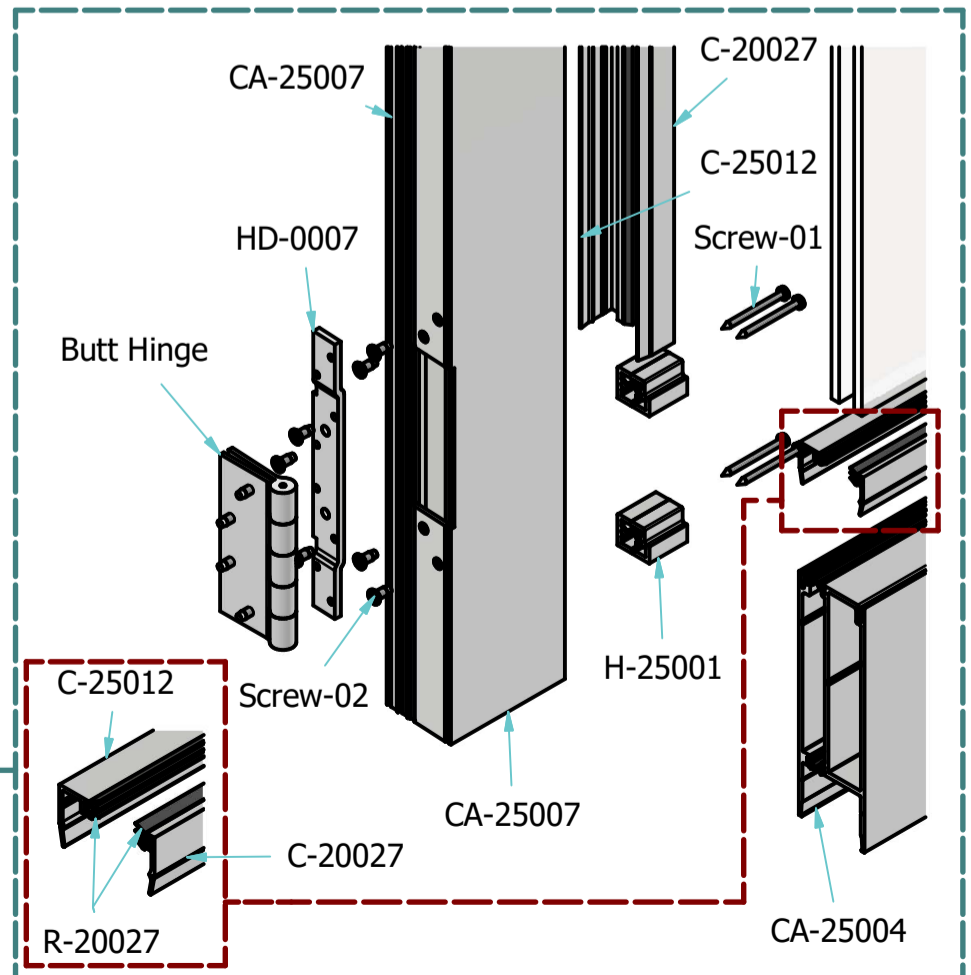
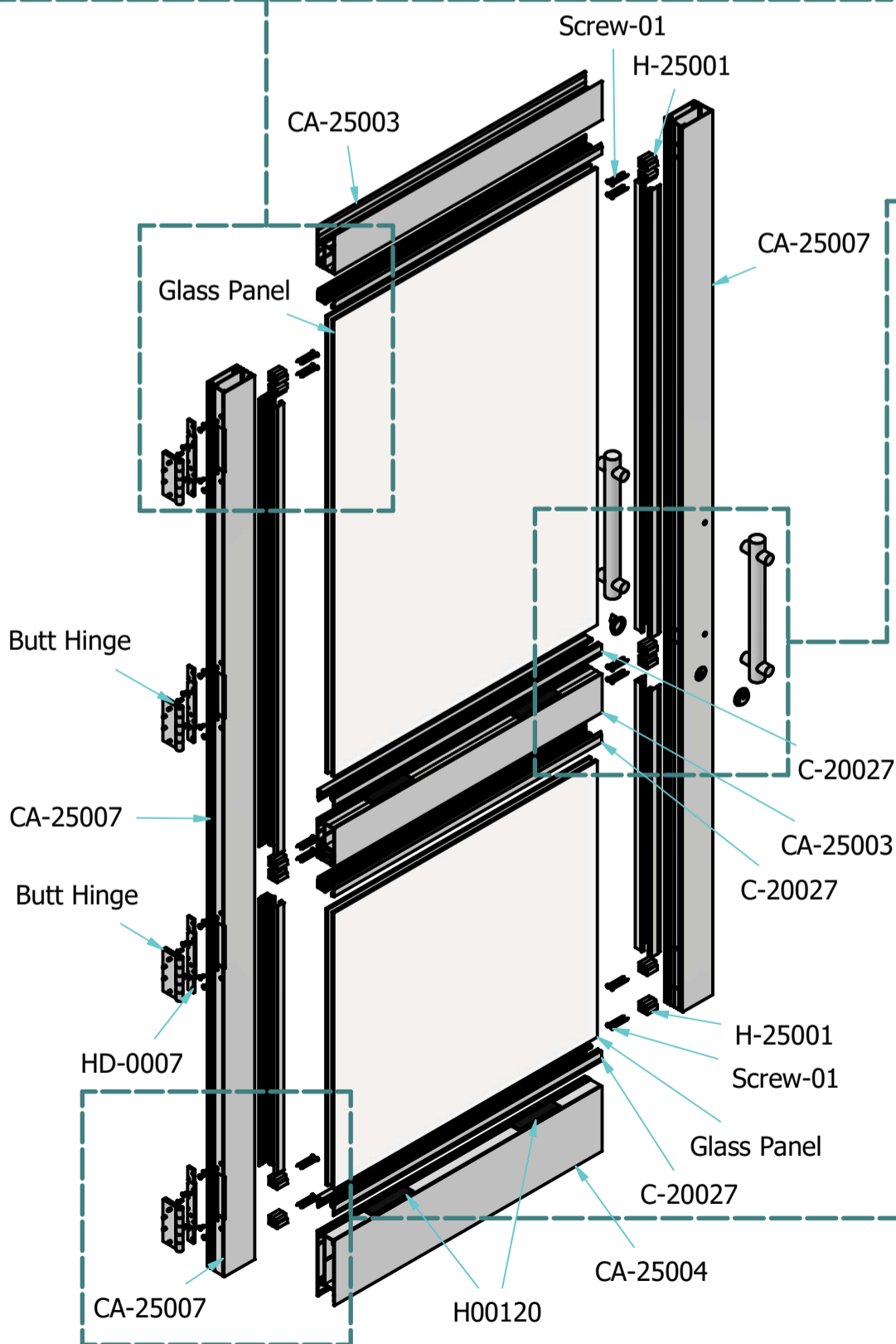
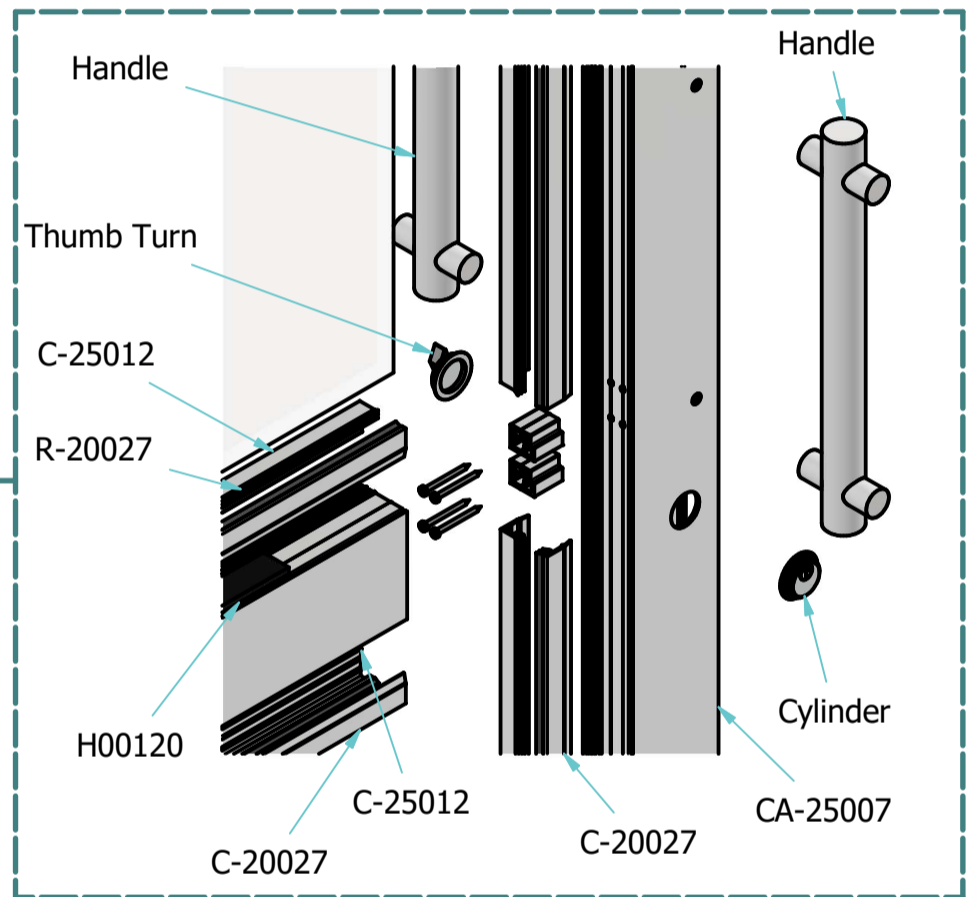
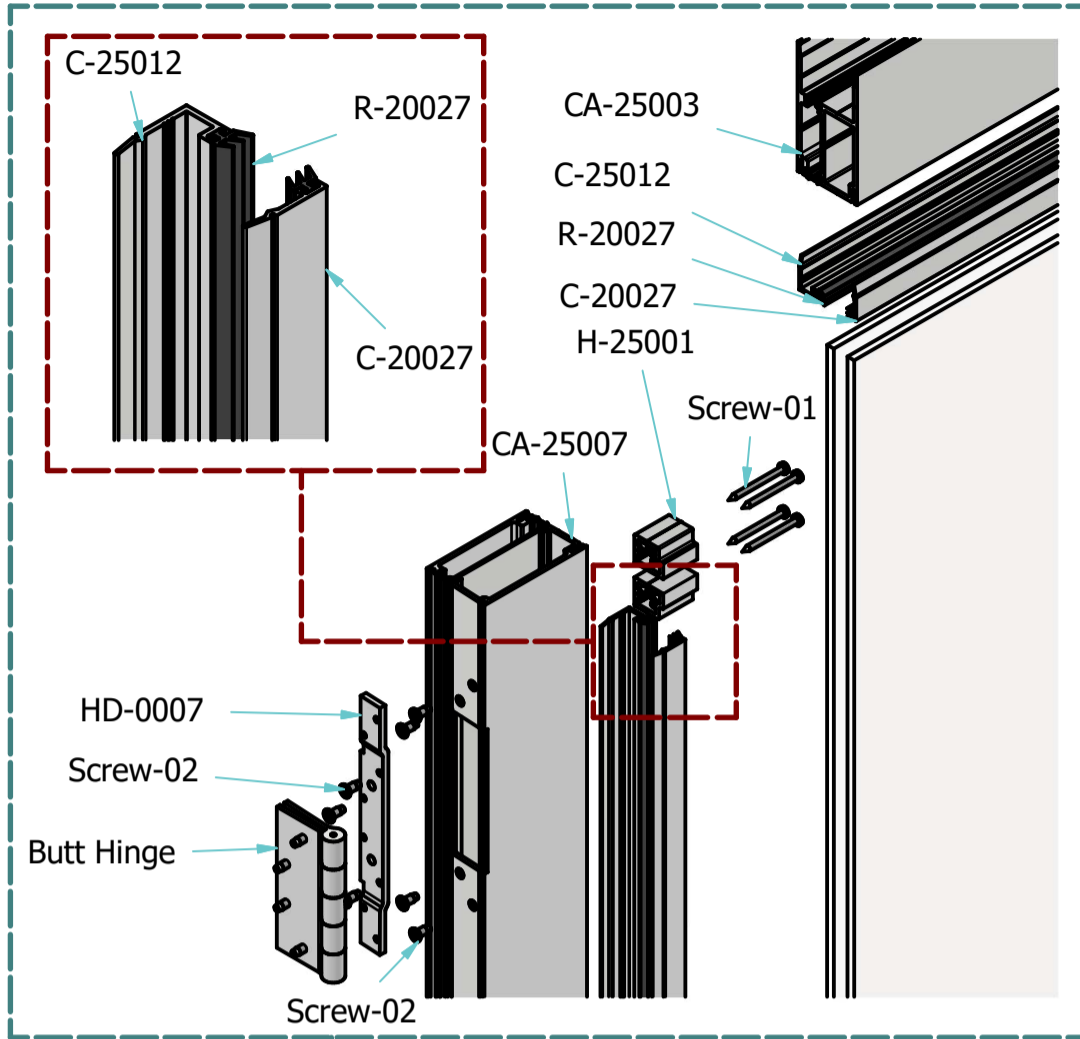


