



Instructions for installing ACRYAL framed windows

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Framed ACRYAL windows are available in various dimensions, for walls of different thicknesses and curvatures. Before starting the installation, make sure that the window and other materials match the wall on which it will be installed.

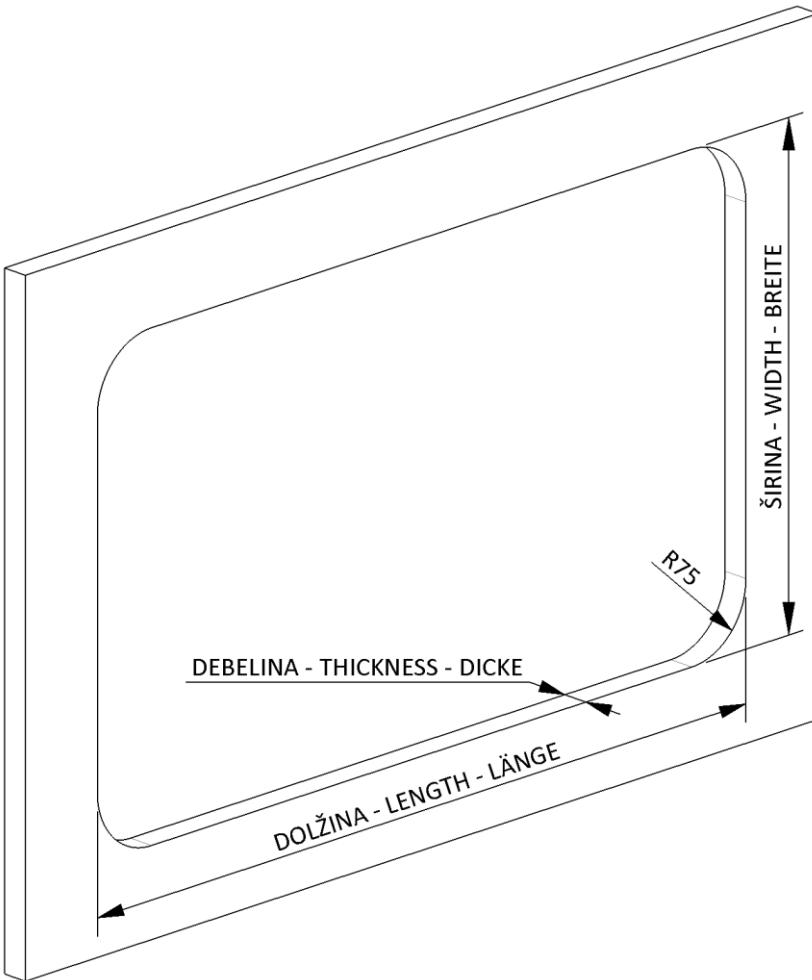


For a complete installation, you need a window, fasteners, screws and ambiental strip. Depending on the selected window, obtain information on the number of fasteners and screws and the appropriate length of ambiental strip from the product technical documentation. Find the type of dedicated fasteners in the table on page 10.

You also need a suitable cleaner, 1 mm spacers, primer and adhesive sealant. Check with the suppliers of these materials that they are suitable for use on all installed materials.

FRAME	AL EN AW 6063 Prašno barvan z lakom na osnovi poliestra
WINDOW	PMMA
PLASTIC PARTS	PA GF
SEAL	EPDM
FASTENERS	INOX 1.4301
AMBIENTAL STRIP	PVC-P

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Wall opening:

