

# SDL INSTALLATION INSTRUCTIONS

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)
- Silane Adhesion Promoter (like GAP-1)
- 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°F and 100°F. The minimum required air temperature is 60°F. SDL bars and glass surface must be within temperature range and must remain at minimum temperature for at least 72 hours after application.**

## STEP 1: Glass & Grille Preparation **\*IMPORTANT!\***

1. If not already completed, finish and/or assemble grille.
2. 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.
3. Use plastic razor blade to remove any sticky residue.
4. 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. Position assembled grille on glass surface to ensure proper fitment.
2. 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).
3. 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.
4. Once fitment is confirmed, move on to Step 3.

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

1. Wipe the glass surface with Isopropyl Alcohol / Water mixture (or use an alcohol prep pad).
2. Use Silane adhesion promoter (GAP-1 Packet or similar) 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 least at each intersecting bar) starting 1" from the end of the grille bar. See Figure A for recommended zip tie placement.
5. Position the SDL bar on the glass surface, making sure to maintain a 1/64 to 1/32" gap between SDL bar and 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 (left and right) then roll the entire top surface of the SDL bar.
  - 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 about 50% after proper rolling (within 20 minutes; see Figure B).

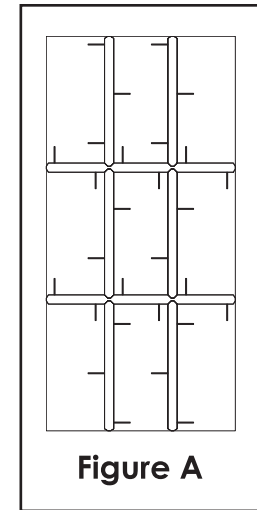


Figure A

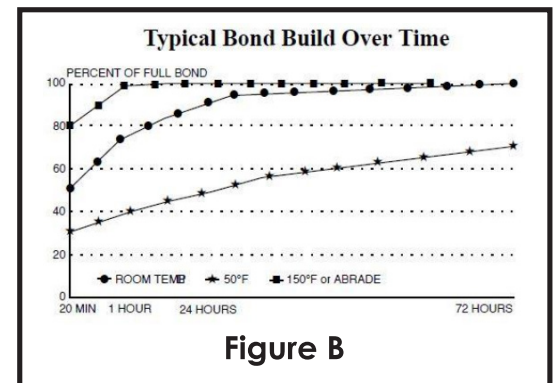


Figure B

Repeat this process for the other side of the glass.

### HOW TO TRIM SDL BARS FOR PROPER FITMENT (IF REQUIRED):

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. For best results, 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 C

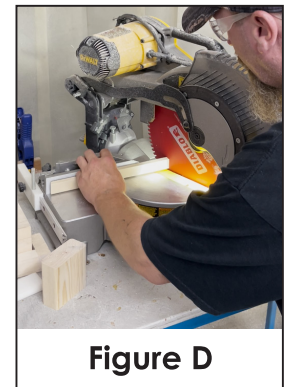


Figure D



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