Summary	Field Installation of Window Assemblies				
Products Affected	Predadoor, Fast Seal, Bantam, Turbo Seal, Plexline				
Key Word Tags	PD, FS, TS, PX, MD, Window Field Install				
Tools/Equipment (If Required)	4' 2"x4" Clamps Drill with ¼" Drill Bit Utility Knife Straight edge				
Parts/Materials (If Required)	WINDOW W/VELCRO LOOP,24 X 24, R1020330-0X WINDOW BORDER W/VELCRO HOOK,24 X 24 R0207884 OR WINDOW W/VELCRO LOOP,17X17, R1060141-0X BORDER WINDOW W/HOOK,17X17 R0207125 AND LOCTITE 495 R0004136				
Related Media					
Author	P.Chichlowski, RevA M.Burzlaff	**Issue Date**	12/05/1996	**Status**	Active

Please Read The Entire Bulletin Before Proceeding

Procedure

Confirm window location with customer before proceeding.
Close door.

⚠ WARNING

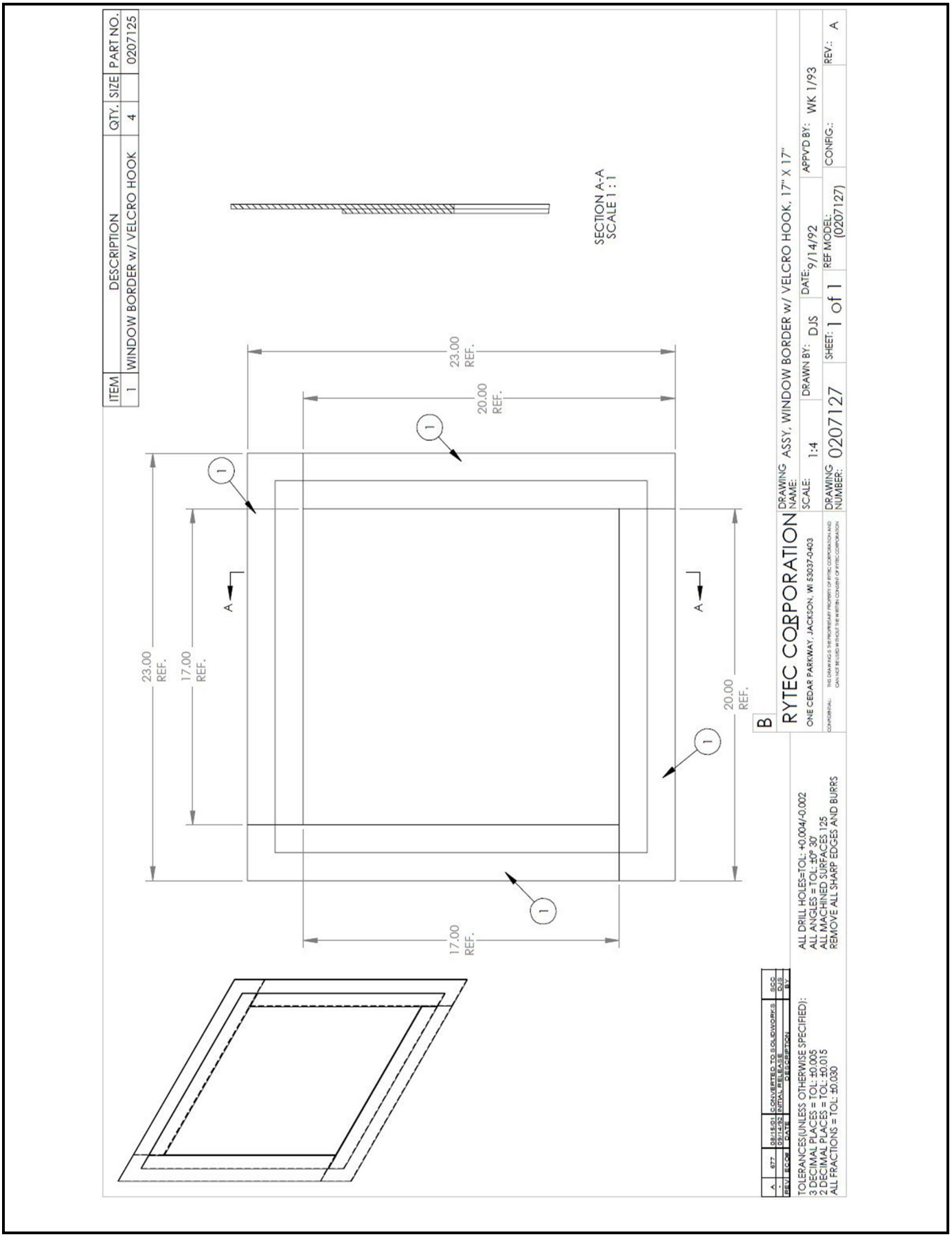
The disconnect must be in the OFF position and properly locked and tagged before performing the next step of the procedure.

