



**Engineering progress
Enhancing lives**

Rio French door

Training manual

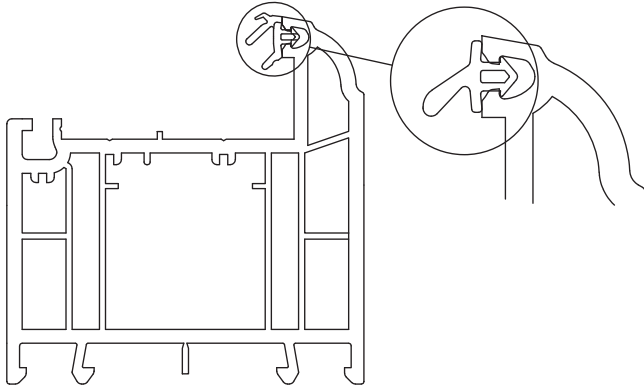


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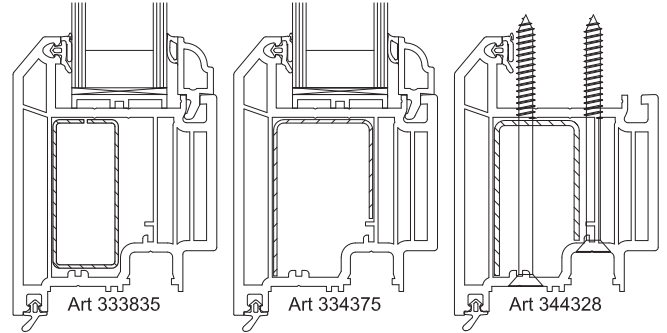
01 Manufacturing guidelines

This manual covers the steps to aid the manufacture of the Rio French door and should be used in addition to the Rio door technical manual. This manual is broken up in to steps with additional information in the appendices. If there are any questions relating to the details please contact your REHAU sales representative.



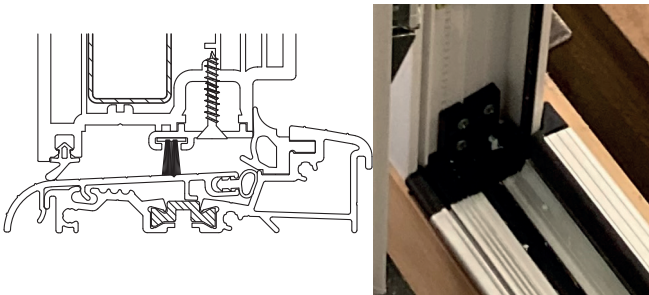
Step 1 - Remove frame gasket

On the 72mm outer frame remove the universal IG and replace with the flipper gasket, Art 329649, with it pointing into frame.



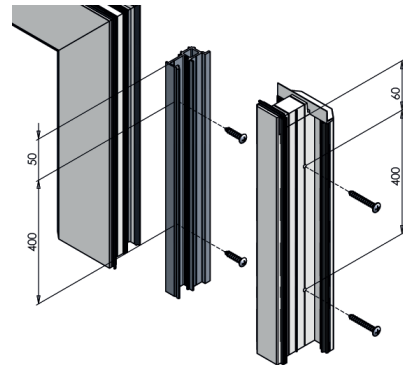
Step 2 - Reinforcement

Sashes use box steel ,Art 333835, and on the lock side use C steel, Art 334375, (if midrails are to be fitted use Art 344328 to allow screw clearance). The 72mm frame uses, Art 216393, (on the lock side for single doors use bucket steel Art 337955).



Step 3 - Low Threshold

Mechanically fit Exitex low threshold to frame using either the sculptured or chamfered plastic blocks dependant on frame used.



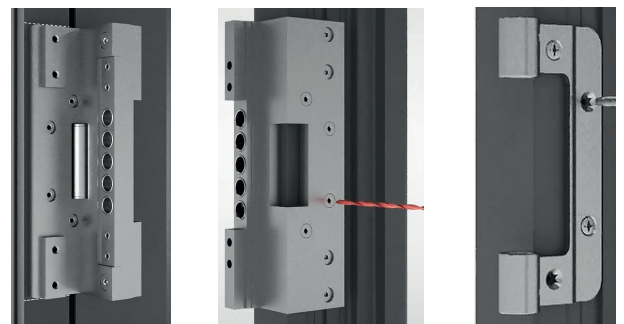
Step 4 - Dummy Mullion

Aluminium spacer has a eurogroove for the inactive gearing. The spacer is cut in lengths to miss gearing and is 22mm either end of sash.



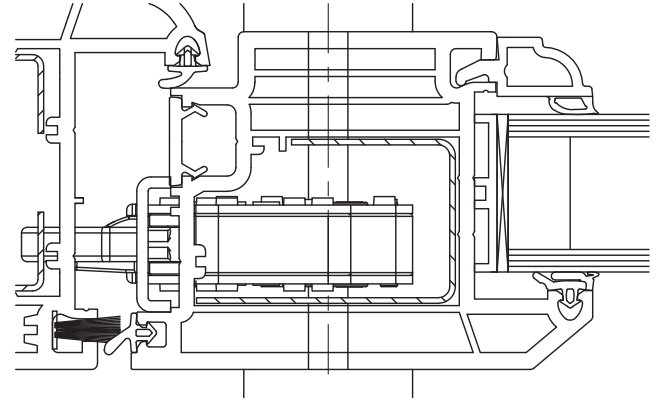
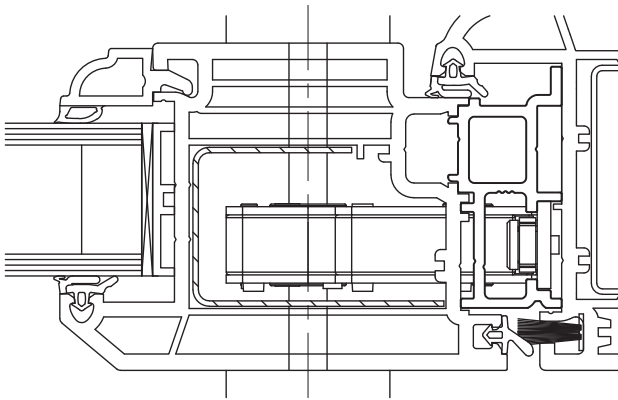
Step 5 - Fitting Hardware - Hinges to Sash