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### Assembly

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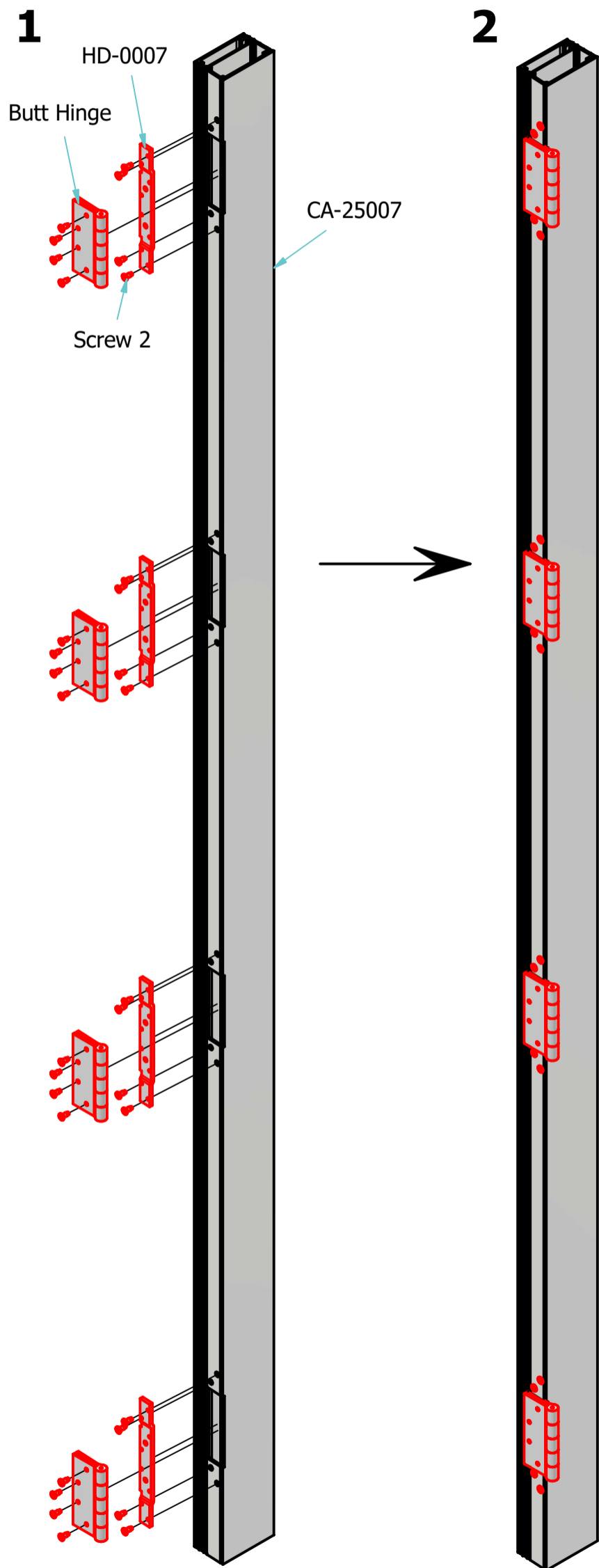
PARTS LIST	
PART NUMBER	DESCRIPTION
Butt Hinge	4 1/2" x 4" S.S Butt Hinge
C-20027	Interior Glazing Stop - (1" Dbl IGU, 1 1/2" Trpl IGU)
C-25012	1" Exterior Glazing Stop
CA-25003	4 1/8" HTP Horizontal Rail
CA-25004	7" HTP Horizontal Rail
CA-25007	HTP 375 Medium Stile ( 3 3/4" )
CA-25011	Mid Rail Adaptor
Cylinder	Door Hardware (Varies)
Glass Panel	Glass Panel
H00120	(1/4 x 1 1/8 x 5" ) E.P.D.M Setting block
H-25001	1.25" Shear Bracket for HTP door
Handle	Door Hardware (Varies)
HD-0007	Back up plate for butt hinges
R-20027	Glazing Gasket
Screw-01	#8 x 2" pan head screw- ZINC ( Shear brackets )
Screw-02	12-24 x 1/2" Undercut Flat head screw
Thumb Turn	Door Hardware (Varies)



