

# SLIDING DOOR SYSTEM: ASSEMBLY INSTRUCTION

## SLIDING DOOR S800 DIVIDING RAIL AND HANDLE

Version 1 (up to date January 2012)

4.02.1.x



**Subject to technical changes.**

**raumplus**

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## GENERAL INFORMATION: Preparation

\* max. width: **1200** mm

\* max. height: **2750** mm

\* max. weight: **180** kg

The panel channel (10 mm) serves to simplify the assembly. For this purpose, a stabilizing panel (**8mm**) can be installed.

The panel is required in slanted doors for stability purposes. Adhesion of the **4mm** glass panel incl. splinter guard foil (PE) with 3M adhesive tape.

One-sided or double-sided adhesion is possible. A slanted door guide is only possible with one-sided adhesion.

### Note:

Do not use transparent glass panels! All profiles have two visible positioning grooves for the adhesive tape.

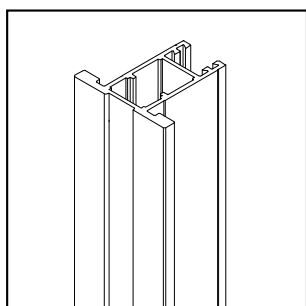
We recommend to test the adhesion

## TOOLS:

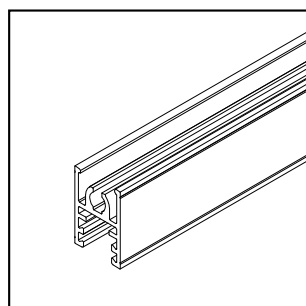
- Straight edge
- Allen key 4 + 5mm
- Drill 5,5mm, 6,5mm, 8mm, 10 mm
- Pencil
- Rubber hammer
- Metal saw
- Cutter / knife
- Gloves
- Small pinch roller
- Large pinch roller
- Suction cup

VERSION INFORMATION  
Version 1:

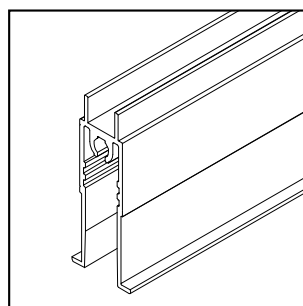
# ACCESSORIES



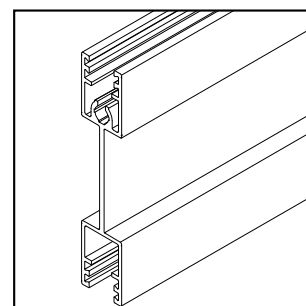
1\_ 19.01.0xx



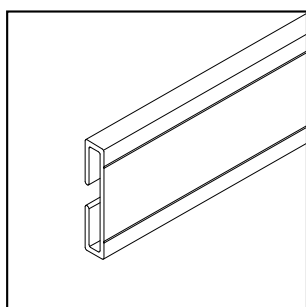
2\_ 19.12.0xx



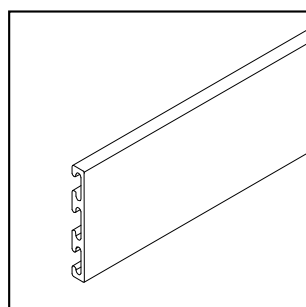
3\_ 19.14.0xx



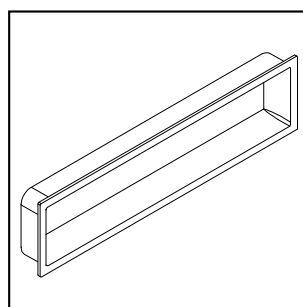
4\_ 19.22.0xx



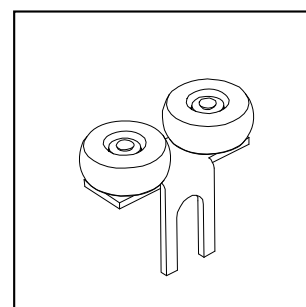
5\_ 19.23.020



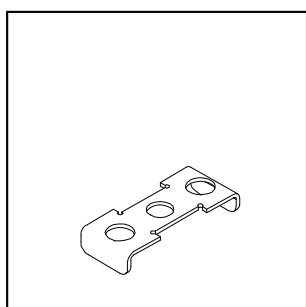
6\_ 19.24.0xx



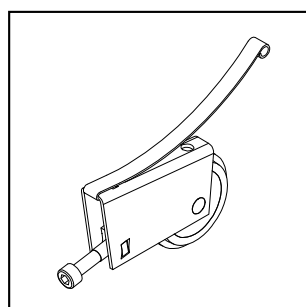
7\_ 10.01.28x



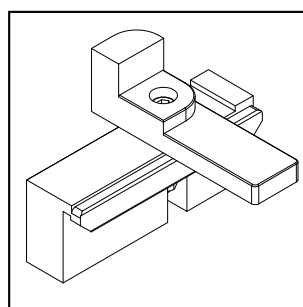
8\_ 10.01.015



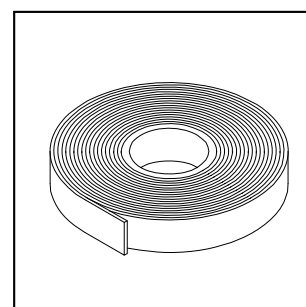
9\_ 10.01.808



10\_ 10.01.120



11\_ 30.03.012



12\_ 25.12.047

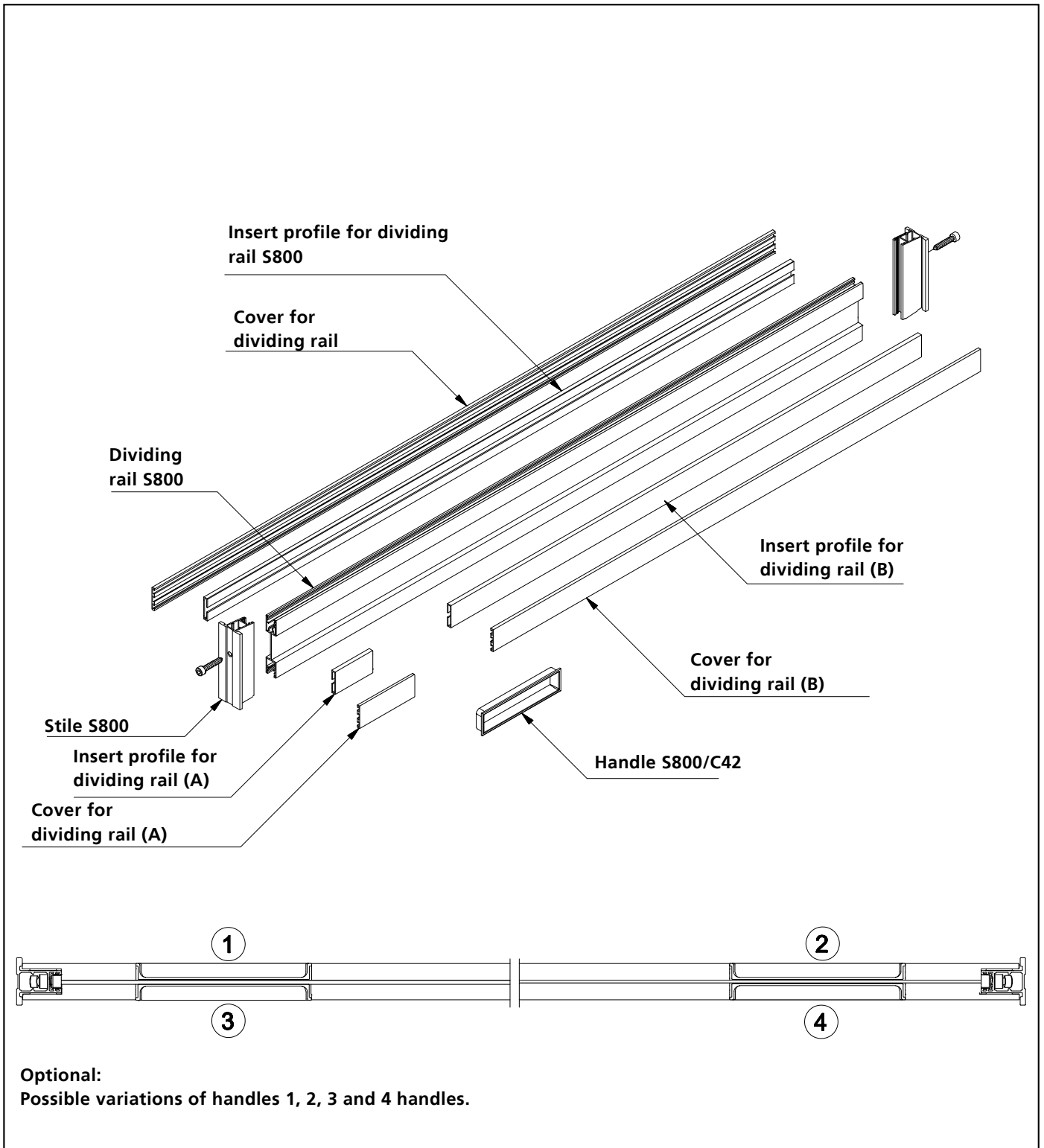
- 1\_ Stile S800
- 2\_ Top rail S800
- 3\_ Bottom rail S800
- 4\_ Dividing rail S800
- 5\_ Insert profile for dividing rail S800
- 6\_ Cover for dividing rail S800
- 7\_ Handle S800/C42
- 8\_ Top roller S800
- 9\_ Security clips S800
- 10\_ Bottom roller S800
- 11\_ Assembly tool S800 for anodized profiles  
Assembly tool S800 for powder coated profiles 30.03.013

