

assembly instructions

stainless steel roll fitting for sliding elements astec b.400

make sure that all parts needed for installation are available. make sure that the following tools are at hand:

- drill
- hex key size 2.5 + 3
- torx screwdriver 20

-> assembly steps for astec b.400 with ceiling track 40/20 mm

1. assembly of floor track

align the floor track with the required distance between wall and door and cut the appropriate groove in the floor so that the top edge of the track is flush with the finished floor. if necessary, use levelling compound in order to guarantee that evenness, straightness and the flush fitting of the floor track are attained. fix the track to the floor with suitable mounting adhesive.

2. assembly of ceiling track

align the ceiling track vertically above the floor track and mark its position. mark the mounting holes of the ceiling track, drill the necessary holes, carefully hammer the anchors into place and screw down the ceiling track.

3. assembly of rollers

fix the rollers to the door leaf. the pre-assembled roller sets are taken apart by turning the wheel discs anti-clockwise, thus loosening the central, inside connecting screw. remove the retaining ring and put the roller half with the fitted ball bearing into the hole in the glass. make sure that the pvc washers to avoid contact between the glass and metal are previously placed between the glass and the retaining ring; likewise the pvc strips between the edge of the glass and felly. secure the roller set in the glass panel by replacing the retaining washer and then rejoin the second wheel disc with the roller set by means of the central connecting screw. it is essential to ensure that the central connection screw is fitted with a screw locking device.

4. preparing and installing door leaf

fix the provided felt strips to the glass panel where it runs in the ceiling track by gluing 2 or 3 approximately 6 to 10 cm long strips on either side of the glass. the felt strips avoid contact between the glass and metal in the ceiling track and ensure practically soundless running of the door leaf. when installing the door leaf, first lift it up at an angle and insert it into the u-profile and then bring it into the vertical position at the bottom position in the grooves.

position the stays on the ceiling track so that frontal impact of the door leaf on the wall or glass/glass collision in the case of double-door, single-track installations is reliably avoided. afterwards, fix the stays to the ceiling using woodscrews through the ceiling track.

if applicable, mount the pull handle/flush pull and clean the fittings and handles/pulls with a soft cloth.

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stainless steel roll fitting for sliding elements
astec b.400

-> assembly steps for astec b.400 with ceiling track 60/30mm and damping system

1. assembly of floor track

align the floor track with the required distance between wall and door and cut the appropriate groove in the floor so that the top edge of the track is flush with the finished floor. if necessary, use levelling compound in order to guarantee that evenness, straightness and the flush fitting of the floor track are attained. fix the track to the floor with suitable mounting adhesive.

2. assembly of ceiling track

disassemble the two-part ceiling track and detach the countersunk screws m5x8mm and the cover plate from the support rail using the size 3 hex key. the pre-installed door damper/end stop may remain in place.

align the ceiling track vertically above the floor track and mark its position. mark the mounting holes of the support rail, drill the necessary holes, carefully hammer the anchors into place and screw down the support rail.

3. assembly of rollers

fix the rollers to the door leaf. the pre-assembled roller sets are taken apart by turning the wheel discs anti-clockwise, thus loosening the central, inside connecting screw. remove the retaining ring and put the roller half with the fitted ball bearing into the hole in the glass. make sure that the pvc washers to avoid contact between the glass and metal are previously placed between the glass and the retaining ring; likewise the pvc strips between the edge of the glass and felly. secure the roller set in the glass panel by replacing the retaining washer and then rejoin the second wheel disc with the roller set by means of the central connecting screw. it is essential to ensure that the central connection screw is fitted with a screw locking device.

