

# ULTRA TRADE FRAMES

## Installation guide for the **Residence Collection** and the **Duraflex Diamond Suite**

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## Residence Collection Installation Guide

The following is to give guidance for the installation of the Residence collection of windows and doors.

We advise only to use a 1.8m level or aluminium straight edge when fitting all doors and double doors.

1. Bed the external cill onto a suitable compound. It should be packed under the cill ensuring it is level and not bowed.
2. The frame should be then wedged temporarily to hold it into position.
3. Adjust the wedging until the frame is standing vertically and the jambs are plumb and true from side to side. Check the diagonal measurements of the frame
4. The outer frame should initially be fixed through 4 positions in or near the centre line of the top and bottom hinges and packed behind each hinge.
5. Before tightening hang the sashes into the frame and ensure there is an even gap all round the outer frame (approx 5mm)
6. Fixing should then be between 150mm and 250mm from each corner and 600mm centres.

For the installation of windows follow steps – 1, 2, 3 and 6.

**TO ENSURE CORRECT OPERATION OF THE WINDOWS,  
DOORS AND DOOR SASHES. THE OUTER FRAME MUST  
NOT BE BOWED.**

For ease of installation sashes can be removed by unscrewing the friction hinges from the frame or removing the dummy sashes.

Foam fixing should only be used as gap filler and not an alternative to mechanical fixings. After applying check that the outer frame has not distorted or bowed. Packers can be used between the frame and the brickwork to prevent bowing.

For hinge adjustment please see pages 8 & 9.

Protective tape should be removed as soon as practical, as ageing tapes can be difficult to remove.

In some instances it may be necessary to pack the frame at certain points to achieve levelness of the sashes.

# Dummy Sash Removal

1. Remove bead from sash starting with the sides then top and bottom.
2. Unfasten fixing screws.
3. Remove the sash (the glass will stay in place as it is bonded to the sash)
4. Fix through outer frame.
5. Re -fit the sash.
6. Re fit the beads.

When removing the dummy sash with astragal bar, the bar is temporary glazed in the factory with the backing tape left on so the sash can be removed in the same way as above.

When re - applying the bar remove the backing tape and ensure the glass is thoroughly cleaned with alcohol wipes or similar apply firm pressure using a seam roller.

After application the bond strength increases and approaches the ultimate bond strength after 72 hours.

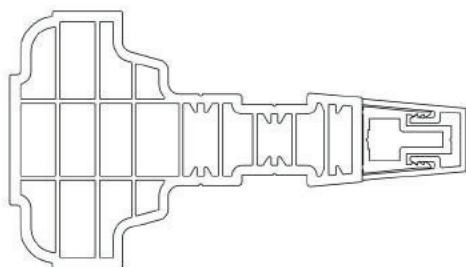
## Fitting the External Weather Bar

The weather bar is supplied in two parts; an aluminium channel which is pre-cut to the same size as the transom bars and a pvc cover which is cut approximately 200mm longer.

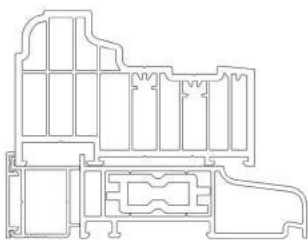
To fix the channel pre-drill and use 4.8mm self tapping screws 50mm long @ 600mm centres in the centre of the transom bar.

Cut the cover at 45° each end using the off cuts also cut at 45° for end caps.

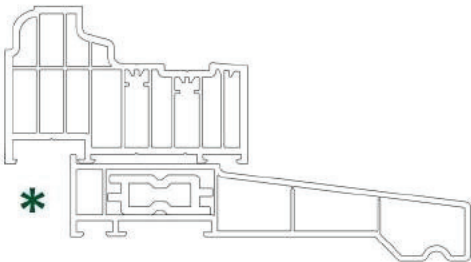
Please note the weather bar is only available in 3m lengths and will have to be mechanically joined if the frame is longer.



