

SI

SM102E – Replacing glass

Service instruction

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Part number	N/A
Part description	PS1/PS2/RS/IG

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File name	SM102E Repairing damaged glass
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Revision history

Revision	Date	By	Description
6.0	2024-07-08	Henk-Jan Postma	Updated and restyled
5.0	2024-03-25	Martin Rewti	Updated and restyled
4.0	2023-06-09	Elroy Kingma	Manual Refreshment
3.0	2018-07-03	Victor Linting	Reference changed from ISO 9001:2008 to IATF 16949:2016. Layout of document changed.
2.0	2016-07-01	Hotze Gerrit Waterlander	Figure 6: replaced “Bottom” by “Top”
1.0	2014-06-03	Klaas- Teake Slager	First release



Preface

The Quality System of Ventura Systems is accredited to EN ISO 9001:2015

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1 Introduction

1.1 Purpose

The purpose of this service instruction is to describe the process of removing and bonding a glass panel to a Ventura door frame.

1.2 Scope

This service instruction applies to all Ventura door PS and RS frames.

1.3 Definitions

Definition	Description
N/A	

Table 1: Definitions

1.4 Acronyms and Abbreviations

Abbreviation	Description
PS	Plug sliding door system
RS	Rapid sliding door system

Table 2: Acronyms and abbreviations

1.5 References

1.5.1 External documents

Reference	Description	Date
IATF 16949:2016	Automotive quality management system standard	2016-10-01
ISO 9001:2015	ISO Standard for Quality Management Systems – Requirements.	2015-10-01

Table 3: External documents

1.5.2 Ventura documents

Reference	Description	Date
MM	Ventura's Maintenance manual for the correct door system	N.A.
IM	Ventura's Installation manual for the correct door system	
SM014E	Replacement of an O-rubber	03-07-2018
IP002E	Inspection protocol for glass	03-10-2020

Table 4: Ventura documents

1.6 Tools

Tool	Description	revision	Date
Knife			
Worktable			
Paint scraper			
Cutting wire			
Caulking gun			
Clamps			
Safety goggles			
Safety gloves			

Table 5: Required tools

1.7 Material



Material	Description	revision	Date
Cleaning paper			
Sealing tape	9x3 mm seals for windows and doors		
Double-sided tape	Bostik foam tape 12x3 mm		
Degreaser	Bostik Simson Cleaner I		
Primer	Bostik Simson prep M		
Adhesive sealant	Bostik Simson ISR 70-08 AP		
Scrap cards	Any plastic card will do		
Window cleaner	Any glass cleaner will do		

Table 6: Required material

2 Instruction

2.1 Remove the glass from the door frame

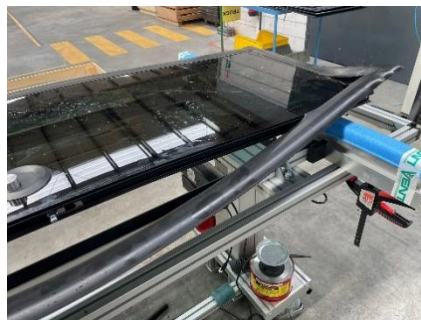
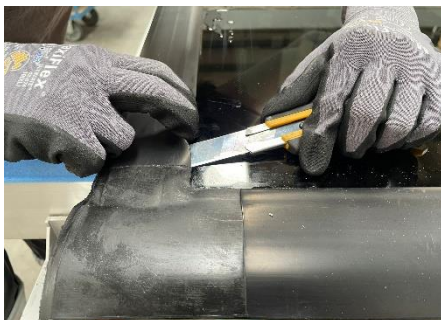
Step 1

Place the door leaf on a worktable or work stand with the glass upwards.



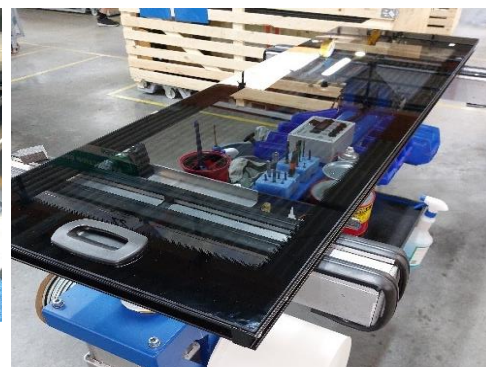
Step 2

Cut the sealant in the corners with a knife between the rubber and the glass. Then push the rubber out of the door frame.



