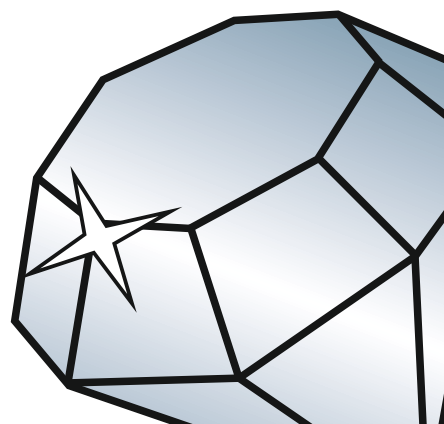


# Hipped Aluminium Roof

## Assembly Guide



DURATION  
WINDOWS

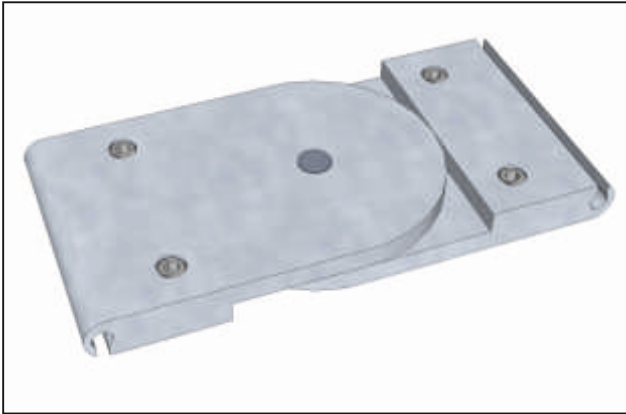


## Step One

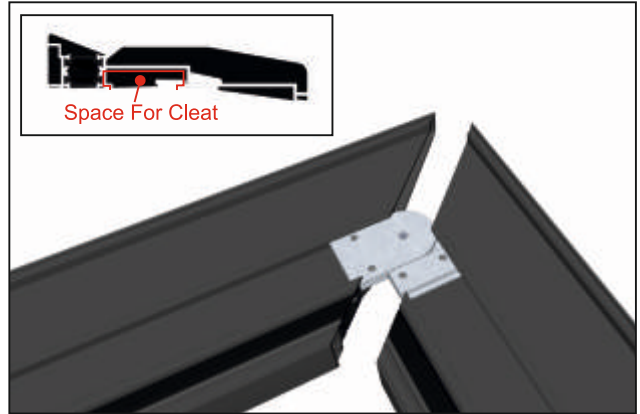
# DURATION WINDOWS

### Assembling Cill

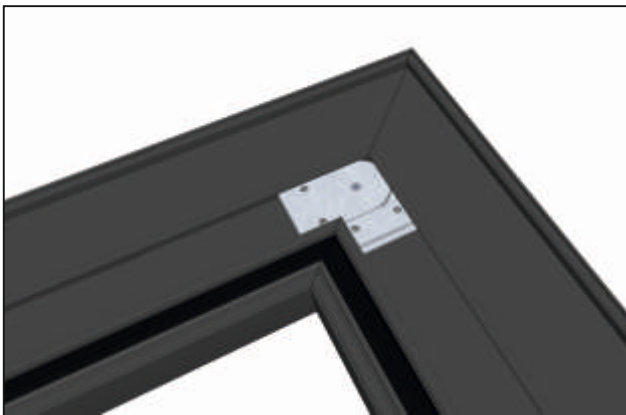
- Start by fitting the window upstand into place.
- If you do not have a window upstand then move to step 3.



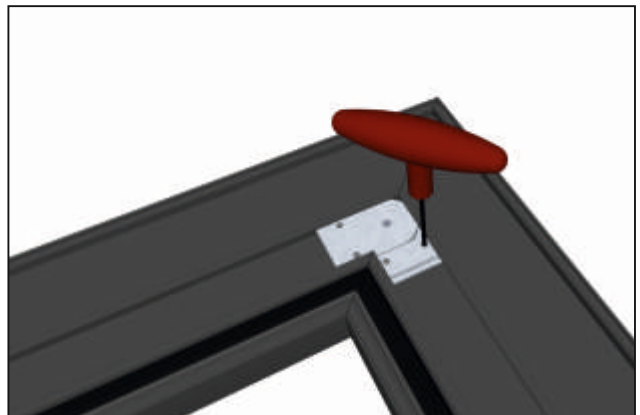
- Use the provided cleat for variable angle cill joints to join the cill together.
- (Other systems are available and will differ in construction. Ask ABD for more details)



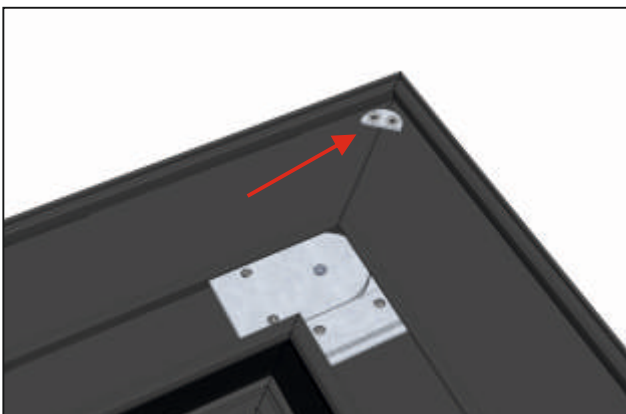
- Insert the cleat into the space provided on the cill as shown above.



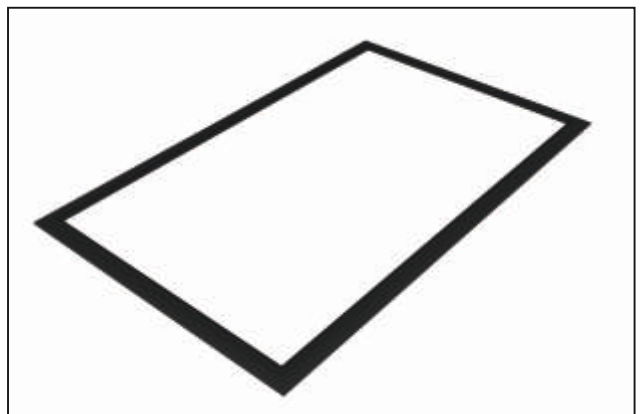
- Push both sections of the cill together until the mitres meet.
- Remember to seal the mitred edge.



