



Sliding Door 8 32x18
Notes on Use and Installation

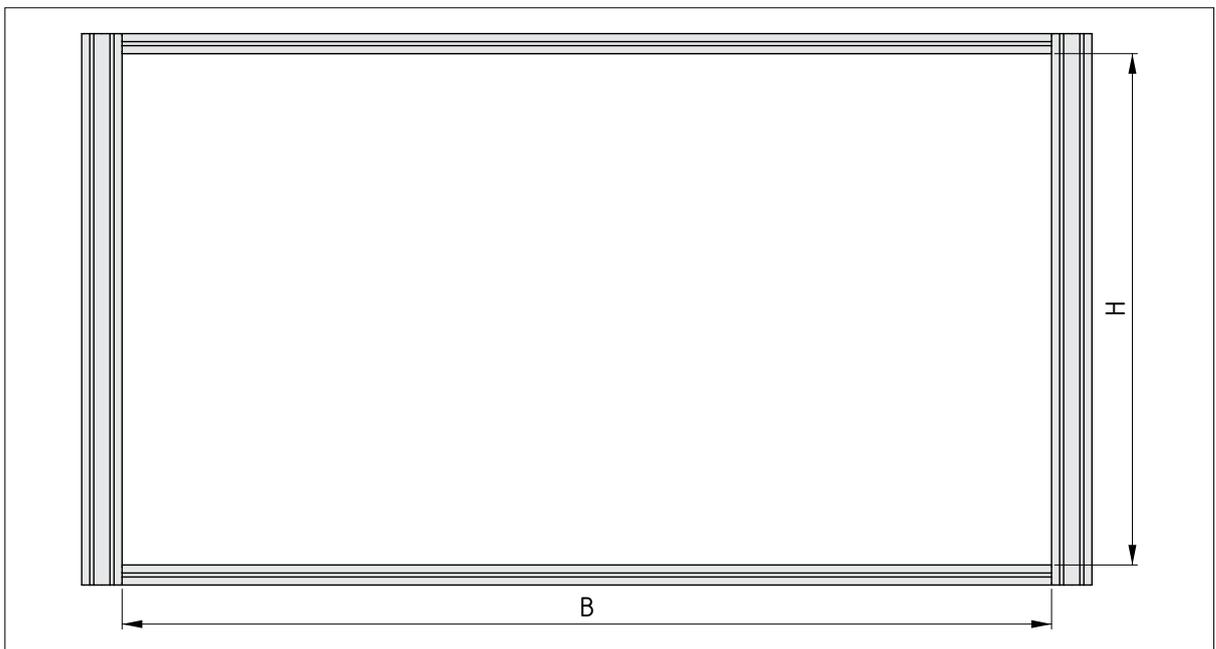
Safety instructions

Sharp edges may be present – wear safety gloves during assembly and installation work.

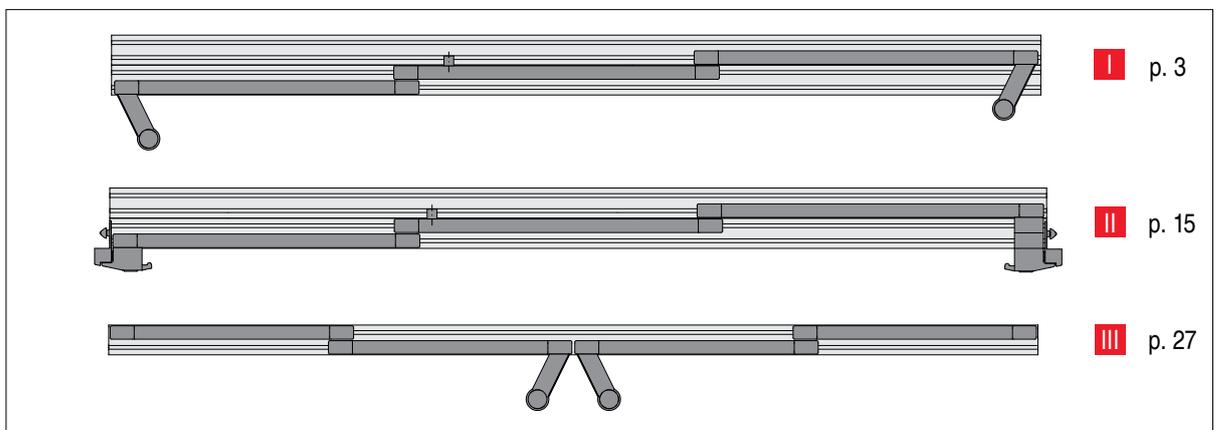
The details and information in this guide are provided for the purposes of describing the product and its assembly only. This information does not discharge users from the obligation to conduct their own assessments and checks.

It is also important to bear in mind that components exposed to mechanical loads are subject to a natural process of wear and ageing. Check all components for obvious defects prior to assembly/installation.

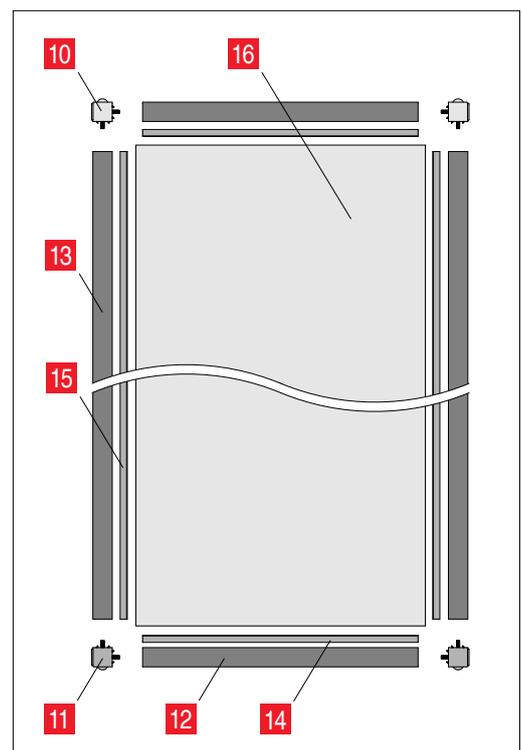
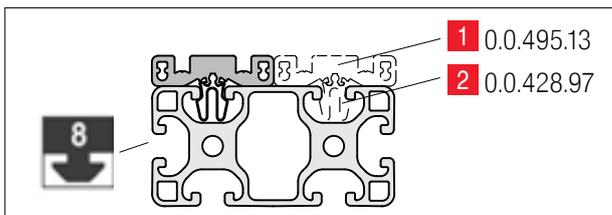
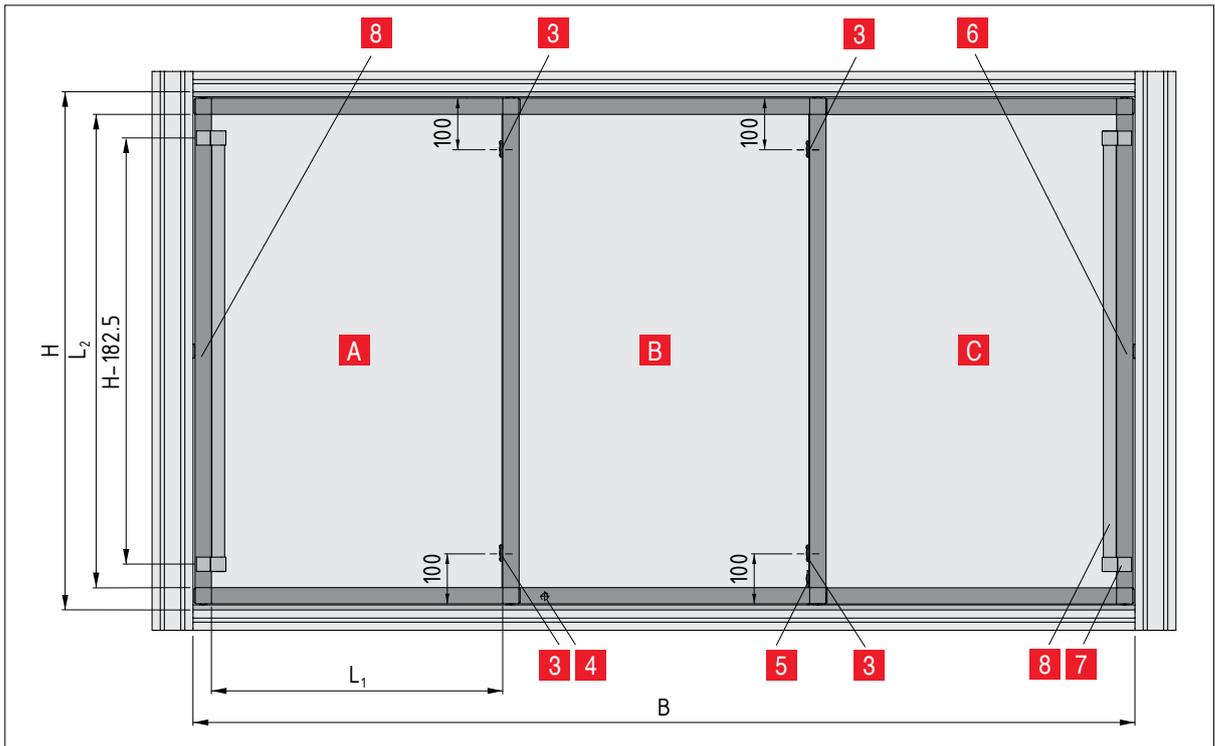
Sliding-door variants



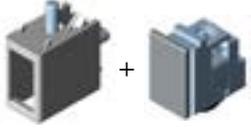
Variants:



Variant **I** – three sliding-door segments with handle, magnetic catch and optional fixing plate



General basic structure				
No.	Article	Quantity	Description	Illustration
1	0.0.495.13	4	Length = B [mm] - 2 mm	
2	0.0.428.97	Quantity = W [mm] / 200 (rounded off, per profile)		
3	0.0.717.55	2		
4	0.0.719.02	1	Optional, to protect against crushing	
5	0.0.717.57	1	Optional, as an immobiliser	
6	0.0.718.40	2		
7	0.0.601.65	4		
8	0.0.601.63	2	H [mm] - 182.5 mm	

General structure for one sliding-door segment (variant I requires 3 sliding-door segments)				
No.	Article	Quantity	Description	Illustration
10 * 11 *	0.0.494.73 + 0.0.494.74	4		
12	0.0.373.67	2	$L_1 = (B - 133) / 3$	
13	0.0.373.67	2	$L_2 = H - 88.5$	
14	0.0.489.91	2	$L_1 = ((B - 133) / 3) \times 1.05$	
15	0.0.489.91	2	$L_2 = (H - 88.5) \times 1.05$	
16	-	1	Panel: 4 mm - 6 mm Panel width = $L_1 + 22$ mm Panel height = $L_2 + 22$ mm	

