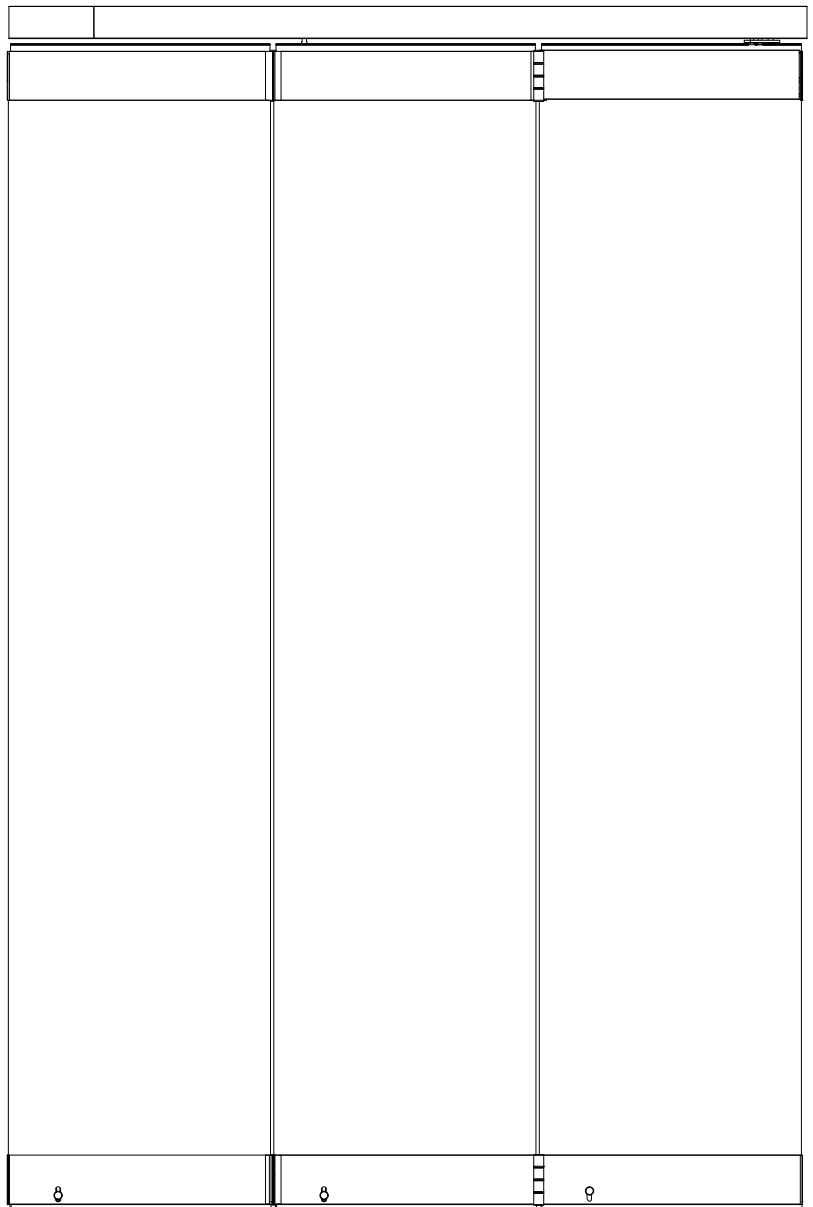
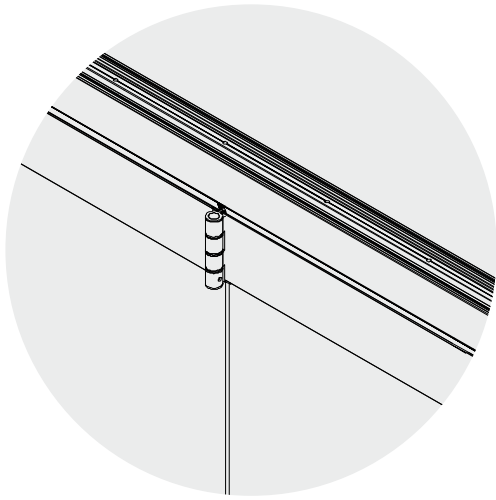


# Σύστημα FW72

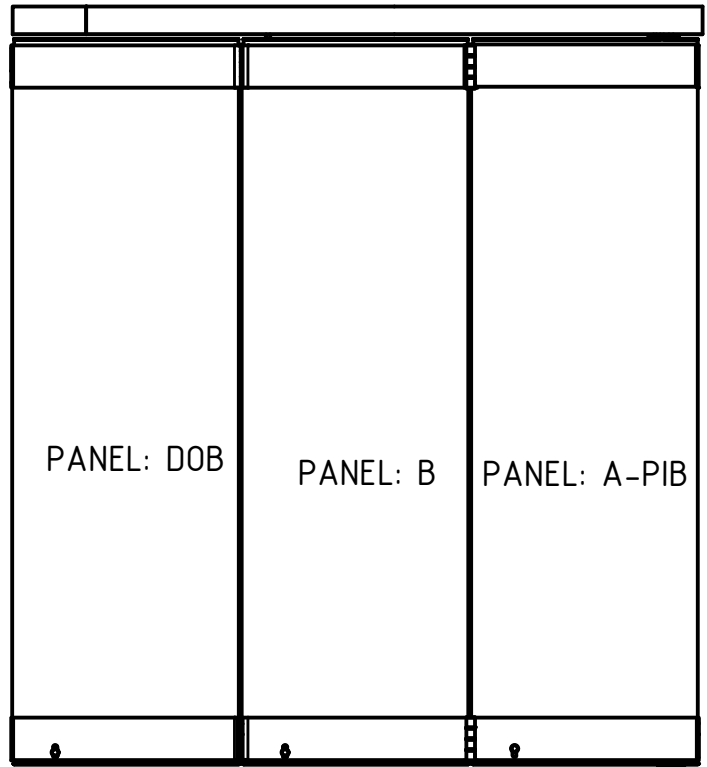
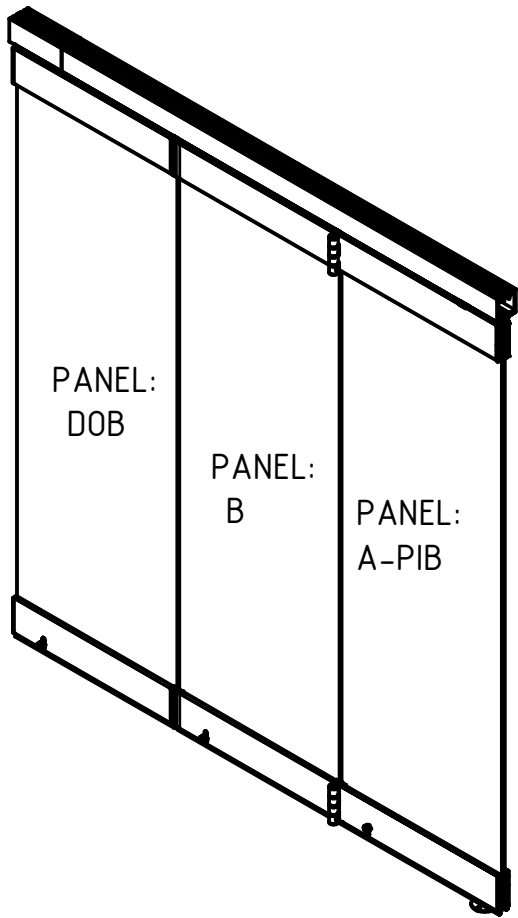
## Οδηγίες Συναρμολόγησης Φύλλου

## System FW72

### Panel Assembly Instructions



FW72 panel  
Assembly instructions



View from inside

GENERAL VIEW OF THE FW-72 SYSTEM



# FW72 panel Assembly instructions

## Index / Contents

1. Tools required for the panel assembly.
2. List of parts provided by Ialonet S.A.
3. Panel assembly presentation.
4. Panel assembly instructions.
5. Appendix.

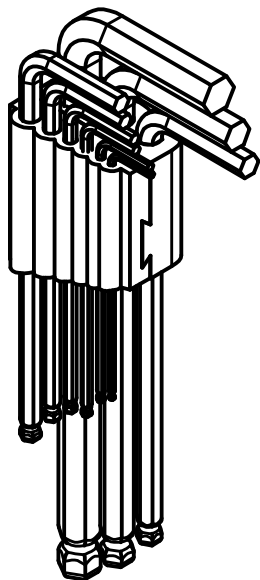


Part-1.

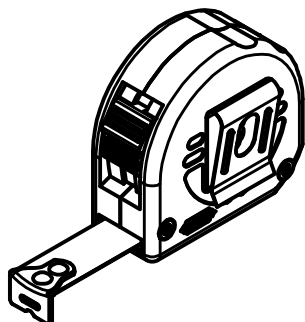
Tools required for the panel assembly:

Allen metric key set or use only the following allen keys:

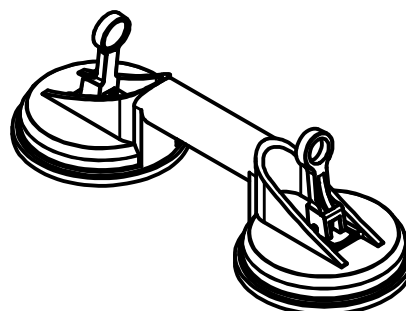
No 6-5-4-3-2,5



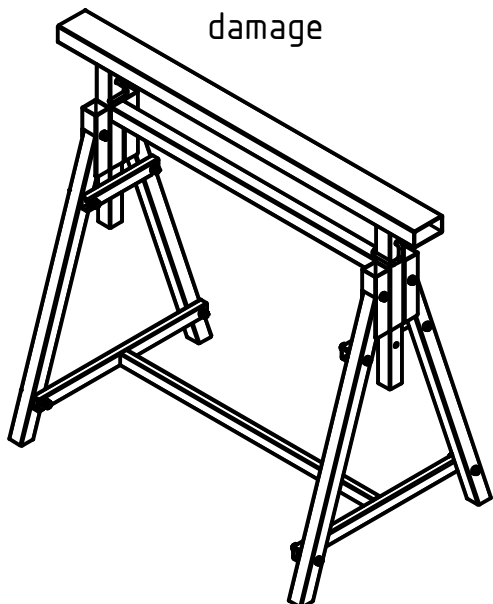
Measuring tape



Suction cups



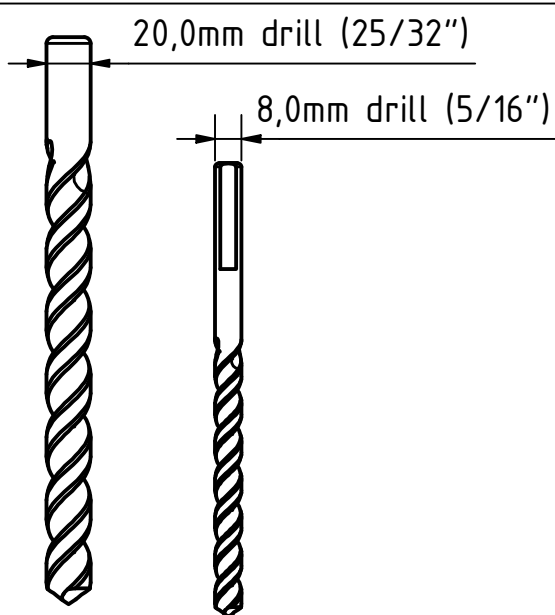
Saw horse with carpet or protected to prevent glass damage



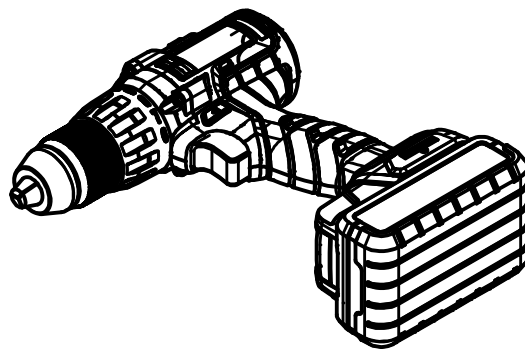
# Part-1.