- 12\_ Double sided tape S800
- 13\_ 3M Cleaner S 151 w/o Fig. 25.12.048
- 14\_ 3M Primer 94 w/o Fig
- 15\_ Plugs for punching holes w/o Fig 10.07.05x
- 16\_ Pressure roller S800 w/o Fig 30.15.025
- 17\_ Pressure roller w/o Fig 30.15.026
- 18\_ Drilling template w/o Fig 30.14.001
- 19\_ Hinge for angle door  
w/o Fig 10.01.060
- 20\_ Punching tool w/o Fig 30.11.031

For colored surfaces please ask your dealer.

# DETAIL DRAWING

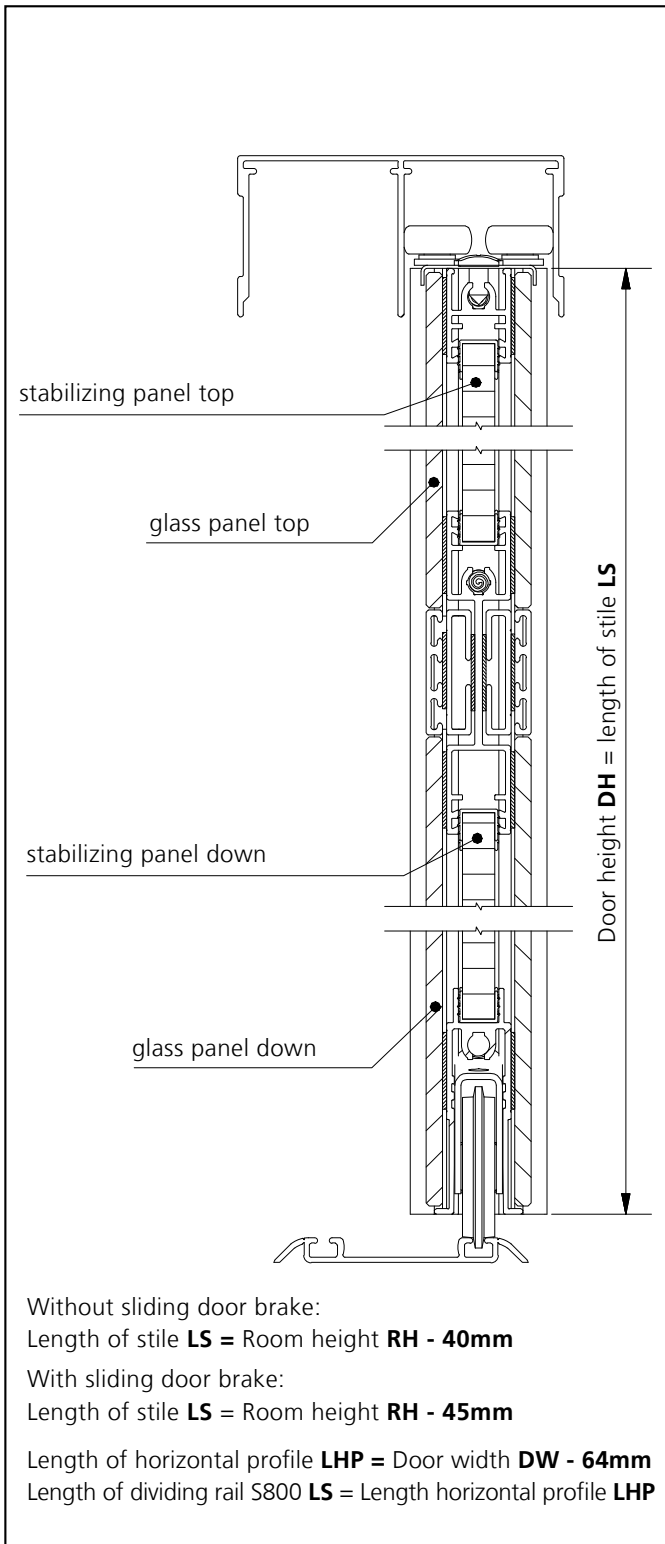
## EXPLODED DRAWING DIVIDING RAIL S800



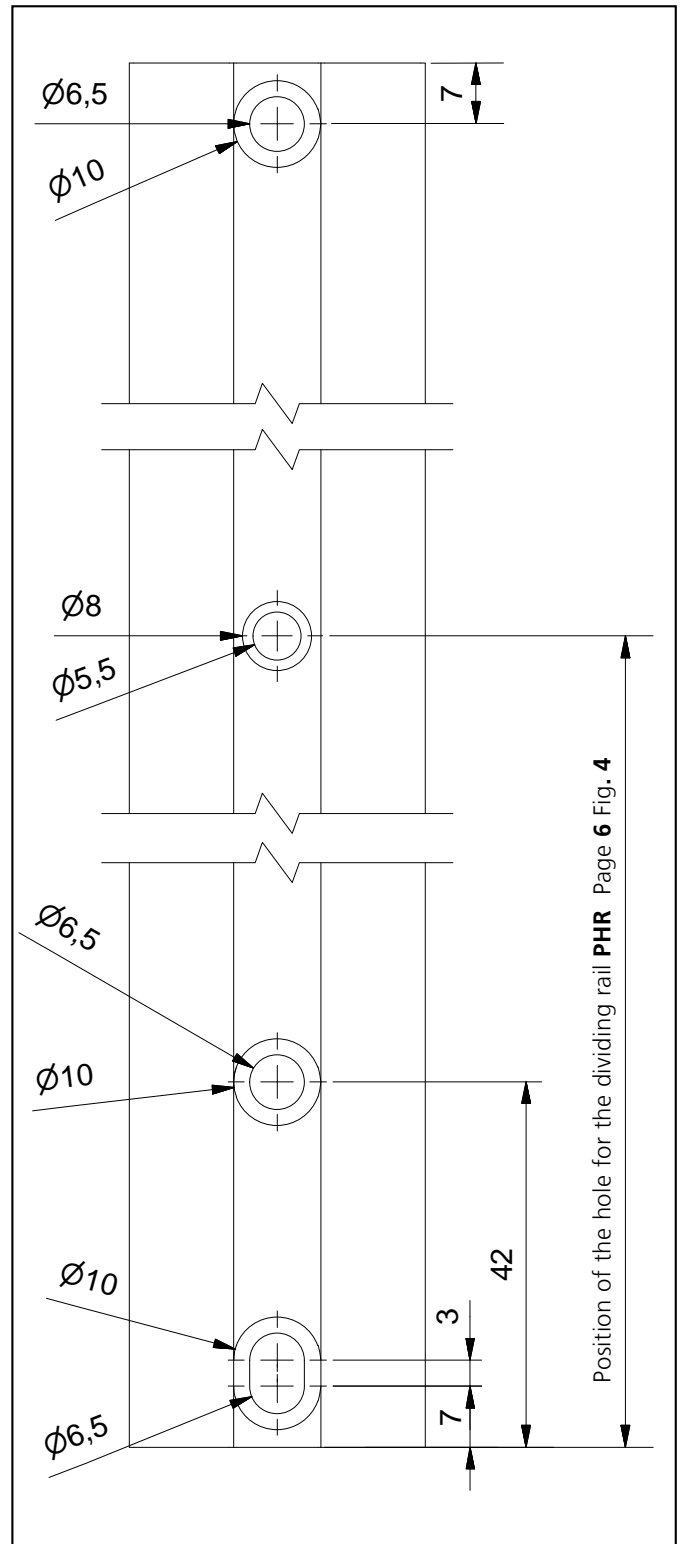
04\_05

# CUTTING DIMENSION

## SLIDING DOOR S800



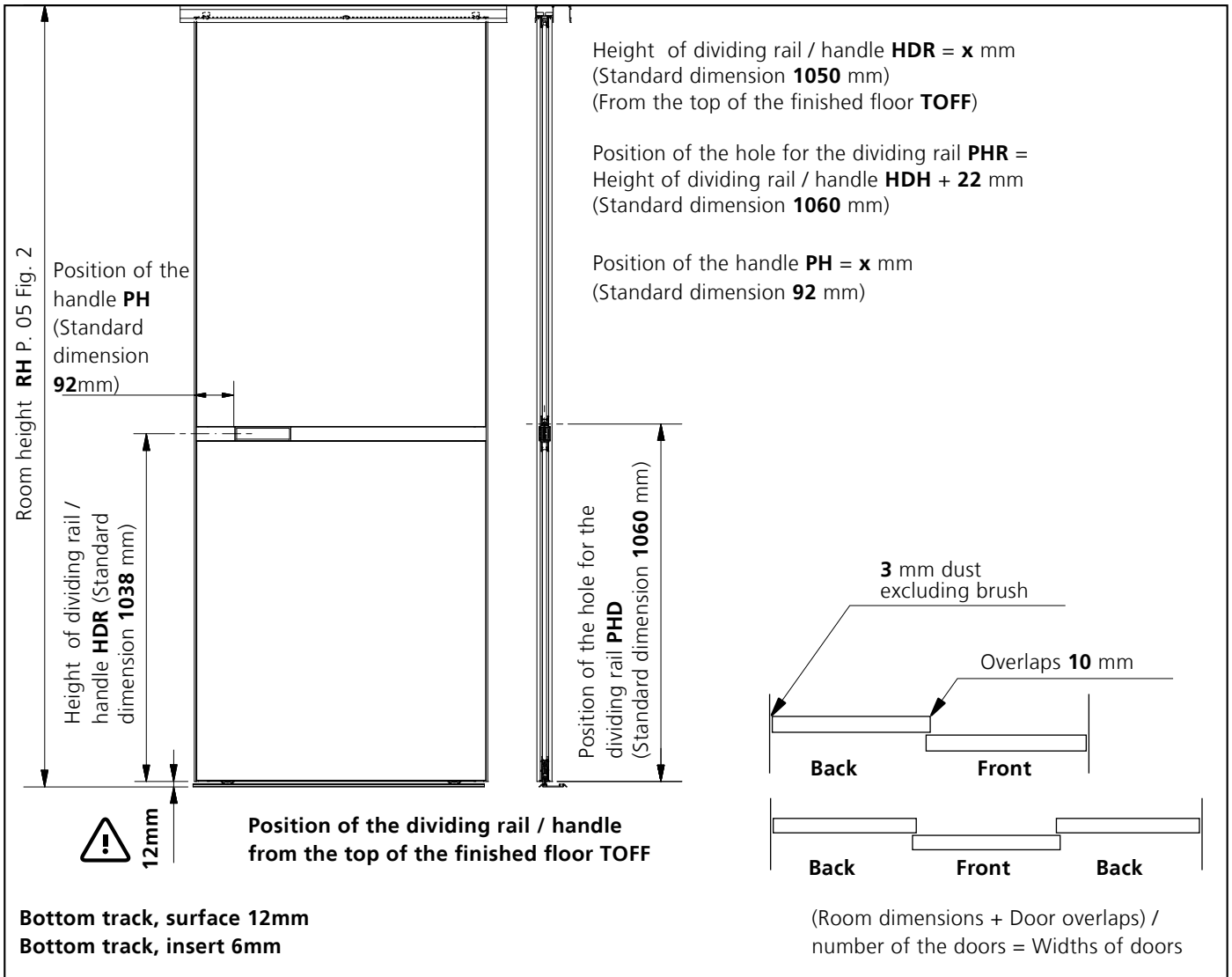
2\_ Cross section vertical / cutting dimension



3\_ Drill hole in vertical profile

# CUTTING DIMENSION

## DIVIDING RAIL AND HANDLE S800



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

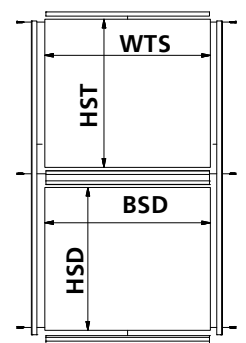
### Cutting dimension Stabilizing panel 8mm

Height stabilizing panel top **HST** = Door height **DH** - Height of dividing rail / handle **HDR** - **50mm**

Width stabilizing panel top **WST** = Door width **DW** - **52mm**

Height Stabilizing panel down **HSD** = Door height **DH** - Height of dividing rail / handle **HDR** - **82mm**  
(Standard dimension **956 mm**)

