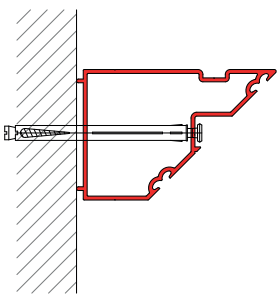




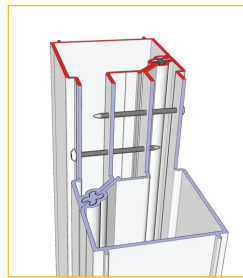
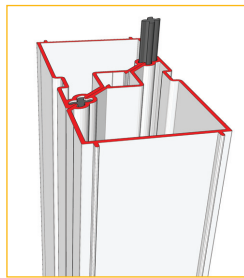
## Global Summer pilaster fitting

# Instructions

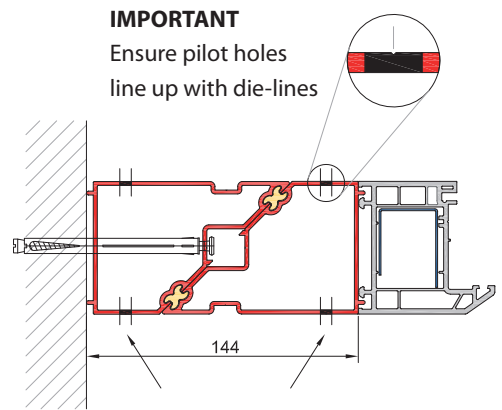
### XDPR1 configuration for wall end



Join **XDPR1** to wall using standard frame fixings



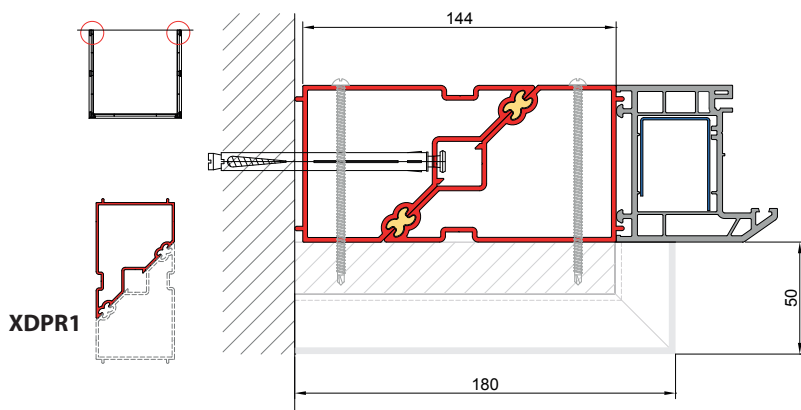
Fix **XDPR1** reinforcements together using 2 x M5x90 fixing screws at top, middle and bottom. Allow approx 150mm from top and bottom, and approx 600mm centres. Ensure that they are staggered so that they do not collide.



**IMPORTANT**

Ensure pilot holes line up with die-lines

Pilot 2 x holes through both faces of **XDPR1** using a 6mm drill bit to allow fixing screws to pass through and attach pilaster (see page 4).

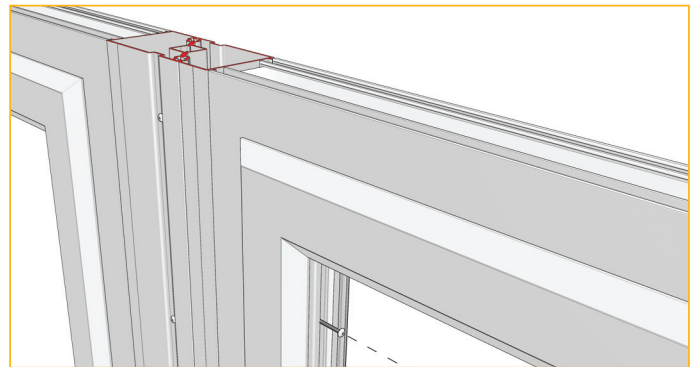
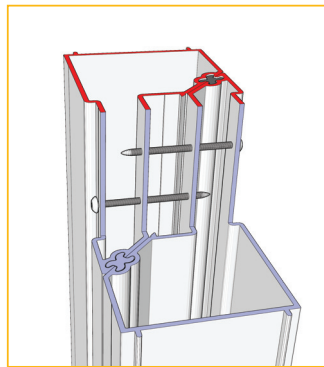
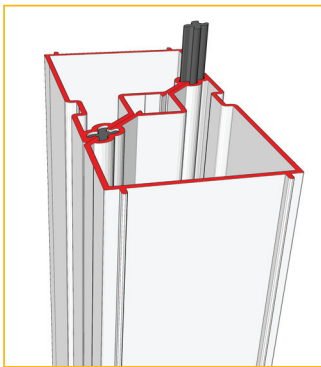