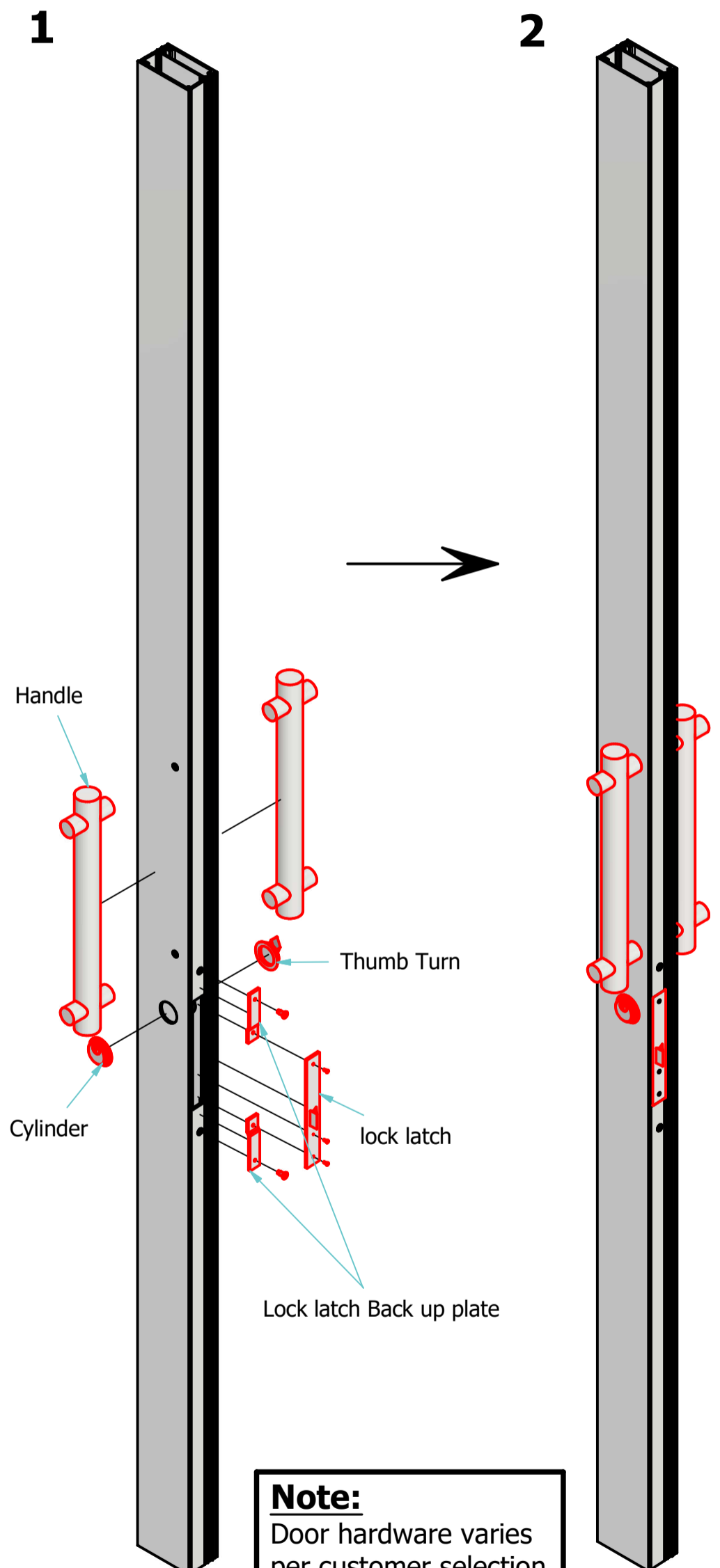
**A S S E M B L Y**

**STEP 1 (Hardware Installation):**

- Install all required hardware on the lock and flush bolt stiles (CA-25007) as specified.
- Install hinges on the hinge stile (CA-25007) using SCREW-02 (12-24 × 1/2" undercut flat head)



