

# ALT SL130

Sliding /  
Lift and slide door  
Installation manual





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# General information

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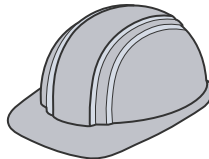
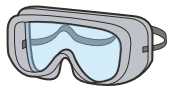
The proper door assembly is a main condition for high performance of the product. The recommended step-by-step installation process of ALT SL130 lift and slide door is shown in this Manual. All the existing norms and regulations applicable to the installation of lift and slide doors must be strictly observed. The contents of this Manual can not be the basis for legal claims. ALUTECH keeps the right to make changes and additions to the lift and slide door structures as well as to this Manual.

## 1. Safety measures

- Read and fully understand the installation guide before starting work.
- Do not work alone. Two or more people are required. Use safe ways to lift large and heavy structures.
- Be careful while handling the glass. Broken or cracked glass can cause serious injury.
- Use protective equipment (for example, goggles, gloves, ear protection etc.).
- Use safe hand/electric tools and follow the operation manuals.
- Be careful when working at height.
- Observe occupational safety regulations.

Only qualified and authorized personnel with the understanding of structure and its installation procedure who got through training and assessment of knowledge in occupational safety must install the door. The national safety rules and regulations must be strictly observed during installation.

### Protective equipment



## 2. Aperture requirements

Prepared apertures must meet the following requirements:

- The surfaces of the framing must be in the same plane and must be even and smooth, without plaster unevenness or cracks.
- The space required for the door installation must be free of engineering structures, heating and ventilation pipelines, etc.
- Apertures for window and door installation must be arranged according to local technical regulations or/and project design documentation.



## 3. Frame installation rules

- Carry out a pre-installation inspection of sliding door system on the following parameters of the finished product:

	Nominal dimensions range, mm	Limit deviation, mm
Frame internal dimensions	>1 000	+1.0
Door leaf external dimensions	>1 000	-1.0
Straightness deviation (length and width)	for 1 m of any frame segment	1.0
Flatness deviation	for 1 m of any segment	1.0
	for the whole length	3.0
	for external surface of adjacent elements	0.3
Diagonal length difference	≤1 000	1.0
	1 000–2 000	2.0
	>2 000	3.0

- The frame should be placed symmetrically to the vertical axis of the aperture.
- While making the frame assembly, its components must be vertically and horizontally leveled.
- The frame must be securely fixed and not pose a danger to human life and health.
- The fixing elements should be selected in accordance with the material used for the apertures. Screws must be made of steel with at least 9 microns of anti-corrosion coating. The strength class of the screws is not less than 5.6. All fasteners must be resistant to corrosion.
- Building products and supplies used for arrangement of door and window apertures must comply with current local regulations, have manufacturer's quality documents and, in accordance with current legislation, certificates of conformity. Replacement of products and materials in accordance with the project design documentation must be carried out according to the established procedure.

## 4. Door installation

Prior to the installation, it is recommended to make the visual examination of the door for:

- the correct parameters of the ordered product (size, opening scheme, colour, hardware, glazing, etc.);
- the integrity and availability of all system components;
- the tight corner joints, absence of cracks, gaps, missing areas and/or other damage.

The aperture as well as rough (finished) floor must be completely prepared before the door installation.

It is necessary to ensure proper waterproofing, steam isolation, and effective joint insulation in accordance with the project design documentation. In case of having any construction works in the area of lift and slide door installation, the door itself should be protected from splashes of mortar, cement, gypsum, aggressive substances (acids and alkalis), paint, etc.

## A collection of various construction and carpentry tools. In the top left is a grey cordless power drill. Below it are three drill bits of different sizes. To the right of the power drill is a long, thin metal hand drill. In the center is a metal caliper. Below the caliper is a long, grey spirit level. To the left of the level is a blue and black tape measure with '5m' marked on the reel. Below the tape measure is a claw hammer. To the right of the hammer is a grey sandbag with a black pump handle. In the bottom right corner are two air tools: a blue and grey air blower and a blue and black air nailer.

Remove all the protective film within two months after completing the door installation. Clean the polluted areas of the door. Cleaning can be done with pure water or non-aggressive detergents using a sponge or a soft cloth. Do not use abrasive cleaners or products containing alcohols.

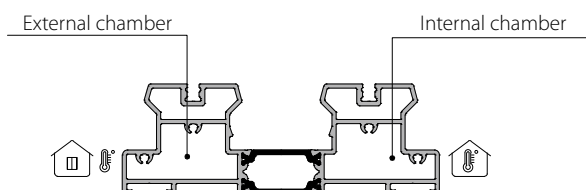
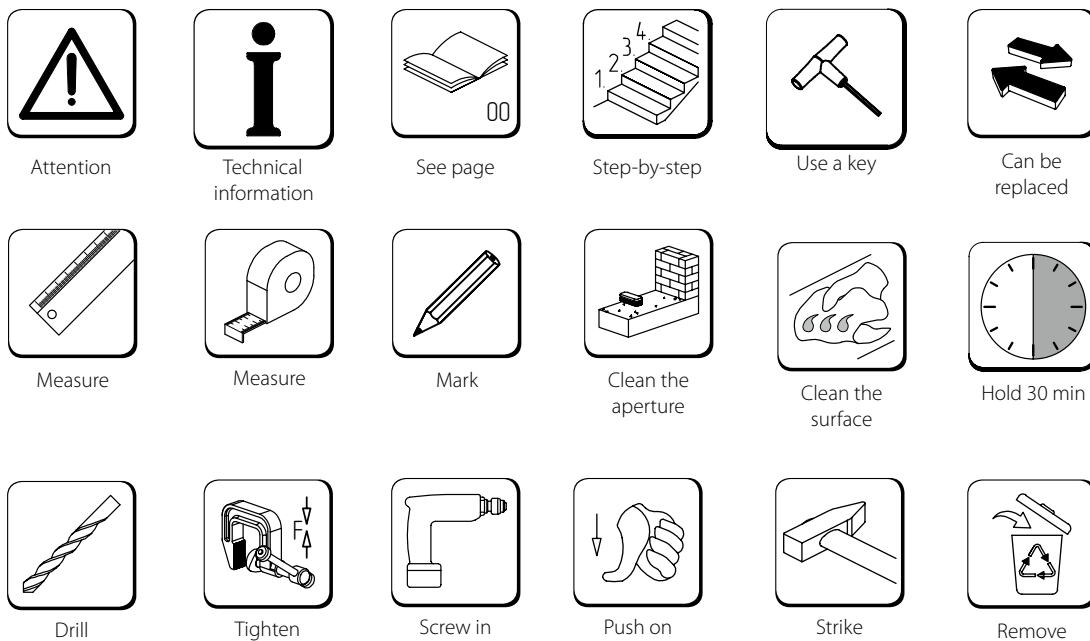
The working capacity of the door must be checked by three open-close cycles. Hardware must work without jamming.

For sliding doors with the electric motor, check automation system operation in all programmed modes.

The assembled door delivery to the customer is carried out according to the local regulations in the following order:

- a representative of the installing company makes a full demonstration of the door operation;
- maintenance documentation issue.

# Information pictograms and symbols

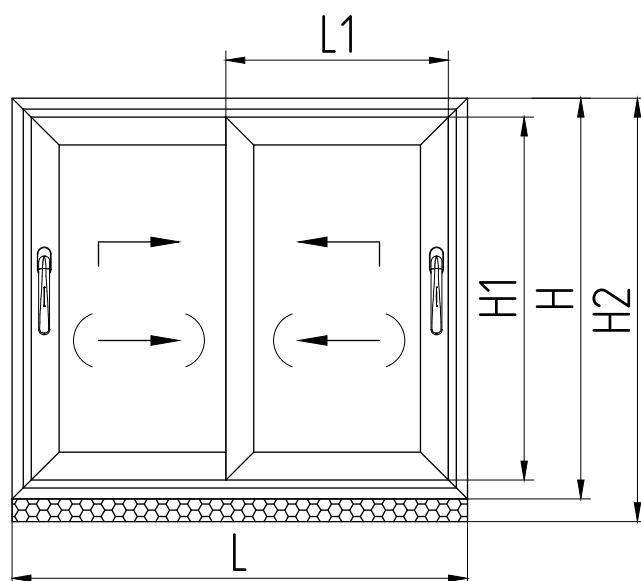


## Door drawing

H – frame height  
 H1 – leaf height  
 H2 – door height  
     with supporting profile  
 L – door width  
 L1 – leaf width



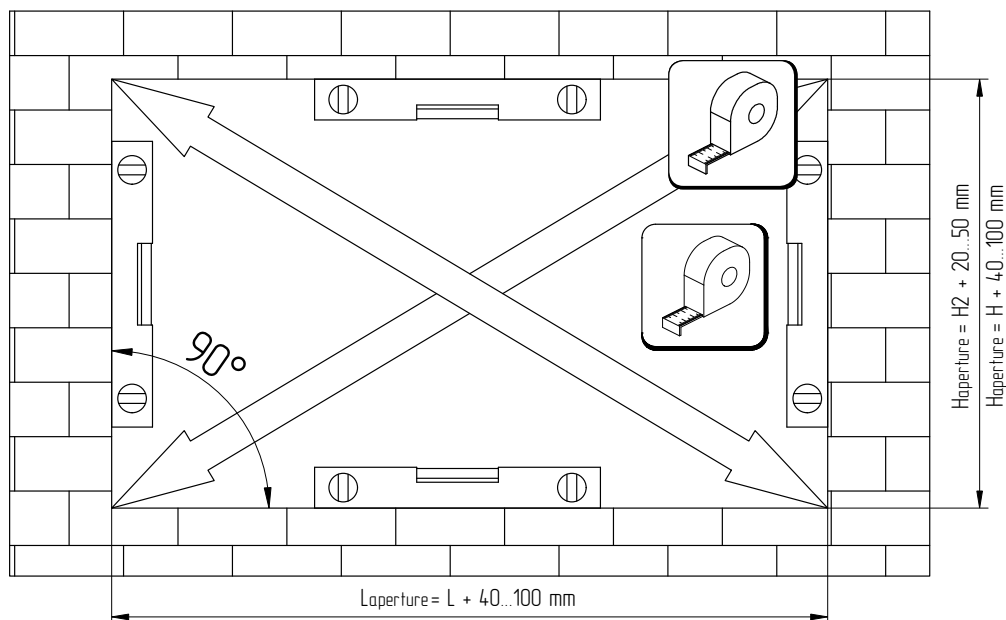
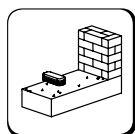
$$\frac{H1}{L1} \leq 2.5$$



# ALT SL130 system installation

1

Check if the dimensions comply with the project design documentation or/and local technical regulations.

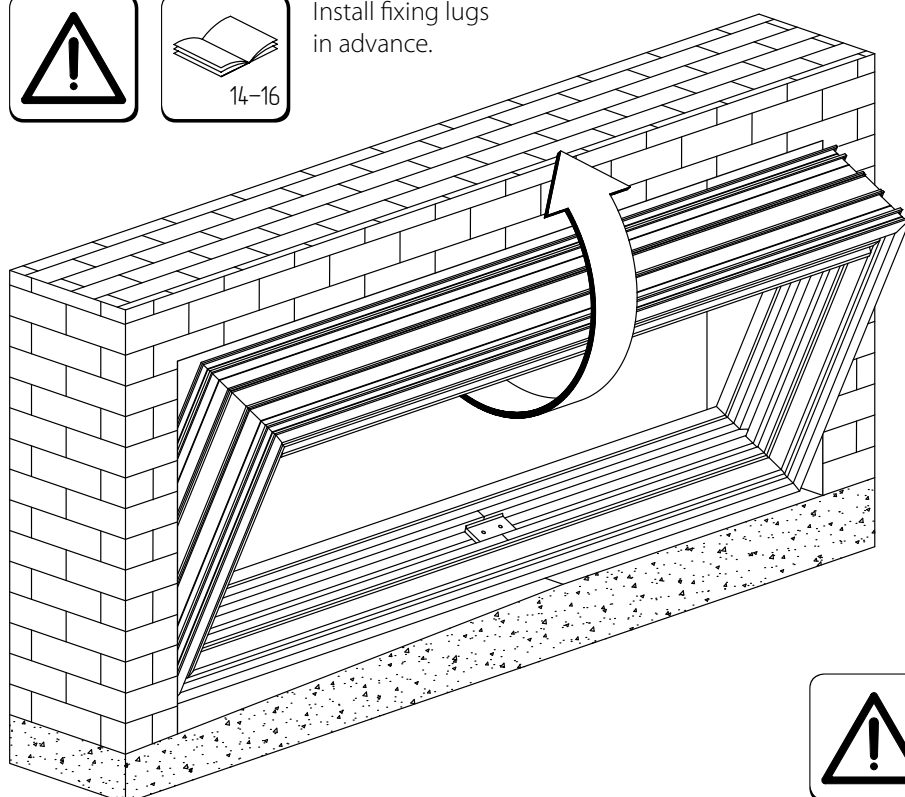


2

Prior to installing the frame, prepare the door aperture according to project design documentation or/and local technical regulations.

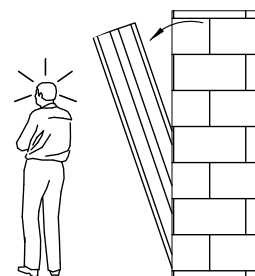


Install fixing lugs in advance.



Prepare the frames for installation into the door aperture:

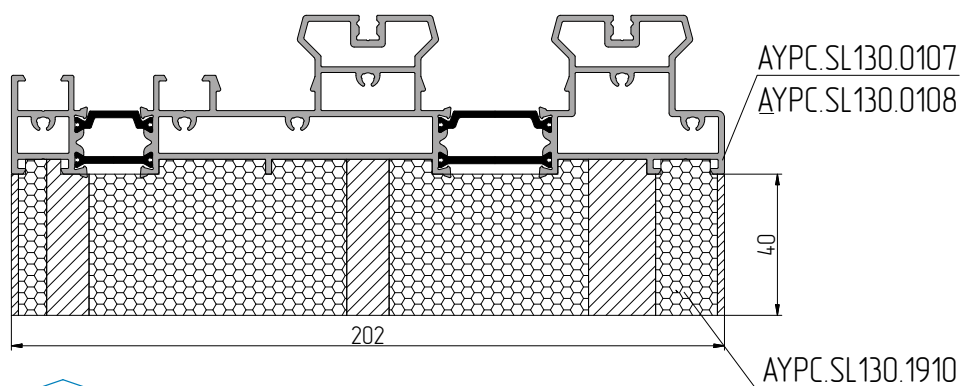
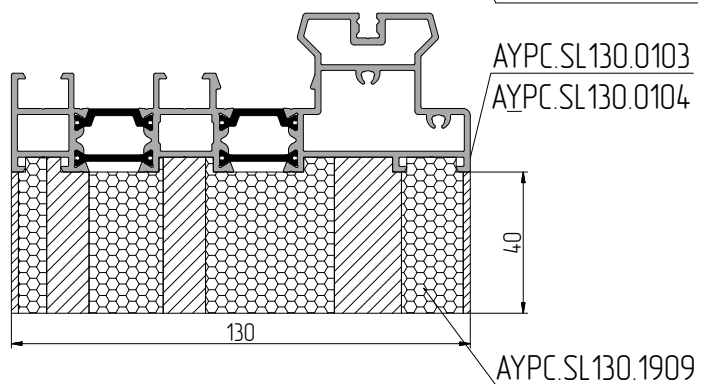
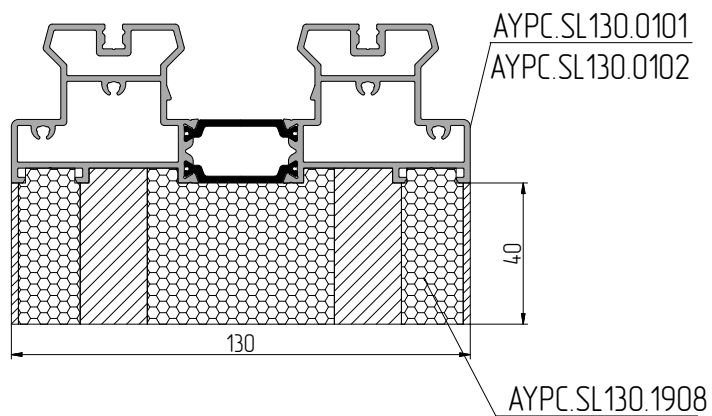
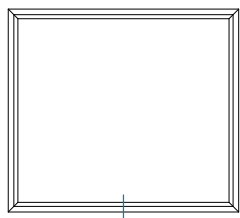
- take down active door leaves;
- take out glass units from fixed light. It is recommended to mark the glass beads and glass units.



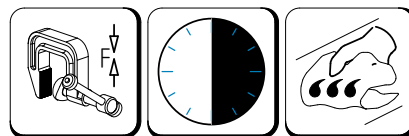
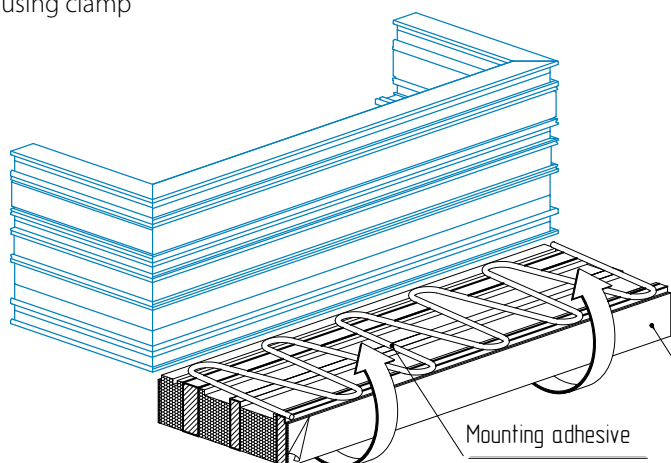
Do not leave the structure unsecured.

# ALT SL130 system installation

## Installation of supporting profiles AYPC.SL130.1908 / 1909 / 1910

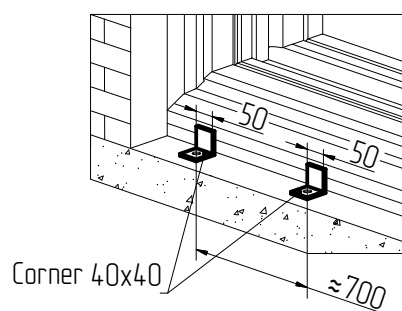
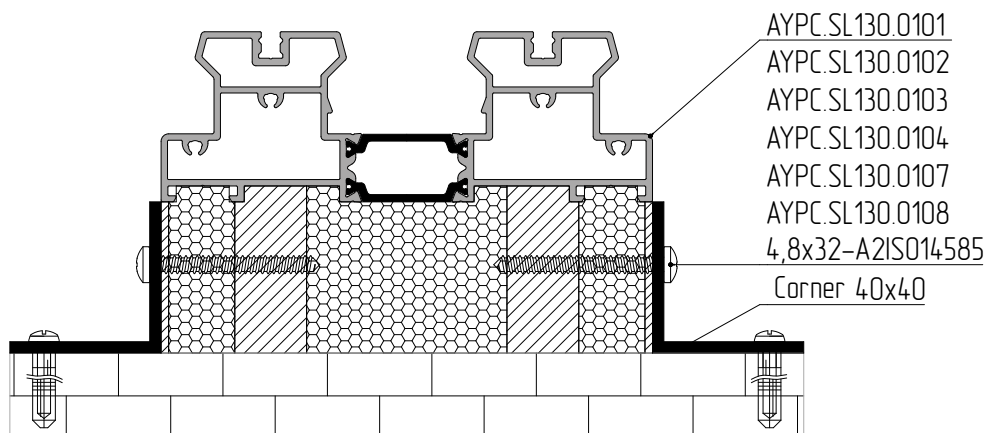
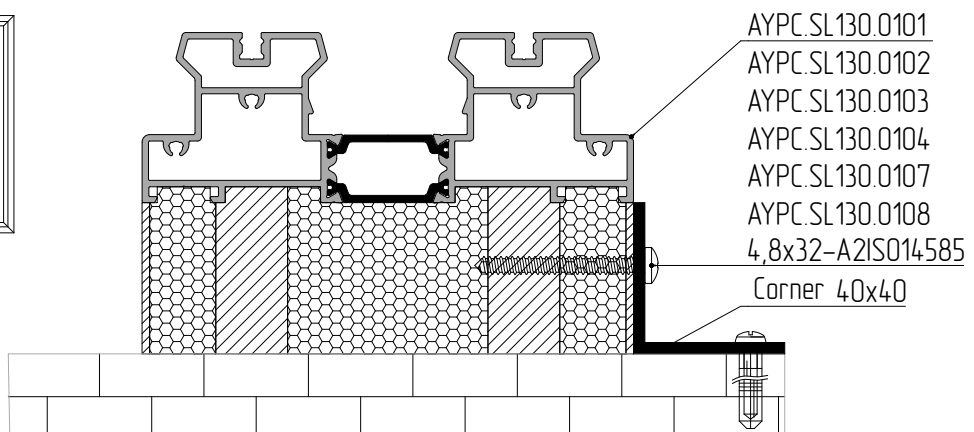
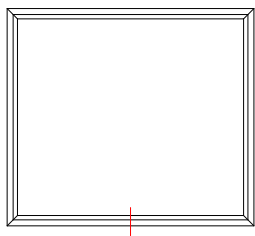


Use support blocks when using clamp



# ALT SL130 system installation

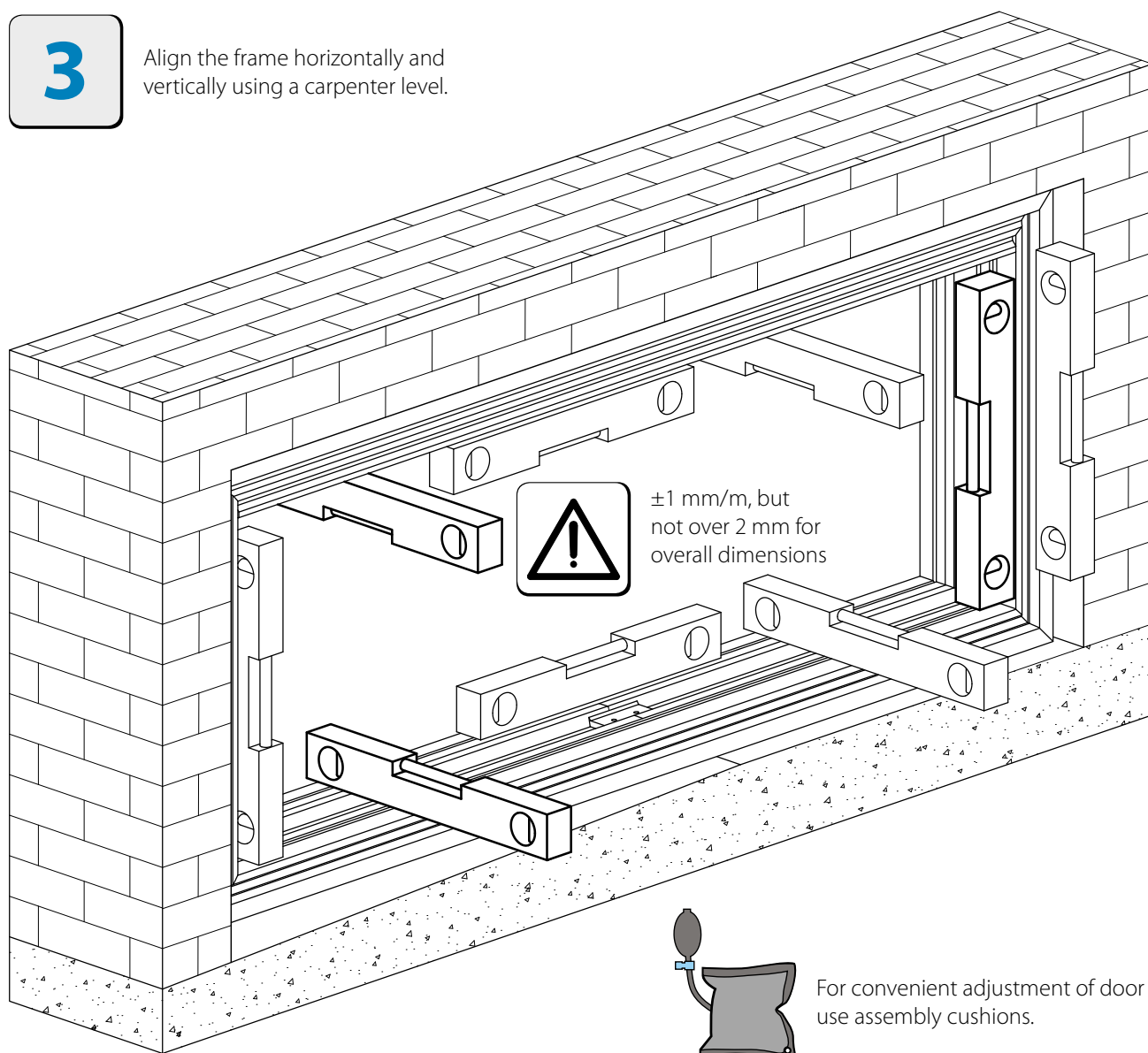
## Installation options



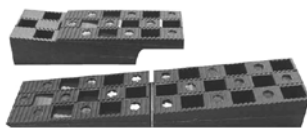
## ALT SL130 system installation

3

Align the frame horizontally and vertically using a carpenter level.