**Note: Wall and fixing underneath a soffit**

Because a soffit blocks the use of **XDPR2** inserts, the order of assembly must be changed to ensure proper alignment of pilaster reinforcements. Prior to attaching to wall, join 2 x **XDPR1** in the 180° configuration using 2 x fixing screws. Then separate by removing screws and inserts, to allow 1 x **XDPR1** to be fastened to wall using standard frame fixings. Once joined to wall, connect the second **XDPR1** as before, using screw holes to align reinforcements.

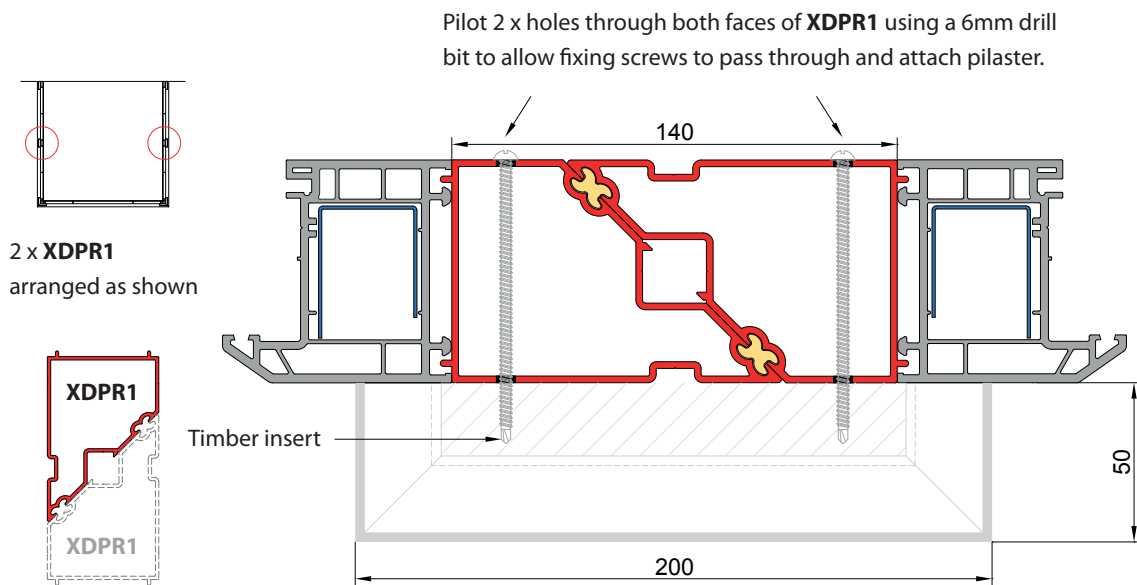
*Note: A suitable lubricant can allow easier fitting of XDPR2 inserts.*

## XDPR1 configuration for 180° inline join



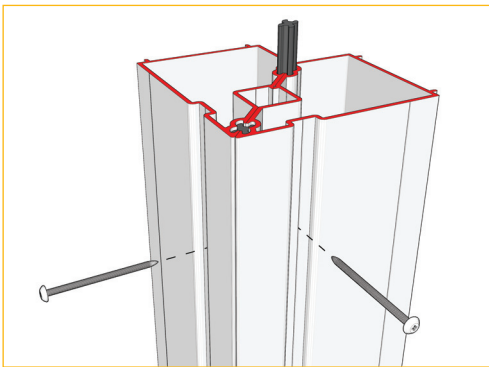
Join frames at inline locations using 2 x pilaster reinforcements (**XDPR1**) in the 180° configuration as shown below (frame to frame deduction 140mm). Join pilaster reinforcements together using 2 x pilaster reinforcement inserts (**XDPR2**), and fix using 2 x M5x90 fixing screws at top, middle and bottom (approx 150mm from top to bottom, and approx 600mm centres). Again ensure these are staggered to avoid collision.