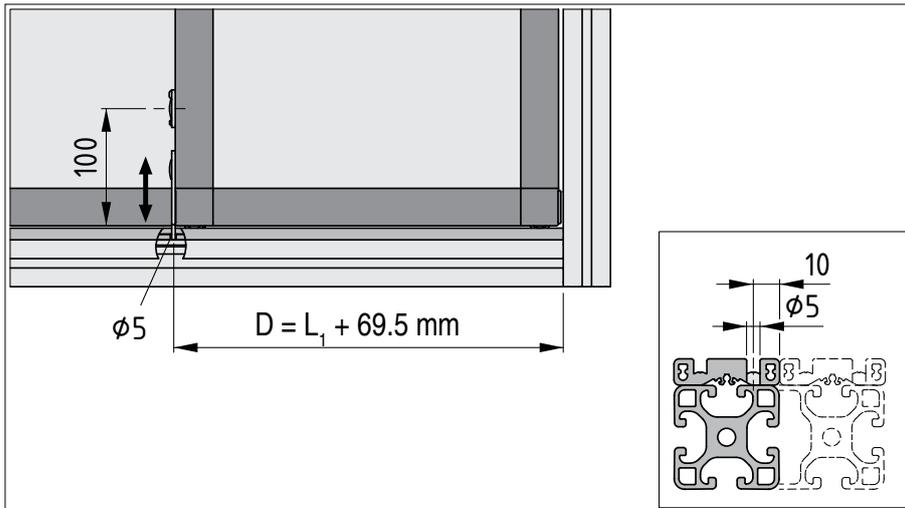
* Rollers for Corner-Fastener 8 32x18 (0.0.494.74) are subsequently slid into the Corner-Fastening Sets Clamp-Profile 8 32x18 (0.0.494.73), the top ones with a spring and the bottom ones with a fixing block.

Profile machining processes



Machine all profiles prior to assembly.

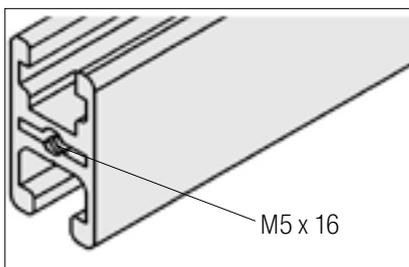
Profile machining of Sliding-Door Guide Profile 8 40x10 **1** for fixing plate **3** Sliding door **C**



Drill a hole for the fixing plate in the internal Sliding-Door Guide Profile 8 40x10.

Profile machining of Clamp Profile 8 32x18 **C**

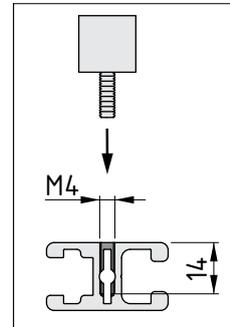
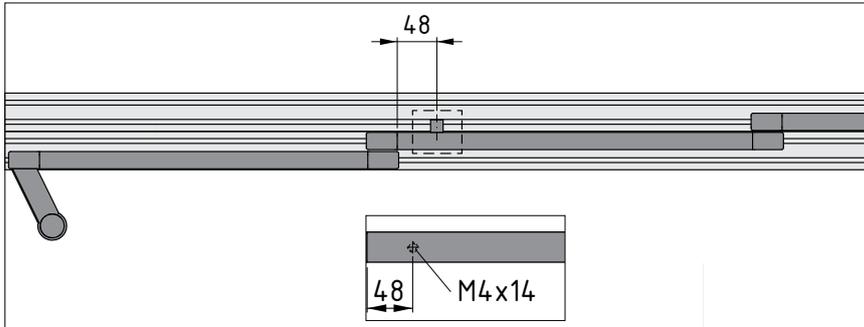
Sliding door **A B**



Tap an M5x16 thread at the ends of all Clamp Profiles 8 32x18.

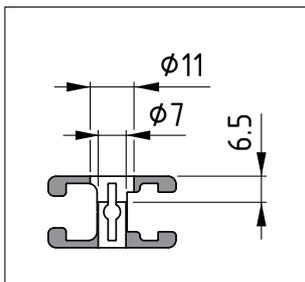
Profile machining of Clamp Profile 8 32x18 **12** for impact buffer **4**
B

Sliding door



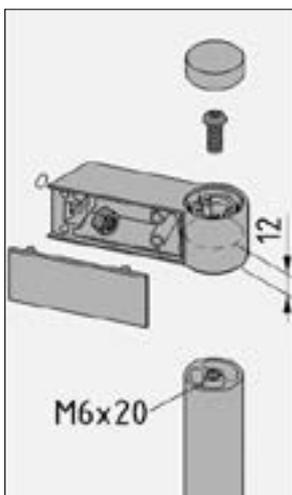
Profile machining of Clamp Profile 8 32x18 **13** for handle **6 7**

Sliding door **A C**



Drill two holes in each of the Clamp Profiles 8 32x18 to which the door handles are to be fastened. Distance apart: H - 178.5 mm.

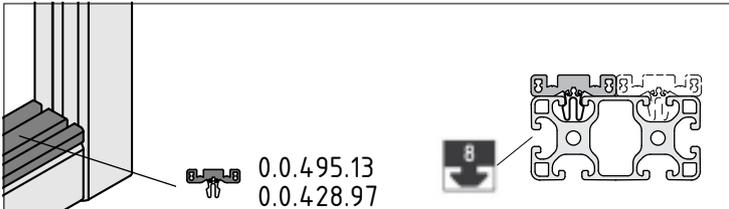
Tip: Use the relevant step drill (0.0.431.20).



Tap an M6x20 thread at both ends of Profile D25 (0.0.601.23).

Assembly

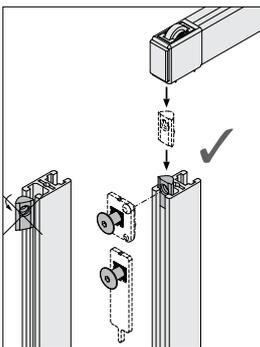
Assembling Sliding-Door Guide Profile 8 40x10 **1** **2**



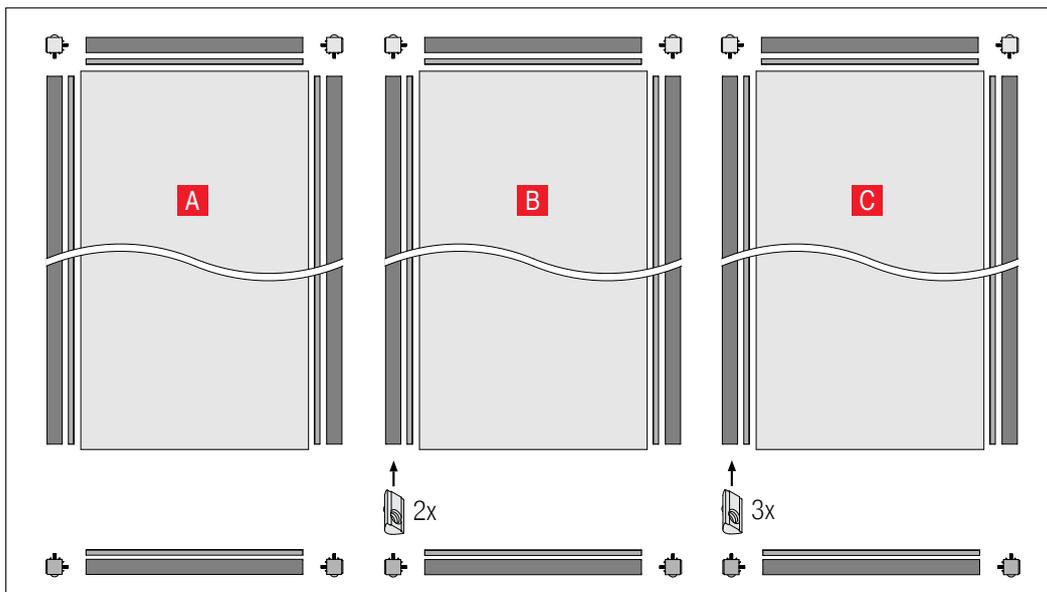
Thread Clips 8 St (0.0.428.97) onto the sliding-door profiles (0.0.495.13) approx. 200 mm apart and then press them by hand into the Line 8 groove geometry.

Assembling the sliding door

Sliding door **A** **B** **C**



Any T-slot nuts that are needed in Clamp Profiles 8 32x18 must be slid in before the sliding door is assembled. It is not possible to swivel them into place afterwards.



1. Corner fastener



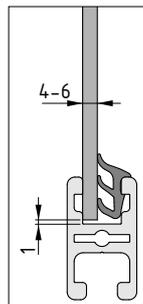
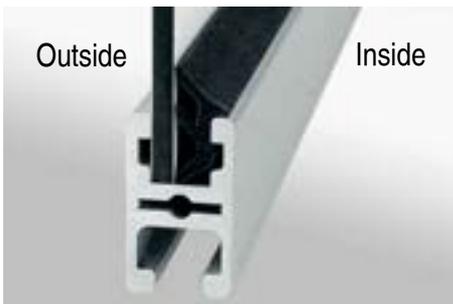
Using Corner-Fastening Sets Clamp-Profile 8 32x18 (0.0.494.73), connect together Clamp Profiles 8 32x18 to create a frame that encompasses the panel.

Clamp Profile 8 32x18 has two different grooves. Make sure you arrange the profile grooves as shown in the picture.

Key width: 3 A/F

Tightening torque: $M_T = 4.5 \text{ Nm}$

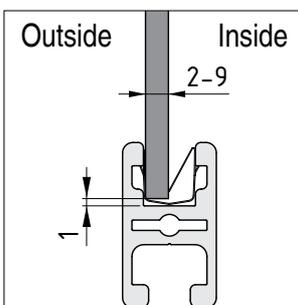
2. Panel fixing



Next, lie the panel down, position it centrally in the frame and secure it in place with the lip seal (0.0.489.91).

Lip seals are fitted on the inside, which pushes the panel outwards. Cut lip seals a few millimetres longer than required, as they contract again slightly when fitted.

