



MASONITE.

How to - Glazing up a Solidor.

Technical Document:	Step by Step Guide to Re-Glaze a Solidor
Creation Date:	14/02/2018

Tasks Covered

1	Cassette Removal
2	Applying New Tape
3	Glazing Cassette and Glass to the door
4	Additional work on T&G panels

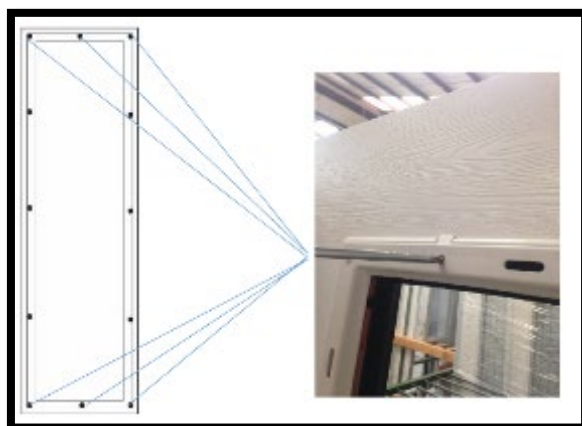
Cassette Removal

*****Prior to removing the existing cassette, clearly mark and make a note of the top and bottom of the cassette while the cassettes is in place.*****

1: Using a flat head screwdriver or similar object (**not a sharp object**), insert into the slot which can be found on the inner cassette at the top and bottom making sure you do not damage the door skin. Once inserted you will see the internal clip on section come away from the screw plate. Grip with your hands and pull away from the slab carefully.



2: Remove all the screws holding the cassette securely to the outer cassette.



3: To remove the external cassette, apply pressure from the inside of the door and push the glass from the inside out to release the glass and cassette from the external side of the door. Following the steps below.



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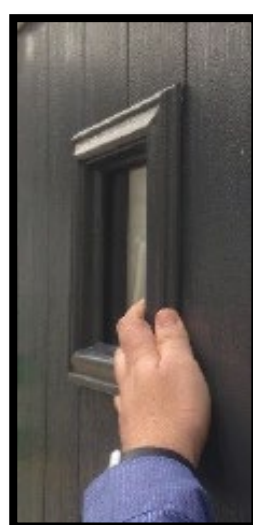
Step 1



Step 2



Step 3



Applying New Tape

External Cassette

- 1: Remove all the old tape from the existing cassette, making sure it is clear of any tape residue.
- 2: Once clean, apply x1 piece of acrylic tape **PC TB109251000RSOL** to the outer part of the cassette covering the full width of the cassette, making sure it has good connection and hasn't been creased. Following this, apply the acrylic tape to the sides overlapping it in the corners.
- 3: Apply to the inner lip x1 piece of black foam (**PC GPAL6813010420B**). How this is applied will depend on style of door. The corners at the bottom of the cassettes need to be cut halfway through the tape at approximately a 30 degree angle. The top of the cassette is butted up.

***** All tapes must be applied close to the edge of the cassette as per arrow shown below, any gaps could result in water leaking through the grooves.*****

Acrylic Tape Images

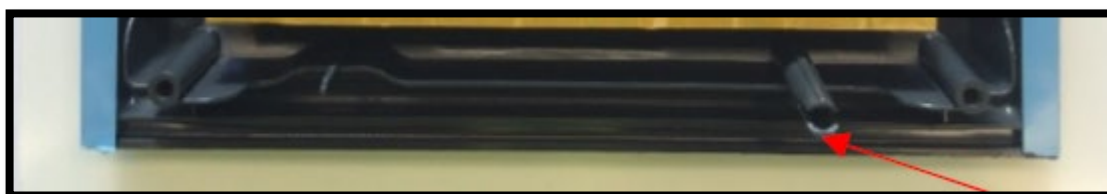
Acrylic tape to overlap at the top of the cassette





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Leave the acrylic tape off the bottom of the cassette as shown by the arrow below

