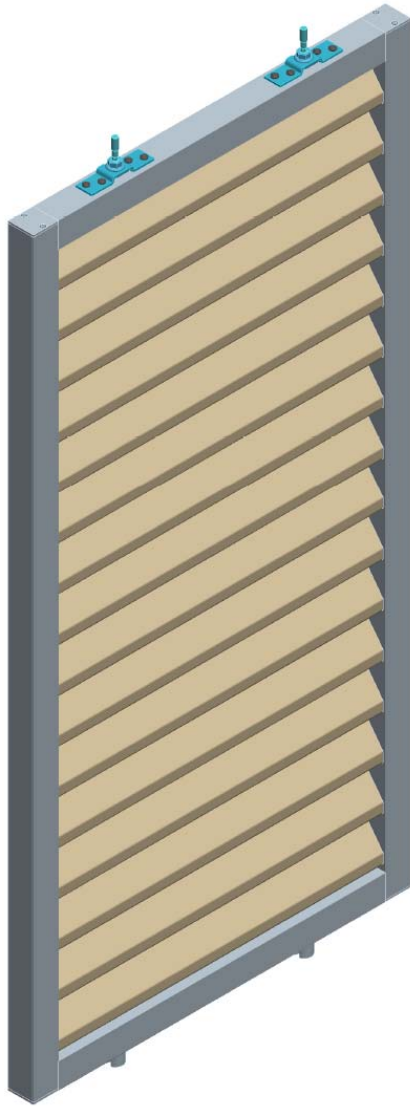
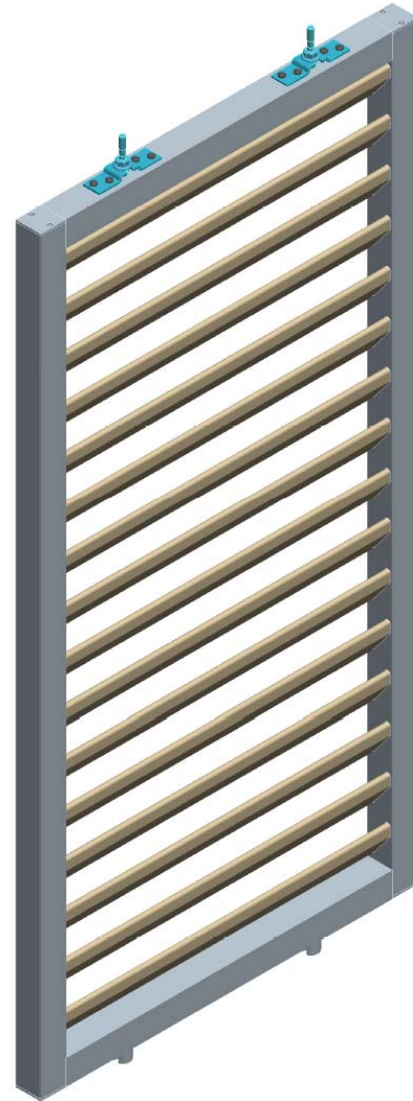


DucoSlide LuxFrame 40/40 Wood

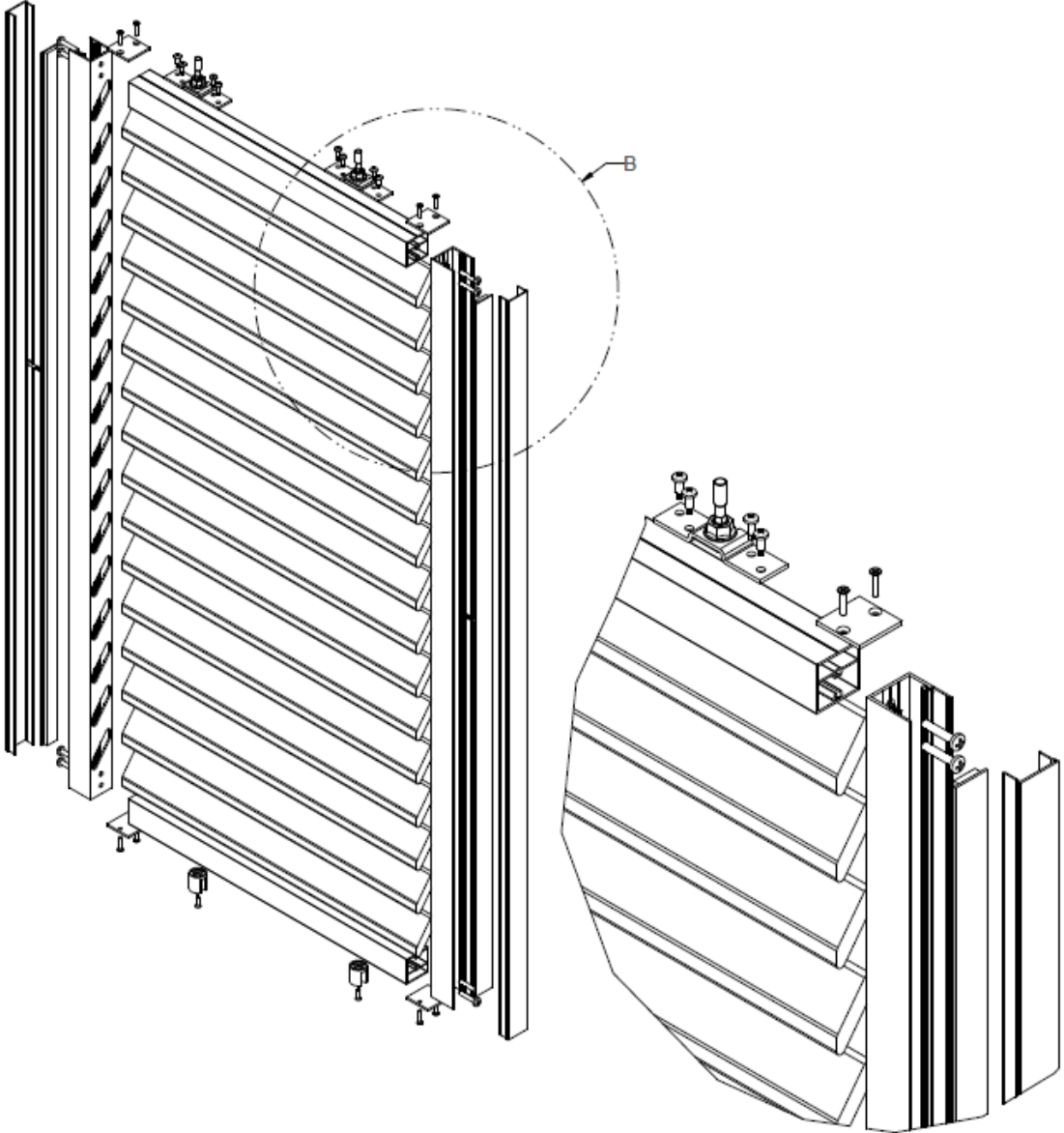
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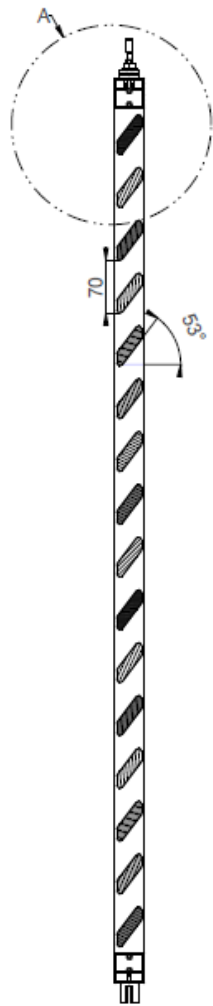


