

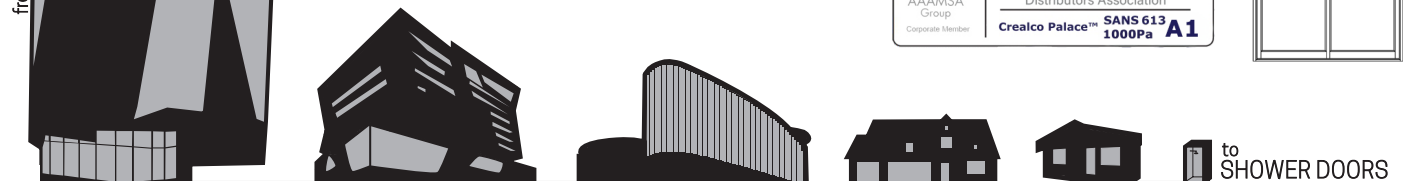
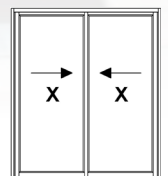
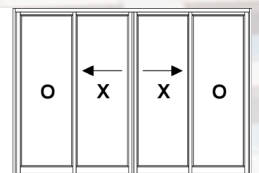
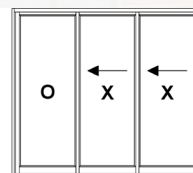
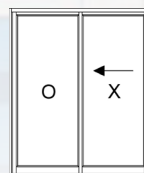
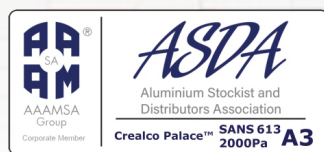
# Product Manual

PALACE™

High Performance Sliding Door



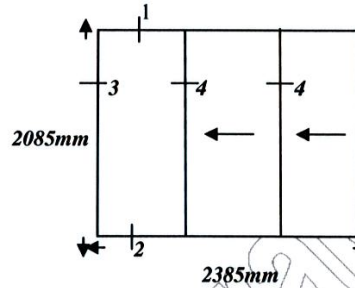
from SKYSCRAPERS



to SHOWER DOORS

**Performance Compliance Report***Non-Transferable***Aluminium System Distributor**

Wispeco (Pty) Ltd  
P O Box 124167  
ALRODE  
1451

**Method of Glazing****Butterfly (B010), Wedge (W01G))****Elevation & Dimensions of Test Unit****Glass Types**

6.38mm PVB clear laminated Safety Glass

**Extrusions used in manufacture**

Detail #	Reference #	Description
1	W31537 & W44087	Head
2	W31535 & W44088	Cill
3	W55434 & W53099	Jamb
4	W55370 & W55371	Interlock
Throughout	W31142	Glazing bead
Throughout	B010 & W01G	Butterfly & Wedge
Throughout	FG69500FG	Fin seal

**Test Results**

Negative Pressure 2000Pa  
Positive Pressure 2000Pa  
Water Penetration No leakage at 400Pa  
Structural Pressure 3000Pa  
Air infiltration 1.34 l/s/m<sup>2</sup>

**AAAMSA Standard Achieved****A3****Comment**

When manufactured to recommendations stipulated by the system provider, the **Palace Multi Sliding Door** is able to pass performance criteria **A3** as laid down in AAAMSA's General Specification for aluminium and glass products.

*Each individual manufacturer must obtain appropriate AAAMSA Performance Test Certificate to confirm his ability to conform to this Performance Compliance Report. APT 11/006.*

**This document is to be read in conjunction with the appropriate technical and assembly documentation supplied by Messrs. Wispeco (Pty) Ltd**

**Issued: 25 October 2011****EXECUTIVE DIRECTOR**

AAAMSA  
Group

Reg. No. 1974/000006/08  
Association Incorporated  
under Section 21  
VAT No. 4900141153

**Tel****(011) 805-5002****Fax****(011) 805-5033**

Incorporating:



AAAMSA Fenestration



South African Fenestration  
& Insulation Energy Rating  
Association



Aluminium Stockists and  
Distributors Association



Expanded Polystyrene  
Association of Southern Africa



South African Building  
Interior Systems Association



South African Glass and  
Glazing Association



SA Shower Enclosure  
Manufacturers Association



South African Glass Institute



Skylight Association of  
Southern Africa



Thermal Insulation  
Association of Southern Africa



Thermal Panel  
Manufacturers Association

Country Representative



# Performance Compliance Report



Postal Address:  
PO Box 7861  
Halfway House, 1685

**Aluminium System Distributors SANS 613 Test Report**  
(for inclusion with Forms 1 of SANS 10400-A)

**NOT TRANSFERABLE**

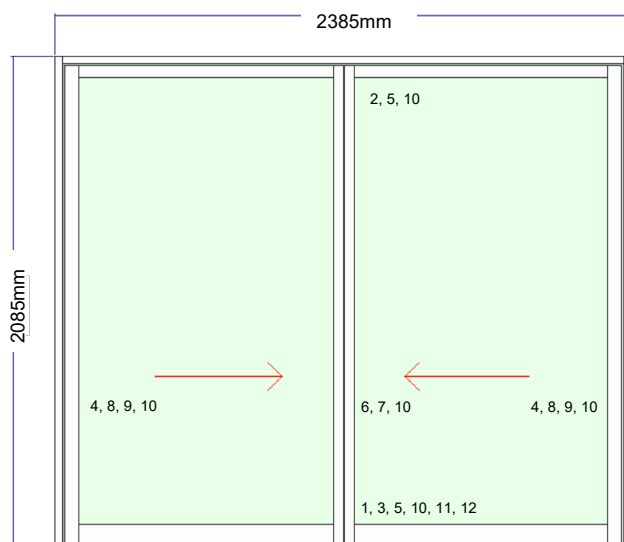
## Aluminium System Distributor

Wispeco (Pty)Ltd  
678 Potgieter Street  
Alrode, Alberton  
1451

Membership No.: D4207  
Vat. No.: 4450101102  
CK No.: 1947/27773/07  
Project Number: GT-1531

**PCR238**

## Elevation & Dimensions of Test Unit



## Test Results

**Positive Pressure** 1 000 Pa - 9.29mm Deflection  
**Negative Pressure** 1 000 Pa - 9.59mm Deflection  
**Water Penetration** No Leakage at 200Pa  
**Structural Pressure** 1 500Pa  
**Air Infiltration** 1.74 l/sec/m<sup>2</sup>  
**Measured Starting Force** - 73 N  
**Measured Operating Force** - 38 N

## AAAMSA Standard Achieved - A1

### Method of Glazing

- VC3 Butterfly (GBF-VC3)
- Finseal (GFP-6750)
- Woolpile (GWP-6790)
- Wedge Gasket VW3 (GWG-VW3)

### Glass Type

- 6.38mm Laminated Glass

## Extrusions used in Manufacture

Detail #	Reference #	Description
1, 2	W37992, W31553	Palace Multi Frame Sill Rail Double HP, Palace Multi Frame Double Head Rail
3, 4	W58916, W55433	Palace Multi Sill Extension, Palace Multi Frame Jamb Double
5, 6	W44088, W57971	Clip 44 Head/Sill Rail, Fixed Interlocker 60mm
7, 8	W57972, W31590	Sliding Interlocker 60mm, Palace multi Frame Jamb Adaptor
9, 10	W53099, W14108	Clip44 Stile 60mm, Clip44 Bead Bevel
11, 12	W31534, W31594	Palace M Frame, Head Cover, Extended Track
Hardware	Crealco Tandum Roller, Patio Stopper, Palace m Sash Block, Crealco Hocklock, Palace M Draught Excluder, Flush Pull Handle	

## Comment

When manufactured to recommendations stipulated by the system provider, the **Palace Multi XX Sliding Door** is able to pass performance criteria **A1** as laid down in AAAMSA's General Specification for aluminium and glass products.

Each individual manufacturer must obtain appropriate AAAMSA Performance Test Certification to confirm his ability to conform to this Performance Compliance Report - **OTH-T-2412-03**

This document is to be read in conjunction with the appropriate technical and assembly documentation supplied by **Messrs. Wispeco (Pty) Ltd**

**Additional testing is required for Fire Safety aspects as it does not form part of this Certification.**  
**Testing is strictly in accordance with SANS 613**

**Executive Director**

**Date of issue: 21 January 2025**



### *General Documentation Disclaimer*

This manual is intended as a manufacturing and installation advisory document. For correct specifications, sizing of profiles and structural information please consult the StarFront Application. If the information you require is not available through the StarFront Application, please contact your stockist before proceeding. It is advisable to have all sizing and performance criteria checked by a qualified structural engineer to ensure that the required criteria will be met.

All information, recommendations or advice contained in this documentation is given in good faith to the best of Wispeco's knowledge and is based on current procedures in effect.

Since the actual use of this documentation by the user is beyond the control of Wispeco, such use is within the exclusive responsibility of the user. Wispeco cannot be held responsible for any loss incurred through incorrect or faulty use of this documentation. Training of Wispeco systems is important for ensuring correct procedures in the manufacturing of products.

Great care has been taken to ensure that the information provided is correct.

Ensure that you have the latest available manual. The revision number and date can be checked on the latest StarFront version.

Wispeco will accept no responsibility for any errors and/or omissions, which may have inadvertently occurred.

### *Specifications concerning products and applications*

This manual is based on standard configurations only. As there are many configurations not covered in this manual, contact your stockist with regards to a configuration not represented herein if required.

AutoDesk drawings (CAD Symbol Library) are available on request and can be issued with the consent of the Wispeco Technical Department.

All mechanical joints must be sealed with a **Crealco approved joint sealer**. Failure to correctly seal the joints can affect the performance of the system. Information on joint sealing can be found in the Cleaning & Maintenance Manual\*\* available for download from [www.crealco.co.za](http://www.crealco.co.za) or from StarFront.

All drawings in the Wispeco Documentation are NOT to scale and are used for illustrative purposes only.

Wispeco will not accept responsibility for the use of standard products since Wispeco does not know where these products are being installed.

The hardware recommended in this documentation is suitable for use in most atmospheric environments. When hardware is used in severe coastal environments the manufacturer of the hardware must be consulted.

For the coastal regions and any other high corrosion areas, the following is advised: to minimize phylliform corrosion use SurTec650 RTU spray during the manufacturing of aluminium profile systems. This should be applied, before assembly, on all pre-work aluminium where the powder coating covering has been removed thereby exposing the raw aluminium base.

The use of non-specified hardware or incorrect mechanical fasteners can adversely affect the mechanical and weathering performance of the system and we strongly advise against deviations. A Wispeco Consultant can advise you of any hardware issues and limitations with regard to this system.

The use of anti-magnetic stainless steel screws and aluminium pop rivets is recommended to reduce galvanic corrosion in harsh environments.

Fixing lugs on frames must be positioned as per the user manual and used in accordance to the AAMSA specifications. When profiles are screwed together the screw centres must also be according to the user manual or as specified by an engineer.

All glass used within Wispeco products must comply with SAGGA regulations. Laminated glass must not stand in water.

*\*\*For Cleaning and Maintenance of this system please download the Wispeco Installation, Cleaning and Maintenance Procedures from the Crealco website ([www.crealco.co.za](http://www.crealco.co.za)).*

**By continuing to use this documentation you acknowledge that you understand and accept the legal disclaimer.**

This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

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### General System

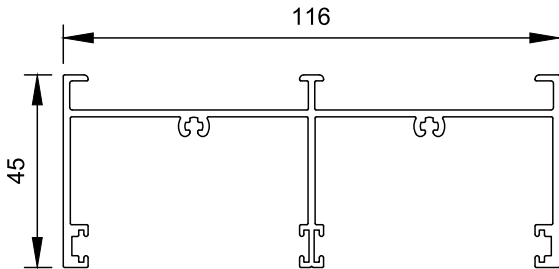
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This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

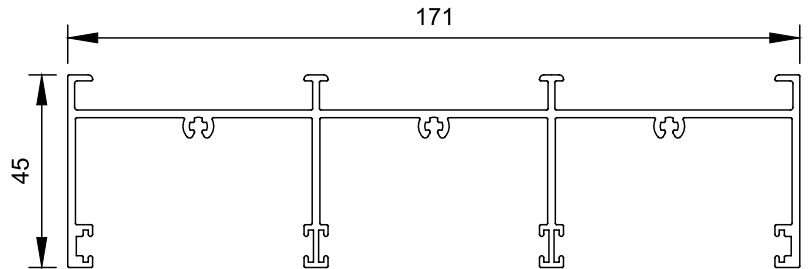
# PALACE™

## High Performance Sliding Door

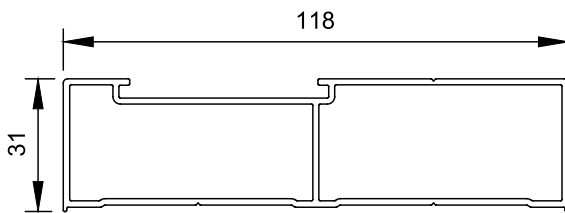
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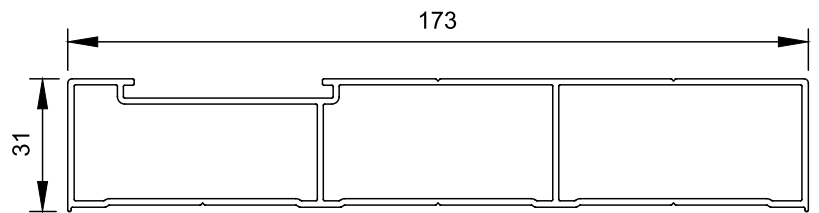
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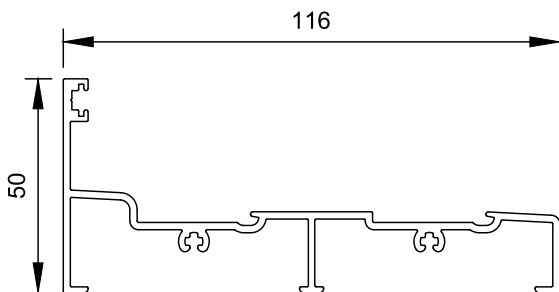
DIE No. <W31537> Palace M Frame Head Rail Triple



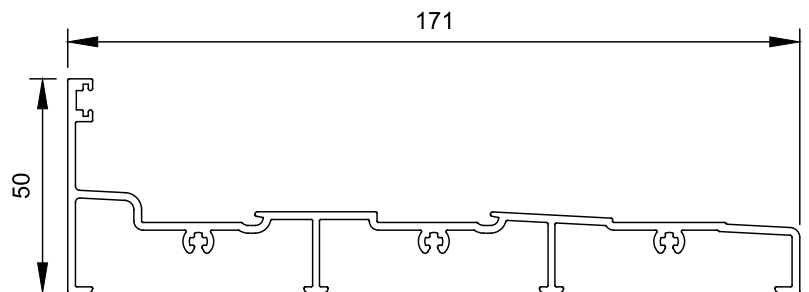
DIE No. <W55433> Palace M Frame Jamb Double



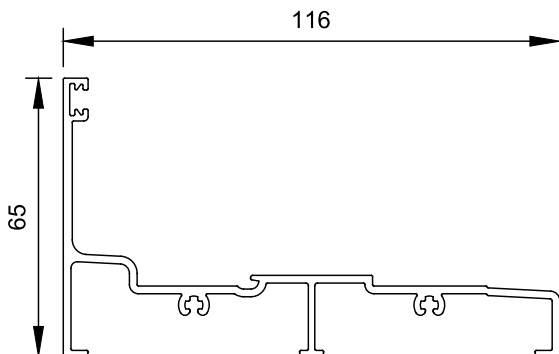
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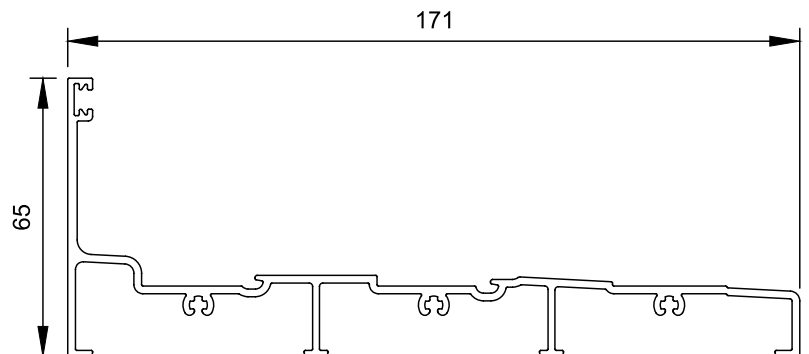
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DIE No. <W31535> Palace M Frame Sill Rail Triple 50mm



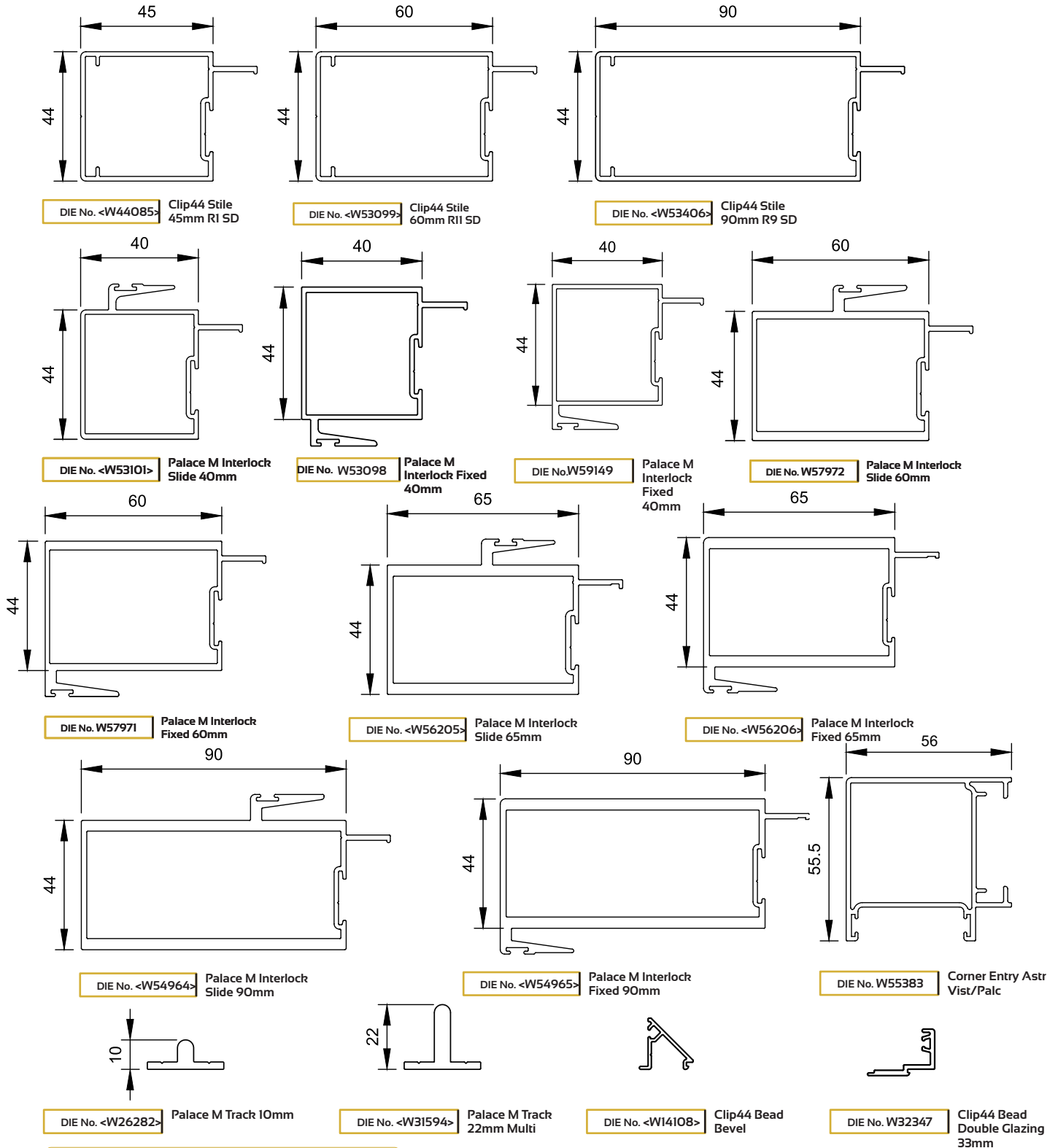
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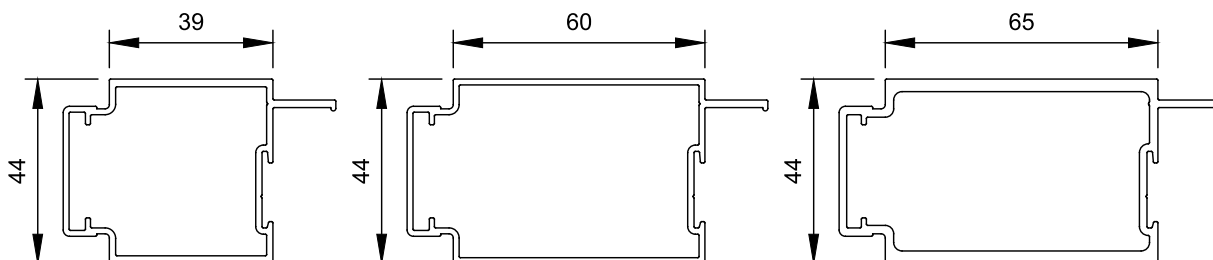
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## Profile Identification

### Palace Multi Profiles



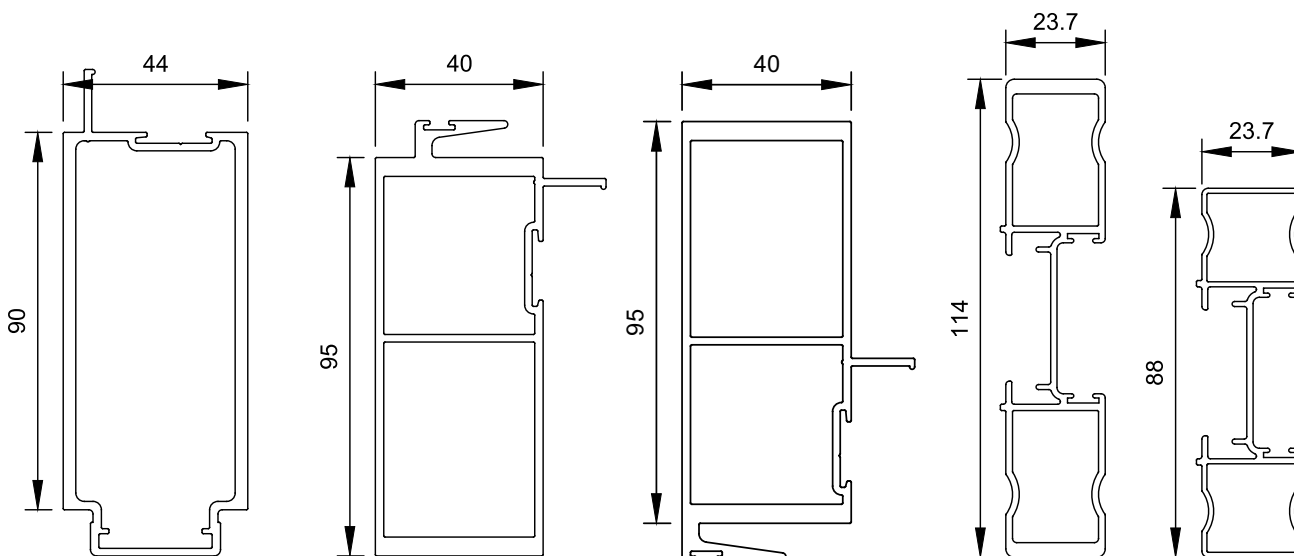




DIE No. <W53100> Palace M Stile Meeting 39mm

DIE No. W58268 Palace M Stile Meeting 60mm

DIE No. W56607 Palace M Stile Meeting 65mm



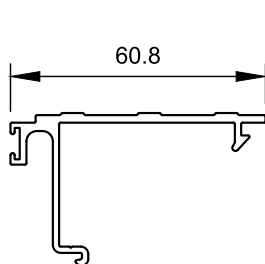
DIE No. <W54966> Palace M Stile Meeting 90mm

DIE No. <W55370> Palace M Interlock Slide 40mm HD

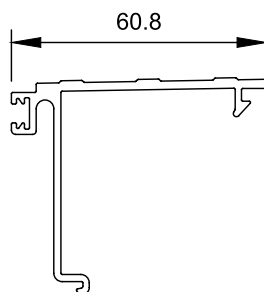
DIE No. <W55371> Palace M Interlock Fixed 40mm HD

DIE No. <W53223> Palace M Astragal Heavy Duty

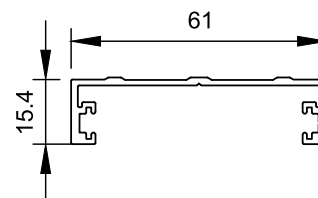
DIE No. W58269 Palace M Astragal 88mm



DIE No. <W31538> Palace M Frame Sill Cover 33mm High



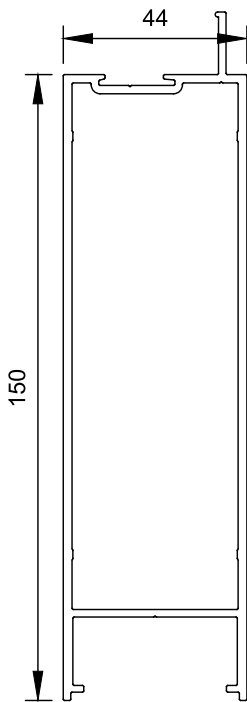
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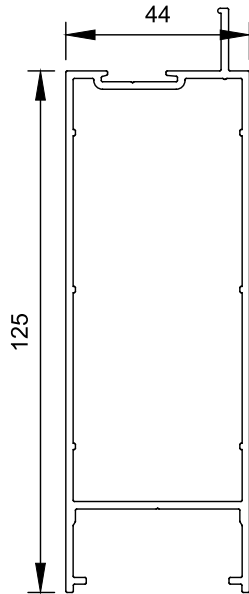
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## Profile Identification

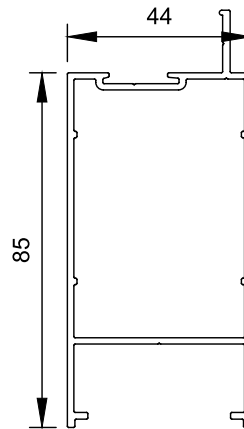
### Palace Multi Profiles



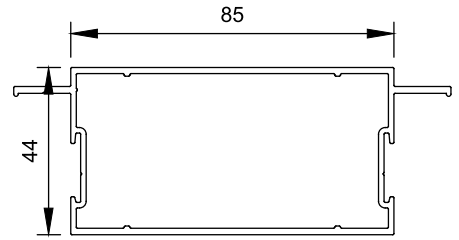
DIE No. <W44094> Clip44 Hd/Sill Rail 150mm R6



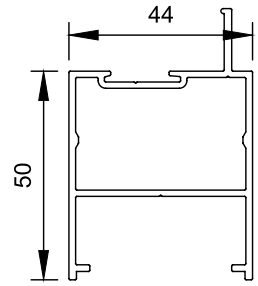
DIE No. W55914 Clip44 Hd/Sill Rail 1 25mm R5



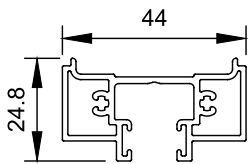
DIE No. <W44088> Clip44 Hd/Sill Rail 85mm R4 SD



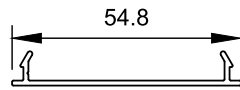
DIE No. <W44089> Clip44 Mid Rail 85mm R4 SP



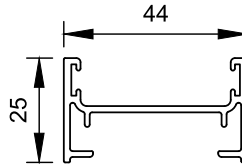
DIE No. <W44087> Clip44 Hd/Sill Rail 50mm R7



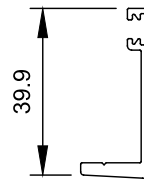
DIE No.W58916 Palace M Adaptor Multi Sill Rail (New)



DIE No.W31534 Palace M Frame Head Cover

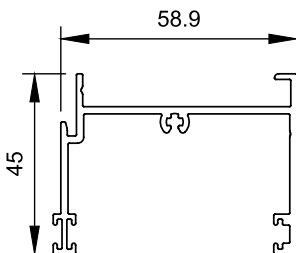


DIE No. <W26399> Palace M Astragal

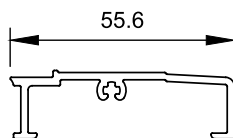


DIE No.W37993 Palace M Adaptor Frame Panel Retention

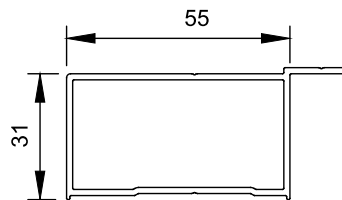
## New Palace Add-On Profiles



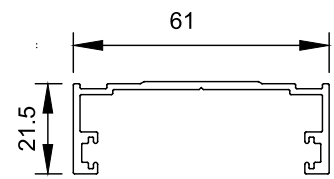
DIE No.W38183 Palace M Frame Head Rail Add On



DIE No.W38184 Palace M Frame Sill Rail Add On



DIE No.W59254 Palace M Frame Jamb Add On

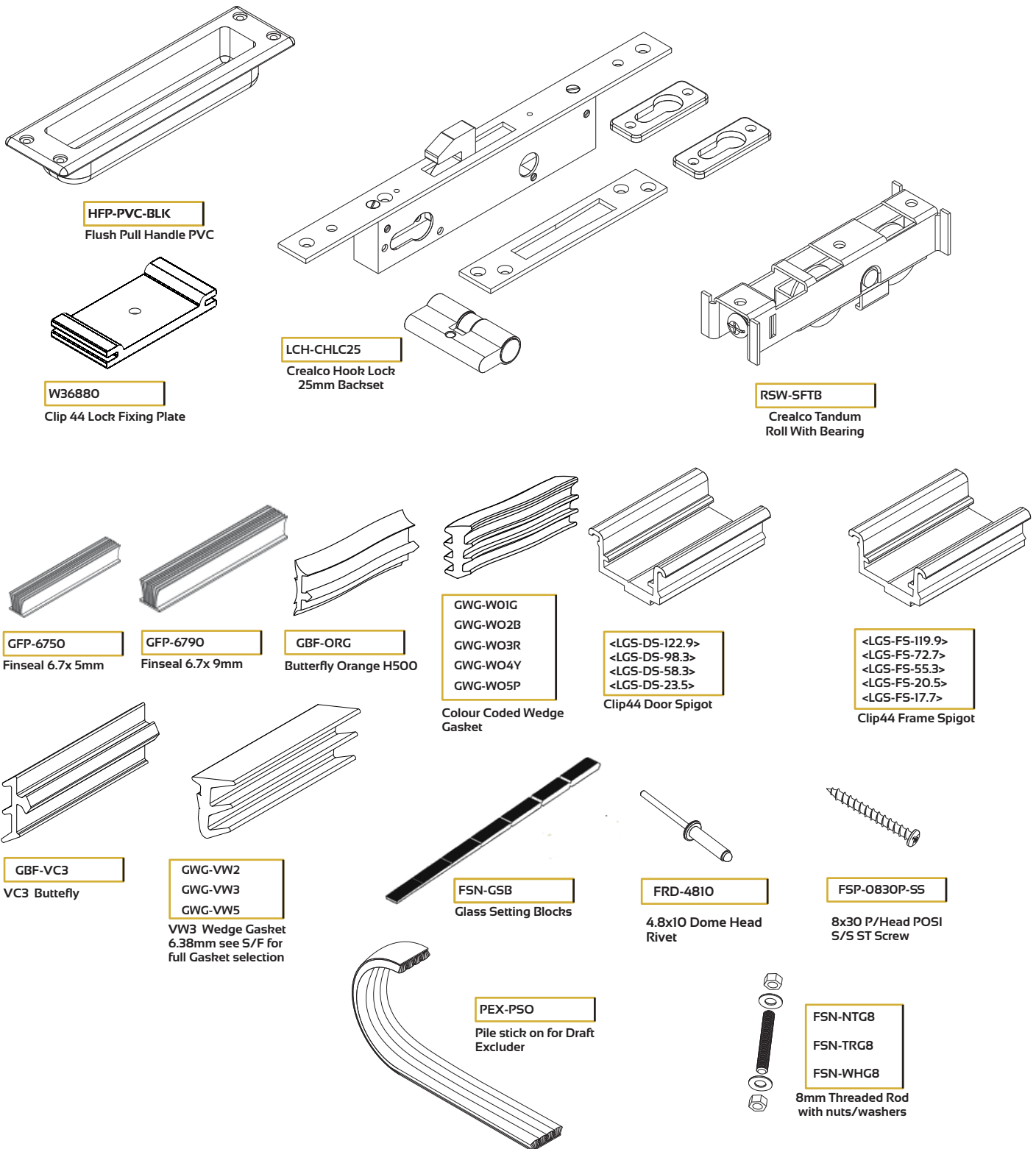


DIE No.W37989 Palace M Adaptor Frame Jamb 20mm Deep

## Hardware Components

### RECOMMENDED PALACE MULTI COMPONENTS

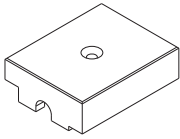
All hardware is available through our CDP's



## Hardware Components

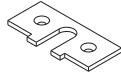
### RECOMMENDED PALACE MULTI COMPONENTS

All hardware is available through our CDP's



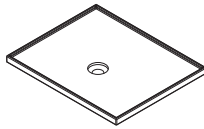
**SGD-PMSB**

Palace M Sash Block



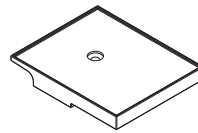
**PEC-PMS**

Palace M End Cap  
Multi Sill Rail



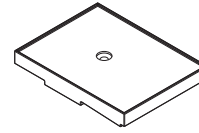
**PEX-PDEM**

Palace M Draft  
Excluder Multi



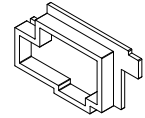
**PEX-PDE**

Palace M Draft Excluder  
Fixed Panel



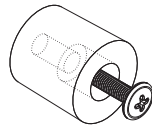
**PEX-PDET**

Palace M Draft  
Excluder Triple Track



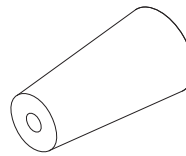
**PEX-PTC**

Palace Middle Track  
Cover for OXX



**SGD-VST  
FSC-0820P-SS**

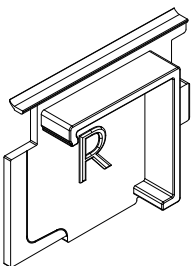
Stopper with Screw



**SGD-PDC**

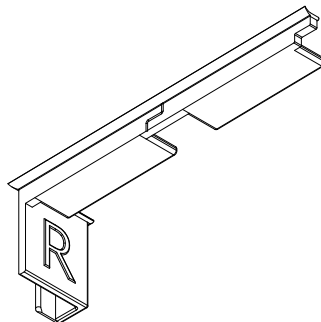
Patio Door Centre  
Stopper 95mm

### End-Caps for High Performance Sill Rails only!



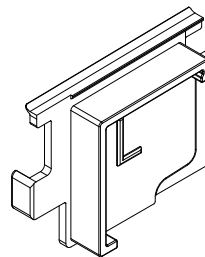
**PEC-PMSCI-HP37994R**

Palace M Sill Cover Int End  
Cap Right 65mm



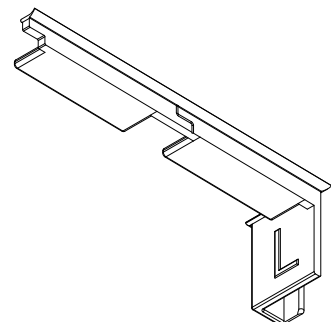
**PEC-PMSCJ-HP37994R**

Palace M Sill Cover Jamb End  
Cap Right 65mm



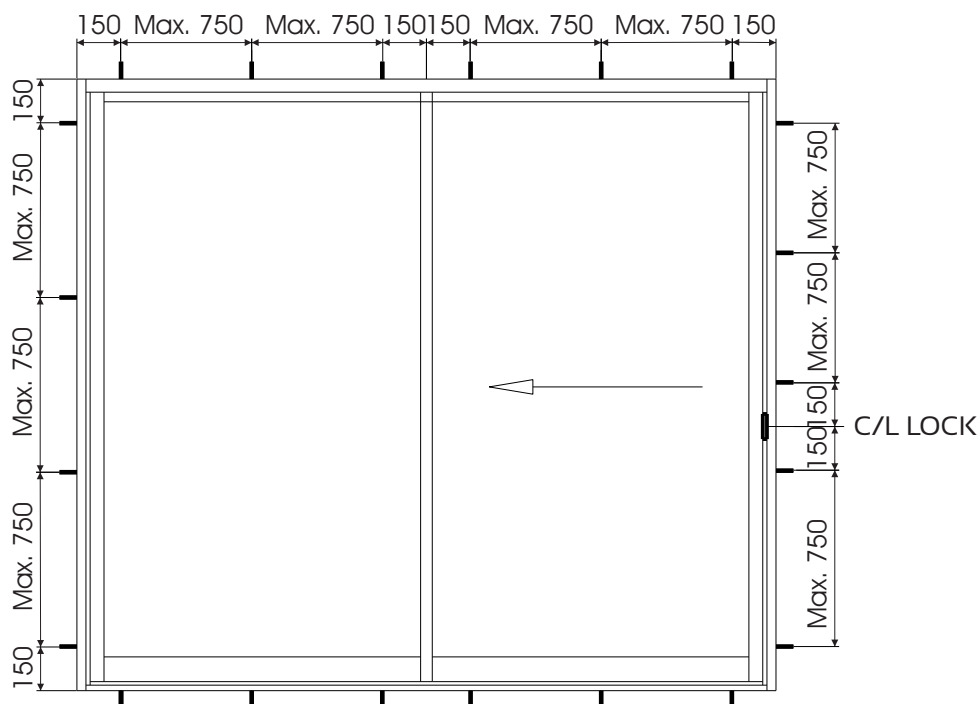
**PEC-PMSCI-HP37994L**

Palace M Sill Cover Int End  
Cap Left 65mm

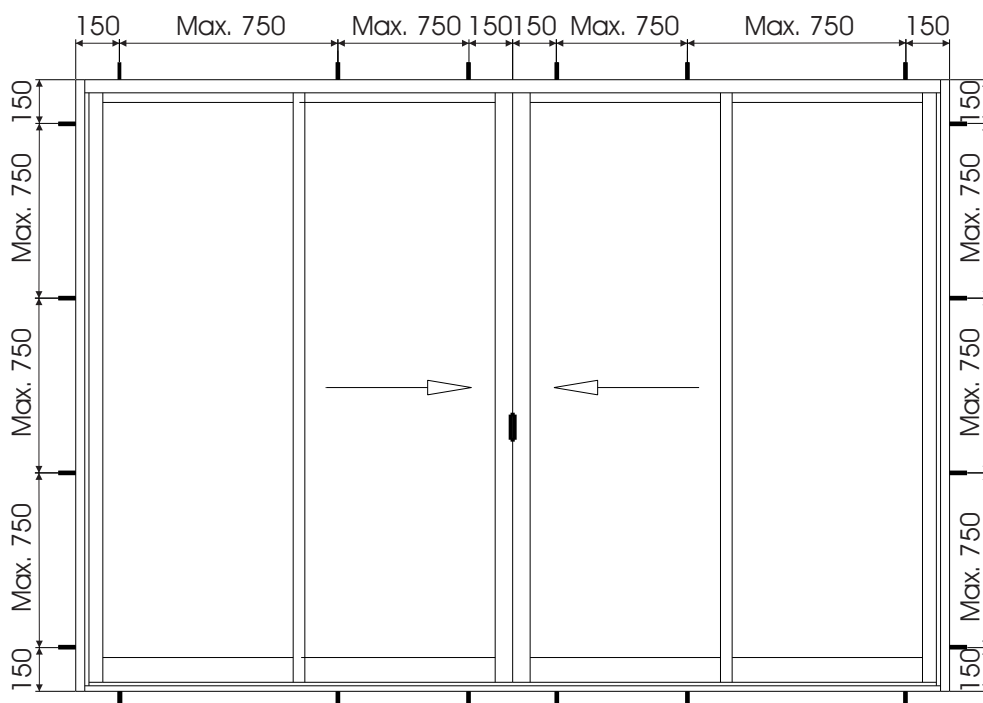


**PEC-PMSCJ-HP37994L**

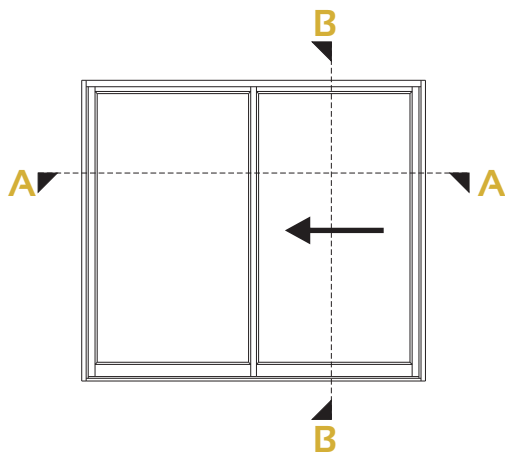
Palace M Sill Cover Jamb  
End Cap Left 65mm