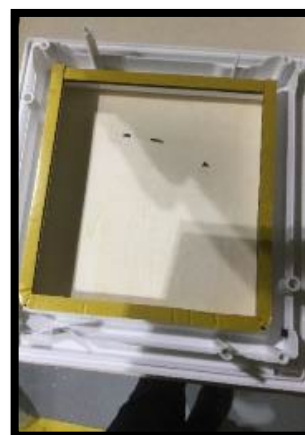
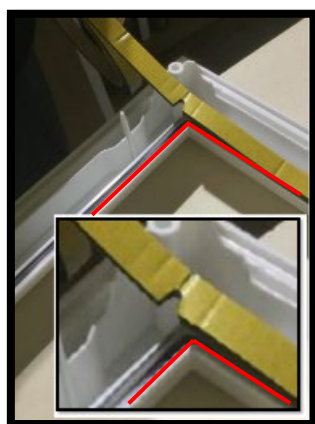


Black Foam Tape Images

The general rule for the foam tape is that any corners on the bottom of the cassette need to be cut half-way through the foam at a 30 degree angle and then folded round. The top sections of the cassette, the foam can be butted up.

Rectangle Cassettes

Starting at the top of the cassette, making sure that the black tape is touching the inner lip (where highlighted in red below) and no gaps are visible, stick the foam tape down to the corner. Cut the tape halfway through at the 30 degree angle around the bottom of the cassette. At the top of the cassette, the tape then butts up.



The butting up of the foam tape to be in the arched area at the top and the cut halfway through the tape at 30 degrees to be in the corner.





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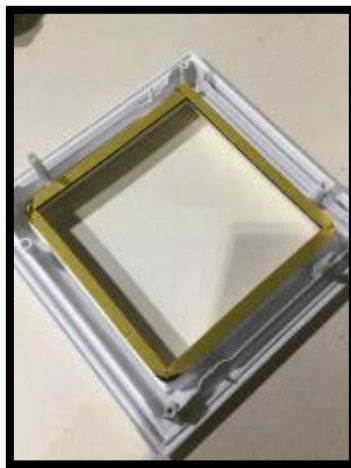
Sienna

The bottom of the cassette to be cut halfway through at 30 degree angle and the top to be butted up.



Diamond

Butt up the tape at the top point. The rest to be cut half-way through the foam at a 30 degree angle.



Internal cassette

Step 1) - Prior to removing the existing cassette clearly mark or make a note of the top and bottom of the cassette while in place.

Step 2) - Remove all old tape off existing cassette, making sure it is clear of any tape residue.

Step 3) - Apply to the inner lip x1 piece of black foam (**PC GPAL6813010420B**). Apply the second piece across the bottom mirroring the top piece. After the top and bottom have been fitted, next scribe the sides making sure that the tape is butted close to the top and bottom piece as per below image. (**See Fig 5**)