The door is installed into the aperture on bearing supports.



- Use spacer blocks and a carpenter level to ensure that each window or door frame is horizontally and vertically level. The bearing supports and spacer blocks must be installed so that they do not cause any deformation to the structure.
- Do not install bearing supports and spacer blocks in fixing points.
- Material: antiseptic wood, plastics, paronite.

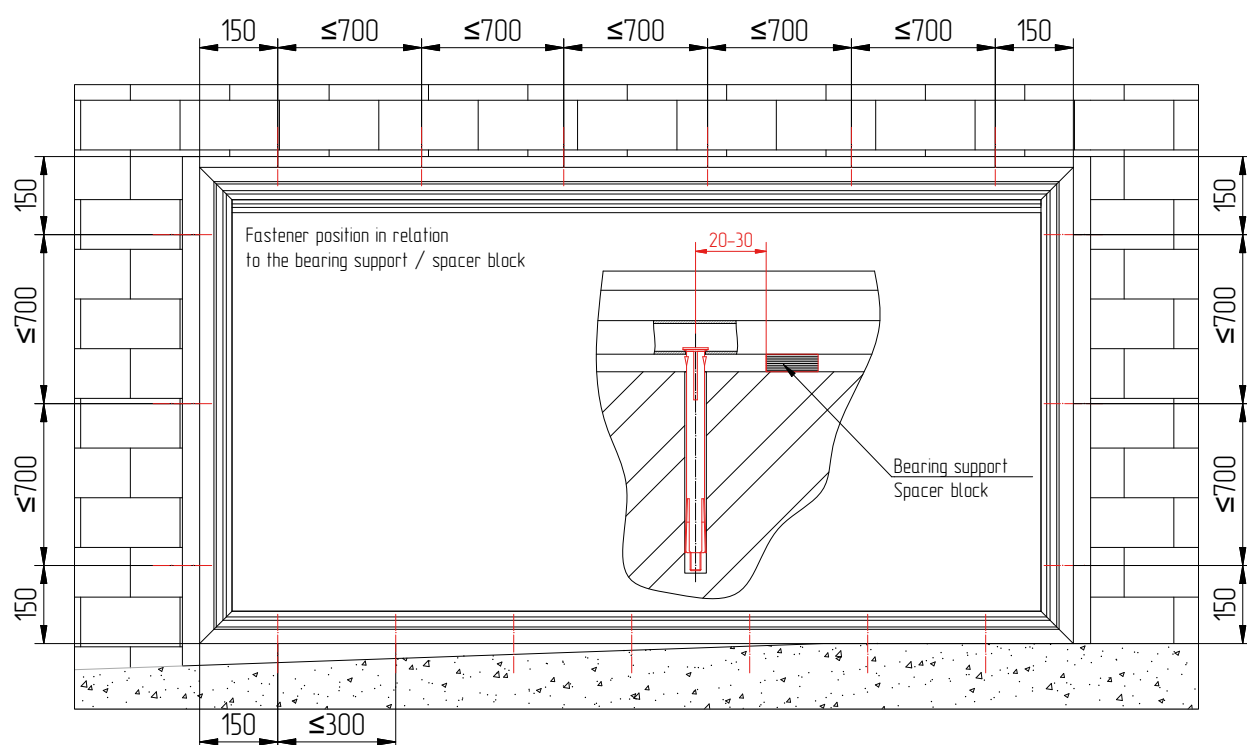
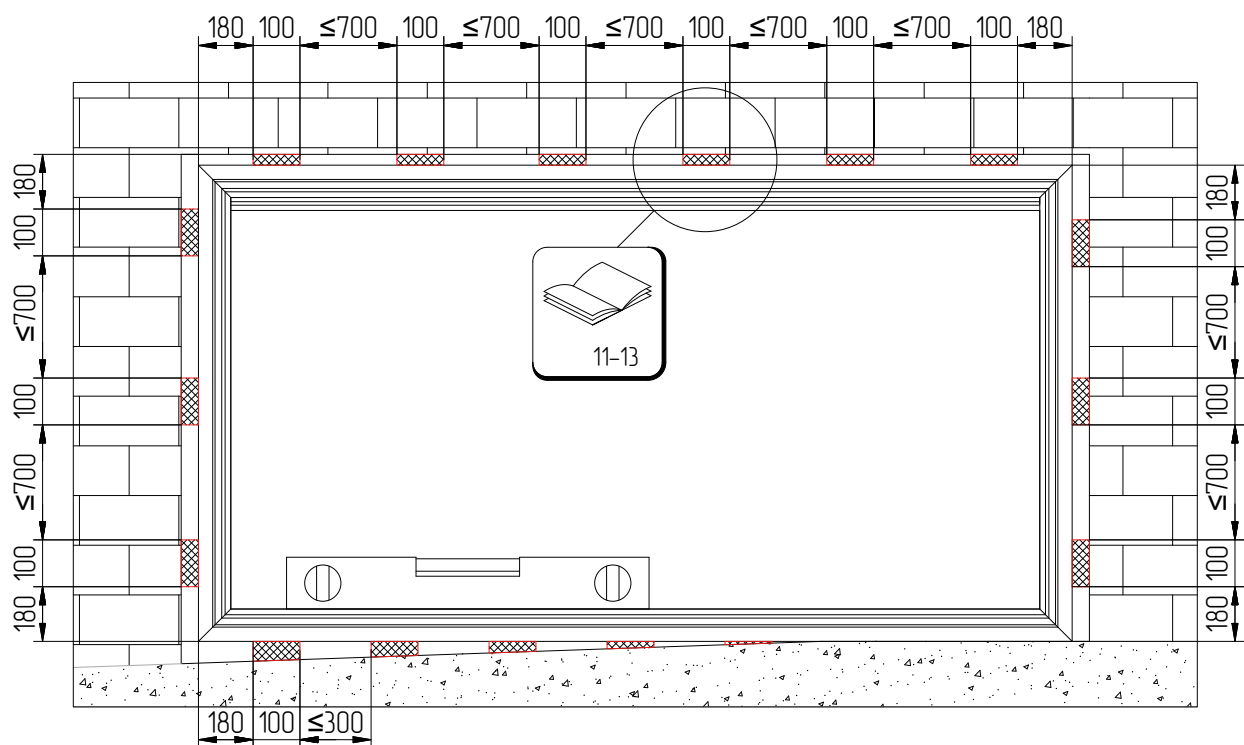


Do not remove the bearing supports after installation and fixing the door!



# ALT SL130 system installation

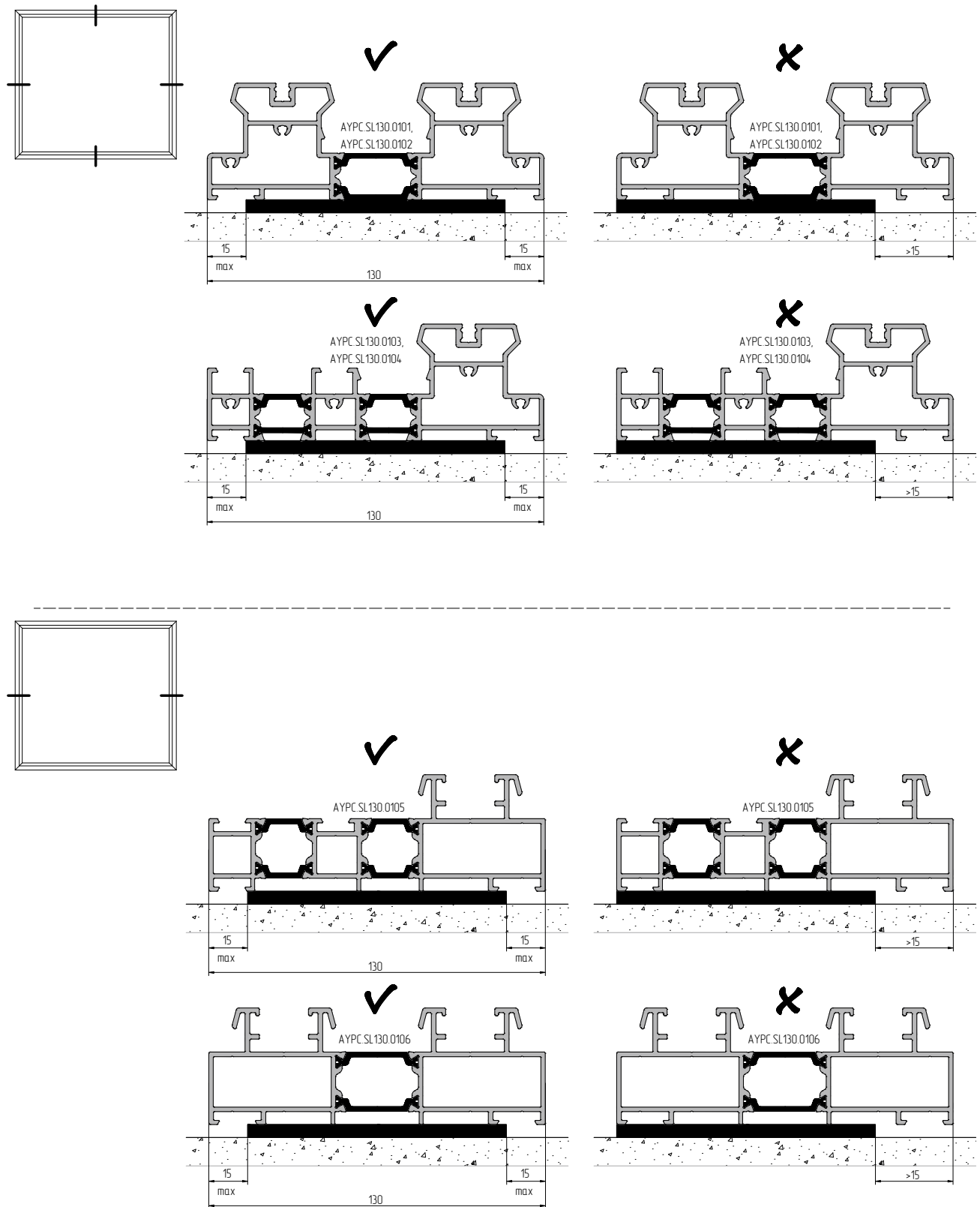
## Installation scheme of bearing and spacer supports



The type and installation depth of the fasteners depend on the wall material.  
The selection is to be made on the basis of the local technical regulations or the project design documentation!

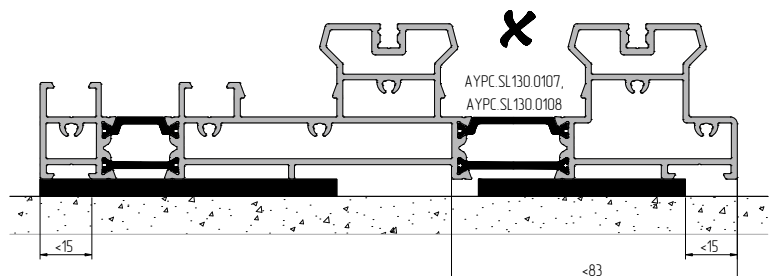
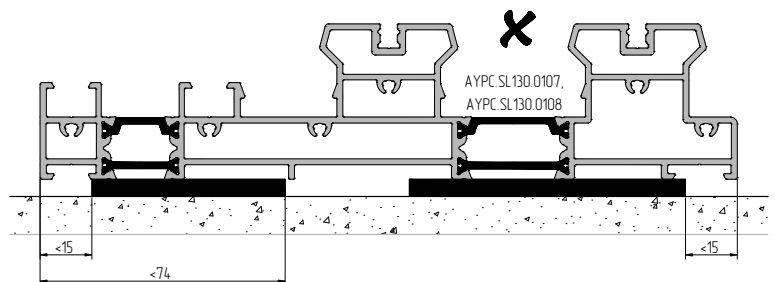
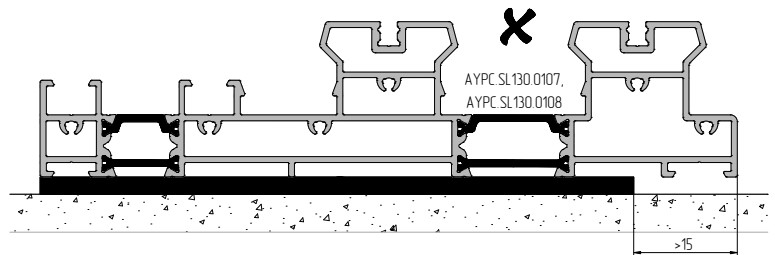
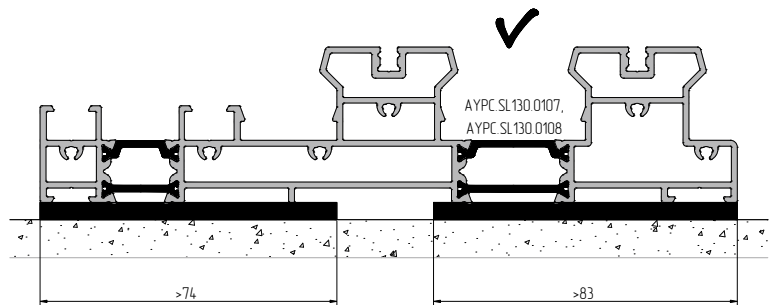
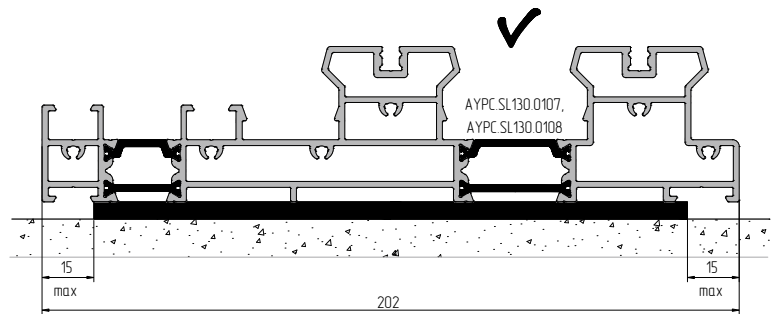
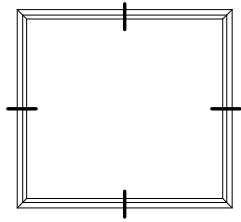
# ALT SL130 system installation

## Installation scheme of bearing and spacer supports



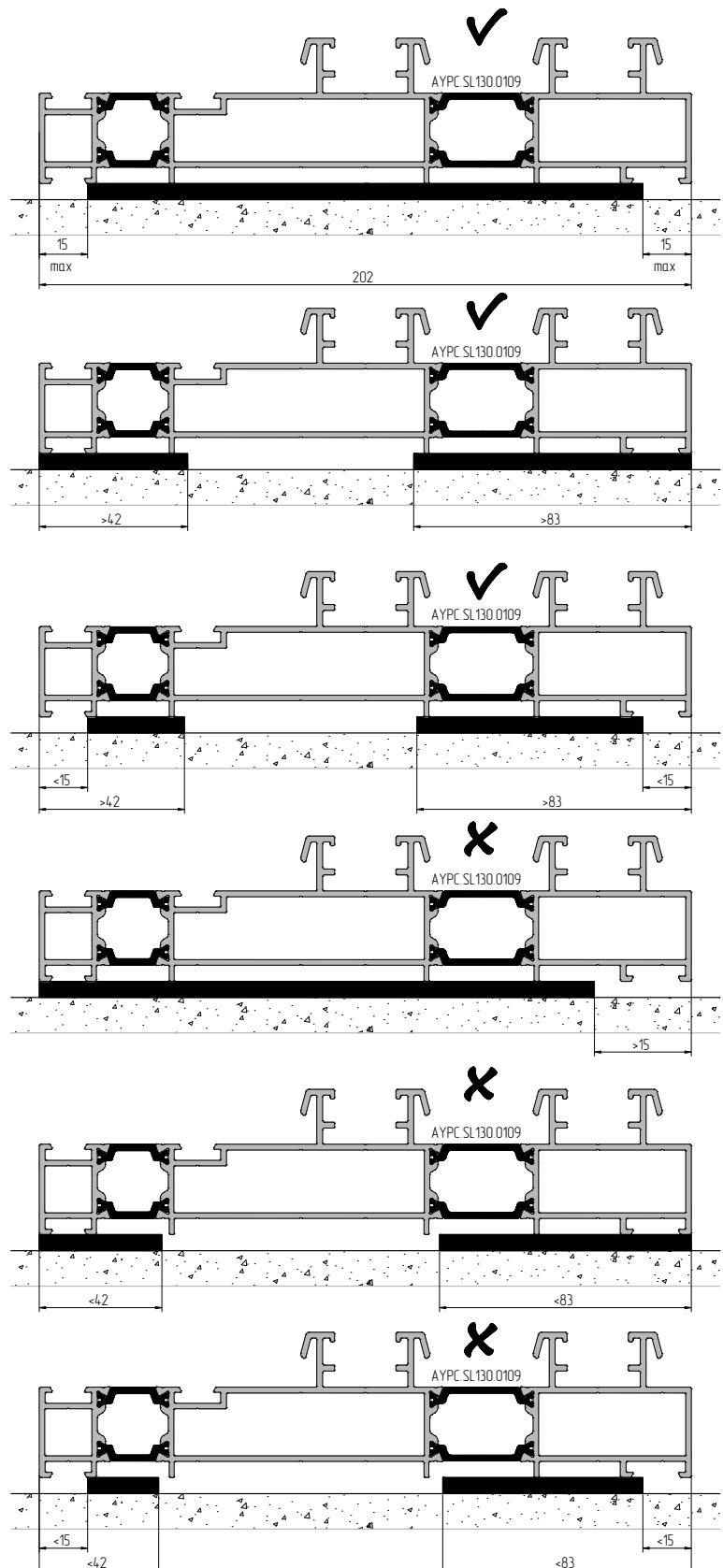
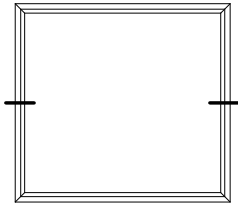
# ALT SL130 system installation

## Installation scheme of bearing and spacer supports



# ALT SL130 system installation

## Installation scheme of bearing and spacer supports

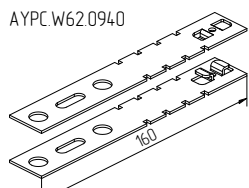


# ALT SL130 system installation

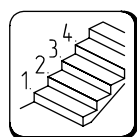
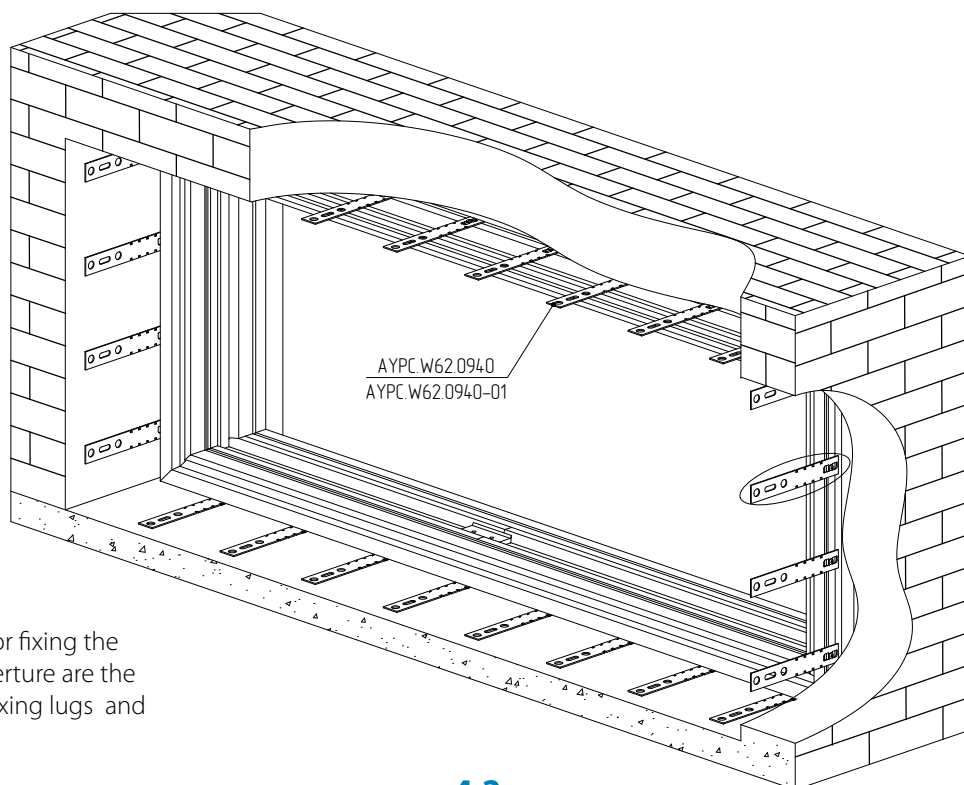
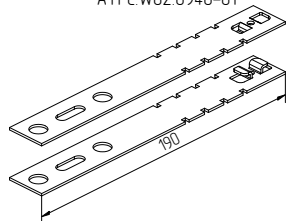
**4**

Installation  
with fixing lugs

AYPC.W62.0940

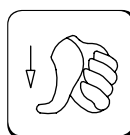


AYPC.W62.0940-01



Requirements for fixing the  
frame in the aperture are the  
same for both fixing lugs and  
anchors.

