



Service instruction: SM036E  
Revision: 1  
Date: 03-06-2014  
Page no.: 1

**Title: Mounting of an IG side seal**

**1. Purpose:**

The purpose of this service instruction is to describe the method of mounting a side seal to a Ventura IG door leaf.

Revision no.	Date:		
1	03-06-2014	Description of the change:	First release
		Name & function:	K. Slager Technical Documentation Specialist

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**2. References:**

- 2.1. ISO 9001 (2008) §7.5.1 Control of production and service provision

**3. Definitions:**

- 3.1. None

**4. Forms:**

- 4.1. None

**5. Scope:**

- 5.1. This service instruction applies to all Ventura IG door leafs.

**6. Material/Tools:**

- 6.1. Cordless drill
- 6.2. Drill Ø.4.2mm
- 6.3. Lube liquid (Liquid lube/water 1:2)
- 6.4. Brush (For lube liquid)
- 6.5. Loctite 406
- 6.6. Simson STR 360 sealant
- 6.7. Caulking gun
- 6.8. Isopropylalcohol
- 6.9. Cleaning paper

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**7. Execution:**

7.1. The right procedure for installing the side seal depends on the following situation:

Type	Sensitive edge	Screw top Part. No. C397	Screw bottom Part. No. C397	Adhesive on top edge	Adhesive on bottom edge	
IG	X	X	X	X	X	Go to 7.2
IG		X	X			Go to 7.2 and skip 7.6 to 7.10
IG trolley	X			X	X	Go to 7.3 and skip 7.5

7.2. Drill a hole of  $\varnothing 4.2\text{mm}$  in the vertical profile. The position of the hole depends on the location of the hole and screw for connecting the horizontal and vertical profile together. Figure 1 and 2 show the location for the  $\varnothing 4.2\text{mm}$  hole depending on the situation.



Figure 1:



Figure 2:

- 7.3. Lubricate the side seal and the vertical profile with Lube Liquid.
- 7.4. Pull the side seal through the vertical profile and make sure the top and bottom of the seal are in line with the door frame.

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- 7.5. Screw the side seal to the door frame according to figure 3 to 5.



Figure 3: Drill a hole of  $\text{Ø}4.2\text{mm}$  in the frame



Figure 4: Screw through the side seal from an angle into the drilled hole in the frame.



Figure 5: Screw head against the side seal

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- 7.6. Install the sensitive edge into the side seal. Cut out rubber in the top edge and route the cable of the sensitive edge into the door frame. See figure 6:

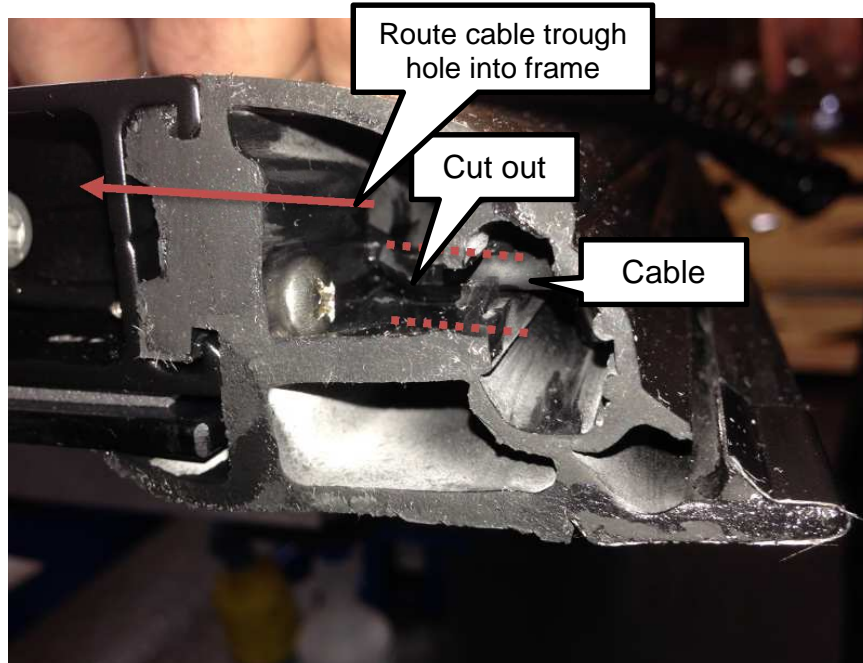


Figure 6: Route the cable through cutouts in the rubber into the door frame

- 7.7. Glue the cable of the sensitive edge to the side seal using Loctite 406 according figure 7:



Figure 7: Gluing the cable to the side seal

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- 7.8. (Applicable when a sensitive edge is installed) Apply sealant (Simson STR 360) a line of 10cm between the glass and the side seal flap covering the glass on the top of the door leaf and on the bottom.



Figure 8: Gluing of the edges

- 7.9. Seal the top edge with sealant (Simson STR 360).



Figure 9: Seal the top edge

- 7.10. Remove any redundant sealant as visible in figure 9. Use cleaning paper and Isopropylalcohol and clean the area around the edge.