Join frames to **XDPR1**, following standard frame fitting procedures.



*Note: Roof must be installed before pilaster is attached to XDPR1. Wall pods attached on the inside will cover XDPR1 from view.*

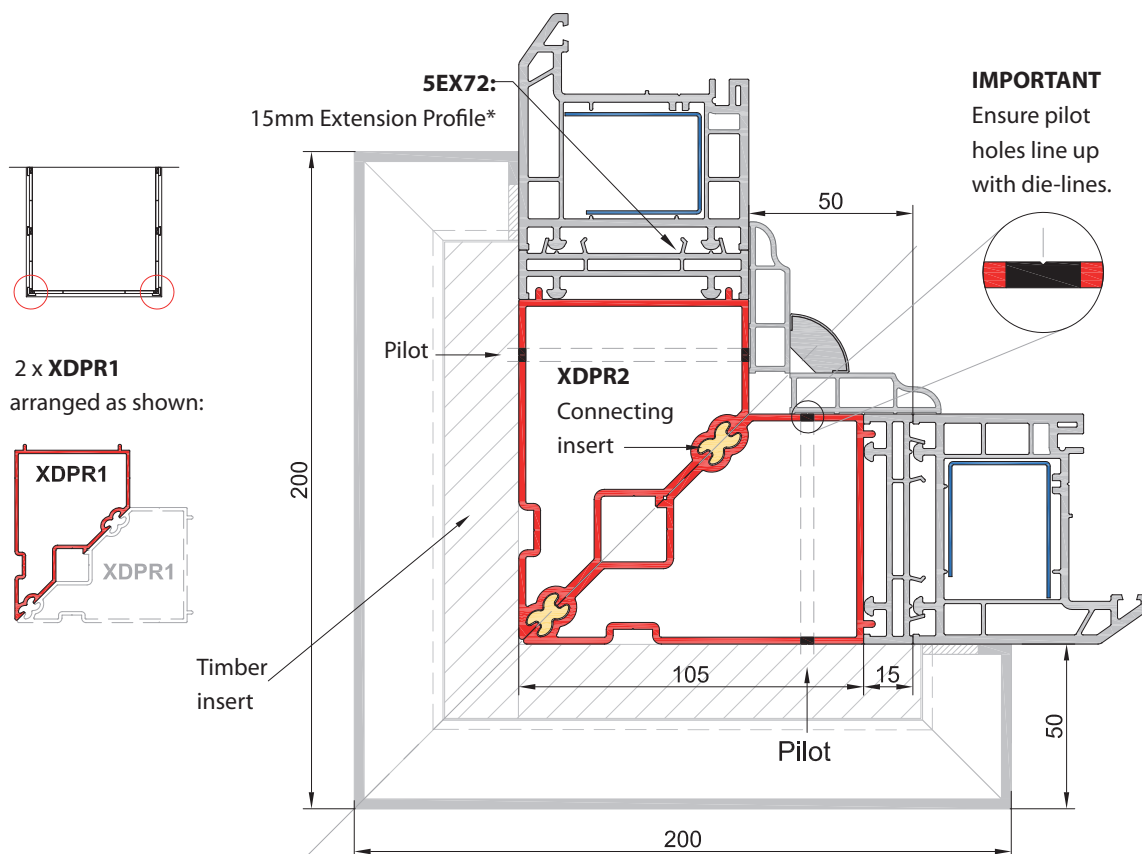
## XDPR1 configuration for a 90° corner



Join frames at inline locations using 2 x pilaster reinforcements (**XDPR1**) in the 90° configuration as shown below.

