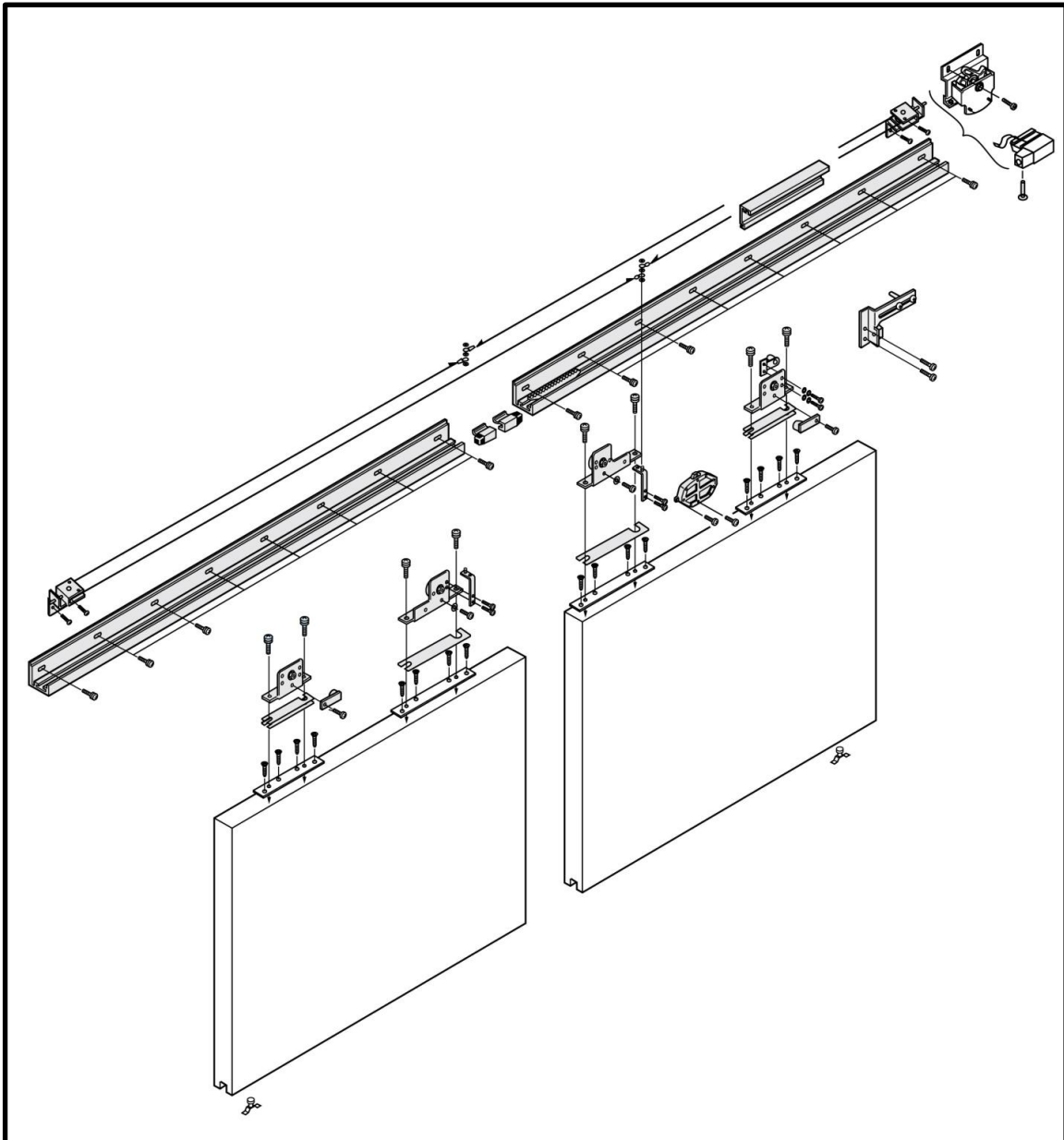
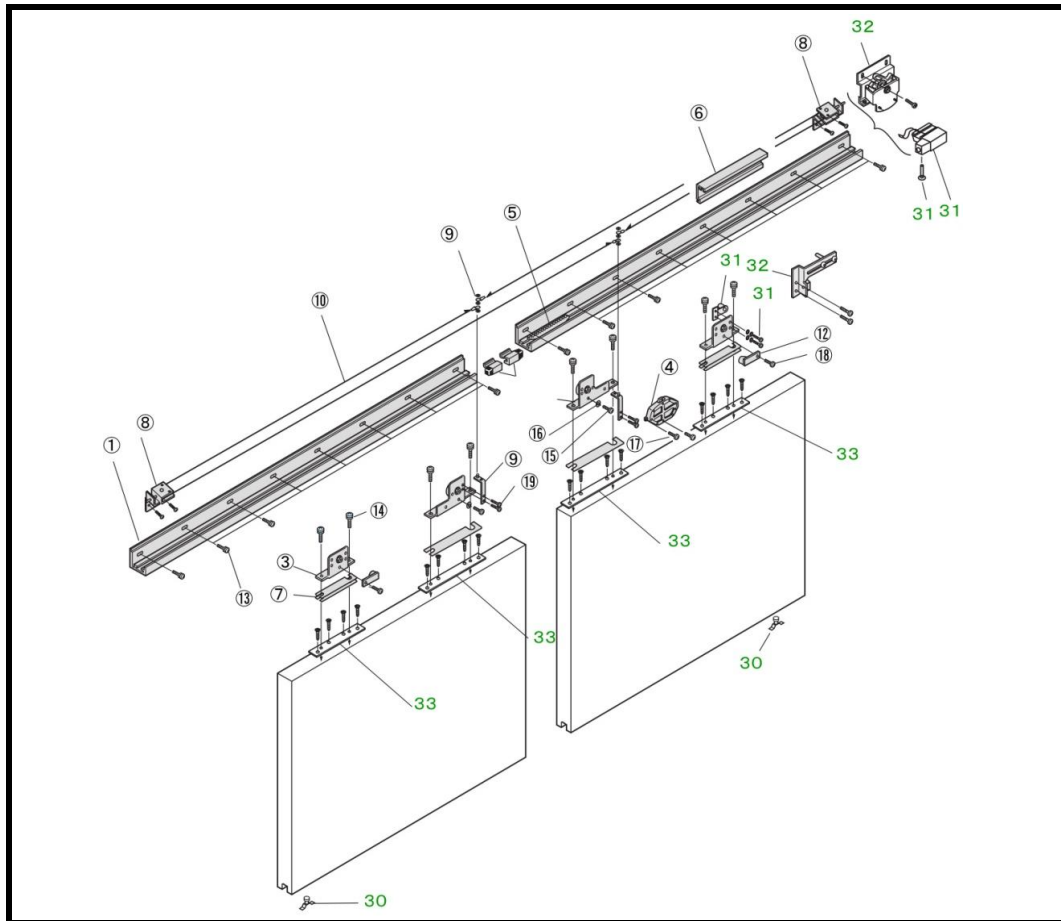


