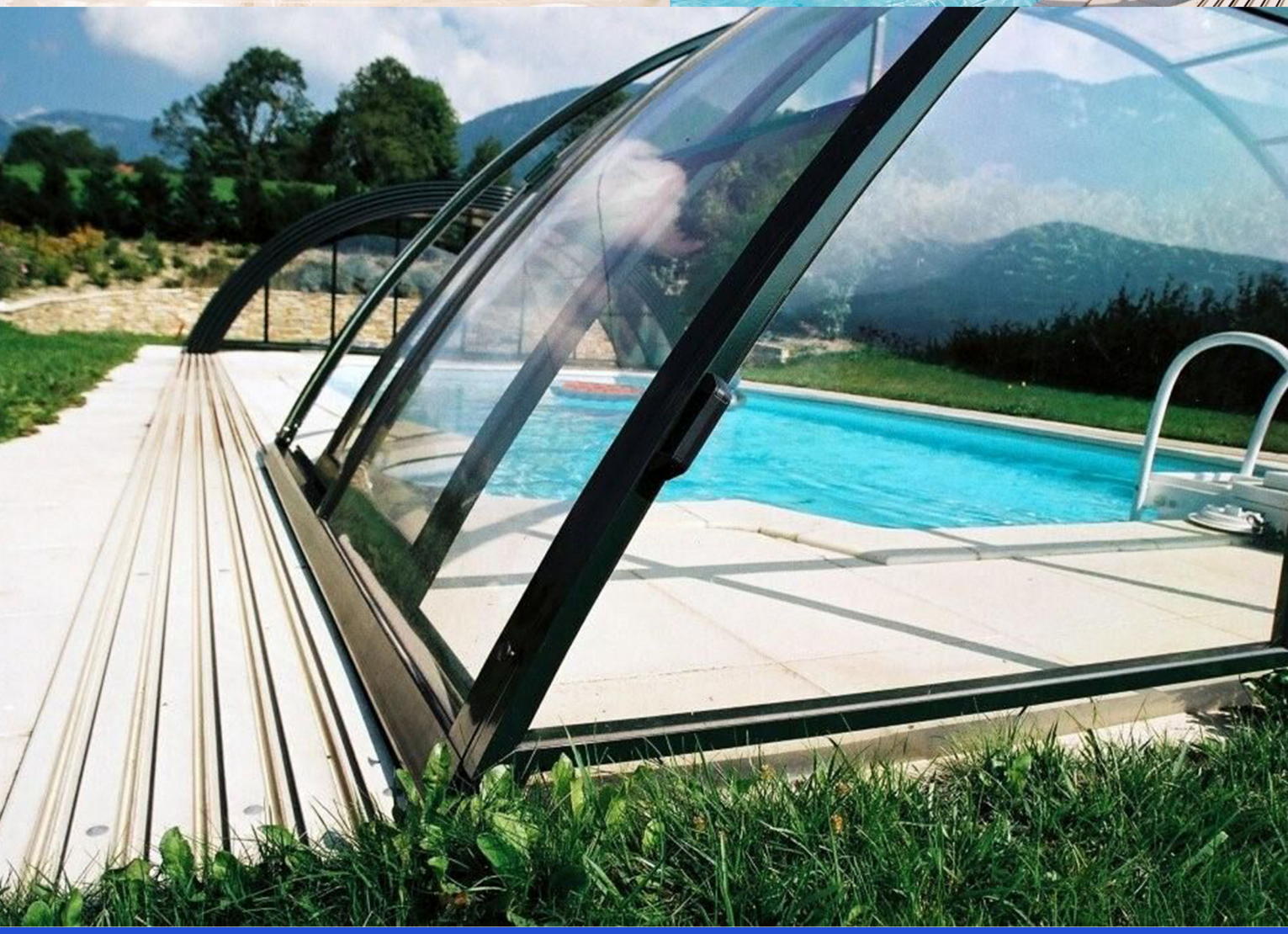


ASSEMBLING INSTRUCTIONS FOR POOL ENCLOSURES

PoolWarehouse

...we know swimming pools

POOL PROGRAMME

ASSEMBLING INSTRUCTIONS FOR POOL ENCLOSURES

PROGRES

Distributor:

IMPORTANT

- Please read these instructions carefully before you start to assemble your PROGRES.
- Please carry out the steps in the order set out in these instructions.
- **Keep these instructions in a safe place for future reference.**
- **Prior to installation be sure to check your local building and zoning requirements.**

SAFETY ADVICE

- Use of work gloves and safety glasses during assembly is required.
- Do not attempt to assemble the PROGRES in windy or wet conditions.
- Do not touch overhead power cables (if any) with the aluminum profiles.
- Always wear shoes and safety goggles when working with extruded aluminum.
- Dispose of all plastic bags safely - keep them out of reach of small children.
- The PROGRES must be positioned and attached on a flat level surface.
- Do not lean against or push the PROGRES during assembly.
- Keep children away from the assembly area.
- Do not position your PROGRES in an area exposed to excessive wind or overhead tree limbs.
- Do not attempt to assemble the PROGRES if you are tired, have taken drugs or alcohol or if you are prone to dizzy spells.
- If using a step ladder or power tools, ensure that you follow the manufacturer's safety advice.

TRACK INSTALLATION

A flat, level surface is required; any of the following is acceptable:

- 3.5" thick foundation of reinforced concrete
- Pavers set in Concrete
- Wood/composite decking

TOOLS AND EQUIPMENT REQUIRED

- Tape measure
- Work gloves
- Rubber mallet
- Safety glasses
- Silicon
- Phillips head screwdriver
- Step ladder
- Drill and bits

CLEANING

Polycarbonate panels can easily be cleaned by hosing down with cold clean water or with a soft cloth made from 100% cotton using a mild dish detergent solution and rinsing with cold water.
DO NOT use acetone, abrasive cleaners or other special detergents to clean the panels. This will void warranty!

Immediate Removal of Protection Sheets from Panels

The polyethylene masking (plastic sheets/foil) **must be removed immediately** from the panels during or immediately after installation. The polyethylene masking covers the panels to protect them during handling, shipping, storage, and installation. If it is removed at a later time, it may be very difficult if not impossible to remove as it will stick to the panel. In hot climates, even 24 hours after the installation is completed it may be too late to remove.

This product is manufactured in Czech Republic

1. PROGRES - names of individual parts

Before starting the installation, it is necessary to get acquainted with the names and terminology of individual parts of the enclosure, individual construction elements and standard accessories, which are integral parts of the enclosure and are indicated in the pictures below.

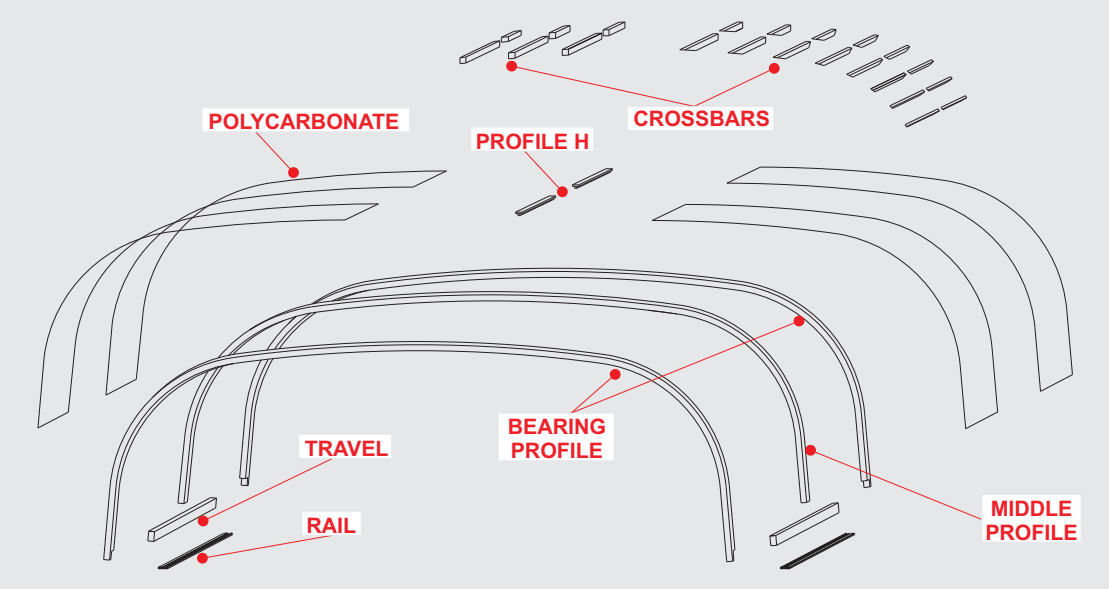


Fig.1.1 - overview of individual construction elements

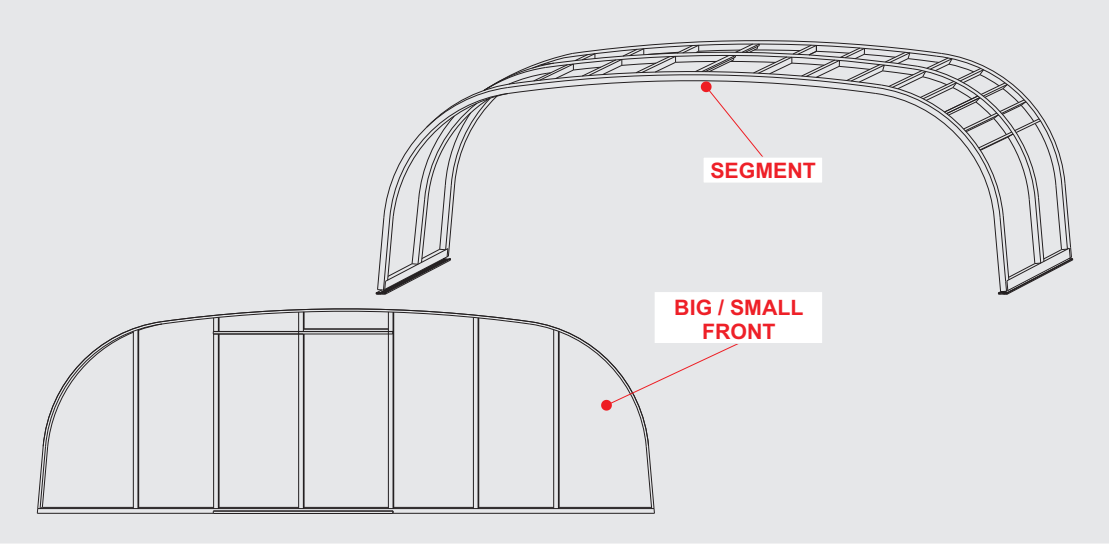


Fig. 1.2 - assembled segment and front

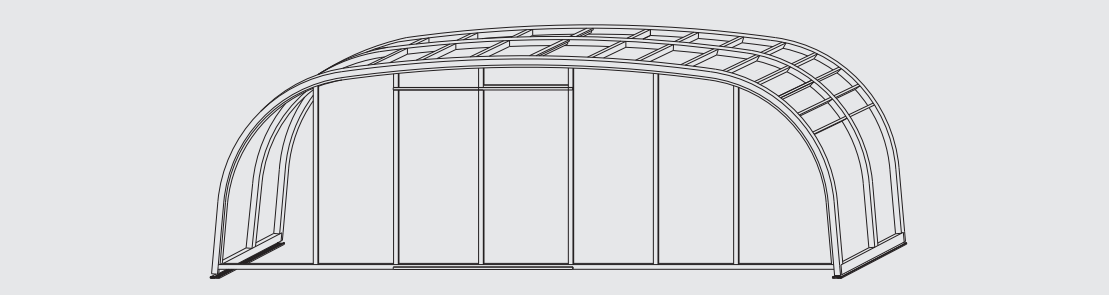


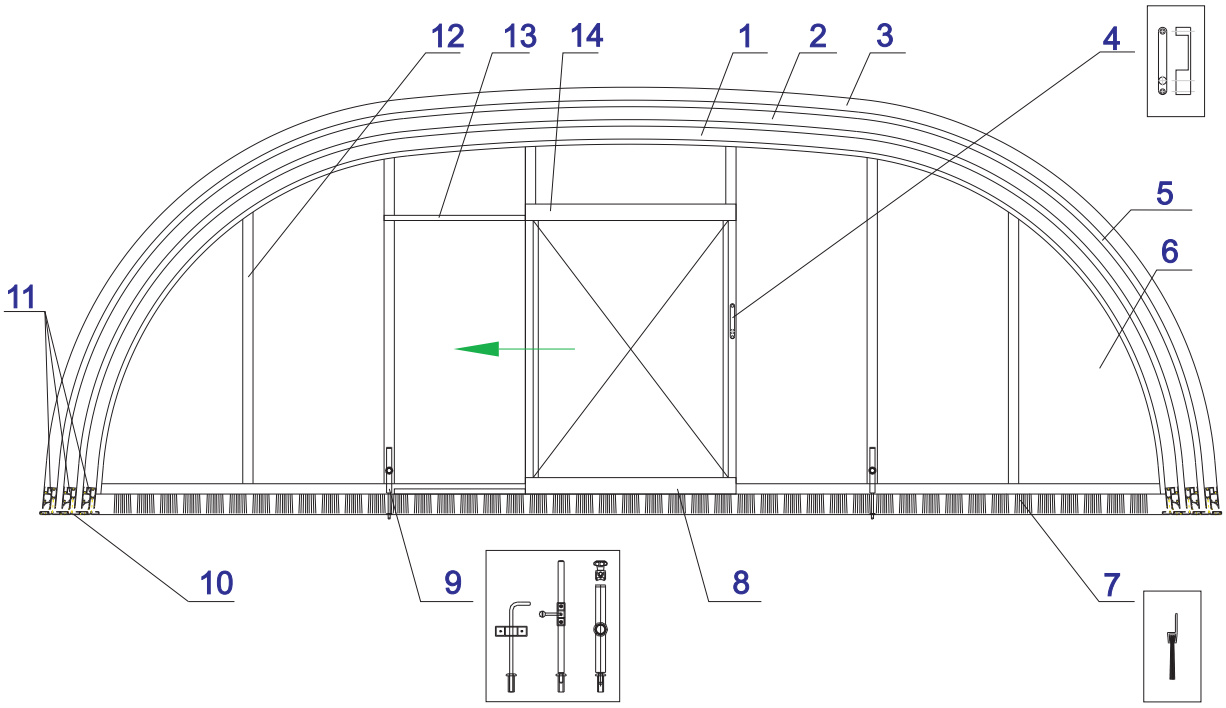
Fig. 1.3 - assembled biggest / smallest segment together with front

It is necessary to introduce a terminology of all items and parts used in the enclosure (see pic. 1.1)

All of these items assembled within the enclosure has its unique catalogue number and part description.

Explanation to pic. 1.4:

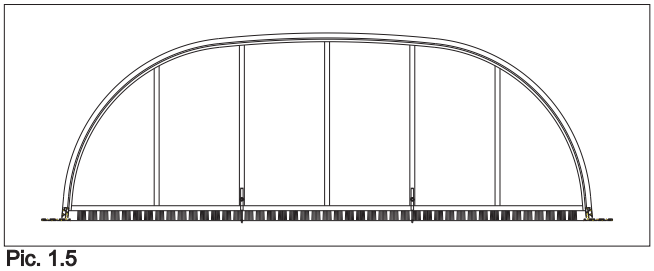
1. first segment
2. second segment
3. third segment
4. locking handle (01.535; 01.574)
5. sealing between segments (01.701; 01.705)
6. fixed face
7. brushes (01.601-01.605; 01.152; 01.153; 01.613)
8. travel for shifting door without dooorsill (01.012)
9. setting arrestment (old 01.406; 22.005, new 22.003)
10. leading line
11. automatic arrestment PROGRES
12. profile H (01.014)
13. door rail (01.208)
14. travel for shifting door (01.247)



Pic. 1.4

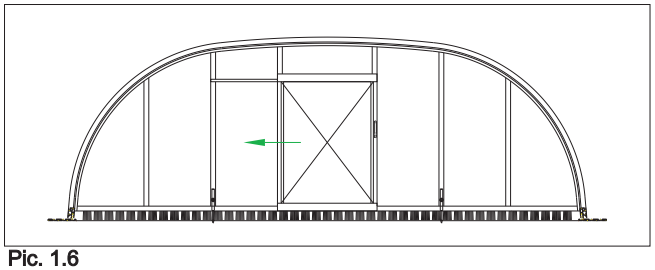
Pictures No. 1.5 and No. 1.6 show implementation of a face with and without door.