## Tools required for the panel assembly:

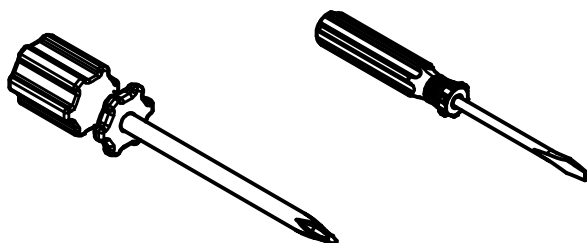
Drills



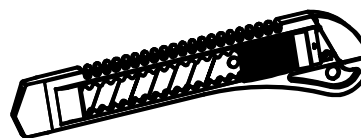
Portable drill machine  
(NOT impact drill)



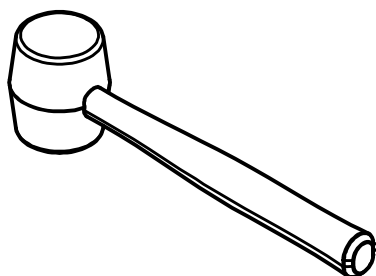
Screwdrivers  
Flat head & Philips



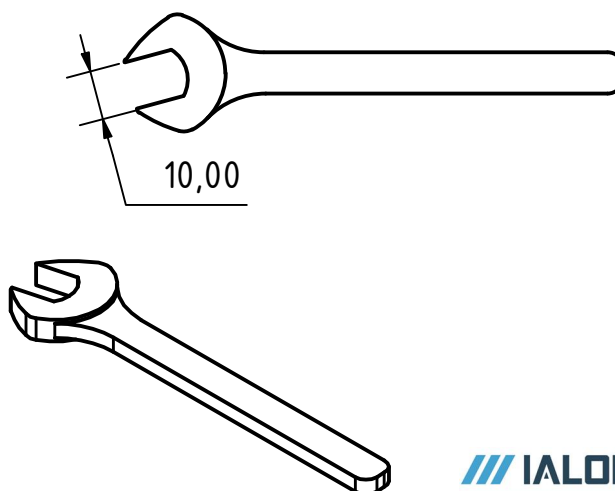
Knife



Rubber mallet

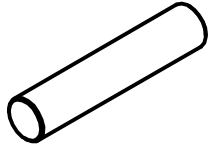


10mm Key

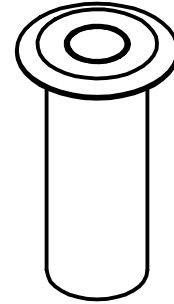


Parts provided by Ialonet P.C.:

Top track connectors  
(4mm stainless steel pins)

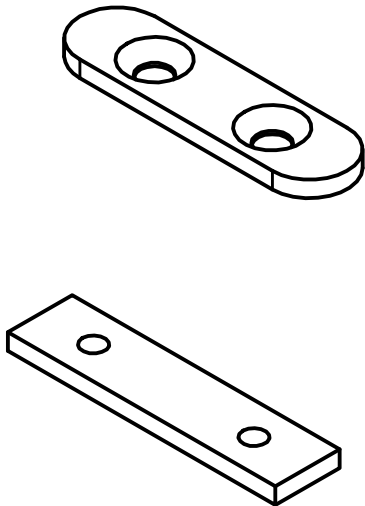


999.936 Lock casing  
(Dust-proof strike)

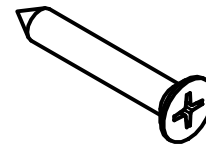


Top track connectors

729.657

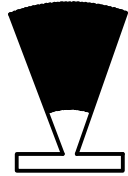


ST.STEEL SHEET METAL  
ROUND HEAD  
SCREWS 4.8x32

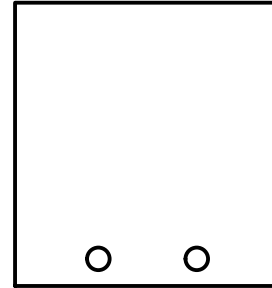


Parts provided by Ialonet P.C.:

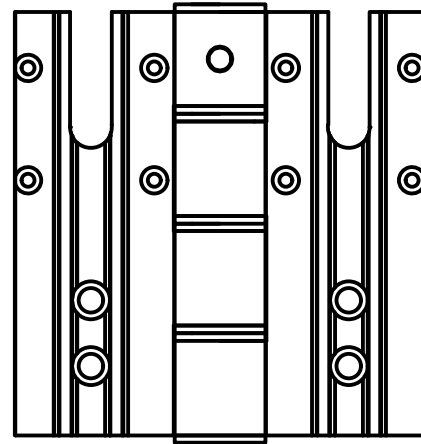
Brush for guide profile  
for panels and hinge.



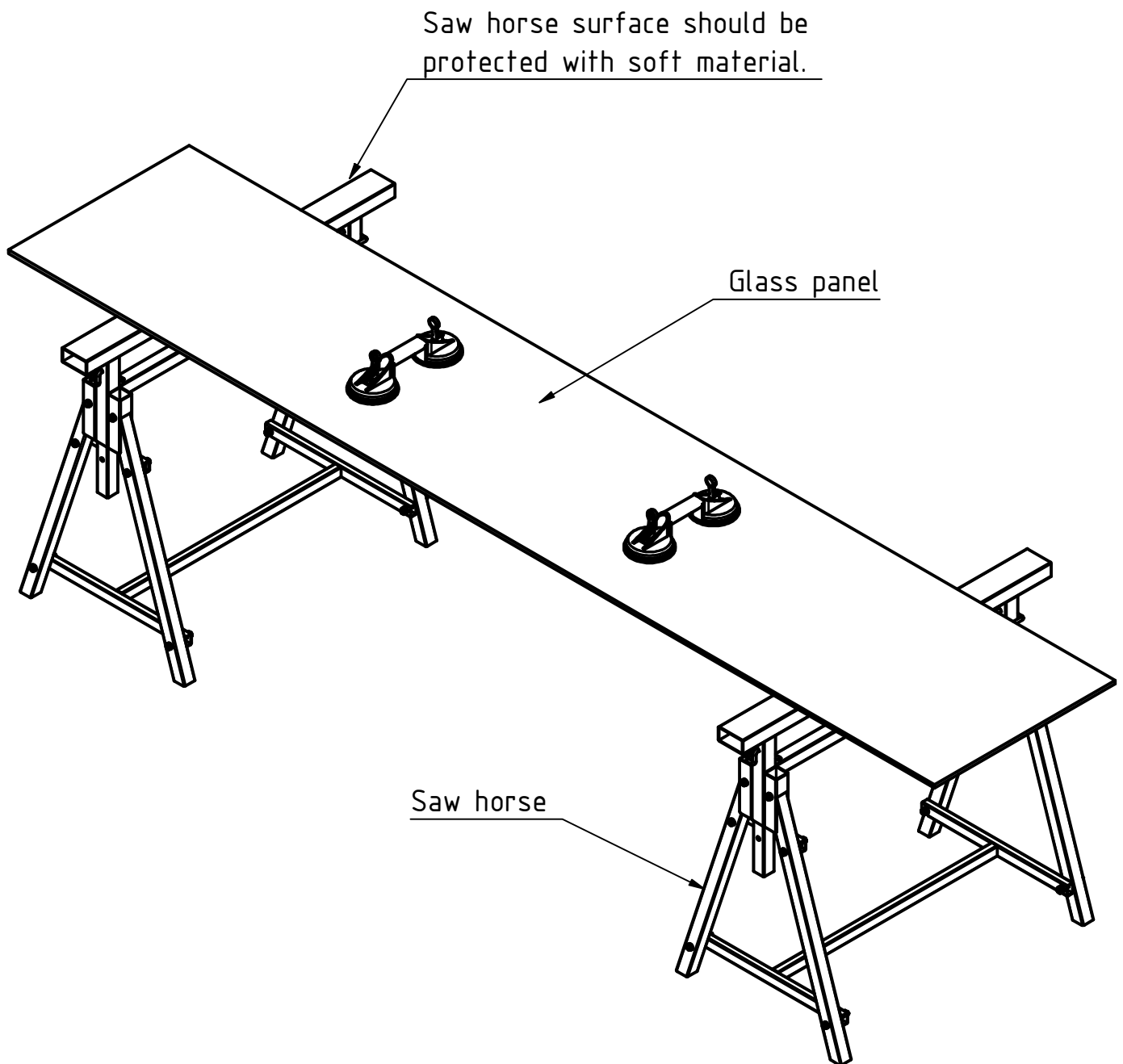
729.522



HINGE



# PANEL ASSEMBLY INSTRUCTIONS



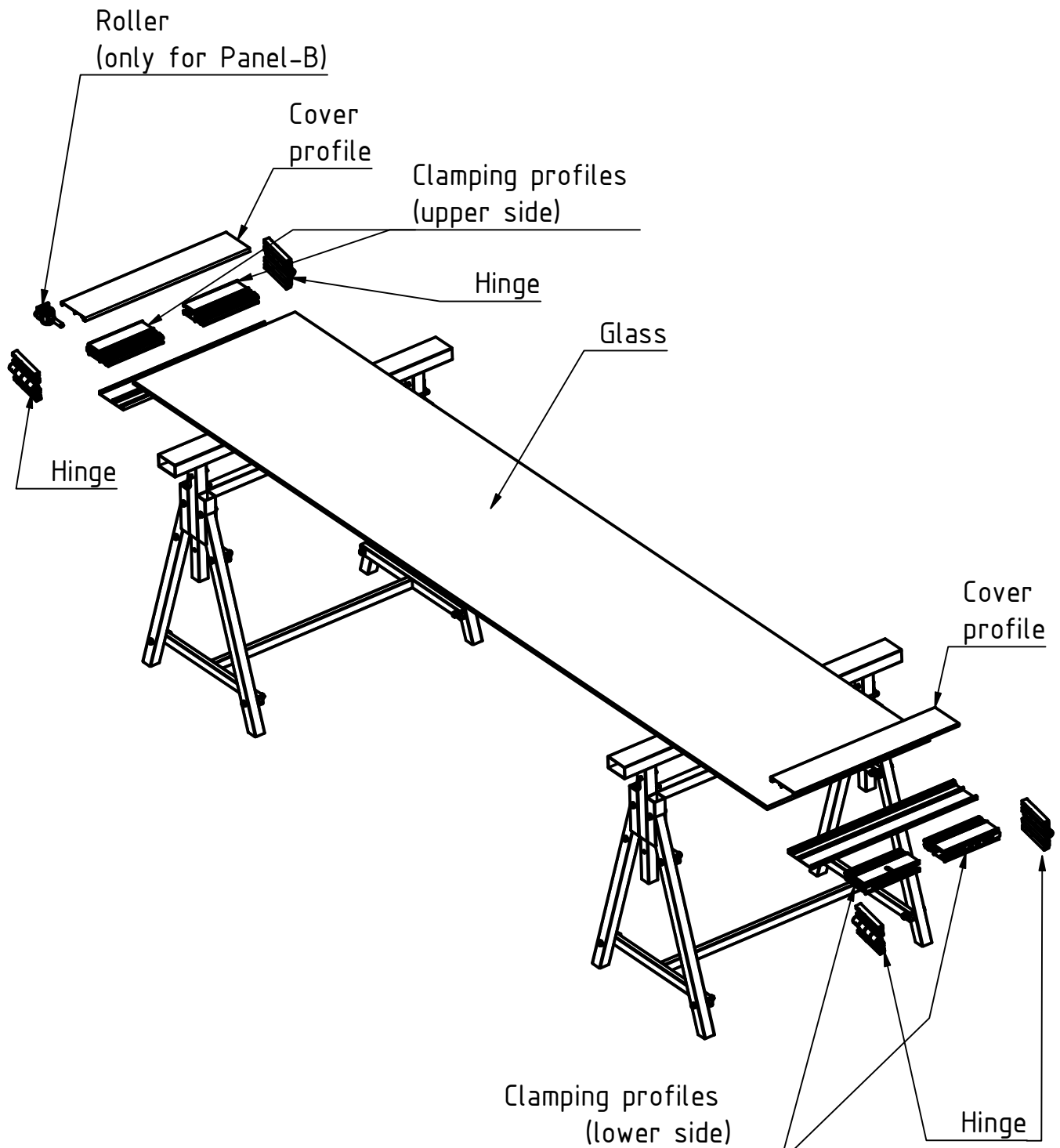
## GLASS PREPARATION:

Place the glass on the saw horses.

