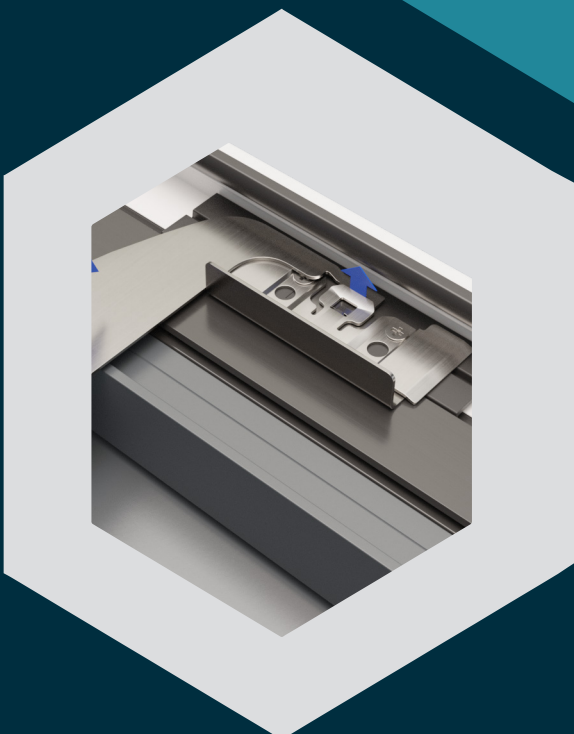
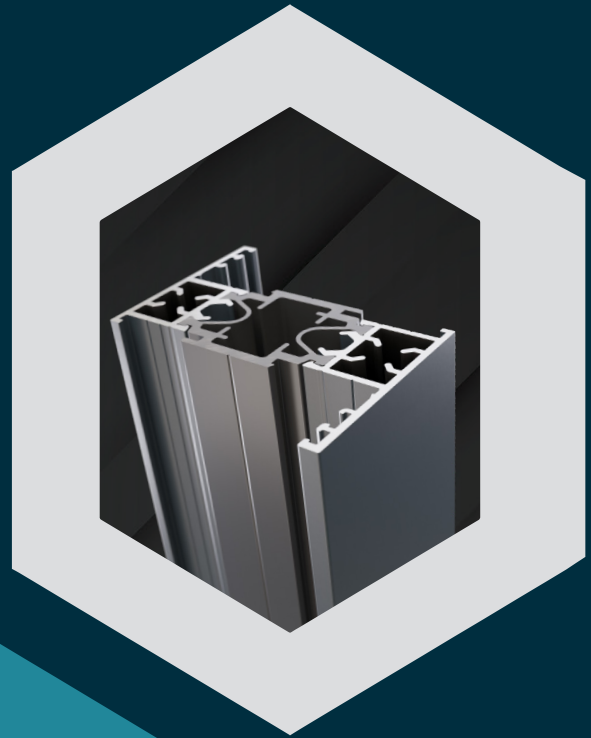


EA-THERM70 WINDOW

Installation Guide



PART L

Compliant ✓

 **ENDURANCE**[®]
ALUMINIUM

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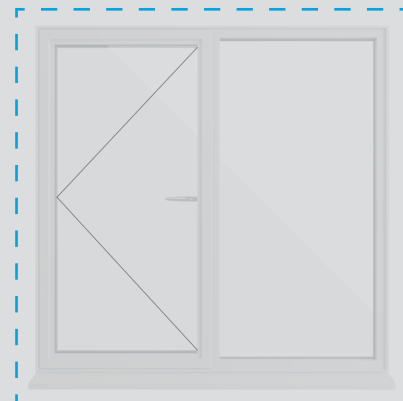
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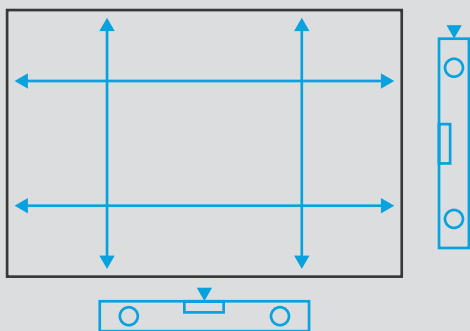
Survey & Pre-Installation

Check the aperture to make sure that there is no loose plaster or brickwork, and that it is free of any debris or brick dust.

Frame size = brick to brick size – 5mm each side, so that the window can be installed level and square.