**Stile at Hinge side**

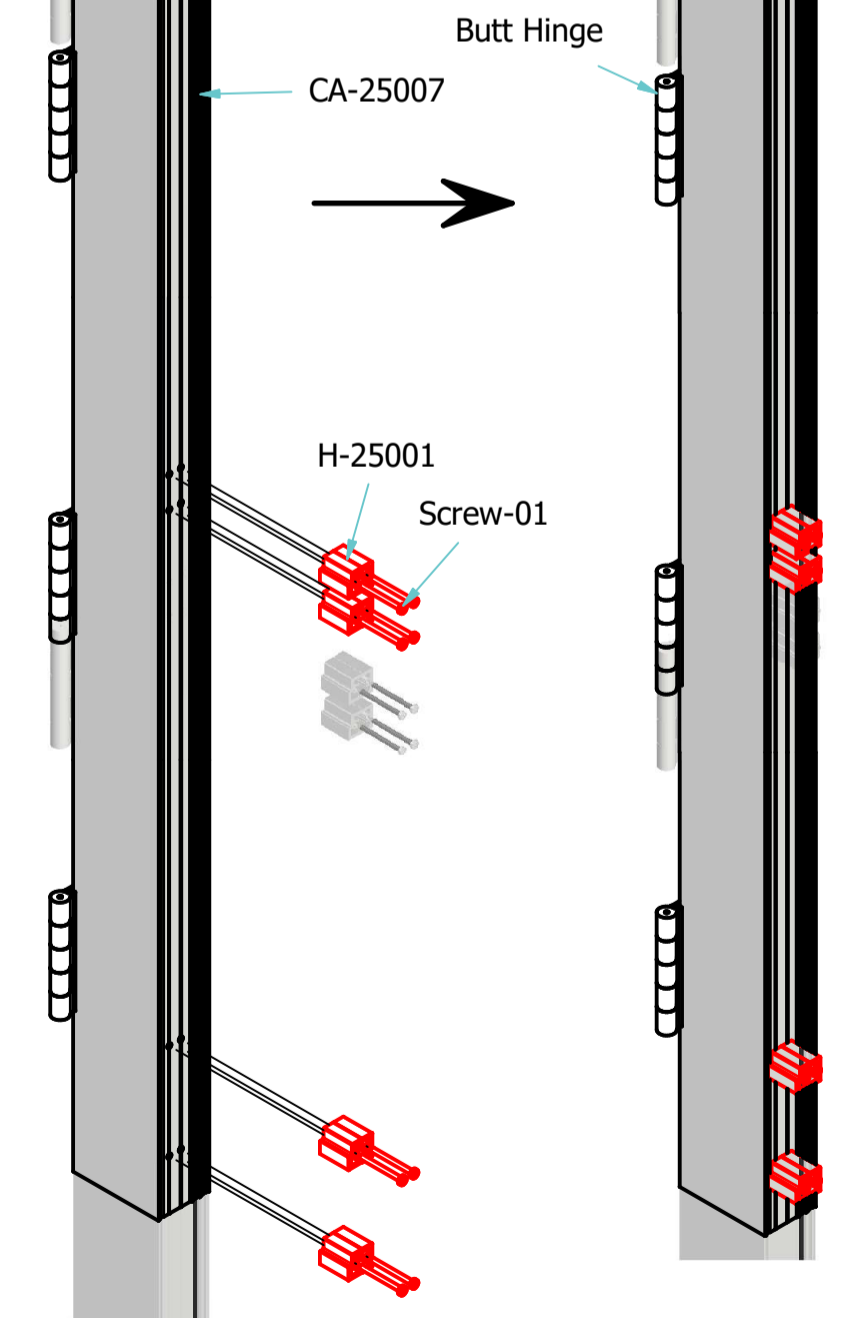
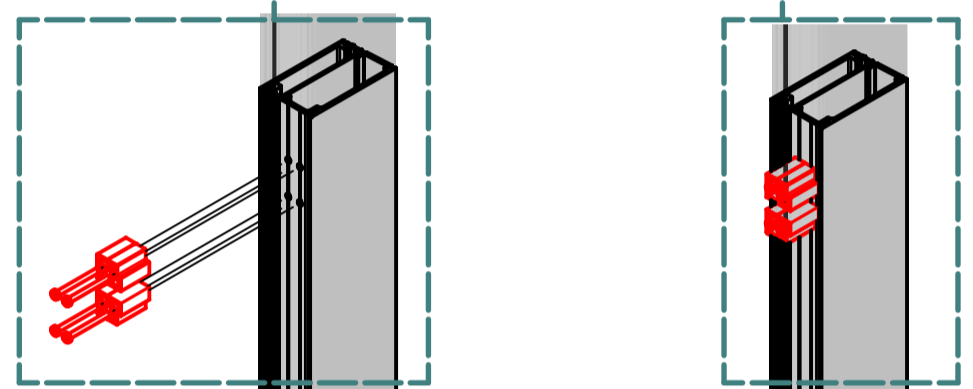
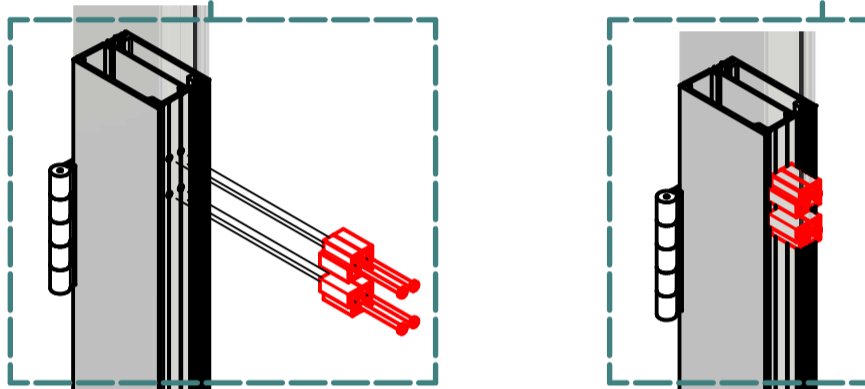
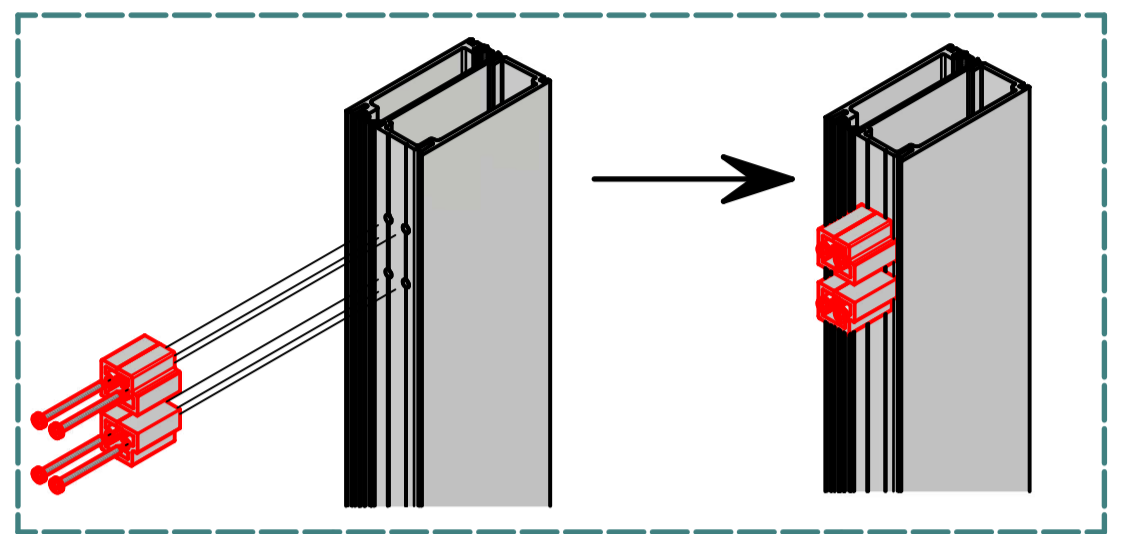
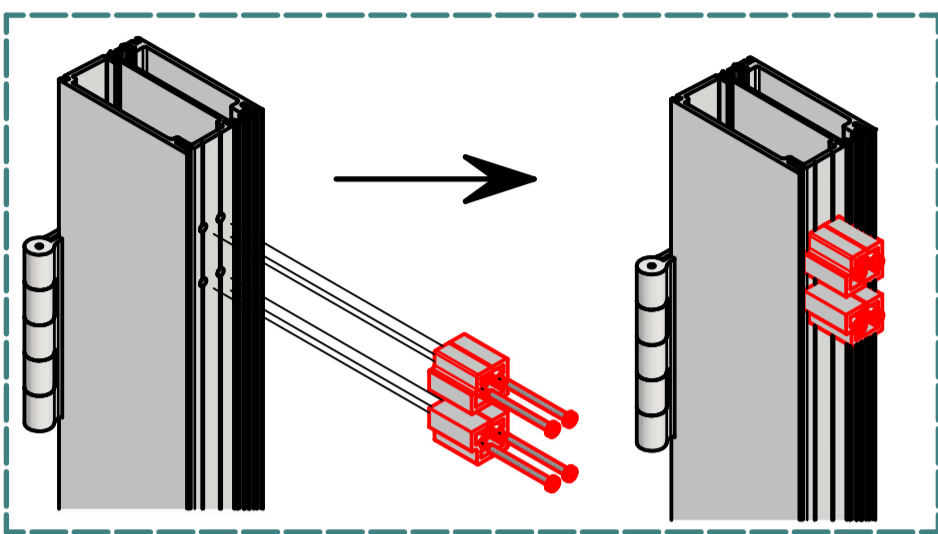


**Note:**  
Door hardware varies per customer selection.

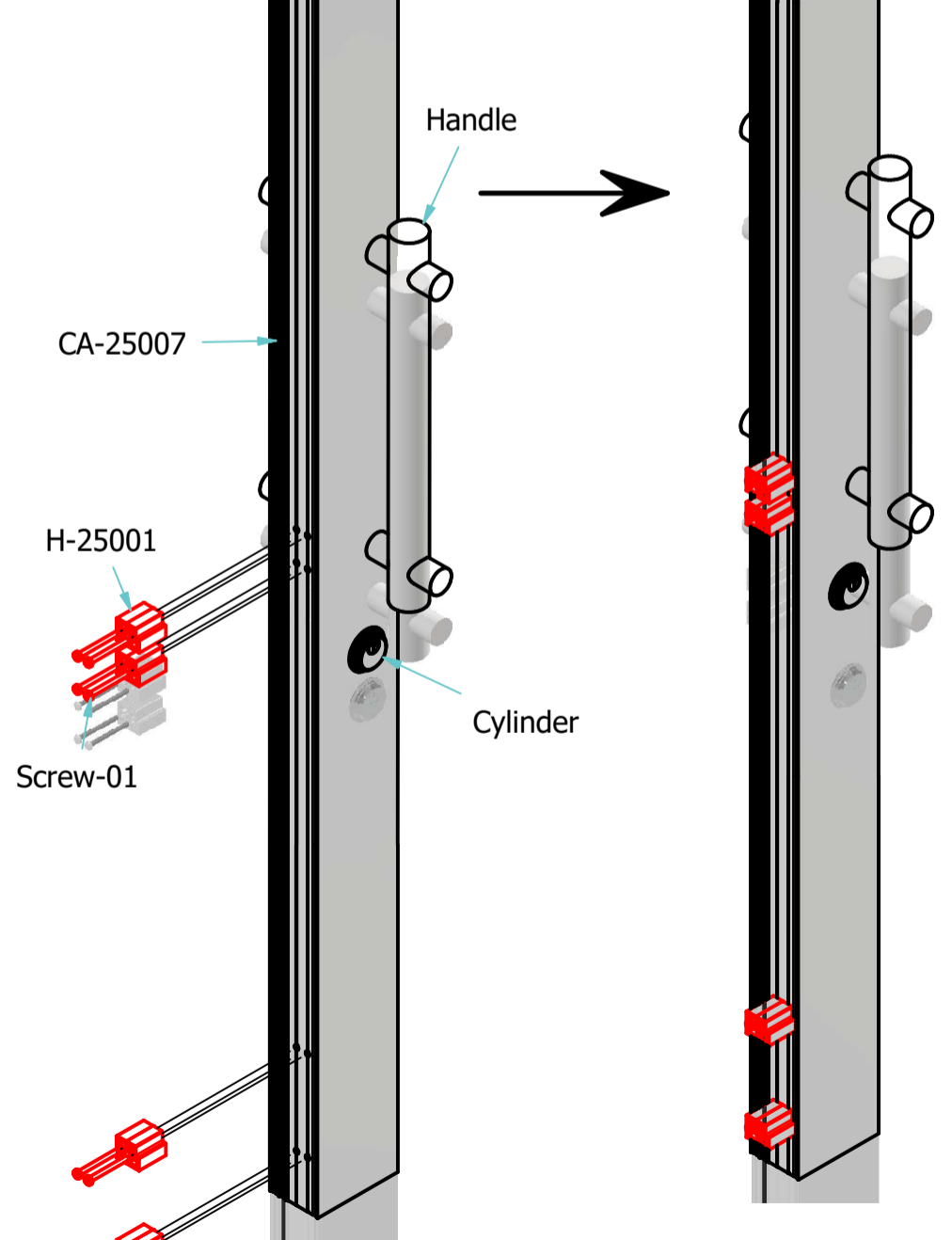
**Stile at Lock side**

**STEP 2 (Shear Bracket Installation):**

Install shear brackets H-25001 onto stiles CA-25007. Fasten with Screw-01 (#8 x 2" zinc pan head screw), as illustrated below.