Join pilaster reinforcements together using 2 x pilaster reinforcement inserts (**XDPR2**), and fix using 2 x M5x90 fixing screws at top, middle and bottom (approx 150mm from top to bottom, and approx 600mm centres). Again ensure these are staggered to avoid collision.

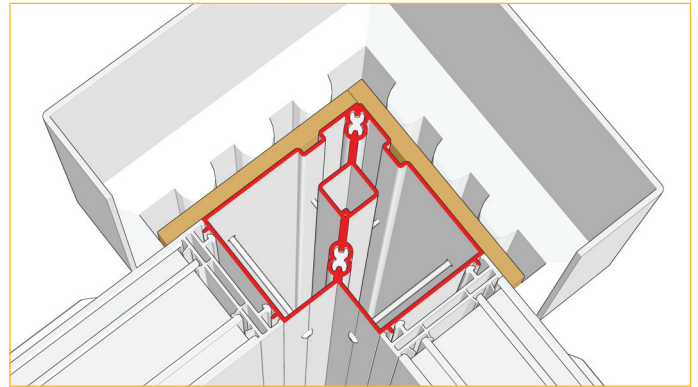
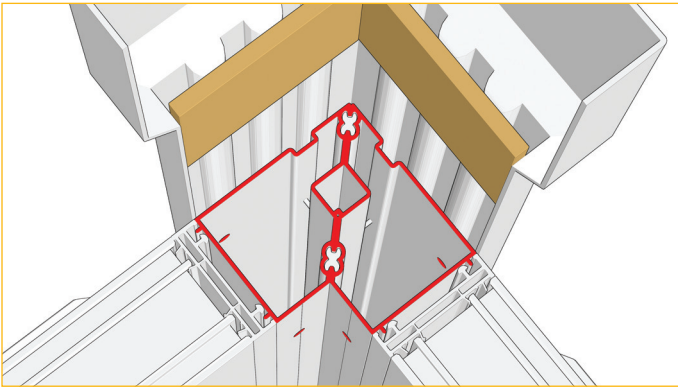
**Note:** Roof must be installed before pilaster is attached to XDPR1.



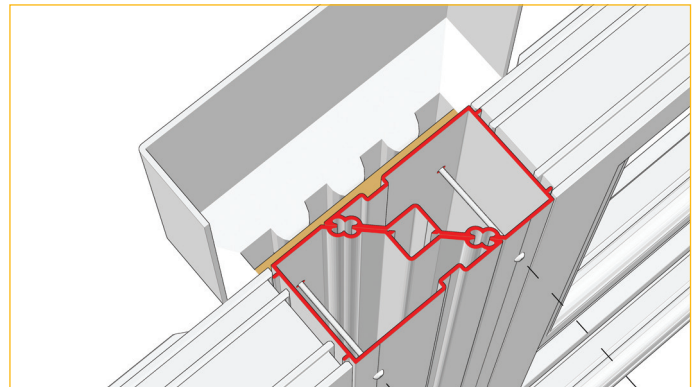
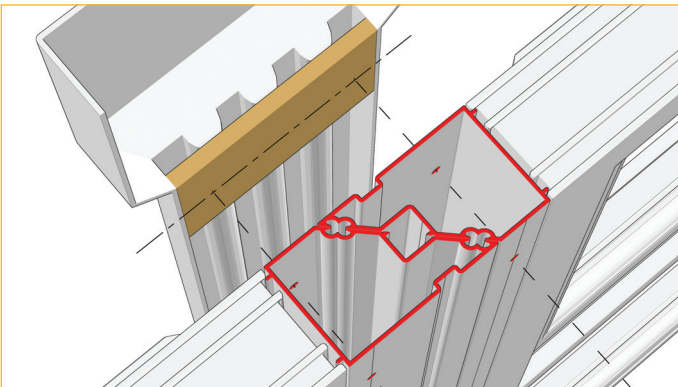
\*Use 15mm extension for 70mm large frame.

\*Use 25mm extension for 60mm intermediate frame.