TYPICAL OX SLIDING DOOR &  
HORIZONTAL SLIDING WINDOW

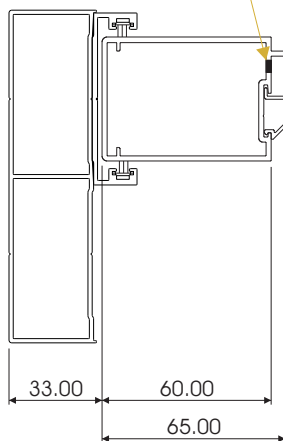


TYPICAL OXXO SLIDING DOOR &  
HORIZONTAL SLIDING WINDOW

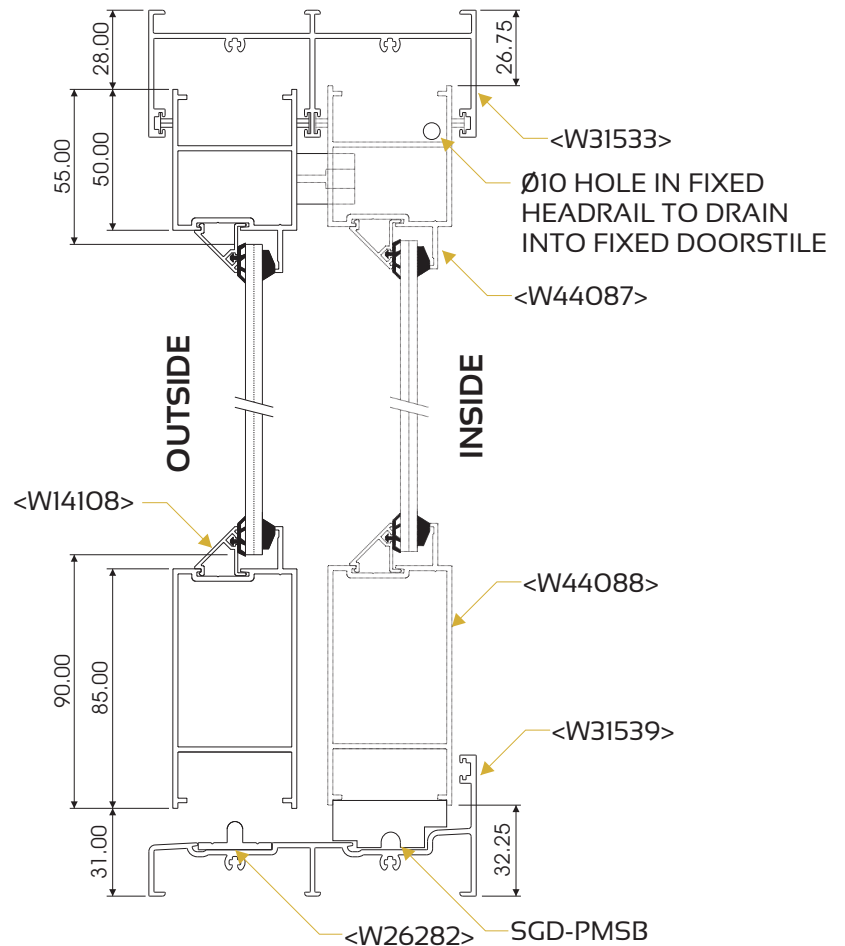


**SECTION A - A**  
Section not to scale

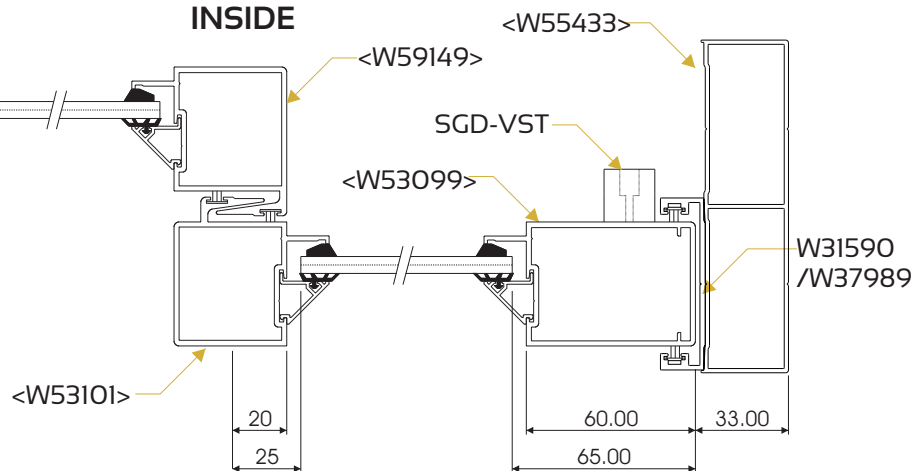
Ø10 HOLE IN FIXED  
HEADRAIL TO DRAIN  
IN FIXED DOORSTILE



**SECTION B-B**  
Section not to scale



INSIDE



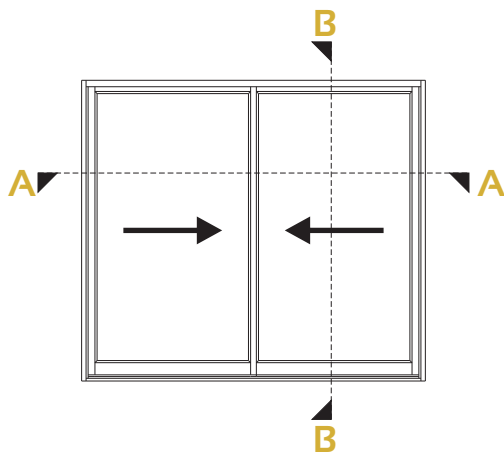
OUTSIDE

This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

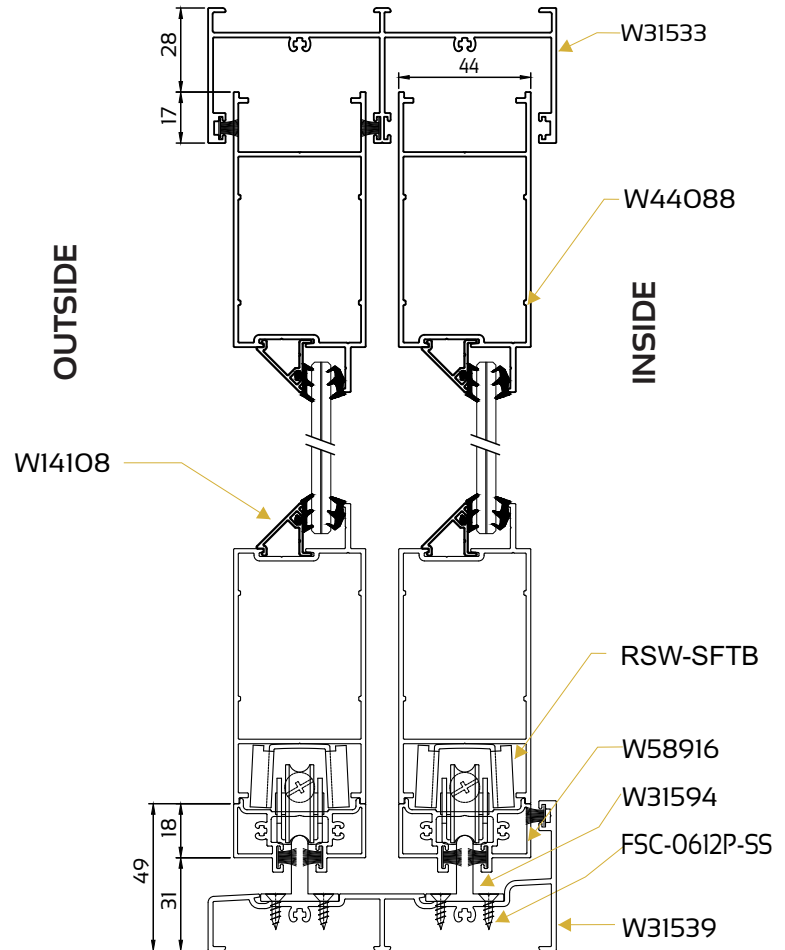


## Typical Cross-Sectional Detail

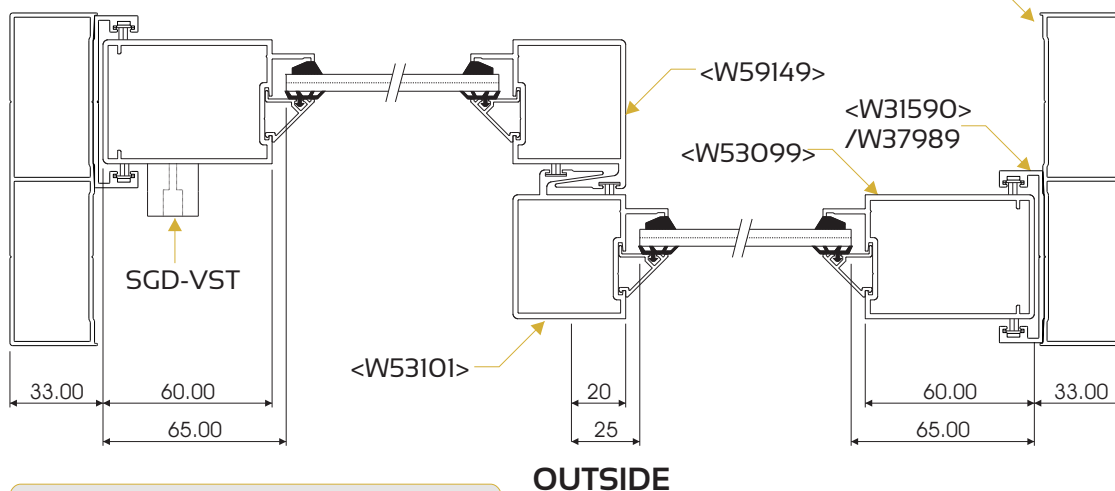
### 2 Panel Multi Slider Configuration



**SECTION B-B**  
Section not to scale



**SECTION A - A**  
Section not to scale

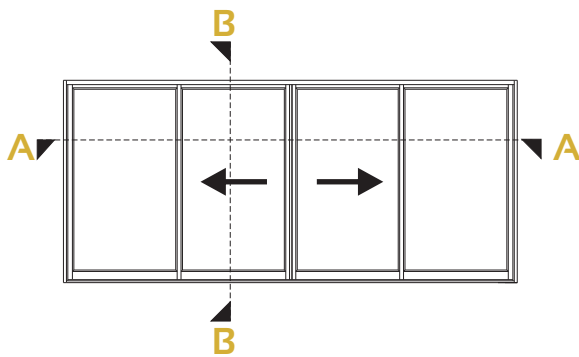


## OUTSIDE

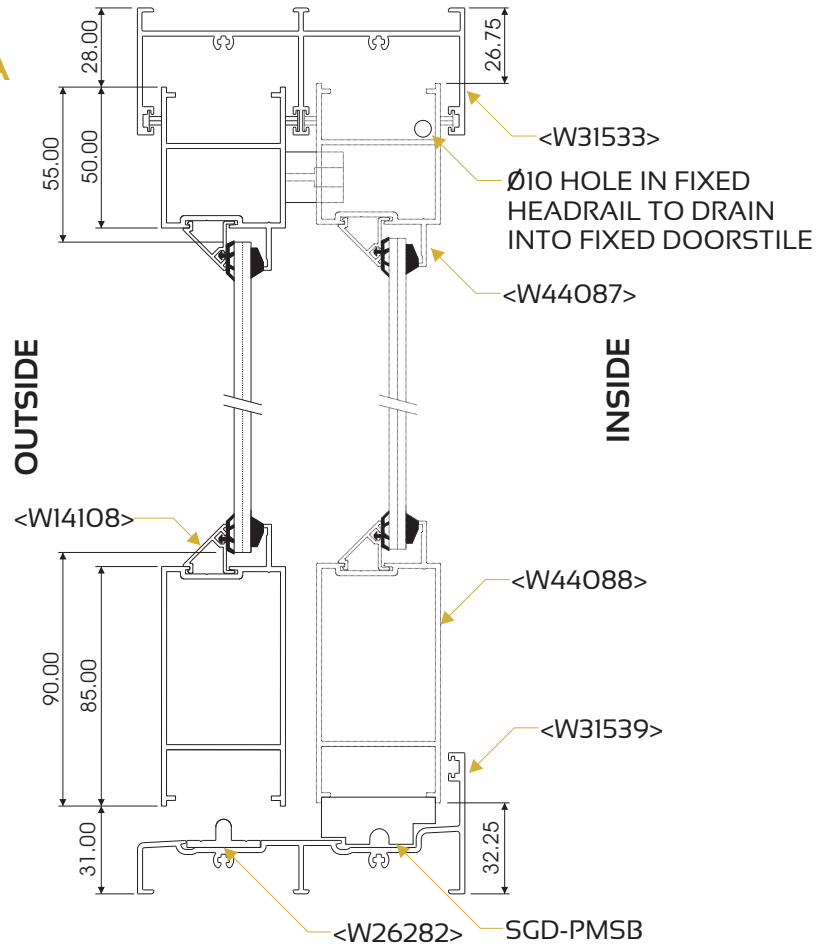
This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.

## Typical Cross-Sectional Detail

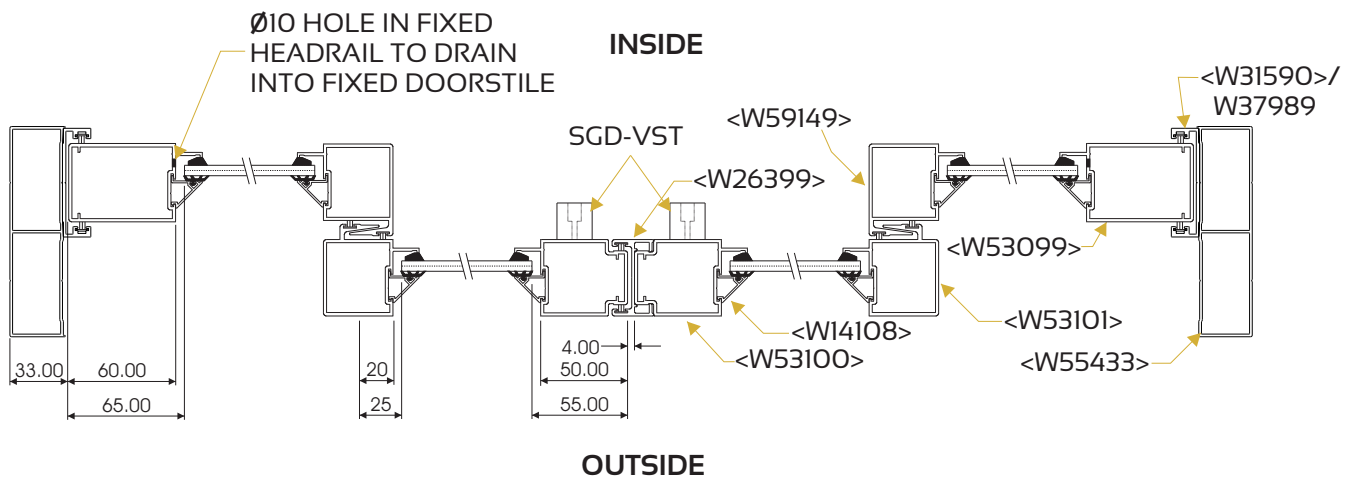
OXO Configuration



**SECTION B-B**  
Section not to scale

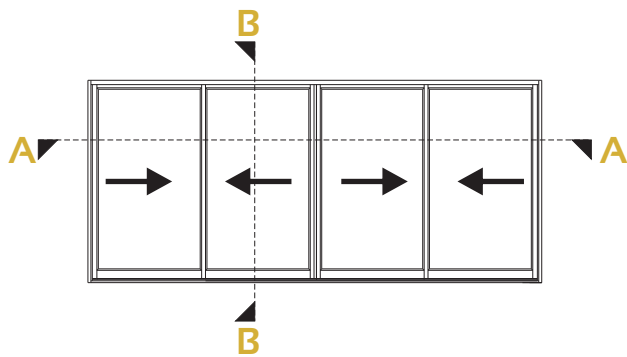


**SECTION A - A**  
Section not to scale

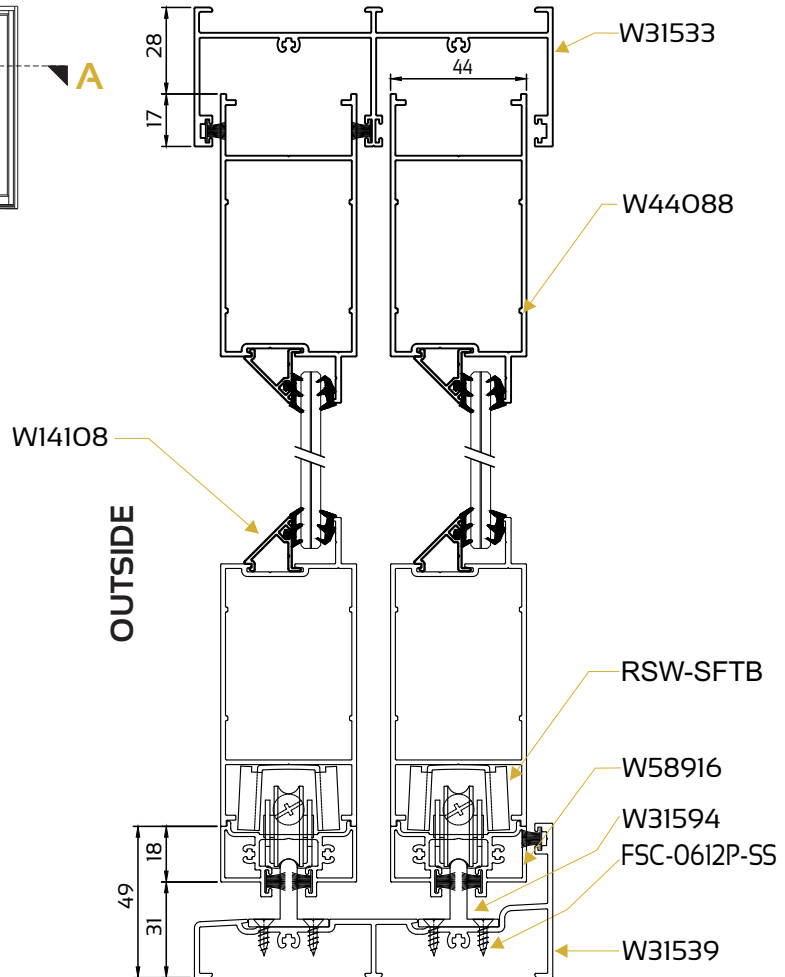


## Typical Cross-Sectional Detail

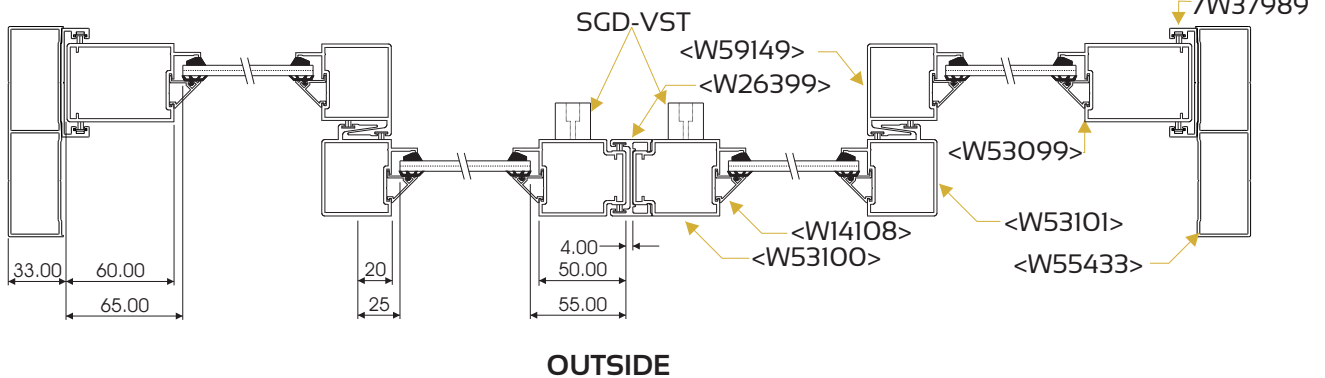
### 4 Panel Multi Slider Configuration



**SECTION B-B**  
Section not to scale



**SECTION A - A**  
Section not to scale

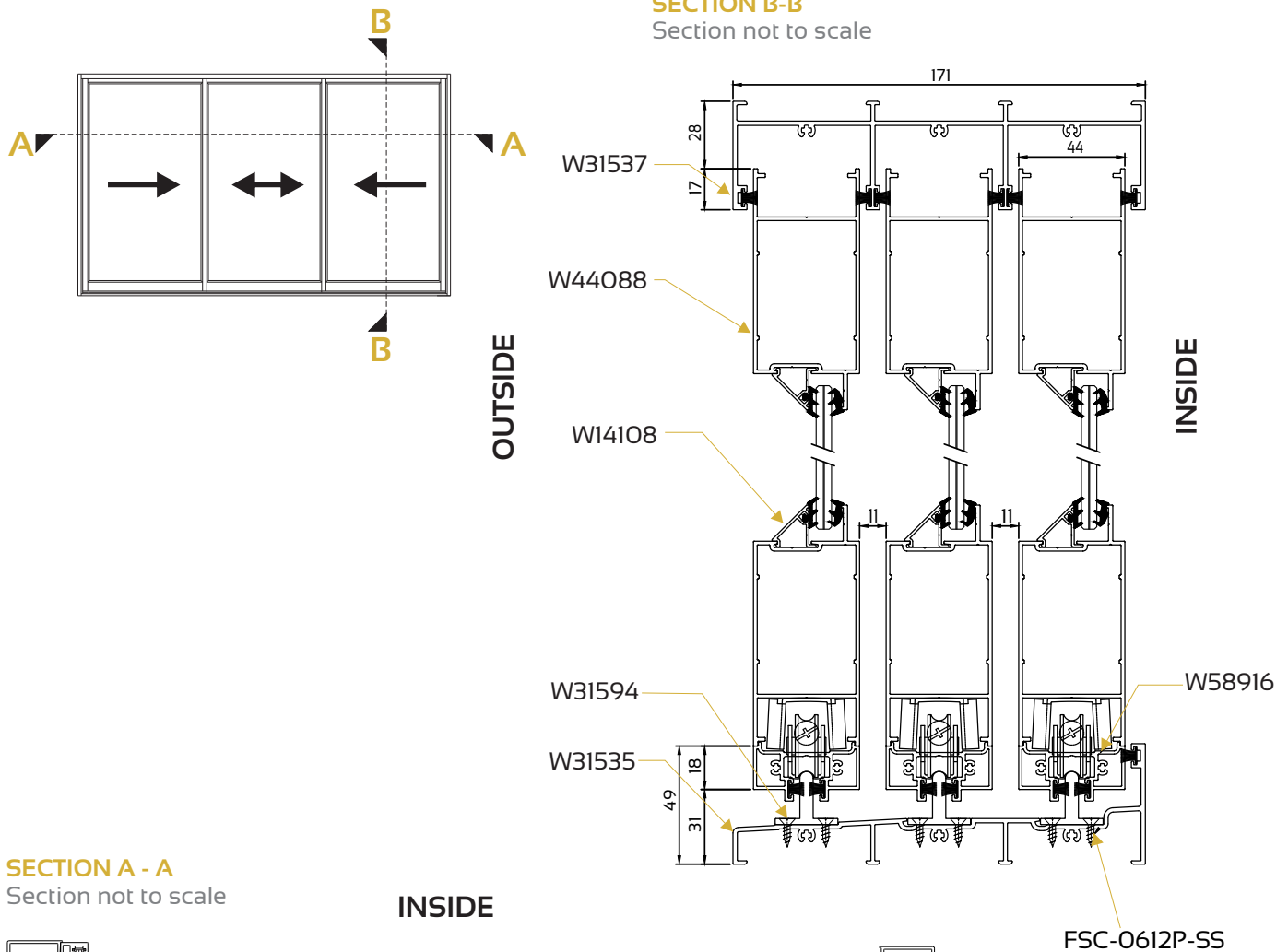


## Typical Cross-Sectional Detail

### 3 Panel Multi Slider Configuration

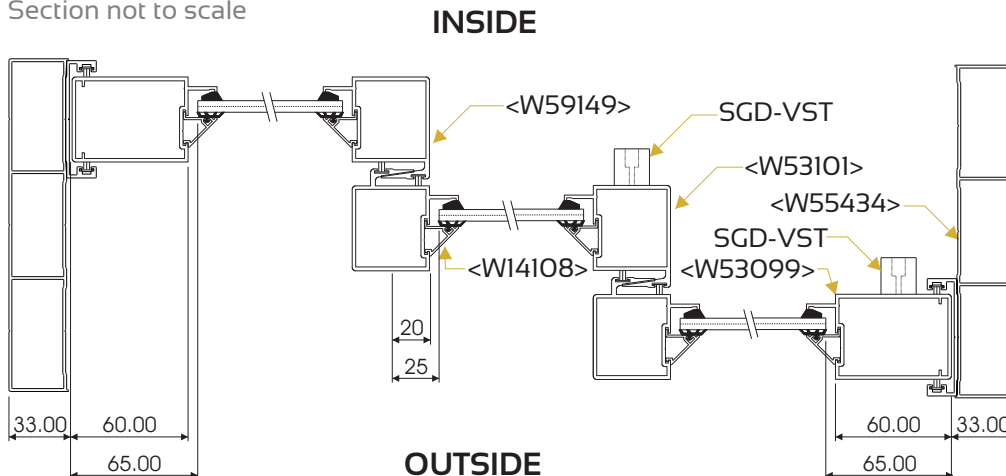
#### SECTION B-B

Section not to scale



#### SECTION A - A

Section not to scale

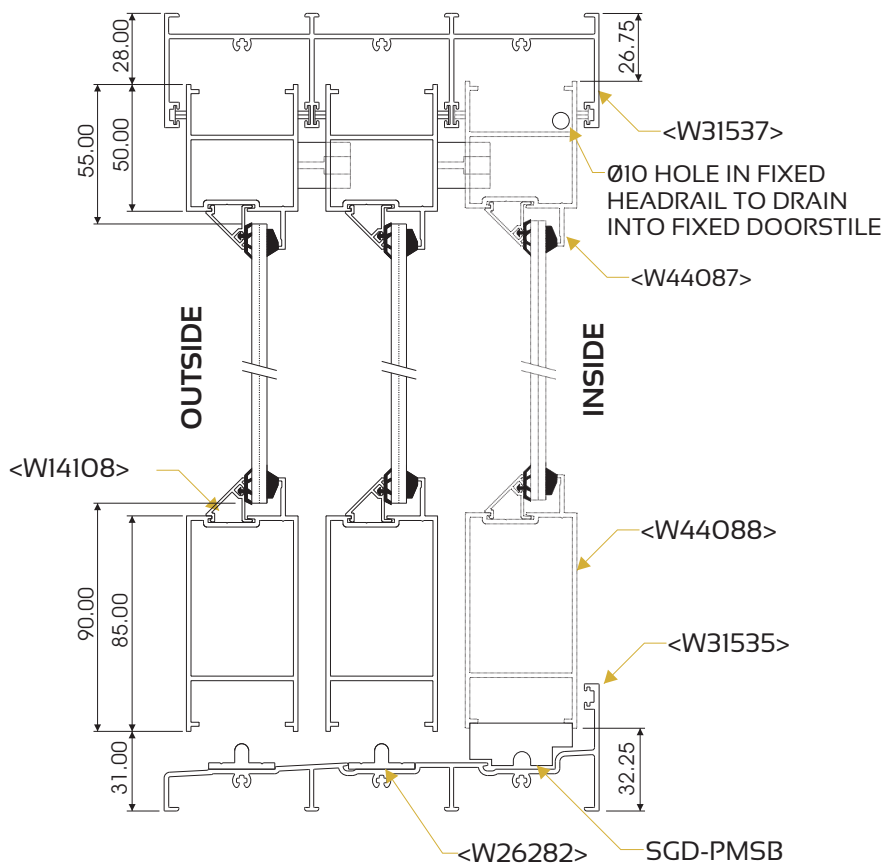
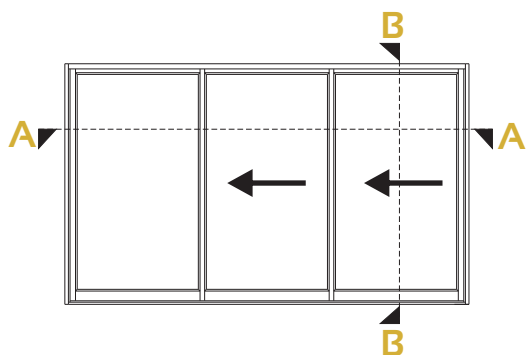


## Typical Cross-Sectional Detail

OXX Configuration

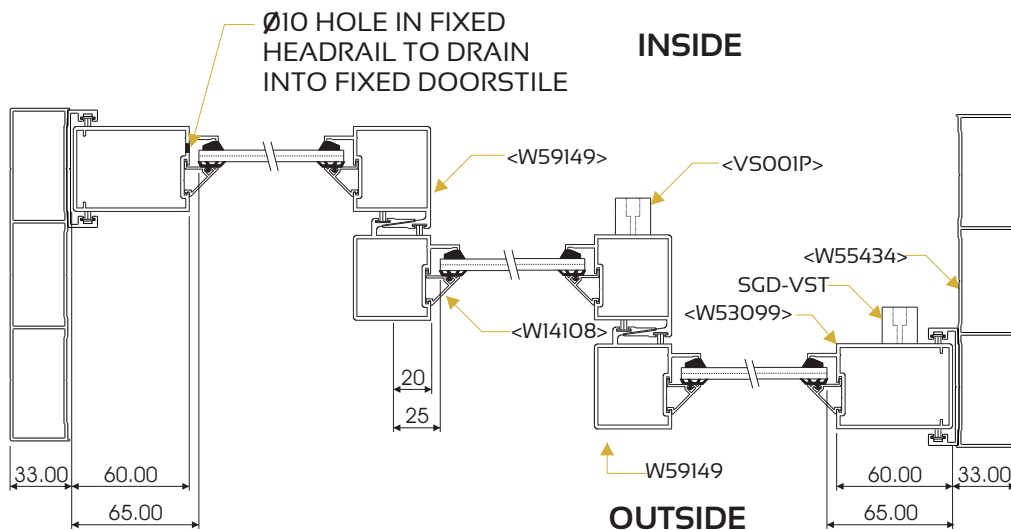
### SECTION B-B

Section not to scale



### SECTION A - A

Section not to scale

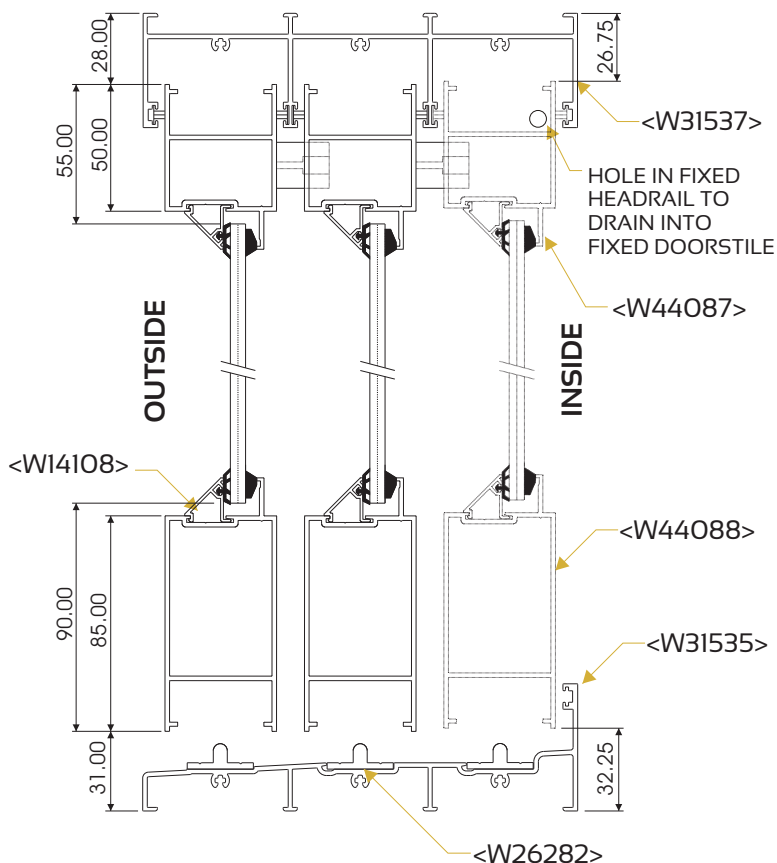
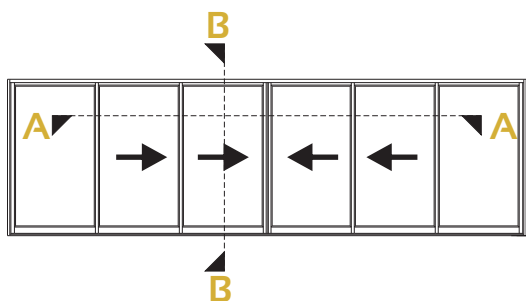


## Typical Cross-Sectional Detail

OXXXXO Configuration

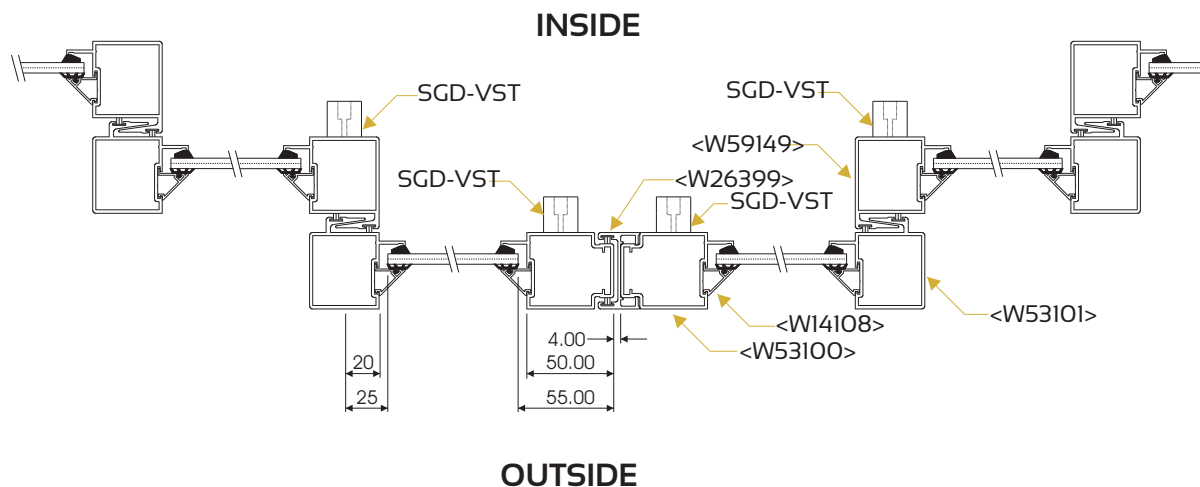
### SECTION B-B

Section not to scale



### SECTION A - A

Section not to scale



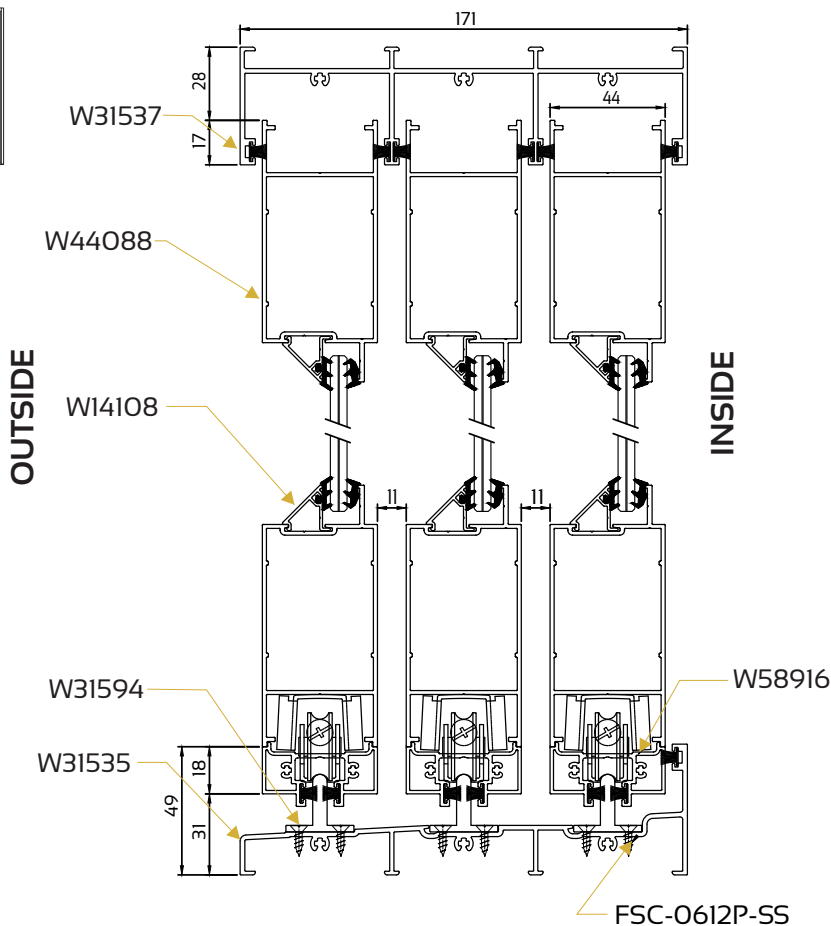
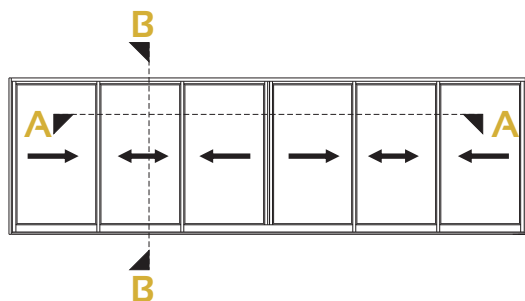


