

Title: Replacement of lower profile on PS door leaf (none-intergraded rail)

1. Purpose:

1.1. This instruction describes how to replace the lower door profile of a PS door leaf.

2. References:

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

3. Definitions:

3.1. None

4. Applicable for:

4.1. All plug slide door leaves with a none-intergraded rail.

5. Tools:

5.1. Cutting wire or glass removal saw (vibration saw)



5.2. Cleaning cloth/paper

5.3. Utility knife

5.4. Glass scraper

5.5. Brush

5.6. Spanner 13mm

5.7. Allen Key 5mm (minimal 30mm length)

6. Needed parts:

Ventura P/N

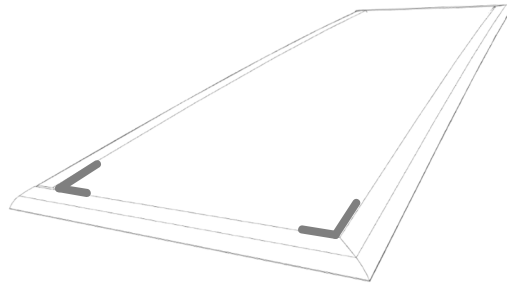
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|------------------------------------|--------|
| 6.1. Ventura lube | VA2951 |
| 6.2. Simson ISR 70-05AP | C676 |
| 6.3. Simson Primer M | L225 |
| 6.4. Isopropyl alcohol | H316 |
| 6.5. Sealing tape 9x3mm Black | C670 |
| 6.6. Foam tape double sided 12x3mm | K812 |
| 6.7. 4x Bolt M6x30 (optional) | B326 |
| 6.8. Lower Profile | |

Revision no.	Date:	Description of the change:	First release
1	26-10-2016	Name & function:	Menno Coehoorn Service Engineer

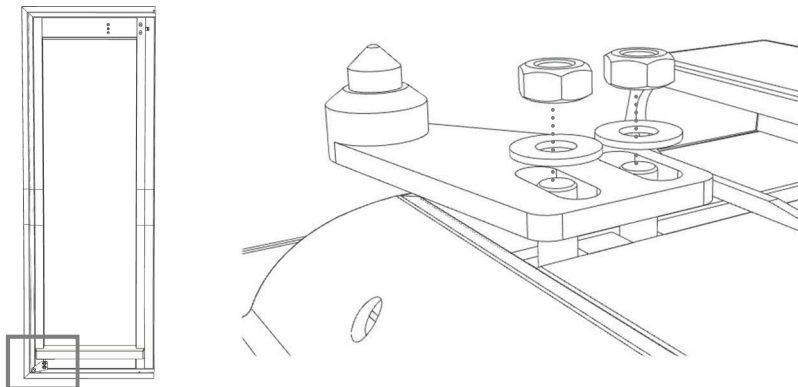
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7. Execution:

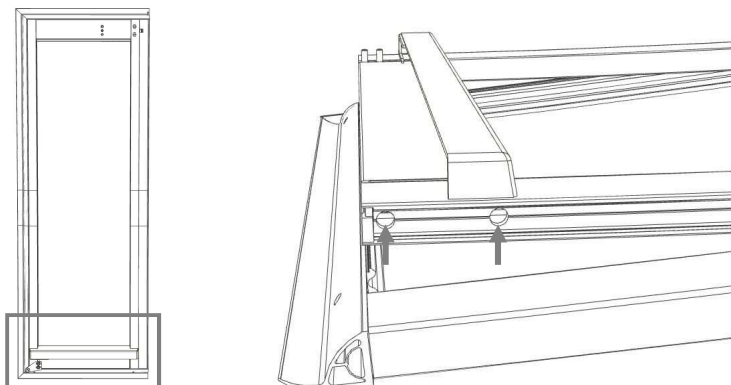
- 7.1. Place the door leaf on a stable surface with the outside of the door leaf facing upwards.
- 7.2. At the corners of the door leaf rubber sealant is used to fix the rubber to the glass. Use the utility knife to loosen the door seal from the glass.