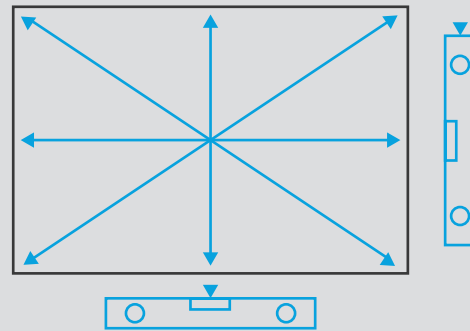
1.



Ensure that all four sides of the aperture are plumb and square and identify any potential packing points.

Please Note: our recommended fixing positions are into the outer wall and the frames are not fixed over an open cavity as this can compromise system performance.

2.

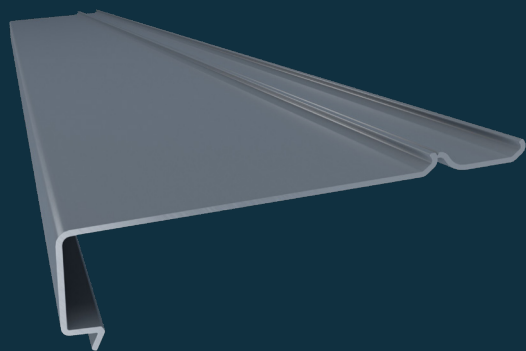


Check that the cill is level and provides a solid base to ensure it will not cause distortion of the window.

Note: The window should be packed under the cill and frame jambs to provide sufficient support.

Check for alignment at points shown.

Disclaimer: Please check with the latest Building Regulations and standards that are relevant to your area for guidance and to ensure you comply with the latest regulations. The advice given in this document assumes fitting will be carried out by a qualified professional following BS 8213 - 4;2016 the Code of Practice for the Survey and Installation of Windows and External doorsets, where applicable.



Cill Protector

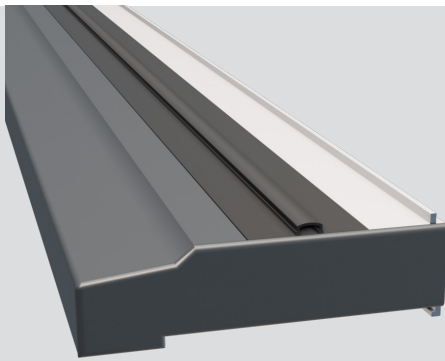
SA516 Reusable Cill Protectors are available from Endurance. These help prevent damage on renovations and new-builds where building work will continue after the doors have been installed.

Cill Preparation

The cill can either be cut square with the width of the window or cut with an additional 100mm on either side to form a traditional horn around the brickwork.

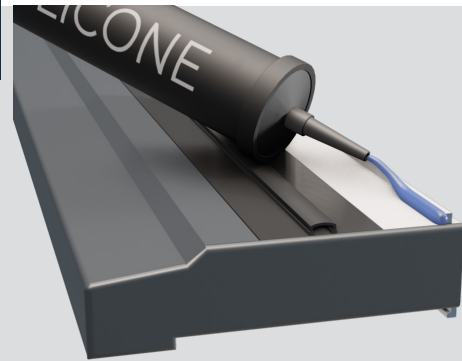


1.



Secure end caps to the cill using a suitable adhesive.

2.



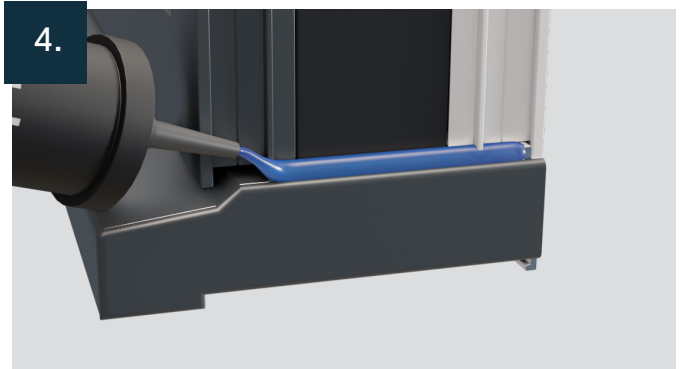
A co-extruded gasket seals between the frame and cill along its length, additional sealant is required as shown.

3.



Fix through the cill into the window frame using countersunk PVCu screws as shown above, taking care that they do not break into the internal glazing rebate.

