



Title: Glue glass to a Ventura door frame

1. Purpose:

The purpose of this service instruction is to describe the process of gluing/sealing a glass panel to a Ventura door frame.

Revision no.	Date:		
3	03-07-2018	Description of the change:	Reference changed from ISO 9001:2008 to IATF 16949:2016. Layout of document changed.
		Name & function:	Victor Linting Process Engineer
2	01-07-2016	Description of the change:	Figure 6: replaced "Bottom" by "Top"
		Name & function:	Hotze Gerrit Waterlander Quality Assurance Manager
1	03-06-2014	Description of the change:	First release
		Name & function:	Klaas-Teake Slager Technical Documentation Specialist

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2. References:

2.1. IATF 16949:2016 §8.5.1

Control of production an service provision

3. Definitions:

3.1. None

4. Forms:

4.1. None

5. Scope:

5.1. This service instruction applies to all Ventura door frames.

6. Material/Tools:

- 6.1. Simson Primer L
- 6.2. Cleaning paper or sponge
- 6.3. Double-sided tape
- 6.4. Knife
- 6.5. Caulking gun
- 6.6. Simson Cleaner I
- 6.7. Simson STR 360
- 6.8. (Ventura) tape

7. Execution:

- 7.1. Clean the door frame using primer (Simson Primer L) and cleaning paper or a sponge.
Clean the ceramic screening of the glass with "Simson Cleaner I".
- 7.2. Apply sealing tape and two-sided tape to the outside of the door frame.
See figure 3 and 5.

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 figure 1.

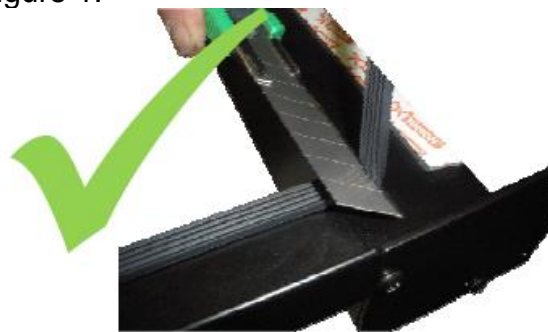


Figure 1: correct cutting of tape.

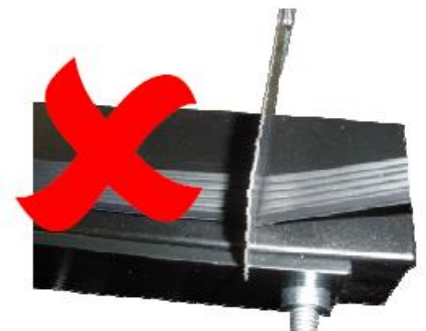


Figure 2: Wrong cutting of tape.

Double-sided tape

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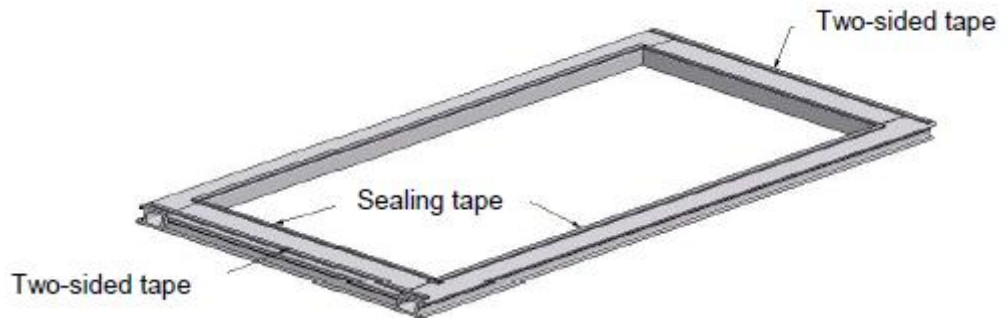


Figure 3: Applying sealant tape and double-sided tape to the door frame

- 7.3. Apply sealant (Simson STR 360) to outer flat service of the entire door frame (Step 7.5 to step 7.7 within 15 minutes due to drying period of sealant. Check table 1 for more specific drying times). See figure 5.