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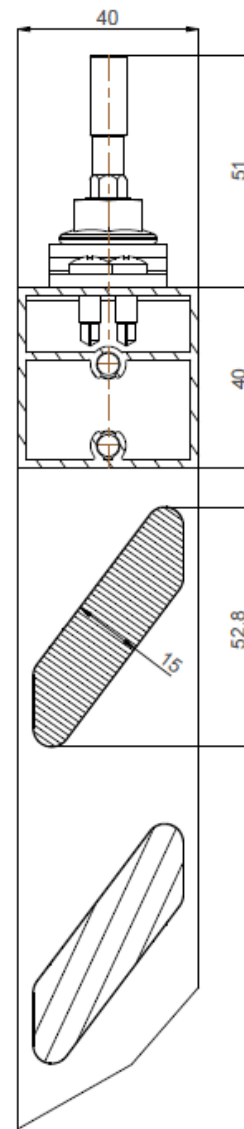
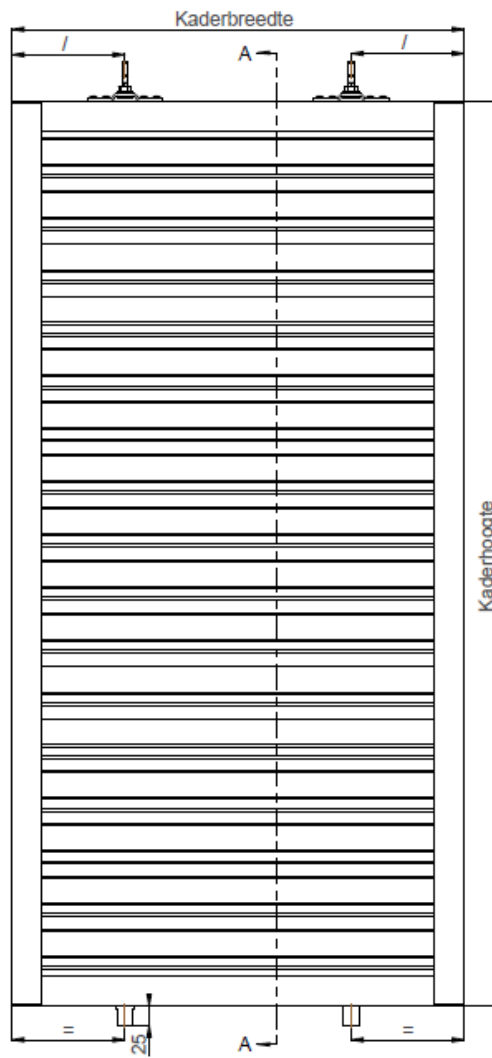