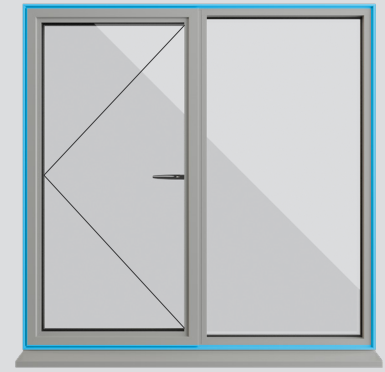
4.



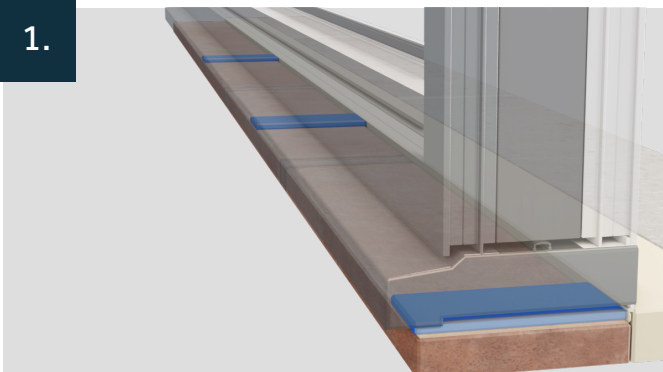
Seal with silicone along the edge where the cill meets the frame.

Frame Fitting

NOTE: Cill packers & screws are not supplied



1.



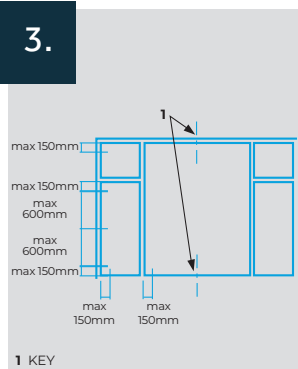
Pack under cill and window jambs and seal along the aperture in preparation for cill installation. It is good working practice to set outer frame 30mm in from the front face of the brickwork.

2.



Pack around the frame using full-width packers ensuring that it's square and level and ensuring a 5mm gap is maintained. Drill pilot holes around the frame at min 150mm from corners and min 600mm centres in between, ensuring at least 2 fixings per side.

3.



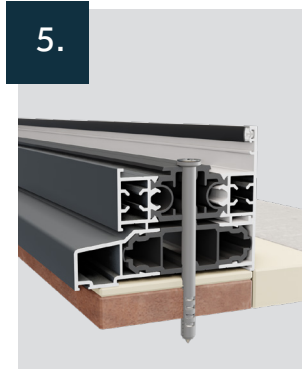
Additional fixings required for frames over 1.8m top and bottom as shown, in line with industry codes of practice.

4.



Prior to fixing the frame, silicone the holes in the bottom of the frame to prevent water ingress.

5.



Fix the frame into the aperture using suitable sized frame fixings to suit construction material.

6.



OPTIONAL: If fitting using fixing cleats, make sure they are securely fastened to the window and through the appropriate fixing holes internally.

Glazing Openers & Dummy Sashes

Remove beads from the window and place them to one side. Beads must be returned to original position once glazed so make a note of where they come from. Ensure all gaskets are inserted into the respective rebates and beads before the glazed unit is fitted.

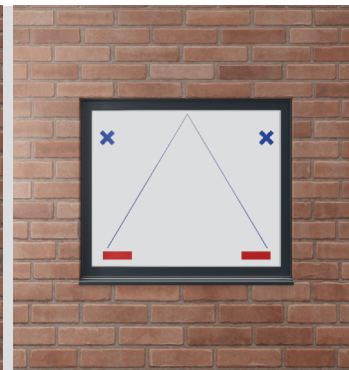
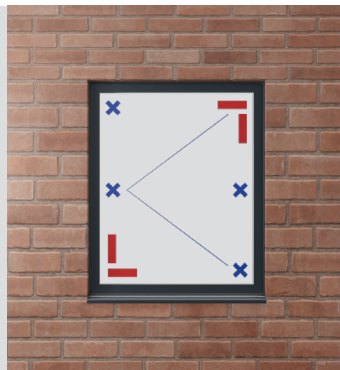


1.

Toe &
Heel



Pack
square*



Fit the glazed unit into the sash, and pack / toe & heel in the appropriate places using glazing packers as shown.

Toe & heeling should distribute the weight of the glass correctly to ensure the window is square and aligned.

Using glass packers at the opposite corners of the sash as shown, creates diagonal support across the glass unit, ensuring the window operates correctly.