- Using an allen key tighten the grub screws. This will lock the cleat into place joining both sections of cill.



- Finally screw nose bracket into place for extra support.

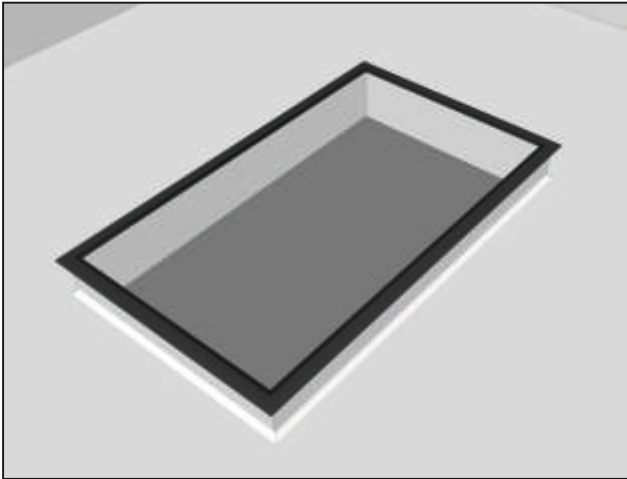


- Repeat process until all corners are joined and sealed.

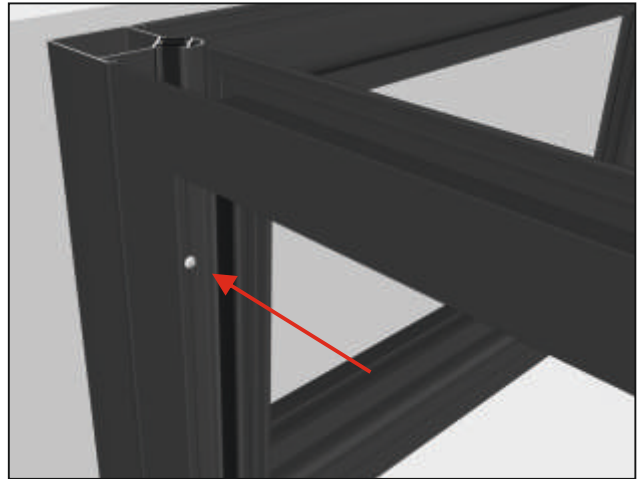
## Step Two

# DURATION WINDOWS

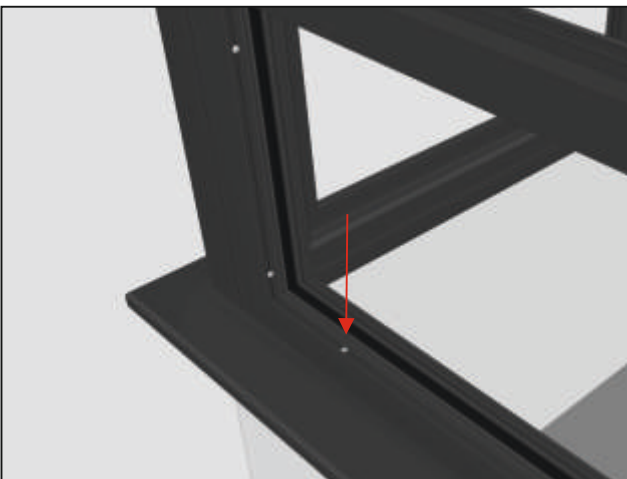
### Constructing Upstands



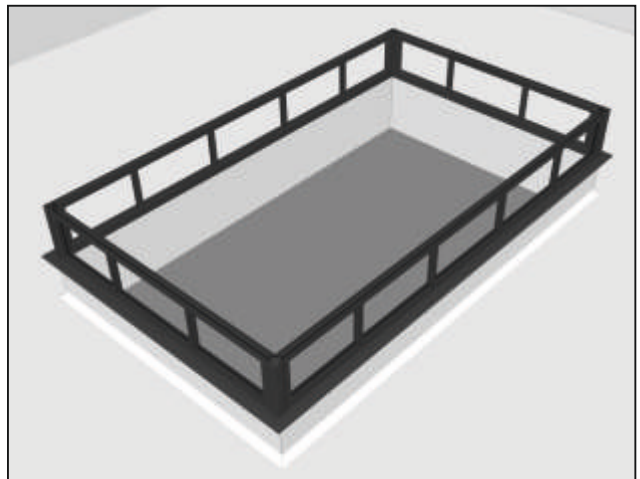
- Once cill is constructed bed down on silicone for water tightness and fix down into structure below (such as a timber upstand)
- Silicone screws to keep water tight.



- Construct the window upstands.
- Screw through the window frame into the corner posts.
- Do this on both sides of the corner post.
- Continue to do this until window upstands are finished.



- Place constructed window upstand on cill and fix down into the cill.
- The window upstand should be glazed at the same time as the roof is glazed
- Silicone screws to keep water tight.



- Now the window upstands are erected the roof can be constructed.



## Step Three

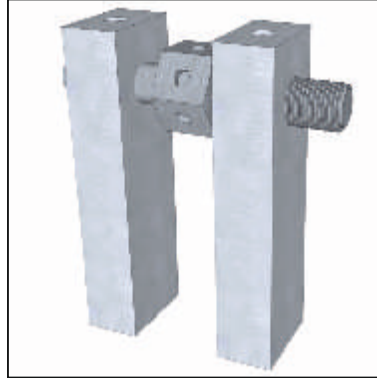
# DURATION WINDOWS

### Assembling Ring Beam

- Parts

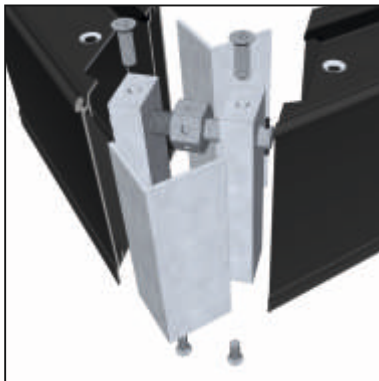


Standard Ring Beam

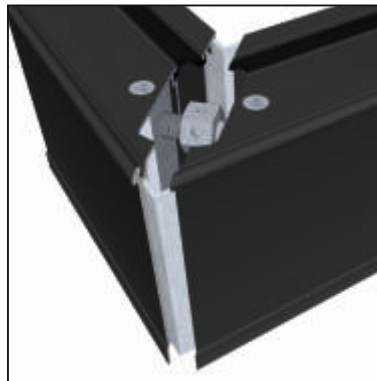


Ring Beam Clamp Bracket

- Assemble ring beam in an open area such as a lawn.