Fit three hinges per sash.



Step 6 - Fitting Hardware - Hinges to Frame

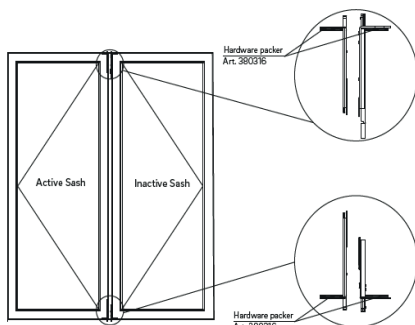
On the frame where the hinges sit remove the 1mm x 1.5mm frame upstand then fit the three hinges.



Step 7 - Fitting Hardware - Inactive Gearing

Before fitting the dummy mullion fit the 35/50 cylinder.

Step 8 Fitting Hardware - Active Gearing

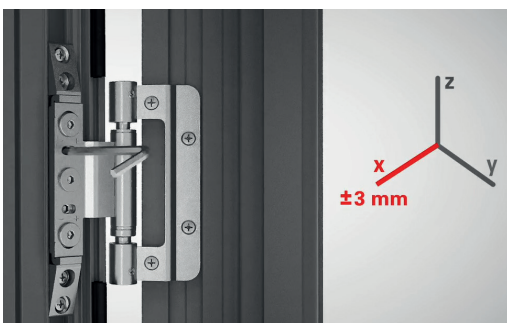


Step 9 - Fitting Hardware - Fitting Corner Drives

PAS24 has shootbolts on both Active and Inactive sashes and for non-PAS24 only on the Inactive.

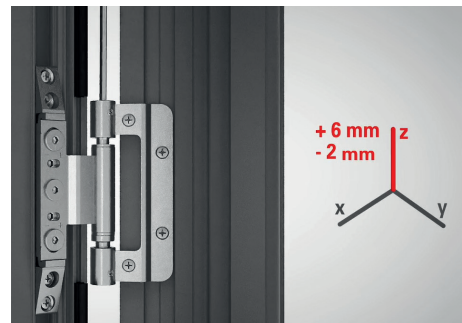
Step 10 - Fitting Hardware - Fitting keeps

Fit Keeps to Threshold and head of frame. Route out clearance for shootbolts.



Step 11 - Hinge Adjustment

Compression



Step 12 - Hinge adjustment

Height

02 Appendices

1. Prep details for master lock 1061 - REHAU Article 380305 - Ingenious Duplex 35mm backset sprung door lock (Active leaf)



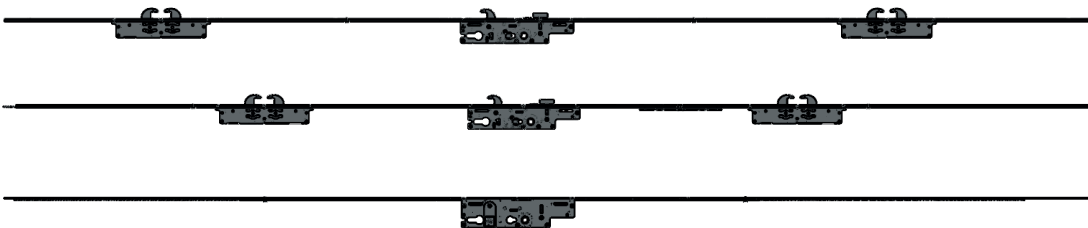
2. Prep details for master lock 1063 - REHAU Article 380306 - Ingenious Duplex 35mm backset sprung door lock PAS24 (Active leaf)



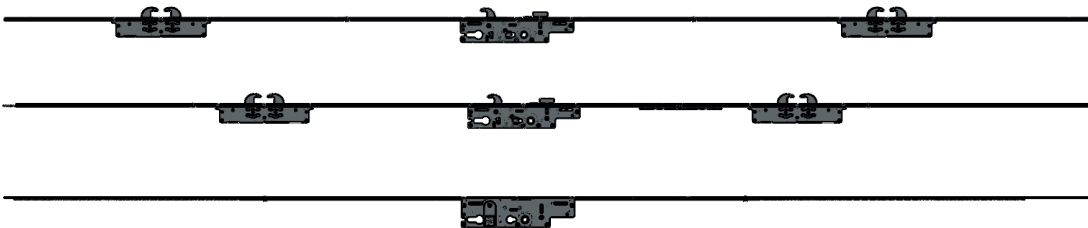
3. Prep details for inactive lock 1027 - REHAU Article 380307 - Ingenious professional door lock (Inactive leaf)



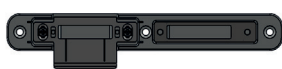
4. Overall lock dimensions for door locks 1061/1063/1027 - REHAU articles 380305/380306/380307



