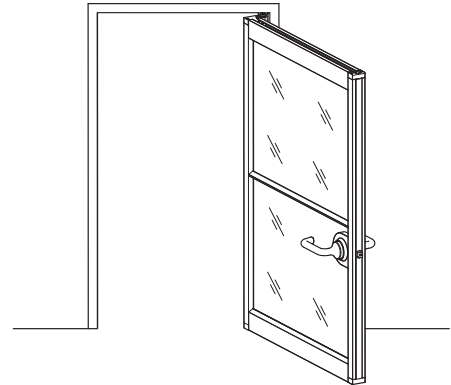


ALUMINUM FRAME SWING DOOR (2WAY ADJUSTABLE) AF-25D INSTALLATION MANUAL

Thank you for selecting our product. Before starting installation, please read this manual thoroughly to ensure correct installation. Please keep this manual at hand for future reference.

ABOUT THE PRODUCT

- This product is a parts set for an aluminum frame swing door system for indoor use.



SPECIFICATIONS





Max.Door width	900 mm (1000 mm when using intermediate support)
Max.Door height	2200 mm (3000 mm when using intermediate support)
Glass thickness	5 mm, 6 mm
Max.Door weight	40 kg (per door)

FOR YOUR SAFE WORK AND CORRECT INSTALLATION







Meaning of symbols

 Warning Caution	 Prohibited	 Required
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WARNING: If not followed injury or damage may result.

-  This (sliding door system) should be installed by a qualified person. If the system is not installed correctly, the door will not operate smoothly, and may cause injury.
-  It is necessary to manufacture the frame with sufficient strength so it endures the weight of the door and impact shocks upon opening/closing the door. A frame with poor strength might result in improper and slower movement of the door. In the worst case, the door might fall and cause injury.
-  Do not try to use this product for anything other than its original purpose. Do not use any part for applications outside of its specification.
-  Do not disassemble nor modify any parts other than those described in this document.

Caution: If not followed injury or damage may result.

-  Make sure to follow the designated dimensions and specifications as well as the horizontal and vertical angles. Make sure that the frame is not warped, since it may affect the movement of the door.
-  If cutting any parts, make sure to remove any burrs before installation. Also check the upper track for any left-over burrs or scraps and remove these.
-  This (sliding door system) is a part for architectural fittings. After installation, make sure to test the finished product thoroughly to ensure that it is well-functioning and safe.
-  Make sure to test the screws for slack at regular intervals (one month from first usage, half a year, and then one time every year is recommended).
-  To avoid damaging of aluminum frame, carry out installation work on clean floor.
-  Use tempered glass. Using shatter-proof film is recommended.

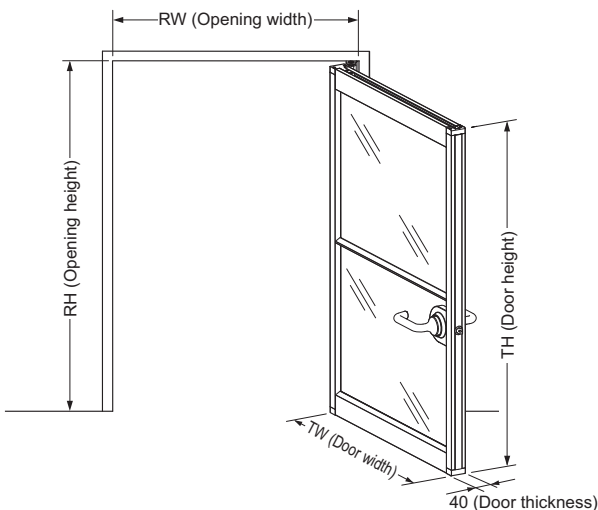
COMPONENT PARTS

Components (per door)	Standard size parts (specify the number of parts required)	Lever handle parts
<p>Pivot hinge AF-25-P10</p> <ul style="list-style-type: none"> ①-1 Hinge cap: 2 pcs. ①-2 Hinge: 1 pc. top, 1 pc. bottom ② Bracket: 1 pc. top, 1 pc. bottom <p>Handle case AF-25-P06</p> <ul style="list-style-type: none"> ③ Case front: 1 pc. ④ Case back: 1 pc. ⑤ Case cover: 2 pcs. ⑥ Gasket: 4 pcs. <p>⑦ Corner parts: 2 pcs. AF-25-P04</p>	<ul style="list-style-type: none"> ⑧ Vertical frame: 2500 mm AF-25-W01 ⑨ Horizontal frame: 2000 mm AF-25-W02 ⑩ Intermediate support: 2000 mm AF-25-W03 ⑪ Gasket AF-25-P02 (2500 mm) for 5 mm AF-25-P15 (3000 mm) for 6 mm ⑫ Gasket for intermediate support AF-25-P03 (2500 mm) for 5 mm AF-25-P16 (2500 mm) for 6 mm ⑬ Cover: 2500 mm AF-25-P01 <p>CAUTION Door assembly screws are not supplied.</p>	<ul style="list-style-type: none"> ⑭ Lever handle: 1 set As for the shape and key type, ask our sales staff. ⑮ Mounting tool: 1 pc. ⑯ Fixing bolt: 1 pc. ⑰ Latch bolt: 1 pc. ⑱ Strike: 1 set 4 x 30 Cross-recessed self-tapping screw 658206 <p>Decorative rings</p> <p>Screw</p> <ul style="list-style-type: none"> ⑲ Hexagon socket countersunk head screw M5 x 12: 4 pcs ⑳ Hexagon head bolt M4 x 12: 1 pc. (Attached to hinge) ㉑ Plain washer 6 mm: 1 pc. (Attached to hinge) <p>Door assembly screw (not provided)</p> <ul style="list-style-type: none"> ㉒ Hexagon socket head bolt M6 x 30: 8 pcs. ㉓ Hexagon socket head bolt M4 x 30: Q'ty of intermediate support x 2 ㉔ Hexagon socket countersunk head screw M4 x 25: 12 pcs ㉕ Countersunk head tapping screw M4 (M5) x 30 or more: 8 pcs.