4. trigger assembly on the door leaf

attaching the end stop/damping triggers

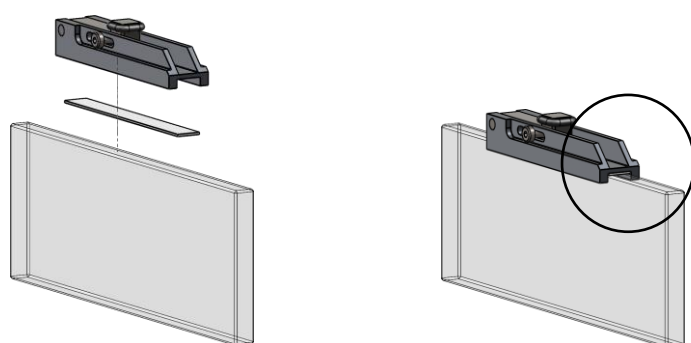
please refer to the order drawings for the correct positioning of the end stop or damping triggers. the glass surfaces and glass edges must be cleaned using the provided cleaning cloth. make sure the surfaces and edges are free of dust and grease. for a solid adhesion, the provided primer must be applied to the bond areas on the glass door leaf. the recommended application temperature for the primer is between 15° C and 25° C. push on the marked area on the cartridge until you feel and hear a click. apply evenly on the bonding areas on the glass. depending on temperature, humidity, air circulation and porosity of the surface, allow a flash-off time of at least 5 minutes. attention: only apply one coat of primer!

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completely remove the large protective sheet from the tape and attach the tape to the underside of the trigger. completely remove the second protective sheet and press the trigger onto the marked area on the door leaf with approx. 20 N/cm². the final bond strength is reached after about 72 hours at 20° C or faster at higher temperatures.

safety warning: only use in well-ventilated spaces, do not breathe in, use provided gloves for protection, avoid contact with eyes and skin.



the beveled edge of the trigger always points toward the outer edge of the glass, i. e. in the direction of the door damper/end stop.

5. adjusting the door leaf

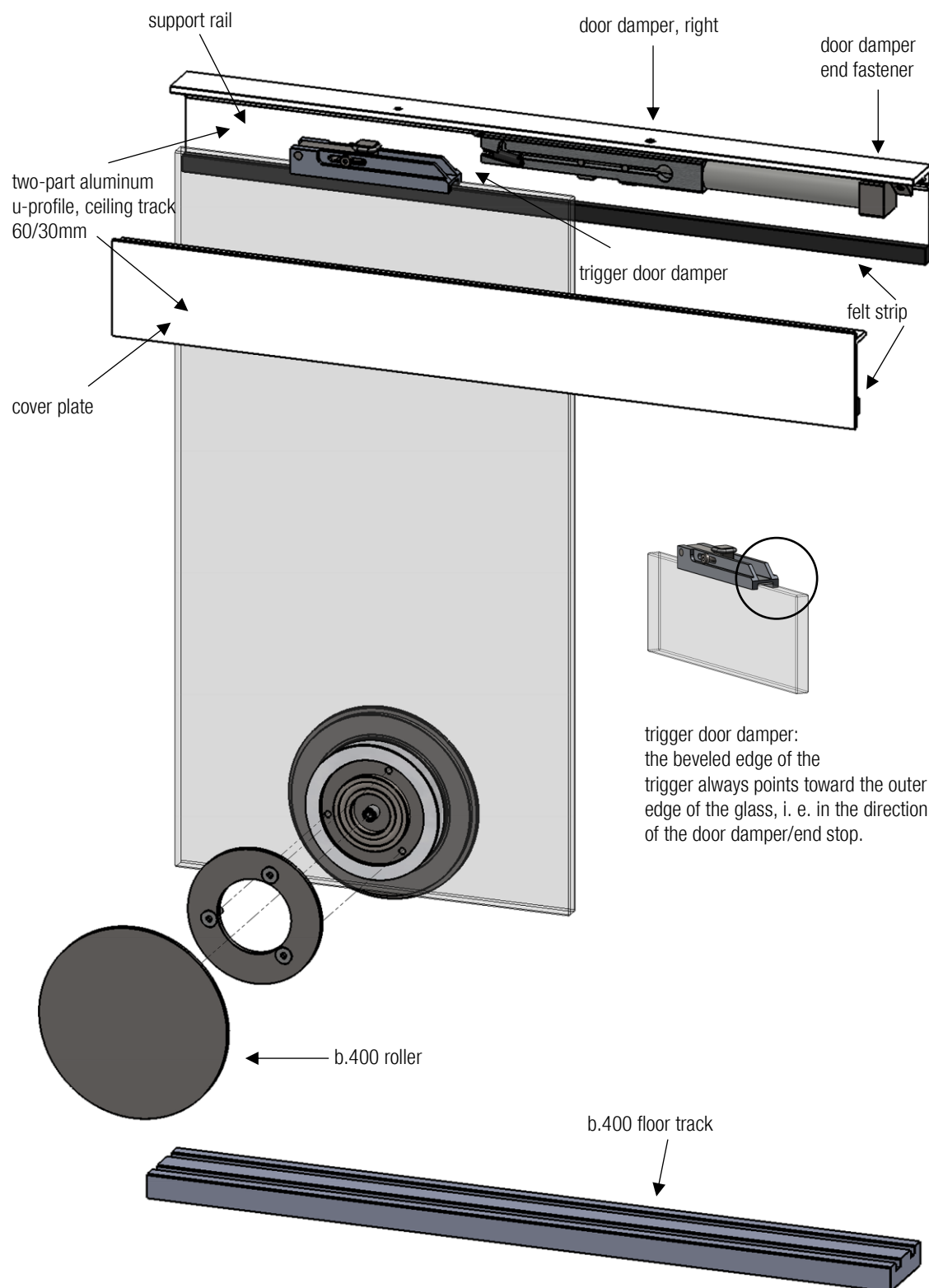
for **surface mount**, adjust the door leaf, set the final end stop or door damper positions according to the affixed trigger and fasten them using the set screws. test the damping and stop functions. attach the cover plate and fasten.