Exploded view



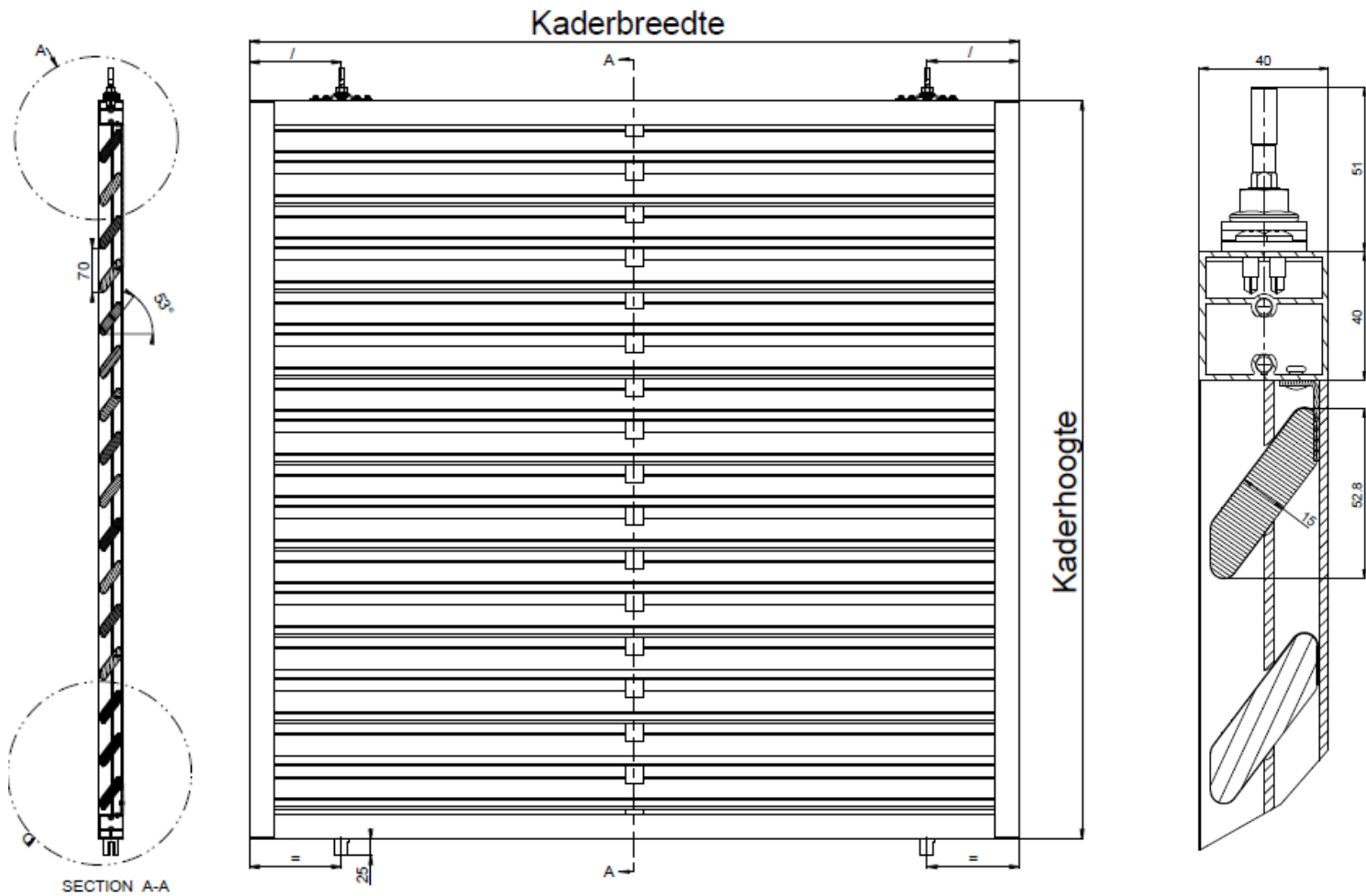


SECTION A-A

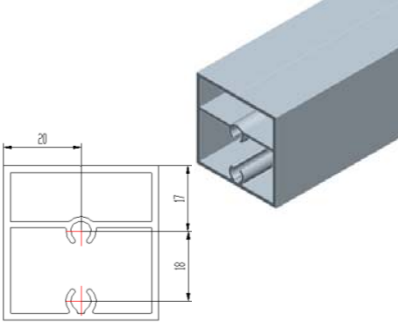
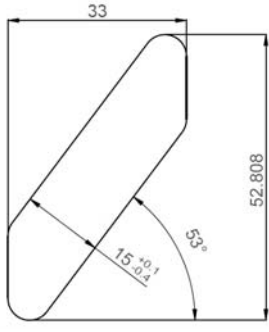
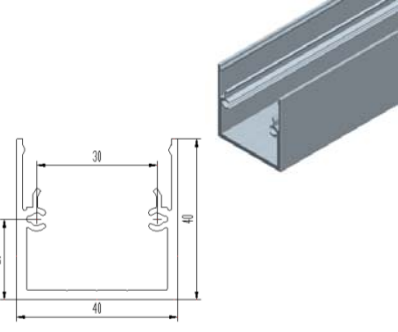
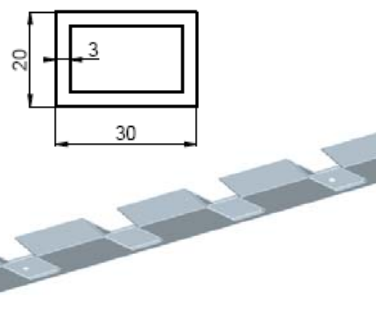
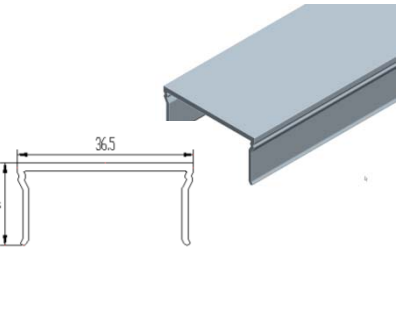
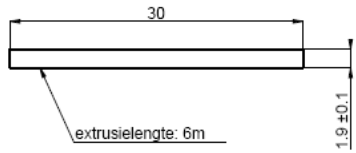


A(0.750)







(with reinforcement profile)



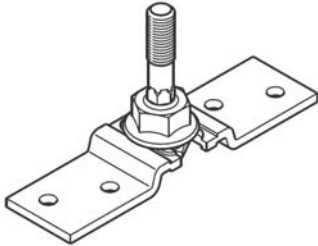


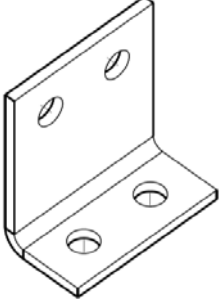
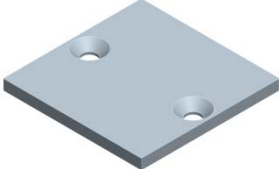
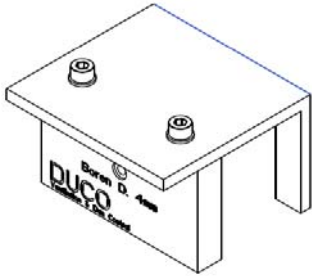
Parts list

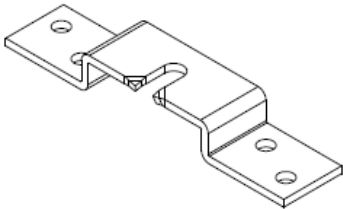
<p>Profile upper/lower side Lux 40/40</p> <p>Code: P14066-10</p> <p>Cut dimension: frame width - 80mm</p>		<p>Lux 40 Wood (Western Red Cedar)</p> <p>Code: P15156-10</p> <p>Cut dimension: frame width - 49mm</p>	
<p>Lux 40/40 series laser cut stile</p> <p>Code: T14072-29 - Links T14072-30 - Rechts</p> <p>Cut dimension: frame height - 6mm</p>		<p>Lux 40 Wood Reinforcement profile</p> <p>Code: T15164-12</p> <p>Cut dimension: frame height - 80mm</p>	
<p>Stile cover (40 x 17)</p> <p>Code: P14073-10</p> <p>Cut dimension: frame height - 6mm</p>		<p>Flat profile 30x1,9</p> <p>Code: P10739-10</p> <p>Cut dimension: frame height - 90mm</p>	