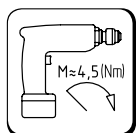
**4.2**



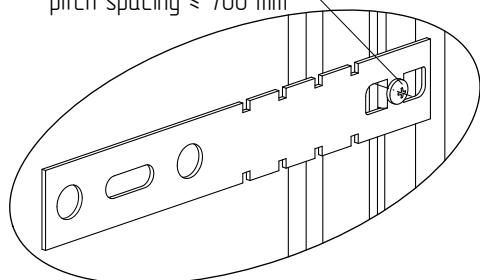
Fixing lug  
rotating  
direction

**4.3**

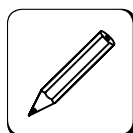
**4.5**



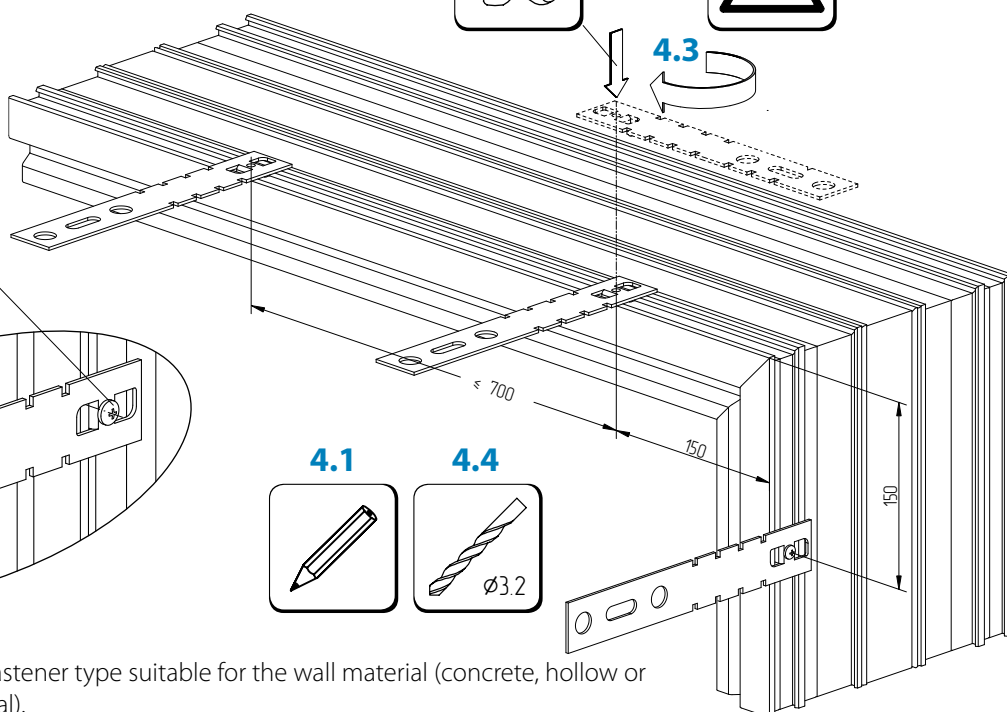
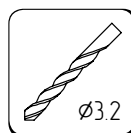
3,9×13 DIN7981  
pitch spacing ≤ 700 mm



**4.1**



**4.4**

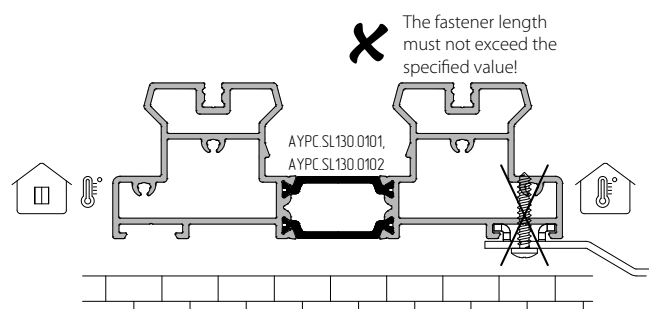
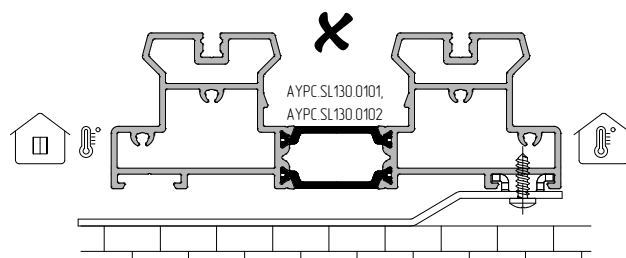
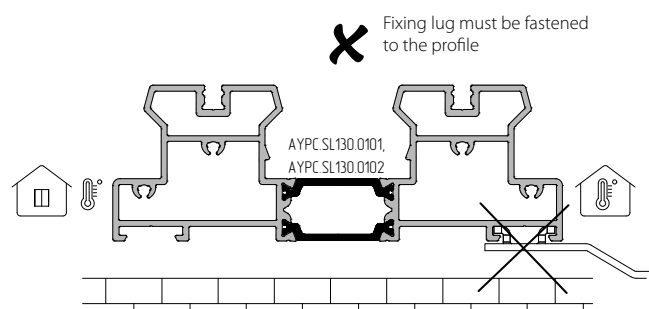
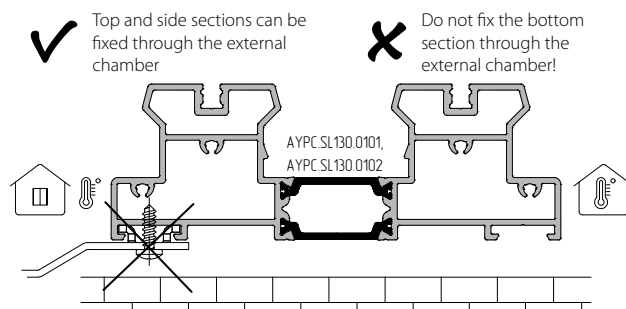
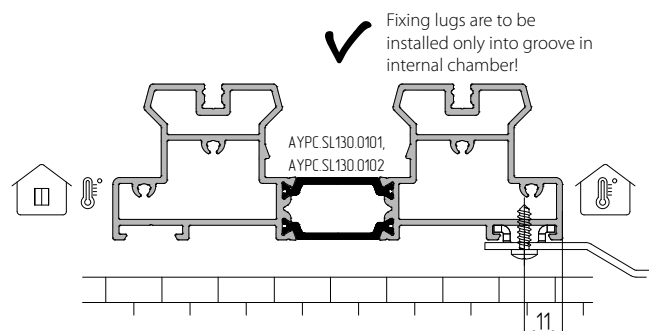
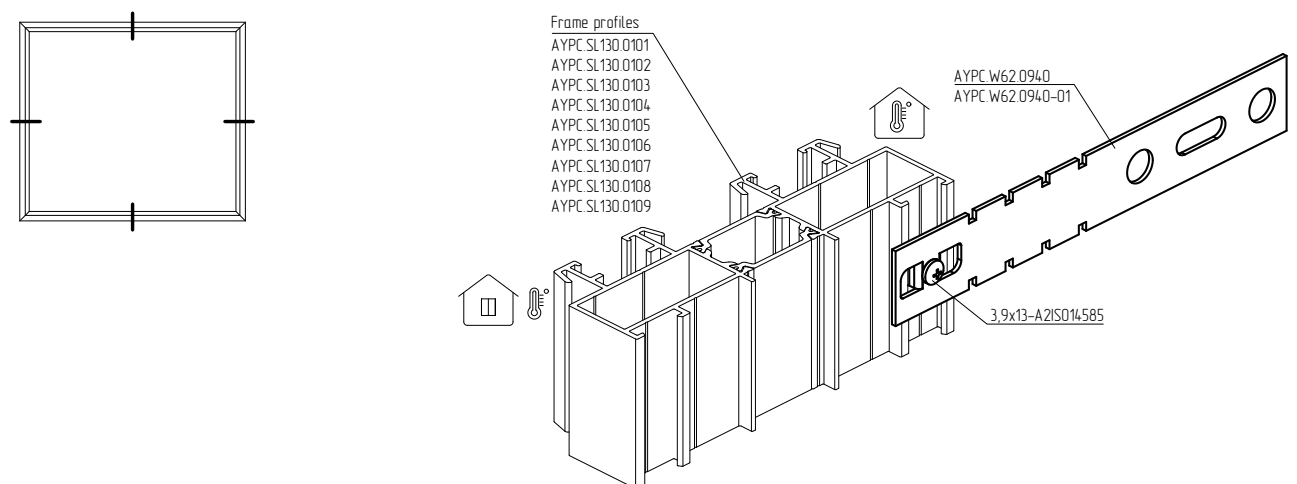


Select the fastener type suitable for the wall material (concrete, hollow or  
solid material).

Fixing points (on the fixing lugs or anchors) should be made in the area of  
the spacer support installation.

# ALT SL130 system installation

## Installation option with fixing lugs



Preparation of internal profile chamber for installation of 3,9x13-A2ISO14858 self-tapping screws for fixing lug fastening

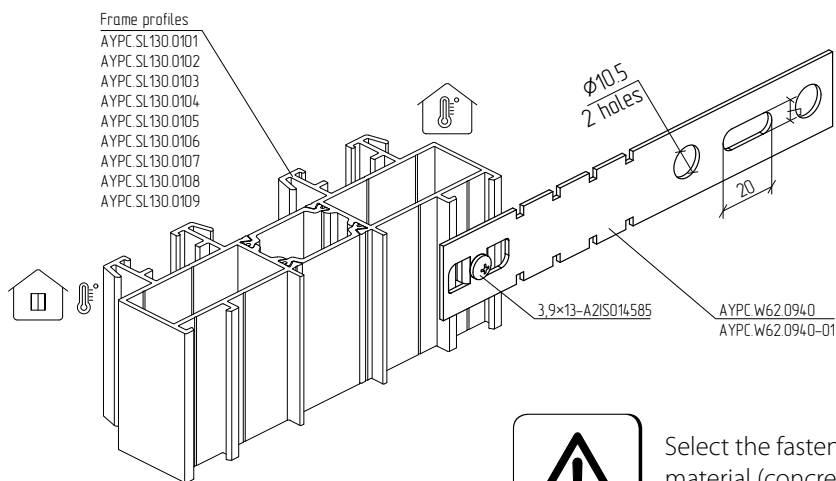
AYPC.SL130.0101, AYPC.SL130.0102, AYPC.SL130.0103, AYPC.SL130.0104, AYPC.SL130.0107, AYPC.SL130.0108,	<p>Ø3.2</p> <p>11</p>
AYPC.SL130.0105, AYPC.SL130.0106, AYPC.SL130.0109	<p>Ø3.2</p>



Prior to installing the frame, learn the arrangement of mounting assembly according to project design documentation and local technical regulations.

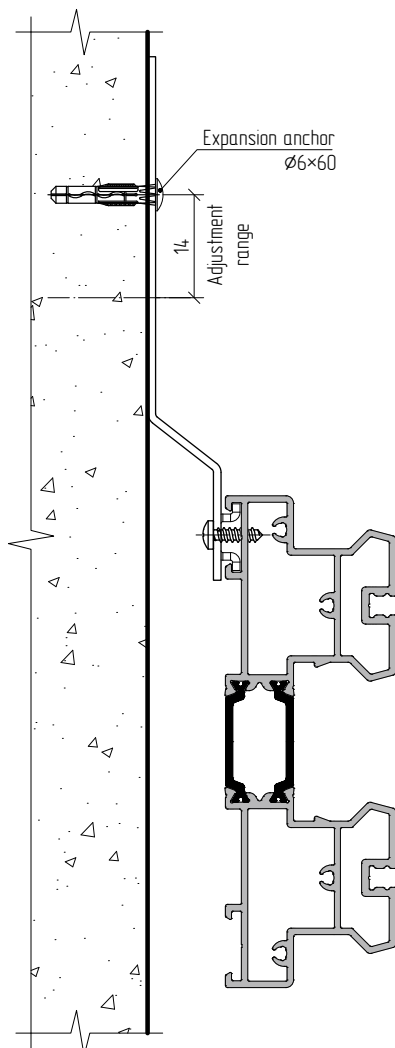
# ALT SL130 system installation

## Installation option with fixing lugs

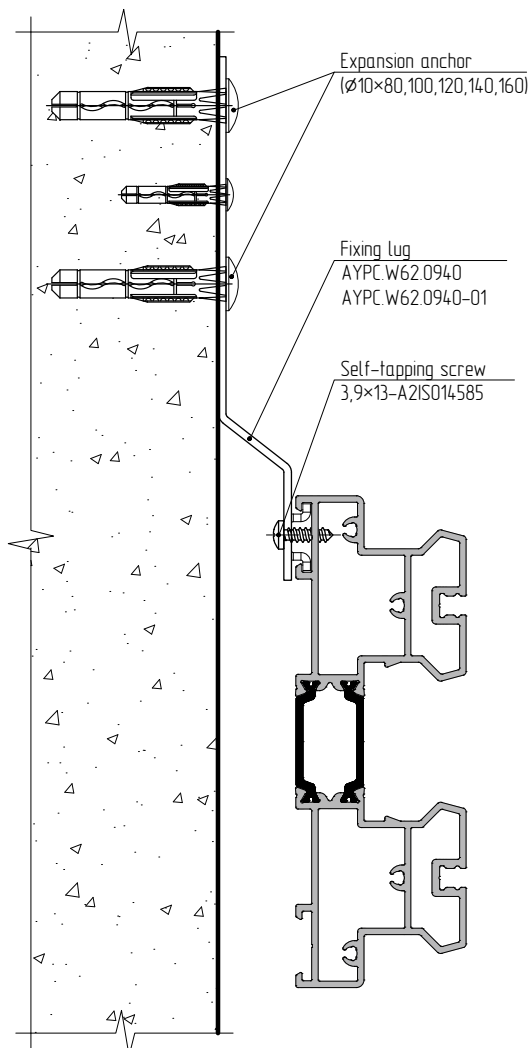


Select the fastener type suitable for the wall material (concrete, hollow or solid material).

Pre-installation and alignment of the frame in the aperture



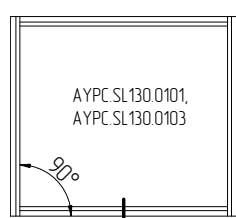
Final anchorage





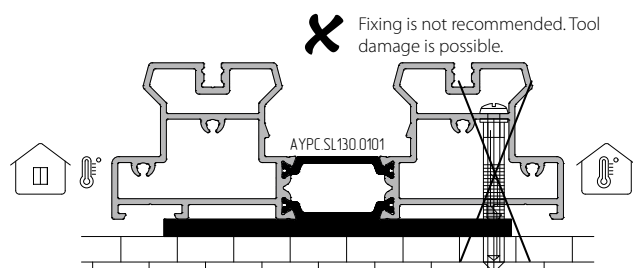
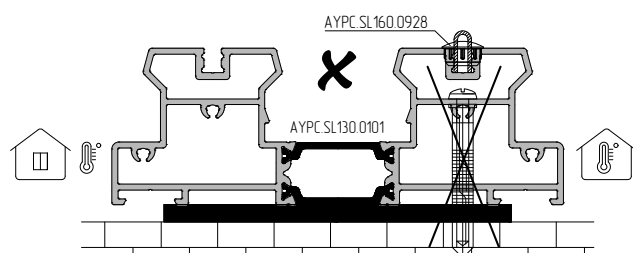
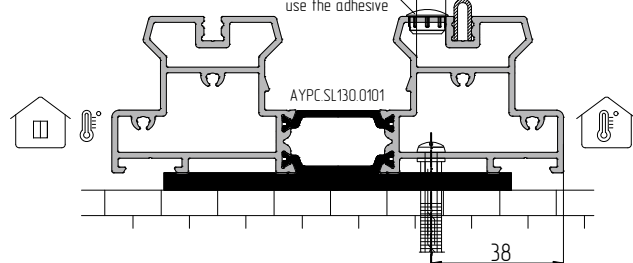
# ALT SL130 system installation

## Installation options. Bottom section

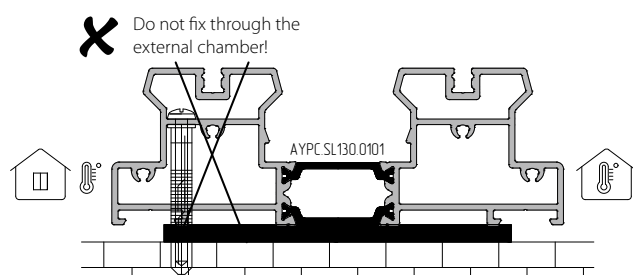


Select the fastener type suitable for the wall material (concrete, hollow or solid material).

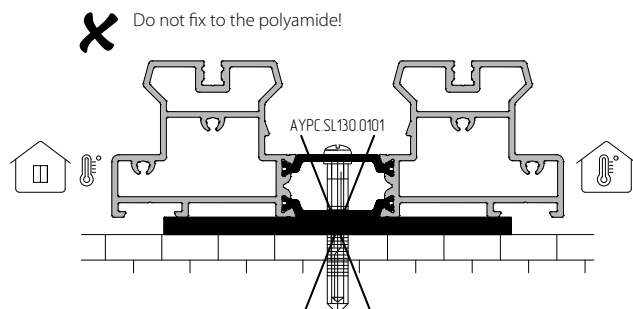
✓  
Decorative  
plug Ø10  
AYPC SL160.0928  
use the adhesive



✗ Fixing is not recommended. Tool damage is possible.



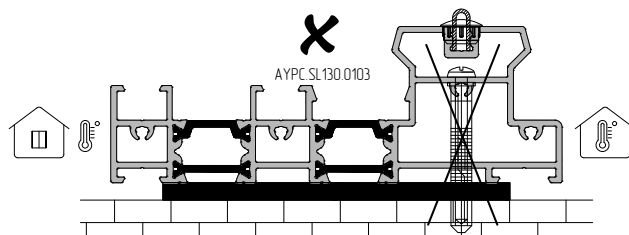
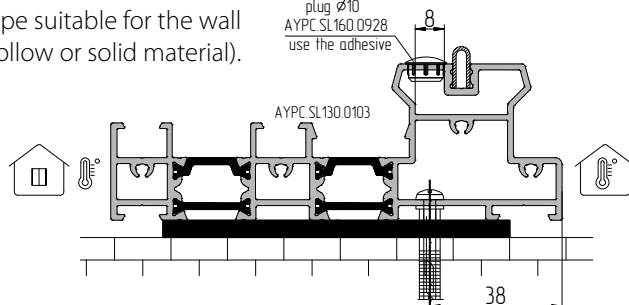
✗ Do not fix through the external chamber!



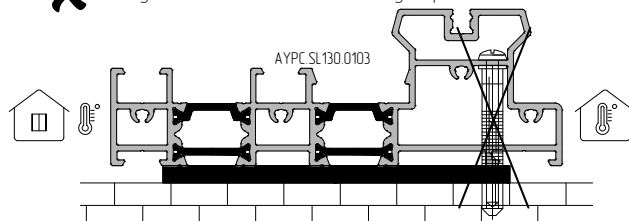
✗ Do not fix to the polyamide!

✓

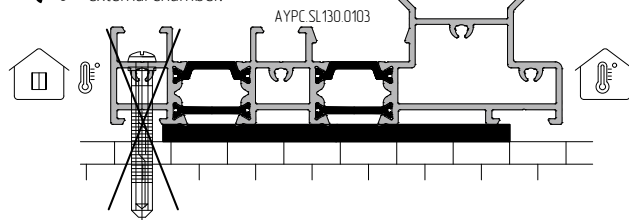
Decorative  
plug Ø10  
AYPC SL160.0928  
use the adhesive



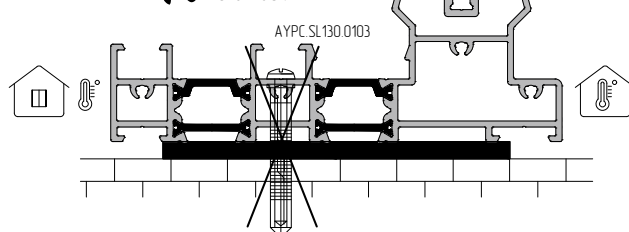
✗ Fixing is not recommended. Tool damage is possible.



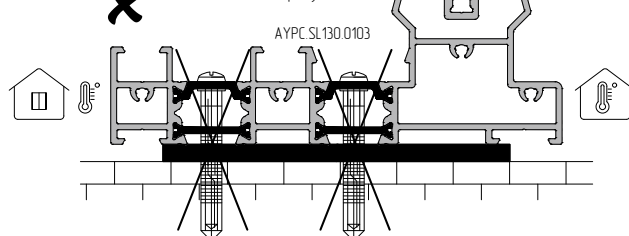
✗ Do not fix through the external chamber!



✗ Do not fix through the intermediate chamber!

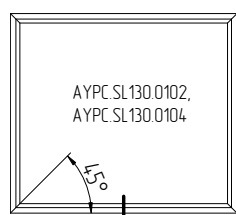


✗ Do not fix to the polyamide!



# ALT SL130 system installation

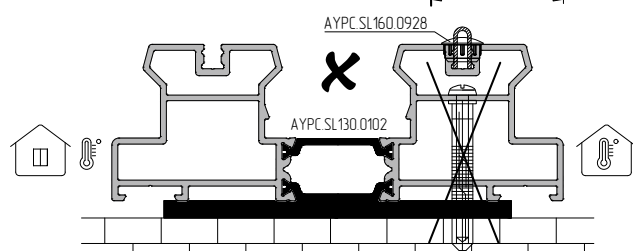
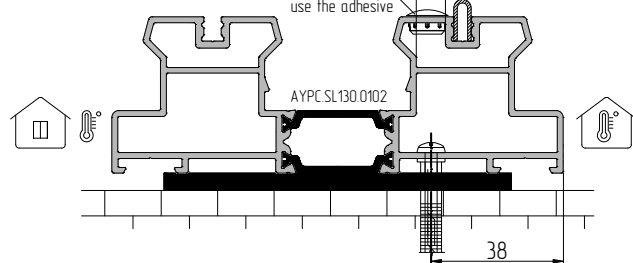
## Installation options



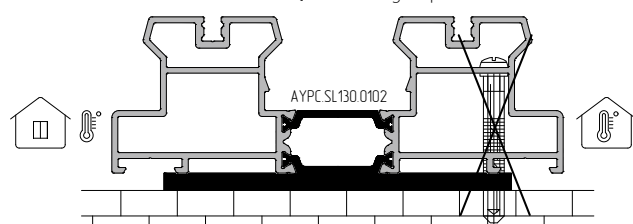
Select the fastener type suitable for the wall material (concrete, hollow or solid material).



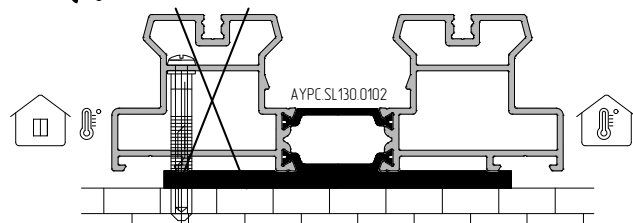
Decorative  
plug Ø10  
AYPC.SL160.0928  
use the adhesive



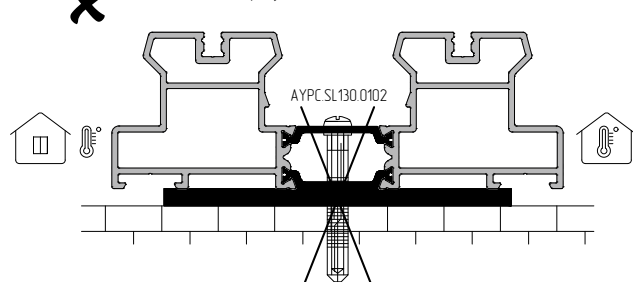
Fixing is not recommended. Tool damage is possible.