DOOR SIZE

TH (Door height) \geq RH (Opening height) - 15
(Set the clearance above the door at 6 mm.)

TW (Door width) = RW (Opening width) - 11
(Gap at hinge side: 7 mm, Gap at door end: 4 mm)



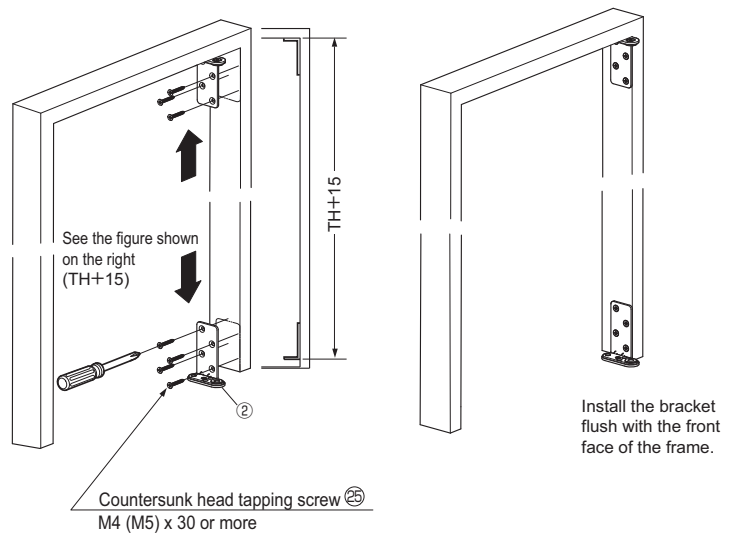
ASSEMBLY

1 Installing bracket for pivot hinge

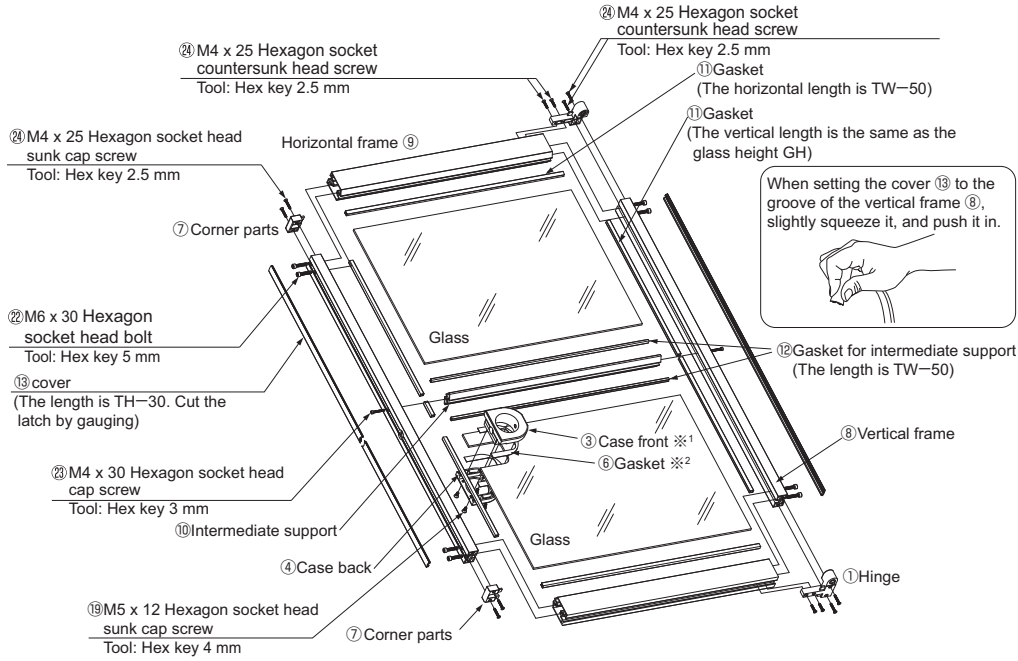
See page 5 to 7 for the process dimensions of parts.

The figure below shows a right handed door.

For a left handed door, swap the hinges.



2 Assembling door



⚠ ATTENTION

Left figure shows a right handed door. For a left handed door, turn the figure 180 degree.

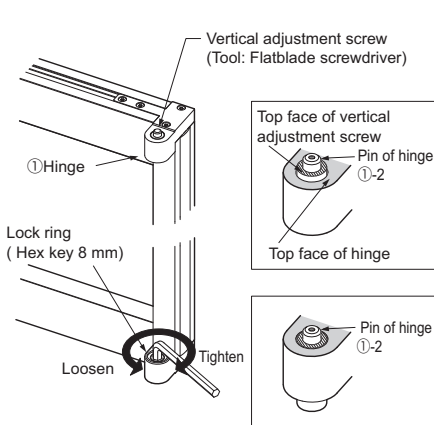
⚠ ATTENTION

※¹: Mount case front ③ and case back ④ last.