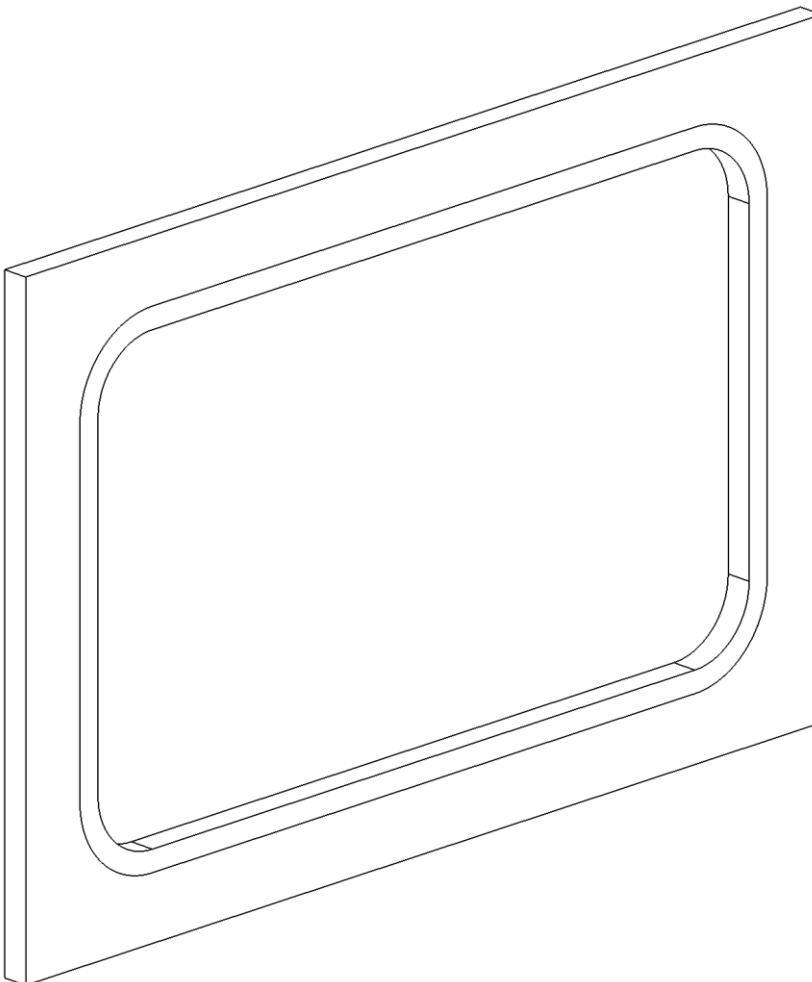
Framed ACRYAL windows are intended for installation on walls with uniform thickness. The window opening is equal to the nominal window dimension.

Make a suitable opening on the wall with a radius of R75 mm.

Wall opening tolerance +1,5/-0 mm.

Wall thickness tolerance ± 1 mm.

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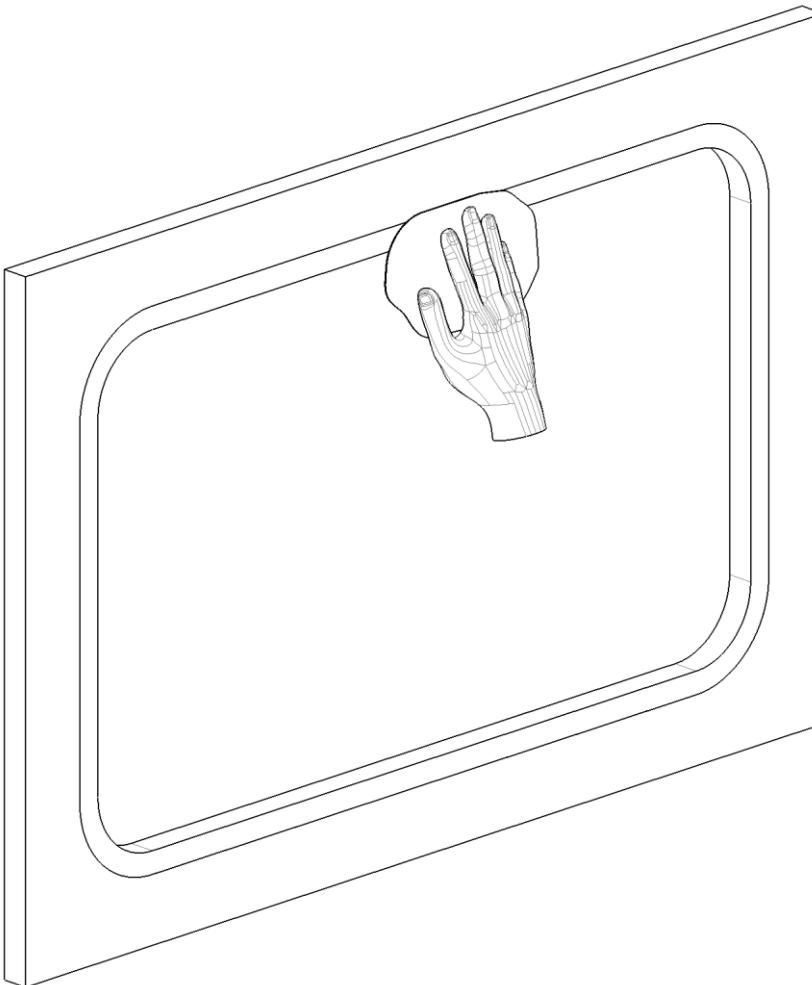


Reinforcements around the wall opening:

A good seal is ensured by adhesive sealant and screwing the window frames together, which causes pressure on the wall in the window area.