Make the sure that the saw horse surface is protected with a soft material.

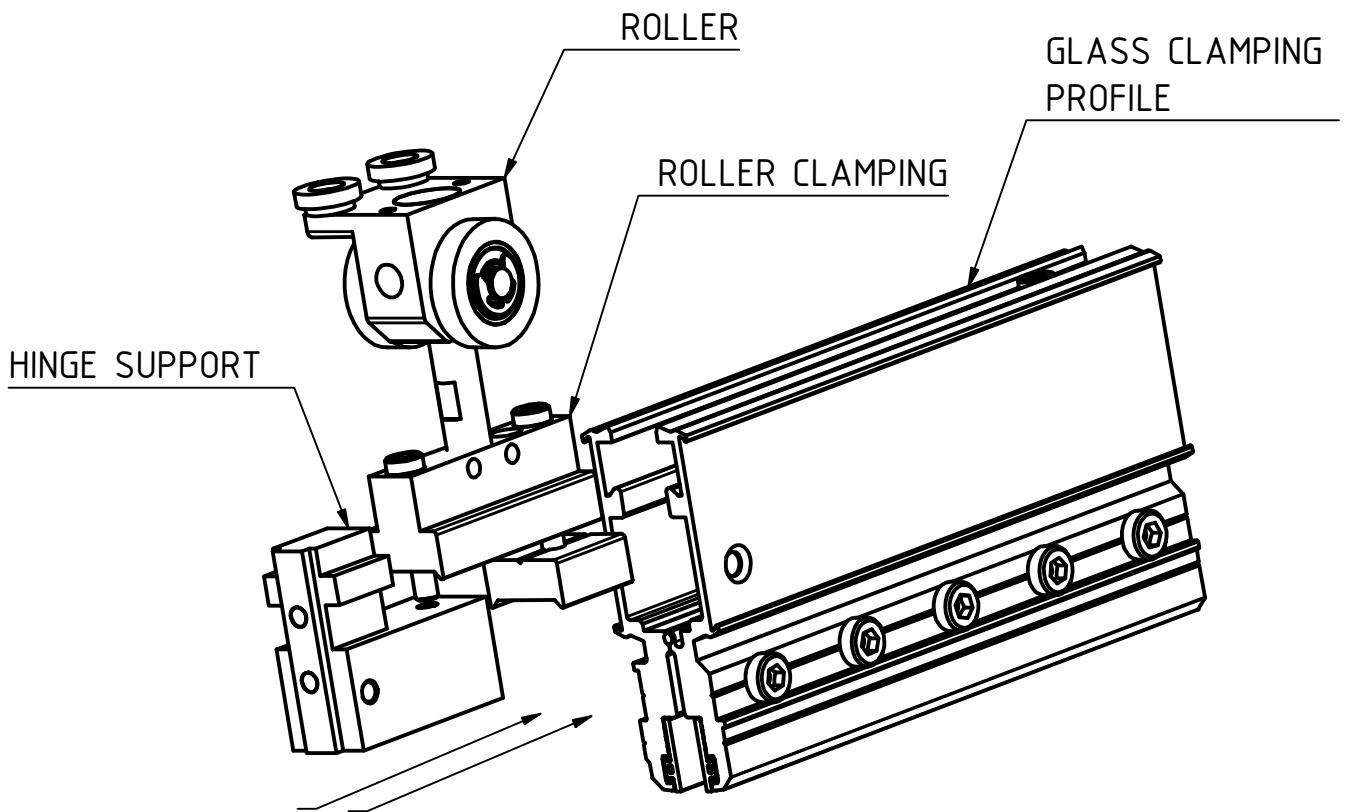


## PANELS B &amp; C ASSEMBLY INSTRUCTIONS



## JOB TO BE DONE:

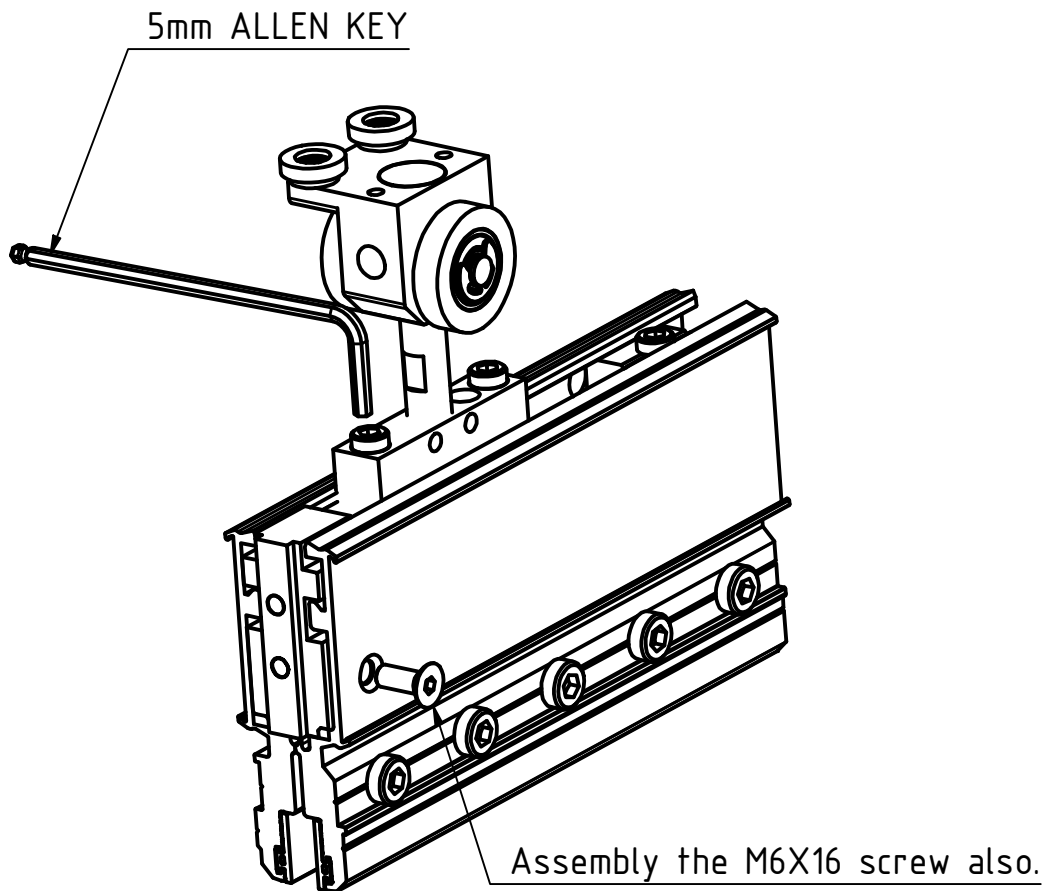
The job that has to be done is the assembly of the clamping profiles and their covers on the glass. Two (2) pieces of alum. clamping profile have to be assembled at each side of the glass panel (upper and lower side). Above of them their covers must be assembled also.



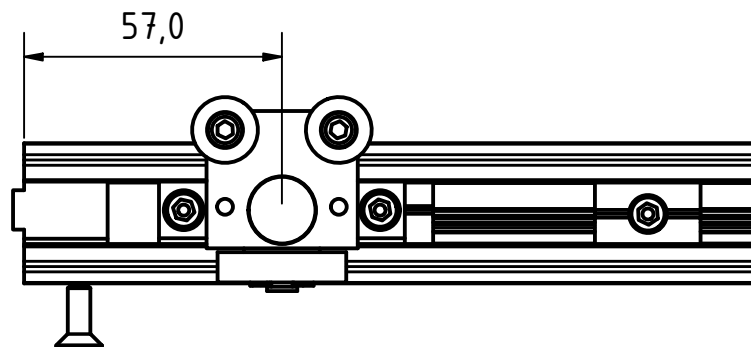
FOR PANEL B - ONLY  
PANEL C DOES NOT INCLUDE ROLLER

**PANEL-B (PREPARATION):**

Assembly the roller with the clamping part and the hinge support part into the glass clamping profile.



FOR PANEL B - ONLY

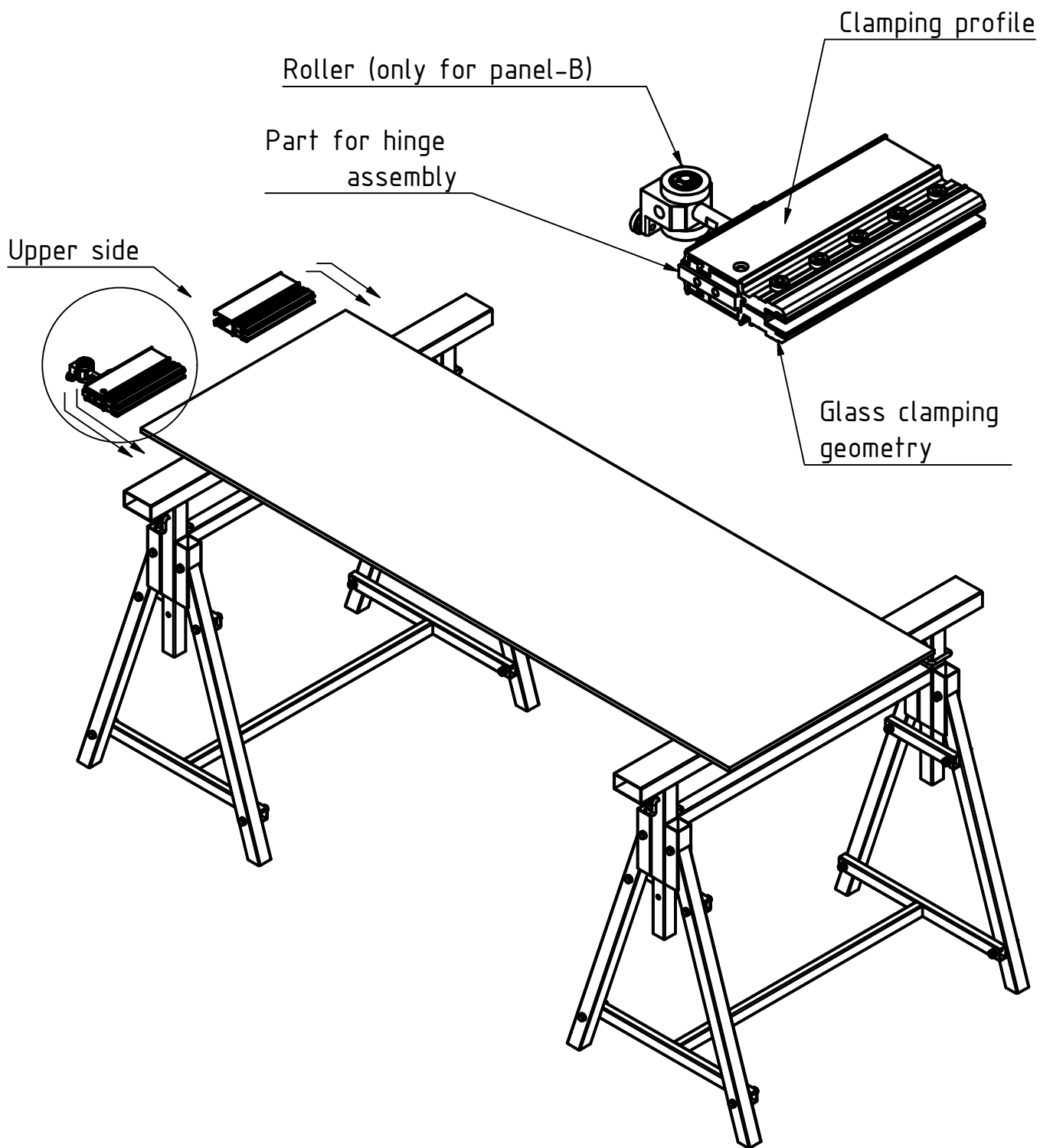


**PANEL-B (PREPARATION):**

Assembly the allen screws or the roller clamping part.

