

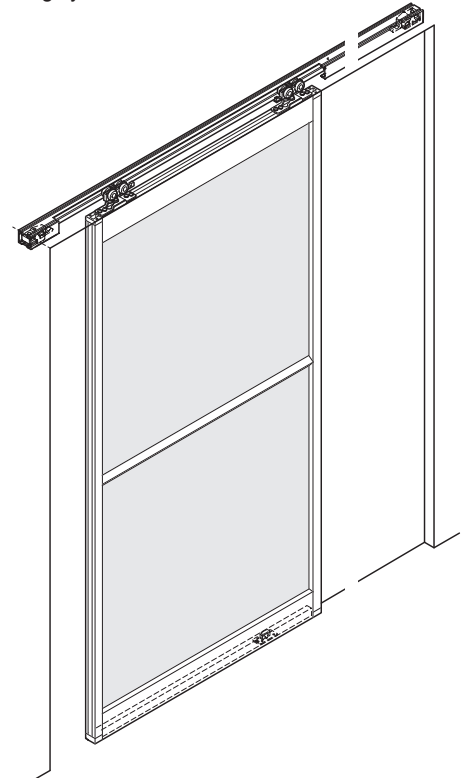
Thank you for selecting our product. Before starting installation, please read this manual thoroughly to ensure correct installation. Please keep this manual at hand for future reference.

## ABOUT THE PRODUCT

- This is a parts set for a heavy duty aluminum frame sliding door system for stores, public facilities and residences.

## SPECIFICATIONS

Required number of intermediate supports ⑫	0	1	2	3
Door height	Max. 2200 mm			2201 – 2700 mm
Door width	Max. 900 mm		901 – 1500 mm	
Glass thickness	5 mm or 6 mm			
Max. Door weight	80 kg/door			
Vertical adjustment	4 mm upward, 4 mm downward			



## FOR YOUR SAFE WORK AND CORRECT INSTALLATION

### Meaning of symbols



**Warning**  
**Caution**



**Prohibited**



**Required**



### **Warning : If not followed, death or serious injury 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 that it endures the weight of the door and any impact upon opening/closing the door. Only use designated screws and ensure that they are fastened firmly. A frame with poor strength or loose screws might result in the door falling and causing 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.

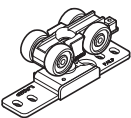
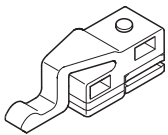
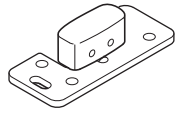
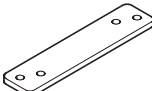


### **Caution : If not followed, injury or damage may result.**

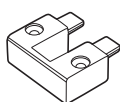
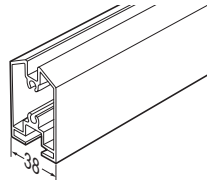
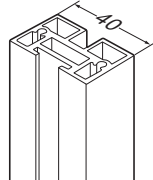
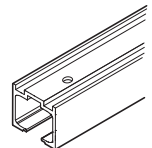
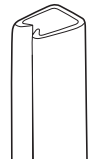
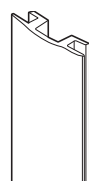
- ❗ Make sure to follow the designated dimensions, specifications, and horizontal/vertical angles. Make sure that the frame is not warped, since it may affect the movement of the door.
- ❗ If cutting any parts, make sure to remove any burrs before installation. Also check the upper track for any left-over burrs or scraps and remove these.
- ❗ This product 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. Please inform the end user about general precautions and safety to prevent improper use.
- ❗ Make sure to check 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.
- ⚠ Please use the tempered glass. It is recommended to use shatter-proof film on the glass.
- ❗ When installing "pocket door" specification, make "easy-maintenance" structure. For example, use removable panel.

# COMPONENT PARTS

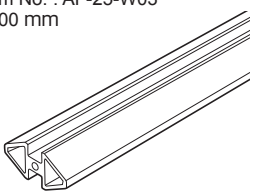
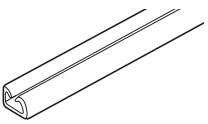

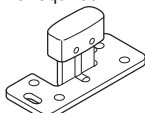

## Parts set (FD80HMP-AF) per door

<p>① Upper roller Accessory : Pan head tapping screw 4 x 45 ..... 4 pcs (not needed for this set)</p>  <p style="text-align: right;"><b>2 pcs</b></p>	<p>② Upper stopper</p>  <p style="text-align: right;"><b>2 pcs</b></p>	<p>③ Floor guide S Accessory : Bind head tapping screw 4 x 16 ..... 5 pcs</p>  <p style="text-align: right;"><b>1 pc</b></p>	<p>④ Plate nut Accessory : Hexagon socket button head screw M5 x 16 ..... 8 pcs Spring lock washer 5 ..... 8 pcs Plain washer 5 ..... 8 pcs</p>  <p style="text-align: right;"><b>1 set</b></p>
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## Required Parts

<p>⑤ Corner Part</p>  <p style="text-align: right;"><b>4 pcs / door</b></p>	<p>⑥ Mount screw set</p> <ul style="list-style-type: none"> <li>• Hexagon socket head cap screw M6 x 30 ..... 8 pcs (for Frame ⑦⑧)</li> <li>• Hexagon socket head cap screw M4 x 30 ..... 6 pcs (for Intermediate support ⑫)</li> <li>• Hexagon socket countersunk head screw M4 x 25 ..... 8 pcs (for Corner Part ⑤)</li> </ul> <p style="text-align: right;"><b>1 set</b></p>	<p>⑦ Horizontal frame 2000 mm</p> 	<p>⑧ Vertical frame 2500 mm/3000 mm</p> 
<p>⑨ Upper track (Various sizes) Accessory : Pan head tapping screw 5x40</p> 	<p>⑩ Gasket for 5 mm glass: 2500 mm for 6 mm glass: 3000 mm</p> 	<p>⑪ Edge cover 2500 mm/3000 mm</p> 	