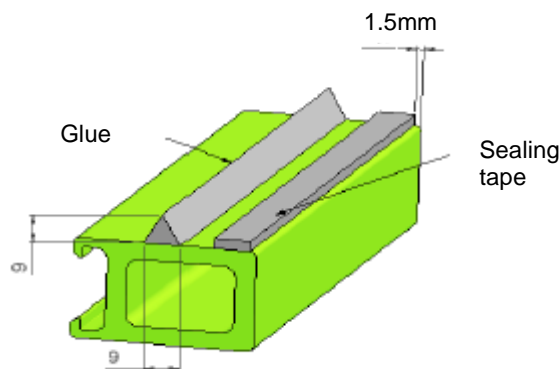


Figure 4: Applying sealing tape

- 7.4. Remove the protection from the double-sided tape.
 7.5. Position glass onto the frame. Ventura logo according to figure 5 and 6. When the panel is single glass, position the glass 2mm from the top (decisive, e.g. lock) as shown in figure 4. When the panel is double glass, position the glass 2mm from the bottom (decisive, e.g. lock), as shown in figure 5.

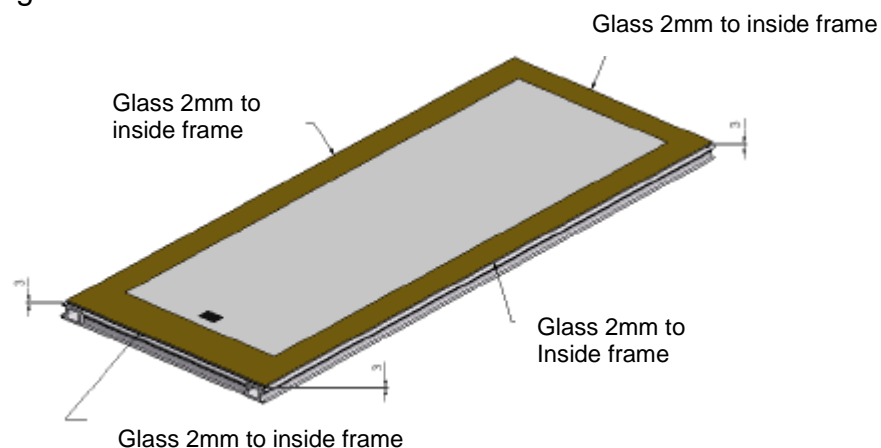
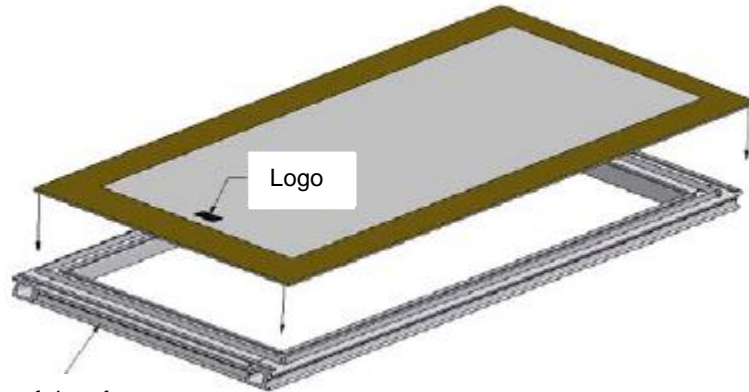


Figure 5: Positioning of glass

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Top of door frame

Figure 6: Applying glass to frame

- 7.6. Press the glass onto the sealing tape and let the sealant dry according to Table 1.

Environment temperature (°C)	Sealant drying time
5	35 min.
10	27 min.
15	20 min.
20	15 min.
25	10 min.
30	7 min.
35	5 min.

Table 1: Drying time of sealant