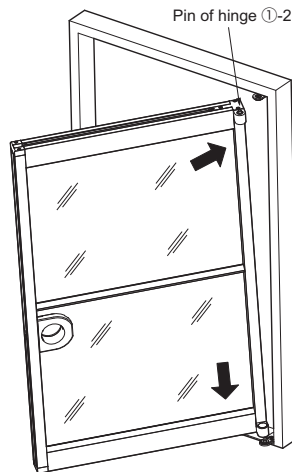
⚠ CAUTION

※²: Q'ty of gasket ⑥;
5 mm of glass thickness: 4 pcs
6 mm of glass thickness: 2 pcs

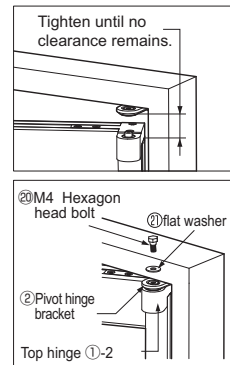
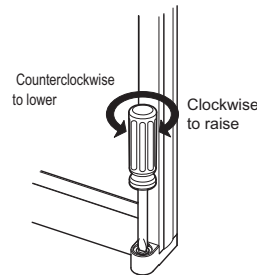
3 Door Hanging and adjustment



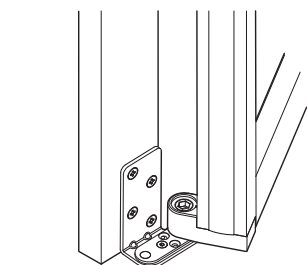
[1] Loosen the lock ring in the top and bottom hinges ①-2, and adjust so that the top face of the vertical adjustment screw is flush with the top face of the hinge.



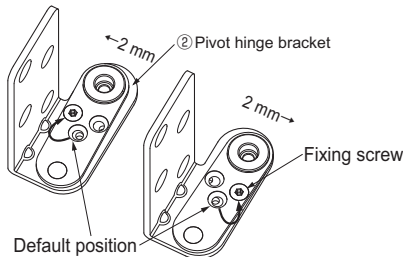
[2] Insert the pivot of the bottom hinge ①-2 into the hole of the bottom bracket. Guide the top pivot to the hole of the top bracket, while pushing the pivot of the top hinge with your finger. Then, release your finger from the pivot, and push the pivot into the top bracket. After setting it, ensure that the door cannot be pulled out from the bracket.



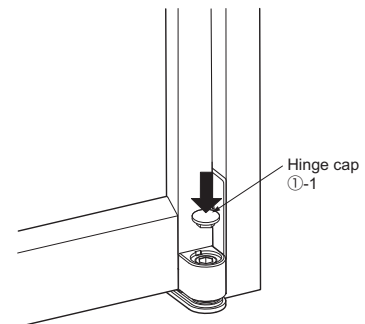
[3] Turn the vertical adjustment screw on the bottom hinge ①-2 until no clearance is left between the top hinge ①-2 and the top bracket ②. After the adjustment is complete, assemble the locking flat washer ② and the hexagon head bolt ② to the top hinge ①-2.



[4] Tighten the lock ring in the top and bottom hinges ①-2 firmly.



[5] Left-Right adjustment can be performed by moving the fixing screw as above.
(Tool: Hex key 3 mm)