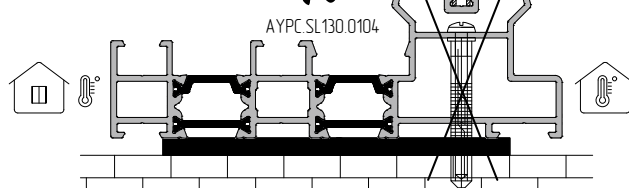
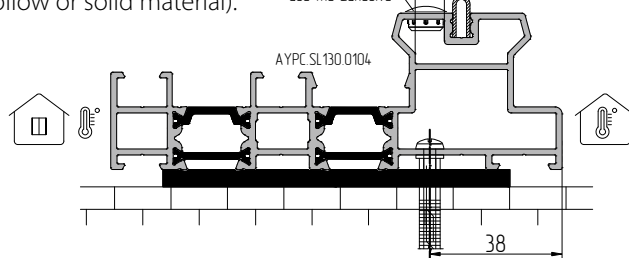
Do not fix through the external chamber!



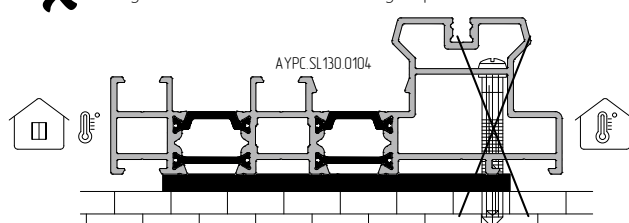
Do not fix to the polyamide!



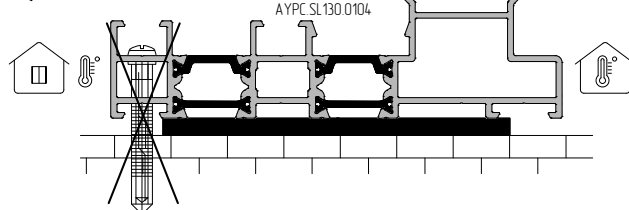
Decorative  
plug Ø10  
AYPC.SL160.0928  
use the adhesive



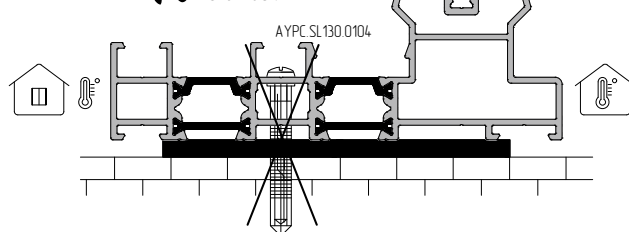
Fixing is not recommended. Tool damage is possible.



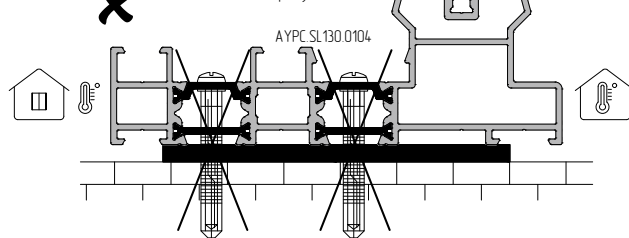
Do not fix through the external chamber!



Do not fix through the intermediate chamber!

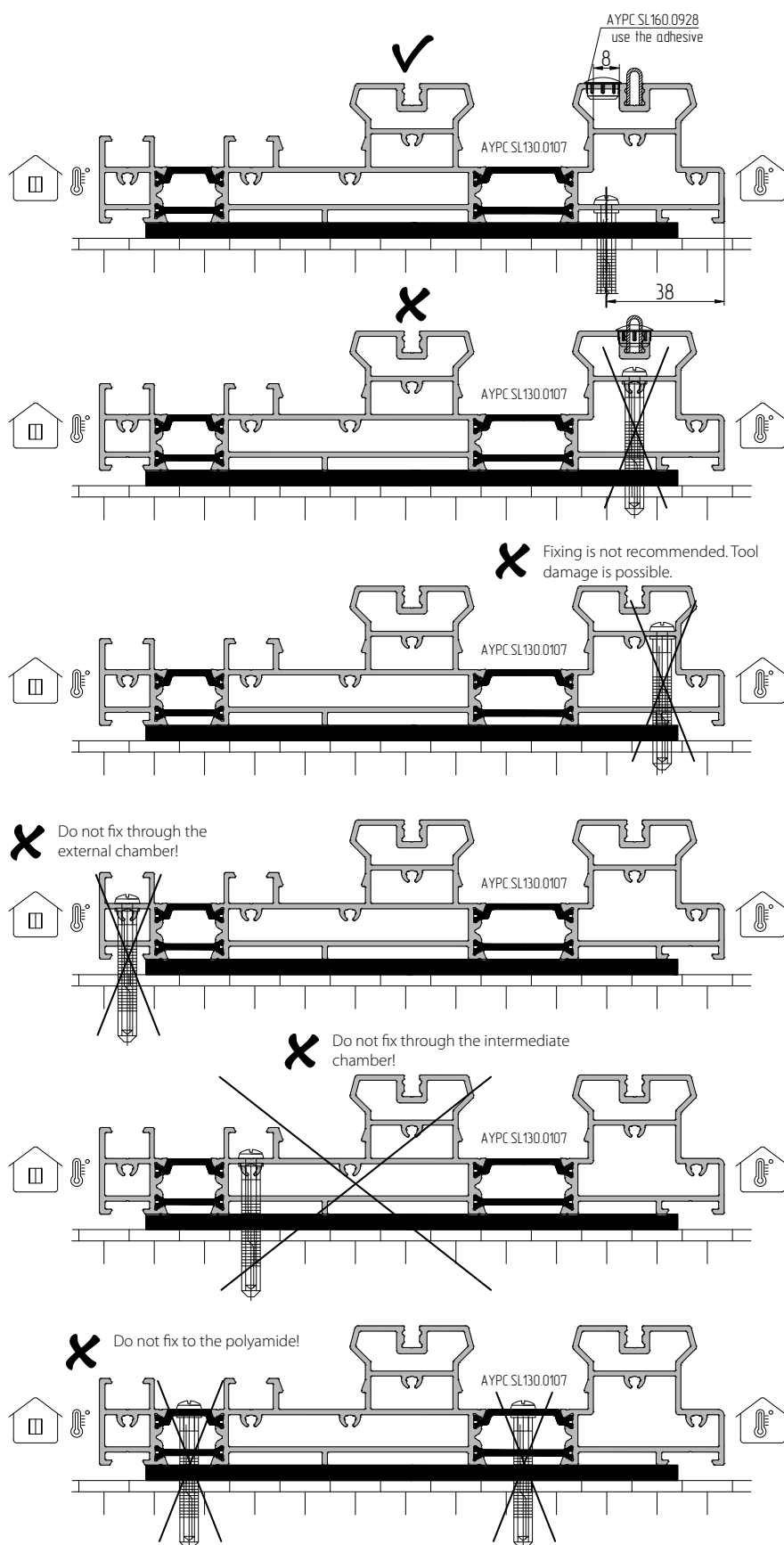
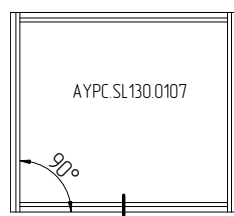


Do not fix to the polyamide!



# ALT SL130 system installation

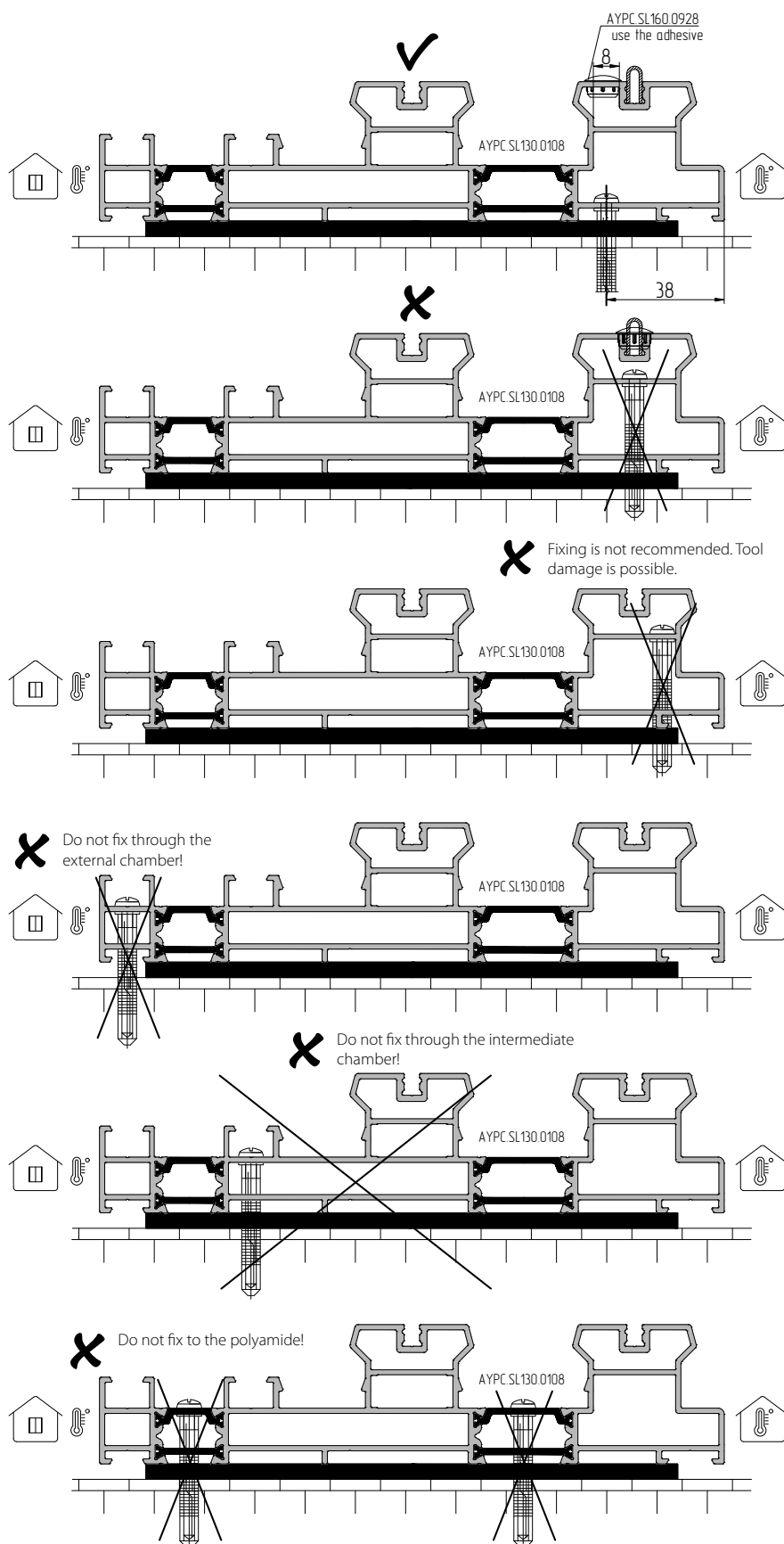
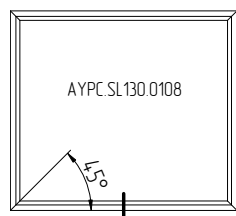
## Installation options. Bottom section



Select the fastener type suitable for the wall material (concrete, hollow or solid material).

# ALT SL130 system installation

## Installation options. Bottom section

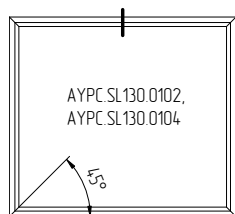


Select the fastener type suitable for the wall material (concrete, hollow or solid material).

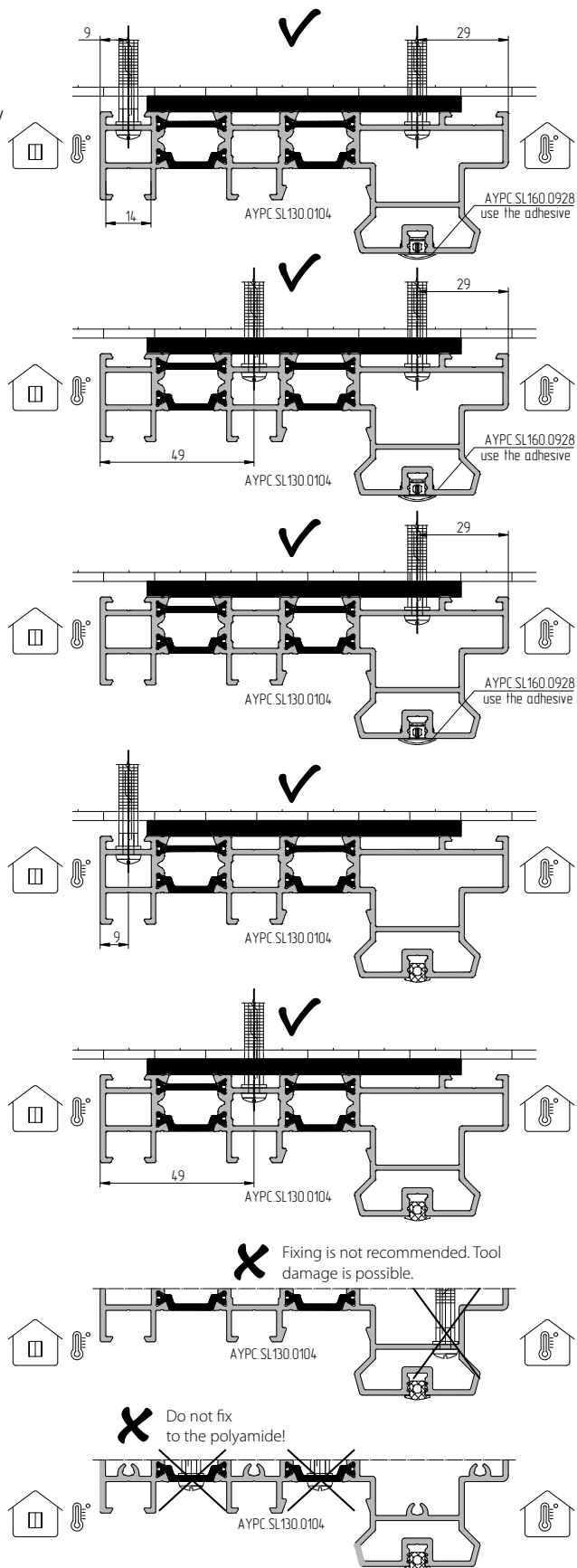
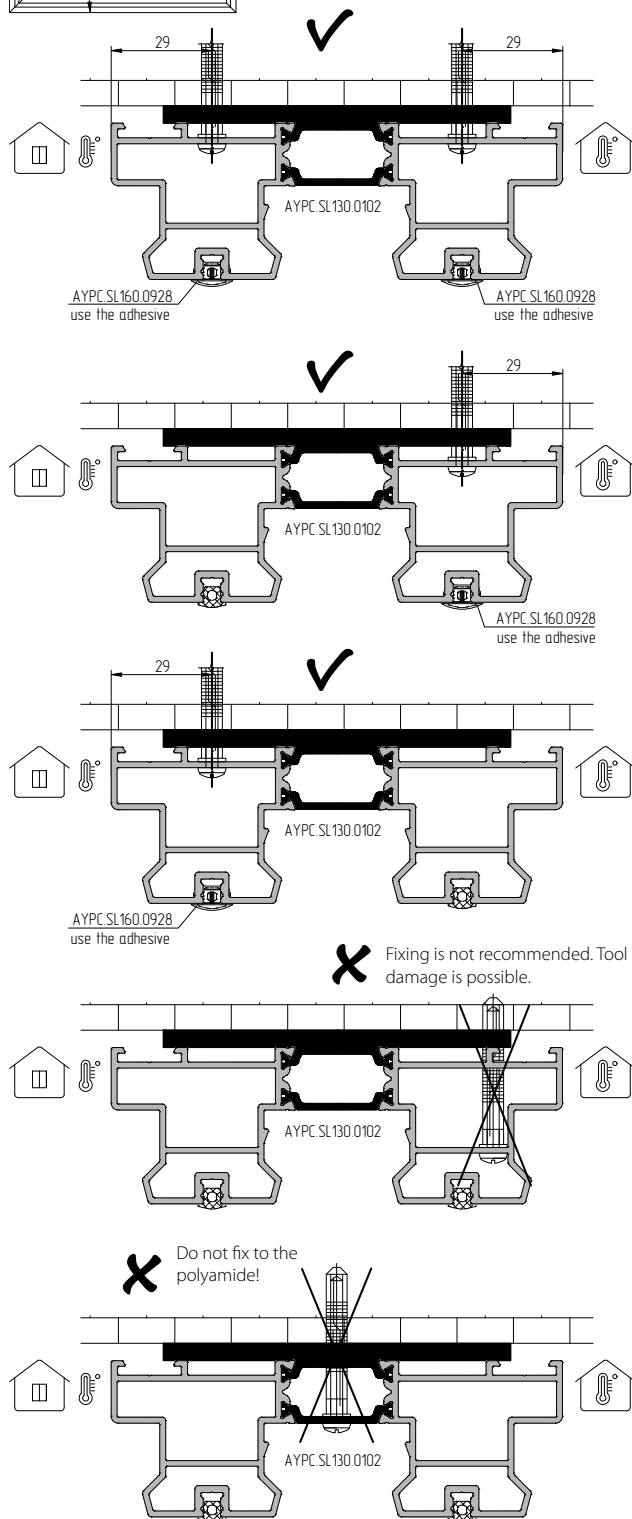


# ALT SL130 system installation

## Installation options. Top section

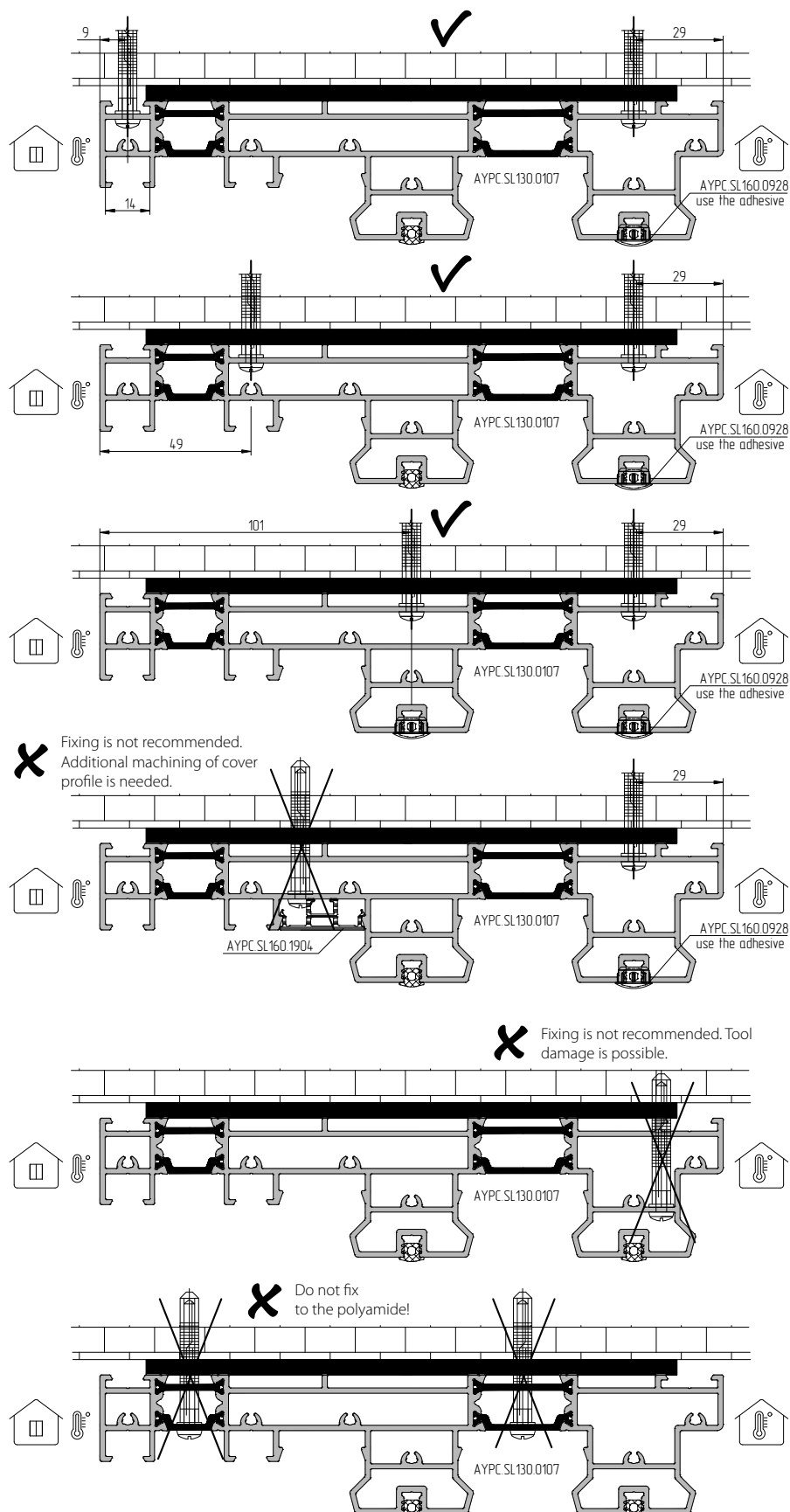
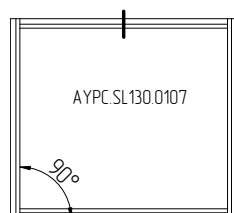


Select the fastener type suitable for the wall material (concrete, hollow or solid material).



# ALT SL130 system installation

## Installation options. Top section

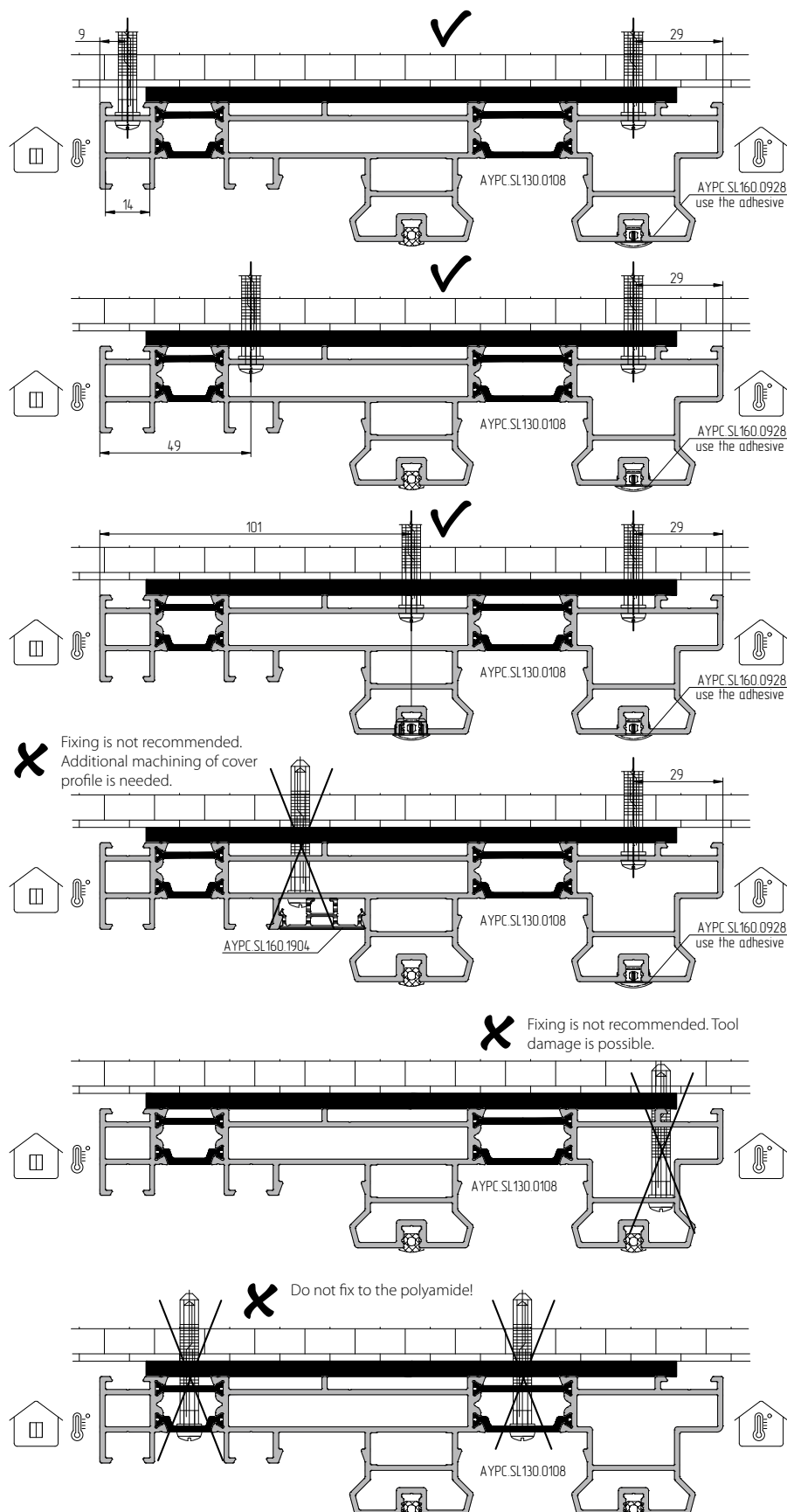
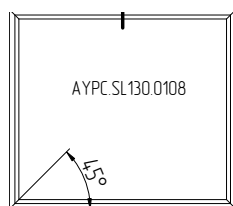


Select the fastener type suitable for the wall material (concrete, hollow or solid material).



