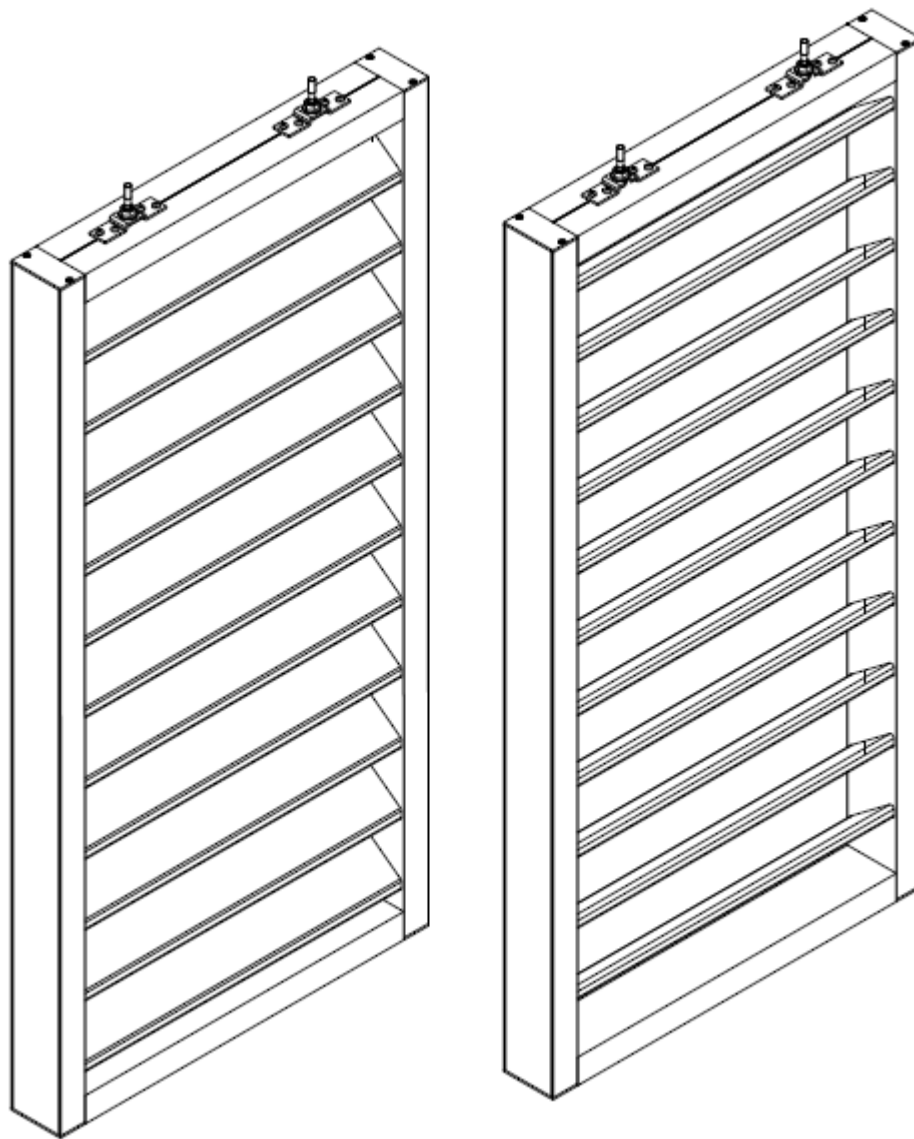
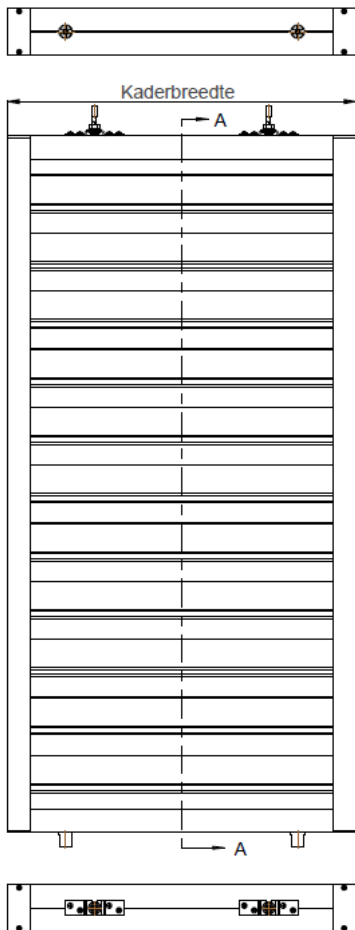


