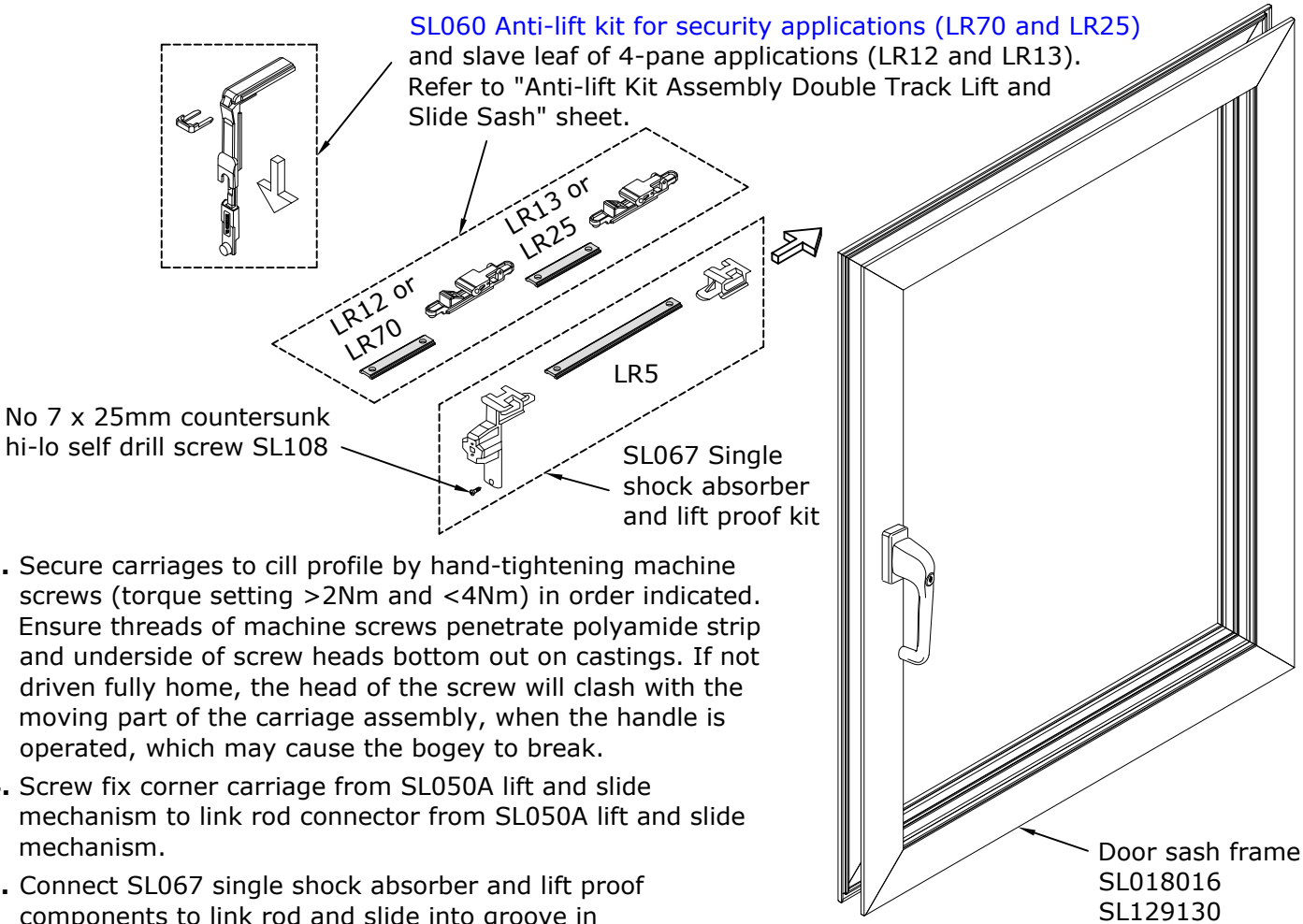


1. Identify locking stile of moving sash.
2. Fit the following components to locking stile of moving sash prior to assembling the sash corners:
   7211 screws (handle SL051) or SL152 screws (handle SL072)
   SL050A Lift and Slide mechanism
   SL051 Locking handle (sash SL018016) or SL072 locking handle (sash SL129130)
   SL054 Spindle drive
   SL060 Anti-lift kit
   SL071 Locking kits
   SL023 Link rod
3. Set spindle drive to neutral position (no spindle drive cogs protruding at rear). Ensure threaded studs are located within spindle drive prior to inserting into sash profile. Head of studs to be located on same side of spindle drive as handle. Connect spindle drive, locking kits, buffer, link rod connector, and link rods and insert into groove in polyamide strip, from below, as indicated, to create vertical locking assembly.
4. Insert and silicone SL079 top, bottom and middle security reinforcements into position as per dimensions shown.
5. Referring to "Corner Assembly Detail" sheets assemble corners.
6. Using 2 No countersunk stainless steel machine screws 7211/SL152, connect locking handle SL051/SL072 to threaded studs in spindle drive, ensuring lever is in horizontal position, as indicated. Secure machine screws and pull handle down into vertical position.

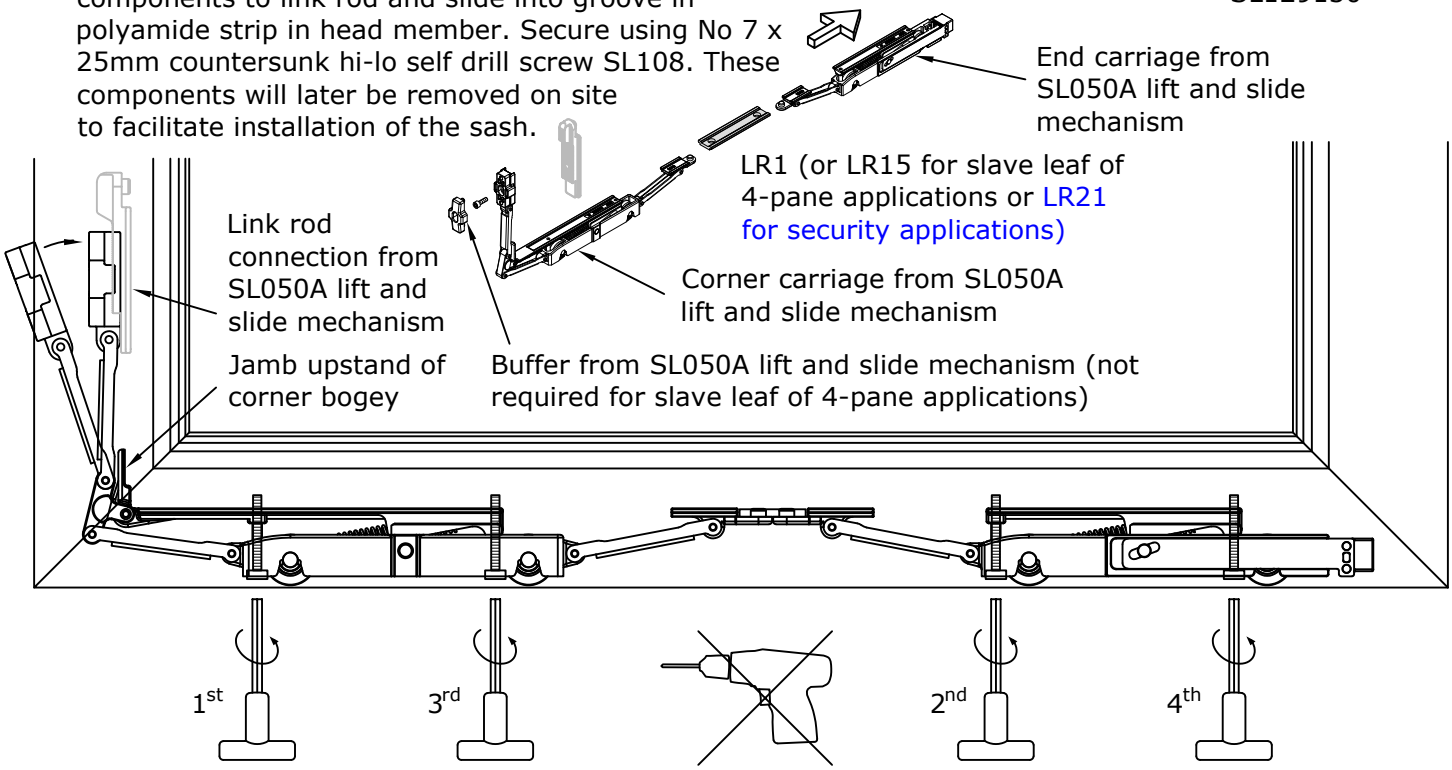
Not to Scale

Carriage Assembly to Double Track Lift and Slide Sash

1. Connect SL050A lift and slide bogeys to link rod and slide into groove in polyamide strip in sash cill member.
2. Push corner carriage into profile so that jamb upstand sits tight against polyamide strip.



3. Secure carriages to cill profile by hand-tightening machine screws (torque setting >2Nm and <4Nm) in order indicated. Ensure threads of machine screws penetrate polyamide strip and underside of screw heads bottom out on castings. If not driven fully home, the head of the screw will clash with the moving part of the carriage assembly, when the handle is operated, which may cause the bogey to break.
4. Screw fix corner carriage from SL050A lift and slide mechanism to link rod connector from SL050A lift and slide mechanism.
5. Connect SL067 single shock absorber and lift proof components to link rod and slide into groove in polyamide strip in head member. Secure using No 7 x 25mm countersunk hi-lo self drill screw SL108. These components will later be removed on site to facilitate installation of the sash.



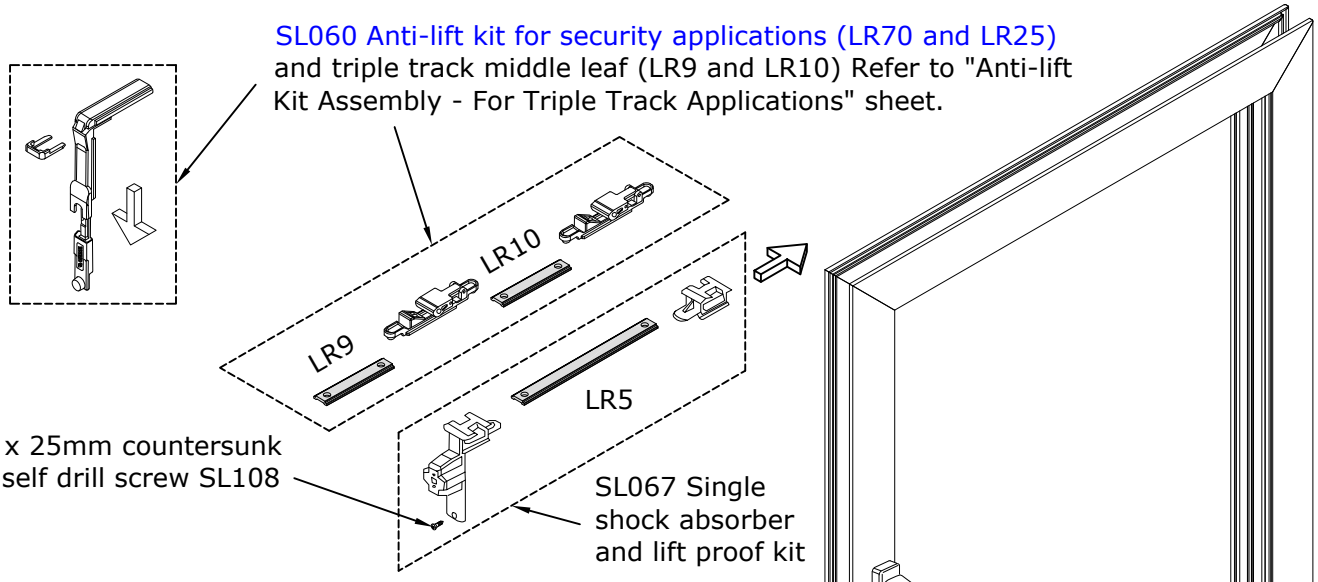
Not to Scale

DO NOT TIGHTEN WITH BATTERY DRILL

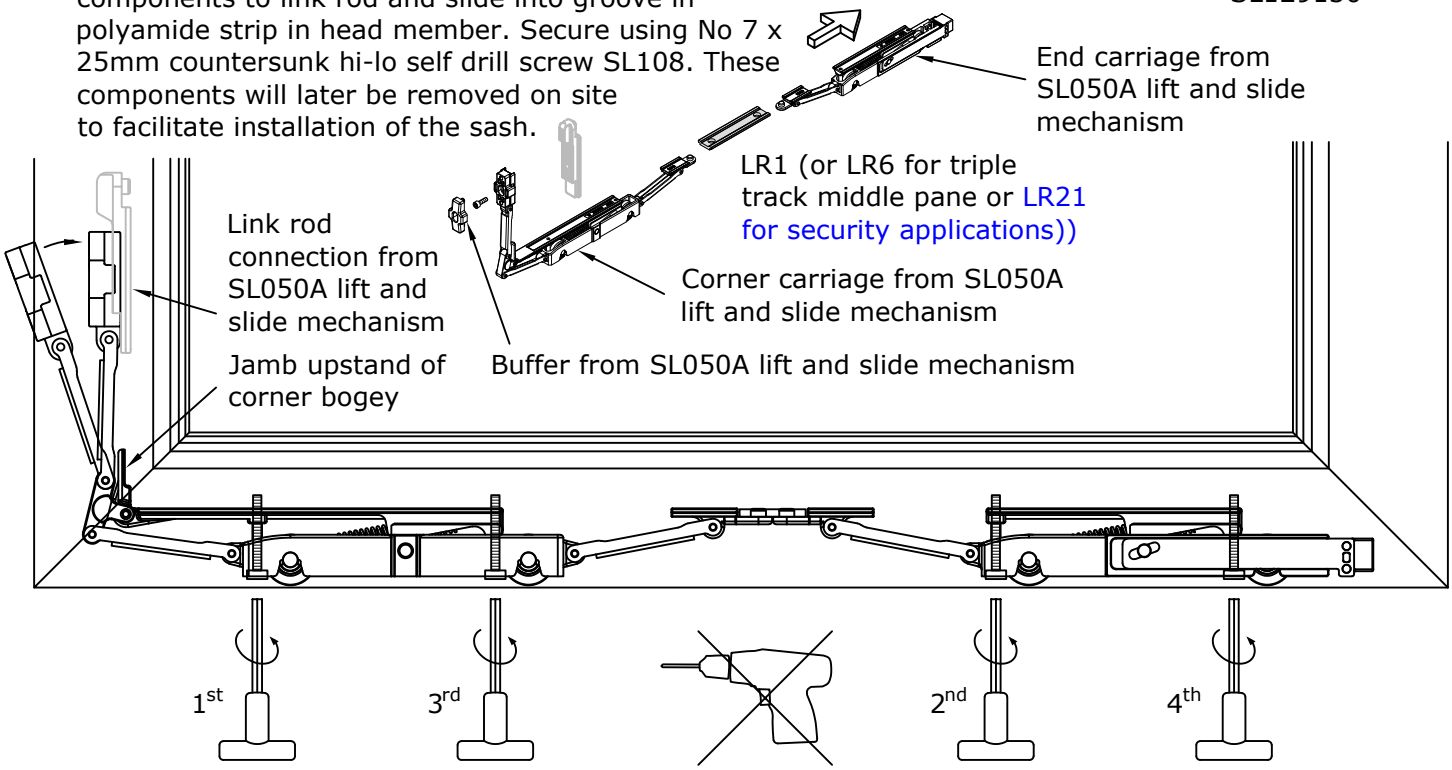
Carriage Assembly to Triple Track Lift and Slide Sashes

System 25 Hi/Hi+
LIFT AND SLIDE DOOR
3T

1. Connect SL050A lift and slide bogeys to link rod and slide into groove in polyamide strip in sash cill member.
2. Push corner carriage into profile so that jamb upstand sits tight against polyamide strip.



3. Secure carriages to cill profile by hand-tightening machine screws (torque setting >2Nm and <4Nm) in order indicated. Ensure threads of machine screws penetrate polyamide strip and underside of screw heads bottom out on castings. If not driven fully home, the head of the screw will clash with the moving part of the carriage assembly, when the handle is operated, which may cause the bogey to break.
4. Screw fix corner carriage from SL050A lift and slide mechanism to link rod connector from SL050A lift and slide mechanism.
5. Connect SL067 single shock absorber and lift proof components to link rod and slide into groove in polyamide strip in head member. Secure using No 7 x 25mm countersunk hi-lo self drill screw SL108. These components will later be removed on site to facilitate installation of the sash.



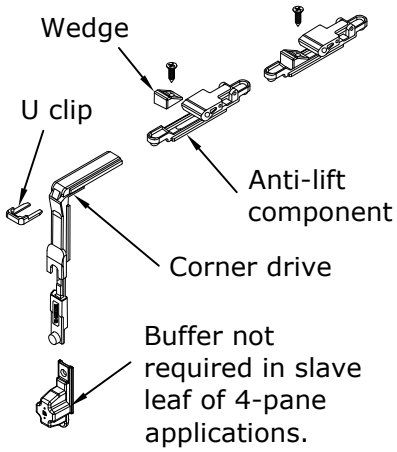
Not to Scale

DO NOT TIGHTEN WITH BATTERY DRILL

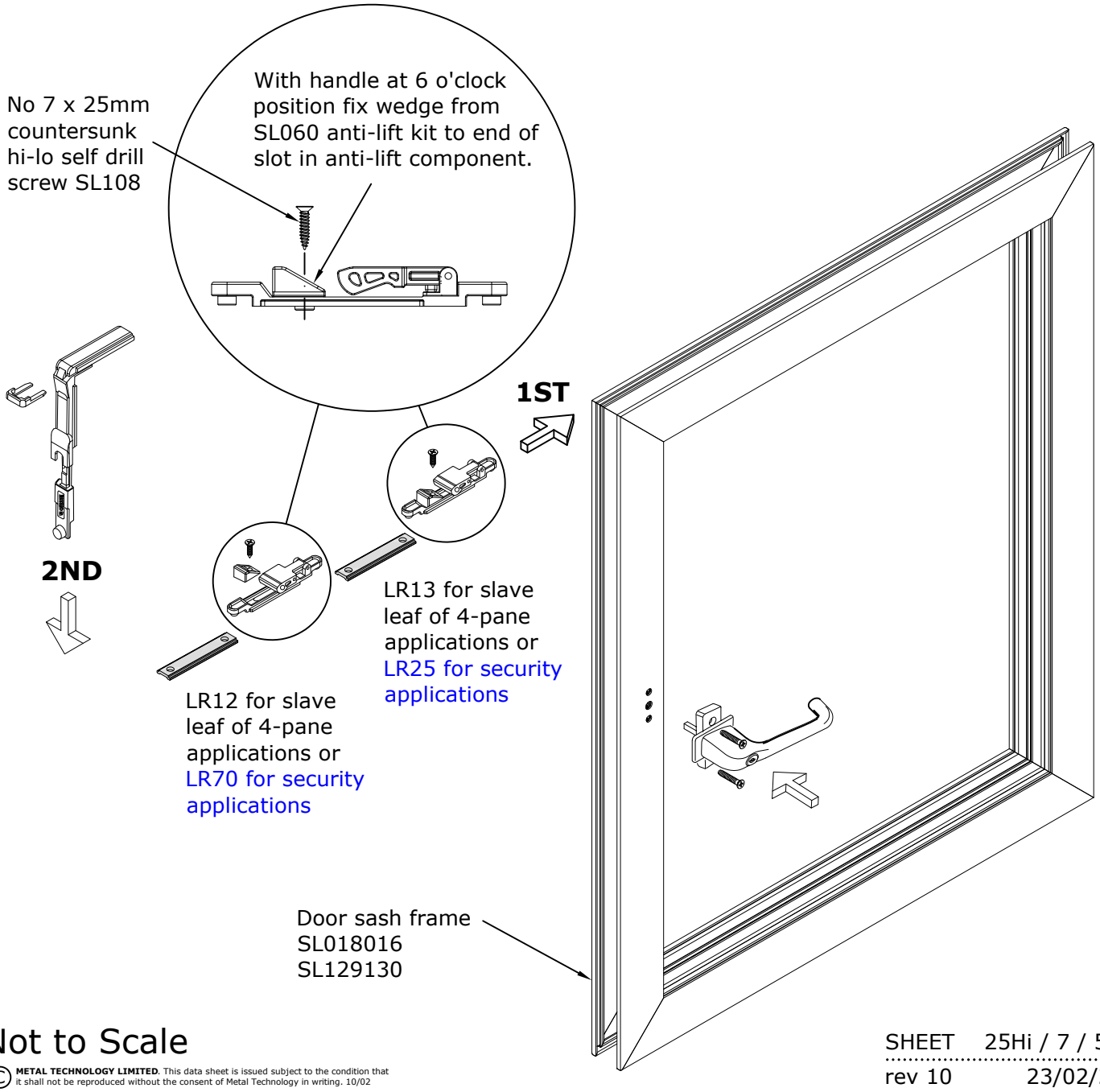
Anti-Lift Kit Assembly Double Track Lift and Slide Sash

For Security Applications and Slave Leaf of 4-pane Applications

1. Anti-lift kit SL060 is required for slave leaf in 4-pane applications and security applications.
2. Assemble horizontal components of SL060 anti-lift kit as indicated and slide into groove in polyamide strip in top rail of slave sash. If already fitted remove handle and disconnect lift and slide carriages.
3. Slide vertical locking kit upward and connect corner drive of anti-lift kit to upper link rod.
4. Slide vertical locking assembly downward and connect corner drive to link rod of horizontal anti-lift kit assembly.
5. Insert U clip into corner drive to secure in place.
6. With spindle drive still in neutral position, re-fit handle, ensuring lever of handle is in horizontal position.
7. Pull handle down into vertical position and secure wedges to polyamide strip in head member through slot in anti-lift components using specialist hi-lo screws SL108, as indicated.
8. Connect vertical locking assembly to carriage assembly.



SL060
ANTI-LIFT KIT



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Anti-Lift Kit Assembly

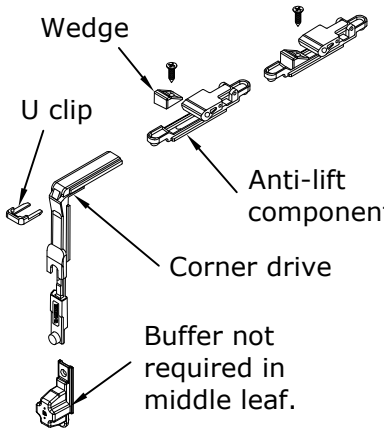
For Triple Track Applications

System 25 Hi/Hi+

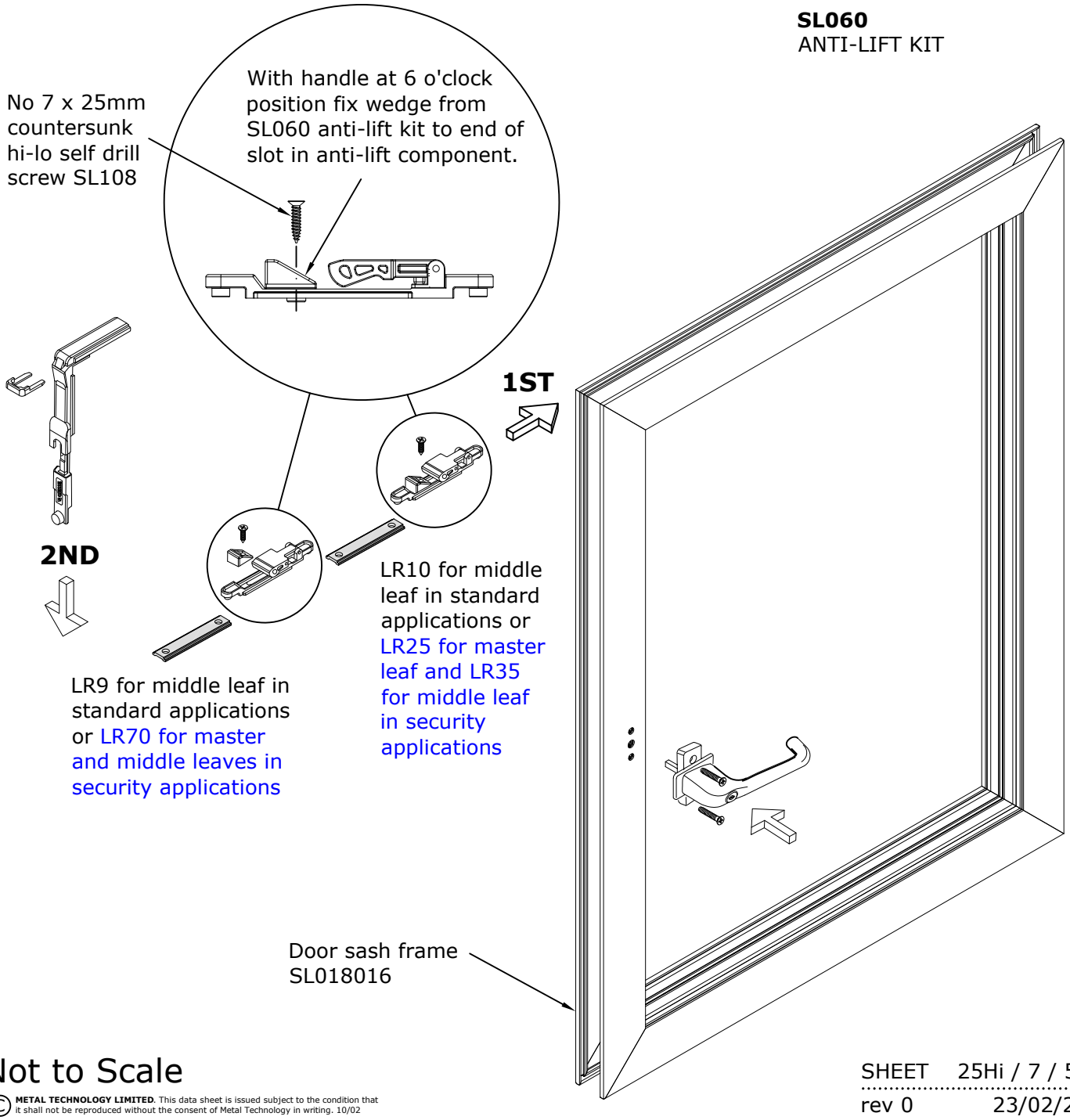
LIFT AND SLIDE DOOR

3T

1. Anti-lift kit SL060 is required for middle leaf in standard applications and master and middle leaves in security applications.
2. Assemble horizontal components of SL060 anti-lift kit as indicated and slide into groove in polyamide strip in top rail of slave sash. If already fitted remove handle and disconnect lift and slide carriages.
3. Slide vertical locking kit upward and connect corner drive of anti-lift kit to upper link rod.
4. Slide vertical locking assembly downward and connect corner drive to link rod of horizontal anti-lift kit assembly.
5. Insert U clip into corner drive to secure in place.
6. With spindle drive still in neutral position, re-fit handle, ensuring lever of handle is in horizontal position.
7. Pull handle down into vertical position and secure wedges to polyamide strip in head member through slot in anti-lift components using specialist hi-lo screws SL108, as indicated.
8. Connect vertical locking assembly to carriage assembly.



SL060
ANTI-LIFT KIT



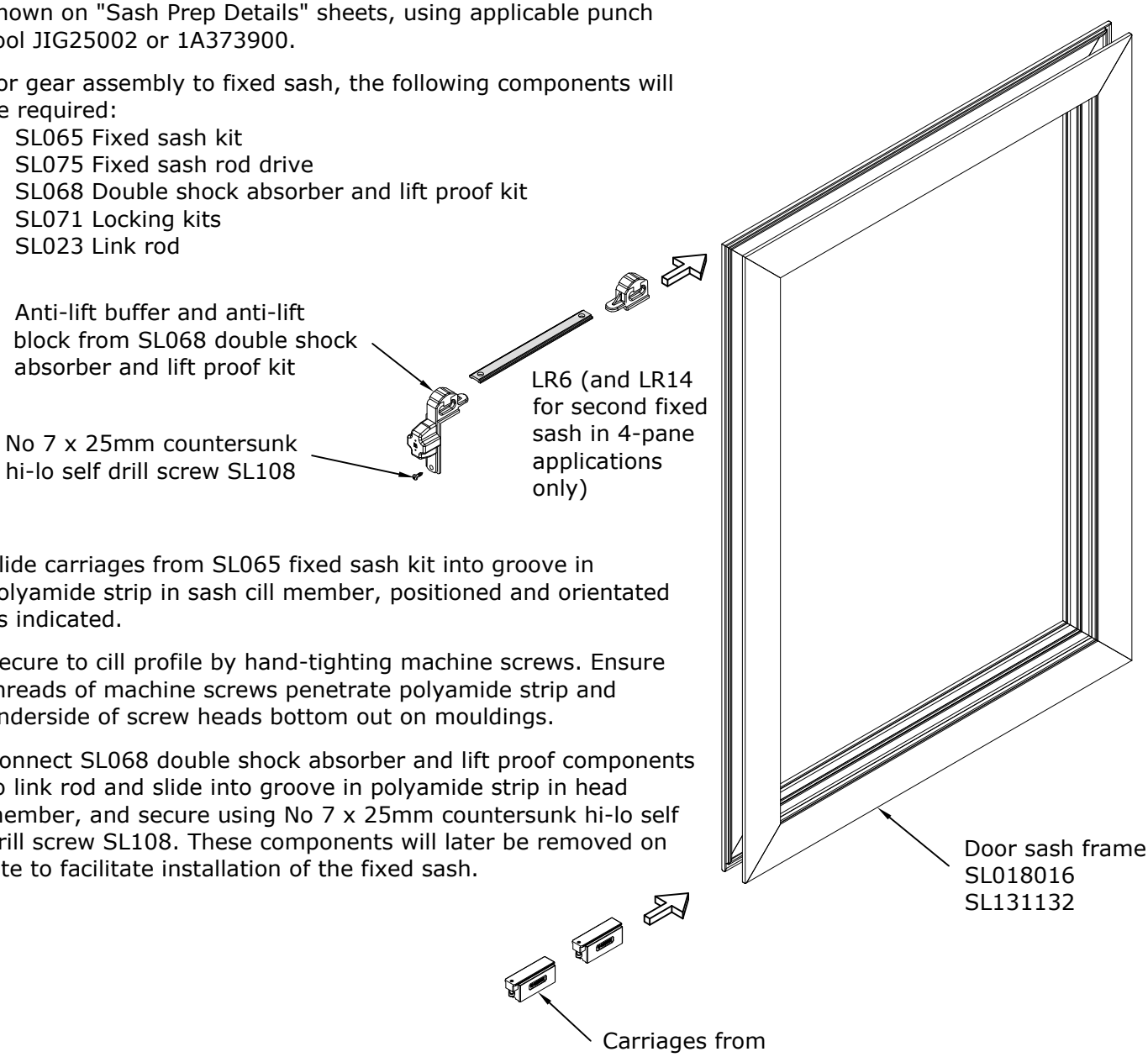
Not to Scale

Carriage Assembly to Fixed Sash

1. Identify jamb stile of fixed sash.

2. Ensure sash corners have been notched 5mm x 2.5mm as shown on "Sash Prep Details" sheets, using applicable punch tool JIG25002 or 1A373900.

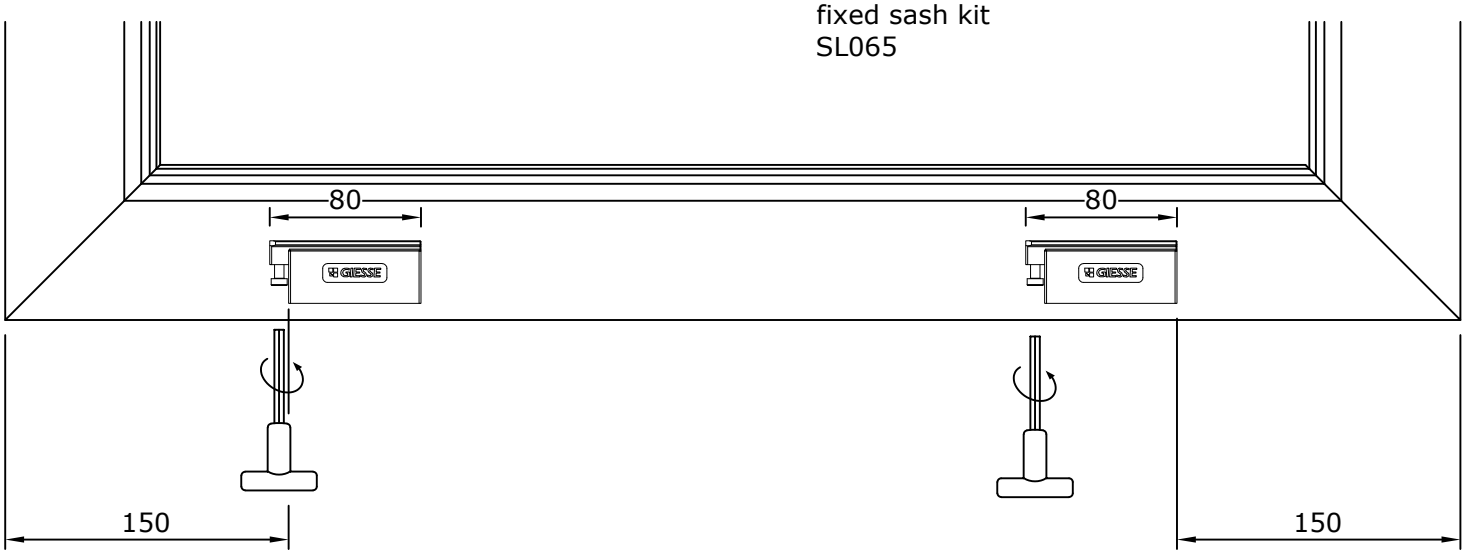
3. For gear assembly to fixed sash, the following components will be required:
SL065 Fixed sash kit
SL075 Fixed sash rod drive
SL068 Double shock absorber and lift proof kit
SL071 Locking kits
SL023 Link rod



4. Slide carriages from SL065 fixed sash kit into groove in polyamide strip in sash cill member, positioned and orientated as indicated.

5. Secure to cill profile by hand-tighting machine screws. Ensure threads of machine screws penetrate polyamide strip and underside of screw heads bottom out on mouldings.

6. Connect SL068 double shock absorber and lift proof components to link rod and slide into groove in polyamide strip in head member, and secure using No 7 x 25mm countersunk hi-lo self drill screw SL108. These components will later be removed on site to facilitate installation of the fixed sash.



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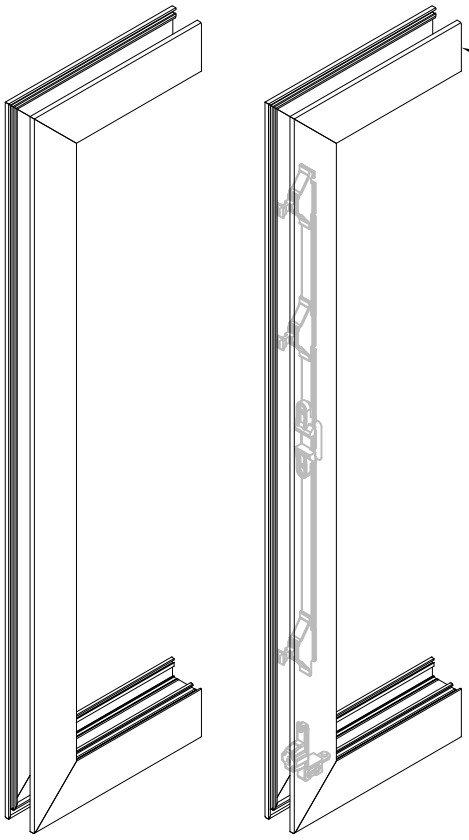
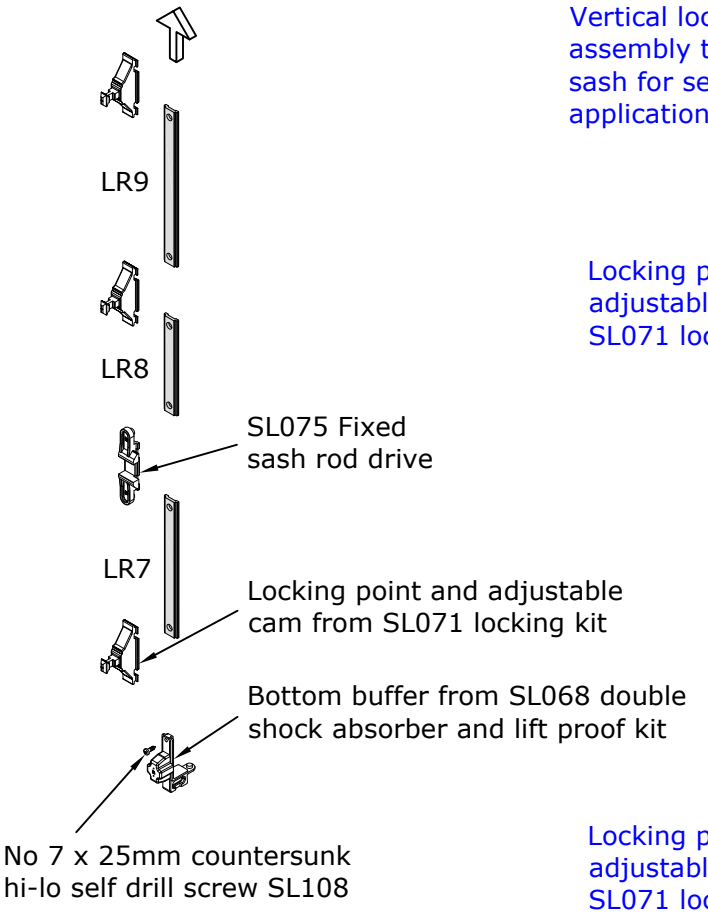
Locking Gear Assembly to Fixed Sash

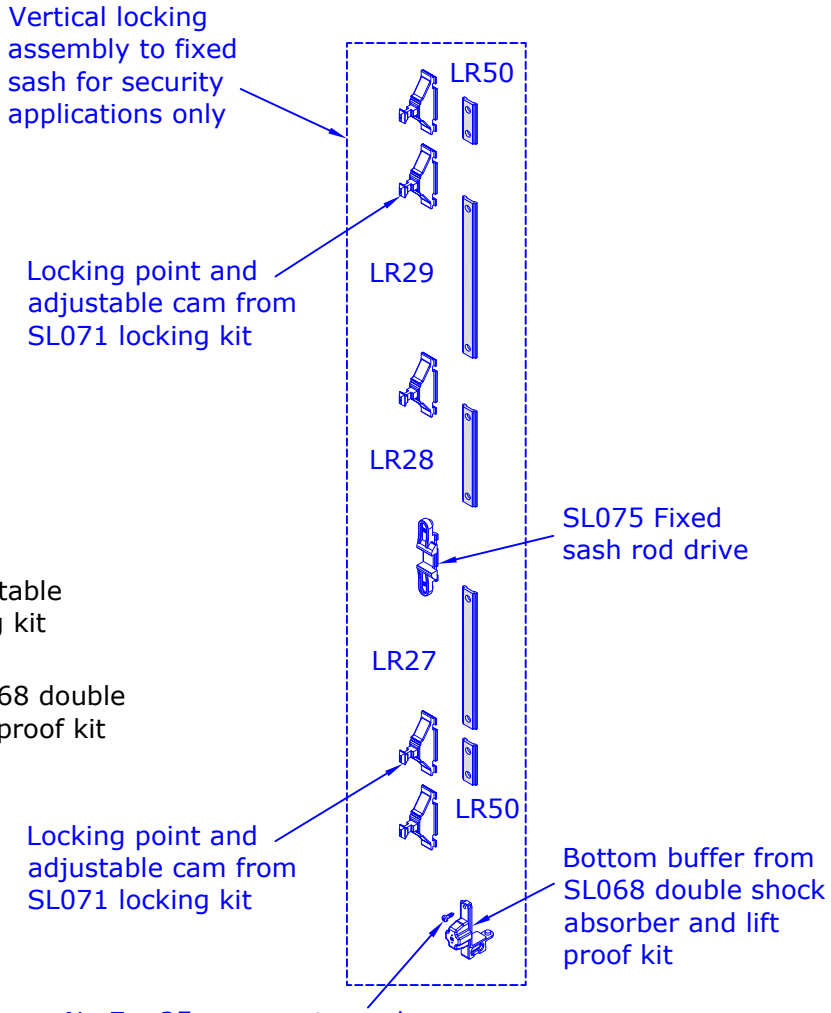


1. Connect slave leaf rod drive, locking kits, and link rods and insert into groove in polyamide strip from below, as indicated to create vertical locking assembly.

2. Align central groove within SL075 fixed sash rod drive with slotted hole in polyamide strip of jamb stile. Refer to "Sash Prep Details - SL075 Fixed Sash Rod Drive" sheet for slotted hole.

3. Insert bottom buffer from SL068 double shock absorber and lift proof kit into bottom corner of jamb stile as indicated and secure using No 7 x 25mm countersunk hi-lo self drill screw SL108.





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SL082 Door Stop Fitting Details

System 25 Hi/Hi+

LIFT AND SLIDE DOOR

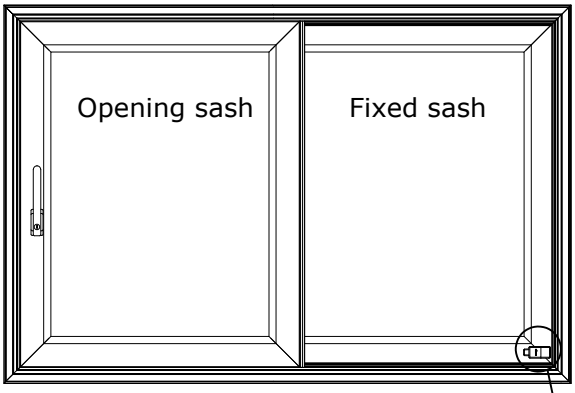
2T 3T

1. Position the door stop as indicated on "Sash Prep Details - SL082 Door Stop" sheet, and secure using No 8 x 13mm self-tapping screws (supplied in kit) into lower set of fixing holes.