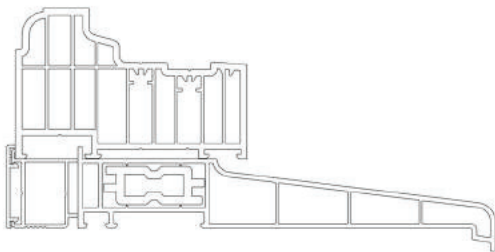
# Residence Collection Cill & Frame Cross Sections



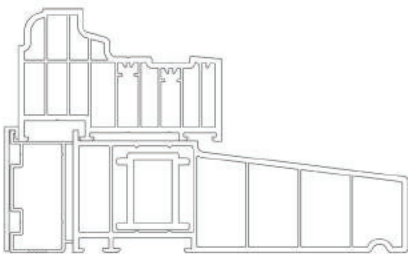
95mm x 30mm Cill



165mm x 30mm Radlington Cill



180mm x 30mm Cill



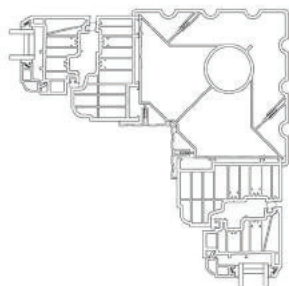
165mm x 55mm Radlington Cill

Cills can be fitted with or without cill infill.

\*Note: Replacement window board can be tucked under frame when not using the cill infill. \*



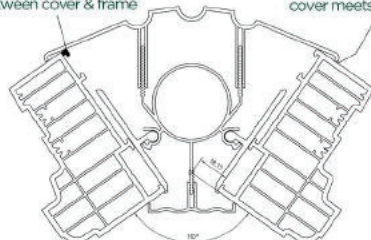
# Corner Post, Baypoles & Couplers cross sections



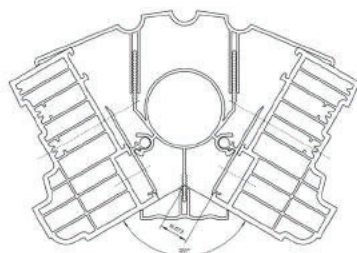
90 Square Bay Post

Removal of this leg will reduce gap between cover & frame

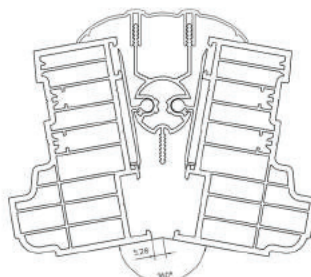
Possible gap where the outer cover meets the frame