Use a 5mm allen key.

When the assembly is made correct the distance of the roller axis from the edge of the profile is 57mm.



PANELS B & DOB (Kit):

STEP-1A:

At the glass assembly the upper clamping profiles.

The profiles includes the parts for hinge assembly.

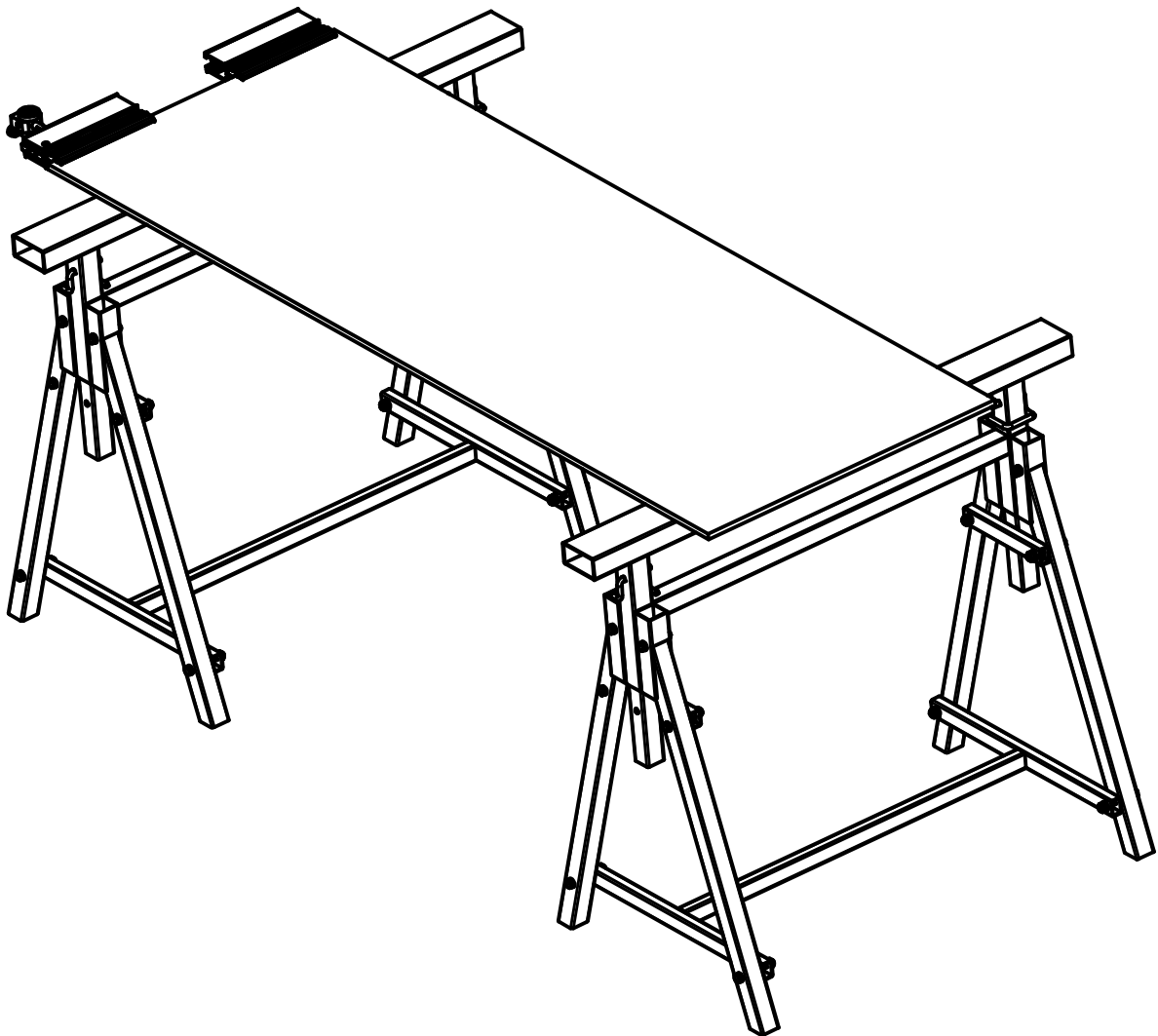
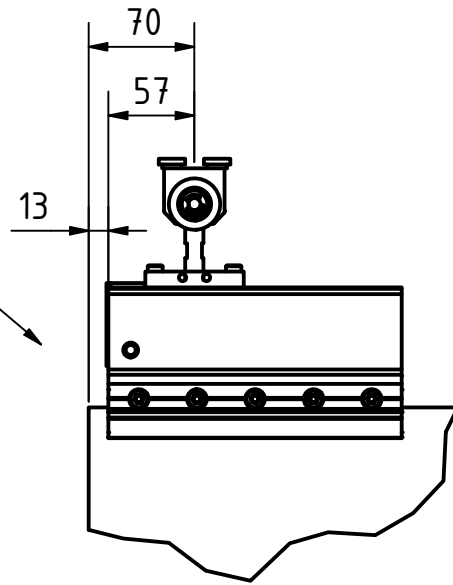
One of the profiles includes the roller.

For panel DOB the upper profiles do not include roller.

# PANEL ASSEMBLY INSTRUCTIONS

The assembly of the clamping profile to the glass must be done at 13mm from the glass edge.

Also check that the roller is placed at 70mm distance from the glass edge.

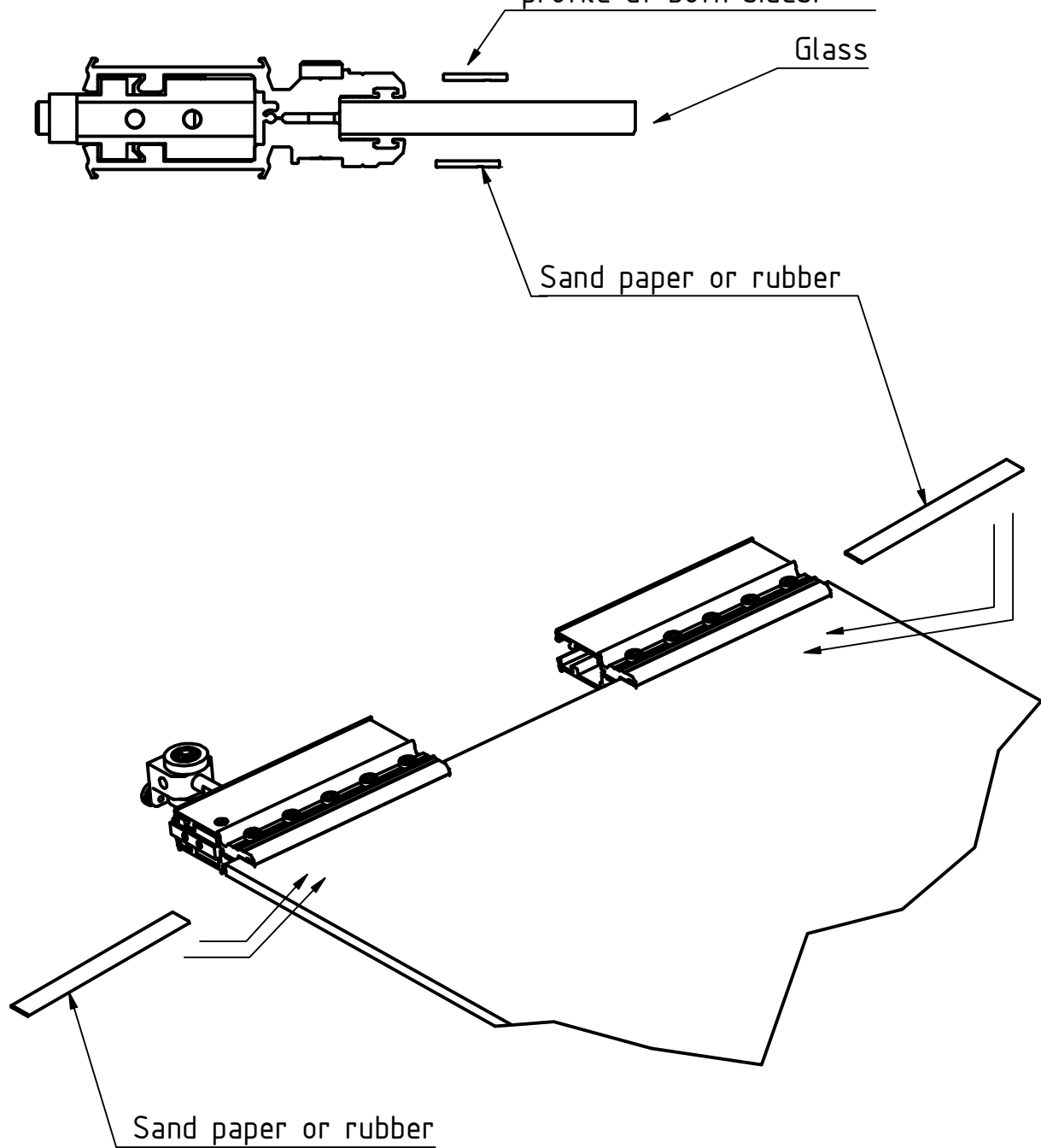


## STEP-1B:

Place the upper clamping profiles at a certain position.

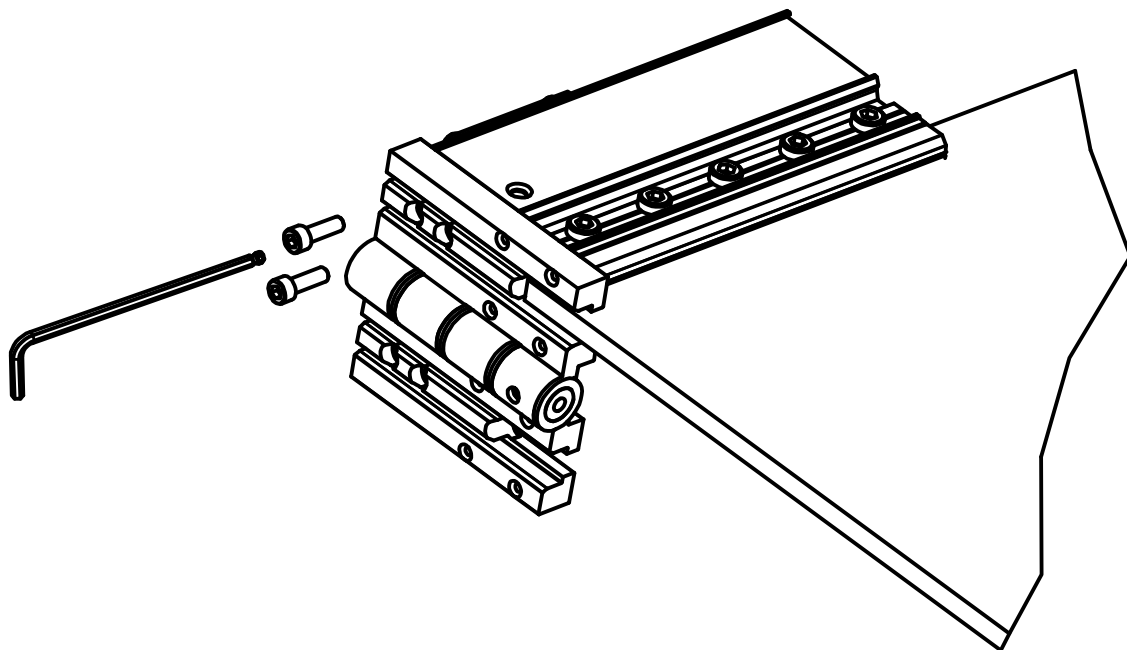
# PANEL ASSEMBLY INSTRUCTIONS

Place the sand paper or the rubber between the glass and the clamping profile at both sides.