- 7.3. Turn the door leaf around so the inside of the door is facing upwards.
- 7.4. Use the 13mm spanner to remove the catch wedge/pin from the door leaf.

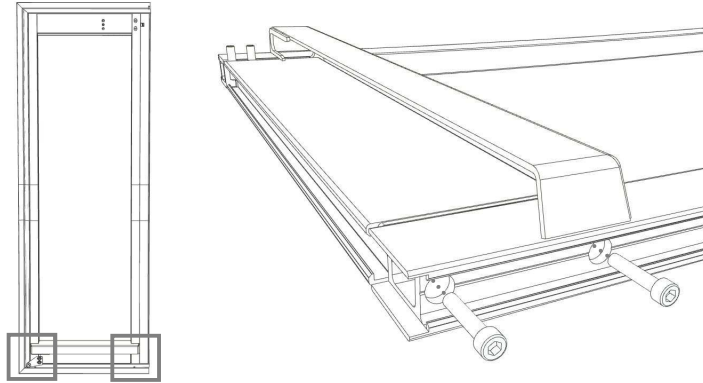


- 7.5. The seal around the door is fitted inside the door frame profile. Remove the seal from the door profile until the holes on the side profiles are visible.

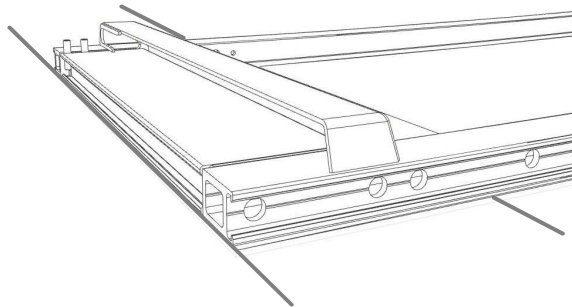


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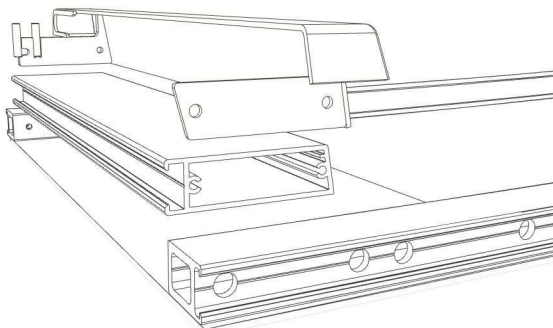
- 7.6. Use the extended Allen key 5mm to remove the bolts on each side of the door leaf.



- 7.7. The glass is fixed to the door leaf frame with sealant. Use the cutting wire or glass removal saw to loosen the lower profile by cutting the sealant between the glass and profile.






- 7.8. When the sealant has been cut the profile can be taken out.



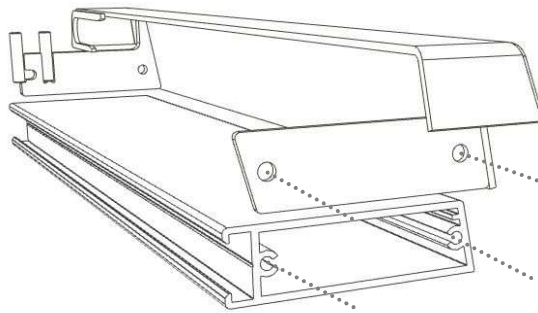
- 7.9. Remove all the sealant residues from the glass with a glass scraper.
Note: Be aware that the scraper can scratch the screening on the glass.

