

# Replacing Glazing in a Composite Door

## Step 1:

Remove internal screw cover caps in cassette



External side      Internal side      Screw cover caps

Easiest way to get out the plugs is to drill a screw slightly into each plug, enough to grip, then pull them out.  
NB old plugs cannot normally be reused.



## Step 2:

Unscrew and remove internal cassette



Unscrew each cassette screw in turn all the way around the cassette. The internal cassette can be pulled away from the door. The external cassette and glass should still be stuck to the door on the outside, however, take care to support this whilst unscrewing the internal cassette in case the glass loosens and falls out.

## Step 3:

### Removing external cassette and glass



Push the glass at the bottom from the inside whilst supporting it on the outside to prise it away from the door. From the outside carefully pull the cassette off the door whilst holding the glass unit. Glazing suction pads might be helpful in this process. The external cassette should remain stuck to the glass.

## Step 4:

### Removing remaining sealant from door face



Using a knife or paint scraper remove the sealant still stuck to the door face, taking care not to cut or scratch the door. A solvent cleaner and a soft cloth can be used to wipe off and remaining residue sealant to ensure door face is clean ready for new cassette.  
NB not removing all the old sealant could prevent the new seals adhering properly that could result in leaks.

## Step 5.1:

### Preparing new external glazing cassette – Method 1



#### Glazing Tape

We recommend 9mm wide, 1mm thick double sided glazing tape. Apply it to over both grooves, inside to stick to the glass and outside to stick to the door face.  
EXCEPT do not seal bottom edge of cassette to allow for drainage. Peel off tape just before applying to the door face.

## Step 5.2:

### Preparing new external glazing cassette – Method 2



#### Applied Sealant

We recommend gun applied Stixall adhesive sealant. Apply it to along both grooves, inside to stick to the glass and outside to stick to the door face.  
EXCEPT do not seal bottom edge of cassette to allow for drainage. Take care to make sure the bead is sufficient to sit proud of the groove, but not too large to cause excessive spew.

## Step 6:

### Fitting new glazing cassette and glass unit



Offer up the external cassette, with seal applied, to the external face of the door, lining up with the bottom of the cut-out making sure it is straight, and press to the door. Offer up the internal cassette and nip in the two lowest side screws so that they just bite into the external cassette. Pull the internal cassette away from the door enough to slide the new glass unit into place. Ensure glass stamps are at the bottom, and the laminated leaf is to the external side. Press glass firmly to the external cassette, then screw in the internal cassette all the way around using torque setting 3. NB a higher torque setting could cause stress cracks in the glass.

## Step 7:

### Finishing



Push in the new screw cover caps with thumb or use a soft head mallet. Check external side for any excess sealant spew and wipe away, using solvent cleaner if necessary. Finally wipe the door and glass of any dust, etc.