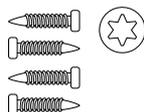


## General information about delivery completion:

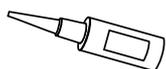
- It may be the case that the product will not be fully assembled at the factory due to the size of the construction (raising logistical issues).
- The product will be assembled at the factory as far as possible, but then needs to be finished on the building site.

## Installation material:



### 1. Screws for assembling profiles

Required quantity included in delivery



### 2. Sealing compound

VISCOSEAL P/N 12220.

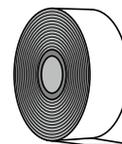
Included in delivery



### 3. ALU surfaces cleaner

(Blaugelb Cleaner Alu-ELP, for example).

Not included in delivery



### 4. Butyl tape

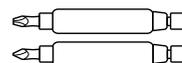
Included in delivery

## Installation tools:

Not included in delivery.

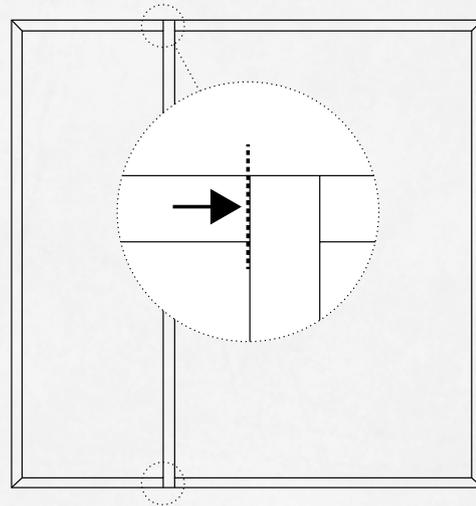
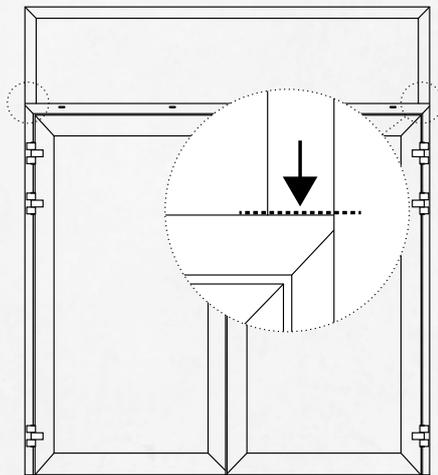


### 1. Cordless screwdriver



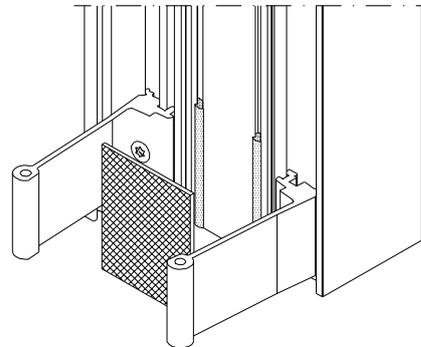
### 2. Magnetic bits

## OPTION 1: 90 Degree (straight) connections

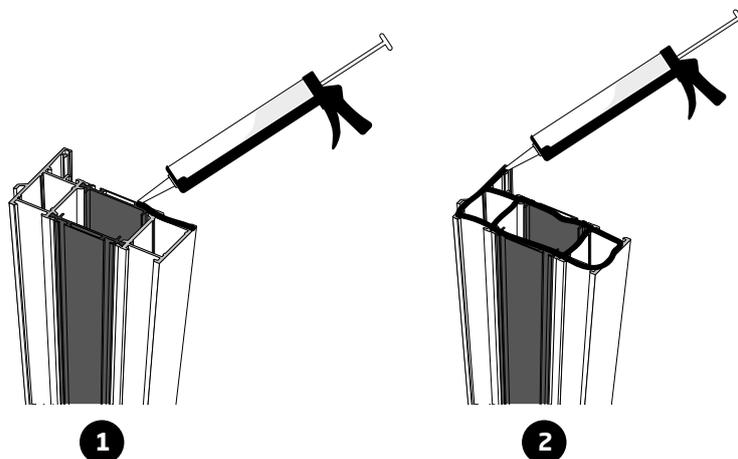


**Step 1.1** Bar cleats will be installed and butyl tape (black tape between bar cleats) will be glued on at the factory.