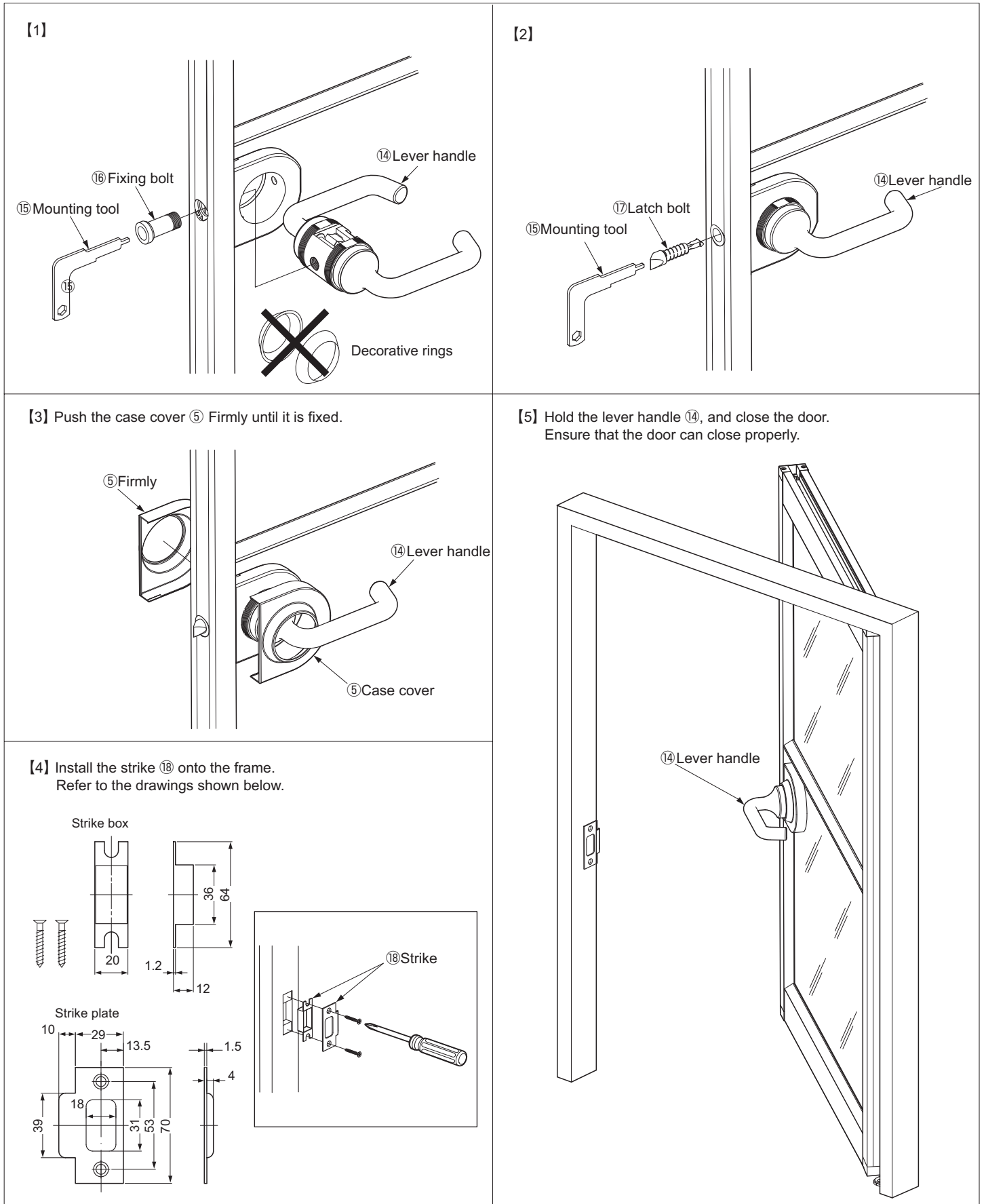


[6] Assemble hinge cap ①-1 in the end.

⚠ WARNING

Be sure to tighten screws firmly. Failure to tighten screws may cause the door to accidentally fall.

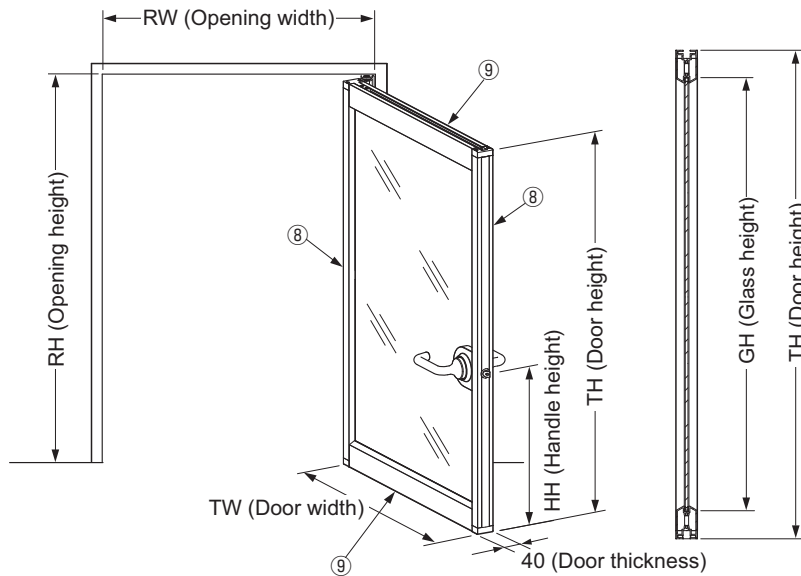
4 Installing lever handle



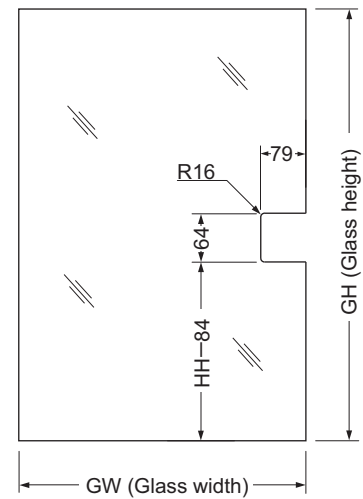
PROCESS DIMENSIONS

1 Door without intermediate support

■ Dimensions of door



■ Glass dimensions



$$GH \text{ (Glass height)} = \frac{TH - 104 - (\text{Q'ty of Intermediate support} \times 11)}{\text{Q'ty of glass}}$$

$$GW \text{ (Glass width)} = TW - 34$$

Ex.) When the door height is 2400 mm and the width is 900 mm,

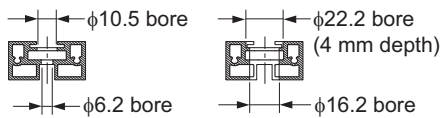
$$GH = \frac{2400 - 104 - (0 \times 11)}{1} \quad GW = 900 - 34$$

$$GH = 2296 \text{ mm} \quad GW = 866 \text{ mm}$$

⚠ CAUTION
Glass is not included.

⚠ CAUTION
Use tempered glass. Using shatter-proof film is recommended.