## Typical Cross-Sectional Detail

6 Panel Multi Slider Configuration

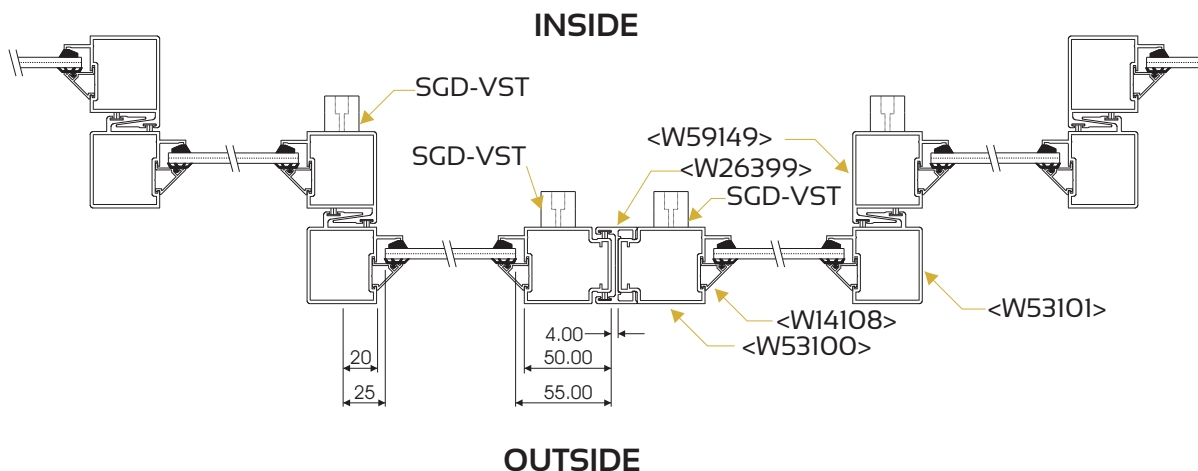
### SECTION B-B

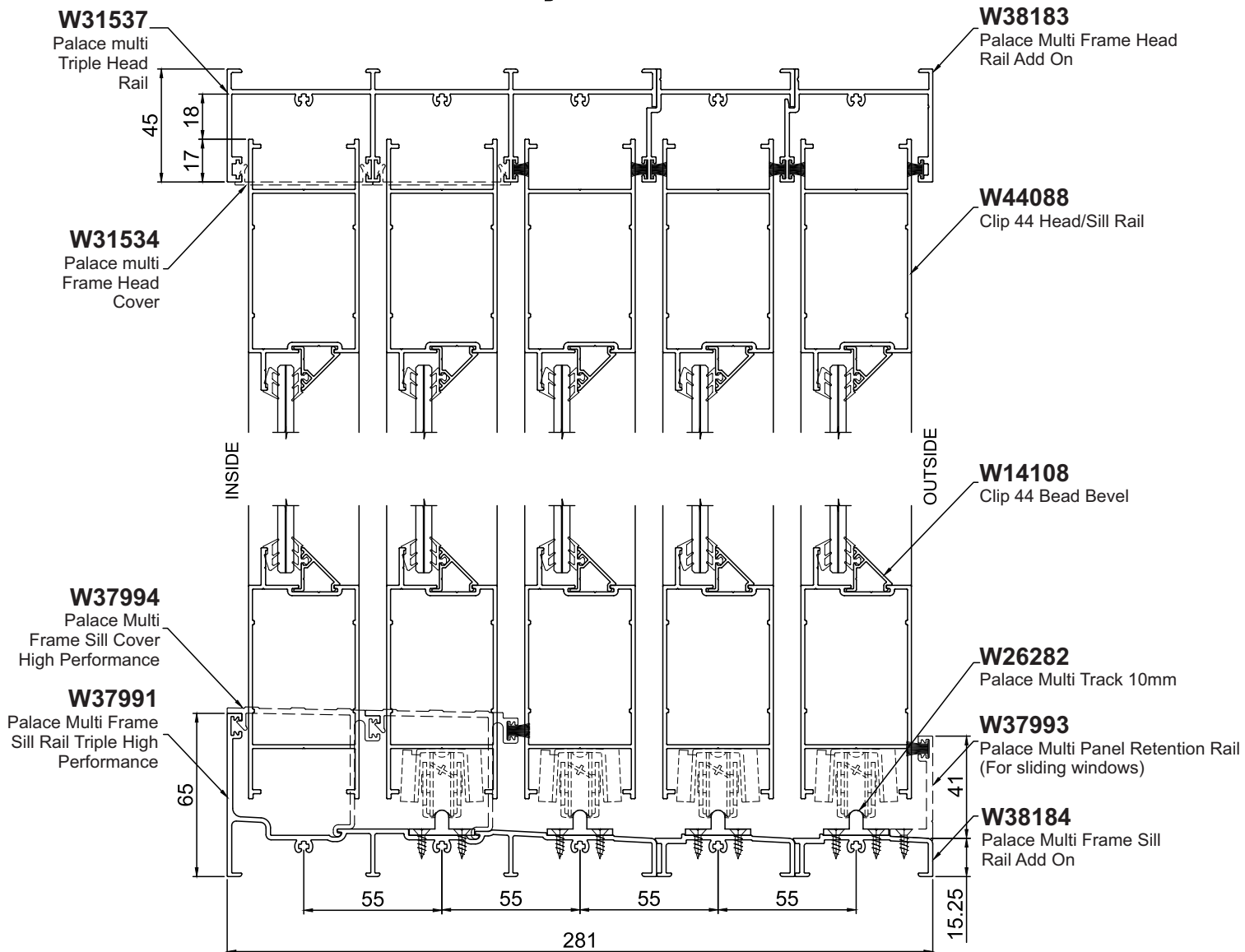
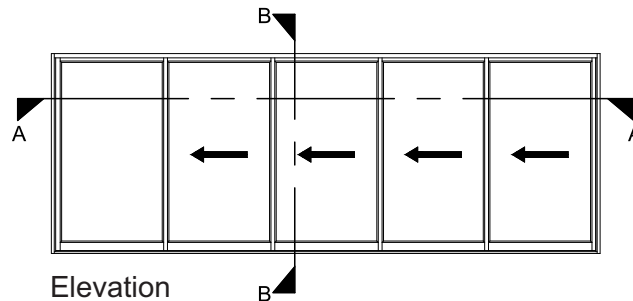
Section not to scale



### SECTION A - A

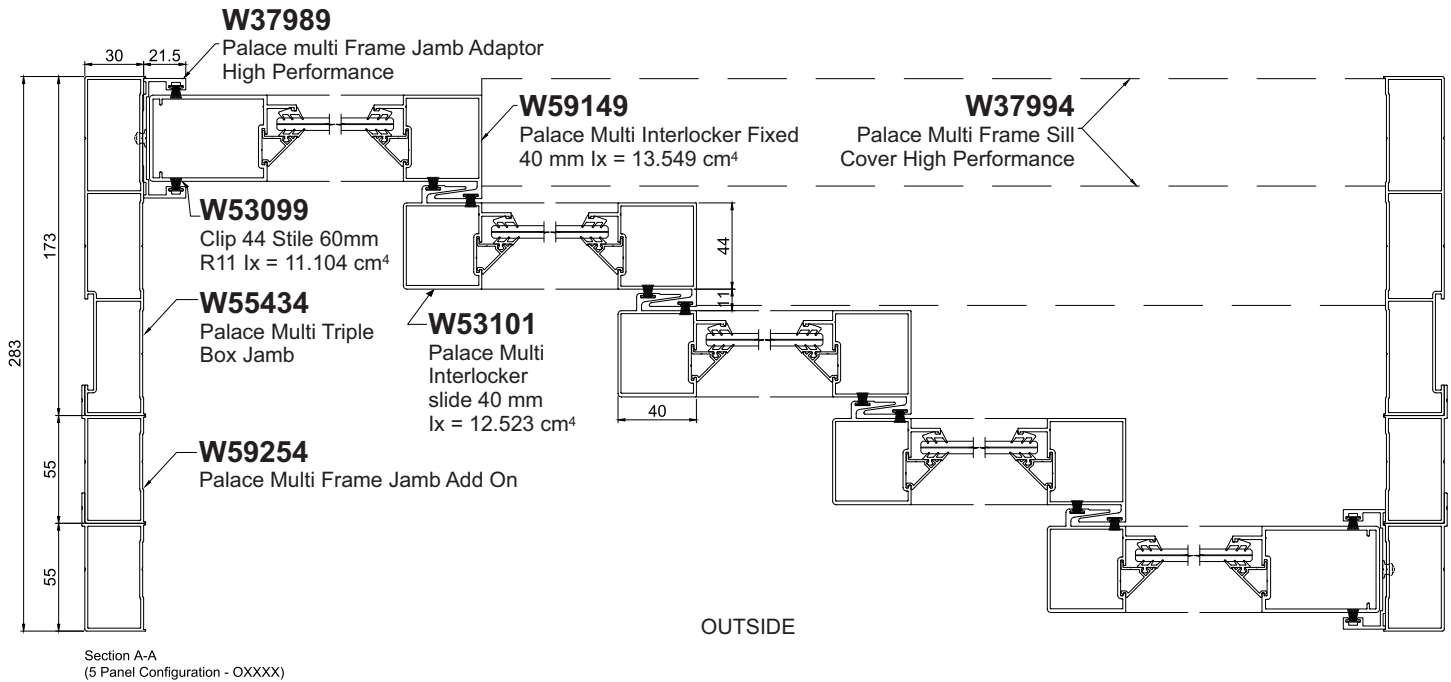
Section not to scale





**Section B-B**

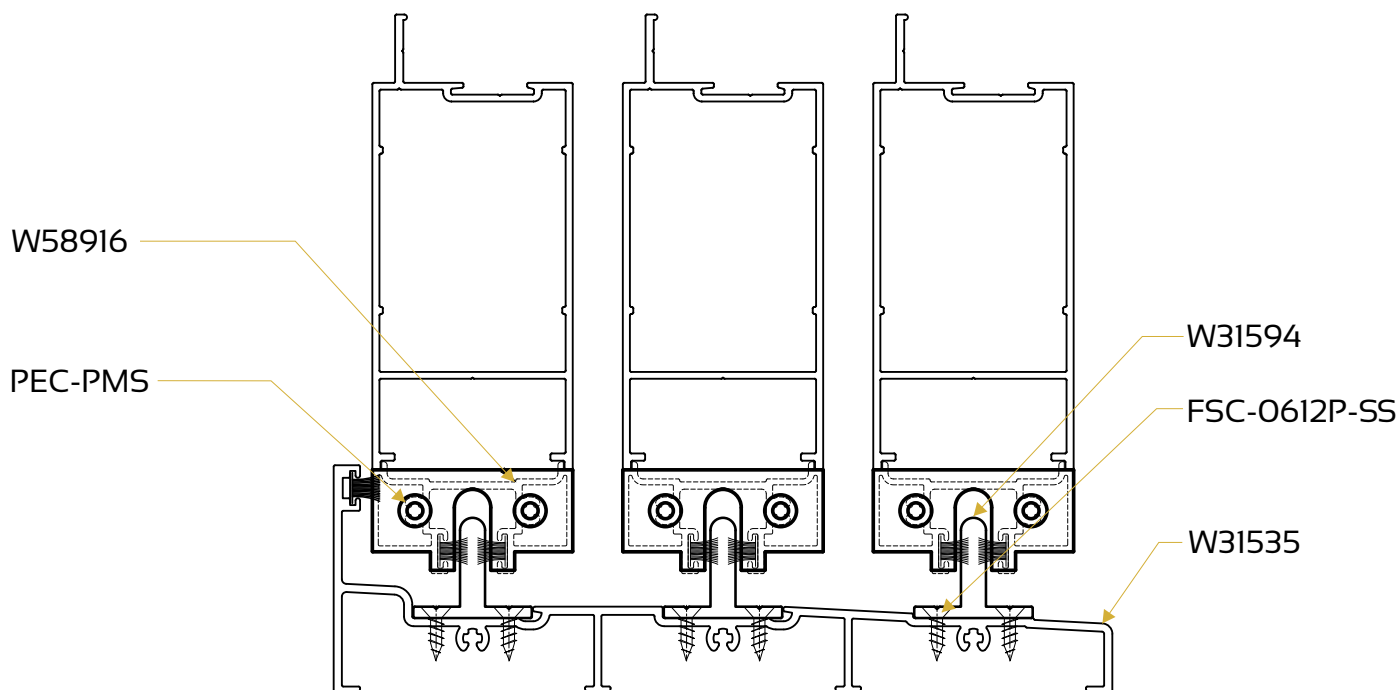
(5 Panel Configuration (Sill Rail - W37991)- OXXXX)



**Section A-A**  
(5 Panel Configuration - OXXXX)

## Typical Cross-Sectional Detail

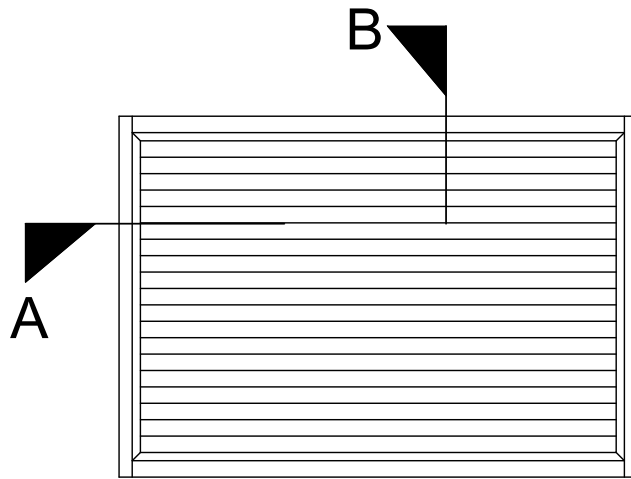
Bottom Sill Extension details



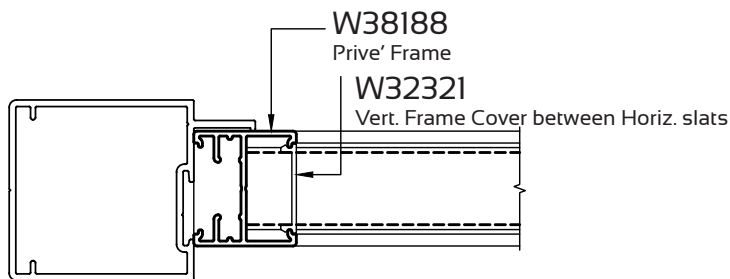
**Detail showing the Palace Multi Sill Extension End Caps**

**Typical Cross-Sectional Detail**

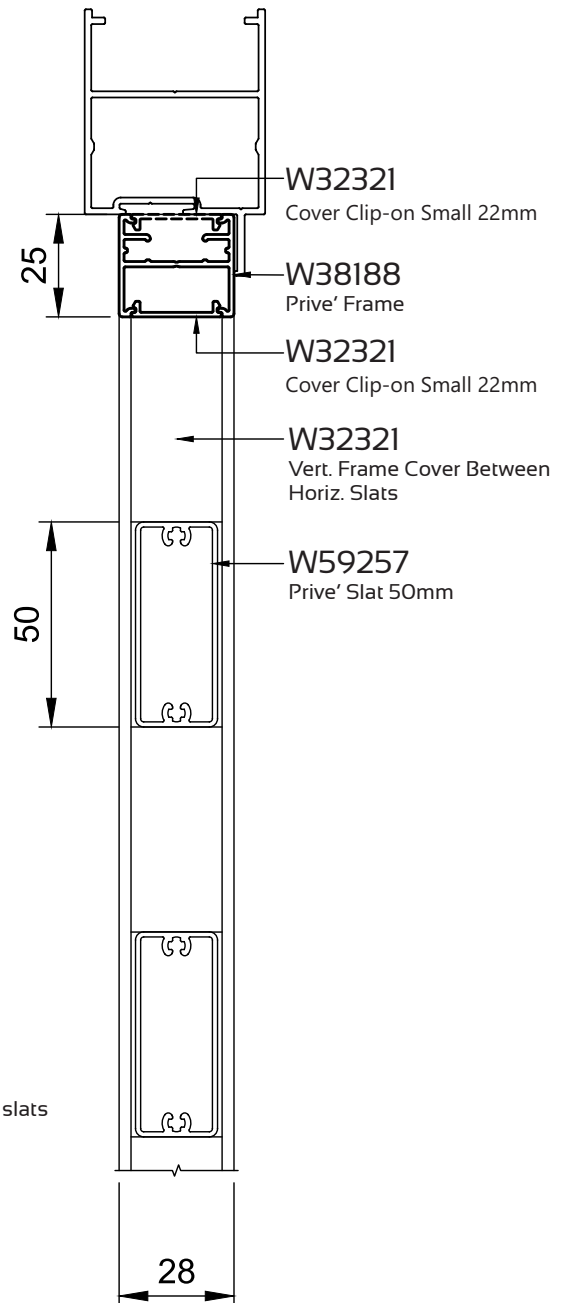
50mm HORIZONTAL PRIVE' SLAT



Please refer to the Prive' manual for further insert details



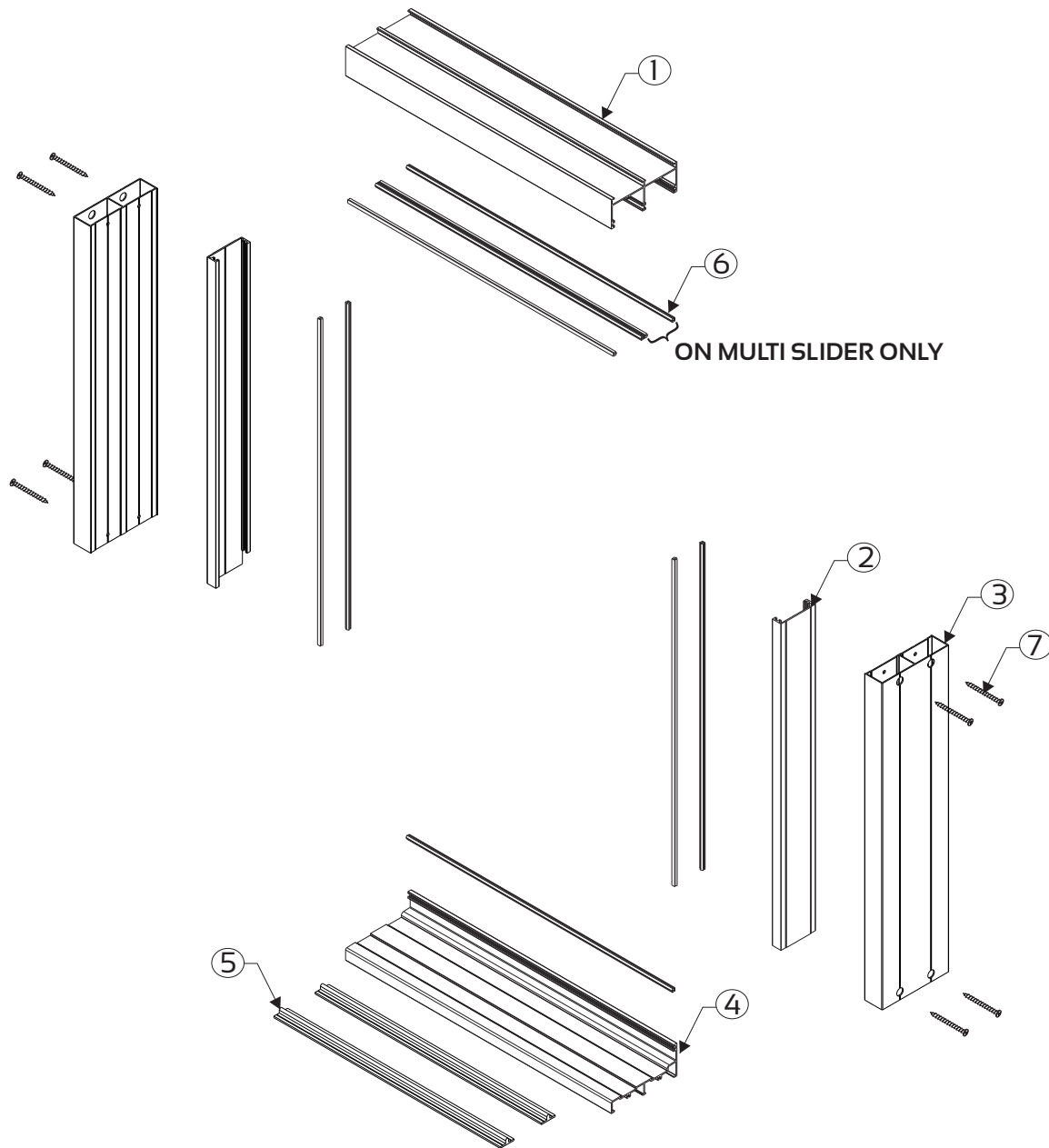
**Section A**



**Section B**

## Outer Frame Component Assembly Detail

Double Track



### System Profiles

ITEM	QTY	DIE No.	DESCRIPTION
1	1	<W31533>	Palace M Frame Head Rail Double
2	2	<W31590>	Palace M Adaptor Frame Jamb 14mm
3	2	<W55433>	Palace M Frame Jamb Double
4	1	<W31539>	Palace M Frame Sill Rail Double 50mm
5	2	<W26282>	Palace M Track 10mm

### Hardware

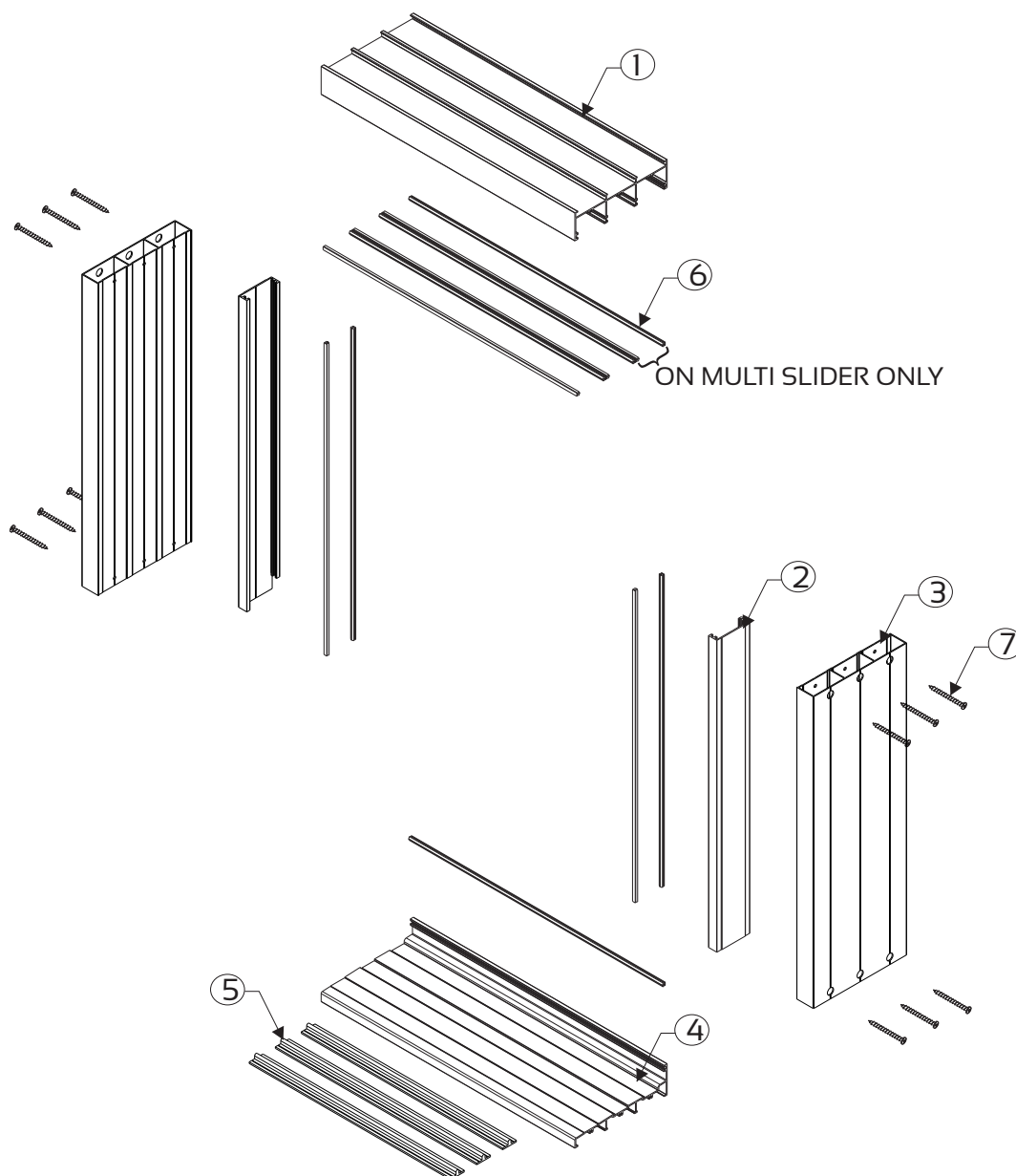
ITEM	QTY	COMPONENT DESCRIPTION
6	8	Finseal
7	8	8x30 P/Head POSI S/S ST Screw



## Outer Frame Component Assembly Detail

Triple Track

Finseal only on Multi Slider XX, XXX or XXXXXX, no finseal on OX, OXXO, OXX and OXXXXO



### System Profiles

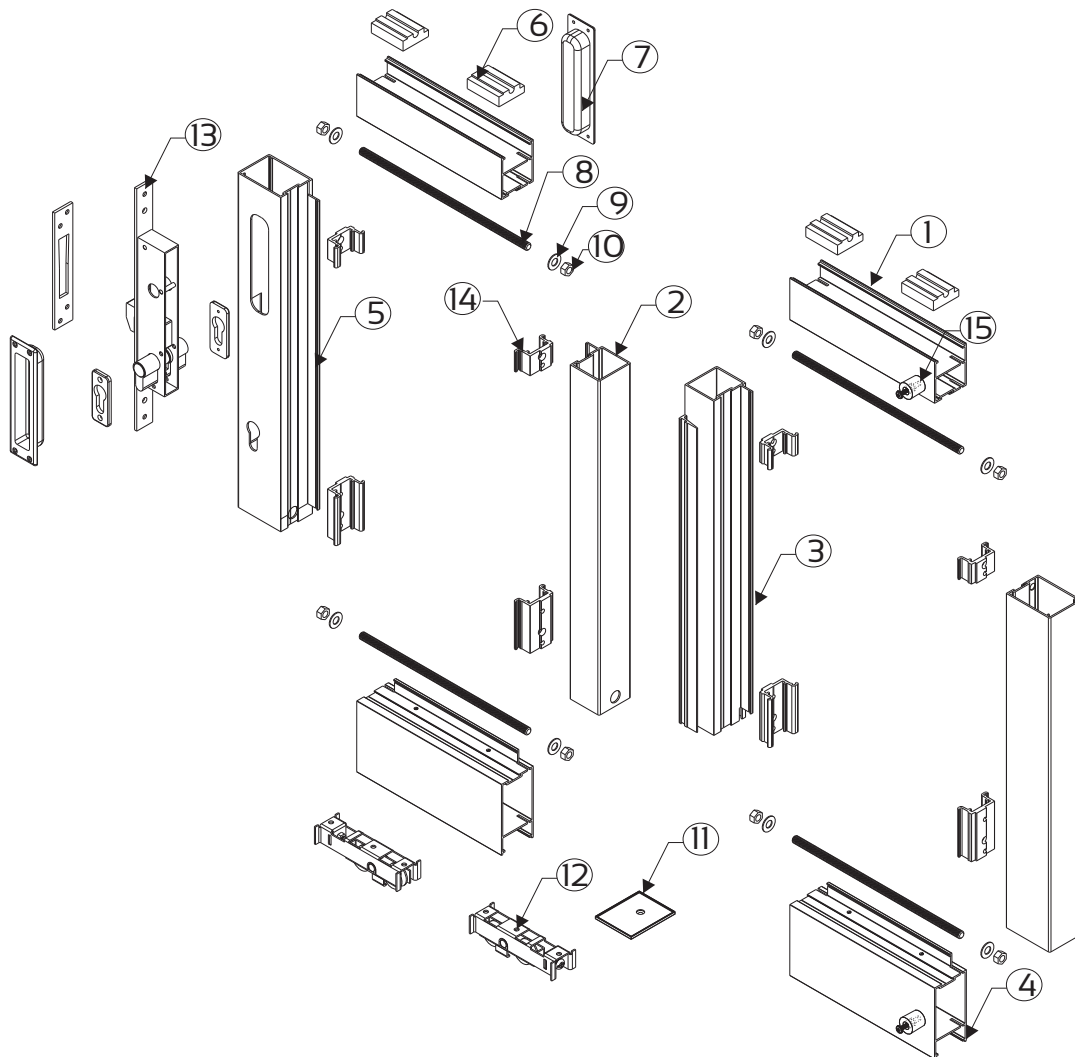
ITEM	QTY	DIE No.	DESCRIPTION
1	1	<W31537>	Palace M Frame Head Rail Triple
2	2	<W31590>	Palace M Adaptor Frame Jamb 14mm
3	2	<W55434>	Palace M Frame Jamb Triple
4	1	<W31535>	Palace M Frame Sill Rail Triple 50mm
5	3	<W26282>	Palace M Track 10mm

### Hardware

ITEM	QTY	COMPONENT DESCRIPTION
6	9	Finseal
7	12	8x30 P/Head POSI S/S ST Screw

## Insert Component Assembly Detail

Sliding/Fixed



### System Profiles

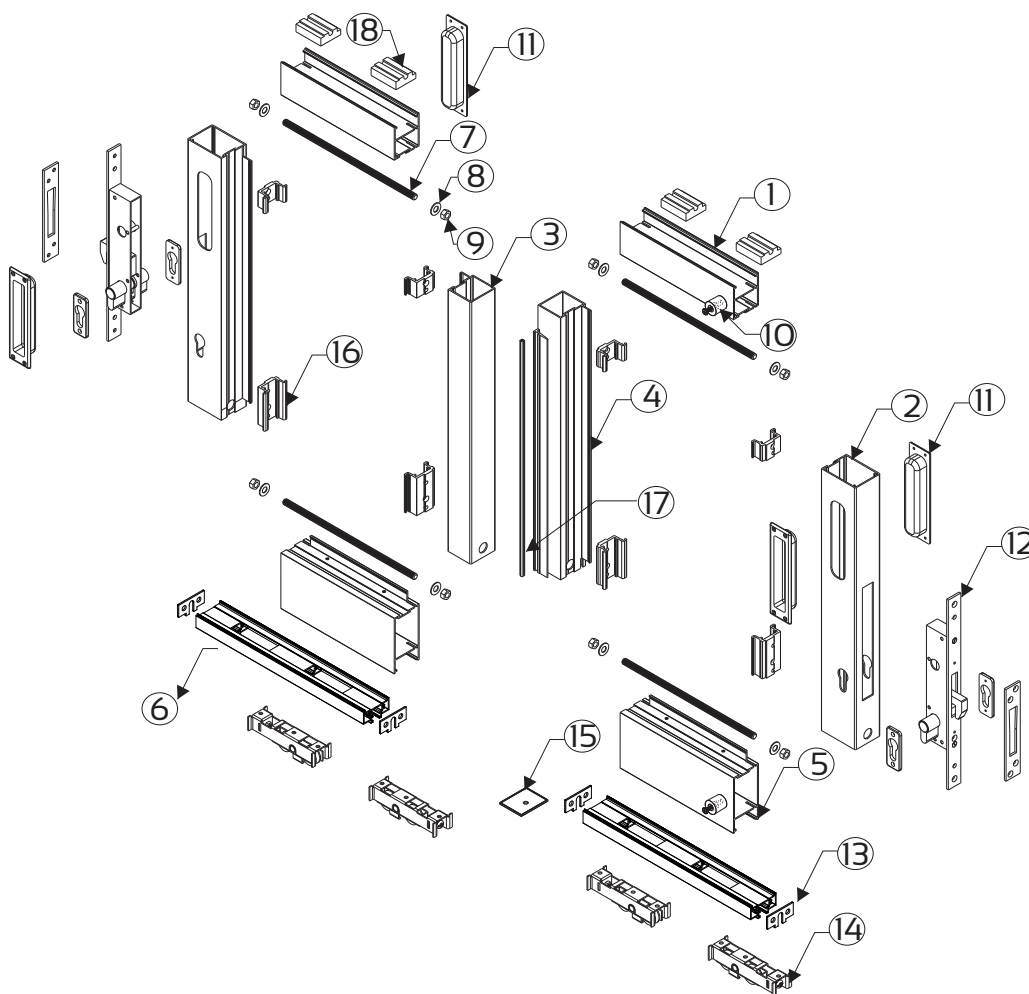
ITEM	QTY	DIE No.	DESCRIPTION
1	2	<W44087>	Clip44 Hd/Sill rail 50mm R7
2	1	<W53101>	Palace M Interlock Slide 40mm
3	1	<W59149>	Palace M Interlock Fixed 40mm
4	2	<W44088>	Clip44 Hd/Sill Rail 85mm R4 SD
5	2	<W53099>	Clip44 Hd/Sil Rail 60mm R11 SD

### Hardware

ITEM	QTY	COMPONENT DESCRIPTION
6	4	Palace Multi Sash Block
7	2	Flush Pull Handle PVC
8	4	Threaded Rod Galv 3m
9	8	Washer Galv 8mm Rod
10	8	Nut Galv 8mm
11	1	Draught Excluder
12	2	Crealco Tandum Roll With Bearing
13	1	Crealco Hook Lock 25mm Backset
14	8	Spigots
15	2	Stopper with Screw

## Insert Component Assembly Detail

Sliding/Sliding



### System Profiles

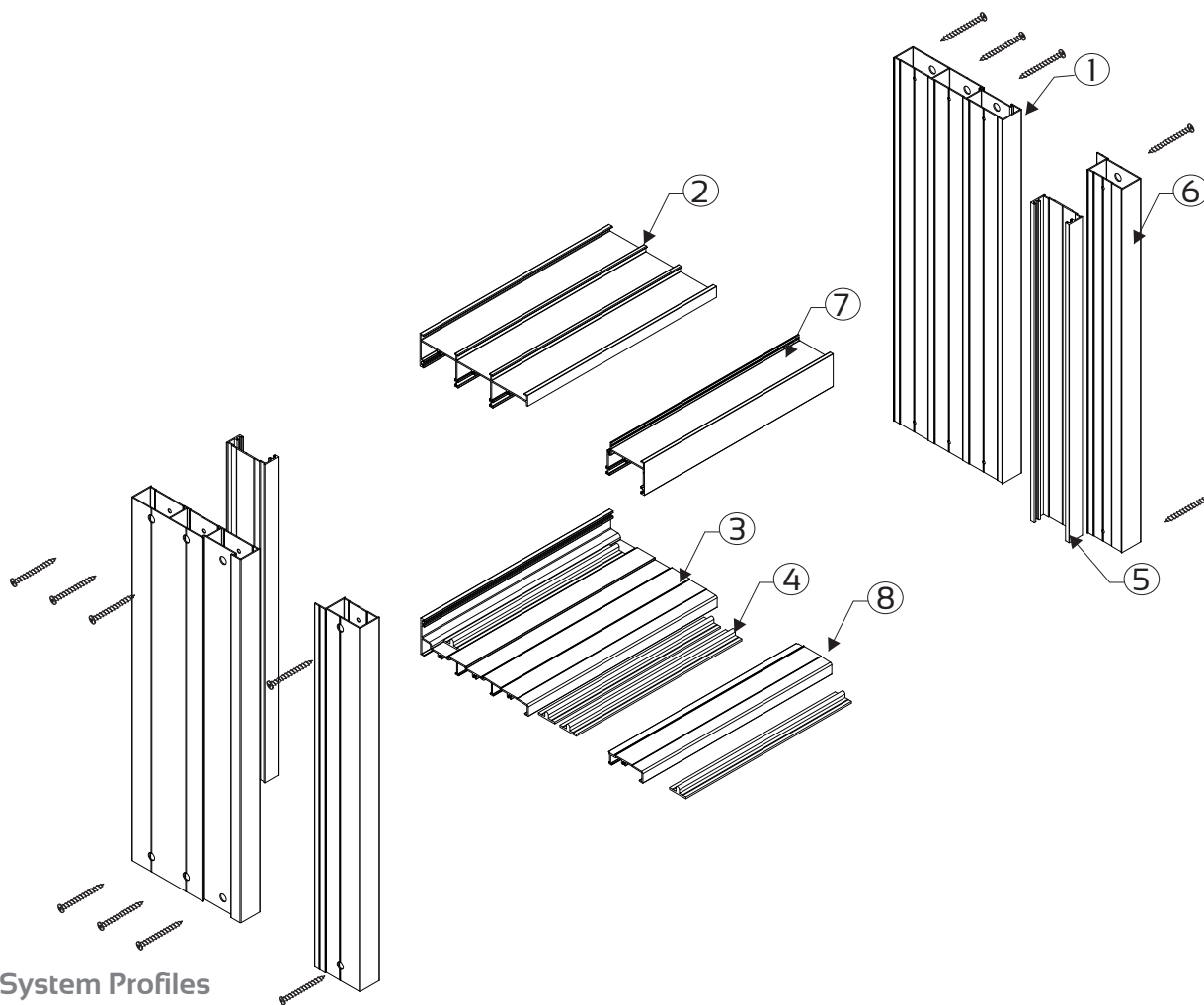
ITEM	QTY	DIE No.	DESCRIPTION
1	2	<W44087>	Clip44 Hd/Sill rail 50mm R7
2	2	<W53099>	Clip44 Stile 60mm RII SD
3	1	<W53101>	Palace M Interlock Slide 40mm
4	1	<W59149>	Palace M Interlock Fixed 40mm
5	2	<W44088>	Clip44 Hd/Sill Rail 85mm R4 SD
6	2	<W58916>	Palace M Adaptor Multi Sill Rail (New)

### Hardware

ITEM	QTY	COMPONENT DESCRIPTION
7	4	Threaded Rod Galv 3m
8	8	Washer Galv 8mm Rod
9	8	Nut Galv 8mm
10	2	Stopper with Screw
11	4	Flush Pull Handle PVC
12	2	CISA Hook Lock 25mm Backset
13	4	Palace Multi Sash End/ No 6x 2 C/S Posi Screws
14	4	Crealco tandum roll with bearing
15	1	Draught Excluder
16	8	Spigots
17	2	Finpile
18	4	Palace Multi Sash Block

## Outer Frame Component Assembly Detail

### Outer Frame Add On Assembly Detail Triple Track with Add On Profiles



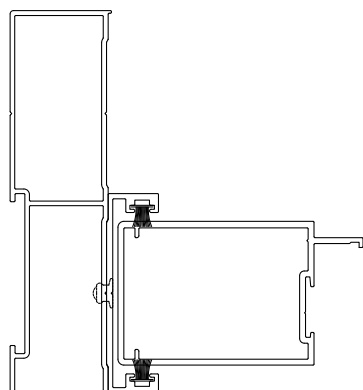
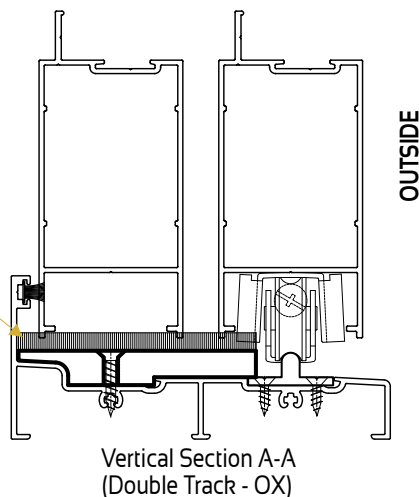
### System Profiles

ITEM	QTY	DIE No.	DESCRIPTION
1	2	W55434	Palace M Frame Jamb Triple
2	1	W31537	Palace M Frame Head Rail Triple
3	1	W31535	Palace M Frame Sill Rail Triple 50mm
4	4	W26282	Palace M Track 10mm
5	2	W37989	Palace M Adaptor Frame Jamb 20mm
6	2	W59254	Palace M Frame Jamb Add On

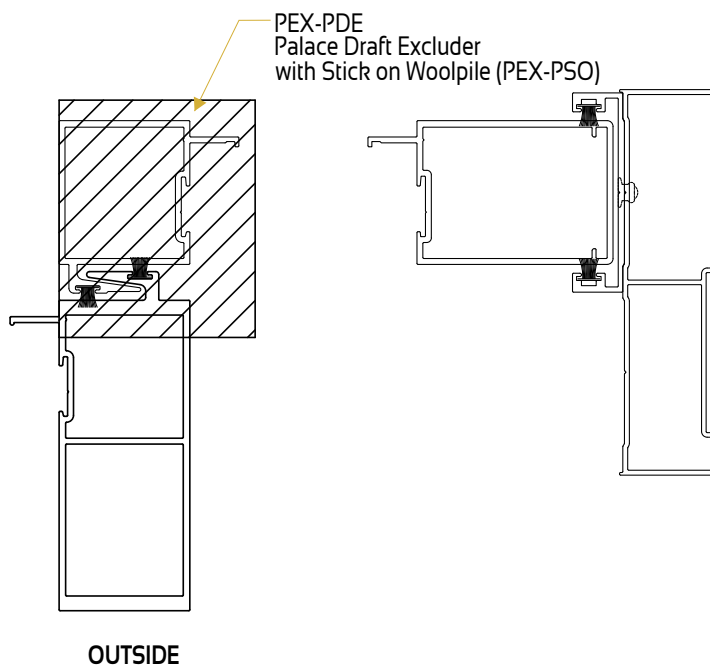
ITEM	QTY	DIE No.	DESCRIPTION
7	1	W38183	Palace M Frame Head Rail Add On
8	1	W38184	Palace M Frame Sill Rail Add On

PEX-PDE  
Palace Draft Excluder with Stick on Woolpile (PEX-PSO)  
To be fitted under the interlockers as shown.