**NB:** after assembling the profiles, cut of any excess butyl tape (keep a 2mm excess on each side).

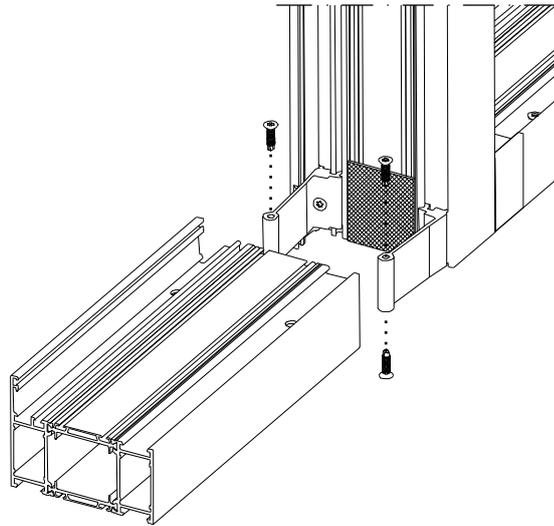


**Step 1.2** The end of the connecting profile needs to be sealed using a sealing compound, P/N 12220 (applies to external constructions only).



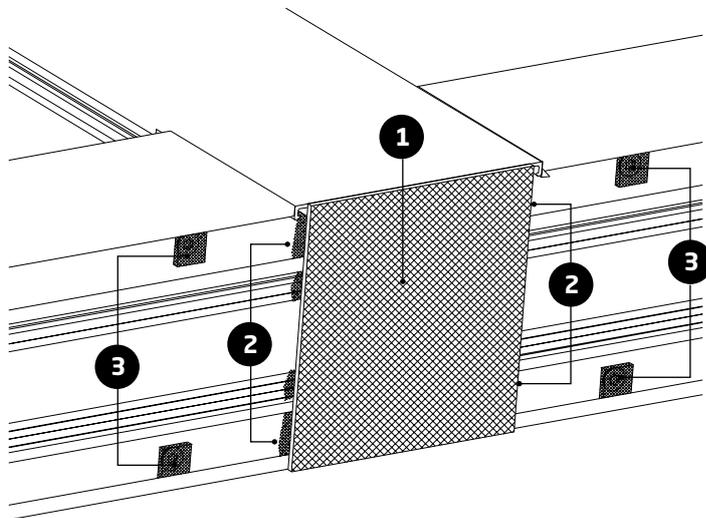
**Step 1.3** Assemble profile with bar cleats according to picture, right, by using Torx magnetic bits, T20. Holes for screws will be predrilled into the profile at the factory.

**Step 1.4** Clean the overflow of any sealing compound, P/N 12220, removing it from the profiles by using ALU surface cleaner (such as Blaugelb Cleaner Alu-ELP) if sealing compound has been used.



#### General instructions for sealing 90 degree (straight) connections after assembly

**NB:** applies to external constructions only.



#### Sealing cross-bar connections

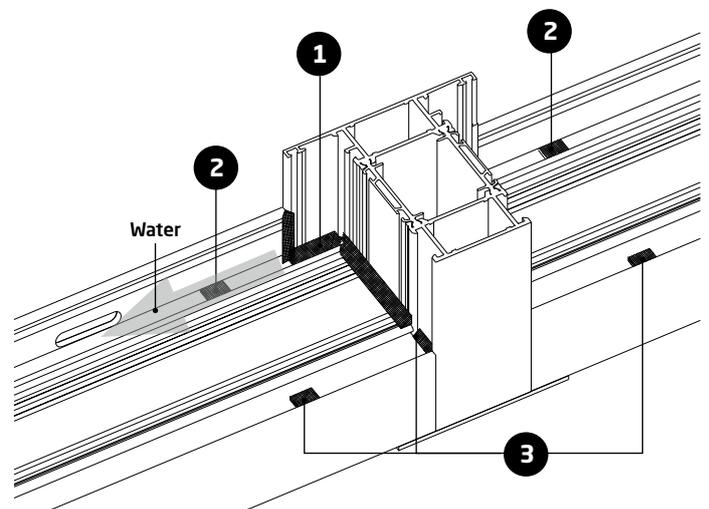
- 1** Seal slots in outer profile groove with P/N 12220 sealing compound.
- 2** Seal screws using P/N 12220 sealing compound.

**NB:** do not use too much compound to ensure that the path towards the drainage hole remains clear.

- 3** In a humid indoor environment seal the inner section screws with P/N 12220 sealing compound.