# ALT SL130 system installation

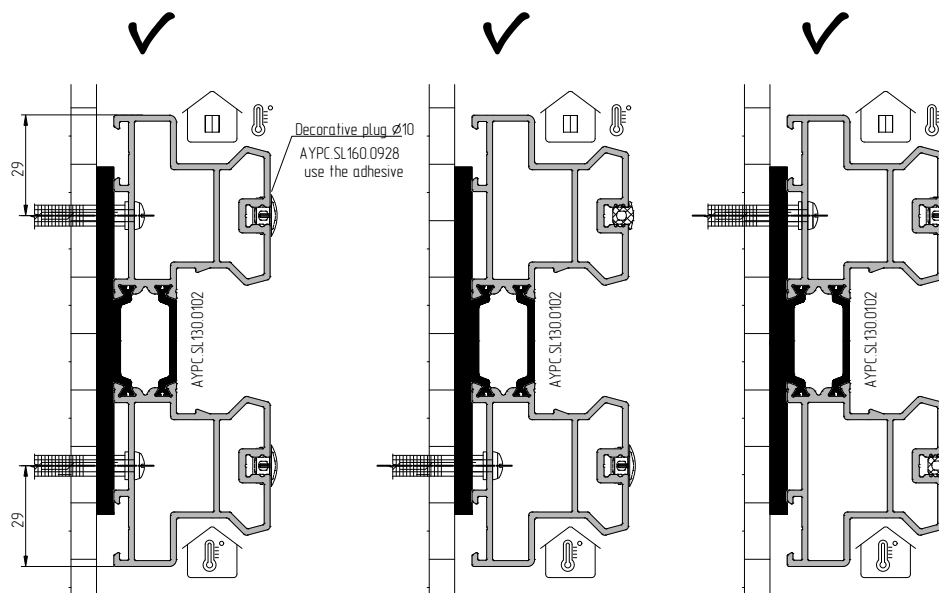
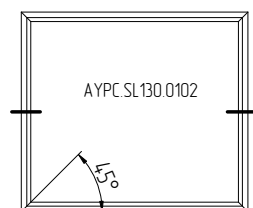
## Installation options. Top section



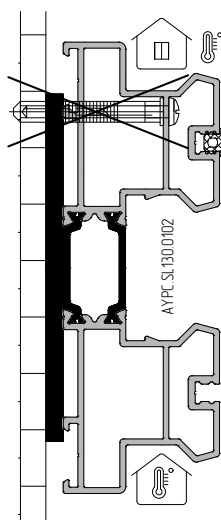
Select the fastener type suitable for the wall material (concrete, hollow or solid material).

# ALT SL130 system installation

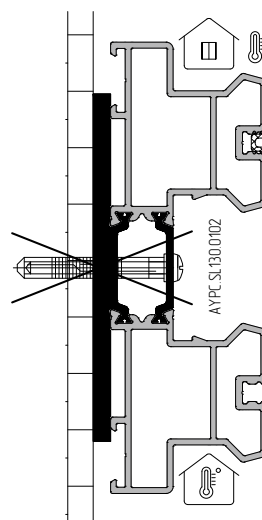
## Installation options. Side section



**X** Fixing is not recommended. Tool damage is possible.



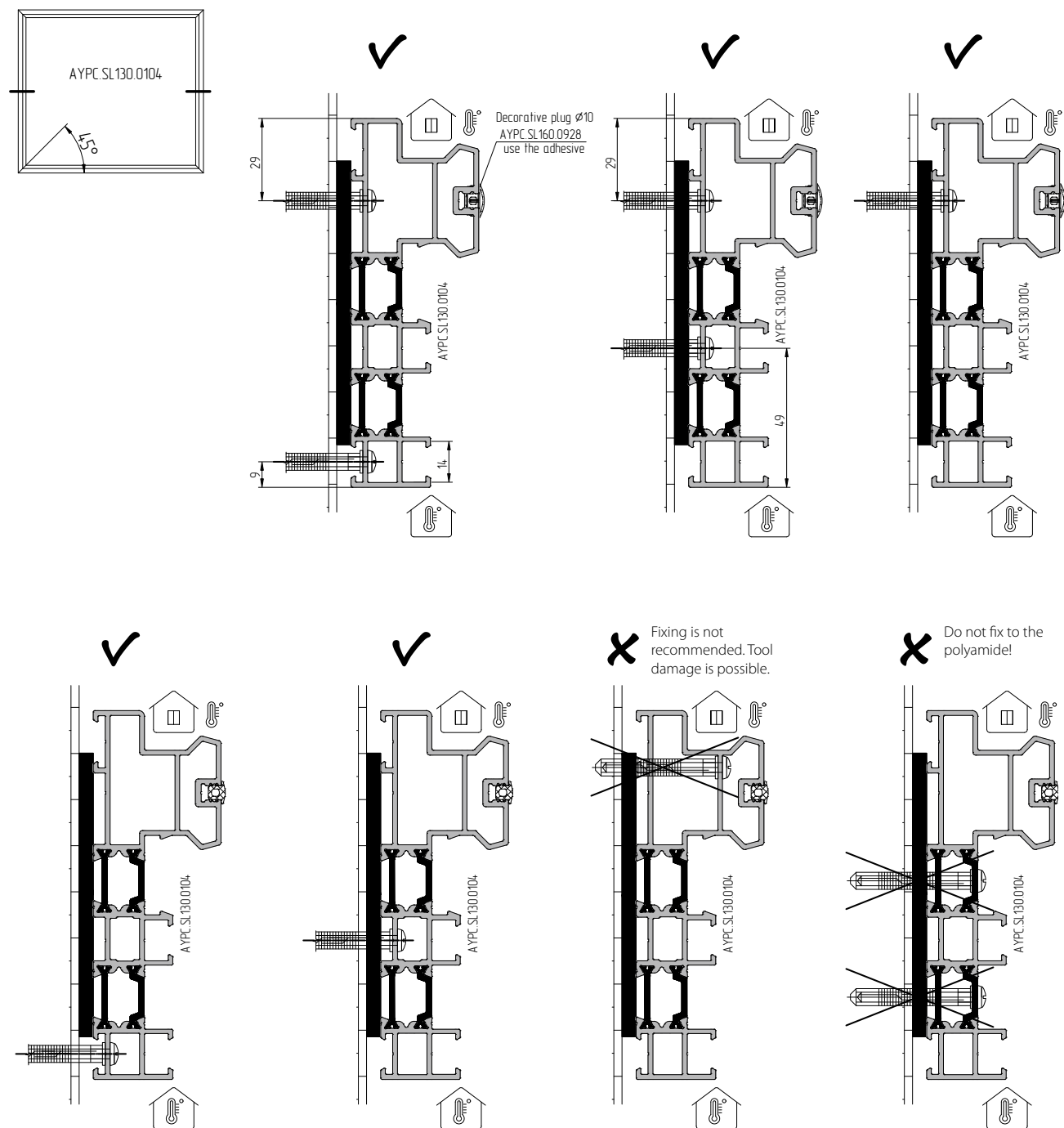
**X** Do not fix to the polyamide!



Fixing points should be made in the area of the spacer support installation.  
Install according to the technical catalogue after the structure is assembled in the aperture.  
Select the fastener type suitable for the wall material (concrete, hollow or solid material).

# ALT SL130 system installation

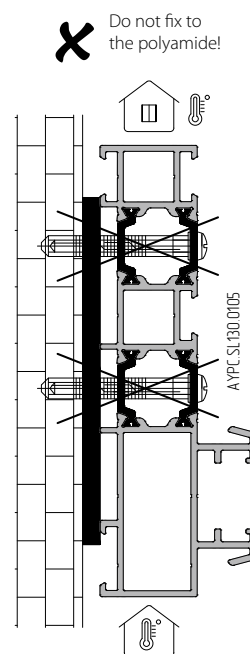
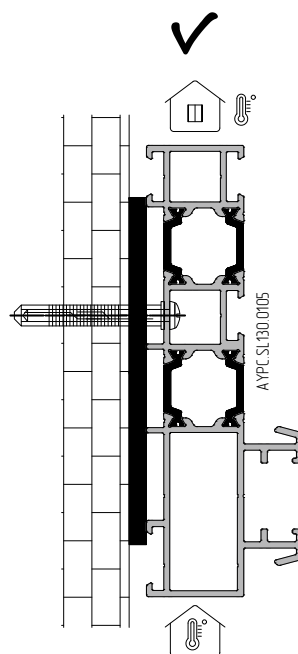
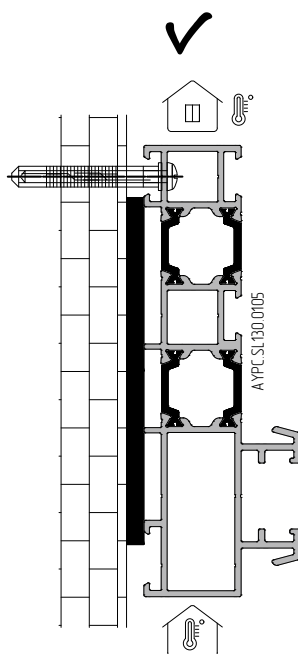
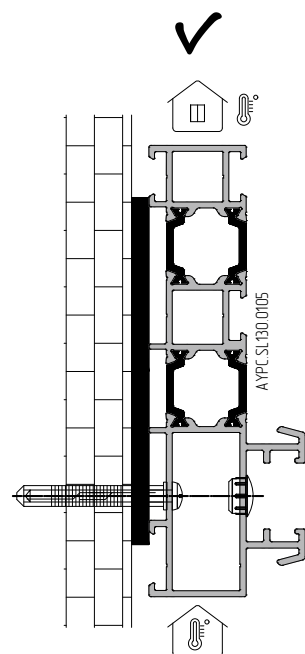
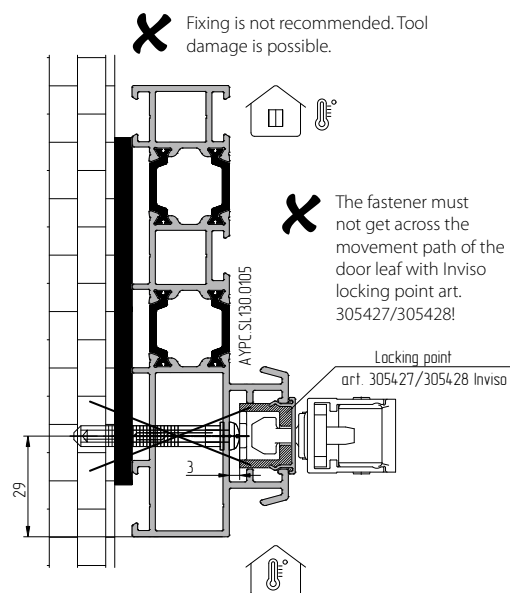
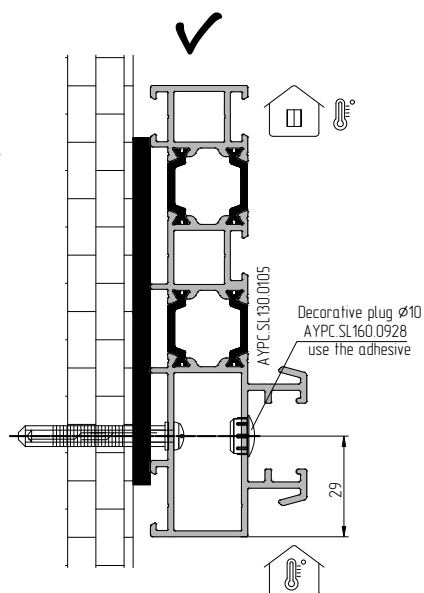
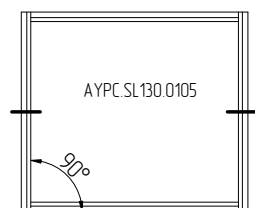
## Installation options. Side section



Select the fastener type suitable for the wall material (concrete, hollow or solid material).

# ALT SL130 system installation

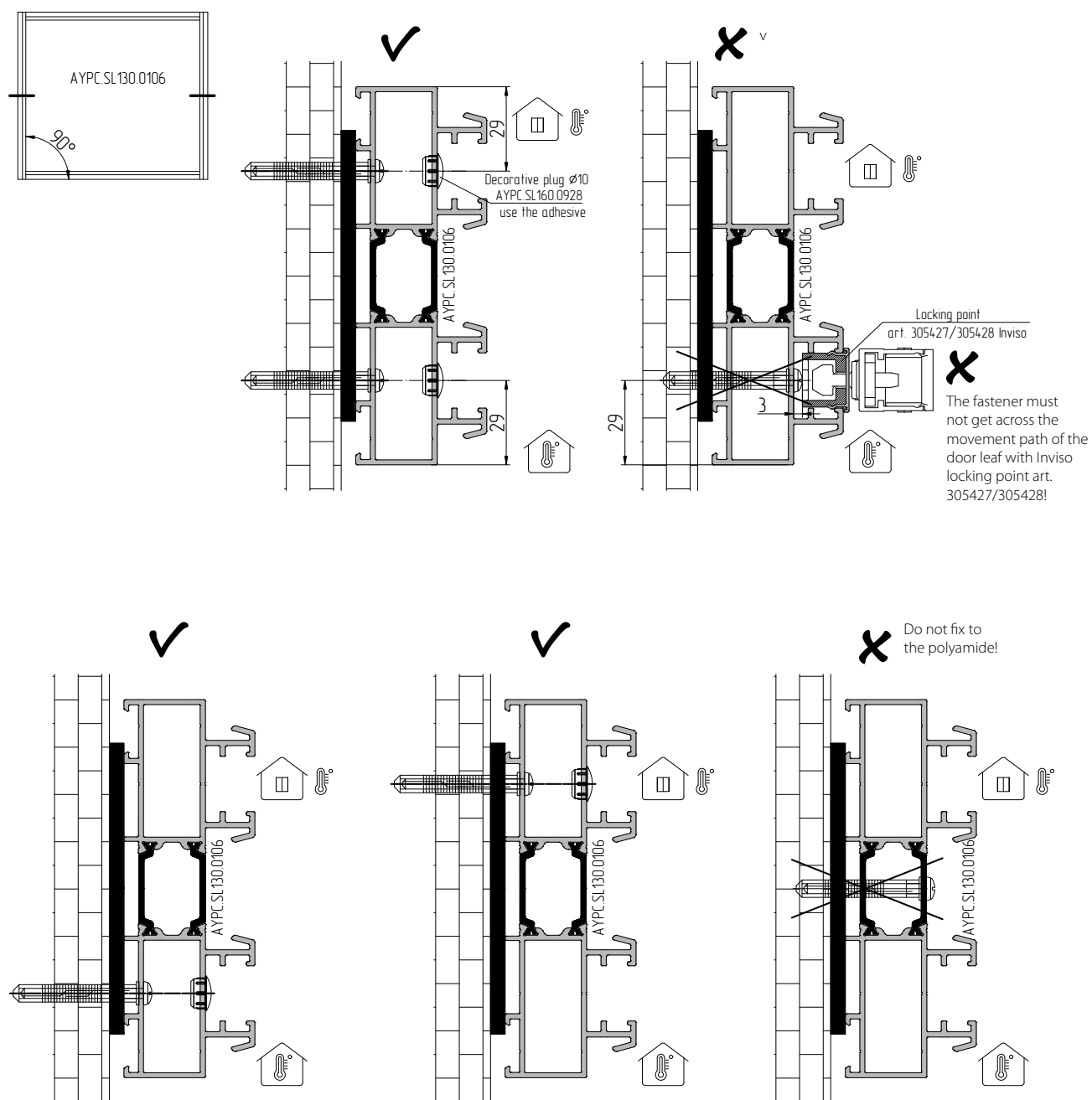
## Installation options. Side section



Select the fastener type suitable for the wall material (concrete, hollow or solid material).

# ALT SL130 system installation

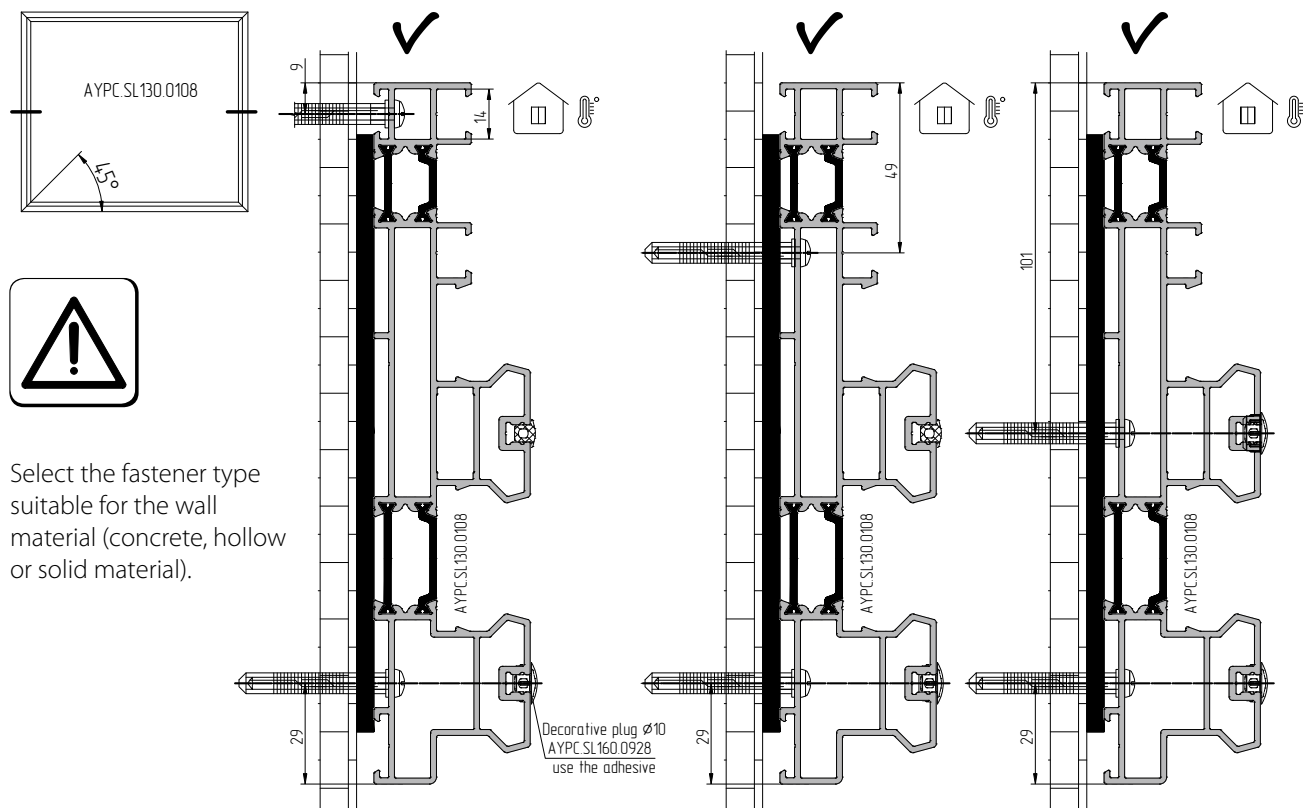
## Installation options. Side section



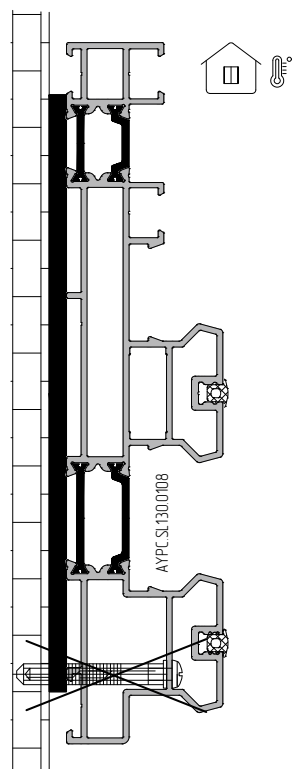
Fixing points should be made in the area of the spacer support installation.  
Install according to the technical catalogue after the structure is assembled in the aperture.  
Select the fastener type suitable for the wall material (concrete, hollow or solid material).

# ALT SL130 system installation

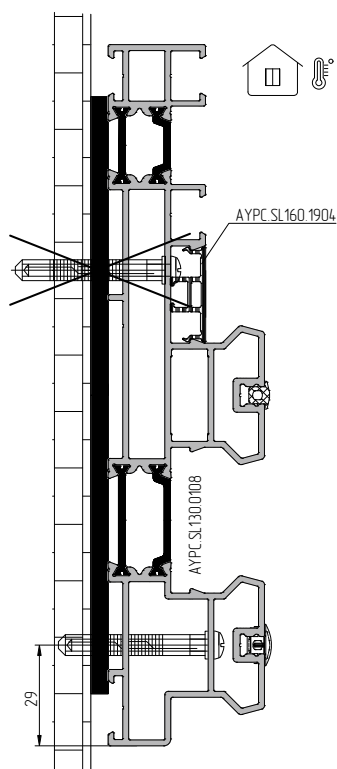
## Installation options. Side section



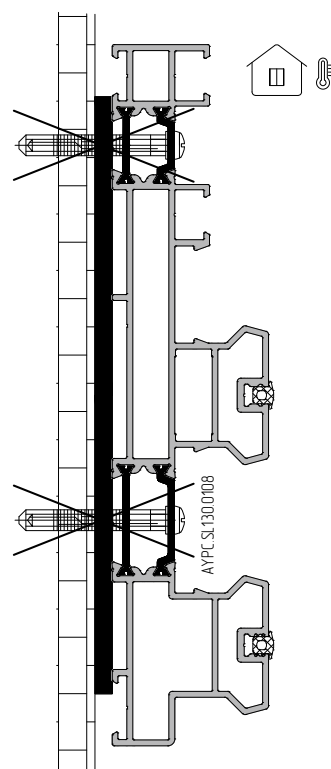
**X** Fixing is not recommended. Tool damage is possible.