2. Clip the door stop cover onto door stop.

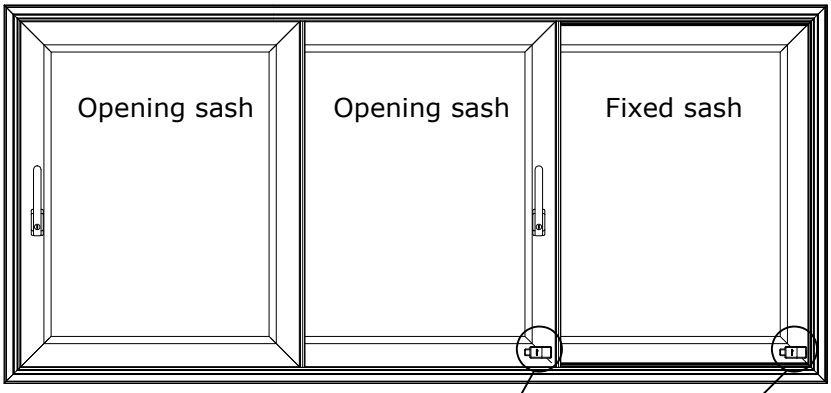
3. Fix buffer to door stop and cover using No 8 x 13mm self tapping screw.

DOUBLE TRACK

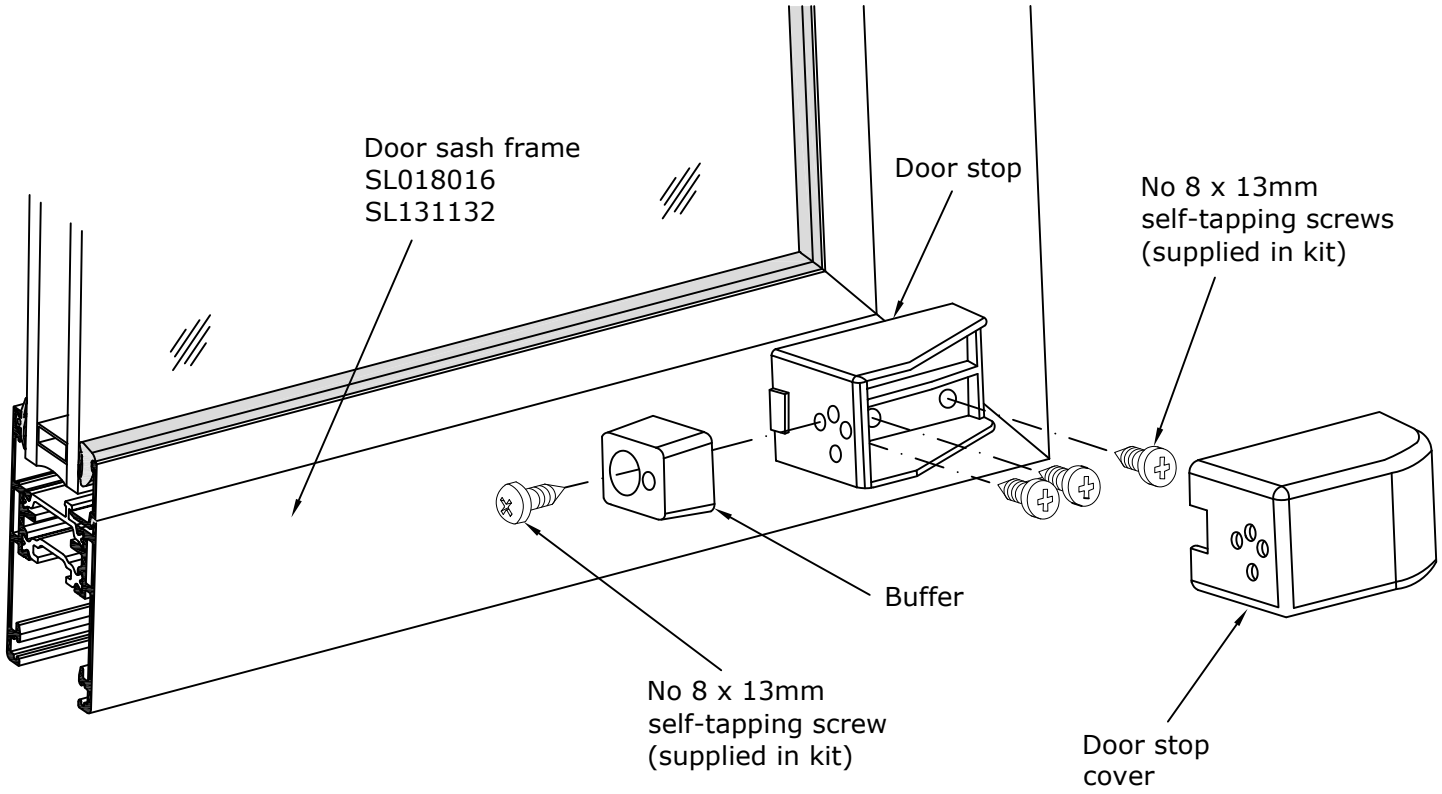


Viewed from inside

TRIPLE TRACK



Viewed from inside



Not to Scale

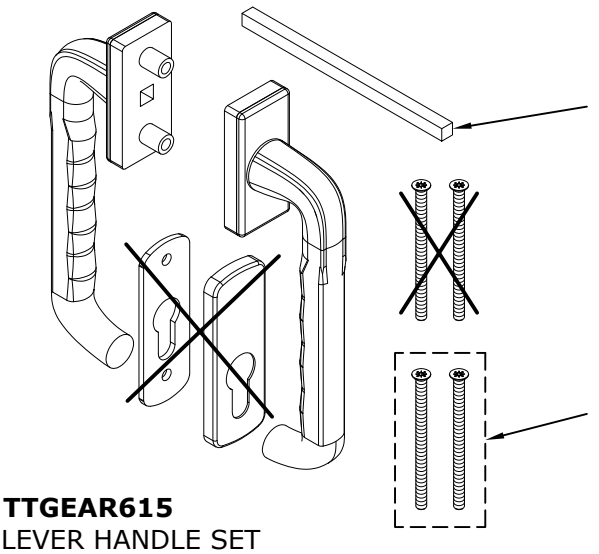
TTGEAR615 Handle Assembly Details - Master Leaf

System 25 Hi/Hi+

LIFT AND SLIDE DOOR

2T 3T

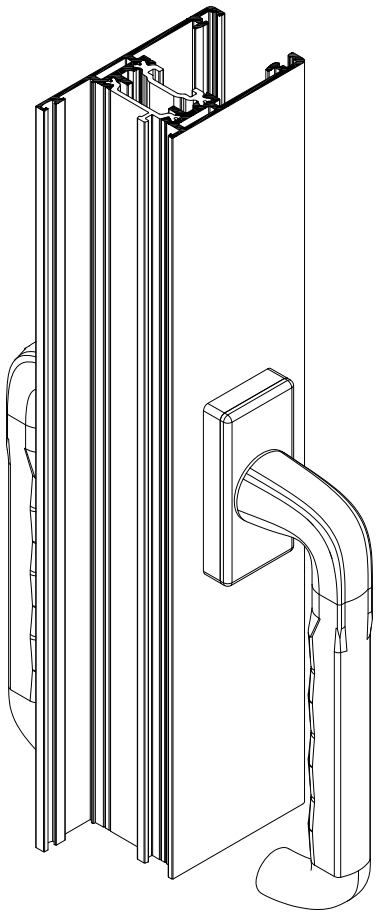
Refer to "Sash Prep Details - SL053 and SL063C Preps for TTGEAR615 Non-Locking Lever Handles" sheet for fixing positions and handing.

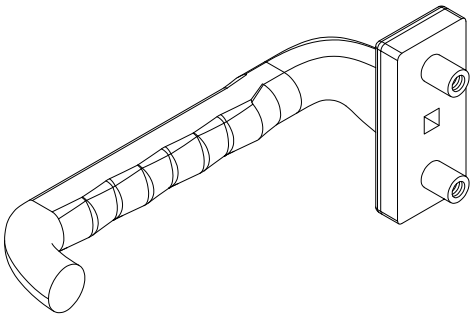


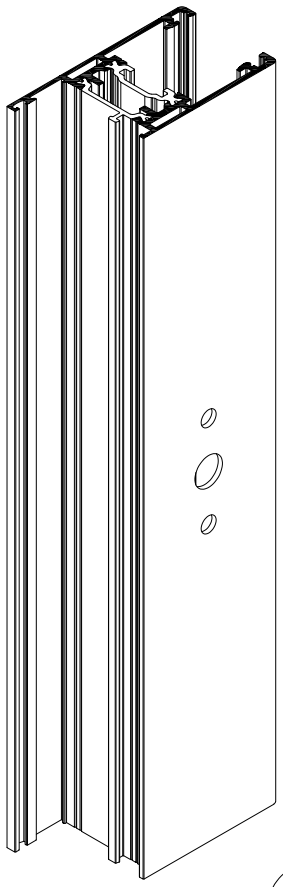
Fabricator to cut spindle supplied with TTGEAR615 lever handle set to 100mm when using SL018016 sash.

2 no M5 screws supplied with lever handle set are used with SL129130 sash only.

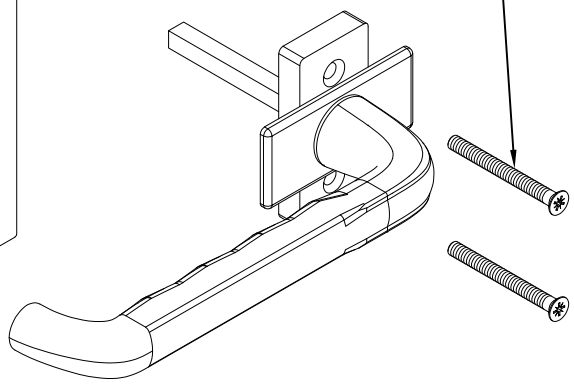
TTGEAR615
LEVER HANDLE SET







M5 countersunk machine screws



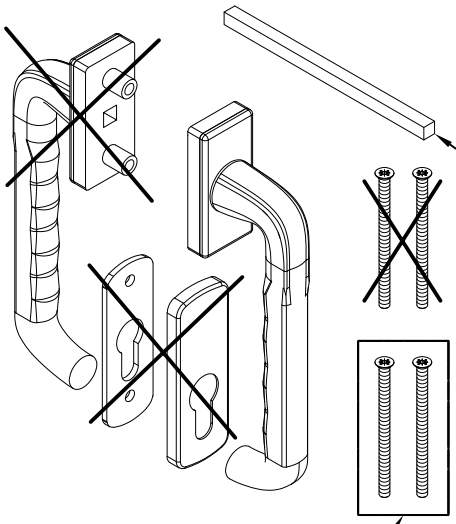
1. Ensure SL053 spindle drive is set to neutral position (no spindle drive cogs protruding at rear).
2. Insert square spindle through sash into spindle drive.
3. Using 2 No M5 x 75mm countersunk machine screws supplied with handle when using SL129130 sash or using 2 no M5 x 50mm countersunk machine screws 7272 when using SL018016 sash, secure internal handle TTGEAR615 backplate through the sash and SL053 spindle drive into the threaded studs of the external handle backplate, ensuring both levers are in the horizontal position, as indicated.
4. Rotate cover plate on internal handle backplate, to conceal fixings.
5. Pull handle down into vertical 6 o'clock position.

Not to Scale

TTGEAR615 Handle Assembly Details - Slave Leaf

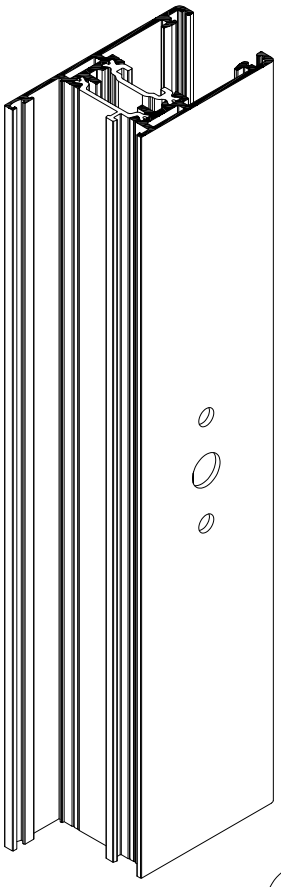
Refer to "Sash Prep Details - SL053 and SL063C Preps for TTGEAR615 Non-Locking Lever Handles" sheet for fixing positions and handing.

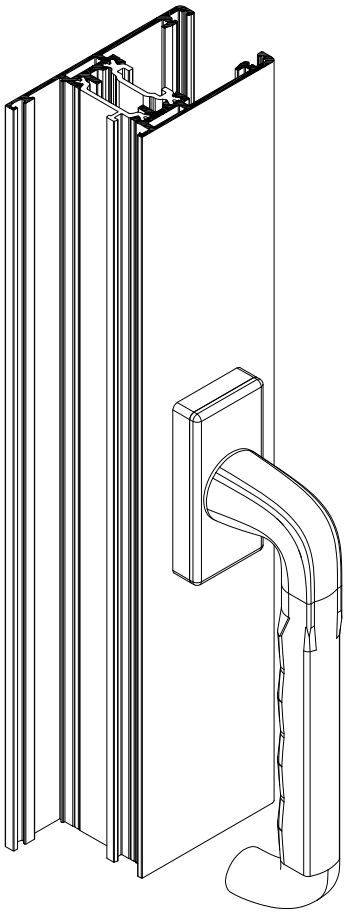
TTGEAR615
LEVER HANDLE SET



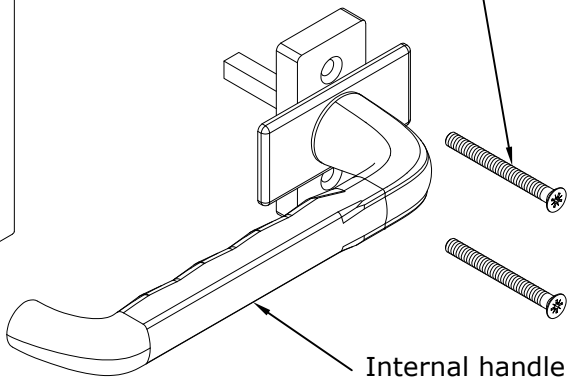
Fabricator to cut spindle supplied with TTGEAR615 lever handle set to 77mm when using SL018016 sash and to 107mm when using sash SL129130.

2 no M5 screws supplied with lever handle set are used with SL129130 sash only.





M5 countersunk machine screws

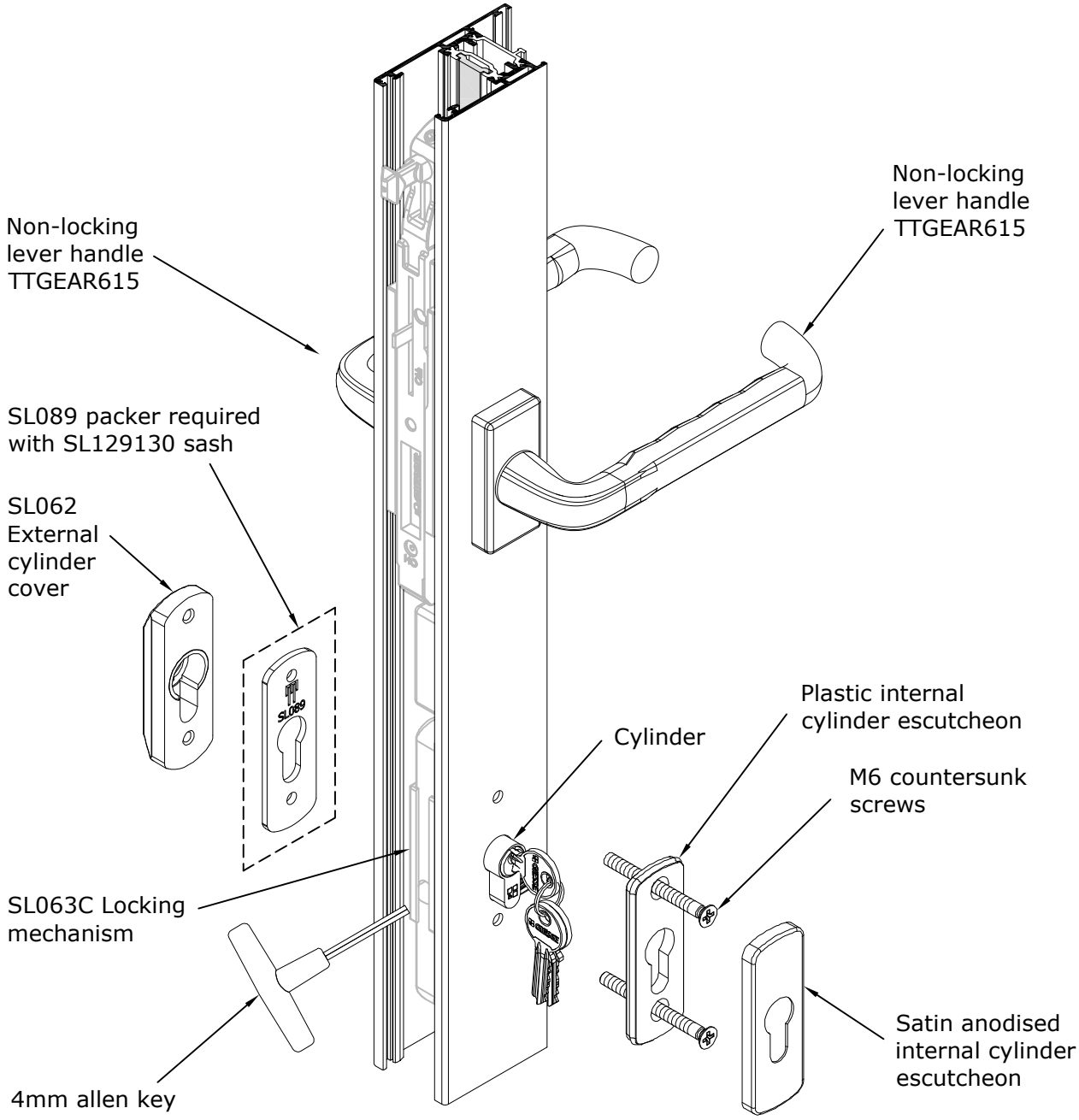


Internal handle

1. Ensure SL054 spindle drive is set to neutral position (no spindle drive cogs protruding at rear).
2. Insert square spindle through sash into spindle drive.
3. Using 2 No M5 x 75mm countersunk machine screws supplied with handle when using SL129130 sash or using 2 no M5 x 50mm countersunk machine screws 7272 when using SL018016 sash, connect internal non-locking lever handle from TTGEAR615 to threaded studs in spindle drive, ensuring lever is in the horizontal position, as indicated. Secure machine screws.
4. Rotate cover plate on internal handle backplate, to conceal fixings.
5. Pull handle down into vertical 6 o'clock position.

Not to Scale

SL062 External Cylinder Cover Assembly Details



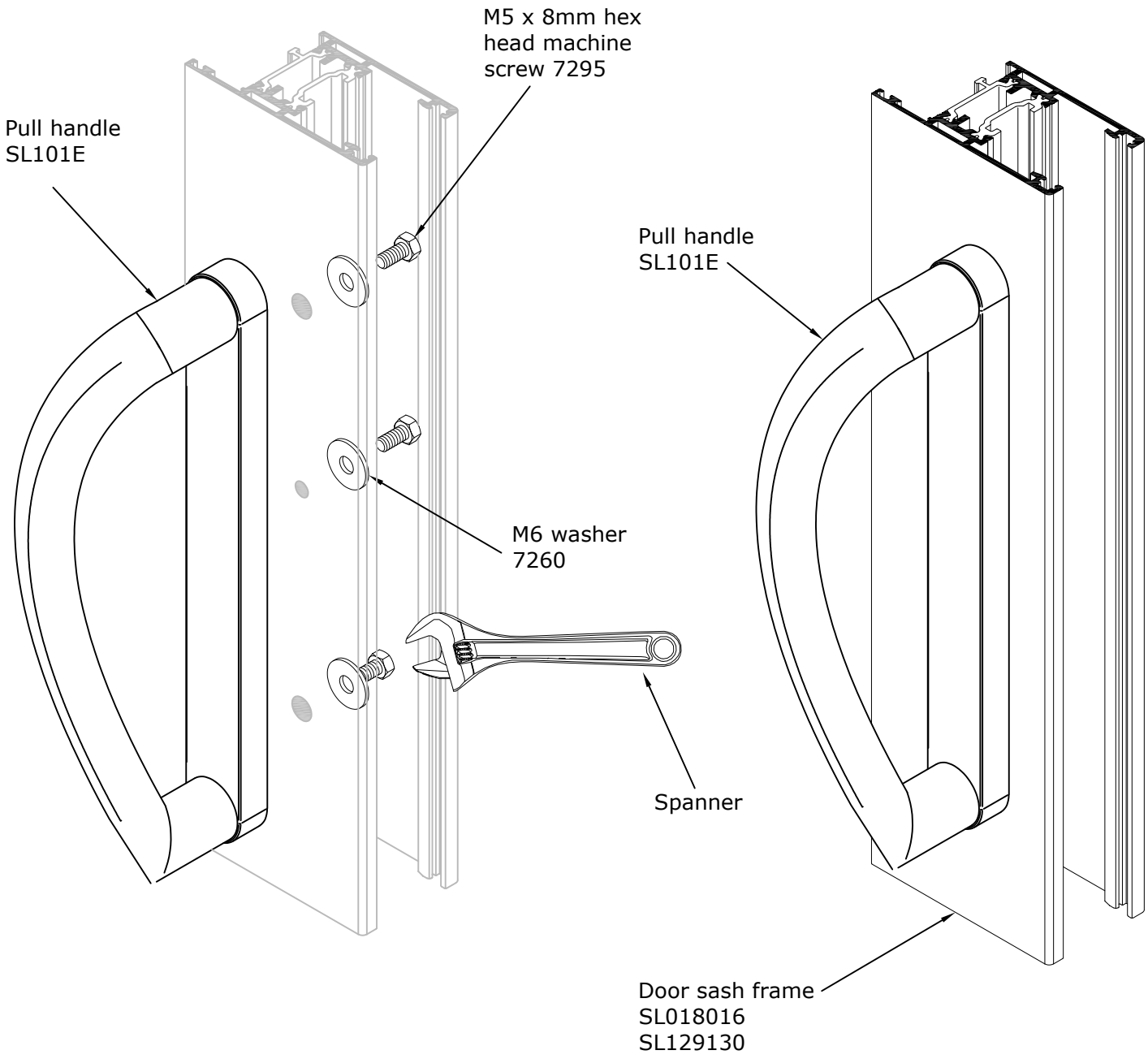
1. Rotate TTGEAR615 handles 45° to allow insertion of cylinder.
2. Insert key into cylinder and rotate cam to allow cylinder to pass through SL063C locking mechanism and profile. Align cylinder.
3. Return TTGEAR615 lever handles to the 6 o'clock position.
4. Secure cylinder to SL063C locking mechanism using 4mm allen key into socket headed screw provided. Ensure socket headed screw is fully inserted to facilitate operation of SL063C locking mechanism.
5. Rotate handles 45° and remove key.
6. Assemble SL062 external cylinder cover (including SL089 packer when using SL129130 sash) as indicated, and locate over cylinder on external face of profile.
7. Locate plastic internal cylinder escutcheon over cylinder.
8. Secure external cylinder cover using 2 no M6 countersunk screws (supplied with SL062 for sash SL018016; BF126 M6 x 90mm for sash SL129130) through internal cylinder escutcheon and SL063C locking mechanism.
9. Push fit satin anodised internal cylinder escutcheon over plastic internal cylinder escutcheon.
10. To lock doors handle must be rotated to vertical (12 o'clock) position.

Not to Scale

SL101E External Pull Handle Assembly Details

Refer to "Sash Prep Details - SL101E External Pull Handle" sheet for fixing positions and handing.

Ensure SL101E external pull handle is fitted prior to fitting vertical locking assembly.

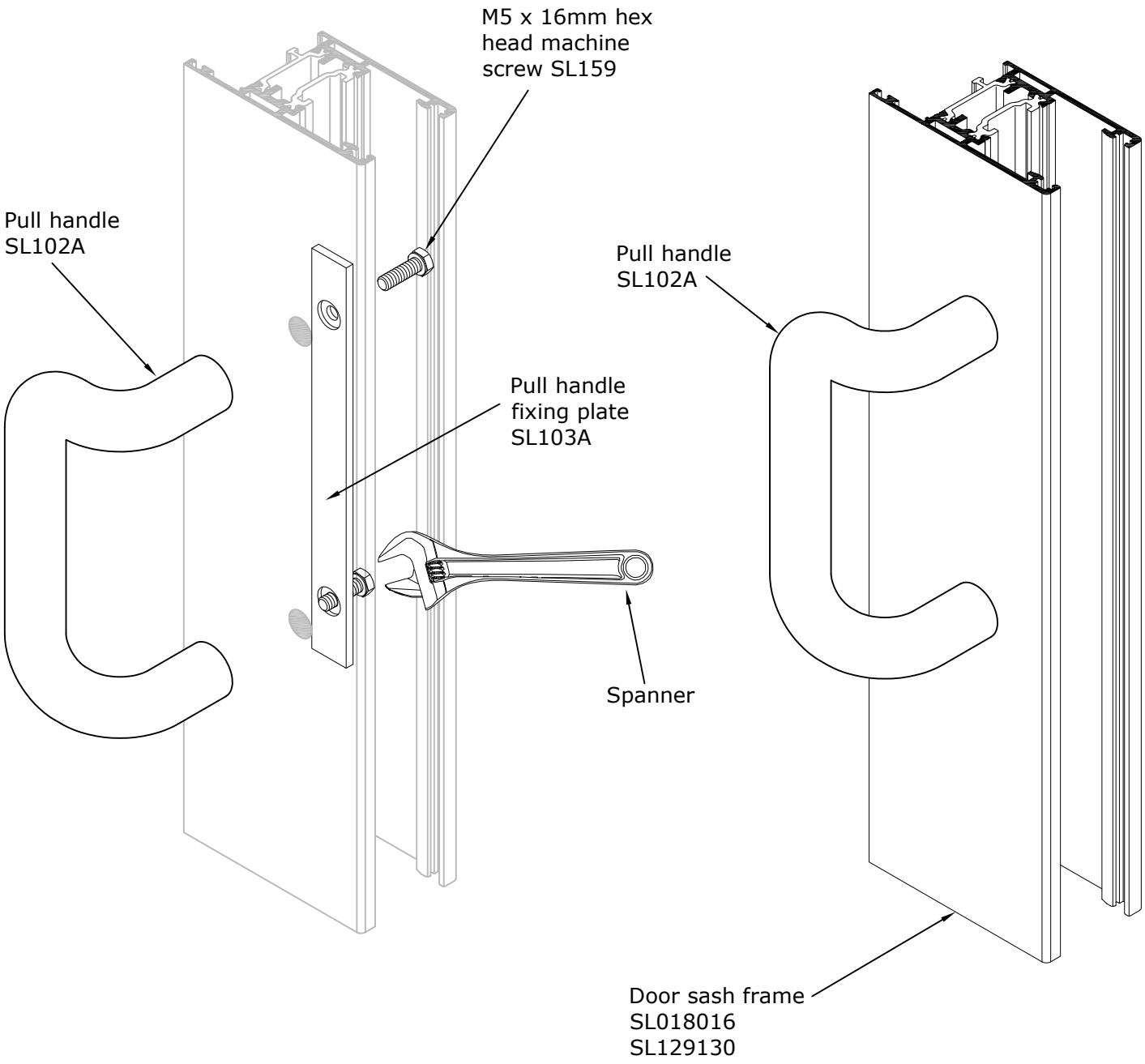


Not to Scale

SL102A External Pull Handle Assembly Details

Refer to "Sash Prep Details - SL102A External Pull Handle" sheet for fixing positions and handing.

Ensure SL102A external pull handle is fitted prior to fitting vertical locking assembly.



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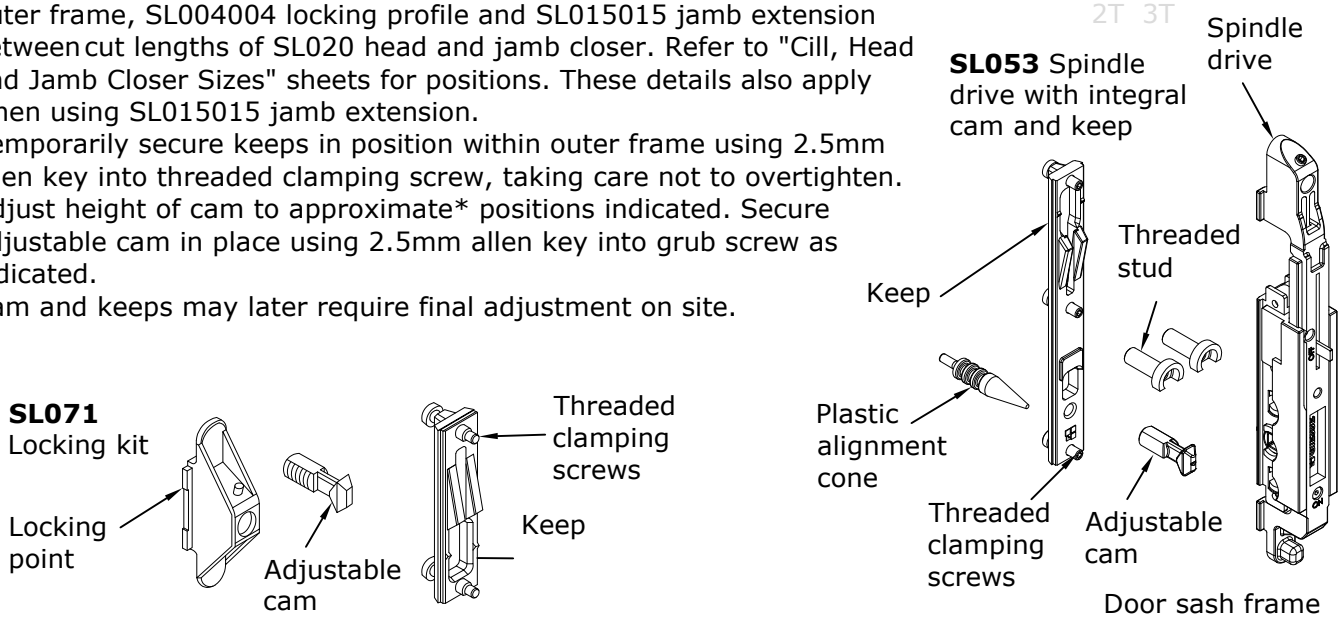
Locking Point Assembly

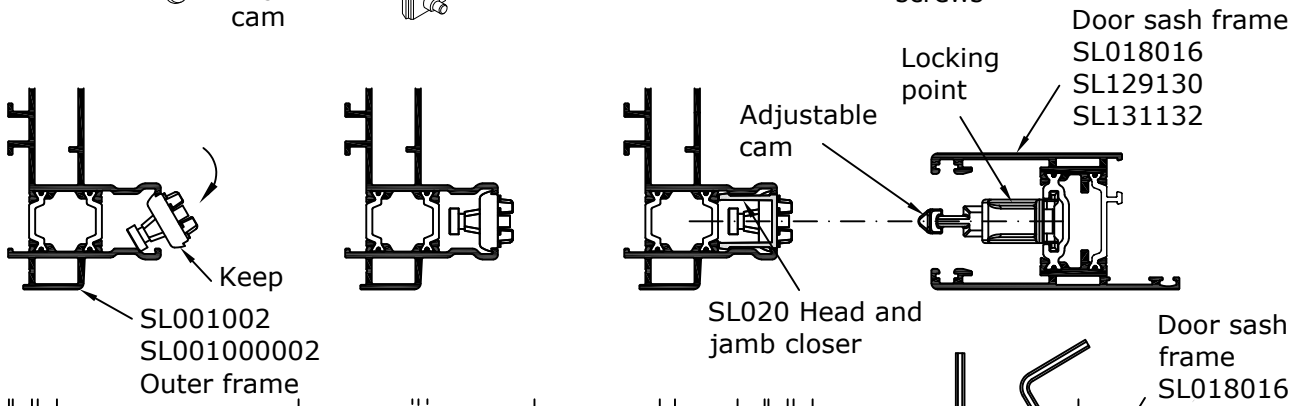
System 25 Hi/Hi+

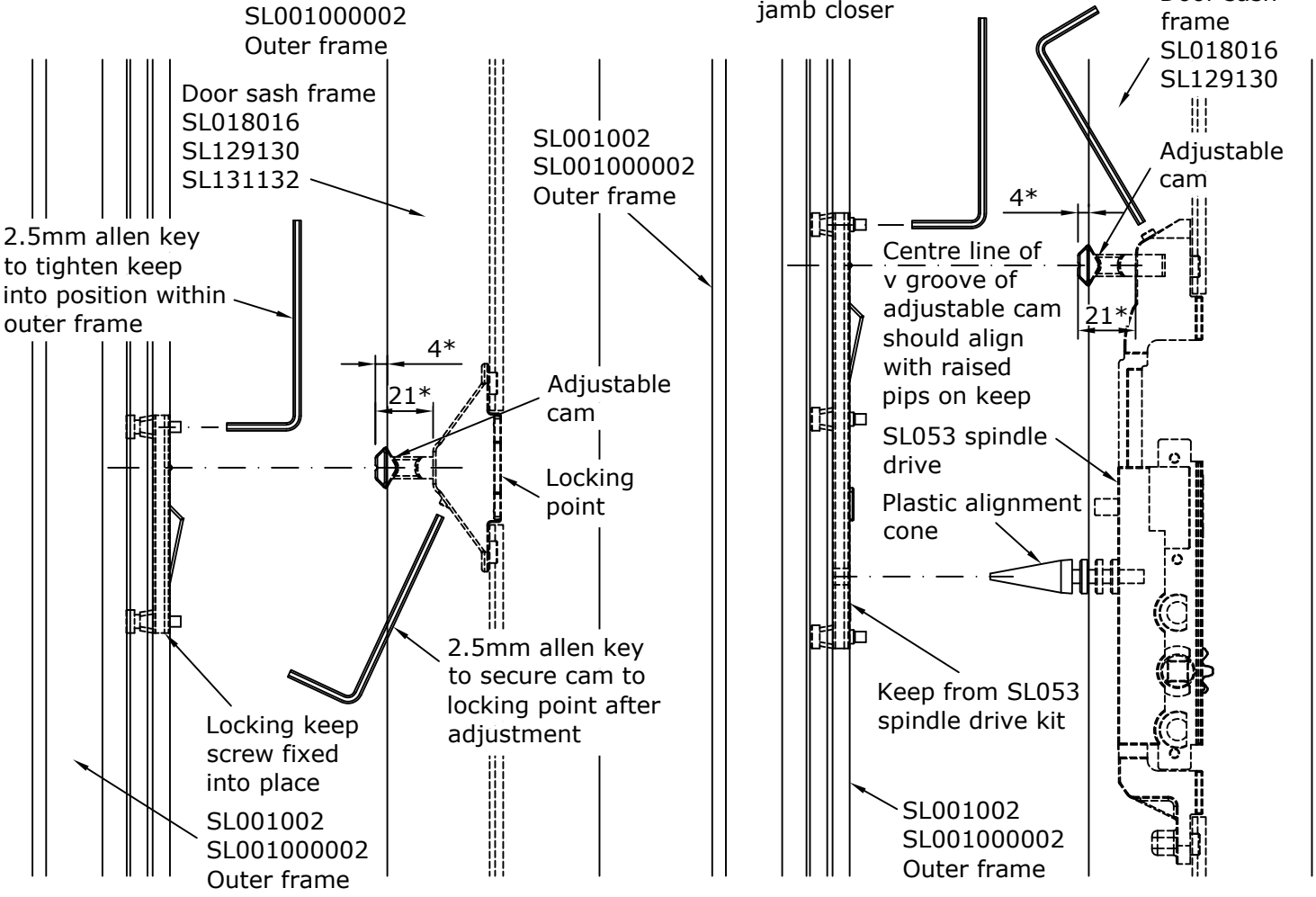
LIFT AND SLIDE DOOR

2T 3T

1. Rotate and clip keeps into position in SL001002/SL001000002 outer frame, SL004004 locking profile and SL015015 jamb extension between cut lengths of SL020 head and jamb closer. Refer to "Cill, Head and Jamb Closer Sizes" sheets for positions. These details also apply when using SL015015 jamb extension.
2. Temporarily secure keeps in position within outer frame using 2.5mm allen key into threaded clamping screw, taking care not to overtighten.
3. Adjust height of cam to approximate* positions indicated. Secure adjustable cam in place using 2.5mm allen key into grub screw as indicated.
4. Cam and keeps may later require final adjustment on site.







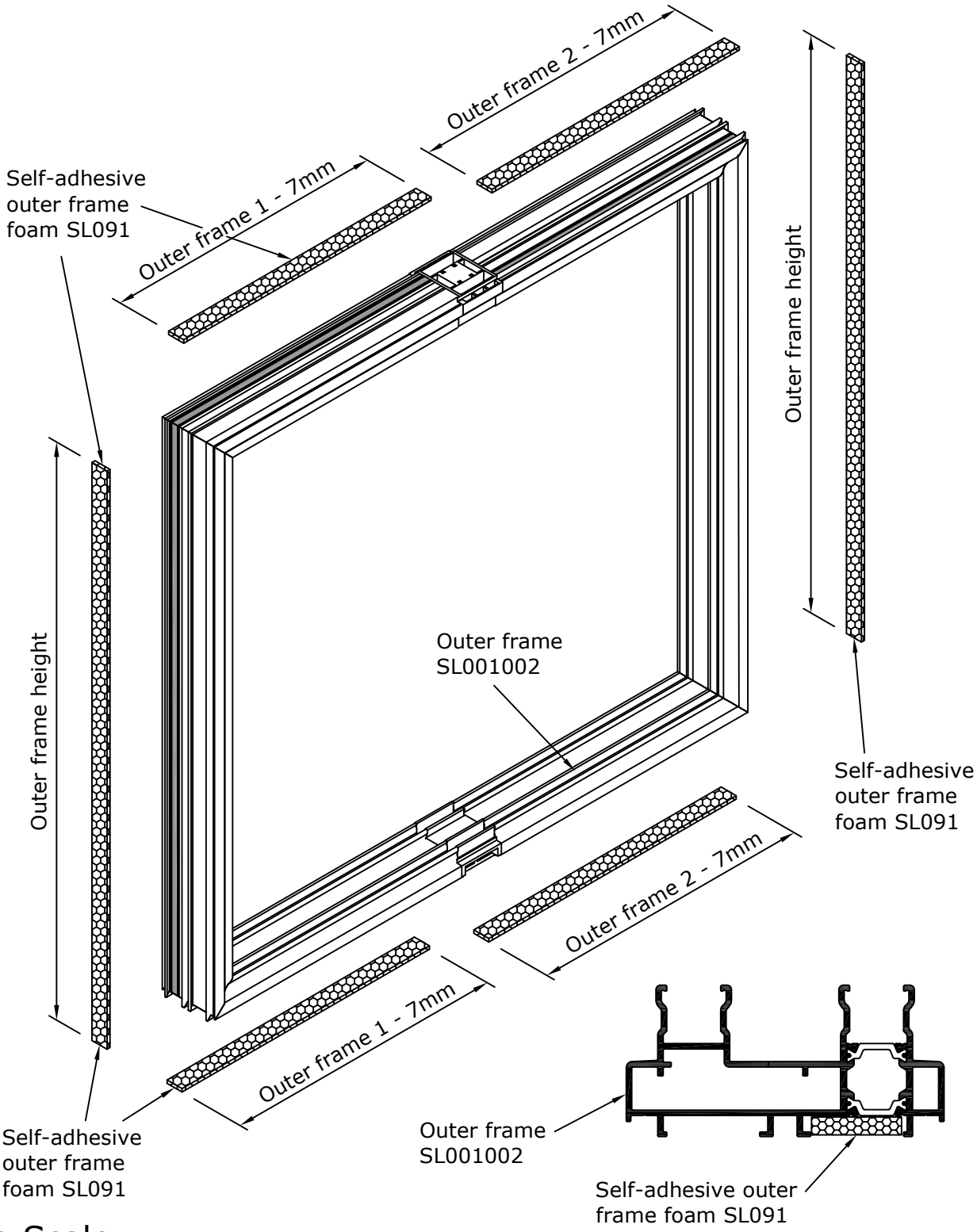
Not to Scale

SL001002 Outer Frame Thermal Foam

Thermal foams should not be exposed to UV light, and must be kept in a clean, dry, and dust-free environment at between 5° and 35°C. Minimum recommended application temperature for adhesive thermal foams is 20°C and therefore these should be applied in clean, dry, and dust-free factory conditions. Before applying self-adhesive foams ensure all surfaces are free from grease or dust. Clean all mating surfaces with suitable cleaning agent. Fabricators should minimise the exposure period of the foams to the elements and provide additional on-site protection to prevent depositing of builders debris.

Cut SL091 outer frame thermal foam into six individual lengths with square cut ends.

All foam corners to be butt jointed without gap.