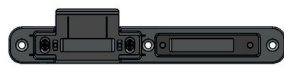
5. Basic centre dimensions for door locks 1061/1063/1027 - REHAU articles 380305/380306/380307



6. Prep details for keeps 1141 & 1143



Article 380310
Left hand centre keep



Article 380311
Right hand centre keep



Article 380313
Duplex hook keep

7. Exitex low threshold & tread plate cut out - REHAU Articles 380314 & 380315 - Single shootbolt keep and double shootbolt keep PAS24

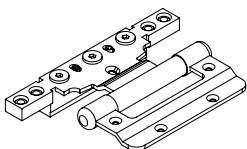


Article 380314
Single shootbolt keep



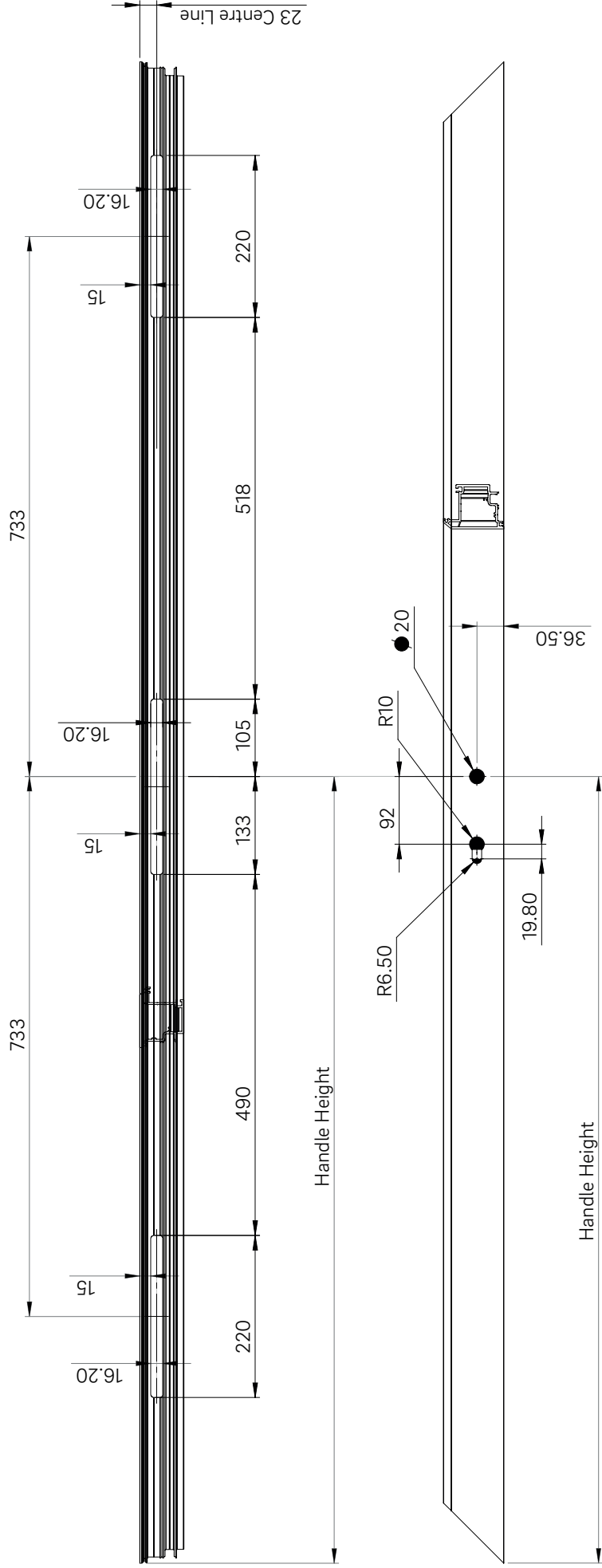
Article 380311
Double shootbolt keep PAS24