## Optional parts

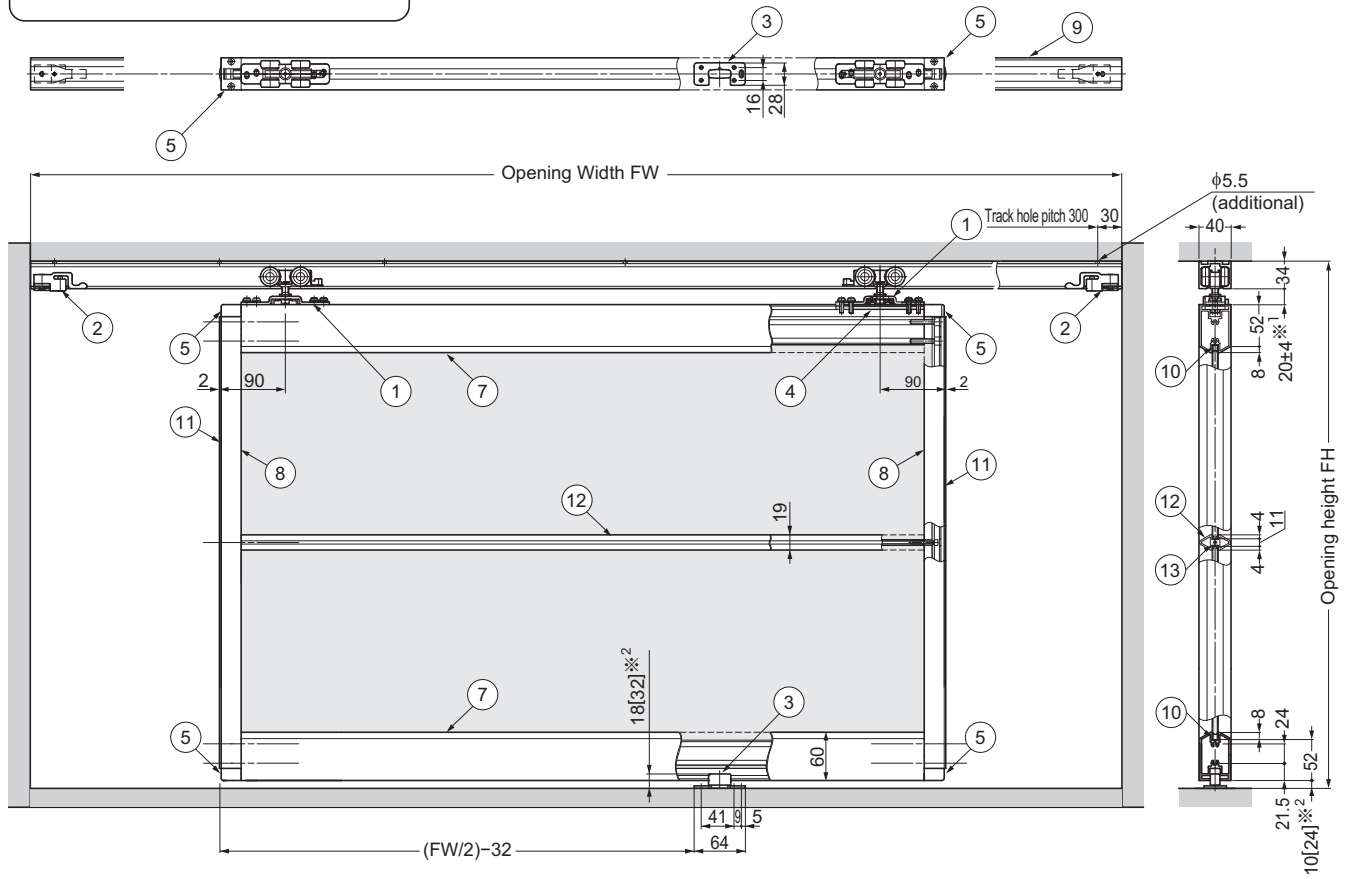
<p>⑫ Intermediate support Item No. : AF-25-W03 2000 mm</p> 	<p>⑬ Gasket for Intermediate support Item No. : for 5 mm glass ..... AF-25-P03 for 6 mm glass ..... AF-25-P16 2500 mm</p> 	<p>⑭ Handle Item No. : WN799Z160E101 It is adhered after drilling two 7 mm dia. holes.</p> 	<p>⑮ Floor guide L Item No. : FD50-BG32 Accessory : Bind head tapping screw 4x16 ..... 5 pcs This is used when larger space below the door is required.</p> 
<p>⑯ Spanner Item No. : FD30-FSP</p>  <p style="text-align: center;">Nominal designation 10, 12</p>			

# INSTALLATION DRAWING (EXAMPLE)

Refer to page 4 about the dimensions of the doors and glass panels.

## Caution

! When a vertical frame is not used, apply a two-way soft closer.



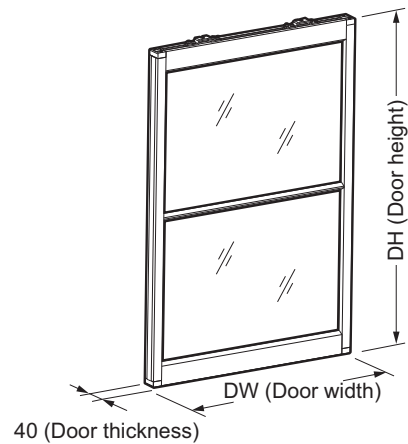
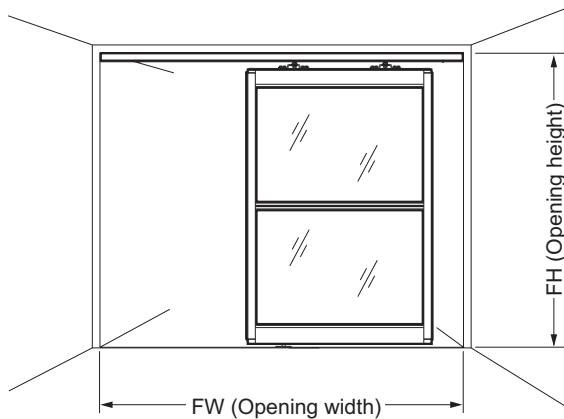
※<sup>1</sup> Vertical adjustment range : -4 mm to +4 mm.

※<sup>2</sup> Dimension in [ ] : when floor guide L 15 (option) is used.

# DIMENSIONS OF DOORS

(Round down the decimal point for the divided dimensions.)

Drawing of installed door



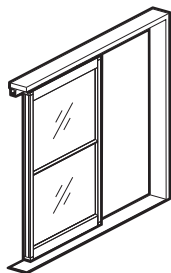
$$DH \text{ (Door height)} = FH - 64$$

$$DW \text{ (Door width)} = \frac{FW - 4}{2} + 20$$

$$GH \text{ (Glass height)} = \frac{DH - 104 - (\text{Number of Intermediate support} \otimes \times 11)}{\text{Number of glass panels}}$$