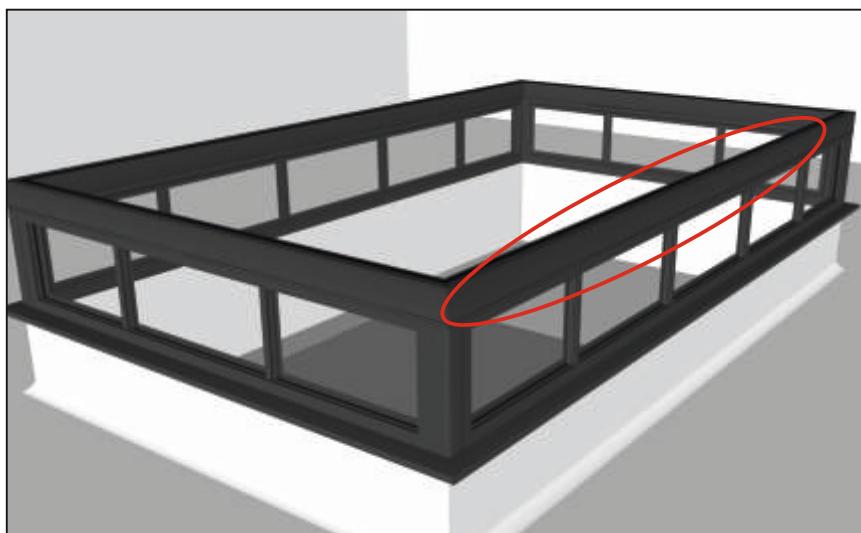
Insert front & rear corner cleats and clamp bracket into one section of the ring beam. Screw into place using screws provided.



Take the next section of ring beam and screw into place. Silicone screws in place to make water tight.



Silicone edges of ring beam then tighten the clamp bracket until both the sections of ring beam are flush with each other. Repeat until all section of ring beam are connected.



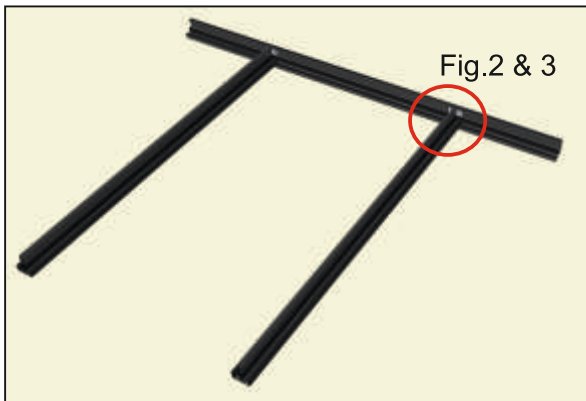
- Lift constructed ring beam onto upstands and fix from product below.
- If window upstands are not used place constructed ring beam on a wood upstand / wood curb (This is not supplied by ABD). Fix down through the box section into the curb below. Remember to bed down on silicone for a water tight seal.

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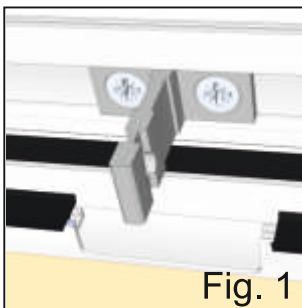
## Step Four

# DURATION WINDOWS

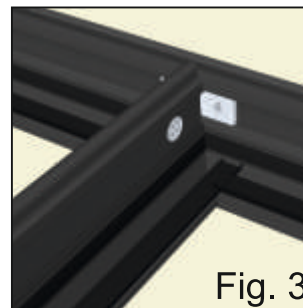
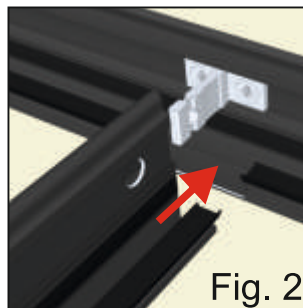
### Assembling Glazing Rafter To Wall Plate Adapter



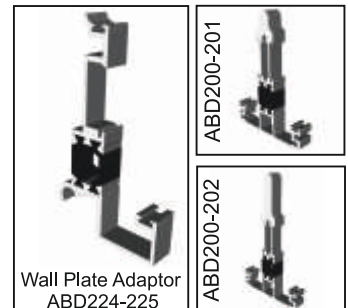
- All gaskets on the glazing bars and wall plate adapter will be pre-inserted in our factory.
- Assemble the first glazing bar to wall plate adaptor using the attached tee cleats (Fig.1 , Fig.2 & Fig.3).
- Screw into position. (Shown in Fig.3)
- Silicone all screws and joins to keep water tight.
- This should be done in an open area such as a lawn.



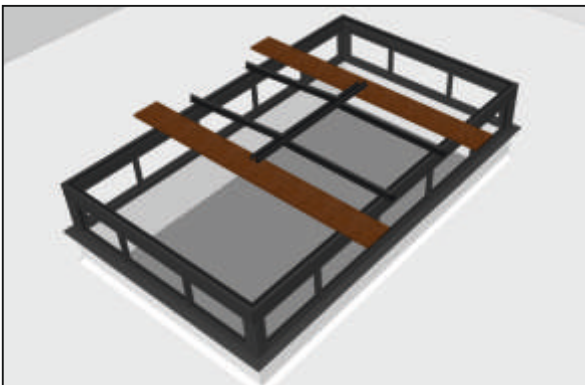
Tee Cleats (ABD208) are screwed into position at the factory.