■ Frame

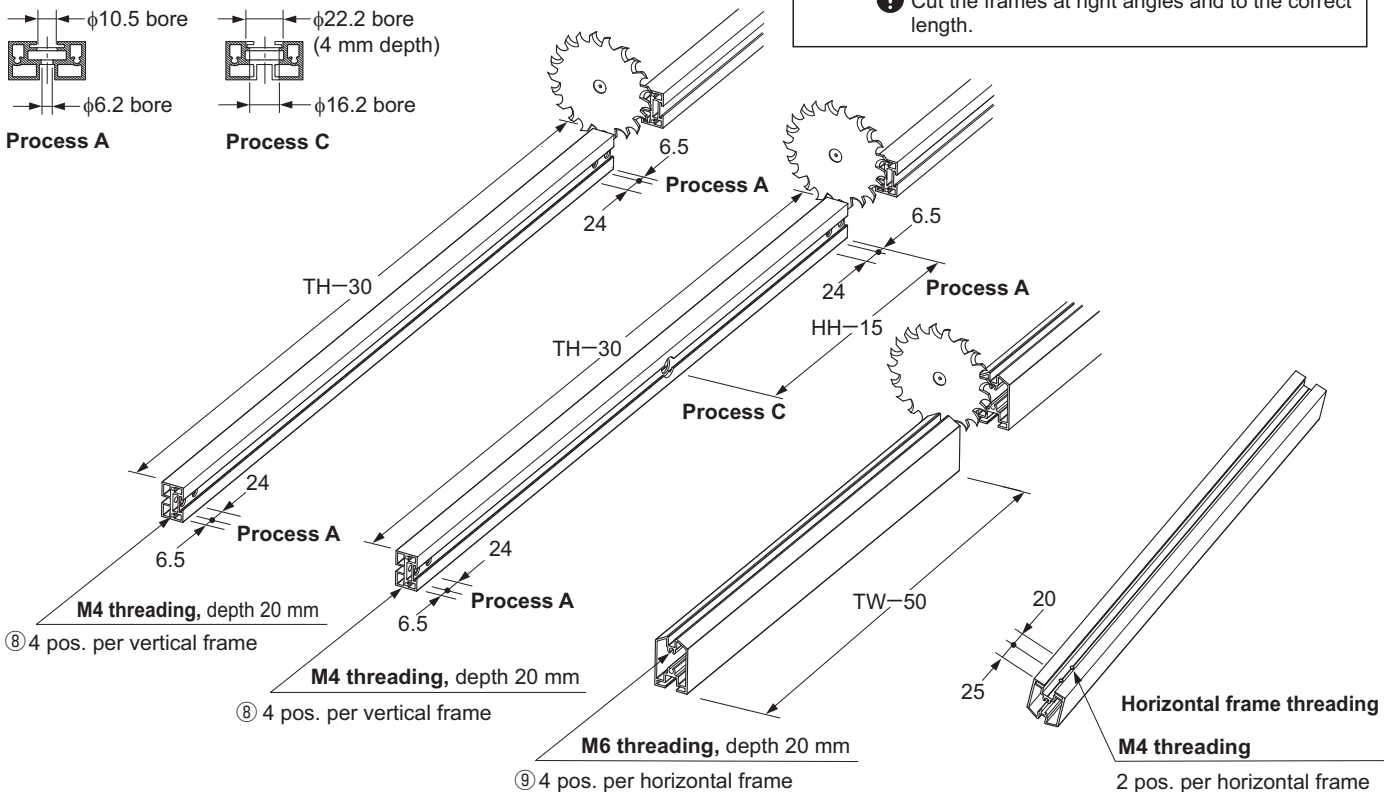


Process A

Process C

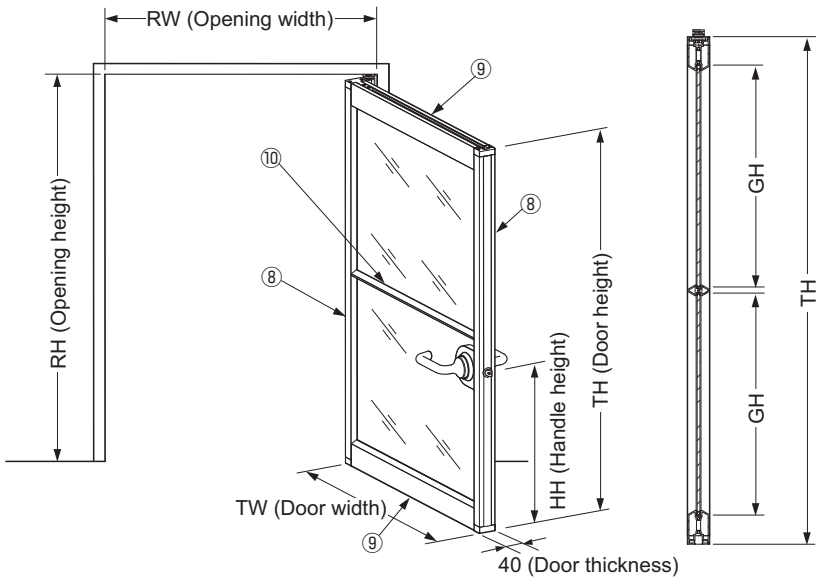


- ⚠ When working on frames, wear protective glasses.
- ⚠ Cut the frames at right angles and to the correct length.