IMPLEMENTATION OF FACE WITHOUT DOOR



Pic. 1.5

IMPLEMENTATION OF FACE WITH DOOR



Pic. 1.6

2. EXPEDITION - TRANSPORT OF ENCLOSURE TO CUSTOMER

The enclusure must be secured on a truck or container to avoid movement, deformation or material damage during the transport to a client. The securing is specific and depends on type of used truck or container. Proper attachment is checked before the transport by responsible person. Following pictures (pic. 2.1 - 2.2) show typical securing and attaching the enclusure on a container.

Driving the truck is in compliance with statutory text of „State traffic law“

Pic. 2.1

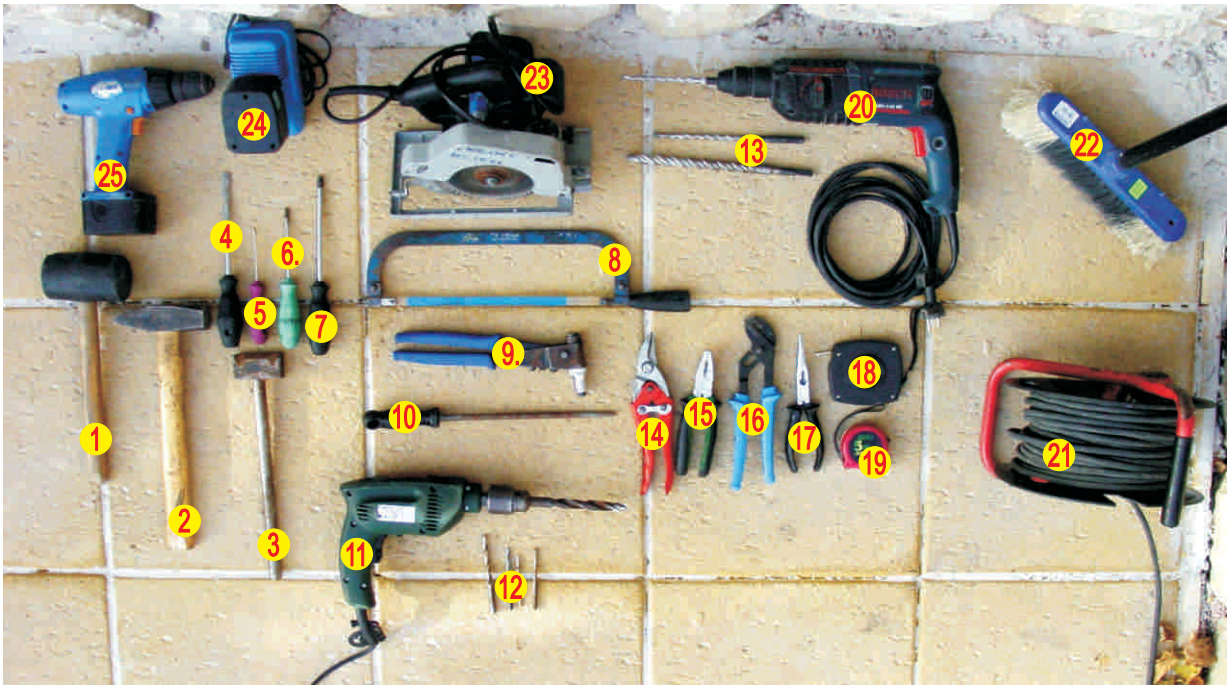
General view on secured enclusure using a method „container“. Elements are placed on the wooden palette.

Pic. 2.2

Elements are fixed to wooden palette and they are sorted under each other by width of the element

LIST OF TOOLS REQUIRED FOR ASSEMBLING THE ENCLOSURE

BASIC LIST OF TOOLS AND MACHINES FOR ASSEMBLING



1. rubber soft hammer
2. hammer
3. bending tool for arrestments
4. big screwdriver (flat)
5. small screwdriver (flat)
6. small screwdriver (cross)
7. big screwdriver (cross)
8. metal saw
9. riveting pliers
10. rasper
11. handy drilling machine
12. drills Ø 4mm; Ø 5mm; Ø 6,2mm; Ø 7mm
13. drills for concrete Ø 8mm; Ø 15mm
14. snips
15. flat pliers
16. tongs
17. small flat pliers
18. measuring tape
19. steel band
20. pneumatic hammer
21. cord extension set
22. dust-brush
23. handy circular saw
24. accumulator battery charger
25. accumulator screwdriver

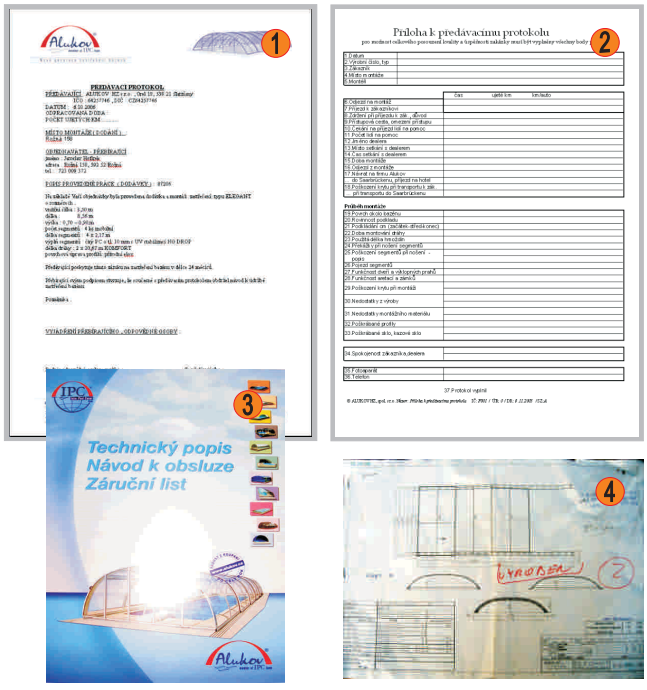
Fig. 2.6

BASIC LIST OF FINALIZING PARTS FOR ASSEMBLING

1. aluminium piece 01.104 - (rail endings)
2. stopper 01.440 + underlay piece 01.441
3. arrestment pin 22.003 22.003
   (according to enclosure disposal)
4. plastic backstop for travel
5. plastic cap for rails 01.532, 01.546, 01.547
6. insert for pavement 01.512
7. raw-plugs 01.801 - 01.808
8. rivets

Fig. 2.7

BASIC LIST OF DOCUMENTATION



1. completion certificate
2. appendix of completion certificate
   (description of assembling)
3. technical specification, operating instruction, certificate of warranty
4. technical documentation - assembly drawing

Fig. 2.8

3. PREPARING THE JOBSITE

Nearby the jobsite of assembling, contact the final customer or responsible person to let him follow 4 basic steps before assembling procedure:

1.) to navigate the truck to place of assembling

2.) to ensure an access to a pool

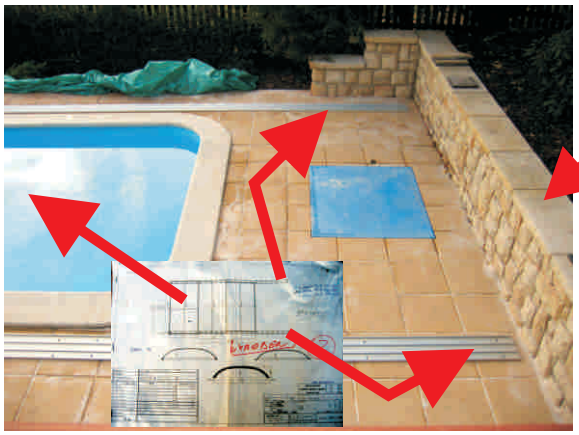
3.) electrical supply connection required

4.) to clarify a position of the enclusure according to the pool, position of the biggest element and direction of movement

According to the basic point No.4, customer or salesman has to specify a **position of the biggest element** in closed position of the enclosure, **location of the leading lines** in respect to a pool, **direction of moving** (opening) the elements, see pictures No. 3.1 - 3.2

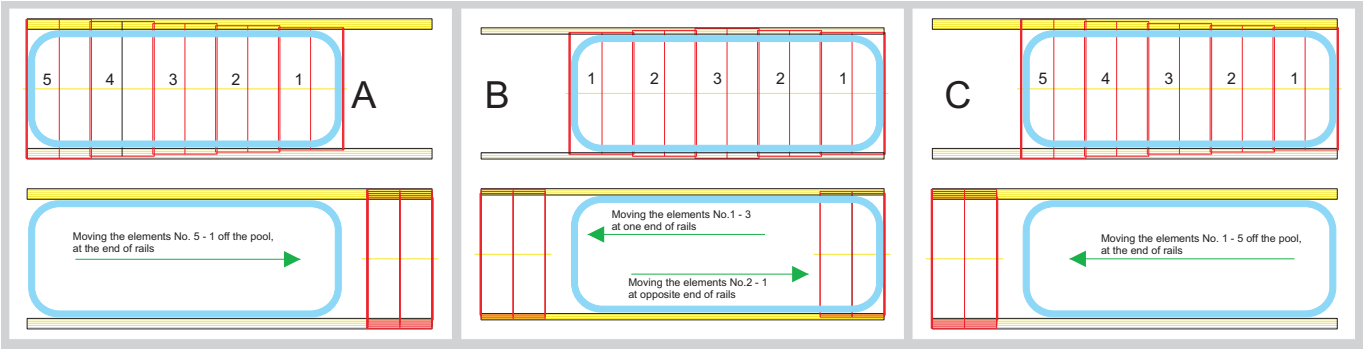
Highlighted items above determines the combination for every single component layout (elements, rails),according to depicted types of opening, see pictures No. 3.3 on following page.

This informations may not be corresponding with production and assembling documentation. Customer has always casting voice.



Pic. 3.1

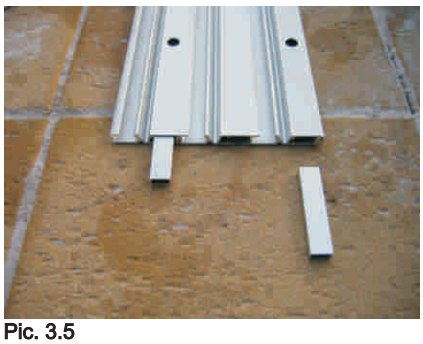
Pic. 3.2



To clean the surface around the pool, especialy the places, where the rails will be fixed to, see picture No. 3.4. Assembling of the enclosure is made on stabilized, plain, level and clean surface.

Pic. 3.4

Assembling of the leading lines is made by connecting all the lines together with rail connection piece (01.436; 01.510) and fix it to the rail by stainless rivet (01.829), see pictures No. 3.5 - 3.9



Pic. 3.5

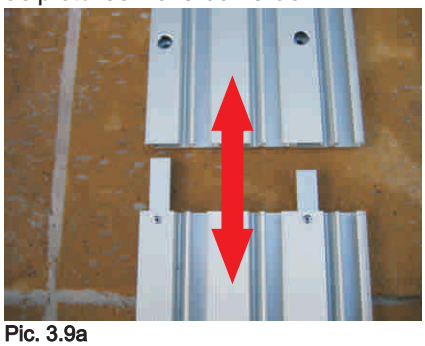
Pic. 3.6

Pic. 3.7

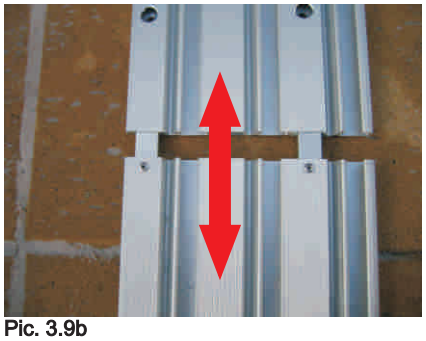
Pic. 3.8

Pic. 3.9

After connecting this piece to one part of the rail, slide the second line on, and put them as close as possible. See pictures No. 3.9a - 3.9c



Pic. 3.9a



Pic. 3.9b

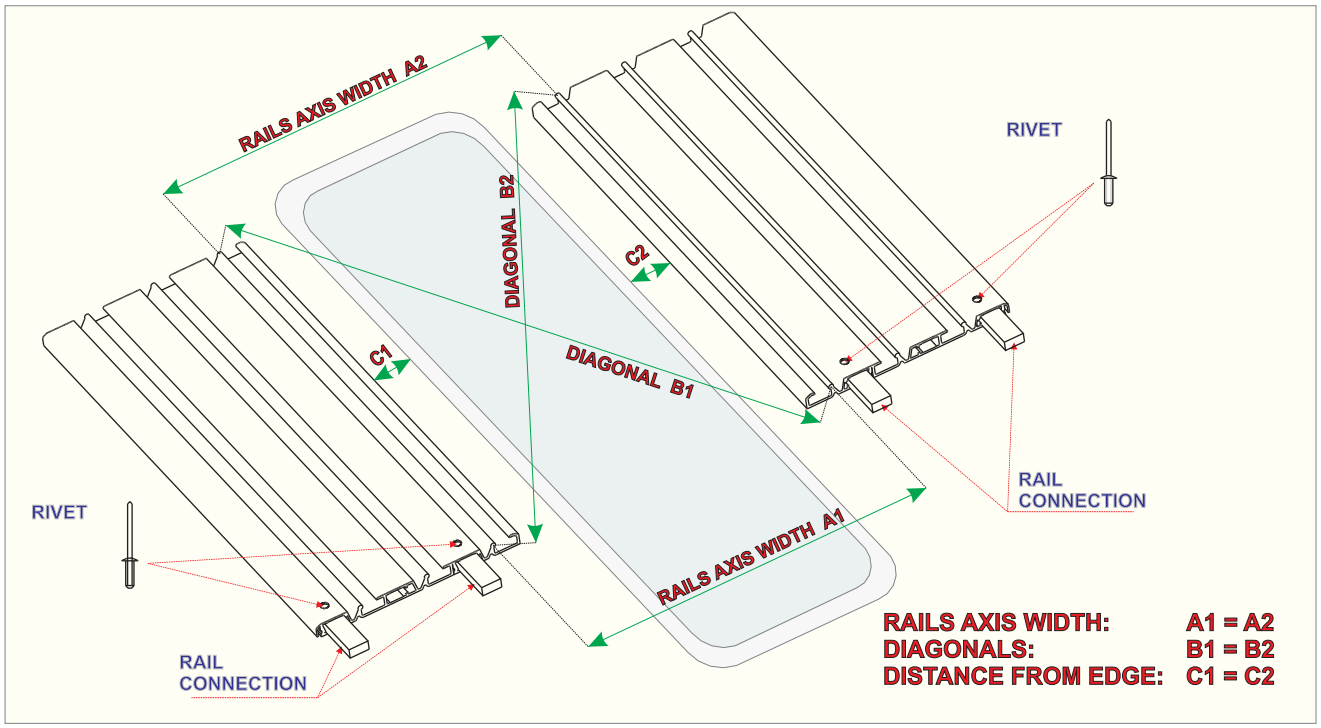
Pic. 3.9c

4. MEASUREMENT THE LEADING LINES

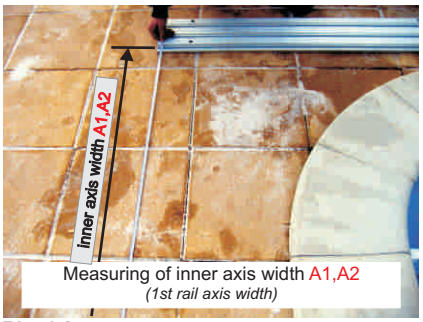
Proceed with grounding the leading lines (rails) it is necessary to keep inner width of the enclosure (between inside edges of the leading lines), which must be checked by measuring diagonals B1,B2 and 1. rails axis widths A1, A2 (below inner axis width). Check the distance C1,C2 from the outer edge of the pool - see pictures No. 4.1 - 4.6.
Keep in mind the position of rails extension for moving elements out of the pool, see pictures No. 4.7 - 4.9

ATTENTION!

After every movement or adjustment the rails check and measure dimensions A1, A2, B1, B2, C1, C2 again!