Not to Scale

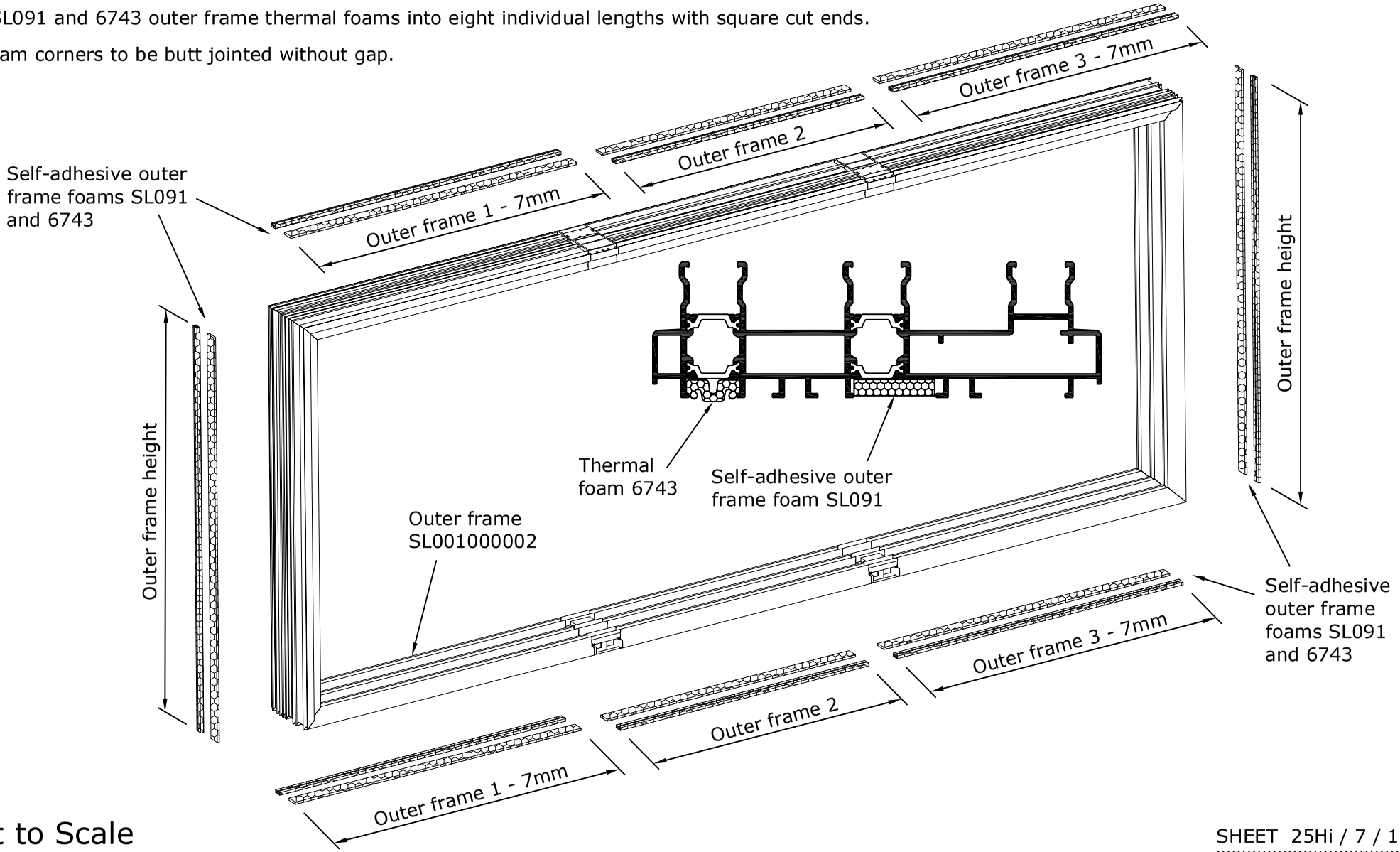
SL001000002 Outer Frame Thermal Foam

System 25 Hi+
LIFT AND SLIDE DOOR

Thermal foams should not be exposed to UV light, and must be kept in a clean, dry, and dust-free environment at between 5° and 35°C. Minimum recommended application temperature for adhesive thermal foams is 20°C and therefore these should be applied in clean, dry, and dust-free factory conditions. Before applying self-adhesive foams ensure all surfaces are free from grease or dust. Clean all mating surfaces with suitable cleaning agent. Fabricators should minimise the exposure period of the foams to the elements and provide additional on-site protection to prevent depositing of builders debris.

Cut SL091 and 6743 outer frame thermal foams into eight individual lengths with square cut ends.

All foam corners to be butt jointed without gap.



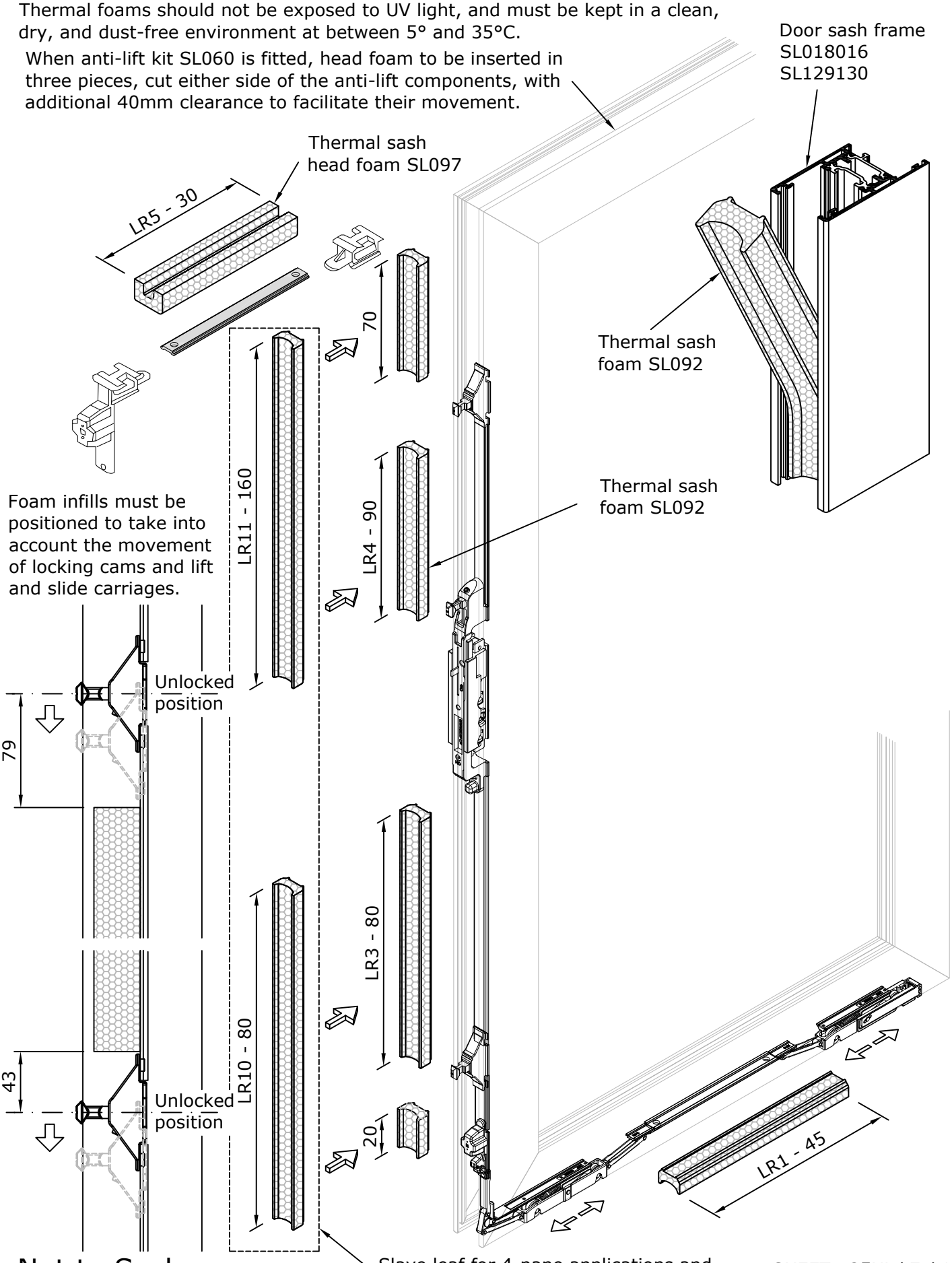
Not to Scale

Lift and Slide Sash Thermal Foams SL092 and SL097 for Head, Cill and Locking Jamb

System 25 Hi+
LIFT AND SLIDE DOOR
2T 3T

Thermal foams should not be exposed to UV light, and must be kept in a clean, dry, and dust-free environment at between 5° and 35°C.

When anti-lift kit SL060 is fitted, head foam to be inserted in three pieces, cut either side of the anti-lift components, with additional 40mm clearance to facilitate their movement.



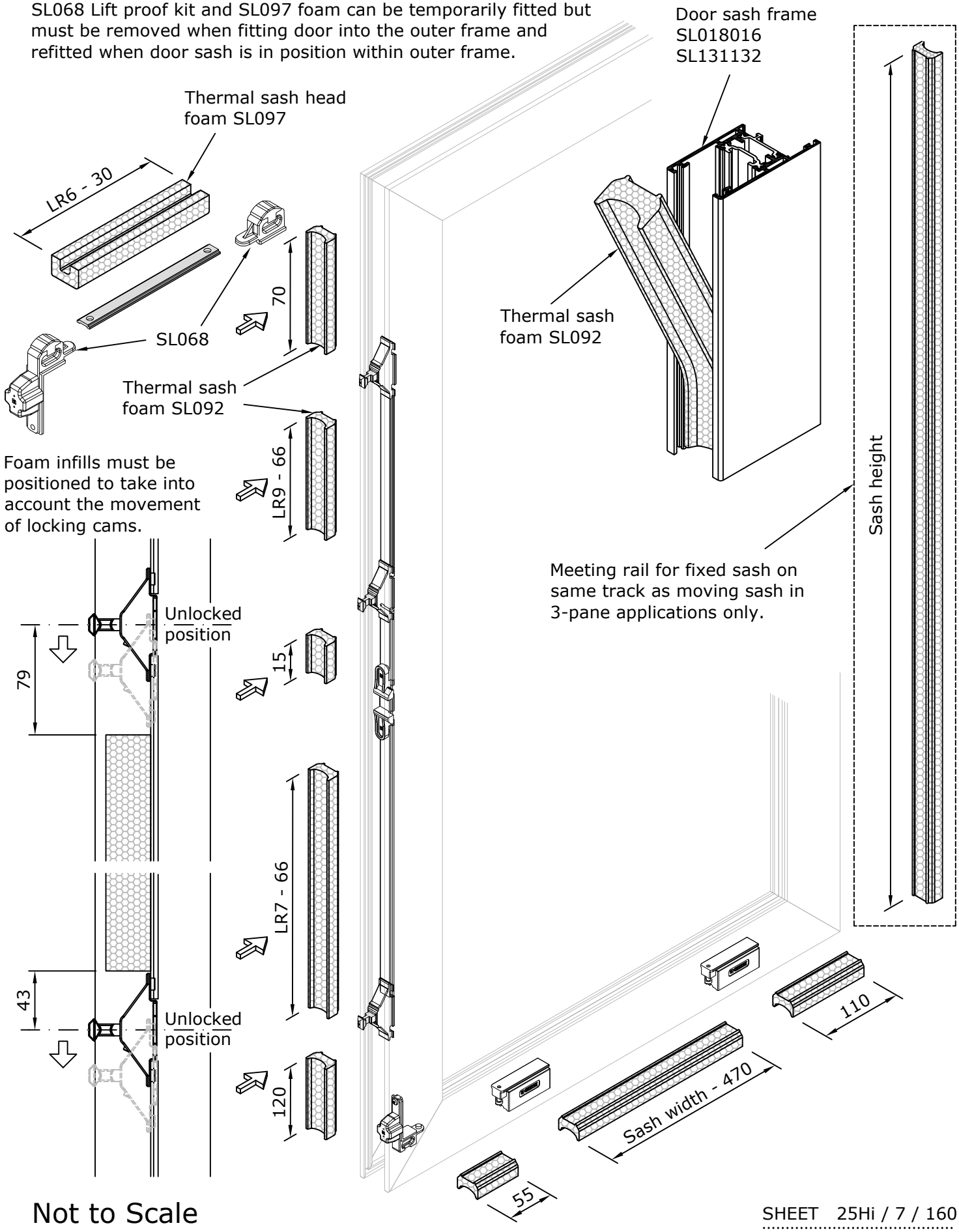
Not to Scale

Fixed Sash Thermal Foams

SL092 and SL097 for Head, Cill and Jambs

Thermal foams should not be exposed to UV light, and must be kept in a clean, dry, and dust-free environment at between 5° and 35°C.

SL068 Lift proof kit and SL097 foam can be temporarily fitted but must be removed when fitting door into the outer frame and refitted when door sash is in position within outer frame.

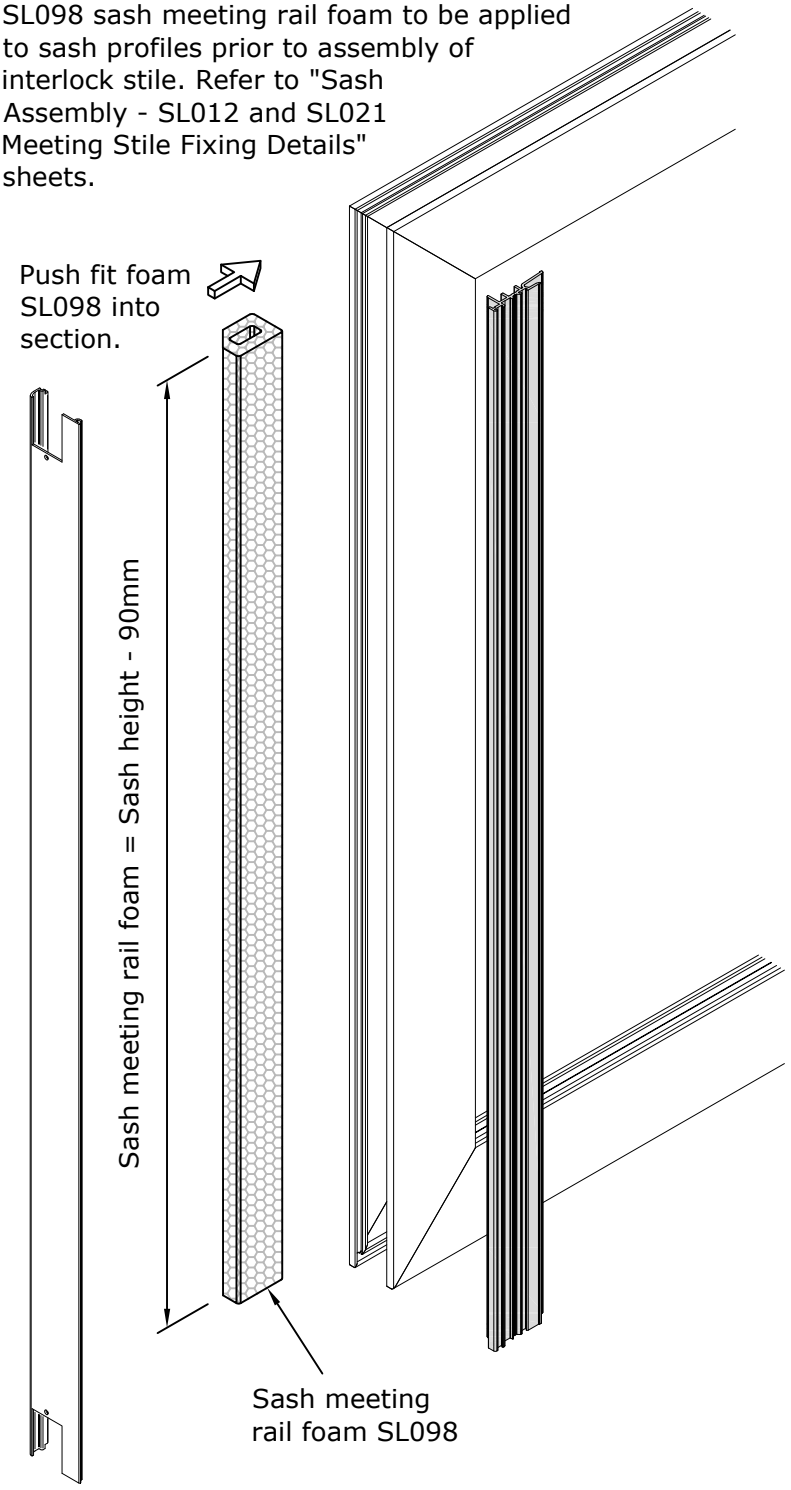


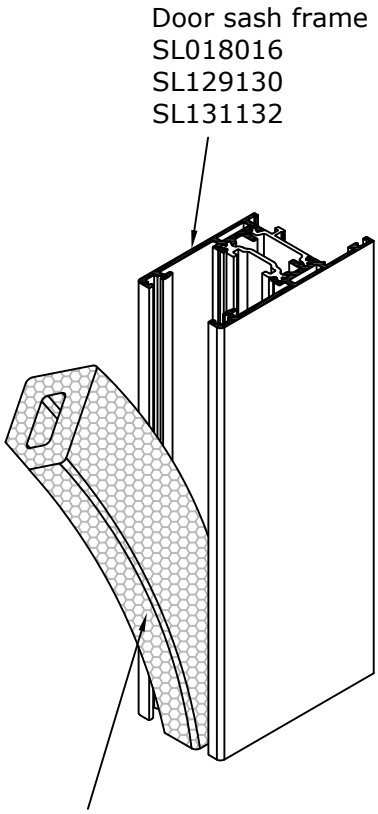
Not to Scale

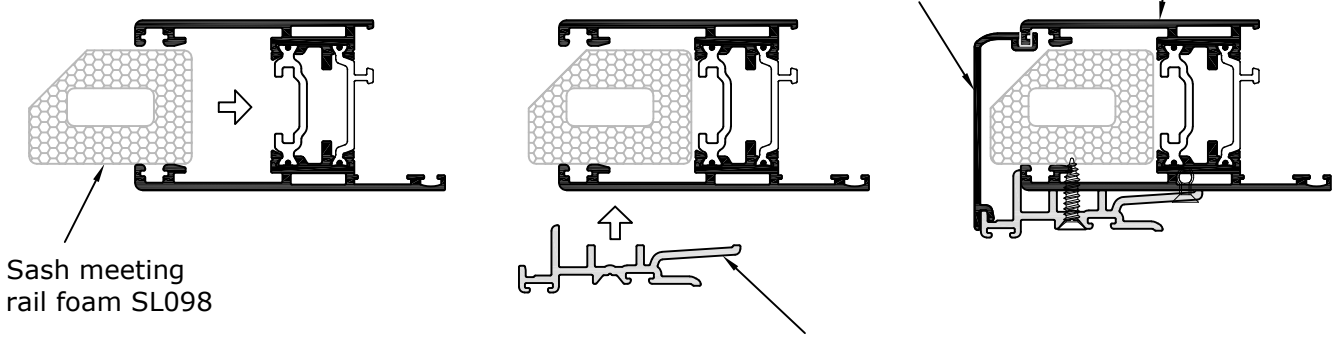
Interlock Thermal Foam

Thermal foams should not be exposed to UV light, and must be kept in a clean, dry, and dust-free environment at between 5° and 35°C.

SL098 sash meeting rail foam to be applied to sash profiles prior to assembly of interlock stile. Refer to "Sash Assembly - SL012 and SL021 Meeting Stile Fixing Details" sheets.







Not to Scale

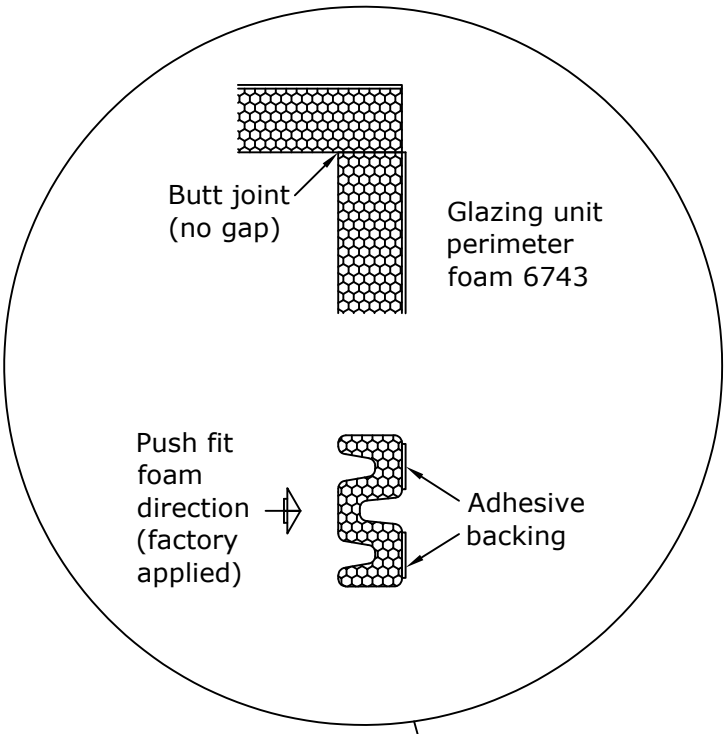
Glazing Unit Perimeter Foam 6743

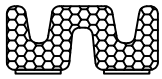
Thermal foams should not be exposed to UV light, and must be kept in a clean, dry, and dust-free environment at between 5° and 35°C. Minimum recommended application temperature for adhesive thermal foams is 20°C and therefore these should be applied in clean, dry, and dust-free factory conditions. Before applying self-adhesive foams ensure all surfaces are free from grease or dust. Clean all mating surfaces with suitable cleaning agent. Fabricators should minimise the exposure period of the foams to the elements and provide additional on-site protection to prevent depositing of builders debris.

Cut 6743 glazing unit perimeter foam into four individual lengths with square cut ends.

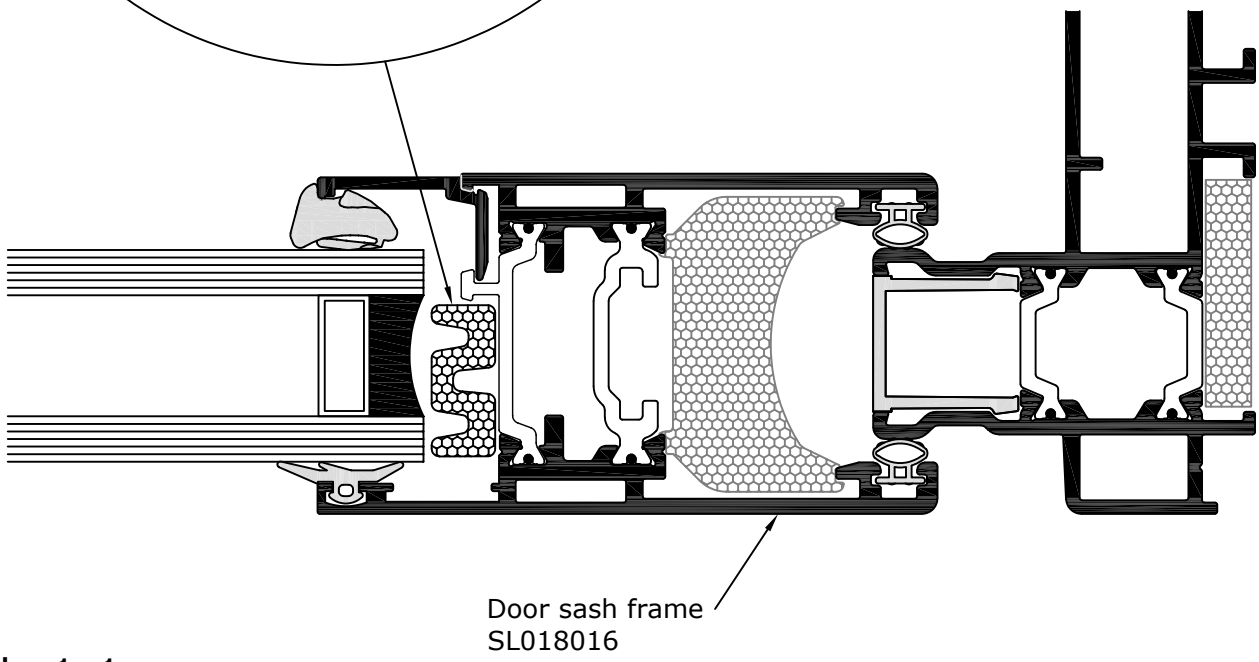
All foam corners to be butt jointed without gap.

Glazing unit perimeter foam to be factory applied to sash/frame where DGUs are to be installed. Remove release strip from rear of foam and bond to frame, omitting foam at glazing support and drainage locations.





Glazing unit closed cell foam 6743 bond to section using self-adhesive backing.



Scale 1:1

Glazing Unit Perimeter Foam 6727

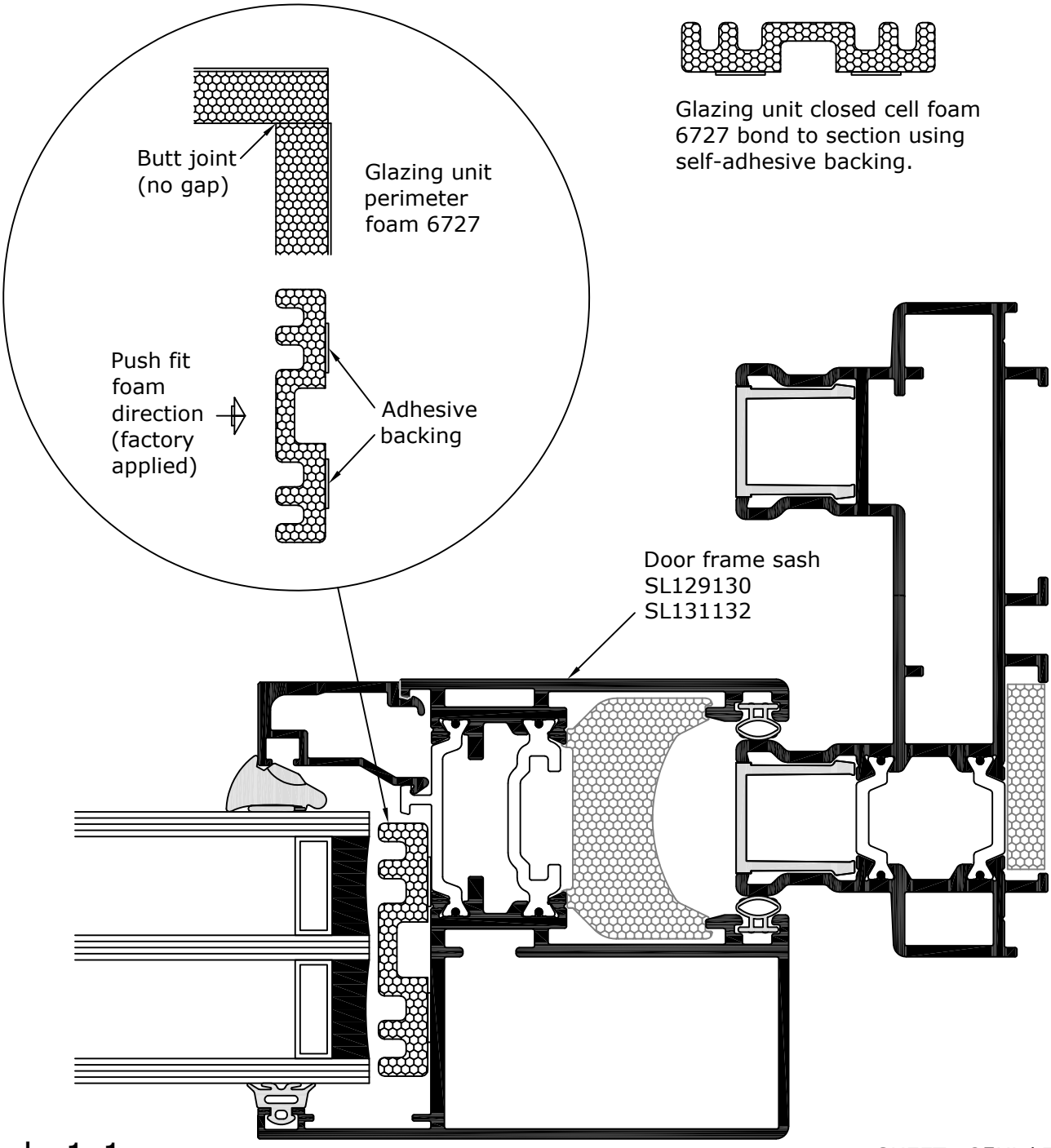
Thermal foams should not be exposed to UV light, and must be kept in a clean, dry, and dust-free environment at between 5° and 35°C. Minimum recommended application temperature for adhesive thermal foams is 20°C and therefore these should be applied in clean, dry, and dust-free factory conditions. Before applying self-adhesive foams ensure all surfaces are free from grease or dust. Clean all mating surfaces with suitable cleaning agent. Fabricators should minimise the exposure period of the foams to the elements and provide additional on-site protection to prevent depositing of builders debris.

Cut 6727 glazing unit perimeter foam into four individual lengths with square cut ends.

All foam corners to be butt jointed without gap.

Glazing unit perimeter foam to be factory applied to sash/frame where DGUs are to be installed. Remove release strip from rear of foam and bond to frame, omitting foam at glazing support and drainage locations.

Glazing unit closed cell foam 6727 bond to section using self-adhesive backing.



Scale 1:1

Installation Procedures

General Information

System 25 Hi/Hi+

LIFT AND SLIDE DOOR

2T 3T

The following instructions are a general guideline and cover the most common conditions. For further information, advice or project specific applications contact Metal Technology's Technical Department.

All doors should be adequately protected against minor scuffs and abrasions during installation. This can be achieved using a suitable low tack tape to all exposed surfaces of the frames. Low tack tape should be periodically renewed and should not remain on the frames for more than 6 months from the date of application. (This period may vary depending on exposure, application and manufacturers instructions) LOW TACK TAPE IS NOT A SUBSTITUTE FOR CAREFUL HANDLING.

Ensure that the brickwork opening is the correct size and square, with sufficient clearance to accommodate any expansion, contraction, building movement and the minimum joint width requirement for the applicable sealant.
Ensure that the structure to which the door is fixed is sound and capable of adequately accepting the fixings and the subsequent loads transferred by them.

When using coupling mullions they should be installed so that they provide the required movement facility to accommodate expansion and contraction. Where units are installed in runs incorporating a sub-cill, this sub-cill should be continuous. Where joints are required within the subcill these should be butt jointed and sealed using a suitable butt strap/splice plate. Where required the joint should be designed to accommodate all applicable movement, expansion and contraction. All subcills should be positioned on top of a continuous EPDM membrane returned upward, behind the sub-cill and sealed and bonded where required. Careful consideration must be given when detailing the interface between head and liners and/or sub-cills with coupling mullions and/or corner posts. Joints within sub-cills should not coincide with coupling mullion positions

All aluminium should be isolated from direct contact with masonry, concrete and other incompatible materials by means of packing pieces, EPDM membranes, suitable paint or similar materials.

As it is not possible to glaze the fixed sash with the opening sash fitted, we recommend that the sashes are not glazed or installed within the outer frame prior to arriving on site. For logistical purposes, outer frame head, cill and jamb bars may also be transported in their pre-fabricated form and assembled on site. (Refer to section 6 of the manual for component and assembly details).

Establish handing and orientation of outer frame and position into opening so that when fitted the fixed and moving sashes are correctly handed, and are on the appropriate track.

Metal Technology recommend the use of fixing lugs, as direct fixing through the cill is not permitted. For further advice refer to Metal Technology's Technical Department. Lugs should be fitted to the frames prior to offering the outer frame into the opening. The choice of fixing lug will depend on site application (two lengths of lug are available). The number and position of fixing lugs will depend on the door size and applicable loading. General fixing lug locations are 150mm from the corner, 150mm either side of a meeting stile and at a maximum of 600mm centres (see "Typical Fixing Detail" and "Typical Sub-Cill Detail" sheets in section 8 of manual for further clarification).

Where required fixing lugs may be cranked to accommodate the gap between the window frame and the structure. This should be done prior to snapping the lug into the frame.

Alternatively, where the gap between the frame and the structure is not suitable for adequately cranking the fixing lug, frame packers may be used.

Position the outer frame within the opening ensuring that all exposed aluminium is isolated from any material which may react unfavourably with it. This also applies to the fixings used to secure the doors. Metal Technology recommend that all fastenings to aluminium be Austenitic Stainless Steel A2-A4 grade, aluminium or other such compatible materials.

Suitable proprietary frame packers should be used to ensure the door frame is plumb, square, level, vertical and centralised within the opening. The frame packers must support the cill outer frame over its 42.5mm depth to ensure smooth operation of the sliding sashes. Packers between frame and structure to be positioned at or adjacent to fixing lug positions at head and jambs, and at maximum 200mm centres at cill, and both sides of cill drainage block. Frames must be adequately packed and fixed to ensure the load is directly transferred to the structure below. Frame packers should not protrude past the external line of the outer frame in order not to interfere with sealing to the structure.

Fix the outer frame to the opening as required ensuring that the outer frame is not bowed or distorted and that the fixings used are adequate and suitable for the applicable loading conditions and application.

cont...

Cement and plaster can damage the finish of this product if they are not removed promptly. Any such contaminants should be removed using a weak solution of mild detergent in water. (i.e. 5% of Teepol in water)

Finished surfaces should be cleaned with a soft cloth or sponge. Where stubborn marks persist a natural bristle brush may be used with care. Abrasive cleaners, solvents or other cleaning agents should not be used.

For additional information on door installation and glazing refer to BS 6262, other relevant British Standards and/or Metal Technology's Technical Department.

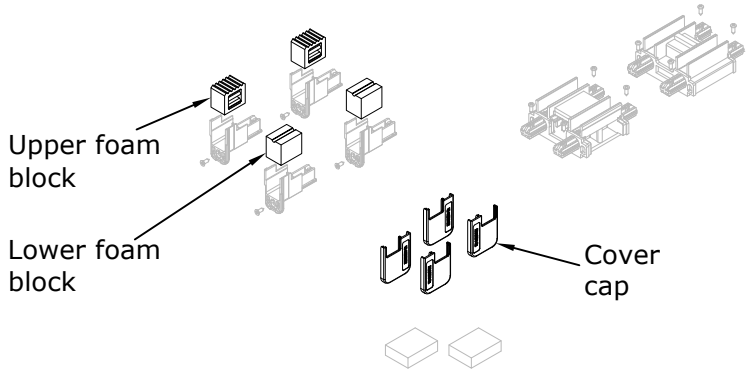
Metal Technology recommend that doors should be installed by experienced and qualified installers. All installers should be fully trained and qualified with regard to the relevant Health and Safety requirements for the applicable site operations and should possess a current CSCS card endorsed with a relevant and recognised NVQ or CWCT Window Installers Part 1 qualification.

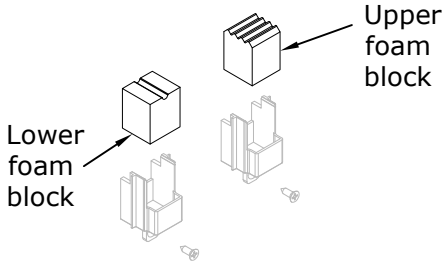
Installation Procedures

Component Identification

Components required on site will be:

SL058A
INTERLOCK KIT - DOUBLE TRACK LIFT AND SLIDE

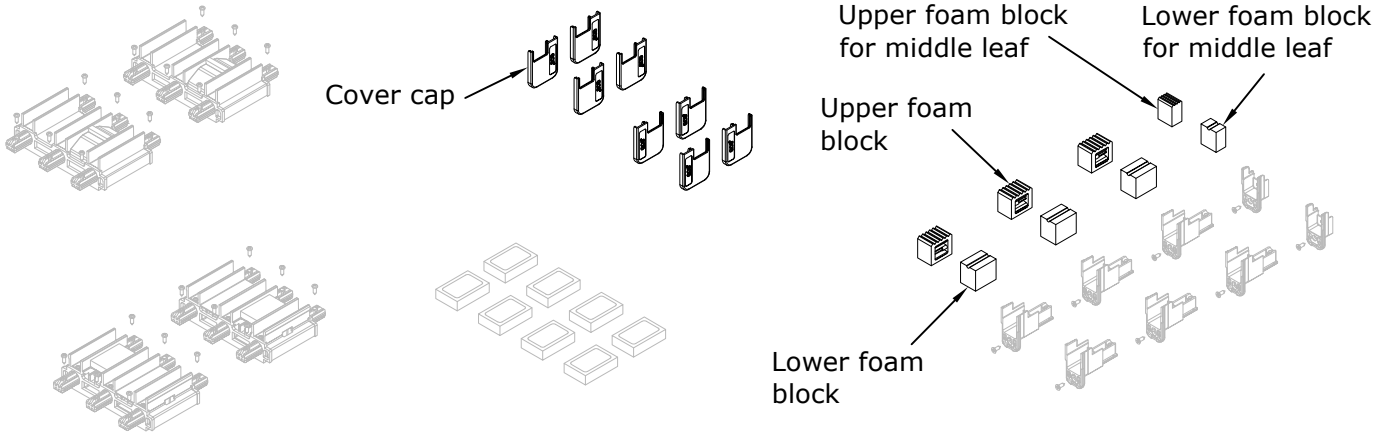




SL055
SASH PLUG KIT

	2 - pane	3 - pane	4 - pane
SL058A upper and lower foam blocks	2 pairs	2 pairs	4 pairs
SL055 upper and lower foam blocks	-	1 pair	1 pair
SL058A cover cap	4	4	8

SL155
INTERLOCK KIT - TRIPLE TRACK LIFT AND SLIDE



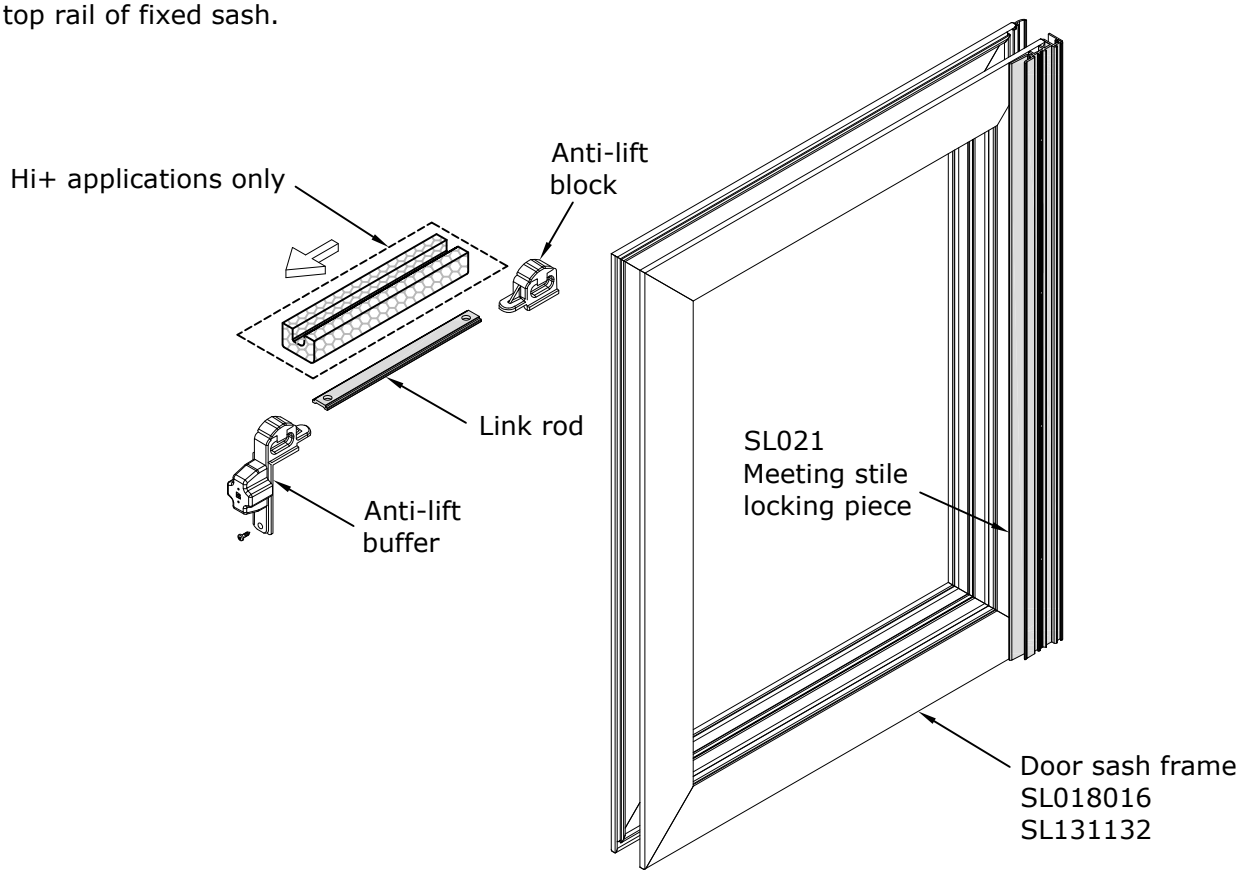
SL155 upper and lower foam blocks	3 pairs
SL155 upper and lower foam blocks for middle leaf at handle side	1 pair
SL155 cover cap	8

Not to scale

Installation Procedures

Fixed Sash

Temporarily remove anti-lift buffer and anti-lift block assembly (including thermal foam) from SL068, from top rail of fixed sash.



Check handing and orientation of sashes. Offer head of fixed sash over appropriate track. Refer to General Arrangement drawings for sash layout details.

Rotate door into position so that fixed sash carriages are centred on bottom track, and lower into place.

Slide fixed sash into "open" position and re-insert anti-lift buffer and anti-lift block assembly (and foam) into top rail from vertical locking gear end and secure using screw provided. Note that anti-lift buffer and anti-lift block assembly may vary from sash to sash. Care must be taken to ensure the correct kit is re-inserted into the correct sash.