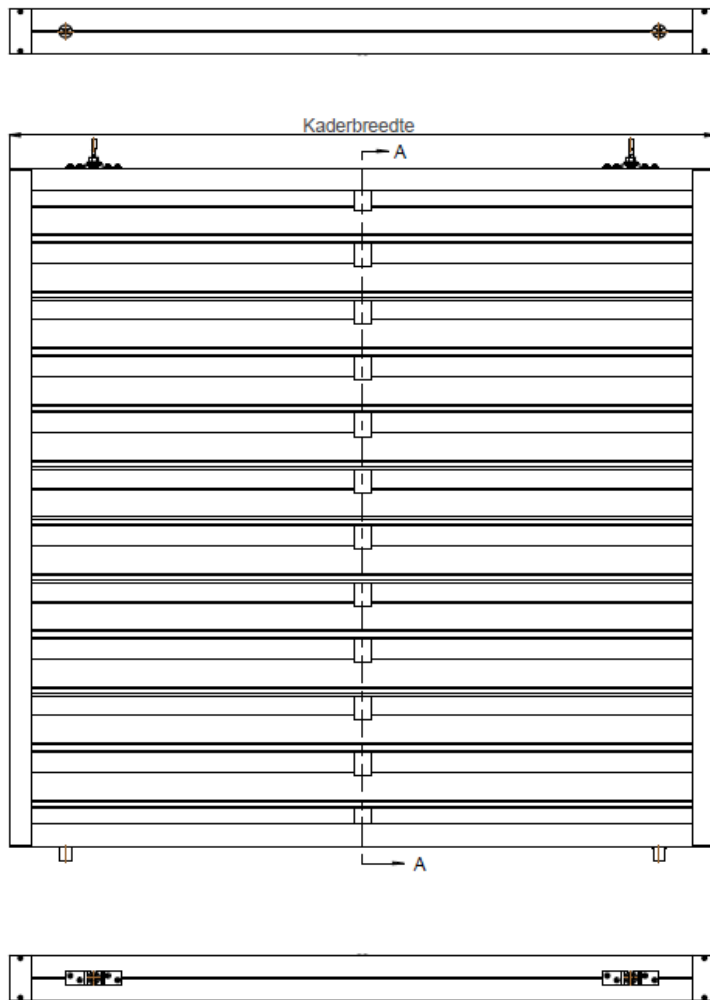
Assembly Instructions

DucoSlide Luxframe 40/80 Wood



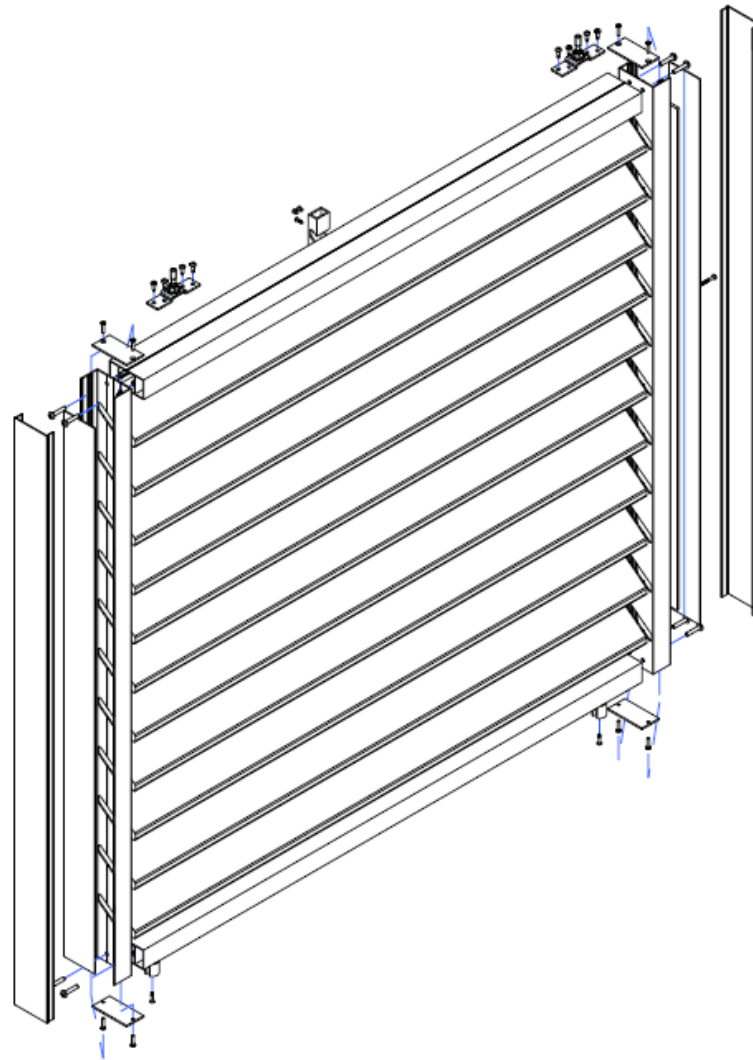


SECTION A-A

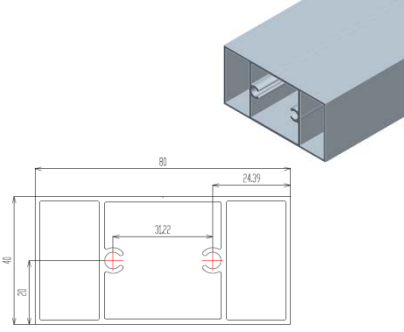
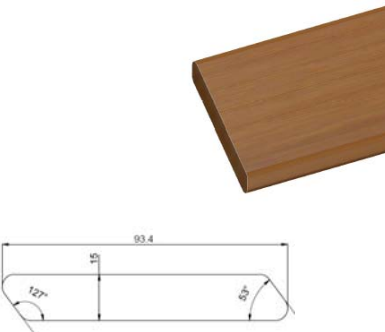
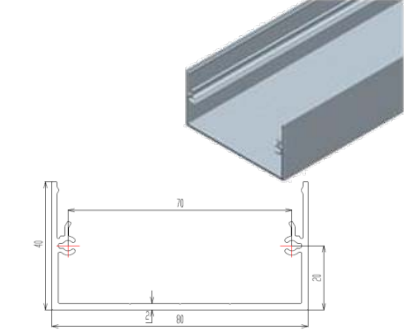
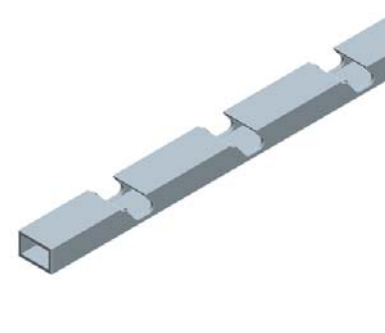
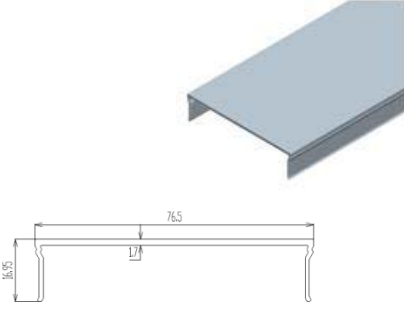
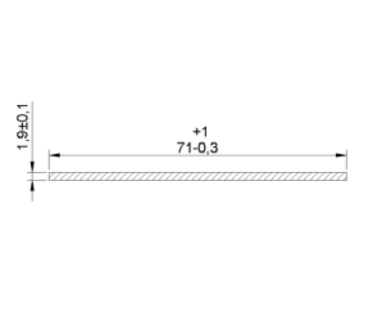