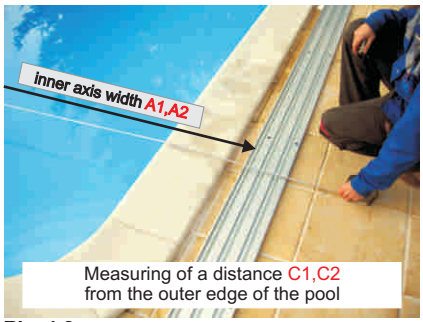


Pic. 4.1



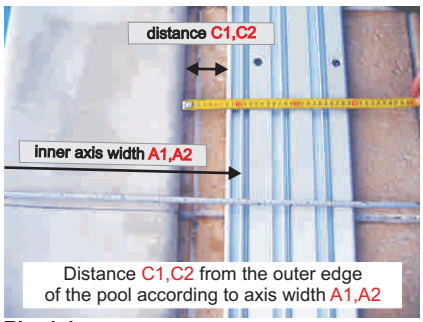
Measuring of inner axis width A1,A2
(1st rail axis width)

Pic. 4.2



Measuring of a distance C1,C2
from the outer edge of the pool

Pic. 4.3

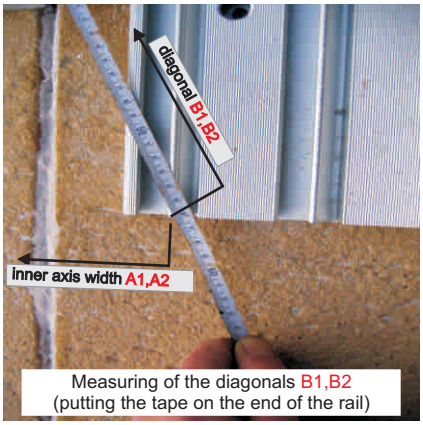


Distance C1,C2 from the outer edge
of the pool according to axis width A1,A2

Pic. 4.4

Measuring of the diagonals B1,B2
(putting the tape on the beginning of the rail)

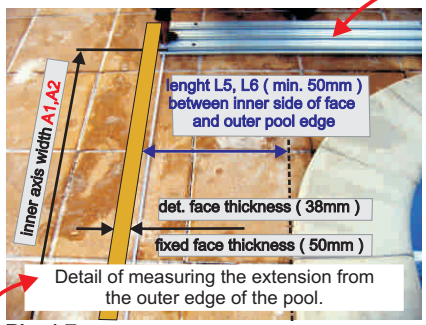
Pic. 4.5



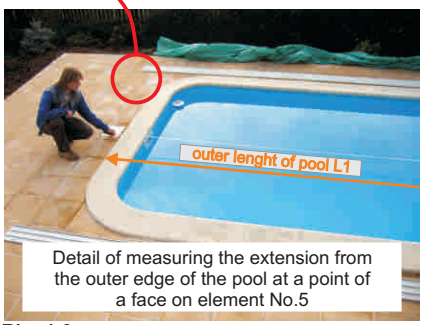
Measuring of the diagonals B1,B2
(putting the tape on the end of the rail)

Pic. 4.6

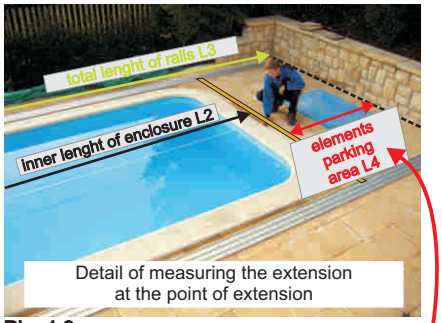
Proceed with leading lines extension for moving the elements off the pool, according to choosen type of opening A see picture No. 3.3. Move the biggest element (e.g. No.5 above the rest element pack 4-3-2-1 until all the elements are out of the pool area. Keep the same height level of the rails, in case of unlevelness use the aluminium strips 01.120, 01.121, 01.122.



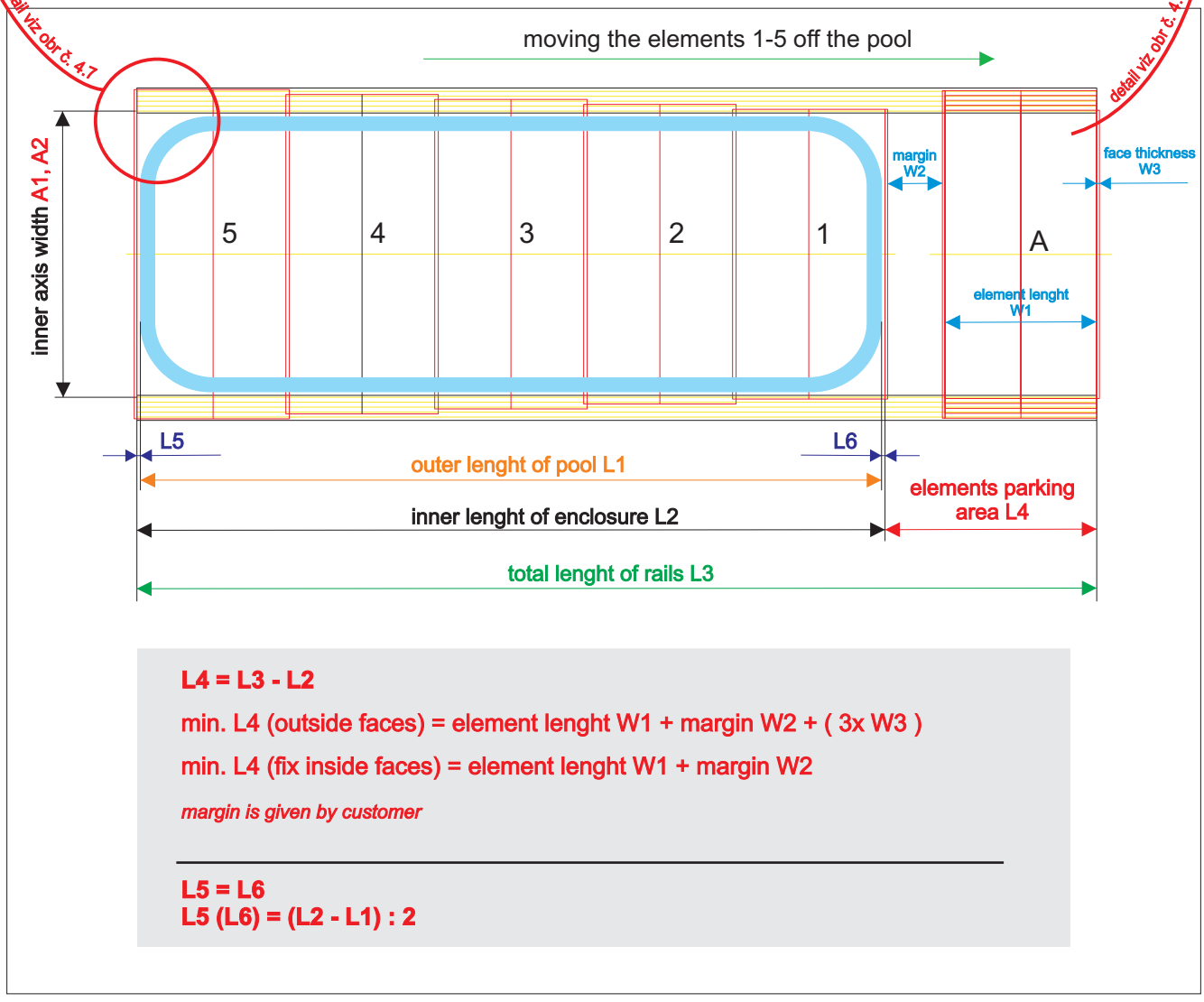
Pic. 4.7



Pic. 4.8



Pic. 4.9



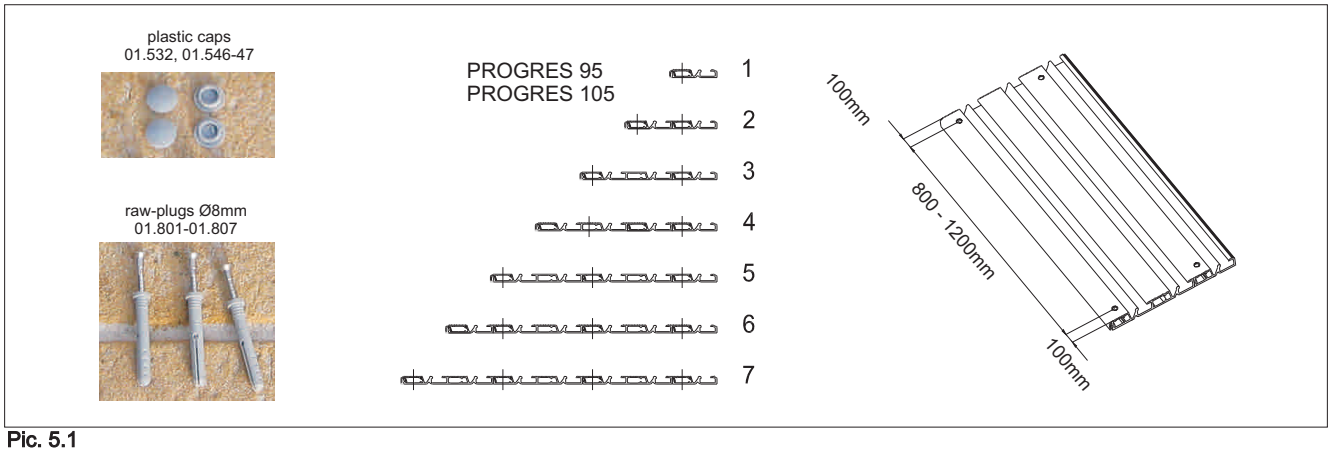
Pic. 4.9a

5. FIXING THE 1st LEADING LINE

First fix one rail belong the longer side of the pool, then, according to this one, proceed with measurement and placing the second rail on the opposite side of the pool.

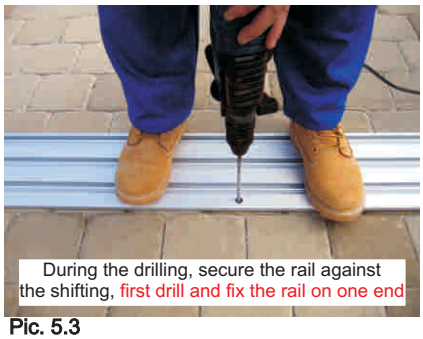
Leading lines are fixed to concrete or pavement surface by plastic raw-plugs Ø8mm (01.801 - 01.807 vrták Ø8mm). Amount of raw-plugs depends on lenght of rails and especialy on specification of ground surface. For wooden floor use spiral dives (01.815).

At the picture No. 5.1 see standard drilling of leading lines and distance between raw-plugs 800 - 1200mm.

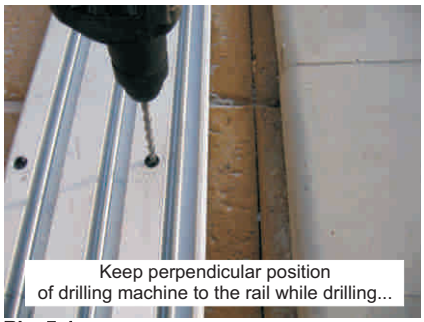


Pic. 5.1

Pic. 5.2



Pic. 5.3

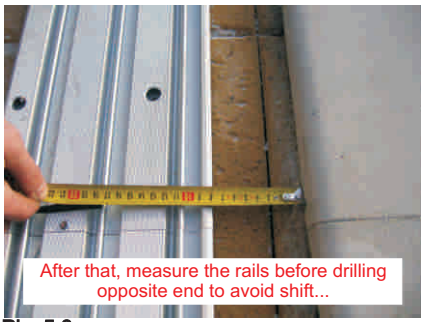


Pic. 5.4

Pic. 5.5

Pic. 5.6

Pic. 5.7



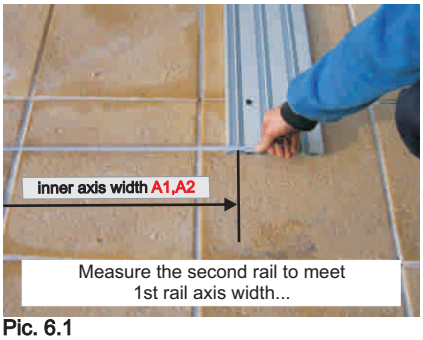
Pic. 5.8

Pic. 5.9

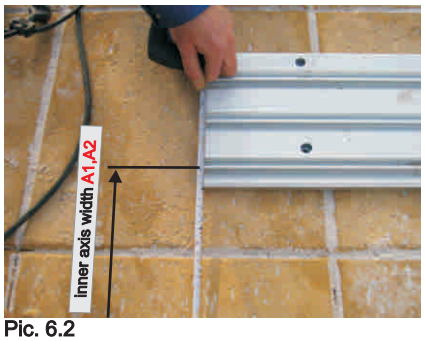
Pic. 5.9a

6. FIXING THE 2nd LEADING LINE

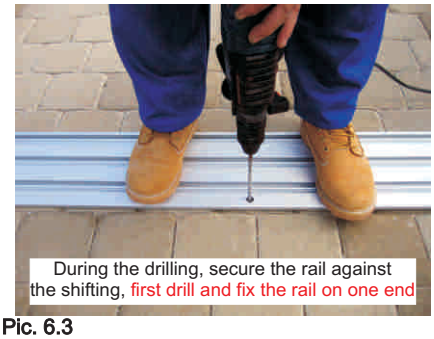
According to the first rail proceed to exact measurement and fixing the second rail on the opposite side of the pool. See pictures No. 6.1 - 6.3



Pic. 6.1



Pic. 6.2

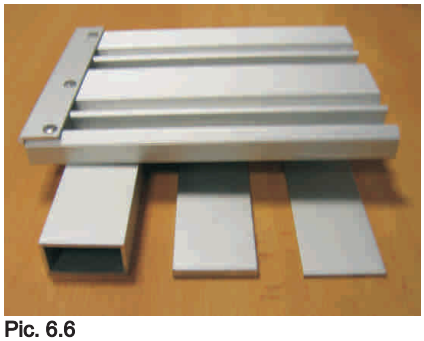


Pic. 6.3

Continue in the same way as the first rail has been fixed, see pictures No. 6.4 - 6.6. According to picture No. 6.6 underlay the leading line with aluminium strips (optional), placing and position depends on unlevelness of the ground.

Pic. 6.4

Pic. 6.5


Pic. 6.6

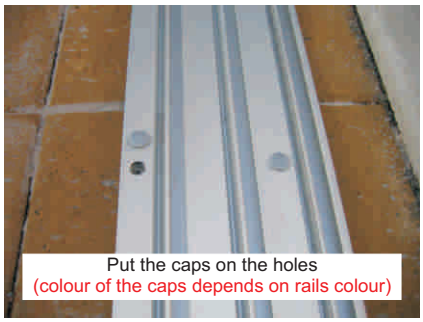
After fixation, it is important to clean the rails of dirt, the best way is to use vacuum cleaner and wash them by water stream.

Not cleaned rails and dirt may cause damage of anodize coating!

Pic. 6.7a

Pic. 6.7b

Cover the holes for raw-plugs with plastic caps with suitable colour (01.532, 01.546-47)



Pic. 6.8

Pic. 6.9

7. PUTTING THE ELEMENTS ON

After the fixing the rails proceed to putting the elements on the leading lines. Be careful while manipulate with elements to avoid damage, deformation and cratching. With respect to weight of the element assure suficient number of people for manipulation with the element.

According to a pictures No. 7.1 - 7.6 unload the elements out of a truck, and bring them to the pool area.

Release the securing attachment and transport device...

Pic. 7.1

Tuck the foam pieces away...