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

Example 1



**Ex: 1 door on single track**

**Size of the door with Opening width 1800 mm and Opening height 2400 mm.**

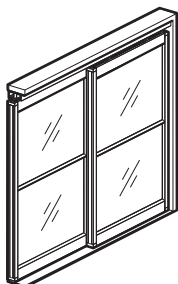
$$DH = 2400 - 64$$

$$= 2336 \text{ mm}$$

$$DW = \frac{1800 - 4}{2} + 20$$

$$= 918 \text{ mm}$$

Example 2



**Ex: 2 door on double track**

**Size of the door with Opening width 1800 mm and Opening height 2400 mm.**

$$DH = 2400 - 64$$

$$= 2336 \text{ mm}$$

$$DW = \frac{1800 - 4}{2} + 20$$

$$= 918 \text{ mm}$$

## 1 Cutting and Hole Processing of Standard Length Parts

### ⚠ Caution

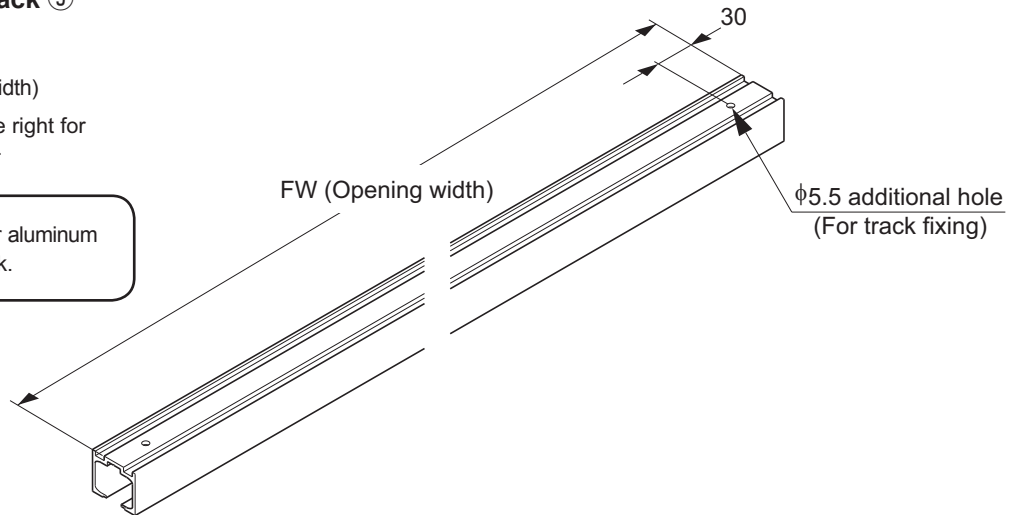
- ❗ Cut carefully so the cut edge is square to avoid bias and skewing.
- ❗ When cutting, reinforce the track to prevent deformation at the cut section.

### [1] Processing of Upper track ⑨

- (1) Length = FW (Opening width)
- (2) Refer to the figure on the right for cutting and drilling holes.

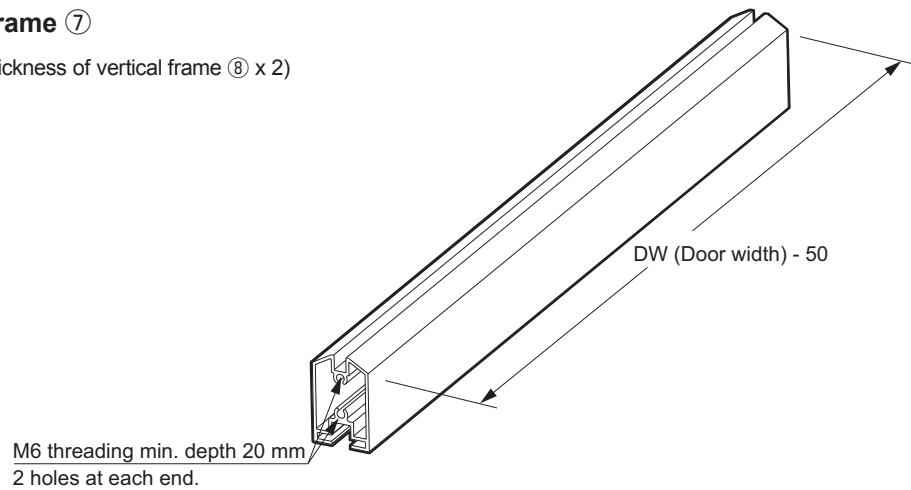
### ⚠ Caution

- ❗ Remove any dirt or aluminum chips from the track.



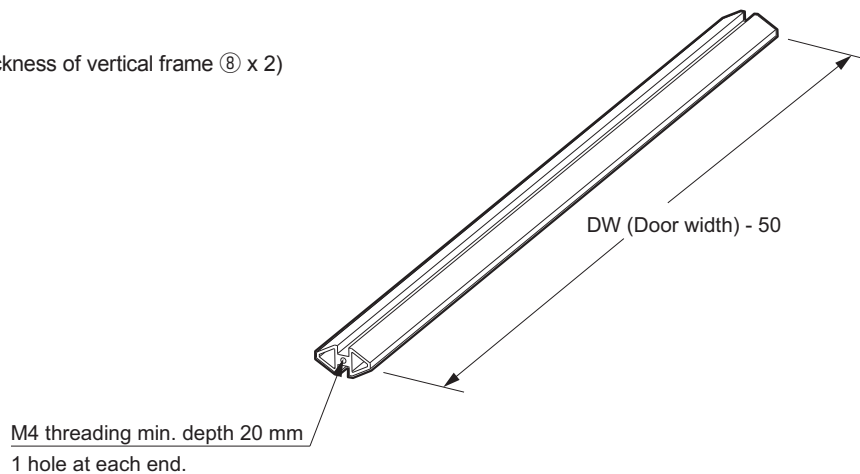
### [2] Processing of Horizontal frame ⑦

Length = DW(Door width) - 50(Thickness of vertical frame ⑧ x 2)

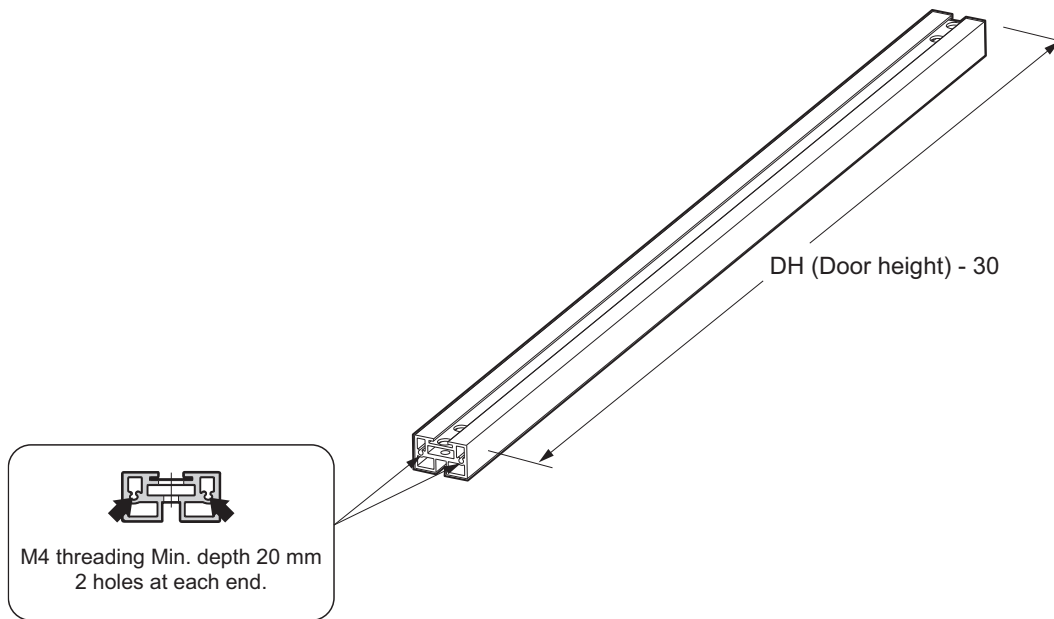


### [3] Cutting and hole processing of Intermediate support ⑫, when used

Length = DW(Door width) - 50(Thickness of vertical frame ⑧ x 2)