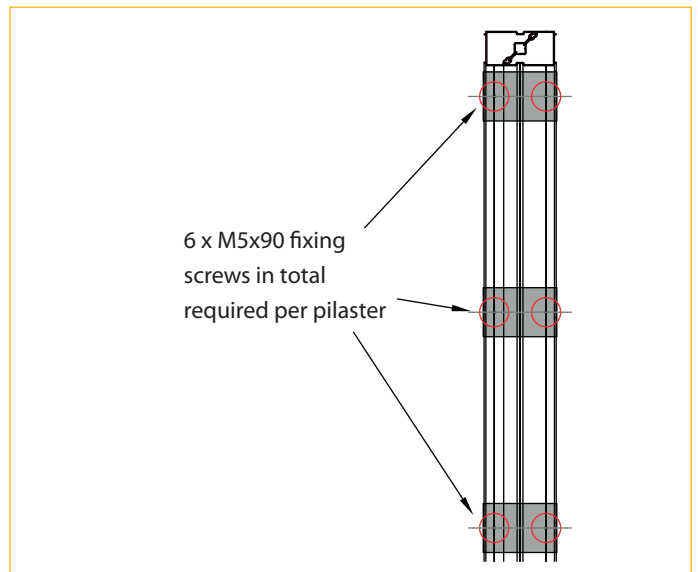
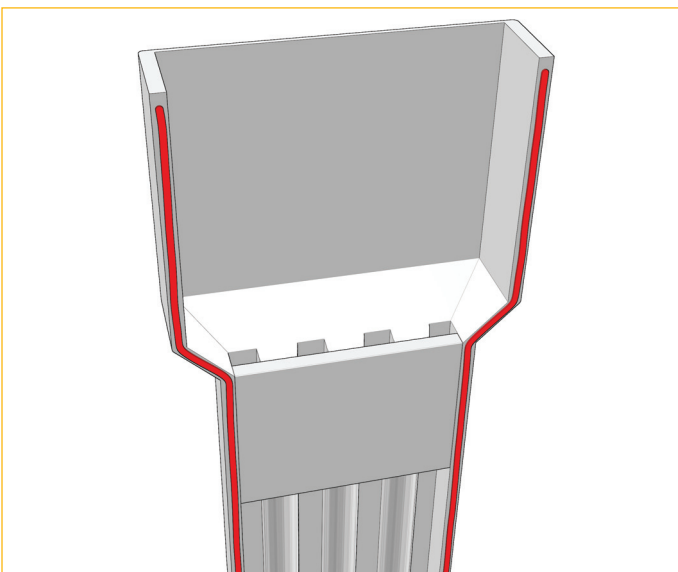
**NOTE:** Diagrams shown without roof section for illustrative purposes.  
Please ensure roof is fully assembled with orangery fascia before fitting pilaster clads.



Drill a hole straight through each **XDPRI** as shown above to allow fixing screws to pass through. Repeat process for each timber insert on the pilaster. Fix M5x90 screws into timber inserts to secure pilaster to the orangery (6 x screws per pilaster).