SLIDEX HCS Bi-PARTING

HCS-XW40A/HCS-XW40B

– INSTALLATION PROCEDURE –





<BASIC PARTS>

| | Name | Material | Number |
|---|------------------------------------|-------------------------------------|------------|
| ① | Aluminum rail (A=1600mm, B=2200mm) | Aluminum material | 2 |
| ② | Front hanger roller | Steel(chromate, resin) | 2 |
| ③ | Rear hanger roller | Steel(chromate, resin) | 2 |
| ④ | Hydraulic control | ADC12 and others | 1 |
| ⑤ | Braking rack | Resin(with G), Urethane | 1 |
| ⑥ | Rear side brake rack | Aluminum materials, Resin, Urethane | 1 |
| ⑦ | Height control plate | Steel(processed steel plate) | A=6, B=10 |
| ⑧ | Interlocking device | Steel(chromate, resin) | 2 |
| ⑨ | L type bracket | Steel(chromate) | 2 |
| ⑩ | Linking wire A=2520mm, B=3240mm | Stainless, nylon | 2 |
| ⑪ | Door stopper | Aluminum, rubber | 2 |
| ⑫ | Latch hexagon special bolt | Steel(chromate), resin | 2 |
| ⑬ | M5 x 16 pan head screw | Steel(chromate) | A=18, B=22 |
| ⑭ | M8 x 25 hexagon screw | Steel(chromate) | 8 |
| ⑮ | Latch hexagon special bolt | Steel(chromate) | 2 |
| ⑯ | Nominal 10 countersunk washer | Stainless | 4 |
| ⑰ | M5 x 16 pan head screw | Steel(chromate) | 2 |
| ⑱ | M10 x 12 hexagon bolt | Steel(chromate) | 2 |
| ⑲ | M5 x 10 pan head screw | Steel(chromate) | 4 |

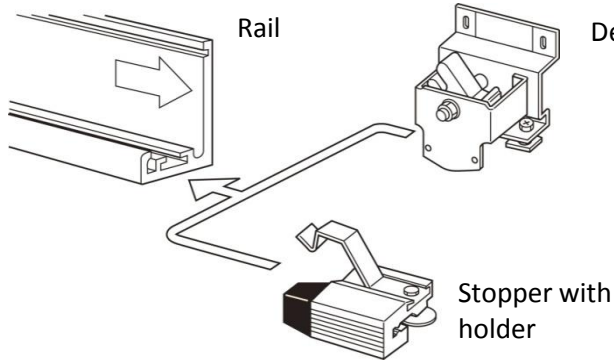
<OPTIONAL PARTS>

| | Name | Number |
|----|-----------------------------|--------|
| 30 | Guide roller | 2 |
| 31 | Door Stopper (for door end) | 1 |
| 32 | Delayed timer body | 1 |
| | Time adjusting plate | 1 |
| 33 | Wooden door plate | 1 |

This guide is for right hand opening of the door.
 Left hand opening is simply a mirror image.

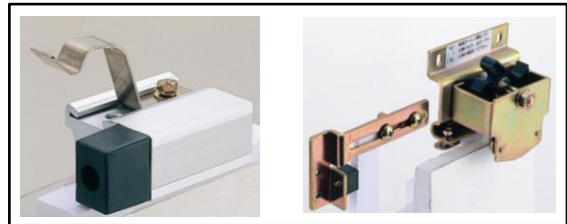
1. RAIL

① Install optional parts

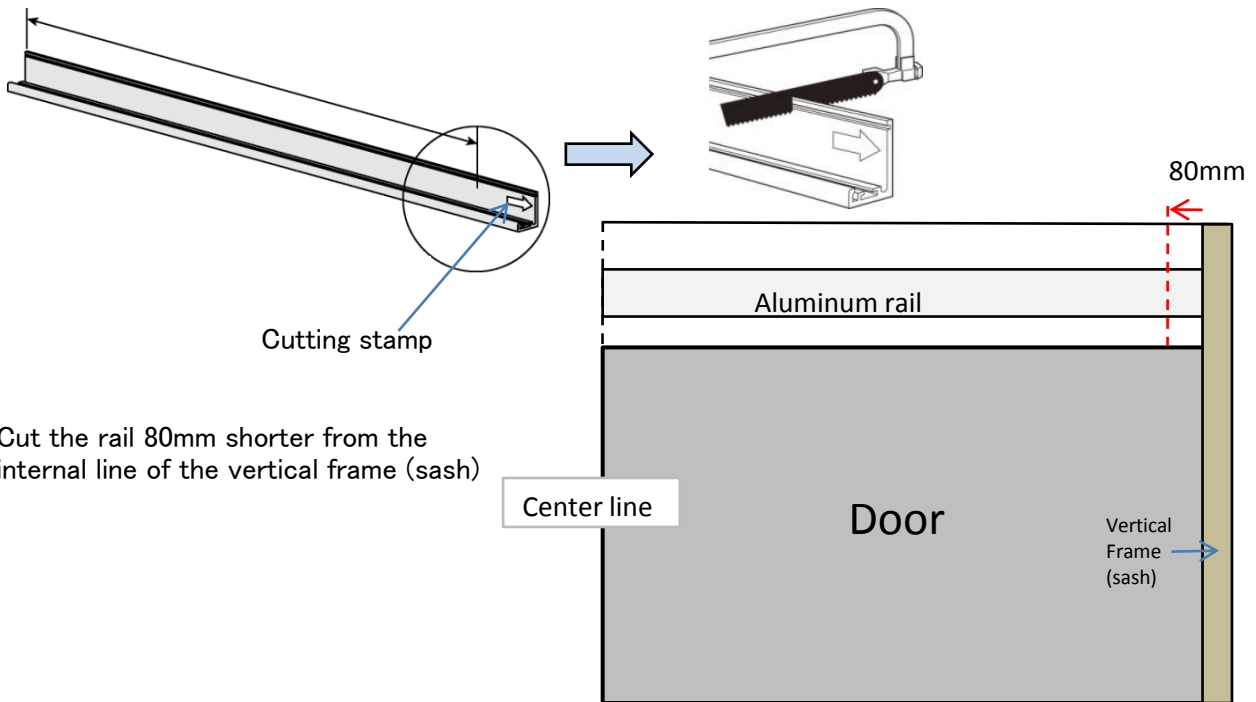


Delayed timer

Insert either Stopper with holder or Delayed timer.