Tip: Lip Seal 8 4-6 mm
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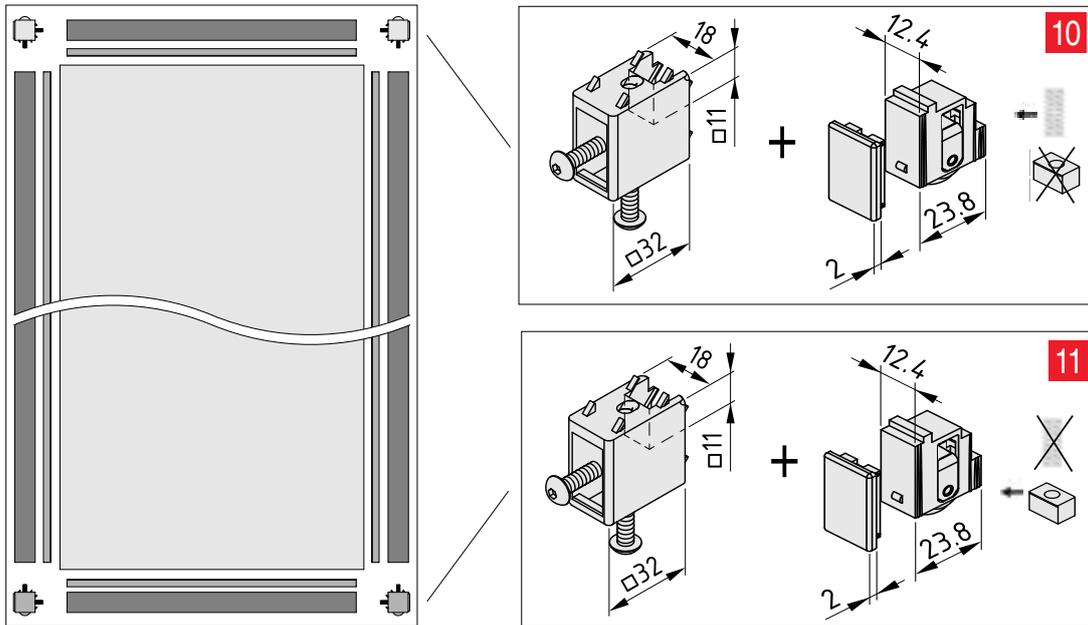


The panel element can optionally be held in place in the special groove of the profile with the help of clamping springs (0.0.406.21).

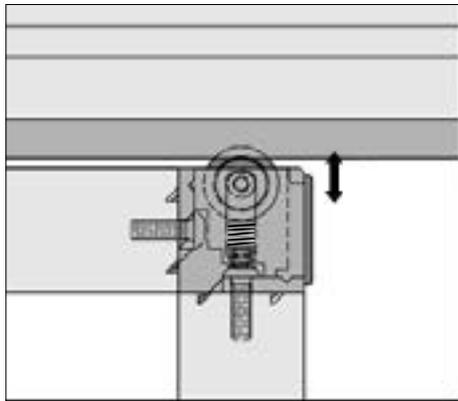
This increases the resistance against the enclosed panel being pressed out. The level of resistance depends on the number of clamping springs used.

In this case, too, ensuring the panel and springs are positioned as shown in the picture is crucial when it comes to the sliding door's functionality.

3. Roller for Corner-Fastener 8 32x18



Now slide the Rollers for Corner-Fastener 8 32x18 (0.0.494.74) into the Corner-Fastening Sets Clamp-Profile 8 32x18 (0.0.494.73) already fitted, the top ones with a spring and the bottom ones with a fixing block.



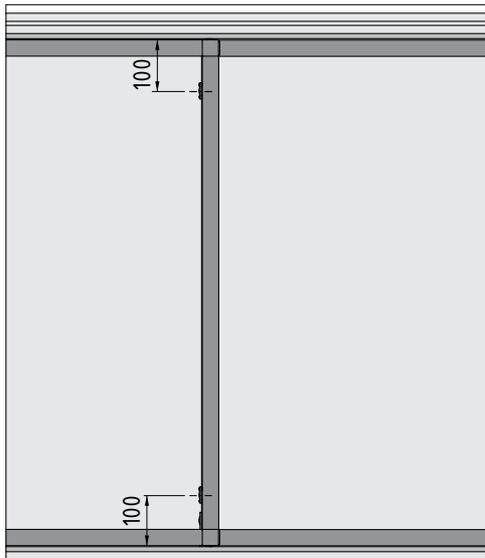
The door can be retrofitted into the frame with the help of the spring-loaded corner elements at the top.

Installing Sliding Door 8 32x18, Catch **3**

Sliding door **A B**

1. Sliding Door 8 32x18, Catch





The T-slot nuts are already in place. Fix the catches in place approx. 100 mm from the top and bottom edges of the sliding door.



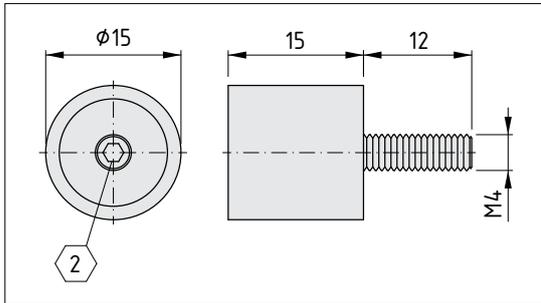
Securing the catch in place:

Key width: 5 A/F

Tightening torque: $M_T = 8 \text{ Nm}$

Installing Impact Buffer D15x15 M4x12 **4**

Sliding door **B**



Fasten Impact Buffer D15x15 M4x12 by hand on the inside of the sliding door.

Installing Sliding Door 8 32x18, Fixing Plate **5**

Sliding door **B**



The T-slot nut was slid into place earlier, when the sliding door was assembled.

When required, the fixing plate can be pushed into the hole drilled in Sliding-Door Guide Profile 8 40x10 to immobilise the door segment.



Insert the anti-torsion feature into the fixing plate.



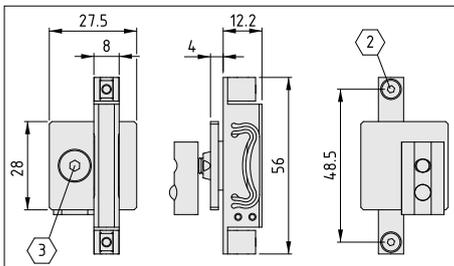
Then secure the fixing plate in place using the flat head screw.

Key width: 5 A/F

Tightening torque: $M_T = 8 \text{ Nm}$

Installing Sliding Door Magnetic Catch 8 **6**

Sliding door **A C**



Fasten the magnetic catches in the groove of Clamp Profile 8 32x18 and on the frame of the construction. Their position can be adjusted at any time by moving them along the groove.



Mark the position of the installed metal plate on the profile located opposite.

Key width: 3 A/F

Tightening torque: $M_T = 8 \text{ Nm}$



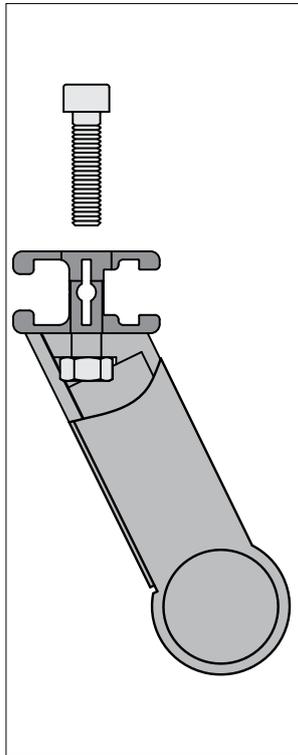
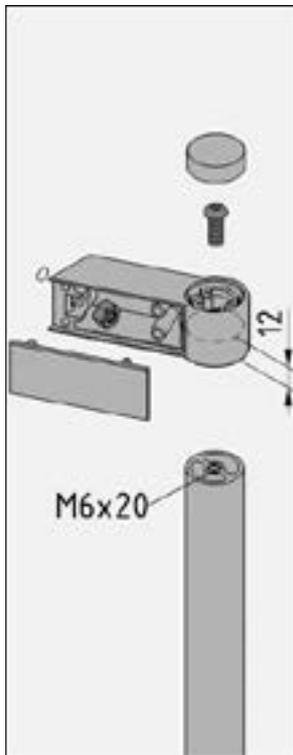
Then secure the magnet in place in the profile groove at the marking.

