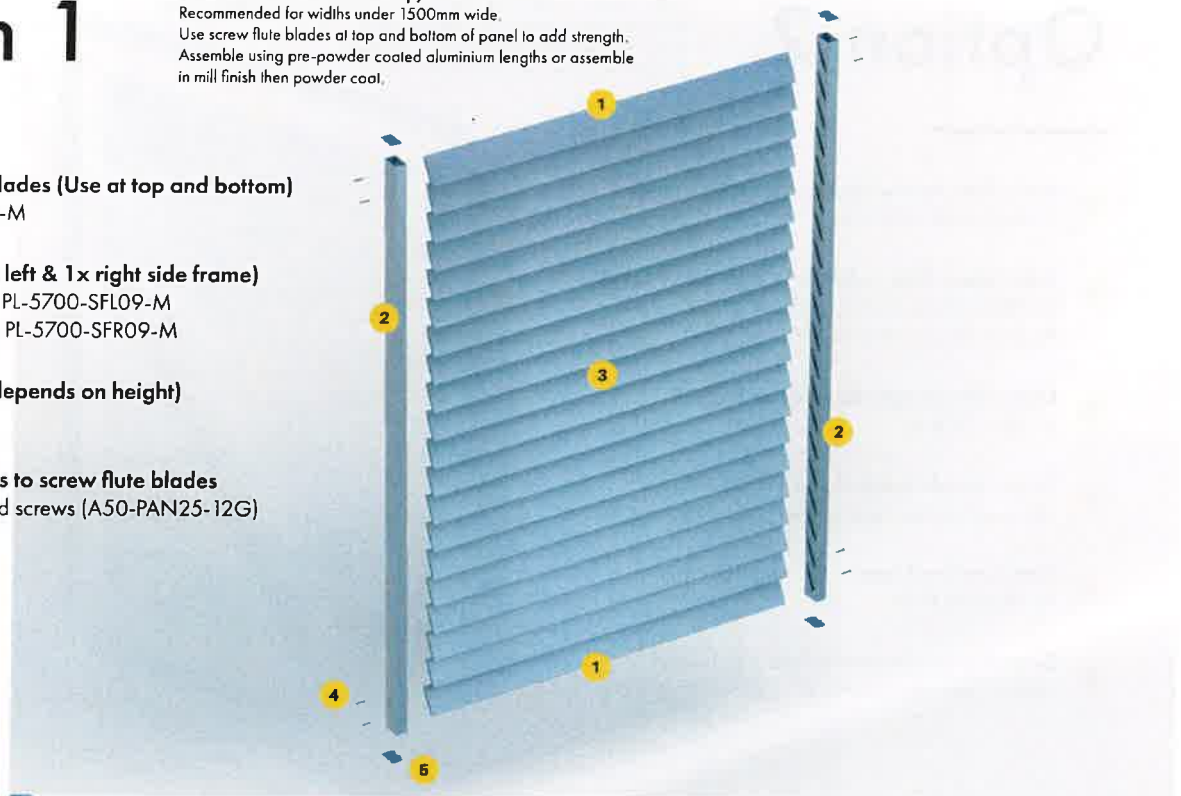


ASSEMBLY CONFIGURATIONS

Option 1

Panel without midrail or top/bottom frame.
 Recommended for widths under 1500mm wide.
 Use screw flute blades at top and bottom of panel to add strength.
 Assemble using pre-powder coated aluminium lengths or assemble in mill finish then powder coat.

- 1 **Screw flute louvre blades (Use at top and bottom)**
 PL-5800-B88SCREW-M
- 2 **Side frames (Use 1x left & 1x right side frame)**
 PL-5800-SFL00-M or PL-5700-SFL09-M
 PL-5800-SFR00-M or PL-5700-SFR09-M
- 3 **Louvre blades (qty depends on height)**
 PL-5800-B88-M
- 4 **Screw fix side frames to screw flute blades**
 12G x 25mm pan head screws (A50-PAN25-12G)
- 5 **Frame caps**
 PL-FC-B/S/W