Step 3

Disconnect the connector of the sensitive edge and remove the rubber from the door leaf.



NOTICE

Remove the buttons from the glass before cutting.

Contact our support department when you are unsure how to remove the button.

Step 4

Use cutting wire to cut through the sealant and sealing tape. Place it between the glass and the frame.

Pull the wire a bit upwards when sawing, so the frame doesn't get damaged.



Step 5

When all the sealant has been cut through, you can remove the glass from the frame.



2.2 Cleaning the door frame

Step 1

Remove the sealant and sealing tape by using a paint scraper. Make sure to not damage the powder coating.



Step 2

Use a scrap card to scrape of the last remains of sealant and sealing tape off the frame.
Use degreaser to make it easier to scrape off the last remains.



Step 3

The frame should be as clean as the frame in the picture on the right.



2.3 Placing glass on the door frame

Step 1

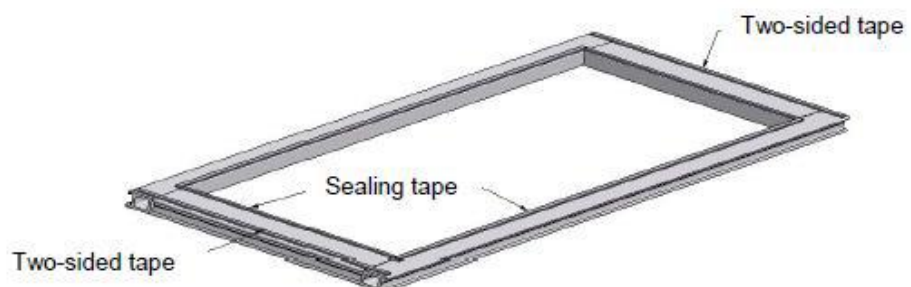
Check if the new glass has cracks or scratches (see IP002E for glass inspection).

Step 2

Clean the door frame using primer (Bostik Simson Prep M) and cleaning paper.

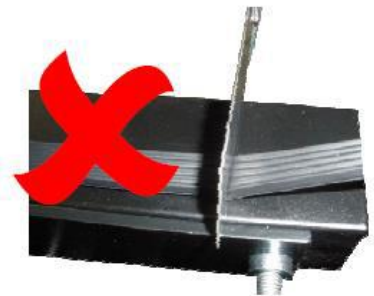
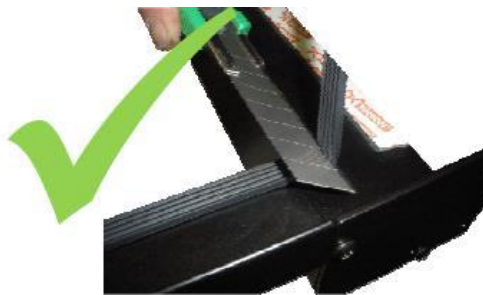
Step 3

Apply sealing tape (9x3 mm) on all four sides of the door frame and two sided tape (12x3 mm) at the top and bottom of the profile.