Rafter & Adapter After Assembly



### Assembling Ridge & Attaching Rafters To Ring Beam



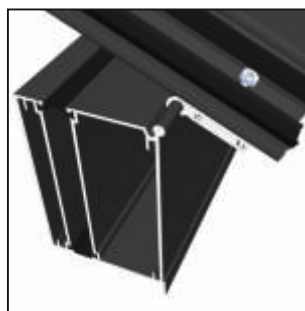
- With help lift assembled wall plate adapter and glazing bars onto the roof and lay in position.
- If required use scaffold boards to support the parts.
- All fixing points will be pre-drilled at the factory.
- All Rafters will have a 50mm over hang unless specified otherwise.
- To fix rafters to ring beam follow instructions below.
- Repeat until all rafters are fixed in place.



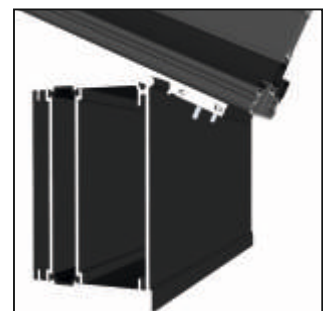
- Insert fixing plate onto ring beam support.



- Insert slide plate into position on fixing plate.



- Screw through the rafter, fixing plate and slide plate.



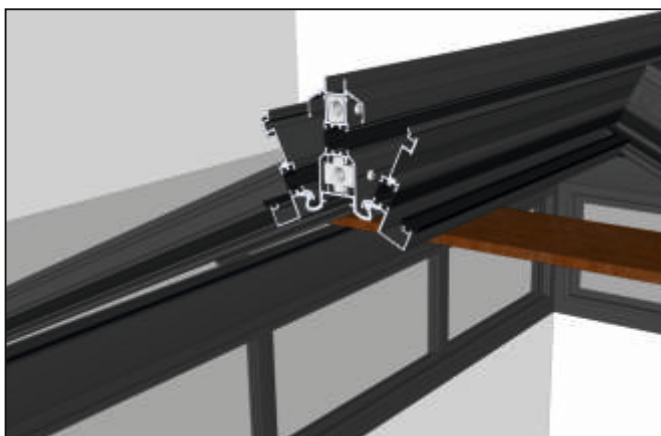
- Once fully tightened bar will be held in place.

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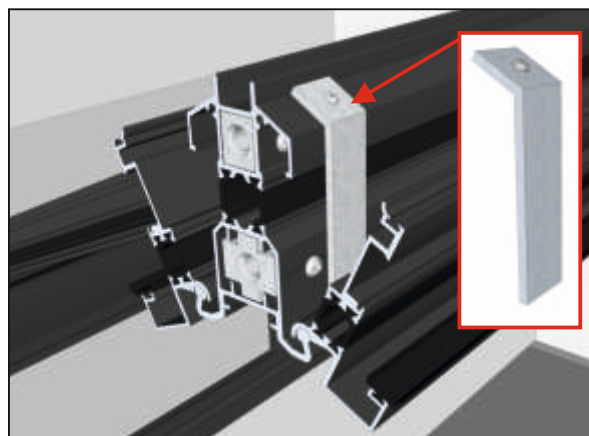
## Step Five

# DURATION WINDOWS

### Fixing Ridge In Place



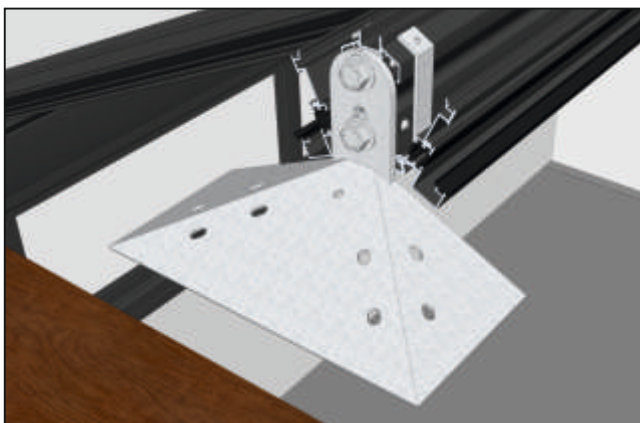
- With help lift assembled wall plate adapter and glazing bars into position and insert the central ridge (ABD222-223).



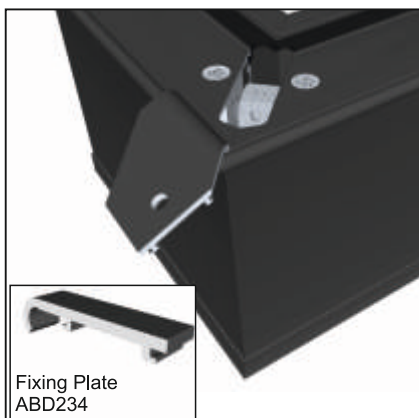
- Once ridge is in position fix the retaining brackets into place. They are fitted on both ends of the ridge & at each point where there is a glazing rafter (the amount of brackets used will depend on roof size).

### Fit Spider Bracket

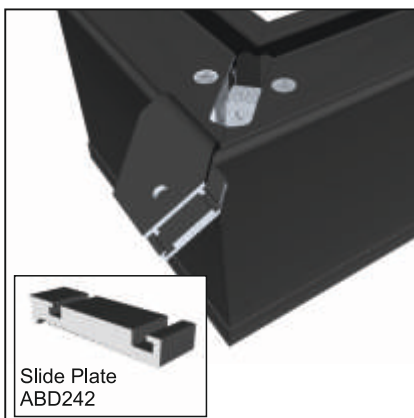
- Using the bolts & washers provided screw the spider into place.
- The bolts will locate into the pre-fixed spider blocks. (The blocks are always fixed in place at the factory)
- The spider should be pushed up so that it aligns with the wall adapter edge (ABD224-225).
- These are fitted at both ends of the roof.