8. SFS dynamic 3D hinge jig details - REHAU Article 340684

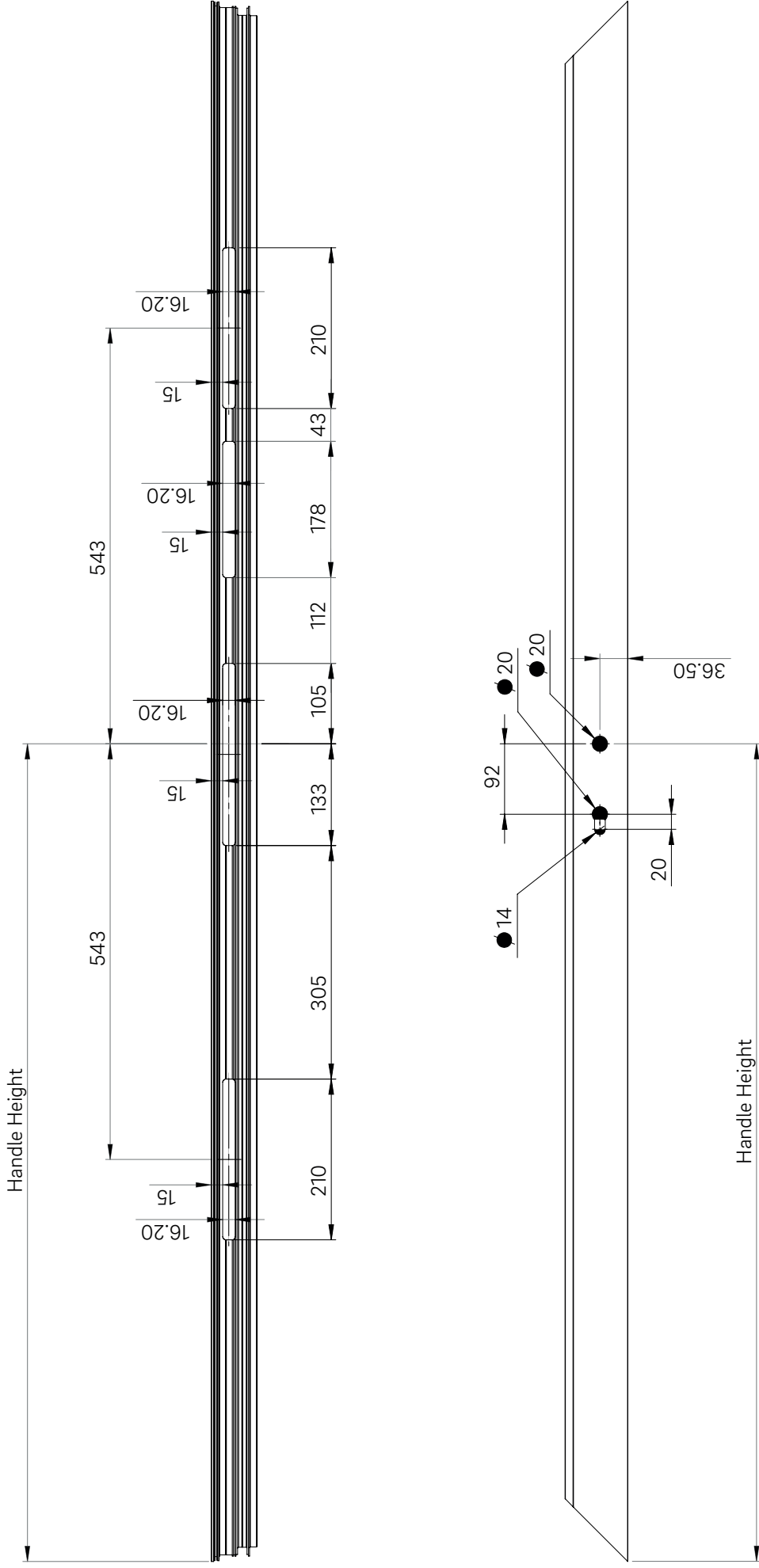


Article 340684
SFS Dynamic 3D hinge

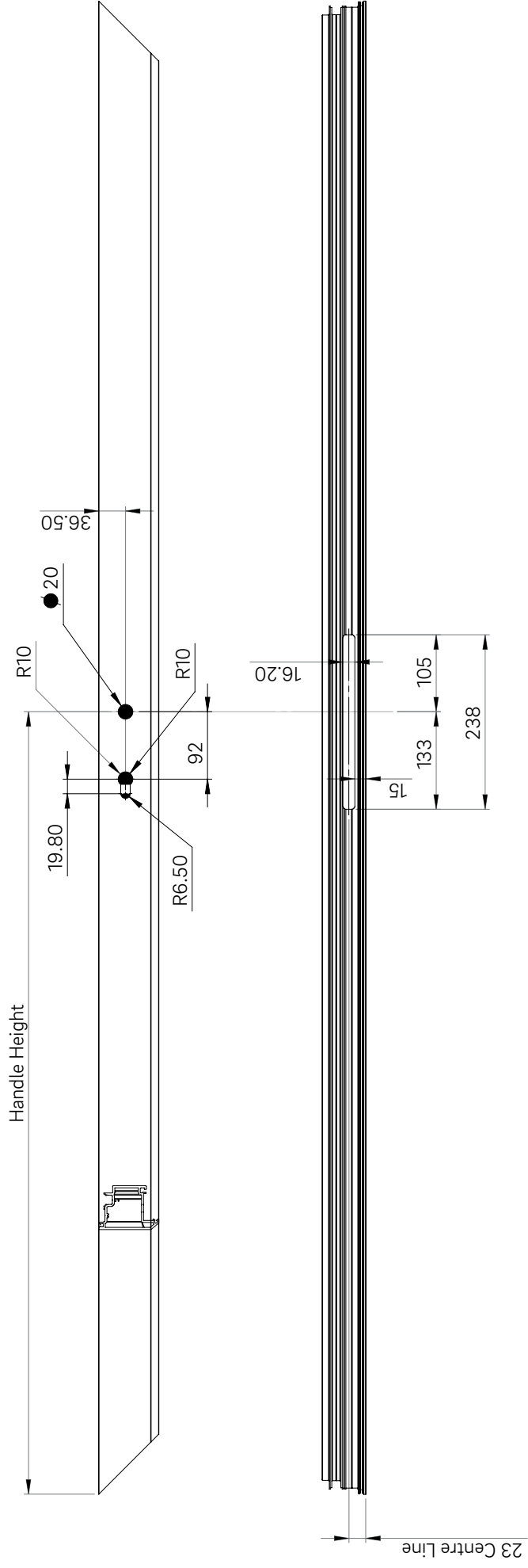
1. Prep details for master lock 1061 - REHAU Article 380305 - Active leaf door lock