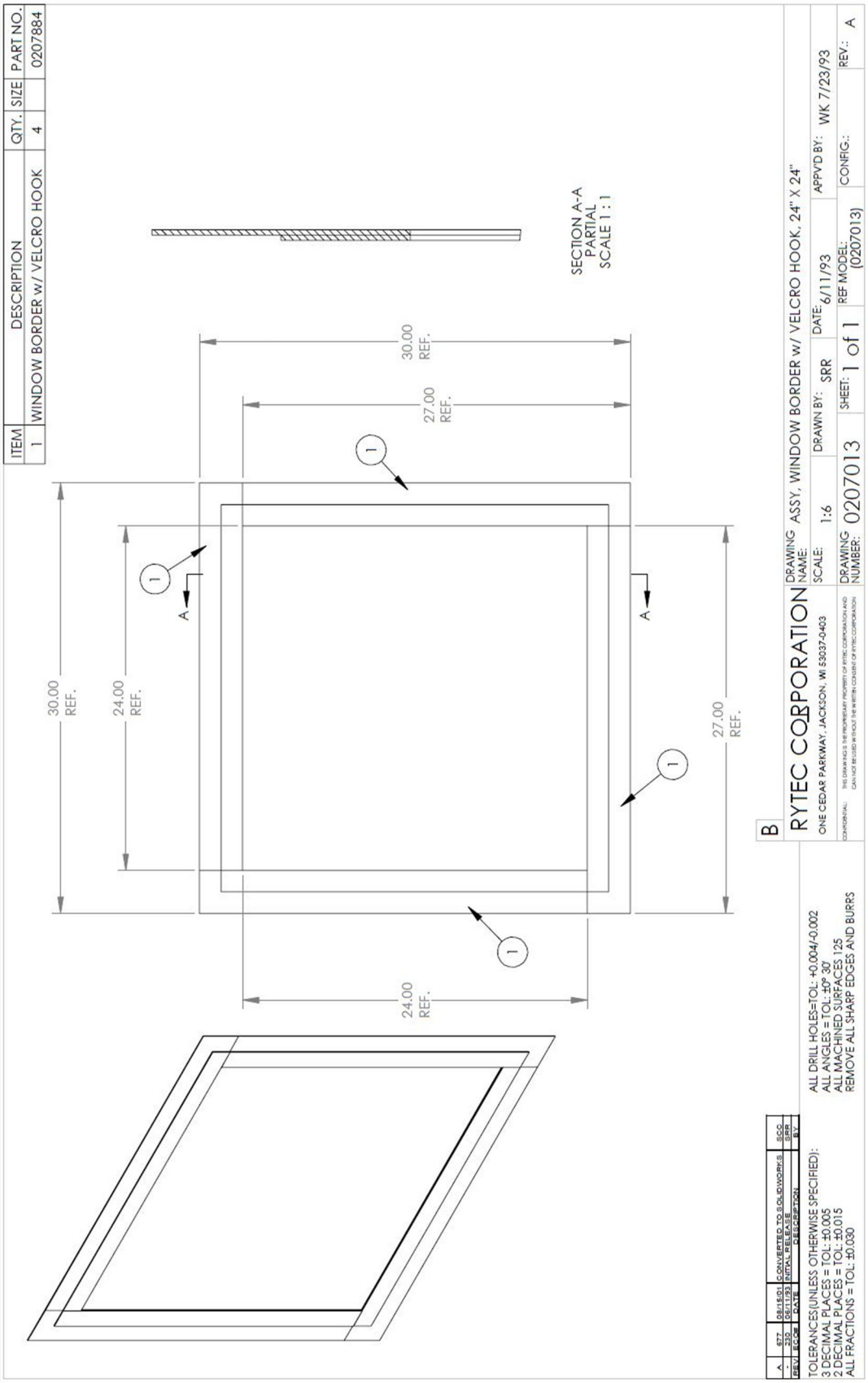
Locate and scribe the window locations. Use the window(s) provided as a template for cut out. Window(s) must be centered across the width of the door panel to provide even tracking of the door panel.

Center and drill a 1/4" hole in each corner, creating a radius at the corners. Using a utility knife and a straight edge, cut out the window opening. Be careful not to cut beyond the 1/4" holes.

The panel material must be clean and dry in order for the window borders to adhere. Note, once attached to the door panel, the Velcro portion of the borders should be in the window opening, facing away from you. Apply Loctite SB #495 to the window borders being careful not to get glue on the Velcro. Affix the borders to the door panel as shown on attached drawing 0207127 (for 17 x 17 windows) or 0207013 (for 24 x 24 windows). Using a 2" x 4" and vise clamps, clamp the window borders to the panel and allow 10 minutes cure time. Check the borders for complete adhesion to the panel. If border edges are lifting up reapply glue as necessary. Repeat this step for each window.

From the opposite side of the door, attach the PVC window to the borders. Reapply power to the door and cycle several times. Check the operation of the door and make adjustments as required. Refer to the Fast Seal Owner's manual for adjustment procedures.


ITEM
DESCRIPTION
QTY.
SIZE
PART NO.
1
WINDOW BORDER w/ VELCRO HOOK
4
0207125
SECTION A-A
SCALE 1 : 1
23.00 REF.
20.00 REF.
17.00 REF.
RYTEC CORPORATION
ONE CEDAR PARKWAY, JACKSON, WI 53037-0403
DRAWING NAME: ASSY, WINDOW BORDER w/ VELCRO HOOK, 17" X 17"
SCALE: 1:4
DRAWN BY: DJS
DATE: 9/14/92
APPV'D BY: WK 1/93
DRAWING NUMBER: 0207127
SHEET: 1 of 1
REF MODEL: (0207127)
CONFIG.:
REV.: A
TOLERANCES(UNLESS OTHERWISE SPECIFIED):
3 DECIMAL PLACES = TOL: ±0.005
2 DECIMAL PLACES = TOL: ±0.015
ALL FRACTIONS = TOL: ±0.030
ALL DRILL HOLES=TOL: +0.004/-0.002
ALL ANGLES = TOL: ±0° 30'
ALL MACHINED SURFACES 125
REMOVE ALL SHARP EDGES AND BURRS



If you have any questions please contact Rytec Customer Support at 1-800-628-1909.