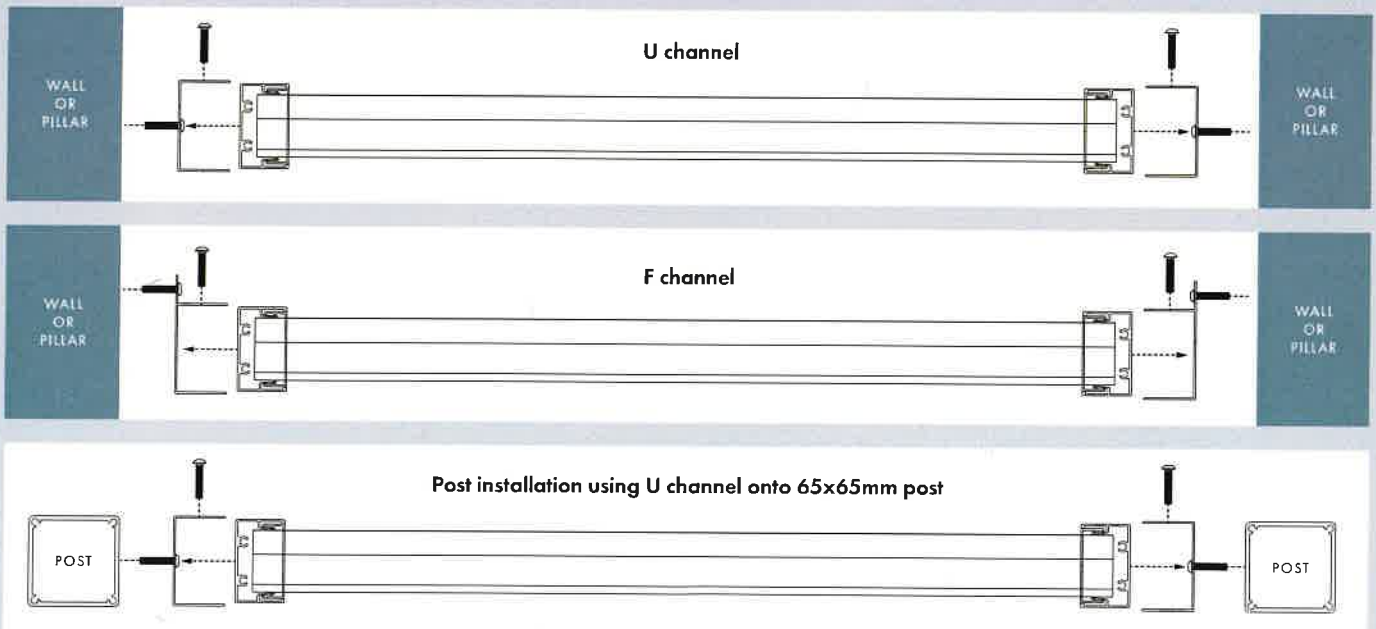
ASSEMBLY AID

Side frame jig (for screw flute blades)
 PL-JIG-SF

Use side frame jig to accurately drill holes in side frame for securing top and bottom screw flute louvre blades

Simply place jig against screw flute blade to locate position of screw flutes. 6mm pilot holes required

SIDE FRAME FIXING OPTIONS

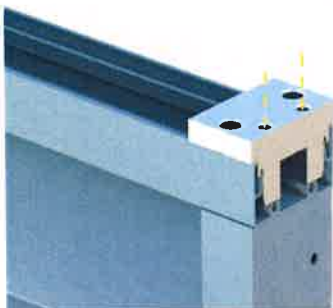


ASSEMBLY CONFIGURATIONS

Option 2

Fully framed panel with top/bottom frame but without midrail.
 Recommended for widths under 1500mm wide.
 Use screw flute blades at top and bottom of panel.
 Assemble in mill finish and then powder coat.

- 1 Screw flute louvre blades (top and bottom)**
 PL-5800-B88SCREW-M
- 2 Side frames (Use 1 x left & 1 x right side frame)**
 PL-5800-SFL00-M or PL-5700-SFL09-M
 PL-5800-SFR00-M or PL-5700-SFR09-M
- 3 Louvre blades (qty depends on height)**
 PL-5800-B88-M
- 4 Screw fix side frames to screw flute blades**
 12G x 25mm pan head screws (A50-PAN25-12G)
- 5 Non-machined frame (top and bottom)**
 PL-5800-NMF-M
- 6 Screw fix top/bottom rails to side frames**
 12G x 25mm pan head screws (A50-PAN25-12G)



ASSEMBLY AID

Drill jig
 PL-JIG

Use small holes in Drill Jig to accurately drill holes in top and bottom frame for securing top and bottom frames to side frames.