It is therefore recommended that all sides of the opening are reinforced with wooden inserts or similar elements enabling the firm and permanent installation of window components.

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Preparing the wall – cleaning:

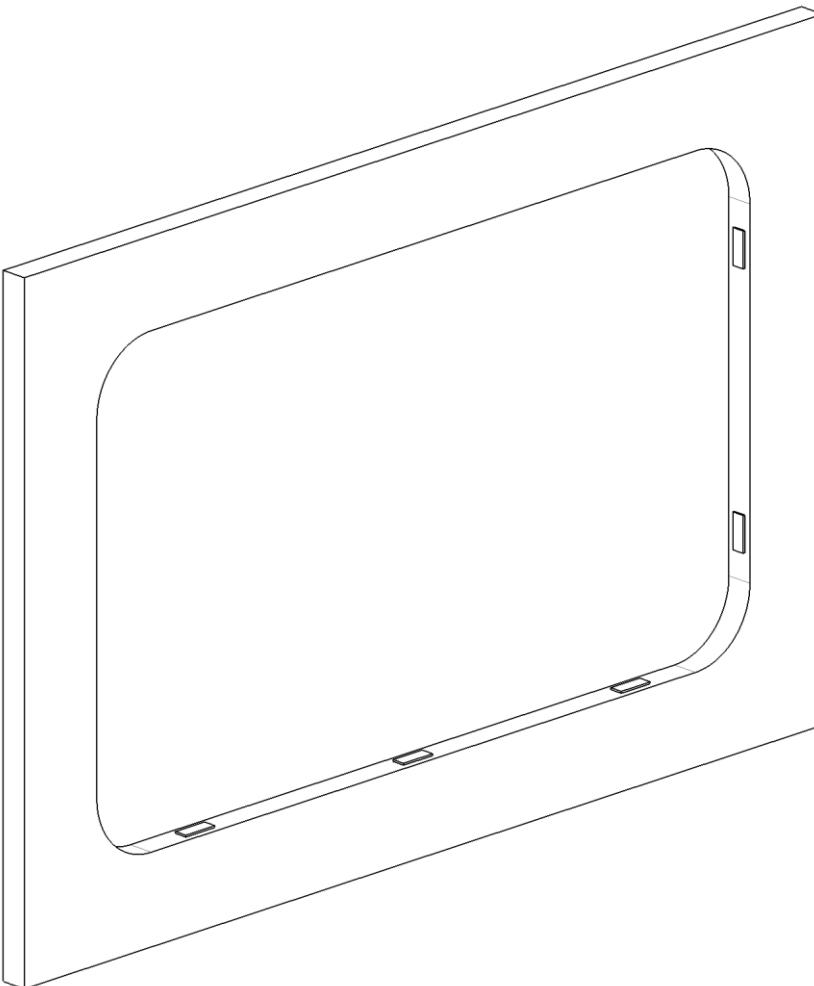
Before mounting the window, make sure that the outer surface of the wall is properly prepared and cleaned.

Wipe the surface with a clean cloth and a cleaner.

Change the cleaning cloth frequently if the wall is very dirty and/or contains fat residues.

When the surface is free of dirt and fat, wait till the cleaner evaporates or remove it in accordance with the instructions of the cleaner supplier.