Parts list

<p>Thread-forming screw : DIN 7500 Form C, M6 x 30, A2 stainless steel Pan head with PZ 3 drive</p> <p>Code : G0100525</p> <p>(Needed for fixing the frame)</p>		<p>Self-drilling screw : DIN 7504 Form M, 4.8 x 16, A2 stainless steel Pan head with PH 2 drive</p> <p>Code : G0000227</p> <p>(Needed for fixing the suspension bracket)</p>	
<p>Thread-forming screw : DIN 7500 Form M, M4 x 20, A2 stainless steel Countersunk head with PZ 2 drive</p> <p>Code : G0100526</p> <p>(Needed for fixing the cover plates.)</p>		<p>Woodscrew : 3.5 x 16, A2 stainless steel Countersunk head with PZ 2 drive</p> <p>Code : G0100671</p> <p>(Needed for fixing the louvre blades to the U-section.)</p>	
<p>Woodscrew : 4 x 35, A2 stainless steel Pan head with PZ 2 drive</p> <p>Code : G0100670</p> <p>(Needed for fixing the frame in the middle.)</p>		<p>Self-drilling screw : DIN 7504 Form O, M3.9 x 19, A2 stainless steel Countersunk head with PH 2 drive</p> <p>Code : G0100528</p> <p>(Needed for fixing the bottom guide.)</p>	

Parts list

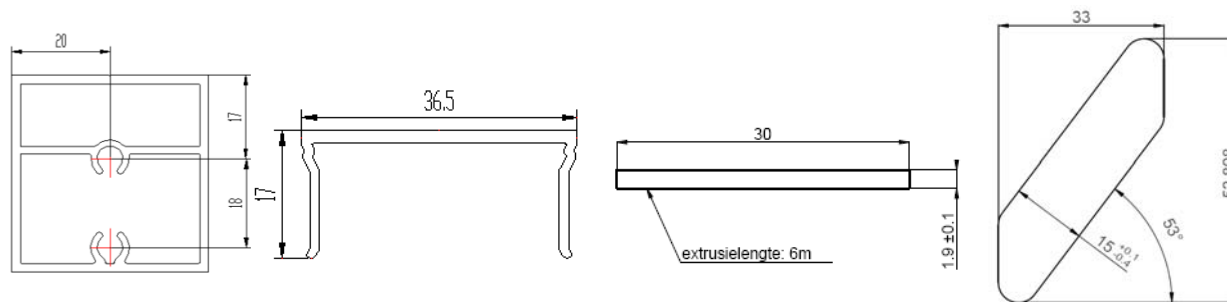
<p>Top rail suspension bracket 30/47/3 & 30/60/3</p> <p>Code : G0013031</p>		<p>Neoprene tape 20 x 5 mm</p> <p>Code: G0100641</p>	
<p>Bottom guide base Ø 25 mm</p> <p>Code: G0100700</p>		<p>L-profile 25x12x1.5</p> <p>Code: G0100675</p>	
<p>Cover plate (40 x 40 x 3)</p> <p>Code: G0100522</p>		<p>Drilling bloc Lux 40 Wood</p> <p>Code: K0001745</p>	

<p>Top fixing plate frame for top track 31/33/2</p> <p>Code: G0013080</p>			

Assembly preparation

Cutting to length

1. Cut both the top and the bottom rail (**P14066-10**) to fit the required “frame width - 80 mm”.
2. Cut the stile cover (**P14073-10**) to fit the required “frame height - 6 mm”.
3. Cut the 30 x 1.9 PVC strip (**P1073910**) to fit the required “frame height - 90 mm”.
4. Cut the timber blade 70-15 (**P1515610**) to fit the required “frame width - 49 mm”.

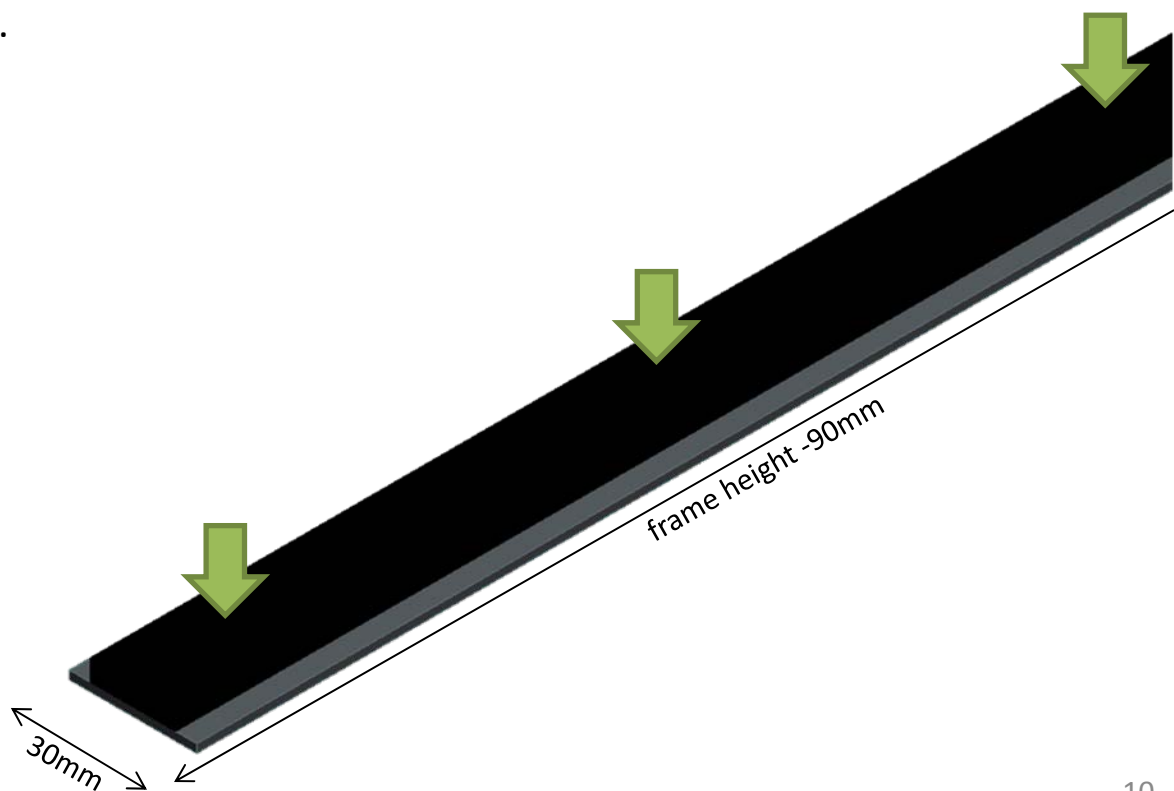


Assembly preparation

1. Fit a 20 x 5 cellular rubber strip (length = frame height - 90 mm) (G0100641), whilst ensuring it's central in the 30 x 1.9 PVC strip (P1515210), along the entire length of it.

