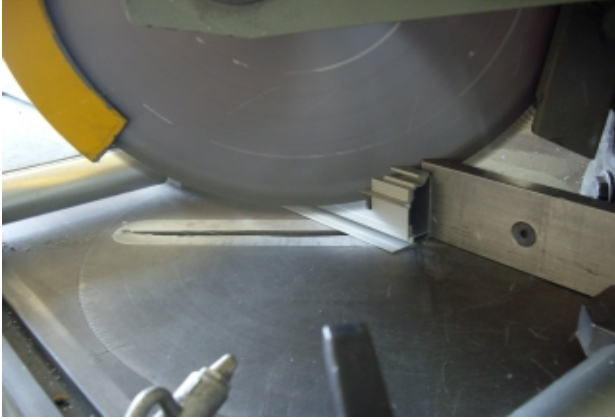


# Cutting and assembly manual

## PRO CASE



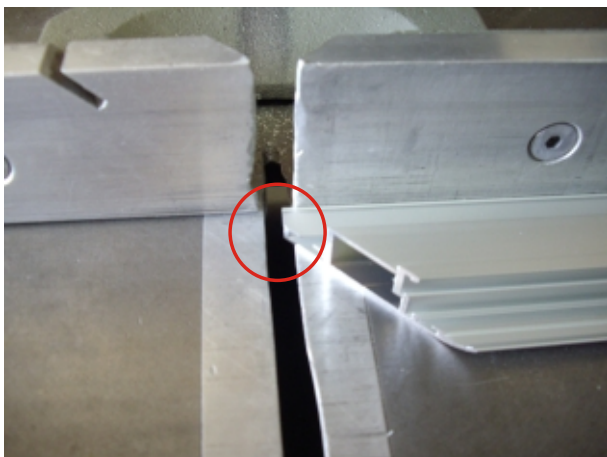
Cutting the base profile (PCB 1052):

- 45° angle; outer dimensions of the showcase



Cutting the hinge profile (PCZ 1053):

- subtract 10mm from outer dimensions of the showcase
- cut on the angle of 45°



Cutting the hinge profile (PCZ 1053):

- cut off 10,5mm straight from each side of the profile

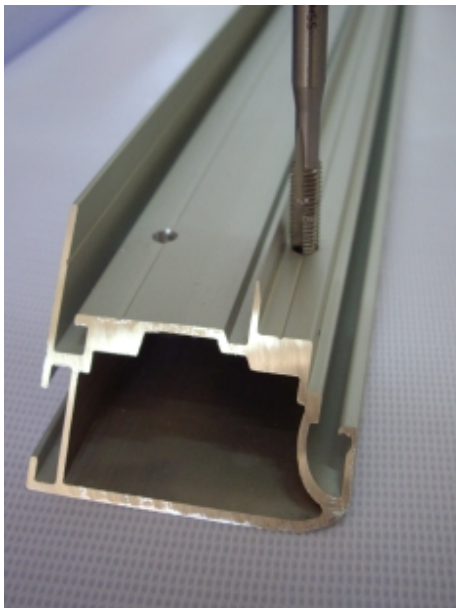




Cutting window profile (PCO1054); 3 sides:  
- subtract 31mm from outer dimensions of the showcase



Preparing the base profile:  
- drill two 5,2mm holes  
- 29mm distance from the inner edge

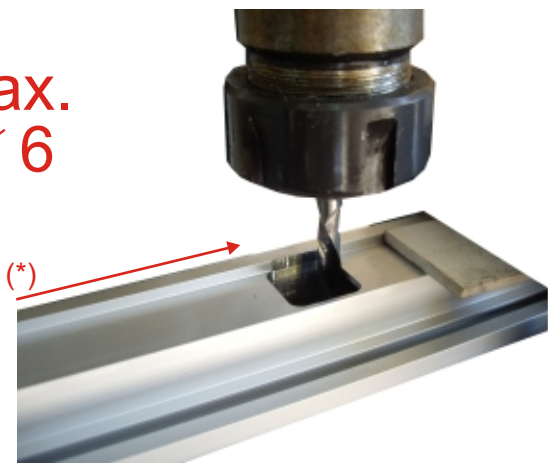


Thread the holes with M6 threader.