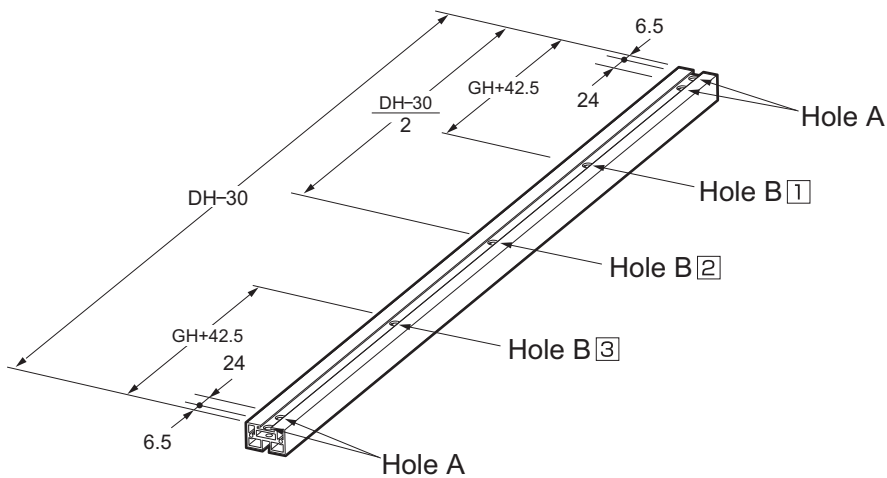
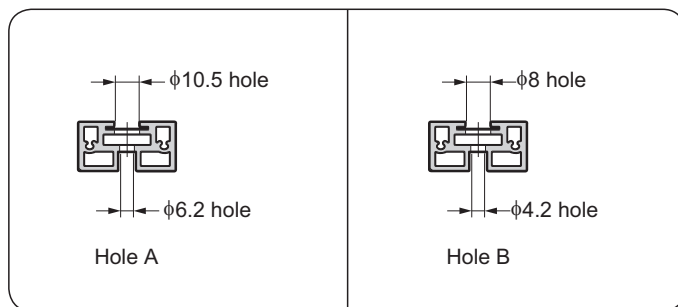
### 1-4 Processing of Vertical frame ⑧ - Step 1



### 1-5 Processing of Vertical frame ⑧ - Step 2

Drill holes according to the quantity of intermediate support.

- Hole A only if there is no intermediate support ⑫
- Hole A + B<sup>2</sup> for 1 intermediate support ⑫
- Hole A + B<sup>1</sup>, B<sup>3</sup> for 2 intermediate supports ⑫
- Hole A + B<sup>1</sup>, B<sup>2</sup>, B<sup>3</sup> for 3 intermediate supports ⑫

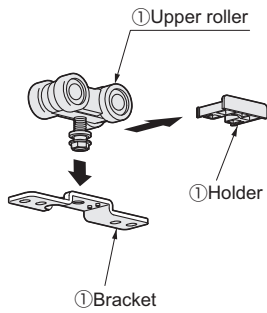


DH: Door height  
GH: Glass height

## 2 Assembling Parts

### [1] Disassembling Upper rollers ①

Remove upper roller bracket and holder

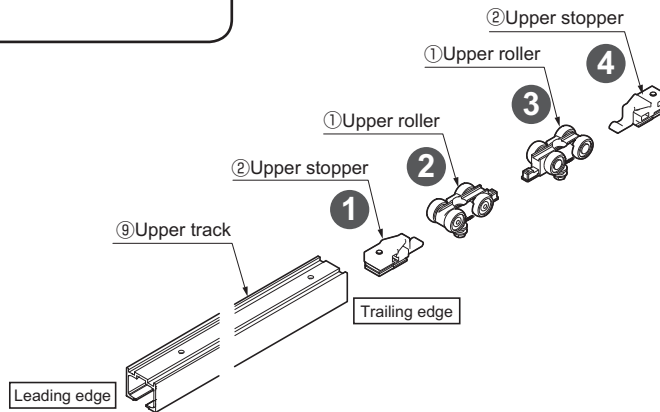


### [2] Inserting Parts into Upper Track

Insert the parts in order from ① to ④.

#### ⚠ Caution

❗ Tape around rollers and upper track to prevent inserted parts from falling.



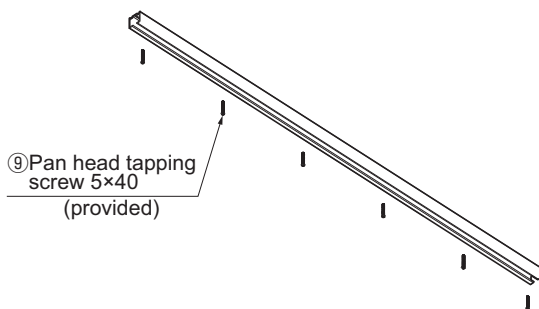
## 3 Fixing Upper Track ⑨ and Floor Guide

### [1] Fixing Upper track ⑨

Fasten the upper track with provided screws.

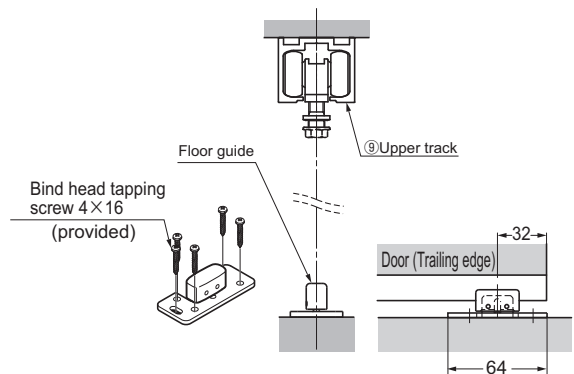
#### ⚠ Caution

❗ Remove any dirt or aluminum chips from the track.



### [2] Fixing Floor guide

- (1) Position floor guide just below the center of upper track.
- (2) Position the floor guide so that the roller part stays under the door when it is opened or closed.



## 4 Assembling Door

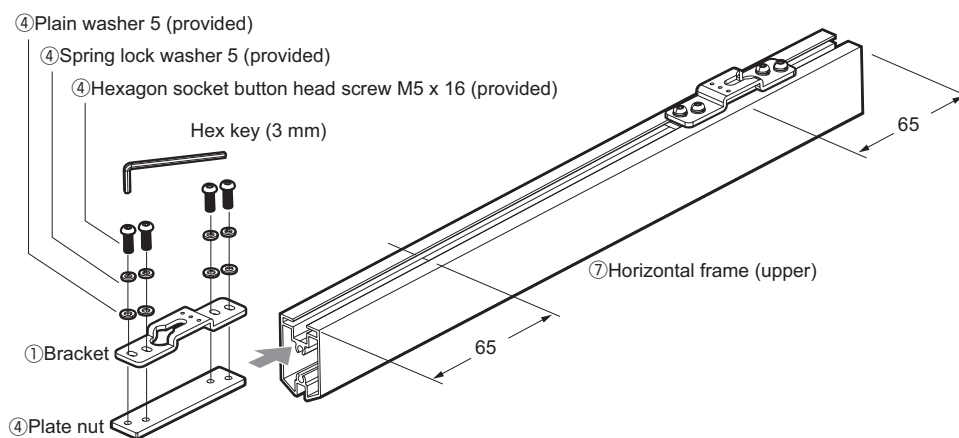
### ⚠ Caution

- ❗ Coat screw threads with an anti-backoff material such as "thread locking".
- ⚠ During door installation, handle the glass carefully to prevent injury.