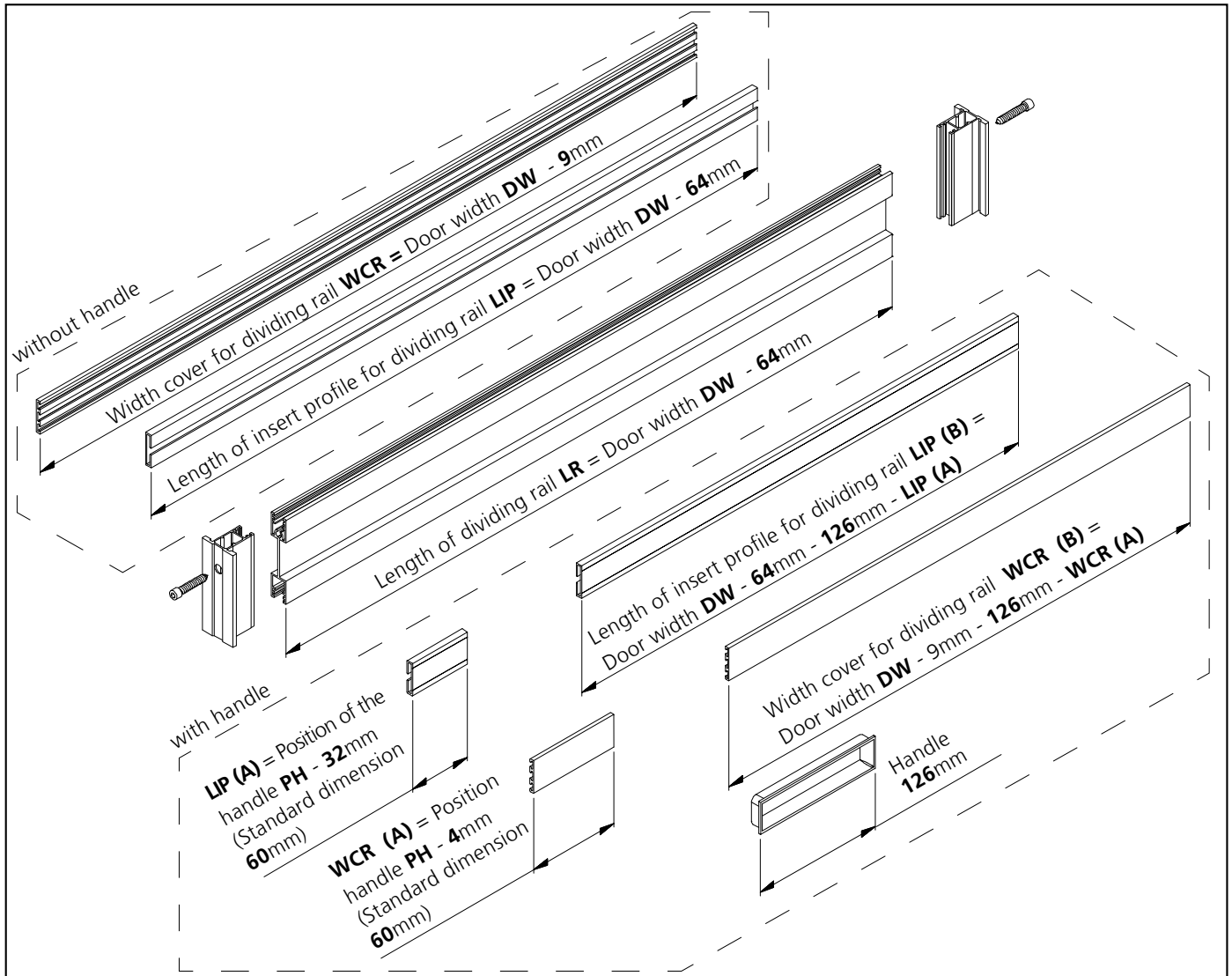
Width Stabilizing panel down **BSD** = Door width **DW** - **52mm**



### 5\_ Cutting dimension stabilizing panel

# CUTTING DIMENSION

## DIVIDING RAIL AND HANDLE S800



6\_ Cutting dimensions for handle and dividing rail

### Cutting dimensions for glass panel 4mm glass

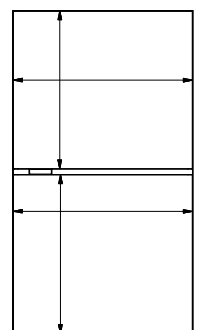
Height glass panel top  $HGT = \text{Door height } DH - \text{Height of dividing rail / handle } HDR - 17\text{mm}$

Width glass panel top  $WGT = \text{Door width } DW - 9\text{mm}$

Height glass panel down  $HGD = \text{Height of dividing rail / handle } HDR - 18\text{mm}$

(Standard dimension 1020 mm)

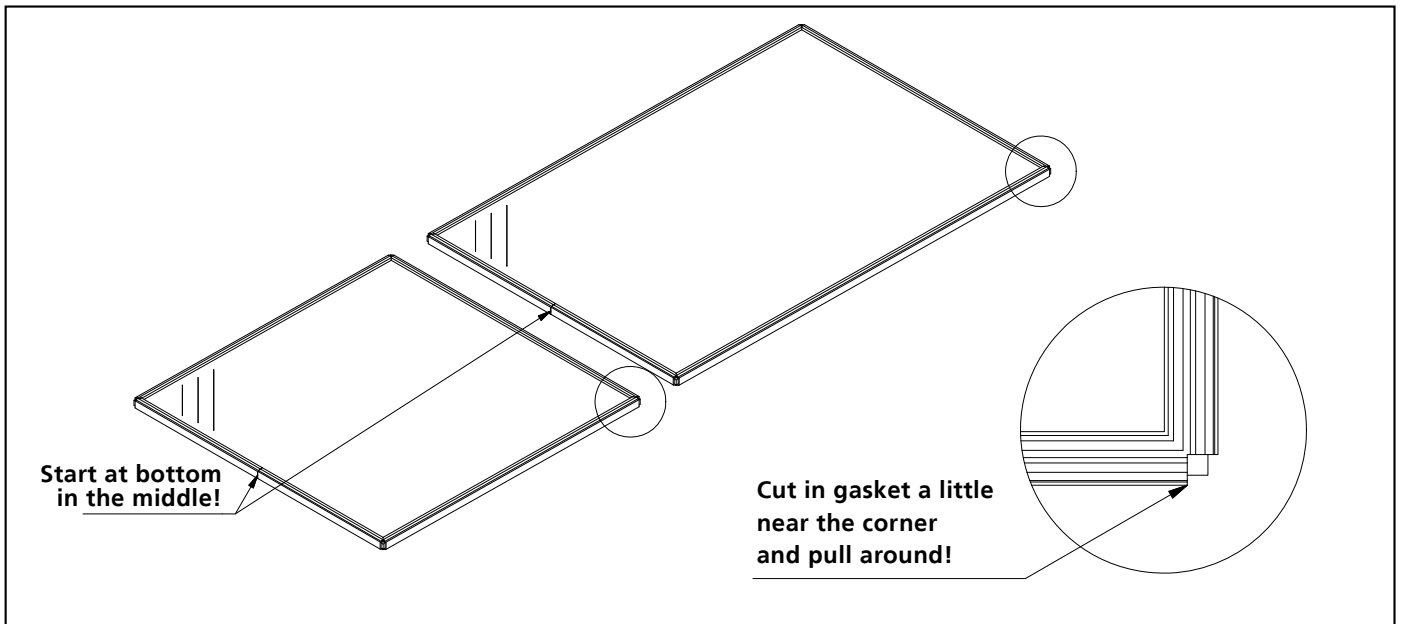
Width glass panel down  $WGD = \text{Door width } DW - 9\text{mm}$