SECTION A-A







Exploded view



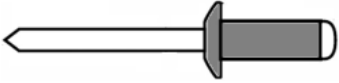

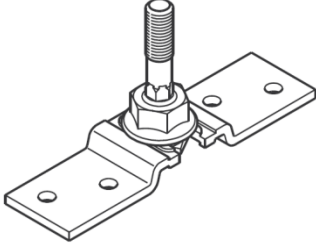
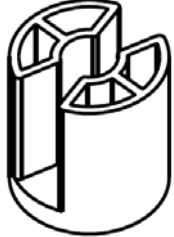
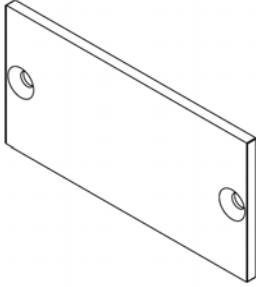
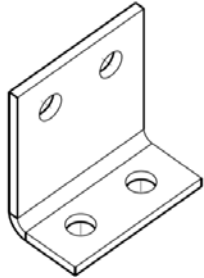
Parts list

<p>Lux 40/80 series top and bottom rails</p> <p>Code : P1402710</p> <p>Cut dimension = frame width - 80 mm</p>		<p>Lux 80 Wood (Western Red Cedar)</p> <p>Code : P1515710</p> <p>Cut dimension : Frame width - 49 mm</p>	
<p>Lux 40/80 series left and right stile</p> <p>Code : T1403123 LH T1403124 RH</p> <p>Cut dimension = frame height - 6 mm</p>		<p>Dividing rail 20 x 30 x 3 Alu</p> <p>Code : T1516416</p> <p>Cut dimension : Frame height - 80 mm</p>	
<p>Lux 40/80 series stile cover trim</p> <p>Code : P1401510</p> <p>Cut dimension = frame width - 80 mm</p>		<p>PVC strip 71x1.9</p> <p>Code : P1073810</p> <p>Cut dimension : Frame height - 90 mm</p>	

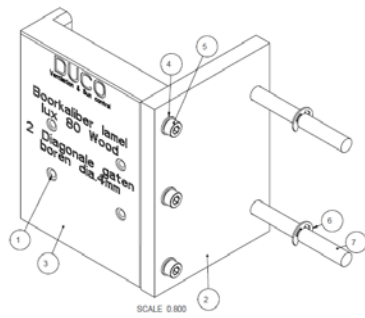
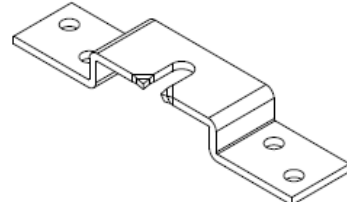
Parts list

<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 7500 Form M, M4.8 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 7500 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 foot.)</p>	

Parts list

<p>4 x 10 mm blind rivet Aluminium AL-AL</p> <p>Code : G0000064</p>		<p>Neoprene tape 50 x 5 mm CS-CR-EPDM</p> <p>Code : G0100649</p> <p>Length = length of PVC strip</p>	
<p>Top rail suspension bracket 34/40/3</p> <p>Code : G0013030</p>		<p>Bottom guide base Ø 25 mm</p> <p>Code: G0100700</p>	
<p>Cover plate (40 x 80 x 3)</p> <p>Code : G0100521</p>		<p>L-section 25 x 12 x 1.5</p> <p>Code : G0100675</p>	

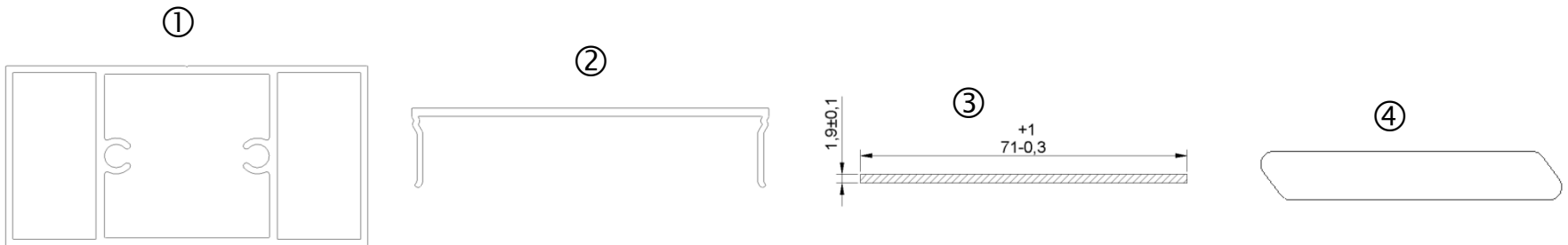
Parts list

<p>Drilling jig Lux 80 Wood</p> <p>Code: K0001746</p>			
<p>Top fixing plate frame for top track 31/33/2</p> <p>Code: G0013080</p>			