**Stile at Hinge side**



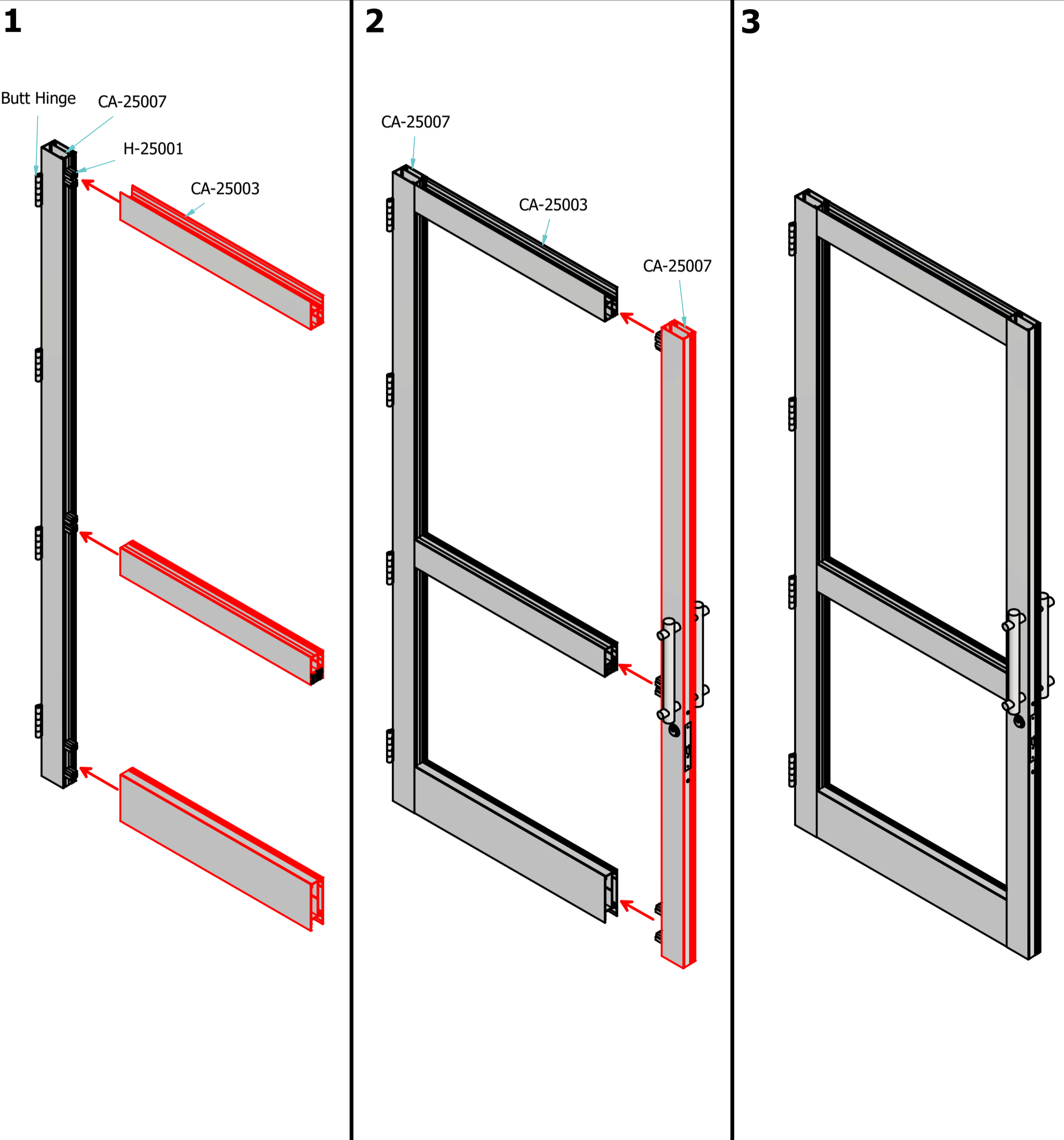
**Stile at Lock side**

**STEP 3 (Door Frame Assembly – Stiles and Horizontals):**

Attach the horizontal members to one stile using the pre-installed shear brackets (H-25001). Then secure the opposite stile to the same horizontal members using the corresponding shear brackets to complete the frame assembly.

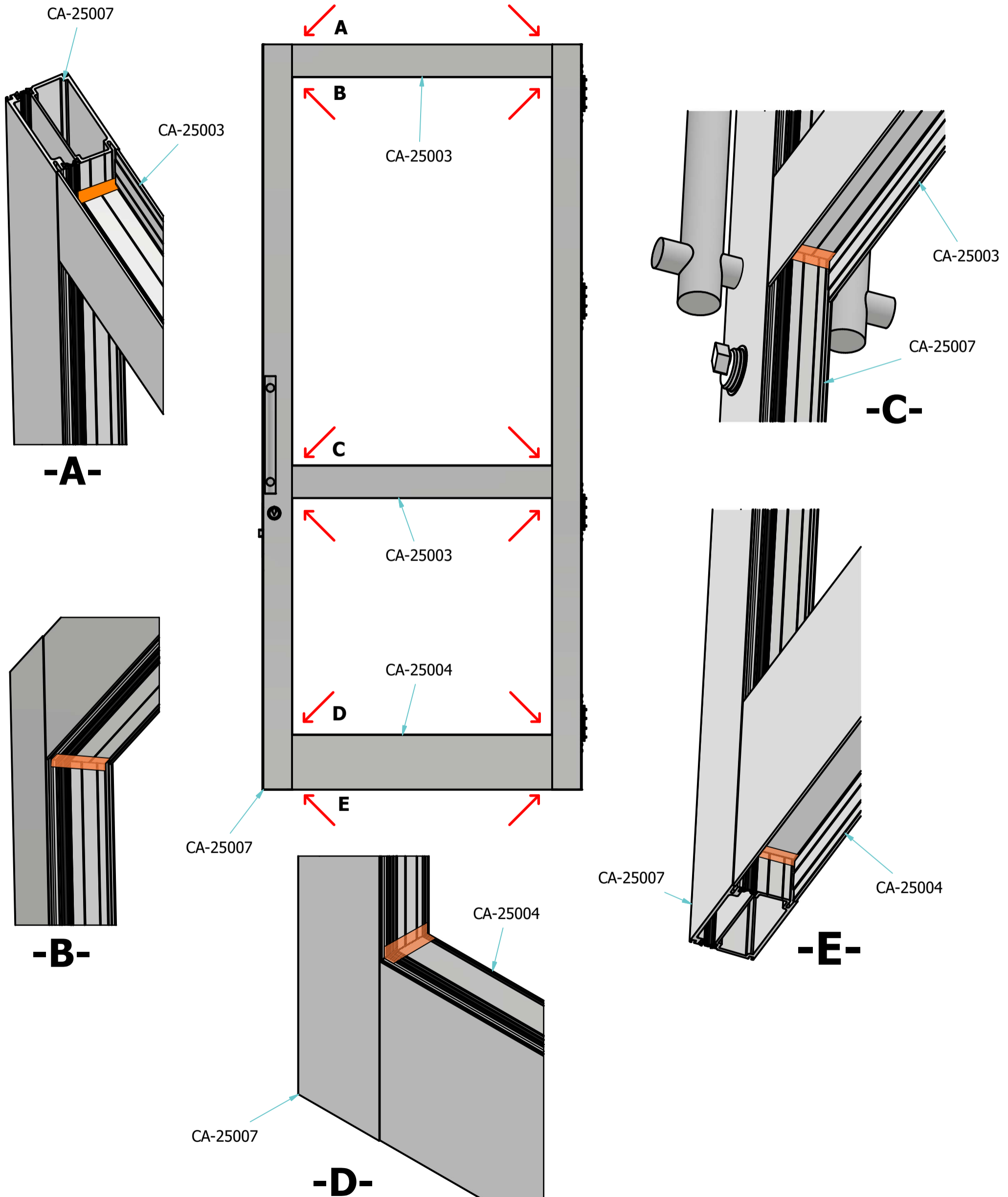
**Note:**

Horizontal members may vary based on customer specifications and project requirements. The configuration shown below represents a typical example.



