



GIESSE OPEN SOURCE SYSTEM

FABRICATION MANUAL STANDARD DOORS GOS-S

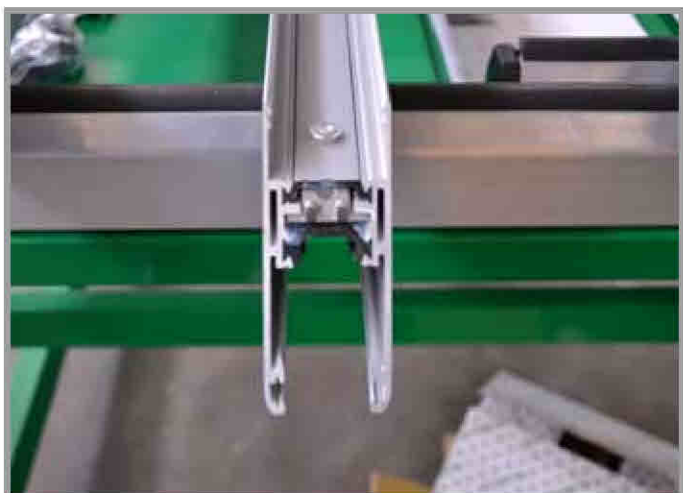
U0505000-REV01-10/2013

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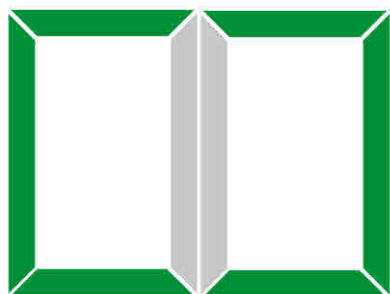
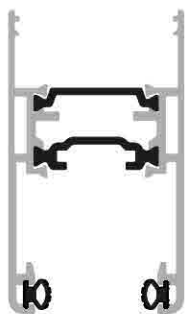
C.2 Insert Corner Joint

Insert the two parts of the corner joint in each sash profile

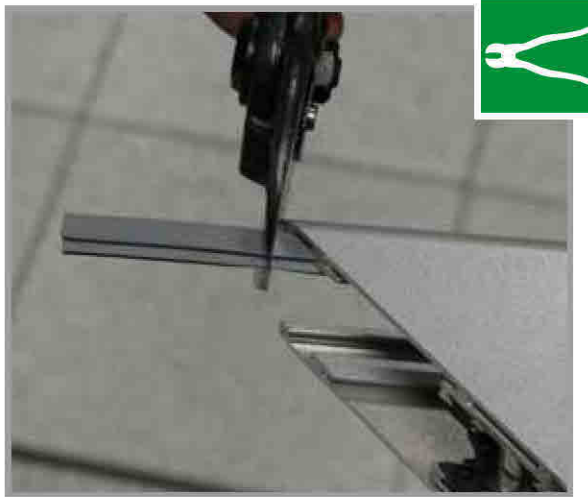
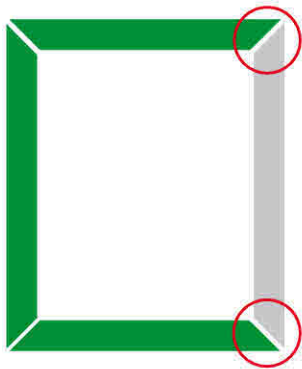


C.3 Insert Gaskets

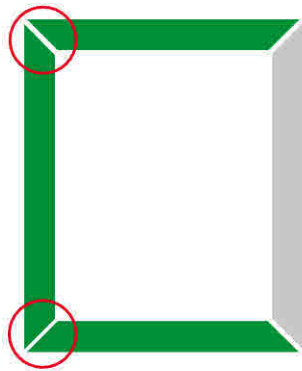
Insert the gasket in sash profile



Cut the gasket at 90° at the edge of the sash profile



On the other side of the sash cross beam, cut the gasket at 45° leaving it 3-4 mm longer