② Cut rail (Cutting stamp side)



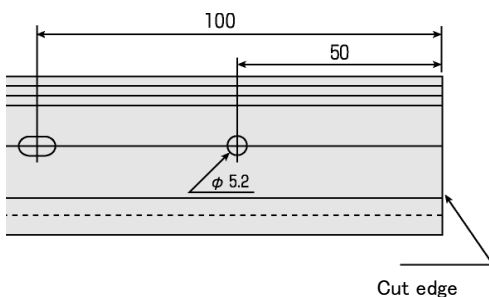
Cut the rail 80mm shorter from the internal line of the vertical frame (sash)

Center line

Door

Vertical Frame (sash)

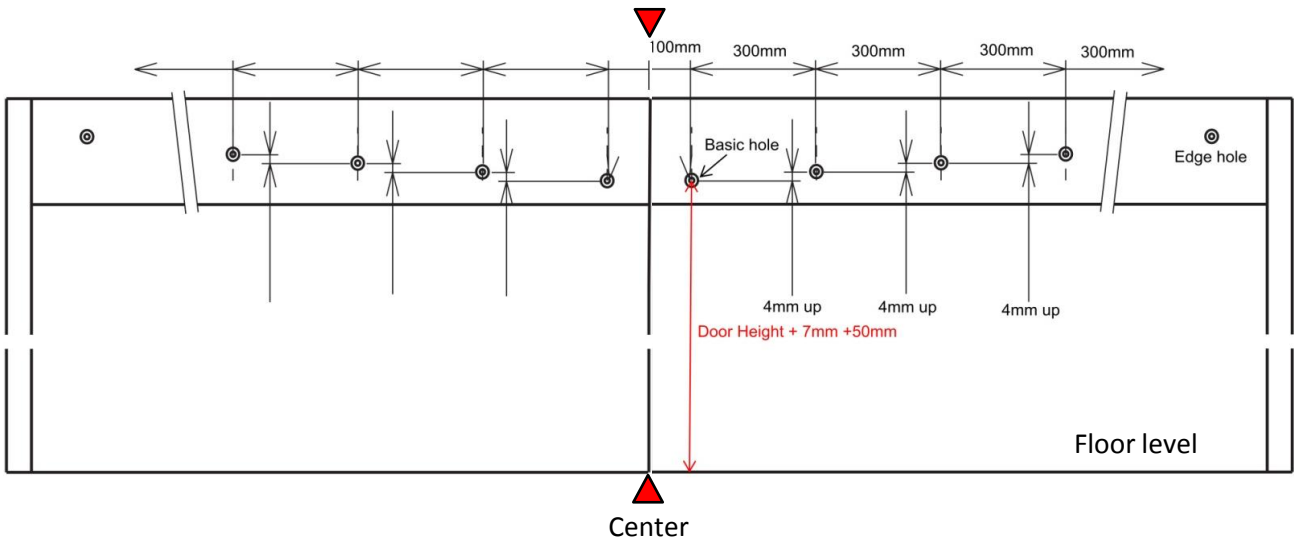
③ Set up the rear side screw hole



Cut edge

After cutting the rail, if the predrilled screw hole location becomes more than 100mm from cut edge, drill a 5.2mm \varnothing hole with the distance of 50mm from edge.

④ Provide taps (M5x0.8) to base plate



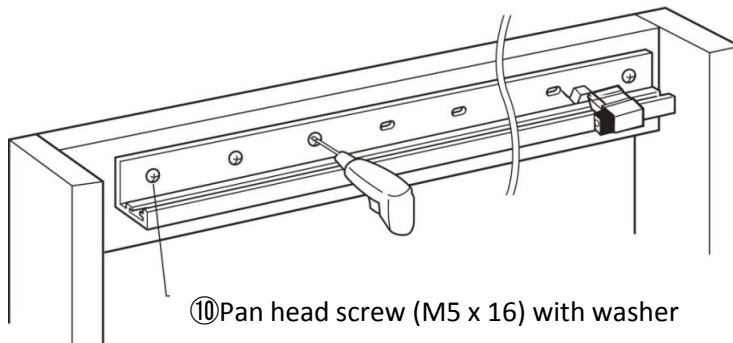
Base hole position

| | Height from floor | Distance from center line |
|-------------|--------------------------------|---------------------------|
| Metal door | Door Height + 7mm + 50mm | 100mm |
| Wooden door | Door Height + 7mm + 50mm + 6mm | 100mm |

* Wooden door is required to fit wooden door plates.



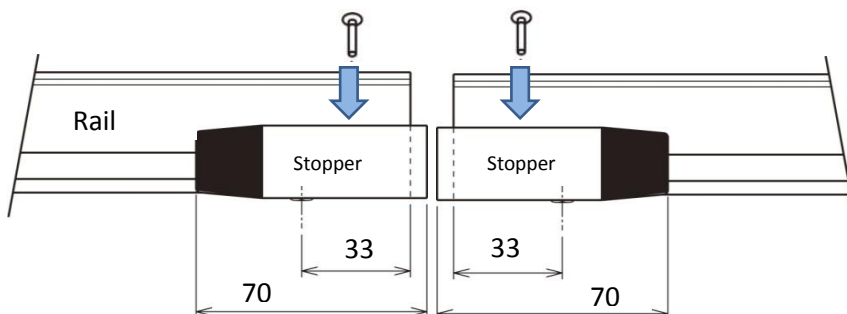
⑤ Fix the rail



1. Install the rail horizontally.
2. Pay special attention on the rail-surface where rollers run so that surface may not receive any damage.

⑥ Temporarily fixing stopper in center side

Temporarily fix stoppers with M4 hexa bolt to avoid dropping door.