Pic. 7.2

... put the faces off the elements for later usage (lower weight and better manipulation with)

Pic. 7.3

Manipulation with element (unloading off the truck)

Pic. 7.4

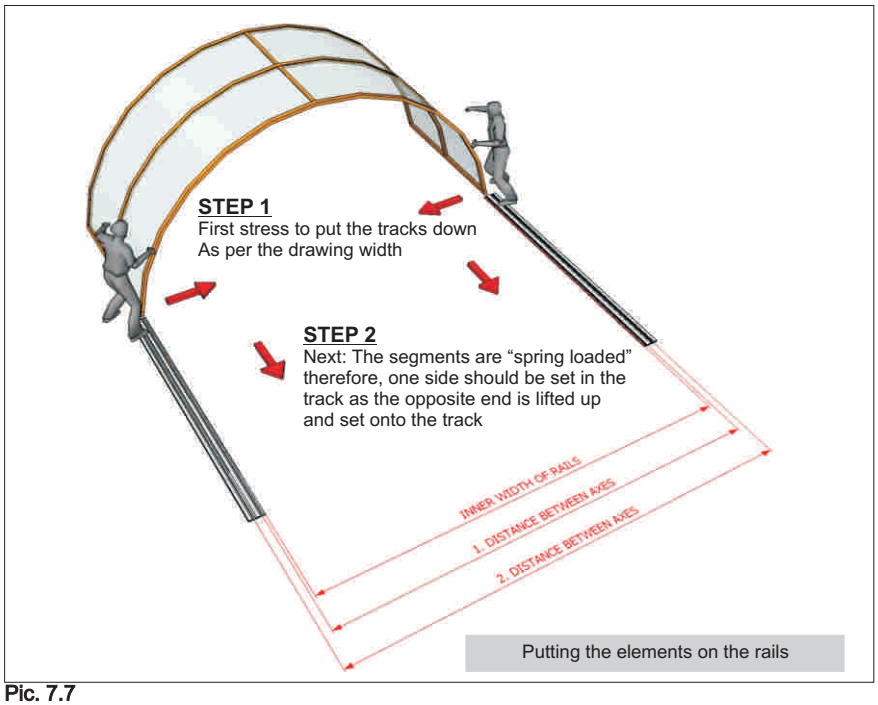
Manipulation by two persons (bringing the elements to the pool area) ...

Pic. 7.5

... and find the simpliest and easiest way to the pool area

Pic. 7.6

According to the picture No. 7.7 - 7.9 put the elements (faces included) on the rails.



Pic. 7.7

While putting the elements on the rails take care...

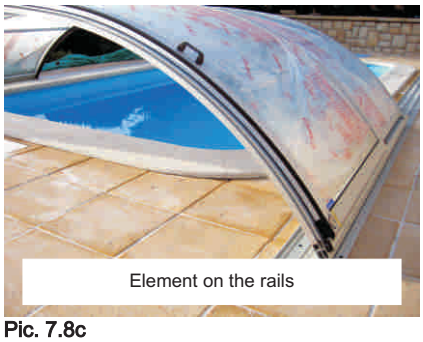
Pic. 7.8

... about suficient distance between arrestment sheets and the ground (risk of sheets or pavement damage)

Pic. 7.8a

Element on the rails
with detail of arrestment sheet

Pic. 7.8b



Element on the rails

Pic. 7.8c

Putting the faces back on the elements

Pic. 7.8d

7.1 FRONT OF SEGMENT

The following pictures fig. 7 - fig. 7.1. display the procedure of installation of the fronts (inner).

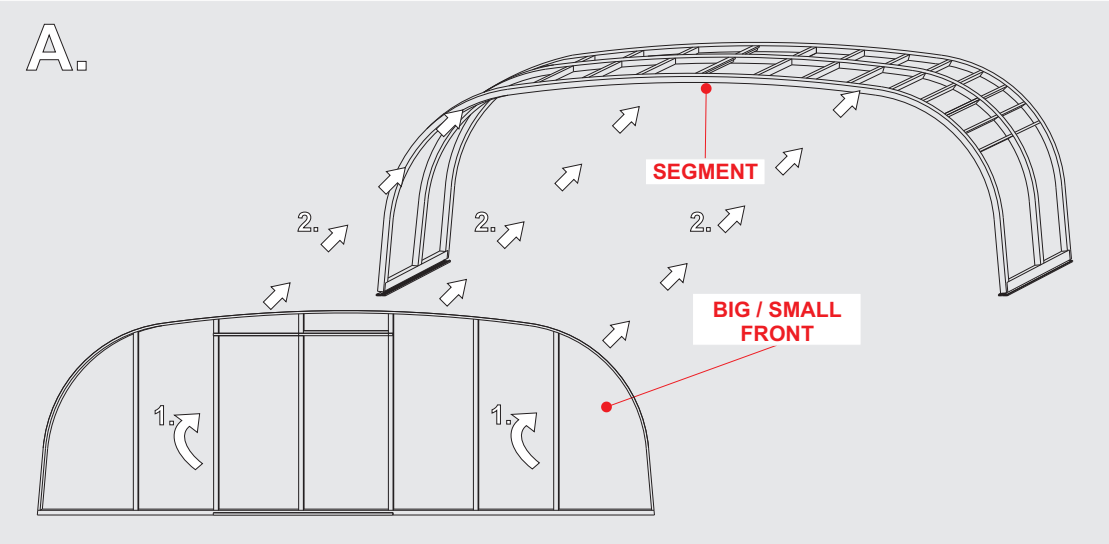


Fig. 7.a - **1.)** take the inner front and turn it over to the vertical position
2.) move the inner front to the bearing profile of the segment

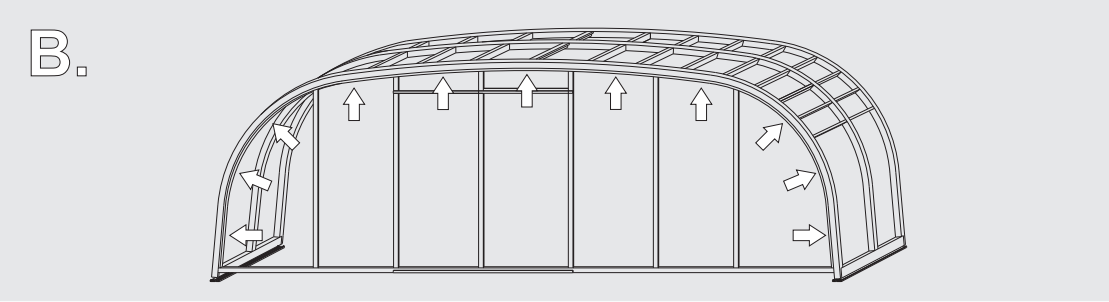


Fig. 7.b - put the inner front to the bottom surface of the bearing profile of the segment

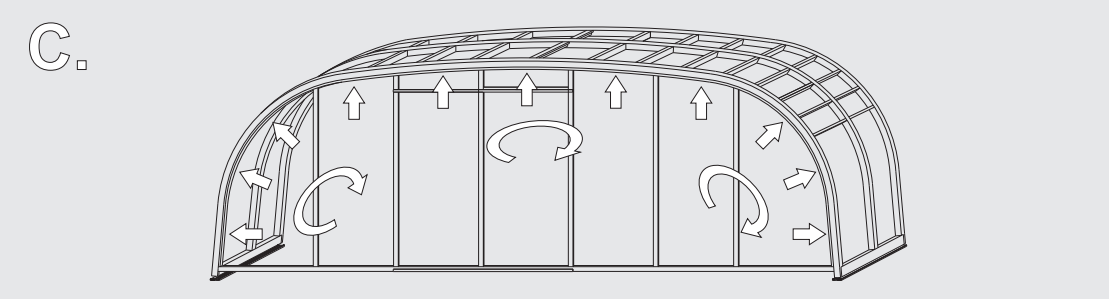


Fig. 7.c - then screw it together according to the following pictures fig. 7.1a - 7.1g

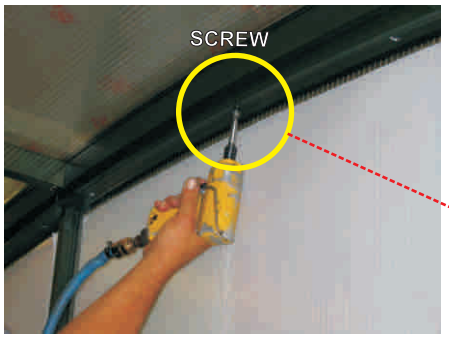


Fig. 7.1a

Fig. 7.1b

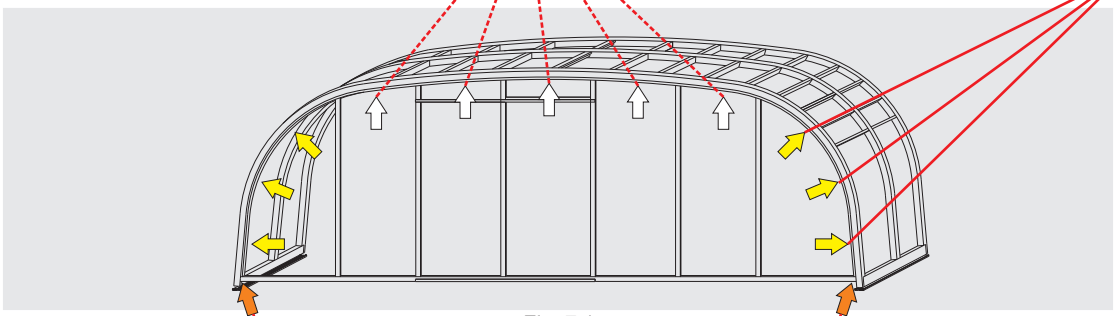


Fig. 7.1c

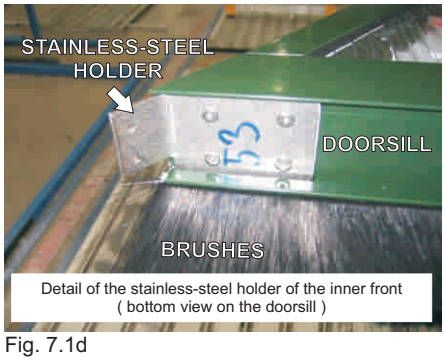


Fig. 7.1d

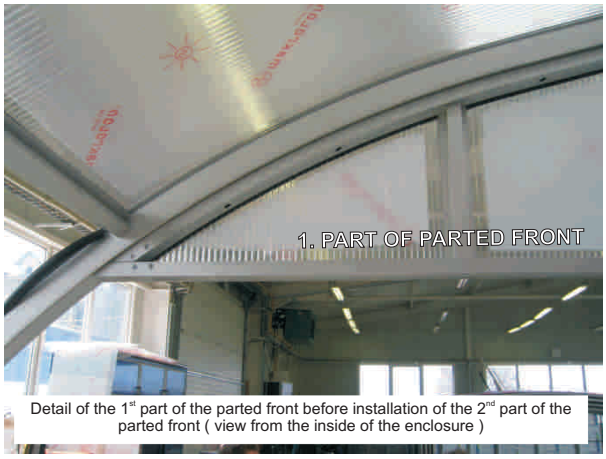
Fig. 7.1e

Fig. 7.1f

Fig. 7.1g

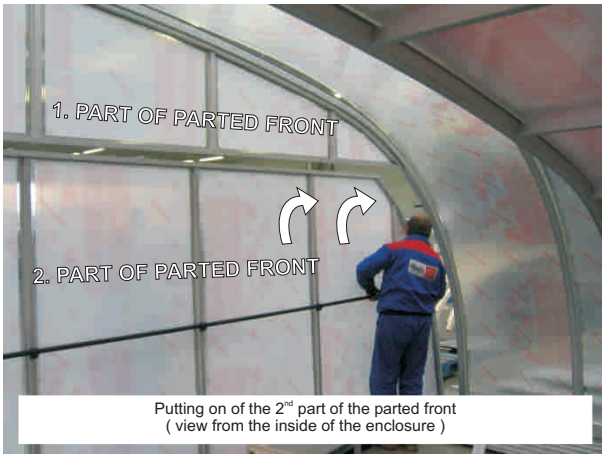
7.2 PARTED FRONT OF THE SEGMENT

The following pictures fig. 7.2a - fig. 7.2f display the procedure of installation of the parted front. This way is used if the front and its dimensions are oversized - oversized dimensions of the front do not allow standard transport to the place of installation.



Detail of the 1st part of the parted front before installation of the 2nd part of the parted front (view from the inside of the enclosure)

Fig. 7.2a



Putting on of the 2nd part of the parted front (view from the inside of the enclosure)

Fig. 7.2b

Fig. 7.2c

First screw together the horizontal part according to the pre-drilled holes (parting plane of the front)

Fig. 7.2d

Detail of screwing of two parts of the parted front together into one unit (view from the inside of the enclosure)

Fig. 7.2e

Then screw together the arced part according to the pre-drilled holes

Fig. 7.2f

7.3 LIFT-UP AND ITS PUTTING ON FACE

The following pictures fig. 7.3a - fig. 7.3e display the procedure of installation of the parted lift-up or standard lift-up.

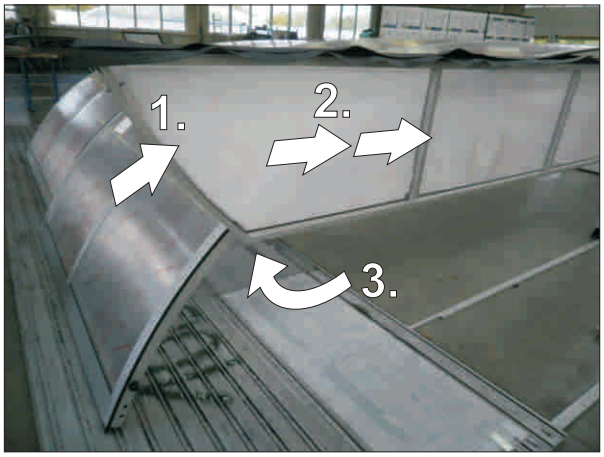


Fig. 7.3a

1.) Take this lif-up ...

2.) ... and put this lif-up into hinges, which are already assembled.

3.) Take a look at last hinge, which is not complet, view from below, see picture fig. 7.3b !!!

4.) Take remaining hinge and put it on the last incomplete hinge, rivet it to the lift-up per predrilling holes

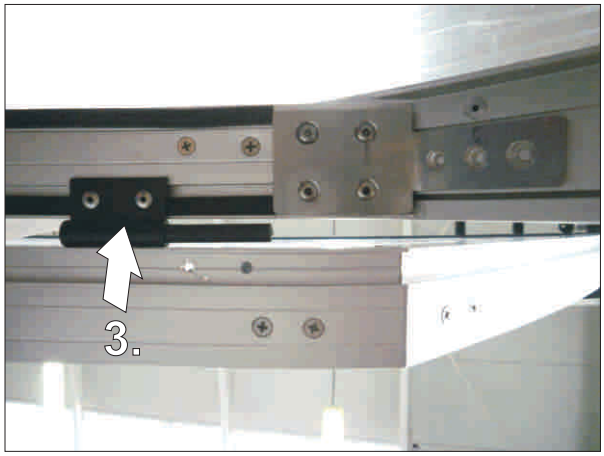


Fig. 7.3b

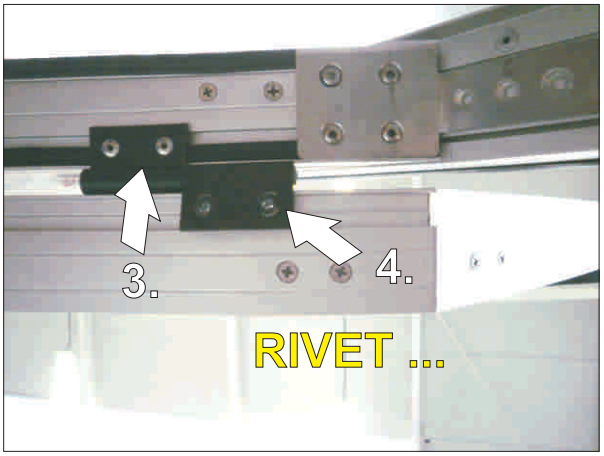


Fig. 7.3c

Fig. 7.3d

5.) After reclining the lift-up down ...