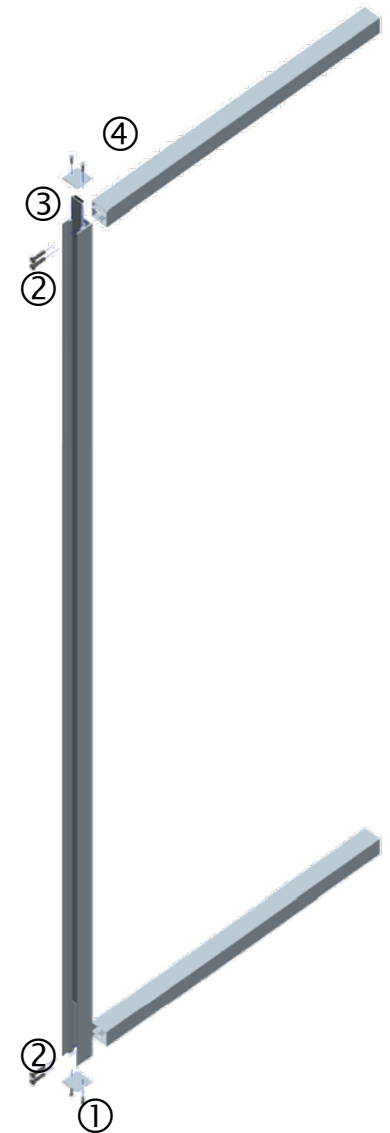
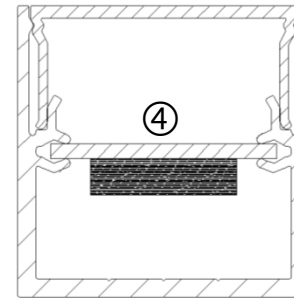
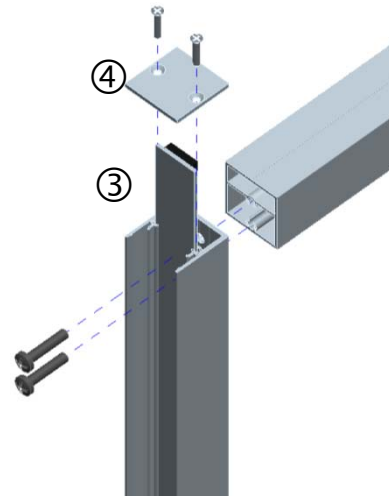
Practical tip : From the edge measure up and mark 5 mm using a vernier caliper and apply the strip against this marker line in the middle.