Prior to assembling

Cutting to length

1. Cut both the top and the bottom rail (**P1402710**) to fit the required frame width - 80 mm.
2. Cut the stile cover trim (**P1401510**) to the frame height - 6 mm.
3. Cut the 30 x 1.9 PVC strip (**P1073810**) to fit the required frame height - 90 mm.
4. Cut the timber blade 70-15 (**P1515710**) to fit the required frame width - 49 mm.

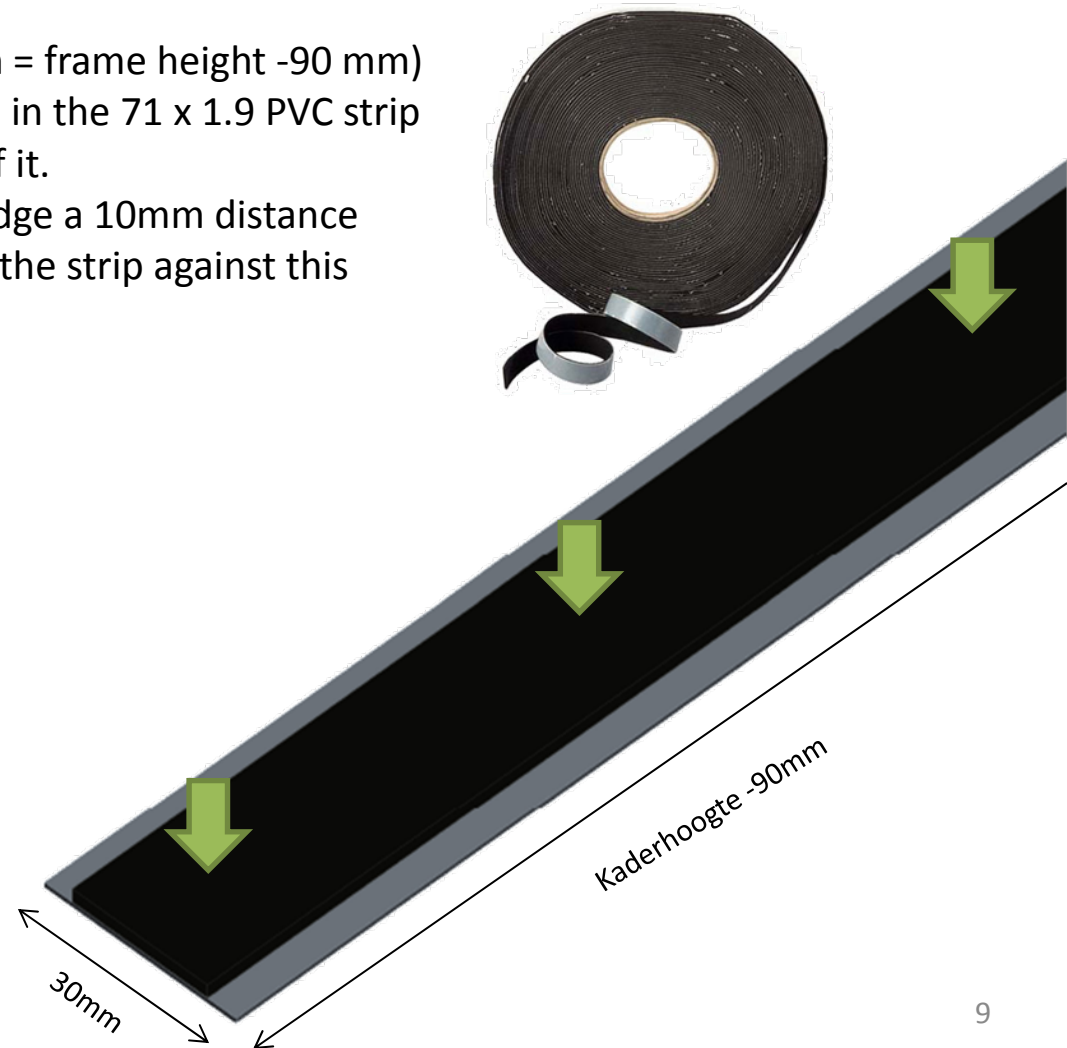


Prior to assembling

1. Fit a 50 x 5 cellular rubber strip (length = frame height -90 mm) (**G0100649**) whilst ensuring it's central in the 71 x 1.9 PVC strip (**P1073810**), along the entire length of it.