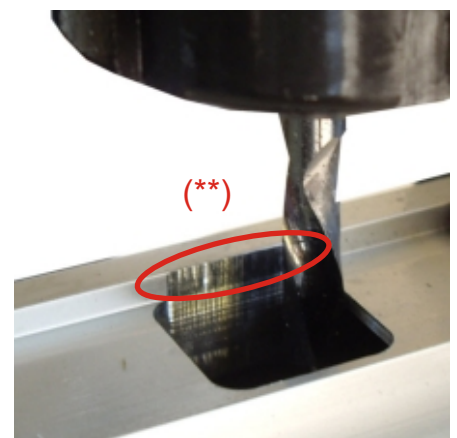
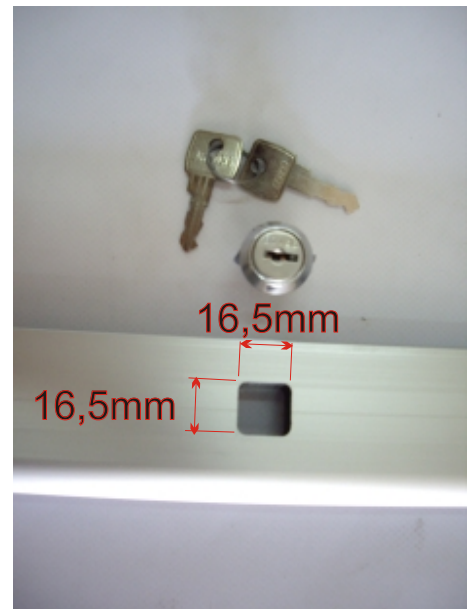
Twist M6 hexagon screws loosely.

Max.  
∅ 6



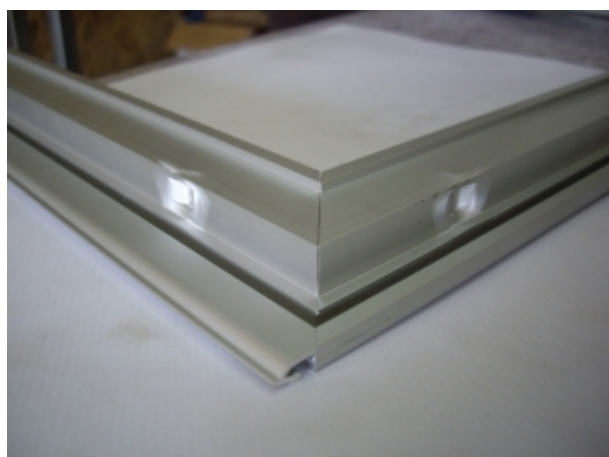
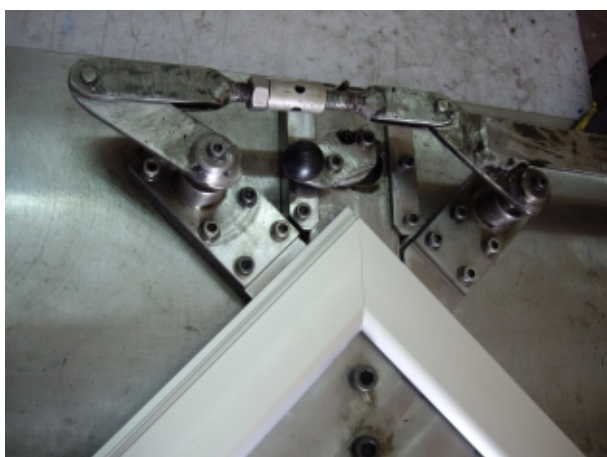
Milling the hole for doorlock:

- hole dimensions: 16,5mm x 16,5mm
- mill max. ∅ 6
- mill alongside the marked side (\*)
- after milling doorlock hole, additionally mill 0,5mm from the marked edge (\*\*)
- when height of the showcase exceeds 1000mm, put 2 doorlocks 250mm from each edge



