

SDL INSTALLATION INSTRUCTIONS

DOOR SDL KITS

View Installation Video



When applying your FrontLine® Bldg. Products Inc. SDL grilles, the three most important factors to consider are:

- Temperature
- Bar Length (not too long)
- Clean Glass

Failure to follow ALL instructions will increase application failure rate and will void the warranty.

Required Materials:

- Isopropyl Alcohol / Water Mixture (50/50)
- Alcohol Prep Pads (included)
- GAP Packets (included)
- Plastic Razor
- Lint Free Cloth
- Spacer Gauge (credit card or business card will work)
- Plastic Zip Ties
- J-Roller

NOTE: The optimum air temperature range for best tape adhesion is between 70- and 100-degrees F. The minimum required air temperature is 60-degrees F. SDL bars and glass surface must be within temperature range as well, and must remain at minimum temperature for 72 hours after application.

STEP 1: Glass Preparation ***IMPORTANT!***

1. Remove all stickers, silicone, or other debris from glass surface. If silicone was present, use an adhesive remover on the glass prior to wiping down with Isopropyl Alcohol / Water mixture.
2. Use plastic razor blade to remove any sticky residue.
3. Clean glass using a disposable, white, lint-free cloth soaked in the Isopropyl Alcohol / Water mixture. Thoroughly wipe the glass surface clean.

NOTE: Failure to properly prepare the glass surface will result in poor tape adhesion. The use of glass cleaner (Windex, etc.) is not a suitable substitute for the recommended procedure and will prevent the tape from properly adhering to the glass surface, resulting in failure.

STEP 2: Dry Fit SDL Bars to Glass Surface

1. Assemble the SDL kit.
2. Position bar on glass surface to ensure proper fitment.
3. There should be a minimum of 1/64" space between the end of the SDL bar and glass perimeter (about the thickness of a credit card).
4. If the gap is too tight, trimming the SDL to proper length is required. See "How to Trim SDL Bars for Proper Fitment" section below.
5. Once fitment is confirmed, move on to Step 3.

STEP 3: Final Glass Prep and Application ***IMPORTANT!***

1. Open Alcohol Prep Pad provided and wipe glass surface.
2. Open GAP Packet and wipe the glass surface where the SDL bars will be applied.
3. Peel plastic film from back of tape.
4. Apply zip ties about 6" apart (or at each intersecting bar), starting 1" from the end work of SDL bar. See Figure A for zip tie placement.
5. Position the SDL bar on the glass surface, making sure to maintain a minimum 1/64" gap between SDL bar and lite frame (use the spacer gauge to assist).
6. Press down on the end of each of the SDL bars.
7. Slowly work your way along the SDL bar (removing the zip ties as you go) and press the SDL bar down to glass surface.
8. Once all the zip ties are removed, use the J-Roller and roll the SDL bars to the glass surface.
 - Start by rolling the outside edges of the SDL bar, working your way towards intersections
 - Use a minimum of 15 pounds of pressure, ensuring that the tape wets out.
 - Check wet out on opposite side of glass if possible. Wet out should be at least 50% after proper rolling (within 20 minutes, see Figure B).

Repeat this process for the other side of the glass.

HOW TO TRIM ALUMINUM SDL BARS FOR PROPER FITMENT (IF REQUIRED): VISIT OUR YOUTUBE PAGE TO VIEW HOW-TO VIDEOS

Using a Disc Sander (Figure C):

1. Set the table to the appropriate angle.
2. Use a miter square and align SDL bar square to the disc sander.
3. Gently touch the SDL tip to the disc sander to remove required amount of material for proper fitment.

Using a Chop Saw (Figure D):

1. Set chop saw to required angle.
2. Use minimum 120-tooth carbide-tipped blade.
3. Place tape side of bar against miter fence and slowly cut SDL bar to appropriate size (recommend removing only 1/32" at a time).
4. Clean up any residue on tape left after trimming if needed.

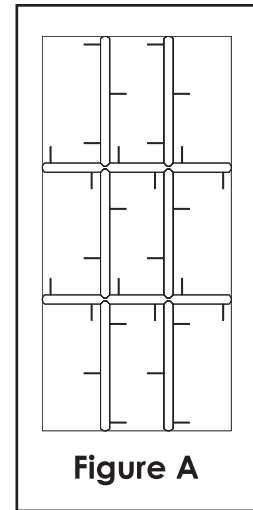


Figure A

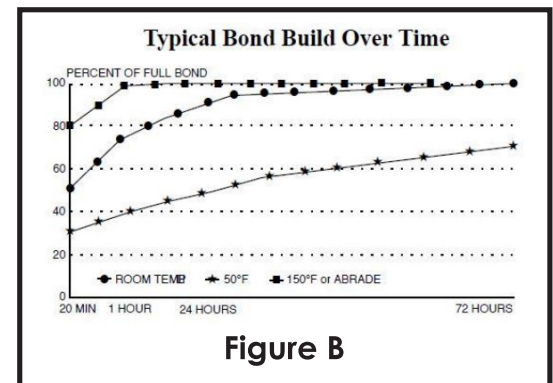


Figure B



Figure C

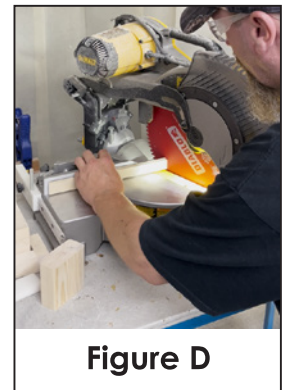


Figure D



Connect with Us

- www.frontlinebldg.com
- SalesMedford@frontlinebldg.com
- 715-748-2288
- [Facebook](#)
- [LinkedIn](#)
- [YouTube](#)
- [Instagram](#)

