



Service instruction: SM037E
Revision: 1
Date: 04-06-2014
Page no.: 1

Title: Construction of an IG door frame box spare kit

1. Purpose:

The purpose of this service instruction is to describe the construction of a new IG4 door frame for replacement of an existing one.

Revision no.	Date:		
1	04-06-2014	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 the following products:
U268 "Box spare M529" replacement kit for a left IG4 door frame (part no. M529).

VA0679 "Box spare M530" replacement kit for a right IG4 door frame (part no. M530).

VA0872 "Box spare O453" replacement kit for a right IG4 door frame with handgrip (part no. O453).

VA0873 "Box spare O454" replacement kit for a right IG4 door frame with handgrip (part no. O454).

6. Material/Tools:

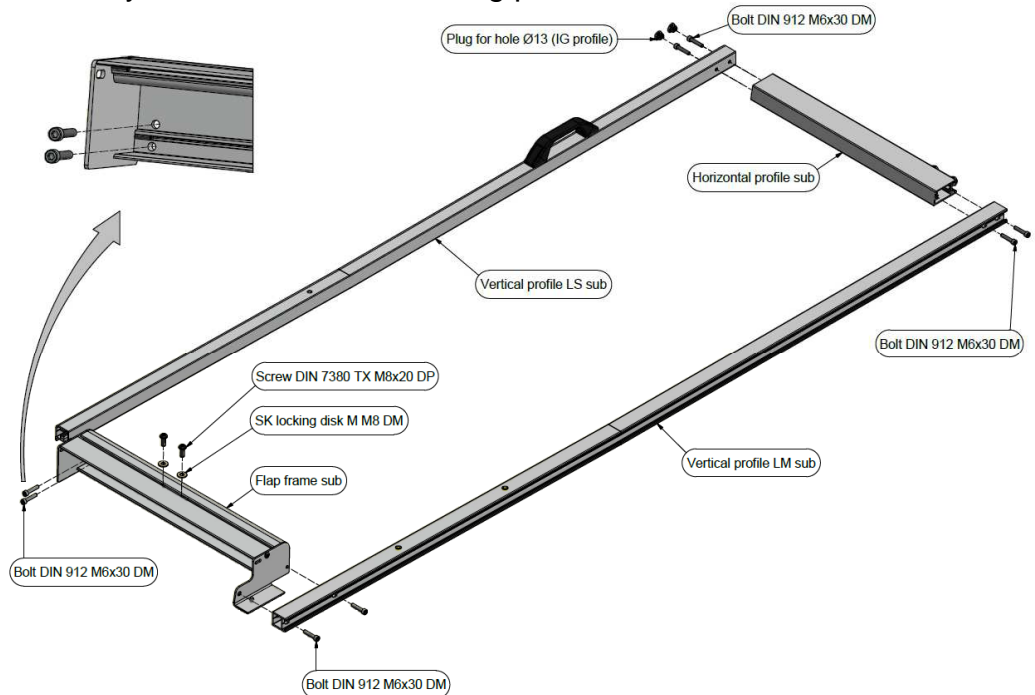
- 6.1. Torque wrench (3/8 in. Adjusted to 12Nm)
- 6.2. Hex bit socket 5mm (3/8 in.)
- 6.3. Allen key 6mm
- 6.4. Plastic hammer

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7. Execution:

(This instruction shows a left door leaf situation, the right door leaf is mirrored)