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Preparing the wall – spacers:

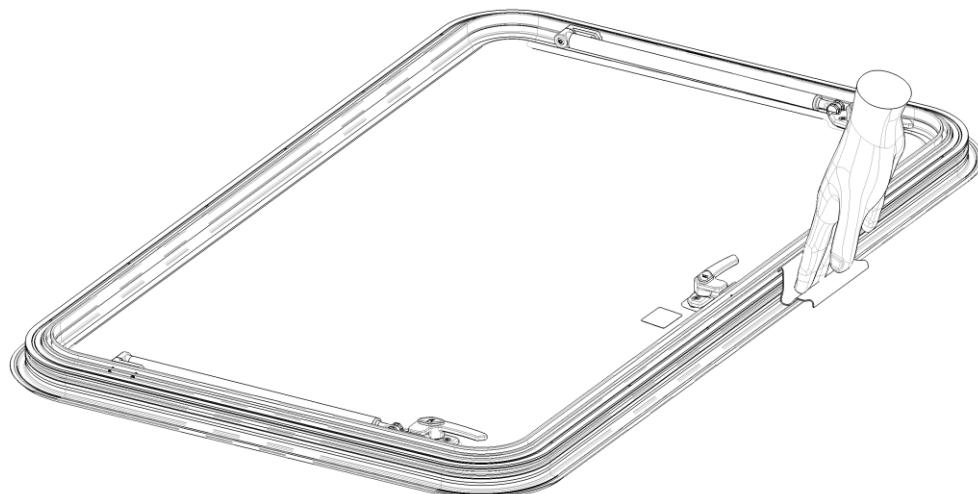
The framed window should be installed as close to the center of the wall opening as possible, with the frame having a minimum clearance of 1 mm from the wall on each side after installation.

We recommend that the clearance be achieved by using **1 mm** thick spacers on the bottom and one side of the opening.

Self-adhesive EPDM foam is recommended for spacers.

If solid spacers are used, they must be removed after the window has been screwed in.

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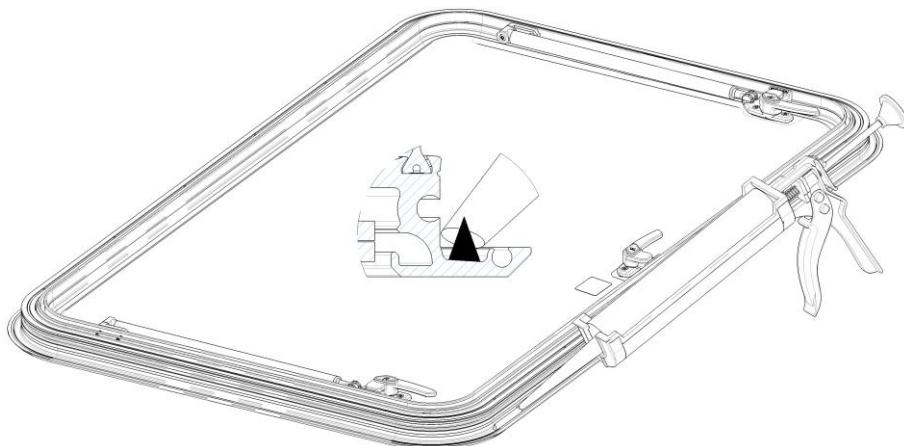
Preparing the window – cleaning:

Place the window on a flat surface.

Make sure the window frame is undamaged and the surface where the sealant will be applied is clean. Remove any irregularities and dirt before applying the sealant.

Prepare the frame surface for better adhesion according to the adhesive sealant supplier's instructions. If necessary, apply a primer to the frame surface before applying the adhesive sealant.

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Preparing the window – applying the adhesive sealant:

Use an adhesive sealant that remains elastic after drying.

Apply the adhesive sealant in the groove provided around the perimeter of the frame.