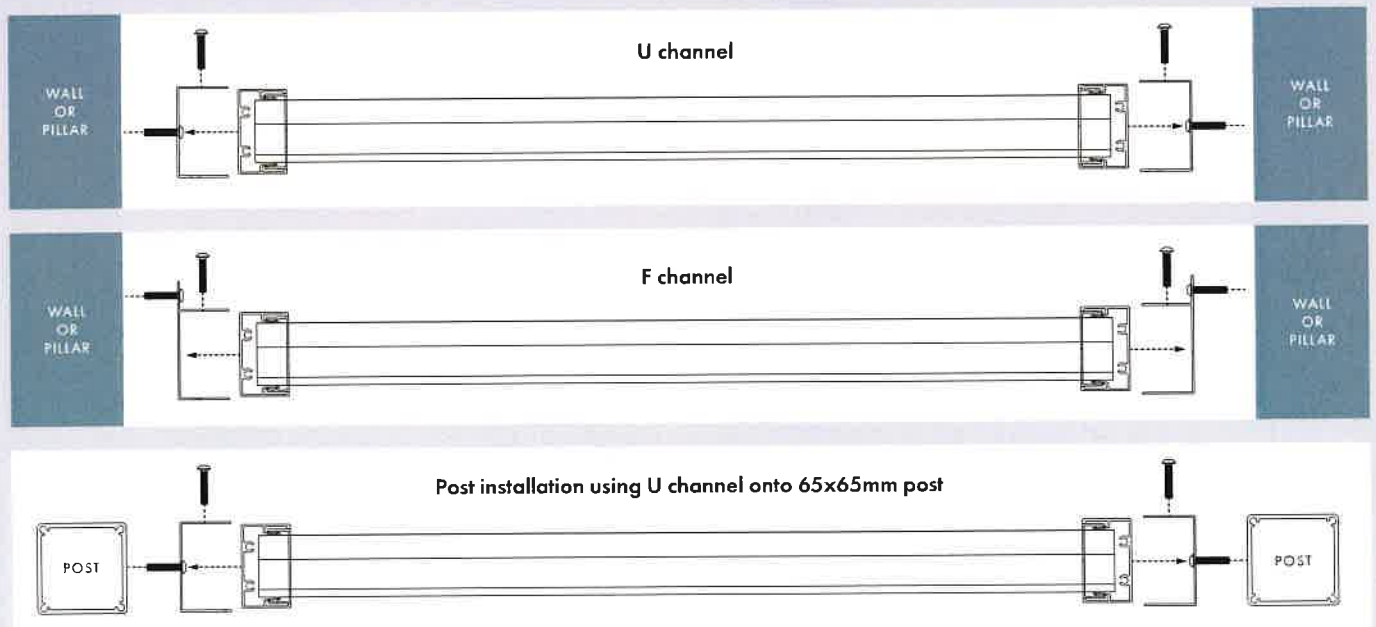


Side frame jig (for screw flute blades)
 PL-JIG-SF

Use side frame jig to accurately drill holes in side frame for securing top and bottom screw flute louvre blades

Simply place jig against screw flute blade to locate position of screw flutes. 6mm pilot holes required

SIDE FRAME FIXING OPTIONS



ASSEMBLY CONFIGURATIONS

Option 3a

Fully framed panel with top/bottom frame and midrail.
Midrails required for wider spans. Position midrails at maximum 1500mm blade spans. Midrail required to be welded or riveted to each blade. Assemble in mill finish and then powder coat.

IMPORTANT
Multiple midrails may be used on wider span panels

WELDED MID RAIL / PANELS WIDER THAN 1400MM

- 1 Side frames (Use 1x left & 1x right side frame)
PL-5800-SFL00-M or PL-5700-SFLO9-M
PL-5800-SFR00-M or PL-5700-SFR09-M
- 2 Louvre blades (qty depends on height)
PL-5800-B88-M
- 3 Slotted mid rail
PL-5800-MR00-M or PL-5800-MR09-M
- 4 Non-machined frame (top and bottom)
PL-5800-NMF-M