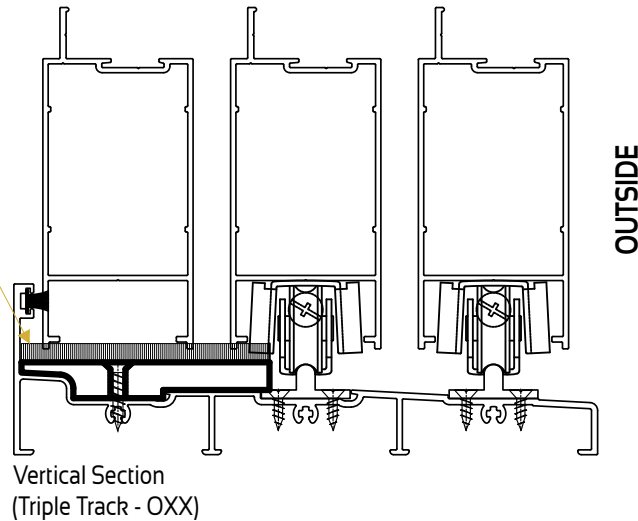
PEX-PDE  
Palace Draft Excluder  
with Stick on Woolpile (PEX-PSO)  
(for OX)



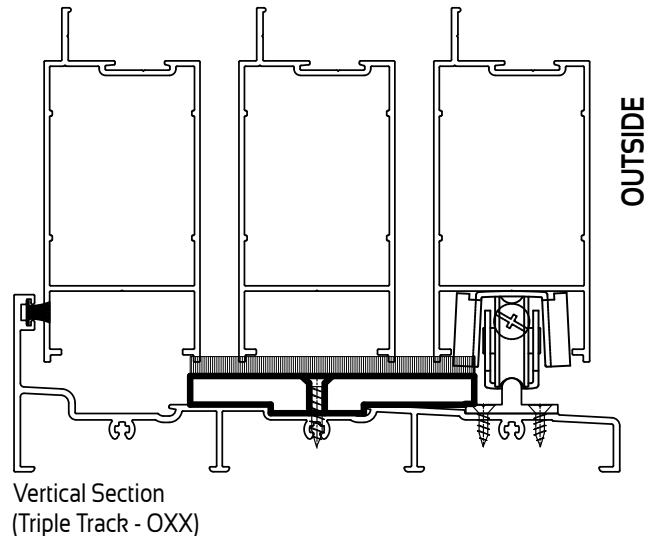
Horizontal Section  
(2 Panel Configuration)



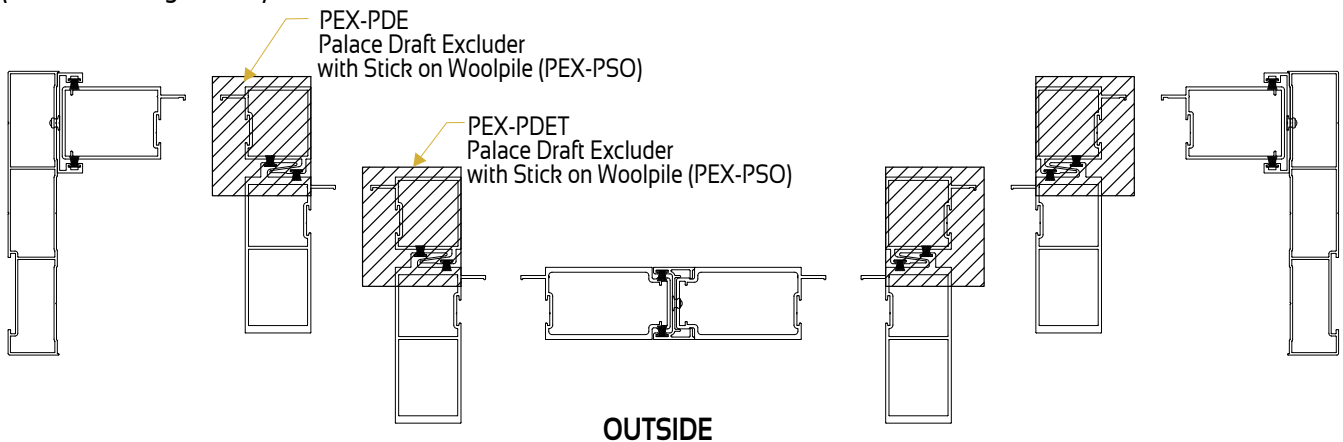
PEX-PDE  
Palace Multi Draft Excluder  
with Stick on Woolpile  
(PEX-PSO)



PEX-PDET  
Palace Multi Draft Excluder Tri Track  
with Stick on Woolpile (PEX-PSO)

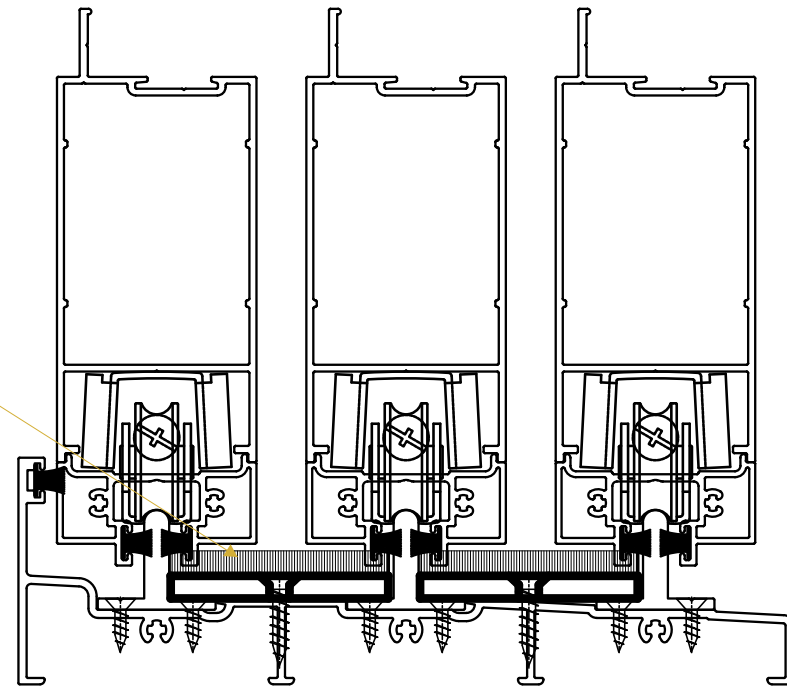


Horizontal Section B-B  
(6 Panel Configuration)



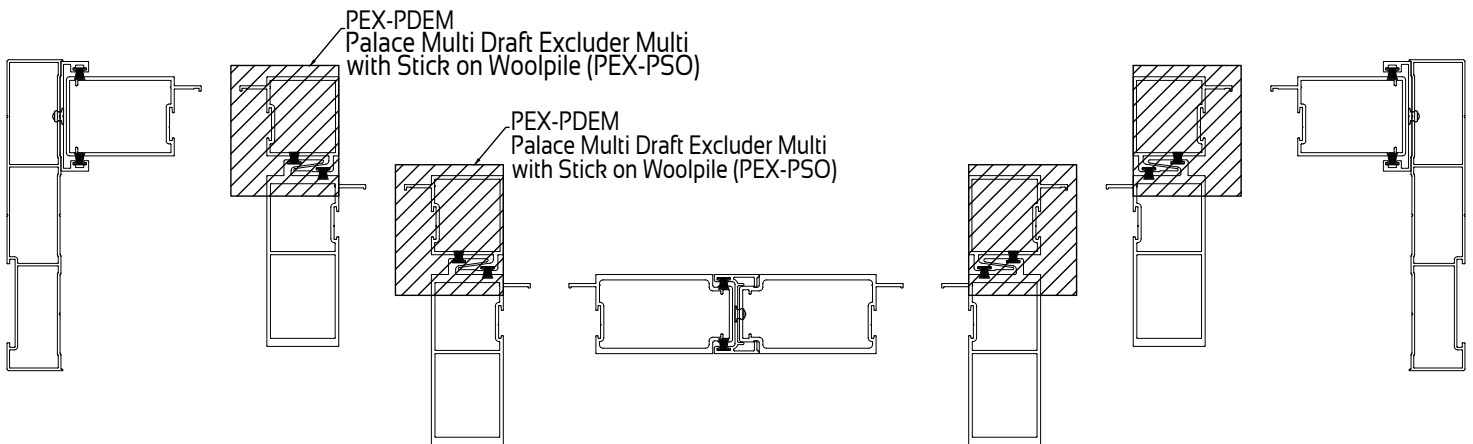


PEX-PDEM  
Palace Multi Draft Excluder Multi  
with Stick on Woolpile (PEX-PSO)



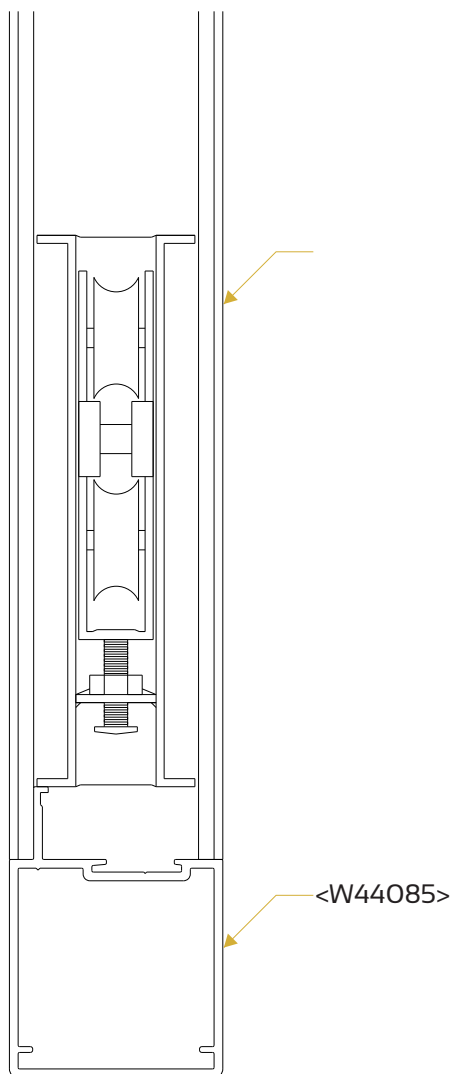
Vertical Section  
(Triple Track - XXX)

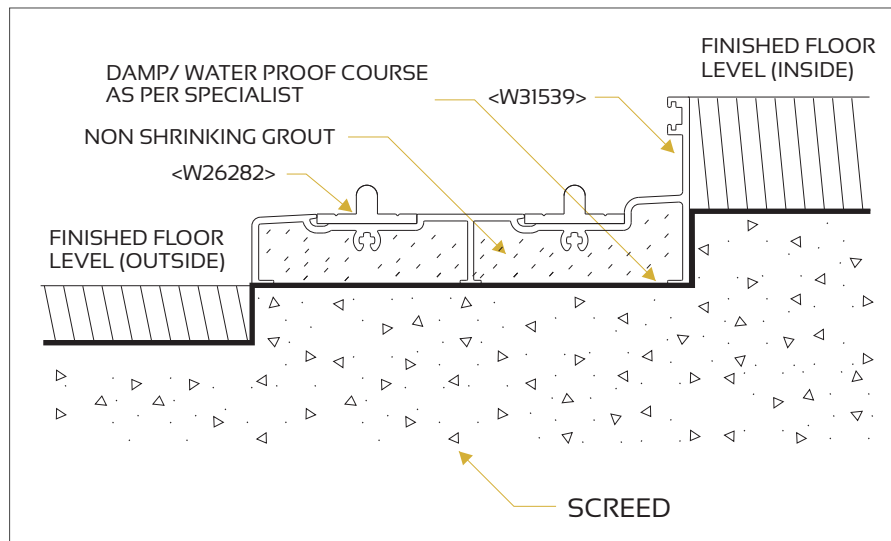
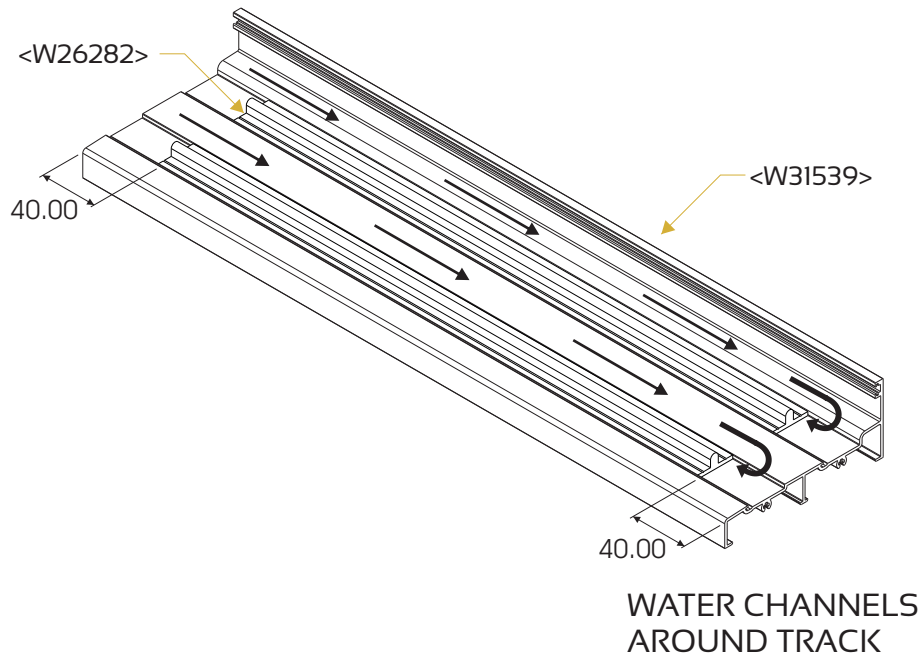
Horizontal Section B-B  
(6 Panel Configuration)

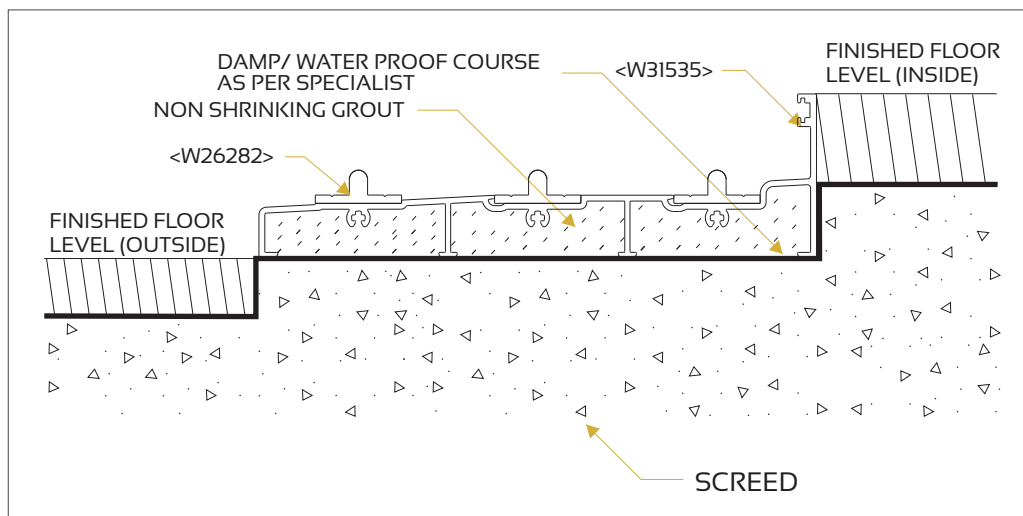
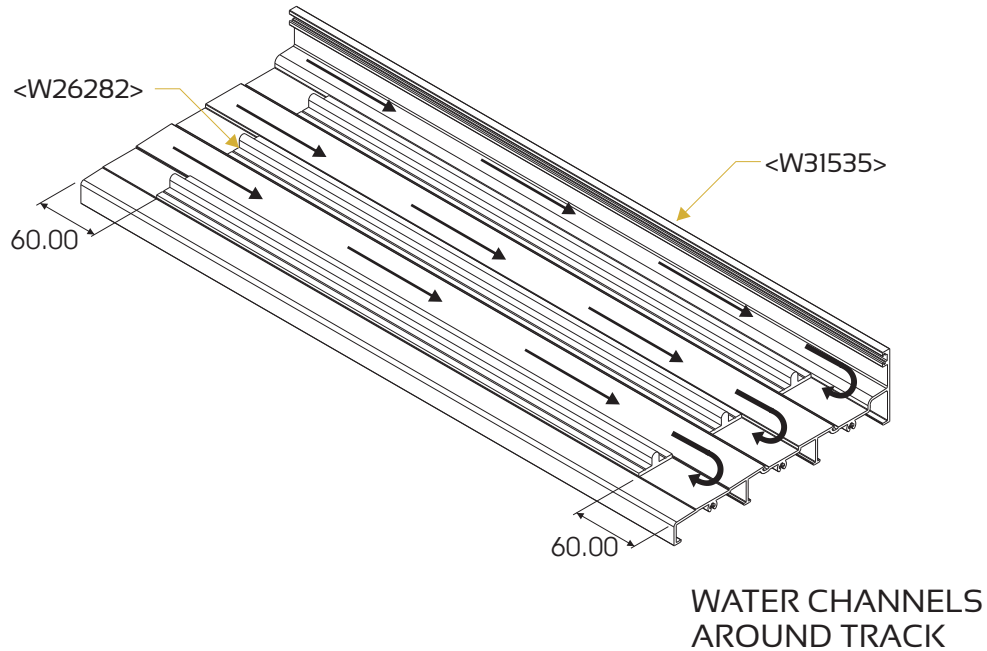


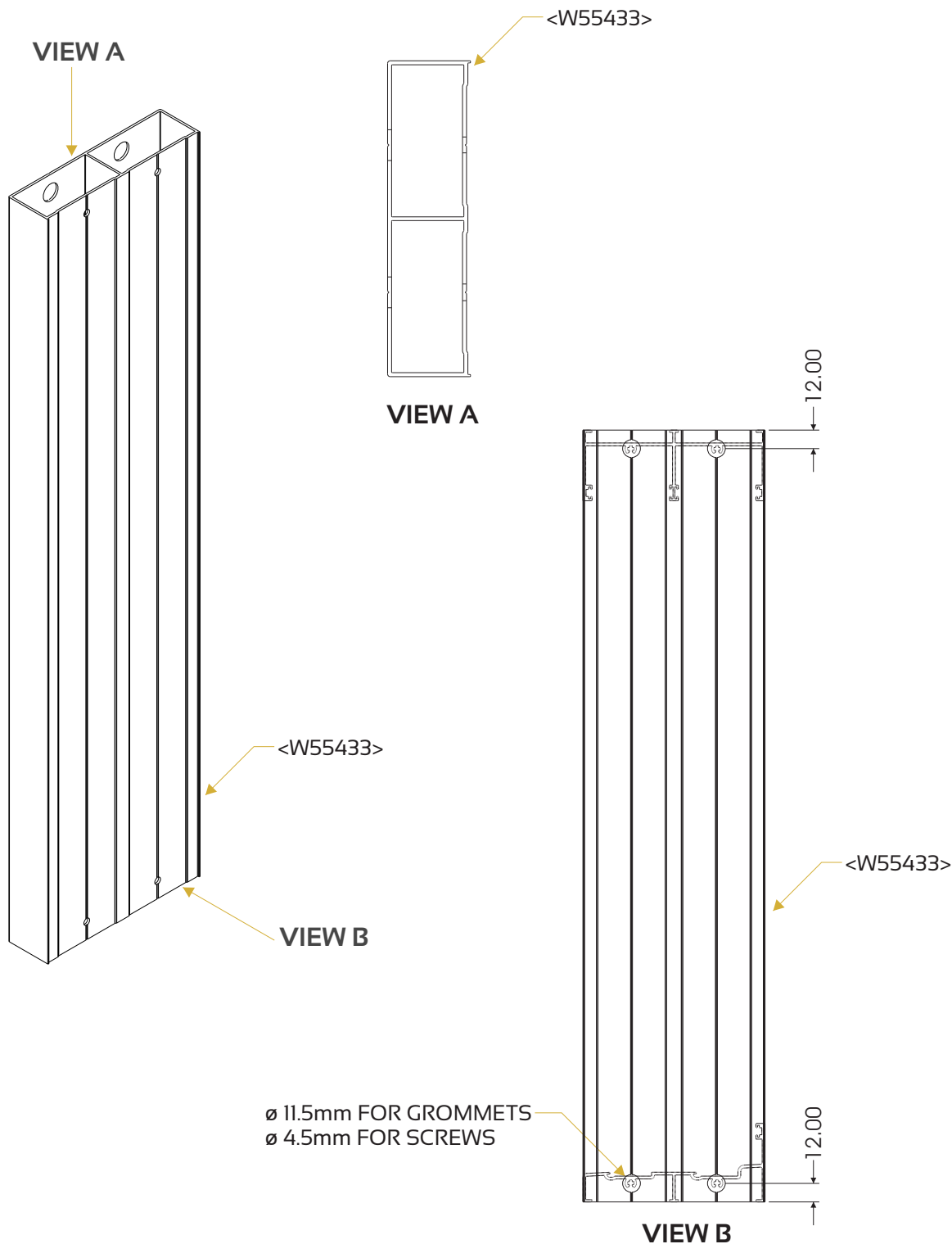
OUTSIDE

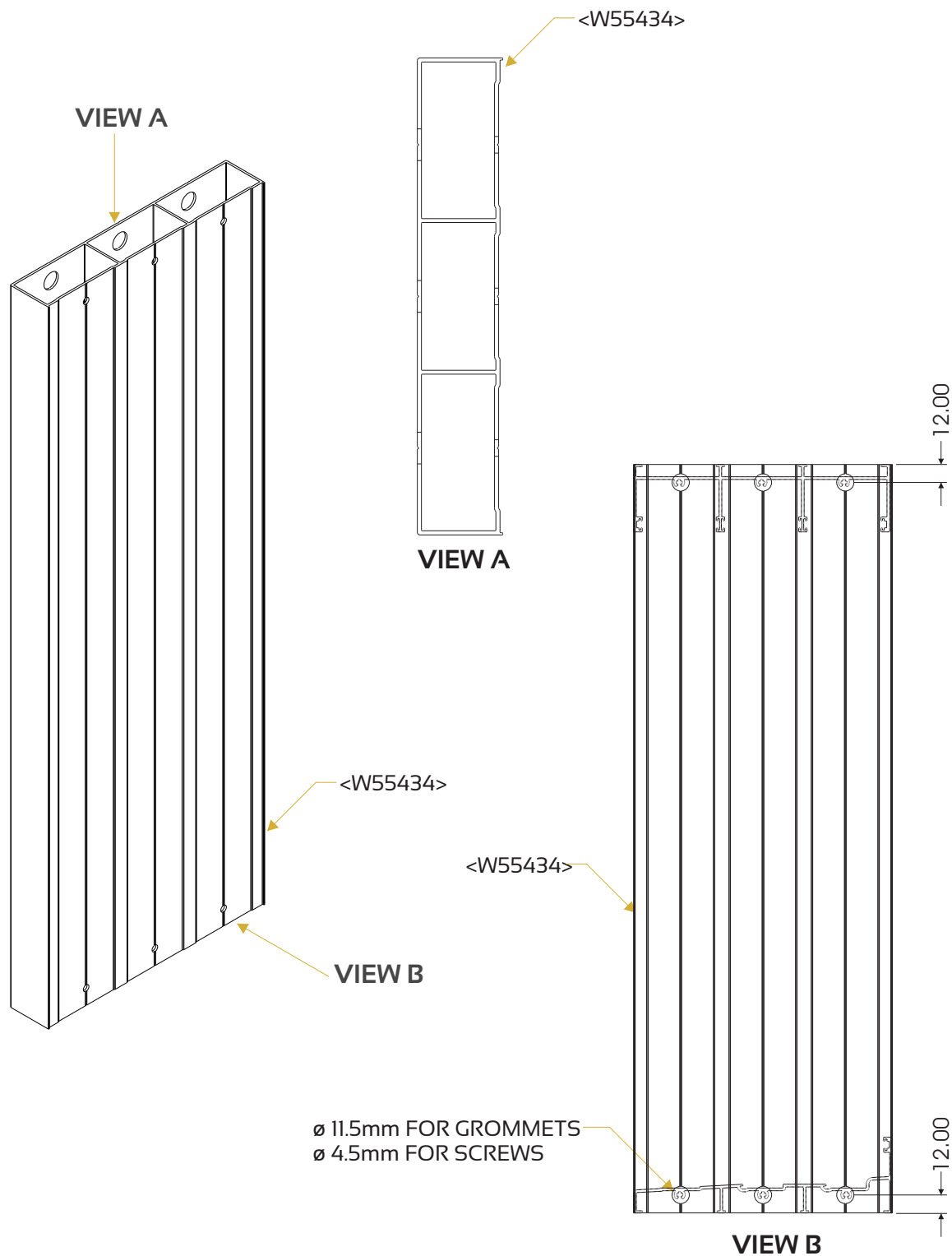
Crealco Tandum  
Roller<W44088>  
<ROLL91ISS> FIXED  
AGAINST <W44085>



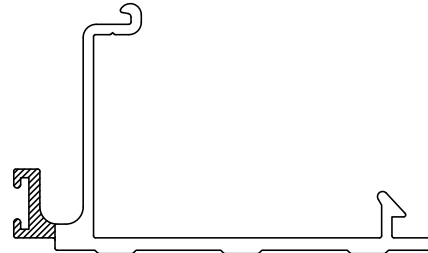






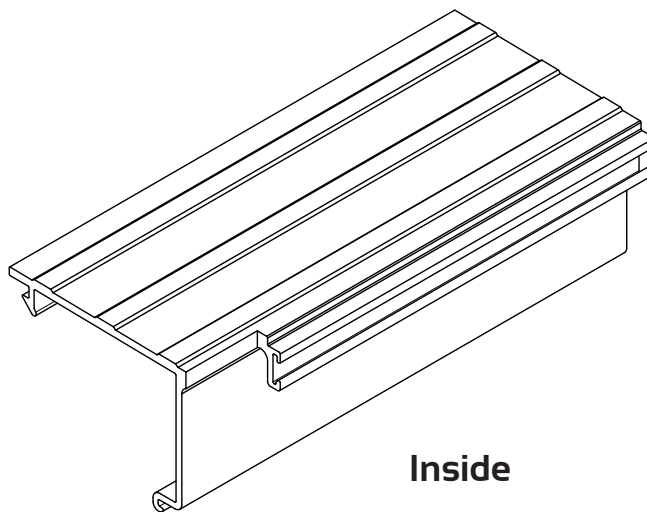


**NOTE:** The Palace M Frame Sill Cover 33mm High can only be used in conjunction with the Palace M Sill Rails 50mm High. The machining of this Sill Cover is applicable for the Palace M Adaptor Jamb 14mm Deep.

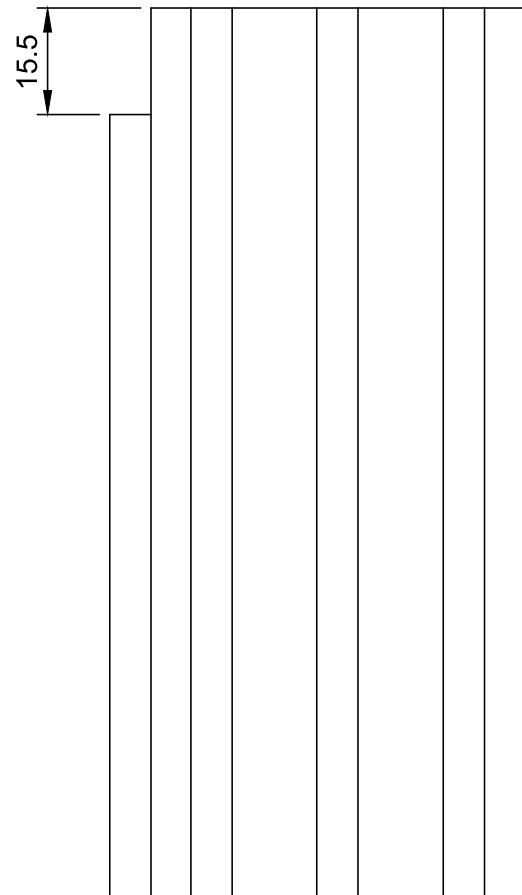


**W31538**

Palace M Frame Sill Cover 33mm High

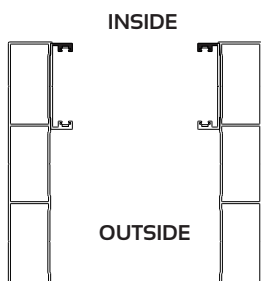


**Inside**

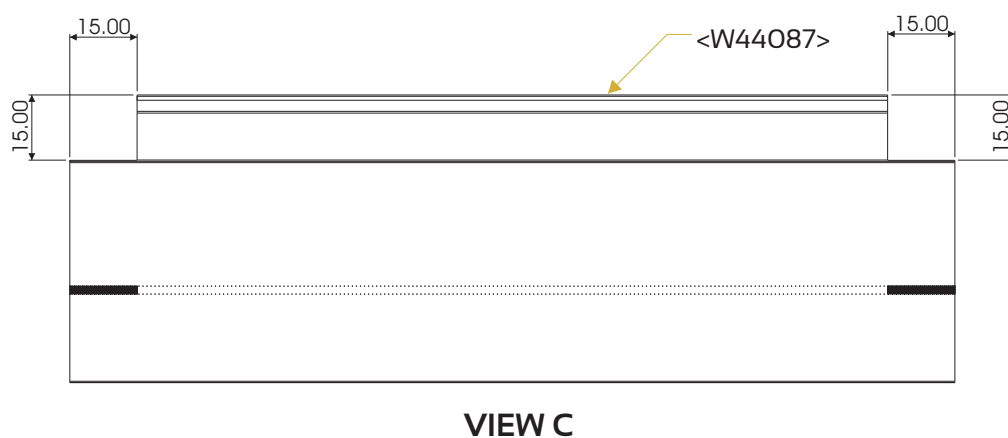
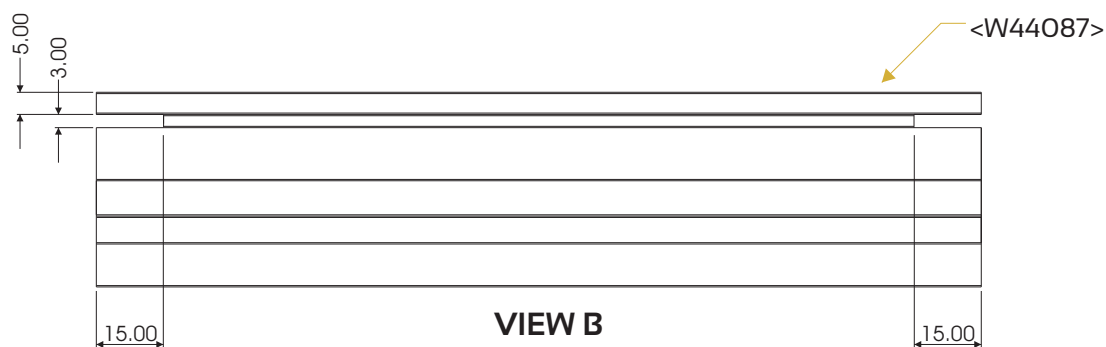
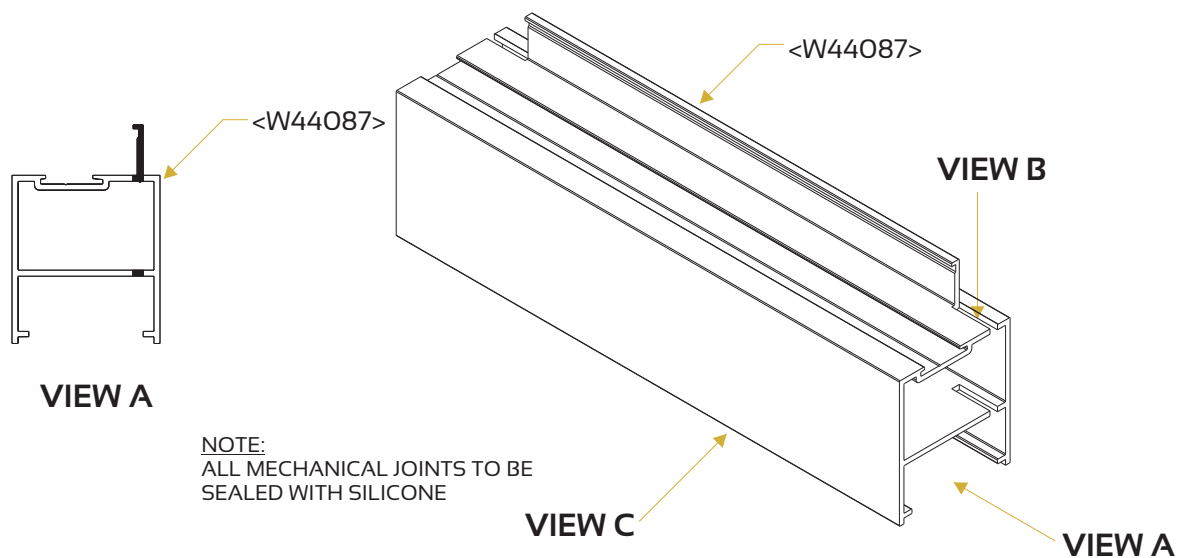




