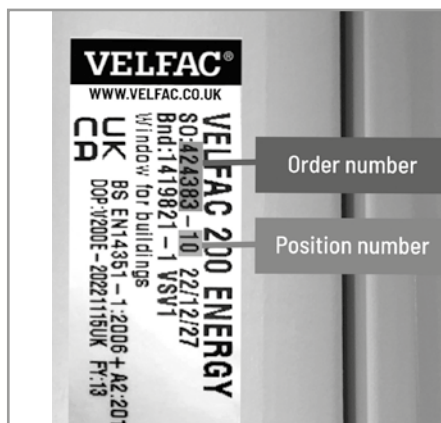
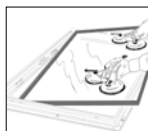


# Glass Replacement Guide for VELFAC 200

Part of the VELFAC Installation and Adjustment Guide per September 2023.

Prior to glass replacement please refer to our Desashing & Adjustment Guides.



**Glass breakage:** To order replacement glass units you will need the Order Number and the Position Number. These are shown on the unique ID tag allocated to each window, generally located in the bottom left rebate of any opening unit. For fixed units the ID Tag is located in either the right or left hand upper corner of the timber mainframe.

If no ID tags are visible, the required information is available on the glass spacer bar. This information is critical to ensure the correct specification of glass is re-supplied by the After-sales Department.

YouTube

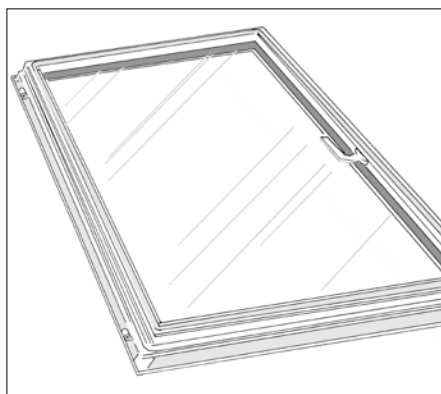
If works are to be undertaken by a third party we recommend viewing of the relevant video prior to undertaking the works: For VELFAC 200 ENERGY (TGU) and VELFAC 200i (DGU) with thermally broken sash profiles, please use the first link. For VELFAC 200 alu (DGU) with aluminium sash profiles, please use the second link.



[A. Thermally broken sash](#)



[B. Aluminium sash](#)



**Desash** the complete opening element with the glass in place (as shown on the opening function page in the VELFAC 200 Desashing and Adjustment Guide).

Place the sash onto trestles with the internal side facing upwards.

A. B.

**A. or B.?** Choose the correct method according to the following differences:

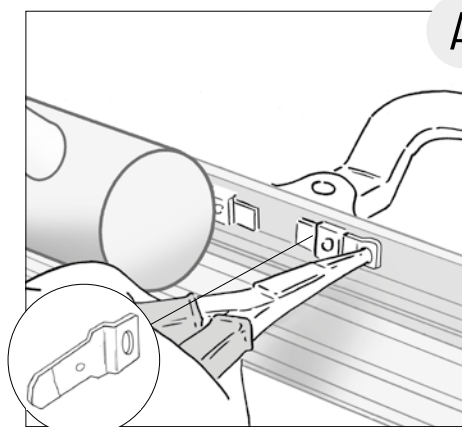
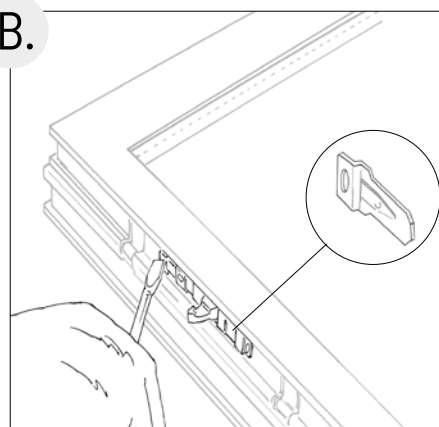
A. VELFAC 200 ENERGY and VELFAC 200i with thermally broken sash profiles.

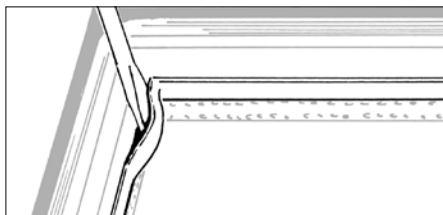
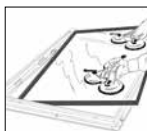
B. VELFAC 200 with unbroken aluminium sash profile.