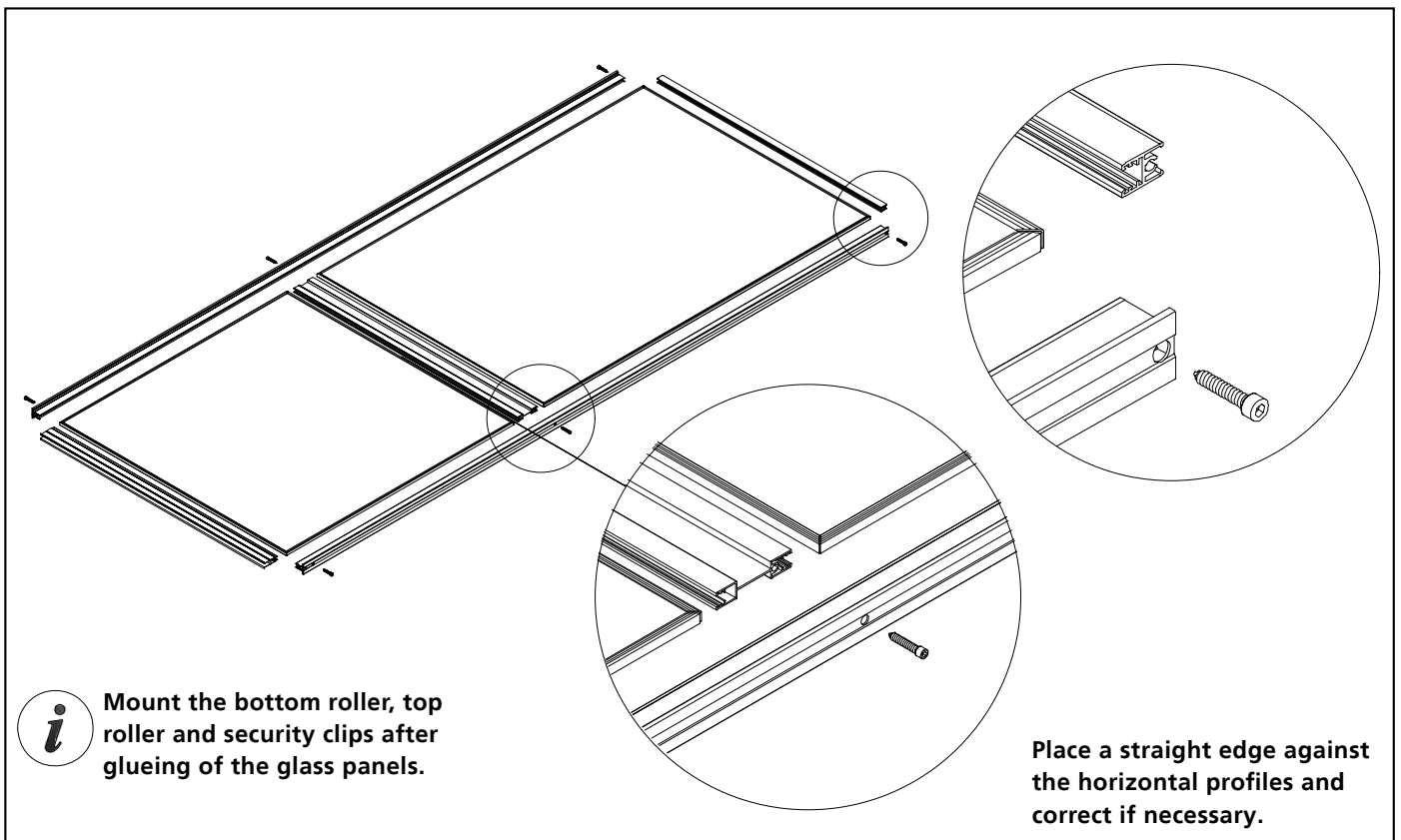
7\_ Cutting dimensions for glass panel

# ASSEMBLY INSTRUCTIONS

## STABILIZING PANEL



1\_ Place panel on a table, affix gasket

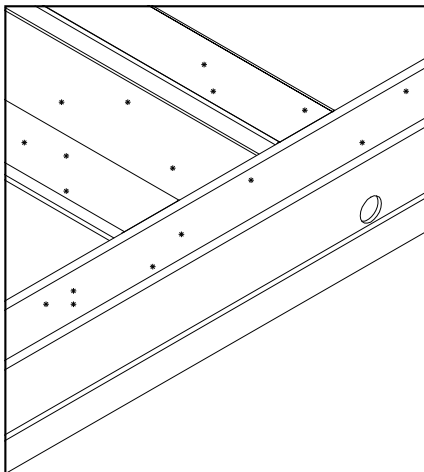


2\_ Attach the vertical profile and the cross profiles, pound it well with the rubber hammer



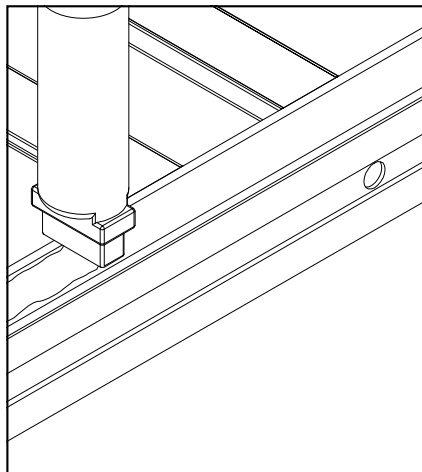
# ASSEMBLY INSTRUCTIONS

## PREPARATION OF ADHESIVE SURFACES



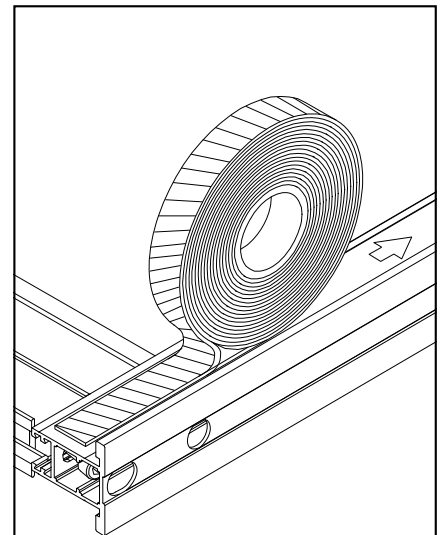
Clean the adhesive surfaces on the profiles and on the back of the glass with 3M cleaner. Use lint-free cloths such as e.g. 3M 34567. The surface has to be free of grease, oil or silicone films as well as dirt particles.

3\_ Clean the adhesive surfaces



Apply a thin layer of primer 3M 94 to the adhesive surfaces, then wait approx. five minutes until all of the remnants of the primer have evaporated.