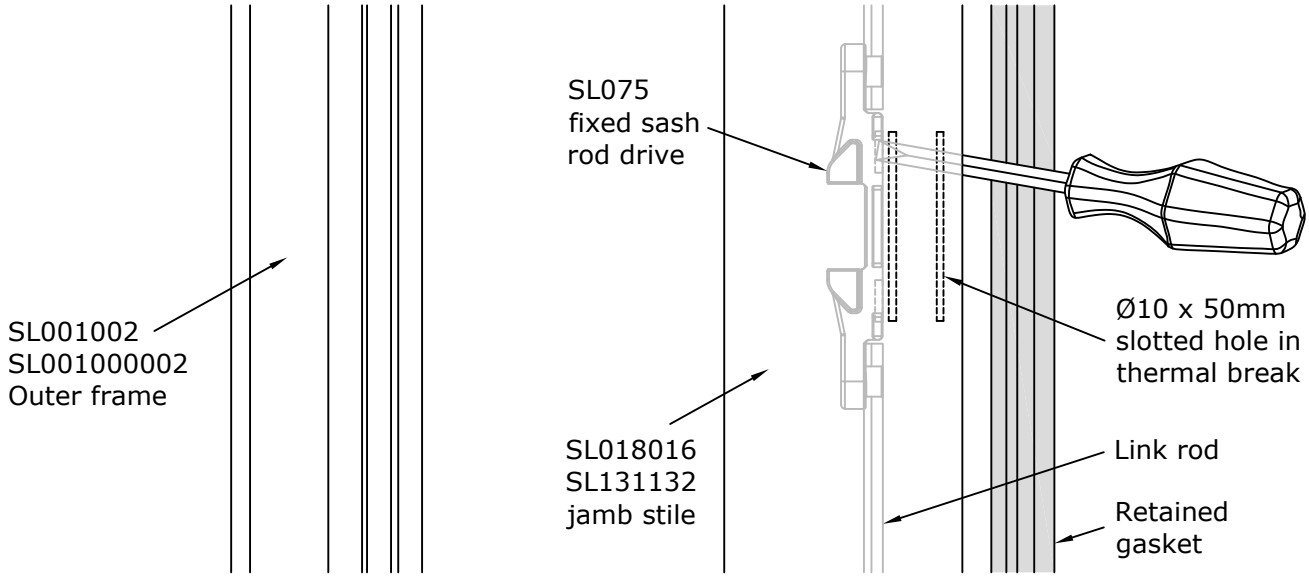
Not to scale

Installation Procedures

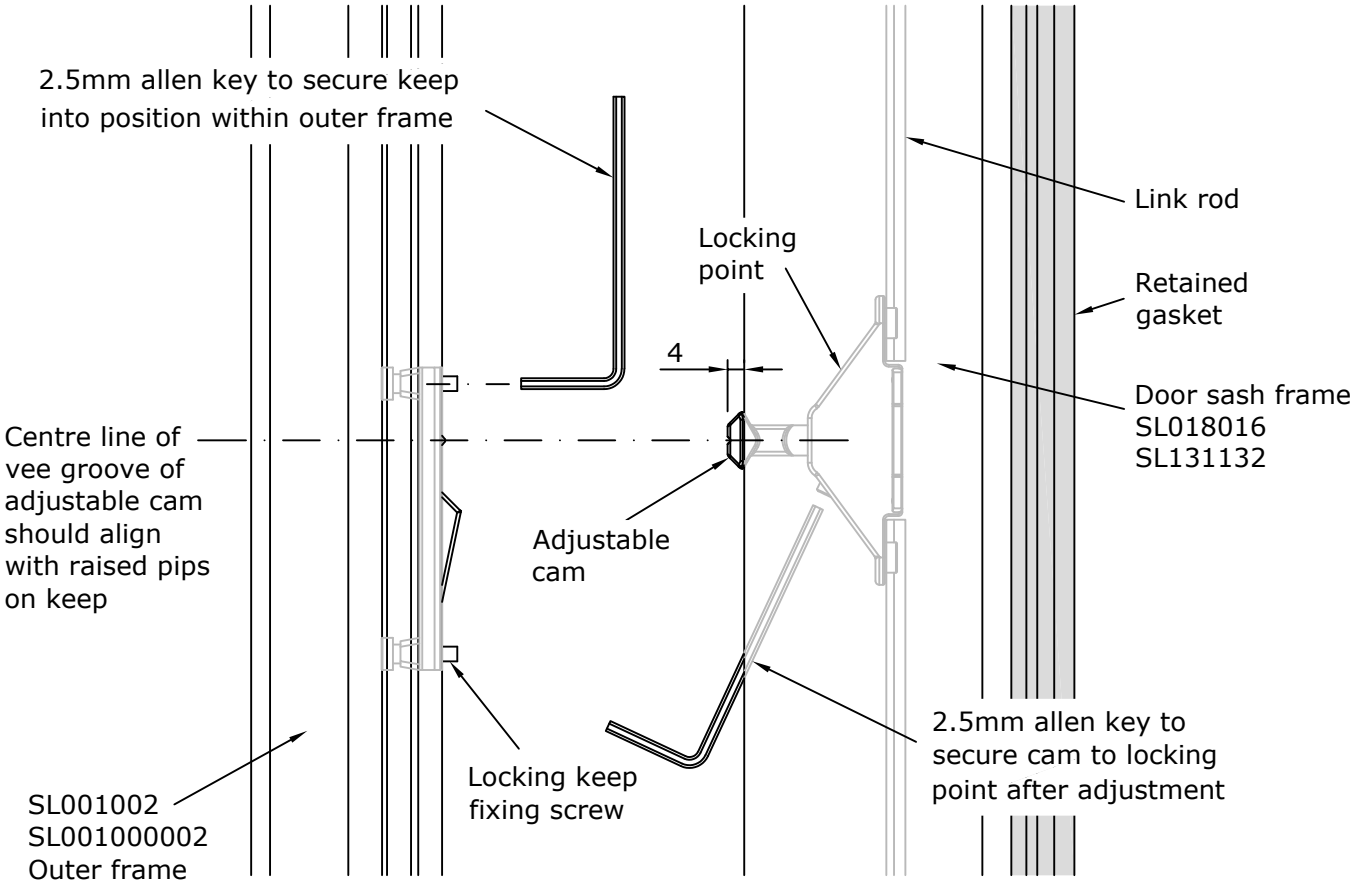
Fixed sash

cont...

Ensure vertical locking gear is in unlocked position. Centralise SL075 fixed sash rod drive within Ø10 x 50mm slotted hole in thermal break of jamb stile.



Slide fixed sash towards closed position, ensuring vee groove on locking points aligns with pip on keeps. Adjust, if necessary, by loosening screws on keep, re-aligning and re-tightening screws. Infills may need to be trimmed accordingly. Ensure adjustable cam on SL071 locking kit projects 4mm past edge of sash and lock into position using allen key as shown.



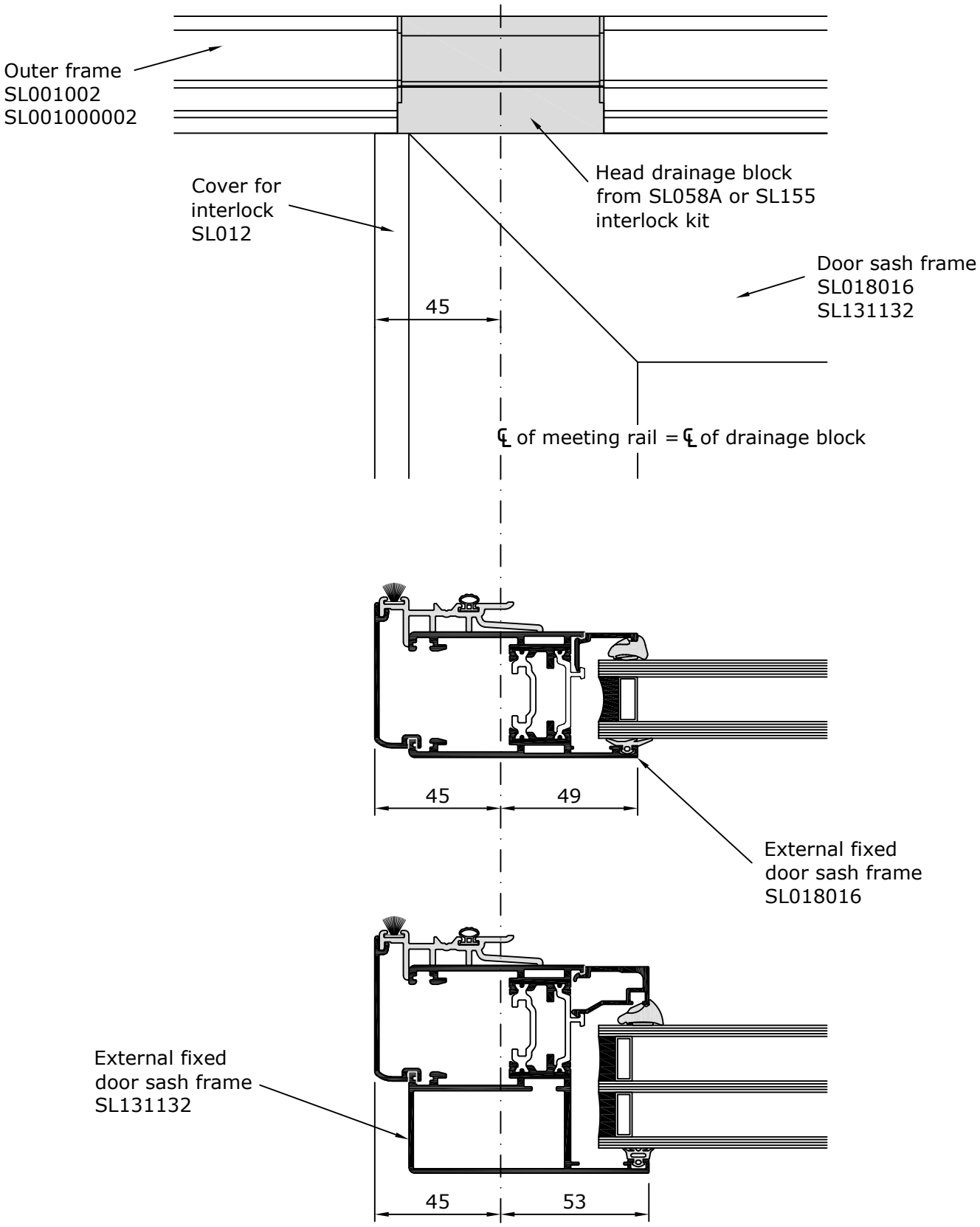
Not to scale

Installation Procedures

Fixed Sash

cont...

When adjusting locking cams on fixed sash ensure they are set so that centre line of meeting rail is centralised with centre line of drainage blocks. Weather performance will be affected if not adjusted corretly.



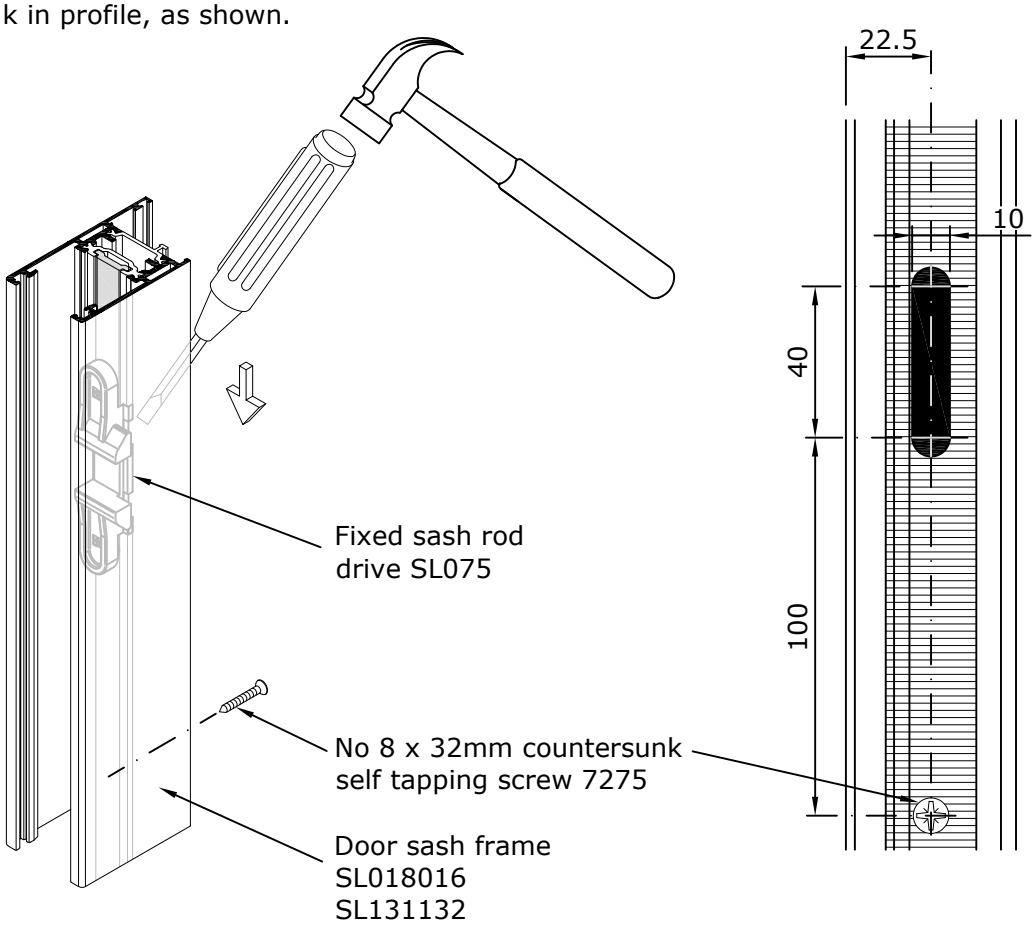
Not to scale

Installation Procedures

Fixed Sash - Glazing

Close fixed sash and secure in position.

Position fixed sash so that it overlaps outer frame by 8.5mm. Insert screwdriver into slotted hole in thermal break of jamb stile and push rod drive downwards to tightly secure locking points in keeps. Finally secure link rod in position by inserting 7275 No 8 x 32mm countersunk self tapping screw through thermal break in profile, as shown.



Refer to "Glazing Details" sheets.

Ensure retained gasket has been factory fitted. If not, insert on site.

Insert aluminium glazing support SL049 at cill of SL018016 sash, or insert glazing support 6745 at cill of SL131132 sash.

If not factory fitted, fit 745 glazing supports at jambs of SL018016 sash, or fit glazing support 6745 at jambs of SL131132 sash.

Fit additional pvc glazing packers (by installer) at cill.

Seal gap in bead nib of polyamide strip of SL131132 sash.

Apply HR50328A to mitre corners of retained gasket.

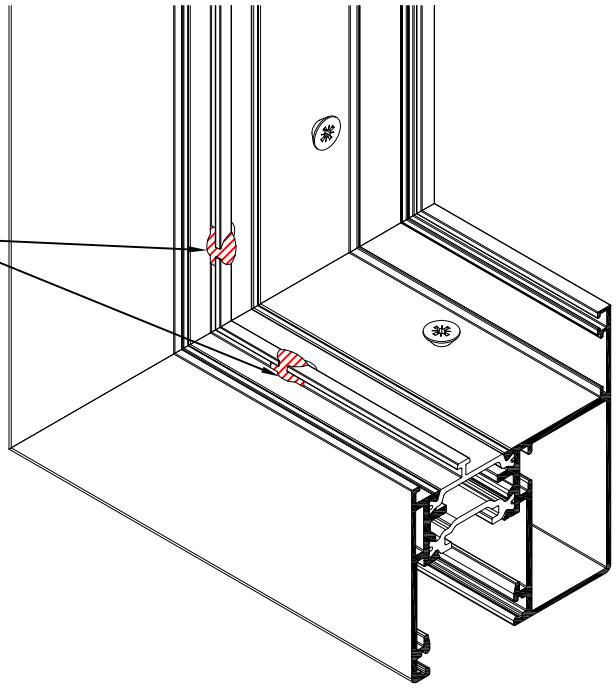
Refer to "Weatherseal Application Details" sheet.

Insert glazing unit and centralise vertically. Additional/alternative pvc glazing packers (by installer) may be required at cill.

Centralise unit laterally and apply additional pvc packers (by installer) at jambs to wedge glazing unit securely in position.

Apply head, cill, and then jamb beads.

Apply wedge gaskets in accordance with Glazing Options table on "Glazing Bead and Gasket Requirements" sheet.

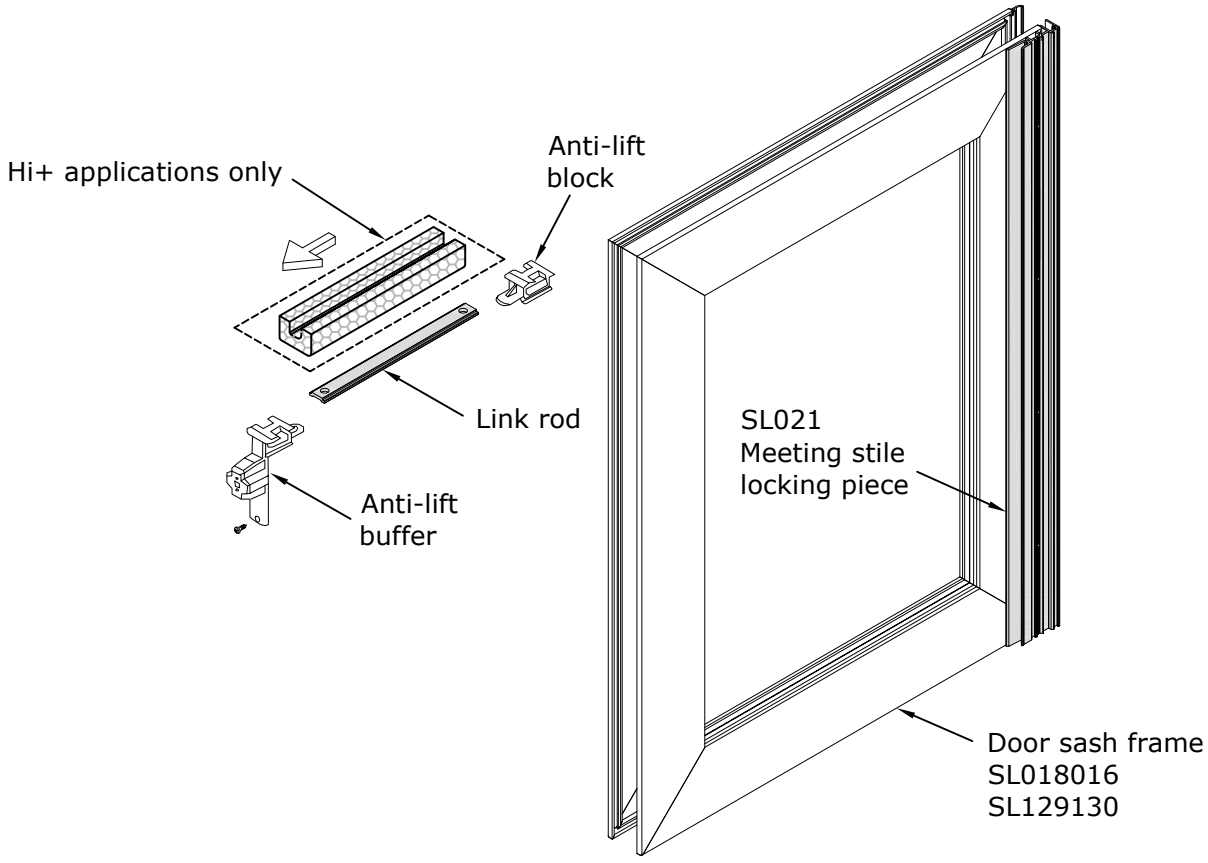


Not to scale

Installation Procedures

Opening Sash

Temporarily remove anti-lift buffer and anti-lift block assembly (including thermal foam) from SL067, from top rail of opening sash. Slave sashes of 4-pane applications and middle sash in triple track applications contain anti-lift kit SL060 which should not be removed.



Check handing and orientation of sashes. Offer head of opening sash over appropriate track. Ensure handle is at 12 o'clock position for master locking sashes. For slave sash in 4-pane applications and middle sash in triple track applications ensure handle is in unlocked position (6 o'clock) in order to dis-engage anti-lift kit SL060 and allow slave sash to be fitted over track. Refer to General Arrangement drawings for sash layout details.

Rotate door into position behind fixed sash so that carriages are centred on bottom track, and lower into place.

Re-insert anti-lift buffer and anti-lift block assembly (and foam) into top rail from vertical locking gear end and secure using screw provided. Note that anti-lift buffer and anti-lift block assembly may vary from sash to sash. Care must be taken to ensure the correct kit is re-inserted into the correct sash.

In triple track applications fit central opening sash prior to fitting master opening sash.

Glaze opening sashes as fixed sashes described previously.

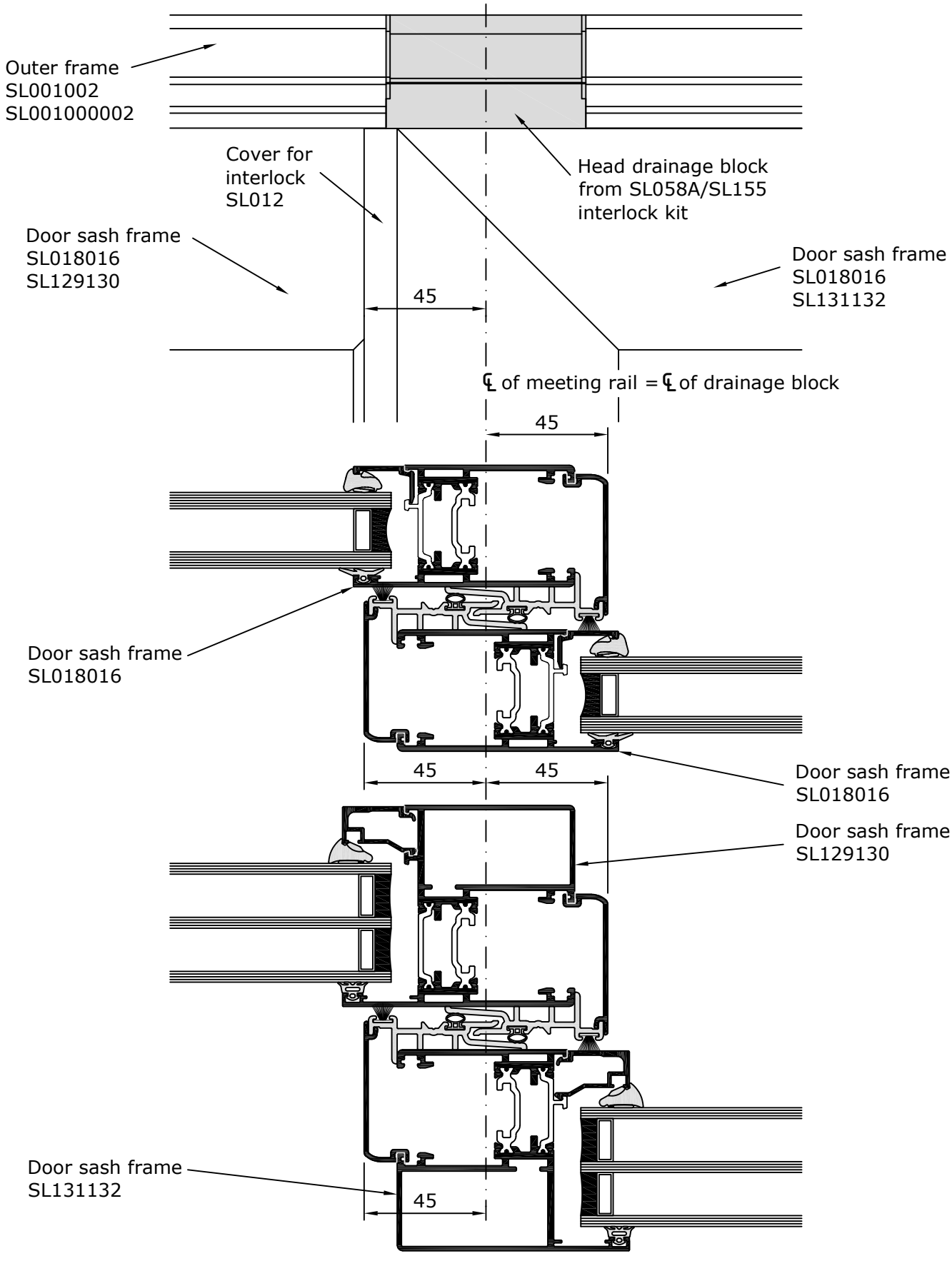
Not to scale

Installation Procedures

Opening Sash

cont...

When adjusting opening sashes ensure they are set so that centre line of meeting rail is centralised with centre line of drainage blocks. Weather performance will be affected if not adjusted corretly.



Close opening sash and secure in position by turning handle to 12 o'clock position

Not to scale

Installation Procedures

Opening Sash

System 25 Hi/Hi+

LIFT AND SLIDE DOOR

2T 3T

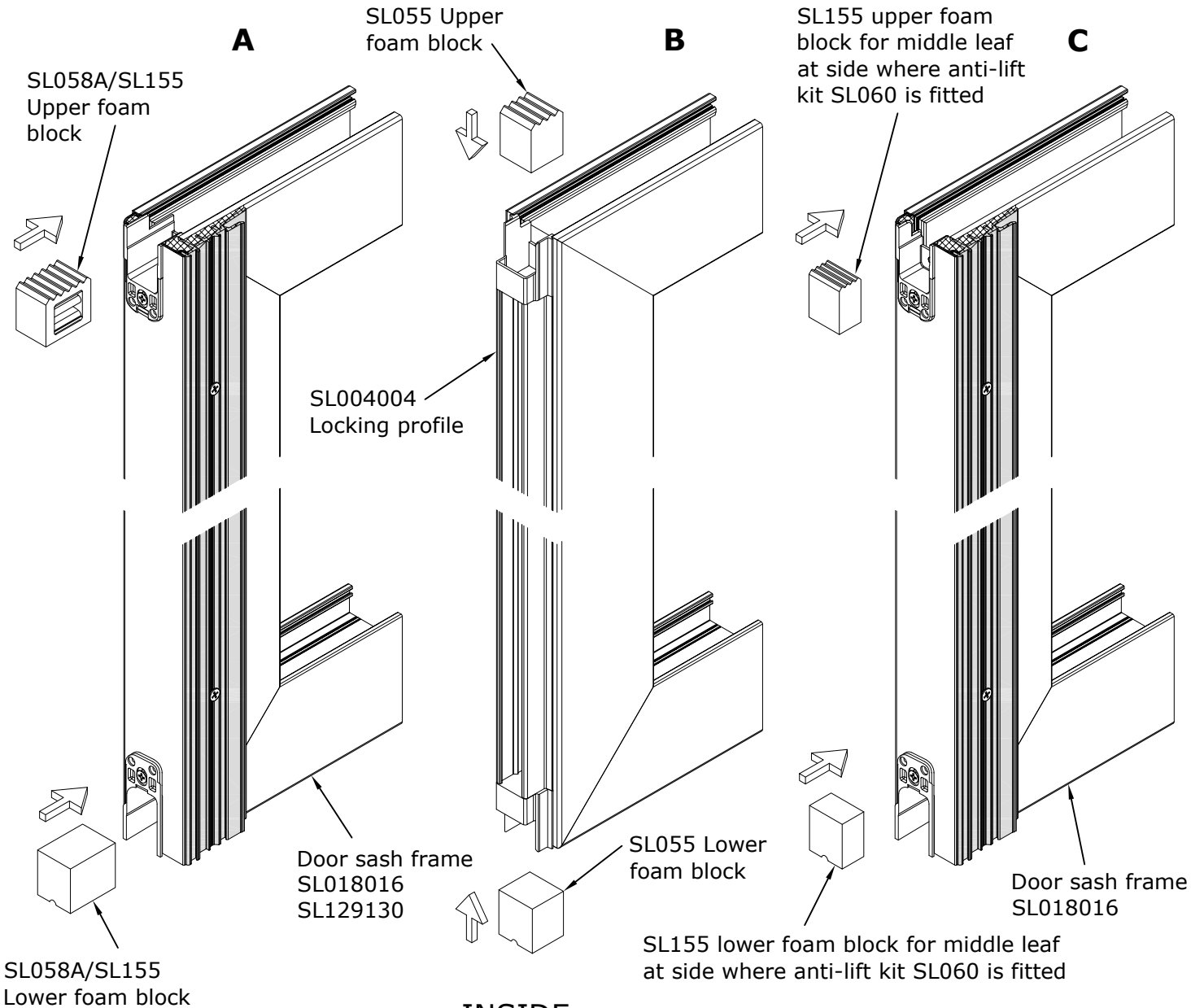
cont...

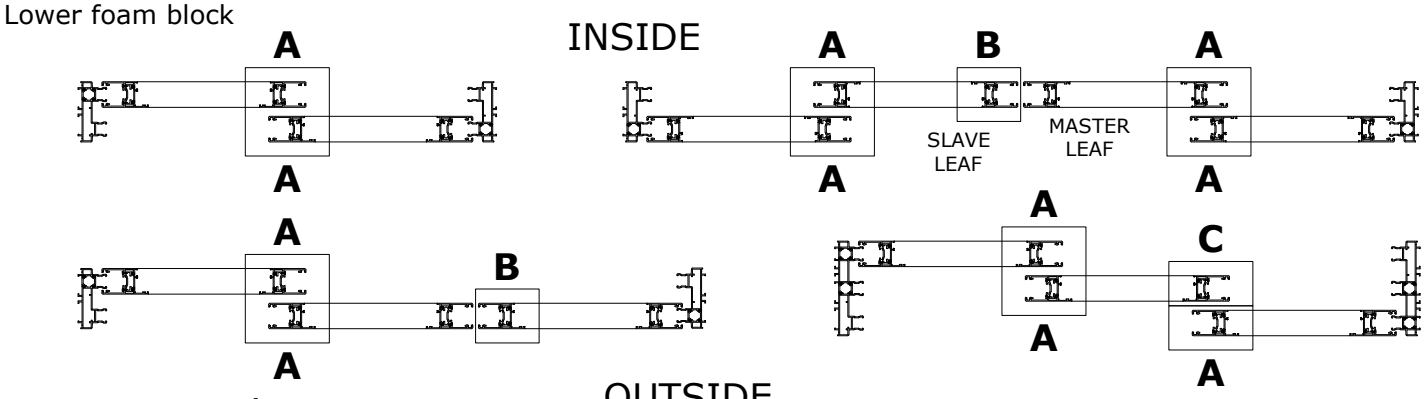
Insert upper and lower foam blocks from SL058A/SL155 interlock kit and SL055 sash plug kit into the interlock end of the fixed and opening sash top and bottom rails. Foam blocks are required for all interlock applications, both rebated and in-line.

MASTER LEAF FOR DOUBLE AND TRIPLE TRACK DOORS AND MIDDLE PANE OF TRIPLE TRACK DOORS

SLAVE LEAF OF 4 PANE AND FIXED LEAF, ON THE SAME TRACK AS THE CENTRAL SASH, OF 3 PANE DOUBLE TRACK DOORS

MIDDLE PANE OF TRIPLE TRACK DOORS





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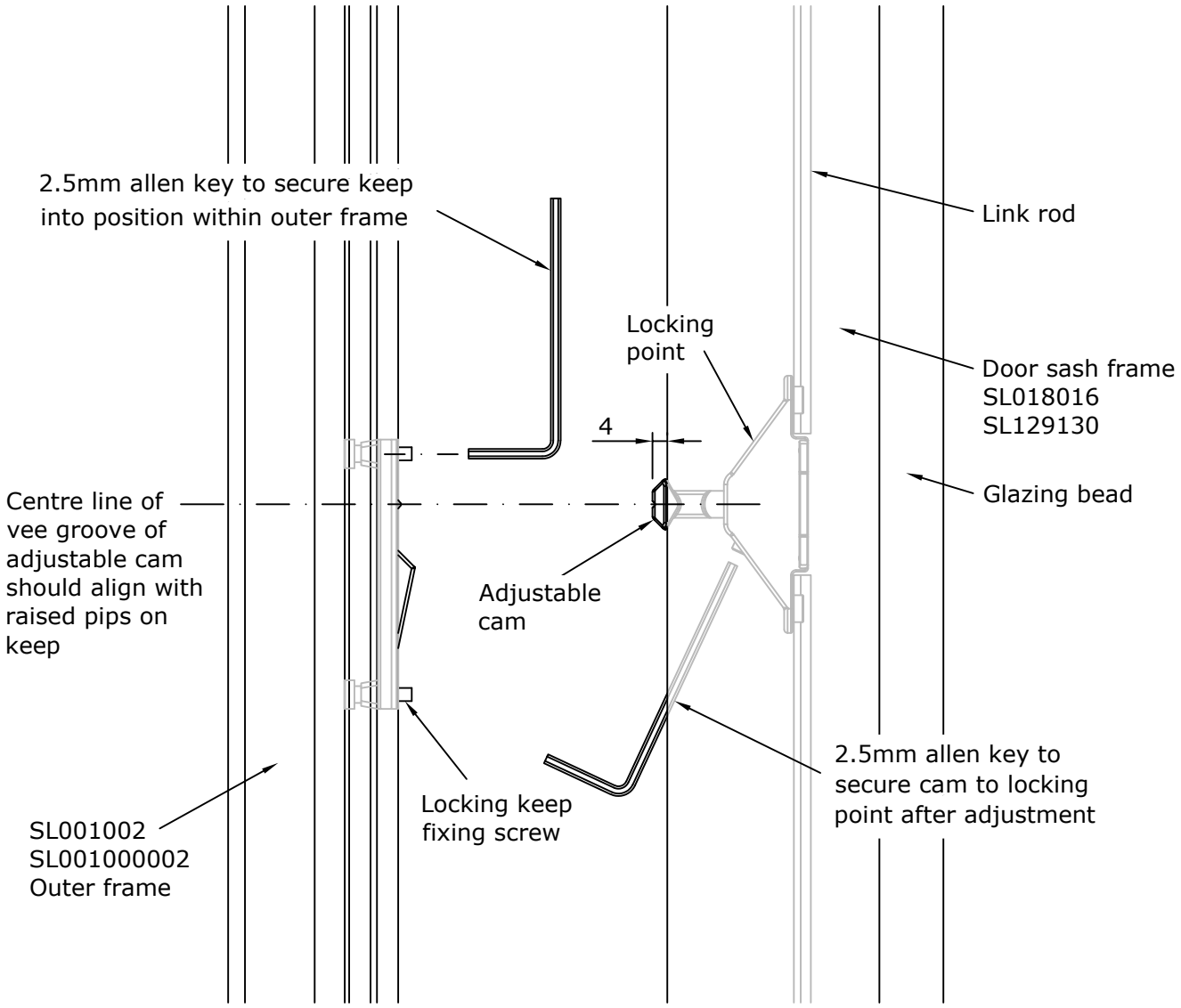
Installation Procedures

Opening Sash

cont...

Turn handle to open position (6 o'clock) and slide master opening sash towards closed position, ensuring vee groove on locking points aligns with pip on keeps.
Adjust, if necessary, by loosening screws on keep, re-aligning and re-tightening screws. Infills may need to be trimmed accordingly. Ensure adjustable cam on SL071 locking kit projects 4mm past edge of sash and lock into position using allen key as shown.

In 4-pane applications slave sash must be in locked position (handle at 12 o'clock) before adjusting pins on master locking sash.



Not to scale

Installation Procedures

Opening Sash - Glazing

Refer to "Glazing Details" sheets.

Ensure retained gasket has been factory fitted. If not, insert on site.

Insert aluminium glazing support SL049 at cill of SL018016 sash, or insert glazing support 6745 at cill of SL129130 sash.

If not factory fitted, fit 745 glazing supports at jambs of SL018016 sash, or fit glazing support 6745 at jambs of SL129130 sash.

Fit additional pvc glazing packers (by installer) at cill.

Apply HR50328A to mitre corners of retained gasket.

Refer to "Weatherseal Application Details" sheet.

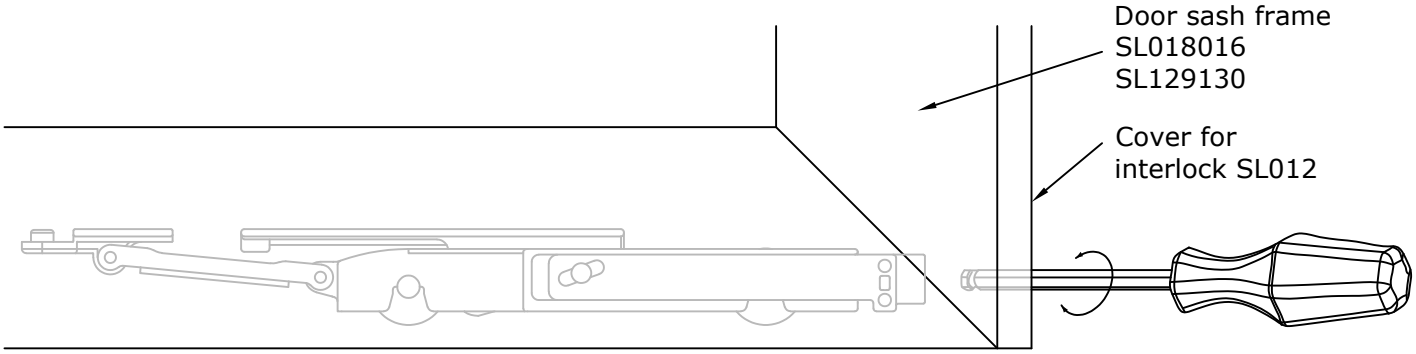
Insert glazing unit and centralise vertically. Additional/alternative pvc glazing packers (by installer) may be required at cill.

Centralise unit laterally and apply additional pvc packers (by installer) at jambs to wedge glazing unit securely in position.

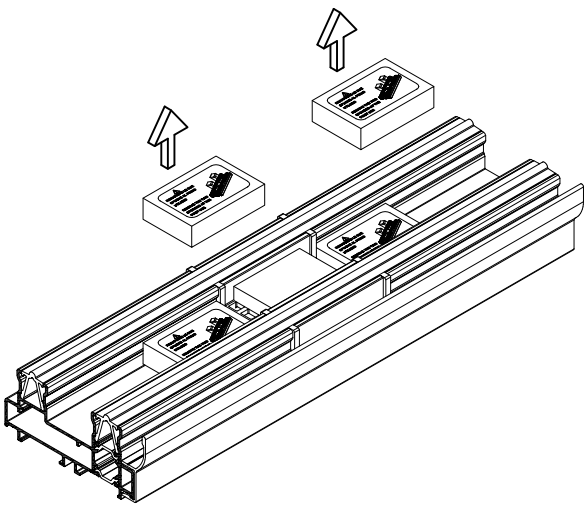
Apply head, cill, and then jamb beads.

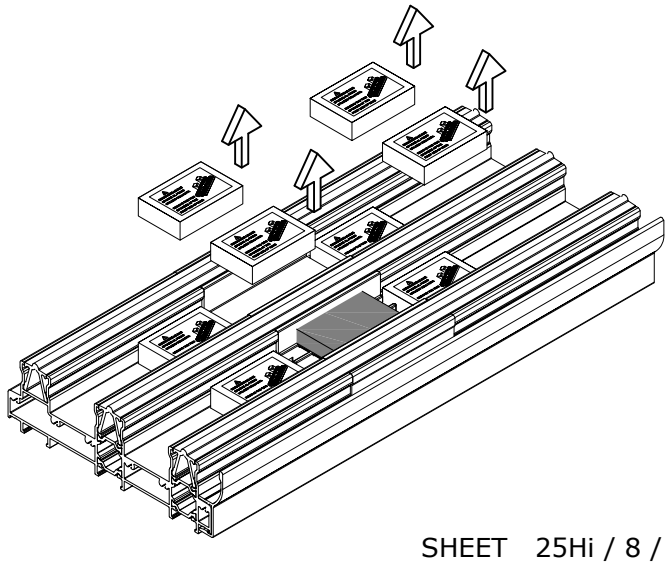
Apply wedge gaskets in accordance with Glazing Options table on "Glazing Bead and Gasket Requirements" sheet.

Check verticality of leading edge of all opening sashes using spirit level. If out of plumb, adjust carriage adjacent to rebated interlock with allen key as illustrated.



When door is operating satisfactorily check groove between tracks in cill member and remove any debris. When satisfied that there is no risk of any further debris contaminating this area, remove temporary cill sponges. Keeping temporary cill sponges in place will help prevent debris from entering the door drainage system. However, they will also reduce the drainage capacity of the system if left in place.