2 Door with one intermediate support

■ Dimensions of door



$$GH \text{ (Glass height)} = \frac{TH - 104 - (\text{Q'ty of Intermediate support} \times 11)}{\text{Q'ty of glass}}$$

$$GW \text{ (Glass width)} = TW - 34$$

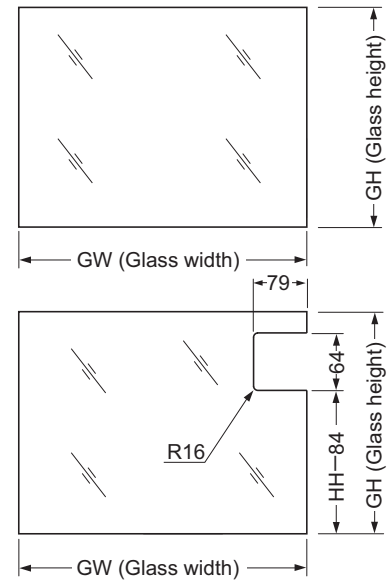
Ex.) When the door height is 2400 mm, the width is 900 mm, and an Intermediate support is located in the middle,

$$GH = \frac{2400 - 104 - (1 \times 11)}{2} \quad GW = 900 - 34$$

$$GH = 1142.5 \text{ mm (1142 mm)} \quad GW = 866 \text{ mm}$$

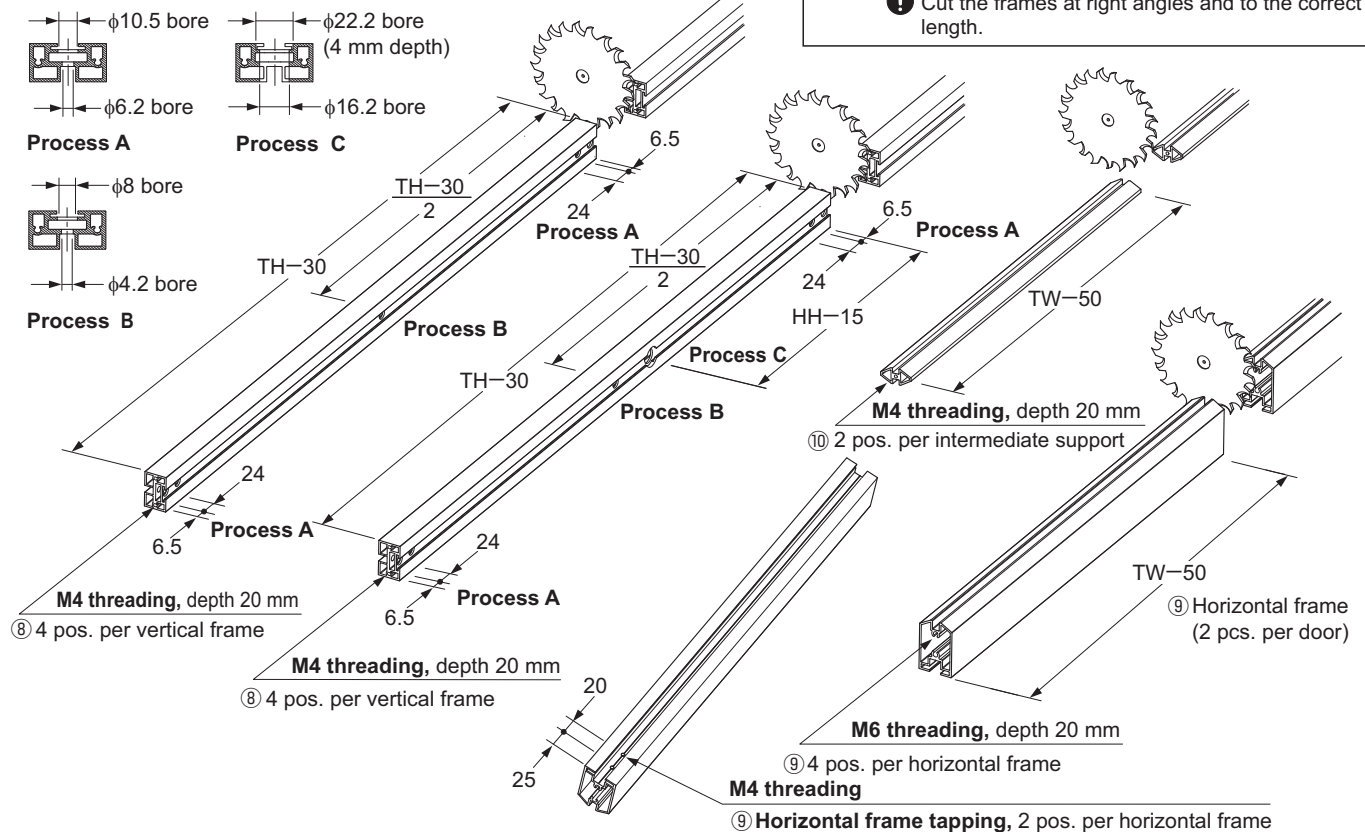
⚠ CAUTION
Glass is not included.