### [1] Preparation of Horizontal frame⑦ - Upper

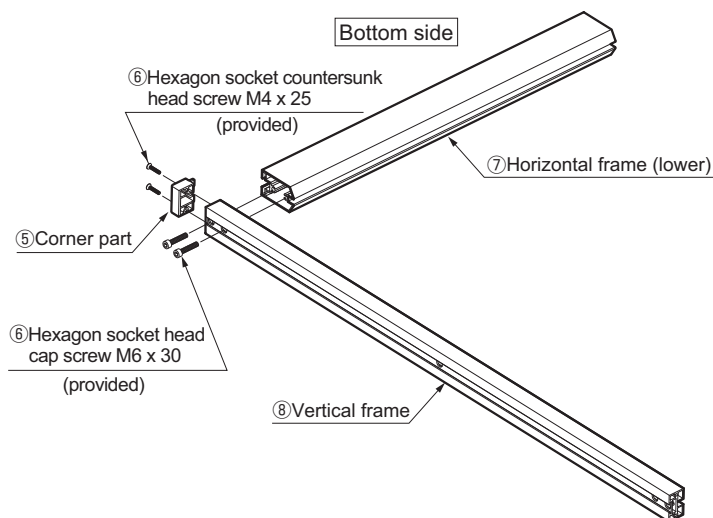
### ⚠ Caution

- ❗ Pay attention to the direction of the brackets. The open part of the bracket should face in the outside direction.



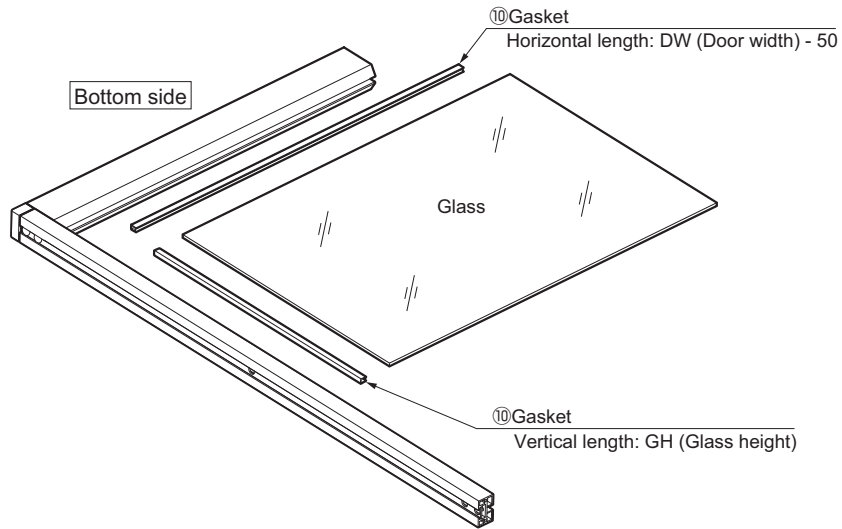
Fasten the bracket to upper horizontal frame ⑦, using plate nut ④.  
The distance from the edge and bracket center should be 65 mm.