OXXXXO & 6 PANEL MULTI  
SLIDER = BOTH SIDES

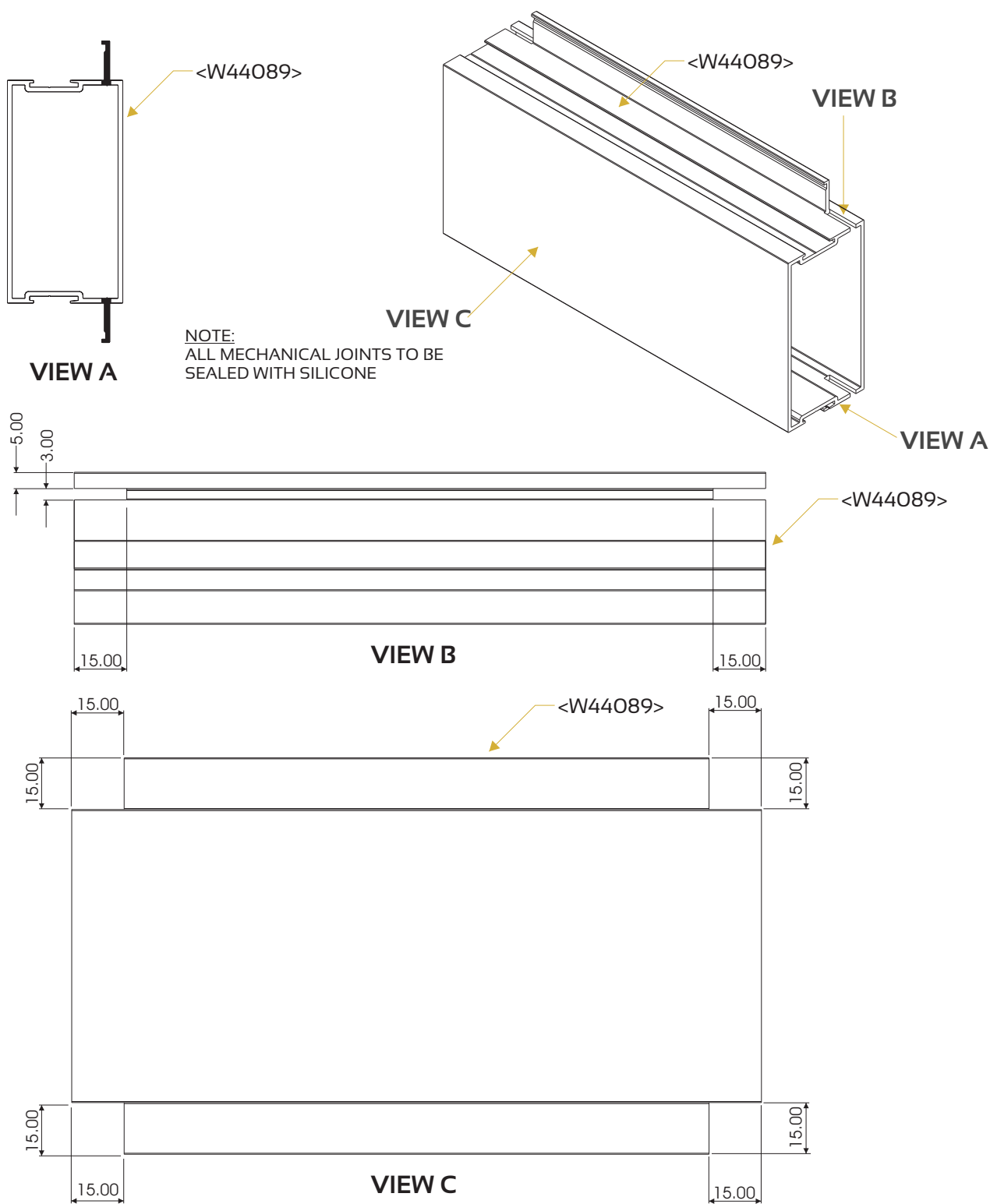


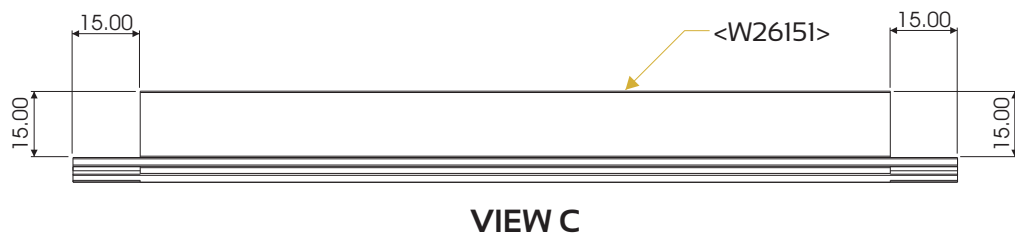
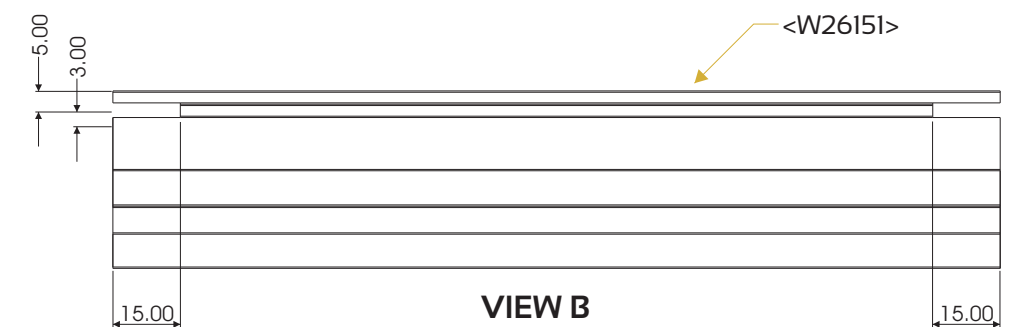
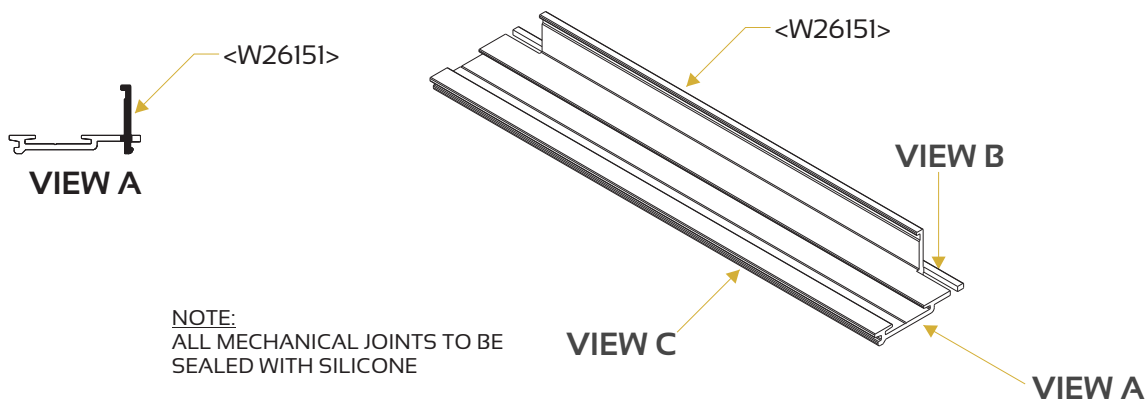


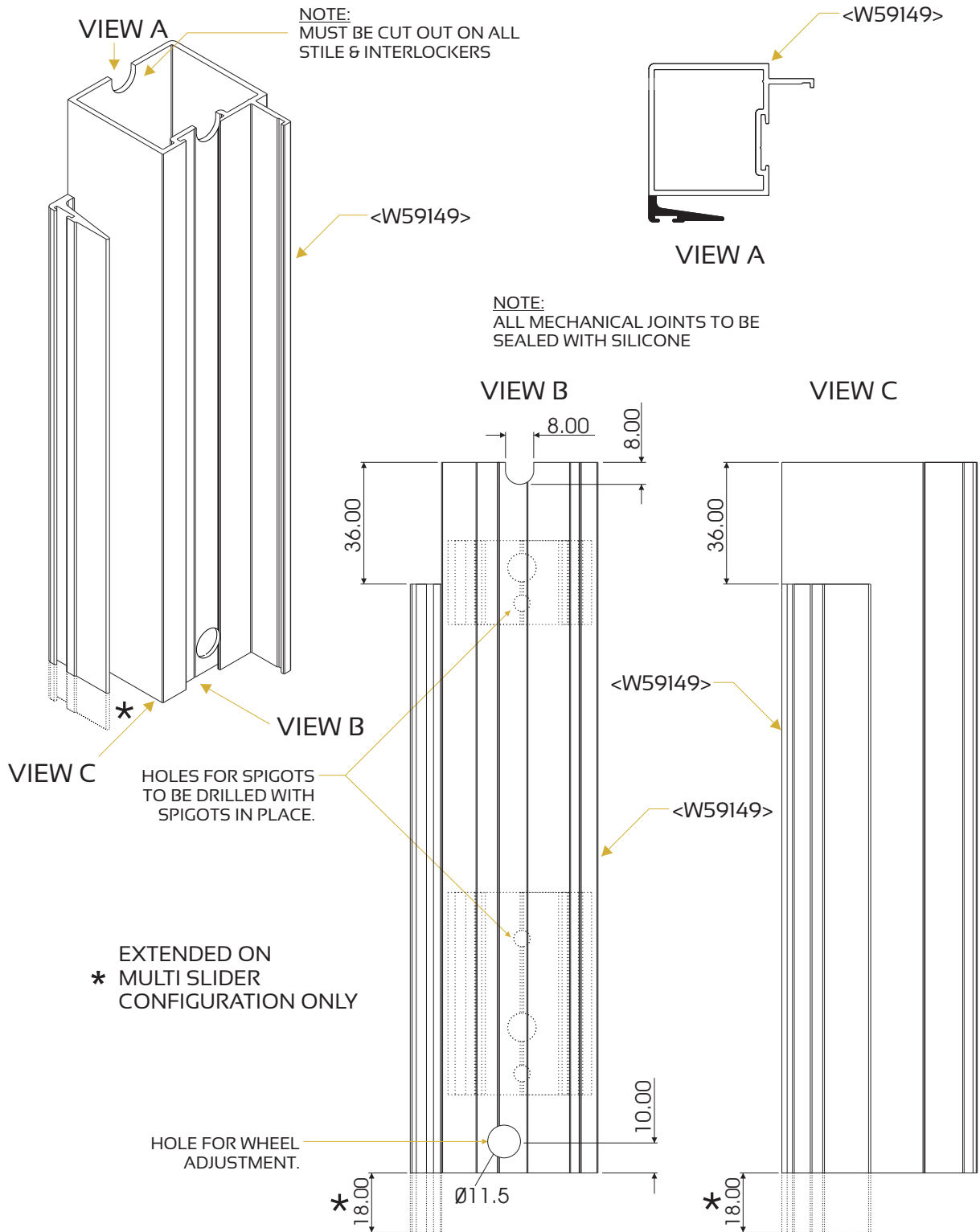


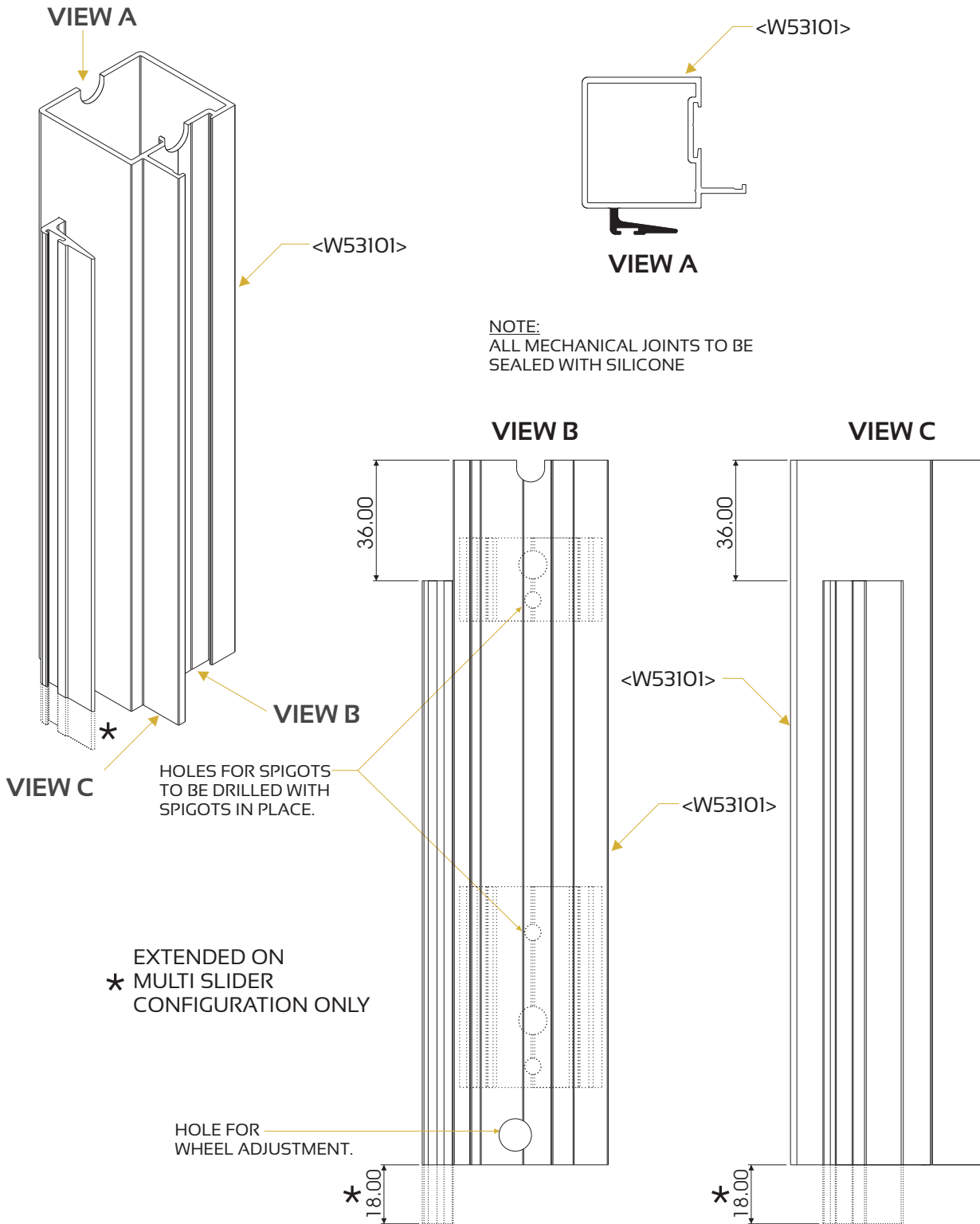
## Machining Detail

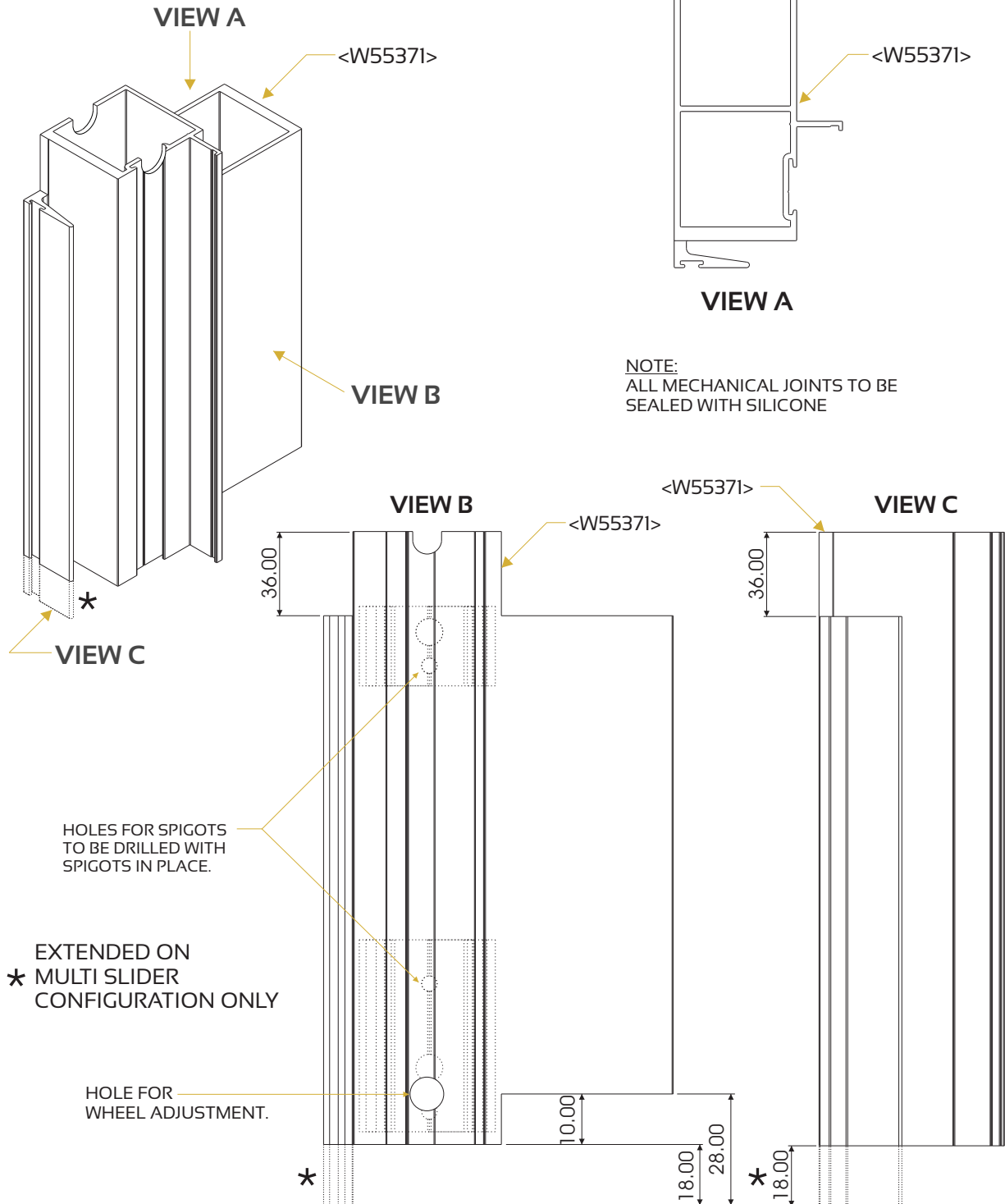
## Midrail to Suit all Combinations

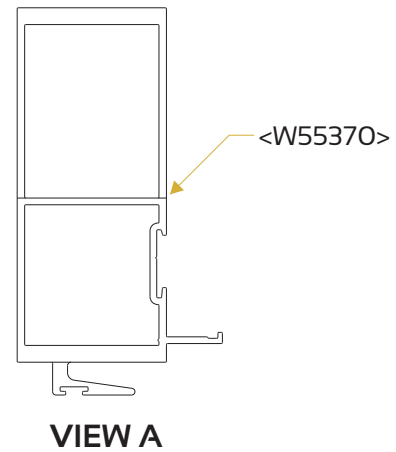
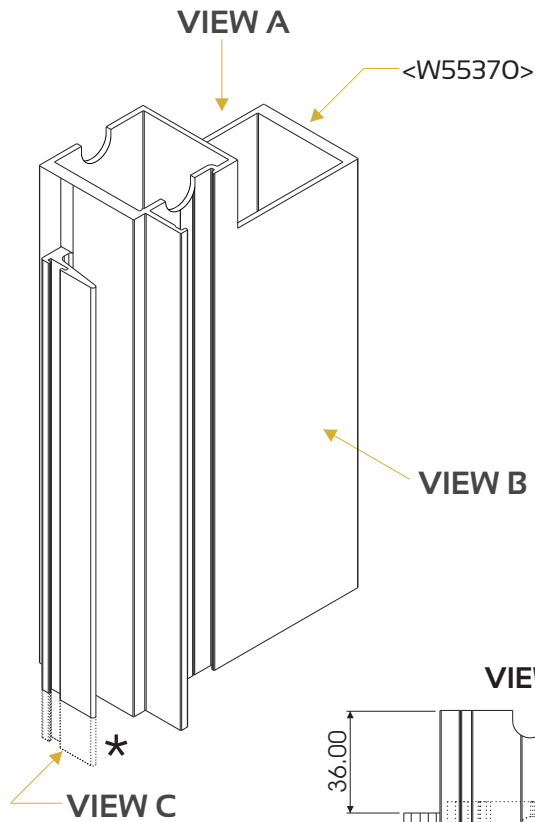




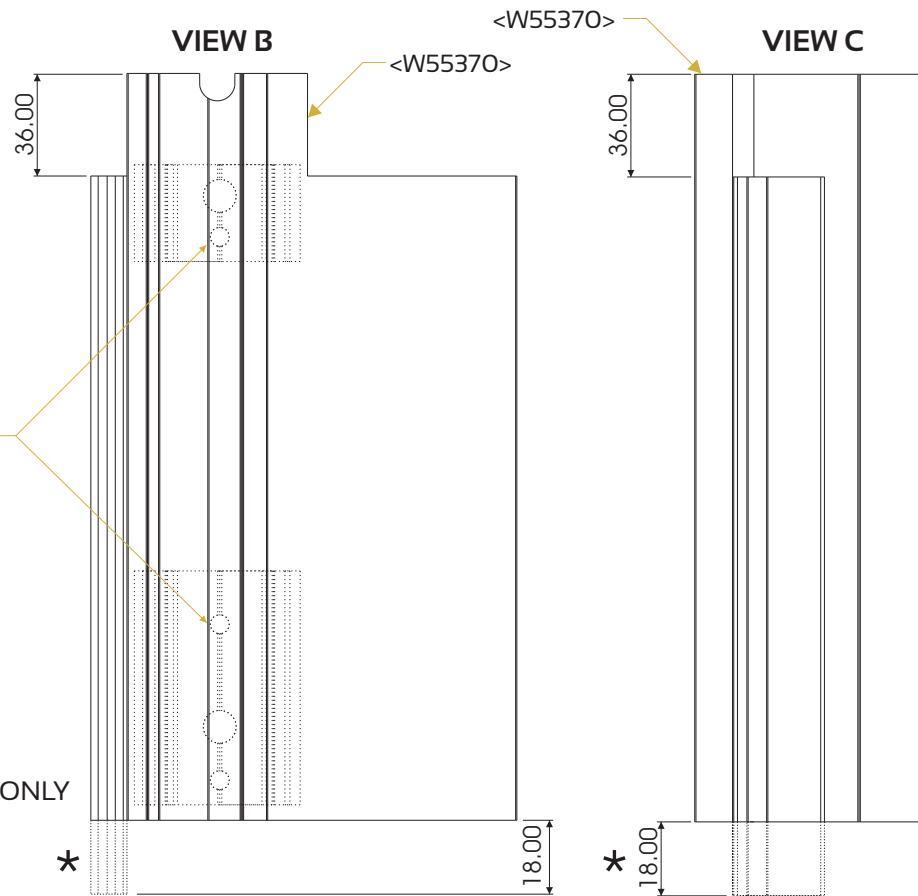


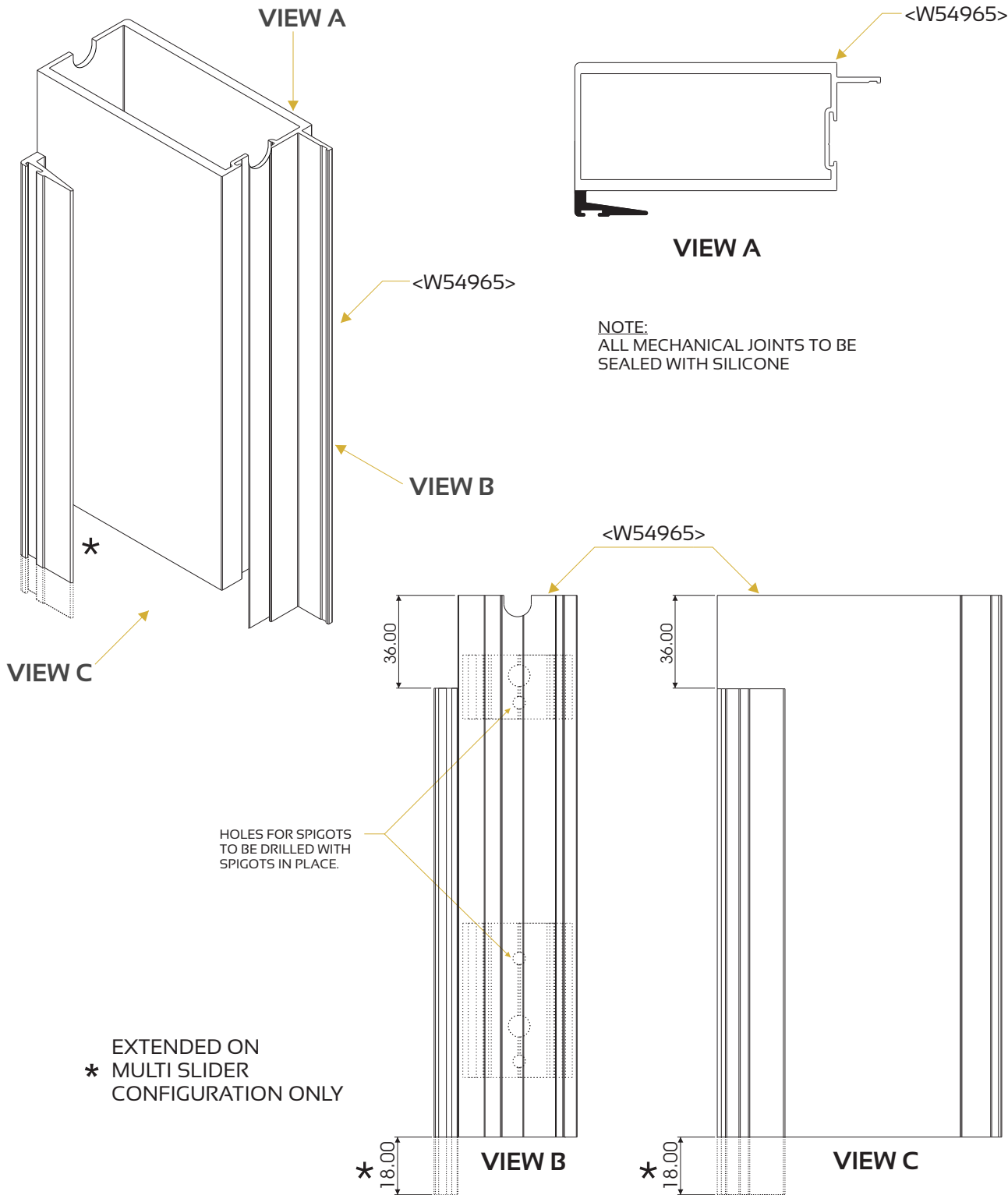




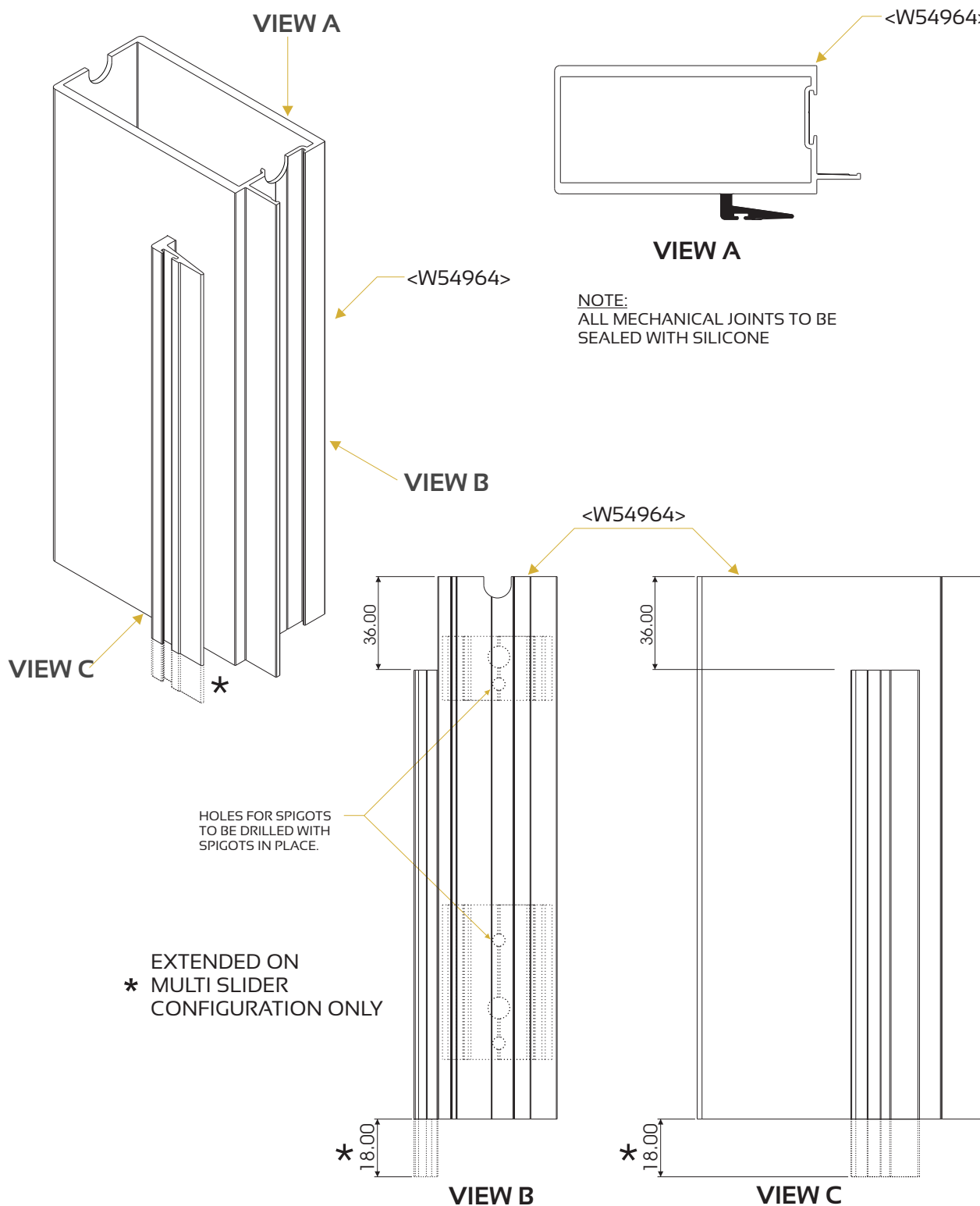


**NOTE:**  
ALL MECHANICAL JOINTS TO BE SEALED WITH SILICONE

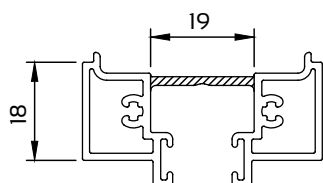
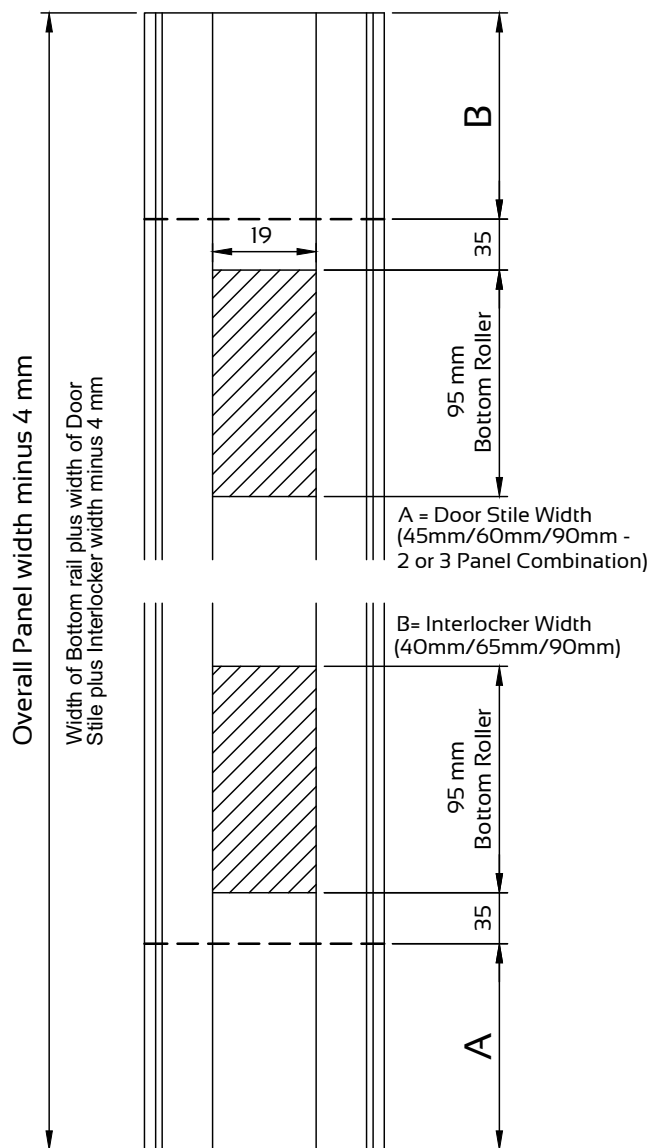






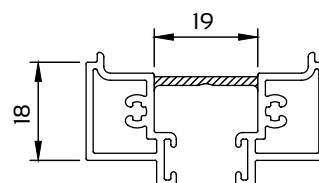
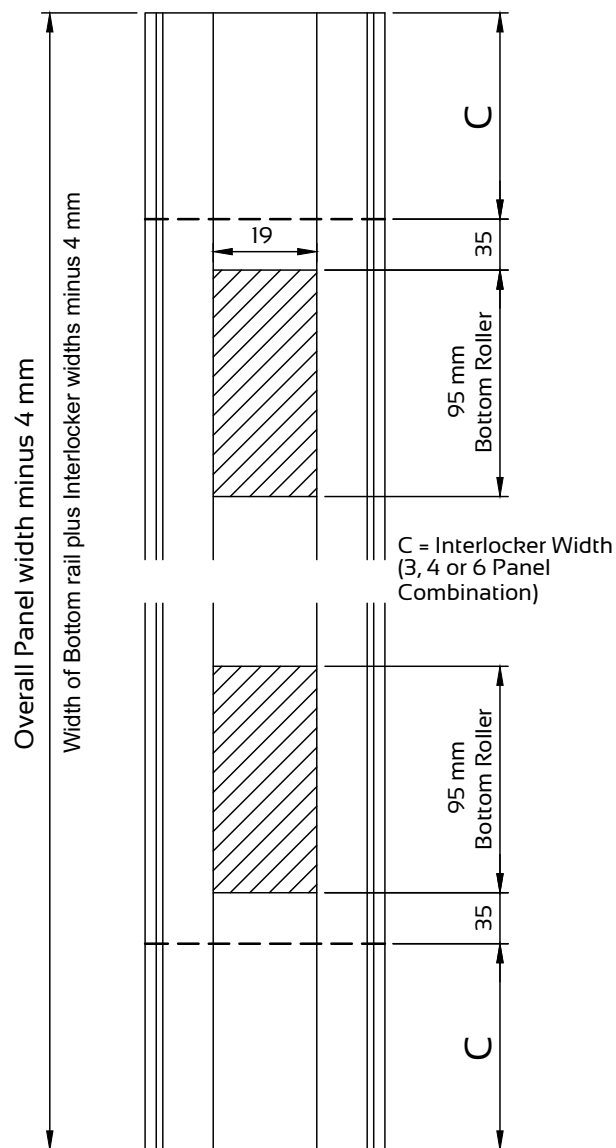


#### 2 or 3 Panel Combination



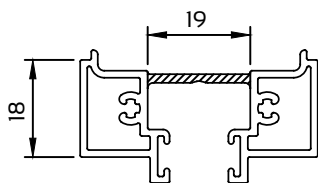
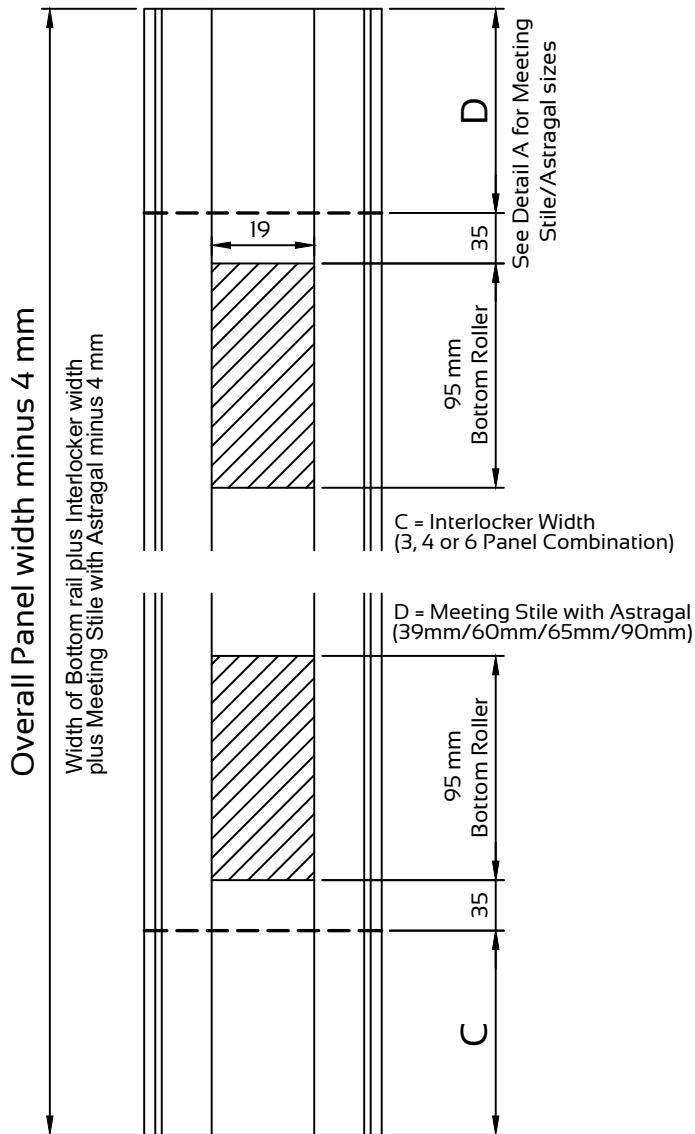
**W58916**  
Palace Multi Sill Extension

#### 3, 4 or 6 Panel Combination



**W58916**  
Palace Multi Sill Extension

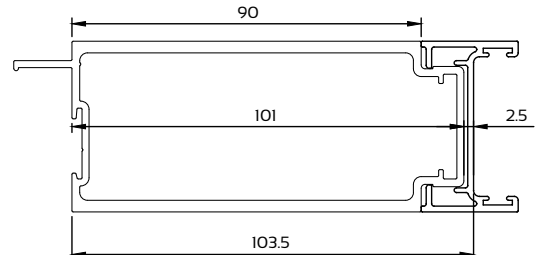
#### 3, 4 or 6 Panel Combination



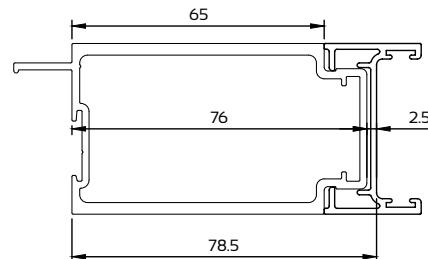
**W58916**  
Palace Multi Sill Extension

#### Detail A

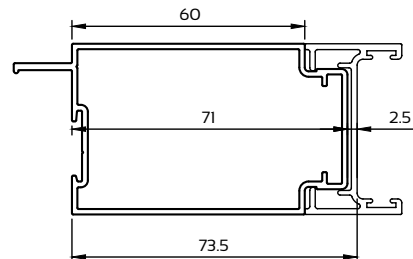
Overall Dimensions to calculate the Sill Extension width on the Meeting Stiles  
(Less the 4 mm on both ends for the end caps)



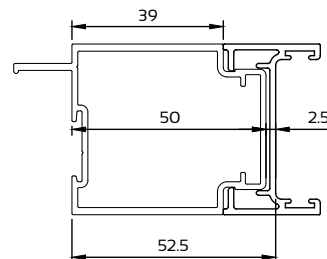
**W54966**  
Palace Multi Stile Meeting 90 mm