■ Glass dimensions



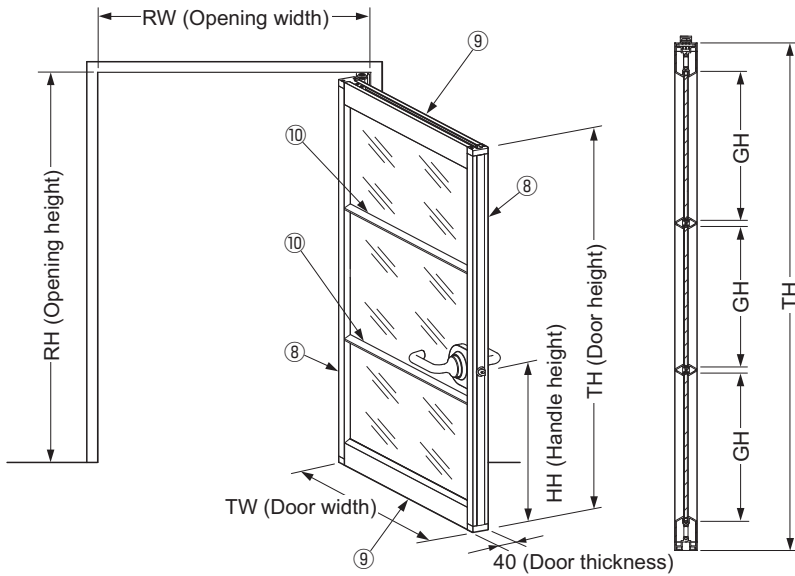
⚠ CAUTION
Use tempered glass. Using shatter-proof film is recommended.

■ Frame



3 Door with two intermediate supports

■ Dimensions of door



$$GH \text{ (Glass height)} = \frac{TH - 104 - (\text{Q'ty of Intermediate support} \times 11)}{\text{Q'ty of glass}}$$

$$GW \text{ (Glass width)} = TW - 34$$

Ex.) When the door height is 2400 mm and the width is 900 mm, and two Intermediate support are located in the middle,

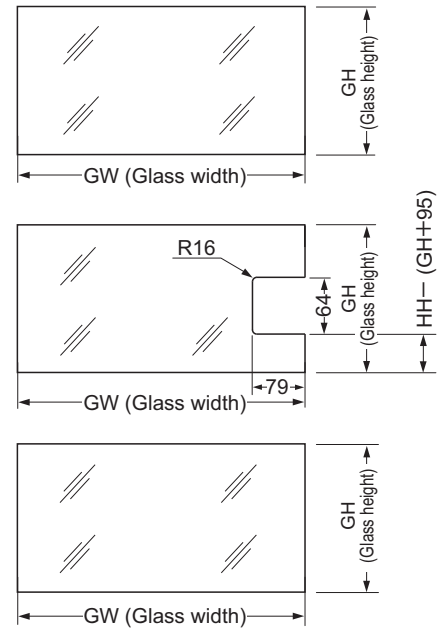
$$GH = \frac{2400 - 104 - (2 \times 11)}{3} \quad GW = 900 - 34$$

$$GH = 758 \text{ mm}$$

$$GW = 866 \text{ mm}$$

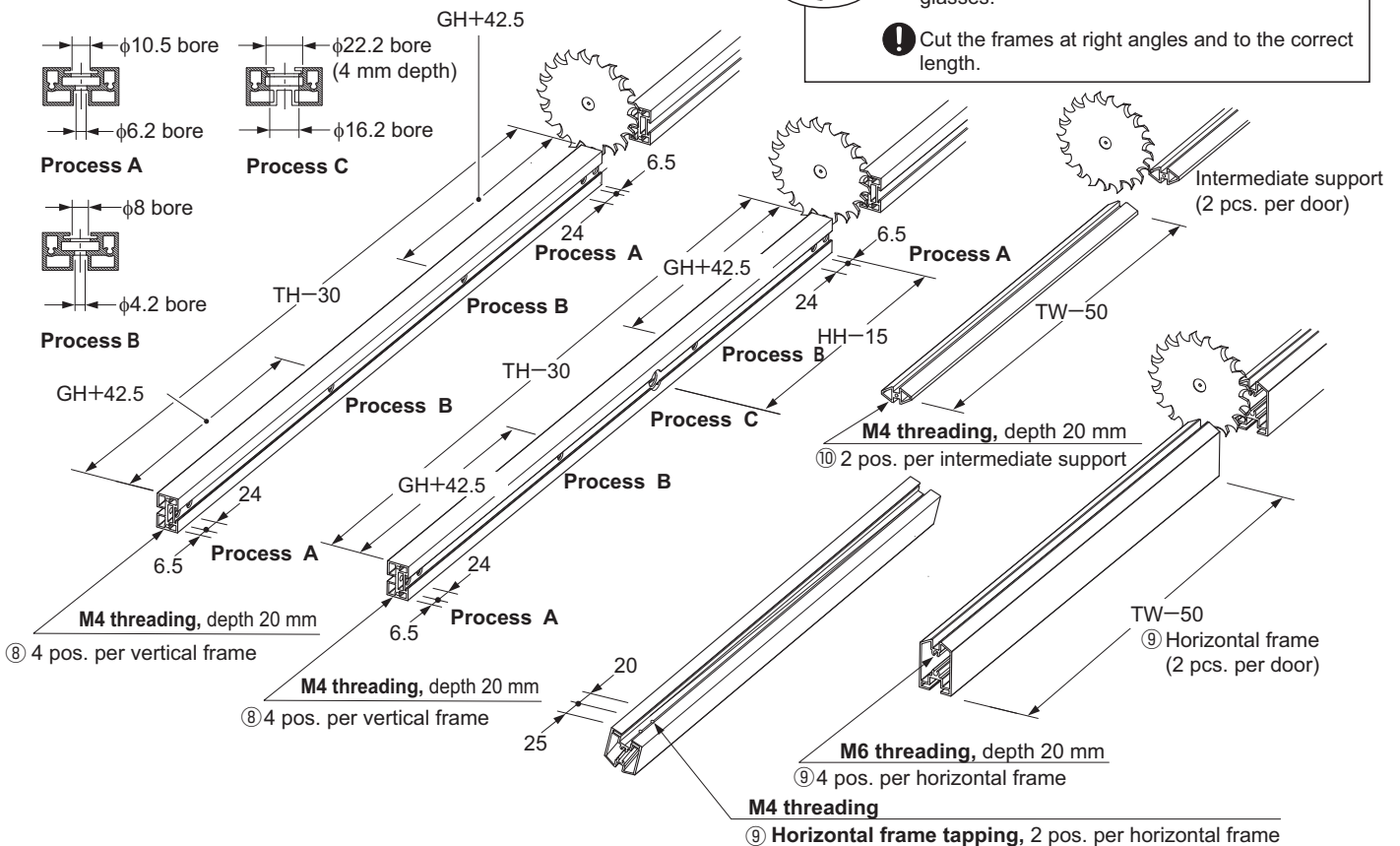
CAUTION
Glass is not included.