### [2] Assembly of Horizontal frame⑦ (lower) and Vertical frame⑧

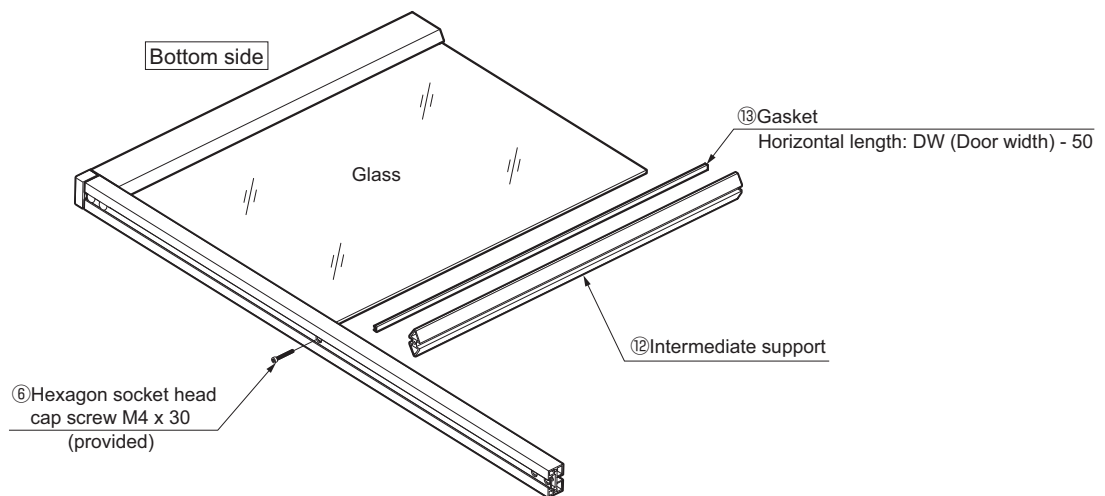




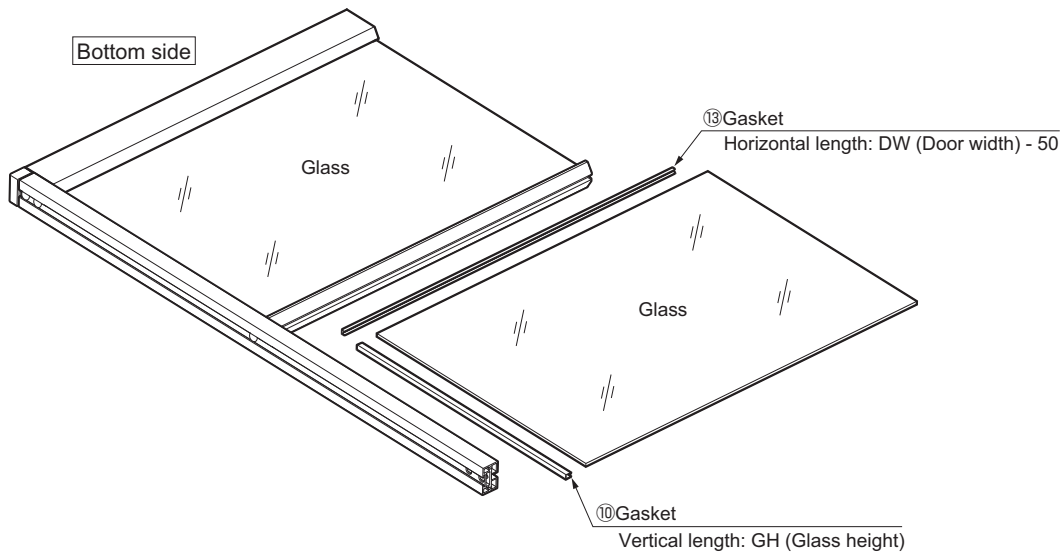
### [3] Insertion of glass - Step 1



### [4] Assembly of Intermediate support ⑫, when used

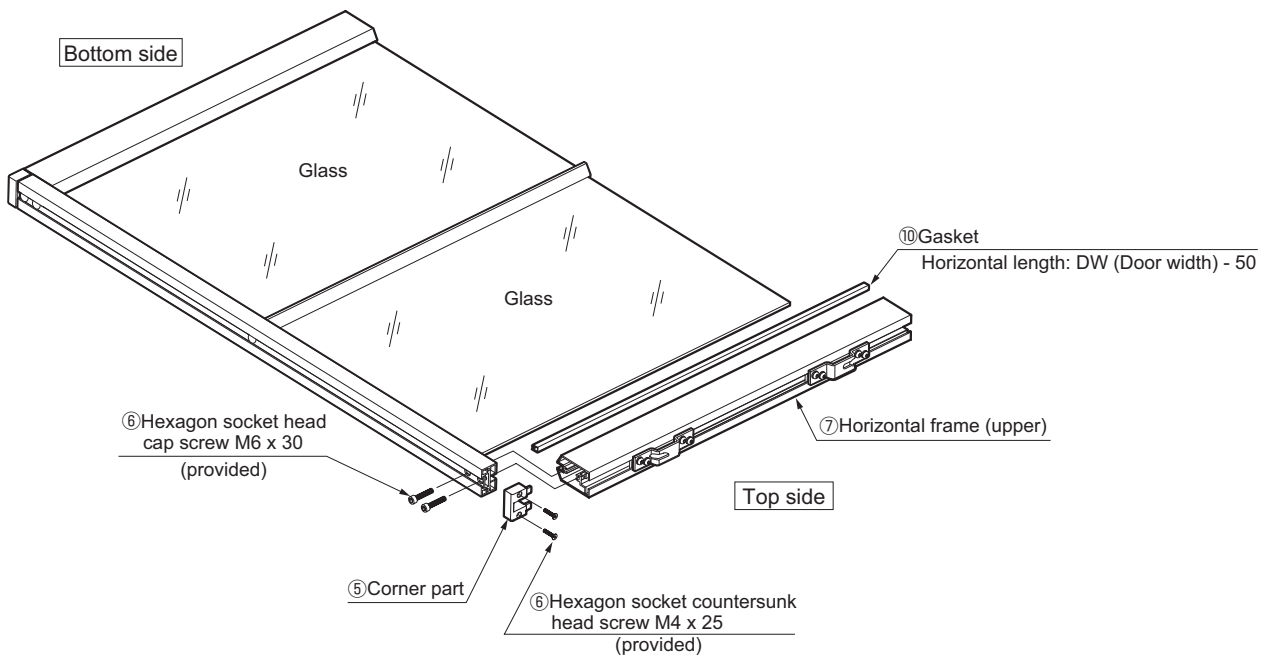


## [5] Insertion of glass - Step 2, when Intermediate support is used

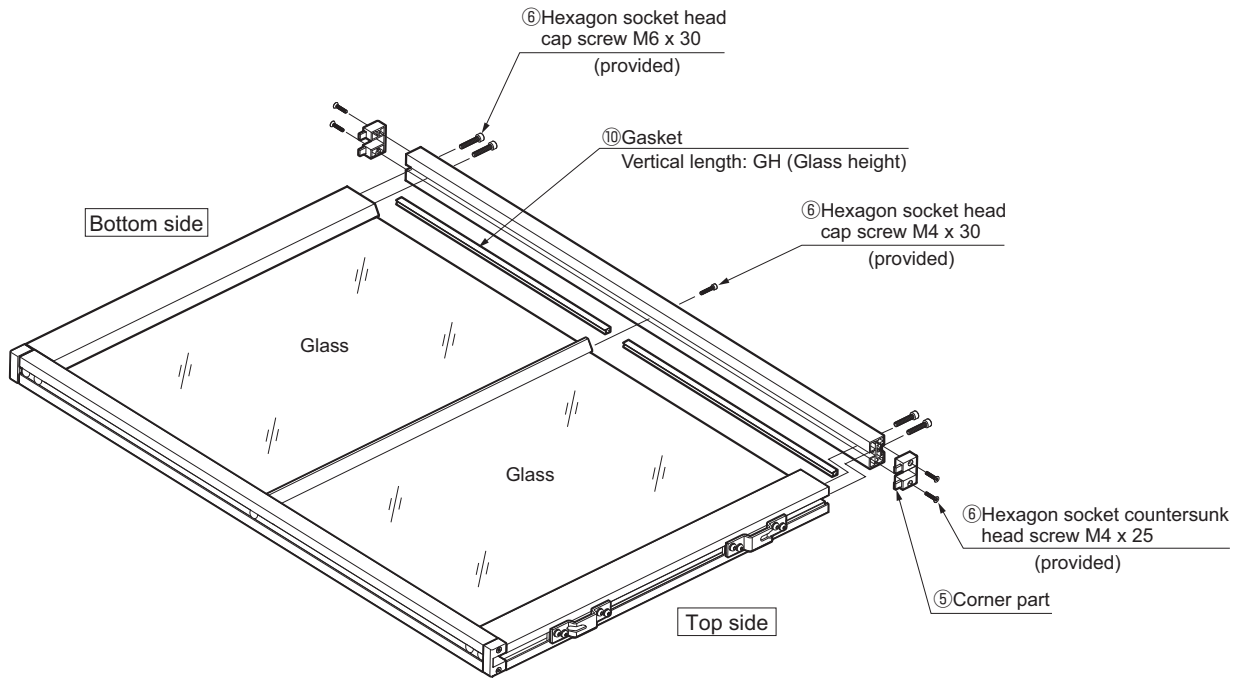


When using more than two Intermediate supports, repeat procedures 4 - [4] to 4 - [5] .