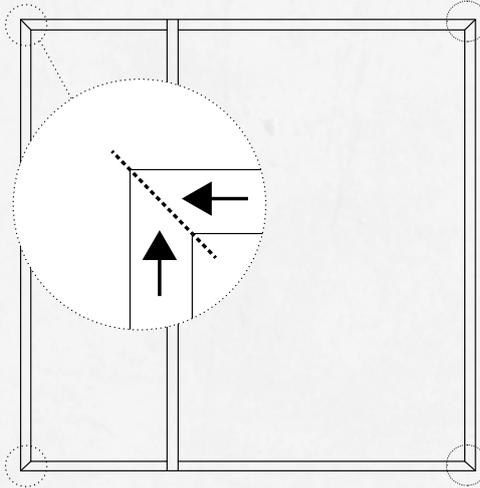
#### Sealing open profile section ends

- 1** Open profile section ends to be sealed with butyl tape.
- 2** Open Slot in profile around butyl tape to be sealed with P/N 12220 sealing compound.
- 3** Screws at the open end are to be sealed using P/N 12220 sealing compound.

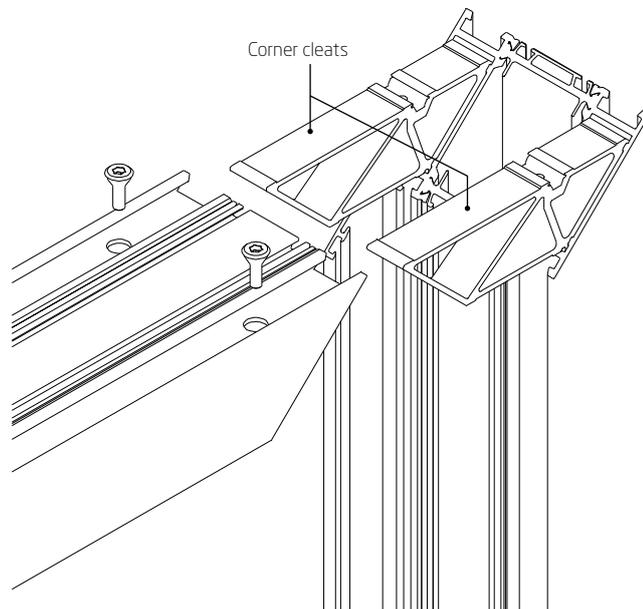


## OPTION 2:

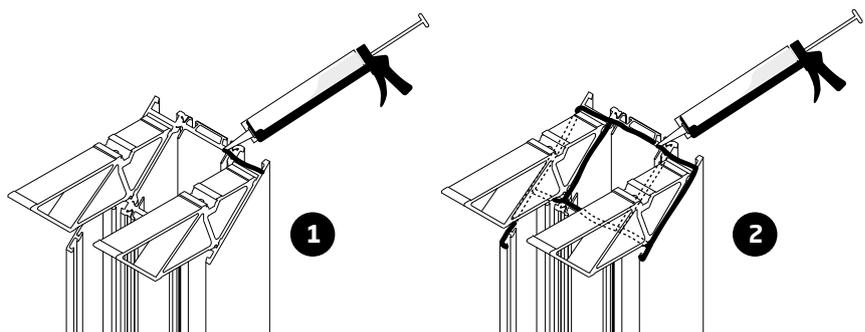
### 45 Degree (corner) connections



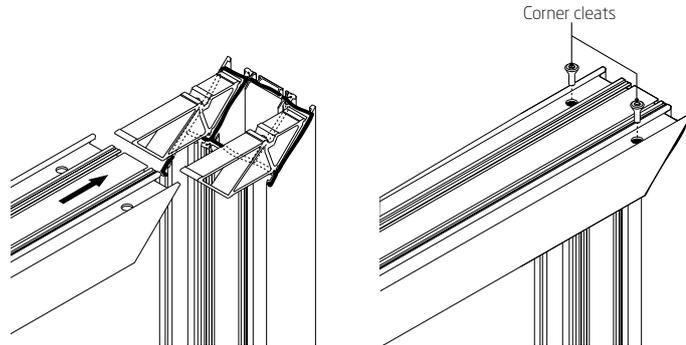
**Step 2.1** Corner cleats will already have been inserted in one of the connecting profiles at the factory.



**Step 2.2** One end of connecting profiles needs to be sealed using P/N 12220 sealing compound (applies to external constructions only).



**Step 2.3** Mount corner cleats by tightening the screws (with the help of Torx magnetic bits, T25) alternately and in two steps so the eccentricity is divided equally. A tightening torque, 3.0-3.5Nm, is advised. Do not use powered pulsating screwdrivers. Holes for screws will be predrilled into the profiles at the factory.



**Step 2.4** Clean overflow of any P/N 12220 sealing compound from the profiles by using an ALU surface cleaner (such as Blaugelb Cleaner Alu-ELP) if a sealing compound was used.