**X** Fixing is not recommended. Additional machining of cover profile is needed.

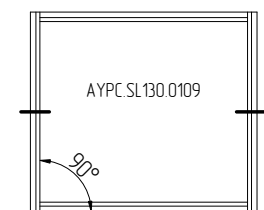


**X** Do not fix to the polyamide!

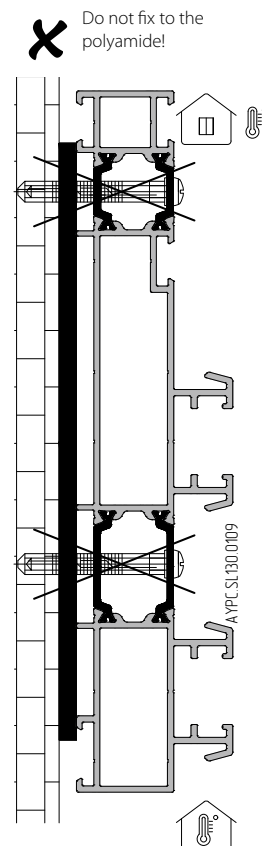
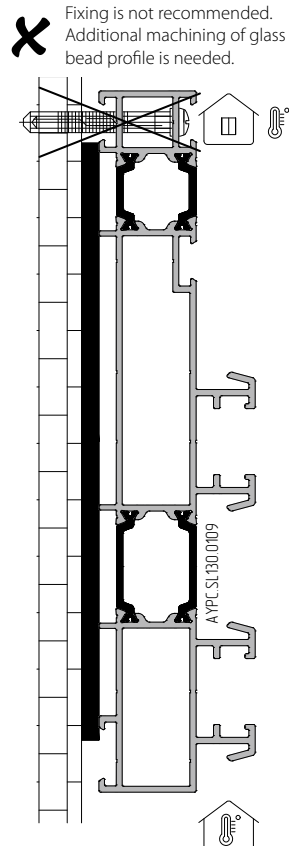
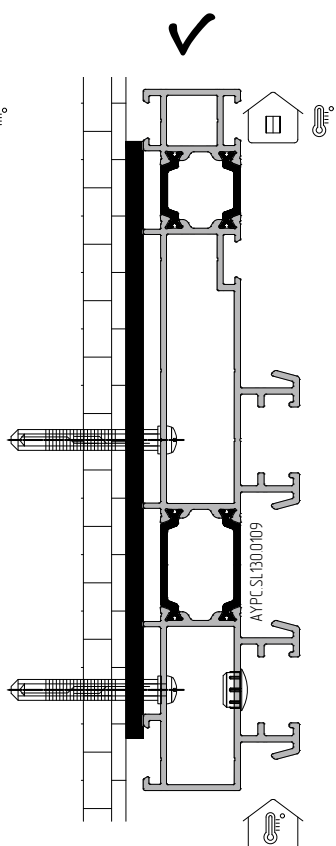
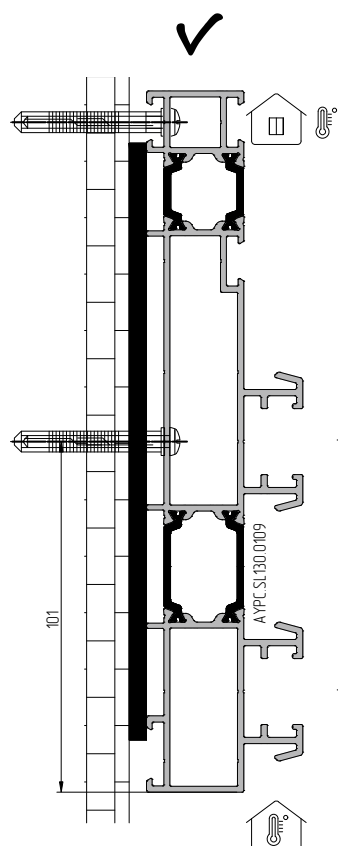
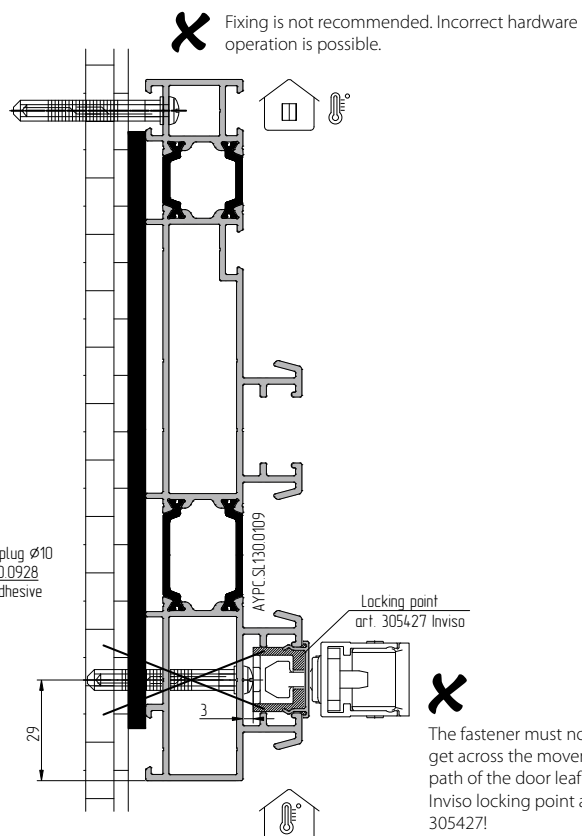
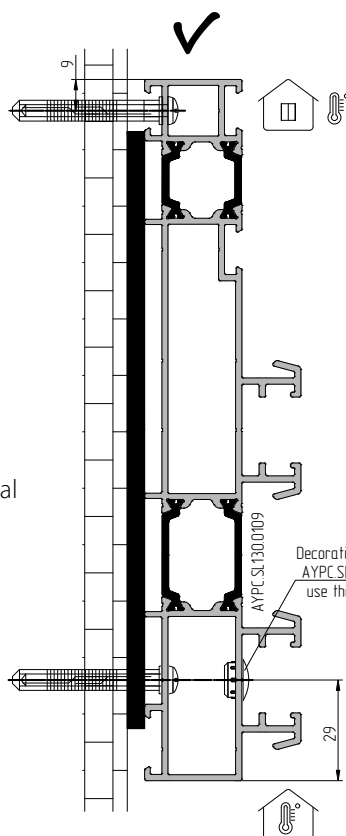


# ALT SL130 system installation

## Installation options. Side section

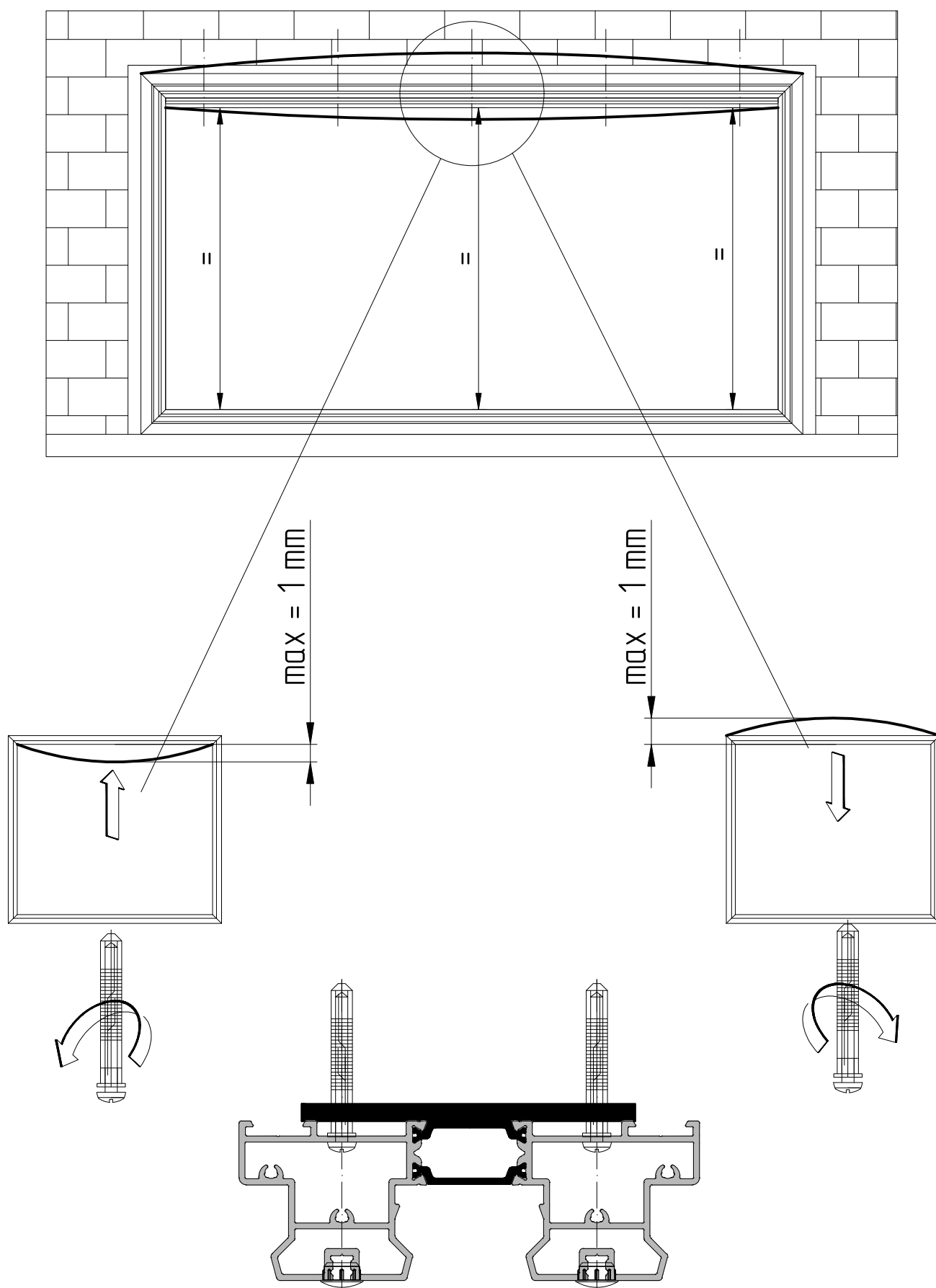


Select the fastener type suitable for the wall material (concrete, hollow or solid material).





## ALT SL130 system installation



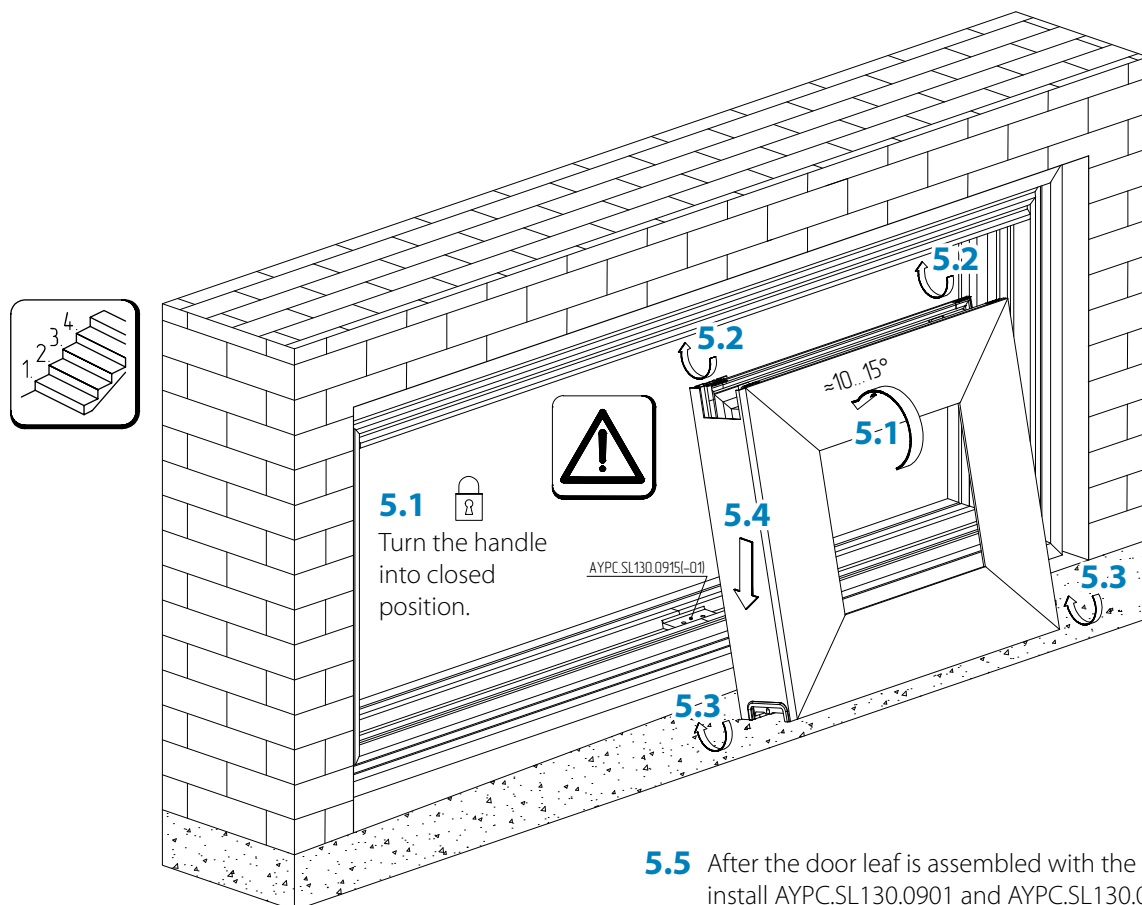
## ALT SL130 system installation

**5**

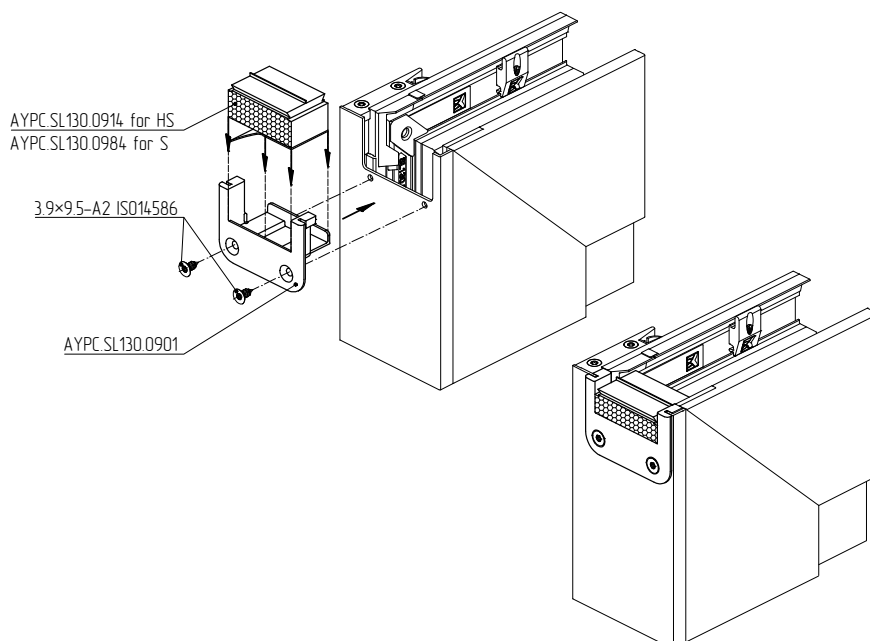
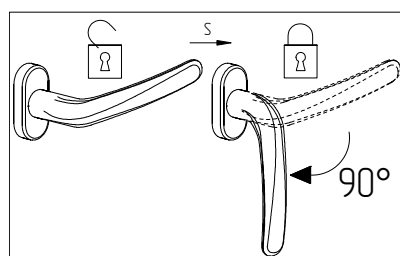
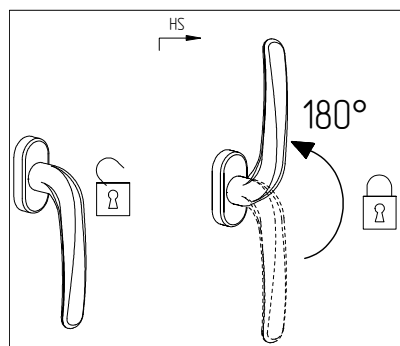
Prior to installing the door leaves, check that the sealing loops are not damaged.

If there is a fixed light, install it as close to the frame ledge profile to avoid SL130.0915(-01) sealing block displacement. Move the leaf by lifting it slightly.

Check that there are no AYPC.SL130.1904/1905 decorative cover profiles which can hamper door leaves installation.

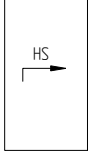
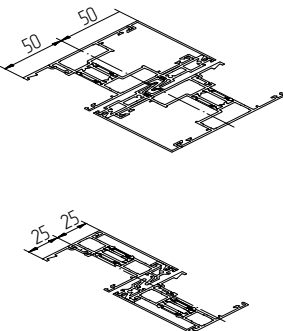
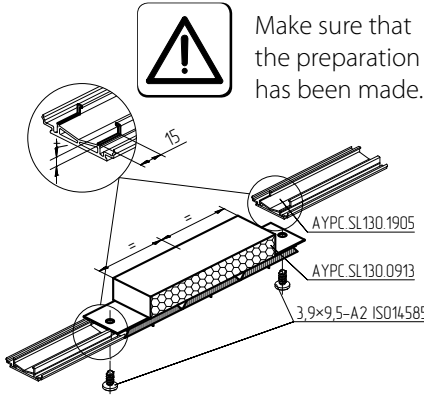
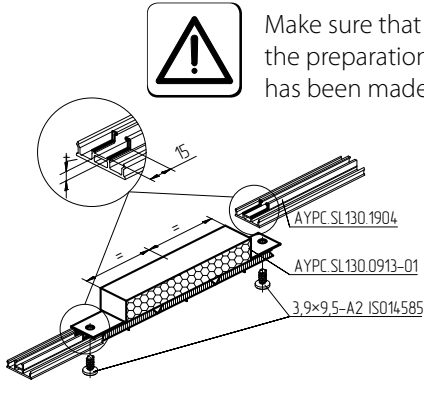
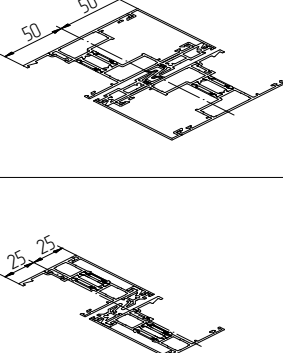
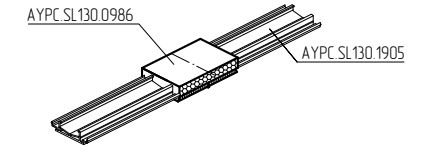
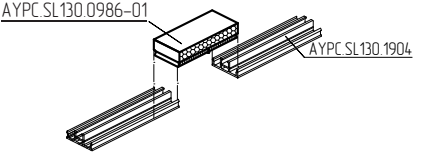
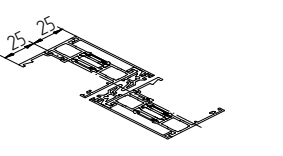
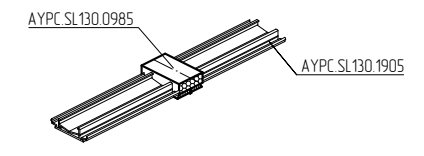
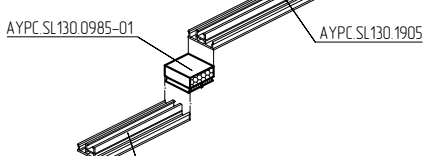


**5.5** After the door leaf is assembled with the frame, install AYPC.SL130.0901 and AYPC.SL130.0914 (AYPC.SL130.0984) from AYPC.SL130.0940 kit.

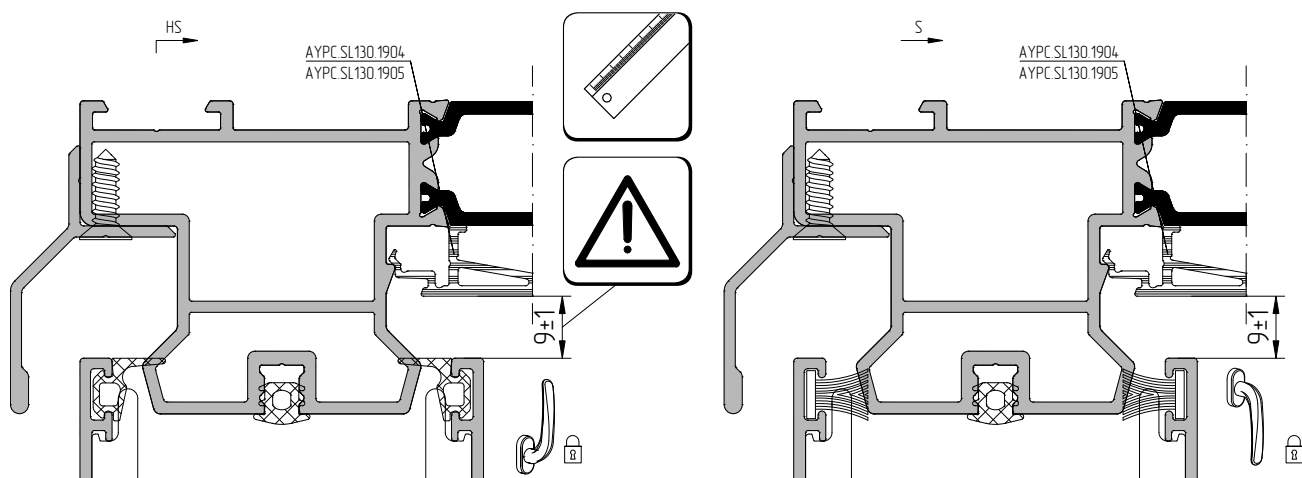


# ALT SL130 system installation

**5.6** Install frame ledge kit and AYP.C.SL130.1904/1905 decorative cover profiles into top frame after door leaf installation.

Leaf type	Leaf connection type	Frame article	
		AYPC.SL130.0101 AYPC.SL130.0102 AYPC.SL130.0107 AYPC.SL130.0108	AYPC.SL130.0103 AYPC.SL130.0104 AYPC.SL130.0107 AYPC.SL130.0108
 HS		Installation of AYP.C.SL130.094.1HS and AYP.C.SL130.094.1HS-01  	Installation of AYP.C.SL130.094.1HS and AYP.C.SL130.094.1HS-01  
		Installation of AYP.C.SL130.0985 and AYP.C.SL130.0986 	Installation of AYP.C.SL130.094.1HS and AYP.C.SL130.094.1HS-01 
			

**5.7** Check that the door leaves run smoothly, without jams.



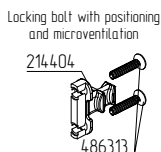
# ALT SL130 system installation

**6A**

Installation of the locking elements. HS120/200/270/420 standard.

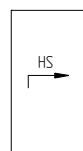
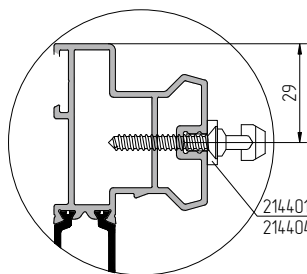
Size table for hook installtion (lift and slide doors)

Type	A1, mm	A2, mm	B1, mm	B2, mm	C1, mm	C2, mm	*D1, mm	*D2, mm	X, mm
HS120 Standard									
Gr 180	—	—	588	612	988	1012	—	—	—
Gr 210	738	762	1188	1212	1588	1612	—	—	—
Gr 240					1888	1912	—	—	—
HS200/270/420 Standard									
Gr 180	—	—	588	612	988	1012	—	—	—
Gr 210	738	762	1188	1212	1588	1612	—	—	—
Gr 240					1888	1912	HHC -323	HHC -299	HHC -701
Gr 270					2188	2212			



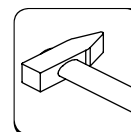
Install from the bottom side.