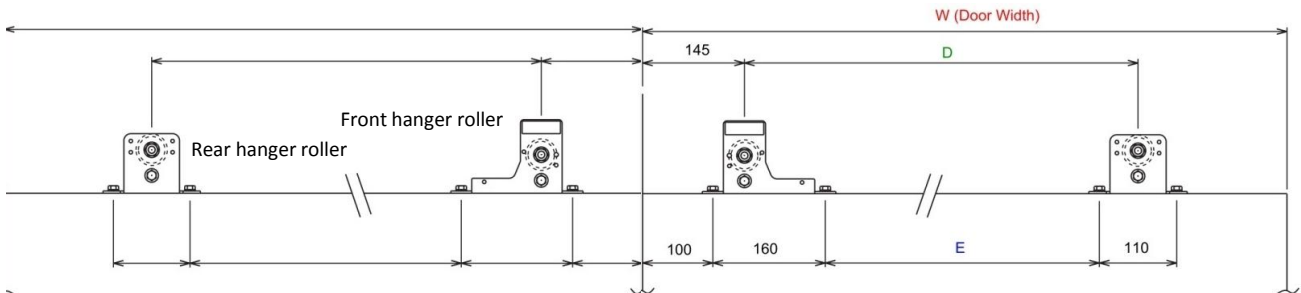
Don't do final fixing as suitable position would be changed.

3. HANGER ROLLERS

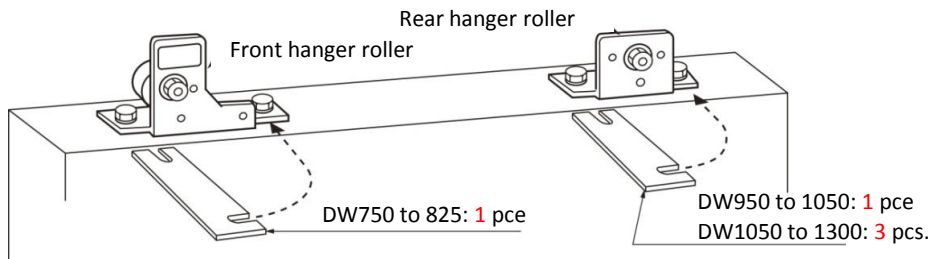
① Installation of Hanger rollers



Under the door being closed position.



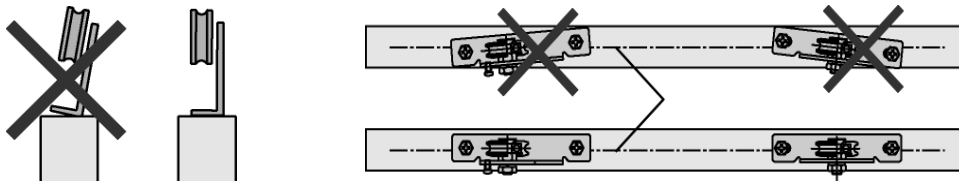
| | W (mm) | D (mm) | E (mm) | Height control plate |
|-----------|--------------|--------|--------|-----------------------|
| HCS-XW40A | 750 to 825 | 450 | 280 | 1 pce to front hanger |
| | 825 to 950 | 525 | 355 | Unnecessary |
| HCS-XW40B | 950 to 1050 | 600 | 430 | 1 pce to rear hanger |
| | 1050 to 1300 | 750 | 580 | 3 pcs to rear hanger |



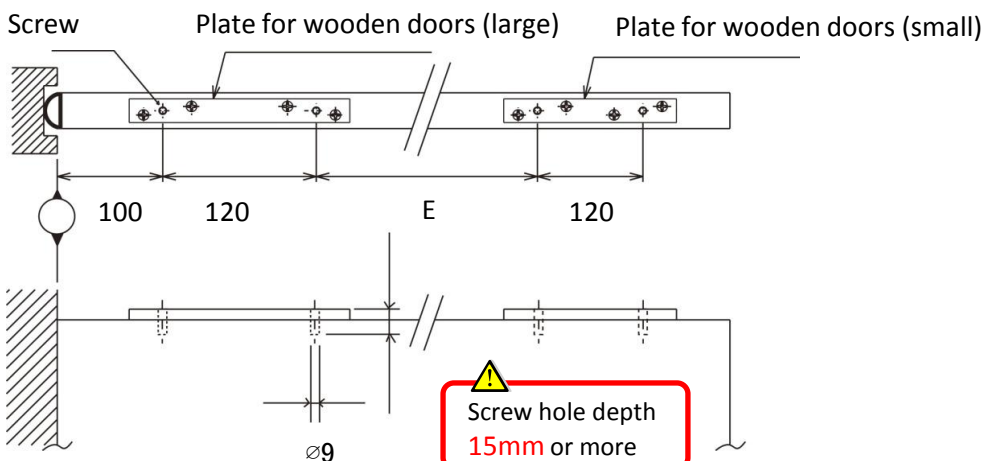
In case of wooden door, insert the plates between wooden door plate and hanger roller.



Ensure the hangers are fixed squarely and in line with the door.