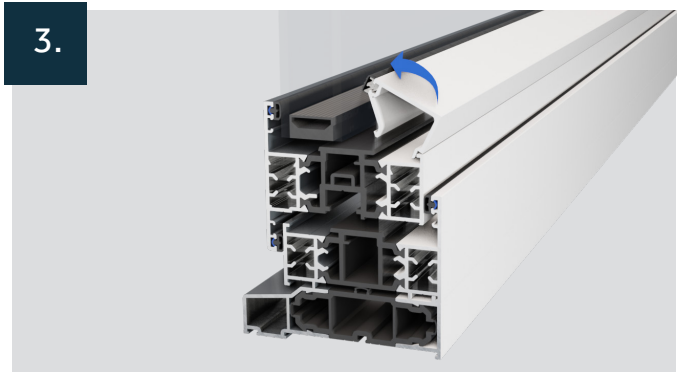
*Position packers in line with locking points to meet PAS 24 requirements

2.



Spray the glass unit with a mild soap/water mix or glass cleaner to prevent the gasket sticking while the bead is being fitted.

3.



Start by locating the front leg of the bead into the receiving channel and rotate the bead until it 'clips' into place.

Fit the top bead first to secure the unit. Continue to fit the bottom bead and then the sides being careful not to scratch the powder coated finish.

If the gasket is not seated correctly, use a glazing shovel to gently press the gasket into the bead to give a nice smooth finish.

Glazing Fixed Panes

(Externally Glazed Only)

Remove beads from the window and place them to one side. Beads must be returned to original position once glazed so make a note of where they come from. Ensure all gaskets are inserted into the respective rebates and beads before the glazed unit is fitted.



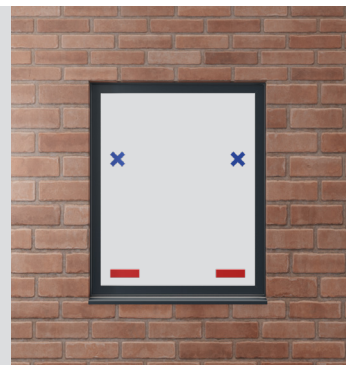
1.



Support
Packers



Pack
square*



The SH128 external/internal Glazing clip base should already be fitted as shown above.

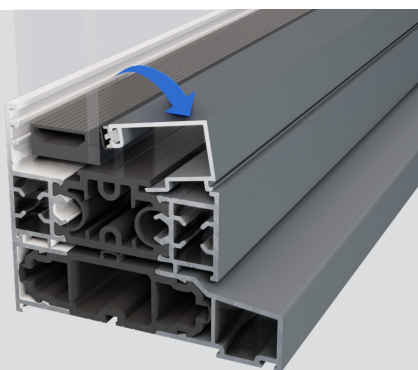
Add the foam strips to the L shaped bracket for the SH128 and clip into place ensuring a positive clip has taken place before securing the glass in the frame.

*Position packers in line with locking points to meet PAS 24 requirements

<600mm 1 clip per side
600mm – 1200mm 2 clips per side
>1200mm 3 clips per side

Note: SH918 Glazing Clip Deglazing Tool required when removing glass.

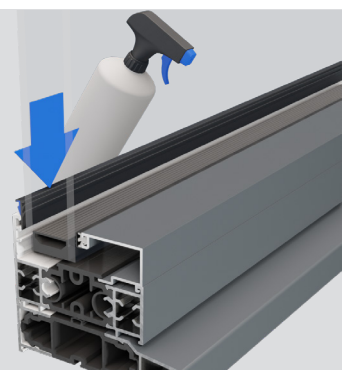
2.



Rotate the back leg of the bead into the frame then clip the front leg into position.

Fit the top bead first to prevent the glazed unit from falling out of the window, continue to fit the bottom bead and then the sides being careful not to scratch the powder coated finish.

3.



Spray the glass unit with a mild soap/water mix or glass cleaner to prevent the wedge gasket sticking to the frame or glass.

If the gasket is not seated correctly, use a glazing shovel to gently press the wedge gasket into the frame to give a nice smooth finish.