**W56607**  
Palace Multi Stile Meeting 65 mm

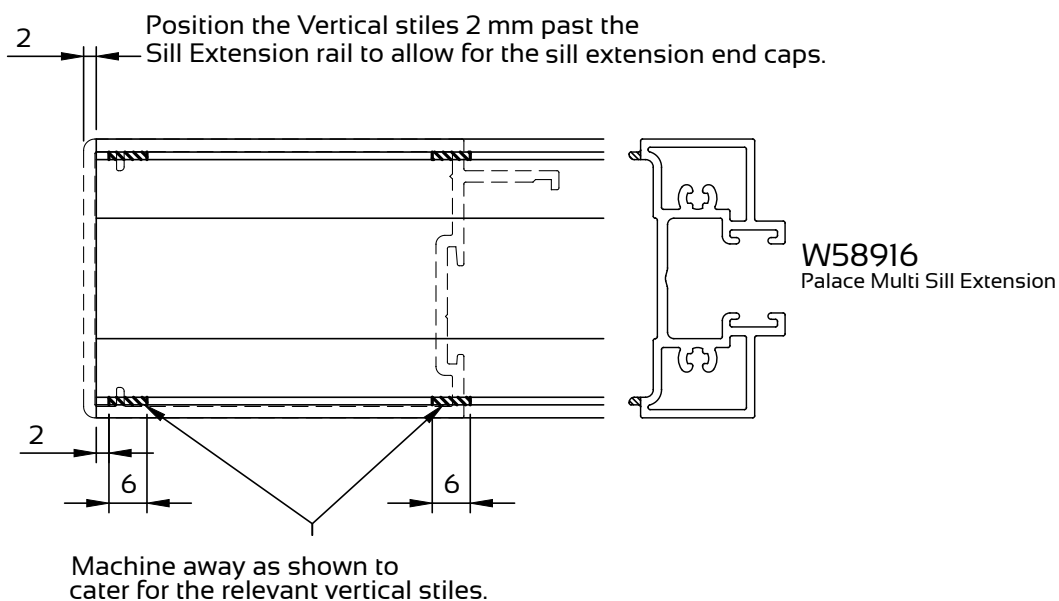


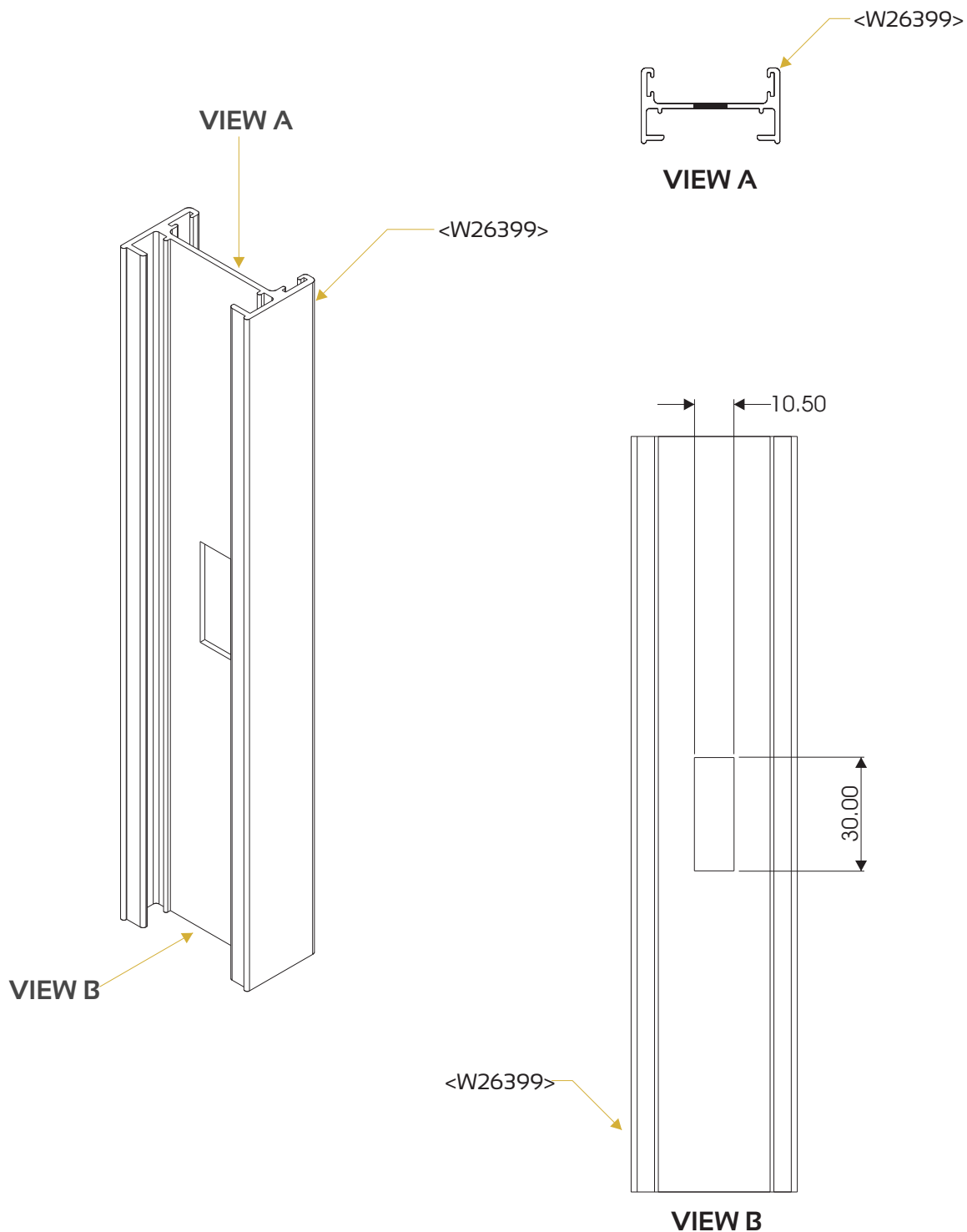
**W58268**  
Palace Multi Stile Meeting 60 mm

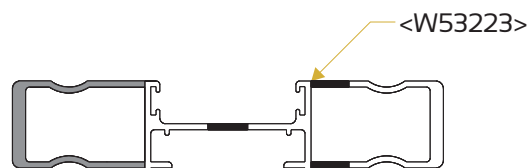
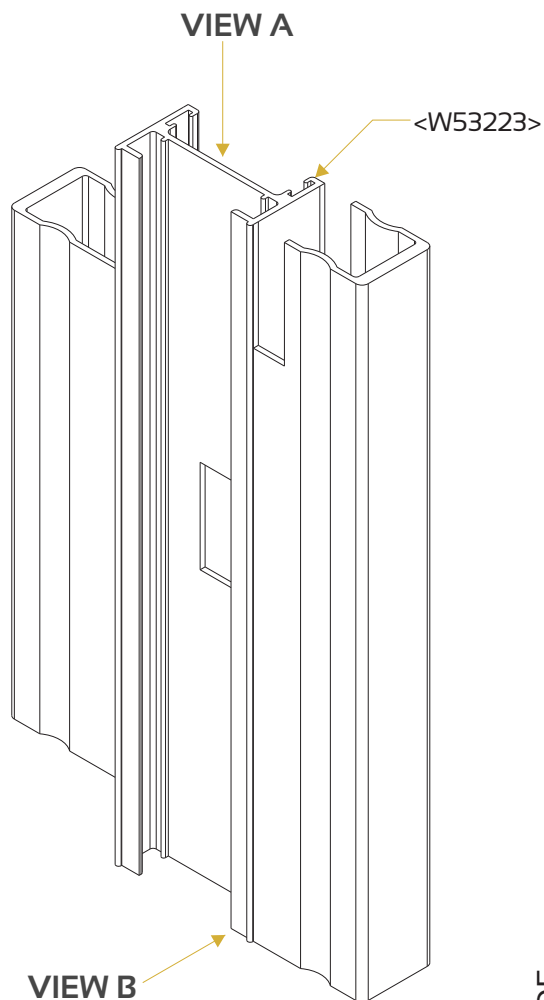


**W53100**  
Palace Multi Stile Meeting 39 mm

#### Position of Vertical stile

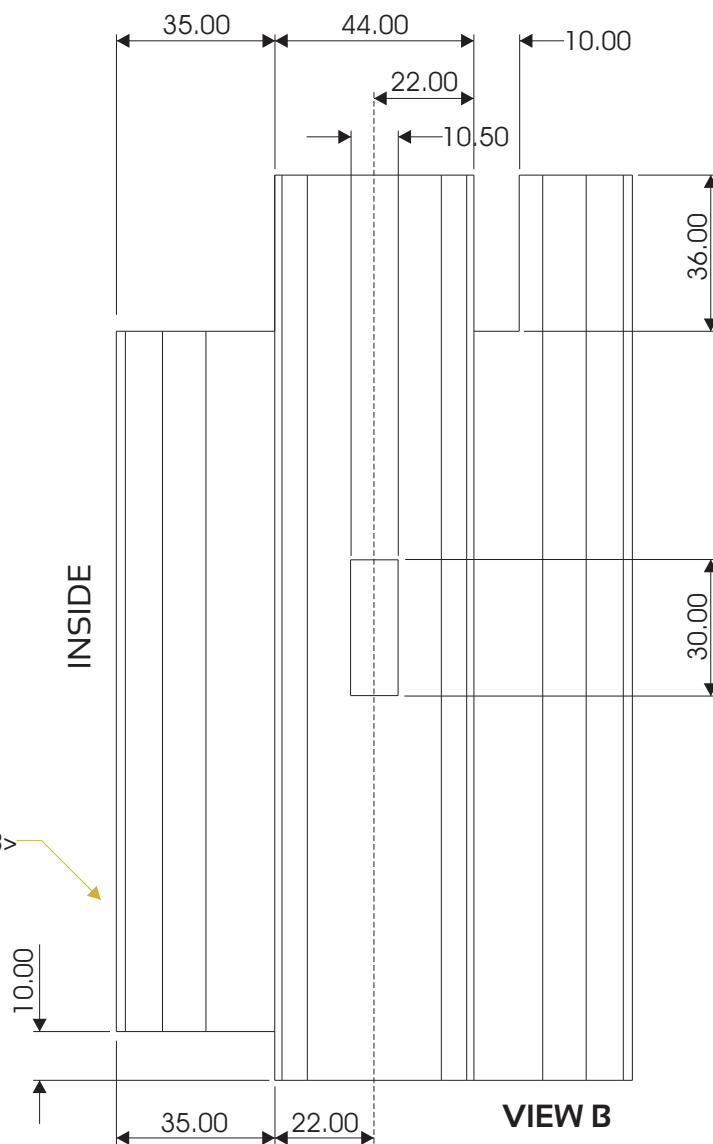


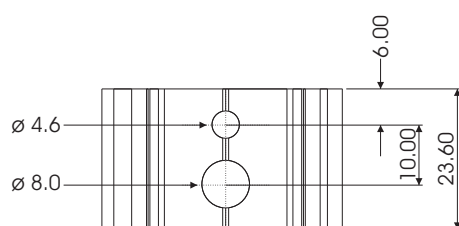
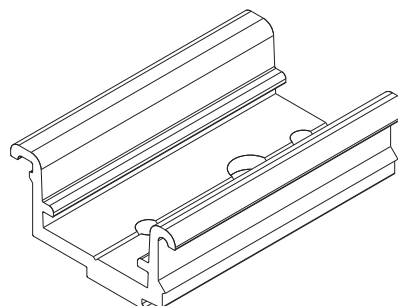
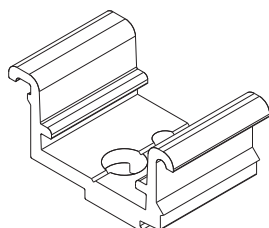




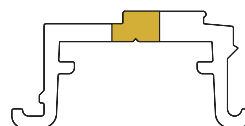
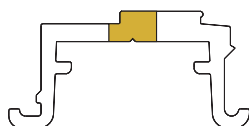
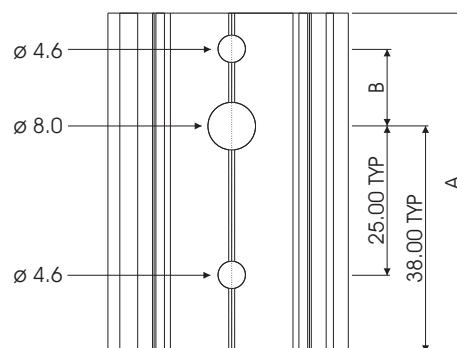
**VIEW A**

NOTE: SHARP MACHINED EDGES  
TO BE ROUNDED TO  
PREVENT UNDUE WOOLPILE  
WEAR.

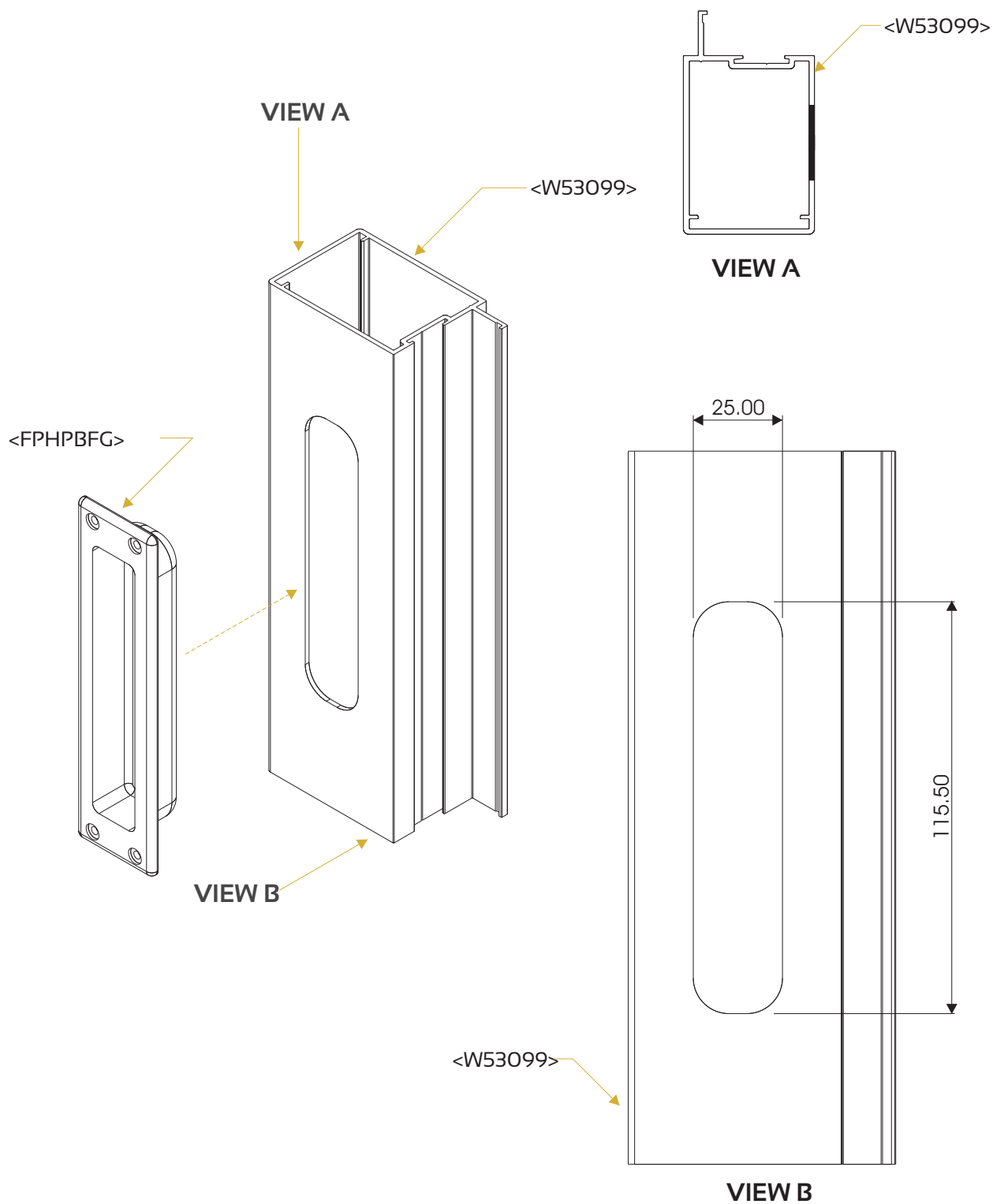




TO ACCEPT <W44087>  
HEAD RAIL



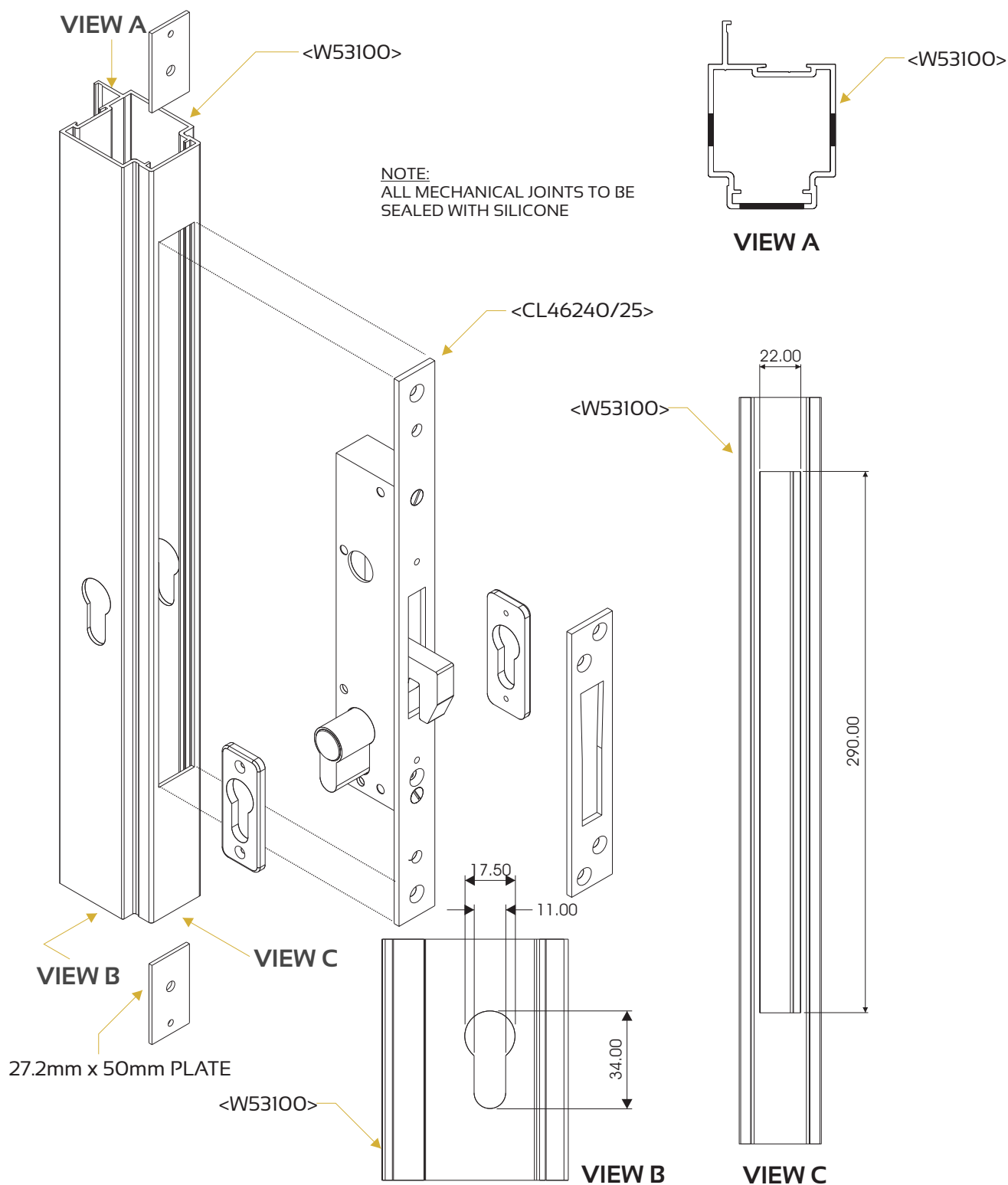
SECTION	DIM A	DIM B
<W44088> BOTTOM RAIL	56.8	11
<W44094> BOTTOM RAIL	123.2	50
<W44089> MIDRAIL	76	30





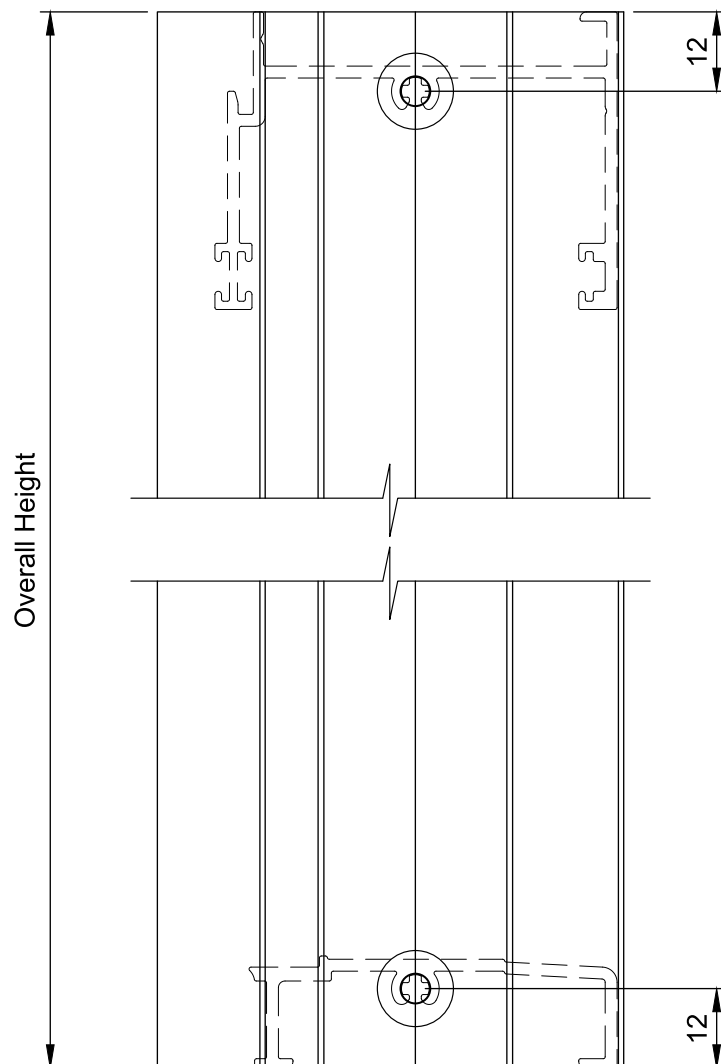
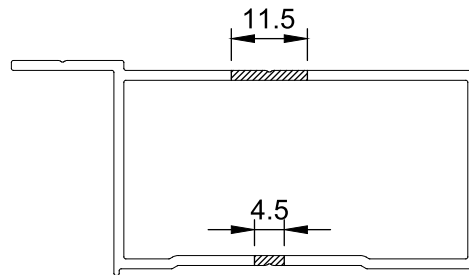
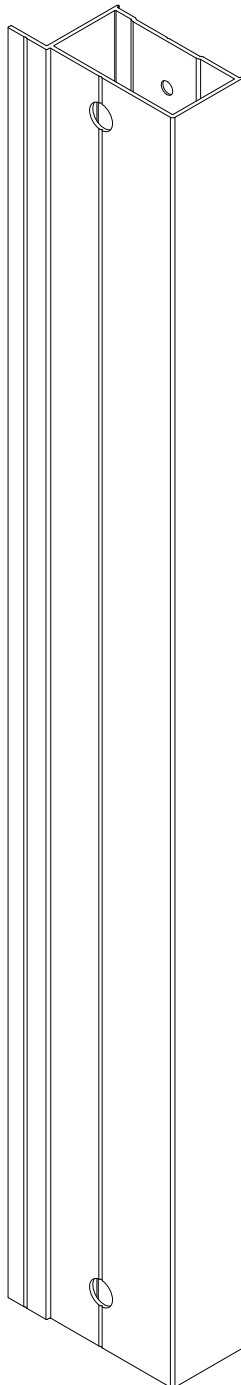
## Machining Detail

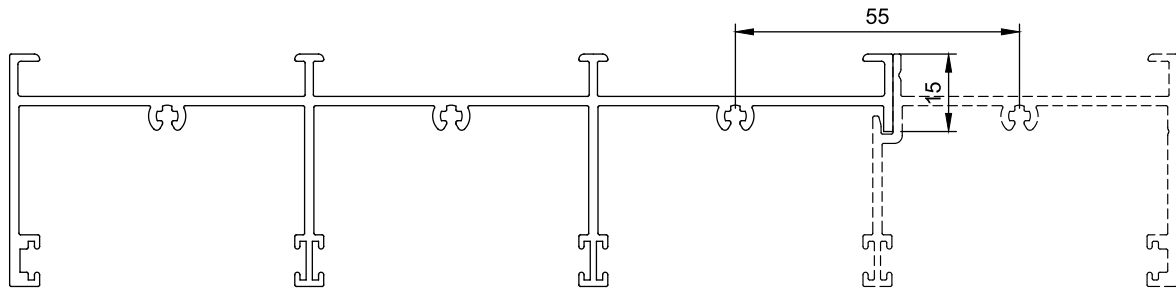
Lock on Meeting Stile



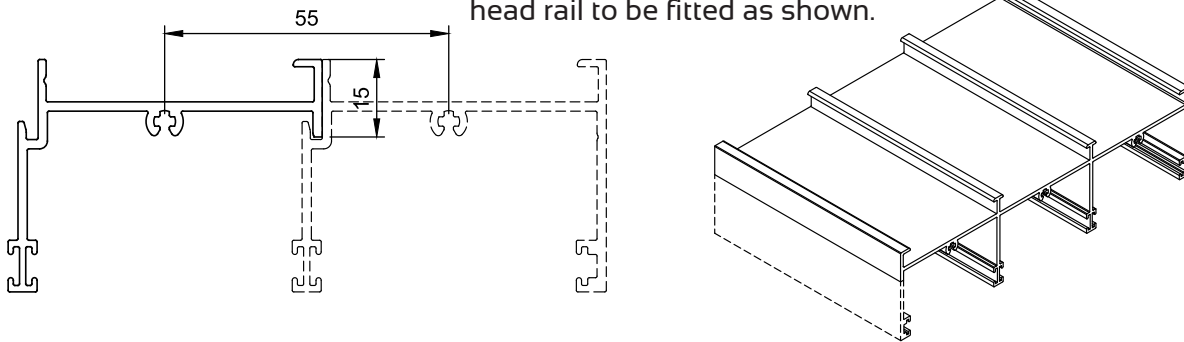
#### W59254

Palace M Frame Jamb Add On

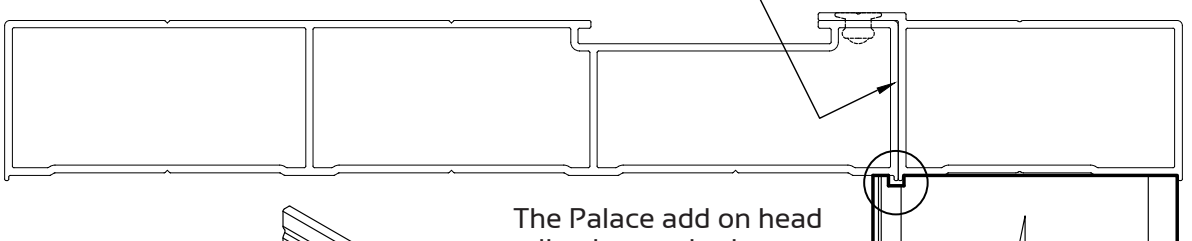




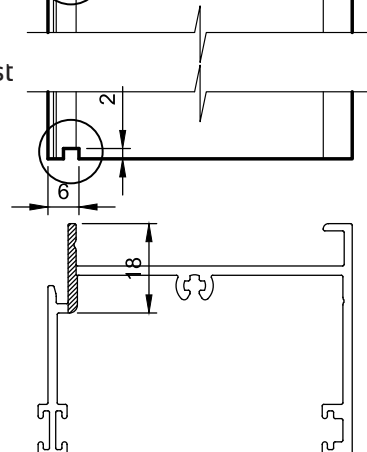
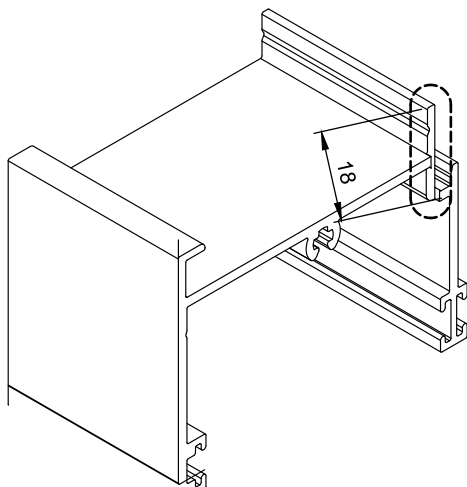
The Palace double, triple head rail and the Palace add on head rail all require to be machined along the full length of the head rail for the add on head rail to be fitted as shown.



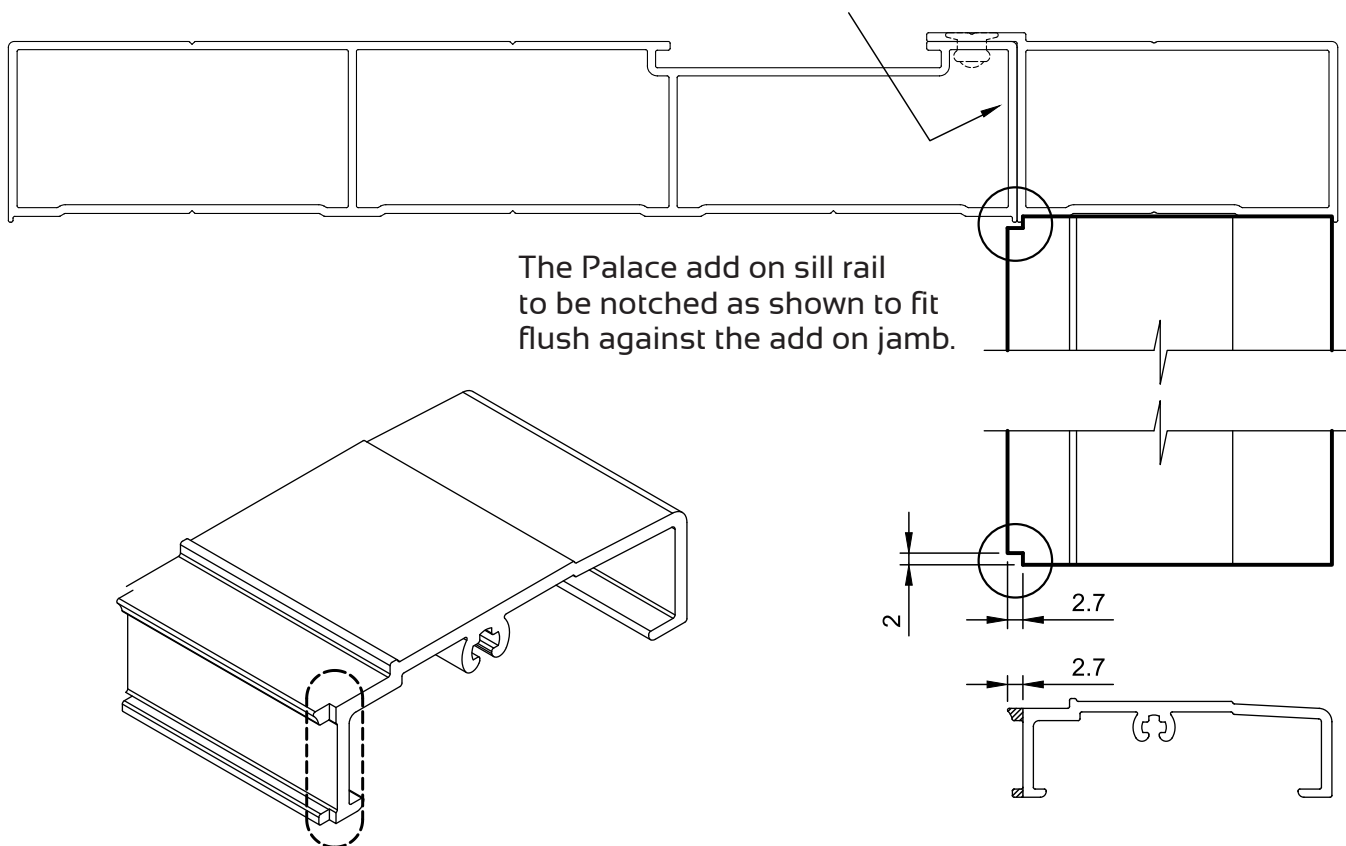
Silicone Sealant to be applied before fitting the add on jamb to the standard jamb.



The Palace add on head rail to be notched as shown to fit flush against the add on jamb.

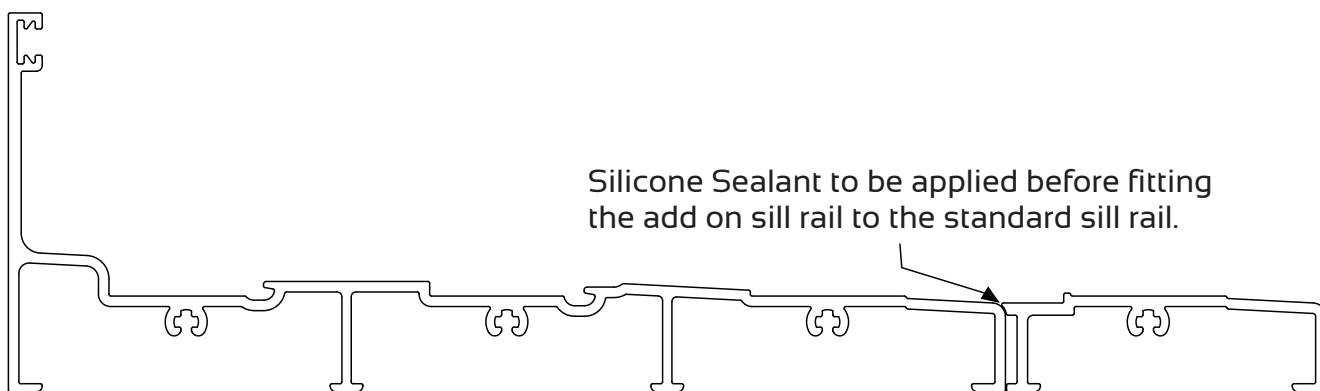


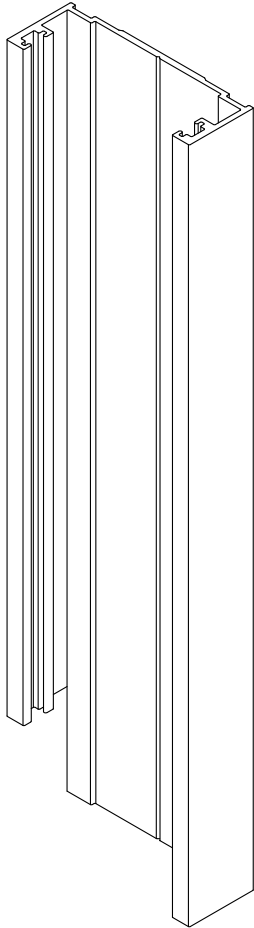
Silicone Sealant to be applied before fitting the add on jamb to the standard jamb.



The Palace add on sill rail to be notched as shown to fit flush against the add on jamb.

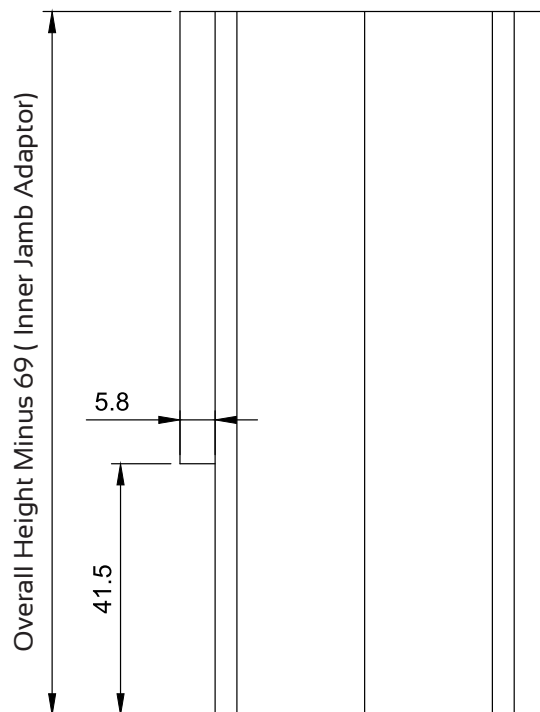
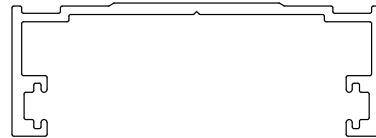
Silicone Sealant to be applied before fitting the add on sill rail to the standard sill rail.