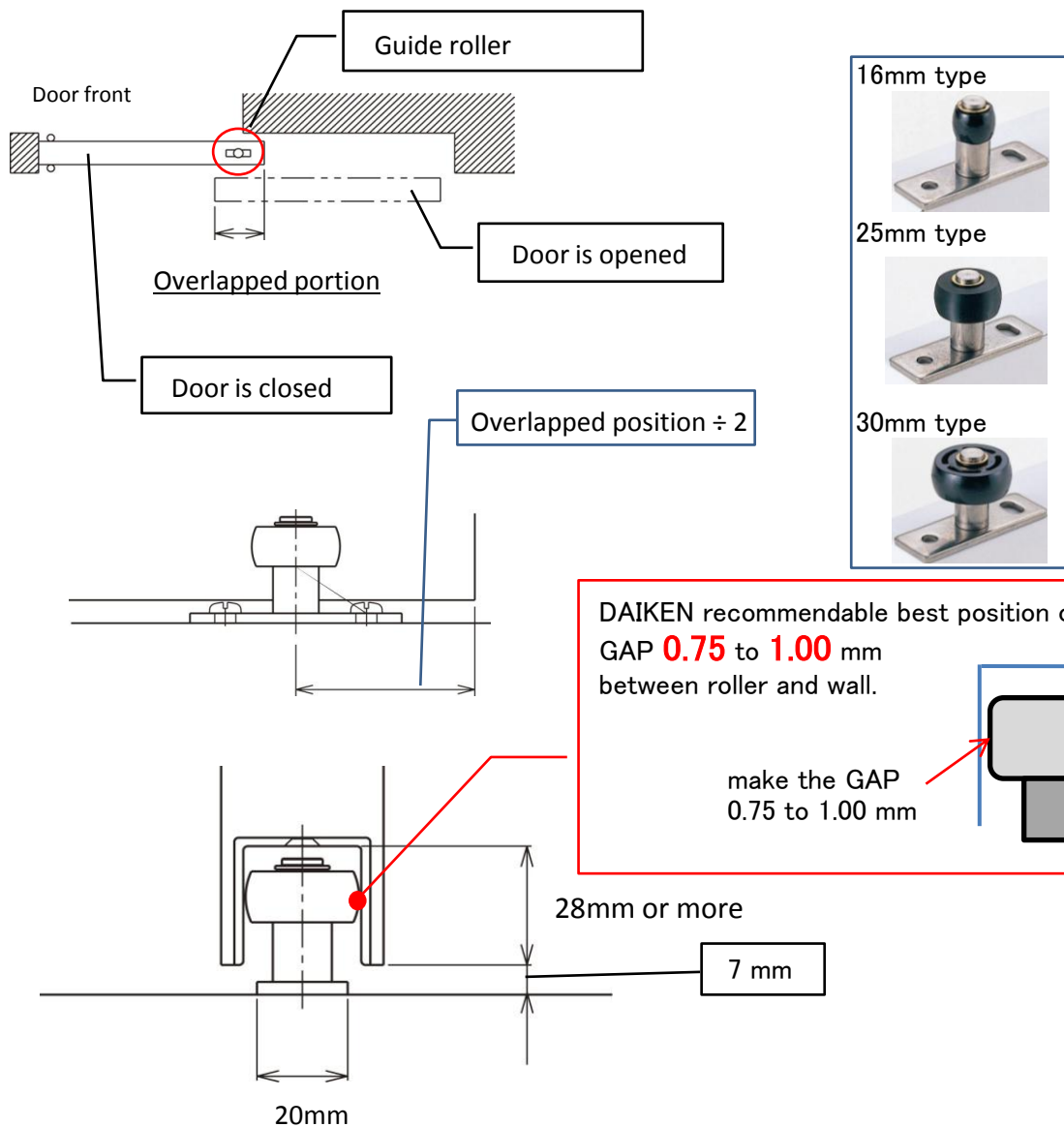
② Wooden door



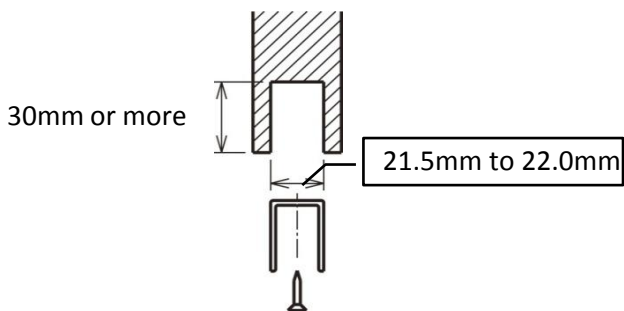
② Installation of the guide roller

***If not fixing guide roller, door would be unstable.**

Install the guide roller at the center of overlapped portion.



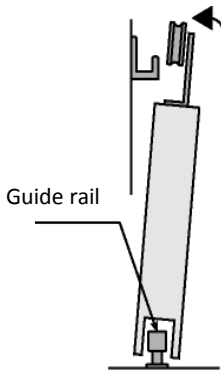
③ Installation of guide rail (option parts)



1. Cut the guide rail by aligning it with the wooden door width.
2. Cut in the bottom portion of the wooden door, and install the guide rail with the attached screw.

⚠ Guide rollers other than 16 diameter cannot be used.

5. DOOR HANGING

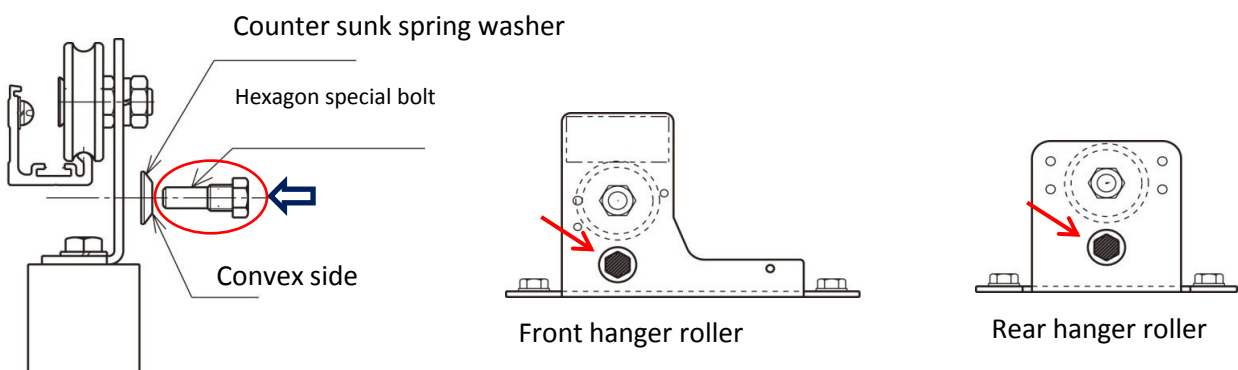


1. Fit the guide roller with the bottom portion of the door.
2. Hang the sash rollers on the rails.
3. Check that the door can slide smoothly and that there are no clearance problems.



1. Take care so that the rail running face is not scratched when hanging the door.
2. Never start hanging door with Hydraulic control on front hanger roller.
3. Be careful with your fingers. At this point, the brake does not yet work. Careless work will result in pinching your fingers.

Fit the door latching bolt. (fastener bolt)



Insert the countersunk spring washer into hexagon special bolt for both the front and rear hanger rollers and tighten it.

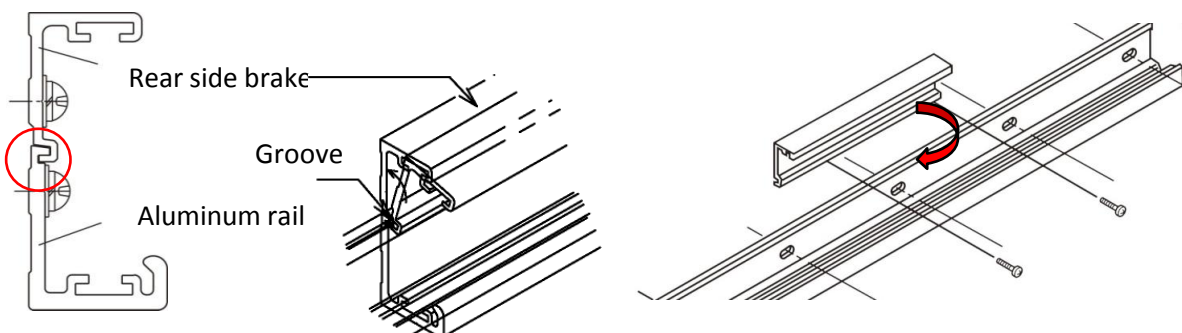
Note: Face the convex side of the countersunk spring washer toward the head of the hexagon special bolt.