Key width: 2 A/F

Tightening torque: $M_T = 1 \text{ Nm}$

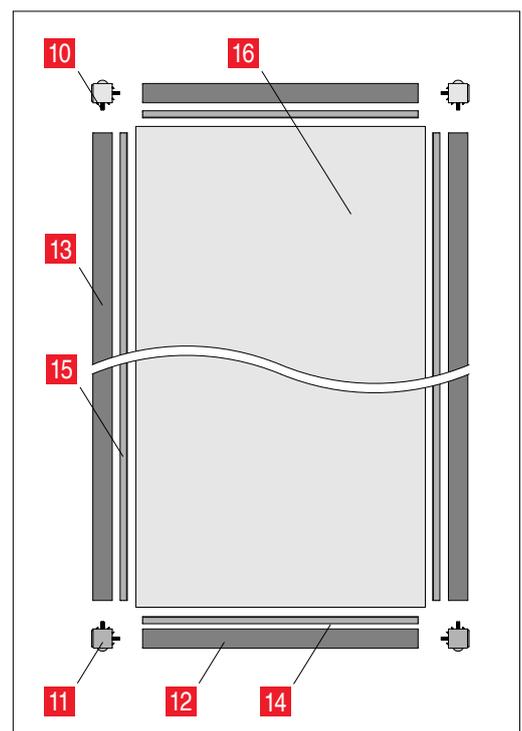
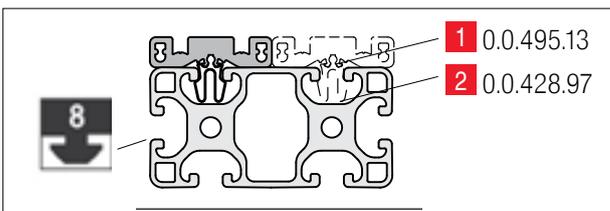
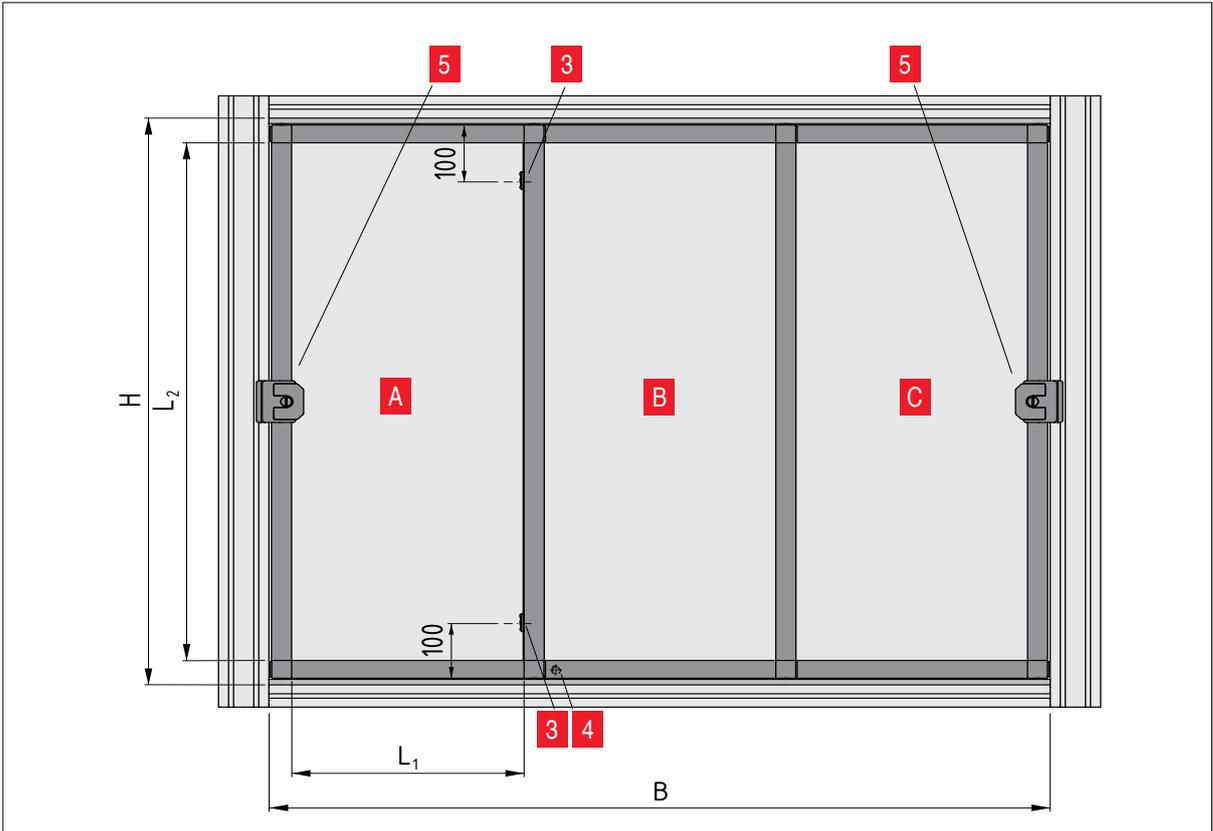
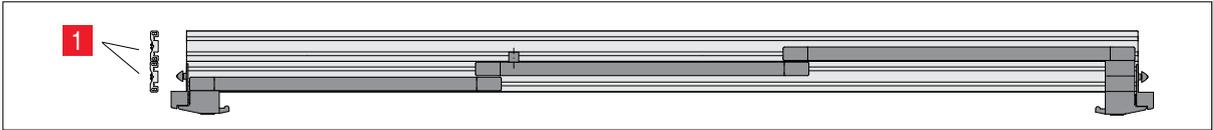
Assembling the handle - Hand Grip Element X D25 and Profile D25 **7 8**

Sliding door **A C**

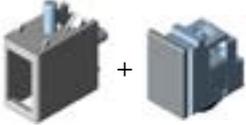


Screw on the handle through the stepped hole in Clamp Profile 8 32x18.
The profile must be machined before assembling the sliding door.
Hexagon socket head cap screw: M6x30
Tightening torque: $M_T = 4 \text{ Nm}$

Variant II – three sliding-door segments with sliding-door lock



General basic structure				
No.	Article	Quantity	Description	Illustration
1	0.0.495.13	4	Length = B [mm] - 2 mm	
2	0.0.428.97	Quantity = W [mm] / 200 (rounded off, per profile)		
3	0.0.717.55	2		
4	0.0.719.02	1	Optional, to protect against crushing	
5	0.0.715.40	2		
	0.0.717.19	2		

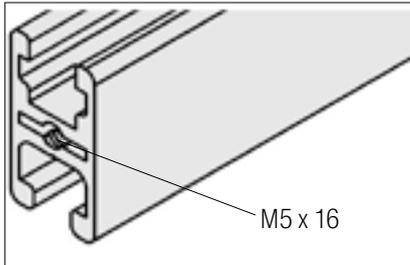
General structure for one sliding-door segment				
No.	Article	Quantity	Description	Illustration
10 * 11 *	0.0.494.73 + 0.0.494.74	4		
12	0.0.373.67	2	$L_1 = (B - 133) / 3$	
13	0.0.373.67	2	$L_2 = H - 88.5$	
14	0.0.489.91	2	$L_1 = ((B - 133) / 3) \times 1.05$	
15	0.0.489.91	2	$L_2 = (H - 88.5) \times 1.05$	
16	-	1	Panel: 4 mm - 6 mm Panel width = $L_1 + 22$ mm Panel height = $L_2 + 22$ mm	

* Rollers for Corner-Fastener 8 32x18 (0.0.494.74) are subsequently slid into the Corner-Fastening Sets Clamp-Profile 8 32x18 (0.0.494.73), the top ones with a spring and the bottom ones with a fixing block.

Sliding-door machining processes

Profile machining of Clamp Profile 8 32x18 **12** **13**

Sliding door **A** **B** **C**



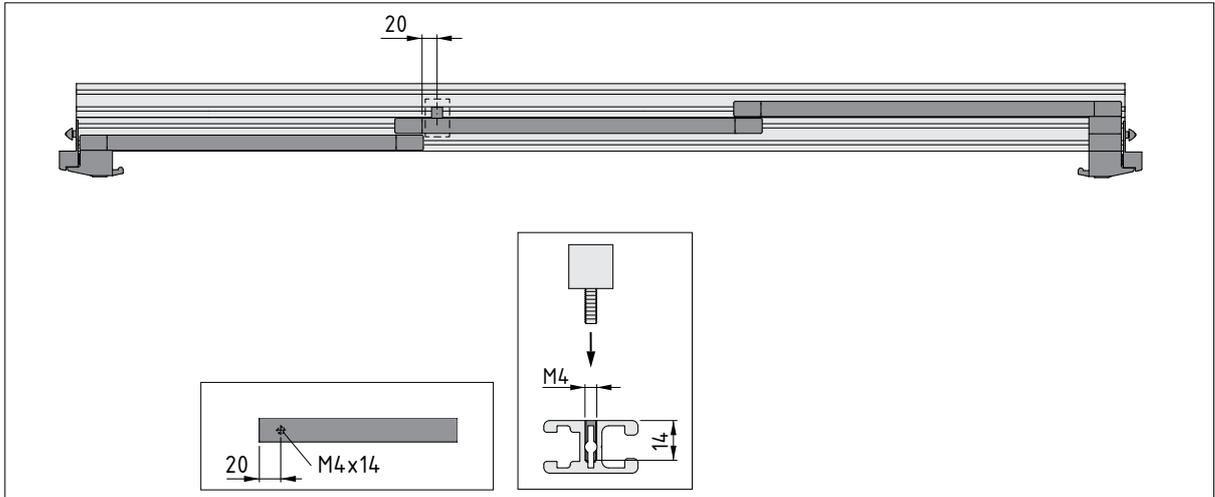
Tap an M5x16 thread at the ends of all Clamp Profiles 8 32x18.

Profile machining of Clamp Profile 8 32x18 **12** for impact buffer **4**

Sliding door **B**

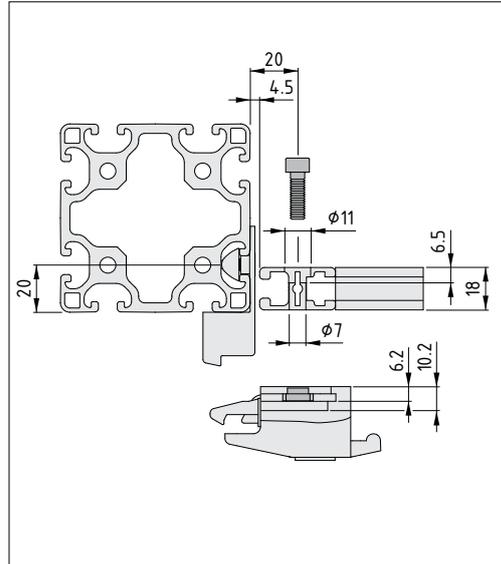
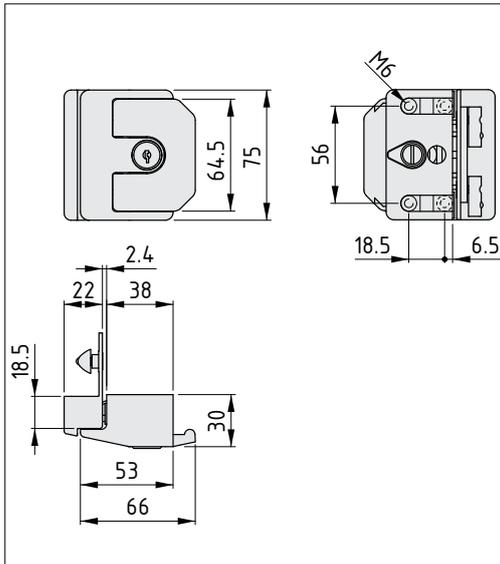


Machine the profile (0.0.373.67) before assembling the sliding door.