A.

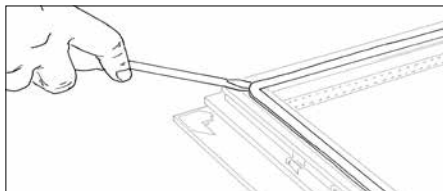
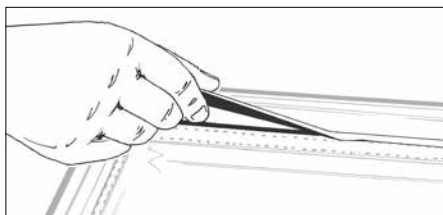
Detach the espagnolette handle from the glazing bead by knocking all the wedges out.

B.

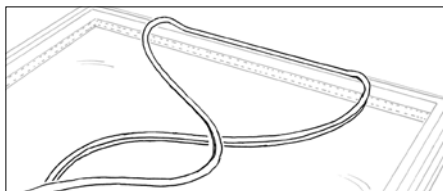
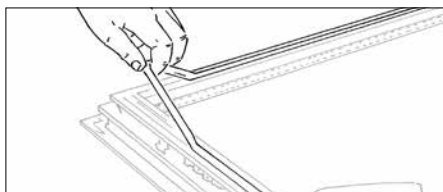




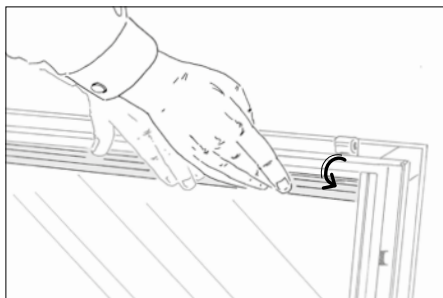
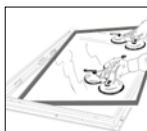
Remove the internal glazing gasket by sliding a flat bladed tool between the bead and underside of the gasket and gently lever upwards.



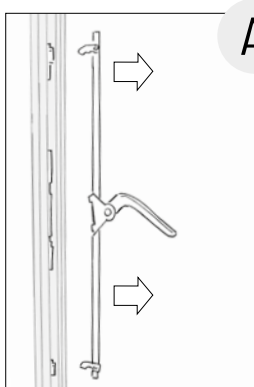
Starting at the bottom and working up either sided remove the primary seal gasket by sliding a flat bladed tool between the inner edge of the sash and the underside of the gasket and gently lever upwards.



The gasket at the top is bonded and should remain in place.



On both sides tip the glazing beads inwards and remove followed by the top and bottom. Ensure bonding agent has been detached.



A.

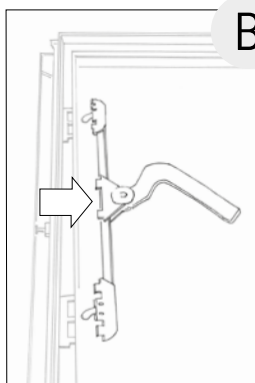
A. VELFAC 200 ENERGY (TGU) or VELFAC 200i (DGU) with thermally broken sash profile:

Once the glazing bead behind the espagnolette handle has been removed, place the handle in the 'open' position.

Tilt the cremone rod out by releasing the bolts (2-3 places) and tilt the handle and cremone rod out of the sash.



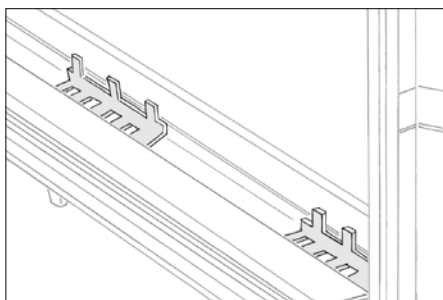
[See video 1:03](#)



B.

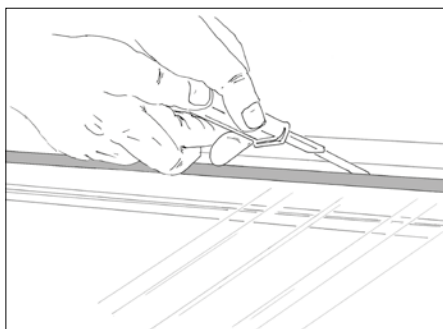
B. VELFAC 200 (DGU) with unbroken aluminium sash profile:

Place the handle in the 'open' position, remove the glazing bead and take out the handle and the espagnolette system.