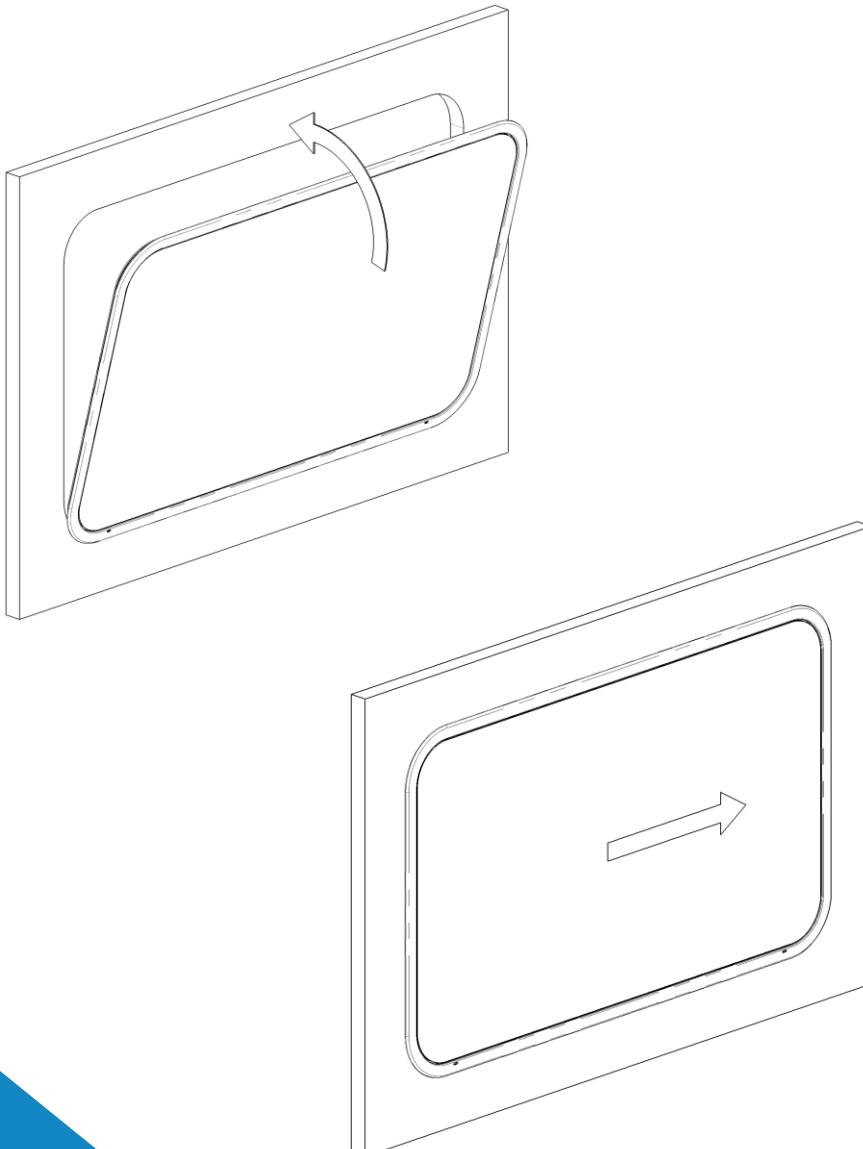
For optimal bonding and sealing, a triangular application of the compound is recommended.

Pay attention to the appropriate amount and constant, continuous application of the adhesive sealant.

Warning:

The screws are used to fix the window to the wall while the adhesive sealant is drying and later. The waterproofing between the wall and the frame is ensured by the adhesive sealant, so the selection and proper application of the compound is important!

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Installing the window on the wall:

Carefully transfer the outer frame to the opening on the outside of the vehicle wall.

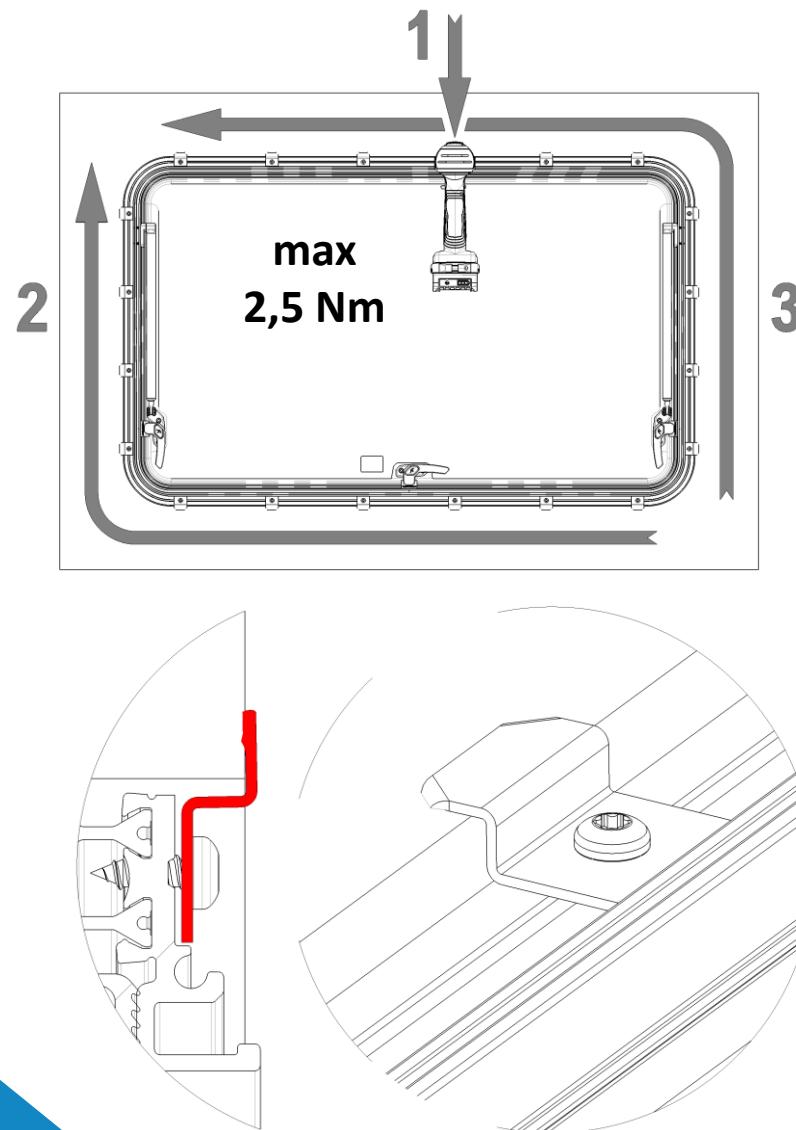
Make sure the framed window is oriented correctly!