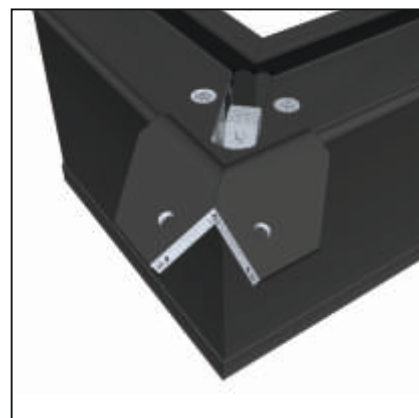
### Fix Hip Plate To Ring Beam



- Insert fixing plate (ABD234) onto ring beam support.



- Insert slide plate (ABD242) onto position showed on fixing plate.



- Repeat process on other corner.

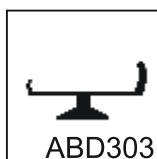
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## Step Six

# DURATION WINDOWS

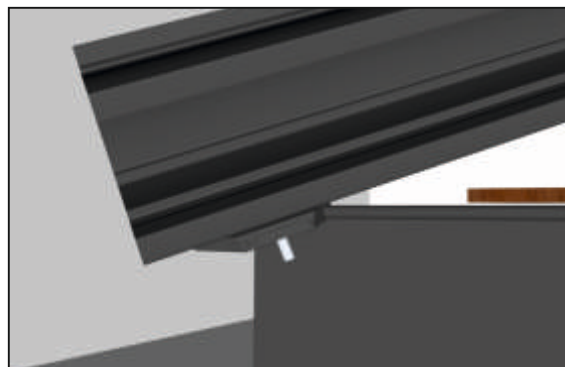
### Fix Hip Bars



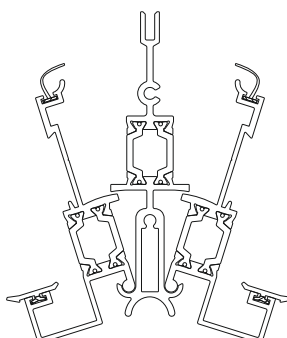
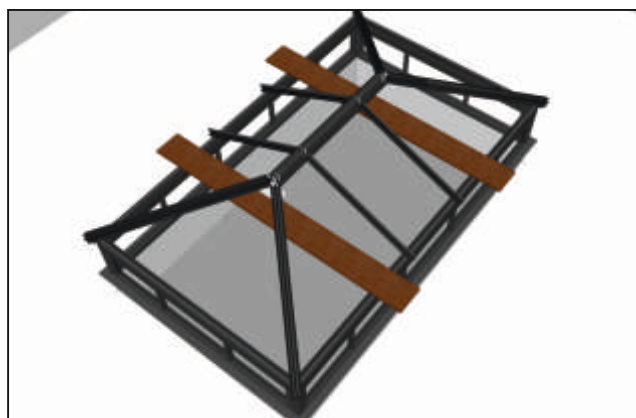
- Check all gaskets are in place. (This should be done at the factory)
- This side sits on the outside of the bar.



- Lay hip bars in place on the spider and fix from underside using screws and washers provided.



- Pre fix hip assembly onto hip plate using screws provided.

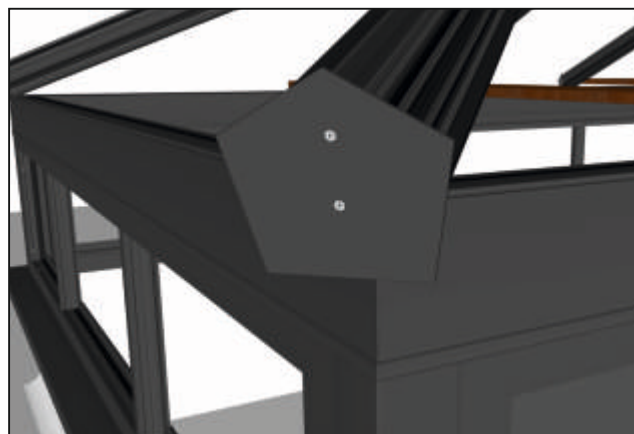


- Continue fixing process until all hips are fitted.
- **Silicone any screws or joints to ensure a water tight seal.**

### Fit End Caps Into Place



- Screw fix end cap (ABD316) to the glazing bar.
- Repeat until all glazing bar caps are fitted.



- Screw fix end cap (ABD318) to the hip bar assembly.
- Repeat until all hip bar caps are fitted.

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## Step Seven

# DURATION WINDOWS

### Jack Rafter - Stage One



- Knock ring beam infill (ABD248) into position on the ring beam with a nylon hammer.
- Knock it hard into place.
- Start with the section that is adjacent to the hip and before the position of the jack rafter.
- Repeat this around any sides with a jack rafter next to a hip.
- **Ensure to silicone all joints.**

### Attaching Jack Rafter To Ring Beam



- Insert fixing plate (ABD234) onto ring beam support.



- Insert slide plate (ABD242) onto position showed on fixing plate.



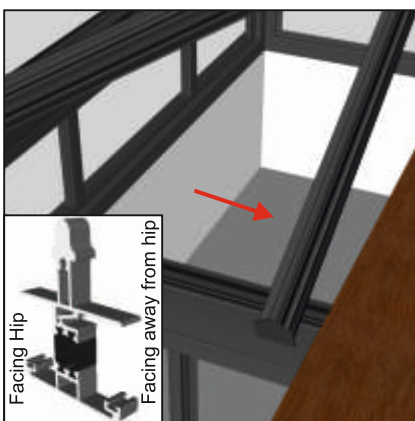
This side sits on outside of the bar.

ABD303

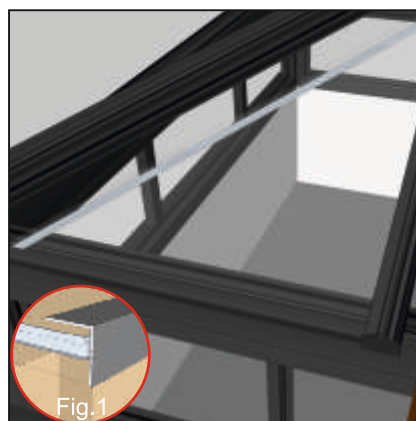


- Check all gaskets are inserted (ABD303).
- Take assembled jack rafter & position on plate. Assembled with end cap & packer at the factory.
- Screw jack rafter in place.