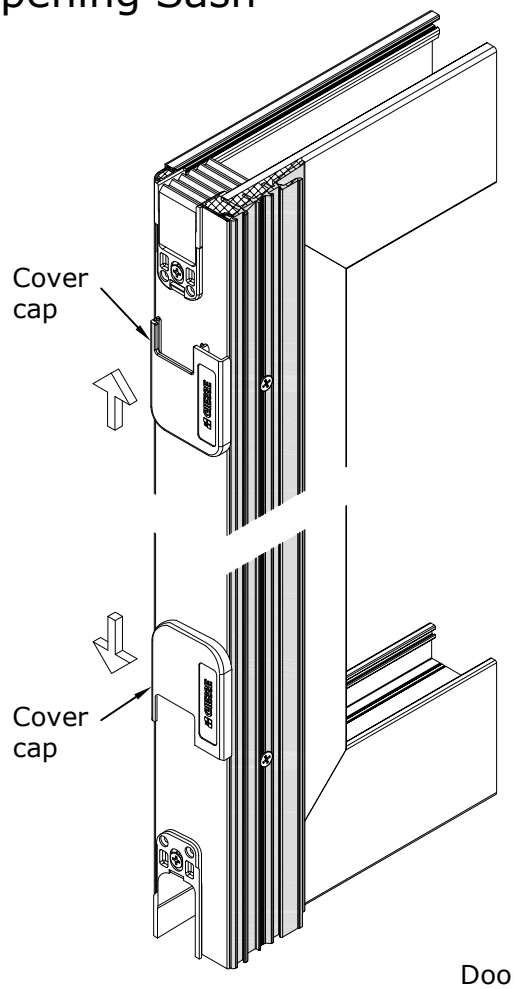




Not to scale

Installation Procedures

Opening Sash



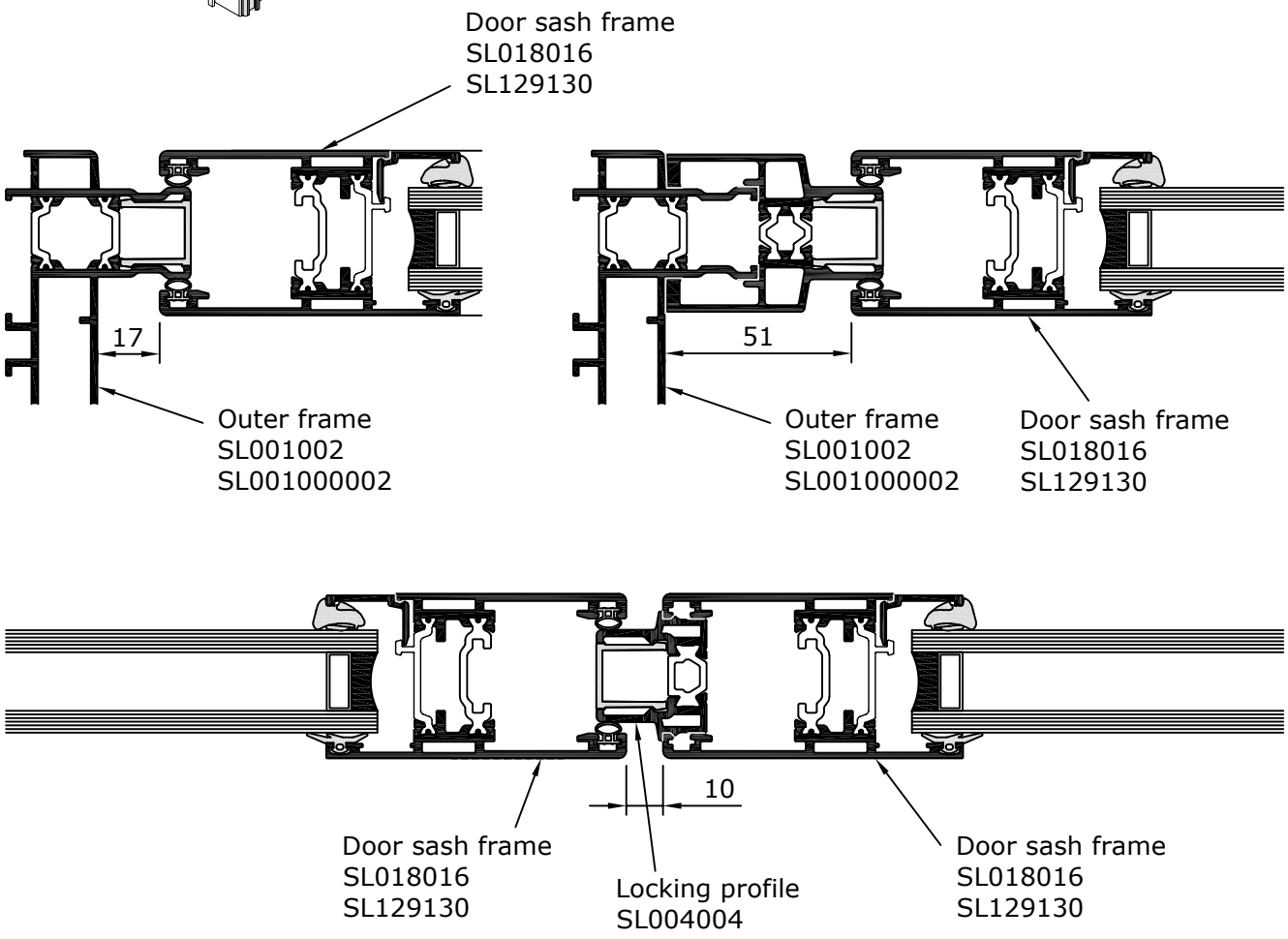
Slide cover cap from SL058A/SL155 interlock kit into position over top / bottom rail insert of fixed and opening sashes.

Check operation of sashes and locking points, and make final adjustments as necessary. In 4-pane applications always ensure slave leaf is closed and locked prior to closing master locking leaf. Adjust locking points to ensure relevant 17mm or 51mm clearance between sash and outer frame and, where applicable, 10mm clearance between sashes when using SL004004 locking profile.

If not already factory-fitted fit SL082 door stop using fixings supplied in kit. Refer to "Sash Prep Details, SL082 Door Stop" sheet.

Fit SL033/SL036 outer frame trims. Refer to "Outer Frame Trim SL033 Installation" or "Outer Frame Trim SL033 and SL036 Installation" sheets.

Apply suitable sealant to perimeter of outer frame. Refer to "Typical Fixing Detail", "Typical Sub-Cill Detail", "Typical Cill Detail Perimeter Interface" and "Typical Sub-Cill Detail Perimeter Interface" sheets.



Not to scale

Typical Fixing Details

Lug Fixing

System 25 Hi/Hi+

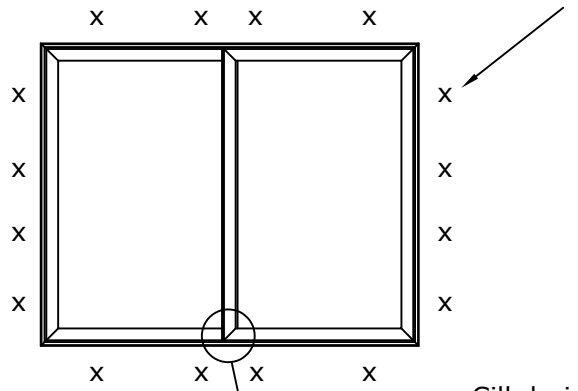
LIFT AND SLIDE DOOR

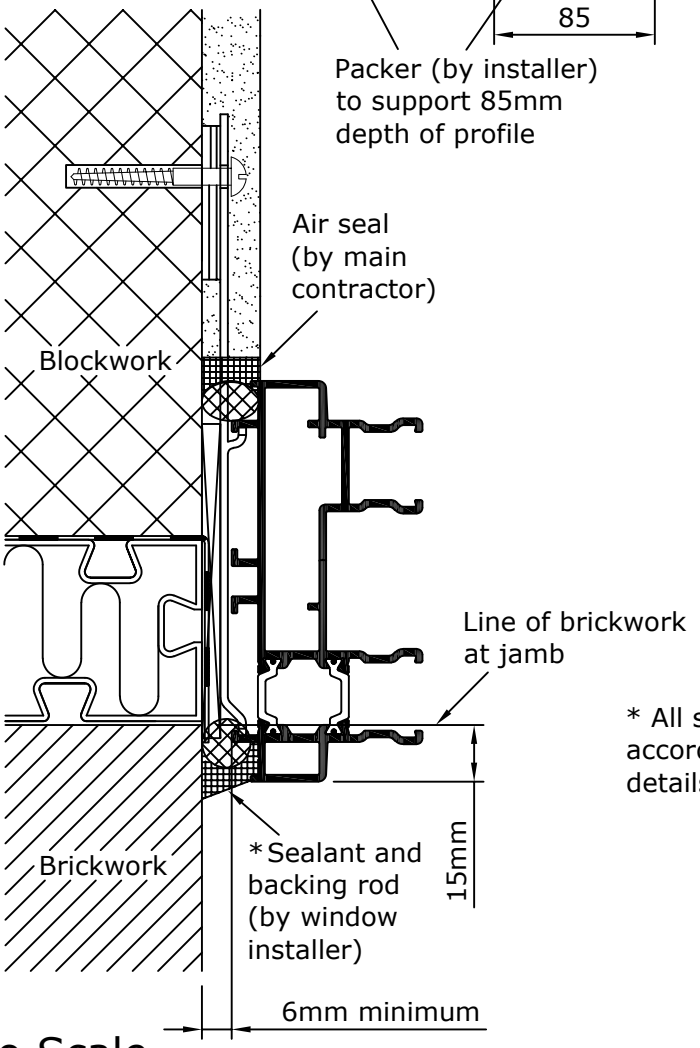
2T

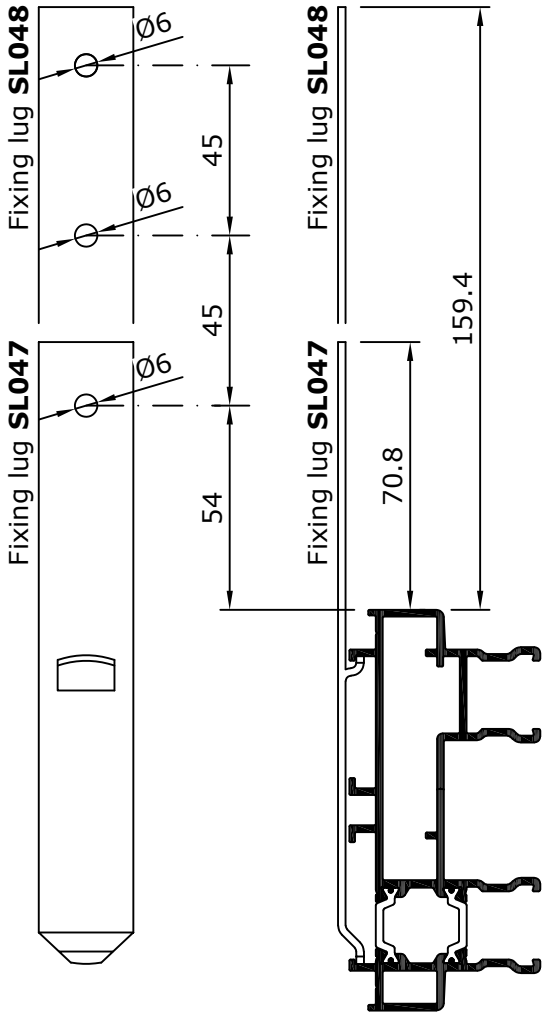
Fixing lugs provide lateral restraint only. Dead load support to be provided by perimeter structure. All fixings to be adequate and suitable for loading conditions and application.

Metal Technology recommend the use of fixing lugs, as direct fixing through the cill is not permitted.

Packers between frame and structure to be positioned at or adjacent to fixing lug positions at head and jambs, and at maximum 200mm centres at cill, and both sides of cill drainage block, as shown. Cill packers to support full width of profile.







Section
SL001002

* All sealants to be installed in strict accordance with manufacturers relevant details and BS 6093 to suit site conditions.

Not to Scale

Typical Fixing Details

Triple Track Lug Fixing

System 25 Hi/Hi+

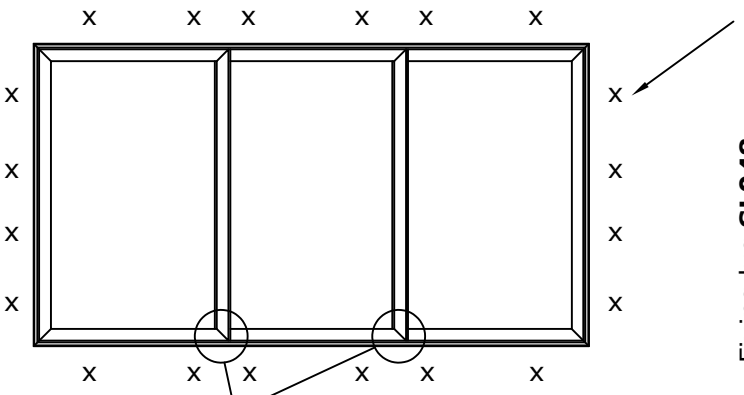
LIFT AND SLIDE DOOR

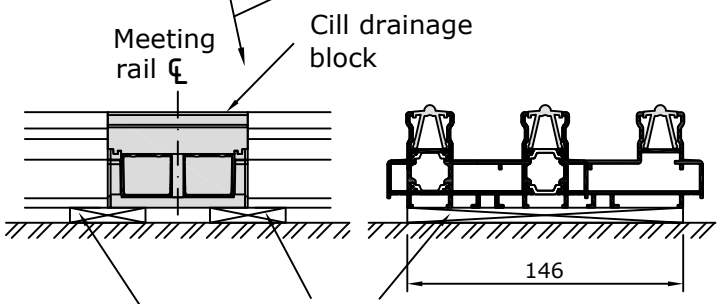
3T

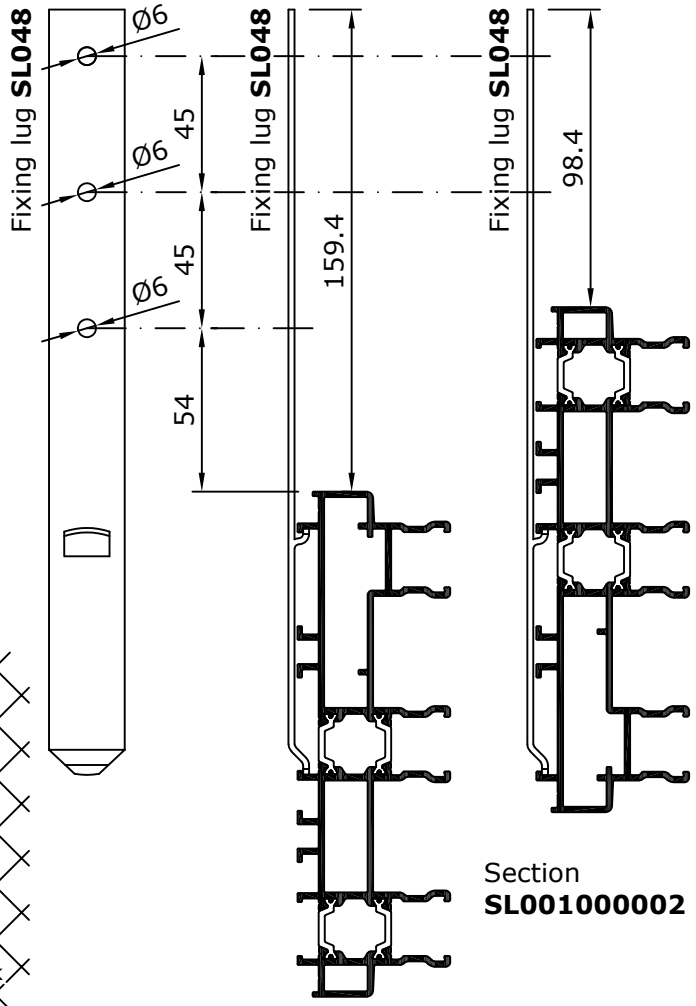
Fixing lugs provide lateral restraint only. Dead load support to be provided by perimeter structure. All fixings to be adequate and suitable for loading conditions and application.

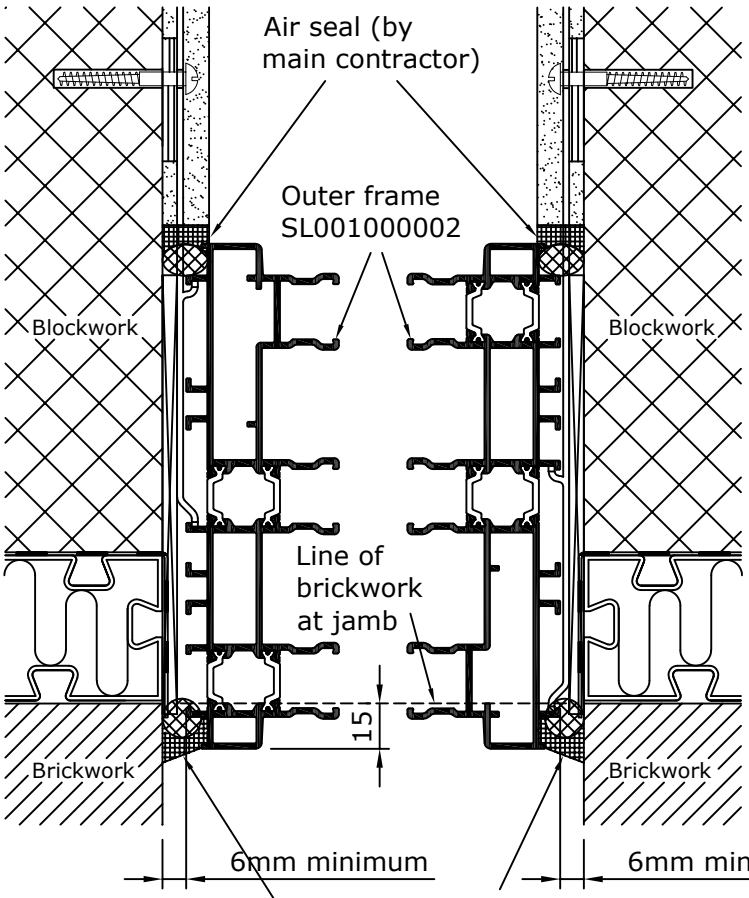
Metal Technology recommend the use of fixing lugs, as direct fixing through the cill is not permitted.

Packers between frame and structure to be positioned at or adjacent to fixing lug positions at head and jambs, and at maximum 200mm centres at cill, and both sides of cill drainage block, as shown. Cill packers to support full width of profile.









* All sealants to be installed in strict accordance with manufacturers relevant details and BS 6093 to suit site conditions.

Not to Scale

Typical Fixing Details

Triple Track Lug Fixing

System 25 Hi/Hi+

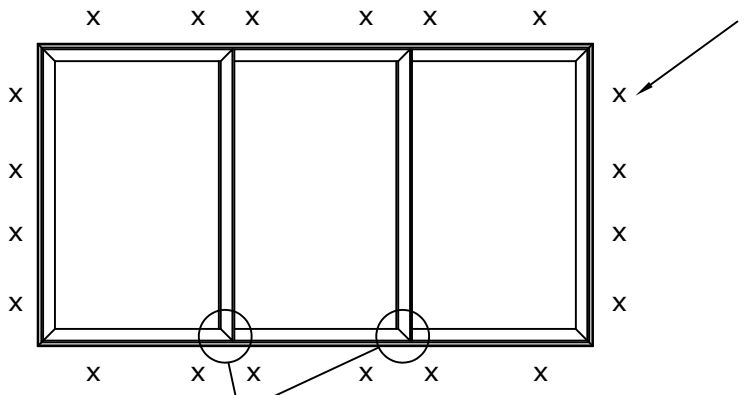
LIFT AND SLIDE DOOR

3T

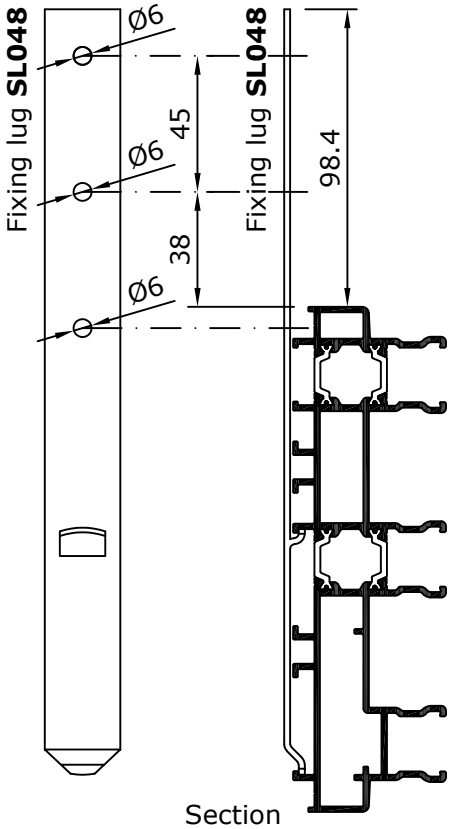
Fixing lugs provide lateral restraint only. Dead load support to be provided by perimeter structure. All fixings to be adequate and suitable for loading conditions and application.

Metal Technology recommend the use of fixing lugs, as direct fixing through the cill is not permitted.

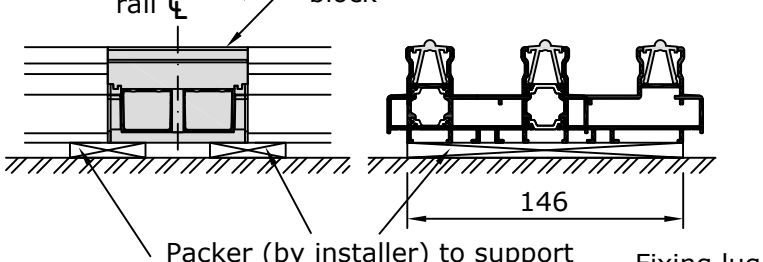
Packers between frame and structure to be positioned at or adjacent to fixing lug positions at head and jambs, and at maximum 200mm centres at cill, and both sides of cill drainage block, as shown. Cill packers to support full width of profile.

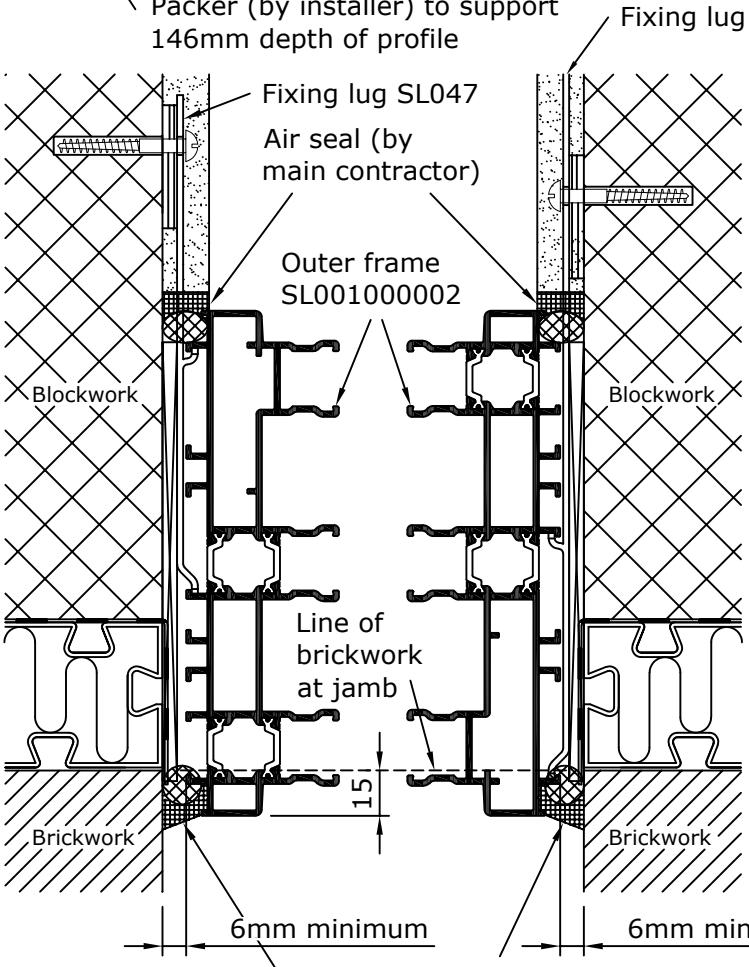


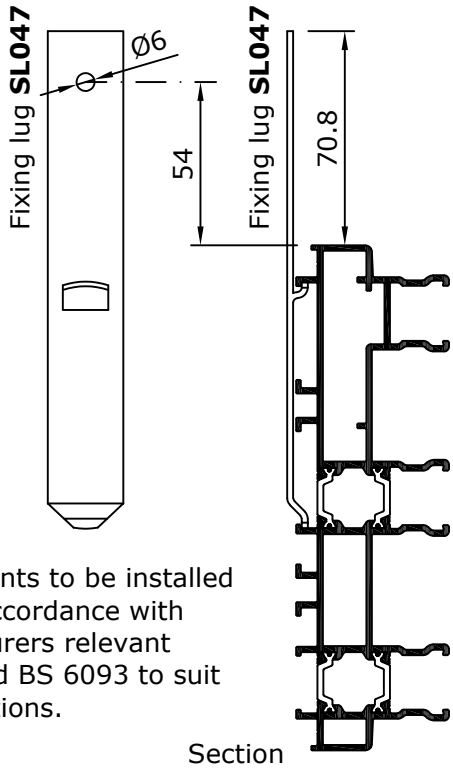
Positions of fixing lugs 150mm from corners and maximum 600mm centres and 150mm either side of a meeting stile.



Section
SL001000002







Section
SL001000002

* All sealants to be installed in strict accordance with manufacturers relevant details and BS 6093 to suit site conditions.

Not to Scale

Typical Fixing Details

Curtain Walling

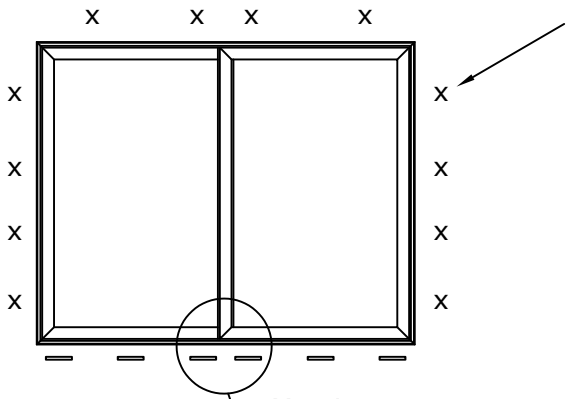
System 25 Hi/Hi+

LIFT AND SLIDE DOOR

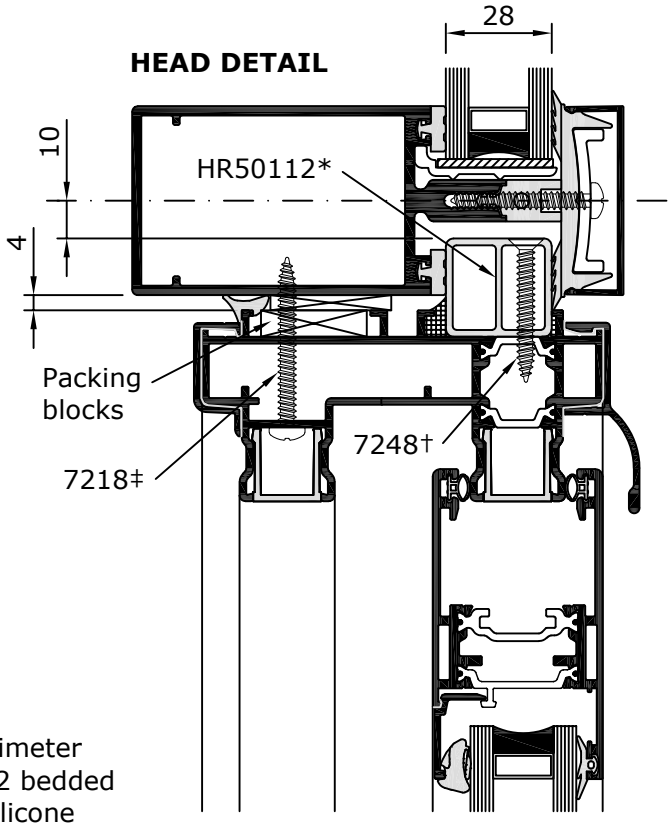
2T

Perimeter fixings provide a lateral restraint only. Dead load support to be provided by curtain wall transom profile. Structural engineer must ensure that the curtain wall transom can accommodate the dead loads transferred to it via the glazing supports when the doors are in the open and closed positions. Where necessary additional support off the structure may be required below the cill transom.

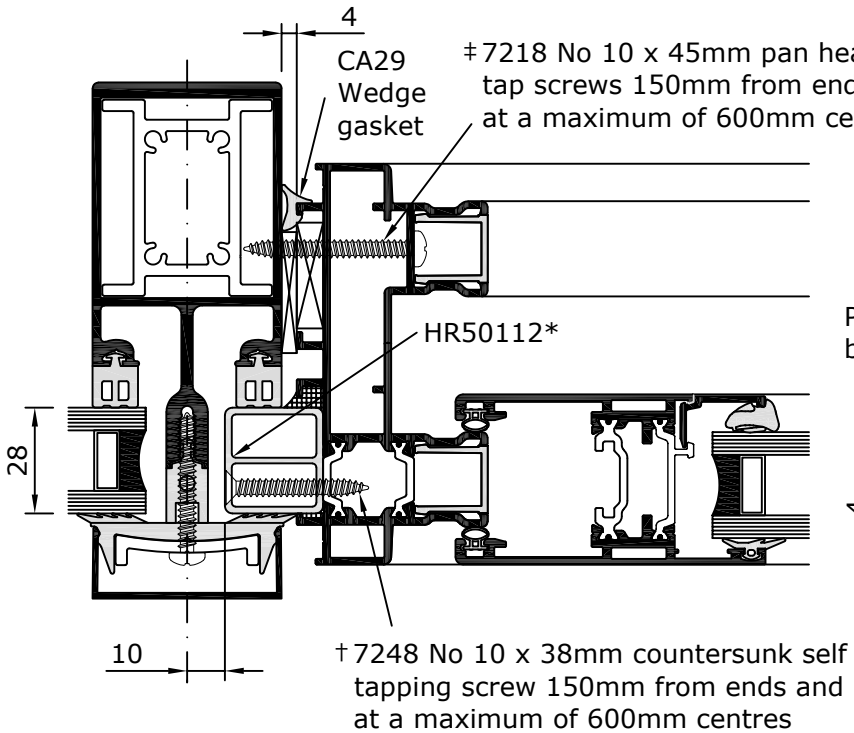
Packers between the outer frame and curtain wall to be positioned at or adjacent to fixing positions at head and jambs, and at glazing support positions at cill. Cill glazing supports to be positioned at jamb corners, either side of the drainage block, and at maximum 200mm centres. Direct fixing through the cill is not permitted.

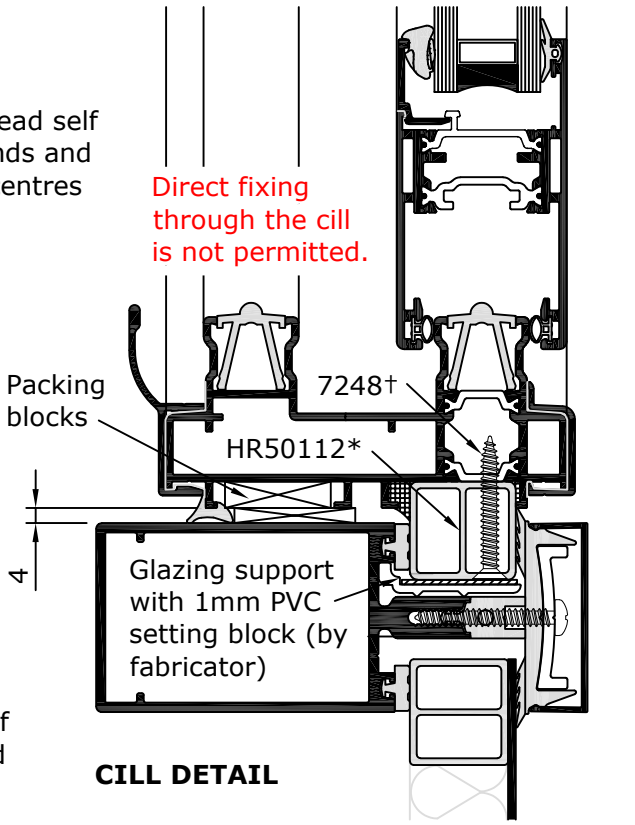


HEAD DETAIL



JAMB DETAIL





CILL DETAIL

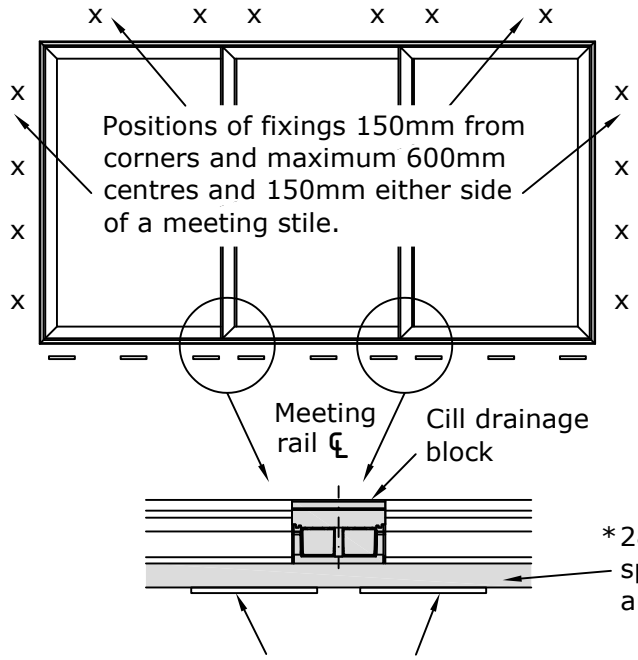
Not to Scale

Typical Fixing Details

Curtain Walling

System 25 Hi/Hi+

LIFT AND SLIDE DOOR



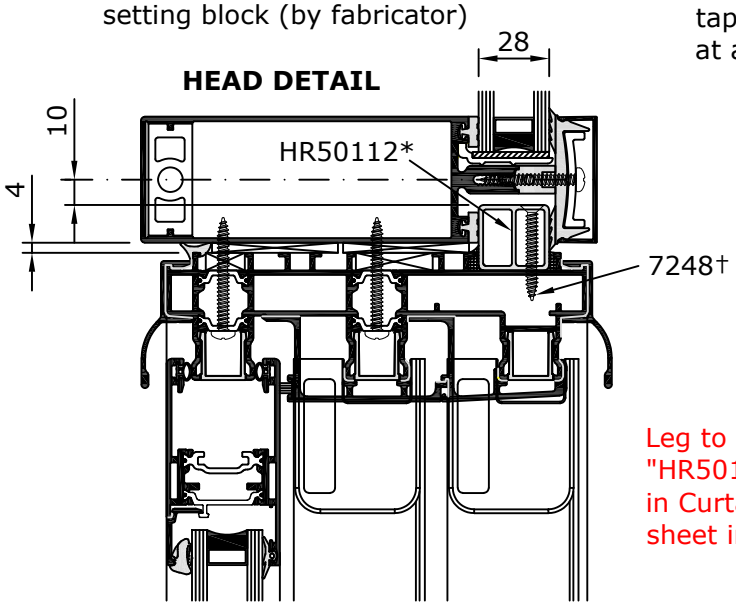
Perimeter fixings provide a lateral restraint only. Dead load support to be provided by curtain wall transom profile. Structural engineer must ensure that the curtain wall transom can accommodate the dead loads transferred to it via the glazing supports when the doors are in the open and closed positions. Where necessary additional support off the structure may be required below the cill transom.

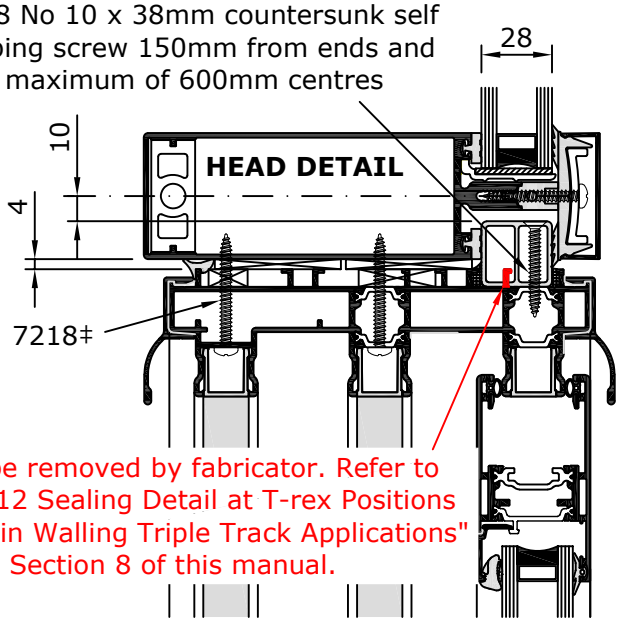
Packers between the outer frame and curtain wall to be positioned at or adjacent to fixing positions at head and jambs, and at glazing support positions at cill. Cill glazing supports to be positioned at jamb corners, either side of the drainage block, and at maximum 200mm centres. Direct fixing through the cill is not permitted.

*28 x 26mm perimeter spacer HR50112 bedded and sealed in silicone

Glazing support with 1mm PVC setting block (by fabricator)

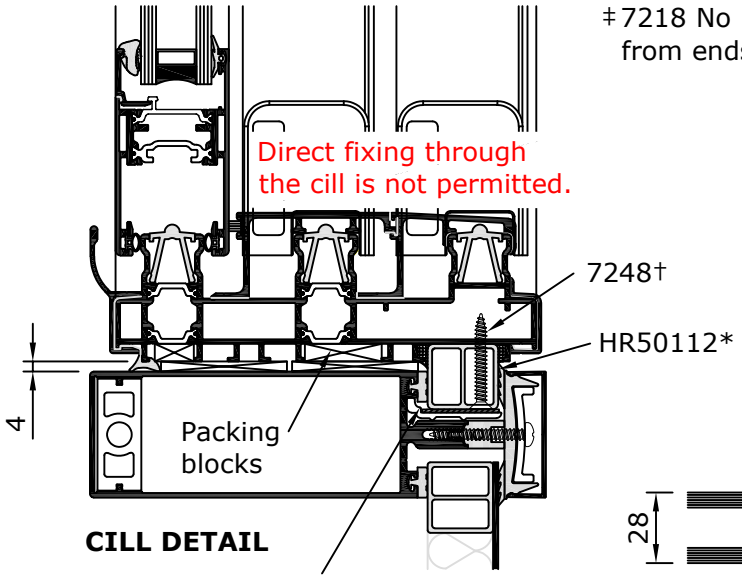
†7248 No 10 x 38mm countersunk self tapping screw 150mm from ends and at a maximum of 600mm centres

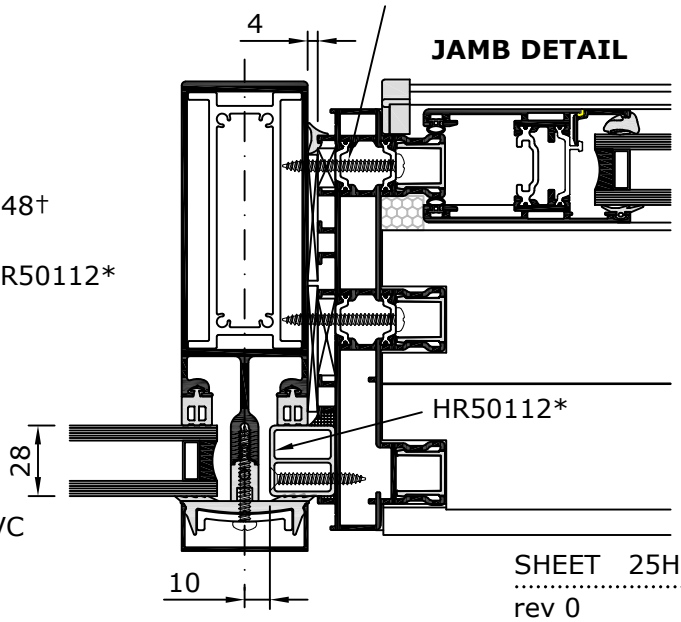




Leg to be removed by fabricator. Refer to "HR50112 Sealing Detail at T-rex Positions in Curtain Walling Triple Track Applications" sheet in Section 8 of this manual.

‡7218 No 10 x 45mm pan head self tap screws 150mm from ends and at a maximum of 600mm centres



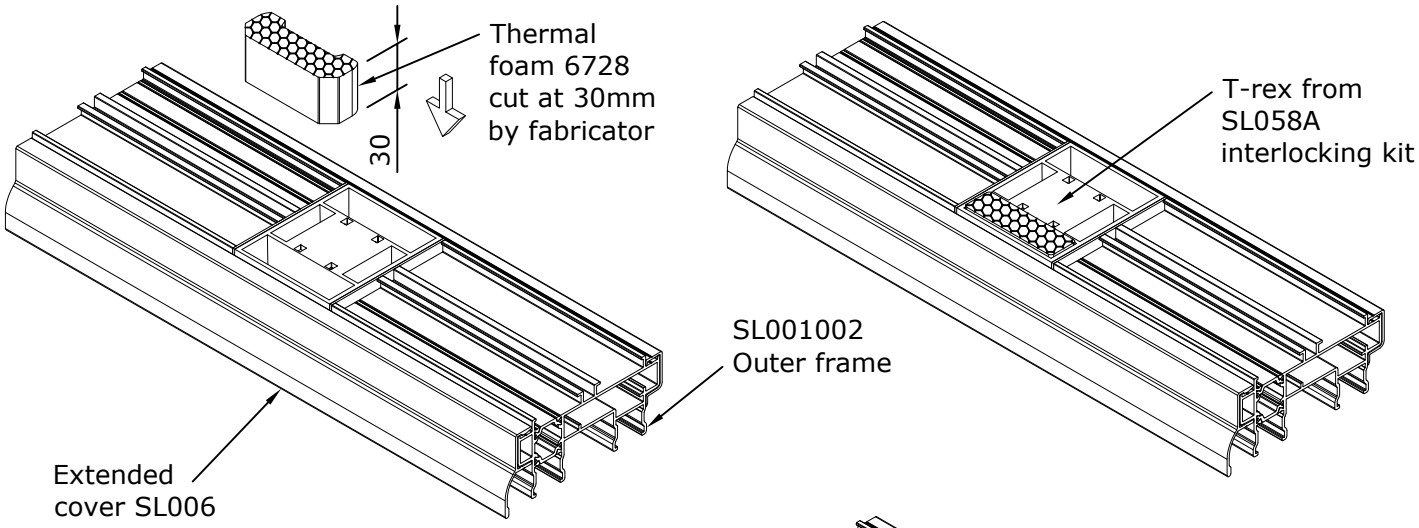


Glazing support with 1mm PVC setting block (by fabricator)

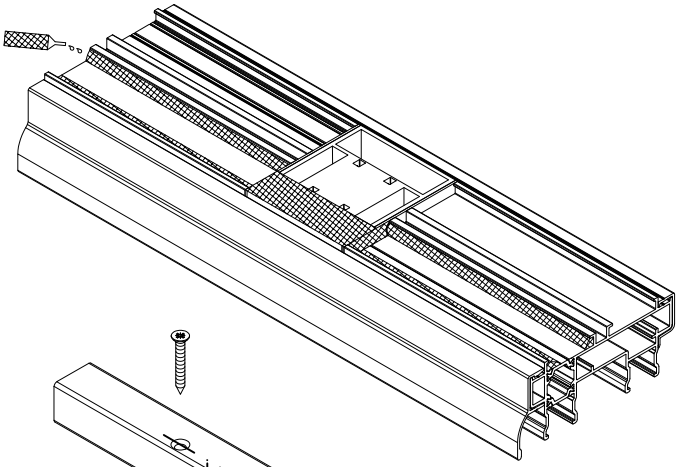
Scale 1:3

HR50112 Sealing Detail at T-rex Positions in Curtain Walling Double Track Applications

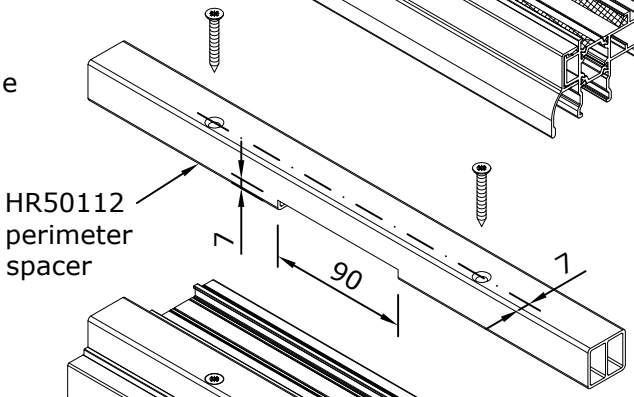
1. Insert foam 6728 cut at 30mm into void in T-rex from SL058A interlocking kit.