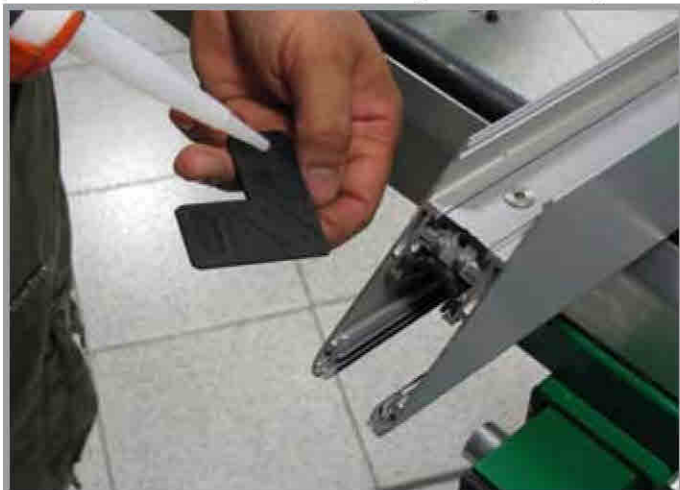


NOTE

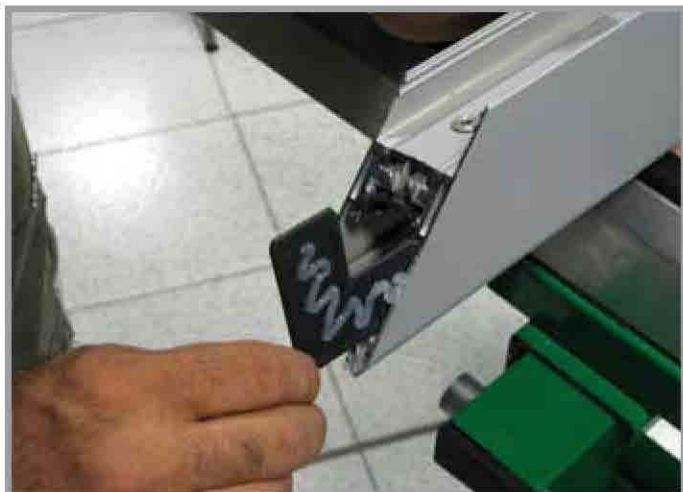
Do not put gasket in central groove sash profiles, where cover profile will be applied.

C.4 Insert Alignment Corner Joints

Put silicone in alignment corner joint, in the side that will be in contact with aluminium