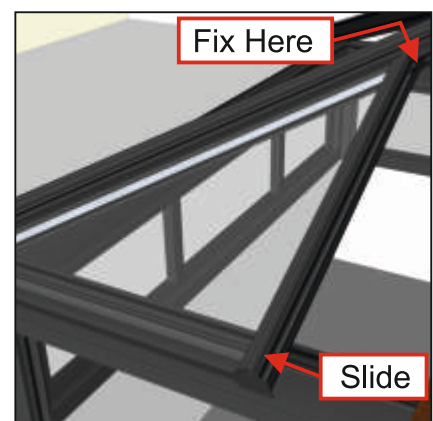
### Attaching Jack Rafter To Ring Beam



- Once jack rafter is attached to the ring beam slide away from the hip allowing room to insert glazed unit.
- The beaded side should face away from the hip.



- Insert the end trim (ABD140) to the bottom of the glazed unit. Fig.1
- Trim around glazing bar if required.
- Then insert this and glazed unit into the jack rafter.



- Slide this assembly so that the glazed unit rests on the hip.
- Place a fixing through the jack rafter into the hip as shown above.
- Continue process until all jack rafters are fitted.

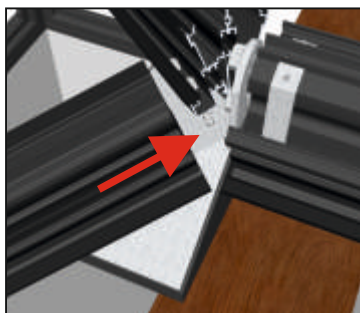
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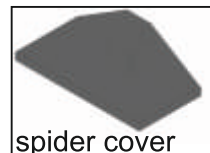
## Step Eight

# DURATION WINDOWS

### Fit Spider Cover



- Place spider cover into position and fix in place through the pre-drilled hole on the spider (using a self tapping screw).
- Repeat this at the other end of the roof.
- We advise this is fitted before glazing the entire roof.

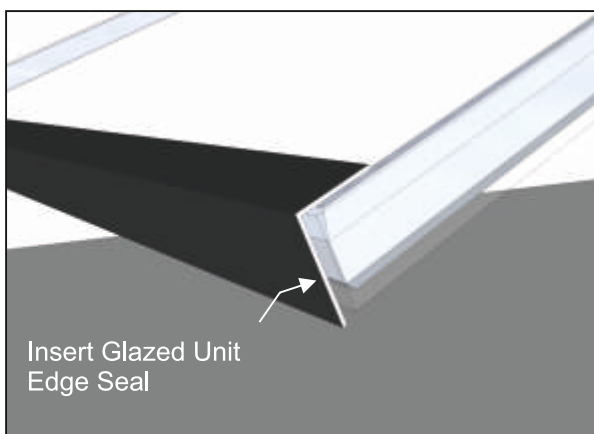


### Ring Beam Infill

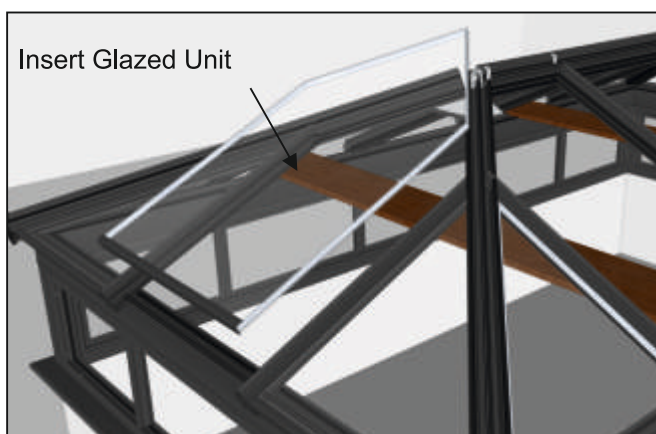


- Knock ring beam infill (ABD248) into position on the ring beam with a nylon hammer.
- Knock it hard into place between each glazing rafter.
- Continue until all infill are snapped into place.
- **Ensure to silicone all joints.**

### Glazing



- Insert ABD140 edge seal into place at the bottom of the sealed unit.
- If needed trim edge seal to allow unit to sit flush on the rafter.

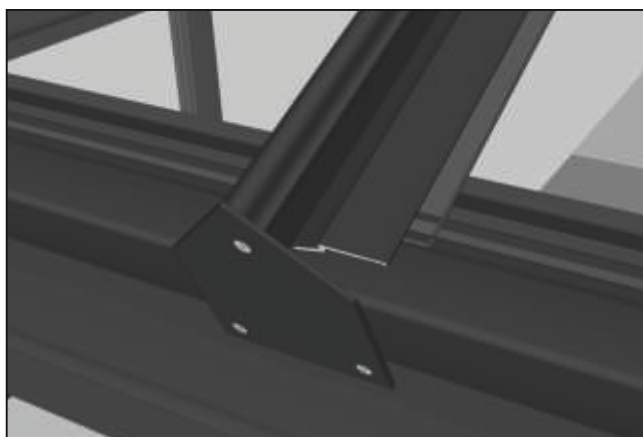


- Insert glazed sealed unit into position. The glazed units will be labelled according to the paper work provided.
- Glazed units should also be labelled with information detailing which way up the units should be installed. (This will be important if using different types of glass such as self cleaning)
- With self cleaning glass use a special silicone.
- Continue process until all glazed sections are in place.