Place the bottom edge of the frame on the opening first and make sure it is centered with the wall opening.

Push the frame into the wall opening, setting it on the spacers on the underside of the opening.

Push the frame toward the spacers on the side, thus ensuring that the outer frame is positioned in the center of the opening.

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Screwing the window in place:

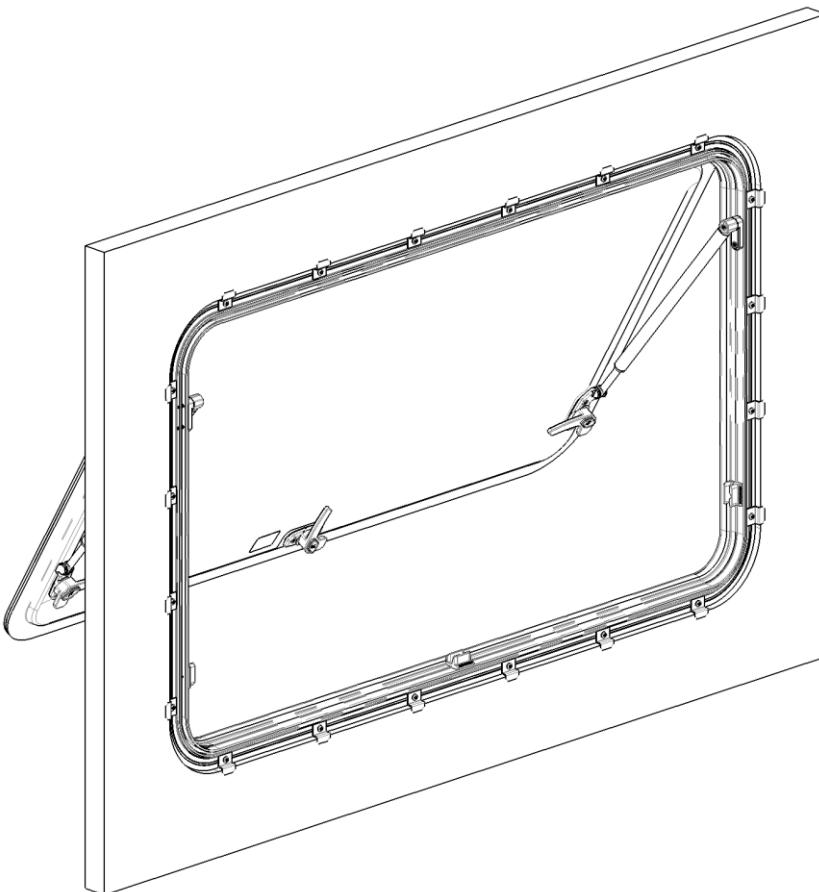
The window is screwed to the wall from the inside with dedicated fasteners and appropriate screws. Depending on the measured wall thickness, determine the type of dedicated fasteners from the table on the left.

The recommended screwing sequence is shown in the picture on the left.

The screw tightening torque is max. 2.5 Nm!