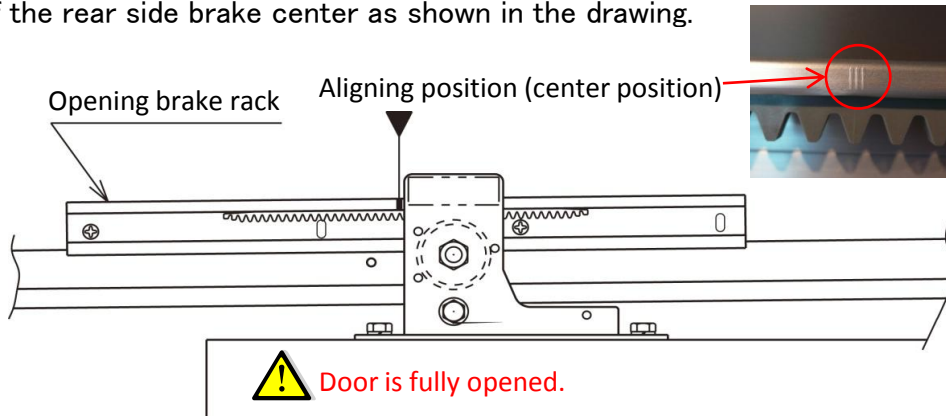
Don't forget to fit fastener bolt because it prevents from dropping door out from rail.

6. REAR SIDE BRAKE (Back check)

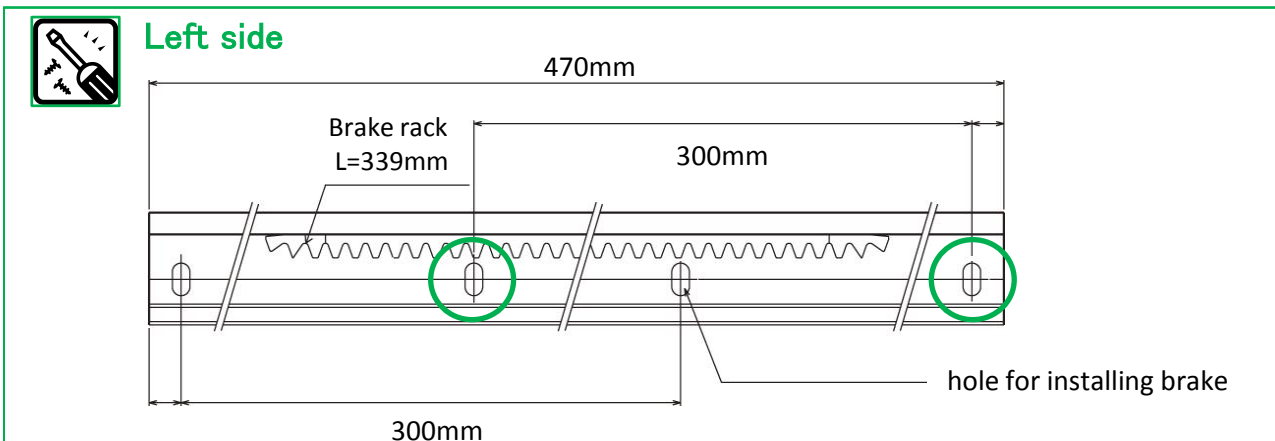
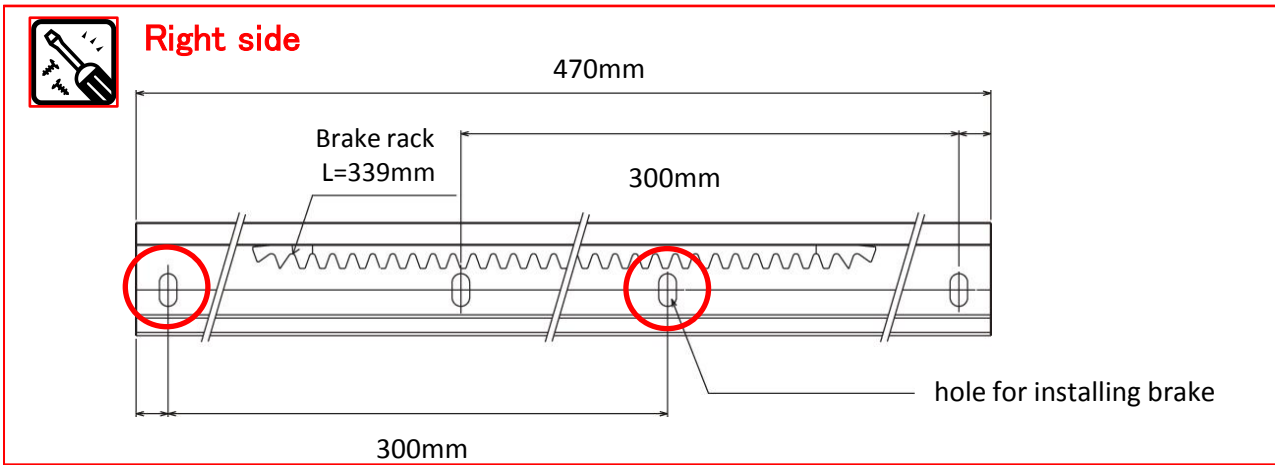
1. The door to be fully opened.
2. Insert the rear side brake into the groove



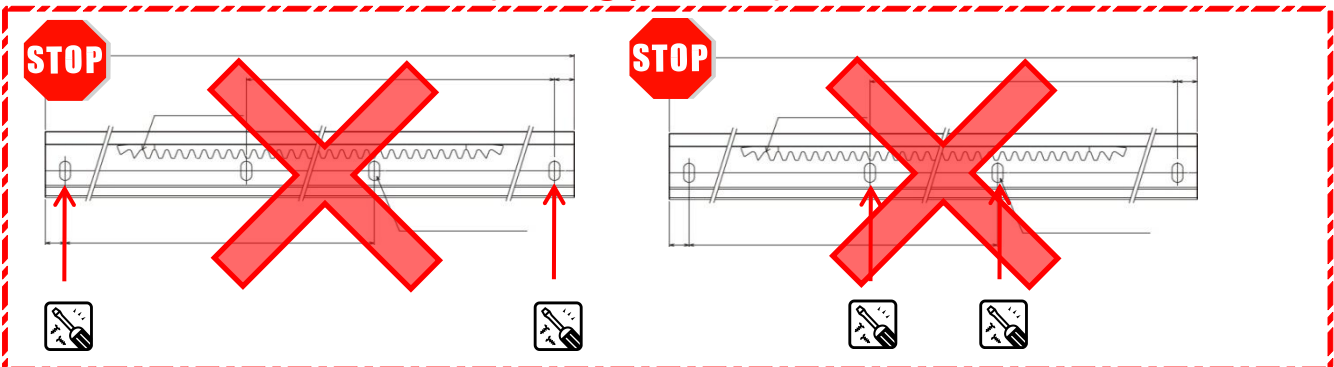
3. Align the front side of the front hanger roller with the stamping position of the rear side brake center as shown in the drawing.