## Step Nine

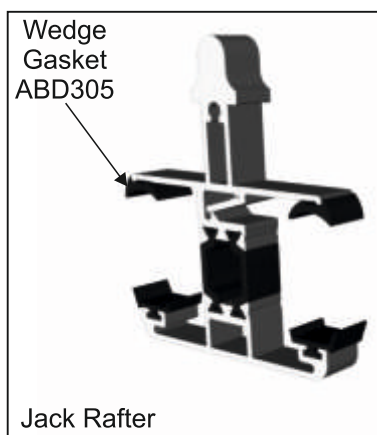
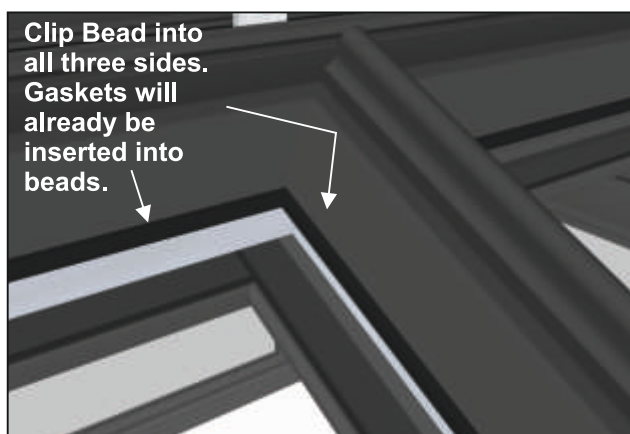
# DURATION WINDOWS

### Beading Jack Rafters



- First clip the jack rafter bead (ABD244) into the jack rafter.

### Beading Rafters And Gaskets

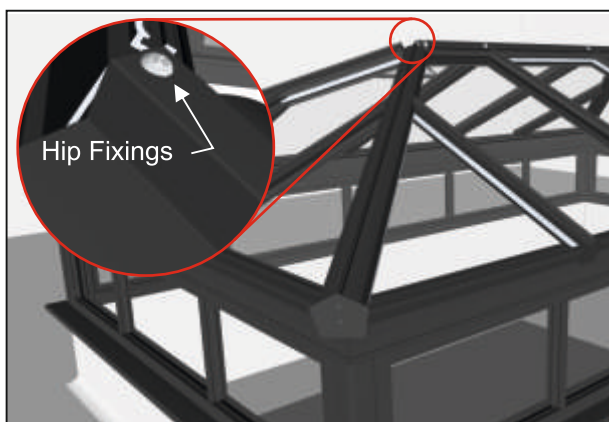


- First clip the glazing bead (ABD210) into the ridge adapter situated at the top of the glazed unit.
- Then clip the two side beads into place.
- **Please note gaskets that seal against the glass will be pre-installed at our factory unless stated otherwise.**
- For glazing a rafter next to jack rafter first clip glazing bead into the ridge adapter at the top of the unit. Then clip the bead into the normal glazing rafter and hip.
- The jack rafter has its own bead which should already have been clipped into place as shown above.
- Most gaskets used between the beads and glass are pre-installed at our factory.
- For jack rafters and transoms wedge gaskets are used.
- These will need to be installed on site once glazed.
- Gaskets will be mitred to suit.
- 28mm Glazed unit:  
ABD305 - Jack Rafter + Transom
- 24mm Glazed Units:  
ABD304 - Jack Rafter + Transom

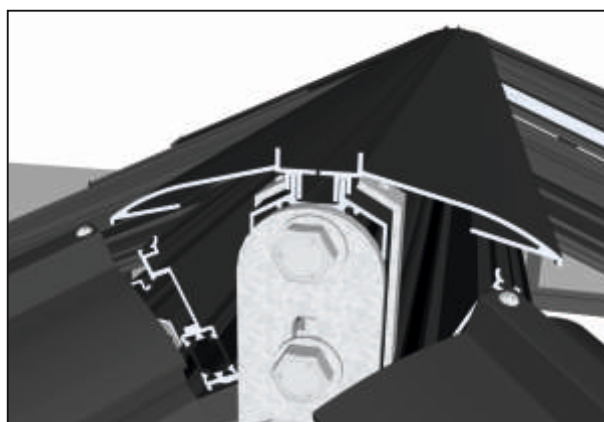
## Step Ten

# DURATION WINDOWS

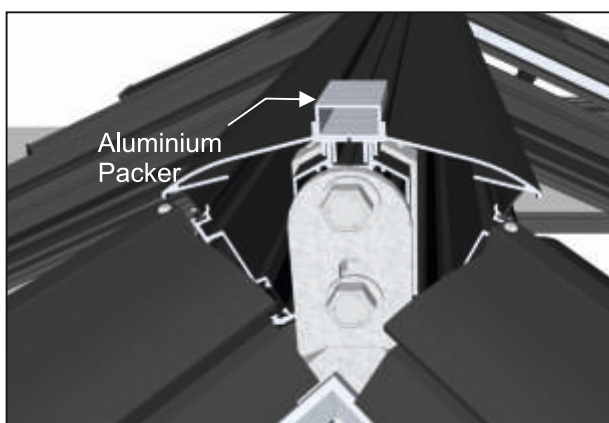
### Caps



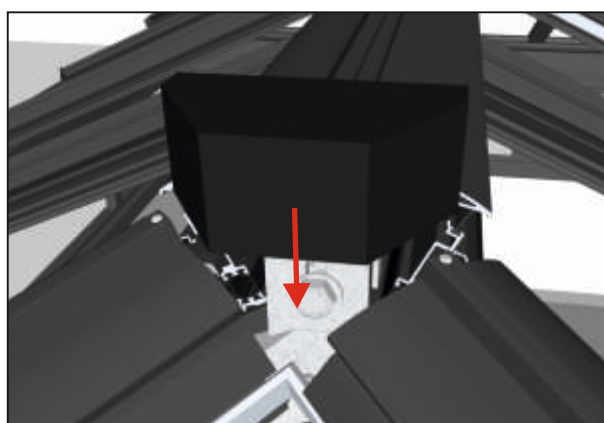
- Fix the hip covers into place. These are screw fixed using the holes provided.
- This is done at both ends of the lantern.



- Next fit the ridge covers into place.