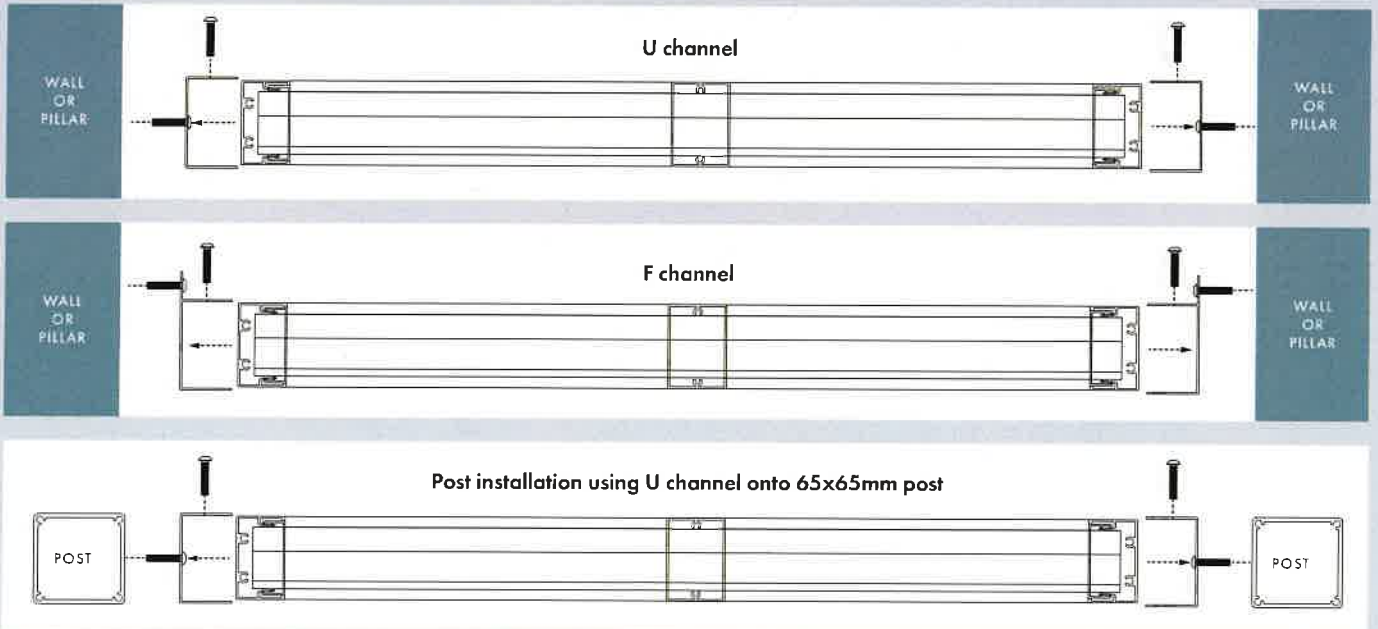
*Screw fluted blades at top and bottom position of panel may be used if desired. If welding midrail, commonly side frames would be also welded to blades therefore removing need for screw fixing side frame to top/bottom blades. Similarly, the top/bottom frame may be screw fixed to side frames but commonly would be welded in this instance. Refer previous page for overview of screw fixing to top and bottom non-machined frame to side frames.

3 SLOTTED MID RAIL INFO

1 piece midrail slotted both sides. Slide midrail(s) along louvre blades to desired position. Requires welding or riveting each louvre blade to the midrail.
Suggested to assemble with top/bottom frame to provide a fully framed panel.
Fully assemble panel in mill finish and then powder coat.



SIDE FRAME FIXING OPTIONS



ASSEMBLY CONFIGURATIONS

Option 3b

Fully framed panel with top/bottom frame and centre support rail (CSR).
 CSR does not require welding to blades. CSR required for wider spans
 Position CSR at maximum 1500mm blade spans.
 Assemble in mill finish and then powder coat.

CENTRE SUPPORT RAIL / PANELS WIDER THAN 1400MM

IMPORTANT
 See page 18
 for assembly
 guidelines

- 1 Screw flute louvre blades (top and bottom)
 PL-5800-B88SCREW-M
- 2 Side frames (Use 1x left & 1x right side frame)
 PL-5800-SFL00-M or PL-5700-SFL09-M
 PL-5800-SFR00-M or PL-5700-SFR09-M
- 3 Louvre blades (qty depends on height)
 PL-5800-B88-M
- 4 Centre support rail
 PL-5800-CSR00-M or PL-5700-CSR09-M
- 6 Screw fix side frames to screw flute blades
 12G x 25mm pan head screws (A50-PAN25-12G)
- 6 Non-machined frame (top and bottom)
 PL-5800-NMF-M
- 7 Screw fix top/bottom rails to side frames
 12G x 25mm pan head screws (A50-PAN25-12G)
- 8 Screw fix top/bottom rails to centre support rails
 8G x 25mm pan head screws (source as required)



4 CENTRE SUPPORT RAIL INFO

Innovative 4 part centre support rail is designed to apply even pressure to all louvre blades, providing support against sagging and preventing rattle.

