RECOMMENDED INSTRUCTION FOR FITTING NAN YA's 'DISTINCTION' GLAZING CASSETTE TO NAN YA DOOR BLANKS.

The NanYa glazing assembly consists of an inner and outer cassette. Both of these have symmetrical male and female connectors/pockets, and are therefore reversible. An inner and outer are exactly the same.

The cassettes have channels around the outer and inner edges to accommodate glazing tape or sealant. Externally and internally the inner channel houses the seal between the cassette and the glass unit, and the outer channel houses the seal between the cassette and the door skin. For glazing tape & wet seal ratio across cassette styles please refer to the Distinction, door and cut out guide.

We recommend using a glass unit which is 24mm thick, as the glazing chamber of the closed assembly unit is 25.4mm. If using leaded glass units with the Nan Ya glazing assembly, the leading should be trimmed to the sight line (thus preventing vulnerable areas from water ingress). Apply a Silver self-wound foil tape to the horizontal base of the aperture cut outs, covering the PU core.

- STEP I Ensure all items are clean and dust/grease-free prior to application of all adhesives, especially at adhesive contact points. Lay both the internal and external cassettes face down on a flat, protected, grit-free work surface.
- STEP 2 Apply a 1,5mm Biolink clear acrylic adhesive tape form to the inner channel of both the internal and external cassettes, always apply horizontal channels first, ensuring all vertical joints are butted together to create a weatherproof seal.
- STEP 3 Remove the protective release liner from the Biolink tape on the external cassette and "if required apply a very fine mist of water to the surface using a fine spray misting gun". This will allow movement to position the glass. Carefully position the glass unit onto the Biolink tape ensuring that it is located adjacent to the female connectors and apply pressure.
- STEP 4 Apply Alanson's Aro-Seal 1101 clear waterproof glazing adhesive sealant, in a bead of approximately 6-8mm in diameter, to the outer channel of the internal and external cassettes. Apply a small amount of Alanson's Aro-Seal 1101 to the female connector, below the strap where the male connector locates behind.
- STEP 5 Lay the door (two man lift in the absence of any mechanical handling equipment) over the external cassette, ensuring that the cassette is square with the top and side edges of the door ensuring that the female connectors fit close to the substrate (thus providing room for the female connectors to locate over the male connectors on the opposing cassette).
- STEP 6 Offer the internal cassette to the external cassette making sure that they are square with the top and side edges of the door. Take care to ensure male and female connectors are in line.
- STEP 7 Apply pressure using the heel of your hand, working round the perimeter of the internal cassette to locate fully into the external cassette so that the male parts of both cassettes fully engage with the female receivers.
- STEP 8 With care, whilst protecting the cassette, persuade with a rubber glazing mallet to ensure that all connectors have mated. Turn door over (two man function in the absence of mechanical handling equipment) repeat the above mallet exercise and ensure that the other half of the cassette is flush with the external door skin. Clean off excess sealant using the industrial wipes provided. Cap off external corners where cassette meets glass with Alanson's 1101.

Health and safety recommendations:

a) Never attempt to lift door blanks whether glazed or unglazed unassisted. If in doubt refer to manual handling guidance data.

b) When handing glass be aware of sharp edges therefore use gloves at all times to reduce the risk of cuts.

c) Take care at all times when using pneumatic sealant applicator and ensure eye protection is worn.

d) Maintain good housekeeping in and around work station (use bins provided) at all times to avoid trips and slips on debris.

e) Do not use compressed air to clean yourself down.

Note: The Alanson's 1101 sealant cures over a period of 28 days, therefore, prior to PAS 24 testing ensure sufficient time is allowed. Ensure glazing application is undertaken on a solid and fully covered surface. 24/09/2013 Version 001