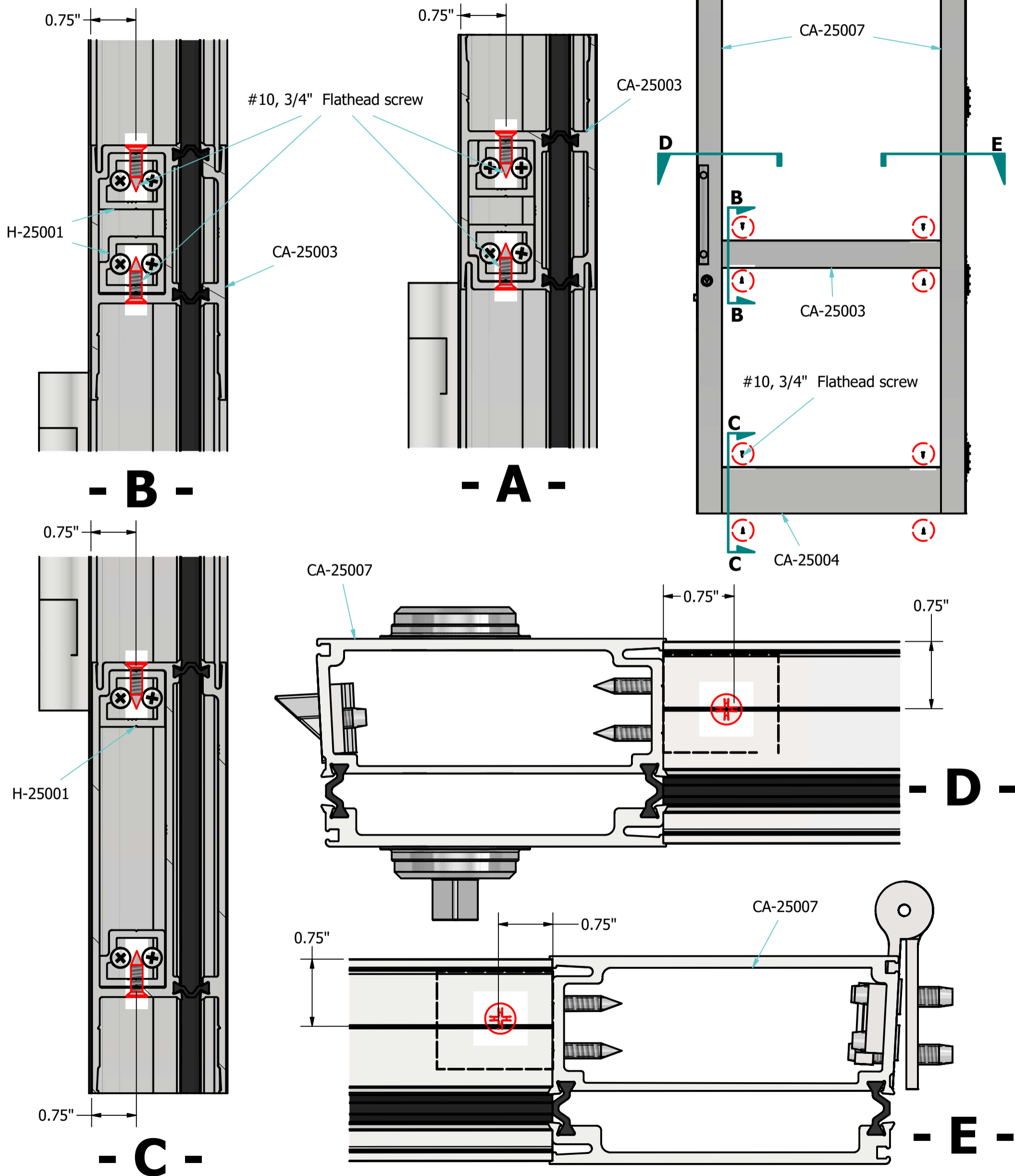
**STEP 4 (Welding Horizontal-to-Stile Joints)**

Provide welds at all horizontal-to-stile joints on both sides of the frame at the locations indicated by the red arrows, including internal DLO corners and perimeter frame corners, as detailed in Details A-E.



## STEP 5 (Horizontal-to-Shear Bracket Fastening):

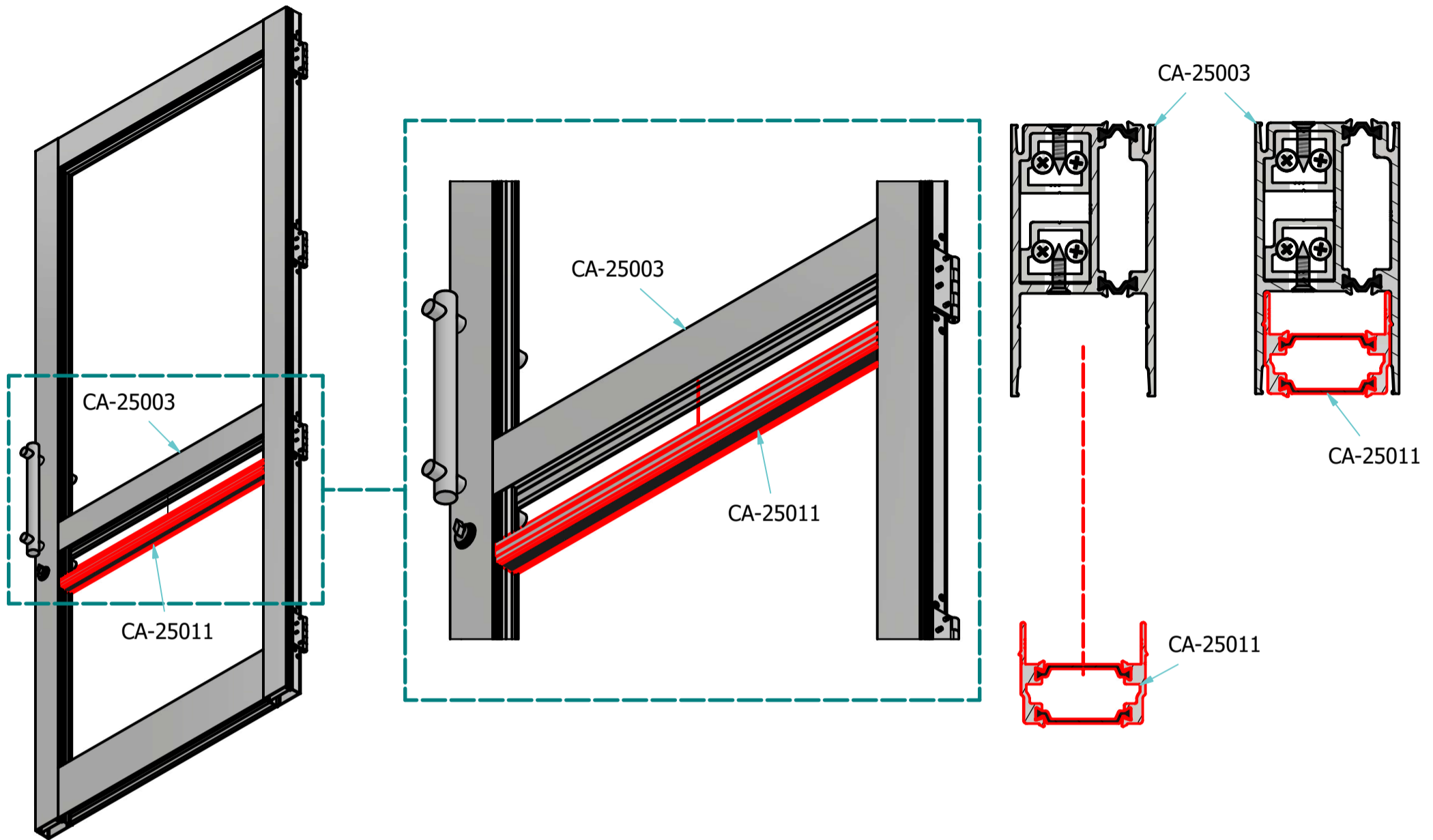
Fasten the horizontals to the pre-installed shear brackets (H-25001) using #10 × 3/4" flat head screws. Position screws 3/4" from the stile (CA-25007) and 3/4" from the exterior face of the horizontal, as shown below.