Non-machined top/bottom frame must be used with centre support rail to provide a fully framed louvre panel. Welding blades to centre support rail is not required due to patented friction fit assembly.

ASSEMBLY AID

Drill jig
 PL-JIG

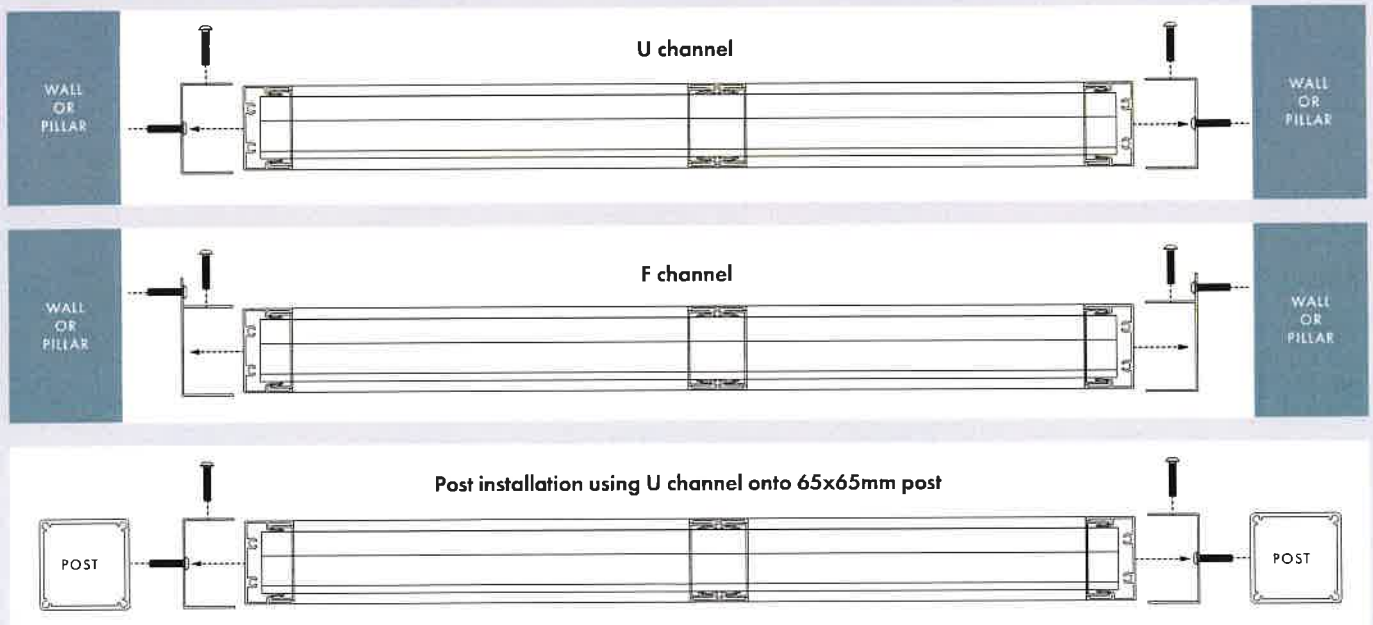
Use small holes in Drill Jig to accurately drill holes in top and bottom frame for securing top and bottom frames to side frames.
 Use large holes in Drill Jig to affix top/bottom frame to centre support rail

Side frame jig (for screw flute blades)
 PL-JIG-SF

Use side frame jig to accurately drill holes in side frame for securing top and bottom screw flute louvre blades

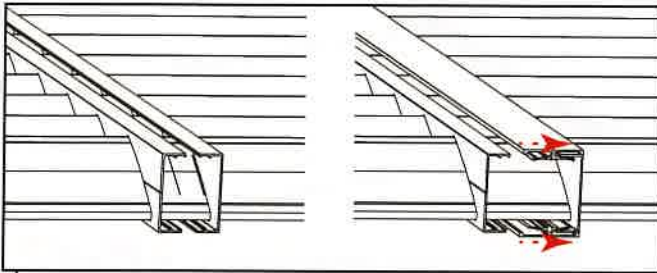
Simply place jig against screw flute blade to locate position of screw flutes. 6mm pilot holes required