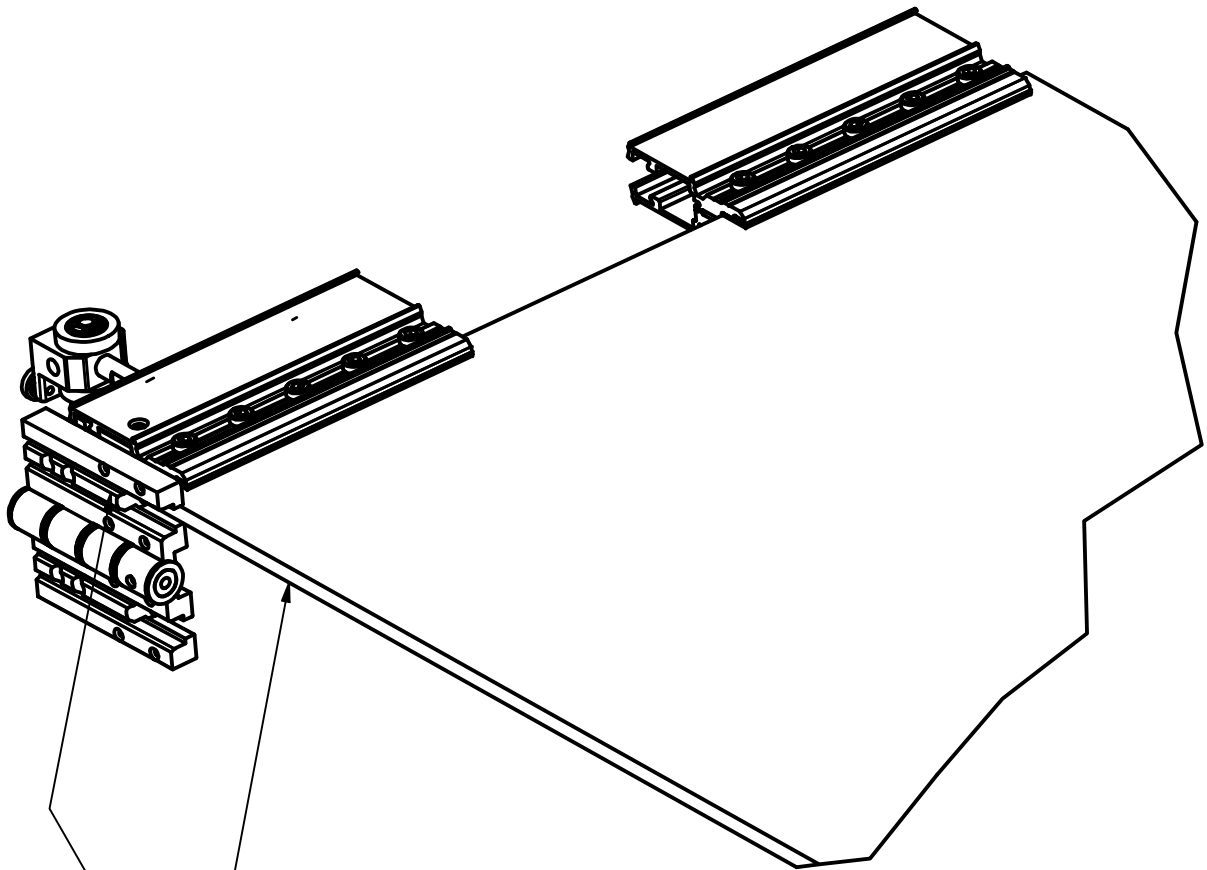
## STEP-2:

Install the sand paper or rubber between the glass surface and the clamping profile.



STEP-3:

Assembly the hinge at the clamping profile.  
Use a 5mm allen key and two M6 screws.

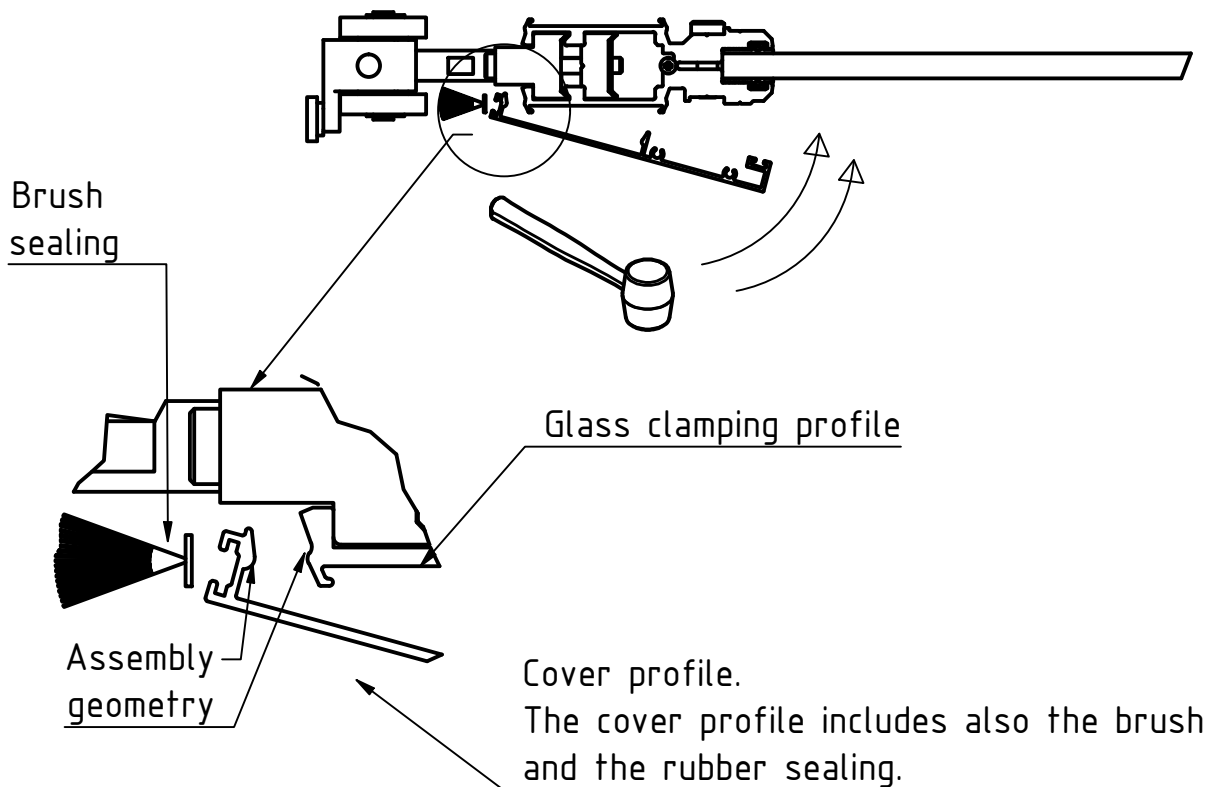
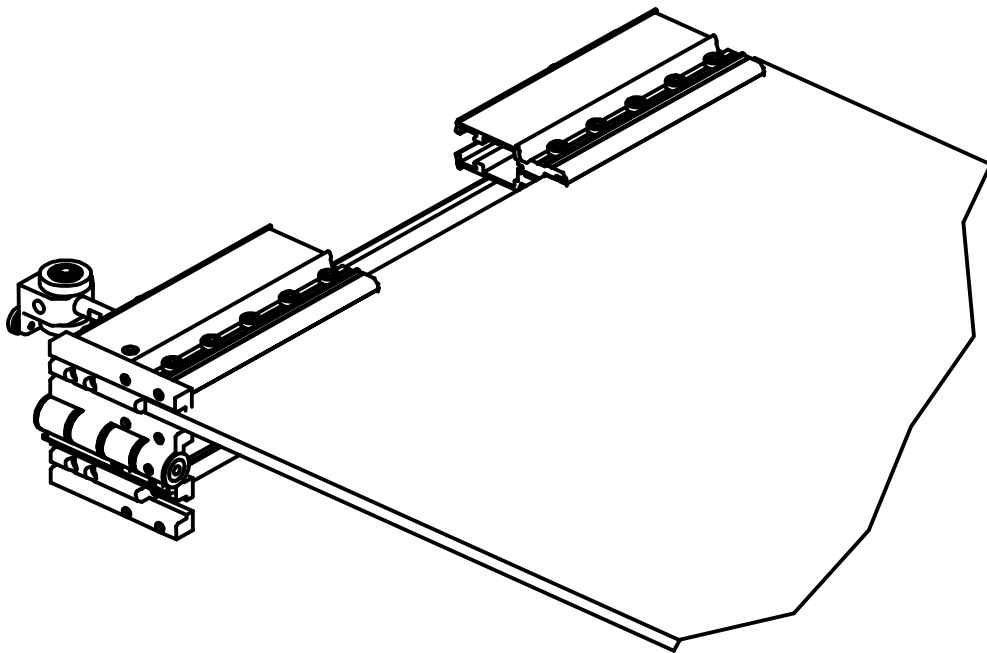


Check the alignment of the hinge's front side and the glass side edge. They should be at the same level.

**STEP-4:**

Assembly the hinges with the clamping profiles.



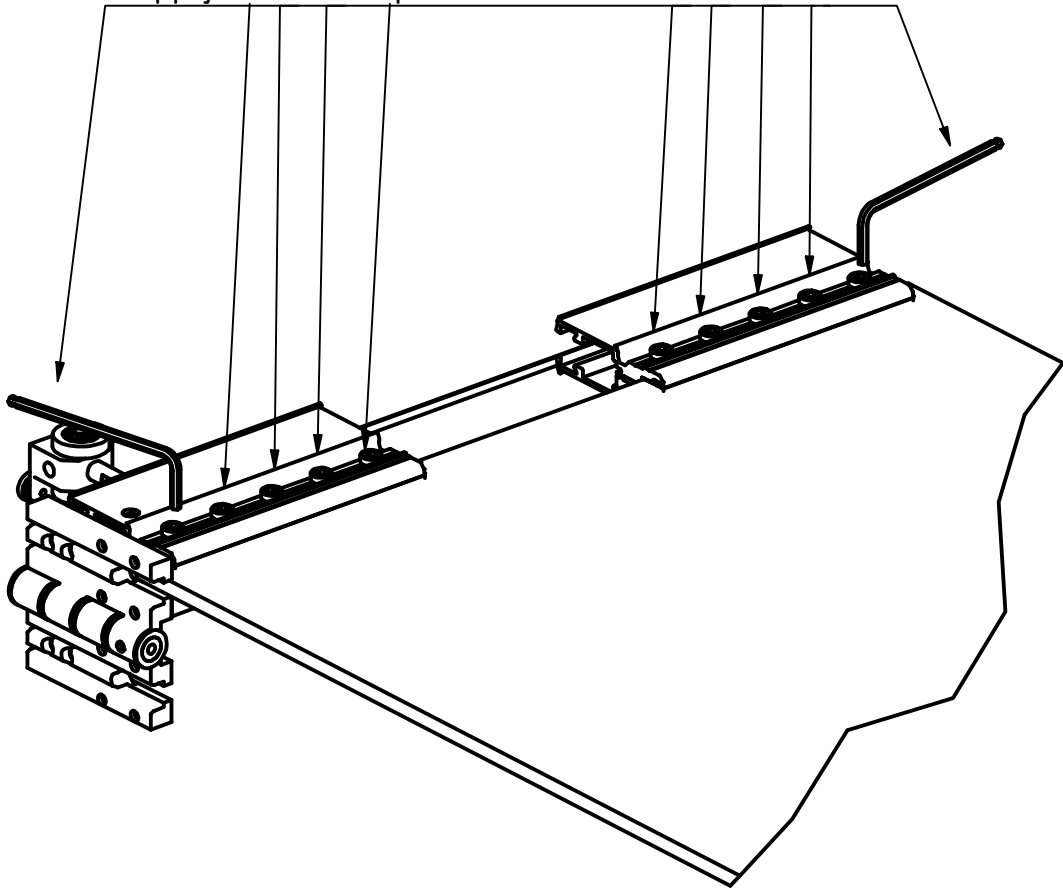


**STEP-5:**

Assembly lower cover profile.