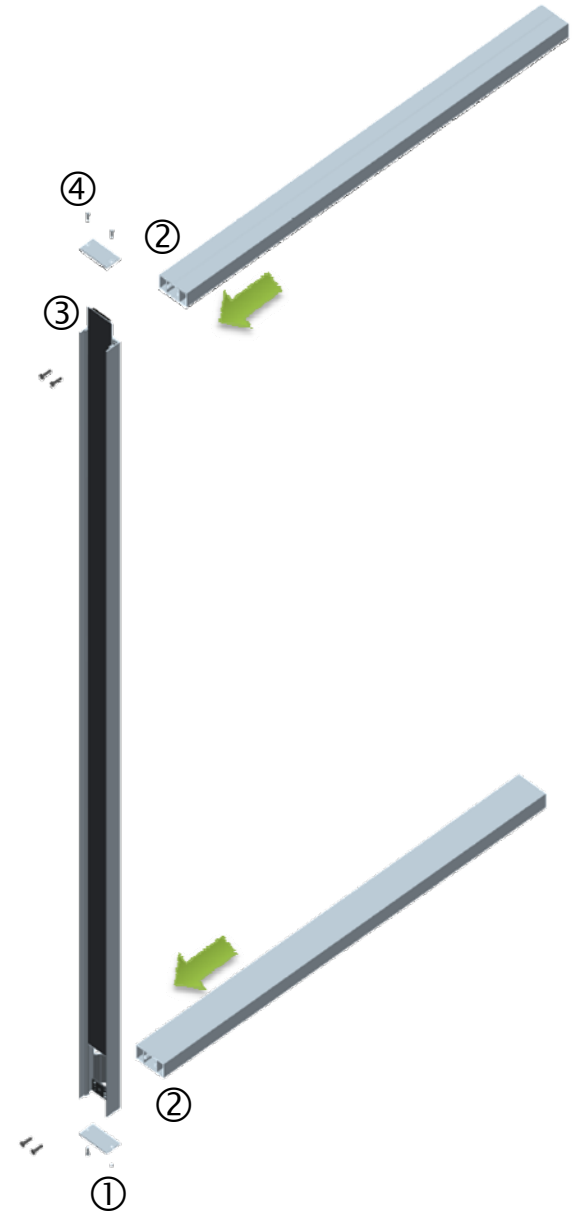
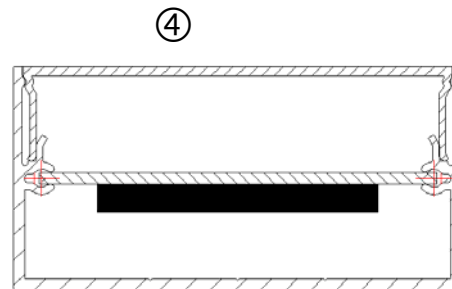
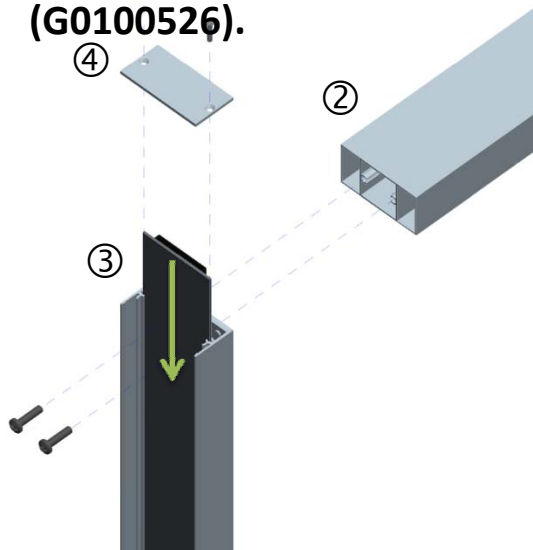
Practical tip : Measure up from the edge a 10mm distance using a vernier caliper and apply the strip against this marker line in the middle.

2. Repeat this twice on each frame.



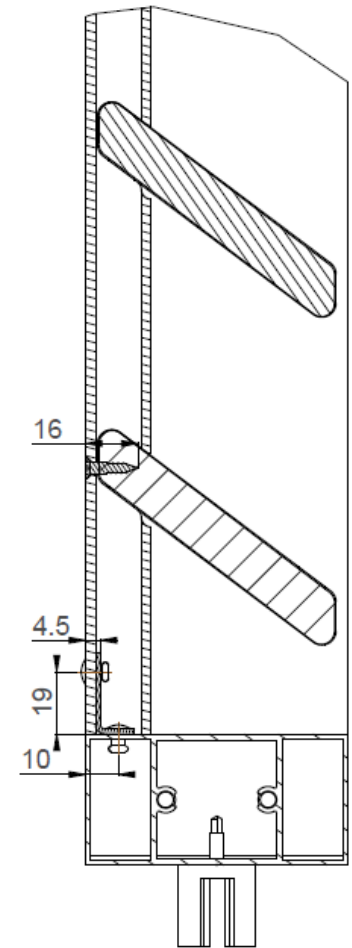
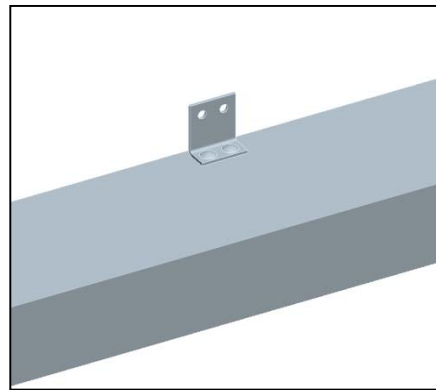
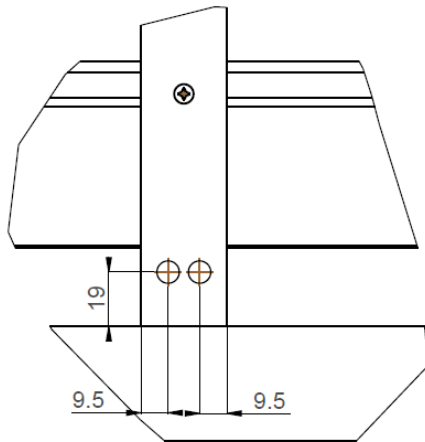
Assembly

1. Fit a cover plate (**G0100521**) 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 (**P1406610**), with the visible drill groove facing outwards, top and bottom, with two A2 stainless steel DIN 7500-C M6x30-A2, Pz3 **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 (**G0100521**) to the top of the stile using two A2 stainless steel M 4 x 20 DIN 7500-M screws with PZ 3 drive (**G0100526**).