Assembling window door:

- connect the profiles with 15mm corners
- press in two-element glue
- clamp edges with clam-machine



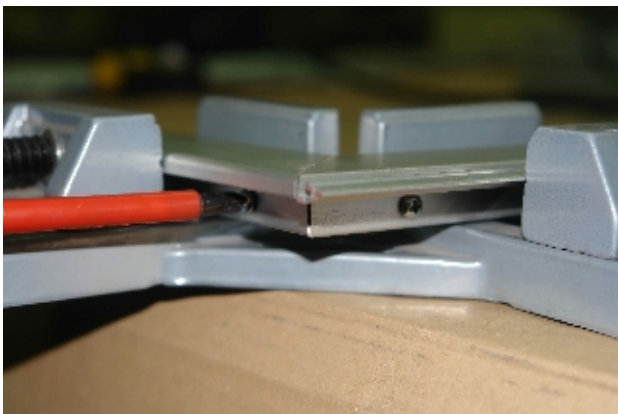
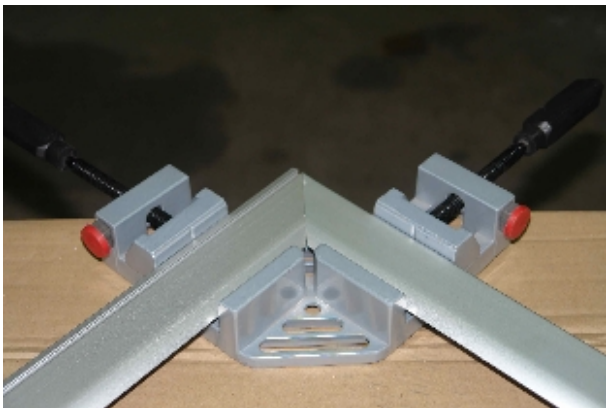
**ALTERNATIVE:** assembling window door without clamp-machine:

-use 90 degrees angle to connect profiles correctly.

-Connect profiles with 15mm corner



- 39mm from the inner edge of the profiles bore 2 holes.  
(Suggested size of the screws : 3-4mm)

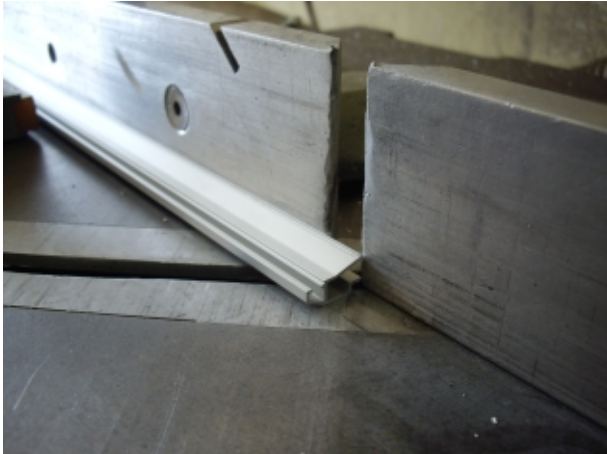
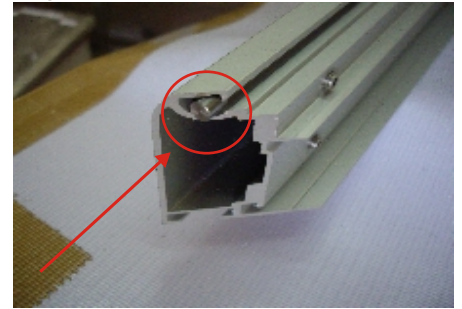


- tighten the screws



#### Assembling base profiles

- connect profiles with 36mm corners
- tighten the M6 hexagon screws
- IMPORTANT! Before tightening the last side, slide in the distance tube (on the side where hinge profile is slid in)!