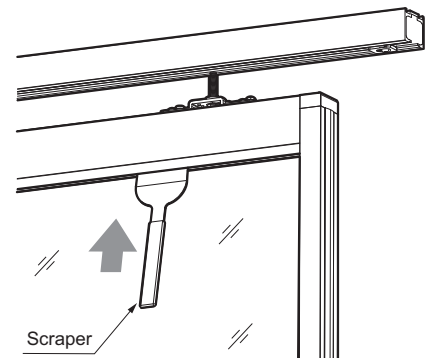
## [6] Assembly of Horizontal frame 7 (upper)



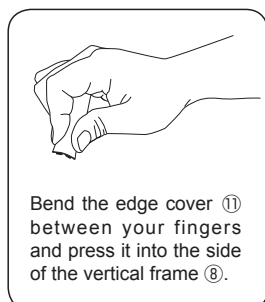
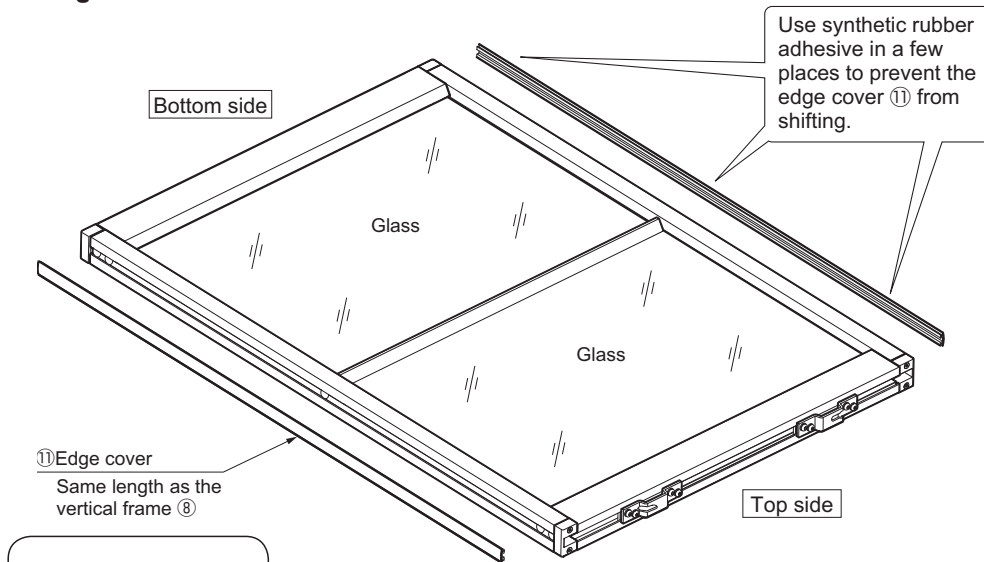
## [7] Assembly of Vertical frame ⑧



You may find the gasket coming off from the frame.  
In such case, use a scraper or something to push it in  
and be careful not to scratch the glass.



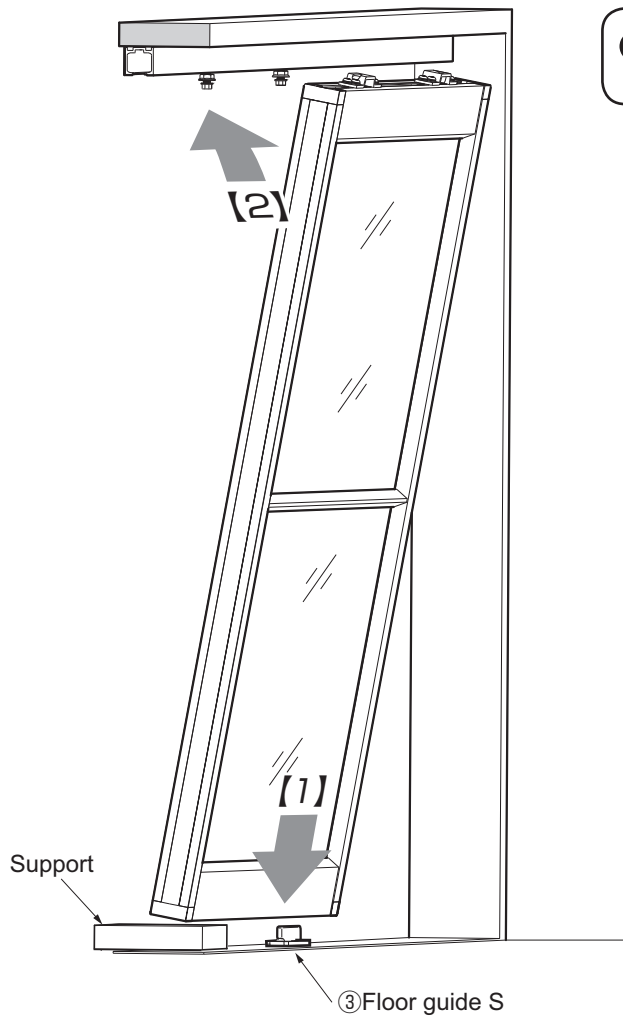
## [8] Assembly of Edge covers ⑪



### ⚠ Caution

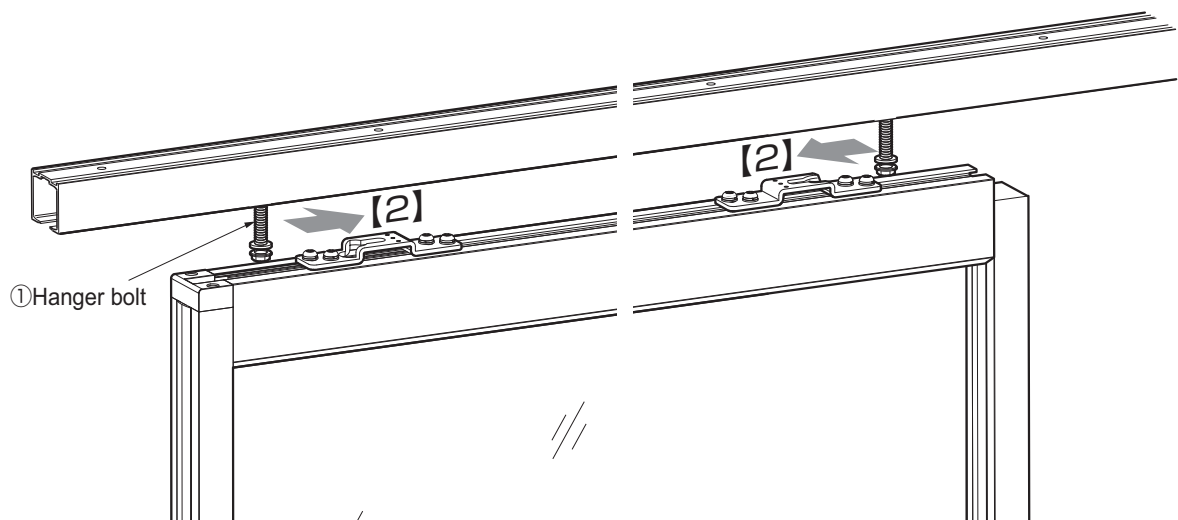
- ❗ Before attaching the edge covers, make sure the frame is not biased or skewed, and that all bolts are tight. Make sure the parts are firmly assembled and there is no warping or skewing.

## 5 Hanging the Door



**⚠ Caution**  
❗ Be sure to have someone with knowledge and experience assist you.

- [1]** Put a support below the door to be hung. Tilt the door as shown in the figure, and set the floor guide S ③ to the groove of the bottom horizontal frame ⑦.
- [2]** Push the door and set the hanger bolts as shown in the figure below.