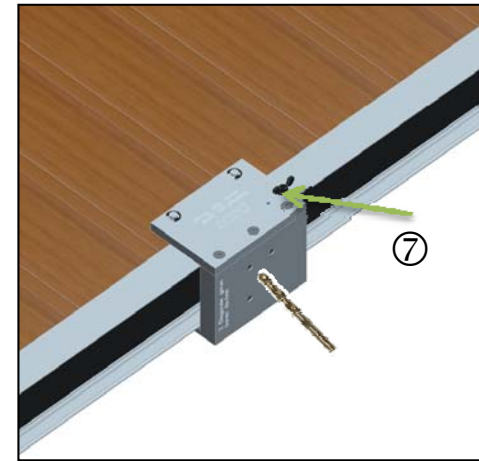
Assembly

1. Drill two 4 mm dia holes at the center of the top rail at 10 mm from the outer edge (mark out with the mounting shoe fitted).
2. Secure the 25 x 12 x 1.5 mounting shoe (**G0100675**) in the middle and at 3mm from the edge of both the top and bottom rail using two 4 mm blind rivets (**G64**).
3. 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**).
4. Turn the framework with the back facing the table's work surface.

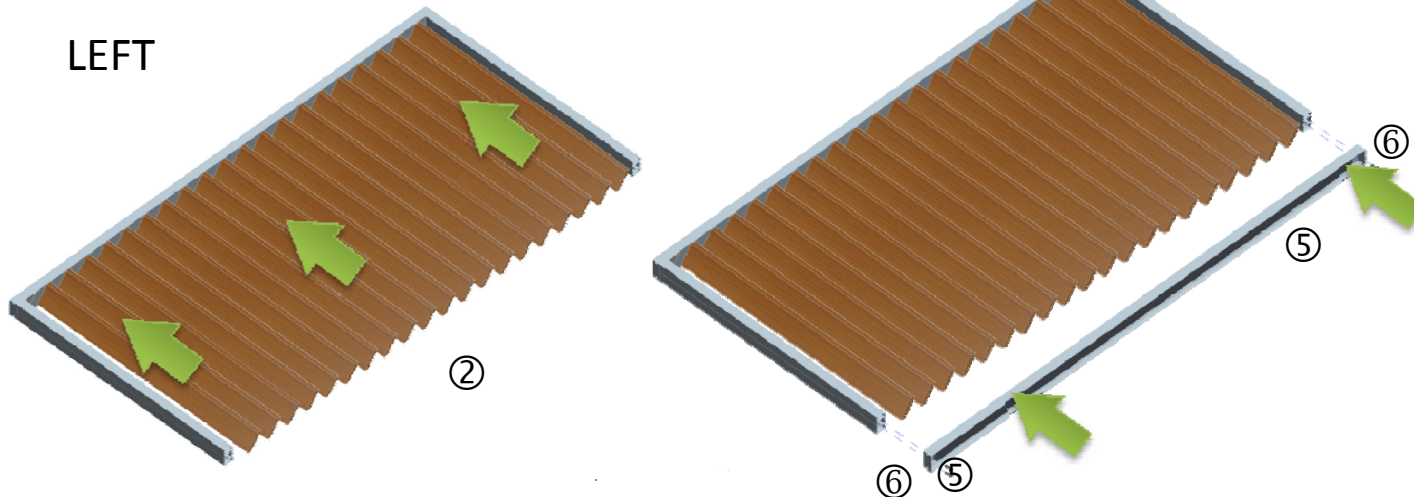


Assembly

1. Lay the framework flat on an even surface.
2. Insert all the louvre blades (**P1515710**) 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 DIN 7500-M M4x20-A, Pz2 **G0100526**.
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 DIN 7500-C M6x30-A2, Pz3 **G0100525** each.
7. Fit the drilling jig onto the stile allowing one pin to abut the bottom of the blade.
8. Clamp the drill jig (**K0001746**) in position and drill, with frame heights
 1. < 2,000 mm : once two 4 mm dia holes through the 30 x 1.9 PVC strip on either side at the central louvre blade.
 2. $\geq 2,000$ mm: twice 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