SIDE FRAME FIXING OPTIONS

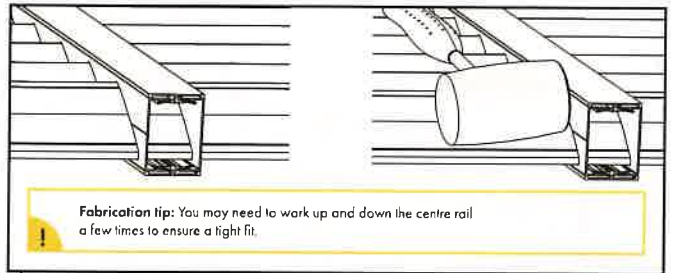


ASSEMBLY INSTRUCTIONS

NON-WELD CENTRE SUPPORT RAIL

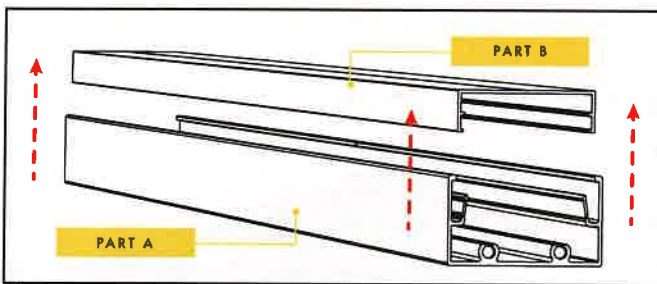


9 Lift screen into a vertical position. Line up one side of the CSR with the 20mm lines previously marked and snap in both gripping extrusions to this side of the CSR.

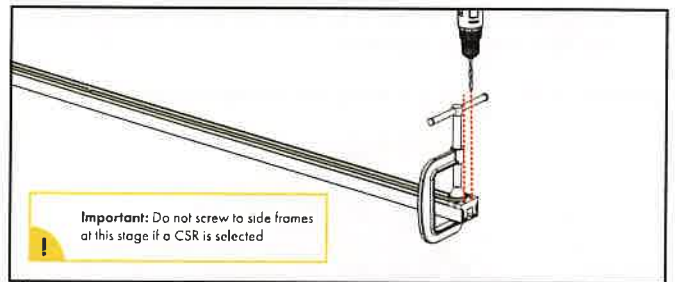


Fabrication tip: You may need to work up and down the centre rail a few times to ensure a tight fit.

10 Slowly slide the second punched frame across and into the gripping extrusions. Lightly tap the CSR working from top to bottom until the CSR is fully clipped together, ensuring the midpoint of the CSR is in line with previously marked centre line.

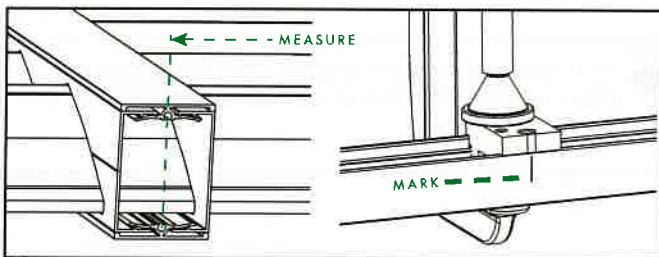


11 Select the non-punched top and bottom rails and place them on your work bench. Remove the unpunched extrusion (Part B) from the rail (Part A).

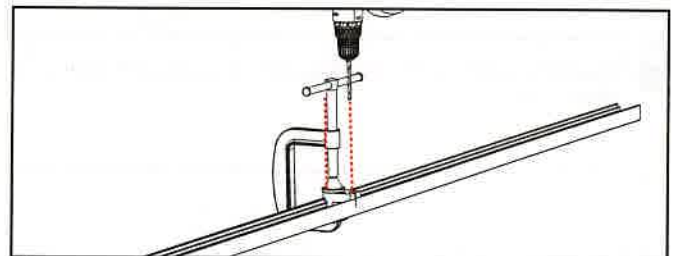


Important: Do not screw to side frames at this stage if a CSR is selected.