■ Glass dimensions

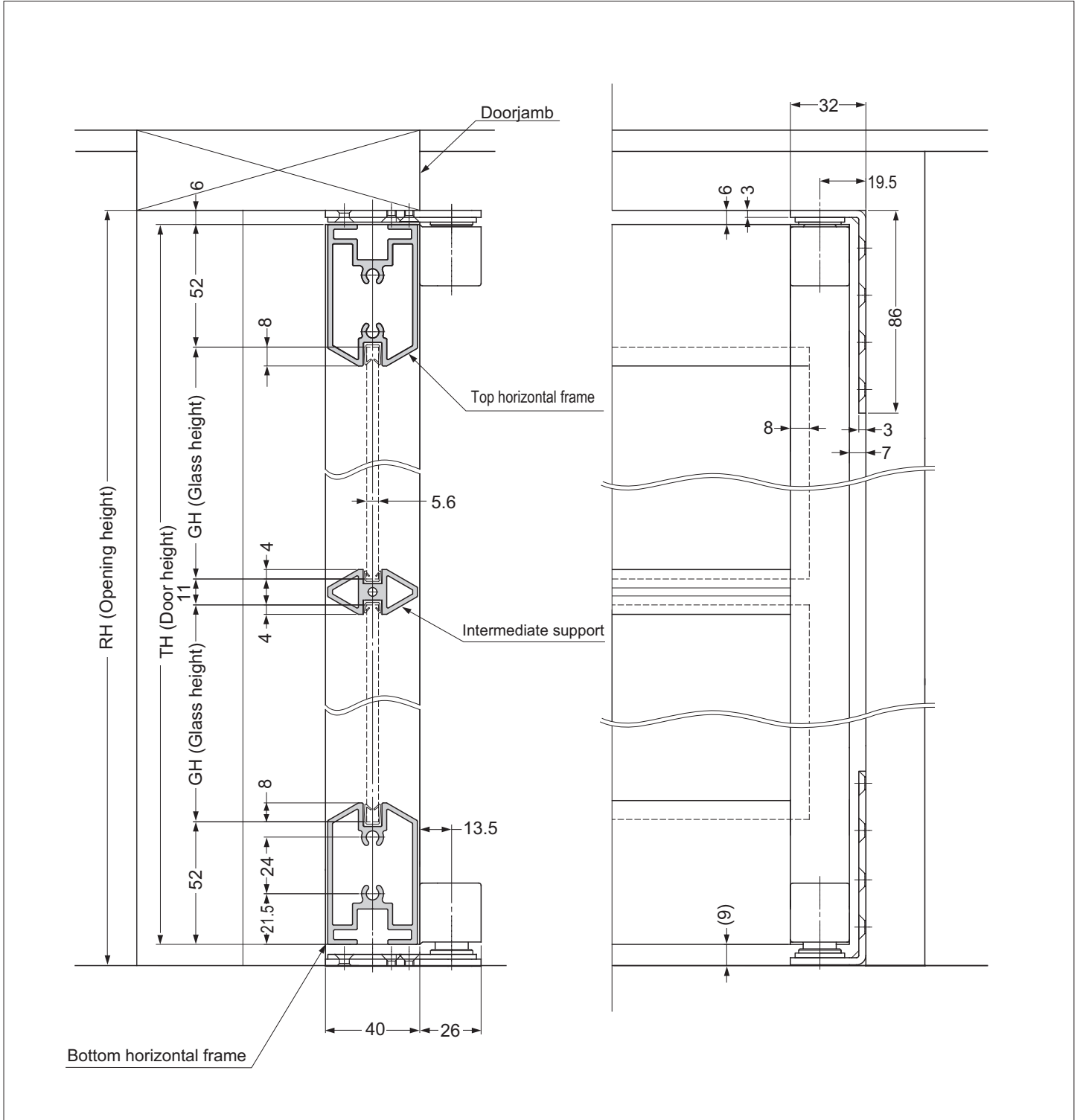


CAUTION
Use tempered glass. Using shatter-proof film is recommended.

■ Frame



INSTALLATION DRAWING (EXAMPLE)



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ISO9001(Japan Offices and Sugatsune America) and ISO14001(Chiba Production division and Logistics center), certified.

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