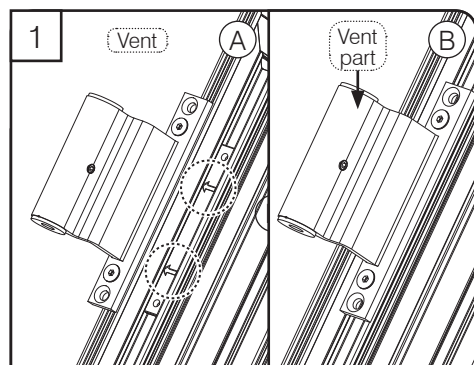
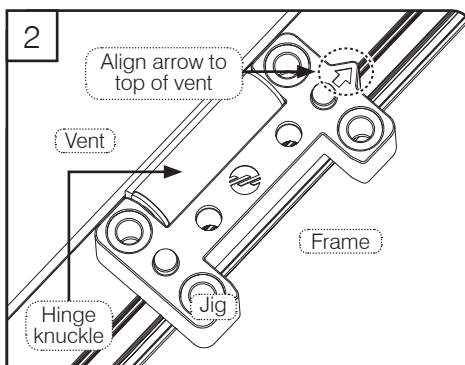


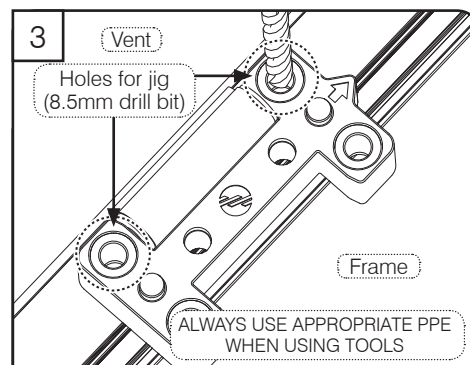
77IWE System - ALUK® Door & Window Hinge - Fitting Instructions



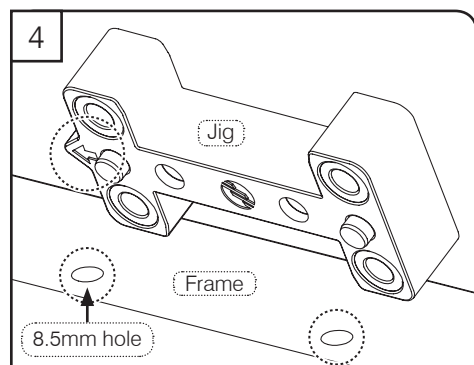
(A) Slide the locating brackets into the recess on the vent, ensure that the arrows point outwards. Position brackets in their desired locations. (B) Attach the vent parts using the supplied machine screws using a 2.5mm hex key.



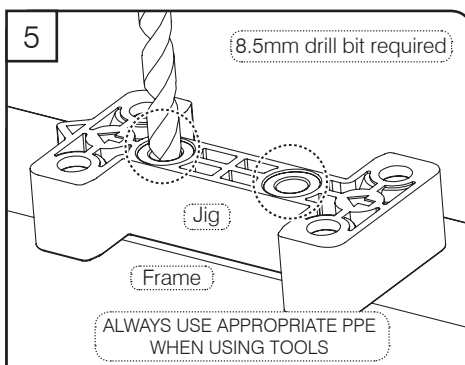
Centralise vent within frame, using appropriate packers or similar. Place the jig tightly over hinge knuckle with steel bosses face up & the jig flat on the frame. Ensure the arrow on the jig is pointing to the top of the frame.



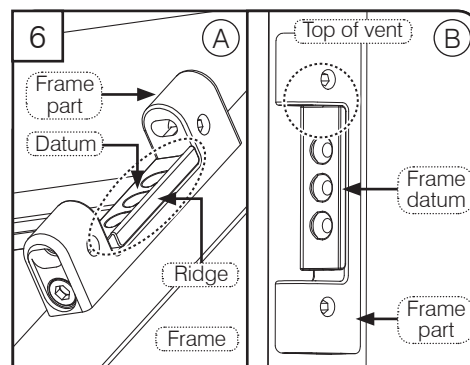
With the jig held tightly against the hinge knuckle, use a 8.5mm drill bit to drill a hole through the top skin of the frame. Repeat for the opposite end of the jig.