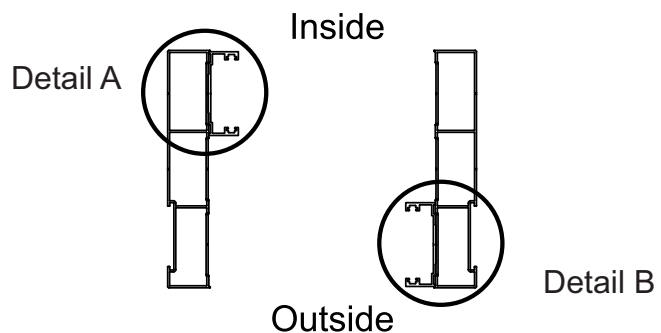
### W37989

Palace M Adaptor Frame Jamb 20mm Deep



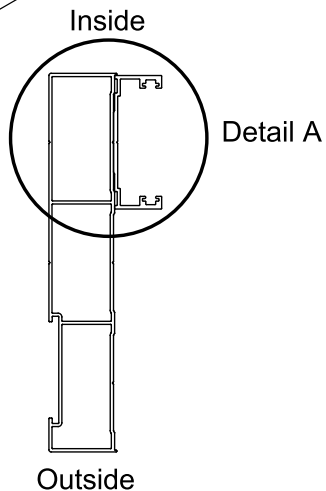
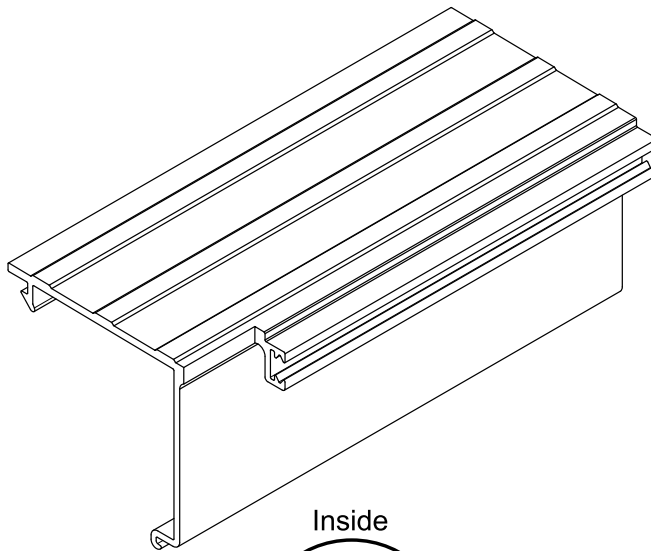
This Jamb adaptor requires machining as shown only when fitted to the inside of the jamb. (See Detail A)

The Outer Jamb adaptor does not require any machining, but needs to be cut 5 mm shorter than the inner jamb adaptor.(See Detail B)



**Note:** Palace M Frame Sill Cover 65mm can only be used in conjunction with the 65mm High sill rails

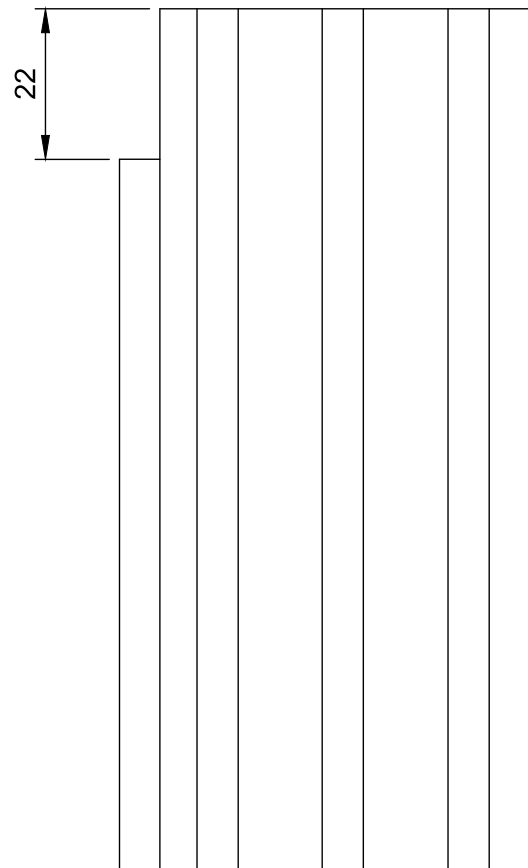
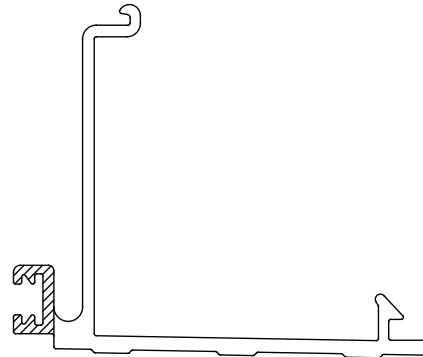
The Sill cover requires machining as shown only when fitting against the Palace M adaptor frame jamb 20mm deep. (See Detail A)

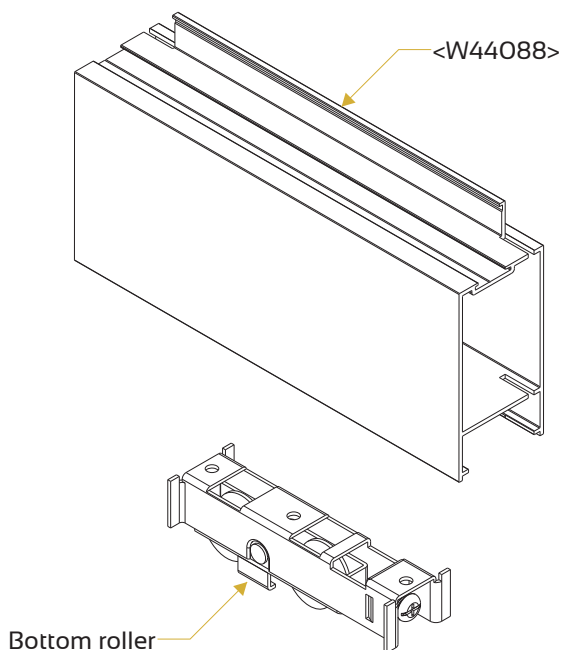


See assembly details for the fitting of the end caps before assembly of the sill cover.

### W37994

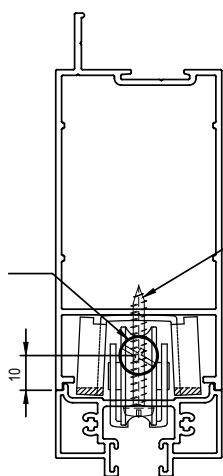
Palace M Frame Sill  
Cover 65mm



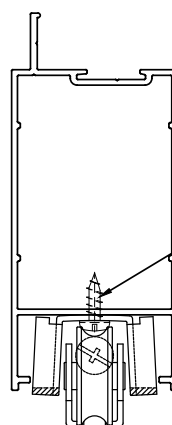


### Sill Detail

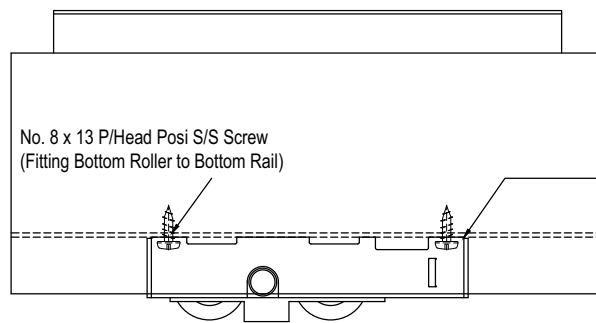
Drill Dia. 10 mm hole on the vertical stiles to access the adjustment screw on the bottom rollers.



No. 8 x 30 P/Head Posi S/S Screw  
(Fitting Sill Extension to Bottom Rail)

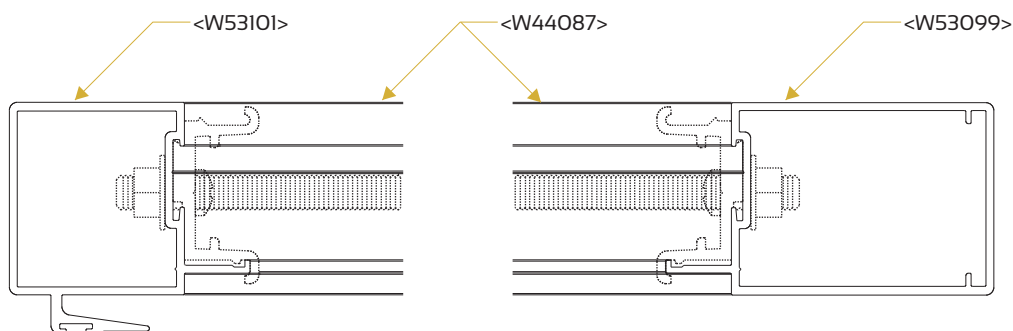
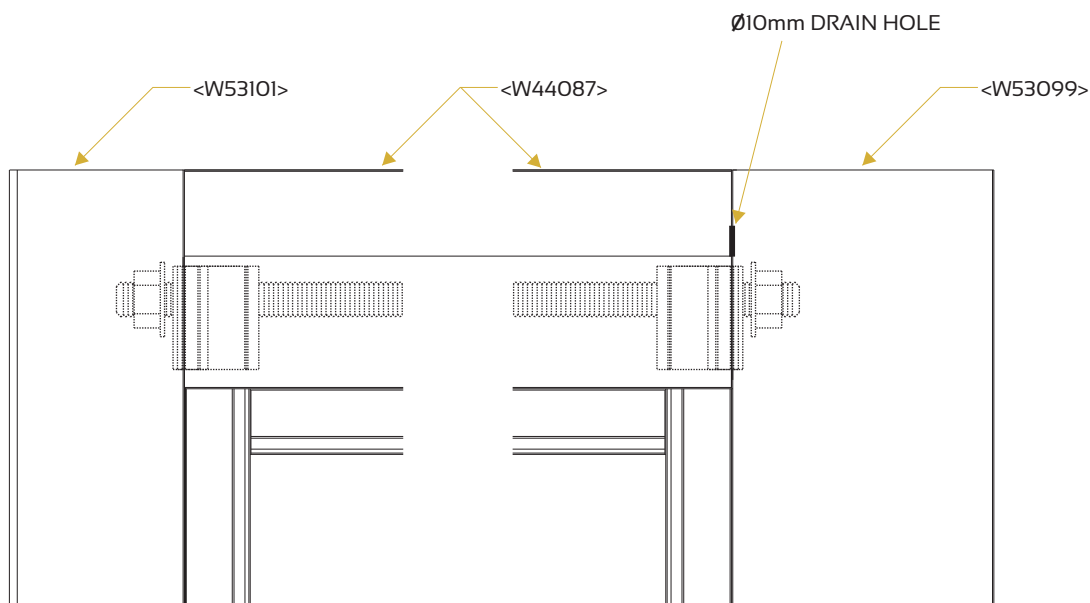


No. 8 x 13 P/Head Posi S/S Screw  
(Fitting Bottom Roller to Bottom Rail)



No. 8 x 13 P/Head Posi S/S Screw  
(Fitting Bottom Roller to Bottom Rail)

RSW-SFTB  
Crealco Tandem Roll  
with Bearing

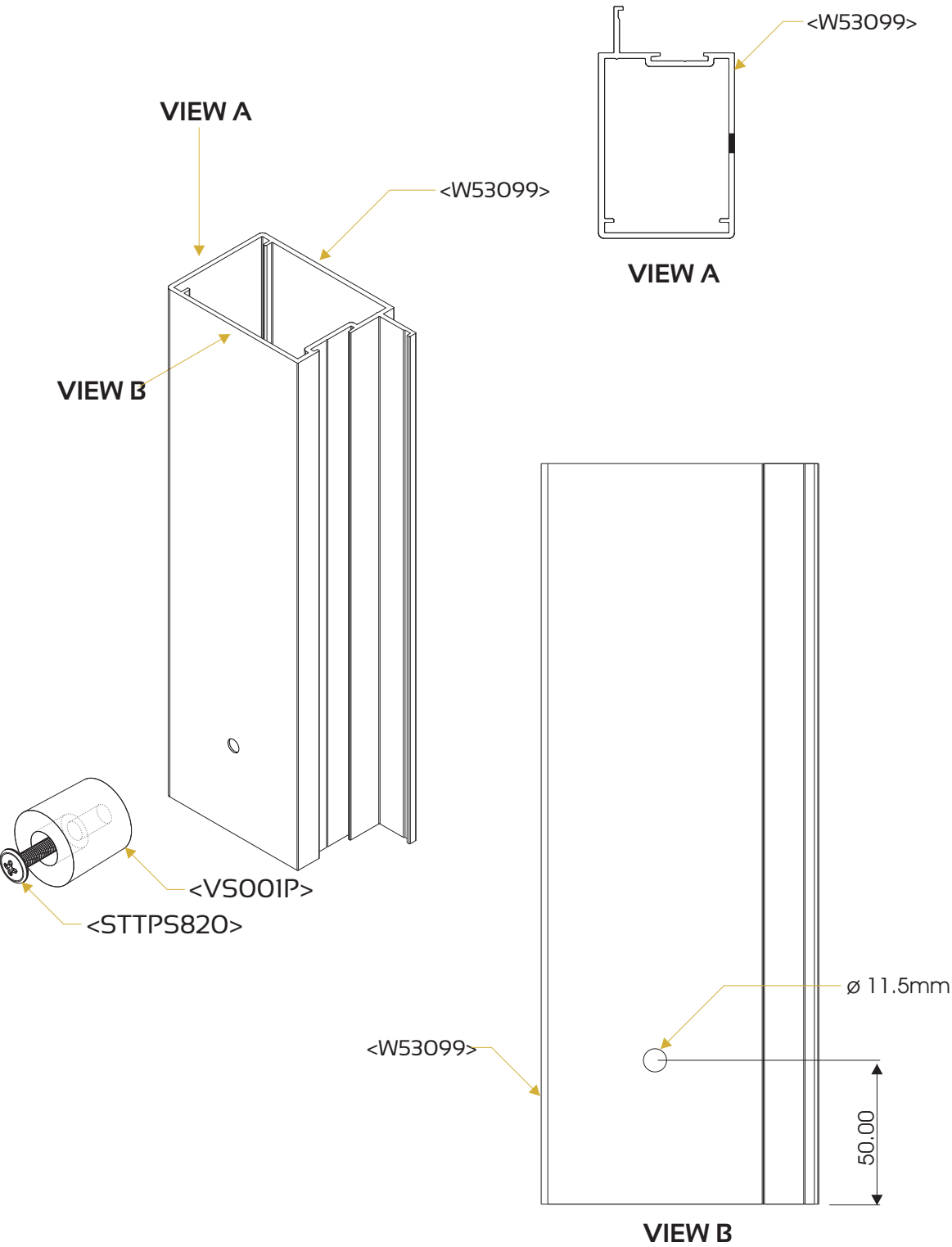


#### DETAIL TYPICAL TO HEAD AND SILL OF FIXED AND SLIDING LIGHTS

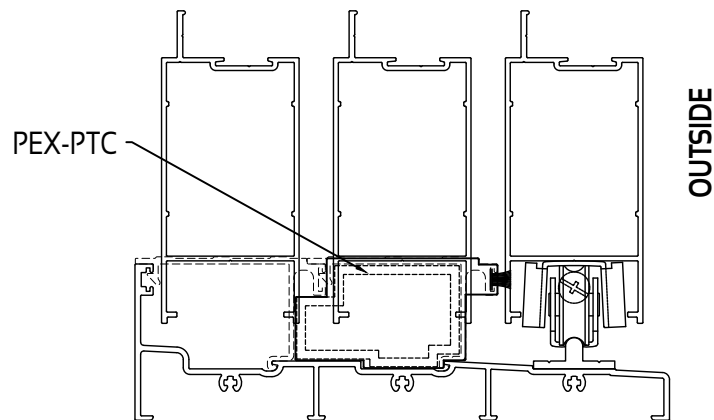
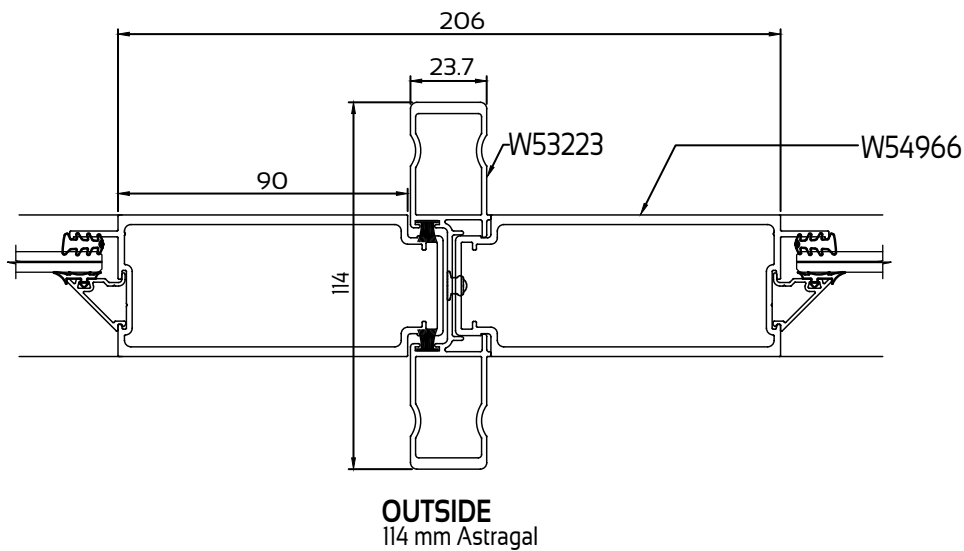
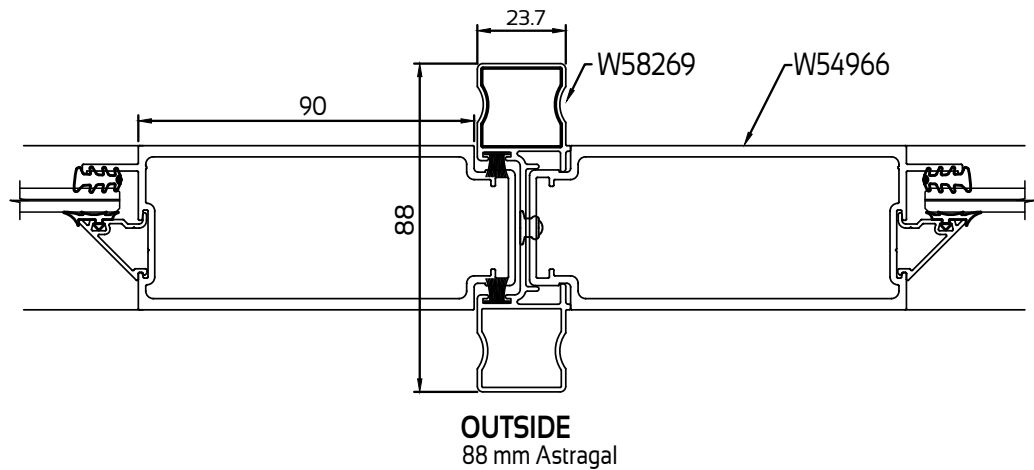
1. ATTACH SPIGOTS TO STILES WITH NO 8 FIXING SCREWS (<STPPS830>)
2. FASTEN STILES TO TOP AND BOTTOM RAILS WITH DIA. 8mm THREADED RODS (<TR8MM>). USE WASHERS (<WSH8MM>), NUTS AND WASHERS.
3. ENSURE ALL MATING JOINTS ARE BEDDED IN SEALANT BEFORE ASSEMBLY.



Stopper for OX, XXX, OXXXXO & XXXXXX

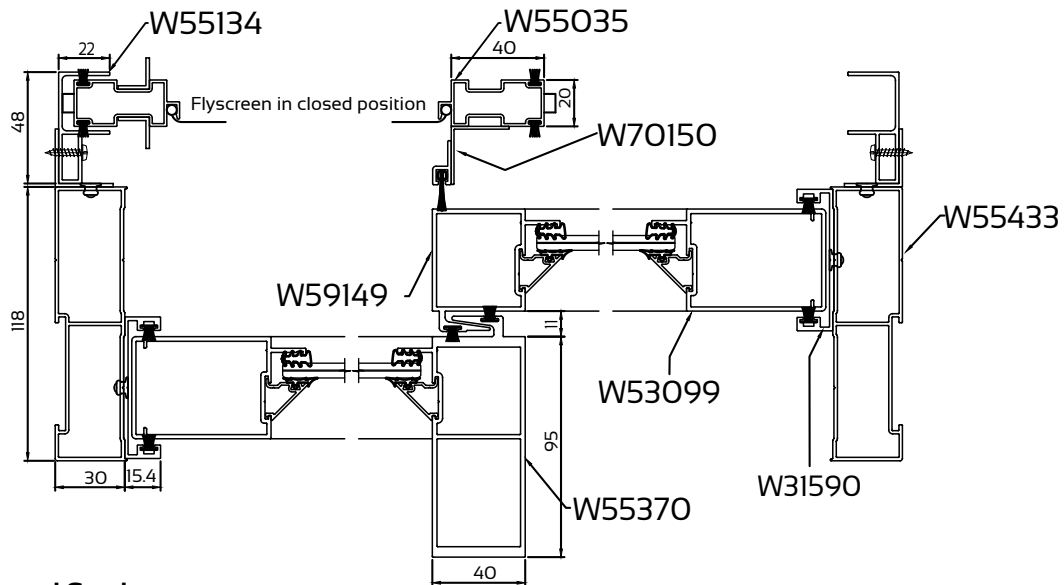


Palace Astragals and Threshold end caps



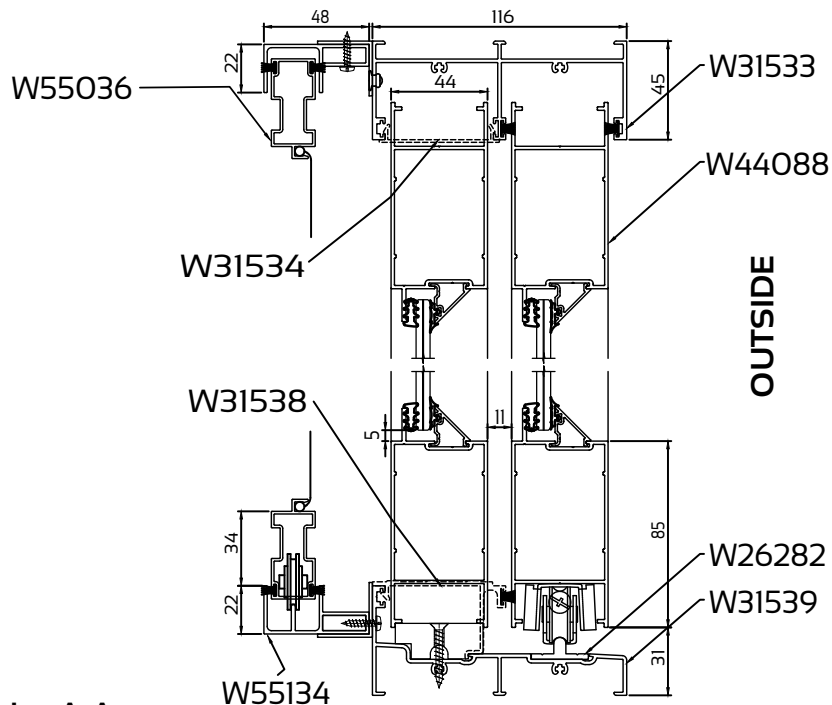
Vertical Section A-A  
(Triple Track - OXX)

This manual must be read in conjunction with the Installation, Cleaning & Maintenance Document and the Performance Certificates for the relevant system. The manual must also be used in conjunction with the design and cutting list from the latest version of StarFront.



**Horizontal Section**  
(2 Panel Configuration with Flyscreen)

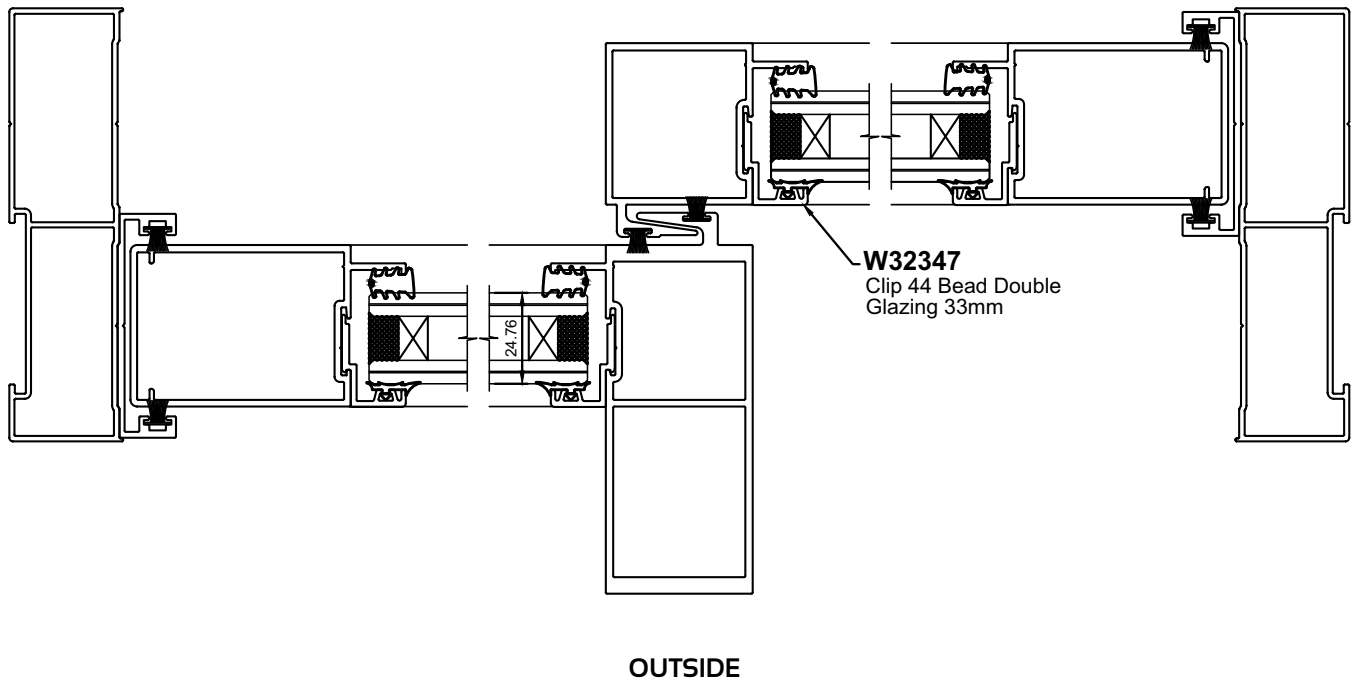
**OUTSIDE**



**Vertical Section A-A**  
(Double Track - OX with Flyscreen)

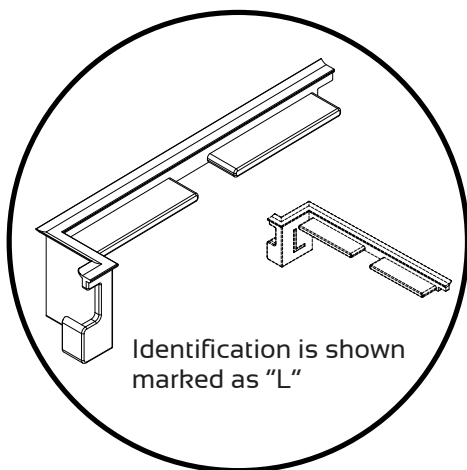
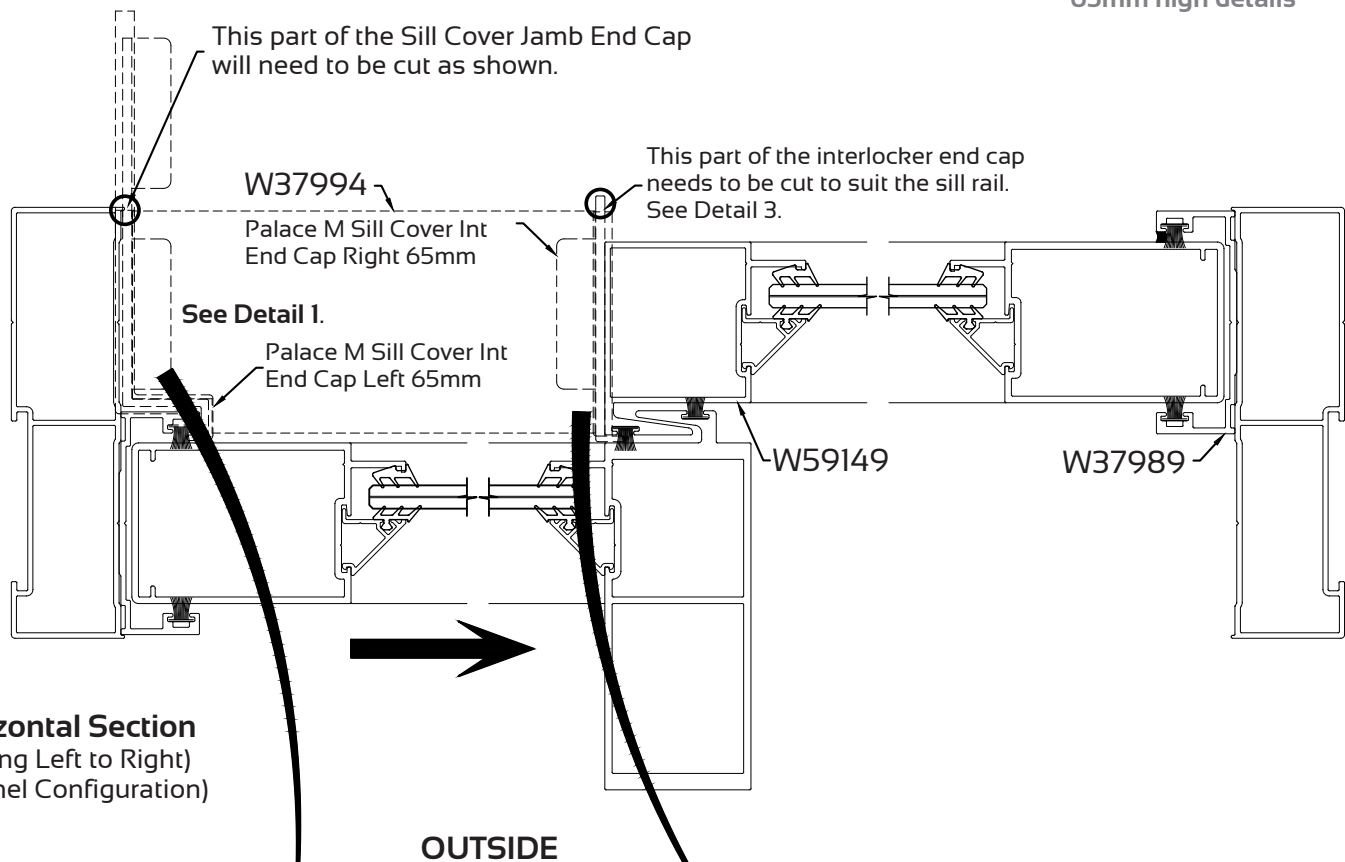
**OUTSIDE**

#### Horizontal Section B-B (2 Panel Configuration)

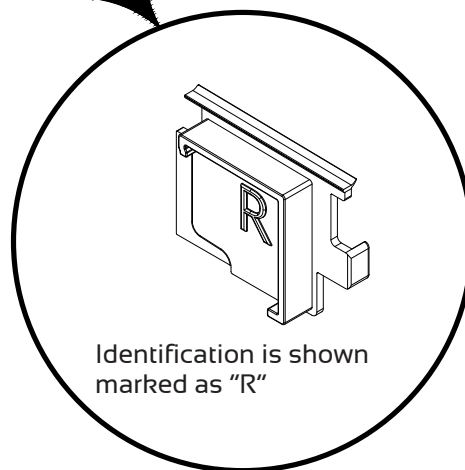


## Assembly Detail

### Palace M Frame Sill Cover 65mm high details



Palace M Sill Cover Jamb  
End Cap Left 65mm



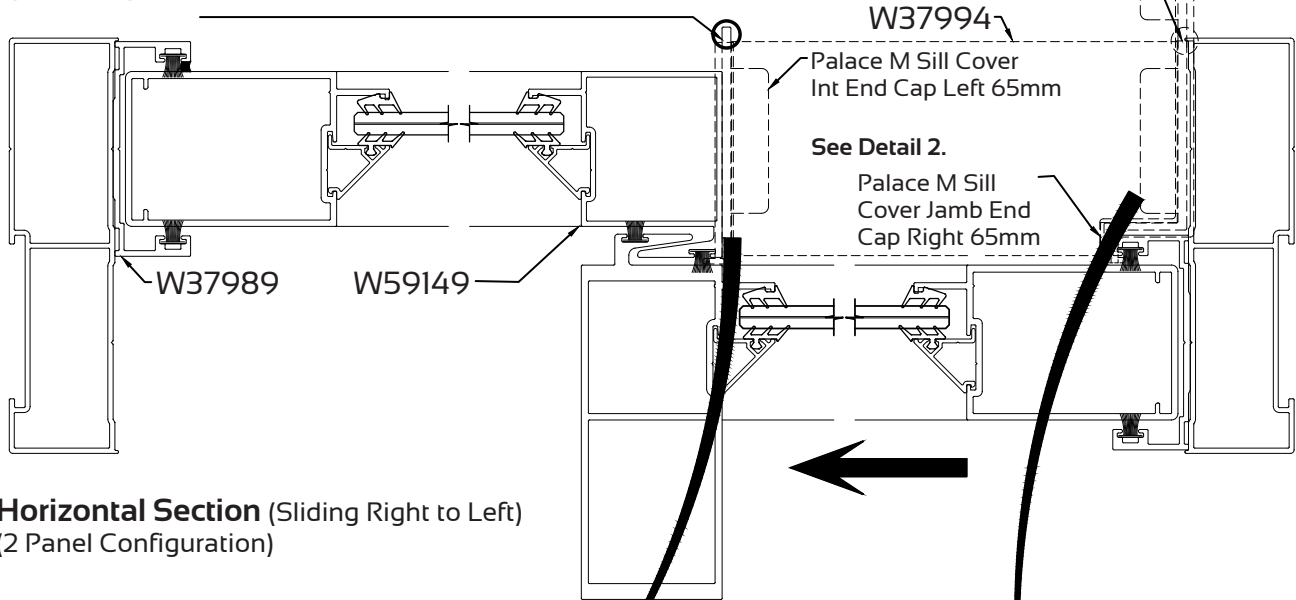
Palace M Sill Cover Int  
End Cap Right 65mm

## Assembly Detail

### Palace M Frame Sill Cover 65mm high details

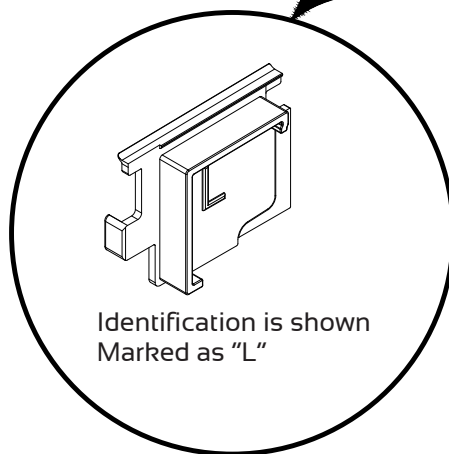
This part of the interlocker End Cap needs to be cut to suit the sill rail.  
**See Detail 3.**

This part of the Sill Cover Cap Jamb Right will need to be cut as shown.



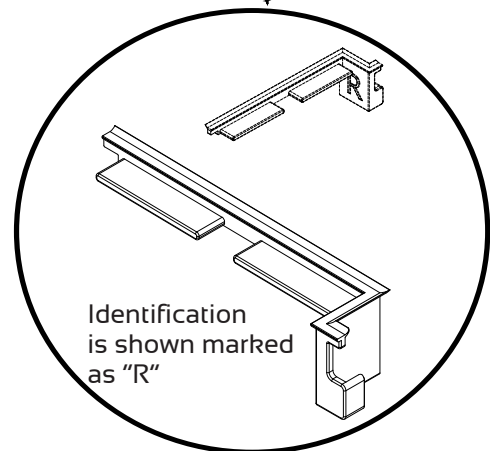
**Horizontal Section** (Sliding Right to Left)  
(2 Panel Configuration)

**OUTSIDE**



Identification is shown  
Marked as "L"

Palace M Sill Cover Int End  
Cap Left 65mm

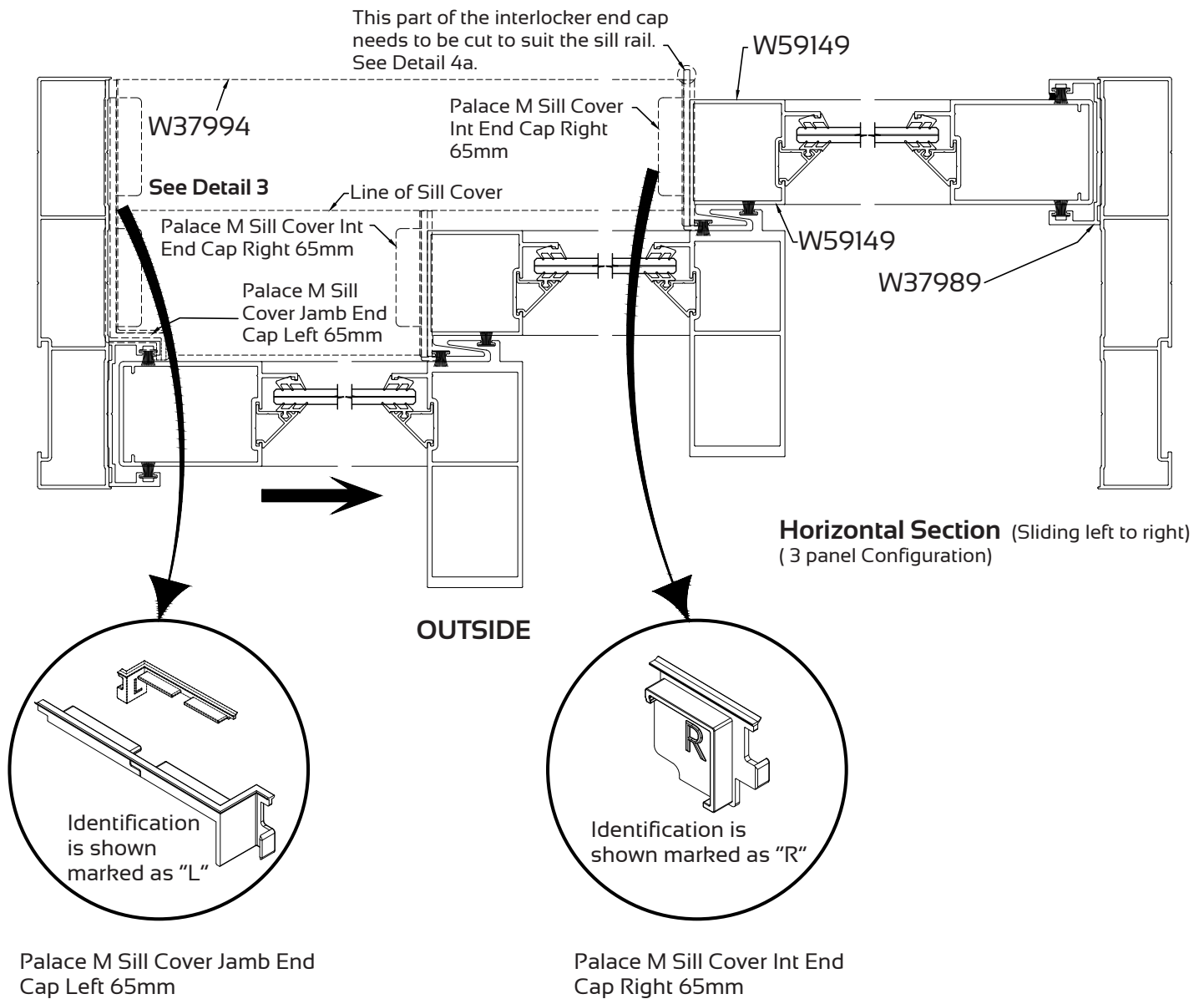


Identification  
is shown marked  
as "R"