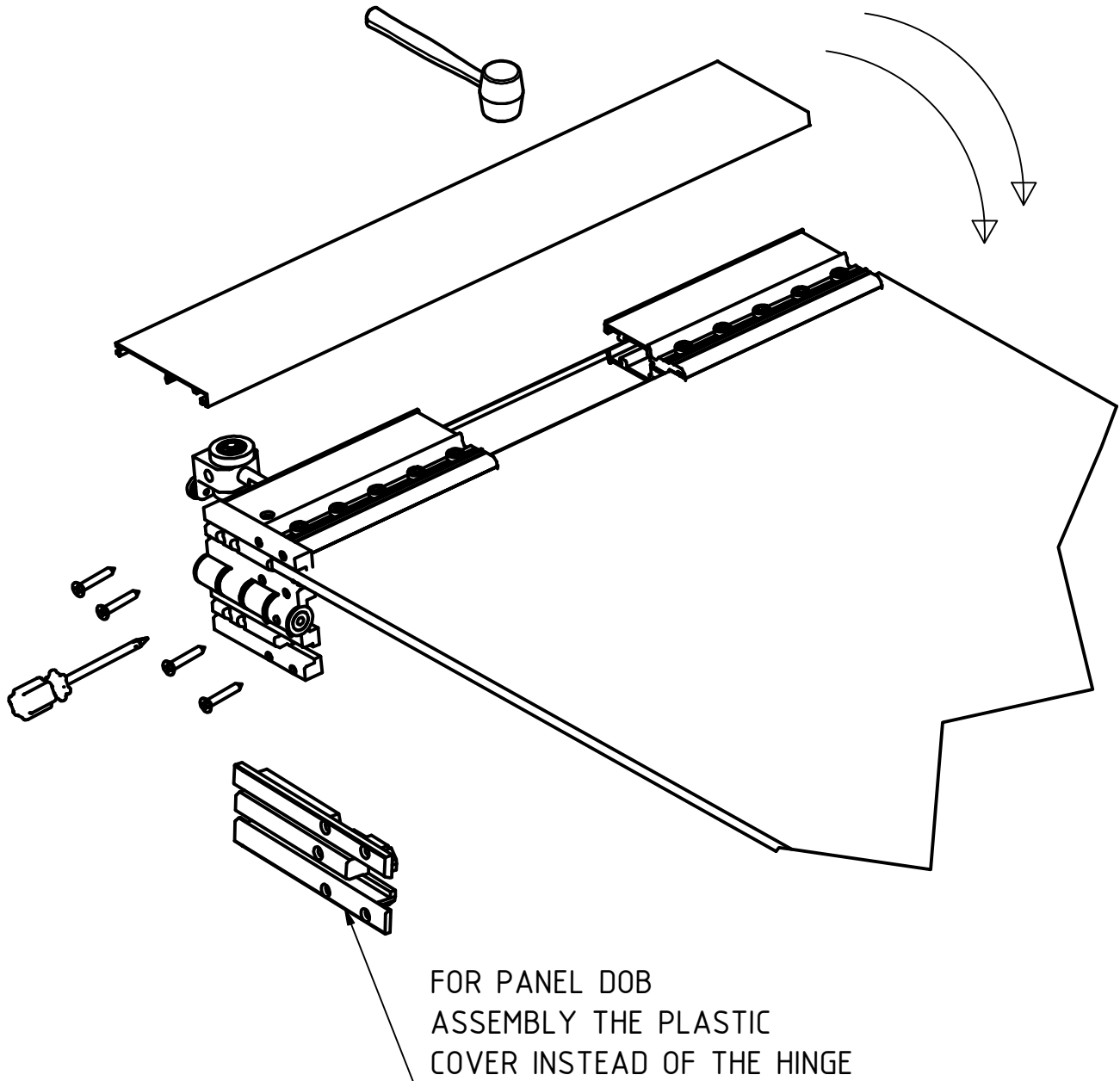
Place it first at the assembly geometry of the clamping profile and then close it towards the glass. Apply small force at the final stage in order to secure assembly.

Use a 6.0mm allen key in order to tight  
ALL the screws of the clamping profile.  
Apply 25Nm torque.



## STEP-6:

Finalize the assembly of the glass with the upper clamping profiles.  
Tight all the screws.

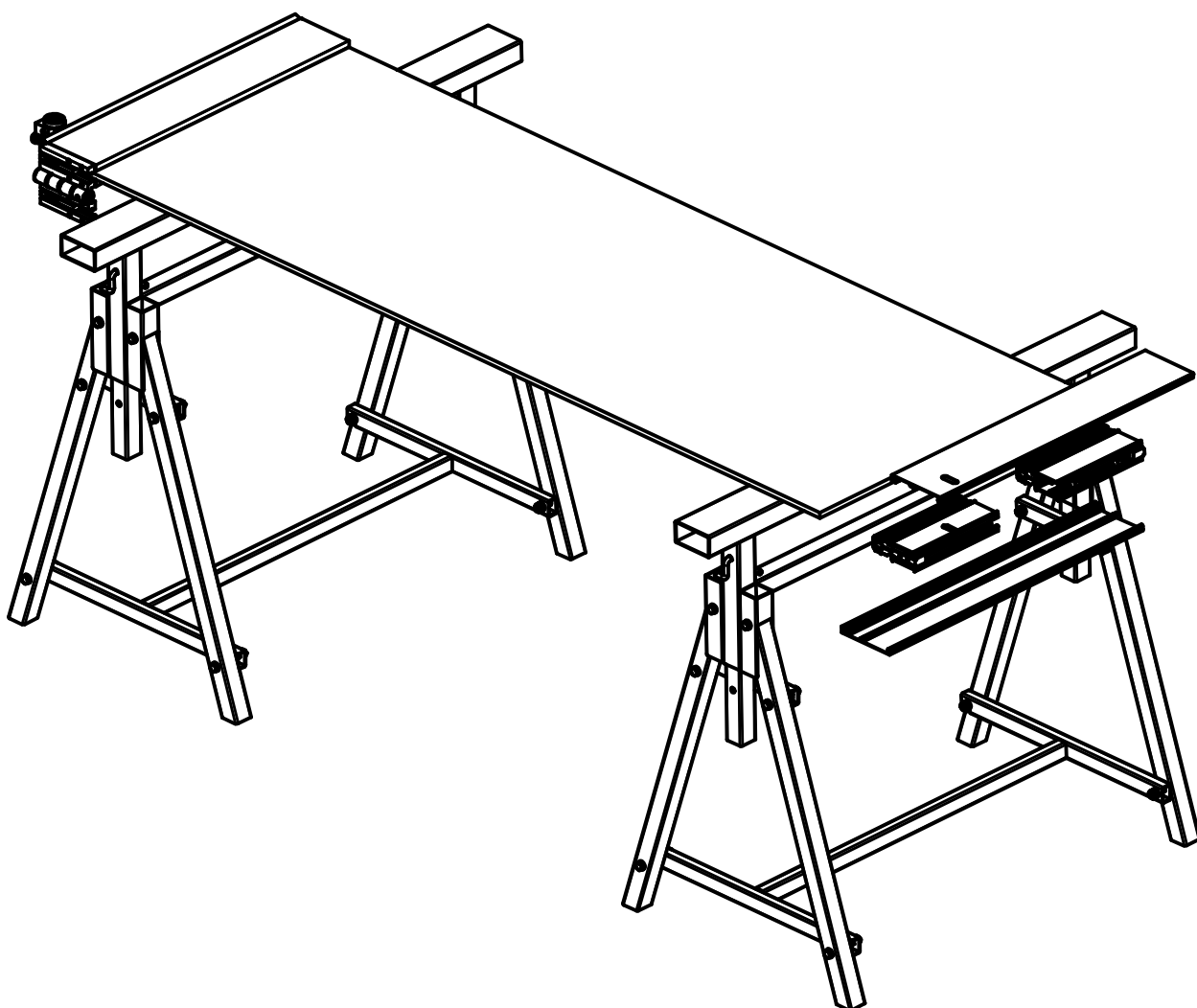


## STEP-7:

Assembly upper cover profile.

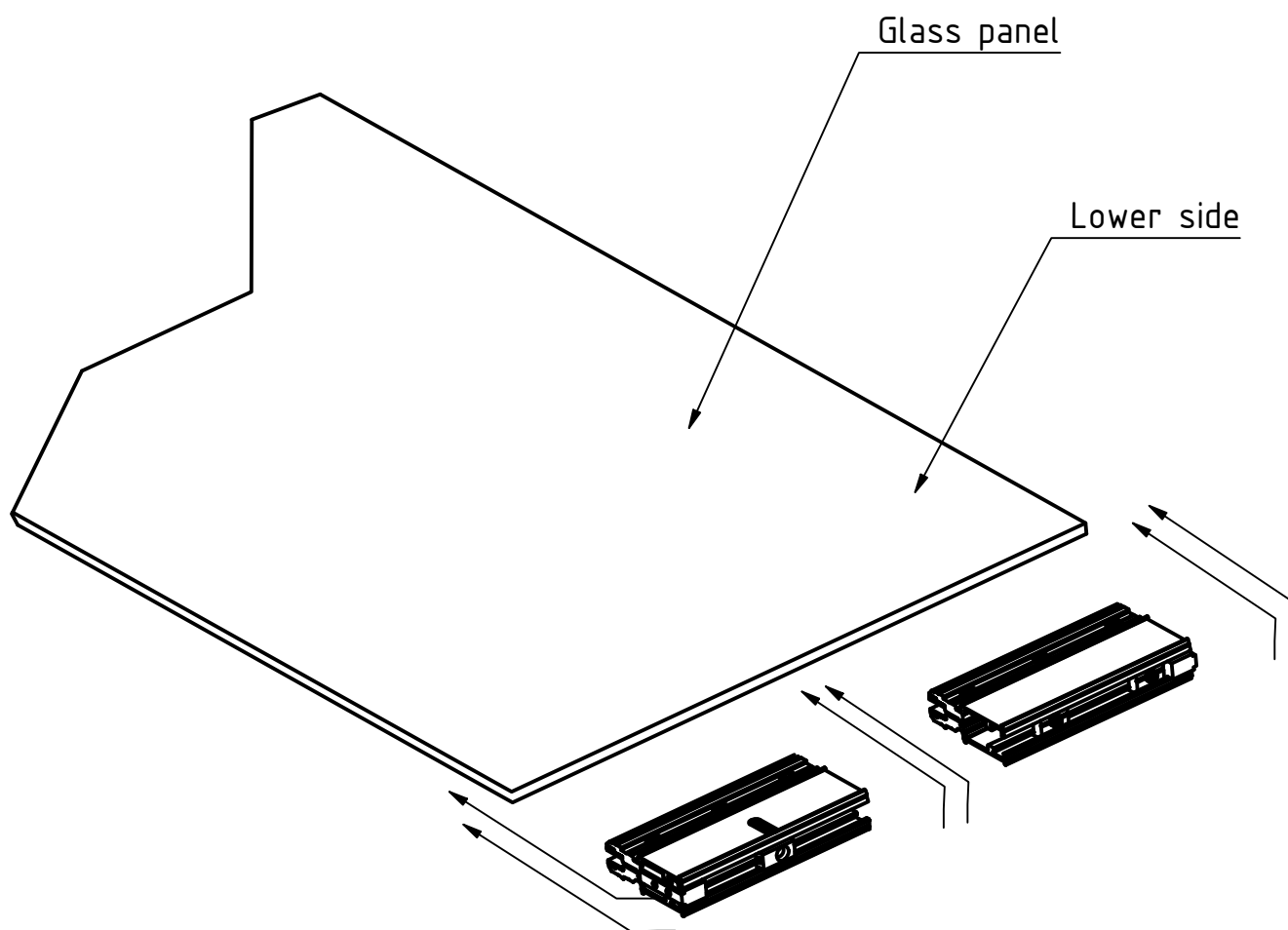
Place it first at the assembly geometry of the clamping profile and then close it towards the glass. Apply small force at the final stage in order to secure assembly. Same like STEP-4.