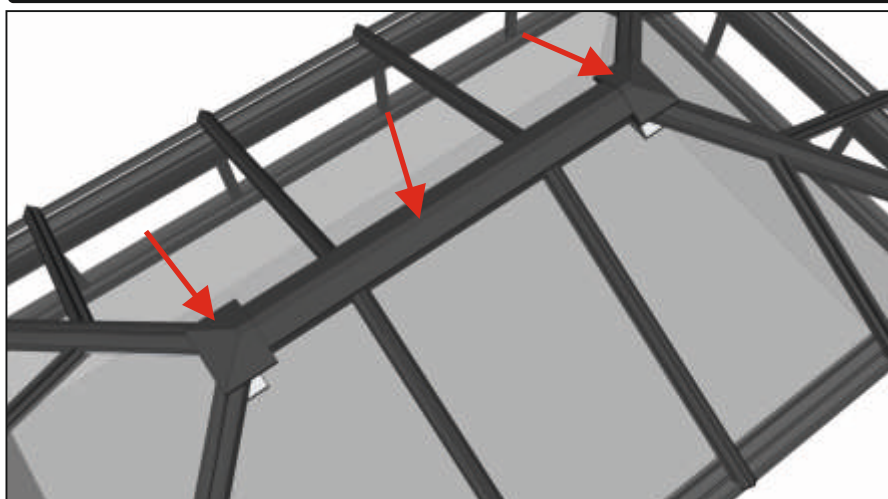


- Place aluminium packer as show. This is the fixing point for the final covers which are fitted after.
- This is done at both ends of the lantern.



- Insert foam bun as shown above.
- This is done at both ends of the lantern.
- **Ensure to silicone all screws in place to create tight water seals.**

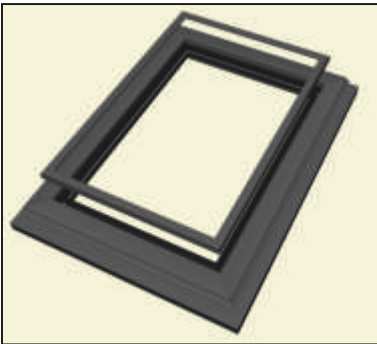
### Fix Final Caps



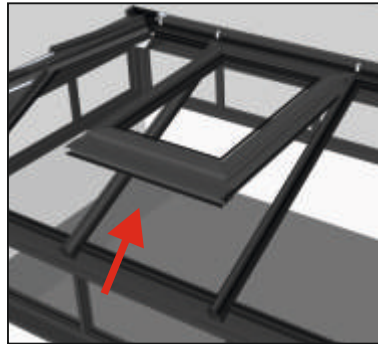
- Finally screw fix the remaining three covers to the top of the roof.  
(Indicated by the arrows on the image to the right)
- **Ensure to silicone all screws in place to create tight water seals.**



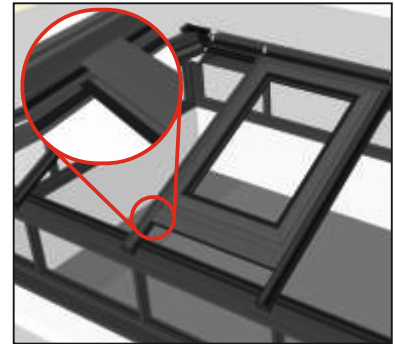
## Installing A Roof Vent



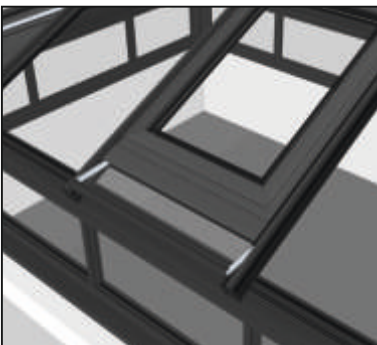
- Roof vent/s will come pre-assembled and unglazed.
- Step one remove beads.
- Please seal all joints on site for weather tightness.



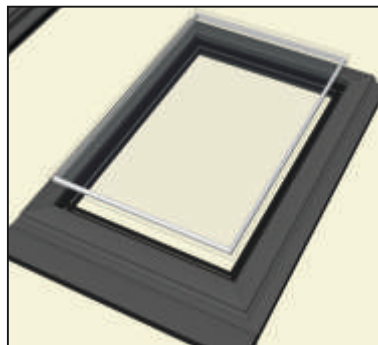
- Lift the vent into position and add transom.



- Glazing bars are pre-prepared for the transom to sit flush
- Bed transom down with silicone onto glazing bar.



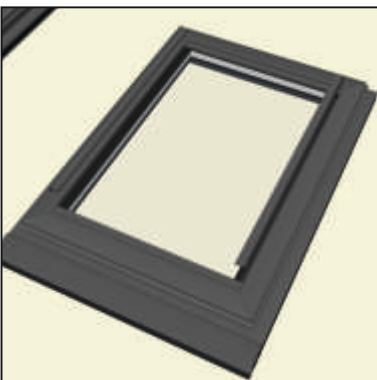
- Insert glazed unit into transom.
- Slip end cap onto glazing.
- Bead as normal: Top first then either side. (This secures the vent and bottom glazed unit in place)
- Gaskets used to seal against the glass / vent will be pre inserted in our factory ready for installation.



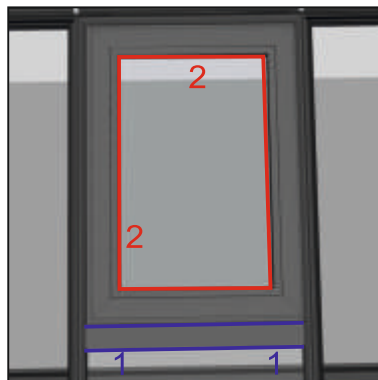
- Insert glazed unit into roof vent.



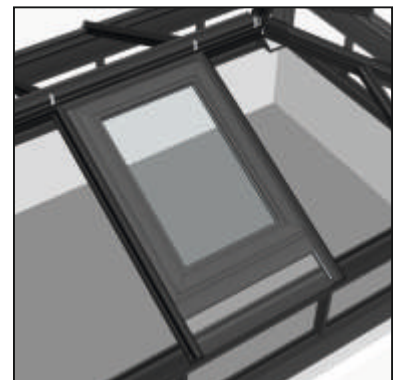
- Snap top and bottom beads into place.



- Snap side beads into place.



- Gasket all components.
- 1: use ABD305 (or ABD304)
- 2: use ABD302 (or ABD301)



- Once installed continue glazing the rest of the roof.

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