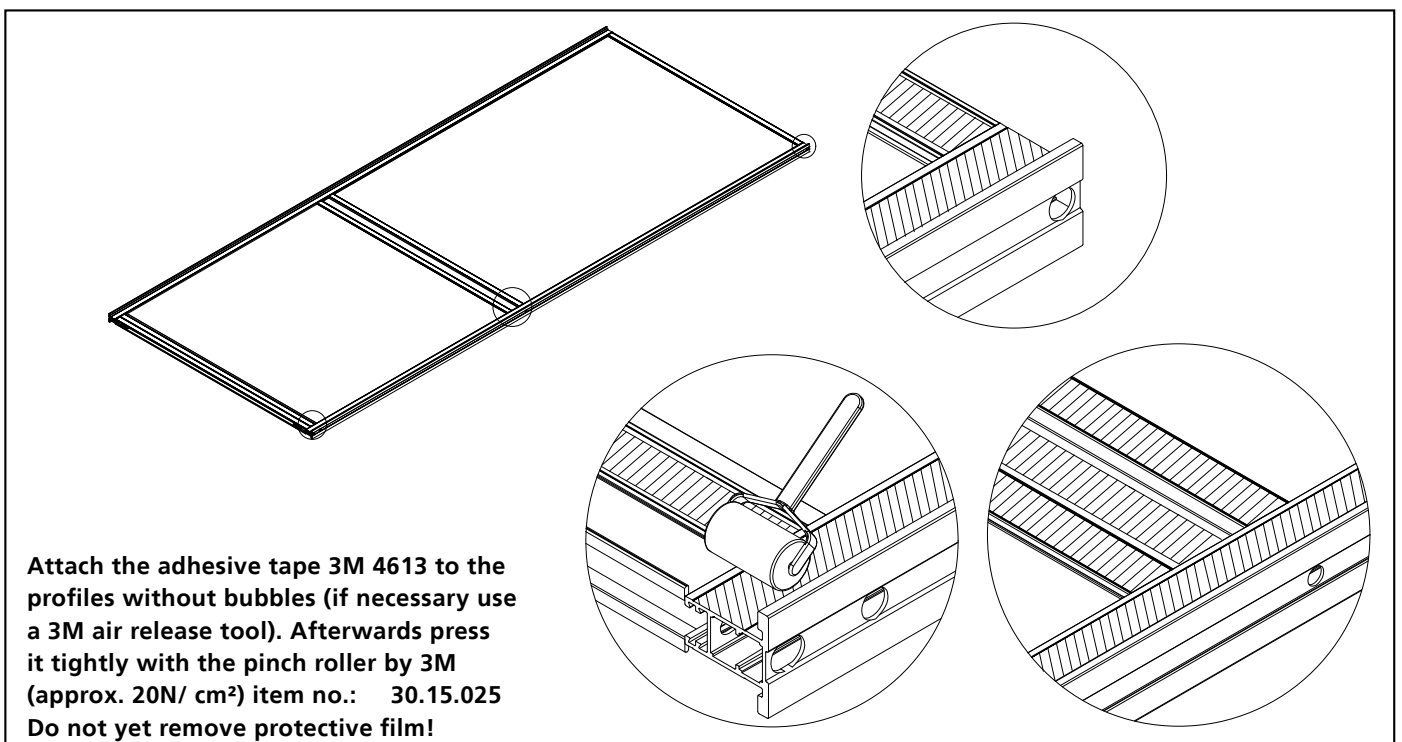
4\_ Apply primer



The processing temperature should not be below 20°C!



5\_ Affixing tape

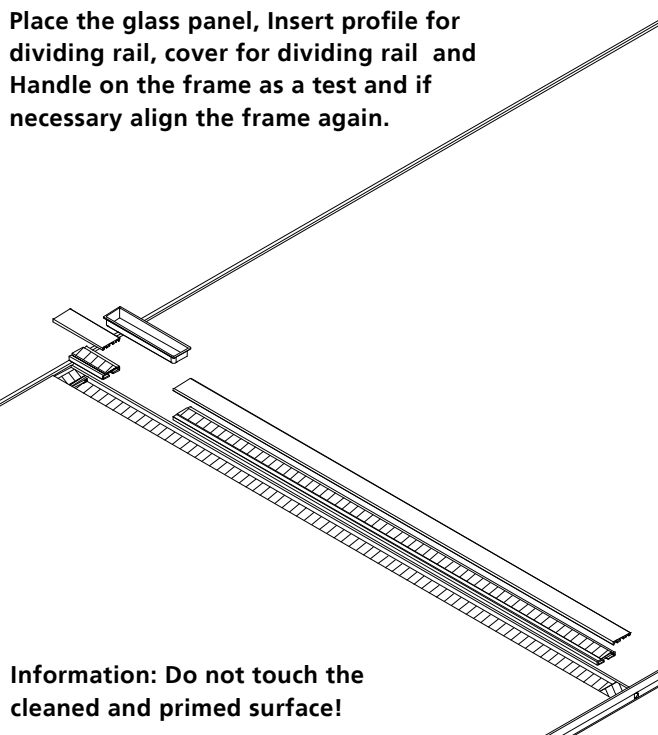


Attach the adhesive tape 3M 4613 to the profiles without bubbles (if necessary use a 3M air release tool). Afterwards press it tightly with the pinch roller by 3M (approx. 20N/ cm<sup>2</sup>) item no.: 30.15.025 Do not yet remove protective film!