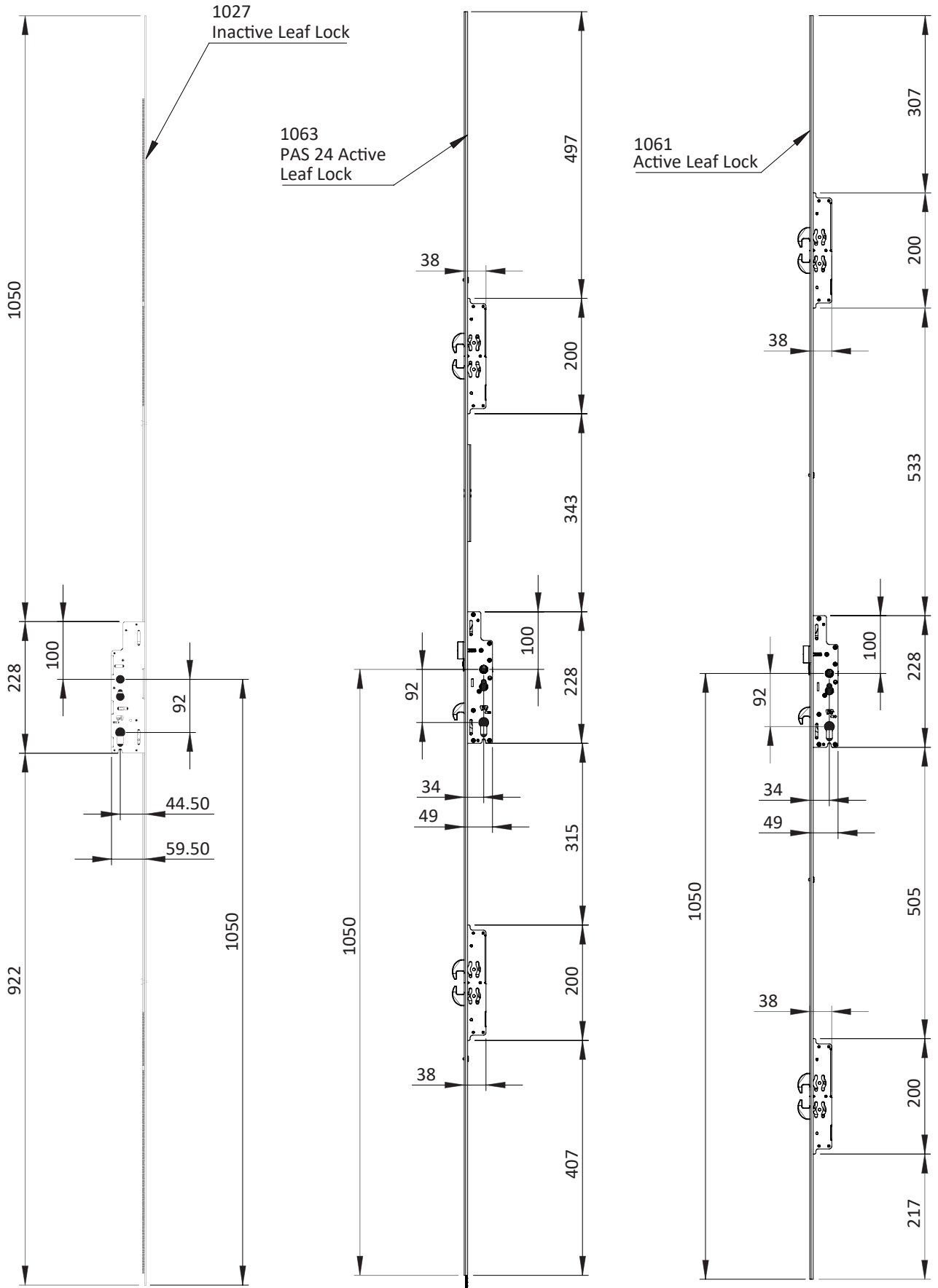
2. Prep details for master lock 1063 - REHAU Article 380306 - Active leaf PAS24 door lock