for **flush mount**, do not remove the cover plate before screwing down the ceiling track. please note: the height adjustment for the trigger cannot be reached without first unhinging the door leaf.

if applicable, mount the pull handle/flush pull and clean the fittings and handles/pulls with a soft cloth.

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example of assembly
astec b.400 with ceiling track 60/30mm and damping system



care and maintenance details

for stainless steel fittings

design fittings made of stainless steel are made of rustproof stainless steel. the solid stainless steel V2A rustproof (material no. 1.4301) is precisely manufactured and of first class quality. especially the decorative surfaces are manufactured very extensively by grinding them and then finely brush them.

although stainless steel doesn't corrode under usual conditions in the atmosphere it is however essential to constantly maintain and care for the stainless steel products in order to maintain a nice and decorative surface as well as to ensure its hygienic features.

for regular care please use a usual stainless steel preservative spray. these sprays can be obtained from different manufacturers or can be bought in hardware stores or in specialized trade shops.

apply this cleaning agent with a soft cloth on the stainless steel surfaces and wipe off stain like oil, dirt or sweat etc. finish and polish with a dry cloth, then you can be sure to have a nice and good like stainless steel fitting for many years. please absolutely avoid any scratching, rubbing cleansers or tools.

as a matter of principle ball bearings of the rollers are sealed and life-long lubricated. wipe the polyamide rollers with a damp cloth. dust and other dirt from the air can cause coating at the rolls which results in unease running resp. blocking of the rolls. with roll fittings, the floor guides are to be cleaned regularly with a vacuum cleaner in order to clean particularly from rough dirt. small stones or other firm dirt are crashed by the runners or are pressed into the smooth polyamide or wood of the floor guide, both result in unease running or disturbing noise.

as a matter of principle, whenever runners don't run easily or cause noise, please check whether screws are fixed tight enough. please always use new tools for it, so that interior forms of screws do not get damaged, as they too, are a decorative part of the fittings. from time to time please also check whether fasteners are still tight enough and also if they are still at the correct position. likewise also the floor guide has to be checked whether it is still tight as well as the anti-lift out security.

your stainless steel fitting are grateful for being taken care of, and show this by long durability, good operation and an always nice and precious look.