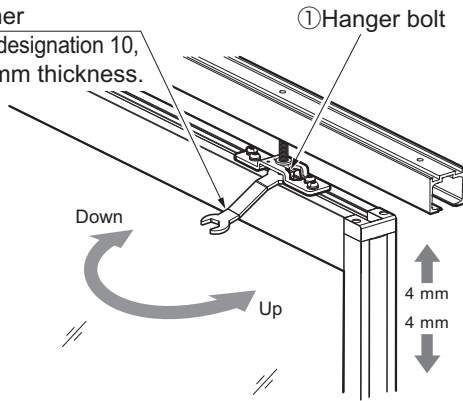
## 6 Adjustment of Door Height

**[1]** Remove the support under the door.

**[2]** Adjust the door so that it is parallel to the upper track with 6-14 mm clearance between the door and floor.

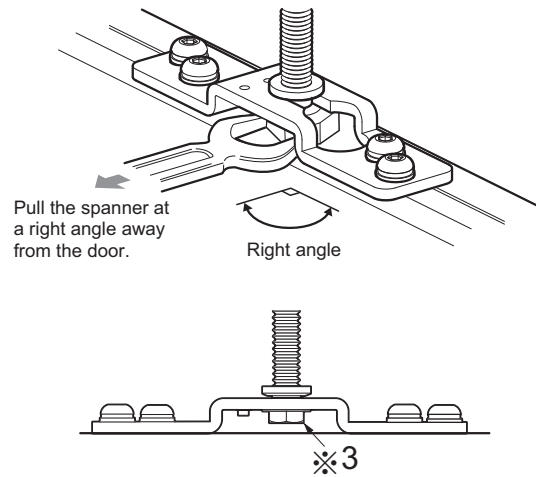
**⑩** Spanner

Nominal designation 10,  
max. 6 mm thickness.

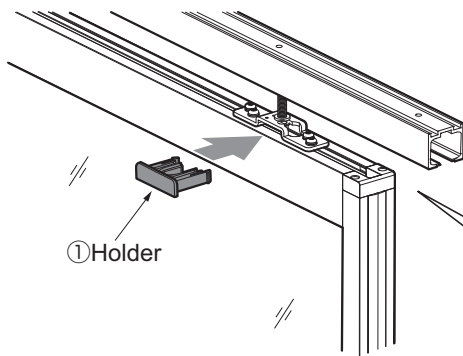


**[3]** After adjusting the door, pull the wrench at a right angle away from the door.

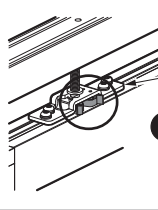
Make sure the width across flats of the bolt head is as shown in the figure ※<sup>3</sup>.



**[4]** Insert the holder as shown below.



**⚠ Caution**



**!** Verify that the claw of the shaft support holder catches the opposite side of the bracket.

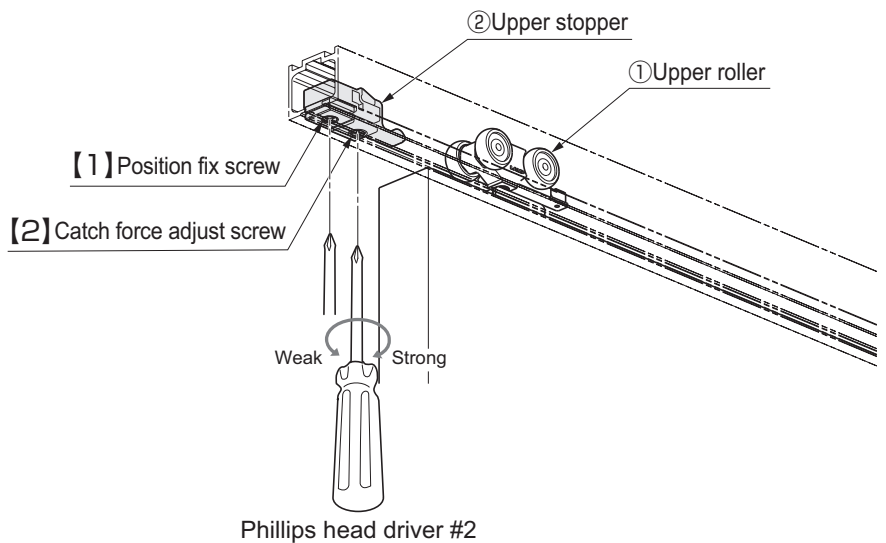
## 7 Fixing Upper Stopper and Adjustment

**[1]** Fix upper stopper ② with the door fully closed.

Set the position of upper stopper such that upper roller in the track contacts with upper stopper, tighten position-set screw with Phillips head driver #2.

**[2]** Using Phillips head driver #2, adjust door catch force by the adjust screw.

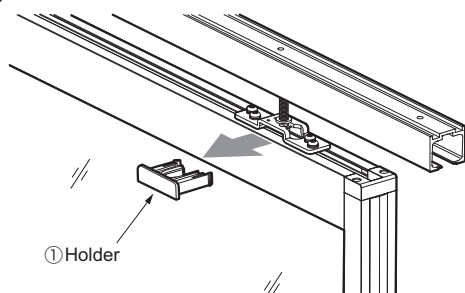
**[3]** Fix another stopper and adjust it at opposite end in the similar manner.



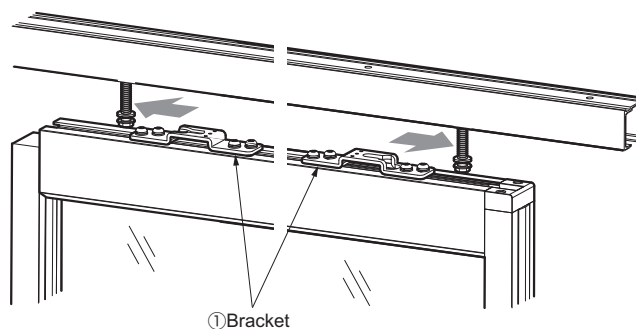
# HOW TO REMOVE DOOR

[1] Put a 10 mm support under the door.

[2] Pull out the holder.



[3] Pull out the upper roller from the bracket.



[4] Remove the door from the floor guide.

**Final verification** | Verify that all screws are securely tightened, and verify that all screws have been used.

**PERIODICAL INSPECTION** | • Clean inside of track.  
• Check upper and lower gaps between the door and frame. If necessary, adjust the gaps.

# TROUBLESHOOTING

Trouble	Checkpoint	Solution
Abnormal noise during operation	Check if door bottom contacts the floor.	Verify that the track fixing screws are not loosened. Then, adjust the door height such that the clearance between the door bottom and floor is 6 - 14 mm.
	Check if door touches adjacent parts.	Correct door position to avoid contact with adjacent objects. Adjust position of the floor guide.
	Check track rollers for aluminum dust.	Remove the track and pull out the roller. Then, clean the roller.
	Check for loose screws retaining the upper track.	Tighten the screw.
Heavy door operation	Check if door bottom contacts the floor.	Verify that the track fixing screws are not loosened. Then, adjust the door height such that the clearance between the door bottom and floor is 6 - 14 mm.
	Check if door touches adjacent parts.	Correct the door position to avoid contact with adjacent objects. Adjust position of the floor guide.
Door does not move.	Check the track retaining screws for looseness.	Retighten screws to free the roller.
Door starts to move.	Check the upper track if it is set horizontally.	Using a level gauge, reset upper track horizontally.

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2019.07 0584-6