7.1. Lay down the two vertical profiles, top horizontal profile and the flap assembly as shown in the following picture:

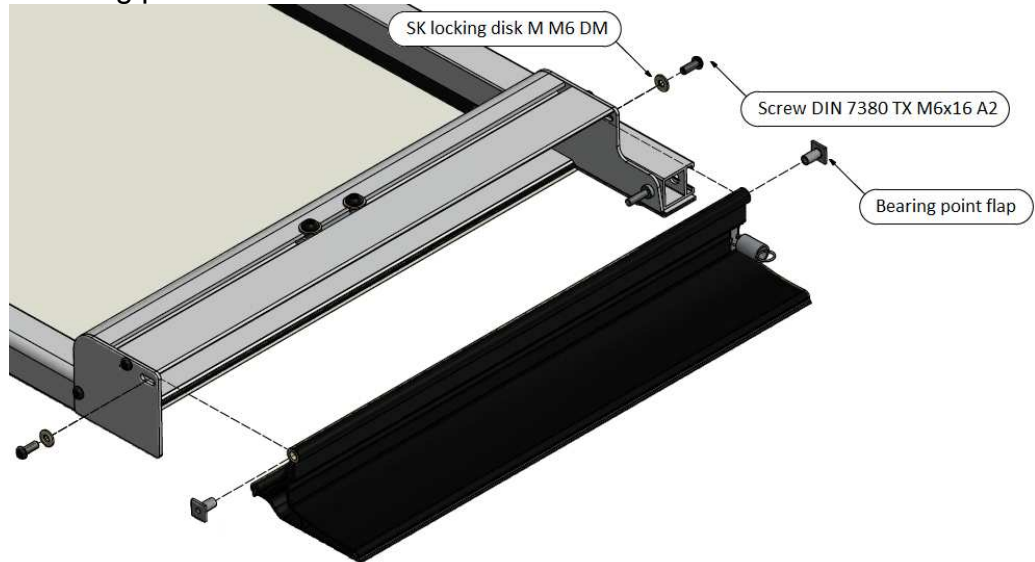


This picture shows a door frame for a left door leaf. The right frame of a right door leaf is mirrored.

7.2. Bolt the vertical profiles to the top horizontal profile using M6x30 bolts provided in the mounting kit bag with small material. Bolt the right vertical profile to the flap frame when the frame is for a left door leaf, or bolt the left vertical profile to the flap frame when the frame is for a right door leaf, also using M6x30 bolts. Bolt the left vertical profile to the flap frame from underneath the flap frame when the door frame is for a left door leaf. Bolt the right vertical profile to the flap frame from underneath the flap frame when the door frame is for a right door leaf, also using M6x30 bolts. All M6 bolts for bolting the frame together should be tightened at 12Nm.

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- 7.3. Place the bearing point flaps inside the flap on each of the sides. Place the flap towards the flap frame with the flat service down as shown in the following picture:



Attach an SK locking disk M M6 onto a Screw DIN 7380 TX M6x16 A2 and screw the flap onto the flap frame at both sides.

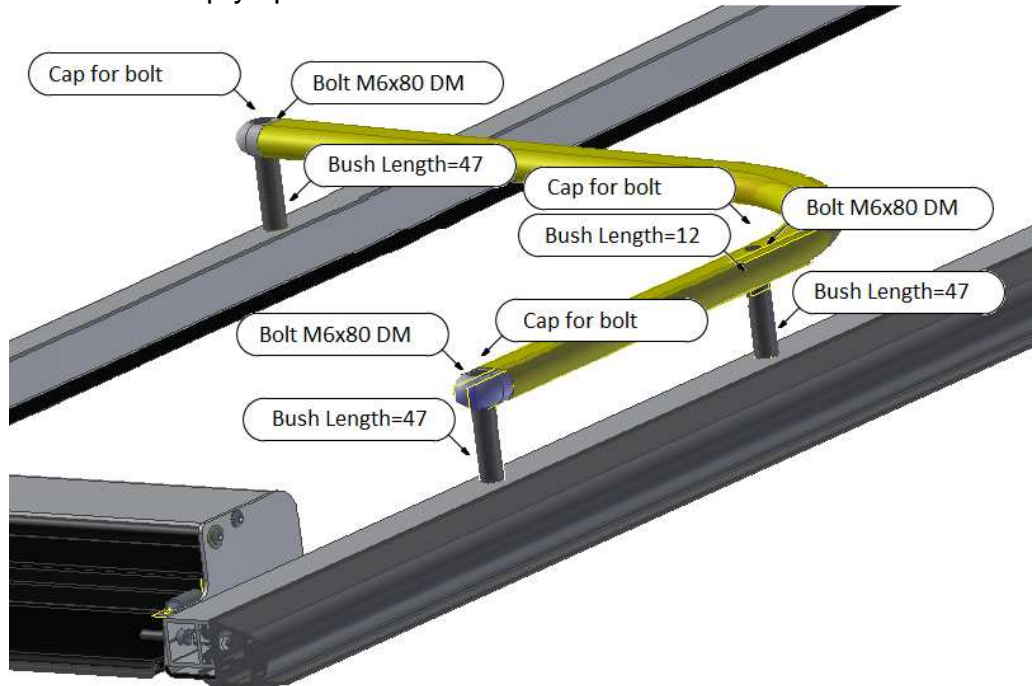
- 7.4. Attach the spring to the thread end of the bolt as shown in the following picture:



Put spring eye over thread end

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- 7.5. Install the handrail. Use the M6x80 bolts to mount the handrail onto the vertical profiles. Please note that the bolt in the middle needs a 12mm bush to fill empty space inside the handrail.



- 7.6. Install the glass onto the door leaf frame (See *Ventura Document No. SM035E latest revision*).
- 7.7. Mount the side seal onto the door frame (See *Ventura Document No. SM036E latest revision*).