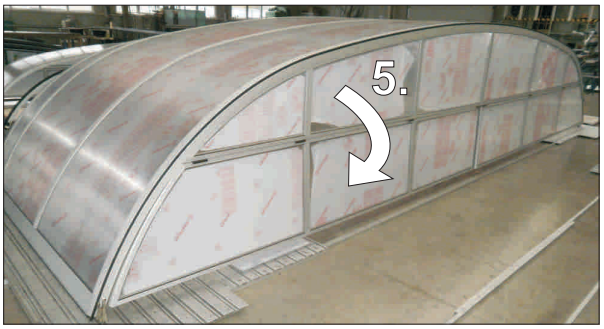


Fig. 7.3e

7.4 FRONT - END ELEMENTS / HANDLE

If the transport conditions do not allow to transport a large front with mounted sleeves, designed for fixation of the pipe rod - handle, it is necessary to mount it later at the assembly site - see Fig. 7.4a - 7.4e below

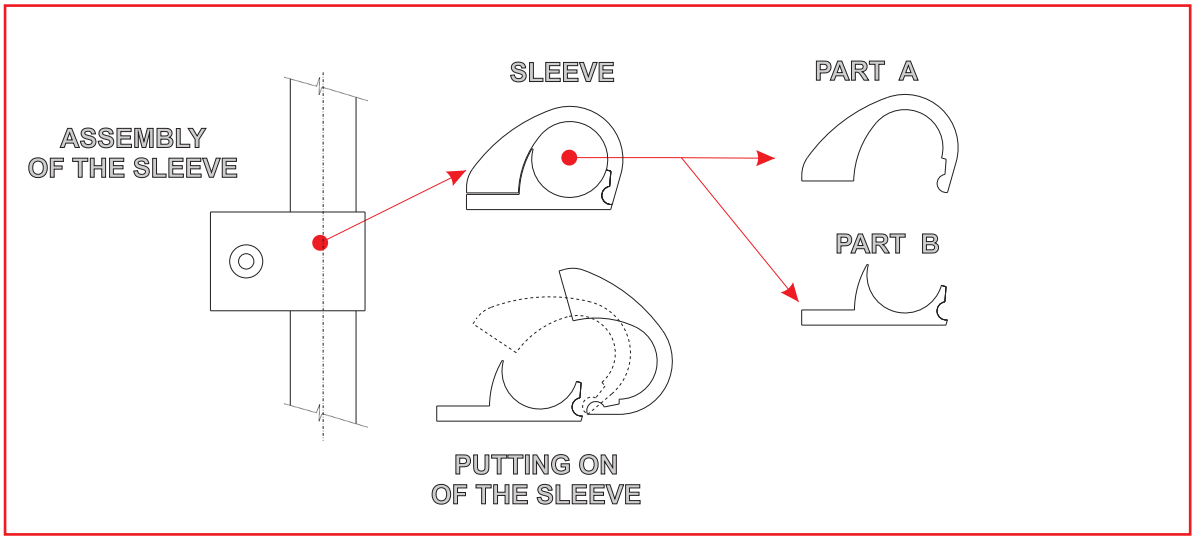


Fig. 7.4a

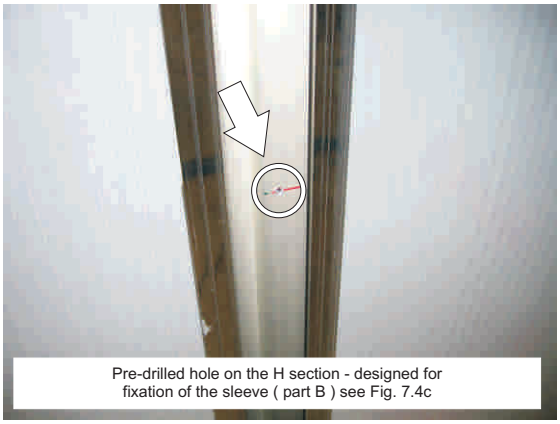


Fig. 7.4b

Fig. 7.4c

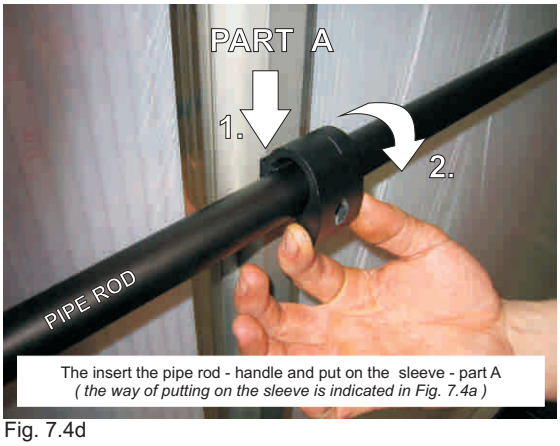


Fig. 7.4d

Fig. 7.4e

7.5 FRONT - END ELEMENTS / DOOR BRUSHES

Transport of a large front where the door is without the threshold - for completion it is necessary to dismount the fixation section and then attach the brush strips by a rivet - see Fig. 7.5a - 7.5d

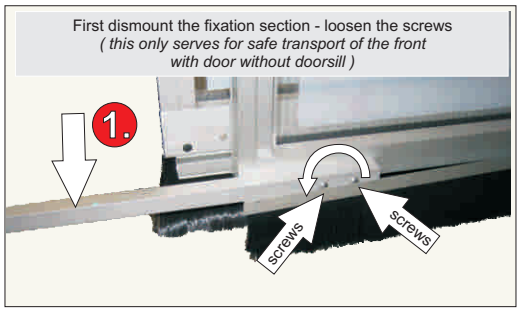


Fig. 7.5a

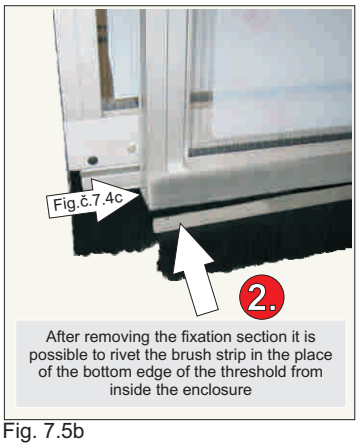


Fig. 7.5b

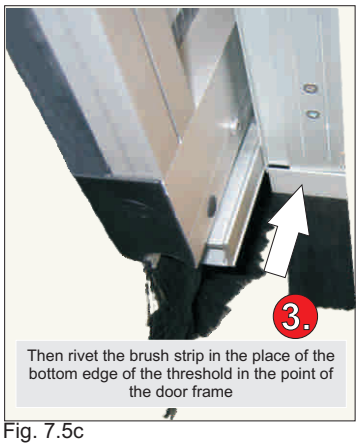


Fig. 7.5c

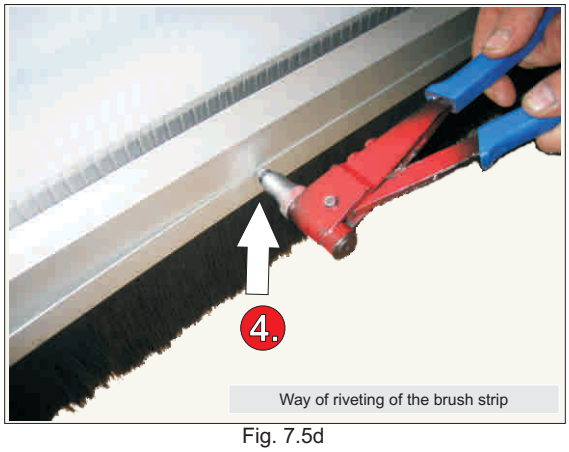


Fig. 7.5d

7.6 SEGMENT - END ELEMENTS / STRIP COVERS AND BLIND FLANGES

The delivery includes strip covers and blind flanges depending on the delivery type - here for example: one of the delivered blind flanges is the strip cover on the rail of the side entrance - see Fig. 7.6a - 7.6b

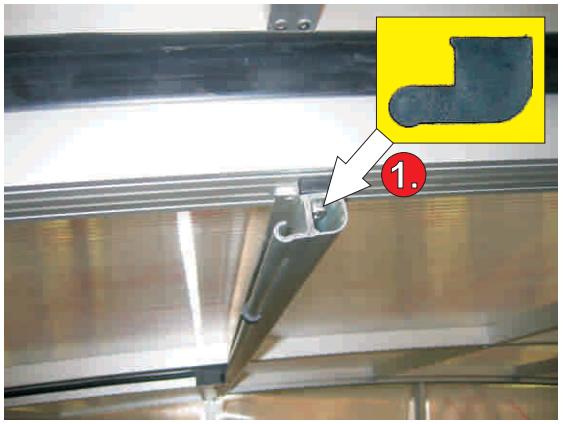


Fig. 7.6a

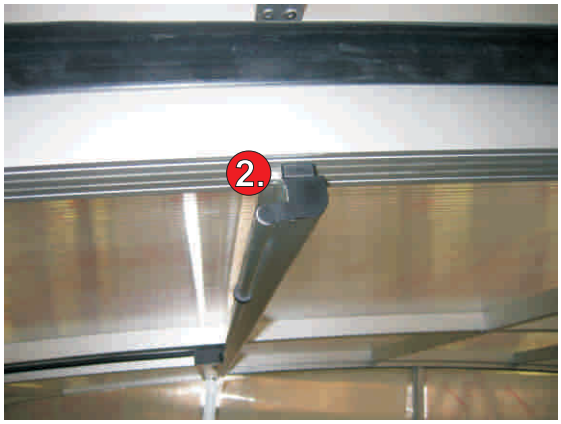
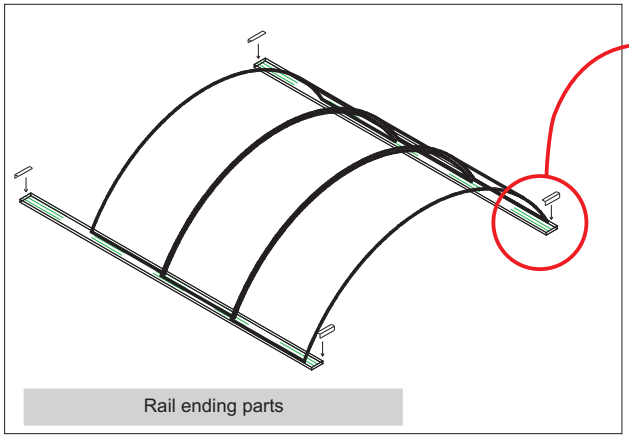


Fig. 7.6b

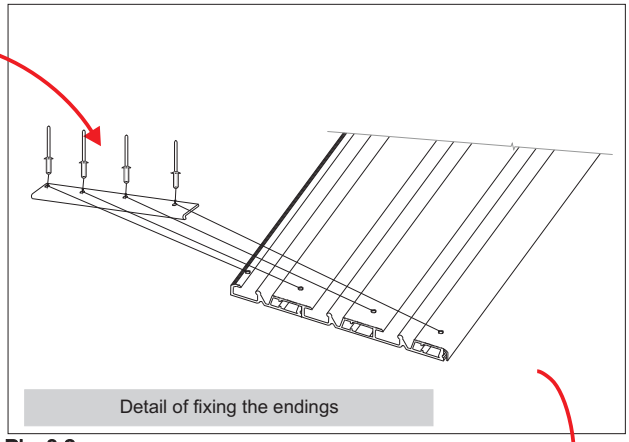
8. FINALIZING THE RAILS

After putting the elements on proceed with assembling - fix the rail ending parts (01.104), see picture No. 8.1 - 8.5.
These endings parts (01.104) avoid moving the elements off the rails.



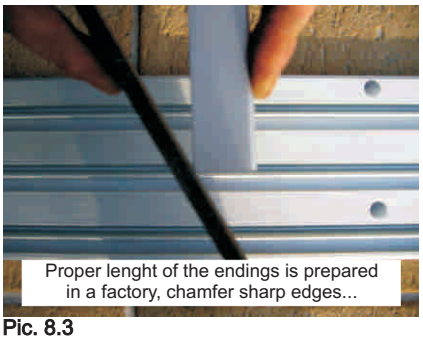
Rail ending parts

Pic. 8.1



Detail of fixing the endings

Pic. 8.2

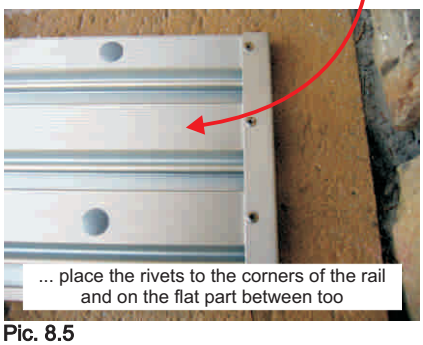


Proper lenght of the endings is prepared in a factory, chamfer sharp edges...

Pic. 8.3

... and fix the endings to the rails by rivets

Pic. 8.4

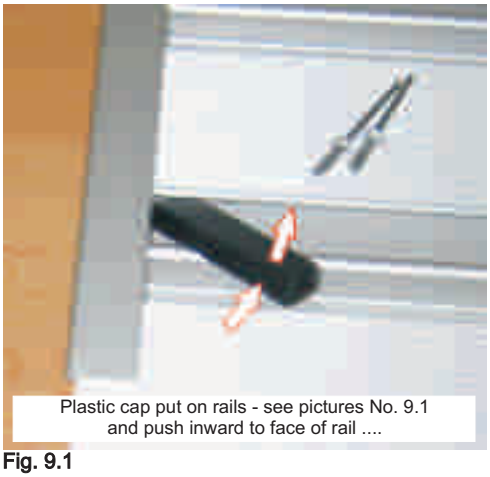


... place the rivets to the corners of the rail and on the flat part between too

Pic. 8.5

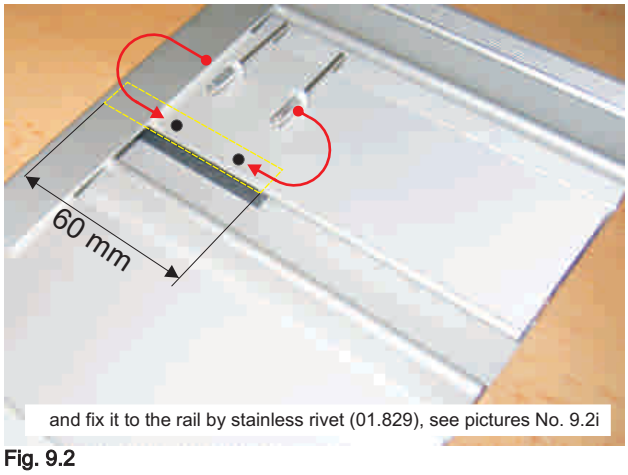
9. PLASTIC CRAP FOR TRAVEL PROGRES

Continue in the same way as the plastic cap for travel has been fixed, see pictures No. 9.1 - 9.2.
This plastic cap (01.543) are for security function - absorb the shock of travel and defend for refuse to start of elements from rails.



Plastic cap put on rails - see pictures No. 9.1 and push inward to face of rail ....

Fig. 9.1



and fix it to the rail by stainless rivet (01.829), see pictures No. 9.2i

Fig. 9.2

10.A. ARRESTMENT COMPONENTS - automatic arrestment of element 1 / 2

Combinations of locks and arrestments are according to a production documentation, where a type and locking system are specified. For types, see appendix .

Arrestment components secure the enclosure especialy against a climatic influences.

Locks components secure the enclosure especialy against a climatic influences, as well as they are further securing component avoiding entrance of unauthorized persons.

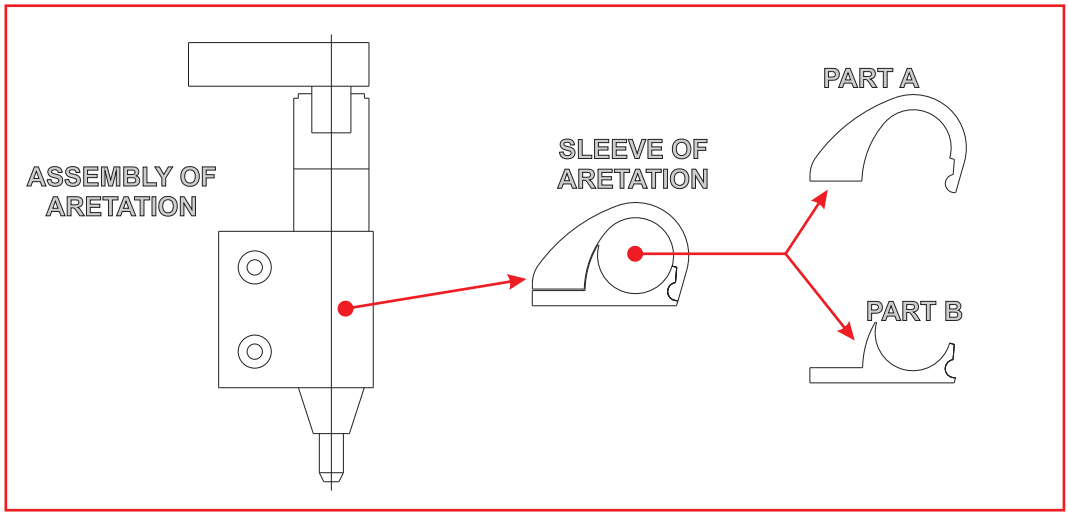


Fig. 10.1a

Fig. 10.1b

Fig. 10.1c

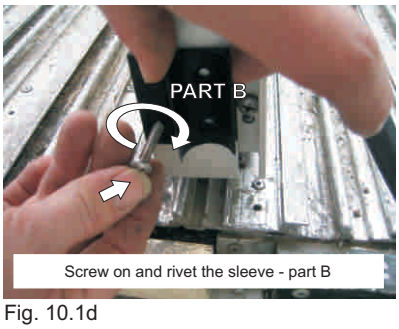


Fig. 10.1d

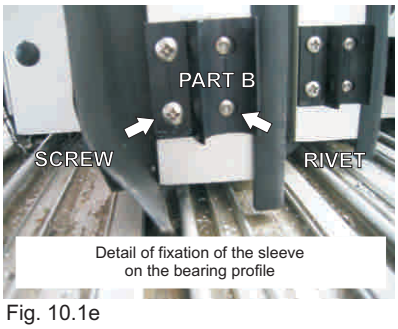


Fig. 10.1e

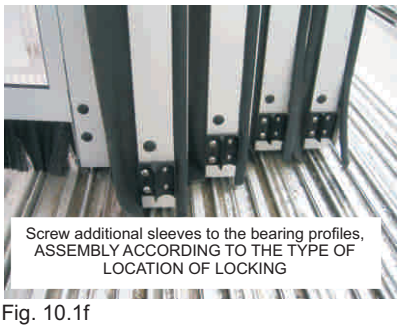


Fig. 10.1f

10.A. ARRESTMENT COMPONENTS - automatic arrestment of element 2 / 2

Assembly of arrestment element

To assemble the arrestment (Fig. 10.2a - 10.2c) put the locking body in one part of the sleeve (**part B** - *mounted already in ALUKOV*) and then put on the other part of the sleeve (**part A**), then secure the position of the locking body with screws.

