

**Please read this complete set of assembly instructions before starting the installation and only when you understand the construction method start to follow the step by step guide.**

**IDENTIFY THE PACK CONTENTS FROM DIAGRAM 1**

The frame head and cill are supplied at 2179mm to allow for an 838mm (33") wide external door. This width can be reduced according to the side light(s) and door width.

The frame mullions and jambs are cut to length to suit either a 1981mm (78") high door or a 2032mm (80") high door. XL Side light dimensions are 2032mm high x 584mm wide and can be reduced by 51mm in height, (to suit a 78" high door) and 120mm overall in the width, (60mm each side max).

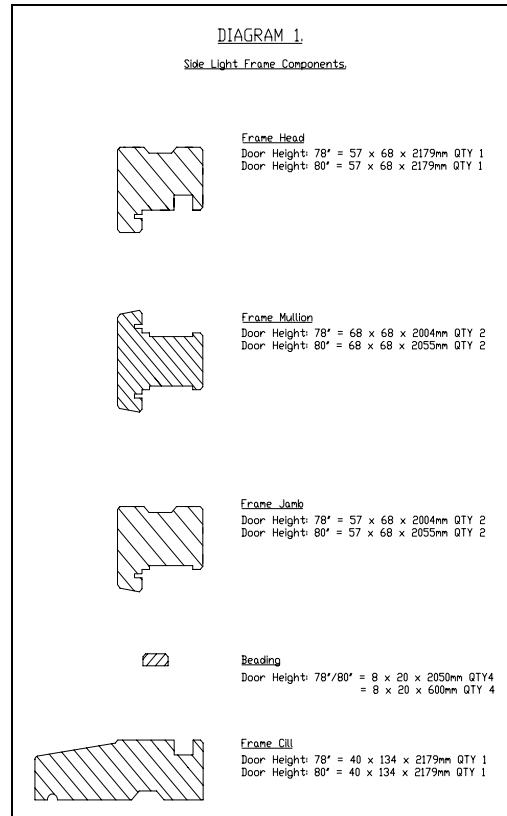
The beading is supplied over length to allow cutting to size to suit side light width.

**ASSEMBLING THE FRAME.**

Assemble the frame as in **Diagram 2** or **3** depending on which frame configuration you are building.

The internal dimensions B and C allow for approximately 2mm clearance to each side of the doors and sidelight for fitting tolerances.

External dimensions A and D also allow for a 2mm clearance to the top and bottom of the door and side lights. (continued on page 3).



**TABLE 1.**

**INTERNAL FRAME DIMENSIONS. Diagram 2 or 3**

**Dimension B** = 588mm when using XL Joinery Universal Sidelight. This dimension can be reduced by 120mm per sidelight, (60mm each side).