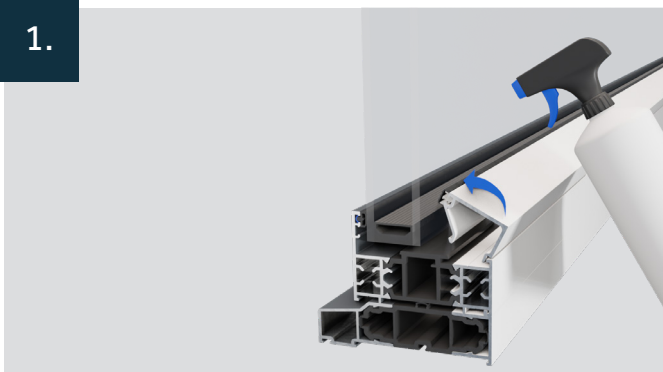
Glazing Fixed Panes

(Internally Glazed - Reversed Butt Window)

Remove beads from the window and place them to one side. Beads must be returned to original position once glazed so make a note of where they come from. Ensure all gaskets are inserted into the respective rebates and beads before the glazed unit is fitted.

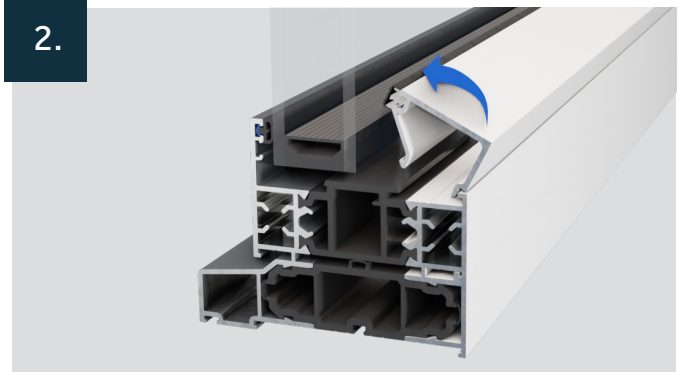


1.



Spray the glass unit with a mild soap/water mix or glass cleaner to prevent the gasket sticking while the bead is being fitted.

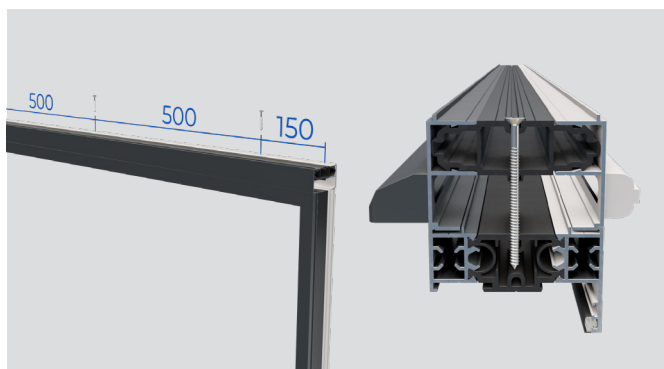
2.



Start by locating the front leg of the bead into the receiving channel and rotate the bead until it 'clips' into place. Fit the top bead first to secure the unit. Continue to fit the bottom bead and then the sides being careful not to scratch the powder coated finish. If the gasket is not seated correctly, use a glazing shovel to gently press the gasket into the bead to give a nice smooth finish.

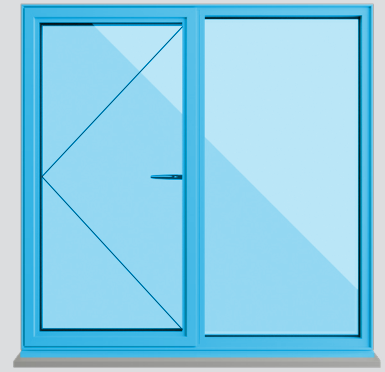
OPTIONAL

Frame Extender



Frame extenders are fitted and fixed as shown, make sure fitting screws do not protrude.

External Finishing & Final Checks



1.

Break off any protruding packers where necessary.

2.

Remove protective tape from all profiles. Clean down aluminium and glass with warm, soapy water.

3.

Expanding foam can be used to fill any large apertures around the frame. Be careful not to overfill. Now trim or silicone around outer frame and seal below external cill if applicable.

4.

Check the window for correct function.

5.