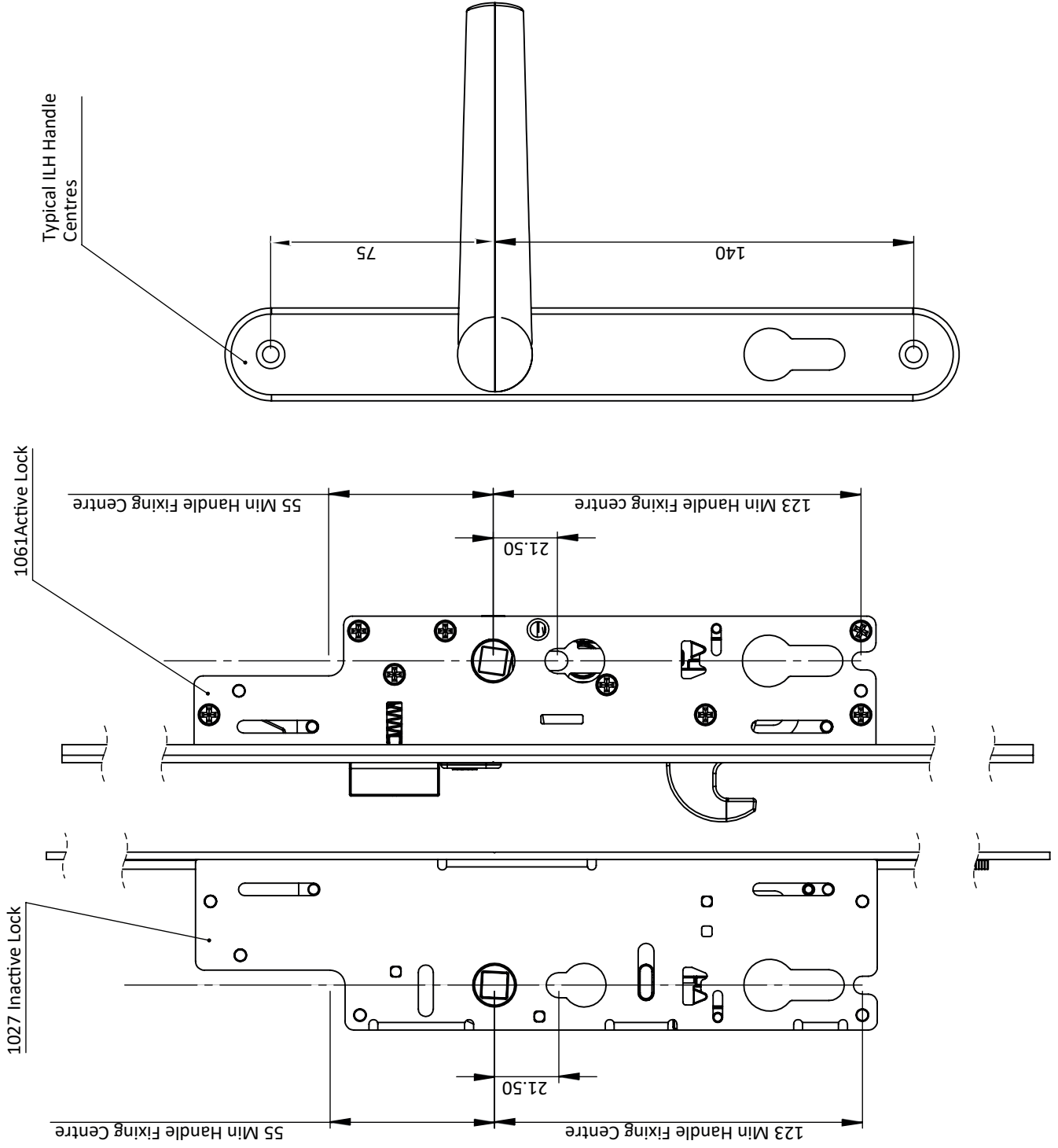
3. Prep details for inactive door lock 1027 - REHAU Article 380307 - Inactive leaf door lock