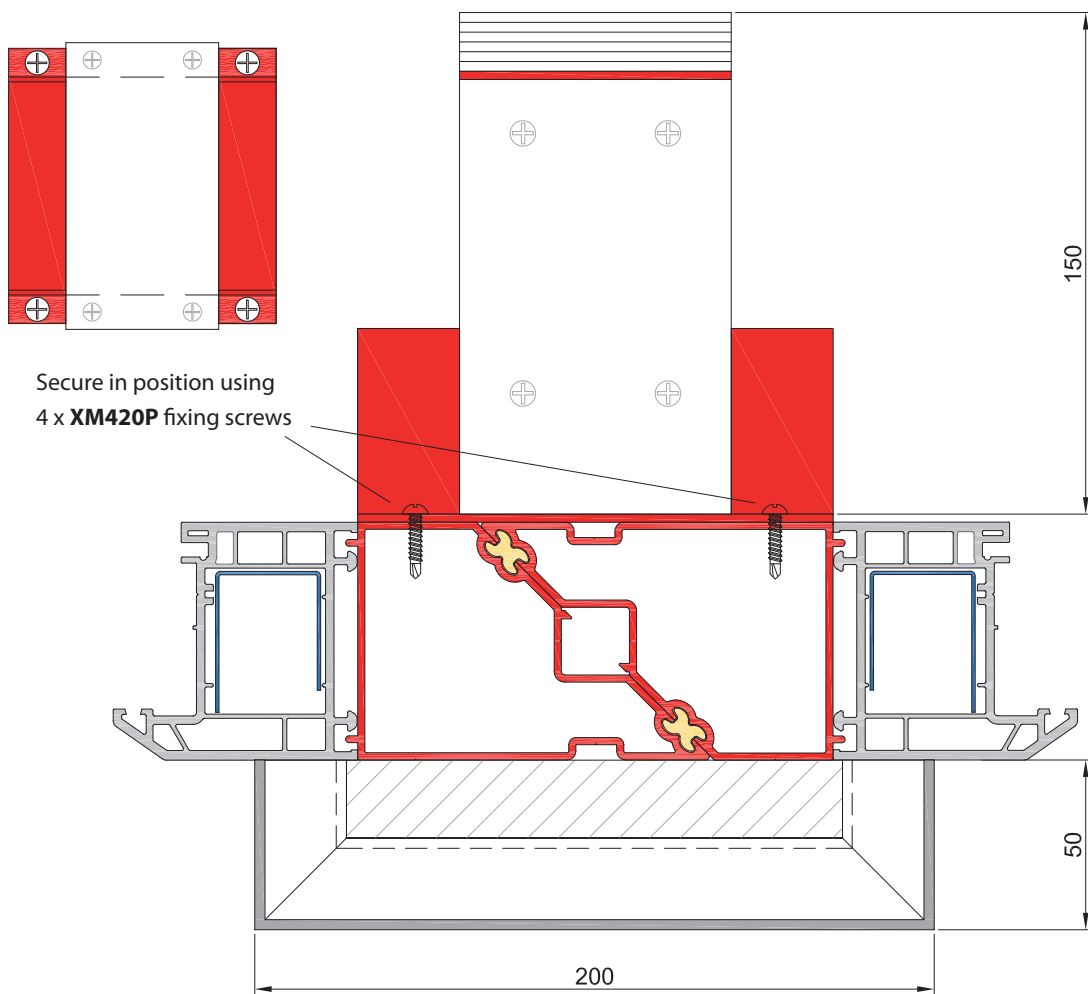
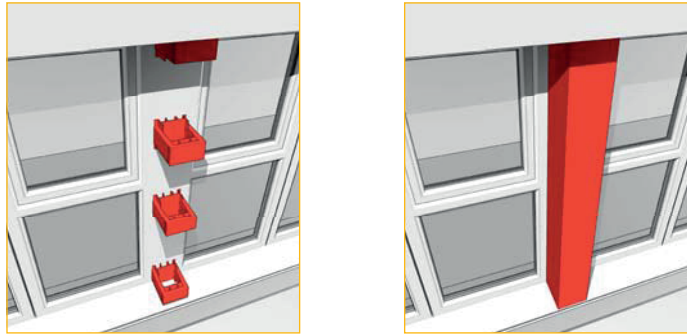
Drill a pilot hole straight through each **XDPRI** on 180° inline joins, aligned with the groove on each profile and the centre line of each timber pilaster insert as shown above. Repeat process for each timber insert. Fix pilaster in place using 6 x M5x90 fixing screws.



**NOTE:** Run a continual line of suitable sealant down each internal reveal prior to fitting. Once fitted, clean and remove excess sealant.

## Mullion pods

Mullion Pods (**XMP1-015**) can be supplied as an optional extra if required, in order to form a vertical mullion section between windows (4 per mullion). The size of these pods will create a mullion 150mm wide and will project 150mm out from internal frame, which is designed to finish flush with the inside edge of a minimum 50mm cavity dwarf wall. Once the pods have been equally positioned along the height of the mullion, 3 sections of plasterboard 150mm wide can be attached to the pods to complete the mullions. This will conceal the **XDPR1** connectors from view.





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