## STEP 6 (If Applicable)

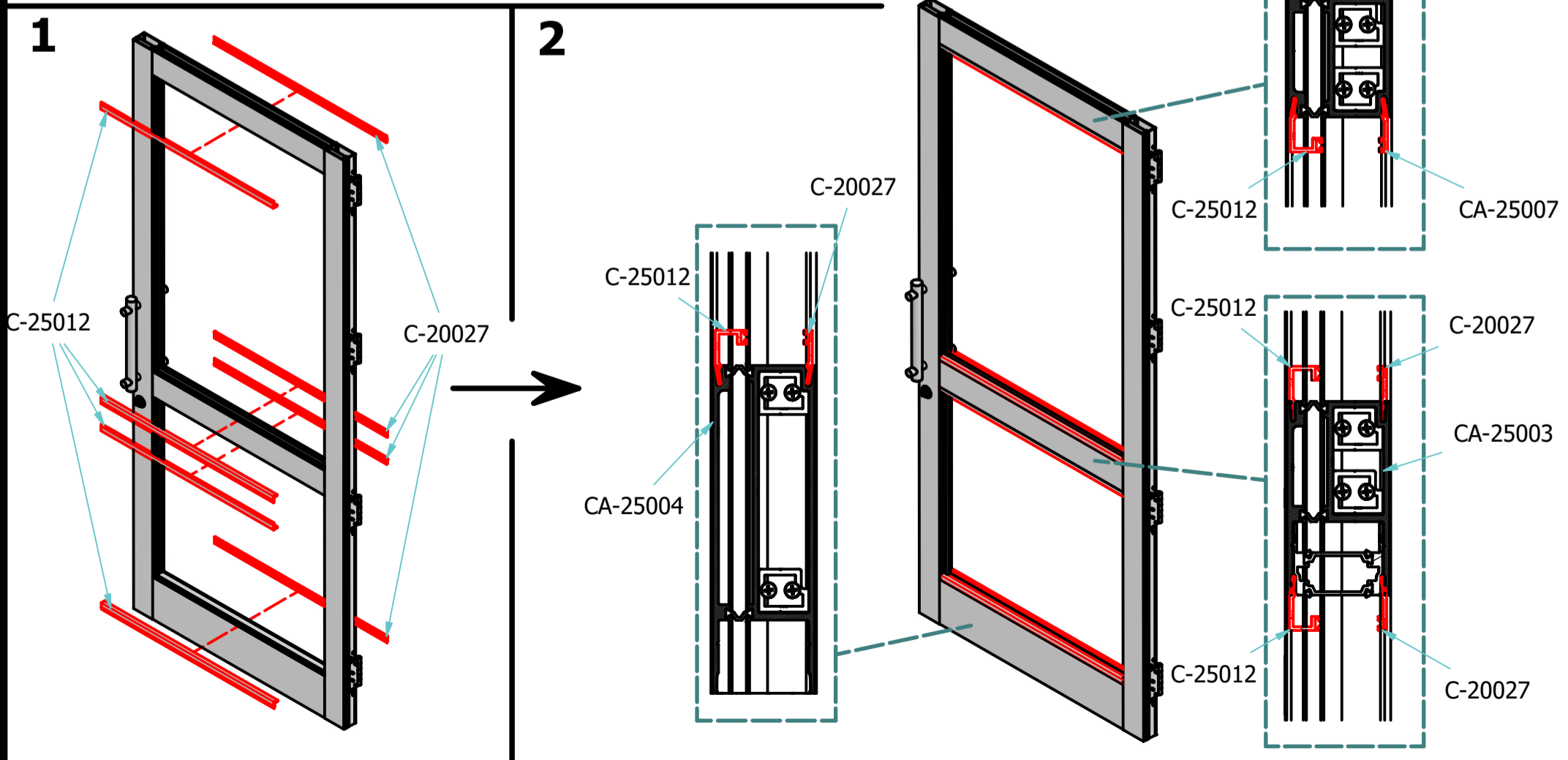
### (Midrail Adaptor Installation):

Snap the midrail adaptor (CA-25011) into the midrail (CA-25003) until fully engaged.

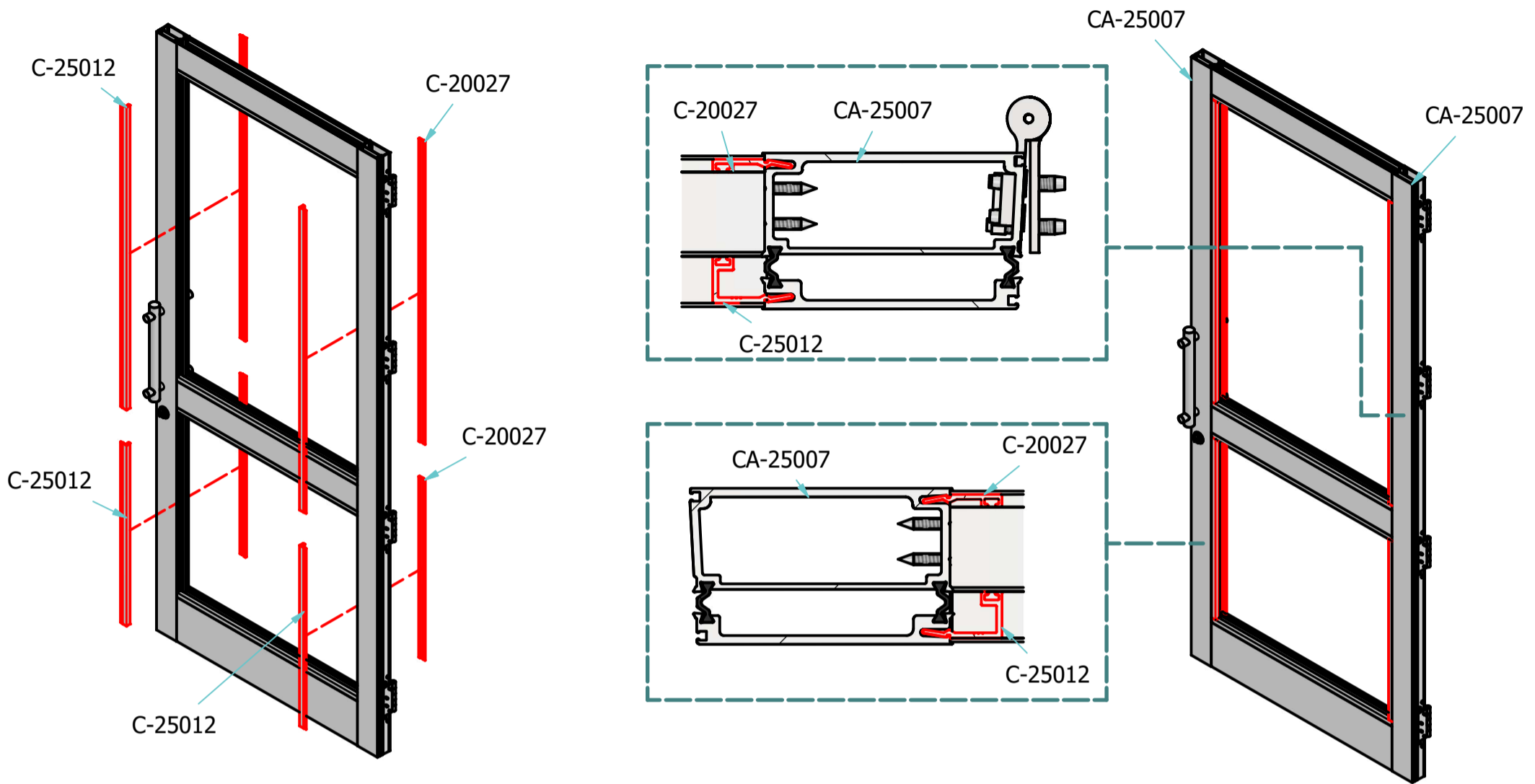


## STEP 7 (Glass Stop Installation):

1) - Snap all horizontal glass stops (C-25012) and (C-20027) into their designated grooves in the horizontals, as shown below.