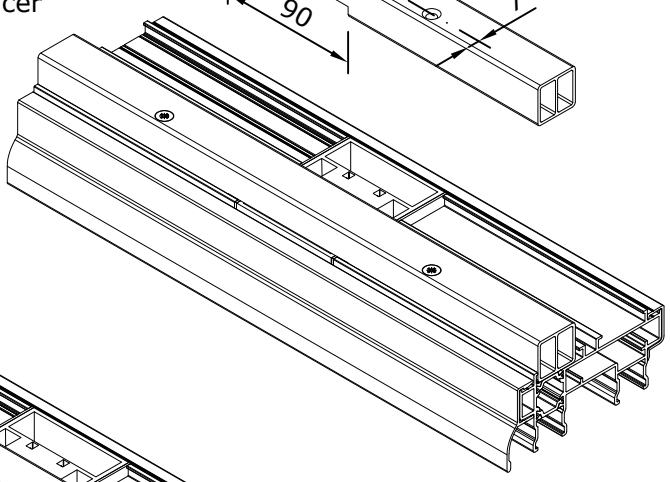
2. Apply silicone seal to foam and run bead of silicone along full length of outer frame as shown before attaching HR50112 perimeter spacer to outer frame SL001002.



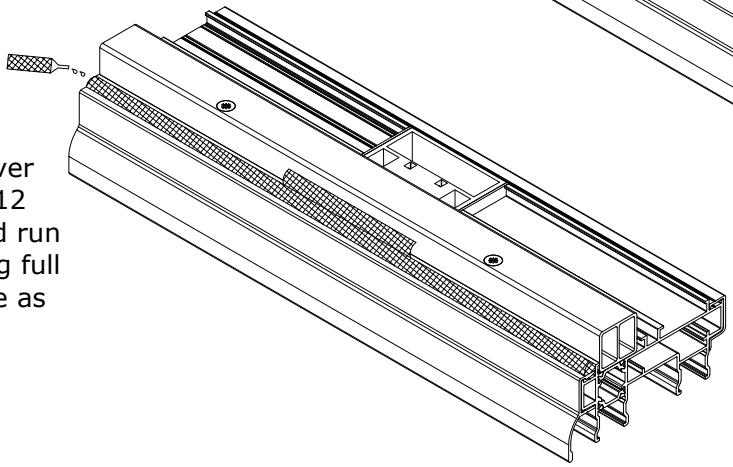
3. Notch HR50112 perimeter spacer at centre line of meeting stile as shown to fit it over T-rex onto outer frame SL001002. The same notch must be carried out at all T-rex positions.



4. Screw fix HR50112 perimeter spacer in place using No 10 x 38mm countersunk self tapping screws 7248. Refer to "Typical Fixing Details - Curtain Walling" sheet in Section 8 of this manual.



5. Apply silicone seal over notch part of HR50112 perimeter spacer and run bead of silicone along full length of outer frame as shown.



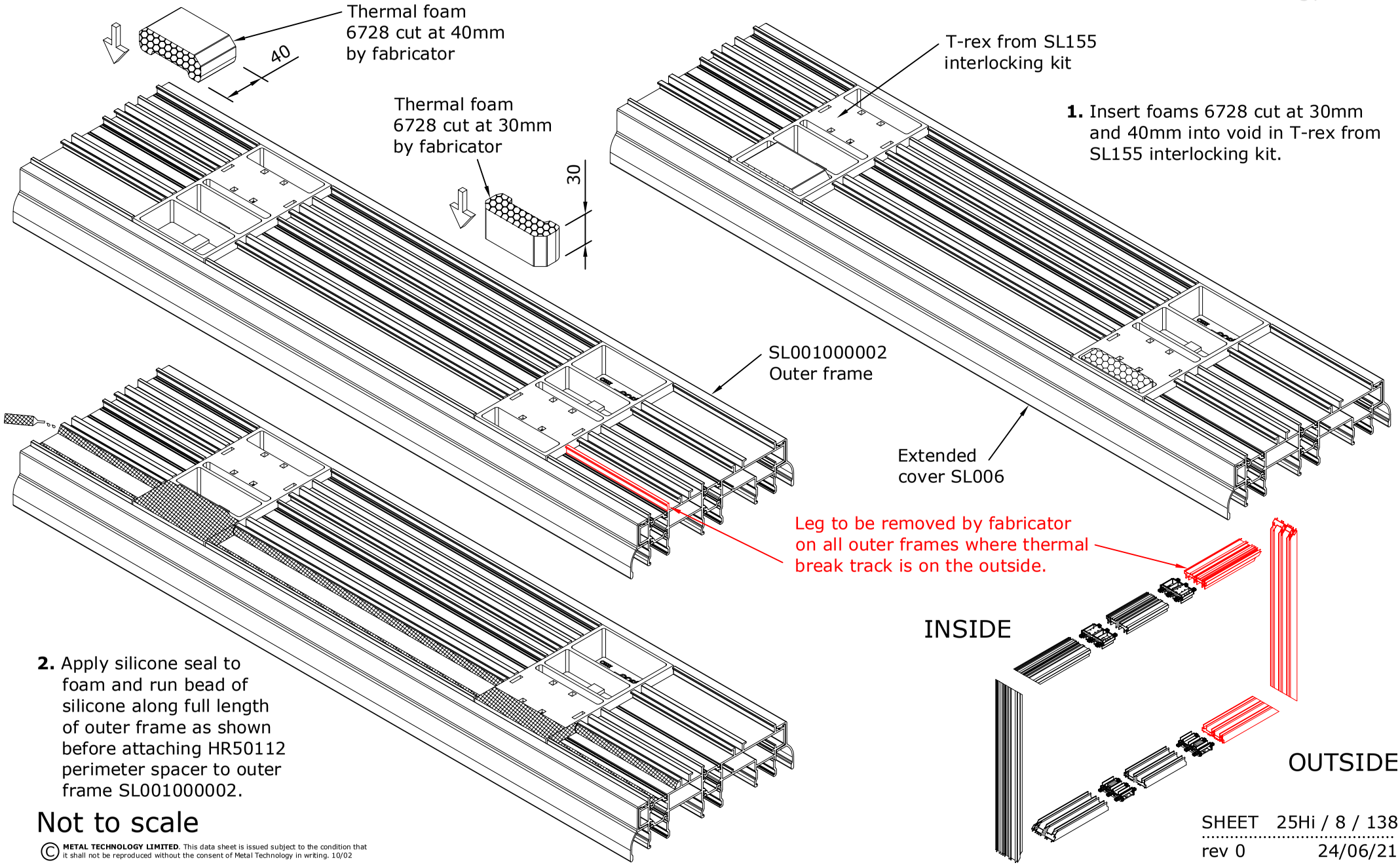
Not to Scale

HR50112 Sealing Detail at T-rex Positions in Curtain Walling Triple Track Applications

System 25 Hi/Hi+

LIFT AND SLIDE DOOR

3T



1. Insert foams 6728 cut at 30mm and 40mm into void in T-rex from SL155 interlocking kit.

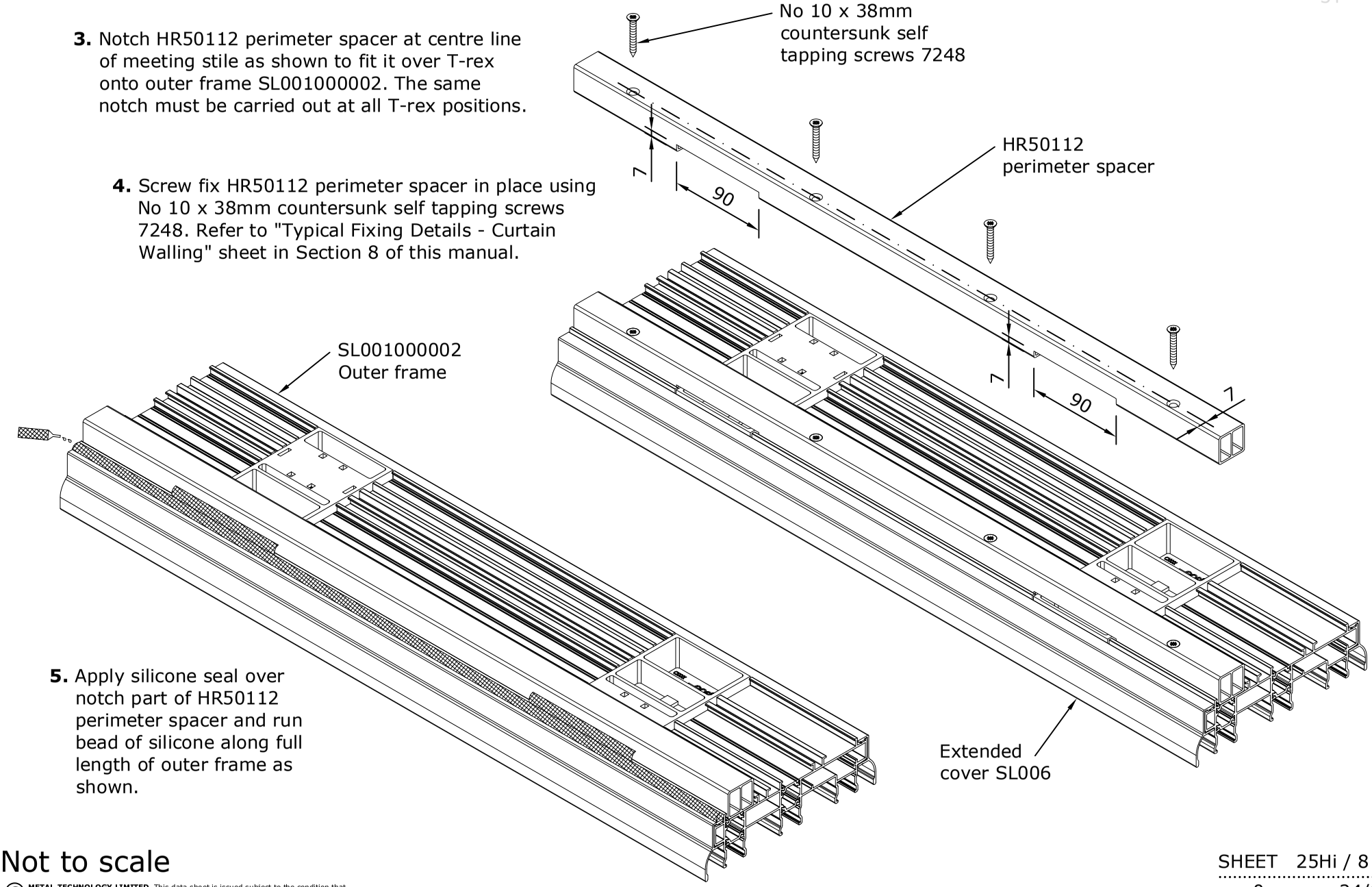
2. Apply silicone seal to foam and run bead of silicone along full length of outer frame as shown before attaching HR50112 perimeter spacer to outer frame SL001000002.

Not to scale

HR50112 Sealing Detail at T-rex Positions in Curtain Walling Triple Track Applications

3. Notch HR50112 perimeter spacer at centre line of meeting stile as shown to fit it over T-rex onto outer frame SL001000002. The same notch must be carried out at all T-rex positions.

4. Screw fix HR50112 perimeter spacer in place using No 10 x 38mm countersunk self tapping screws 7248. Refer to "Typical Fixing Details - Curtain Walling" sheet in Section 8 of this manual.



5. Apply silicone seal over notch part of HR50112 perimeter spacer and run bead of silicone along full length of outer frame as shown.

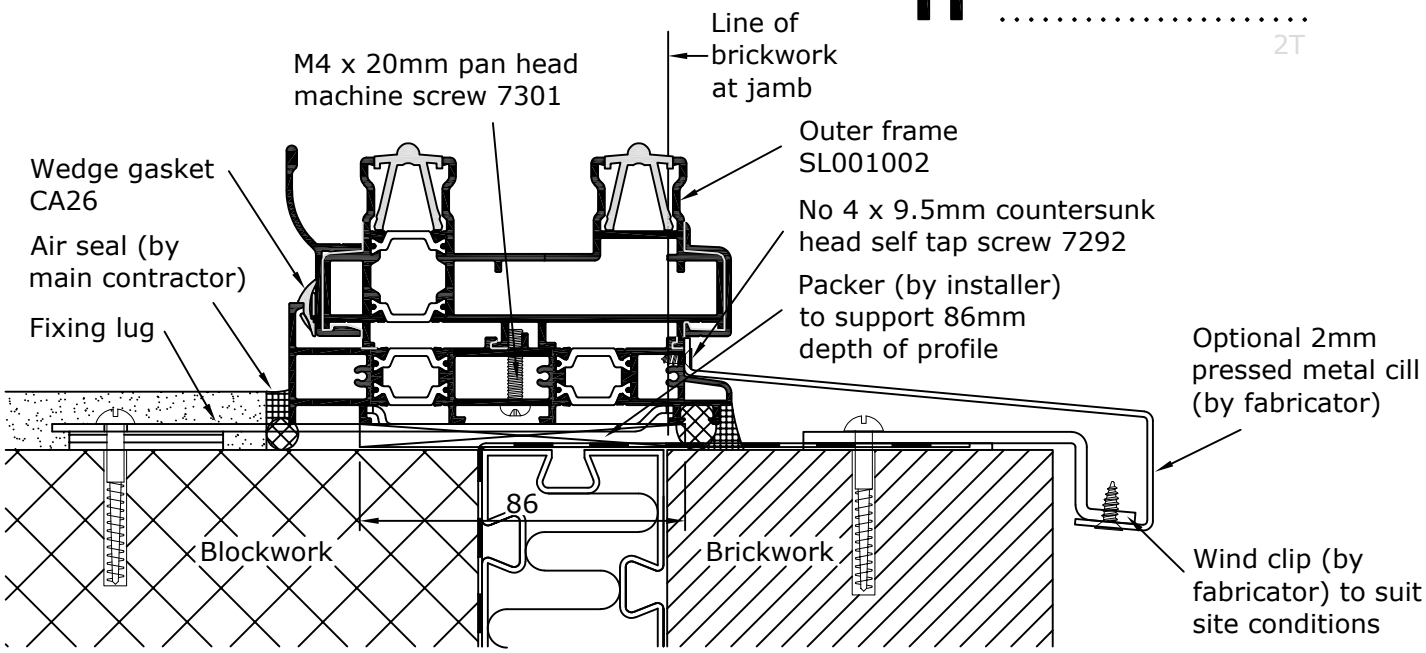
Not to scale

Typical Sub-Cill Detail

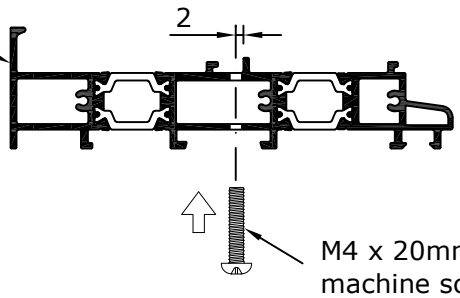
System 25 Hi/Hi+

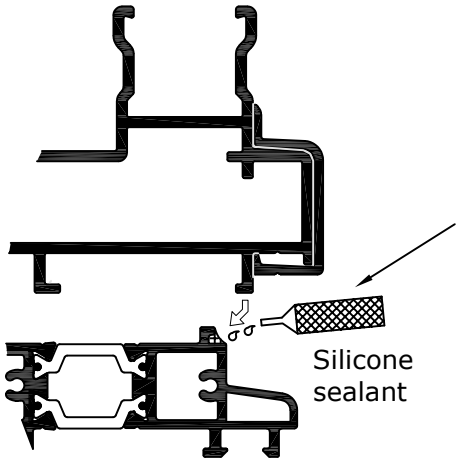
LIFT AND SLIDE DOOR

2T



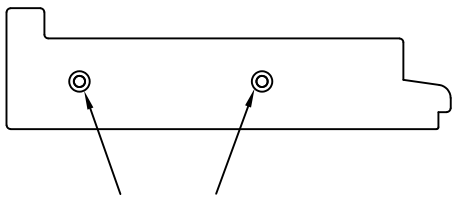
Drill and tap holes into cill SL104105106 to suit M4 screws, 75mm from each end and 75mm either side of the centre line of drainage blocks from SL058A interlock kit, and at not greater than 300mm centres.





Run bead of silicone along full length of cill as shown before attaching to outer frame SL001002

SL107 End cap (Black)



Holes to suit No 4 x 9.5mm countersunk self tapping stainless steel screw 7292

All sealants to be installed in strict accordance with manufacturers relevant details and BS 6093 to suit site conditions.

Scale 1:2

Glazing Details

Sash SL018016

System 25 Hi/Hi+

LIFT AND SLIDE DOOR

2T 3T

Note sash size and weight limitations apply - see graphs in section 3 of this manual.

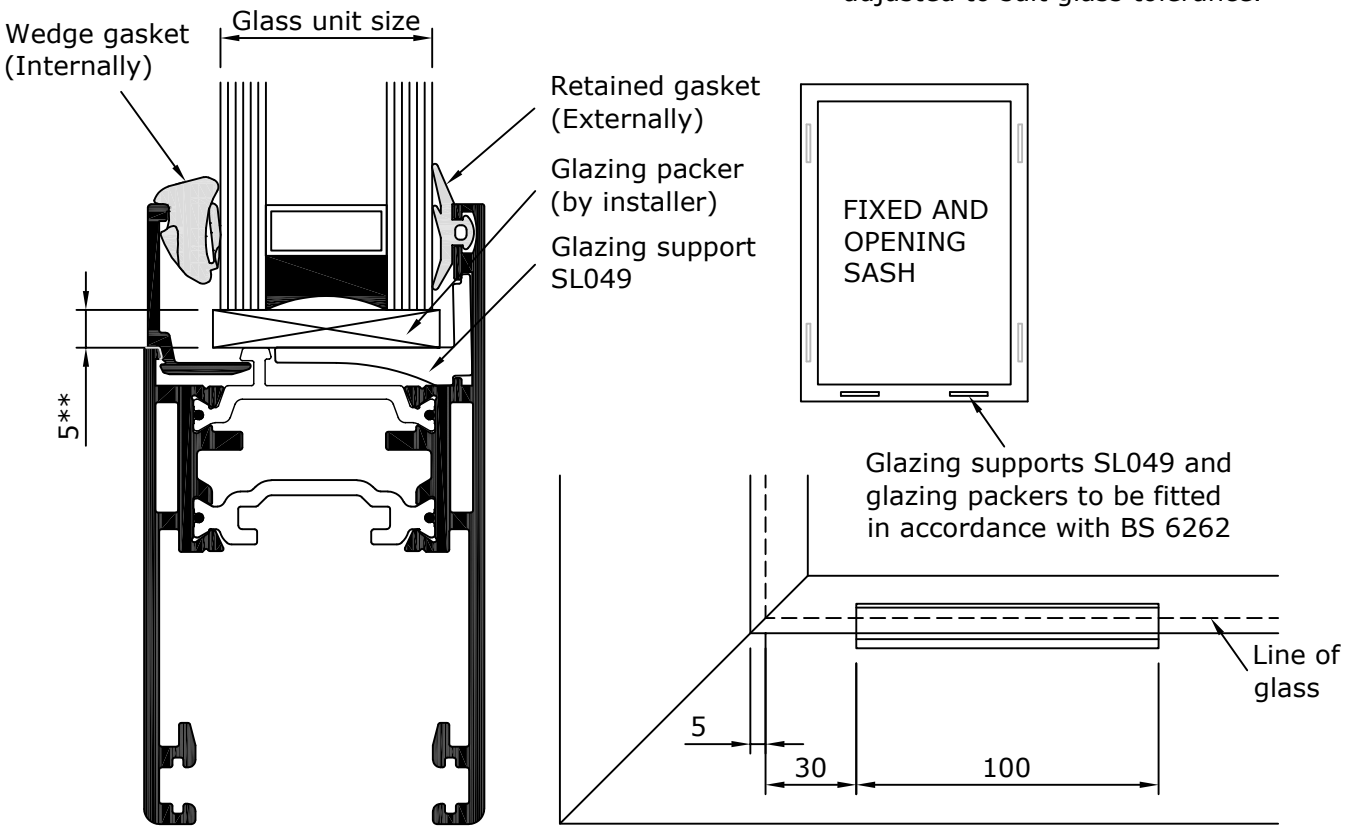
Metal Technology suggest that 745 glazing support/location blocks be fitted during factory fabrication.

Additional packers** to be installed on site during glazing.

In Hi+ applications 6743 glazing unit perimeter foam to abut glazing supports.

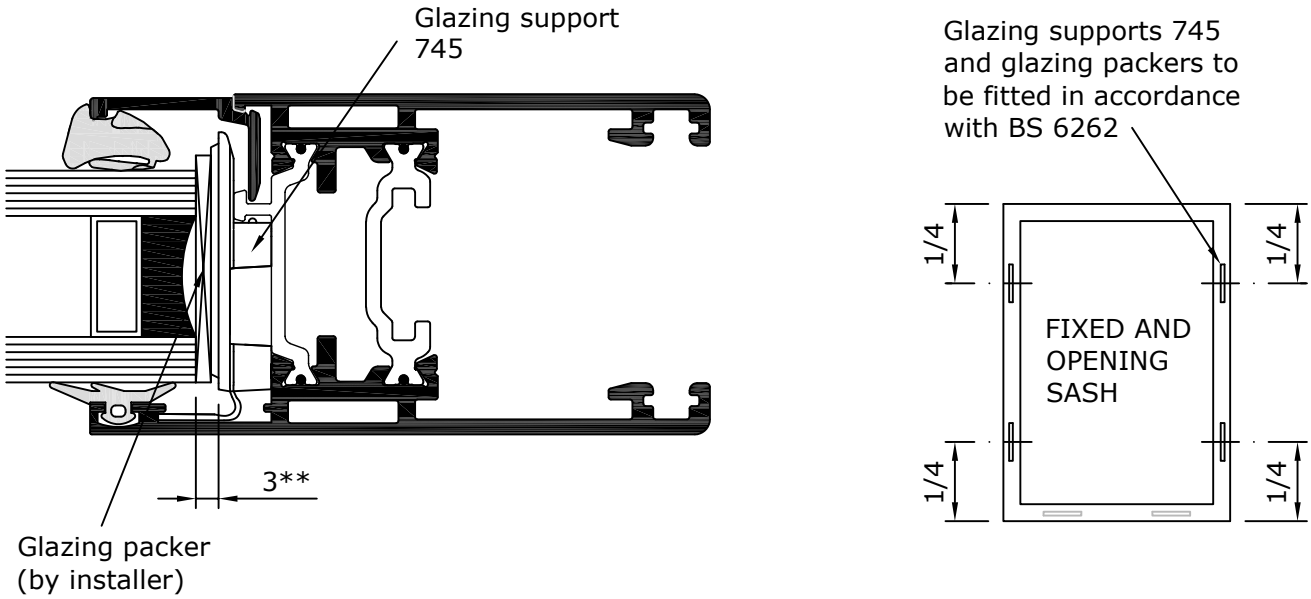
** Additional glazing packers by installer. Approximate thickness 3mm and 5mm, adjusted to suit glass tolerance.

CILL DETAIL



Scale 1:2

JAMB DETAIL



Scale 1:1

Glazing Details

Sashes SL129130 and SL131132

System 25 Hi/Hi+

LIFT AND SLIDE DOOR

2T

Note sash size and weight limitations apply - see graphs in section 3 of this manual.

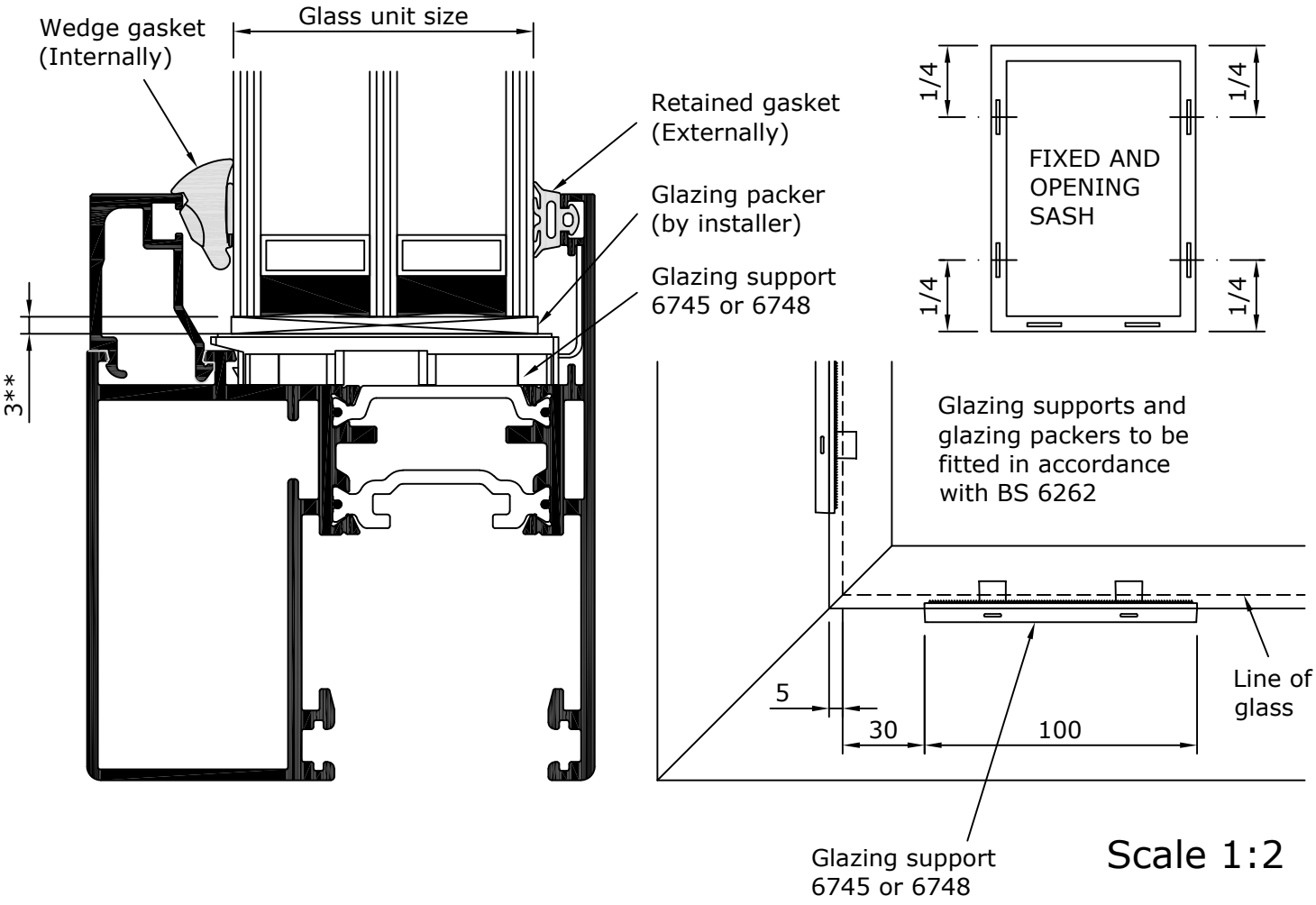
Metal Technology suggest that glazing support/location blocks be fitted during factory fabrication.

Refer to "Glazing Bead and Gasket Requirements" sheet for relevant glazing support reference.

Additional packers** to be installed on site during glazing.

In Hi+ applications 6727 glazing unit perimeter foam to abut glazing support.

** Additional glazing packers by installer. Approximate thickness 3mm and 5mm, adjusted to suit glass tolerance.



Scale 1:2

Scale 1:1

Glazing Bead and Gasket Requirements

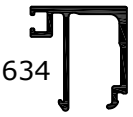
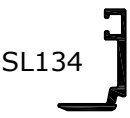
To suit standard sash SL018016:

Glazing unit size	External gasket	Internal gasket	Glazing bead
28mm	CA25 (red) / CA25A (black)	066 (grey)	SL017 
30mm	PCD82 (black)	CA27 (white)	SL017 

These unit sizes (i.e. 28mm to 55mm) are based on nominal sizes. Where glazing unit tolerance is at its extreme (±0.5mm) or where alternative glass thicknesses are being considered the gasket/bead/section combination should be physically checked on a sample window.

For thicker glazing unit sizes than those indicated, refer to Metal Technology's technical department.

To suit heavy duty sashes SL129130 and SL131132:

Glazing unit size	External gasket	Internal gasket	Glazing support	Glazing bead	
				Square	Raked
28mm 29mm 30mm 31mm	6080 (purple) 6080 (purple) 6081 (black) 6081 (black)	CA27 (white) PTT36 (red) CA27 (white) PTT36 (red)	6745	628 	623 
32mm 33mm 34mm 35mm	6080 (purple) 6080 (purple) 6081 (black) 6081 (black)	CA27 (white) PTT36 (red) CA27 (white) PTT36 (red)		634 	635 
36mm 37mm 38mm 39mm	6080 (purple) 6080 (purple) 6081 (black) 6081 (black)	CA27 (white) PTT36 (red) CA27 (white) PTT36 (red)		636 	644 
40mm 41mm 42mm 43mm	6080 (purple) 6080 (purple) 6081 (black) 6081 (black)	CA27 (white) PTT36 (red) CA27 (white) PTT36 (red)		645 	646 
44mm 45mm 46mm 47mm	6080 (purple) 6080 (purple) 6081 (black) 6081 (black)	CA27 (white) PTT36 (red) CA27 (white) PTT36 (red)		653 	654 
48mm 49mm 50mm 51mm	6080 (purple) 6080 (purple) 6081 (black) 6081 (black)	CA27 (white) PTT36 (red) CA27 (white) PTT36 (red)	6748	SL133 	
52mm 53mm 54mm 55mm	6080 (purple) 6080 (purple) 6081 (black) 6081 (black)	CA27 (white) PTT36 (red) CA27 (white) PTT36 (red)		SL134 	

Not to Scale

Weatherseal Application Details

System 25 Hi/Hi+

LIFT AND SLIDE DOOR

2T 3T

Gasket 6080, 6081, CA25, CA25A or PCD82 (Outside) Wedge 066 or CA27 (Inside)

CA25 must be inserted into sash profiles prior to crimping.

Cut 6080, 6081, CA25/CA25A or PCD82 gasket into four individual lengths with mitred corners and fit into section grooves. See detail below for fitting direction. Bond gasket corners using cyanoacrylate (superglue) adhesive.

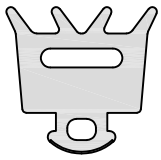
Metal Technology recommend installers apply HR50328A sealant to the mating surface of the gasket with the glass, of the mitred corners, on site immediately prior to offering up the glazing units.

After locating glass and inserting bead, cut wedge gasket into four individual lengths and push fit between profile and glazing unit. Corners and joints to be sealed using HR50328A sealant as indicated.

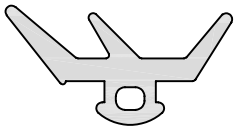
Gaskets must not be stretched and should be cut 1-3% oversize as required to accommodate shrinkage. When oversizing the gasket to accommodate any anticipated potential shrinkage, fabricators should ensure gasket is not installed so that it remains wrinkled. While it is preferable that gaskets be installed too long rather than too short, excessive wrinkles or distortion should be avoided once the gasket has had an opportunity to settle into its natural state within its final intended environment.

Where gaskets are supplied in a bag, the bag should be re-sealed to prevent drying out. Should gaskets become dry and difficult to apply, they can be re-lubricated using 7400 silicone spray as they are inserted into the window frames.

Gasket 6080 or 6081 (Outside)



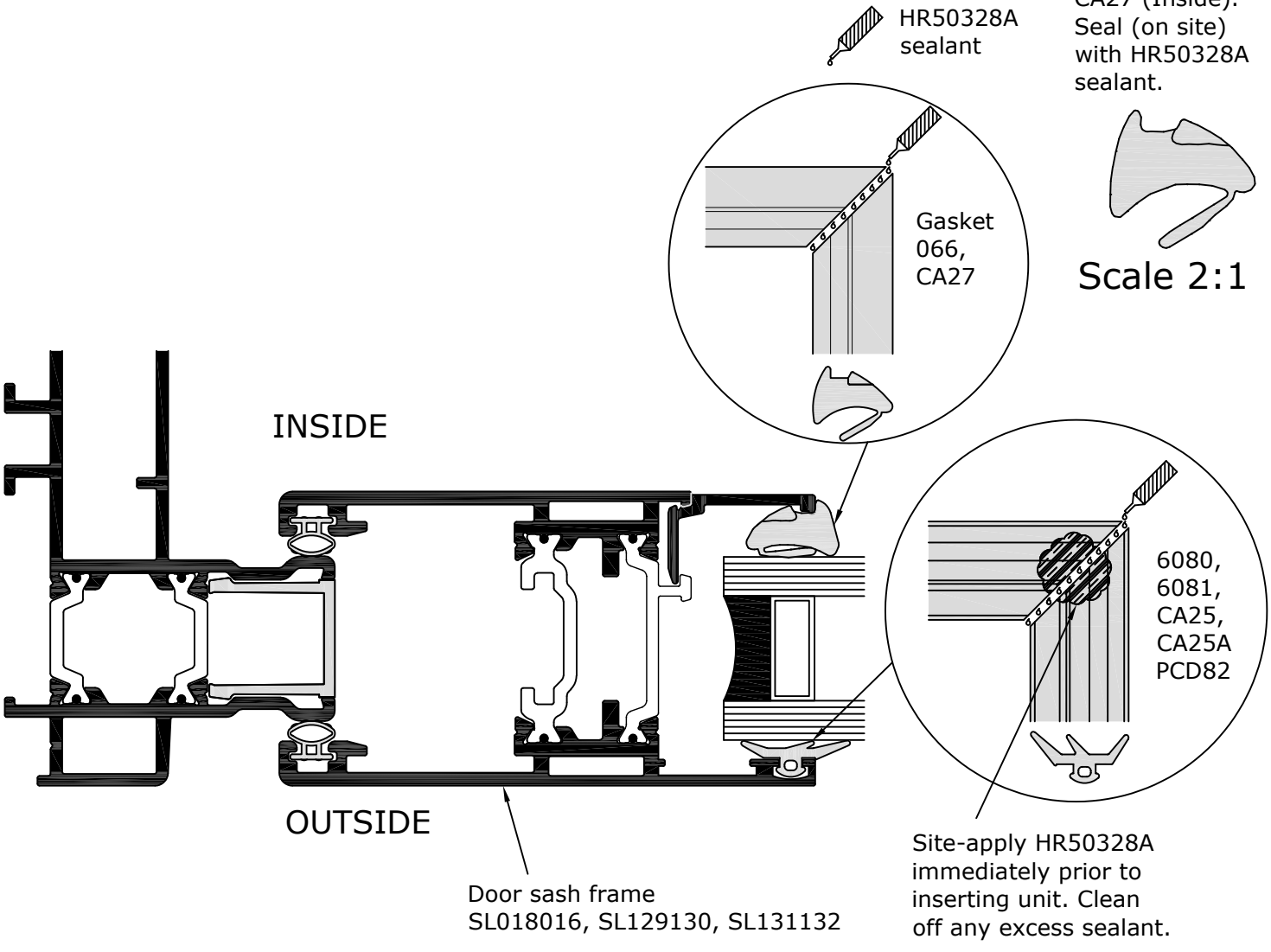
Gasket CA25, CA25A (Outside)



Gasket PCD82 (Outside)

Wedge 066 or CA27 (Inside). Seal (on site) with HR50328A sealant.

Scale 2:1



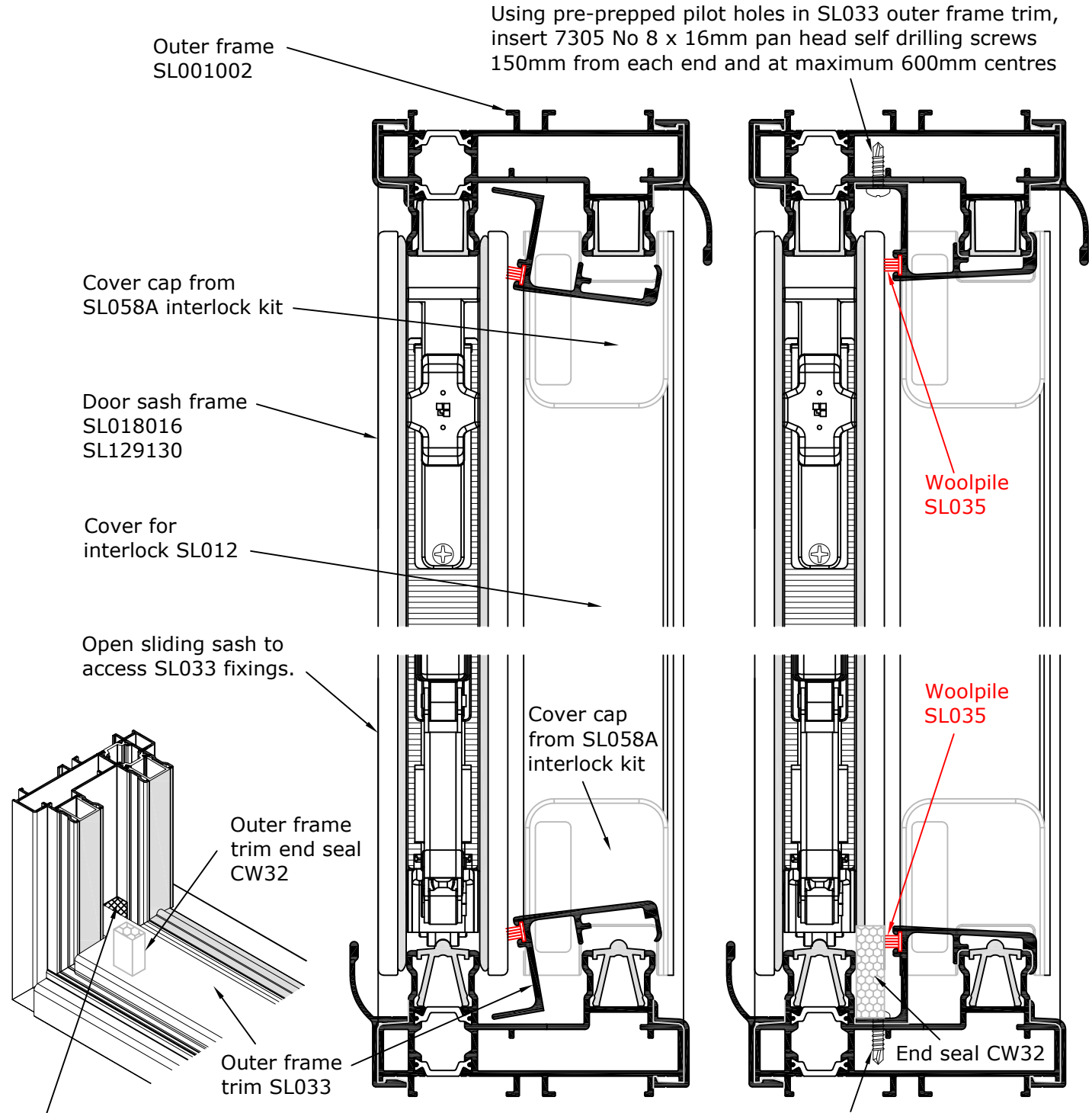
Scale 1:1

Outer Frame Trim SL033 Installation

System 25 Hi/Hi+
LIFT AND SLIDE DOOR

If SL033 is pre-cut to size in factory, adjust sash opening to suit profile. If SL033 has been cut oversize in factory measure opening '**Dim x**' , reduce by 1mm and cut to suit on site. Refer to "Outer Frame Trim SL033 Prep Details" sheet. Insert SL035 woolpile into SL033 outer frame trim and cut woolpile 12mm over size for 2 and 3 pane doors and 24mm over size in 4 pane applications.

Fit SL033 at head and cill using 7305 No 8 x 16mm pan head self drilling screws at pre-drilled hole positions in SL033 and silicone seal the ends as shown.



Apply adhesive prior to CW32 insertion

Apply cyanacrylate adhesive (superglue) to vertical surface of jamb outer frame for height of SL033 trim. Insert CW32 outer frame trim end seal between sash and outer frame profile, flush with top surface of SL033 trim.