Before full tightening of the screws it is necessary to adjust the locking so that in the SECURED position there is a stopper of 1.5 mm between the protruding peg and the rail.

Put the body in one part of the sleeve (**part B**, see Fig. 10.1a)

Then put on the other part of the sleeve (**part A**, see Fig. 10.1a) and then delimit a space of 1.5 mm acc. to Fig. 10.2b

Secure the position of the locking body by tightening of screws with already delimited stopper of 1.5 mm in the SECURED state

MOUNTING OF SLEEVE 25 mm FROM THE BOTTOM EDGE OF THE SECTION!
APPLIES FOR ALL ANGLES , 50 - 85 DEGREES!
STATUS - RELEASED

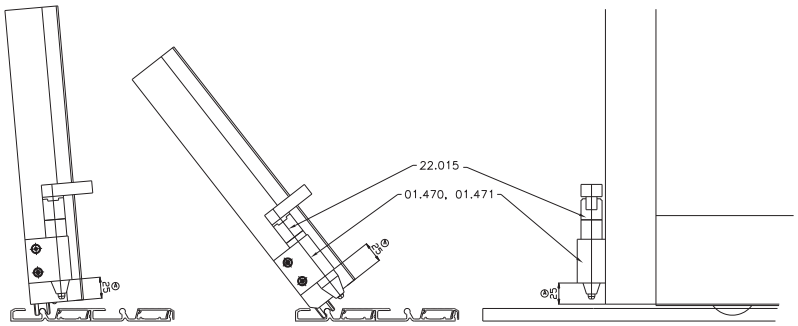


Fig. 10.2d

MOUNTING OF SLEEVE 25 mm FROM THE BOTTOM EDGE OF THE SECTION!
APPLIES FOR ALL ANGLES , 50 - 85 DEGREES!
STATUS - SECURED

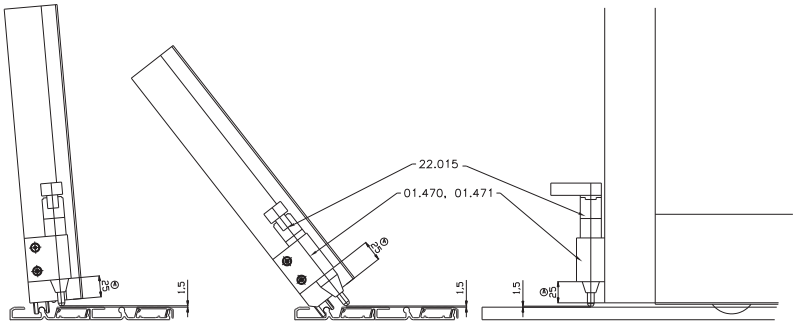


Fig. 10.2e

AUTOMATIC ARRESTMENTS PROGRES is locked by means of stoppers - before mounting the clips it is necessary to drill holes (drill bit □4mm) in the travel track and then put in the stopper (01.440) and rivet it. When drawing the enclosure to its total length above the pool, the locking securing pegs, located on individual elements, fit in the hole in the clip one after another.

Depending on the selected arrestments (see Suplement) shall the stoppers be placed only after drawing the elements along the entire length of the enclosure (now in this expanded state the element only overlap each other by the width of the section - see Fig. 10.2h)


Fix the automatic arrestments (see Fig. 10.2a - 10.2c)

Fig. 10.2f

... with already delimited gap of 1.5 mm in the SECURED state

Fig. 10.2g


First set out the elements along the entire length of the pool and check overlapping of elements by the width of the section

Fig. 10.2h


Mark the position of the stopper according to the protruding locking peg and rivet it to the rail...

Fig. 10.2i

If the securing peg does not fit in the hole in the clip or otherwise does not fulfil the locking function, it is necessary to underlay the clip with the washer 01.441 so as to make the securing peg fit in the hole in the clip - see Fig. 10.2j


... and check the functionality of the arrestments element

Fig. 10.2j

Securing against unwanted spontaneous moving of elements from the drawn-in state of the enclosure

(applies for automatic arrestments and for manual locking)


Fig. 10.3a


Fig. 10.3b

At the end of assembly of the locking elements it is necessary to lock the biggest or the smallest element at the end of rails, more specifically in the point of maximum side displacement of all elements.

10.B. ARRESTMENT COMPONENTS - lock for element 1 / 2

LOCK FOR ELEMENT PROGRES is locked by means of stoppers - before mounting the clips it is necessary to drill holes (drill bit □4mm) in the travel track and then put in the locking clip (01.440) and rivet it. After drawing the enclosure to its total length above the pool, the locking securing pegs, located on individual elements, fit in the hole in the clip just during locking.

Depending on the selected locking system (see Suplement) shall the clips be placed only after drawing the elements along the entire length of the enclosure (now in this expanded state the element only overlap each other by the width of the section - see Fig. 10.2h)


Fix the manual locks of elements
(similar to Fig. 10.2a - 10.2c)

Fig. 10.3a

... with already delimited gap of 1.5 mm
in the SECURED state

Fig. 10.3b


First set out the segments along the entire
length of the pool and check overlapping
of elements by the width of the section

Fig. 10.3c


Mark the position of the clip according
to the protruding locking peg
and rivet it to the rail...

Fig. 10.3d

If the securing peg does not fit in the hole in the clip or otherwise does not fulfil the locking function, it is necessary to underlay the clip with the washer 01.441 so as to make the securing peg fit in the hole in the clip - see Fig. 10.2j


.... and check the functionality
of the element manual lock

Fig. 10.3e

10.B. ARRESTMENT COMPONENTS - lock for element 2 / 2

Securing against unwanted spontaneous moving of elements from the drawn-in state of the enclosure

(applies for automatic arrestments and for manual locking)

Fig. 10.4a

Fig. 10.4b

At the end of assembly of the locking elements it is necessary to lock the biggest or the smallest element at the end of rails, more specifically in the point of maximum side displacement of all elements.

LOCKING OF MANUAL LOCK FOR PROGRES ELEMENT

PROCEED AS SEEN IN FIG. 10.5a - 10.5f

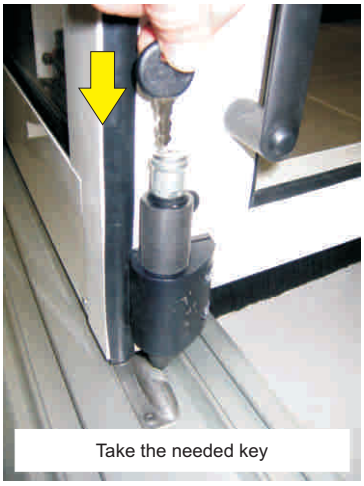


Fig. 10.5a

Fig. 10.5b

Fig. 10.5c

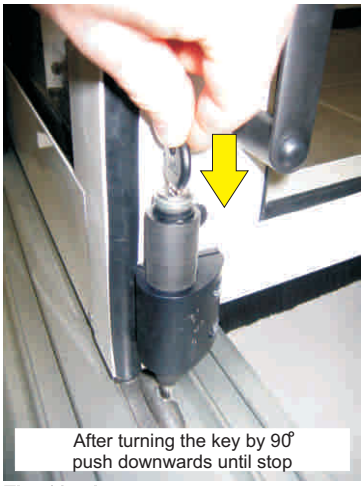


Fig. 10.5d

Fig. 10.5e

Fig. 10.5f

10.C. LOCK COMPONENTS - lock for lift-up

The safe transport segments is necessary not to give lock for lift-up, then up to the assembly on placework must be screwed by fig. 10.6a - 10.6c

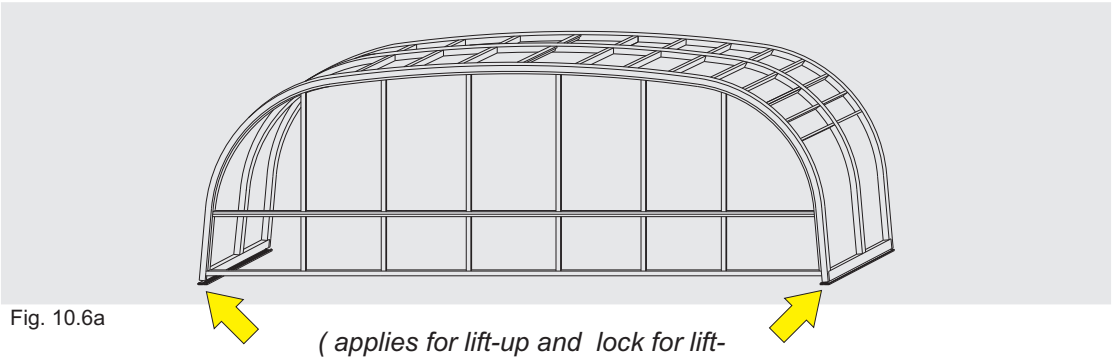


Fig. 10.6a

(applies for lift-up and lock for lift-up)

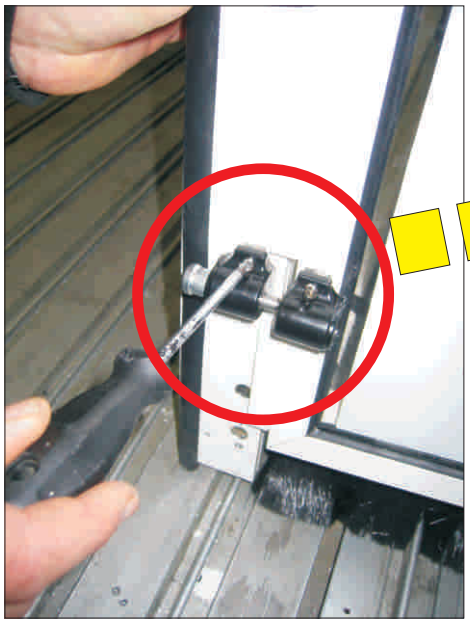


Fig. 10.6b

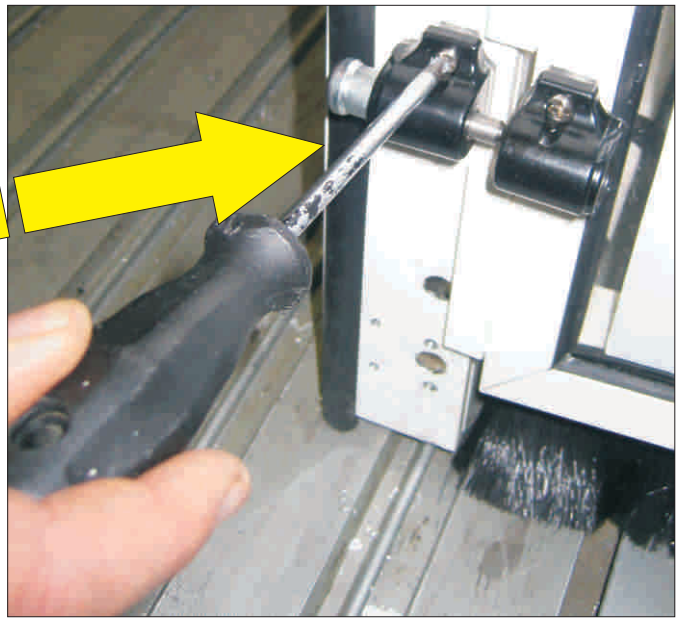
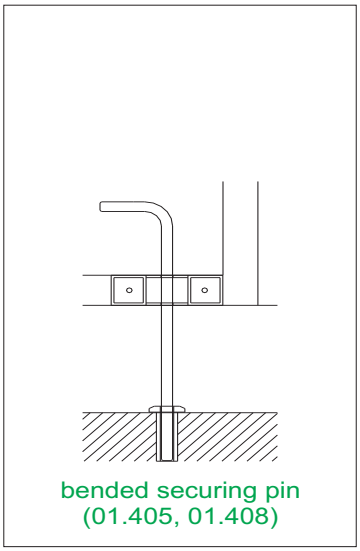


Fig. 10.6c

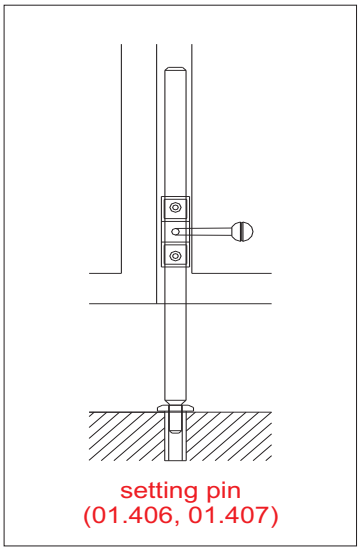
11. ARRESTMENT COMPONENTS - arrestment of faces

Arrestment components secure the enclosure especialy against a climatic influences.

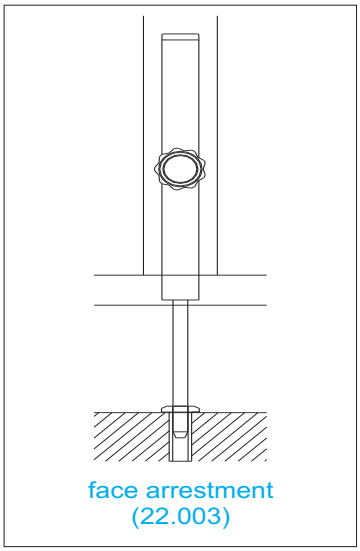
Arrestment components secure the enclosure especialy against a climatic influences.



bended securing pin
(01.405, 01.408)



setting pin
(01.406, 01.407)



face arrestment
(22.003)

Arrestment of faces

Faces arrestments (bended securing pin 01.405, 01.408 or setting pin 01.406, 01.407) are fixed by rivets (01.827 drill Ø4mm), from the season 2007 newer face arrestment is used (22.003).

Proceed with drilling a hole Ø15mm into a pavement or ground and push a plastic insert in (01.512). Distance between arrestments depends on a face outfit and distance of the reinforcements.

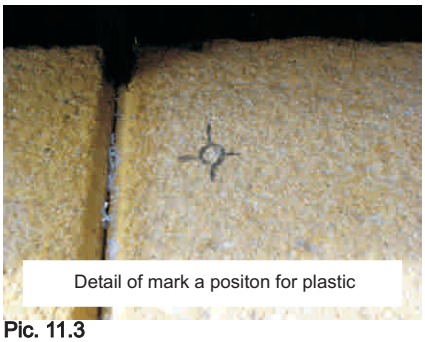
For drilling proceedure, see picture No.11.1 - 11.5

Fixing of leading bar for the face arrestment and putting the arrestment on the leading bar...