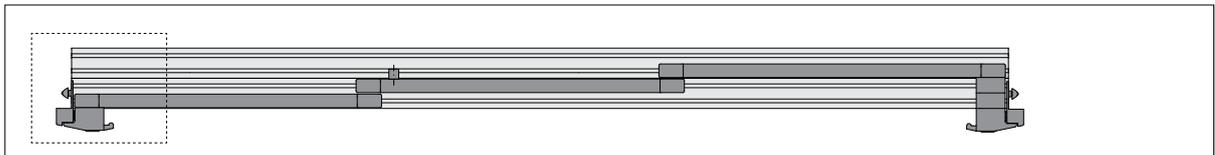


Profile machining of Clamp Profile 8 32x18 **13** for lock **5**

Sliding door **A**

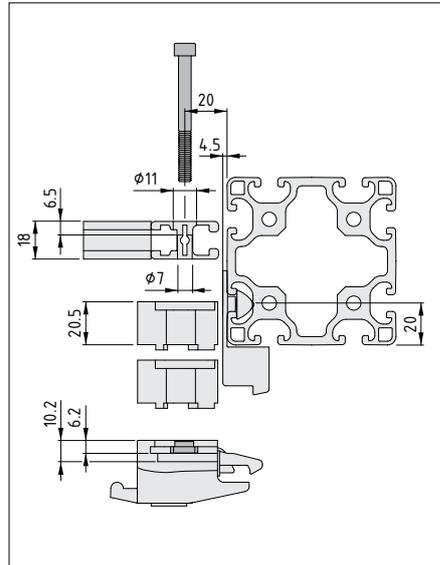
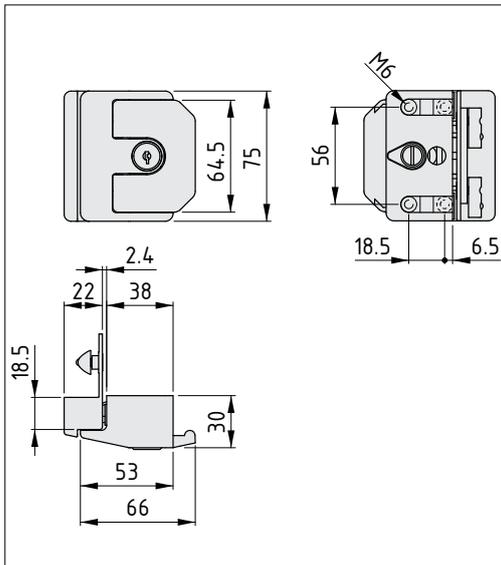


Clamp Profile 8 32x18 must be machined before assembling the sliding door.
Any position can be selected for the lock – the through holes are spaced 56 mm apart.

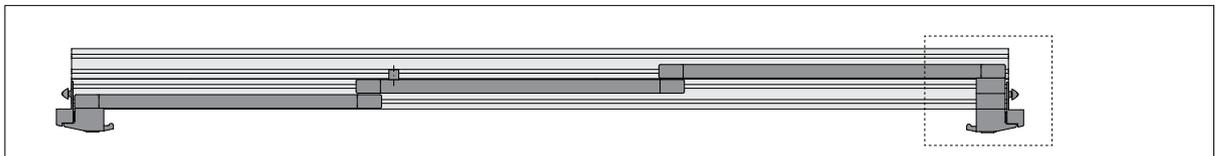


Profile machining of Clamp Profile 8 32x18 **13** for lock **5**

Sliding door **C**



Clamp Profile 8 32x18 must be machined before assembling the sliding door.
 Any position can be selected for the lock – the through holes are spaced 56 mm apart.
 The lock of sliding door **C** must fill the gap to the frame with the help of spacers.

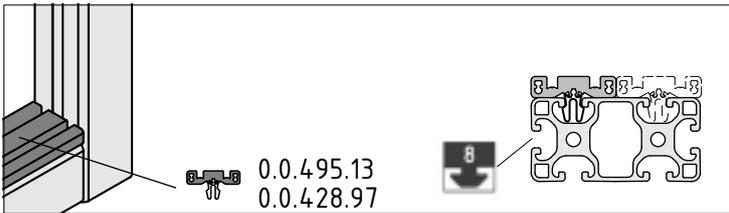


Assembly



Assembly can start once all clamp profiles have been machined and the necessary T-slot nuts have been inserted.

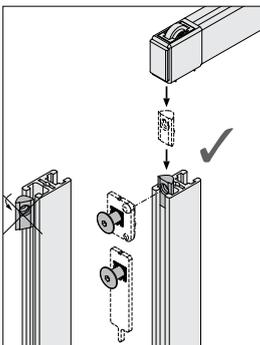
Assembling Sliding-Door Guide Profile 8 40x10 **1** **2**



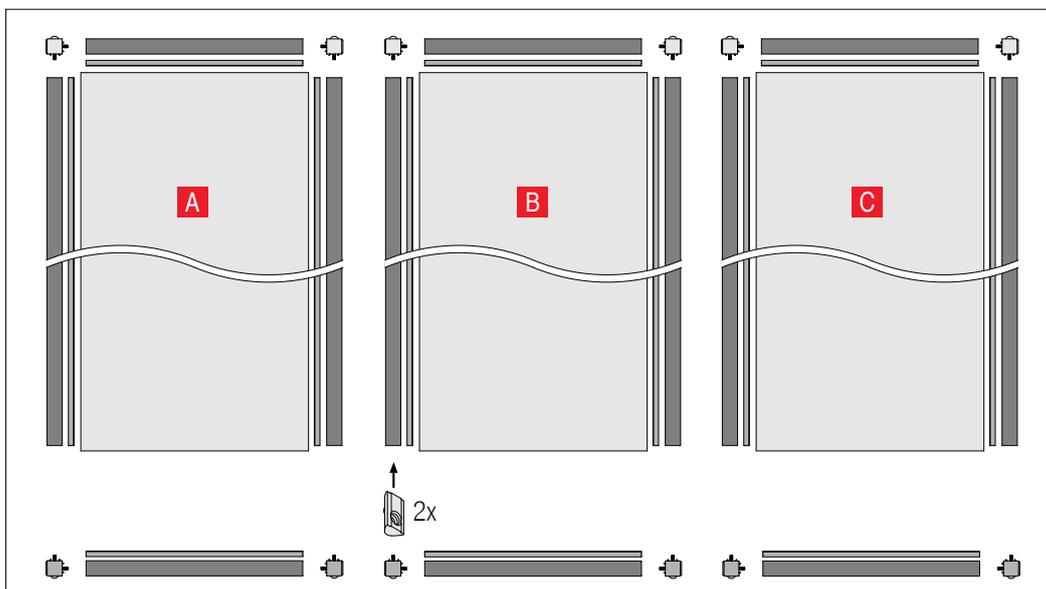
Thread Clips 8 St (0.0.428.97) onto the sliding-door profiles (0.0.495.13) approx. 200 mm apart and then press them by hand into the Line 8 groove geometry.

Assembling the sliding door

Sliding door **A** **B** **C**



Any T-slot nuts that are needed in Clamp Profiles 8 32x18 must be slid in before the sliding door is assembled. It is not possible to swivel them into place afterwards.



1. Corner fastener



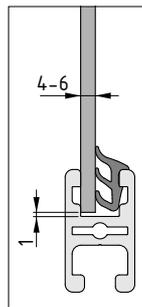
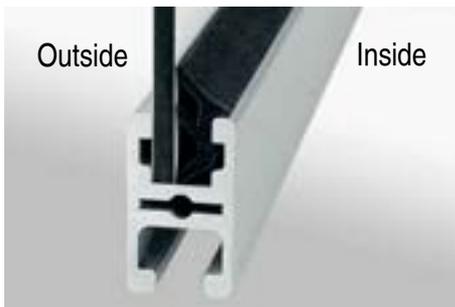
Using Corner-Fastening Sets Clamp-Profile 8 32x18 (0.0.494.73), connect together Clamp Profiles 8 32x18 to create a frame that encompasses the panel.

Make sure you arrange the profile grooves as shown in the picture.

Key width: 3 A/F

Tightening torque: $M_T = 4.5 \text{ Nm}$

2. Panel fixing

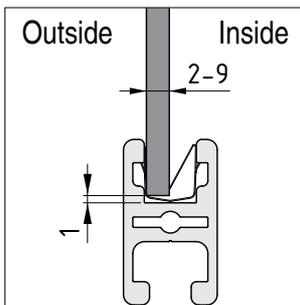


Next, lie the panel down, position it centrally in the frame and secure it in place with the lip seal (0.0.489.91).

Lip seals are fitted on the inside, which pushes the panel outwards. Cut lip seals a few millimetres longer than required, as they contract again slightly when fitted.

Tip: Lip Seal 8 4-6 mm

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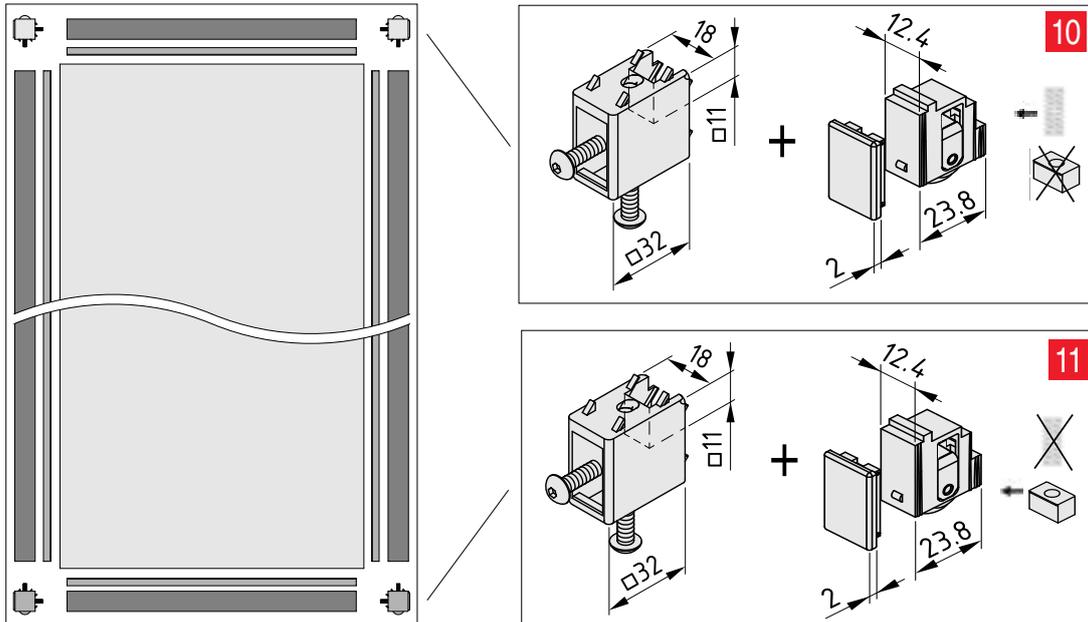


The panel element can optionally be held in place in the special groove of the profile with the help of clamping springs (0.0.406.21).

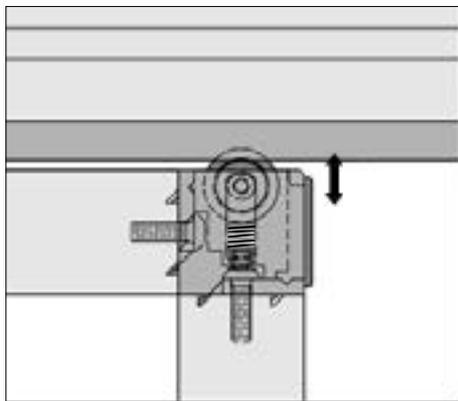
This increases the resistance against the enclosed panel being pressed out. The level of resistance depends on the number of clamping springs used.