Using pre-prepped pilot holes in SL033 outer frame trim, insert 7305 No 8 x 16mm pan head self drilling screws 150mm from each end and at maximum 600mm centres

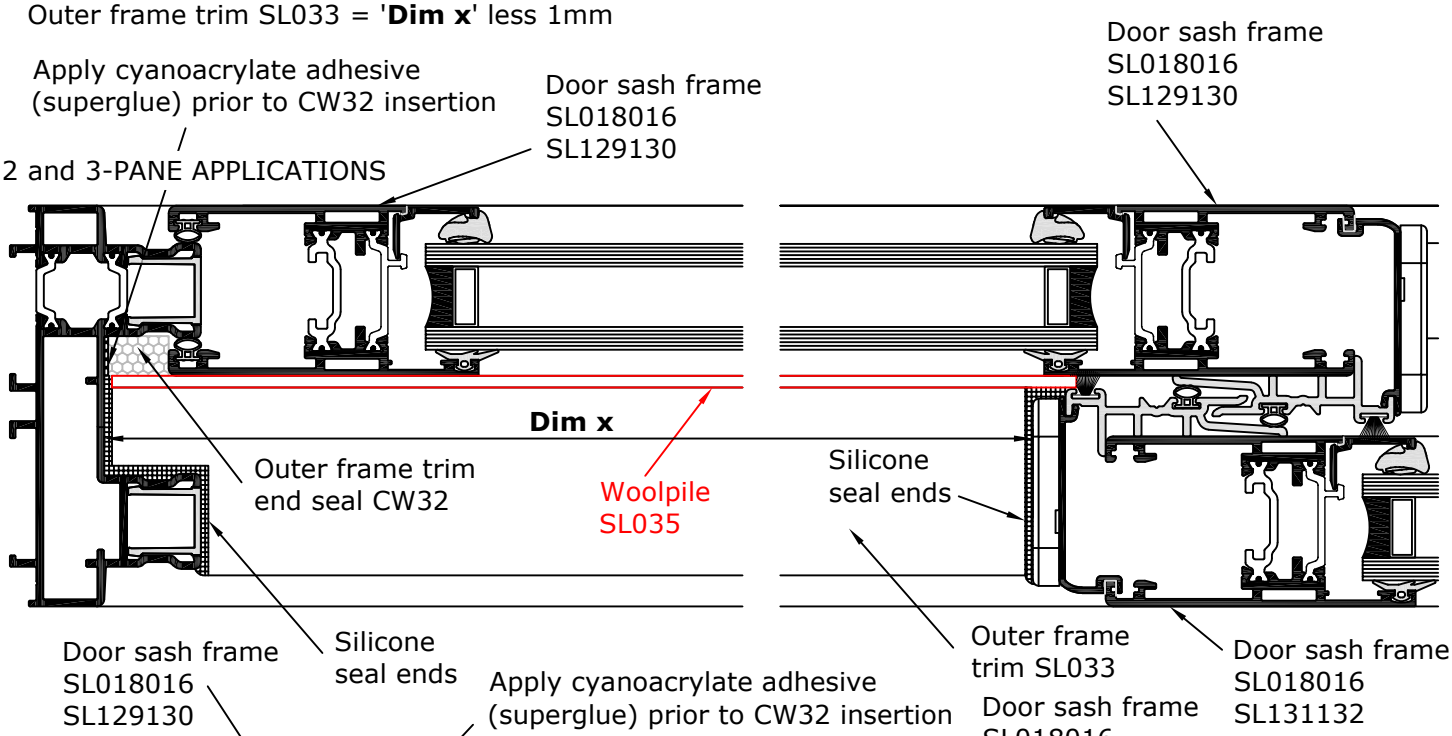
Not to Scale

Outer Frame Trim SL033 Installation

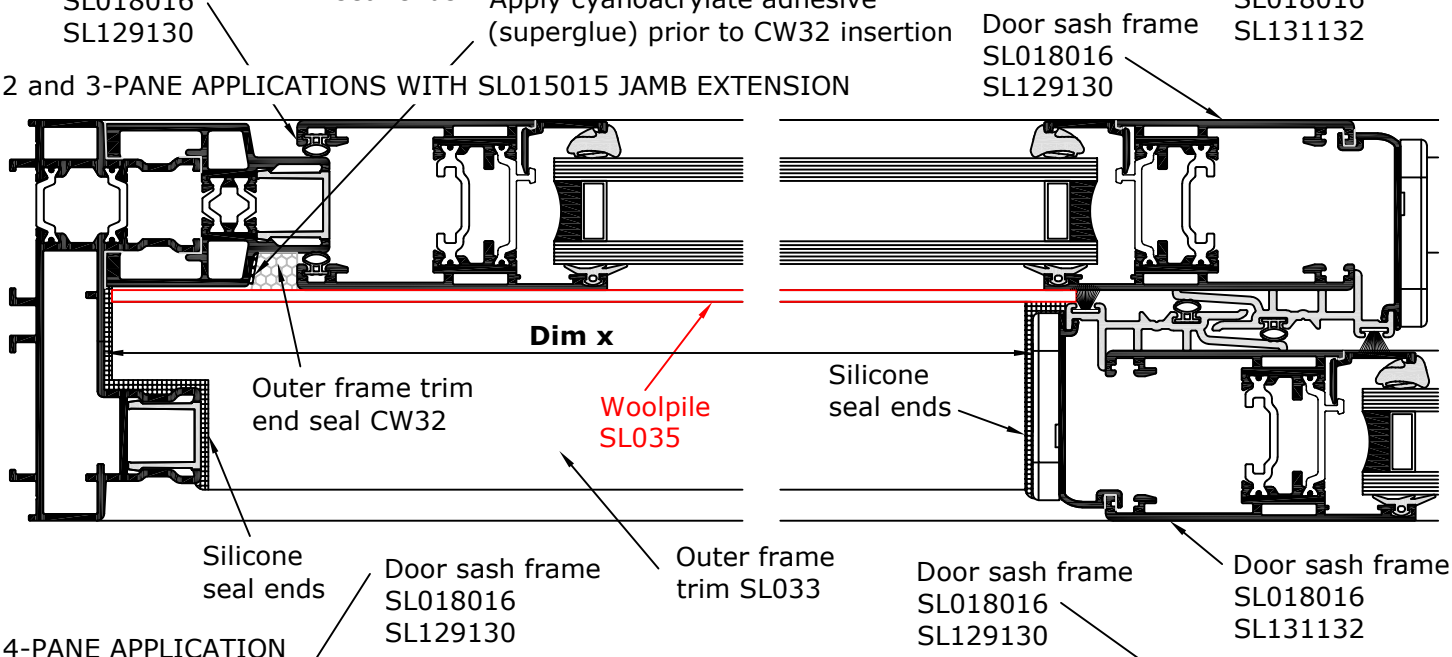
cont...

Outer frame trim SL033 = '**Dim x**' less 1mm

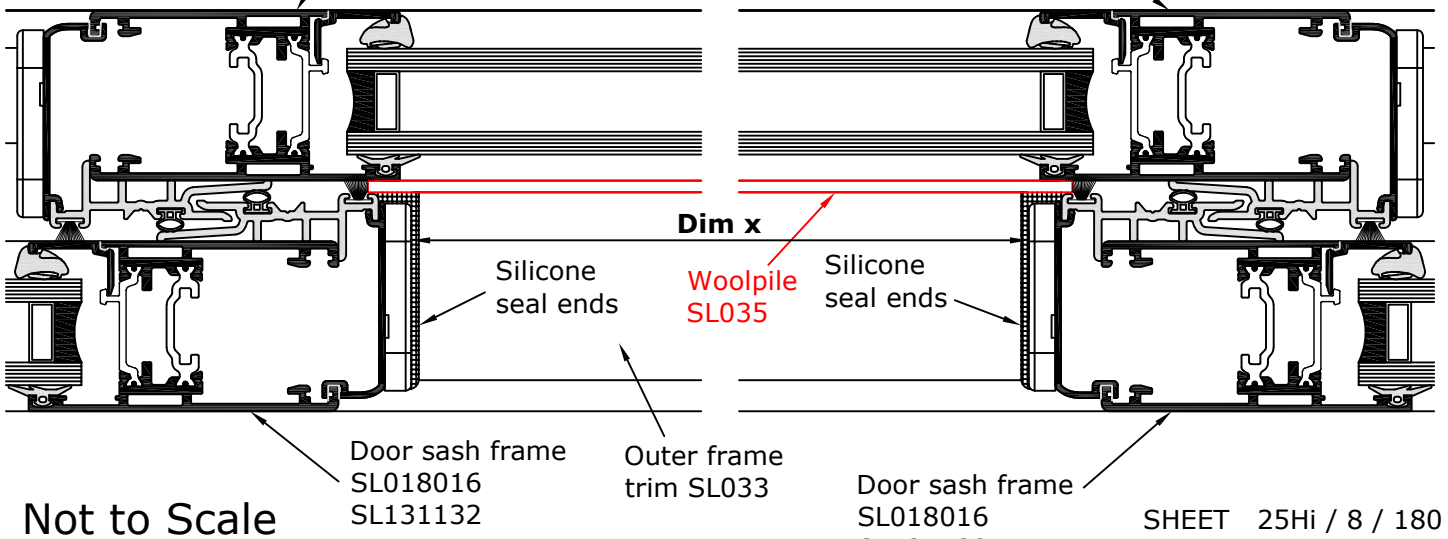
2 and 3-PANE APPLICATIONS



2 and 3-PANE APPLICATIONS WITH SL015015 JAMB EXTENSION



4-PANE APPLICATION



Not to Scale

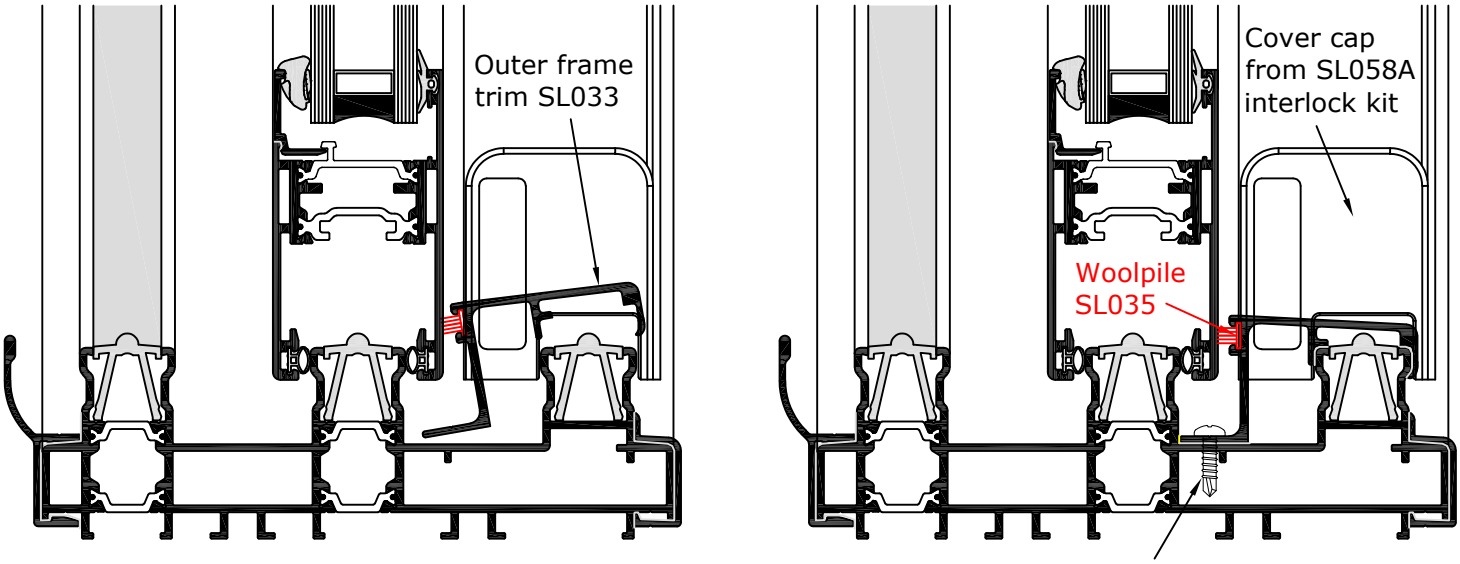
Outer Frame Trim SL033 and SL036 Installation

System 25 Hi/Hi+

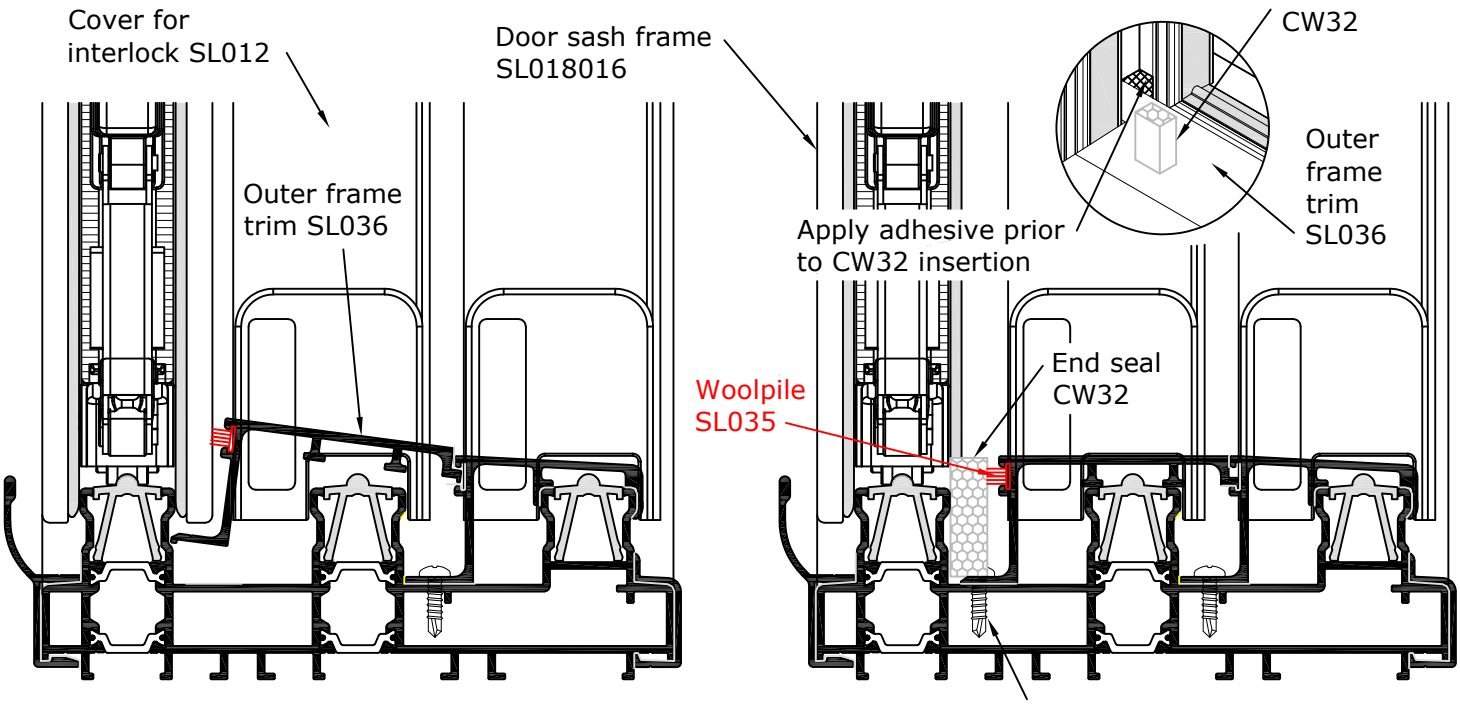
LIFT AND SLIDE DOOR

If SL033 and SL036 are pre-cut to size in factory, adjust sash opening to suit profile. If SL033 and SL036 have been cut oversize in factory measure opening '**Dim x**' and '**Dim y**', reduce by 1mm and cut to suit on site. Refer to "Outer Frame Trim SL033 and SL036 Prep Details" sheet. Insert SL035 woolpile into SL036 outer frame trim cut woolpile 12mm over size. Insert SL035 woolpile into SL033 outer frame trim cut woolpile using calculation **Dim y** less **Dim x** plus 12mm.

Open sliding sashes and fit SL033 at **head** and **cill** using 7305 No 8 x 16mm pan head self drilling screws at pre-drilled hole positions in SL033 and silicone seal the ends as shown. Then fit SL036 at **head** and **cill** using 7305 No 8 x 16mm pan head self drilling screws at pre-drilled hole positions in SL036 and silicone seal the ends as shown.



Using pre-prepped pilot holes in SL033 outer frame trim, insert 7305 No 8 x 16mm pan head self drilling screws 150mm from each end and at maximum 600mm centres



Using pre-prepped pilot holes in SL036 outer frame trim, insert 7305 No 8 x 16mm pan head self drilling screws 150mm from each end and at maximum 600mm centres

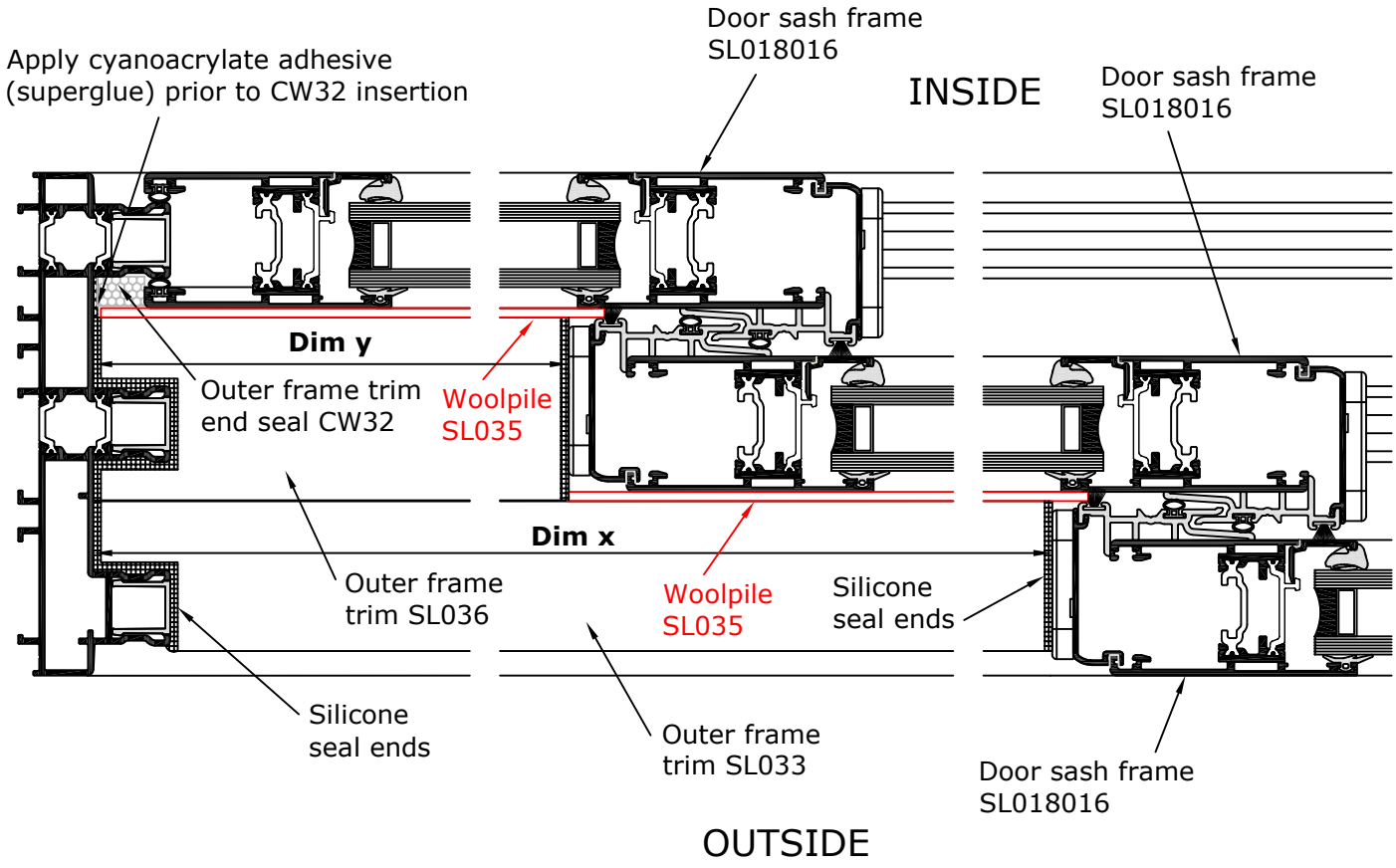
Apply cyanacrylate adhesive (superglue) to vertical surface of jamb outer frame for height of SL036 trim. Insert CW32 outer frame trim end seal between sash and outer frame profile, flush with top surface of SL036 trim.

Not to Scale

Outer Frame Trim SL033 and SL036 Installation

cont...

Outer frame trim SL033 = '**Dim x**' less 1mm
Outer frame trim SL036 = '**Dim y**' less 1mm



Not to Scale

Typical Cill Detail

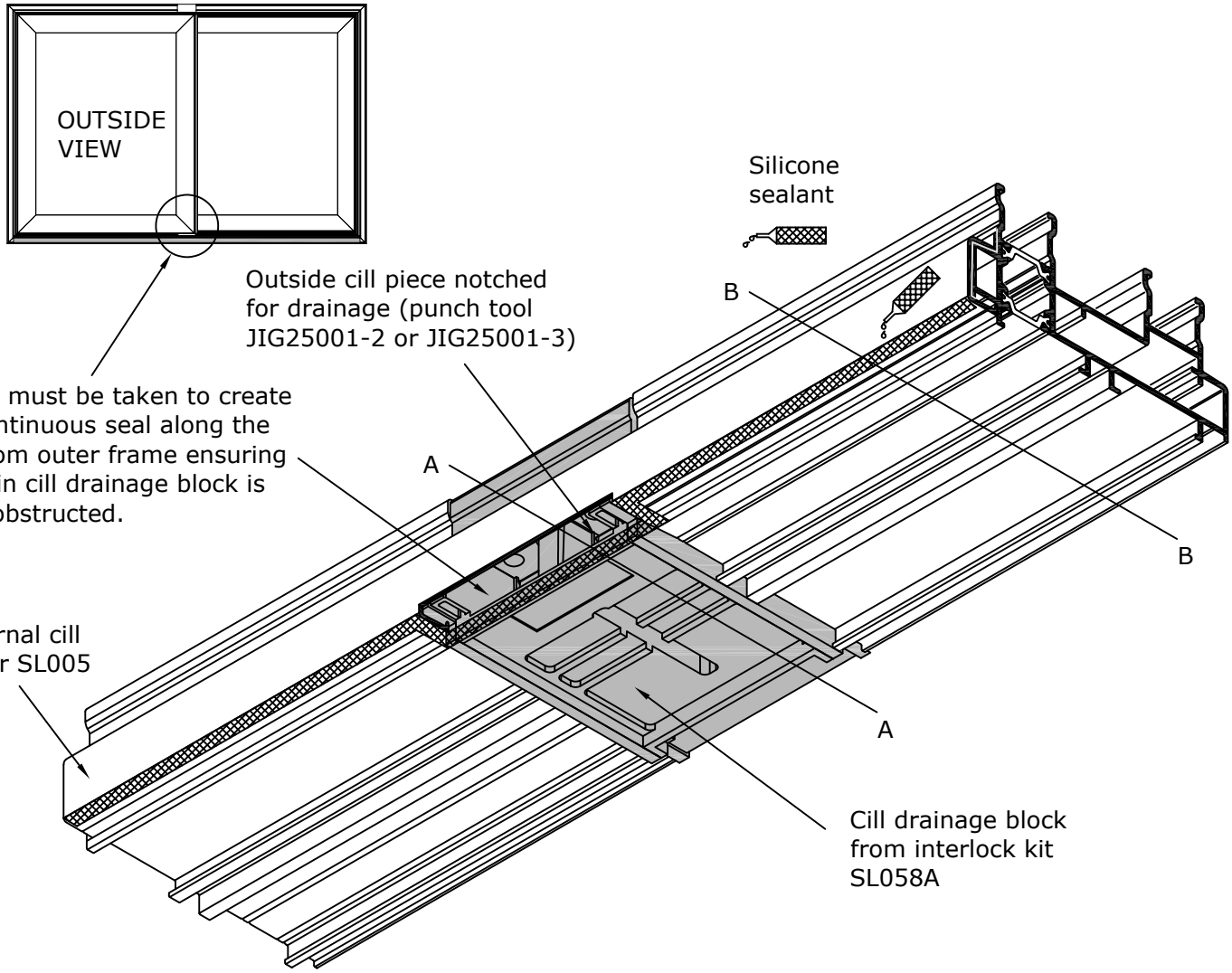
Perimeter Interface

System 25 Hi/Hi+

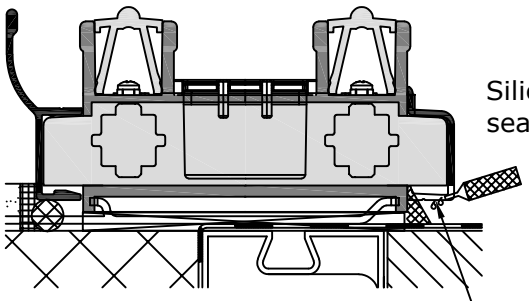
LIFT AND SLIDE DOOR

2T

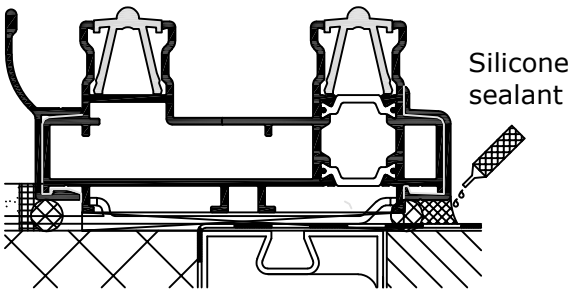
Apply a suitable sealant to the perimeter of the outer frame as per the sealant manufacturers recommendations and instructions. Care must be taken not to seal drainage route below cill drainage block from SL058A interlock kit. Any excess sealant should be removed so as not to detract from the finished product/installation.



SECTION A-A



SECTION B-B



Not to scale

Typical Cill Detail

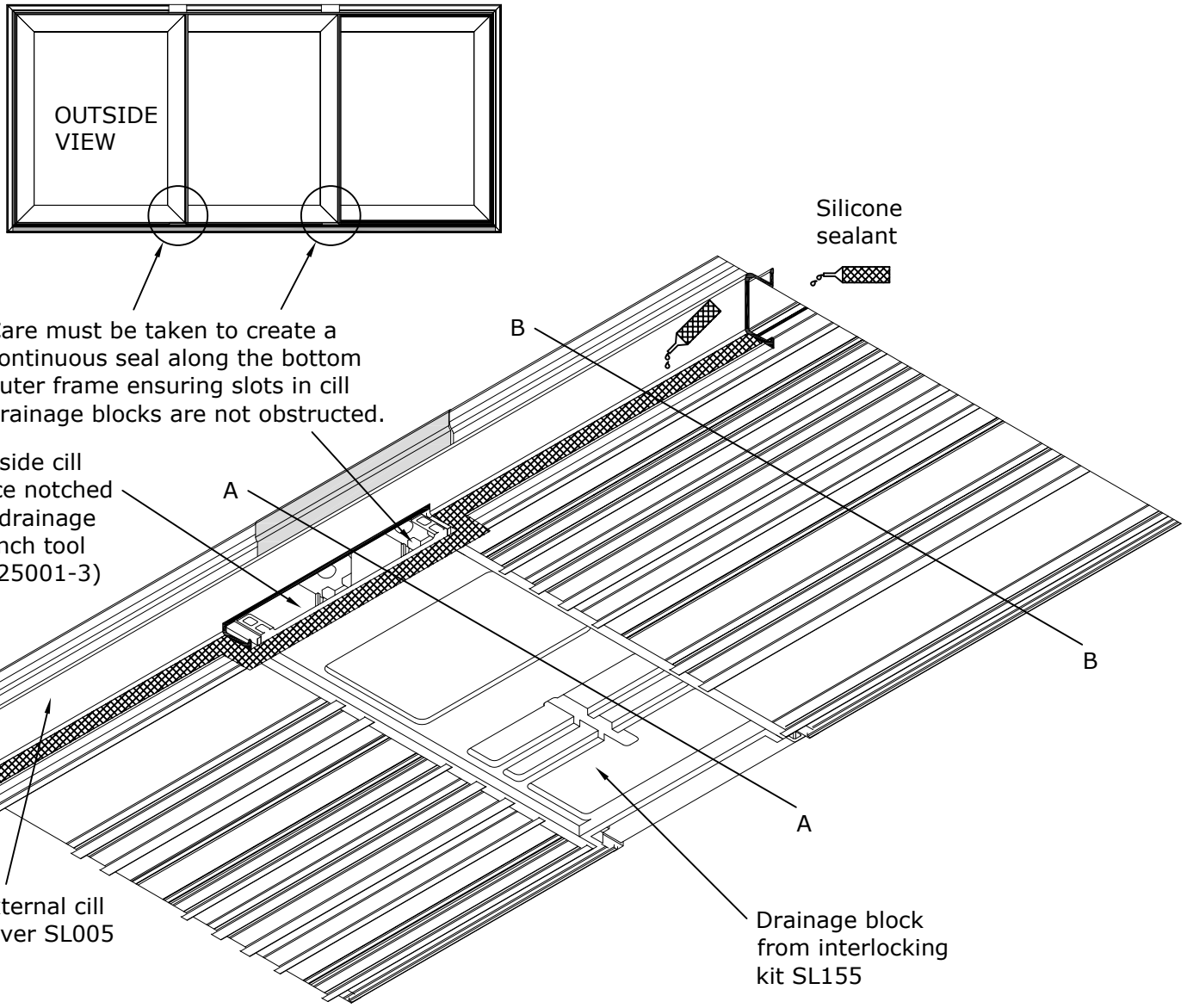
Perimeter Interface

System 25 Hi/Hi+

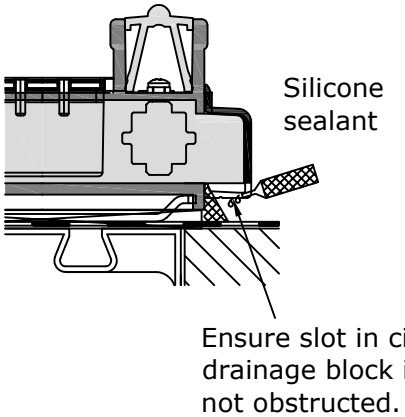
LIFT AND SLIDE DOOR

3T

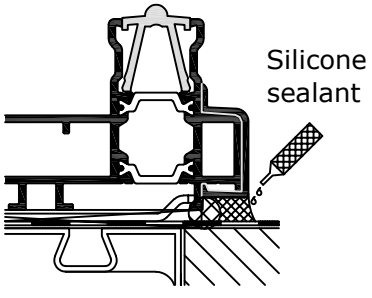
Apply a suitable sealant to the perimeter of the outer frame as per the sealant manufacturers recommendations and instructions. Care must be taken not to seal drainage route below cill drainage block from SL155 interlock kit. Any excess sealant should be removed so as not to detract from the finished product/installation.



SECTION A-A



SECTION B-B



Not to scale

Typical Sub-Cill Detail

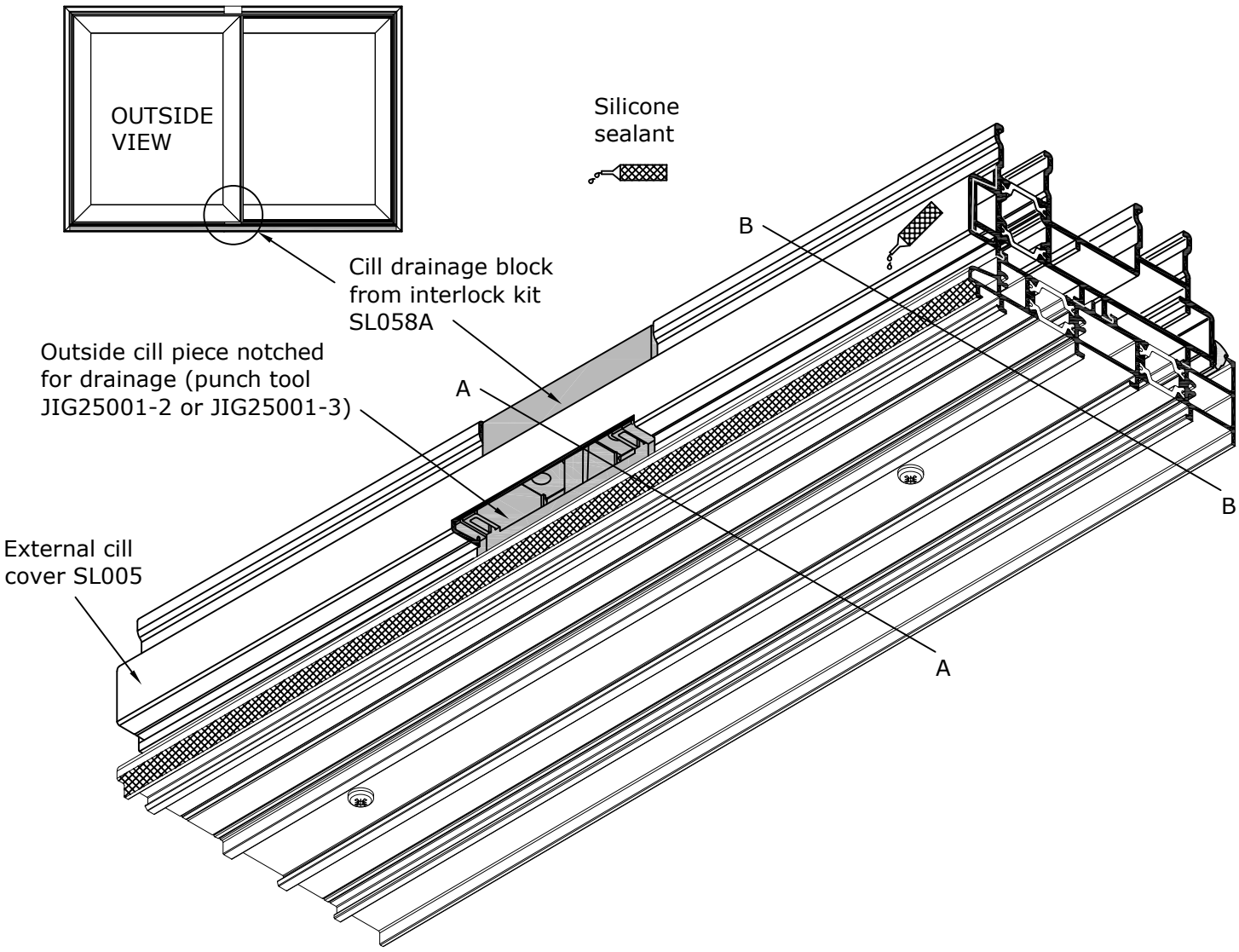
Perimeter Interface

System 25 Hi/Hi+

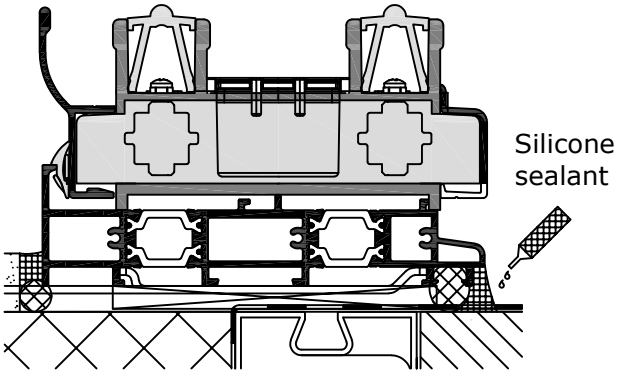
LIFT AND SLIDE DOOR

2T

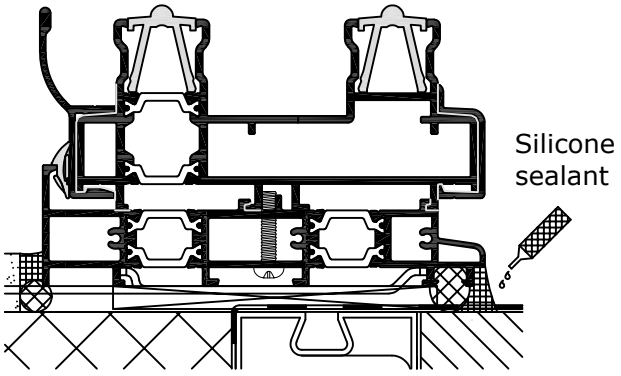
Apply a suitable sealant to the perimeter of the outer frame as per the sealant manufacturers recommendations and instructions. Care must be taken not to seal drainage route below cill drainage block from SL058A interlock kit. Any excess sealant should be removed so as not to detract from the finished product/installation.



SECTION A-A



SECTION B-B



Not to scale

Operating Instructions

Internal Lever Handle Only (SL051/SL072)

System 25 Hi/Hi+

LIFT AND SLIDE DOOR

2T 3T

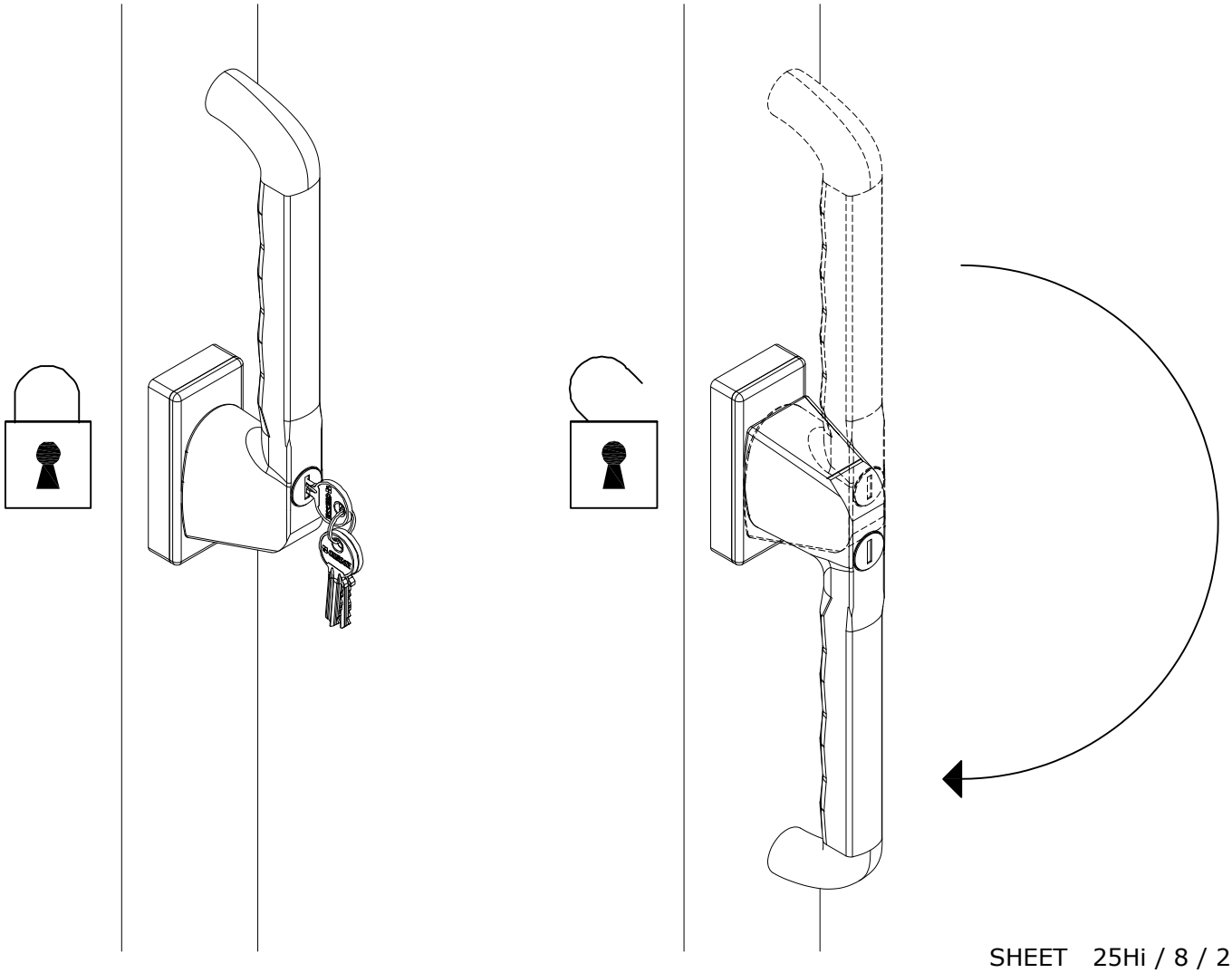
2 and 3 pane lift and slide door

When sliding master leaf is closed and the handle is at 12 o'clock the door is secured. Handle can be locked in secure position using key. To open the sliding master leaf unlock handle using key and rotate to 6 o'clock position to release sash. Pull sash via handle to slide open. While handle remains at the 6 o'clock position the opening master leaf can slide open or closed using the internal lever handle or optional external 'D' shaped pull handle. To secure door push sliding master leaf to closed position and return handle to 12 o'clock position to secure leaf. Lock handle by turning key.
In triple track applications when middle pane is also to be opened, unlock both sashes as described above. Pull master leaf until it catches middle sash, opening both sashes simultaneously. To secure doors push master leaf until it catches middle sash, sliding both sashes closed. Return both handles to 12 o'clock position to secure leaves. Lock handles by turning keys.

4 pane lift and slide door

When central sliding leaves are closed and the handles are at 12 o'clock the door is secured. Handles can be locked in secure position using key. To open doors unlock master leaf handle using key. Rotate handle on master leaf to 6 o'clock position to release sash and slide open. While handle remains at the 6 o'clock position the master leaf can slide open or closed using the internal lever handle or optional external 'D' shaped pull handle. To open slave leaf repeat process. However please note that the slave leaf cannot be opened until after the master leaf has been opened. The master leaf is the leaf containing the operational locking mechanism. The slave leaf is the leaf containing the fixed keeps.

To close doors first slide slave leaf to closed position and return handle to 12 o'clock to secure leaf. Slide master leaf to closed position and return handle to 12 o'clock position to secure. Check, by attempting to pull both leaves apart, that doors are secured. Lock handles using key.