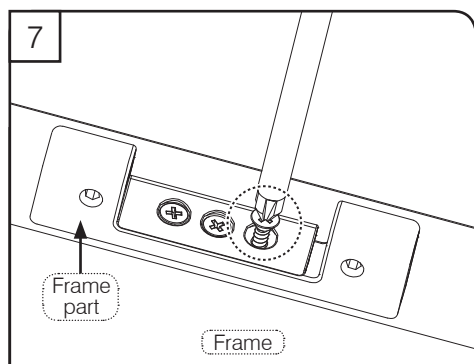
Remove vent & turn the jig over to locate the steel bosses into the 8.5mm drilled holes. Ensure the arrow on the jig is pointing to the top of the frame.



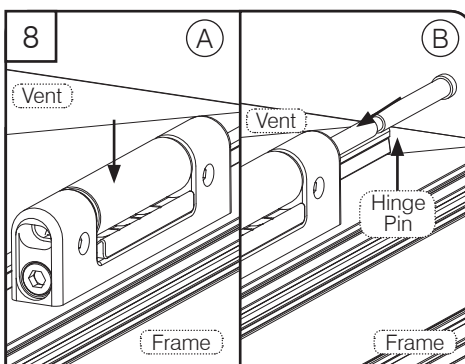
Using a 8.5mm drill bit, drill the two central holes on the jig. Only drill through the top skin of the frame. Then remove the jig.



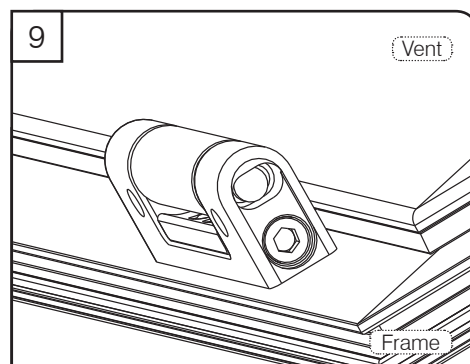
(A) Insert the frame datum into frame part, ensuring the ridge on datum is away from the vent and locate into the drilled holes on the frame. (B) Pull frame part downwards towards the bottom of the frame.



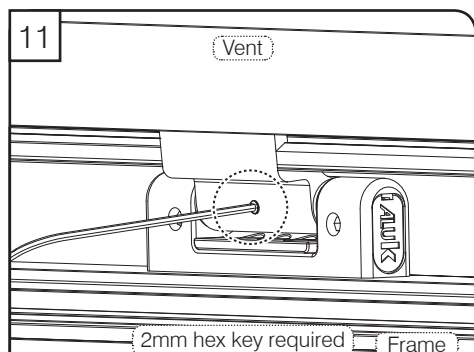
Secure frame datum with 3 appropriate screws, starting with the central screw first.



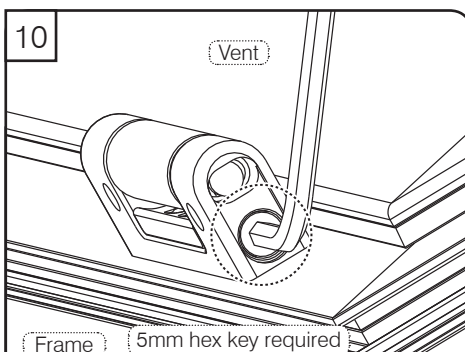
(A) Reposition the vent into the frame, aligning the hinge knuckle onto the frame part. (B) Insert hinge pin into the top of hinge. Repeat for all hinges.



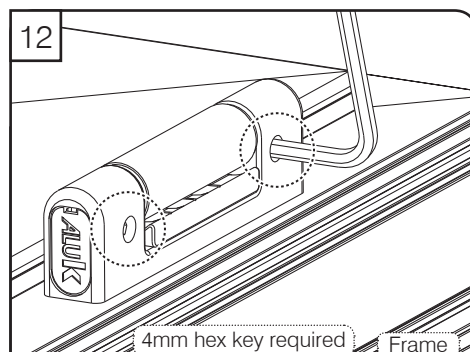
Ensure pin is fully recessed. Fit cover caps. Repeat for all hinges.



Open door and using a 2mm hex key, tighten security screw on all hinges.



Vertical adjustment: Remove the top cover cap, insert a 5mm hex key into the vertical adjuster screw. This screw allows up to 4mm of upwards adjustment. Adjust all hinges equally and refit the cover caps.



Lateral adjustment: Insert a 4mm hex key into the lateral adjuster screws, located on the side of the frame part. You will need to adjust both screws equally.