In this case, too, ensuring the panel and springs are positioned as shown in the picture is crucial when it comes to the sliding door's functionality.

3. Roller for Corner-Fastener 8 32x18



Now slide the Rollers for Corner-Fastener 8 32x18 (0.0.494.74) into the Corner-Fastening Sets Clamp-Profile 8 32x18 (0.0.494.73) already fitted, the top ones with a spring and the bottom ones with a fixing block.



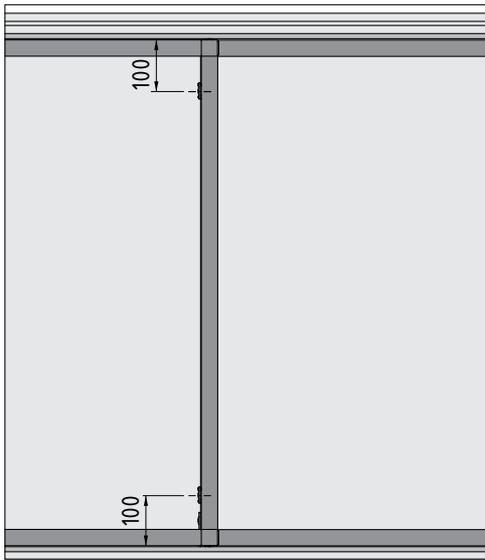
The door can be retrofitted into the frame with the help of the spring-loaded corner elements at the top.

Installing Sliding Door 8 32x18, Catch **3**

Sliding door **A B**

1. Sliding Door 8 32x18, Catch





The T-slot nuts are already in place. Fix the catches in place approx. 100 mm from the top and bottom edges of the sliding door.



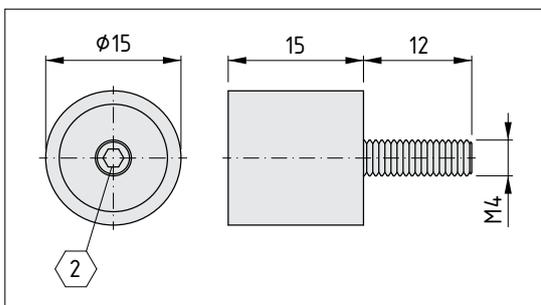
Securing the catch in place:

Key width: 5 A/F

Tightening torque: $M_T = 8 \text{ Nm}$

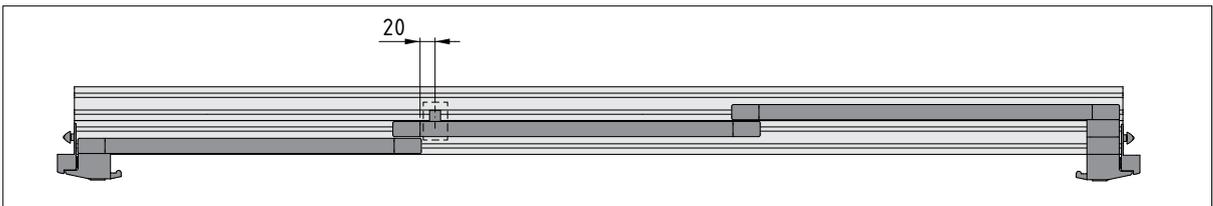
Installing Impact Buffer D15x15 M4x12 **4**

Sliding door **B**



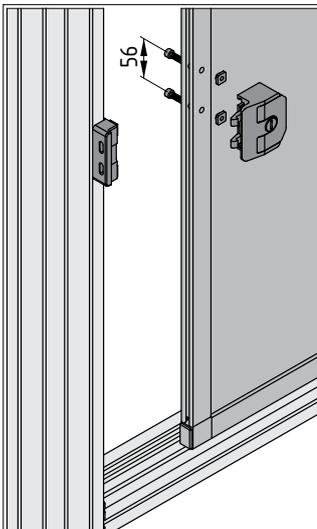


Fasten Impact Buffer D15x15 M4x12 (0.0.719.02) by hand on the inside of the sliding door.



Installing Sliding-Door Lock 8 **5**

Sliding door **A**

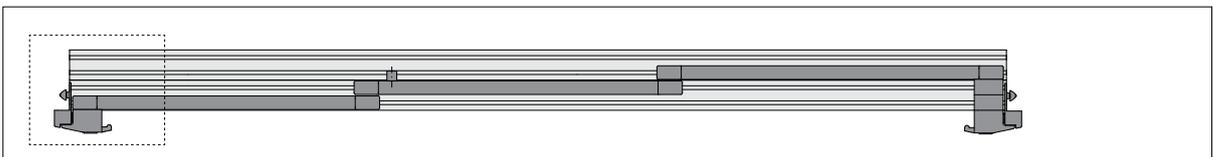


Clamp Profile 8 32x18 must be machined before assembling the sliding door.

After installation, the lock can be adjusted at right angles to the direction of the groove, while the lock case on the frame profile can be adjusted in the direction of the groove.

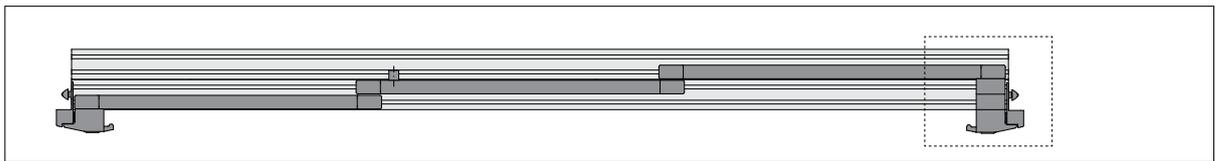
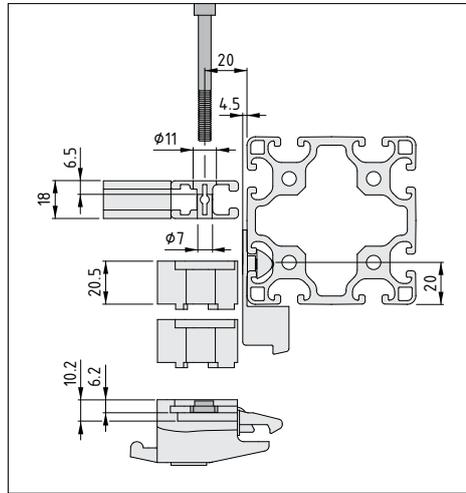
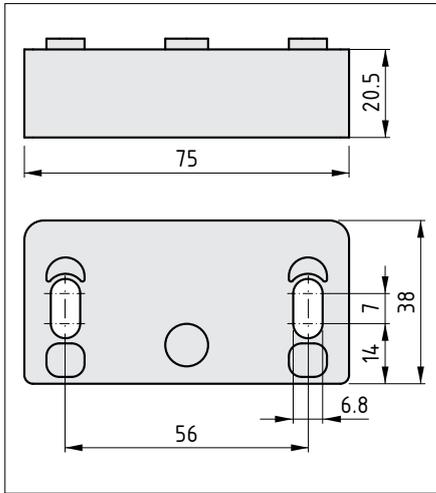
Fixing for locking piece:
 Countersunk Screws DIN 7991
 M5x12
 Key width: 3 A/F
 Tightening torque: $M_T = 8 \text{ Nm}$

Fixing for sliding-door lock:
 Hexagon Socket Head Cap Screws
 DIN 912 M6
 Key width: 5 A/F
 Tightening torque: $M_T = 10 \text{ Nm}$



Installing sliding-door lock and Spacer 8 32x18 **5**

Sliding door **C**



Clamp Profile 8 32x18 must be machined before assembling the sliding door.

The lock of sliding door **C** must fill the gap to the frame with the help of spacers. The number of spacers determines the lengths of the screws. After installation, the lock can be adjusted at right angles to the direction of the groove, while the lock case on the frame profile can be adjusted in the direction of the groove.

Fixing for locking piece:

Countersunk Screws DIN 7991 M5x12

Key width: 3 A/F

Tightening torque: $M_T = 8 \text{ Nm}$

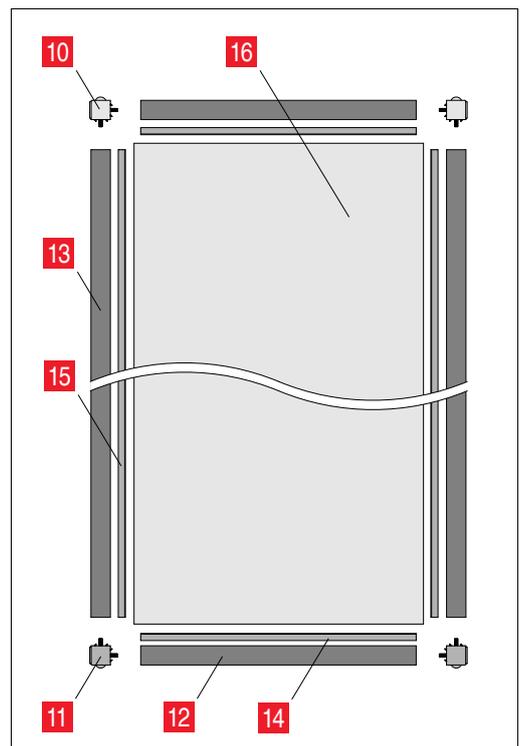
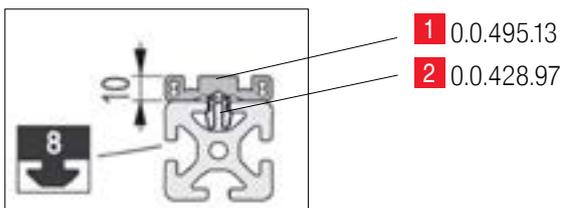
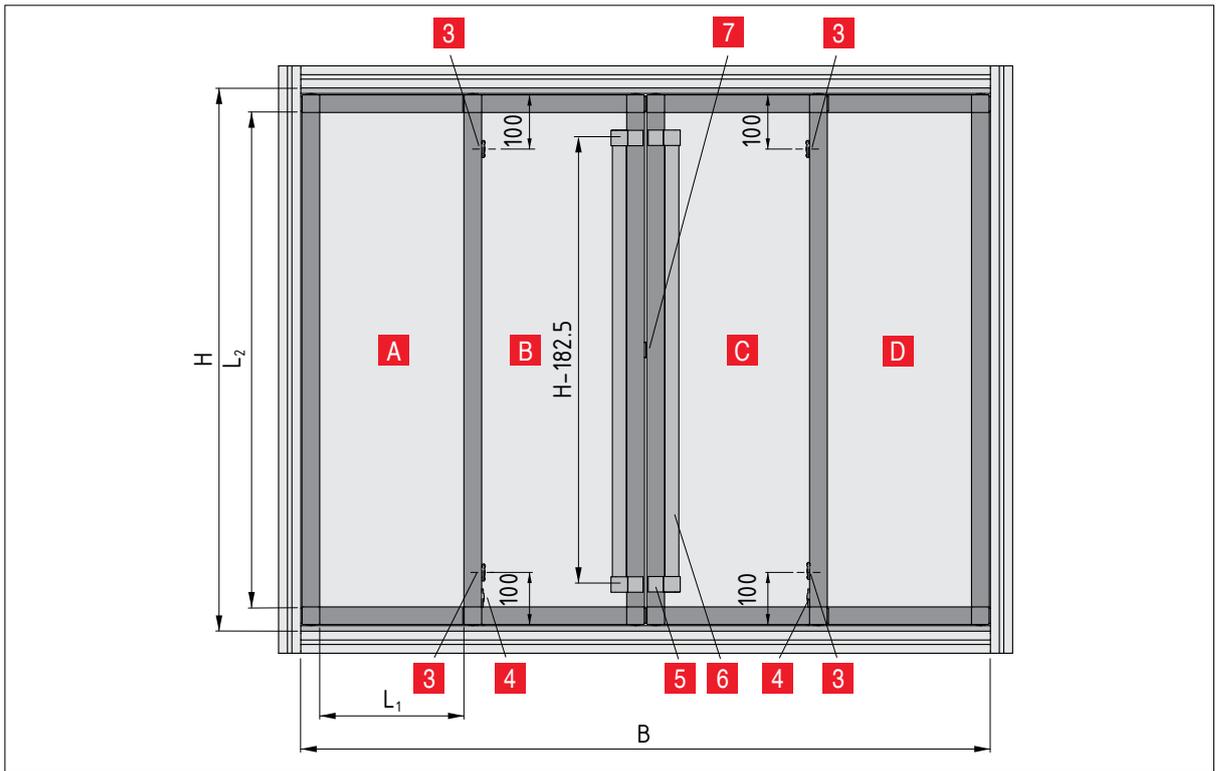
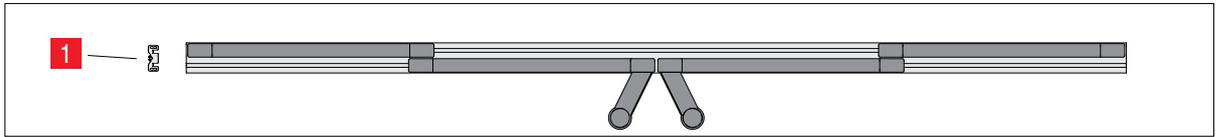
Fixing for sliding-door lock:

Hexagon Socket Head Cap Screws DIN 912 M6

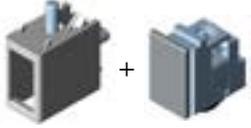
Key width: 5 A/F

Tightening torque: $M_T = 10 \text{ Nm}$

Variant III – four sliding-door segments with handle, magnetic catch and optional fixing plates



General basic structure				
No.	Article	Quantity	Description	Illustration
1	0.0.495.13	2	Length = B [mm] - 2 mm	
2	0.0.428.97	Quantity = W [mm] / 200 (rounded off, per profile)		
3	0.0.717.55	4		
4	0.0.717.57	2	Optional fixing plate on both sides	
5	0.0.601.65	4		
6	0.0.601.63	2	H [mm] - 182.5 mm	
7	0.0.718.40			

General structure for one sliding-door segment				
No.	Article	Quantity	Length	Description
10 * 11 *	0.0.494.73 + 0.0.494.74	4		
12	0.0.373.67	2	$L_1 = 0,25 \times B - 49,25$	
13	0.0.373.67	2	$L_2 = H - 88,5$	
14	0.0.489.91	2	$L_1 = (0,25 \times B - 49,25) \times 1,05$	
15	0.0.489.91	2	$L_2 = (H - 88,5) \times 1,05$	
16	-	1	Panel: 4 mm - 6 mm Panel width = $L_1 + 22$ mm Panel height = $L_2 + 22$ mm	

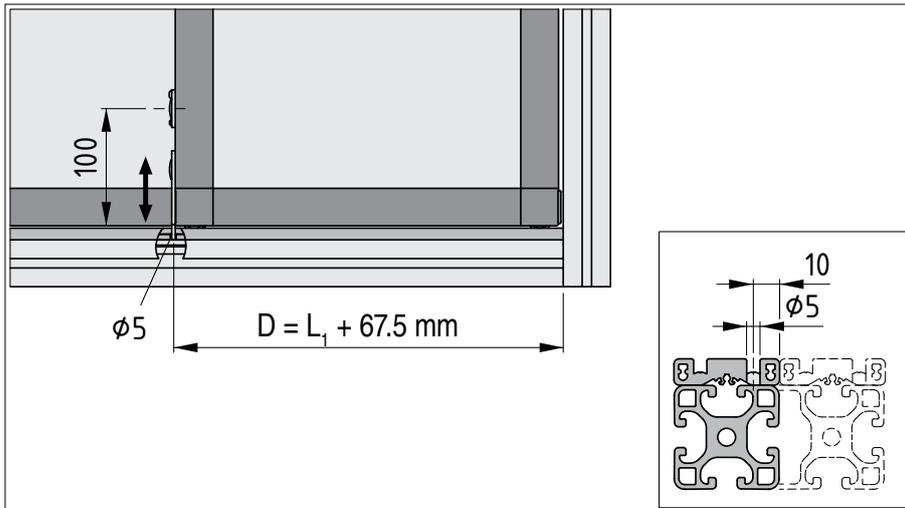
* Rollers for Corner-Fastener 8 32x18 (0.0.494.74) are subsequently slid into the Corner-Fastening Sets Clamp-Profile 8 32x18 (0.0.494.73), the top ones with a spring and the bottom ones with a fixing block.

Profile machining processes



Machine all profiles prior to assembly.

Profile machining of Sliding-Door Guide Profile 8 40x10 **1** for fixing plate **4**



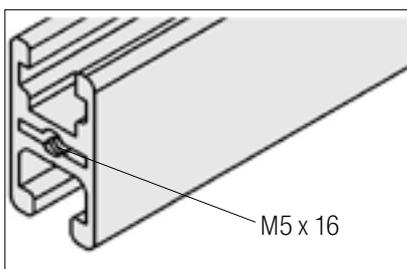
Drill two holes in Sliding-Door Guide Profile 8 40x10 for the fixing plate.



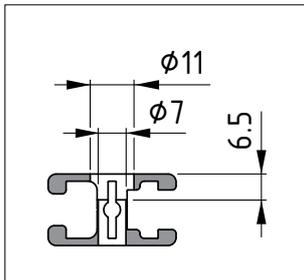
The distance D applies from both the right-hand and left-hand sides of the frame.

Profile machining of Clamp Profile 8 32x18

Sliding door **A B C D**

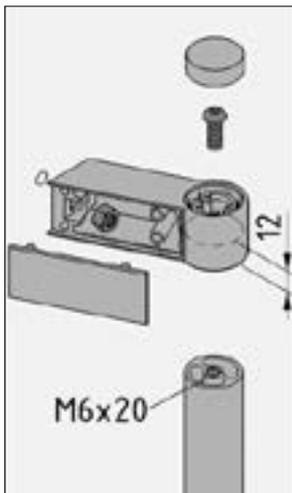


Tap an M5x16 thread at the ends of all Clamp Profiles 8 32x18.

Profile machining of Clamp Profile 8 32x18 **13** for handle **6 7**Sliding door **B C**

Drill two holes in each of the Clamp Profiles 8 32x18 to which the door handles are to be fastened. Distance apart: H - 178.5 mm.

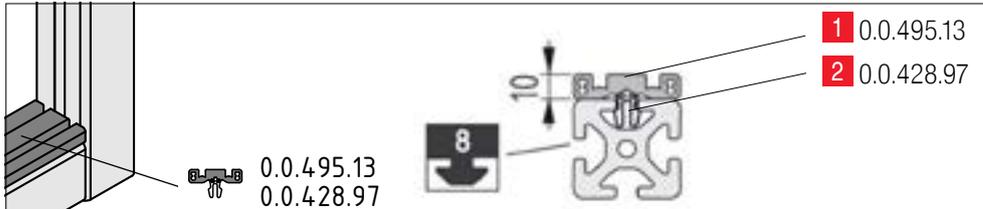
Tip: Use the relevant step drill (0.0.431.20).



Tap an M6x20 thread at both ends of Profile D25 (0.0.601.23).

Assembly

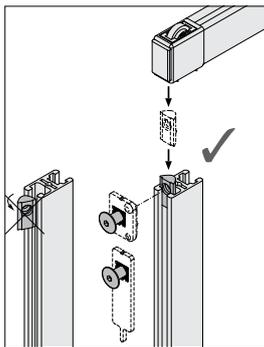
Assembling Sliding-Door Guide Profile 8 40x10 **1** **2**



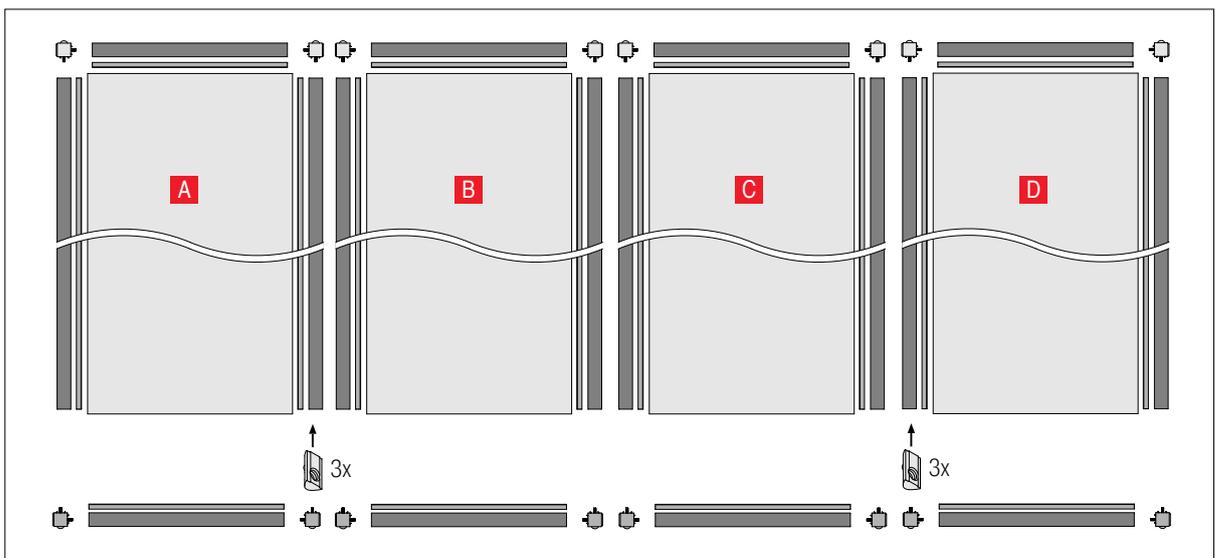
Thread Clips 8 St (0.0.428.97) onto the sliding-door profiles (0.0.495.13) approx. 200 mm apart and then press them by hand into the Line 8 groove geometry.