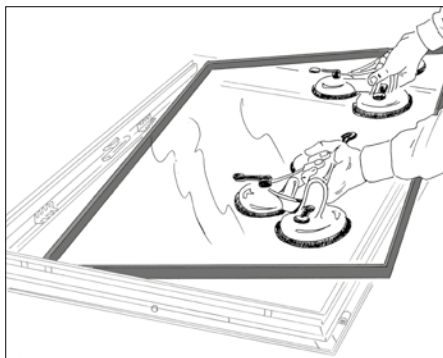
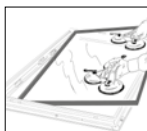


Notice the location of the glazing packers, as these must be re-installed in the exact same position during re-glazing.

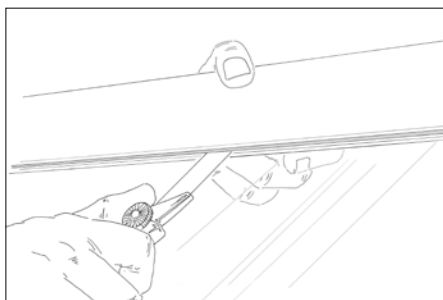
Any loose glazing packers must be tilted up.



At point of manufacture a bonding agent may have been applied at intermittent locations between the sash profile and glazing rebate. To remove the glass the contact bond will need breaking and the remaining glazing packers tilted up.



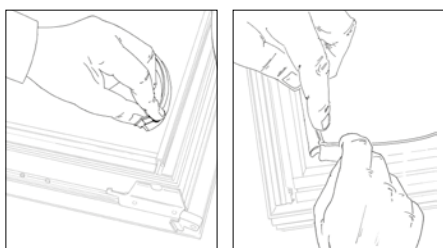
Once free of the bonding agent the glass unit can be lifted from the sash using the appropriate equipment.



If the glazed unit remains bonded carefully stand the sash vertical on one edge to allow access to the outer face. Soften the external glazing gaskets with a solution of mild detergent and water, and at the points where a bond remains in place, slide a flat blade tool between the external glazing gasket and glass and cut the remaining seal.



[See video 1:52](#)

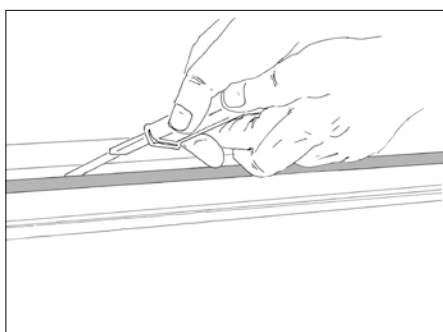
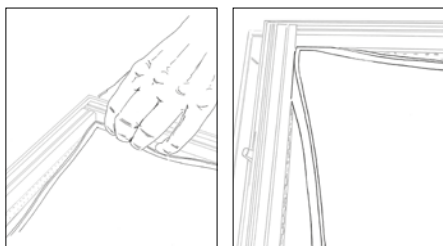


The external glazing gasket must be replaced if damaged: Start and end at the top.

The gasket must be compressed during installation and cut off with an excess of 1 cm. Finish by cutting the corners slightly.



[See video 2:14](#)

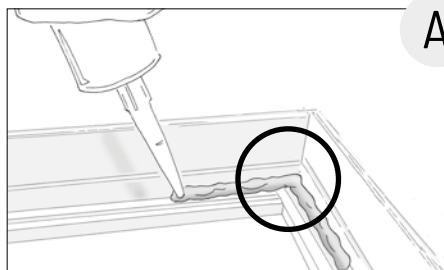


#### Before installing a new pane:

- Clean any glue residues that may be present on the new pane.
- Clean any glue residues behind the espagnolette handle.



[See video 2:57](#)

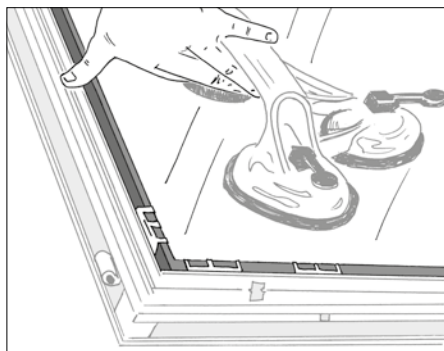


A.