Palace M Sill Cover Jamb End  
Cap Right 65mm

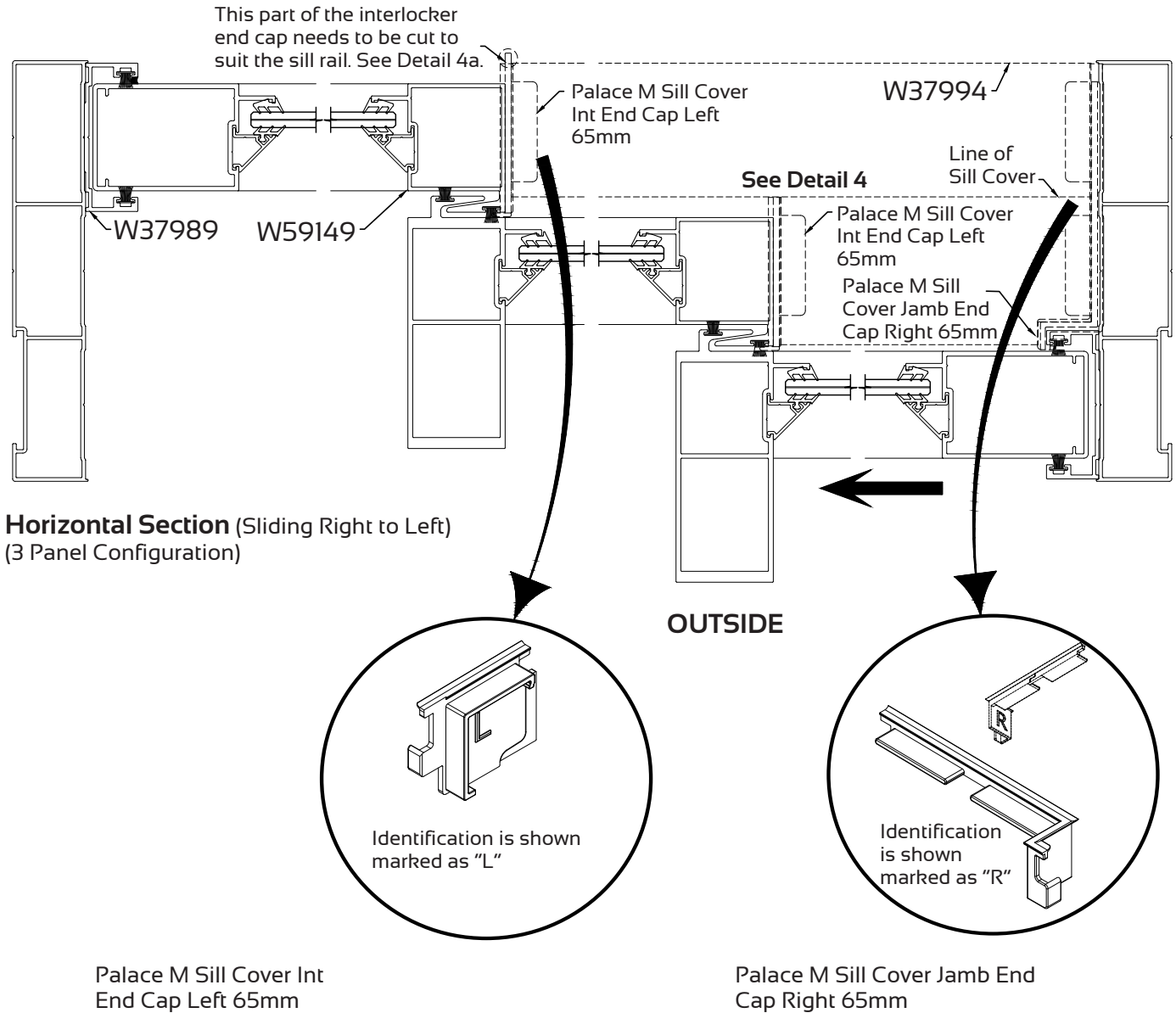
## Assembly Detail

Palace M Frame Sill Cover  
65mm high details



## Assembly Detail

Palace M Frame Sill Cover  
65mm high details



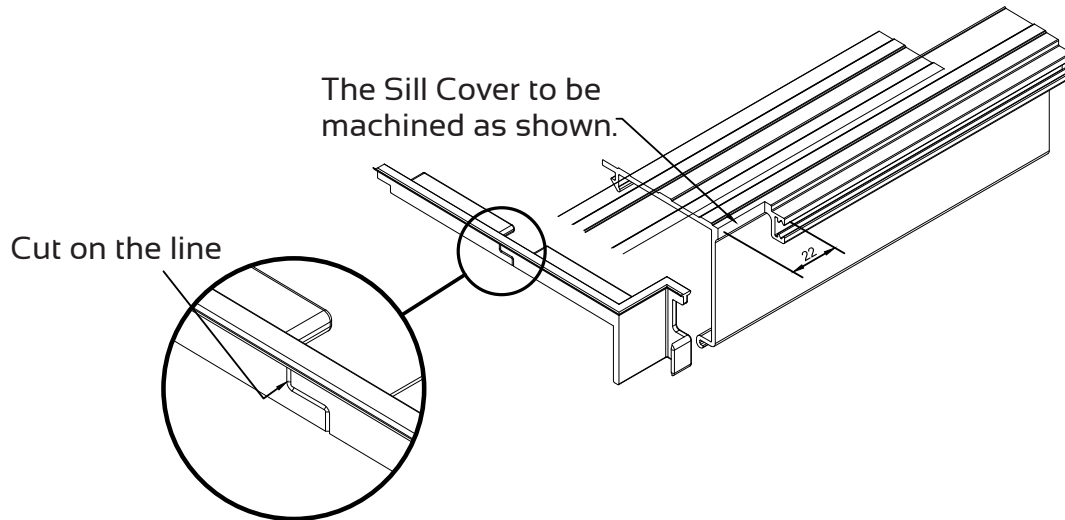
Palace M Sill Cover Int End Cap Left 65mm

Palace M Sill Cover Jamb End Cap Right 65mm



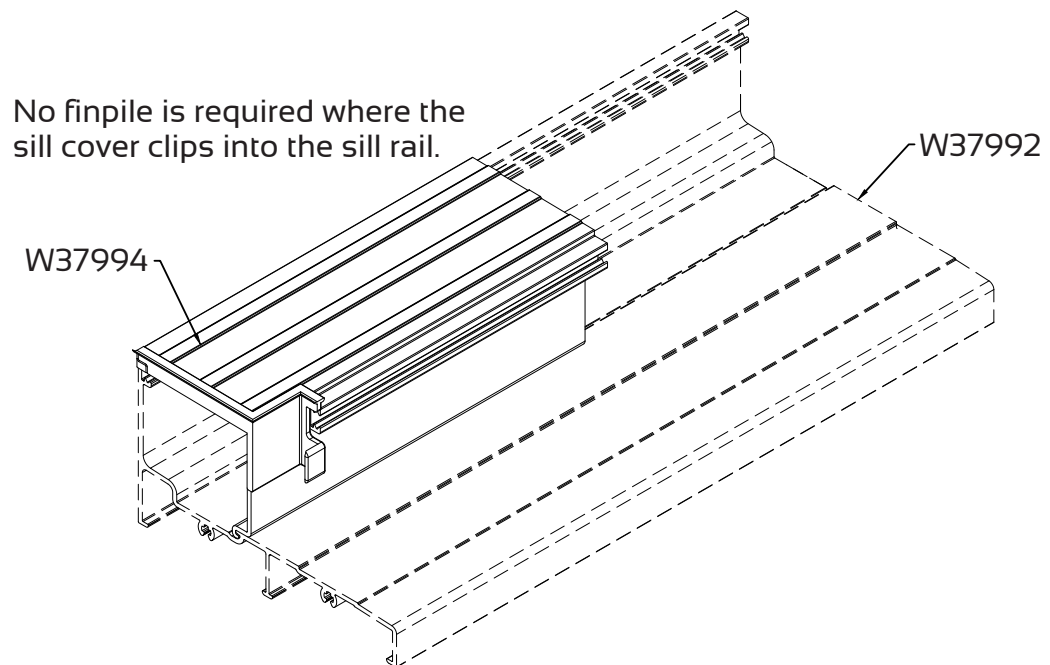
## Assembly Detail

Palace M Frame Sill Cover  
65mm high details



For OX Palace Doors, the Sill Cover Jamb End Cap will need to be cut as shown on the line.

### Detail 1a

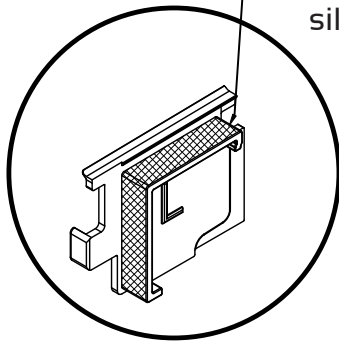


### Detail 1b

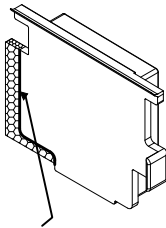
## Assembly Detail

Palace M Frame Sill Cover  
65mm high details

Apply silicone before  
fitting the end cap.

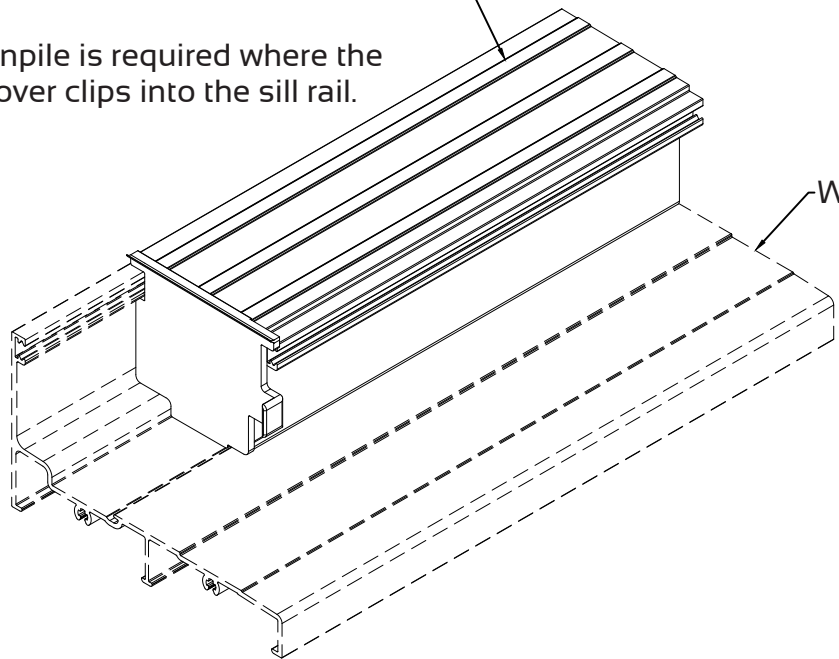


No finpile is required where the  
sill cover clips into the sill rail.



Where the Sill Cover is located to the inside  
of the Sill Rail, the Sill Cover End Cap needs  
to be cut as shown.

W37994



W37992

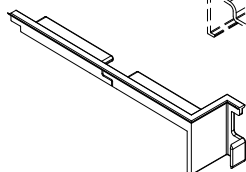
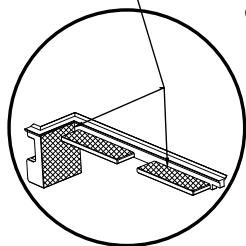
## Detail 2

## Assembly Detail

### Palace M Frame Sill Cover 65mm high details

Silicone to be applied  
to the jamb end cap as shown,  
before fitting to the sill cover.

No finseal is required  
where the sill cover  
clips into the sill rail.



The sill cover to be  
machined as shown.

W37994

W37991

For a triple sill rail setup, clip the inner  
sill cover first with both the sill cover  
end caps in place (Silicone into position),  
then the centre sill cover can be clipped into  
position with both sliding panels in the open  
position. (Remember that no finseal is required  
where the sill cover clips in)

### Detail 3a

No finseal is required where the  
sill cover clips into the sill rail.

W37994

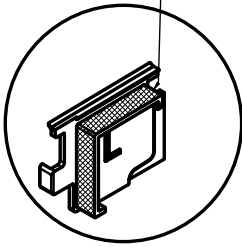
W37991

### Detail 3b

## Assembly Detail

Palace M Frame Sill Cover  
65mm high details

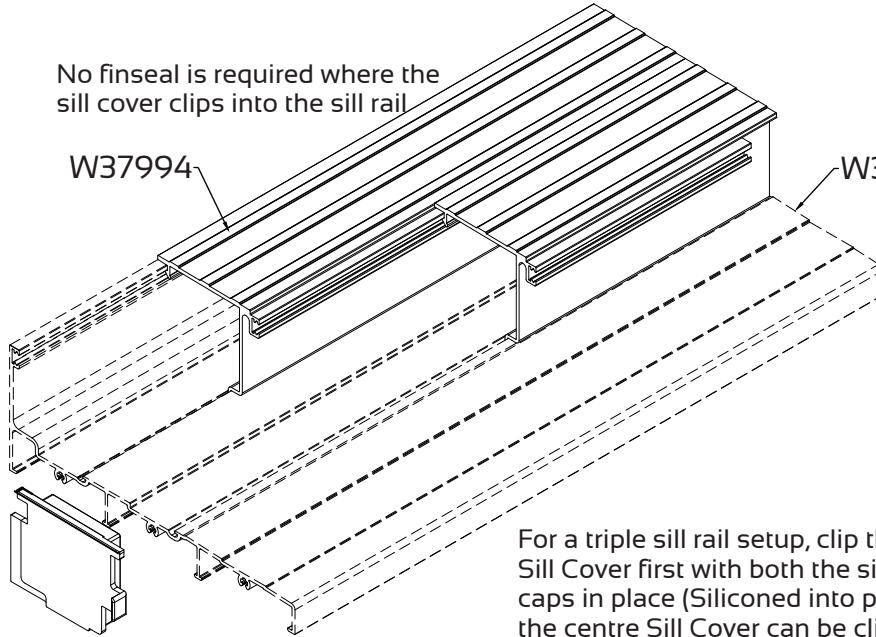
Apply silicone  
before fitting  
the end cap.



No finseal is required where the  
sill cover clips into the sill rail

W37994

W37991



For a triple sill rail setup, clip the inner  
Sill Cover first with both the sill cover end  
caps in place (Siliconed into position), then  
the centre Sill Cover can be clipped into position  
with both sliding panels in the open position.  
(Remember that no finseal is required where  
the sill covers clip in)

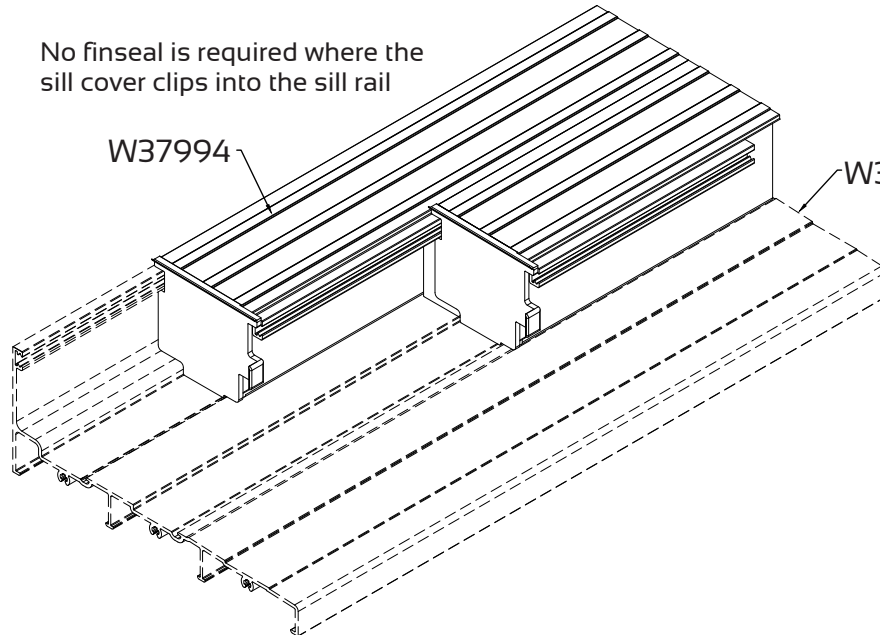
Where the Sill Cover is located  
to the inside of the Sill Rail the  
Sill Cover End Cap needs to be  
cut as shown.

### Detail 4a

No finseal is required where the  
sill cover clips into the sill rail

W37994

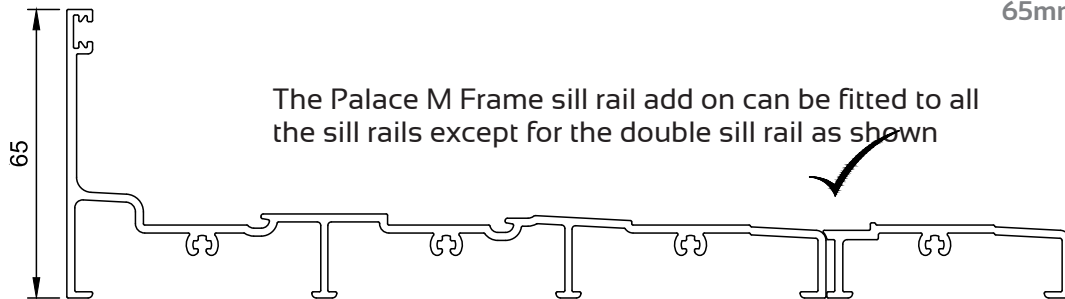
W37991



### Detail 4b

## Assembly Detail

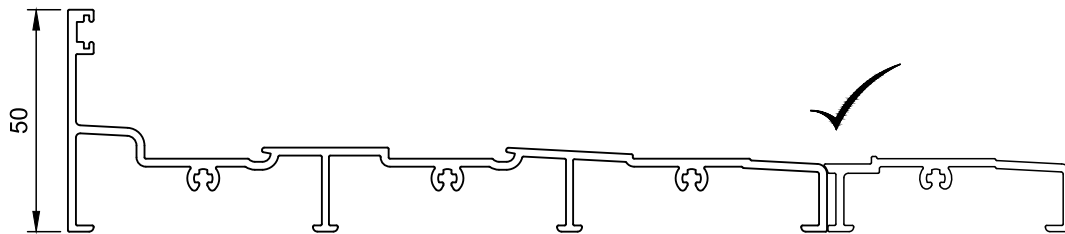
Palace M Frame Sill Cover  
65mm high details



The Palace M Frame sill rail add on can be fitted to all the sill rails except for the double sill rail as shown

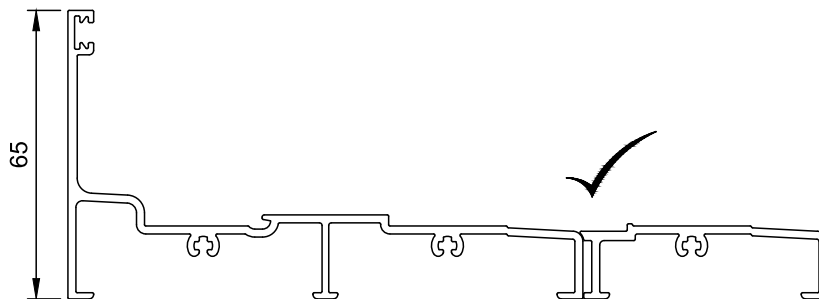
**W37991**

Palace M Frame Sill Rail Triple 65mm



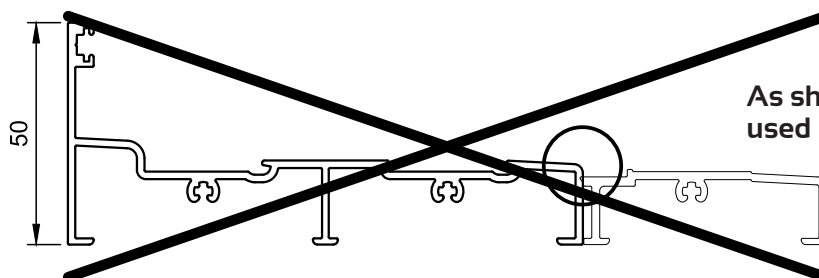
**W31535**

Palace M Frame Sill Rail Triple 50mm



**W37992**

Palace M Frame Sill Rail Double 65mm



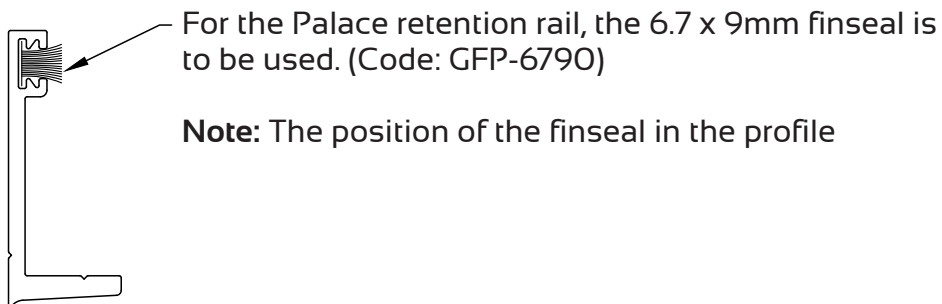
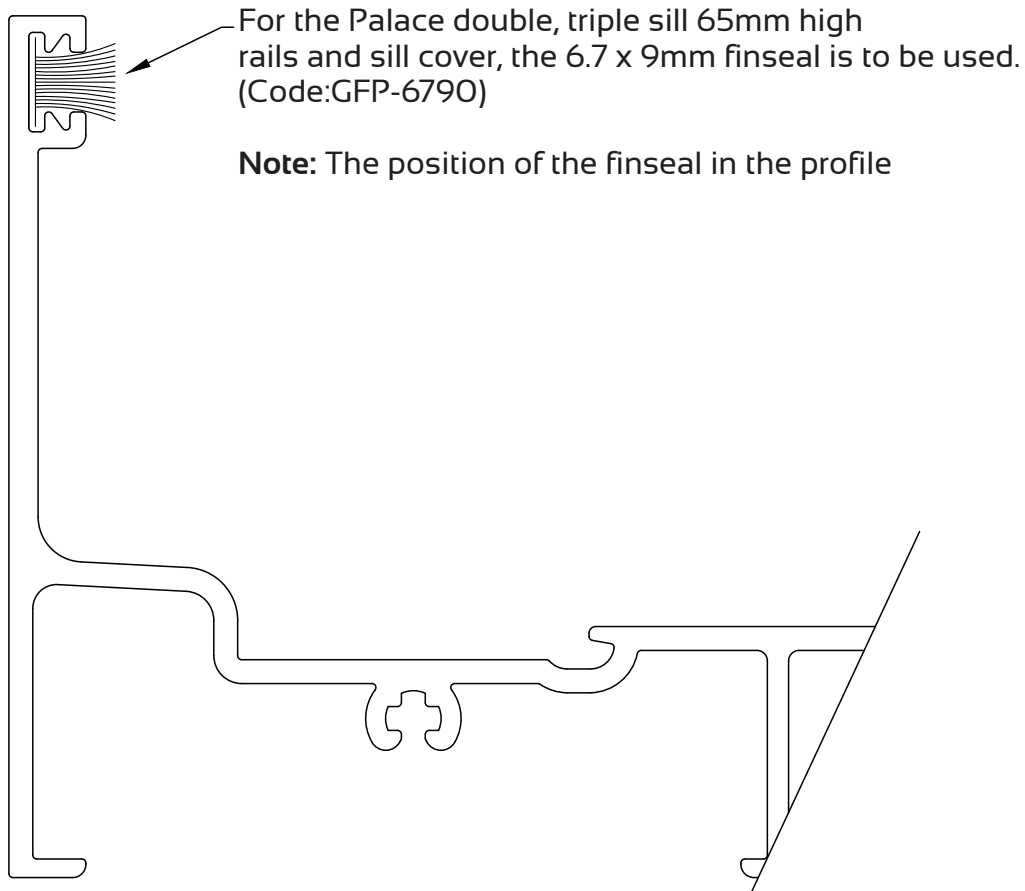
As shown, this double sill rail cannot be used in conjunction with the add on sill rail.

**W31539**

Palace M Frame Sill Rail Double 50mm

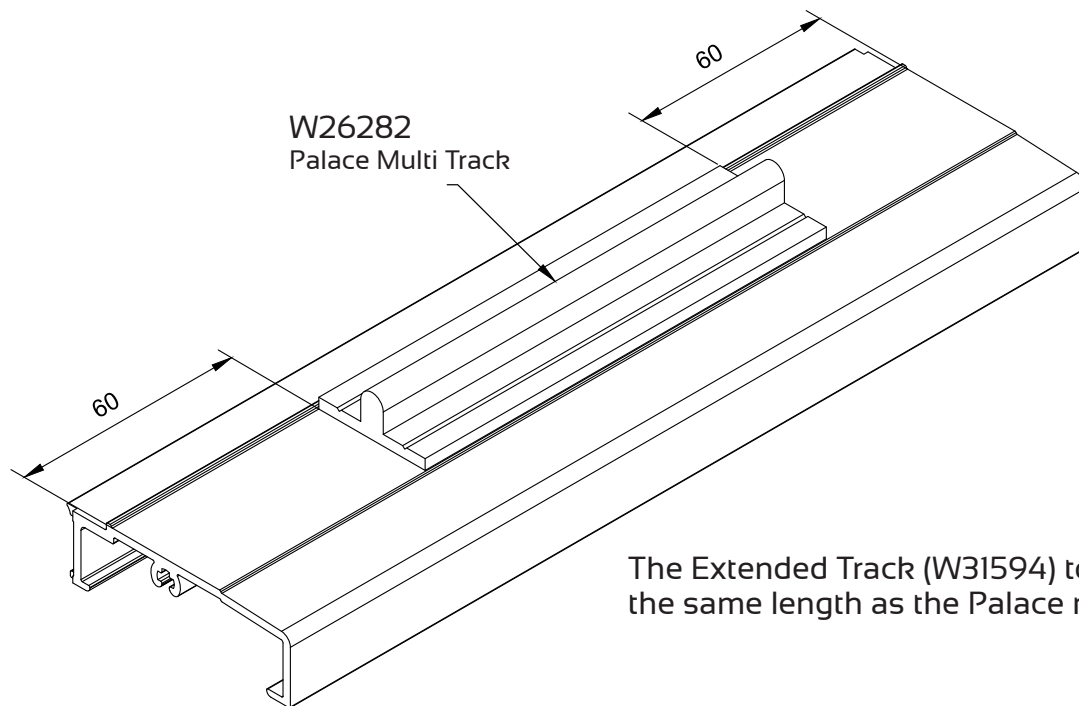
## Assembly Detail

Palace M Frame Sill Cover  
65mm high details

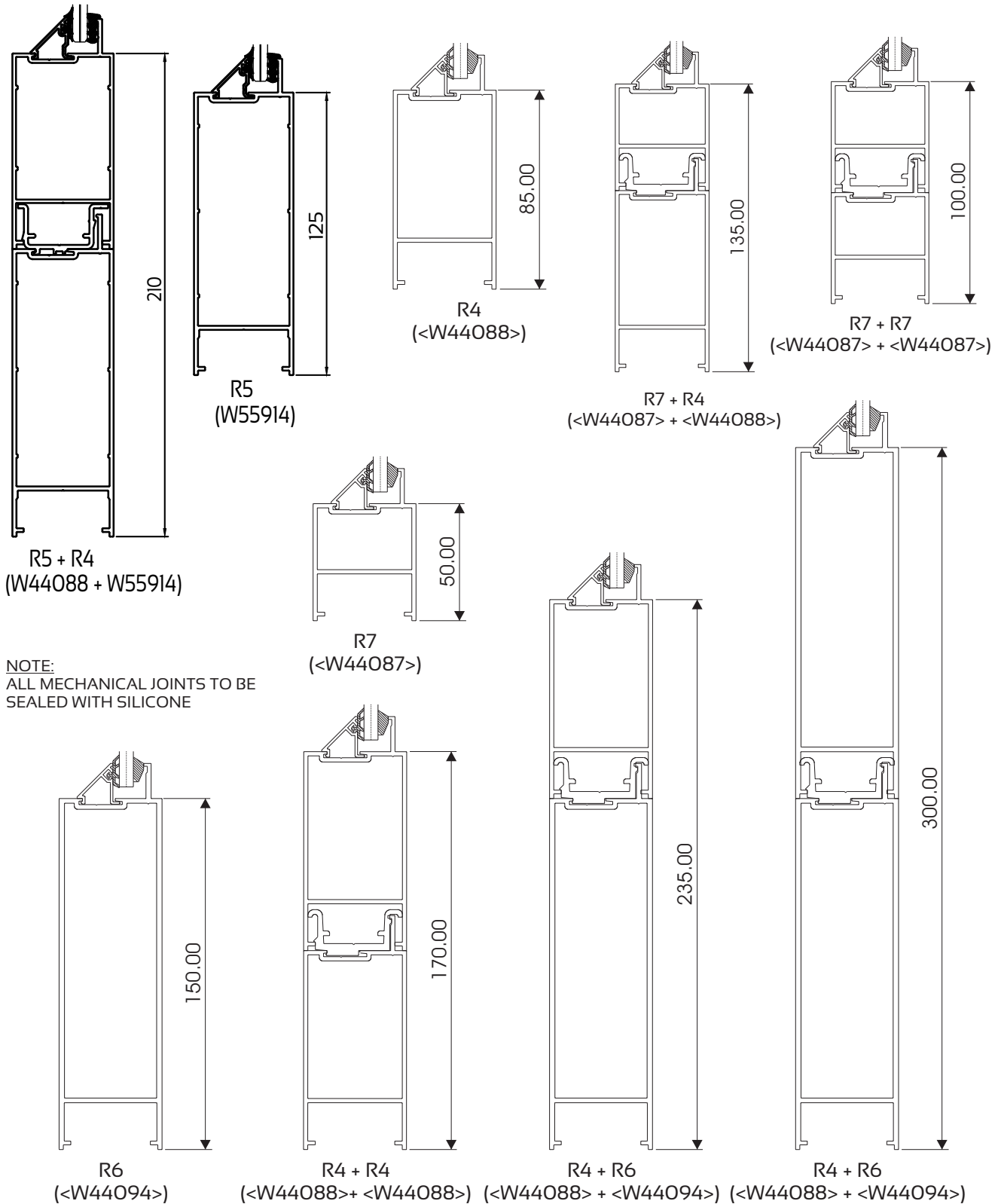


## Assembly Detail

Palace M Frame Sill Cover  
65mm high details

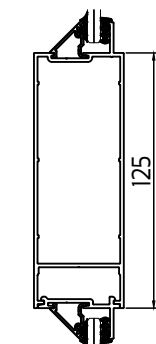
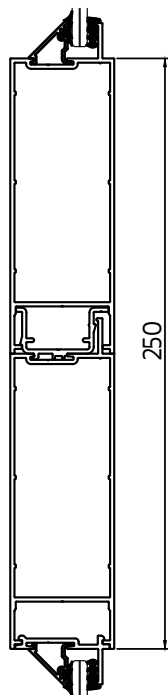


The Extended Track (W31594) to be cut the same length as the Palace multi track.

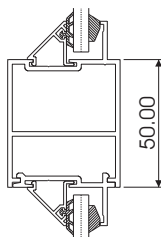


**NOTE:**  
ALL MECHANICAL JOINTS TO BE  
SEALED WITH SILICONE

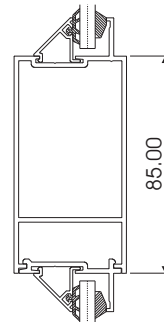




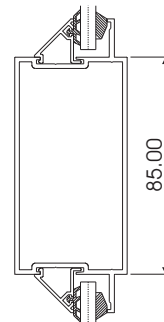
R5 + Glazing Sill Rail  
(W55914 + W26151)



R7 + R4 FILLER  
(<W44087> + <W26151>)



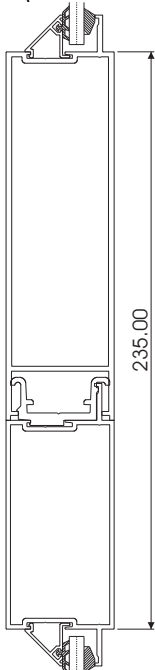
R4 + R4 FILLER  
(<W44088> + <W26151>)



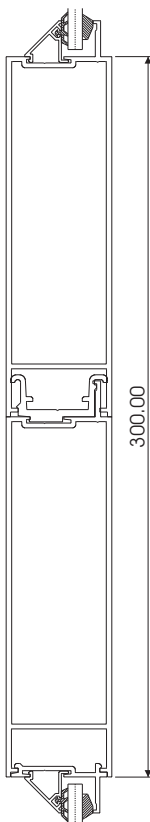
R4SP  
(<W44089>)

**NOTE:**  
ALL MECHANICAL JOINTS TO BE  
SEALED WITH SILICONE

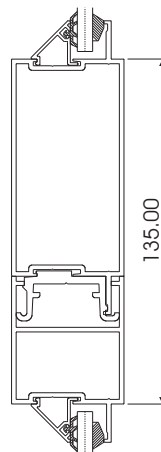
R5 + R5 + Glazing Sill Rail  
(W55914 + W55914 + W26151)



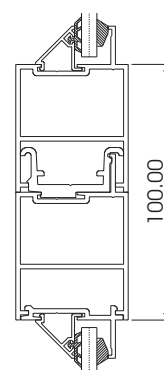
R6 + R4SP  
(<W44094> + <W44089>)



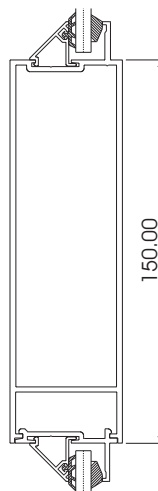
R6 + R6 + R4 FILLER  
(<W44094> + <W44094> + <W44094> +  
<W26151>)



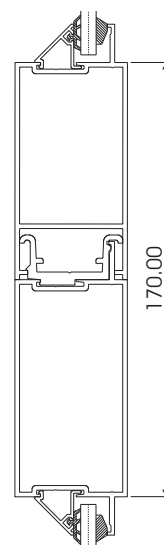
R7 + R4SP  
(<W44087> + <W44089>)



R7 + R7 + R4 FILLER  
(<W44087> + <W44087> +  
<W26151>)



R6 + R4 FILLER  
(<W44094> + <W26151>)



R4 + R4SP  
(<W44088> + <W44089>)

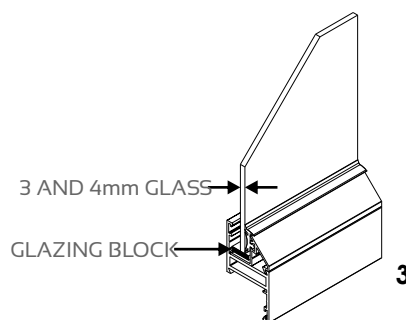
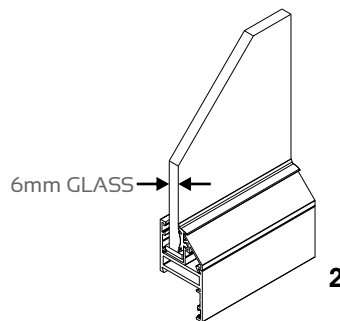
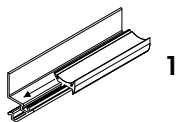
Insert the pull-in vinyl gasket into glazing beads by sliding or pressing it into the groove (1). Before cutting gasket, ensure that it has not stretched and cut 6mm longer so that corners are in compression at all times.

Position bottom glazing bead in glazing bead rebate (2).

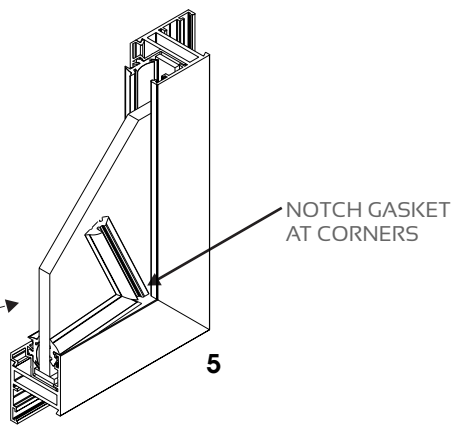
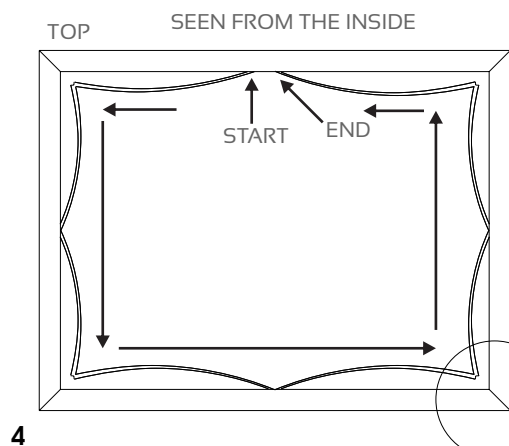
Place glass on glazing blocks (3).

Insert top and then side glazing beads ensuring that they are in correctly.

Starting from top centre, insert roll in gasket (4) without stretching it (5). Stop 150mm from corner and partly cut gasket 6mm longer than the edge of the vertical bead. Insert gasket at corner and then roll in remaining 150mm. Repeat this on the other sides. Where gasket ends meet, cut gasket 6mm longer. Insert cut ends first and complete.



ENSURE GASKETS ARE NOT STRETCHED AT ANY STAGE



### GLAZING

#### 1. SELECTION OF GLAZING METHODS

##### 1.1 SETTING AND LOCATION BLOCKS

Glass-to-metal contact must be avoided at all times by using setting and location blocks having a hardness of 50° to 90° shore A durometer. Use only blocks made of Neoprene, EPDM, Silicone or other elastomeric material.

Setting blocks are to have a minimum thickness of 3mm and must be at least 27mm in length per square metre of glass area.

The position of the setting and location blocks is illustrated in Figure 2.

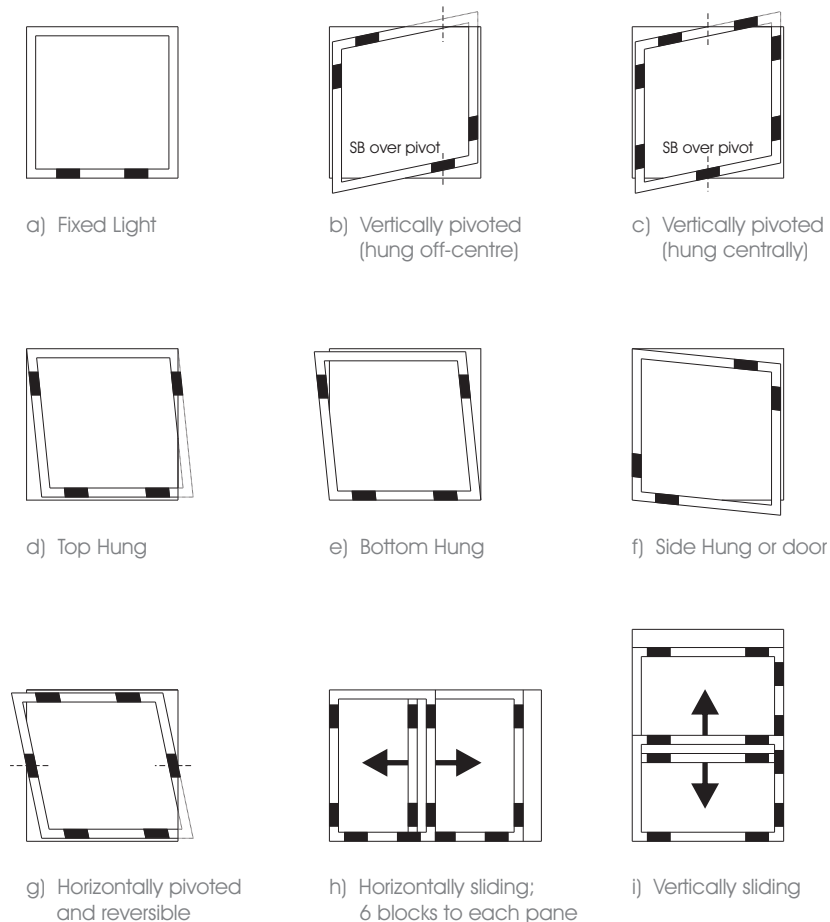


FIGURE 2 - POSITION OF SETTING AND LOCATION BLOCKS