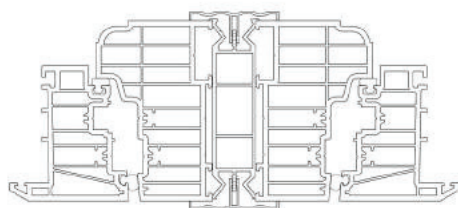
100 - 119 Bay Pole



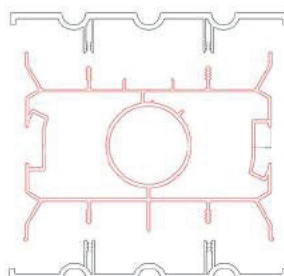
120 - 150 Bay Pole



151 - 179 Bay Pole



24mm coupler

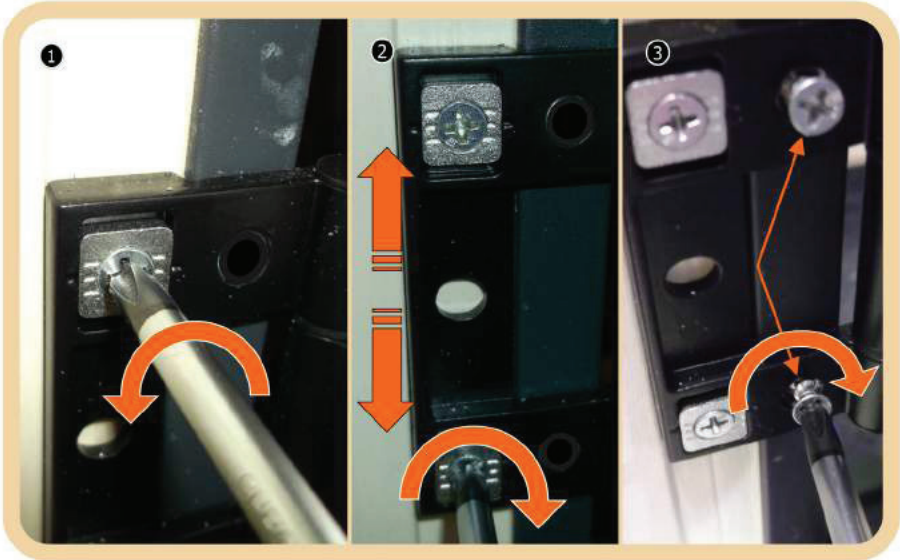


132mm coupler

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# Hinge adjustments

## Height Adjustment:



Slacken top and bottom  
frame screws on all hinges

Move window sash up or  
down as required and  
tighten frame screw up

Insert fixed hole frame  
screws to all hinges

Sheet 1 of 2



## Lateral adjustments

**To increase the gap on hinge side:** *(1 full thread showing = maximum gap)*



Turn Grub Screw anti clockwise to turn out

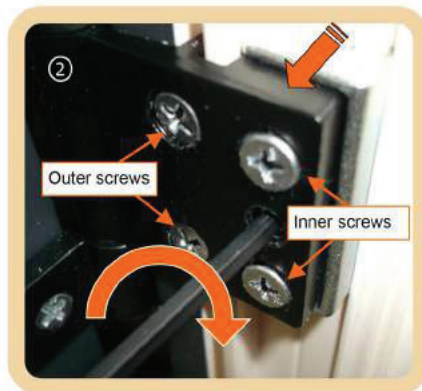


Tighten inner screws  
Then check outer screws are tight

**To decrease the gap on hinge side:** *(3 full turns in from flush = minimum gap)*



Slacken off inner screws



Turn Grub Screw clockwise to turn in  
Then tighten inner screws back up  
Then check outer screws are tight

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# Duraflex PVCu Window & Door Installation Guide

The following is to give guidance for the installation of Duraflex PVCu windows and doors.

We advise only to use a 1.8m level or aluminium straight edge when fitting all doors and double doors.

1. Secure the cill onto the outer frame – pre drill the cill with a 3.5mm drill bit at 300mm centres. Invert the frame and apply a bead of low modulus silicone along the length of the frame and return across both ends. The cill is then placed onto the outer frame and screwed into place – either from the top down or bottom up.
2. Turn over the frame and apply silicone to the ends of the frame to seal.
3. Secure the cill end caps using super glue.
4. Use plastic packers to level the cill ensuring a 5mm gap between frame and opening.
5. The frame should then be wedged temporarily to hold it into position.

6. Adjust the wedging until the frame is standing vertically and the jambs are plumb and true from side to side and diagonally from corner to corner.
7. Remove the glazing beads from fixtures (sides first then top and bottom) and mark to ensure correct position. later when glazing.
8. Drill holes through the frame between 150mm and 250mm from each corner and 600mm centres ready to insert the frame fixings. Place a plastic packer between the fixing and the opening. Do not over tighten the fixings as this could cause the frame to bow.
9. Before positioning the glass place a plastic bridge packer in the frame recess. Position the glass unit using glazing packers (see page 12 for full details).
10. Fit the top and bottom beads first and then the sides.
11. Seal the outside using silicone and the inside using acrylic.

Foam fixing should only be used as gap filler and not an alternative to mechanical fixings.

After applying check that the outer frame has not distorted.

Protective tape should be removed as soon as practical, as ageing tapes can be difficult to remove.