Pic. 11.1

... mark a positon for plastic insert in a ground

Pic. 11.2



Detail of mark a positon for plastic

Pic. 11.3

Drill a hole
(as exact as possible)

Pic. 11.4

Detail of pushing the insert into the hole and face arrestment function check

Pic. 11.5

12. SEALING OF POLYCARBONATE - overview of individual sealings

Seal the polycarbonate in the segment using sealing rubber. The sealing rubber is inserted in the space between the polycarbonate and the inner wall of the section.

For the list of recommended tools see fig .**12.**
Overview of the used sealing and the place - see additional pictures fig.**12.x.x**

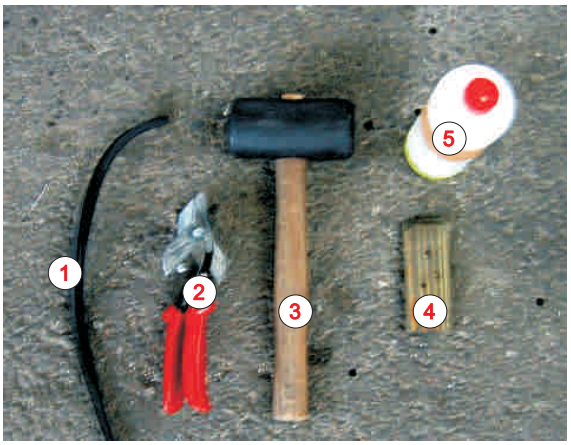


Fig.12.1

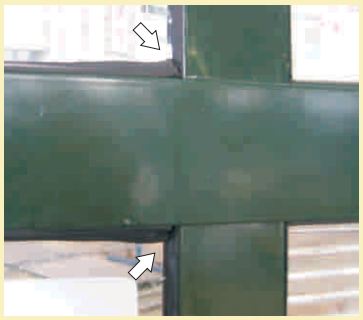
LEGEND to fig. 12.1

1. rubber sealing
2. scissors
3. rubber mallet
4. auxiliary block
5. bottle with detergent solution

Detergent solution
ratio of water to detergent approx. 10:1
- enables easier sealing, reduces friction between the rubber sealing and polycarbonate during sealing

During sealing (with rubber) keep in mind the corner overlaps of the sealing rubber, which will be then trimmed in the corner to measure (for the corner of an angle of 90° trim the sealing under an angle of 45°)

Use of the detergent solution enables easier sealing, reduces friction between the rubber sealing and polycarbonate during sealing



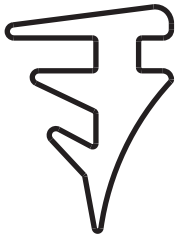
12.1a SEALING OF POLYCARBONATE - types of sealing depending on the polycarbonate

PC washer
ref.No. 01.710 - strong

PC washer
ref.No. 01.728 - middle

PC washer
ref.No. 01.737 - thin

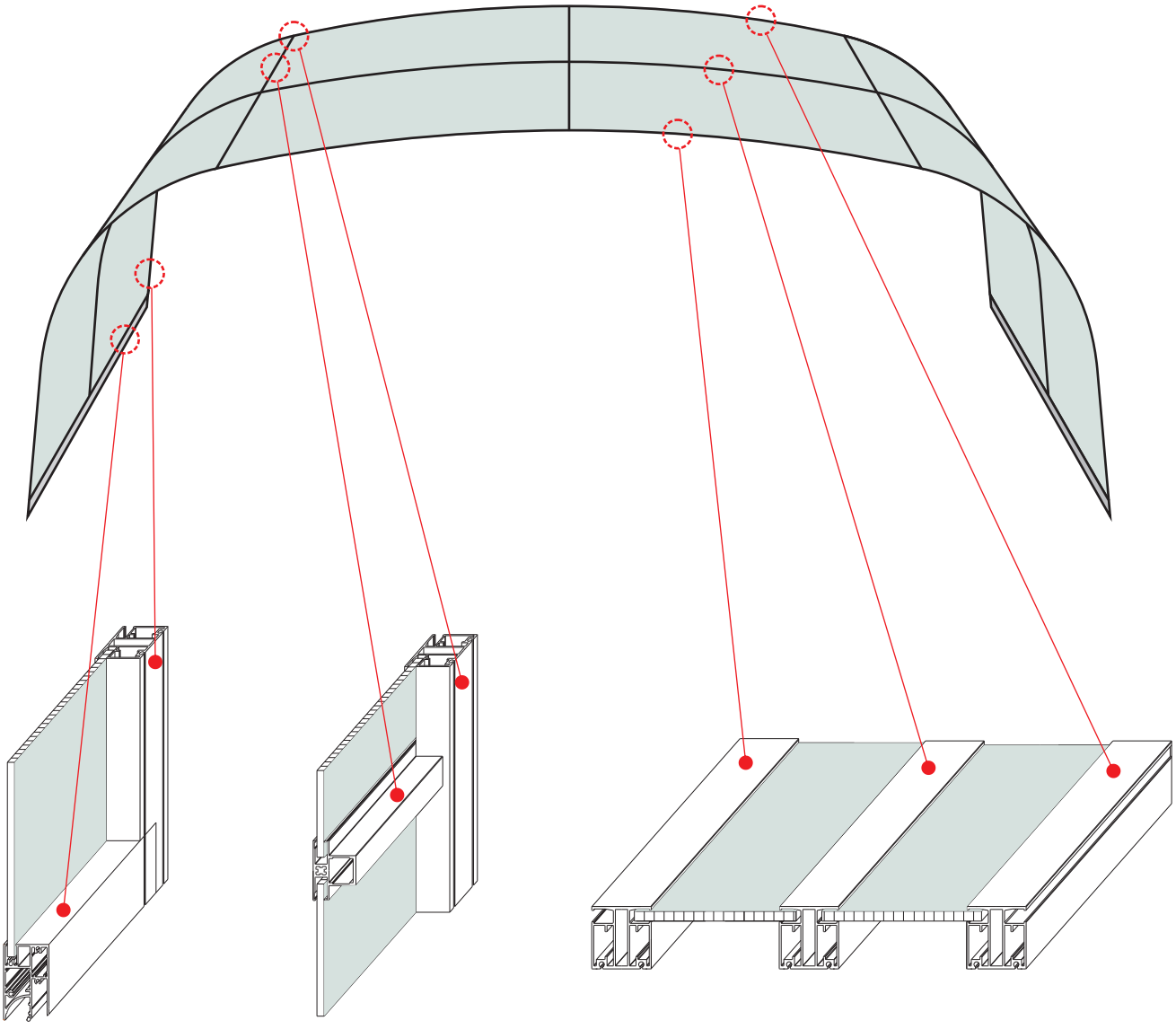
Fig. A



Washer middle
IMP, RAV
ref.No. 01.706

Fig. B

12.1b SEALING OF POLYCARBONATE - overview of positions of profiles in the segment



1.) BEARING PROFILE
2.) MIDDLE PROFILE
3.) TRAVEL

1.) BEARING PROFILE
2.) MIDDLE PROFILE
3.) PROFILE H

1.) BEARING PROFILE
2.) MIDDLE PROFILE

Fig. C

12.2 SEALING OF POLYCARBONATE - bearing profile, middle profile

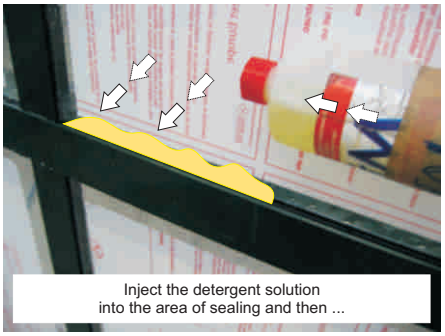


Fig.12.2.1a

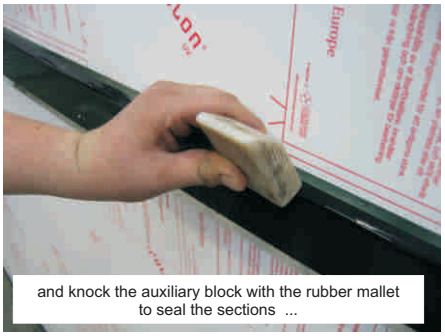


Fig.12.2.1b

Fig.12.2.1c

POLYCARBONATE
10 mm

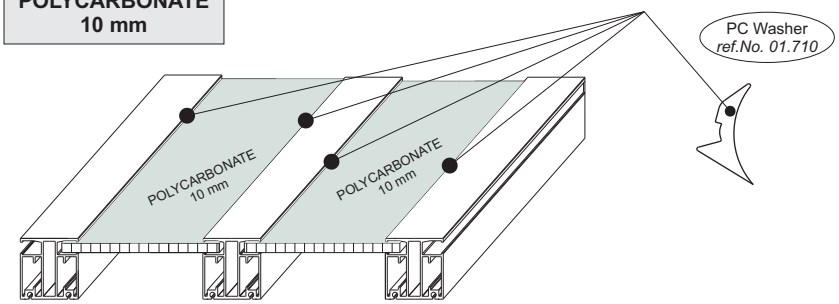
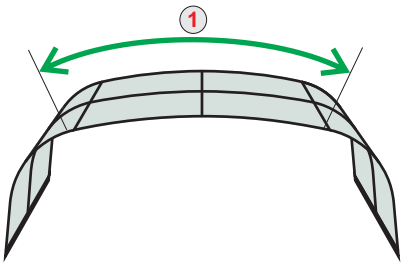


Fig.12.2.1d



1.) SEAL FROM THE OUTSIDE ALONG THE ENTIRE ARC LENGTH FROM THE FIRST CROSSBAR TO THE LAST CROSSBAR

POLYCARBONATE COMBINATION
8 mm / 4 mm

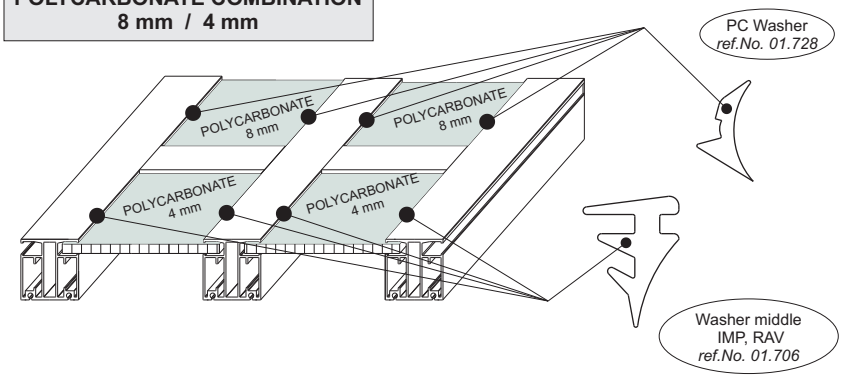
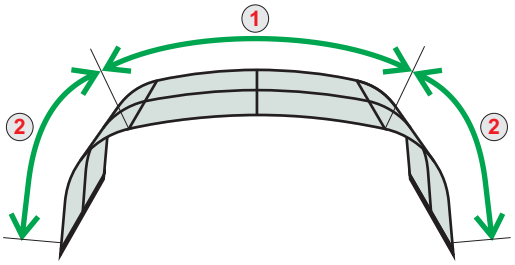


Fig.12.2.1e



1.) SEAL FROM THE OUTSIDE ALONG THE ENTIRE ARC LENGTH FROM THE FIRST CROSSBAR TO THE LAST CROSSBAR

2.) SEAL FROM THE OUTSIDE ALONG THE ARC LENGTH FROM THE CROSSBAR TO THE TRAVEL

POLYCARBONATE
4 mm

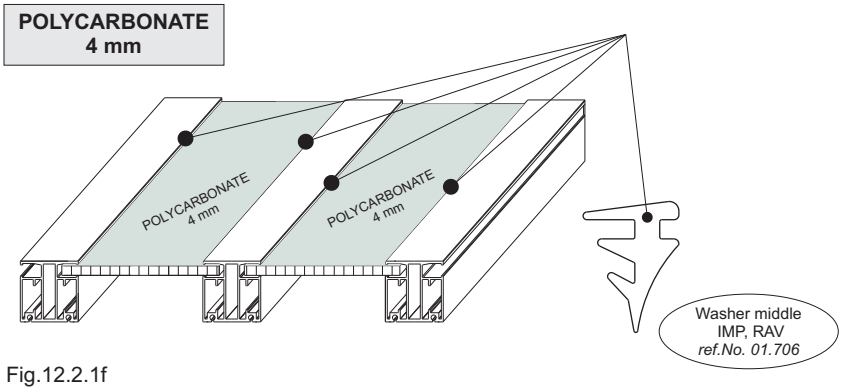
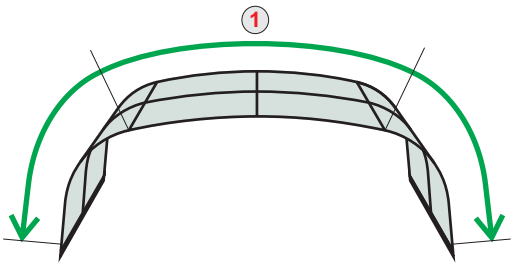


Fig.12.2.1f



1.) SEAL FROM THE OUTSIDE ALONG THE ARC LENGTH FROM TRAVEL TO TRAVEL

12.3 SEALING OF POLYCARBONATE - Profile H

Seal the polycarbonate in the travel section using the sealing rubber. The sealing rubber is inserted in the space between the polycarbonate and the inner wall of the section.

For the list of recommended tools see fig .**12.** Overview according to the used sealing and the place - see additional pictures fig **12.3.1d - f**

Fig.12.3.1a

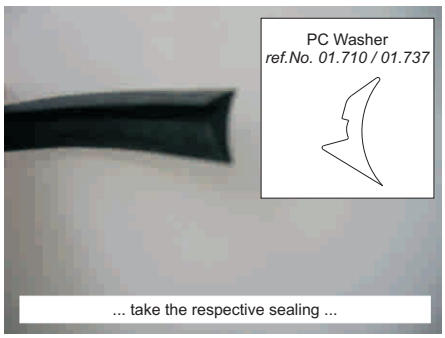


Fig.12.3.1b

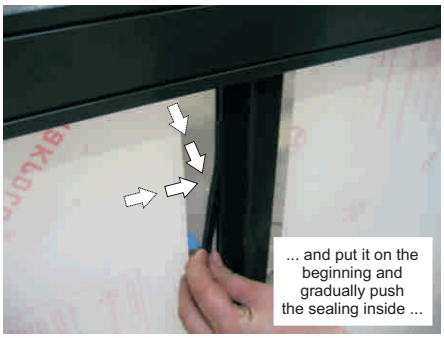


Fig.12.3.1c

POLYCARBONATE
10 mm

DO NOT SEAL !!!

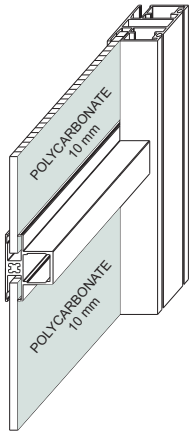


Fig.12.3.1d

POLYCARBONATE
COMBINATION
8 mm / 4 mm

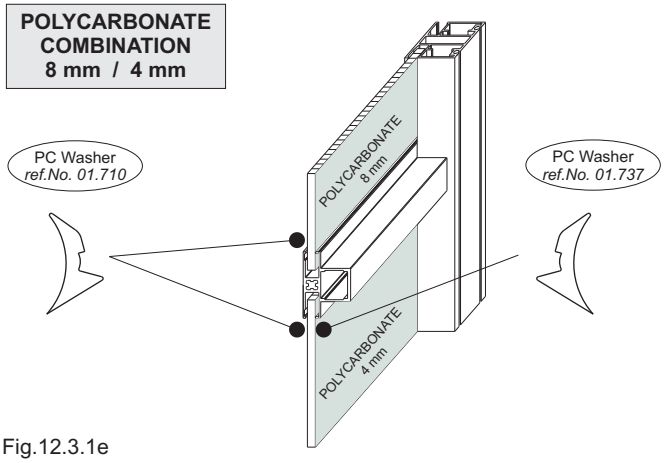


Fig.12.3.1e

POLYCARBONATE
4 mm

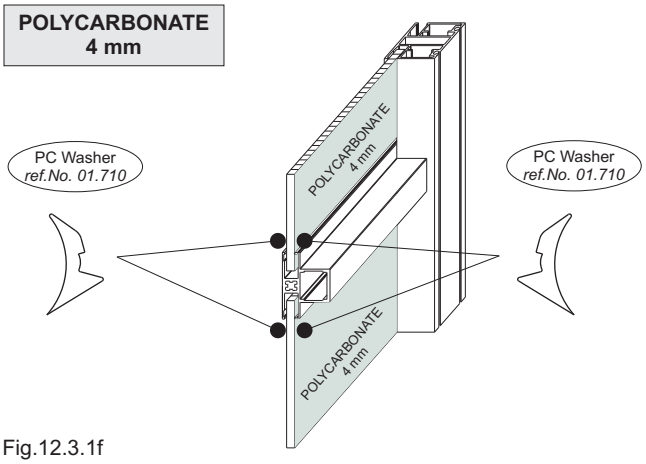


Fig.12.3.1f

12.4 SEALING OF POLYCARBONATE - travel

Seal the polycarbonate in the travel section using the sealing rubber. The sealing rubber is inserted in the space between the polycarbonate and the inner wall of the section.