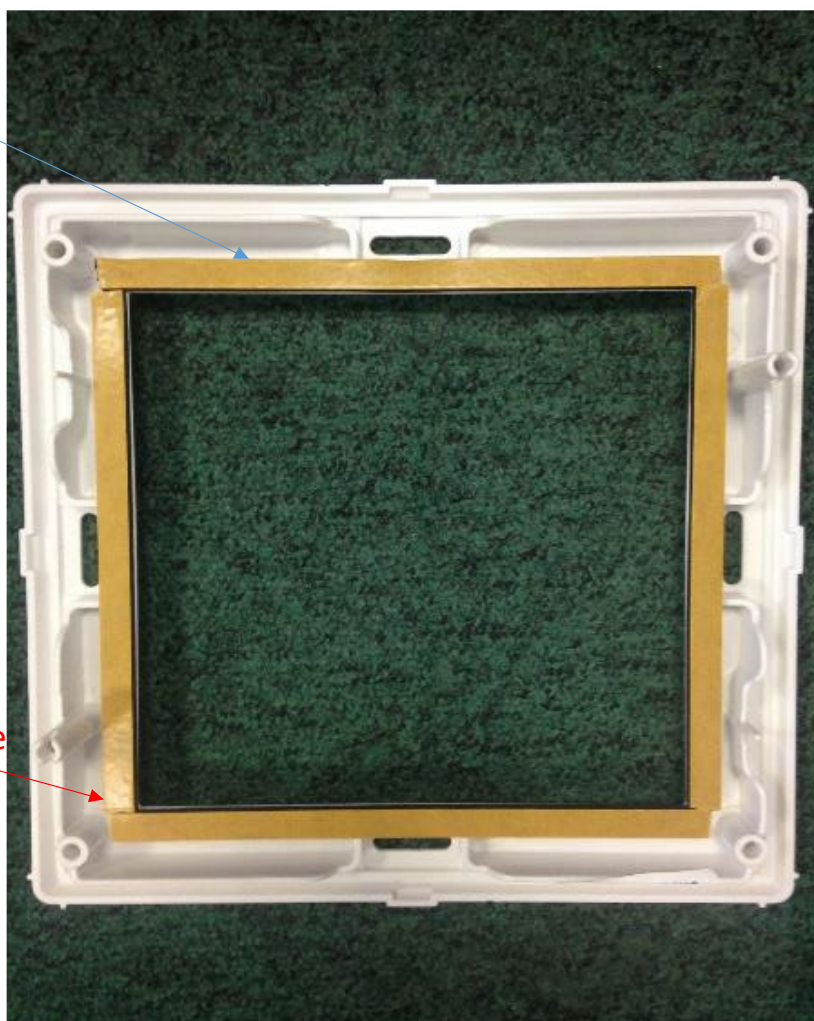


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Fig 5

Foam tape only required to the inner lip.

Do not overlap the tape but scribe as shown here

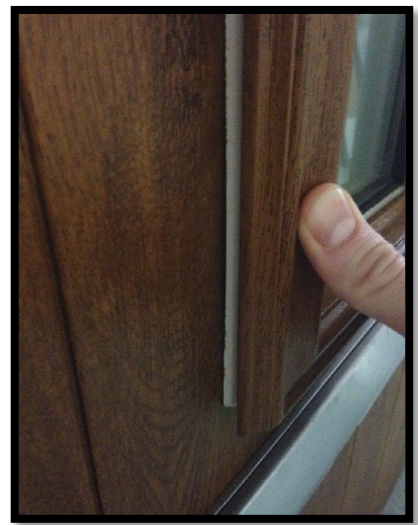
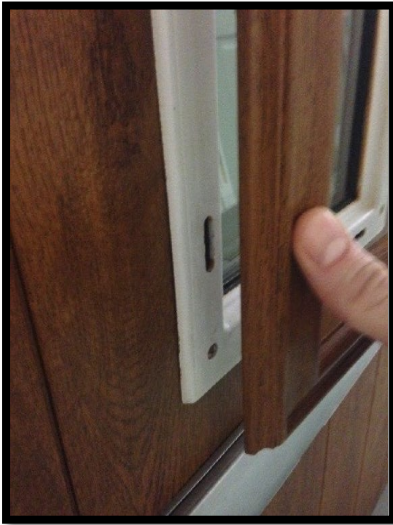


Glazing the Cassette and Glass unit to the door

- 1: Place the outer cassette onto a clean flat surface and peel the backing paper from both the double sided tape already fitted to the cassette.
- 2: Place the glass unit on a flat surface and gently lower the cassette on to the glass ensuring it is straight and that the seal is secure to the glass.
- 3: Fit the outer cassette to the door applying pressure all round to make sure tape is securely stuck to the door outer surface.
- 4: Split the inner cassette from its screw retaining part by pulling apart at the top and bottom.
- 5: Peel the backing paper from the double sided tape already fitted to the inner retaining part and fit to the door, ensuring the screw bosses are aligned to the outer cassette.
- 6: Assemble the cassettes using the screws provided, tighten the screws to ensure the cassettes are securely held to the glass. DO NOT EXCEED 12"/lbs of torque on your driver. Excessive force can cause the frames to crack.
- 7: Clip the inner cover cassette to the screw retaining plate using your hands.



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8: If the door is a flint style door (Tongue + Groove), a drop of silicone is required at the top of the outside cassette where the door meets the glazing cassette. Please see next section.

Tongue & Groove Panels

For all grooved style doors, silicone (Neutral cure – Clear) should be applied to the top of the door, where the cassette meets the door slab.