After the assembly install the 4 screws that hold the covers with the half hinge.



**STEP-8A:**

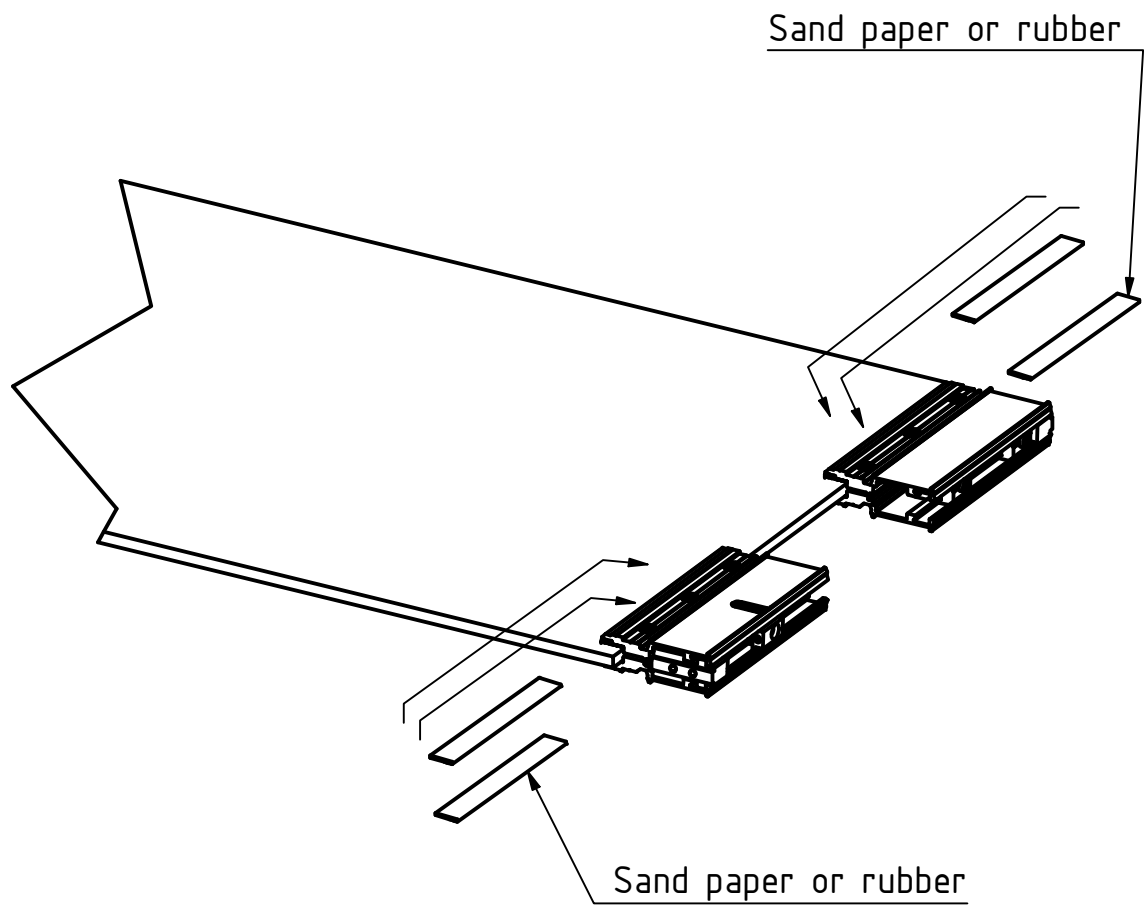
Assembly the parts for the lower side of the glass panel.  
Follow the steps from 1 to 7 mentioned before for the similar parts.



**STEP-8B:**

Assembly the glass the lower clamping profiles.

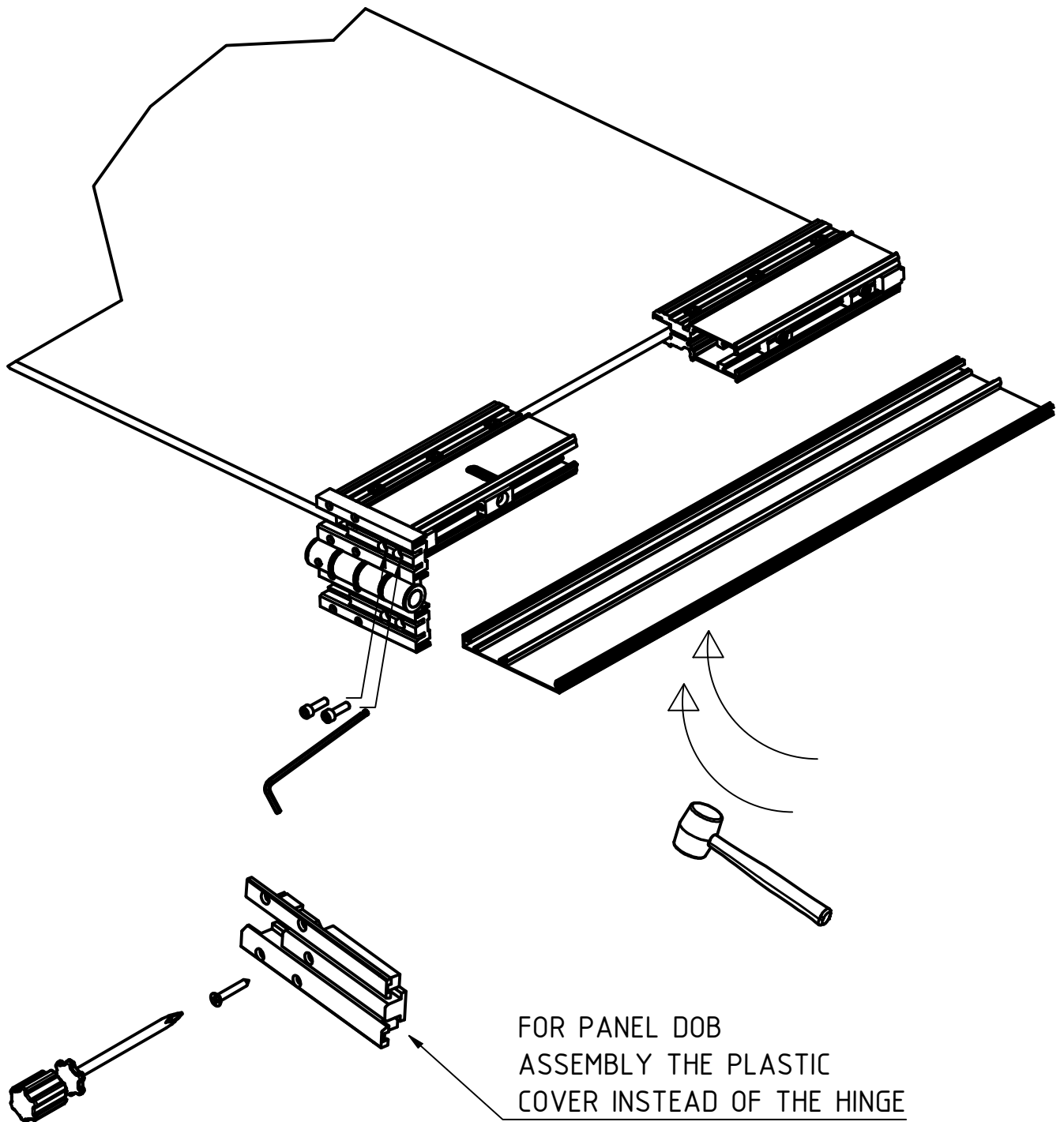
These profiles include bolts or locks. Same like steps 1A & 1B.



**STEP-9:**

Install the sand paper or rubber between the glass surface and the clamping profile. Same like STEP-2.





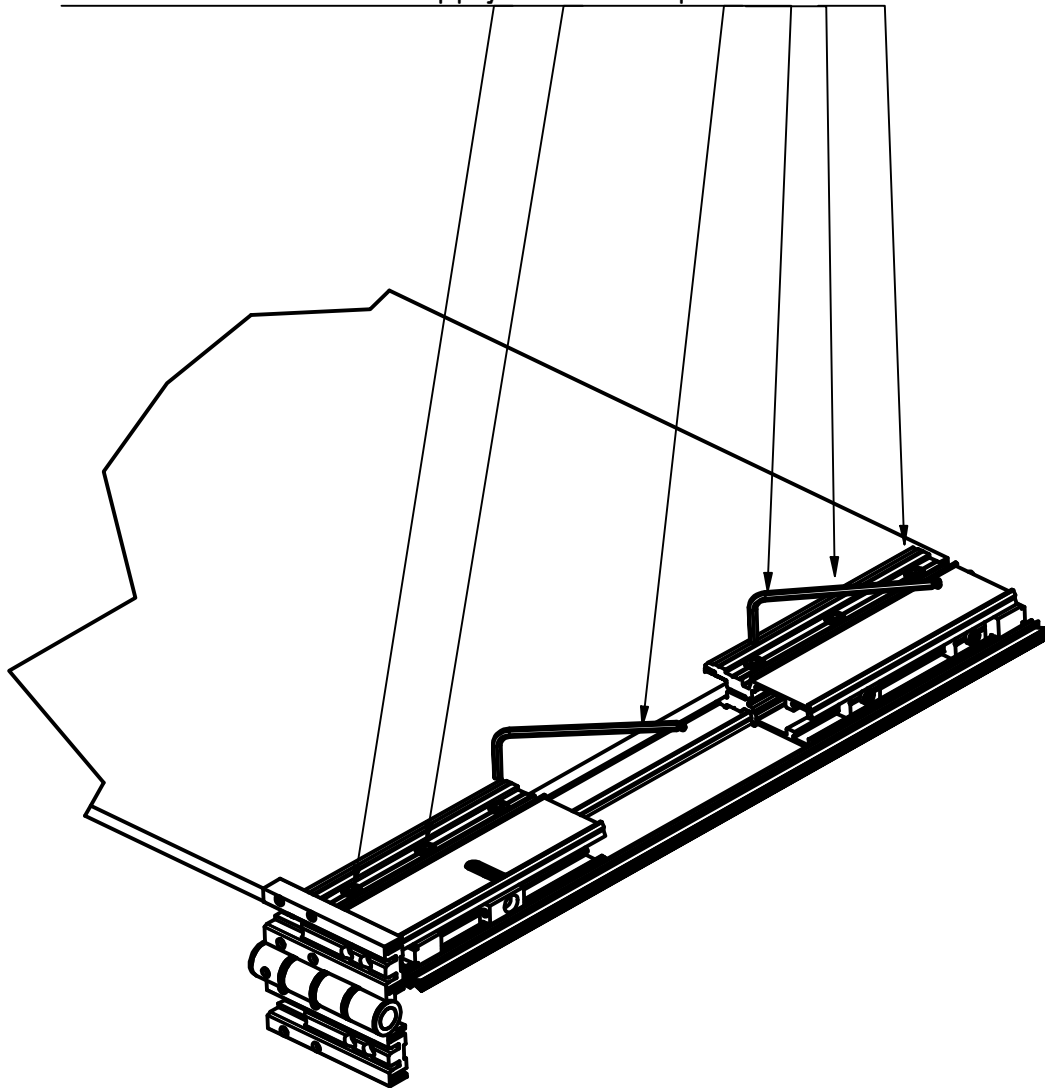
FOR PANEL DOB  
ASSEMBLY THE PLASTIC  
COVER INSTEAD OF THE HINGE

**STEP-11:**

Assembly the hinge and the lower cover profile.  
Place it first the hinge with the M6 screws and then at the assembly geometry of the clamping profile place the cover and then close it towards the glass. Apply small force at the final stage in order to secure assembly. Same procedure like STEPS 4 & 5.