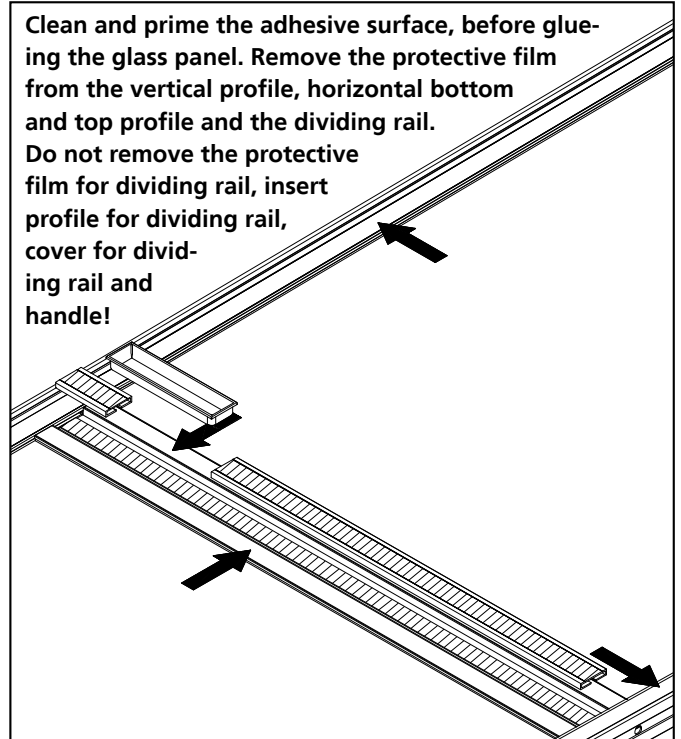
6\_ Press on tape

# ASSEMBLY INSTRUCTIONS

## GLUING THE GLASS PANEL

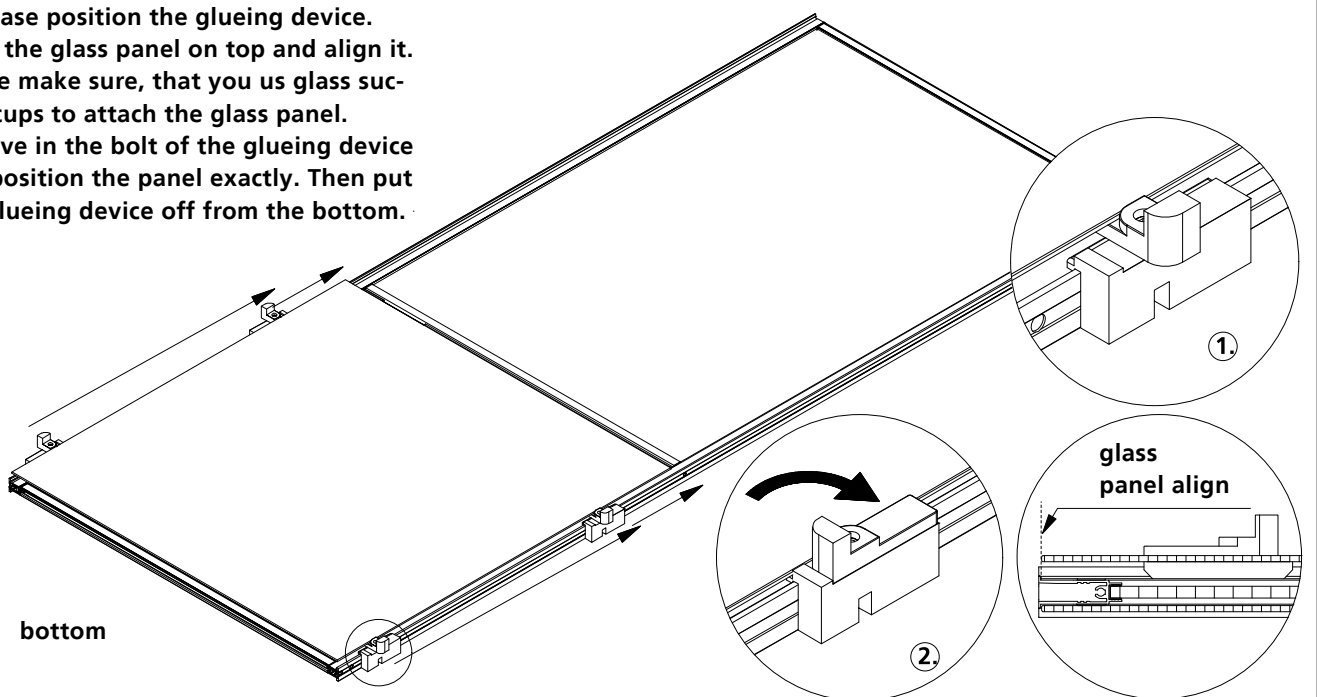


7\_ Preparation of glueing



8\_ Preparation of glueing

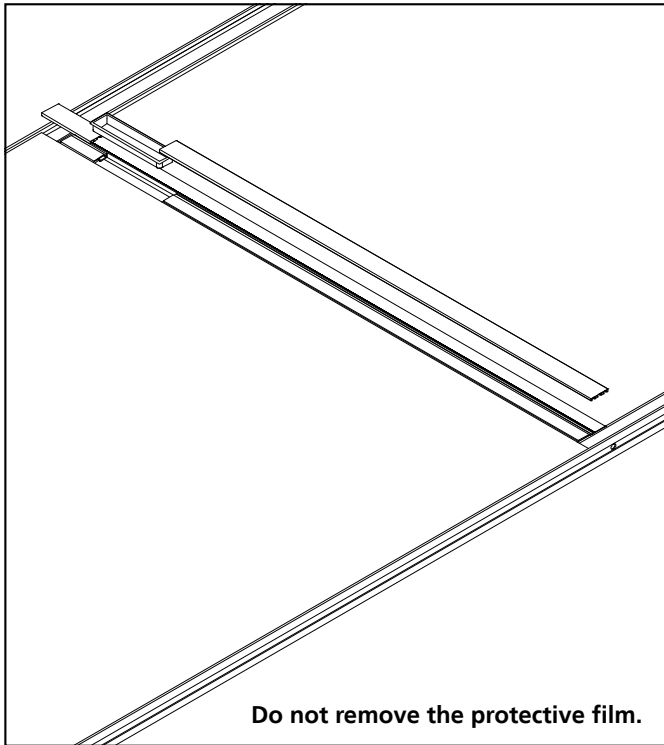
1. Please position the glueing device. Place the glass panel on top and align it. Please make sure, that you use glass suction cups to attach the glass panel.
2. Drive in the bolt of the glueing device and position the panel exactly. Then put the glueing device off from the bottom.



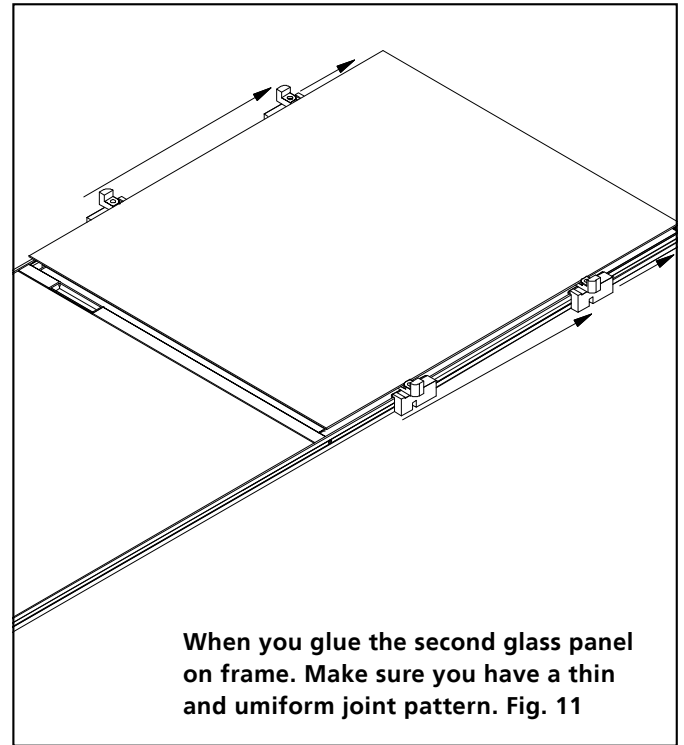
9\_ To glue on the glass panel, 2 installers might be needed depending on the door size. Precision work is very important!