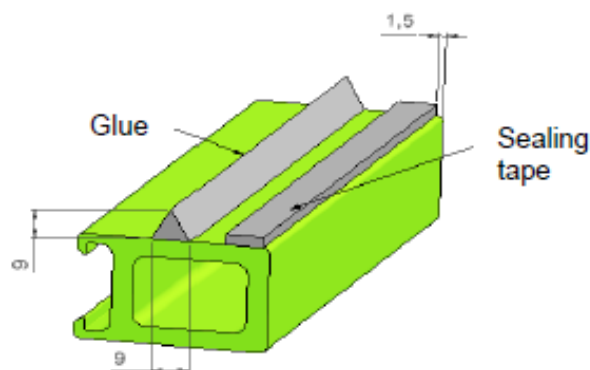
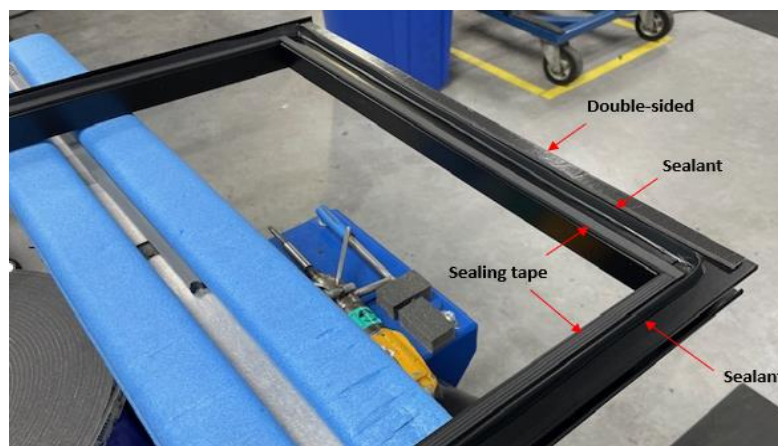
See the picture right for the correct way of cutting the sealing tape.

Cut the double-sided tape with a knife. It is important the powder coated layer on the door frame doesn't get damaged. Cut the tape according to the picture right. Please note that the sealing tape must touch each other in all corners. There should be no space between them.



Step 4

Apply sealant (Simson ISR 70-08 AP) to the outer flat service of the entire door frame. The application temperature should be between +5°C and +35°C.

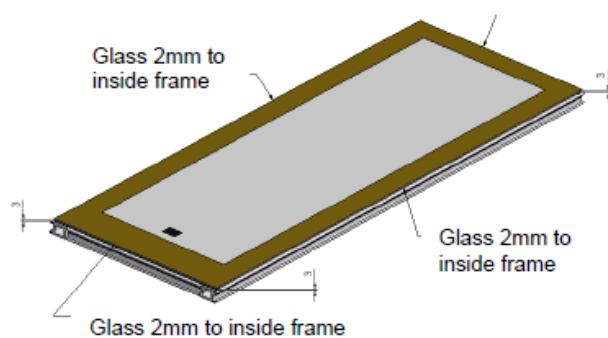


Step 5

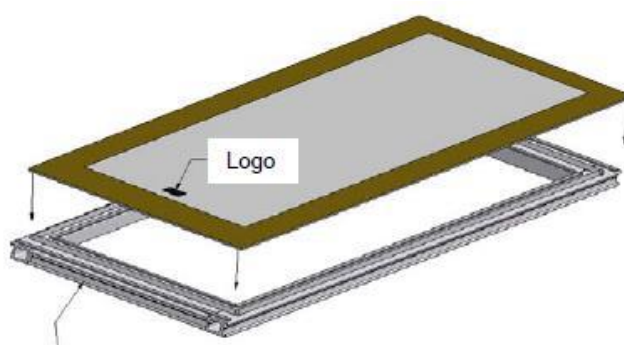
Remove the backing tape from the double-sided tape.

Step 6

Position glass onto the frame. Ventura logo according to figure 9 and 10. When the panel is a single glass, position the glass 2 mm from the top. When the panel is double glass, position the glass 2 mm from the bottom, as shown in figure 9.



Positioning of glass



Applying glass to frame



Step 7

Press the glass onto the sealing tape and sealant with your hands and let the sealant dry.

If the frame is not flat, use clamps to keep the glass in place. Place the clamps where the frame starts to bend. The drying duration is 24 hours in room temperature.



Step 8

Put the rubber back on the door frame. Use documentation: Replacement of an O-rubber for further instructions. "SM014"

Step 9

Clean the glass with glass cleaner.

3 Effect of change

Part numbers	date	Serial number
N/A		

[supporting text]

4 Related tests

Related test reports

Test report no	Description
N/A	

5 Related instructions

Related instructions for replacement

Instruction	Description
MM	Ventura's Maintenance manual for the correct door system
IM	Ventura's Installation manual for the correct door system
SM014E	Replacement of an O-rubber
IP002E	Inspection protocol for glass