Operating Instructions

Internal and External Lever Handles (TTGEAR615)

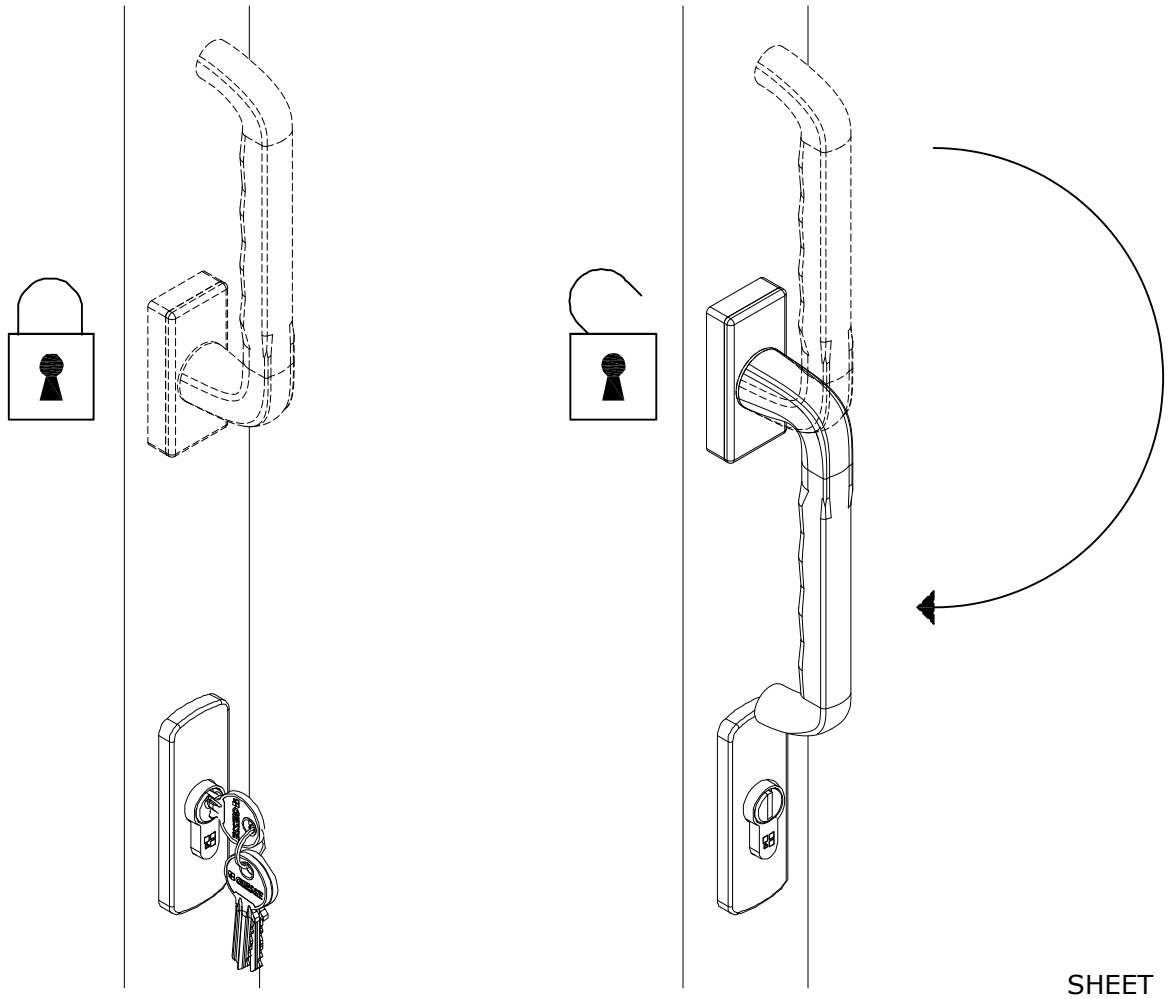
2 and 3 pane lift and slide door

When sliding master leaf is closed and the handle is at 12 o'clock the door is secured. Door can be locked in secure position using key into the cylinder from the internal or external side. To open the sliding master leaf unlock door using key. Rotate handle to 6 o'clock position to release sash. Pull sash via handle to slide open. While handle remains at the 6 o'clock position the master opening leaf can slide open or closed using the internal or external lever handle. To secure door push sliding master leaf to closed position and return handle to 12 o'clock position. Lock door by turning key in cylinder.
In triple track applications open sliding master leaf as above. Open middle leaf by unlocking SL051 handle using key and rotate to 6 o'clock position to release sash. Pull master leaf until it catches middle sash, opening both sashes simultaneously. To secure doors push master leaf until it catches middle sash, sliding both sashes closed. Return both handles to 12 o'clock position to secure leaves. Lock handles by turning keys.

4 pane lift and slide door

When central sliding leaves are closed and the handles are at 12 o'clock the door is secured. Doors can be locked in secure position using key into the cylinder from the internal or external side. To open doors unlock master leaf using key. Rotate handle on master leaf to 6 o'clock position to release sash and slide open. While handle remains at the 6 o'clock position the master leaf can slide open or closed using the internal or external lever handle. To open slave leaf repeat process. However please note that the slave leaf cannot be opened until after the master leaf has been opened. The master leaf is the leaf containing the operational locking mechanism. The slave leaf is the leaf containing the fixed keeps and has no external handle.

To close doors first slide slave leaf to closed position and return handle to 12 o'clock position. Slide master leaf to closed position and return handle to 12 o'clock position. Check, by attempting to pull both leaves apart, that doors are secured. Lock both sashes by turning key in cylinders.



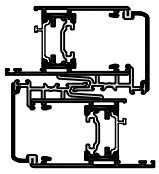
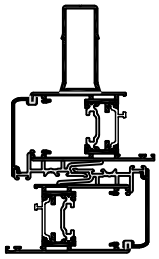
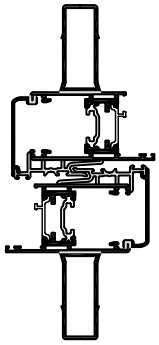
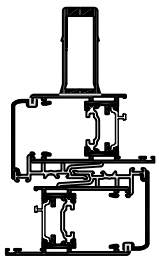
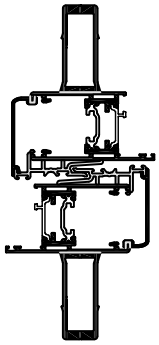
Structural Properties

System 25 Hi/Hi+

LIFT AND SLIDE DOOR

2T 3T

Select values according to span
All structural values in cm^4
Calculation of composite Ixx values based on BS EN 14024

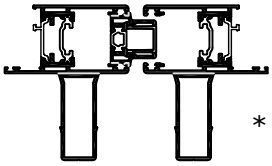
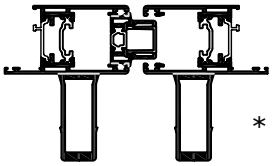
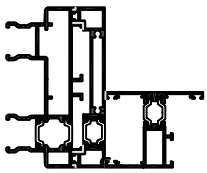
Section		Ixx values (cm^4) based on span in metres				Iyy values (cm^4)
Representative profile drawing	Section Number	1 to 1.5m	1.5 to 2m	2 to 2.5m	2.5 to 2.8m	All spans
	SL018016 SL018016	39.40	44.30	47.30	49.20	48.70
 Stiffener may alternatively be fitted to outside only.	007 SL018016 SL018016	79.30	89.40	95.80	100.00	51.60
	007 SL018016 SL018016 007	126.00	141.30	151.20	157.80	54.60
 Stiffener may alternatively be fitted to outside only.	008 SL018016 SL018016	90.87	101.30	108.10	112.60	52.30
	008 SL018016 SL018016 008	149.20	165.20	175.70	182.80	55.90

Scale 1:5

Structural Properties

System 25 Hi/Hi+
LIFT AND SLIDE DOOR
2T

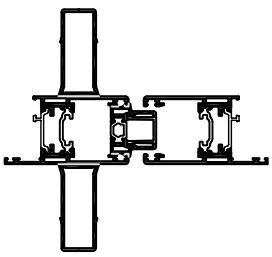
Select values according to span
All structural values in cm^4
Calculation of composite Ixx values based on BS EN 14024

Section		Ixx values (cm^4) based on span in metres				Iyy values (cm^4)
Representative profile drawing	Section Number	1 to 1.5m	1.5 to 2m	2 to 2.5m	2.5 to 2.8m	All spans
	SL018016 SL004004 SL018016	28.00	33.10	36.20	38.20	49.00
 *	SL018016 SL018016 SL004004 007 007	119.10	134.40	144.30	150.90	52.00
 *	SL018016 SL018016 SL004004 008 008	142.30	158.30	168.90	175.90	55.00
	SL013014	49.38	53.18	55.42	56.78	1.63
	SL001002 SL013014 102-202	119.45**	129.85**	136.33**	140.24**	18.17**

*Not suitable for use with external handles.

**Use these values only where the adjoining outer frames of System 25 Hi/Hi+ and window are attached to the coupling mullion over the full height of the coupling mullion.

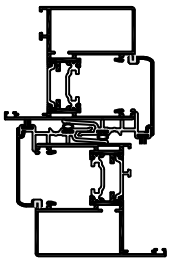
This detail applies to 3-pane (Fixed/Lift and Slide/Fixed) application only.

Section		Ixx values (cm^4) based on span in metres				Iyy values (cm^4)
Representative profile drawing	Section Number	1 to 1.5m	1.5 to 2m	2 to 2.5m	2.5 to 2.8m	All spans
	SL018016 SL018016 SL004004 007 007	136.00	160.00	177.00	190.00	50.00

Scale 1:5

Structural Properties

Select values according to span
All structural values in cm^4
Calculation of composite Ixx values based on BS EN 14024

Section		Ixx values (cm^4) based on span in metres				Iyy values (cm^4)
Representative profile drawing	Section Number	1 to 1.5m	1.5 to 2m	2 to 2.5m	2.5 to 2.8m	All spans
	SL129130 SL131132	69.12	81.69	90.02	93.61	71.69

Scale 1:5

System 25 Hi/Hi+ - Lift and Slide Door

APPENDIX

Section 0: Specification, Profile Index and Component ID

25Hi/0/10 rev 14	Specification Hi/Hi+
25Hi/0/20 rev 6	Specification Hi/Hi+
25Hi/0/30 rev 19	Profile Index Hi/Hi+
25Hi/0/40 rev 23	Component Identification Hi/Hi+
25Hi/0/41 rev 0	Component Identification Hi/Hi+
25Hi/0/50 rev 34	Component Identification Hi/Hi+
25Hi/0/60 rev 14	Component Identification Hi/Hi+
25Hi/0/70 rev 7	Component Identification Hi+
25Hi/0/80 rev 7	Component Identification Hi/Hi+
25Hi/0/90 rev 14	Component Identification Hi/Hi+

Section 1: Section Drawings

25Hi/1/10 rev 16	Section Drawings Hi/Hi+
25Hi/1/11 rev 0	Section Drawings Hi/Hi+
25Hi/1/15 rev 2	Section Drawings Hi/Hi+
25Hi/1/20 rev 15	Section Drawings Hi/Hi+
25Hi/1/30 rev 3	Section Drawings Hi/Hi+
25Hi/1/40 rev 2	Section Drawings Hi/Hi+

Section 2: General Arrangement Drawings

25Hi/2/10 rev 18	General Arrangement - 25Hi 3-Dimensional Assembly Detail, 25Hi+ 3-Dimensional Assembly Detail Hi/Hi+
25Hi/2/15 rev 1	General Arrangement - 25Hi 3-Dimensional Assembly Detail, 25Hi+ 3-Dimensional Assembly Detail Hi/Hi+
25Hi/2/17 rev 0	General Arrangement - 25Hi 3-Dimensional Assembly Detail Hi/Hi+
25Hi/2/20 rev 19	General Arrangement - 1 Pane Lift and Slide / 1 Pane Fixed (Inside pane sliding with internal handle) Hi
25Hi/2/25 rev 2	General Arrangement - 1 Pane Lift and Slide / 1 Pane Fixed (Inside pane sliding with internal handle) Hi
25Hi/2/30 rev 21	General Arrangement - 1 Pane Lift and Slide / 1 Pane Fixed (Inside pane sliding with internal and external handles) Hi
25Hi/2/40 rev 18	General Arrangement - Lift and Slide / Fixed / Fixed (Inside pane sliding with internal handle) Hi
25Hi/2/45 rev 0	General Arrangement - Lift and Slide / Fixed / Fixed (Inside pane sliding with internal handle) Hi
25Hi/2/50 rev 20	General Arrangement - Lift and Slide / Fixed / Fixed (Inside pane sliding with internal and external handles) Hi
25Hi/2/60 rev 17	General Arrangement - Fixed / Lift and Slide / Fixed Hi
25Hi/2/65 rev 1	General Arrangement - Fixed / Lift and Slide / Fixed Hi
25Hi/2/66 rev 0	General Arrangement - Triple Track Lift and Slide Door Hi
25Hi/2/67 rev 0	General Arrangement - Triple Track Lift and Slide Door Hi

25Hi/2/68 rev 0	General Arrangement - Triple Track Lift and Slide Door (Internal handle) Hi
25Hi/2/69 rev 0	General Arrangement - Triple Track Lift and Slide Door (Internal and external handles) Hi
25Hi/2/70 rev 16	General Arrangement - Fixed / Lift and Slide / Lift and Slide / Fixed (Inside panes sliding) Hi
25Hi/2/75 rev 1	General Arrangement - Fixed / Lift and Slide / Lift and Slide / Fixed (Inside panes sliding) Hi
25Hi/2/80 rev 15	General Arrangement - Curtain Wall Insert Hi
25Hi/2/85 rev 2	General Arrangement - Curtain Wall Insert Hi
25Hi/2/87 rev 0	General Arrangement - Curtain Wall Insert Hi
25Hi/2/90 rev 14	General Arrangement - 1 Pane Lift and Slide / 1 Pane Fixed (Inside pane sliding with internal handle) Hi+
25Hi/2/95 rev 3	General Arrangement - 1 Pane Lift and Slide / 1 Pane Fixed (Inside pane sliding with internal handle) Hi+
25Hi/2/100 rev 18	General Arrangement - 1 Pane Lift and Slide / 1 Pane Fixed (Inside pane sliding with internal and external handles) Hi+
25Hi/2/110 rev 16	General Arrangement - Lift and Slide / Fixed / Fixed (Inside pane sliding with internal handle) Hi+
25Hi/2/115 rev 0	General Arrangement - Lift and Slide / Fixed / Fixed (Inside pane sliding with internal handle) Hi+
25Hi/2/120 rev 19	General Arrangement - Lift and Slide / Fixed / Fixed (Inside pane sliding with internal and external handles) Hi+
25Hi/2/130 rev 13	General Arrangement - Fixed / Lift and Slide / Fixed Hi+
25Hi/2/135 rev 1	General Arrangement - Fixed / Lift and Slide / Fixed Hi+
25Hi/2/136 rev 0	General Arrangement - Triple Track Lift and Slide Door Hi+
25Hi/2/137 rev 0	General Arrangement - Triple Track Lift and Slide Door Hi+
25Hi/2/138 rev 0	General Arrangement - Triple Track Lift and Slide Door (Internal handle) Hi+
25Hi/2/139 rev 0	General Arrangement - Triple Track Lift and Slide Door (Internal and external handles) Hi+
25Hi/2/140 rev 16	General Arrangement - Fixed / Lift and Slide / Lift and Slide / Fixed (Inside panes sliding) Hi+
25Hi/2/145 rev 1	General Arrangement - Fixed / Lift and Slide / Lift and Slide / Fixed (Inside panes sliding) Hi+
25Hi/2/150 rev 12	General Arrangement - Curtain Wall Insert Hi+
25Hi/2/155 rev 3	General Arrangement - Curtain Wall Insert Hi+
25Hi/2/157 rev 0	General Arrangement - Curtain Wall Insert Hi+
25Hi/2/160 rev 7	Mullion Stiffener - For Double Track 2, 3 and 4 Pane Doors Hi/Hi+
25Hi/2/170 rev 6	Mullion Stiffener - For Double Track 2, 3 and 4 Pane Doors Hi/Hi+
25Hi/2/180 rev 7	Mullion Stiffener - For Double Track 3 and 4 Pane Doors Hi/Hi+
25Hi/2/190 rev 6	Mullion Stiffener - For Double Track 3 and 4 Pane Doors Hi/Hi+
25Hi/2/194 rev 0	Mullion Stiffener - For Triple Track 3 Pane Doors Hi/Hi+
25Hi/2/196 rev 0	Mullion Stiffener - For Triple Track 3 Pane Doors Hi/Hi+
25Hi/2/198 rev 0	Mullion Stiffener - For Triple Track 3 Pane Doors Hi/Hi+
25Hi/2/200 rev 3	Coupling Detail Hi/Hi+
25Hi/2/205 rev 3	Coupling Detail Hi/Hi+
25Hi/2/210 rev 4	Cill and Head Options Hi/Hi+

Section 3: Ironmongery Requirements

25Hi/3/10 rev 17	Ironmongery - General Cautionary Notes and Thermal Foams Hi/Hi+

25Hi/3/20 rev 24	Vent Size Limitation Chart - Lift and Slide Door Sashes SL018016, SL129130, and SL131132 Hi/Hi+
25Hi/3/30 rev 22	Lift and Slide / Fixed (2 Pane) - Sash SL018016 - Kitting List (Standard Locking, Internal Pane Sliding, Internal Lever Handle) Hi/Hi+
25Hi/3/35 rev 2	Lift and Slide / Fixed (2 Pane) - Sashes SL129130/SL131132 - Kitting List (Standard Locking, Internal Pane Sliding, Internal Lever Handle) Hi/Hi+
25Hi/3/40 rev 25	Lift and Slide / Fixed (2 Pane) - Sash SL018016 - Kitting List (Standard Locking, Internal Pane Sliding, Internal and External Lever Handles) Hi/Hi+
25Hi/3/45 rev 1	Lift and Slide / Fixed (2 Pane) - Sashes SL129130/SL131132 - Kitting List (Standard Locking, Internal Pane Sliding, Internal and External Lever Handles) Hi/Hi+
25Hi/3/50 rev 21	Lift and Slide / Fixed / Fixed (3 Pane) - Sash SL018016 - Kitting List (Standard Locking, Internal Pane Sliding, Internal Lever Handle) Hi/Hi+
25Hi/3/55 rev 1	Lift and Slide / Fixed / Fixed (3 Pane) - Sashes SL129130/SL131132 - Kitting List (Standard Locking, Internal Pane Sliding, Internal Lever Handle) Hi/Hi+
25Hi/3/60 rev 27	Lift and Slide / Fixed / Fixed (3 Pane) - Sash SL018016 - Kitting List (Standard Locking, Internal Pane Sliding, Internal and External Lever Handles) Hi/Hi+
25Hi/3/65 rev 1	Lift and Slide / Fixed / Fixed (3 Pane) - Sashes SL129130/SL131132 - Kitting List (Standard Locking, Internal Pane Sliding, Internal and External Lever Handles) Hi/Hi+
25Hi/3/70 rev 25	Fixed / Lift and Slide / Fixed (3 Pane) - Sash SL018016 - Kitting List (Standard Locking, Internal Pane Sliding, Internal Lever Handle) Hi/Hi+
25Hi/3/75 rev 1	Fixed / Lift and Slide / Fixed (3 Pane) - Sashes SL129130/SL131132 - Kitting List (Standard Locking, Internal Pane Sliding, Internal Lever Handle) Hi/Hi+
25Hi/3/80 rev 16	Fixed / Lift and Slide / Fixed (3 Pane) - Sash SL018016 - Kitting List (Standard Locking, Internal Pane Sliding, Internal and External Lever Handles) Hi/Hi+
25Hi/3/82 rev 0	Fixed / Lift and Slide / Fixed (3 Pane) - Sashes SL129130/SL131132 - Kitting List (Standard Locking, Internal Pane Sliding, Internal and External Lever Handles) Hi/Hi+
25Hi/3/85 rev 0	Lift and Slide / Lift and Slide / Fixed (Triple Track 3 Pane) - Sash SL018016 - Kitting List (Standard Locking, Internal Panes Sliding, Internal Lever Handles) Hi/Hi+
25Hi/3/87 rev 0	Lift and Slide / Lift and Slide / Fixed (Triple Track 3 Pane) - Sash SL018016 - Kitting List (Standard Locking, Internal Panes Sliding, Internal and External Lever Handles) Hi/Hi+
25Hi/3/90 rev 14	Fixed / Lift and Slide / Lift and Slide / Fixed (4 Pane) - Sash SL018016 - Kitting List (Standard Locking, Internal Panes Sliding, Internal Lever Handles) Hi/Hi+
25Hi/3/95 rev 1	Fixed / Lift and Slide / Lift and Slide / Fixed (4 Pane) - Sashes SL129130/SL131132 - Kitting List (Standard Locking, Internal Panes Sliding, Internal Lever Handles) Hi/Hi+
25Hi/3/100 rev 17	Fixed / Lift and Slide / Lift and Slide / Fixed (4 Pane) - Sash SL018016 - Kitting List (Standard Locking, Internal Panes Sliding, Internal and External Lever Handles) Hi/Hi+
25Hi/3/105 rev 1	Fixed / Lift and Slide / Lift and Slide / Fixed (4 Pane) - Sashes SL129130/SL131132 - Kitting List (Standard Locking, Internal Panes Sliding, Internal and External Lever Handles) Hi/Hi+
25Hi/3/110 rev 18	Lift and Slide / Fixed (2 Pane) - Security - Sash SL018016 - Kitting List (Security Locking, Internal Pane Sliding, Internal Lever Handle) Hi/Hi+
25Hi/3/115 rev 0	Lift and Slide / Fixed (2 Pane) - Security - Sashes SL129130/SL131132 - Kitting List (Security Locking, Internal Pane Sliding, Internal Lever Handle) Hi/Hi+
25Hi/3/118 rev 0	Lift and Slide / Lift and Slide / Fixed (Triple Track 3 Pane) - Security Sash SL018016 - Kitting List (Security Locking, Internal Panes Sliding, Internal Lever Handles) Hi/Hi+
25Hi/3/120 rev 15	Lift and Slide / Fixed (2 Pane) - Link Rod Details (Standard Locking, Internal Pane Sliding, Internal Lever Handle) Hi/Hi+
25Hi/3/130 rev 13	Lift and Slide / Fixed (2 Pane) - Link Rod Details (Standard Locking, Internal Pane Sliding, Internal and External Lever Handles) Hi/Hi+
25Hi/3/140 rev 9	Lift and Slide / Fixed / Fixed (3 Pane) - Link Rod Details (Standard Locking, Internal Pane Sliding, Internal Lever Handle) Hi/Hi+
25Hi/3/150 rev 6	Lift and Slide / Fixed / Fixed (3 Pane) - Link Rod Details (Standard Locking, Internal Pane Sliding, Internal and External Lever Handles) Hi/Hi+
25Hi/3/160 rev 7	Fixed / Lift and Slide / Fixed (3 Pane) - Link Rod Details (Standard Locking, Internal Pane Sliding, Internal Lever Handle) Hi/Hi+
25Hi/3/170 rev 7	Fixed / Lift and Slide / Fixed (3 Pane) - Link Rod Details (Standard Locking, Internal Pane Sliding, Internal and External Lever Handles) Hi/Hi+
25Hi/3/175 rev 0	Lift and Slide / Lift and Slide / Fixed (Triple Track 3 Pane) - Link Rod Details (Standard Locking, Internal Panes Sliding, Internal Lever Handles) Hi/Hi+
25Hi/3/177 rev 0	Lift and Slide / Lift and Slide / Fixed (Triple Track 3 Pane) - Link Rod Details (Standard Locking, Internal Panes Sliding, Internal and External Lever Handles) Hi/Hi+
25Hi/3/180 rev 5	Fixed / Lift and Slide / Lift and Slide / Fixed (4 Pane) - Link Rod Details (Standard Locking, Internal Panes Sliding, Internal Lever Handle) Hi/Hi+
25Hi/3/190 rev 5	Fixed / Lift and Slide / Lift and Slide / Fixed (4 Pane) - Link Rod Details (Standard Locking, Internal Panes Sliding, Internal and External Lever Handles) Hi/Hi+
25Hi/3/200 rev 8	Lift and Slide / Fixed (2 Pane) - Security - Link Rod Details (Security Locking, Internal Pane Sliding, Internal Lever Handle) Hi/Hi+
25Hi/3/202 rev 0	Lift and Slide / Lift and Slide / Fixed (Triple Track 3 Pane) - Security - Link Rod Details (Security Locking, Internal Panes Sliding, Internal Lever Handles) Hi/Hi+
25Hi/3/210 rev 2	Cill, Head and Jamb Closer Sizes - Lift and Slide / Fixed (2 Pane) Hi/Hi+
25Hi/3/220 rev 2	Cill, Head and Jamb Closer Sizes - Lift and Slide / Fixed / Fixed (3 Pane) and Fixed / Lift and Slide / Fixed (3 Pane) Hi/Hi+

25Hi/3/225 rev 0	Cill, Head and Jamb Closer Sizes - Triple Track - Lift and Slide / Lift and Slide / Fixed (Triple track application) Hi/Hi+
25Hi/3/230 rev 2	Cill, Head and Jamb Closer Sizes - Fixed / Lift and Slide / Lift and Slide / Fixed (4 Pane) Hi/Hi+
25Hi/3/240 rev 2	Cill, Head and Jamb Closer Sizes - Security - Lift and Slide / Fixed (2 Pane) Hi/Hi+
25Hi/3/250 rev 0	Cill, Head and Jamb Closer Sizes - Security - Lift and Slide / Lift and Slide / Fixed (Triple track 3 pane) Hi/Hi+

Section 4: Profile Cutting and Prepping Details

25Hi/4/10 rev 17	Bar Cutting Sizes - Standard 2 Pane (Inside pane sliding with internal handle), 2 Pane with Jamb Extension (Inside pane sliding with internal and external handles) Hi/Hi+
25Hi/4/20 rev 21	Fabrication and Cutting Sizes (2 Pane) - Sash SL018016 - 1 Pane Lift and Slide / 1 Pane Fixed Hi/Hi+
25Hi/4/25 rev 1	Fabrication and Cutting Sizes (2 Pane) - Sashes SL129130/SL131132 - 1 Pane Lift and Slide / 1 Pane Fixed Hi/Hi+
25Hi/4/30 rev 24	Fabrication and Cutting Sizes (2 Pane with Jamb Extension) - Sash SL018016 - 1 Pane Lift and Slide / 1 Pane Fixed Hi/Hi+
25Hi/4/35 rev 1	Fabrication and Cutting Sizes (2 Pane with Jamb Extension) - Sashes SL129130/SL131132 - 1 Pane Lift and Slide / 1 Pane Fixed Hi/Hi+
25Hi/4/40 rev 24	Bar Cutting Sizes - Standard 3 Pane, Standard 3 Pane, 3 Pane with Jamb Extension Hi/Hi+
25Hi/4/50 rev 14	Fabrication and Cutting Sizes (3 Pane) - Sash SL018016 - 1 Pane Lift and Slide / 2 Pane Fixed Hi/Hi+
25Hi/4/55 rev 0	Fabrication and Cutting Sizes (3 Pane) - Sashes SL129130/SL131132 - 1 Pane Lift and Slide / 2 Pane Fixed Hi/Hi+
25Hi/4/60 rev 13	Fabrication and Cutting Sizes (3 Pane with Jamb Extension) - Sash SL018016 - 1 Pane Lift and Slide / 2 Pane Fixed Hi/Hi+
25Hi/4/65 rev 1	Fabrication and Cutting Sizes (3 Pane with Jamb Extension) - Sashes SL129130/SL131132 - 1 Pane Lift and Slide / 2 Pane Fixed Hi/Hi+
25Hi/4/67 rev 0	Bar Cutting Sizes - Standard Triple Track, Triple Track with Jamb Extension Hi/Hi+
25Hi/4/68 rev 0	Fabrication and Cutting Sizes (Triple Track 3 Pane) - Sash SL018016 - 2 Pane Lift and Slide / 1 Pane Fixed Hi/Hi+
25Hi/4/69 rev 0	Fabrication and Cutting Sizes (Triple Track 3 Pane with Jamb Extension) - Sash SL018016 - 2 Pane Lift and Slide / 1 Pane Fixed Hi/Hi+
25Hi/4/70 rev 9	Bar Cutting Sizes - 4 Pane Hi/Hi+
25Hi/4/80 rev 14	Fabrication and Cutting Sizes (4 Pane) - Sash SL018016 - 2 Pane Lift and Slide / 2 Pane Fixed Hi/Hi+
25Hi/4/85 rev 1	Fabrication and Cutting Sizes (4 Pane) - Sashes SL129130/SL131132 - 2 Pane Lift and Slide / 2 Pane Fixed Hi/Hi+
25Hi/4/90 rev 12	Handing of Outer Frame Profiles - For 2 pane and 3 pane double track applications Hi/Hi+
25Hi/4/95 rev 0	Handing of Outer Frame Profiles - For 3 pane triple track applications Hi/Hi+
25Hi/4/100 rev 8	Handing of Outer Frame Profiles - For 4 pane double track applications Hi/Hi+
25Hi/4/110 rev 6	SL001002 Outer Frame Prep Details Hi/Hi+
25Hi/4/112 rev 0	SL001000002 Triple Track Outer Frame Prep Details Hi/Hi+
25Hi/4/114 rev 0	SL001000002 Triple Track Outer Frame Prep Details Hi/Hi+
25Hi/4/116 rev 0	SL005, SL006/SL135 Cover Prep Details Hi/Hi+
25Hi/4/120 rev 7	SL018016 Sash Prep Details Hi/Hi+
25Hi/4/122 rev 1	SL129130 Sash Prep Details Hi/Hi+
25Hi/4/124 rev 1	SL131132 Sash Prep Details Hi/Hi+
25Hi/4/130 rev 8	Sash Prep Details - SL051 Locking Handle Hi/Hi+
25Hi/4/135 rev 2	Sash Prep Details - SL072 Locking Handle Hi/Hi+
25Hi/4/140 rev 9	Sash Prep Details - SL053 and SL063C Preps for TTGEAR615 Non-Locking Lever Handles Hi/Hi+
25Hi/4/145 rev 0	Sash Prep Details - SL053 and SL063C Preps for TTGEAR615 Non-Locking Lever Handles Hi/Hi+
25Hi/4/150 rev 7	Sash Prep Details - SL101E External Pull Handle Hi/Hi+

25Hi/4/160 rev 8	Sash Prep Details - SL102A External Pull Handle Hi/Hi+
25Hi/4/170 rev 10	Sash Prep Details - SL075 Fixed Sash Rod Drive Hi/Hi+
25Hi/4/180 rev 9	Sash Prep Details - SL082 Door Stop Hi/Hi+
25Hi/4/190 rev 10	Outer Frame Trim SL033 Prep Details Hi/Hi+
25Hi/4/200 rev 11	Outer Frame Trim SL033 Prep Details - For Jamb Extension SL015015 Applications Hi/Hi+
25Hi/4/202 rev 0	Outer Frame Trim SL033 and SL036 Prep Details Hi/Hi+
25Hi/4/203 rev 0	Outer Frame Trim SL033 and SL036 Prep Details - For Jamb Extension SL015015 Applications Hi/Hi+
25Hi/4/210 rev 7	Interlock Cover SL012 Prep Details Hi/Hi+
25Hi/4/220 rev 4	Locking Profile SL004004 Prep Details Hi/Hi+
25Hi/4/230 rev 6	End Prep for SL015015 Jamb Extension Hi/Hi+
25Hi/4/240 rev 3	Mullion Stiffener - 007, 008 and 009 Prep Detail Hi/Hi+
25Hi/4/250 rev 3	SL021 Meeting Stile Locking Piece Prep Details - Security - Preps to Suit SL076 Security Interlock Hi/Hi+

Section 5: Drainage Details

25Hi/5/10 rev 18	Drainage Detail - Opening Sash Hi
25Hi/5/20 rev 18	Drainage Detail - Fixed Sash Hi
25Hi/5/30 rev 13	Drainage Detail - Opening Sash Hi+
25Hi/5/40 rev 12	Drainage Detail - Fixed Sash Hi+
25Hi/5/50 rev 5	Drainage Detail - SL001002 Outer Frame - SL099 Foam Filler Hi/Hi+
25Hi/5/55 rev 0	Drainage Detail - SL001000002 Outer Frame - SL099 Foam Filler Hi/Hi+
25Hi/5/60 rev 3	Drainage Detail - Outer Frame - SL033 Outer Frame Trim Hi/Hi+
25Hi/5/63 rev 0	Drainage Detail - Outer Frame - SL033 and SL036 Outer Frame Trim Hi/Hi+
25Hi/5/70 rev 2	Drainage Detail - SL001002 Outer Frame - SL005 Cill Cover Hi/Hi+
25Hi/5/73 rev 0	Drainage Detail - SL001000002 Triple Track Outer Frame - SL005 Cill Cover Hi/Hi+

Section 6: Assembly Details

25Hi/6/10 rev 13	Head and Cill Profile Assembly - Drainage Block from SL058A Interlock Kit Hi/Hi+
25Hi/6/12 rev 0	Head and Cill Profile Assembly - Drainage Block from SL155 Interlock Kit Hi/Hi+
25Hi/6/14 rev 0	Head and Cill Profile Assembly - Drainage Block from SL155 Interlock Kit Hi/Hi+
25Hi/6/20 rev 16	Head and Cill Profile Assembly - Application of SL005 and SL006/SL135 to SL001002 Outer Frame Hi/Hi+
25Hi/6/25 rev 0	Head and Cill Profile Assembly - Application of SL005 and SL006 to SL001000002 Outer Frame Hi/Hi+
25Hi/6/26 rev 0	Head and Cill Profile Assembly - Application of SL005 and SL006 to SL001000002 Outer Frame Hi/Hi+
25Hi/6/30 rev 13	Corner Assembly Detail - Outer Frame SL001002 Hi/Hi+
25Hi/6/40 rev 18	Corner Assembly Detail - Outer Frame SL001002 Hi/Hi+
25Hi/6/44 rev 0	Corner Assembly Detail - Outer Frame SL001000002 Hi/Hi+
25Hi/6/46 rev 0	Corner Assembly Detail - Outer Frame SL001000002 Hi/Hi+
25Hi/6/50 rev 17	SL015015 Jamb Extension Assembly Hi/Hi+
25Hi/6/60 rev 12	Outer Frame Prep Details for SL015015 Jamb Extension Hi/Hi+

25Hi/6/70 rev 15	SL104105106 Sub-Cill Assembly Hi/Hi+
25Hi/6/80 rev 16	Head / Jamb and Cill Closer Application Hi/Hi+
25Hi/6/90 rev 18	Corner Assembly Detail - Sash SL018016 Hi/Hi+
25Hi/6/95 rev 2	Corner Assembly Detail - Sashes SL129130 and SL131132 Hi/Hi+
25Hi/6/100 rev 13	Sash Assembly - Gasket Application Hi/Hi+
25Hi/6/110 rev 17	Sash Assembly - SL087 and SL088 Corner Chevrons Hi/Hi+
25Hi/6/120 rev 10	Sash Assembly - SL084 Corner Cleat into SL018016 Hi/Hi+
25Hi/6/125 rev 2	Sash Assembly - SL084 and SL150 Corner Cleats into SL129130 and SL131132 Hi/Hi+
25Hi/6/130 rev 13	Sash Assembly - SL012 and SL021 Meeting Stile Fixing Details Hi/Hi+
25Hi/6/140 rev 14	Sash Assembly - SL012 and SL021 Meeting Stile Fixing Details - Double Track Hi/Hi+
25Hi/6/142 rev 0	Sash Assembly - SL012 and SL021 Meeting Stile Fixing Details - Triple Track Hi/Hi+
25Hi/6/150 rev 19	Sash Assembly - SL076 Security Interlock Fixing Details Hi/Hi+
25Hi/6/160 rev 10	Sash Assembly - SL004004 Locking Profile Fixing Details Hi/Hi+

Section 7: Ironmongery Assembly and Foams

25Hi/7/10 rev 12	Locking Gear Assembly to Double Track Lift and Slide Sash Hi/Hi+
25Hi/7/12 rev 0	Locking Gear Assembly to Triple Track Lift and Slide Sashes Hi/Hi+
25Hi/7/20 rev 22	Locking Gear Assembly to Master Leaf Lift and Slide Sash SL018016 with TTGEAR615 Handles Hi/Hi+
25Hi/7/21 rev 1	Locking Gear Assembly to Master Leaf Double Track Lift and Slide Sash SL129130 with TTGEAR615 Handles Hi/Hi+
25Hi/7/22 rev 1	Locking Gear Assembly to Slave Leaf Double Track Lift and Slide Sashes with TTGEAR615 Handles - 4-Pane Applications Hi/Hi+
25Hi/7/30 rev 24	Security Locking Gear Assembly to Lift and Slide Sash Hi/Hi+
25Hi/7/40 rev 13	Carriage Assembly to Double Track Lift and Slide Sash Hi/Hi+
25Hi/7/42 rev 0	Carriage Assembly to Triple Track Lift and Slide Sashes Hi/Hi+
25Hi/7/50 rev 10	Anti-Lift Kit Assembly Double Track Lift and Slide Sash - For Security Applications and Slave Leaf of 4-pane Applications Hi/Hi+
25Hi/7/52 rev 0	Anti-Lift Kit Assembly - For Triple Track Applications Hi/Hi+
25Hi/7/60 rev 14	Carriage Assembly to Fixed Sash Hi/Hi+
25Hi/7/70 rev 13	Locking Gear Assembly to Fixed Sash Hi/Hi+
25Hi/7/80 rev 13	SL082 Door Stop Fitting Details Hi/Hi+
25Hi/7/85 rev 1	TTGEAR615 Handle Assembly Details - Master Leaf Hi/Hi+
25Hi/7/90 rev 15	TTGEAR615 Handle Assembly Details - Slave Leaf Hi/Hi+
25Hi/7/100 rev 15	SL062 External Cylinder Cover Assembly Details Hi/Hi+
25Hi/7/110 rev 9	SL101E External Pull Handle Assembly Details Hi/Hi+
25Hi/7/120 rev 9	SL102A External Pull Handle Assembly Details Hi/Hi+
25Hi/7/130 rev 10	Locking Point Assembly Hi/Hi+
25Hi/7/140 rev 14	SL001002 Outer Frame Thermal Foam Hi+
25Hi/7/145 rev 0	SL001000002 Outer Frame Thermal Foam Hi+
25Hi/7/150 rev 8	Lift and Slide Sash Thermal Foams - SL092 and SL097 for Head, Cill and Locking Jamb Hi+

25Hi/7/160 rev 9	Fixed Sash Thermal Foams - SL092 and SL097 for Head, Cill and Jambs Hi+
25Hi/7/170 rev 5	Interlock Thermal Foam Hi+
25Hi/7/180 rev 2	Glazing Unit Perimeter Foam 6743 Hi+
25Hi/7/190 rev 1	Glazing Unit Perimeter Foam 6727 Hi+

Section 8: Installation

25Hi/8/10 rev 12	Installation Procedures - General Information Hi/Hi+
25Hi/8/20 rev 12	Installation Procedures - General Information Hi/Hi+
25Hi/8/30 rev 15	Installation Procedures - Component Identification Hi/Hi+
25Hi/8/40 rev 13	Installation Procedures - Fixed Sash Hi/Hi+
25Hi/8/50 rev 13	Installation Procedures - Fixed Sash Hi/Hi+
25Hi/8/60 rev 12	Installation Procedures - Fixed Sash Hi/Hi+
25Hi/8/70 rev 11	Installation Procedures - Fixed Sash - Glazing Hi/Hi+
25Hi/8/80 rev 13	Installation Procedures - Opening Sash Hi/Hi+
25Hi/8/90 rev 12	Installation Procedures - Opening Sash Hi/Hi+
25Hi/8/95 rev 1	Installation Procedures - Opening Sash Hi/Hi+
25Hi/8/100 rev 9	Installation Procedures - Opening Sash Hi/Hi+
25Hi/8/110 rev 9	Installation Procedures - Opening Sash - Glazing Hi/Hi+
25Hi/8/120 rev 10	Installation Procedures - Opening Sash Hi/Hi+
25Hi/8/130 rev 5	Typical Fixing Details - Lug Fixing Hi/Hi+
25Hi/8/132 rev 0	Typical Fixing Details - Triple Track Lug Fixing Hi/Hi+
25Hi/8/134 rev 0	Typical Fixing Details - Triple Track Lug Fixing Hi/Hi+
25Hi/8/135 rev 1	Typical Fixing Details - Curtain Walling Hi/Hi+
25Hi/8/136 rev 0	Typical Fixing Details - Curtain Walling Hi/Hi+
25Hi/8/137 rev 0	HR50112 Sealing Detail at T-rex Positions in Curtain Walling Double Track Applications Hi/Hi+
25Hi/8/138 rev 0	HR50112 Sealing Detail at T-rex Positions in Curtain Walling Triple Track Applications Hi/Hi+
25Hi/8/139 rev 0	HR50112 Sealing Detail at T-rex Positions in Curtain Walling Triple Track Applications Hi/Hi+
25Hi/8/140 rev 5	Typical Sub-Cill Detail Hi/Hi+
25Hi/8/150 rev 3	Glazing Details - Sash SL018016 Hi/Hi+
25Hi/8/155 rev 2	Glazing Details - Sashes SL129130 and SL131132 Hi/Hi+
25Hi/8/157 rev 0	Glazing Bead and Gasket Requirements Hi/Hi+
25Hi/8/160 rev 5	Weatherseal Application Details - Gasket 6080, 6081, CA25, CA25A or PCD82 (Outside), Wedge 066 or CA27 (Inside) Hi/Hi+
25Hi/8/170 rev 5	Outer Frame Trim SL033 Installation Hi/Hi+
25Hi/8/180 rev 6	Outer Frame Trim SL033 Installation Hi/Hi+
25Hi/8/184 rev 0	Outer Frame Trim SL033 and SL036 Installation Hi/Hi+
25Hi/8/186 rev 0	Outer Frame Trim SL033 and SL036 Installation Hi/Hi+
25Hi/8/190 rev 2	Typical Cill Detail - Perimeter Interface Hi/Hi+

25Hi/8/195 rev 0	Typical Cill Detail - Perimeter Interface Hi/Hi+
25Hi/8/200 rev 2	Typical Sub-Cill Detail - Perimeter Interface Hi/Hi+
25Hi/8/210 rev 3	Operating Instructions - Internal Lever Handle Only (SL051/SL072) Hi/Hi+
25Hi/8/220 rev 2	Operating Instructions - Internal and External Lever Handles (TTGEAR615) Hi/Hi+

Section 9: Structural Properties

25Hi/9/10 rev 7	Structural Properties Hi/Hi+
25Hi/9/20 rev 6	Structural Properties Hi/Hi+
25Hi/9/30 rev 0	Structural Properties Hi/Hi+