#### Cutting the closing profile

- subtract 93mm from the outer dimensions of the showcase

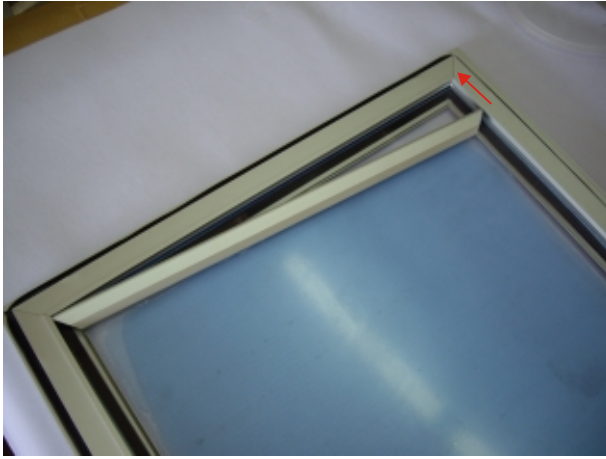


#### Mounting window gasket:

- use the self adhesive gasket on the inner edge of the window

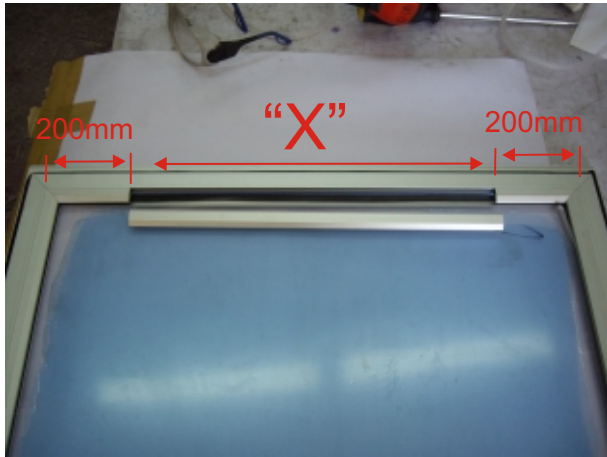


- use the pressed gasket on the outer edge of the window



Mounting the glass::

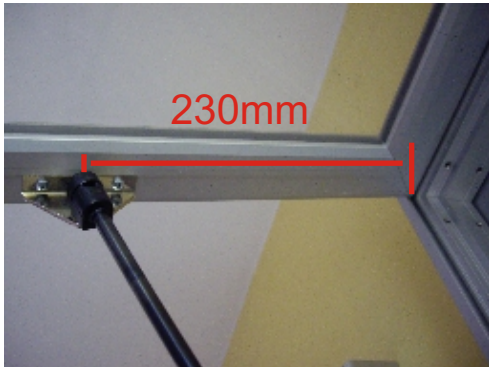
- use 4mm tempered glass or PVC
- Size of the glass : subtract 102mm from the outer dimensions of the showcase
- slide the closing profile
- size of the steel plate (back) - subtract 38mm from the outer dimensions of the showcase



- in order to eliminate gaps between angles, divide the closing profile on two edges of window door to 3 pieces (200mm; X; 200mm)\_
- finally, press the transparent gasket between window and closing profile

# Mounting automatic jackgas units.

- Mounting the jackgas handle

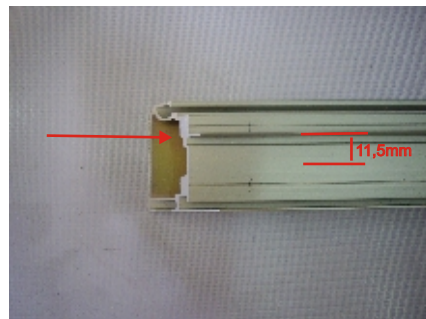


- measure 230mm from the inner edge of the window profile  
it is the middle of the handle
- screw with two  $\varnothing 3$  screws

- Mounting the jackgas handle (#2)



- measure 590mm from the inner side of the base profile
- measure 11,5mm from the edge marked on picture (\*)
- bore a 11mm hole in the point  
where two of the coordinates cross
- press the rivet with riveting machine
- screw in the second handle



(\*)

# ASSEMBLED PRO CASE