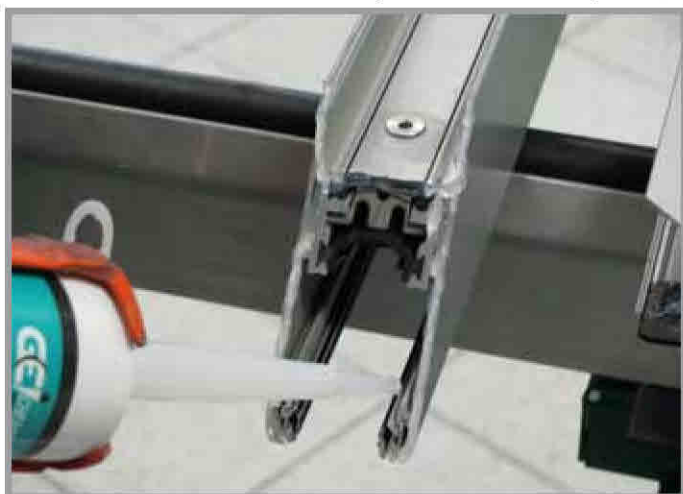


Insert plastic alignment corner joint on upper and lower sash profile

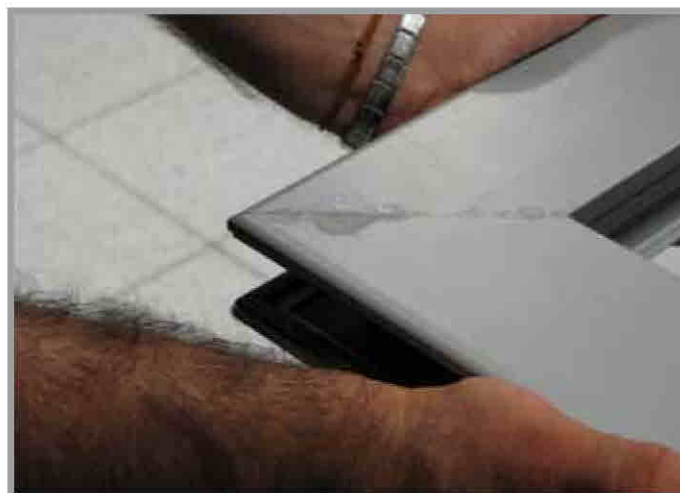


C.5 Assemble Sash

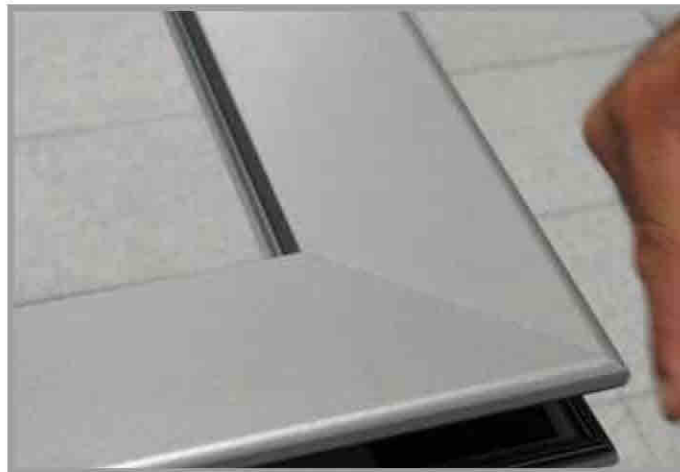
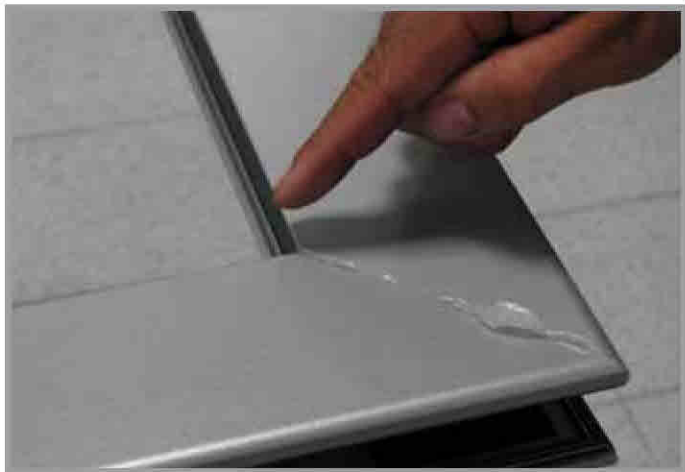
Put silicone on the perimeter of sash profile, where plastic alignment corner joints are not present



Close sash corners

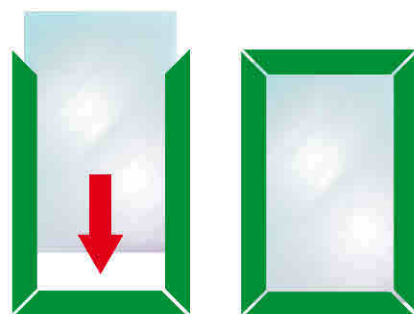


Clean excess of silicone



GLASS:

In case of **insertion glass**, first close the lower crossbeam with the two uprights, proceed with section C.6 (Seal Sash), then slide the glass panel from the upper side of the sash and then close with the upper crossbeam profile.