4. Overall lock dimensions for door locks 1061/1063/1027 - REHAU Articles 380305/380306/380307

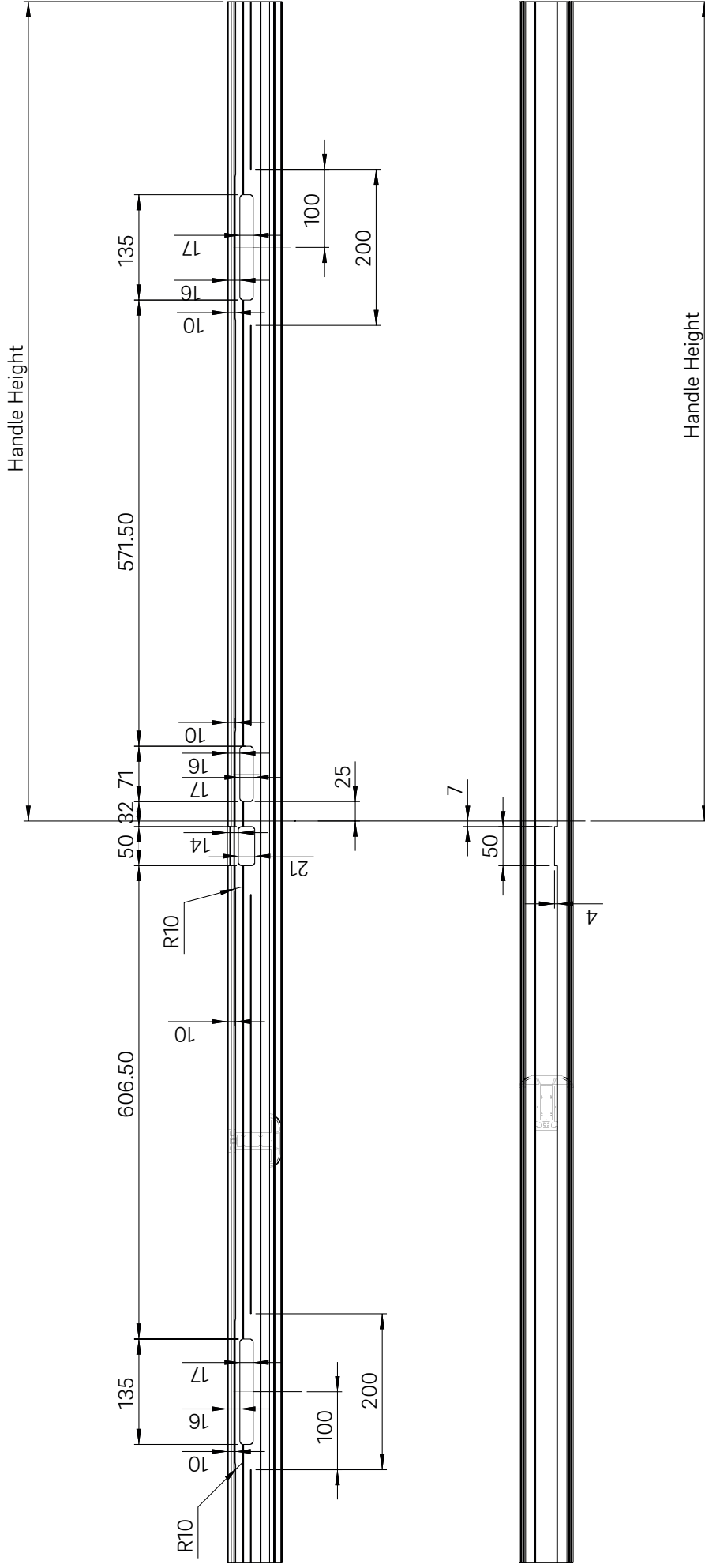


5. Basic centre dimensions for door locks 1061/1063/1027 - REHAU Articles 380305/380306/380307

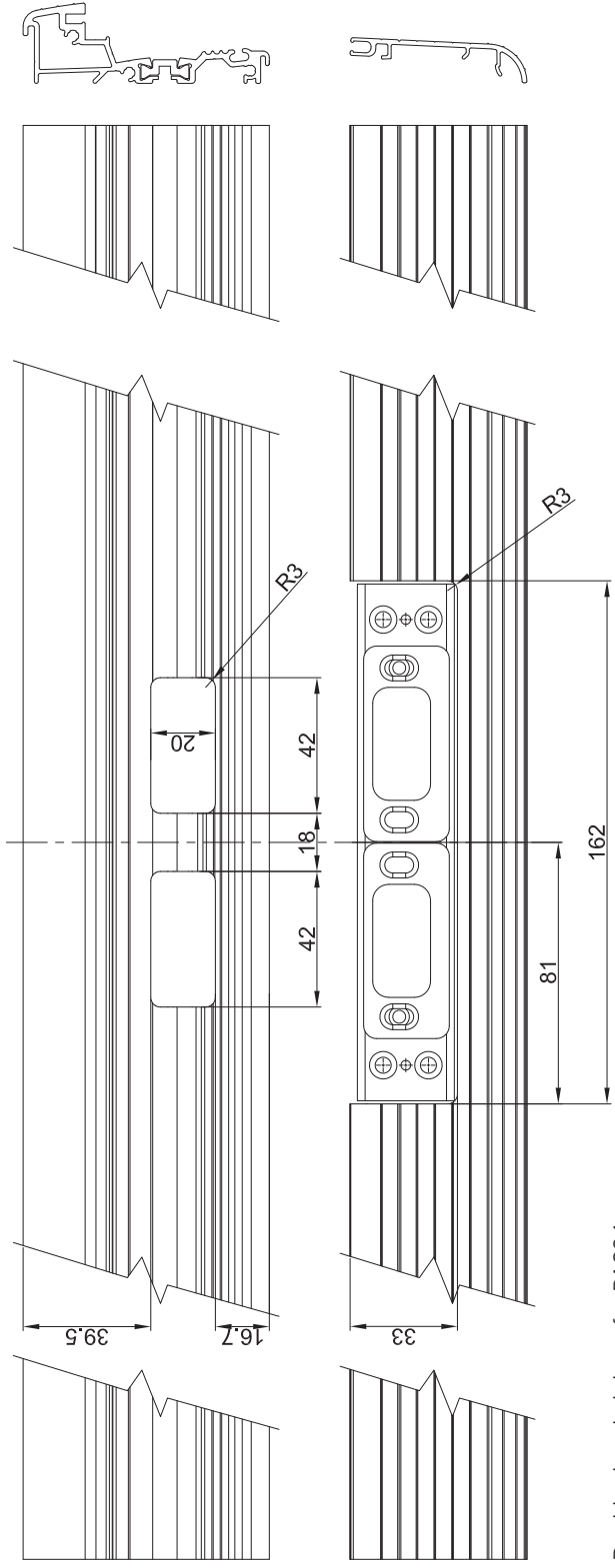
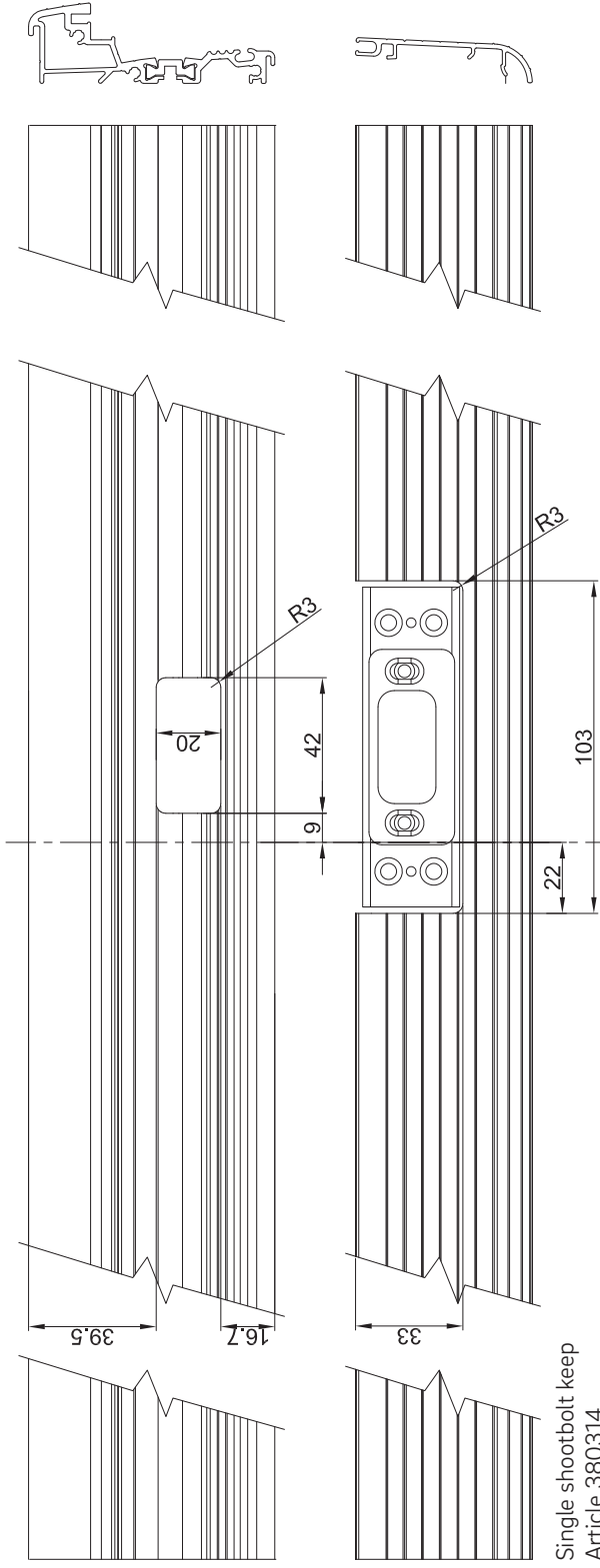