# Glass packing details

To ensure the correct operation of the windows/doors it is essential that glazing shims/packers are positioned as shown below:

Fixed Window



Top Hung

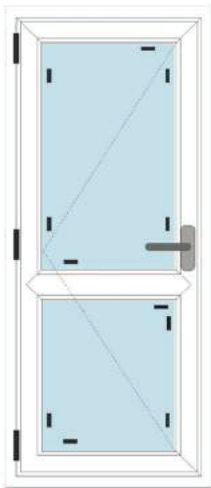


Side Hung

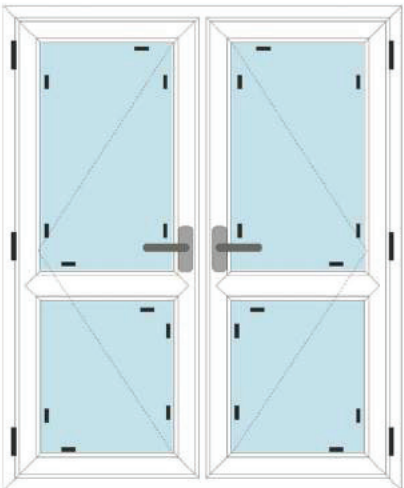


Beads are supplied in two formats, Scribed and Mitred.  
Scribed beads are supplied with 2 pieces square cut and 2 pieces milled to follow the featured detail of the bead each end. The square cut beads are fitted first, followed by the scribed beads and fitted as detailed in figures 1 and 2.

Residential Door



French Door



## Fitting of glazing beads

Fig 1  
Insert back leading leg  
into the bead retention slot



Tilt the bead to insert the leading leg of the bead under the main profile bead under the main profile bead retention slot (A)

Fig 2  
Push downwards  
or tap with rubber mallet



Apply pressure to the back face of the bead. This causes the bead leading leg to spring back allowing the beads short leg to snap under the main profiles bead retention leg (B)

## Door Lock adjustment



Shootbolt Adjustment  
+/- 2mm



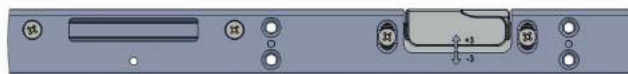
To reverse the latch position: Undo the screw, turn the latch around & then re-tighten the screw



Latch Casting Adjustment  
+/- 3mm



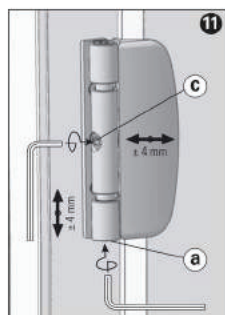
Roller Adjustment  
+/- 1mm



Roller Casting Adjustment  
+/- 3mm

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## Door Hinge adjustment



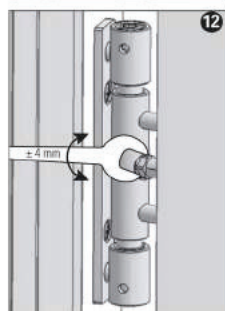
### Adjustment Instructions

Horizontal adjustment:

adjust by turning screw (c) with a 5mm Allen Key.

Height adjustment:

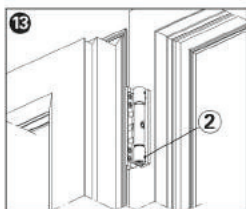
adjust by turning screw (a) with a 5mm Allen Key.



In difficult situations it is possible to make the horizontal adjustment from inside turning the hexagonal nut with a 9mm spanner.

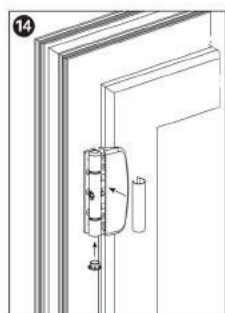
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### Adjustment Instructions continued

Open the door and tighten security screw (2).



Insert the lower cap and the cover cap as shown in fig. 14.

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