Assembling the sliding door

Sliding door **A** **B** **C** **D**



Any T-slot nuts that are needed in Clamp Profiles 8 32x18 must be slid in before the sliding door is assembled. It is not possible to swivel them into place afterwards.



1. Corner fastener



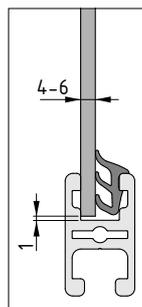
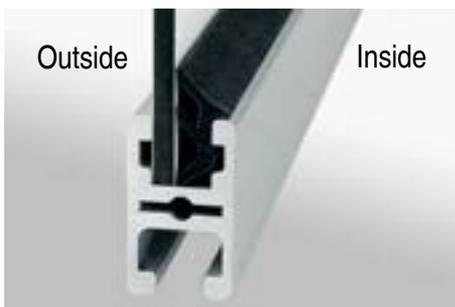
Using Corner-Fastening Sets Clamp-Profile 8 32x18 (0.0.494.73), connect together Clamp Profiles 8 32x18 to create a frame that encompasses the panel.

Clamp Profile 8 32x18 has two different grooves. Make sure you arrange the profile grooves as shown in the picture.

Key width: 3 A/F

Tightening torque: $M_T = 4.5 \text{ Nm}$

2. Panel fixing

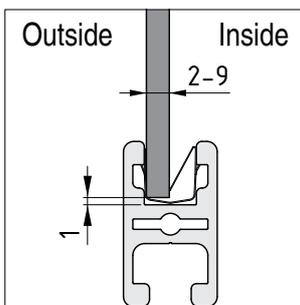


Next, lie the panel down, position it centrally in the frame and secure it in place with the lip seal (0.0.489.91).

Lip seals are fitted on the inside, which pushes the panel outwards. Cut lip seals a few millimetres longer than required, as they contract again slightly when fitted.

Tip: Lip Seal 8 4-6 mm

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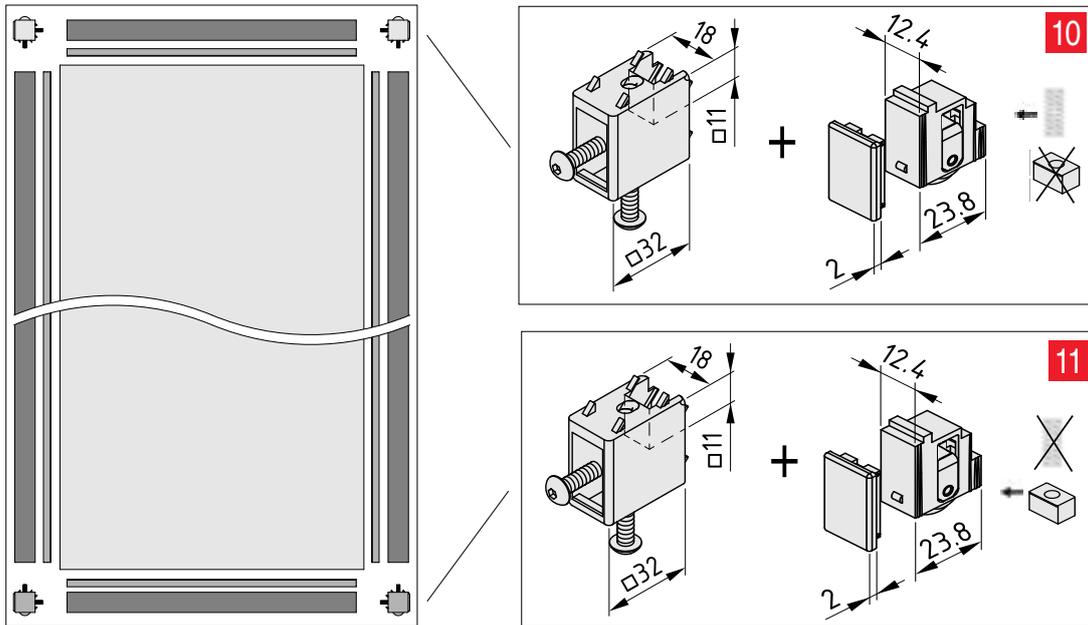


The panel element can optionally be held in place in the special groove of the profile with the help of clamping springs (0.0.406.21).

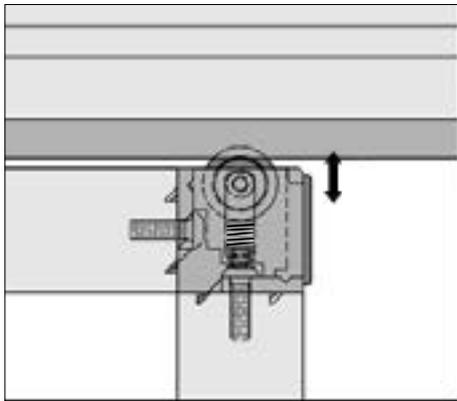
This increases the resistance against the enclosed panel being pressed out. The level of resistance depends on the number of clamping springs used.

In this case, too, ensuring the panel and springs are positioned as shown in the picture is crucial when it comes to the sliding door's functionality.

3. Roller for Corner-Fastener 8 32x18



Now slide the Rollers for Corner-Fastener 8 32x18 (0.0.494.74) into the Corner-Fastening Sets Clamp-Profile 8 32x18 (0.0.494.73) already fitted, the top ones with a spring and the bottom ones with a fixing block.



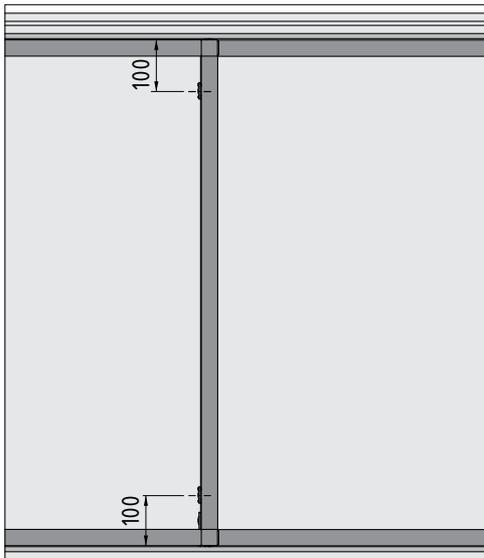
The door can be retrofitted into the frame with the help of the spring-loaded corner elements at the top.

Installing Sliding Door 8 32x18, Catch **3**

Sliding door **A D**

1. Sliding Door 8 32x18, Catch





The T-slot nuts are already in place. Fix the catches in place approx. 100 mm from the top and bottom edges of the sliding door.



Securing the catch in place:

Key width: 5 A/F

Tightening torque: $M_T = 8 \text{ Nm}$

Installing Sliding Door 8 32x18, Fixing Plate **4**

Sliding door **A D**



The T-slot nut was slid into place earlier, when the sliding door was assembled.

When required, the fixing plate can be pushed into the hole drilled in Sliding-Door Guide Profile 8 40x10 to immobilise the door segment.



Insert the anti-torsion feature into the fixing plate.

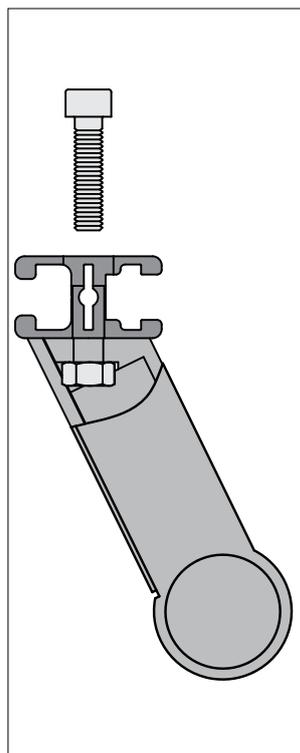
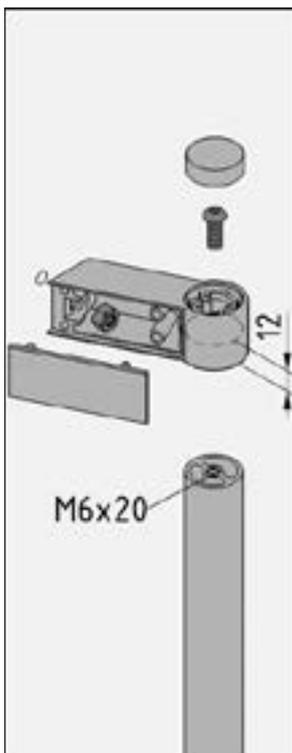


Then secure the fixing plate in place using the flat head screw.

Key width: 5 A/F

Tightening torque: $M_T = 8 \text{ Nm}$

Assembling the handle comprising Hand Grip Element X D25 and Profile D25 **5 6**
Sliding door **B C**



Screw on the handle through the stepped hole in Clamp Profile 8 32x18.

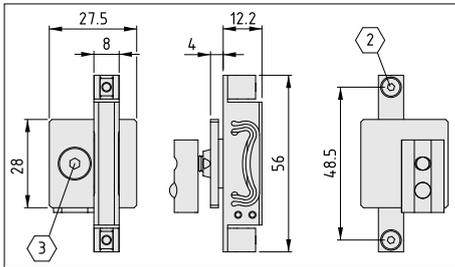
The profile must be machined before assembling the sliding door.

Hexagon socket head cap screw: M6x30

Tightening torque: $M_T = 4 \text{ Nm}$

Installing Sliding Door Magnetic Catch 8 **7**

Sliding door **B C**



Fasten the magnetic catches in the groove of Clamp Profile 8 32x18 and on the frame of the construction. Their position can be adjusted at any time by moving them along the groove.



Mark the position of the installed metal plate on the profile located opposite.

Key width: 3 A/F

Tightening torque: $M_T = 8 \text{ Nm}$



Then secure the magnet in place in the profile groove at the marking.

Key width: 2 A/F

Tightening torque: $M_T = 1 \text{ Nm}$

item

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