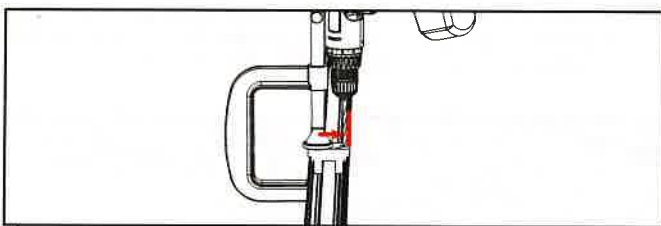
12 Line up the drill jig (PL-JIG) flush with the end of the extrusion, ensuring the 6mm holes in the drill jig are facing outwards. Clamp the jig into position and drill 2 x 6mm holes through the extrusion.



13 Check measure the positioning of the centre screw flute on the CSR's and mark accordingly on your top & bottom rails (Part A).



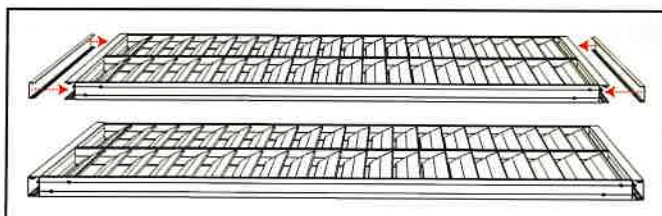
14 Using the 10mm holes on the drill jig, slide the jig along until the bottom of the guide slot lines up with your centre line mark. Secure jig with a clamp. Drill 2x 10mm holes to remove the internal side fins only. **DO NOT DRILL THROUGH THE BOTTOM OF THE EXTRUSION.** Repeat this step for every CSR position both top & bottom.



15 With the jig in position, place a 4mm drill bit against the outer side of the 10mm hole. Drill through the bottom of the extrusion.



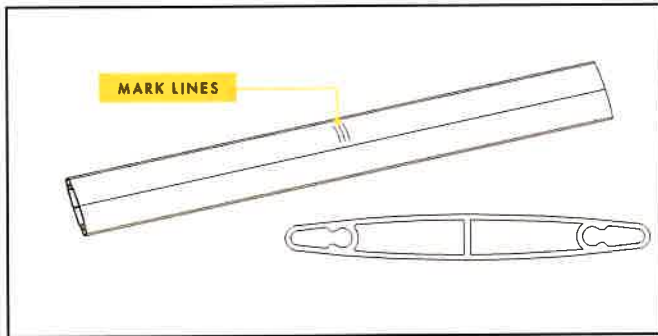
16 Place drilled extrusion on top of your built louvre frame aligning holes with the screw flutes in the punched side frames & CSR's and secure with appropriate screw types: Side frame fixings - 12G x 25mm pan head screws
CSR fixings - 8G x 25mm pan head screws
Flip screen and repeat the above process. Check measure diagonally to ensure screen is square.



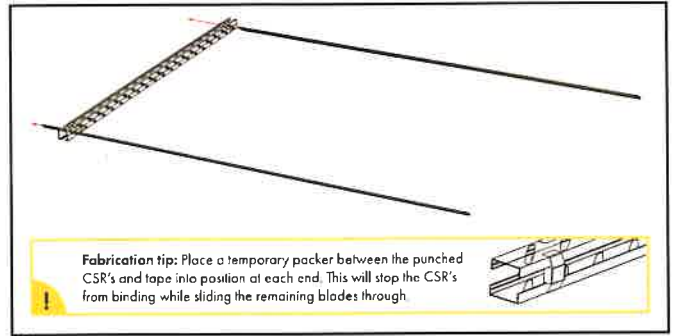
17 Snap on the unpunched extrusion (Part B) to complete the top & bottom rails.