2. Repeat this twice on each frame.

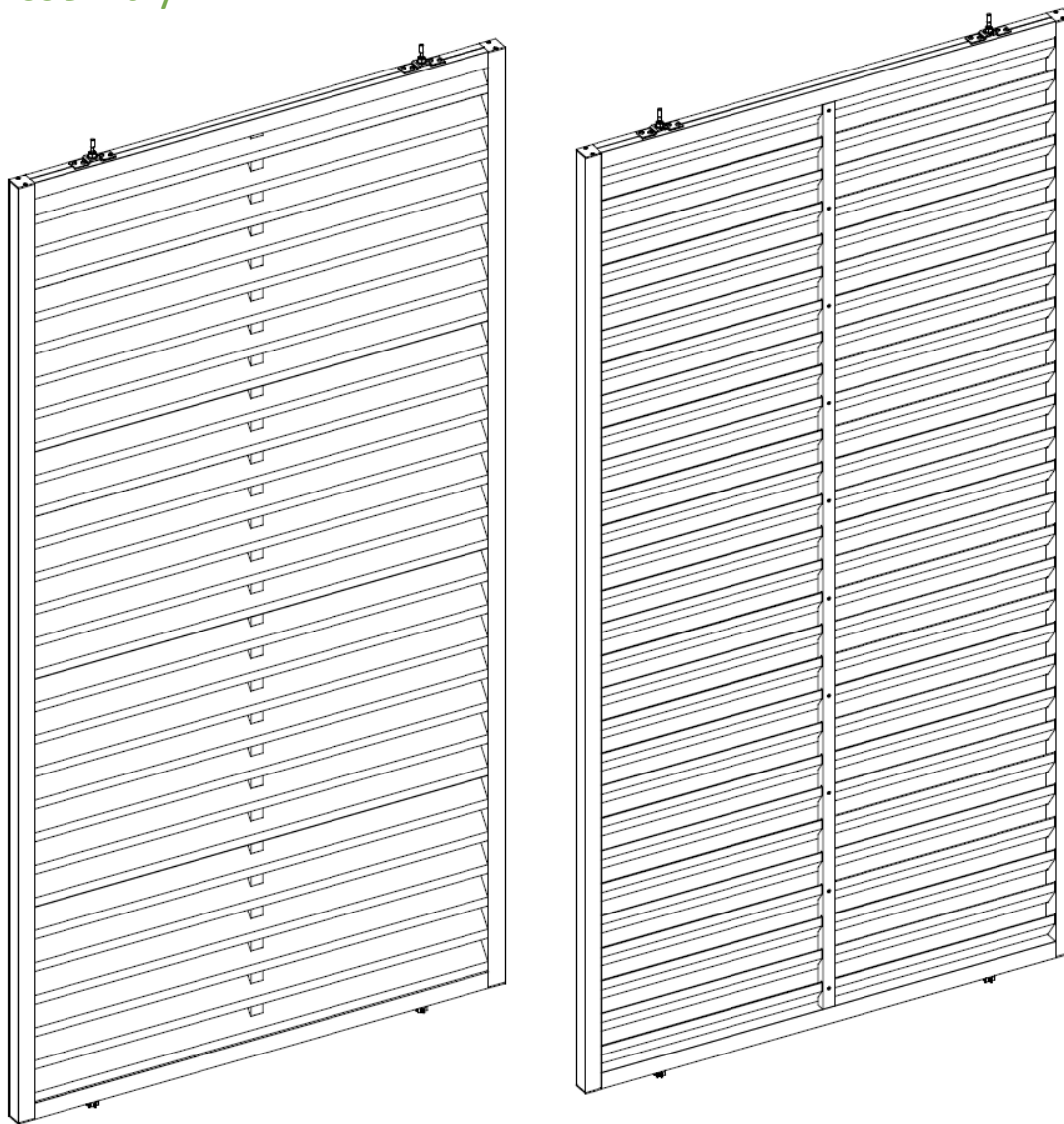


Assembly

1. Fit a cover plate (G0100522) to the bottom of the stile using two A2 stainless steel M 4 x 20 DIN 7500-M screws with PZ 3 drive (G0100526).
2. Screw fix the top and bottom rails (P14066-10), with the visible drill groove facing outwards, top and bottom, with two A2 stainless steel M 6 x 25 DIN 7500-C screws with PZ 3 drive (G0100525) each.
3. Slide the 30 x 1.9 PVC strip, with the cellular rubber strip affixed to it, into the screw channel with the cellular rubber strip facing inwards.
4. Fit a cover plate G0100522 to the top of the stile using two A2 stainless steel M 4 x 20 DIN 7500-M screws with PZ 2 drive (G0100526).



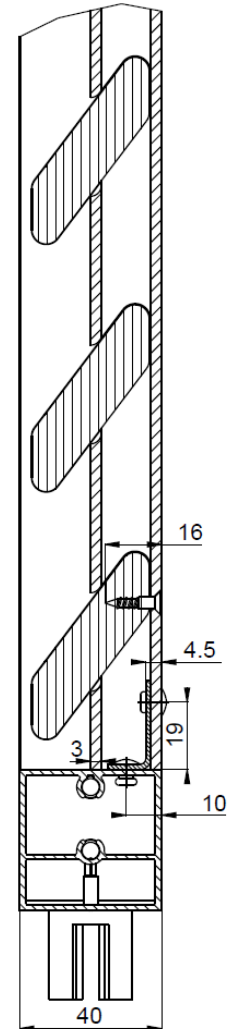
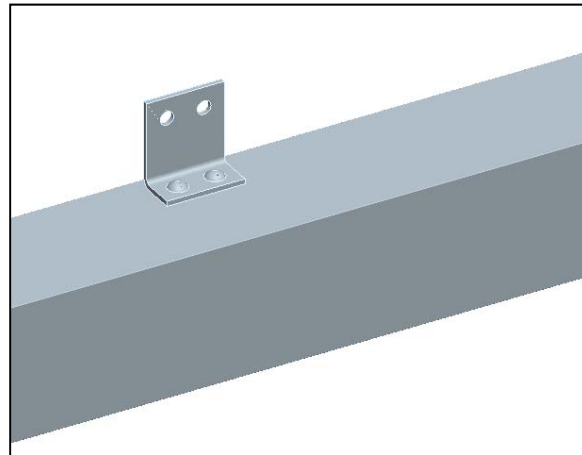
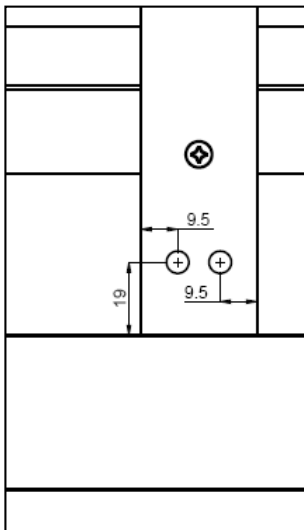
Assembly



Any louvre system width over a certain maximum value requires a 20 x 30 x 3 dividing rail (T1516412).
(See Excel calculation sheet.)

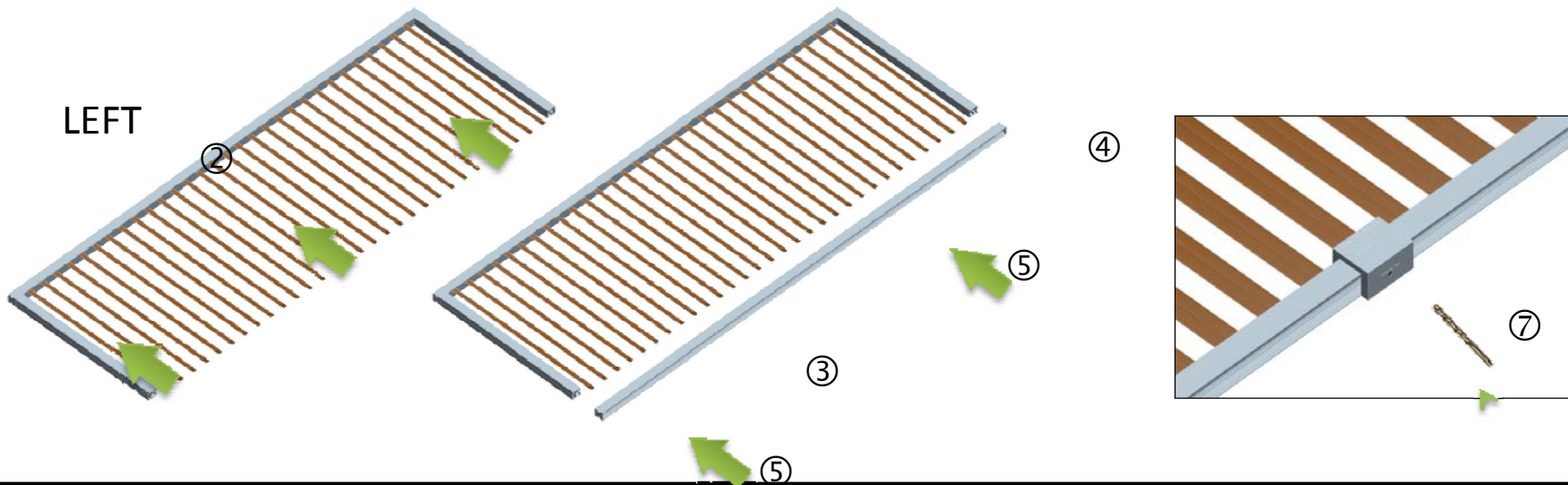
Assembly

- Drill two 4 mm dia holes at the center of the bottom profile at 10 mm from the outer edge (mark out with the mounting shoe fitted).
- Secure the 25 x 12 x 1.5 mounting shoe in the middle and at 3 mm from the edge of both the top and bottom rail using two 4 mm blind rivets.
- Place the framework with the front facing the table's work surface and fix the 20 x 30 x 3 tube section to the mounting shoe using two 4 x 10 blind rivets (G64).
- Turn the framework with the back facing the table's work surface.