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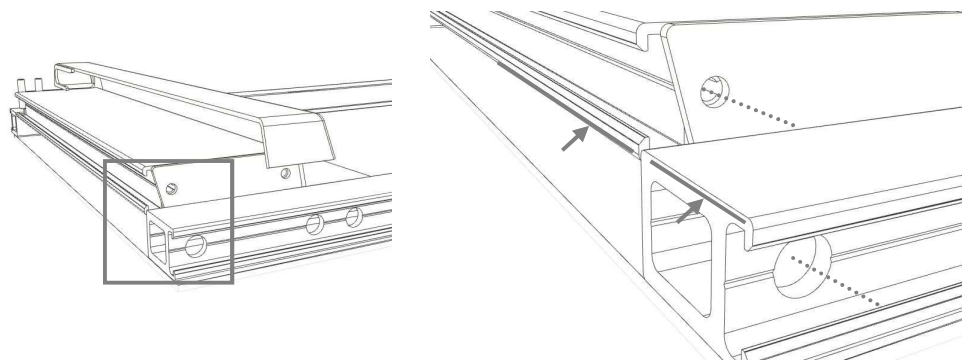
- 7.10. Clean the glass and the new lower profile with Isopropyl alcohol and apply A and B to the new profile. Use Primer M to "clean" the surface between A and B and apply C.
- A: Foam tape 
 B: Sealing tape 
 C: Simson ISR 70-05AP 



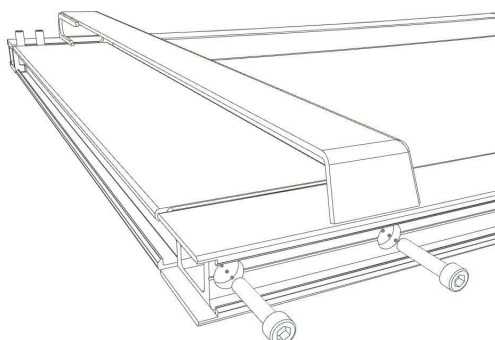
- 7.11. Align the holes of the rail and lower profile.



- 7.12. Align the lower profile to the side profiles and the holes. Then push it into position.

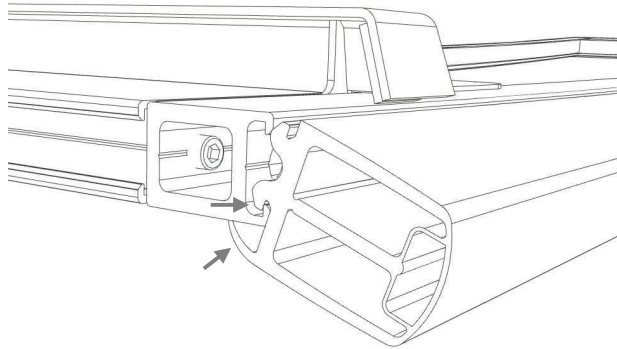


- 7.13. Use the M6x40 bolts to secure the profile.

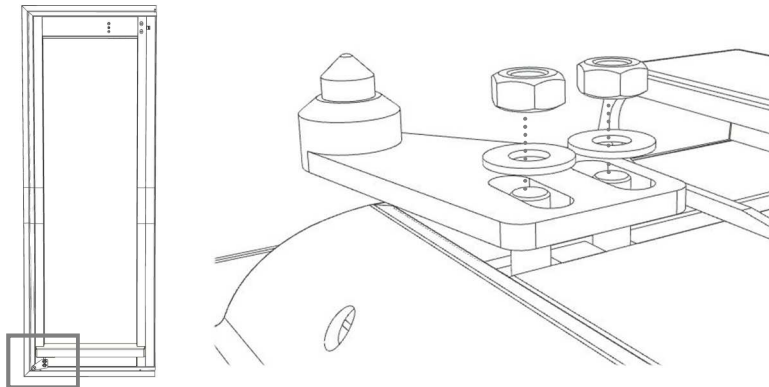


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- 7.14. Use a brush to apply Ventura Lube to the profile to be able to mount the door rubber.
- 7.15. Start by pushing the lower part of the seal into the door profile following the upper part. Be sure the small rubber flap lies against the glass.



- 7.16. Use the 13mm spanner to mount the catch wedge/pin on the door leaf



- 7.17. Turn the door around so the outside of the door is facing upwards.
To secure the door rubber, clean the corners between the glass and the door seal with Isopropyl alcohol and apply 10cm sealant to each lower corner