The locking points must be placed along the hardware groove.



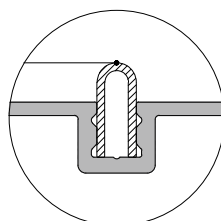
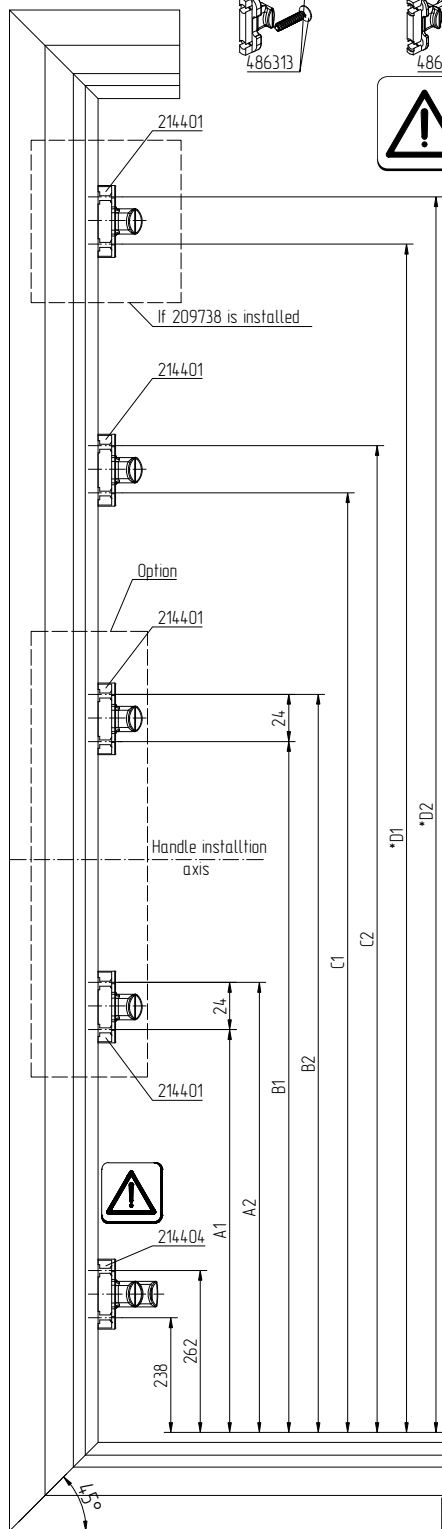
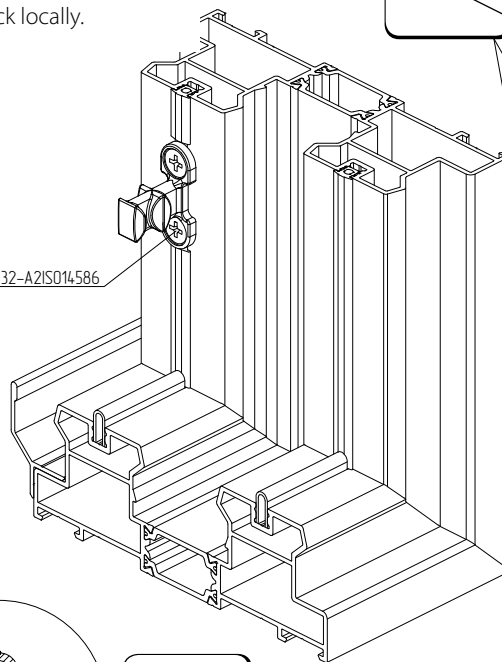
209738  
for 195431 and 195437

Remove the plugs  
if additional locking  
points are used.



Check locally.

4,8x32-A2ISO14586



Size should be measured  
out from the top of AYPC.  
SL160.1950 guide rail.

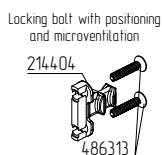
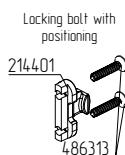
# ALT SL130 system installation



Installation of the locking element. S270 standard.

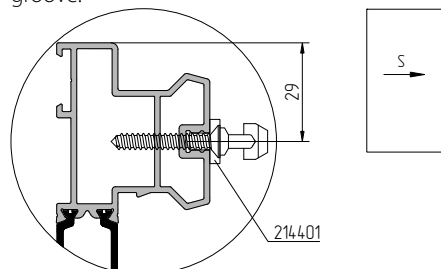
Size table for hook installtion (sliding doors)

Type	A1, mm	A2, mm	B1, mm	B2, mm	C1, mm	C2, mm	D1, mm	D2, mm
S270 Standard								
Gr.50	-	-	167	143	133	157	-	-
Gr.200	759	735	259	235	291	315	741	765

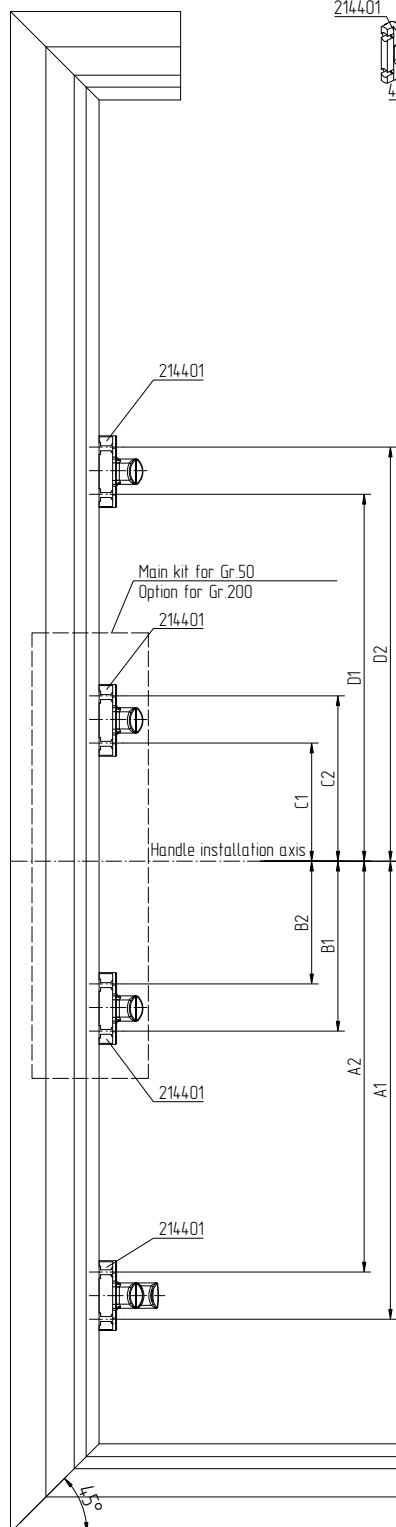
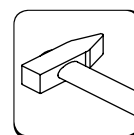


Install from the bottom side.

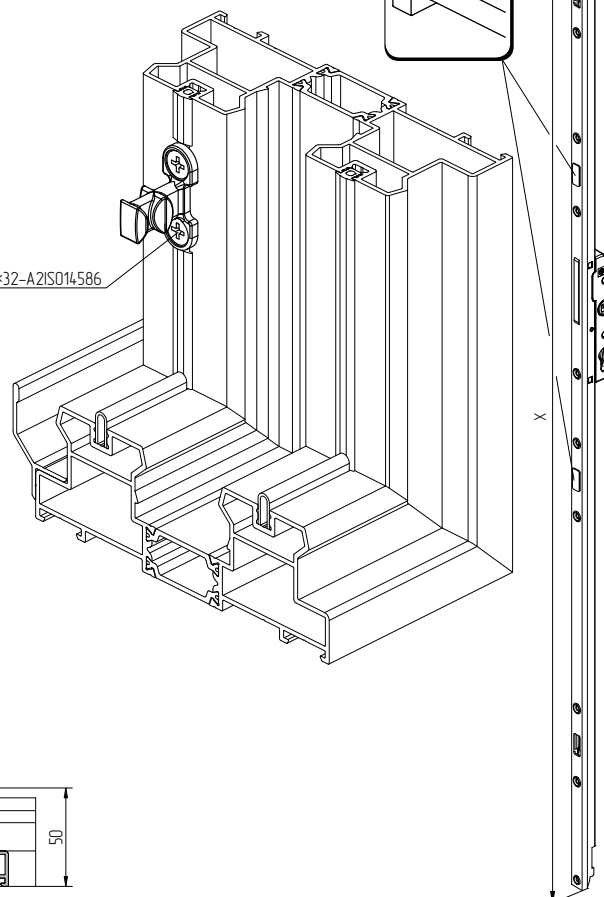
The locking points must be placed along the hardware groove.



Remove the plugs if additional locking points are used.



4,8x32-A2ISO14586



6c

Diagram illustrating the installation of the door handle:

- Hook with strike plate 305427
- 305428
- installation into the frame
- installation on the door leaf
- Check

Type	A1, mm	A2, mm	B1, mm	B2, mm	C1, mm	C2, mm	*D1, mm	*D2, mm	X, mm
HS120 in viso									
Gr. 180	-	-	546	654	946	1054	-	-	-
Gr. 210	696	804	1146	1254	1546	1654	-	-	-
Gr. 240					1846	1954	-	-	-
HS200/270/420 in viso									
Gr. 180	-	-	546	654	946	1054	-	-	-
Gr. 210	696	804	1146	1254	1546	1654	-	-	-
Gr. 240					1846	1954	HHC - 365	HHC - 257	HHC - 701
Gr. 270					2146	2254			

en strike plates  
n installed onto  
C.SL130.0105,  
C.SL130.0106,  
C.SL130.0109  
es, cut AYP.C.  
80.0806 cover  
profile after  
strike plates  
allation and  
stment.

Mark

Mark

Remove the plugs  
if additional locking  
points are used.

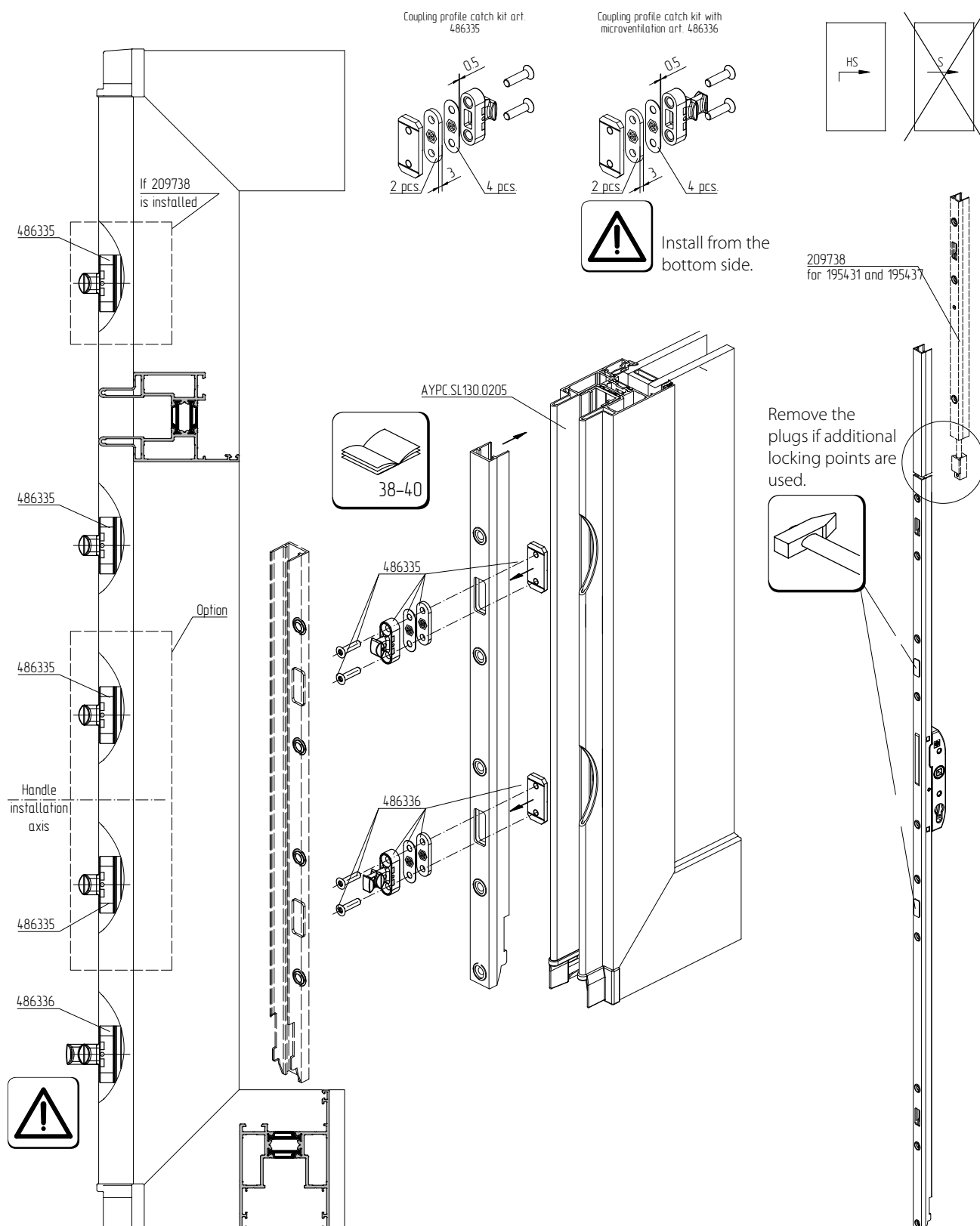
Size should be measured  
out from the top of  
AYP.C.SL160.1950 guide  
rail.

50

# ALT SL130 system installation

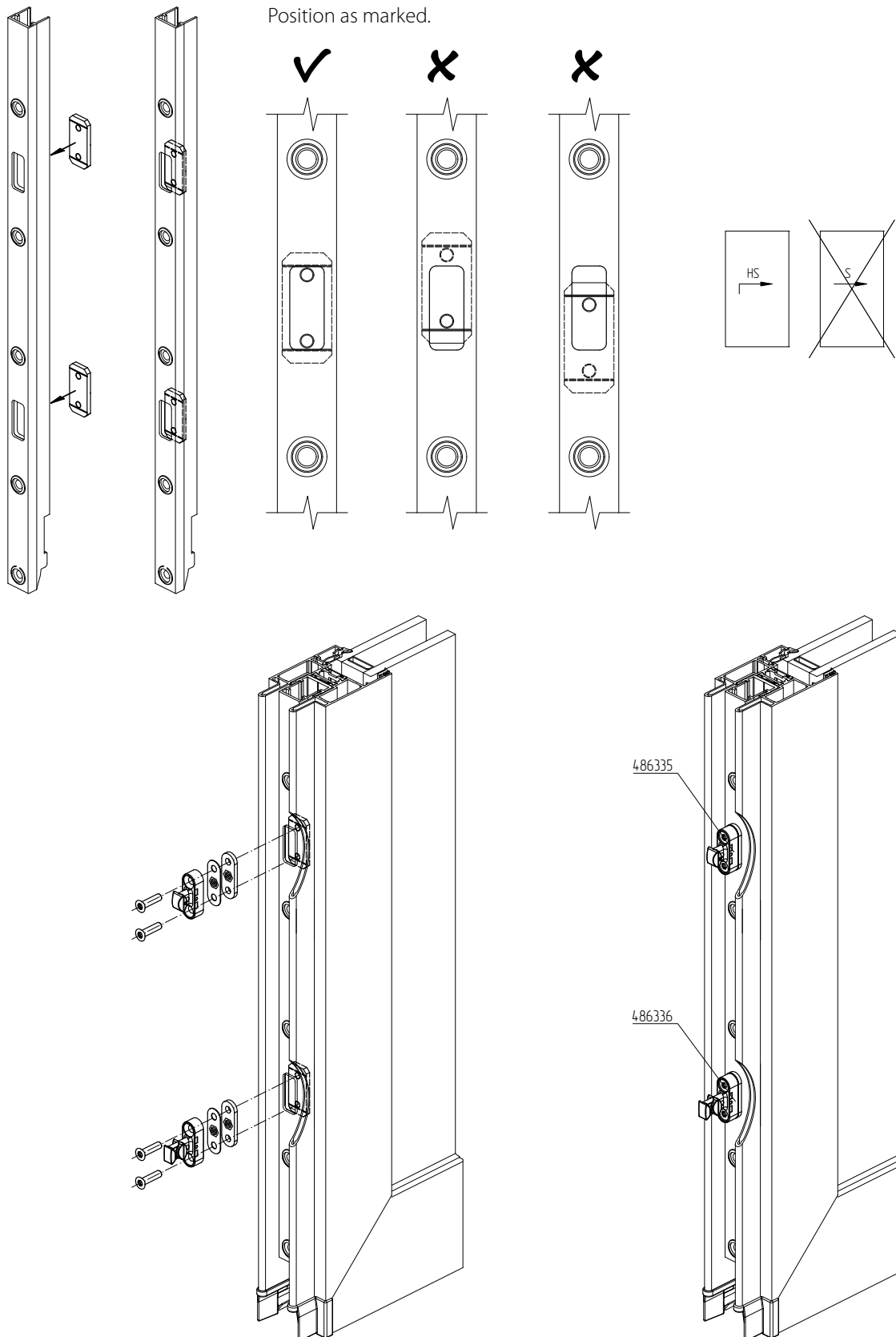


Installation of the locking elements on the coupling profile. HS120/200/270/420 standard / invisio.



# ALT SL130 system installation

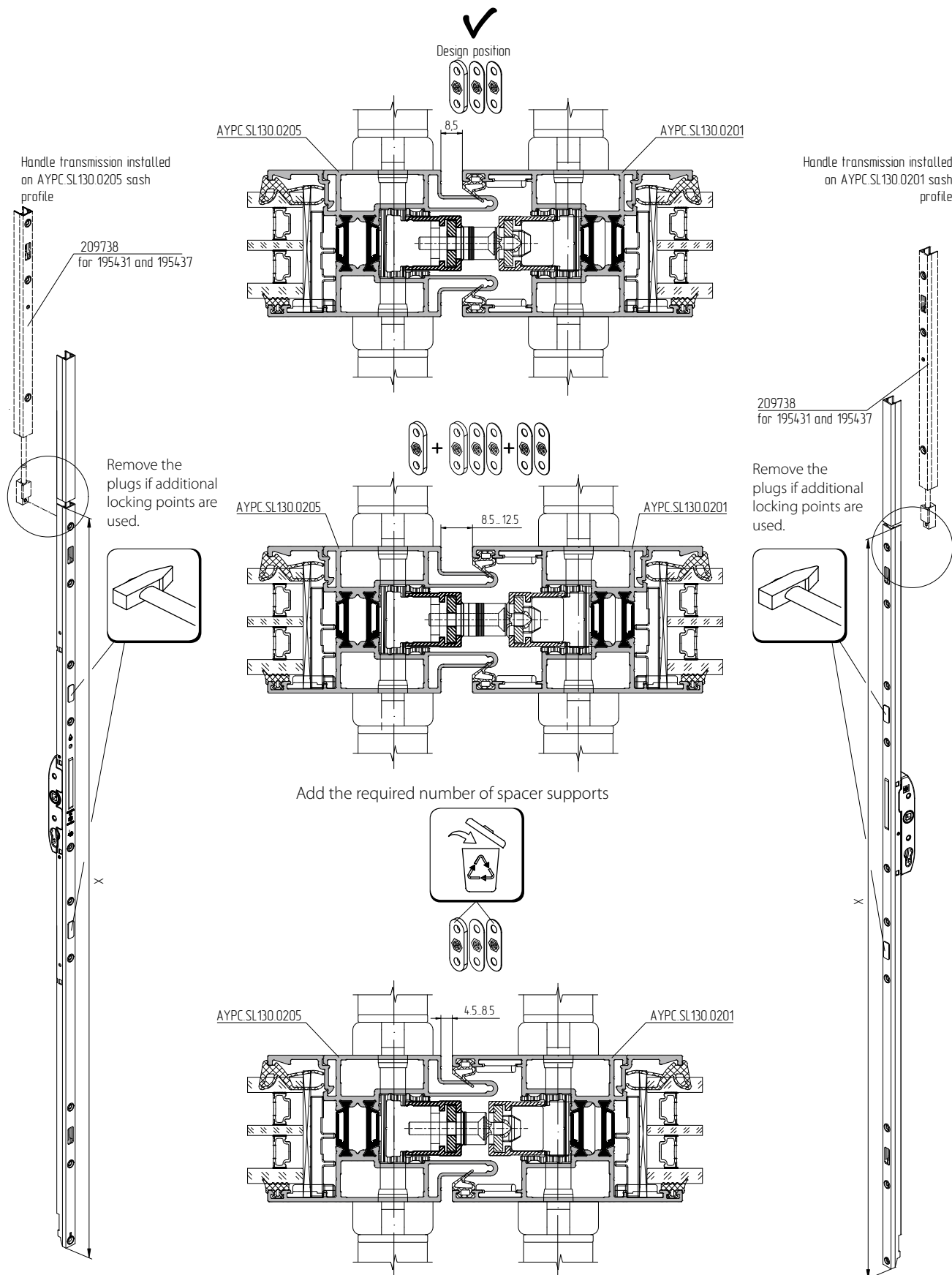
## Installation scheme of coupling profile catch kit



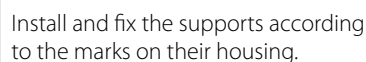


# ALT SL130 system installation

## Adjustment of locking elements on the coupling profile

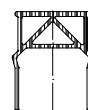
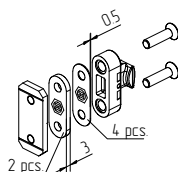


## Adjustment of locking elements on S270 coupling profile



Coupling profile catch k  
art 486335

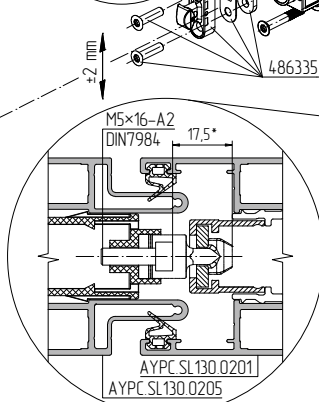
Decorative profile  
art. AYPC.SL130.1907



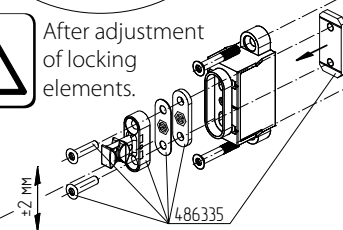
Remove the plugs if additional locking points are used.



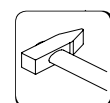
Install and fasten the fixing lug with the catch according to marks on the support housing.



After adjustment  
of locking  
elements.