ASSEMBLY INSTRUCTIONS

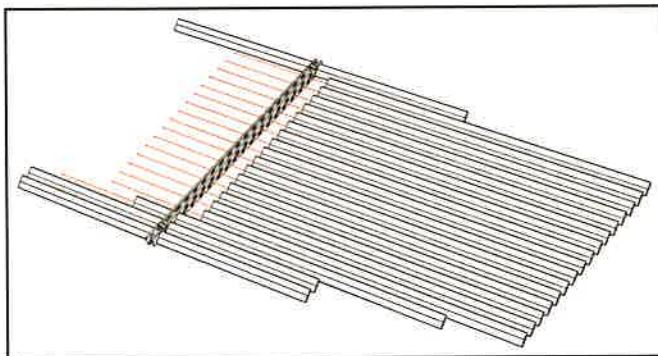
NON-WELD CENTRE SUPPORT RAIL



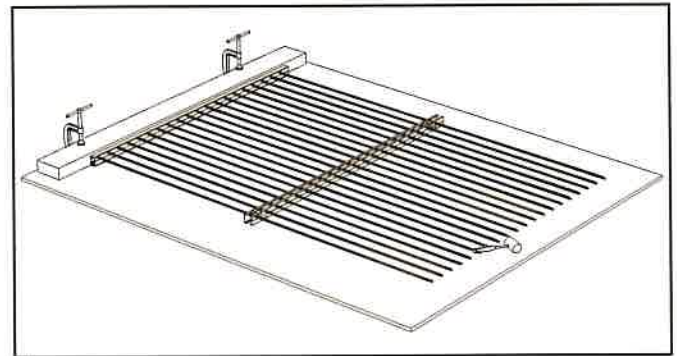
1 When using Centre Support Rail (CSR) - for use with spans over 1500mm wide - select screw fluted blades for top and bottom of screen. Measure and mark both the top and bottom fluted blades where the CSR is to be positioned. Also mark 20mm either side of centre line.



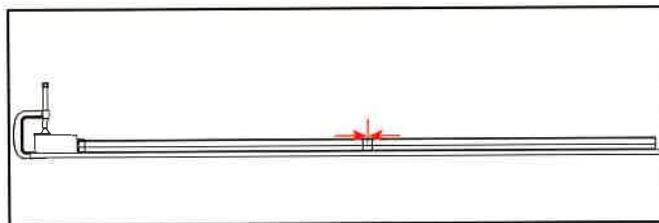
2 Laying the extrusions flat, position the two punched extrusions of the CSR at the approximate position of the centre line. Slide the top and bottom screw fluted louvre blade through the punched CSR's.



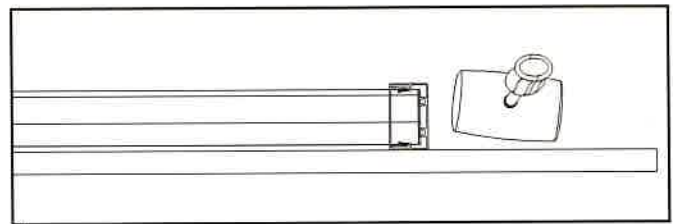
3 Thread all blades through the remaining punched holes inline with your top and bottom blades.



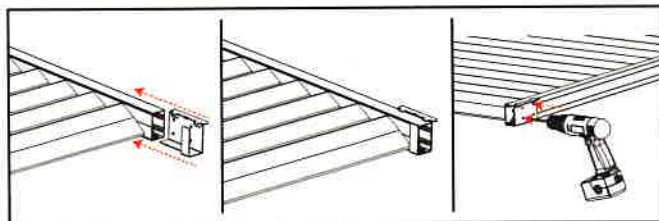
4 Place one Punched side frame hard against a clamped straight edge and position all blades into punched side frame. Lightly tap all blades until hard against the screw flutes.



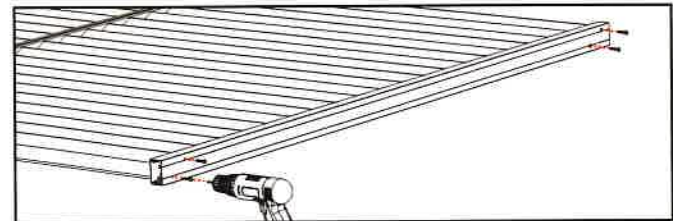
5 Re-position the CSR's above the centre line as they will have moved.



6 Line up the second punched side frame with the blades, lightly tap the frame into position working from one end to the other. The side frame will not be in its final position in one action. Lightly tap up and down the side frame a few times until all louvre blades are hard against the internal screw flutes.



7 Using a hardened drill bit, drill 6mm hole into the side frame at all screw fluted blade locations using the side frame drill jig (PL-JIG-SF).
NOTE: Ensure the jig "tongue" sits hard against the outer blade and "tabs" are held flat to the side frame.



8 Spray a lubricant into these hole and drive 12g x 25mm pan head screws into all screw flutes. Check measure diagonally to ensure screen is square.