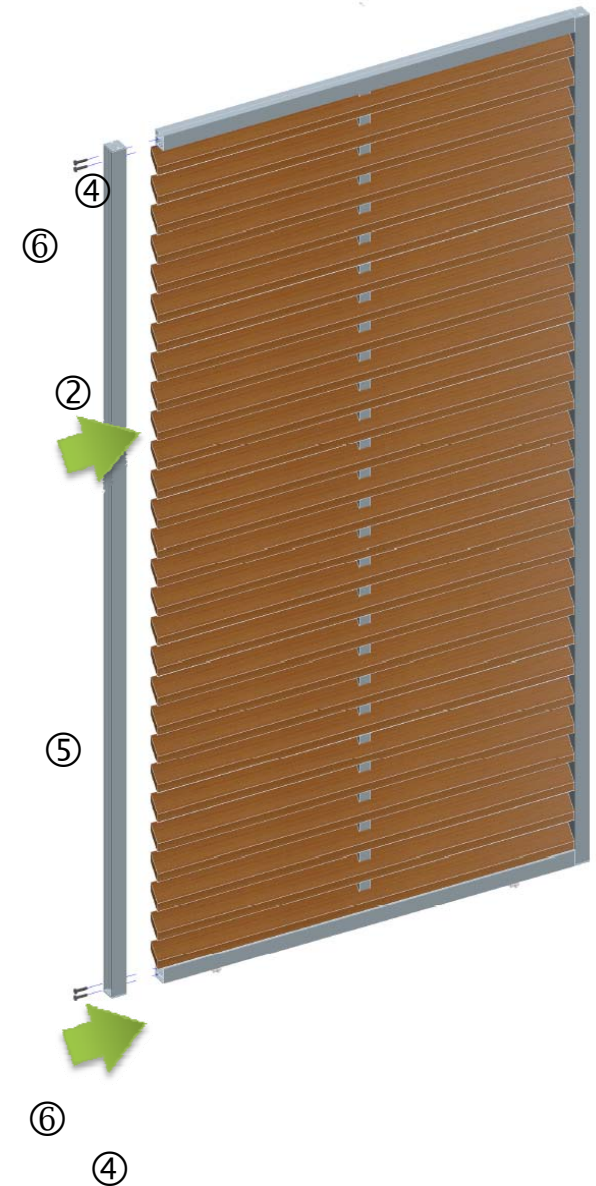
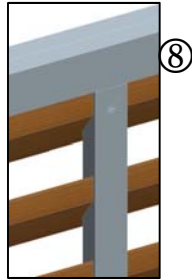
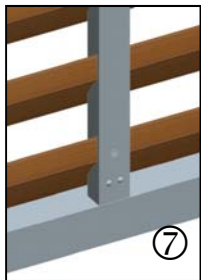
Assembly

1. Lay the framework flat on an even surface.
2. Insert all the louvre blades (P15156-10) in the laser-cut holes provided in the stiles.
3. Slide in the 30 x 1.9 PVC strip, with the cellular rubber strip affixed to it, in the screw channels of the right hand stile.
4. Fit a cover plate (G0100522) to the top and the bottom of the RH stile using two A2 stainless steel M 4 x 20, DIN 7500-M screws with PZ 2 drive (G0100525).
5. Push the right-hand stile so that it locates against the top and bottom rail.
6. Fasten the top and bottom rail on the top and bottom with two A2 stainless steel M 6 x 25 DIN 7500-C screws with PZ 3 drive (G0100526) each.
7. Drill using the drill jig (K0001745), with frame heights
 1. < 2,000 mm : a 4 mm dia hole through the 30 x 1.9 PVC strip on either side at the central louvre blade.
 2. > 2,000 mm : two 4 mm dia holes through the 30 x 1.9 PVC strip on either side at the louvre blades located at 1/3 and 2/3 of the frame height



Assembly

1. Lay the framework flat on an even surface.
2. Insert all the blades (P1515610) in the laser cut holes provided in the stile and in the U-shaped dividing rail.
3. Slide in the 30 x 2 aluminium plate, with the cellular strip affixed to it, in the screw channels of the right hand stile.
4. Fit a cover plate (G0100522) to the top and the bottom of the RH stile using two A2 stainless steel M 4 x 20 DIN 7500-M screws with PZ 2 drive (**G0100525**).
5. Push the right-hand stile so that it locates against the top and bottom rail.
6. Fasten the top and bottom rail on the top and bottom with two A2 stainless steel M 6 x 25 DIN 7500-C screws with PZ 3 drive (**G0100526**) each.
7. Insert a 3.5 x 16 mm countersunk screw into each hole provided in the dividing rail.
Tighten these screws every third blade.
8. The topmost blade must always be screw-fixed ;
if considered necessary, drill and chamfer 4 mm dia holes at 80/160/240 mm centres located above the last hole.