Wall thickness [mm]	Fasteners
22 – 23	500 00016
24 – 25	500 00017
26 – 27	500 00018
28 – 29	500 00019
30 – 31	500 00020
32 – 33	500 00021
34 – 35	500 00022
36 – 37	500 00023
38 – 39	500 00024
40 – 41	500 00025
42 – 43	500 00026

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Checking the window installation:

Visually and functionally inspect the framed window for possible irregularities and correct them.

Check:

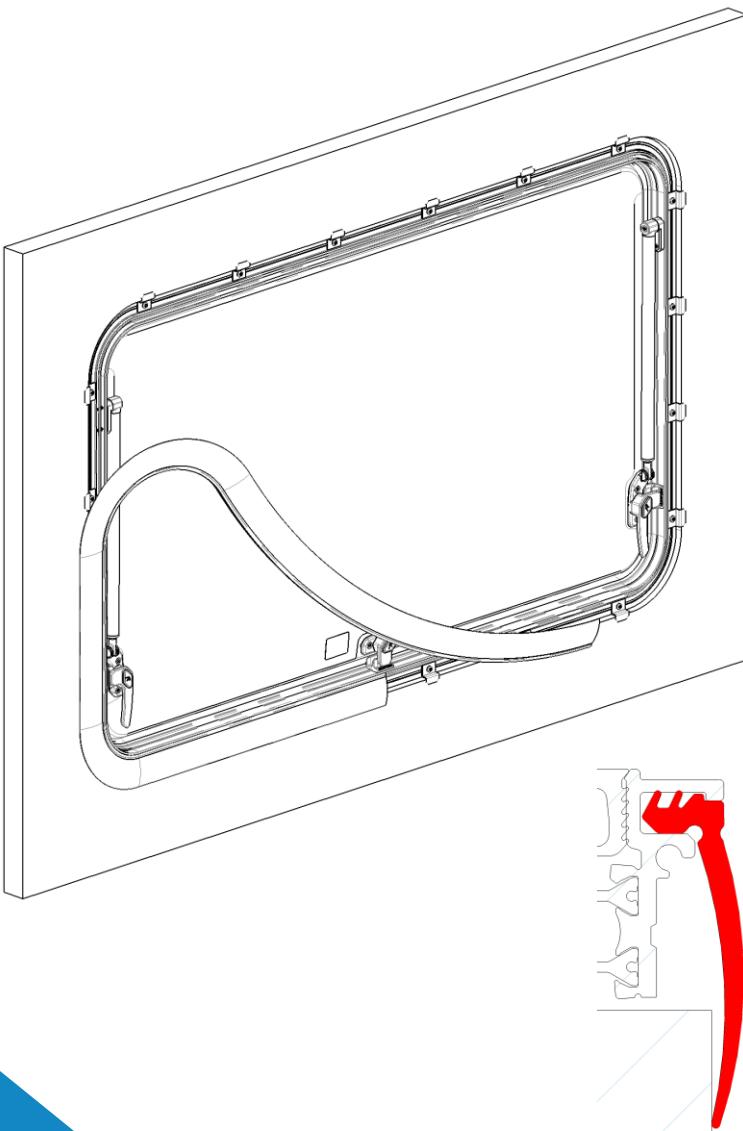
- the opening and closing of the window and
- the operation of the actuators and closers.

The correct use of the window and its subassemblies is described in the operating instructions.

Once the framed window has been properly installed on the vehicle, the protective foil should be removed.

Also remove any excess adhesive. Be careful not to damage the surface of the frame.

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Installing the ambiental strip:

The ambiental strip is available separately from the window. For information on the appropriate length, please refer to the product's technical documentation.

Install the ambiental strip in the dedicated groove on the window frame. We recommend starting the installation in the middle of the bottom side of the frame.

When installing at the corners of the window, make sure that the ambiental strip maintains its shape.

There is a bit too much ambiental strip at the end of the installation. Correct the shape and fit of the ambiental strip to the wall, then shorten the ambiental strip accordingly and press the end of the strip into the frame.

It is recommended to bond the start and end sections of the strip with a fast-drying adhesive to prevent the formation of a gap that could occur at lower temperatures due to material shrinkage.

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Following these steps the installation of the framed window will be done correctly.

To ensure proper functioning and longevity of your windows, please also read the safety and longevity guidelines in the instruction for use.

Find them on the product page at www.acryform.com.