4. Tap machining (M5 pitch 0.8) and Tighten by the pan head screw (M5 x 16)

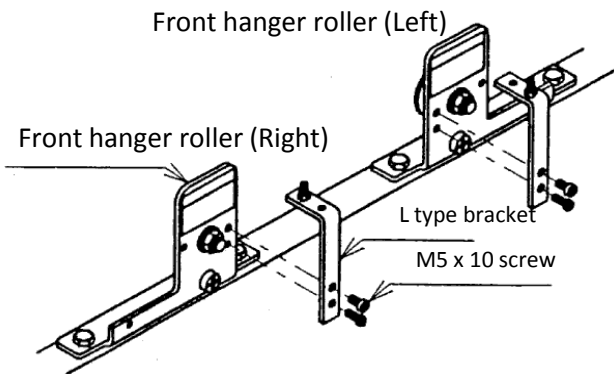


CAUTION for POSITIONS! (Wrong position)



8. INTERLOCKING DEVICE

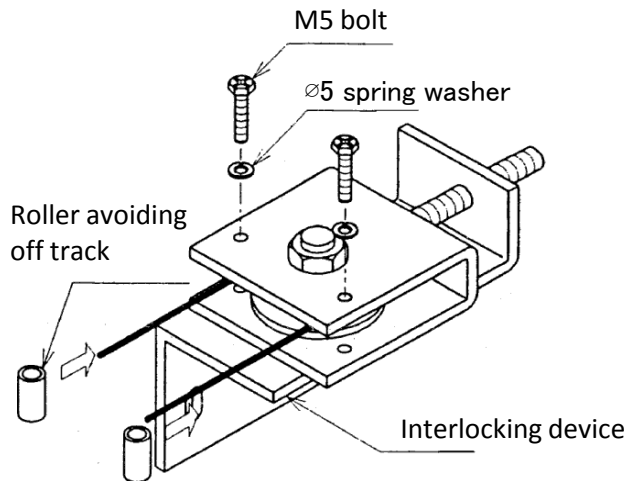
① L type bracket



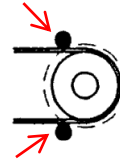
Install L type bracket on both side front hanger roller by attached M5 x10 screws.

② Wire and roller avoiding off track

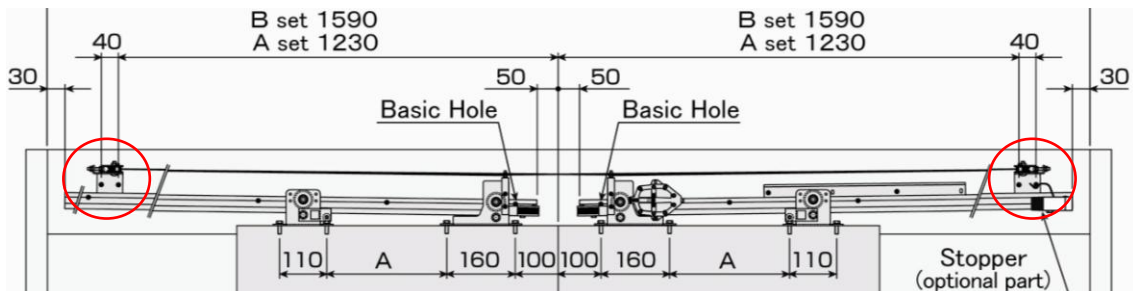
Pass the wire through pulley of interlocking device. Fix the roller by attached M5 x 18 hex. Bolt.



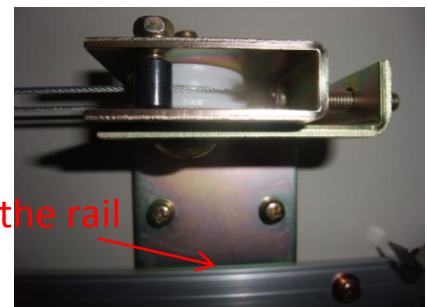
Put rollers to be out side of linking wire.



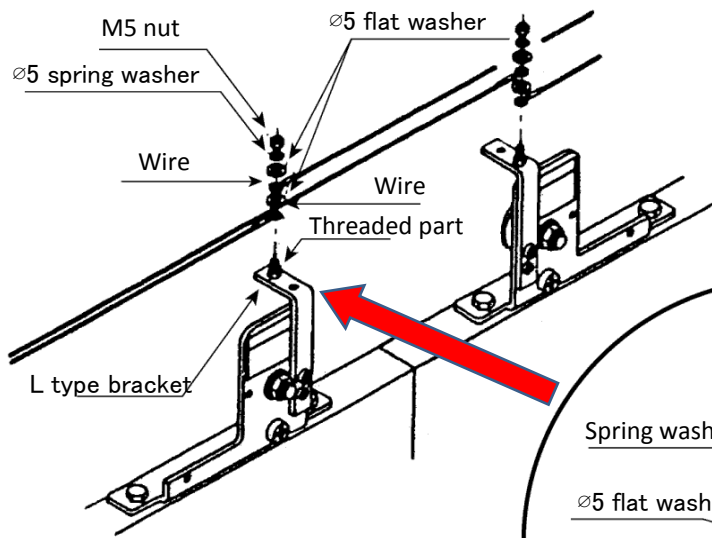
③ Interlocking device



According to the above sketch, put the interlocking device on the rail and fix by attached M5 x 25 screw.

