

## 5.4 FD30 door leaf glazing instruction

### Step 1

Always have the recommended tools available. The solid bench/work surface should be protected and clean to avoid marking the door or cassettes. Ensure all necessary personal protective equipment is worn to prevent the risk of injury. Position the door blank (two-person lift) external face down upon the work bench, with the glazed side raised using your rubber mallet or a block by circa 150mm, to allow ease of cassette introduction when glazing. Ensure the door and glass surface contact points are clean, dust and grease free.



### Step 2

Begin by removing the breakout flanges from both the inner and outer cassettes to accommodate the two-part fds steel fire glass retention clips. Taking care, use a Stanley knife to score along the horizontal base line.



Then using a hack saw cut vertically down either side to meet the base line and carefully remove using pliers.



### Step 3

Offer one of the cassettes into the aperture cut out ensuring it is square-central and mark off the clip positions onto the foam core.



Remove cassette from the aperture and present the base clip centrally over the marks, with the up-stand positioned to the external door skin and pilot holes for the clip feet. Position using a small pin or plastic head hammer ensuring the external feet straddle the door inner and outer GRP skins, seated positively. Then introduce the secondary clips with the internal feet passing through the slots in the base clip into foam and the long external foot locating on the outside of the skin face.



### Step 4

Remove all clips to permit the installation of the required Loriant GP3002 intumescent strip. Measure and cut one strip to required length. Using the Alansons 1107 sealant apply a 5mm bead centrally to the foam core, around the full aperture cut out.



Then apply the intumescent strip starting at the base, central clip position, working your way around the aperture ensuring the intumescent sits neat, flush and central to the core, and overlaps at meeting point.



### Step 5

Reposition all base clips over the top of the intumescent strip ensuring that the steel clip feet straddle over both external and internal skins.



### Step 6

Clean thoroughly the inner and outer up-stand rebate leg channels of both cassettes using fds industrial wipes and dry off using industrial type paper roll, ensure surfaces are dust/grease free.



Take the external glazing cassette and apply 1 x 8mm bead of Alansons 1107 sealant to the outer rebate leg where cassette meets GRP skin face, then 2 x 8mm beads where the cassette meets the DGU glass face, along with a bead within the female connector cavity. Slide the cassettes into position beneath the raised door blank, remove raised 150mm block and lay the external door face flat over the cassettes. Check the steel clip upstands are sitting central between the relived cassette areas and cassette is central within the glazing aperture.



## Step 7

Carefully position the fire resistant DGU ensuring its correct orientation (refer to Fig 1) ensuring it is square within the cassette. Backfill with Alansons 1107 the full void between 2-part steel glazing clips.



Introduce the secondary fire glass retention steel clip, make certain that the long external foot is positioned over the outside of the internal skin and persuade it into position using a small pin or plastic head hammer.



## Step 8

Take the internal glazing cassette and apply 1 x 8mm bead of Alansons 1107 sealant to the outer rebate leg where cassette meets GRP skin face, then 2 x 8mm beads where the cassette meets the DGU glass face, along with a bead within the female connector cavity.



Offer the internal cassette over the external cassette ensuring that the male and female connectors are aligned. Working around the cassette apply pressure using the heel of your hand to push the internal cassettes down to meet the external cassette and mate the connectors.



## Step 9

Carefully use a rubber mallet, protected with a piece of card and gently work your way around the perimeter of the cassette persuading it into position and sitting flush to skin face, taking note that the cassette local to fire clips may be slightly raised.



Using a plastic scraping spatula remove the excess sealant between both the glass-cassette and door-cassette. Use the fds universal wipes and liquid spray to clean remaining residue. Turn the door over (two-person lift) checking that the cassettes have mated and sitting flush and repeat the process using hand or mallet. Finally remove the excess sealant on the external door face as explained above. Stand the door vertically for approx four hours to permit sealant to cure and prevent ruptures or further cleaning.



## FD30 Dry Graphite Glazing Guide

1107 + Lorient GP3002 Cavity

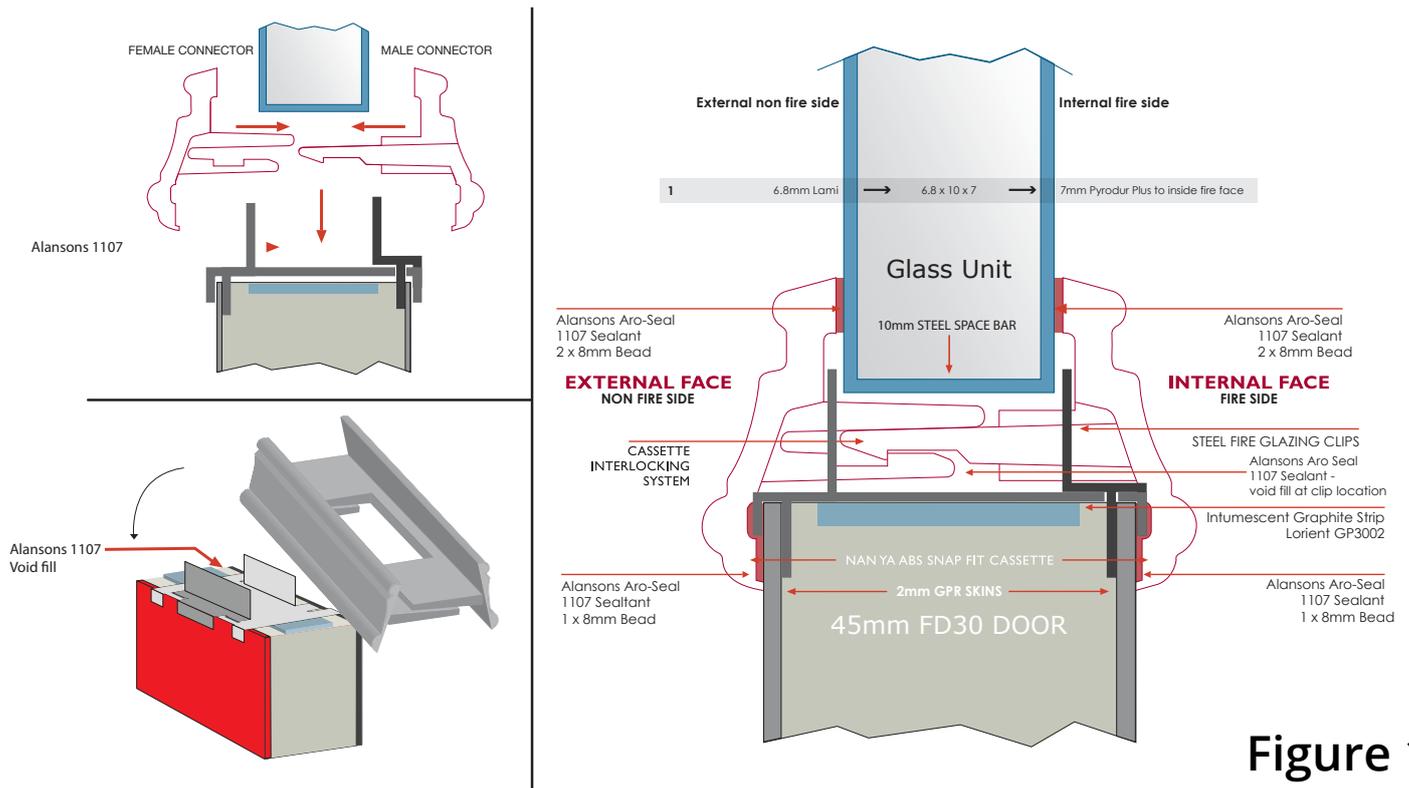


Figure 1