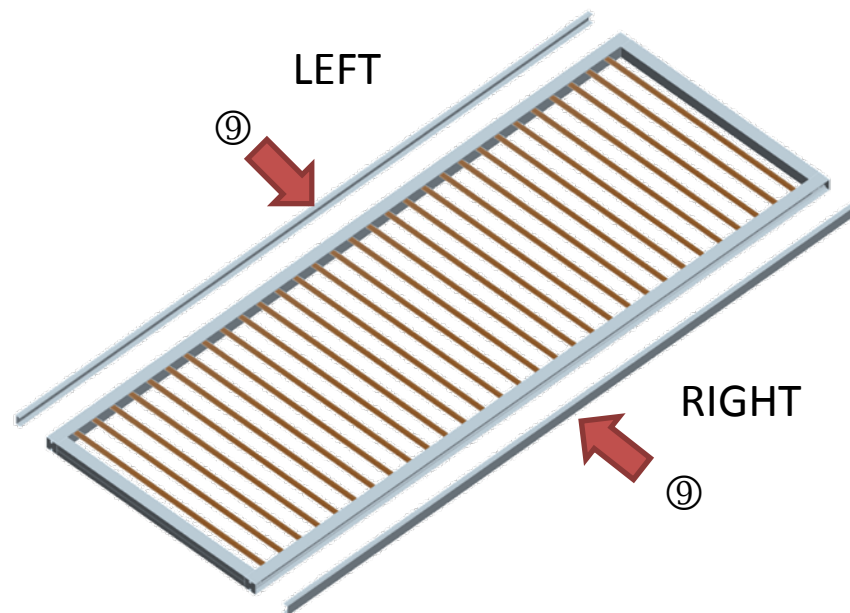
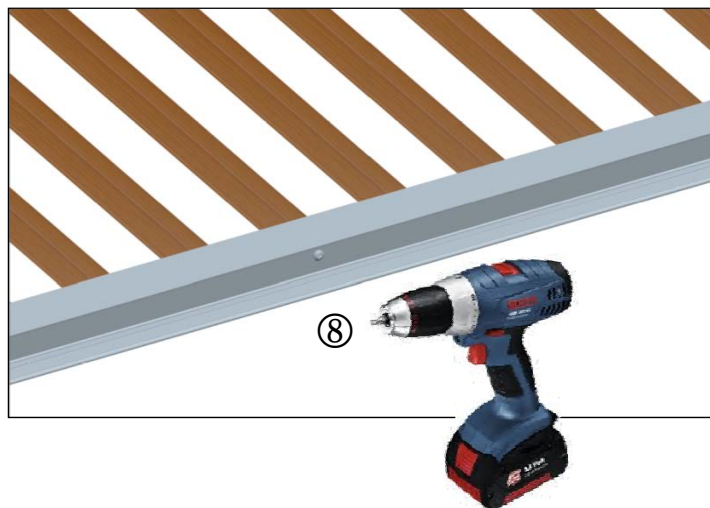
Assembly

1. Screw fix on both sides the central blade or the two blades located at 1/3 and 2/3 of the frame height with the 4 x 35 woodscrews (G0100670).

Take care to ensure that the frame remains square

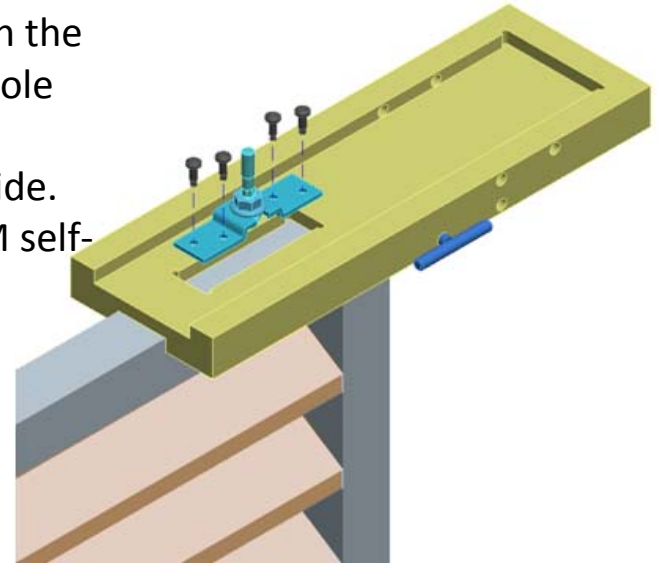
(these louvre blades only should be screw-fixed, since the frame is allowed to expand/contract at these locations) !

2. Clip the stile covers (P14073-10) onto the stiles.



Assembly

* Place the suspension bracket (G0013031 or G0013080) on the top rail of the slide (using the positioning jig). Be sure the hole provided in the suspension bracket, to accommodate the suspension bracket screw, points towards the rear of the slide. Fasten it with four A2 stainless steel M 4.8 x 18 DIN 7504-M self-drilling screws with PH 2 drive(G0000227). Do this for both sides of the slide.



* A choice of three possible fixing positions of the suspension bracket is available :
These positions vary depending upon what the customer ordered !

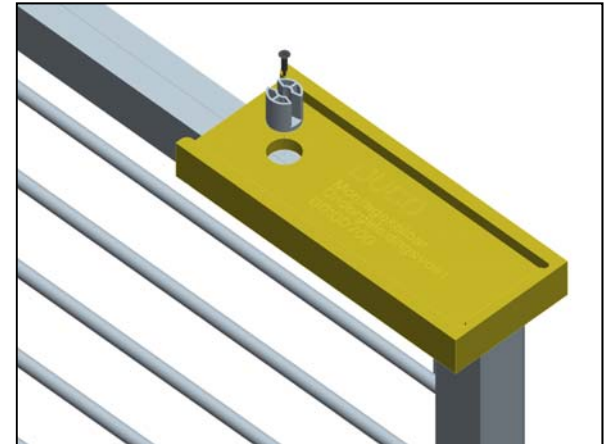
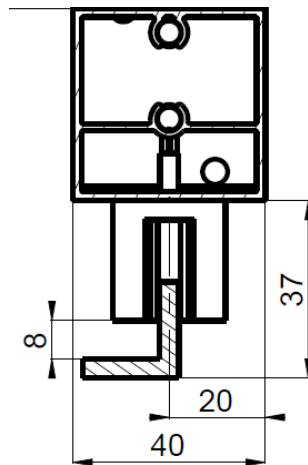
- Standard position at 110 mm, for manually operated slides ; underneath the actuator at 200 mm, for motorized single slides ;
- With motorized symmetrical slides : underneath the actuator at 200 mm ; in the center at 2 x 100 mm ; at the return pulley at 150 mm ;
- With motorized triple slides : underneath the actuator at 200 mm ; at the opposite side of the motorized actuator at 170 mm ; the other two slides at 150 mm.

These different positions can be set by shifting or removing the pin, depending on the position by the suspension bracket.

Assembly

Place the bottom guide base (G0100700) on the bottom rail of the slide using the positioning jig. Fasten it with an A2 stainless steel M 3.9 x 19 DIN 7504-O self-drilling screw with PH 2 drive (G0100528).

Do this for both sides of the slide.



CE label

Put the CE-label on a visible spot, for example on the side of the frame (do not put it on the wooden blades)

Make sure the label fits good on the frame.