# ASSEMBLY INSTRUCTIONS

## INSERT DIVIDING RAIL & HANDLE

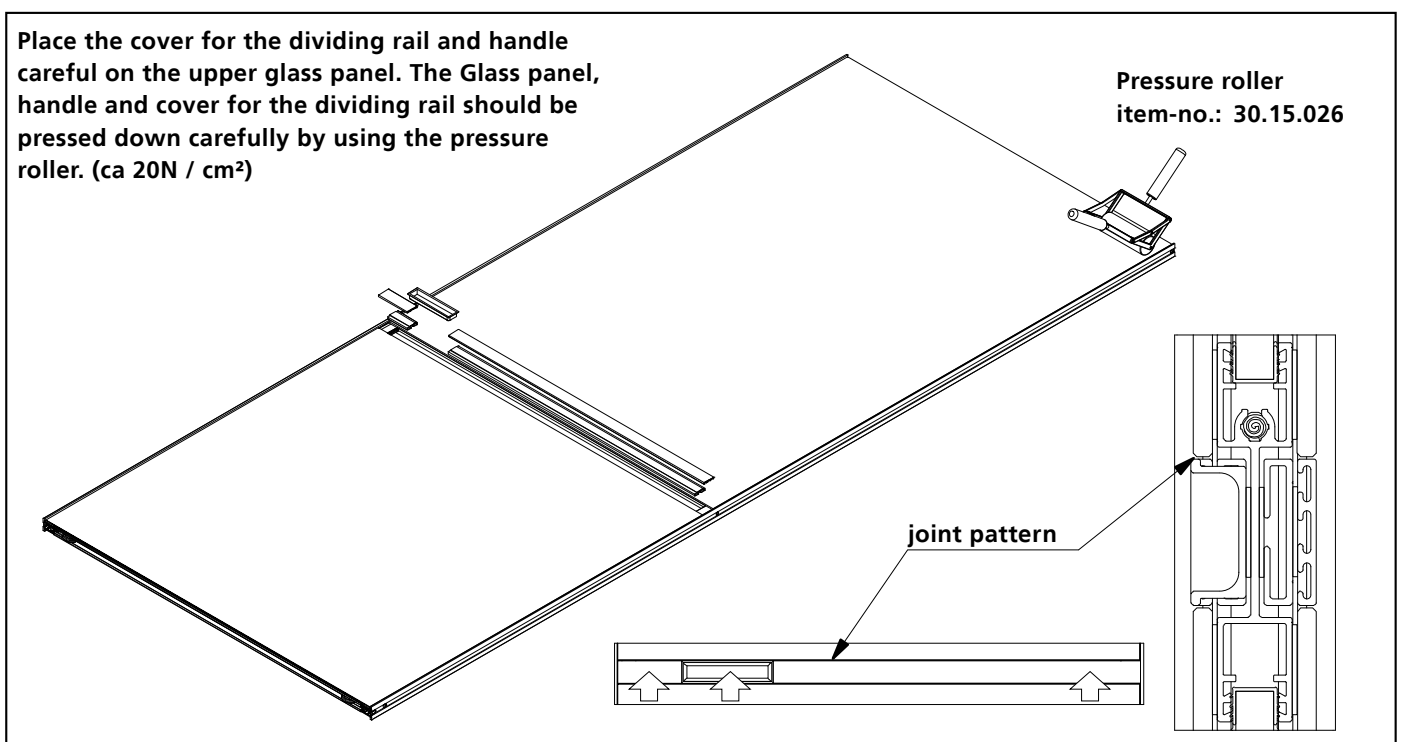


10\_ Insert the insert profile, cover and the handle



11\_ Glue the second glass panel

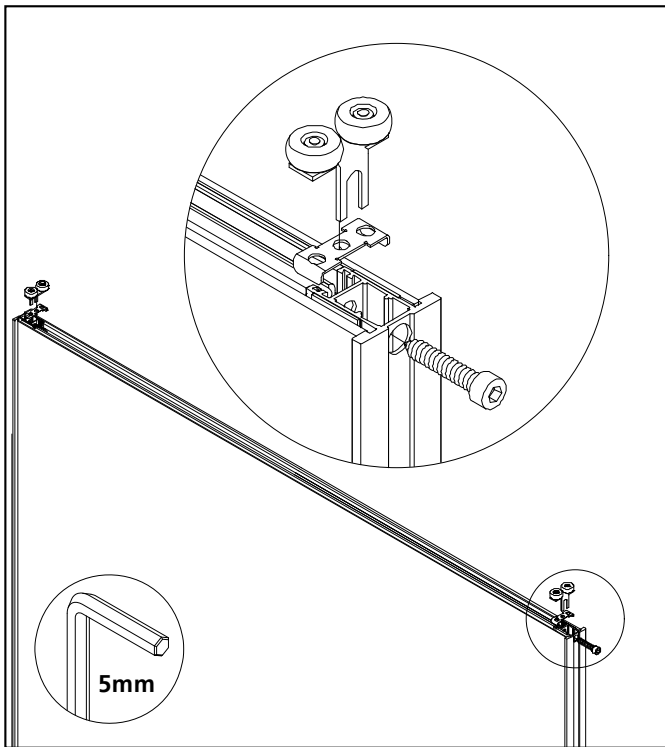
Place the cover for the dividing rail and handle careful on the upper glass panel. The Glass panel, handle and cover for the dividing rail should be pressed down carefully by using the pressure roller. (ca 20N / cm<sup>2</sup>)



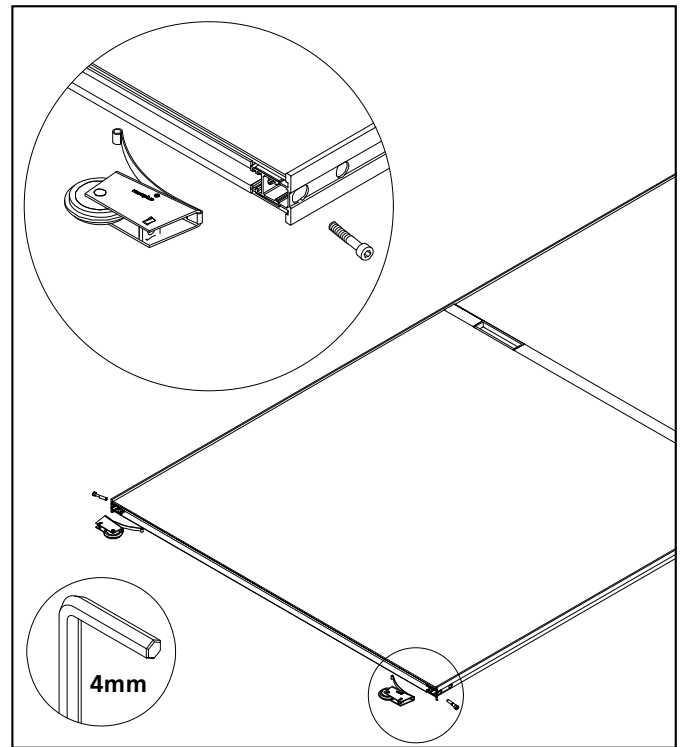
12\_ Use the insert profile for dividing rail, cover for dividing rail and the handle

# ASSEMBLY INSTRUCTIONS

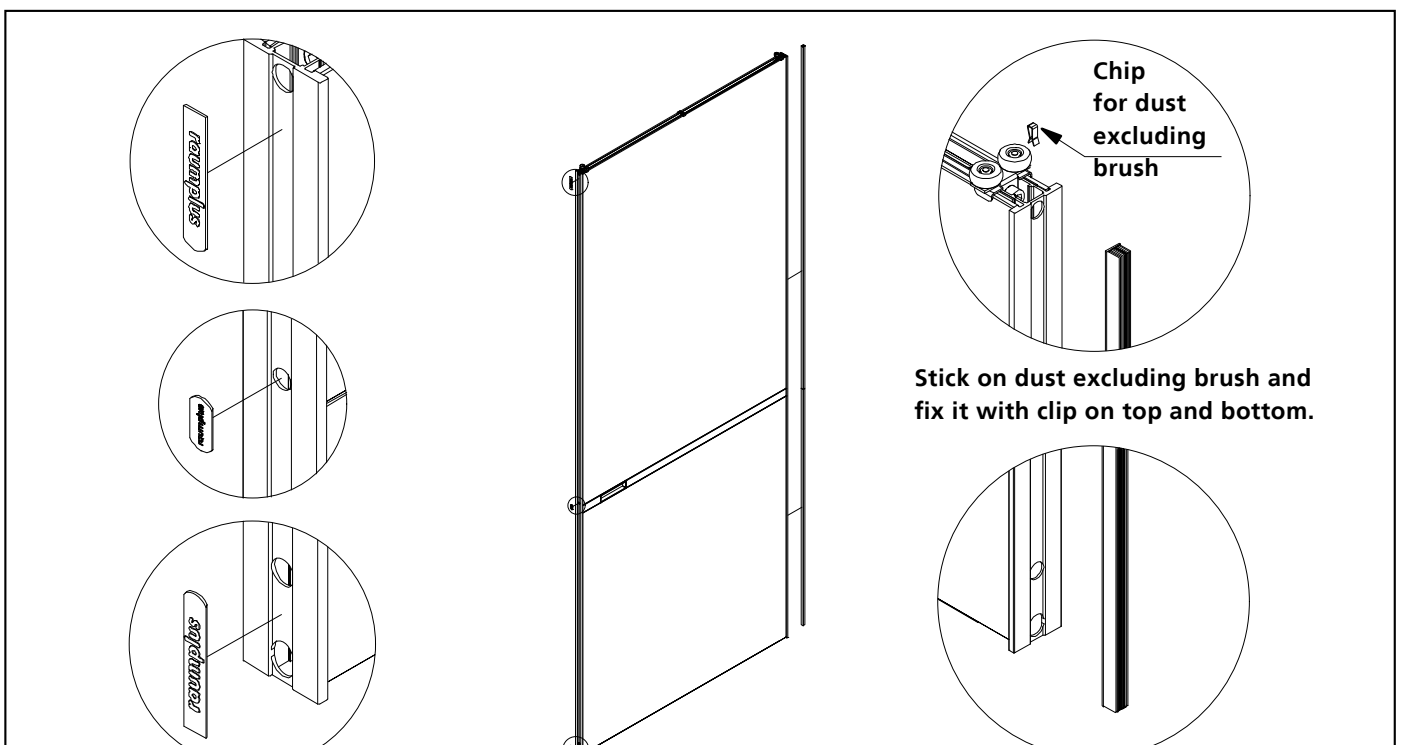
## USE OF THE ROLLERS



13\_ Insert the top roller / Security clips



14\_ Insert the bottom roller



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