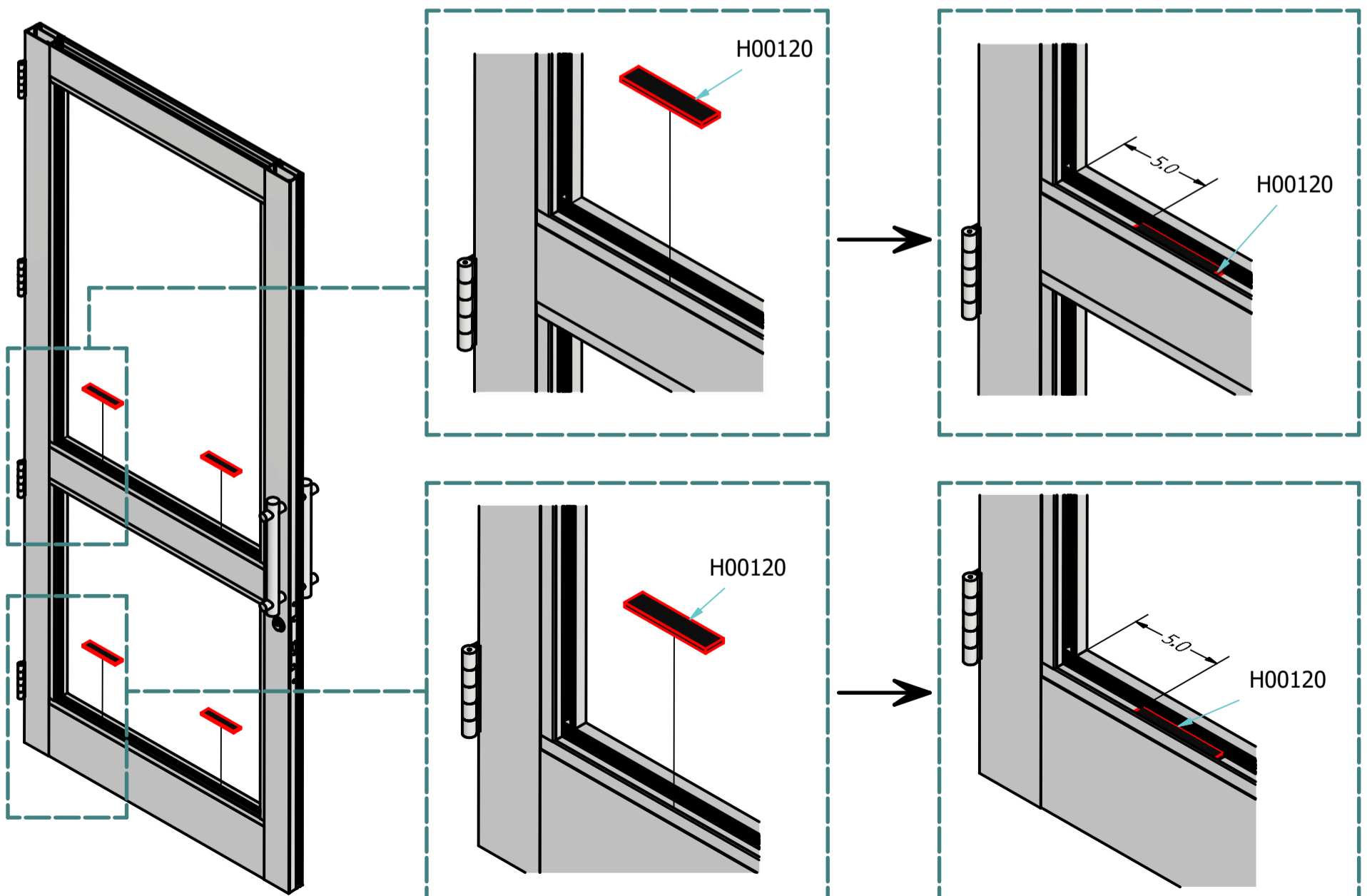


2) - Snap all vertical glass stops (C-25012) and (C-20027) into their designated grooves in the stiles (CA-25007), as shown below.



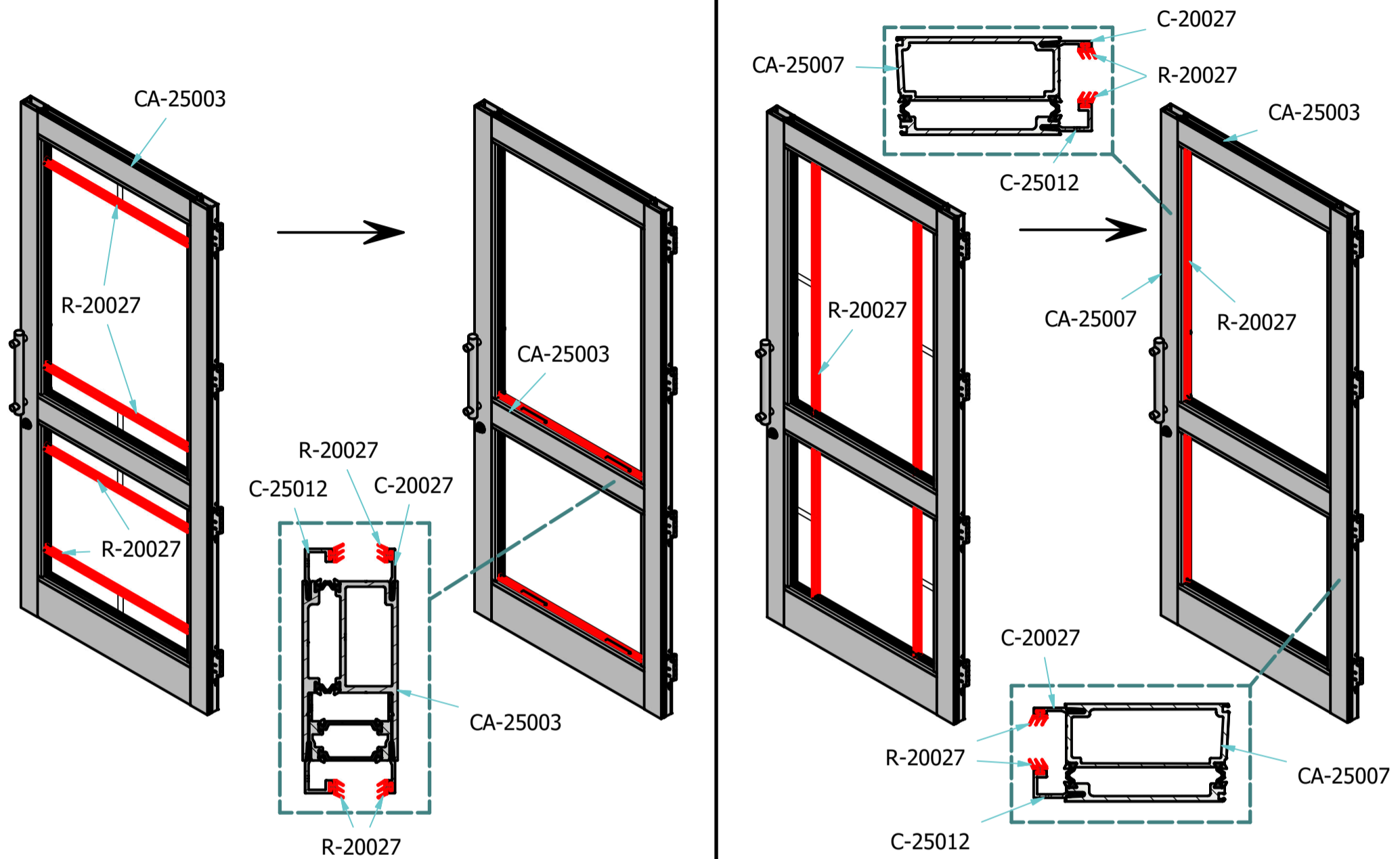
## STEP 8 (Setting blocks):

Position setting blocks on top of transoms and sills, placing them 5 inches from the edge on each side, as shown below.



**STEP 9 (Gasket Installation):**

Carefully insert the gaskets (**R-20027**) into the designated grooves of the glass stops (**C-20027**) and (**C-25012**), as shown below.



**End of Shop Assembly**

Shop assembly is complete at this stage.

Do not install glass panels in the plant.

Glass panel installation and all remaining steps shall be performed on site.

Refer to the **Glass Door Installation guide** for continuation.