Handle installation axis  
type door leaf



215529  
active door leaf  
AYPC.SL130.0201

AYPC.SL130.0906  
install before glazing

215532  
active door leaf  
AYPC.SL130.0201

### Adjustment of locking elements on the coupling profile

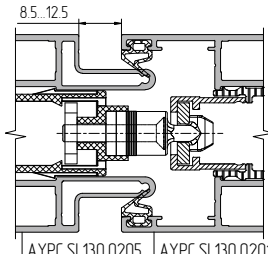
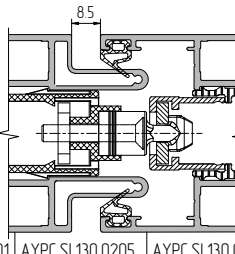
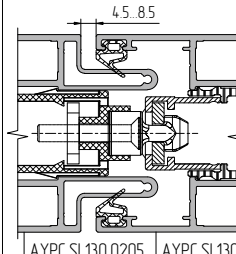
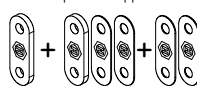
Remove the required number  
of spacer supports



### Design position



Add the required number



AYPR SI 130 0205

AYPR SI 130 0201 A

AYPC SI 130 0205

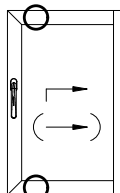
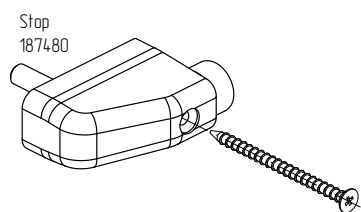
AYPC SI 130 0201

AYPR SI 130.0205

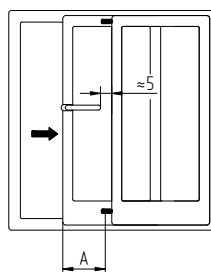
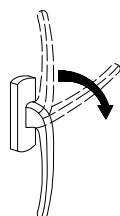
5	AYPR SI 130 0201
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# ALT SL130 system installation

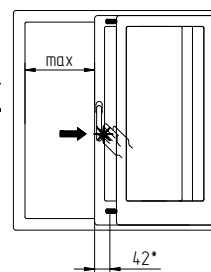
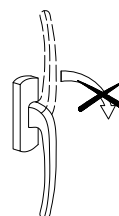
## Stop installation



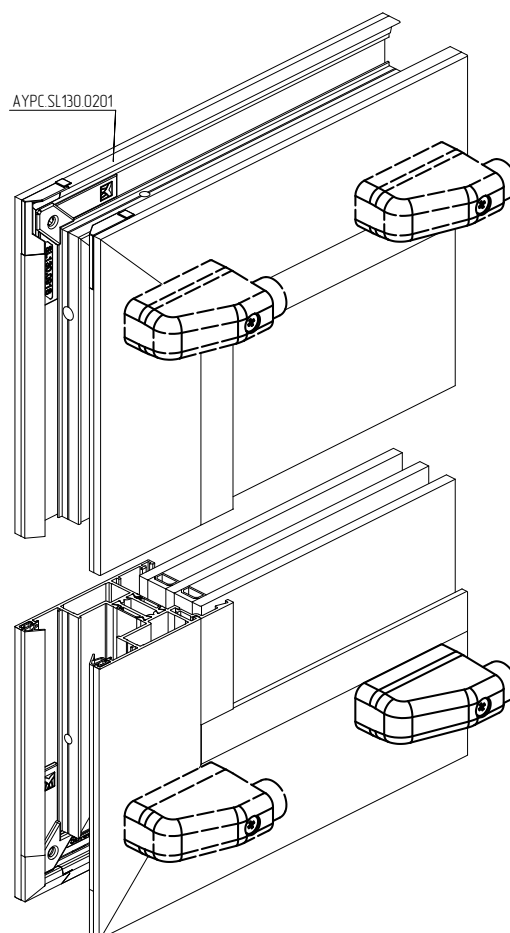
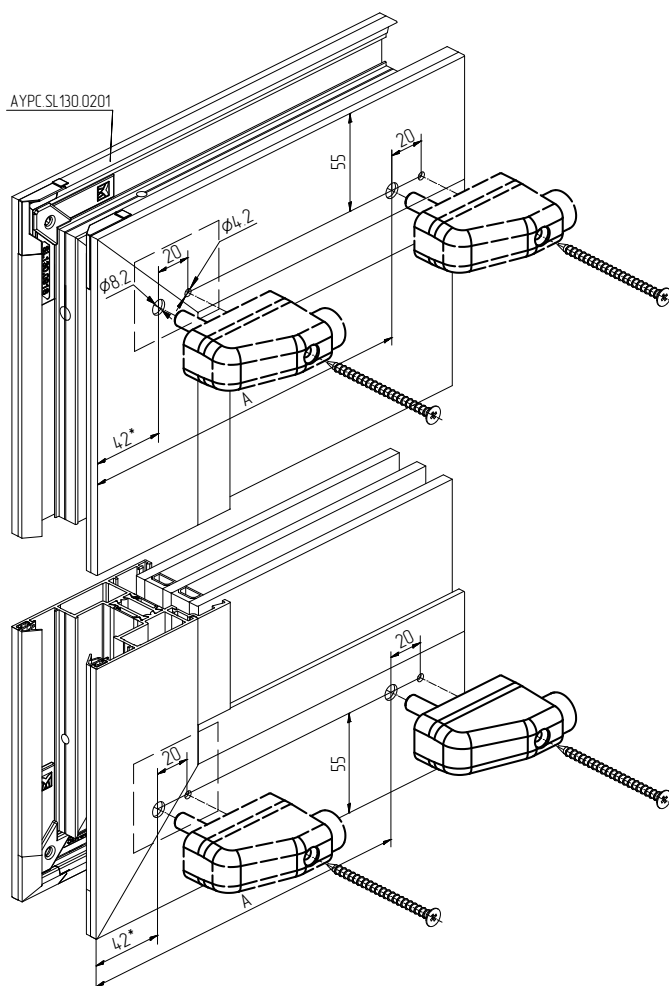
Always install two stops!  
If only one stop is installed, door leaf sideways is possible.



The distance at which the stops are positioned depends on the required handle position after opening the leaf.



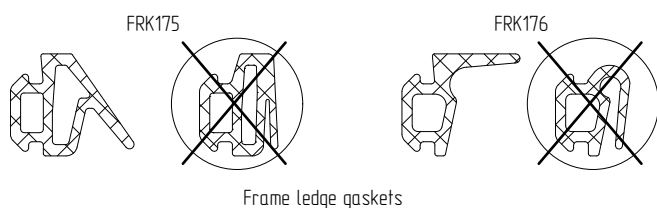
Maximum opening of the leaf. In door open position, the handle can not be turned.



## ALT SL130 system installation



### Gaskets check



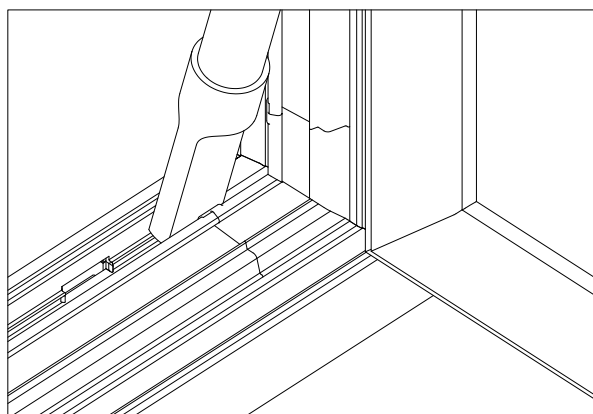
Check all gaskets for damage, sticking or breakage:

- gasket perimeter;
- gasket joints.



### Door cleaning.

1. Check the structural elements for debris and dirt: building materials, dust, etc.
2. Clean the drain holes, grooves and hardware with a vacuum cleaner or soft cloth and a diluted neutral pH detergent.



To maintain the surface quality of the hardware over time and to prevent wear through corrosion, observe the following recommendations:

- do not use aggressive cleaning agents, solvents or detergents, such as synthetic solvents, acetone or nitrosolvents. Use neutral soap and water;
- do not use hard abrasives such as scrapers, metal brushes, rough sponges etc. Use plastic or wooden scrapers, soft cloth and brushes or a vacuum cleaner.

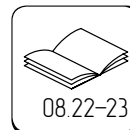


Recommended cleaner kit  
Cleaning&Care by Weiss

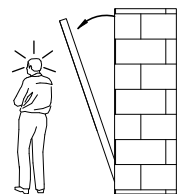
# ALT SL130 system installation

9

Install the infill units into fixed lights.



See section 'Profile machining and assembly. Infill unit installation' in SL130 Technical Catalogue.



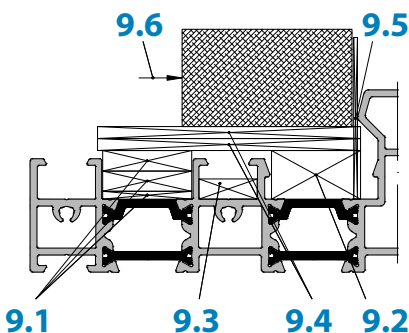
Do not leave the glass unit unsecured!



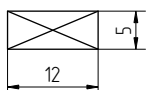
Install leveling and spacer support kits.

**9.1** Leveling support kit. See section 'Table of glazing' in the Technical Catalogue.

**9.2** Kit of temporary spacer supports (not included in the delivery kit).

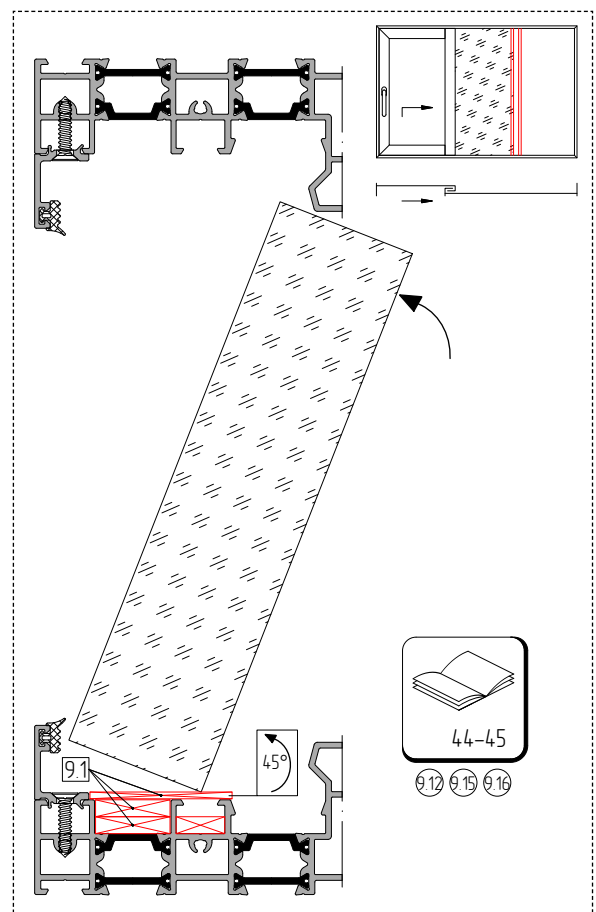


**9.3** Install the spacer support 100x12x5 (not included in the delivery kit).

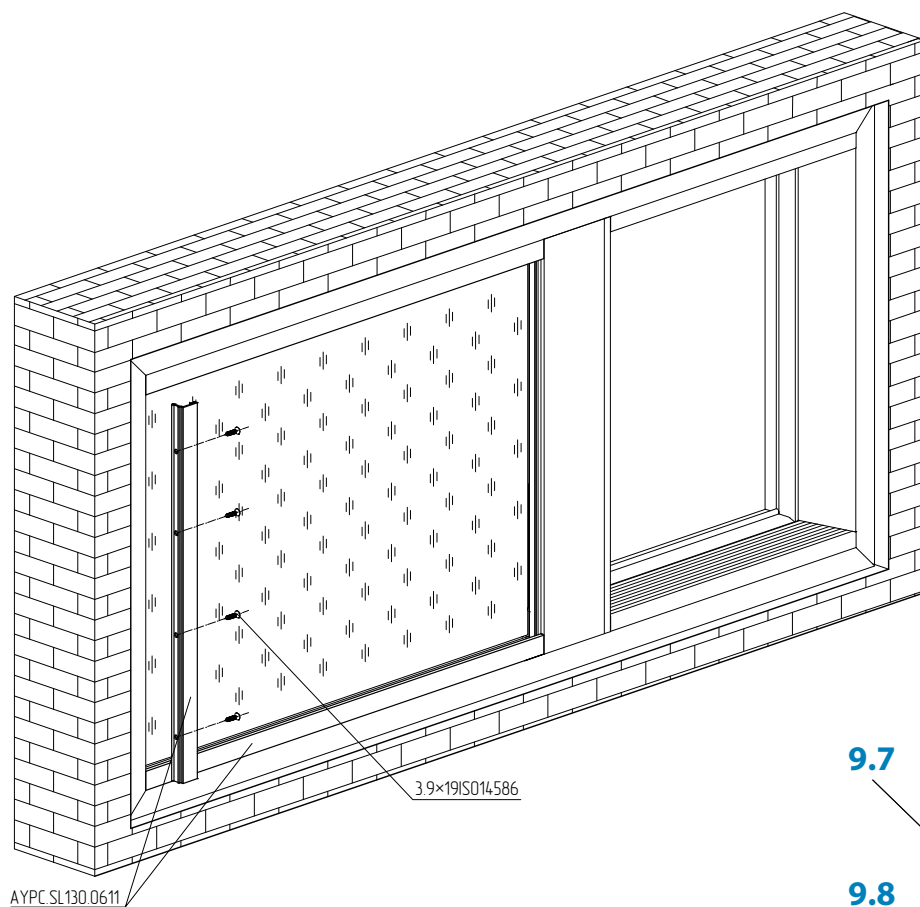


**9.4** Leveling support kit. See Table of glazing. Temporarily install diagonally.

**9.5** Temporary leveling support (not included in the delivery kit).

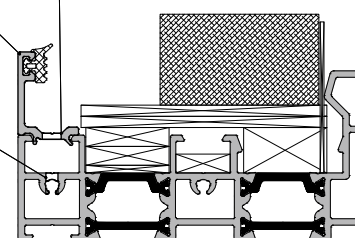


## ALT SL130 system installation



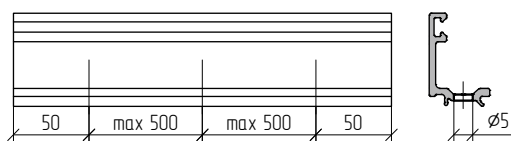
9.7 9.8-9.9

9.8



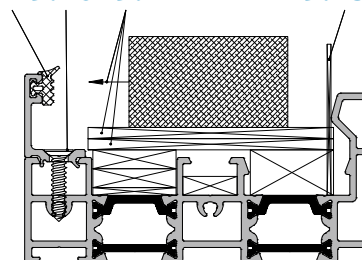
**9.6** Install the glass unit up to support 9.5.

**9.7** Install AYPC.SL130.0611 ledge profile.



9.11 9.10 9.12

9.13



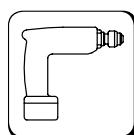
**9.8**



**9.9**



**9.10**



3,9x19-A2ISO14586

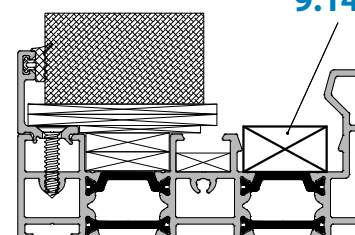
**9.11** Install the external sealing contour of the glass unit.

**9.12** Install the glass unit and leveling supports in design position. See Table of glazing.

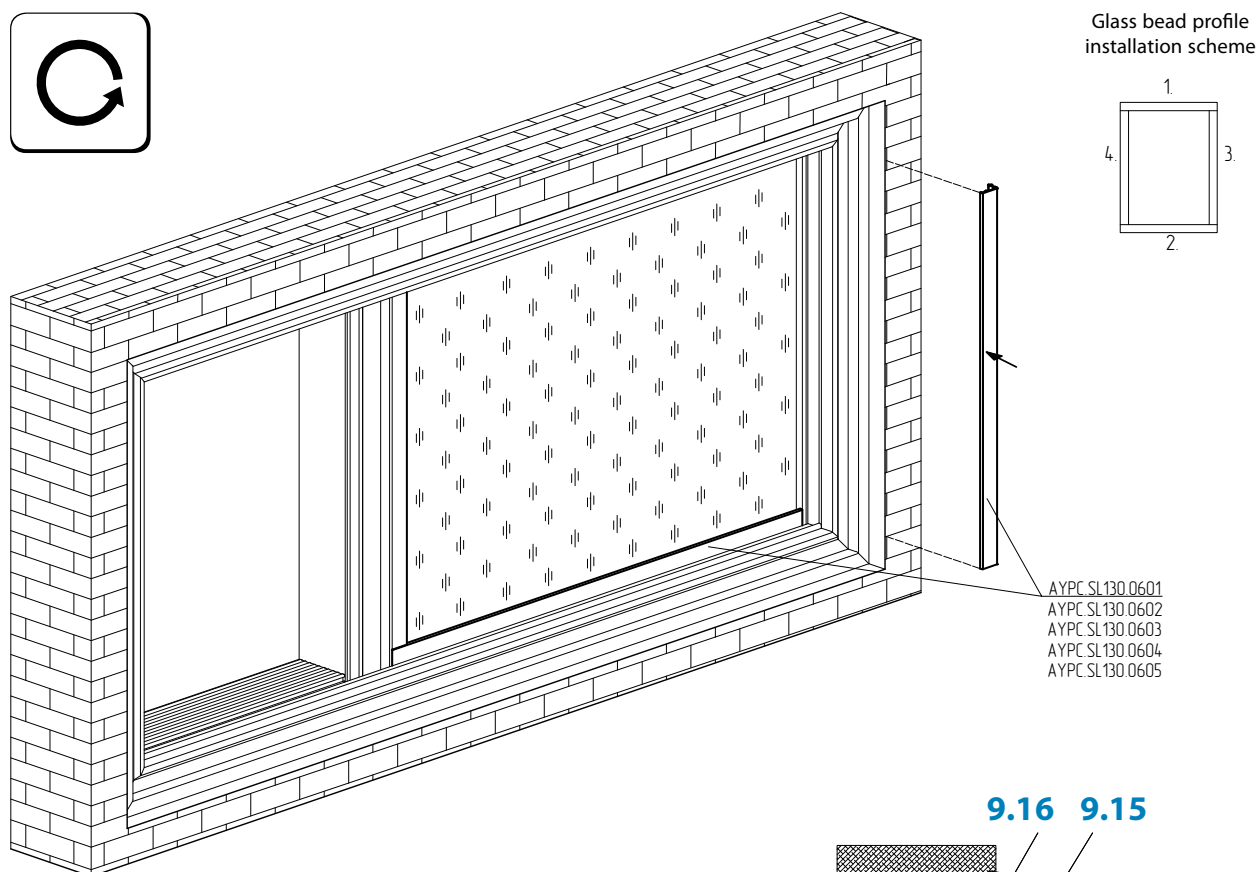
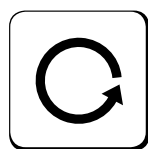
**9.13** Remove temporary leveling supports.

**9.14** Remove temporary spacer supports.

9.14

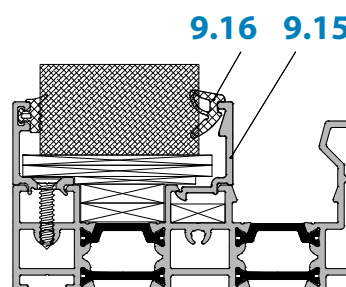


# ALT SL130 system installation



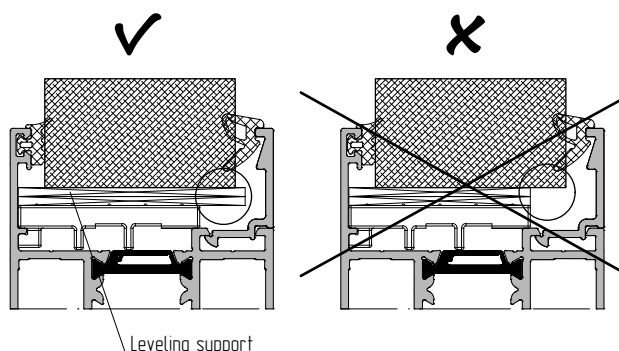
**9.15** Install AYPC.SL130.0601 — AYPC.SL130.0605 glass bead profiles depending on the glass unit thickness.

**9.16** Install the inner sealing contour of the glass unit.



- The glass units must be carried vertically, avoiding impacts, leaning against corners or a rigid base.
- Use hand-held suction cups for glass installation.
- Place the glass unit in the correct position according to its marking and formula.
- When installing supports and ledge seal, check that they do not cover drain and ventilation holes.
- Install glass beads according to the marking. See step 2 'Infill removal' of the Installation Manual.

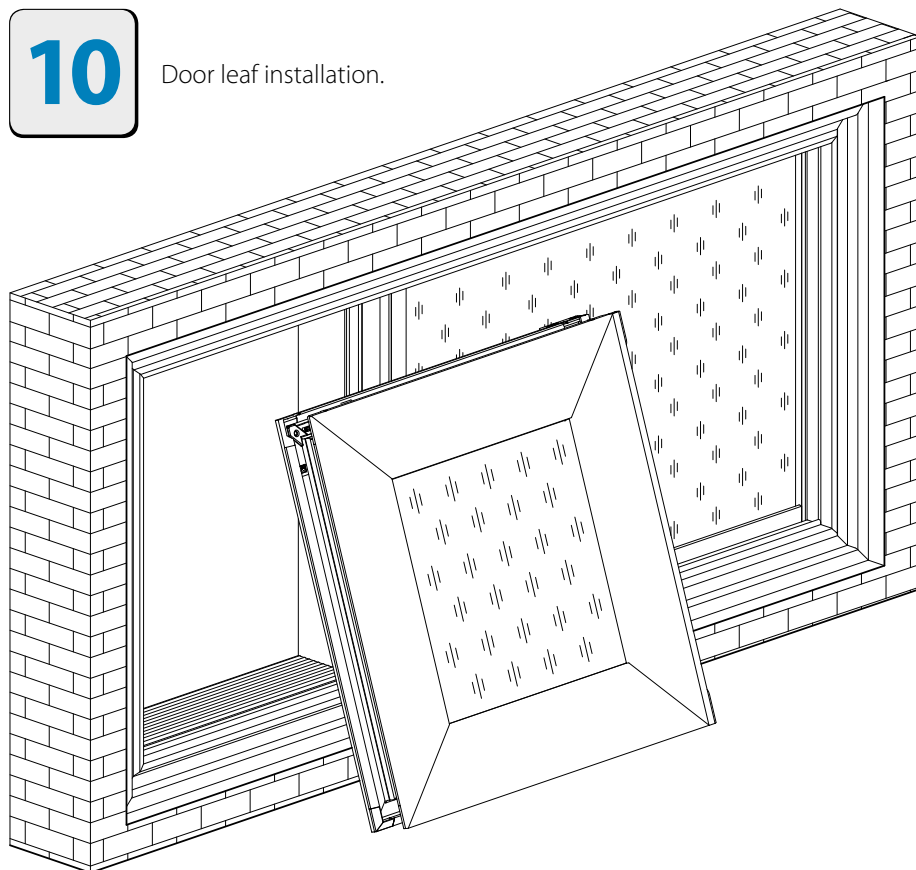
To decide on the width of the leveling support, consider the following recommendations:



## ALT SL130 system installation

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Door leaf installation.



- Insert the door leaves into the frame, perform a test opening. Door leaves must move smoothly without unusual noise or squeaks. In case of incorrect opening or/and closing, do not apply excessive force in order to prevent damage to hardware or other structural elements.
- Door leaf position in the frame can be set right by adjusting the hardware.
- Refer to the hardware manufacturer's catalogue for information on hardware adjustment.
- Check all safety relevant components (rollers, opening stops, etc.). No deformation or damage to hardware components, no loose or missing fasteners are allowed.

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Door cleaning.  
See section 8.