**Dimension C** = 766mm when using a single 30" wide door.

**Dimension C** = 817mm when using a single 32" wide door.

**Dimension C** = 842mm when using a single 33" wide door.

**EXTERNAL FRAME DIMENSION. Diagram 2 or 3**

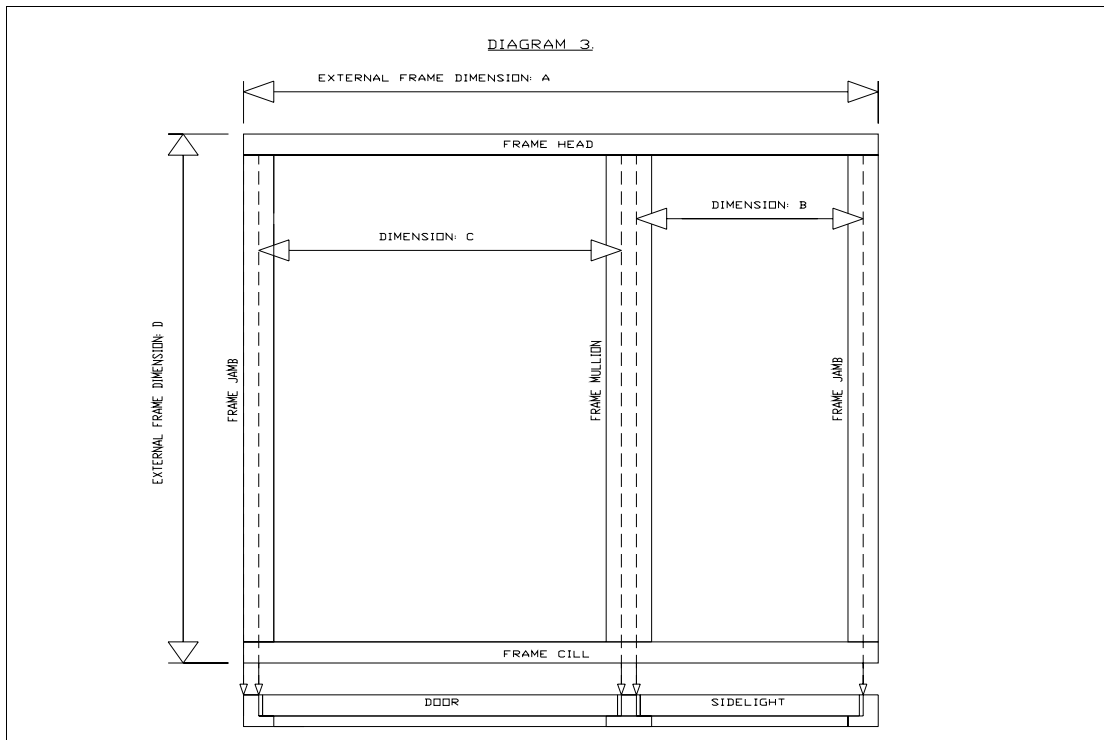
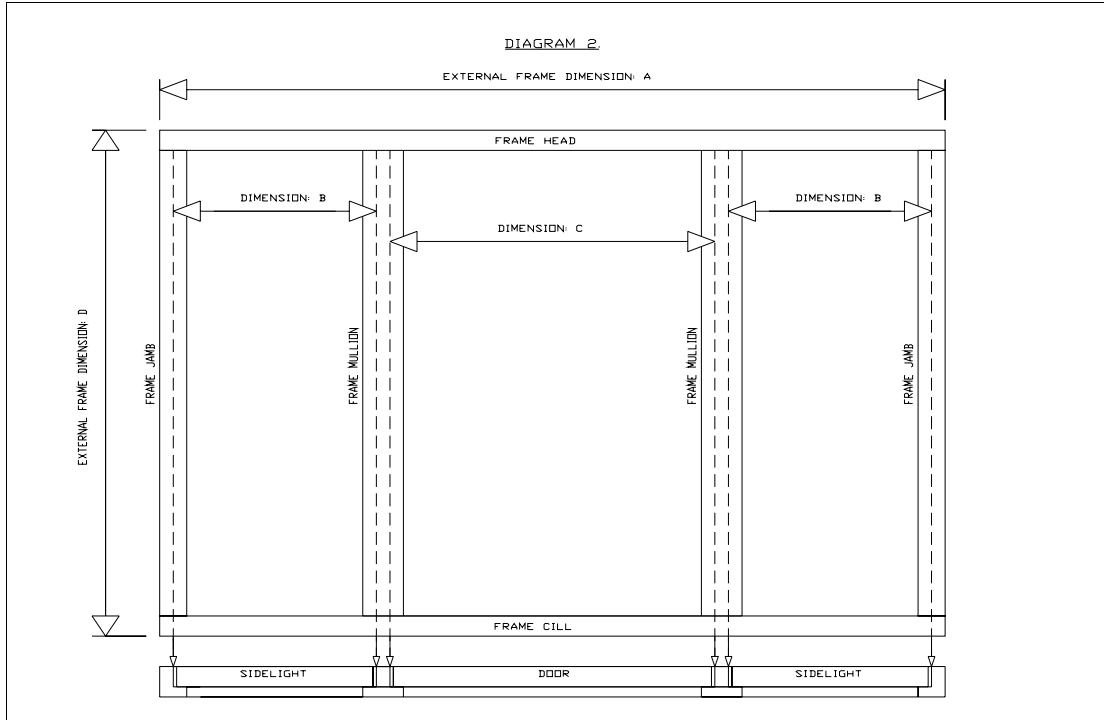
**Dimension A** = 2103mm when using a single 30" wide door.

**Dimension A** = 2154mm when using a single 32" wide door.

**Dimension A** = 2179mm when using a single 33" wide door.

**Dimension D** = 2067mm when using a single 78" high door.

**Dimension D** = 2118mm when using a single 80" high door.



**ASSEMBLING THE FRAME.** (From page 1). Prior to assembling the frame, measure the brickwork opening width and height that the frame will be fixed into. Reduce these measurements by 10mm to determine the actual frame size required. Determine the difference in width between **Dimension A** and the actual width you require. The difference should be divided equally between each side of the side light (s) up to a maximum of 60mm per side, (**Example 1**). Up to an extra 10mm can also be removed from each side of the door if necessary.

To reduce the side lights to the relevant width either plane or saw off the excess ensuring you leave a smooth straight finish.

