

Installation and maintenance

– Glazing beads, sealing strips, etc.

The procedure is as follows:

Bottom glass mouldings

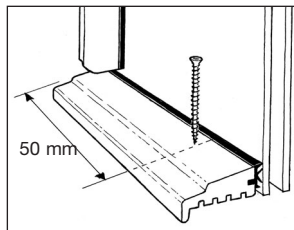
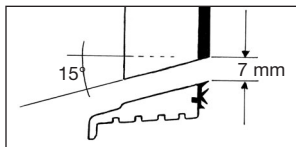
Cut the bottom glass moulding using a fine-toothed saw or a mitre cutter in a straight line. Attach using stainless steel nails or screws at a distance of no more than 150mm (or a maximum of 50mm from an edge).

NB: Avoid inserting nails through the ventilation holes of profiles.

Glazing beads

Cut the associated glazing beads. In the top corners, cut a bevel of 45°. At the bottom, cut the profile at an angle which corresponds to the 15° angle of the bottom glass moulding. Leave a gap of 7mm between the two vertical profiles and the bottom glass moulding to allow ventilation. The glazing beads should be nailed or screwed in place as described under "Bottom glass mouldings".

NB: Do not paint glazing beads in a dark colour.



Avoid passing nails or screws through the ventilation holes of the bottom glass moulding.

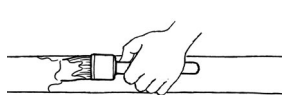
Painting guidelines



Degrease the profile using base cleaner.



Wet-sand the profile using a sanding block or sandpaper.



Paint the profile with a pure 100% acrylic paint or enamel. Minimum of two coats.



The procedure is as follows:

General considerations concerning sealing strips

Sealing strips should not be fitted prior to any vacuum impregnation/painting and normal degassing.

When using sealing strips, sufficient space should be left in the frame to enable the sealing strip to continue to function.

You should therefore prevent the strip with the installation unit in the closed position from being completely pressed together. The strip would otherwise lose its ability to spring back and consequently its sealing ability.

Weather strips

For strips with springs, shaped nylon wheels with a shaft can be used.

Weatherstrips

When the hard part forms a firm and stable point of attachment, installation can be carried out using clamps from an air gun. The air pressure must not be set higher than that necessary to ensure that the clamp is level with the top of the profile after clamping. The distance between clamps

should be such that there is no air between the abutting surfaces after installation.

Welding sealing strips

For corner joints, 45° mitre clips can be used, which are welded together. For profiles which are to be made into welded frames, PRIMO is suitable with regard to shaped welding blocks and different shapes for welding machines.

Weatherstrips

Strips can be cut at an angle of 45° without clipover of the profile using special tongs (see page 4.03). The profile is then bent around the corner. When using profiles with cord, insertion is made easier and tearing apart is prevented. Many of our weatherstrips also have a hard back, which makes installation much easier.

Lubricant and talcum powder

Many profiles, particularly weatherstrips, are supplied with a lubricant to make installation easier. Talcum powder is applied to all silicone profiles, both internally and externally.

TPE = Thermoplastic elastomers

Specific gravity	DIN 53479	g/cm ³	1,17
Breaking strength	DIN 53504	N/mm ²	5,0
Strain	DIN 53504	%	630
E-modulus	DIN 53457	N/mm ²	-
Hardness Shore A	DIN 53505	-	58 ± 5
Pressurisation test 70t 23°C	DIN 53517	%	17
Use temperature	-	°C	+ 40 + 80
Deformation-resistant method	ADIN 53461	°C	-
Water adsorption	DIN 53495	%	<0,01
Colour	RAL	-	Grey, white and black
Welding properties	-	-	Extremely good

Chemical resistance

Resistant to

Salt water
Diluted acids and bases
Water-based acrylic paints

Not resistant to

Solvents
Mineral oils

TPE is a PVC-free material, which is suitable for outdoor use. The material has particularly good welding properties.