For the list of recommended tools see fig. **12.** Overview according to the used sealing and the place - see additional pictures fig **12.4.1a - b**

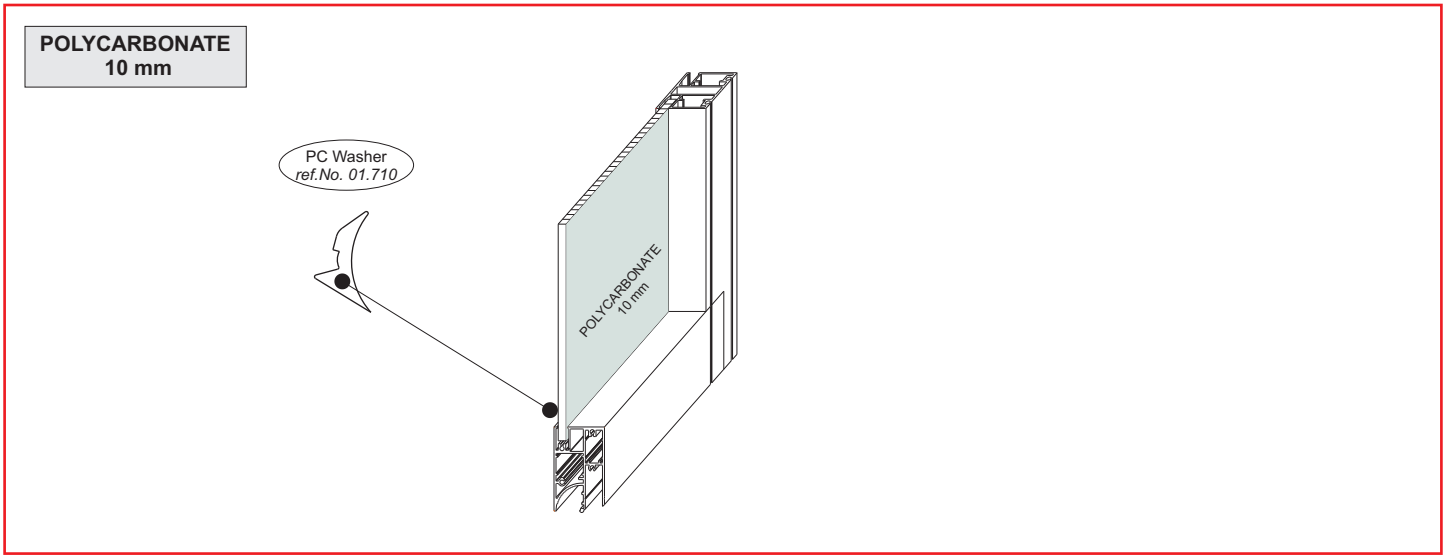


Fig. 12.4.1a

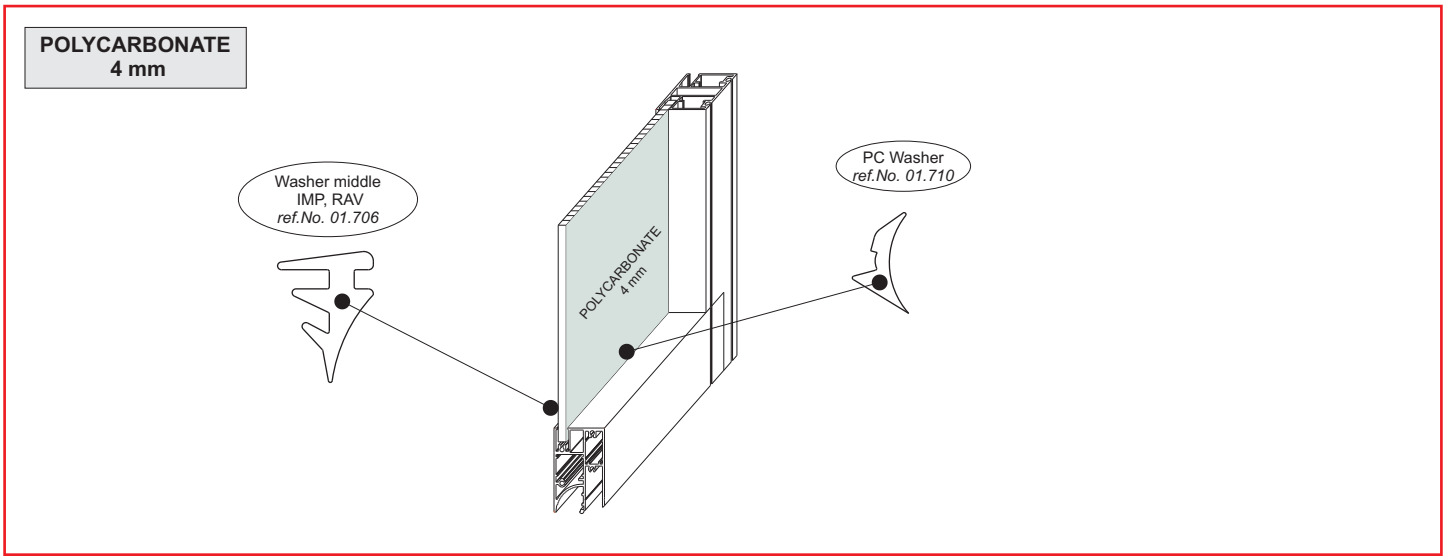


Fig. 12.4.1b

12.5 GASKET BETWEEN SEGMENTS_ - overlapping of individual segments

Seal the segments using 2 flags in the point of overlapping of the segments - see fig. **12.5.1**
For the procedure of sealing see fig. **12.5.1a - f**

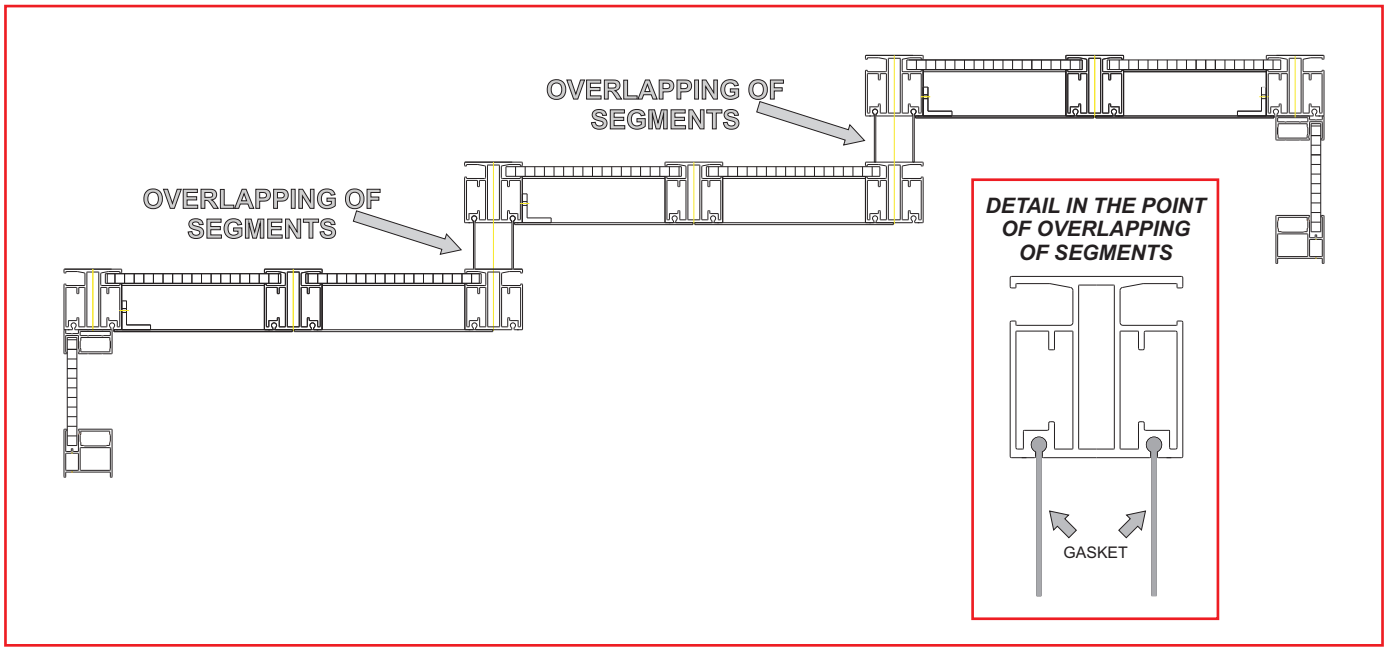


Fig. 12.5.1

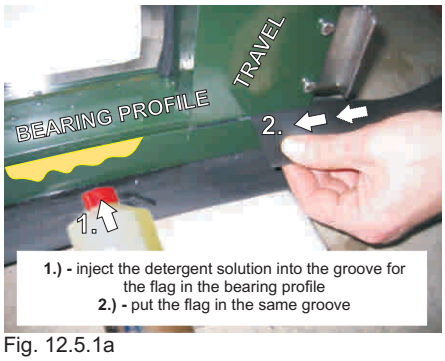


Fig. 12.5.1a

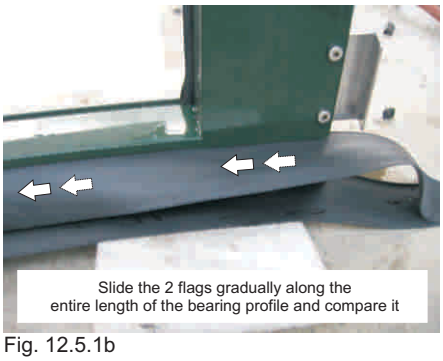


Fig. 12.5.1b

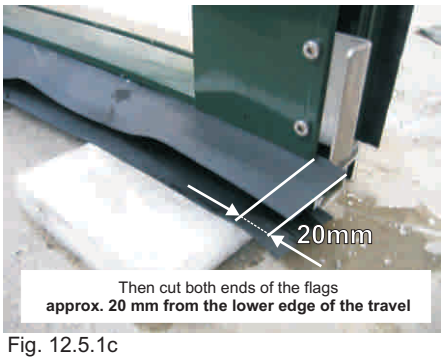


Fig. 12.5.1c

Fig. 12.5.1d

Fig. 12.5.1e

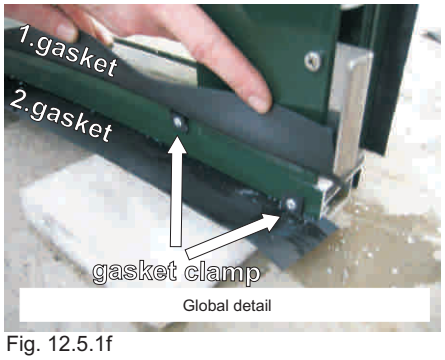
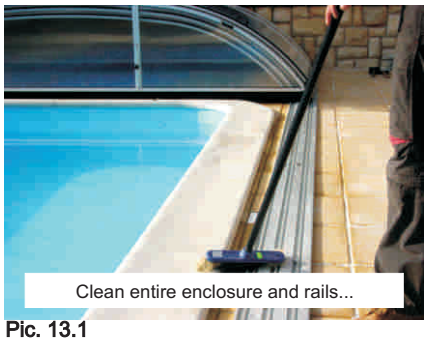


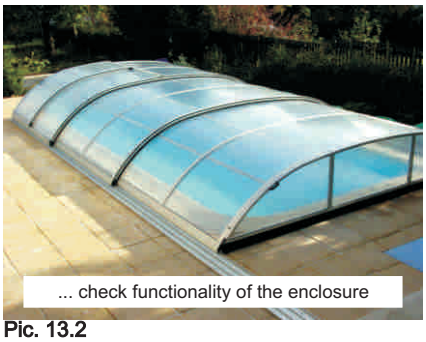
Fig. 12.5.1f

13. FINALIZATION OF ASSEMBLING

For easy moving the elements, clean all parts of the enclosure, leading lines included. Check functionality of all parts and of entire enclosure, after that, remove the protection foil from the polycarbonate. Clean a place of assembling, and restore all the obstacles, which had to be removed before the manipulation with elements, see picture No. 13.1 - 13.6


Clean entire enclosure and rails...

Pic. 13.1


... check functionality of the enclosure

Pic. 13.2


Removing of the protection foil from the polycarbonate

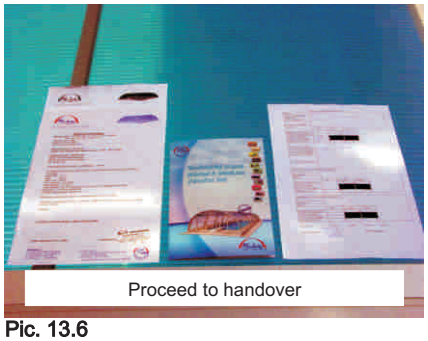
Pic. 13.3


Cleaning a place, foils included ...

Pic. 13.4


... restoring all the obstacles

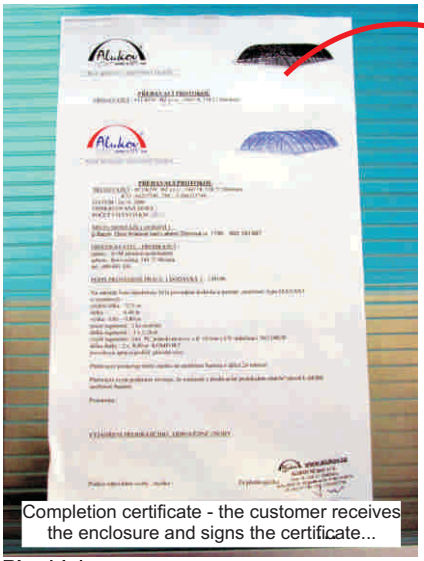
Pic. 13.5


Proceed to handover

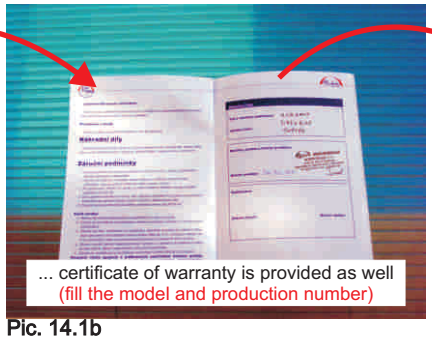
Pic. 13.6

14. COMPLETION CERTIFICATE

Before the final handover it is necessary to fill in some data about the transport and assembling.
These data are provided by workers in the completion certificate appendix, see picture No. 14.1c. All other data are filled in by company representatives, see picture No. 14.1a - 14.1c
Customer confirm the handover by signature and is able to use the eclosure.

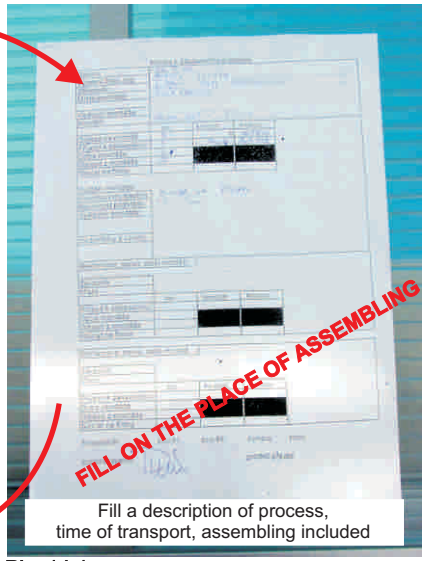

Completion certificate - the customer receives the enclosure and signs the certificate...

Pic. 14.1a


... certificate of warranty is provided as well (fill the model and production number)

Pic. 14.1b


End of assembling



Fill a description of process, time of transport, assembling included

Pic. 14.1c