6. Prep details for keeps 1141 & 1143 - REHAU Article 380310/380311 & 380313

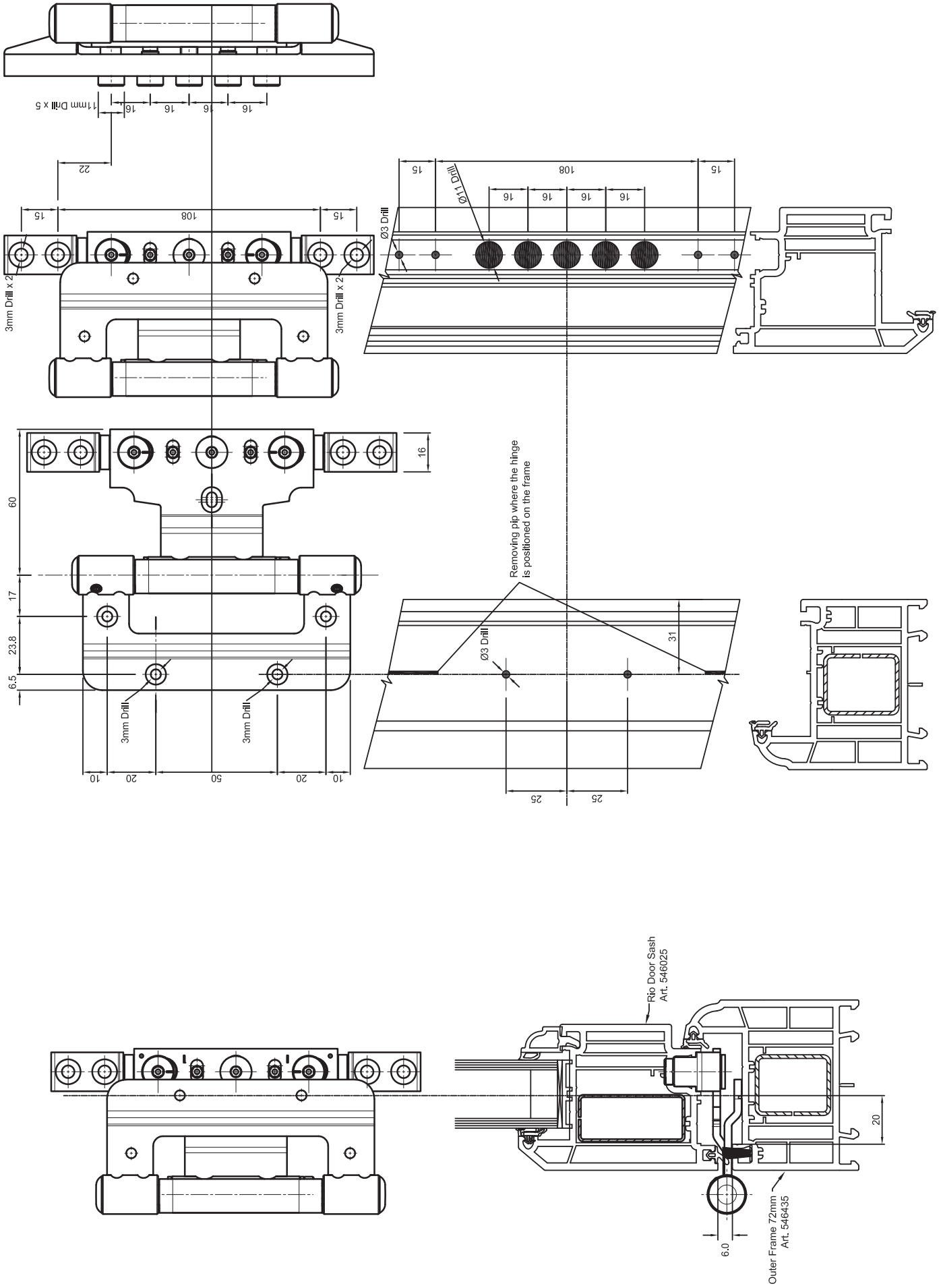
Note : Mirror prep for opposite hand



7. Exitex low threshold & tread plate cutout- REHAU Article 380314 & 380315



8. SFS Hinge jig positions - REHAU Article 340684



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11.2023