Loosely assemble the frame face down with the side light(s) and door resting within the frame component rebates. If using only one side light ensure that it is positioned to the correct side of the door. Push the stub tenons of the vertical

components fully into the grooves within the frame sill and head sections as shown in **Diagram 4, Section 2**. Ensure that you leave a 2mm gap between the top, bottom and sides of the door/ side light (s) and the frame components. Double check that the external frame dimensions are 10mm less than the brickwork opening dimensions you measured previously.

Mark all the drill hole positions onto the sill and head in pencil, then drill and countersink the frame screw fixing holes. Use a waterproof adhesive on all the joints and screw the head and sill to the jambs and mullions using No.10 x 100mm countersunk screws through drilled holes. The frame must be assembled perfectly square and remain square throughout the rest of the installation. Check the frame diagonals, and only when these measure the same can you be sure the frame is square. Remove the door and side light(s) and allow the adhesive to set. If necessary cut off the sill and head at one end, to be flush with the frame jambs.

**EXAMPLE 1.**

Dimension A = 2179mm wide when using an 838mm (33") wide door and 2 x 588mm wide side lights.

Dimension D = 2067mm high when using a 1981mm (782) high door.

Brickwork opening = 2149mm wide x 2077mm high.

Actual frame width required = 2139mm (2149mm - 10mm clearance).

Actual frame height required = 2067mm (2077mm - 10mm clearance).

Difference between Dimension A and actual frame width required = 40mm (2179mm – 2139mm).

Difference to remove from each edge of sidelights = 10mm (40mm divided by 4 edges).

Therefore each side light will need to be reduced to 568mm wide (588mm – 10mm each side).

Note: As the XL Universal side light is produced to suit a 2032mm (80") high door 50mm will also need to be reduced from the side light height from the bottom rail.

**FITTING THE FRAME.**

Offer the assembled frame into the brickwork opening. Check that the sill is level. Also check that the jambs are vertical from side to side and from back to front, (**Diagram 5**). Use a plumb bob and line to check that the inside face of the head is vertically aligned with the inside face of the sill at both ends.

Use wooden / plastic wedges above the jambs and as close to the jambs as possible to hold the frame in the correct position, (**Diagram 5**).