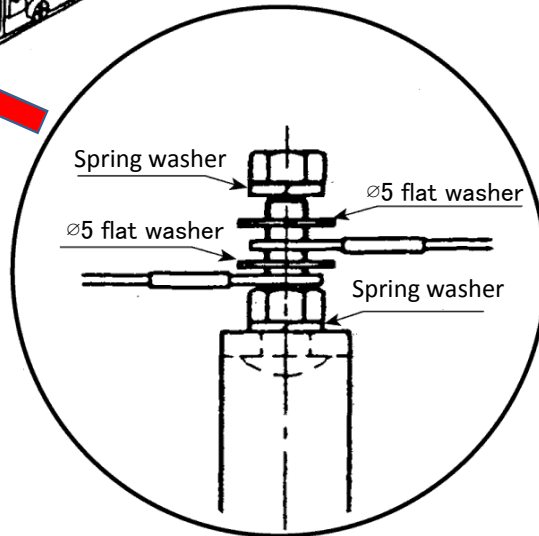


9. LINKING OF WIRE WITH L TYPE BRACKET



Link them to threaded part of L type bracket according to below order.

1. Spring washer
2. Wire
3. Ø5 flat washer
4. Wire
5. Spring washer
6. Fix them by M5 nut

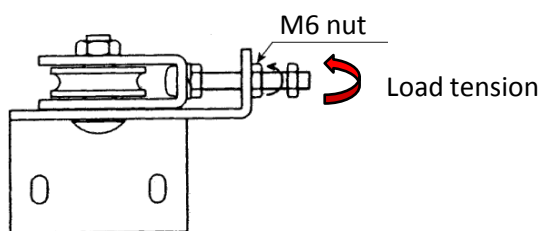


10. ADJUSTMENT OF WIRE TENSION

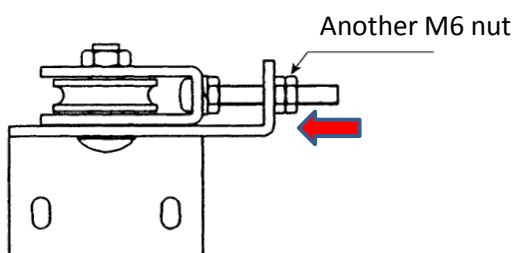
Turn M6 nut attached to the interlocking device to load tensions.

Note 1: Load tension equally between right and left side.

Note 2: Smooth operation is not made if the tension is not equal.

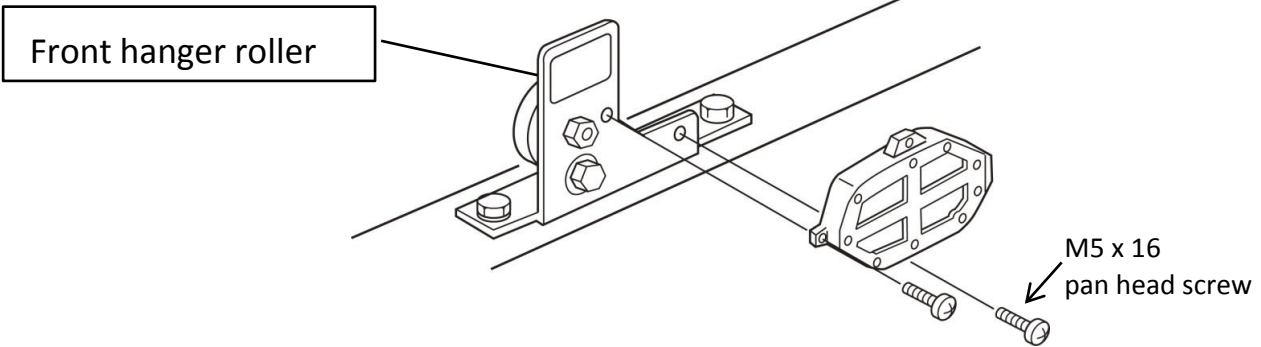


After adjusting tension, please open/close door 2 or 3 times for checking operation. If there is no problem, do double-locking by another M6 nut.



11. HYDRAULIC CONTROL

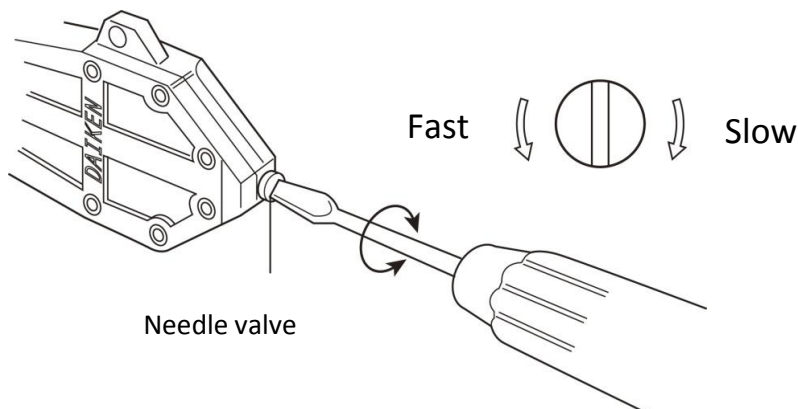
① Installation



! Door to be opened half or more.
(Avoid the control rack and rear side brake)

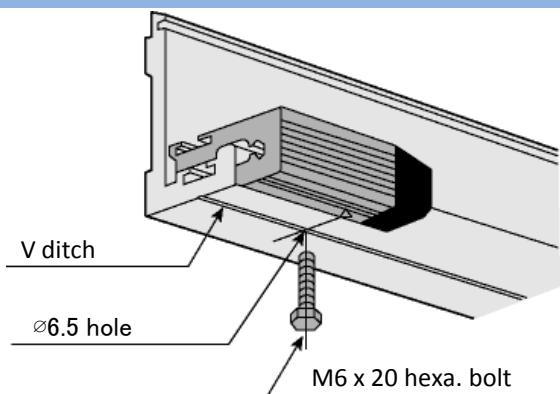
② Adjustment of door closing speeds

*Adjustment can be controlled about 250mm short from door closed position.

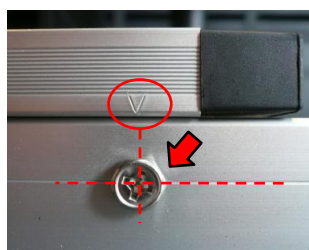


! Do not turn the needle valve more than 2 times.

11. STOPPER



Adjust stopper position for doors to be zero gap when they are closed.



Put ø6.5 hole on cross point of delta mark and V ditch.

Fix stopper with M6 x 20 bolt.

– COMPLETED –

! **Caution when using**

1. If wire is slack, door does not move smoothly. Please check and adjust the tension regularly.
2. This has structure avoiding off-tracking wire from pulleys, but, if off tracked, please load the wire on pulleys immediately.