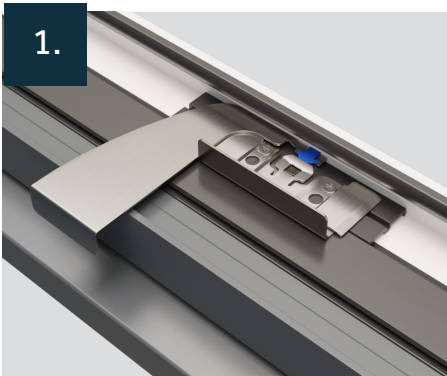
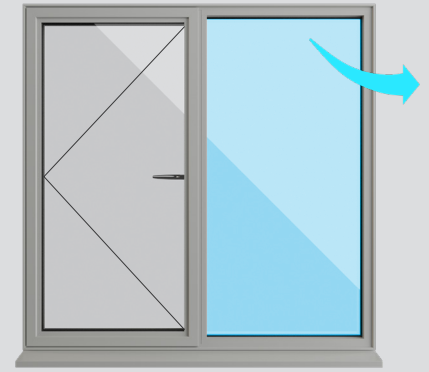


If you need to adjust the compression on window sashes, to ensure they open with minimal effort but maintain a tight seal when closed. Adjust the locking pins on the espag lock using a 4mm allen key.

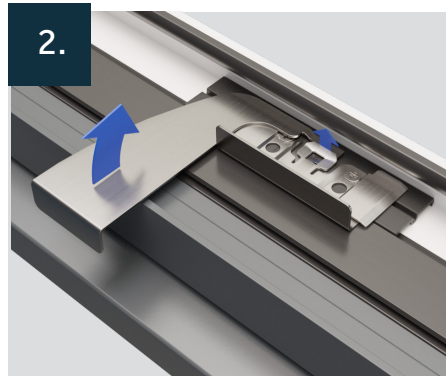
Turning clockwise or counter-clockwise, to decrease or increase the contact pressure between the sash and frame as required.

Fixed Pane Removal

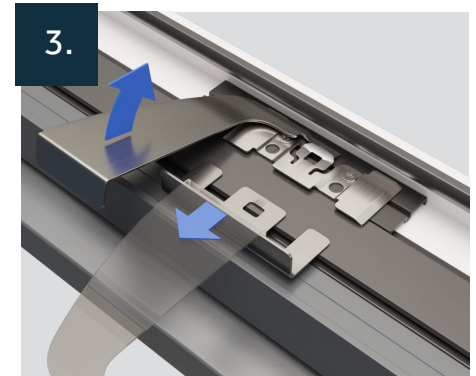
(Externally Glazed Only)



1. Place the de-glazing tool under the sealed unit to the back of the window section as shown. Then slide the de-glazing tool to the left / right until it meets the Securi-clip and pull towards you.

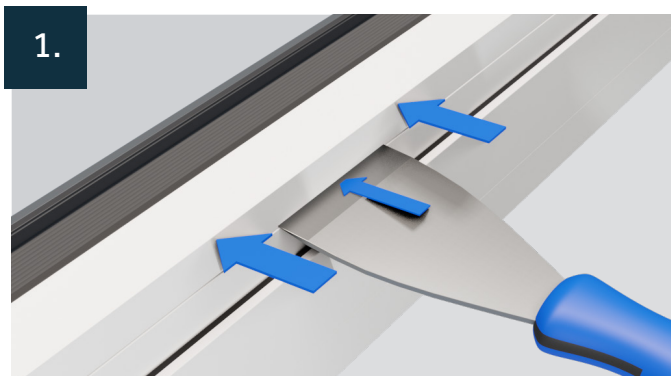


2. Lift the de-glazing tool to engage between the base unit and Securi-clip.

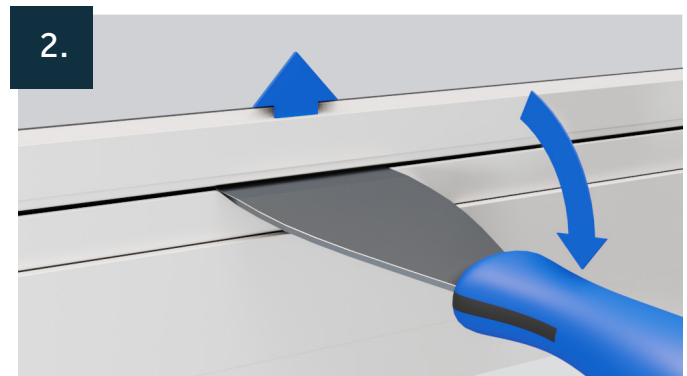


3. Place the handle part of a second de-glazing tool between the clip and the glass and pull the clip out as shown.

Bead Removal



1. Press the top edge of the bead toward the glass, creating a gap between the bead and the frame/ sash.



2. Using a thin pallet knife or appropriate tool, insert the tool in the gap created and lever away from the bead to disengage from the fixed profile.

Please send any photos of your installation to

info@endurancealuminium.co.uk

so we can share your work.

Or tag us on social media:



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