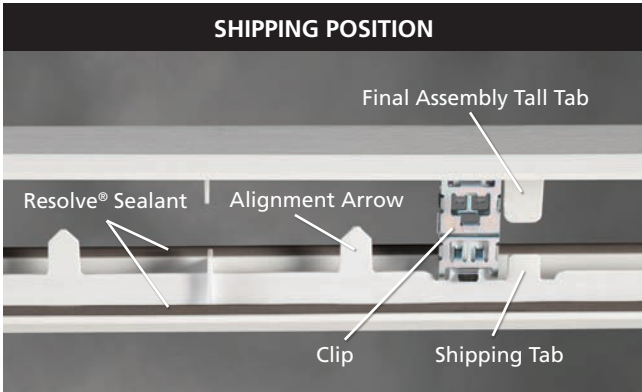


ZEEL™ Frame Assembly Instructions

Tools needed: flat, stable working surface, rubber mallet, safety glasses



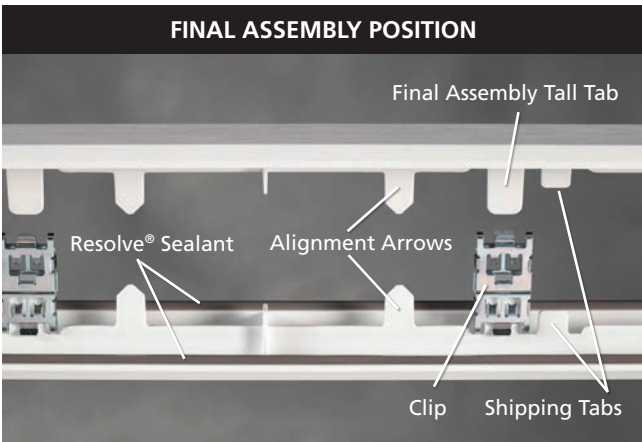
1. Getting Started

- Grasp each end of the assembly and remove from box.

Tip: The Resolve® Sealant does not adhere to the IG, so lifting in the middle will cause the frame to flex away from the IG. Doorlights larger than 22x36 will require 2 people to remove. Smaller sizes and sidelights require 1 person.

- Place assembly on a table, or other flat, solid and stable surface, that is larger than the IG/Frame assembly with the outer frame face down.

Tip: Outer frame has Resolve Sealant and clips attached.



2. Remove Inner Frame

- Assembly is received with frame in the shipping position (short tabs engaged in the clip).

Tip: The frame set has four alignment arrows that are on the opposite sides of the inner and outer frames during shipping.

- Work around frame and gently loosen the shipping tabs out of the clips.

Important: Do not pull one end of the frame up or tabs may break.

- Remove inner frame and set to the side.
- Inspect outer frame to ensure all clips are in a vertical position.





3. Place Door Over Outer Frame

- Align door carefully over the outer frame and lower door.

Important: Do not drop the door on clips as this may damage the clips and tabs

Tip: If using a lift, make sure frame is aligned prior to lifting frame and IG into door cut-out.

- Ensure the door cut-out is in contact with the Resolve Sealant.

Tip: The frame fit to the door cut-out is the same as other frames produced by ODL. Some movement is required due to frame and door cut-out tolerance. Doorglass and outer frame assembly should be positioned so that the frame is aligned with the bottom of the door cut-out.



4. Prepare for Installation

- Rotate inner frame 180° from shipping position.
- Match up the alignment arrows along the vertical section of the frame. (This will allow the tall tabs to line up with the clips.)
- Start in one corner and align the tall tabs into the clips. Proceed down the long side of the frame, aligning tabs to clips until you reach the opposite corner. The remainder of the frame can be laid down and tabs should be aligned.

IMPORTANT: ENSURE ALL TABS ARE ALIGNED. Visually verify that all tabs are aligned into the top edge of clips. This is critical to success. Visually inspect along the glass edge that each tall tab is inside the top edge of clip.



5. Install Inner Frame

- Gently work your way around the frame, pressing the long tabs into the clips.

Tip: In this initial step you will feel a friction fit to the clip. When you feel increased resistance STOP.

- Press the door down with one hand to put compression on the Resolve Sealant. Use a rubber mallet to lightly tap the tabs into the clips as you work your way around frame.

Tip: You may need to go around the frame a few times with increasing force to get the frame fully seated to the door.





6

6. Inspect Inner Frame for Gap

- Inspect perimeter of inner frame to glass, and inner frame to door, for any gaps.
- If gaps are present, repeat step 5.

Tip: If repeating step 5 is not successful and a gap is still present, a clip was likely missed. Carefully lift frame at gap location and attempt to align frame tab into clip (This can be done but it is difficult. A prybar may be needed to gently lift frame). Then repeat step 5 again. If a gap cannot be eliminated and the frame has movement away from door by hand, the frame will need to be completely removed and replaced.

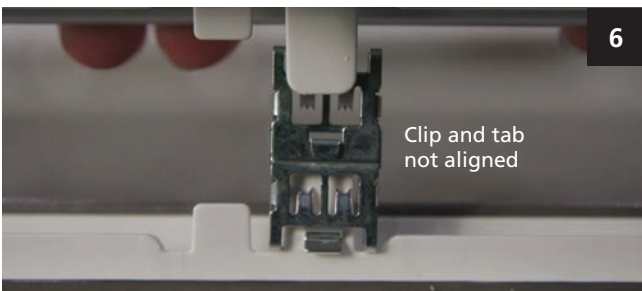


6

7. Inspect Outer Frame for Gap

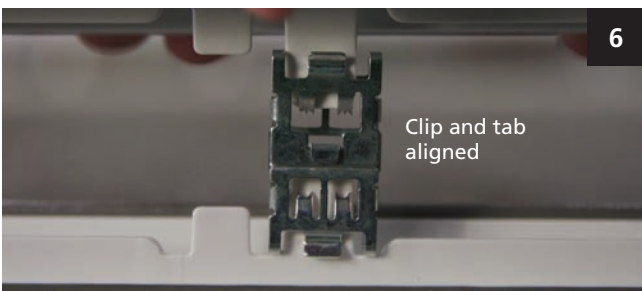
- Flip door and inspect perimeter of outer frame to glass, and outer frame to door, for any gaps.
- If gaps are present place the assembly on a table, or other flat, solid and stable surface, that is larger than the IG/frame assembly with the outer frame face up, and repeat step 5.

Tip: If repeating step 5 is not successful and a gap is still present, a clip was likely missed. Carefully lift frame at gap location and attempt to align frame tab into clip (This can be done but it is difficult). Then repeat step 5 again. If a gap cannot be eliminated and the frame has movement away from door by hand, you have likely missed a clip.



6

Clip and tab
not aligned

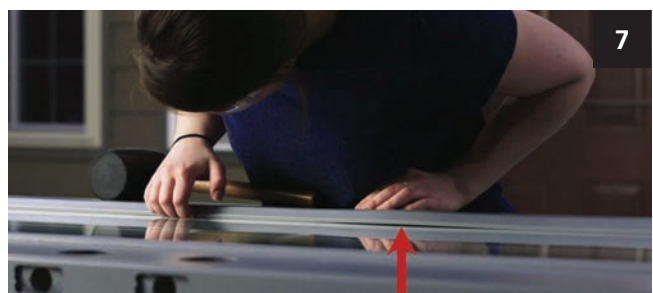


6

Clip and tab
aligned



7



7