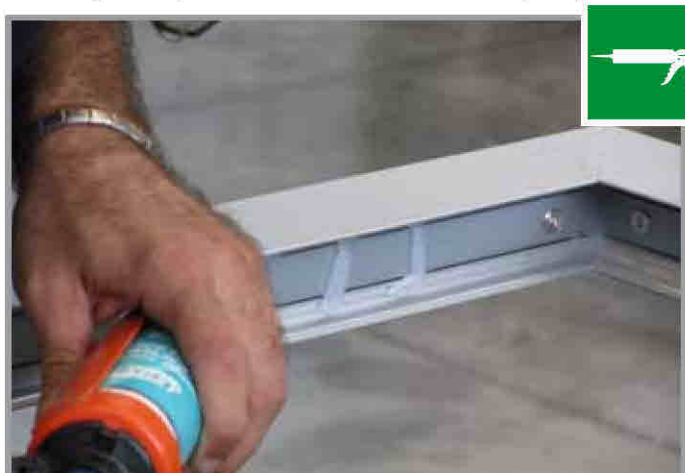


C.6 Seal Sash

Seal the bottom sash corner on both sides



Fix the glass spacers with silicone over the pulleys



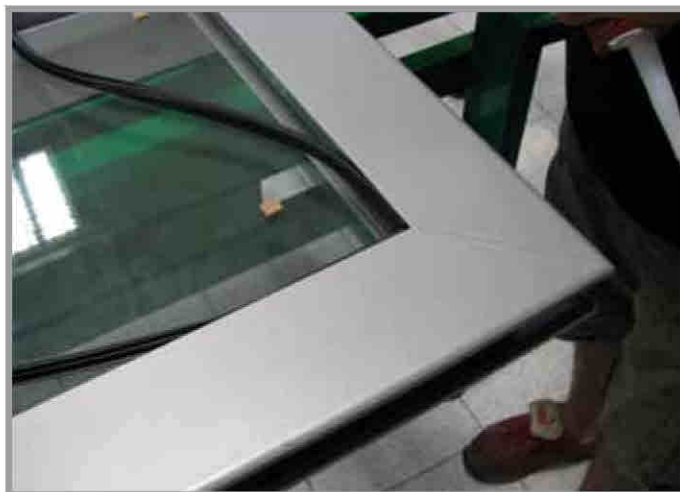
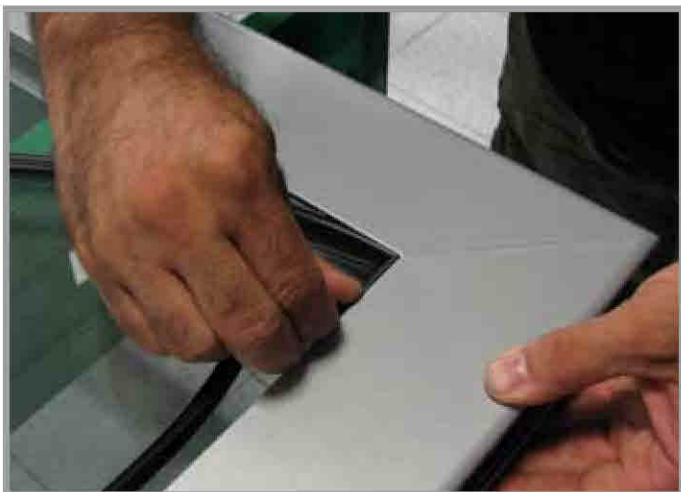
Fix glass spacers on the sides, top and bottom.