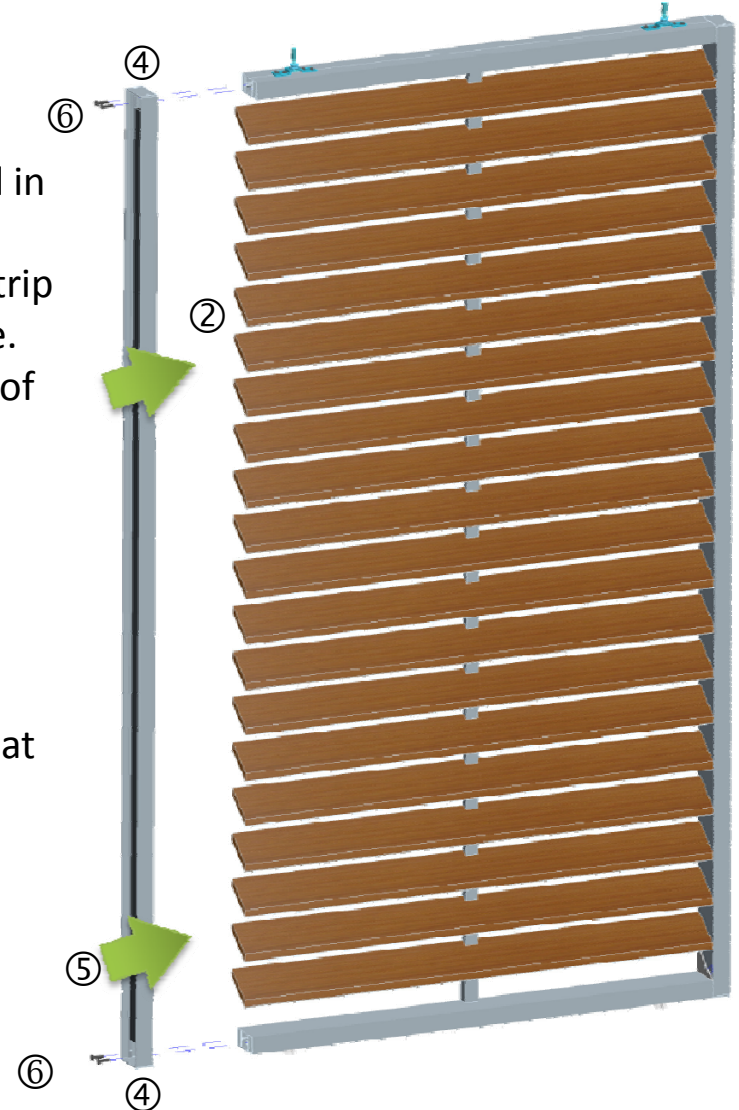
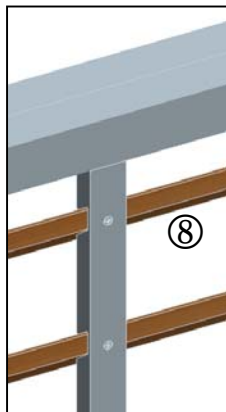
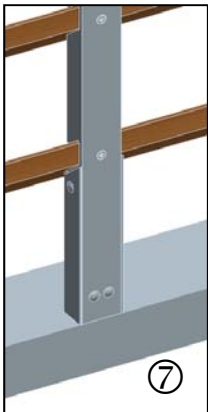


LEFT



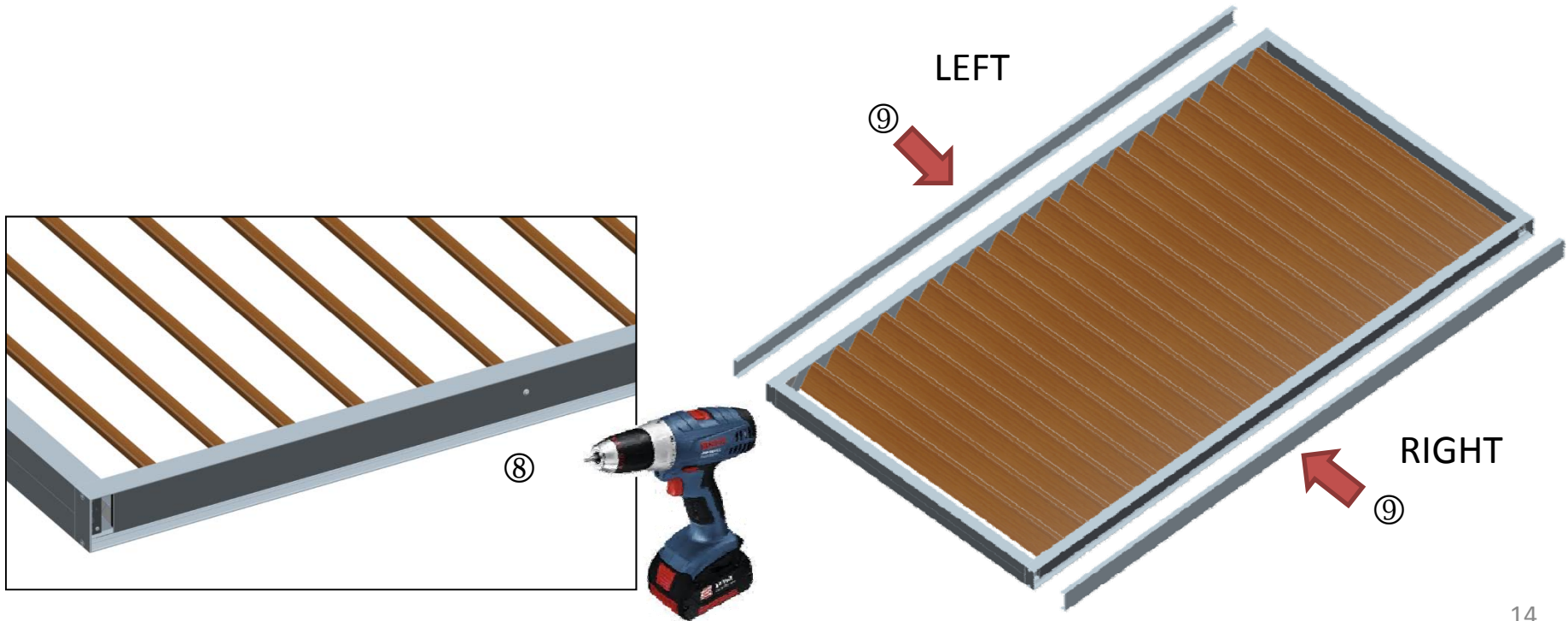
Assembly

1. Lay the framework flat on an even surface.
2. Insert all the blades (**P151710**) in the cut holes provided in the stile and in the U-shaped dividing rail.
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 (G0100521) 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 (**G0100526**).
5. Insert a 3.5 x 16 mm countersunk screw into each hole provided in the dividing rail. Tighten these screws every third blade.
6. 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.