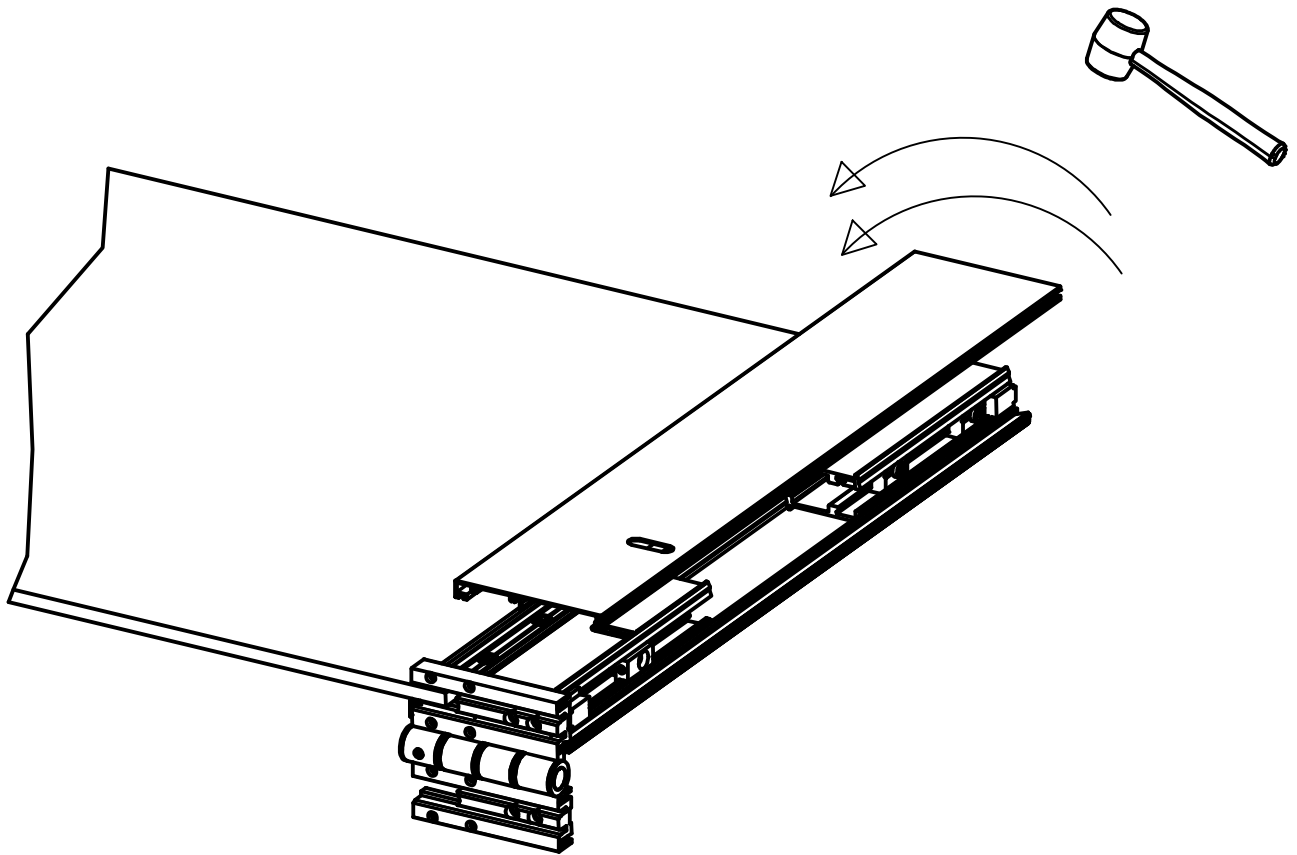


Use a 6.0mm allen key in order to tight  
ALL the screws of the clamping profile.  
Apply 25Nm torque.



**STEP-12:**

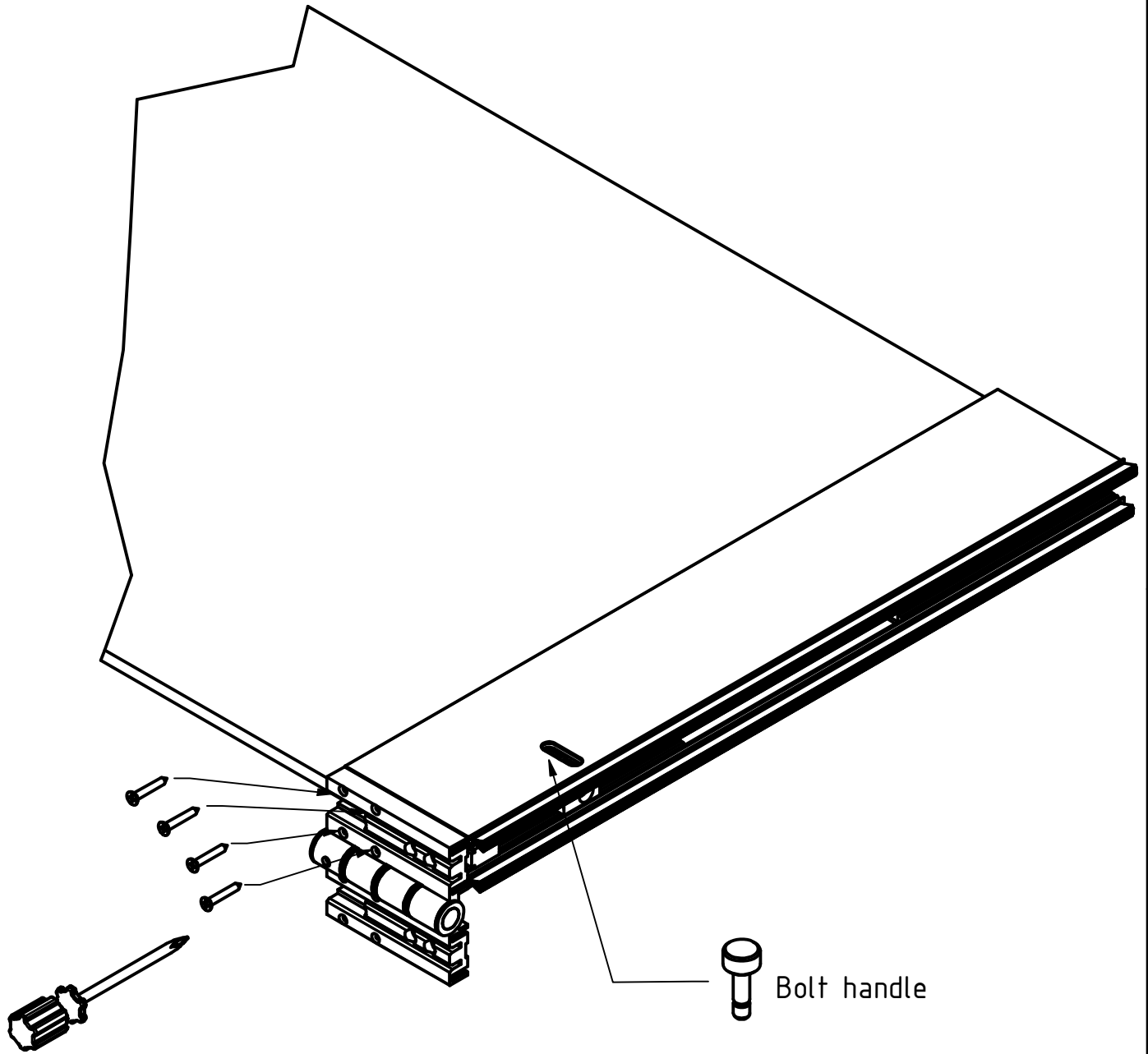
Finalize the assembly of the glass with the lower clamping profiles.  
Tight all the screws. Same like STEP-6.



**STEP-13:**

Assembly upper cover profile.

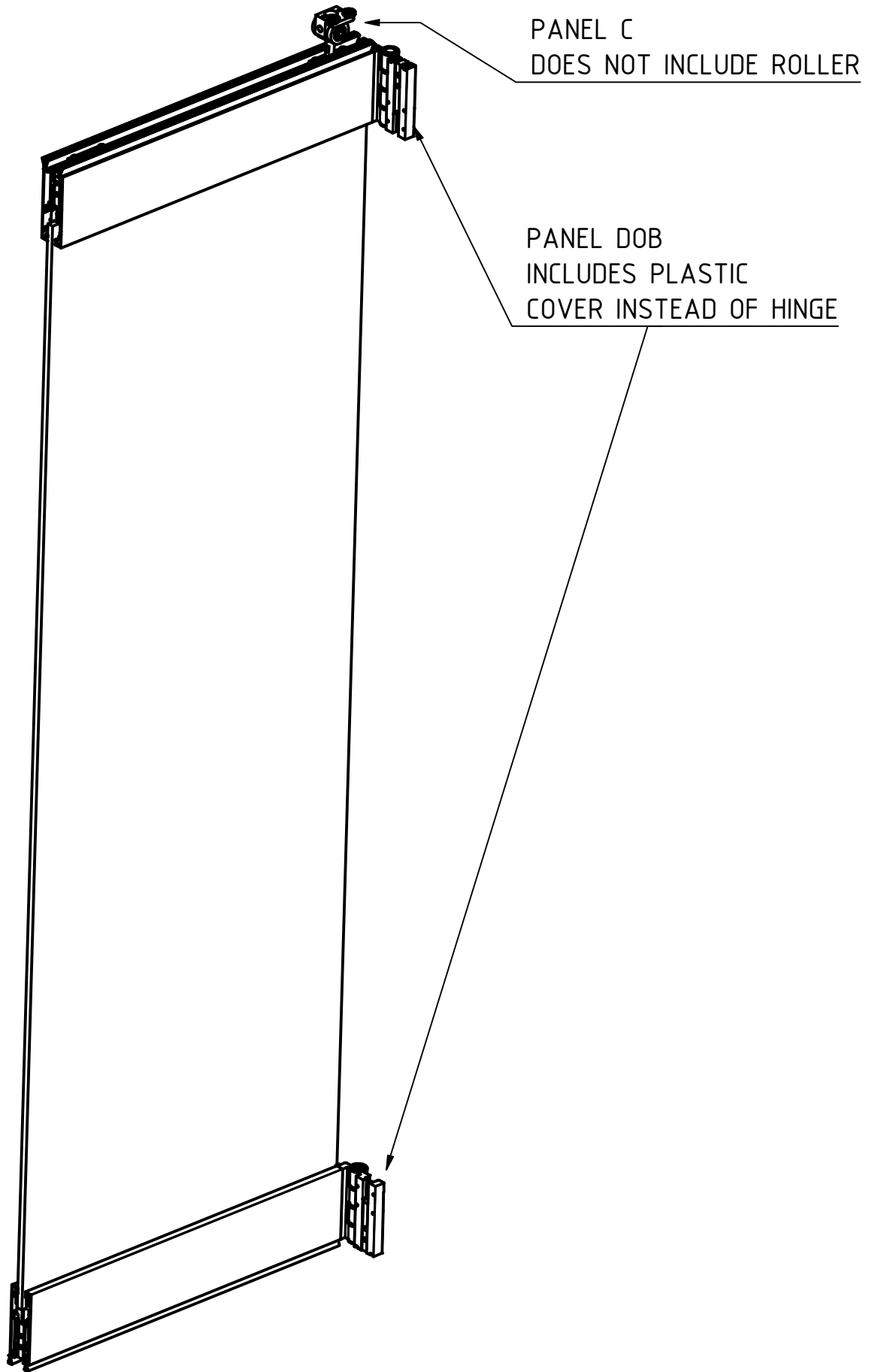
Place it first at the assembly geometry of the clamping profile and then close it towards the glass. Apply small force at the final stage in order to secure assembly. Same like STEP-7.



**STEP-14:**

Assembly the bolts that hold the cover and the hinge and then the parts for the locks and bolts.

# PANEL ASSEMBLY INSTRUCTIONS



PANEL C  
DOES NOT INCLUDE ROLLER

PANEL DOB  
INCLUDES PLASTIC  
COVER INSTEAD OF HINGE

PANEL IS READY

  
INNOVATIVE GLASS SYSTEMS

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