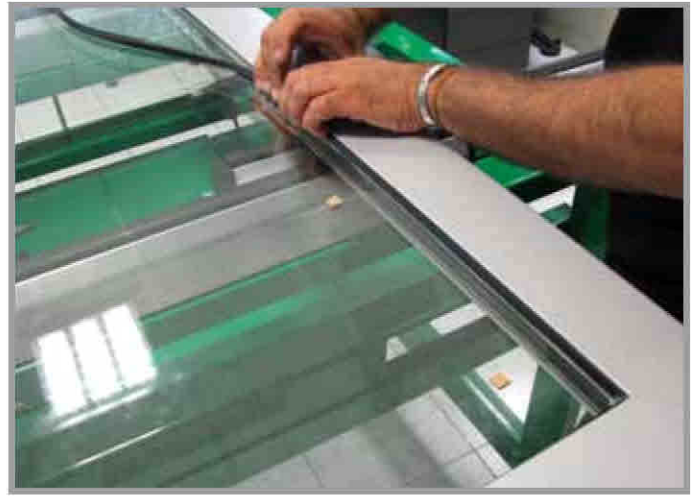
C.7 Insert Glass Gaskets

Use **gasket** typology which compresses the glass **1-2 mm more** than the one which would be used in standard situations (required to have a better grip on the glass at high pressures during tests).

Example: If standard application requires gaskets 5 mm, for test better use 7 mm gaskets (on both sides).
For a correct positioning of the gasket, it must be inserted from a corner, and advancing from it.

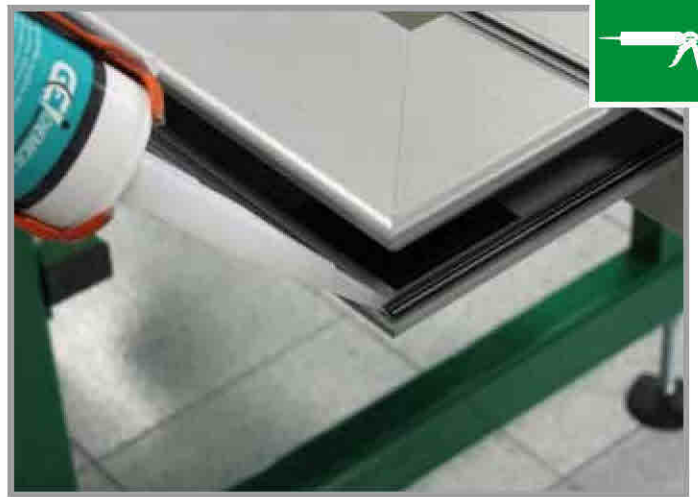
Insert gasket in the corner





C.8 Assemble Cover and Labyrinth

Put silicone in the internal side of the profile where cover profile will be snapped



Snap cover in



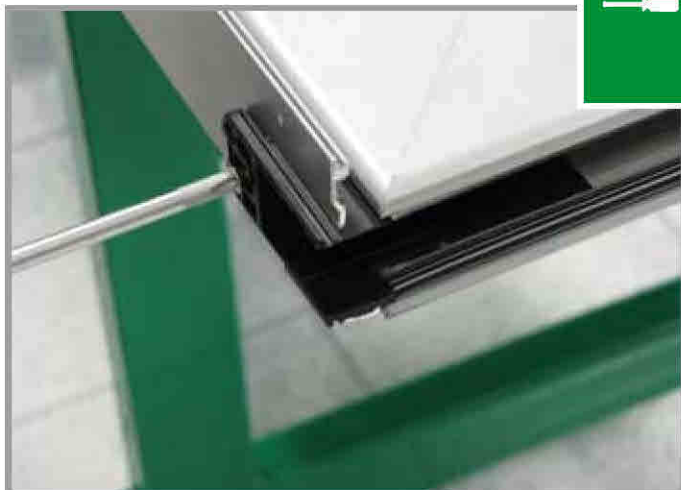
Insert plugs to define the correct position of the cover profile



NOTE:

Make sure that the gasket is cut at 90° on this side.
If necessary, correct the gasket and/or plug position.

Fix plugs with screws (top and bottom)



Seal the cover profile on the side of connection with labyrinth profile