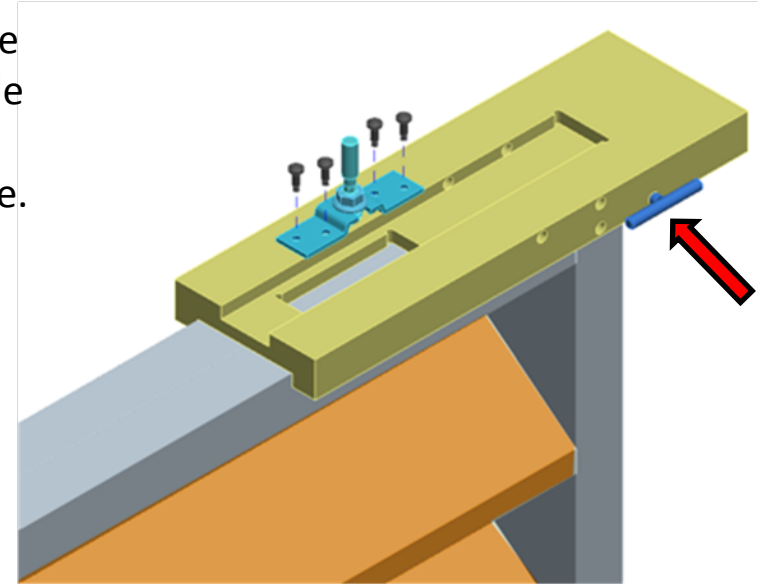
Assembly

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 (P14015-10) onto the stiles



Fitting Mounting

*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 16 DIN 7504-M self-drilling screws with PH 2 drive. Do this for both sides of the slide.

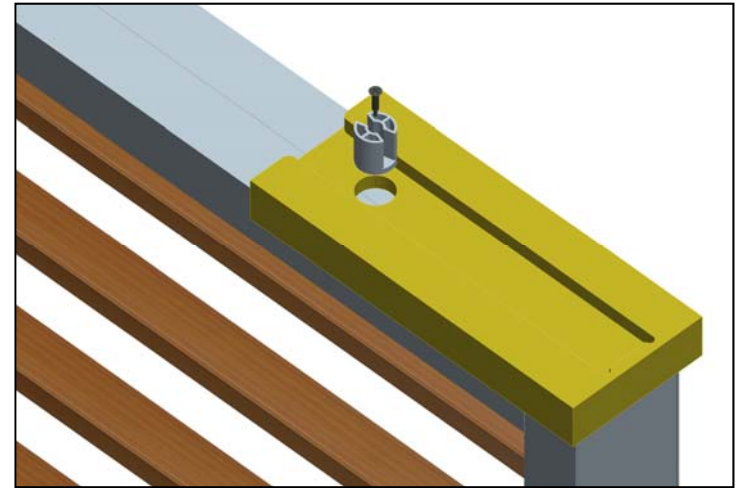
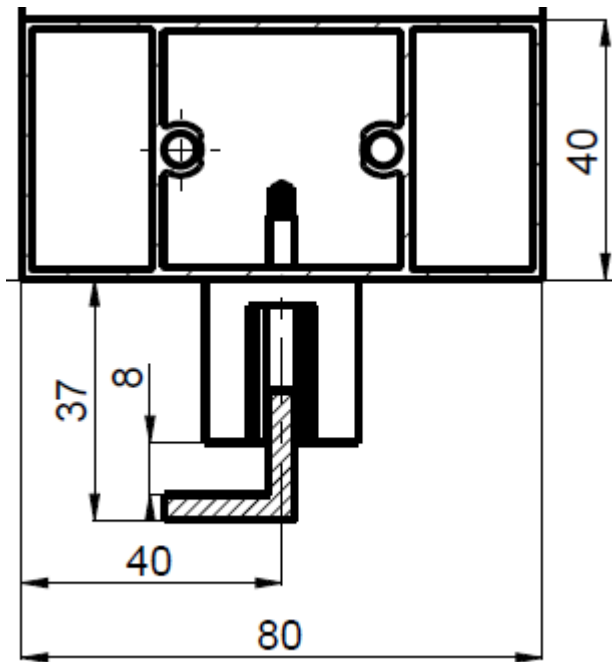


* A choice of three possible fixing positions of the suspension bracket is available :
These positions vary depending upon what the customer ordered !

- 1) Standard position at 150 mm for all slides ;
 - 2) At 195 mm for telescopic and symmetric slides on the return pulley side ;
 - 3) At 260 mm for the side of the slide underneath the actuator, of all electric motorized slides.
- These different positions can be set by shifting of removing the pin, depending on the position by the suspension bracket.

Fitting mounting

* 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. 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.