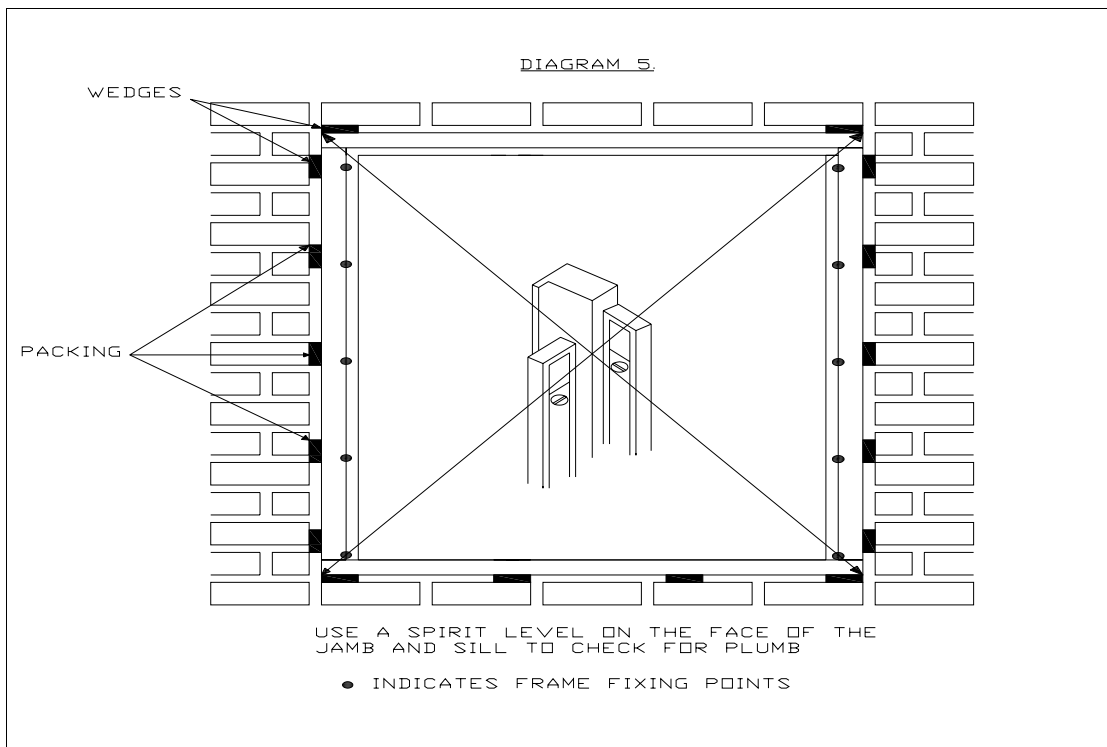
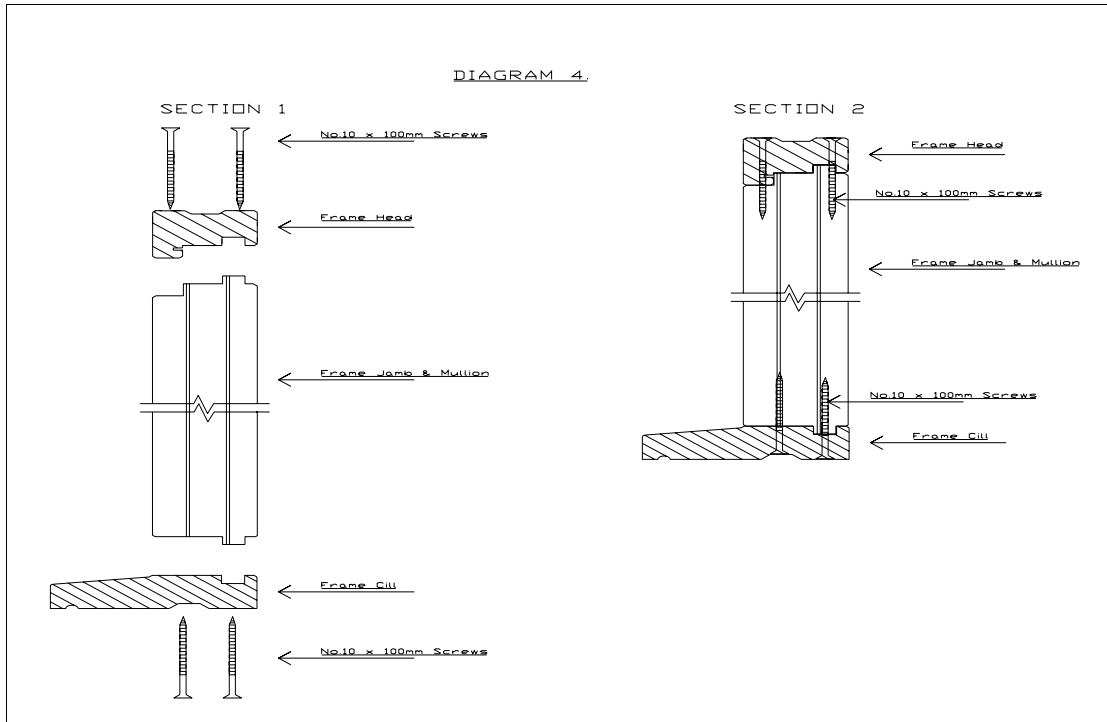
It is important to ensure that the frame is positioned and fitted in accordance with all the horizontal and vertical frame checks. Slip wooden / plastic packing into the gap between the frame and the wall ready

to take the permanent fixings. Take care not to bend the jambs in the process.

Secure the frame to the brick opening using a suitable size of frame fixer. 8mm x 120mm frame fixers are suitable in most cases.

Drill and countersink a minimum of five 8mm diameter holes into each of the jambs, a maximum of 150mm from the top and bottom corners and equally spaced.

When tightening the screws use wooden / plastic packing to prevent the frame from distorting. Ensure that the screw heads are below the timber surface. Seal between the brickwork and frame with a suitable mastic or silicone sealant internally and externally.



**FITTING THE SIDE LIGHTS.**

Using a 4mm bit, drill 5 holes through each of the panel verticals at the angle and positions shown in **Diagram 6**.

Run a generous amount of silicone on top of the sill in the panel opening. Insert the side light into the frame from the inside, ensuring it is the correct way up and the correct way around, (the drainage slot must be to the bottom and facing the outside). With the panel sitting on the sill, push the panel hard up against the frame seals. Secure the panel in place using 50mm countersunk screws through the drilled holes, (**Diagram 6, Section 3**).

The drill holes will be covered by fixing the beads centrally over the joint between the frame components and the side lights. These beads should be mitred at 45 Degrees and the width and height is dictated by the size of the side light opening.

Fit the vertical and horizontal internal beads around the perimeter of the side light using woodworking adhesive and 20mm panel pins, (**Diagram 6, Section 3**).

Repeat this procedure for fitting the other side light if required.