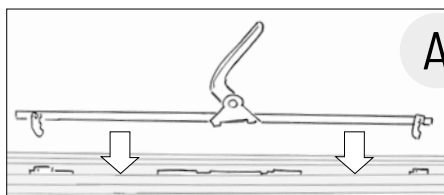
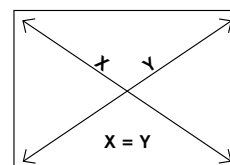
- Gun in a sealing joint at the bottom of the sash and behind the cremone handle.
- Ensure that sealing behind the sash corners is intact.
- The new pane must be sealed with a bonding agent in the same places as before, use MS Polymer or equivalent, e.g. Illbruck SP 350.



See video 3:15

**Re-glazing:**

- Place the pane down in the middle of the sash so that the free space on all sides is equal.
- Refit the glazing packers as before, and re-seal the unit. Check the diagonal dimensions and adjust glazing packers if necessary.



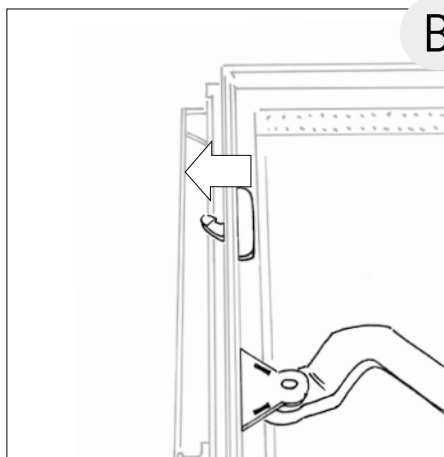
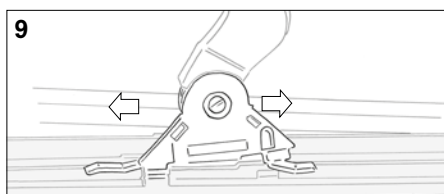
A.

**A. Refit the handle and espagnolette mechanism:**

- Slide one bolt into position (8) and click into sash.
- Fit the handle beneath the retaining bracket, one side at a time (9).
- Click the remaining bolts in place in the sash in the same way (8).
- Check that the handle functions properly.
- Ensure all moving parts are lubricated.



See video 4:19



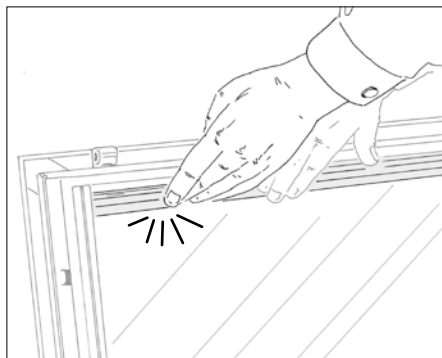
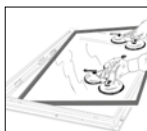
B.

**B. Refit the handle and espagnolette mechanism:**

- The handle is re-installed by clicking the bolts in place in the sash.
- Check that the handle functions properly.



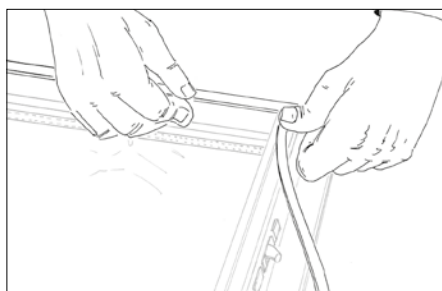
See video 4:50



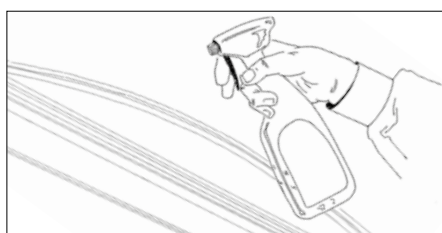
Click the glazing beads into position – start at the top and bottom.



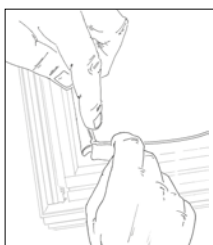
[See video 4:41](#)



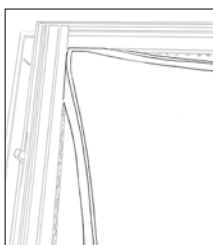
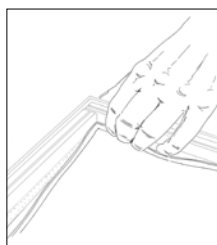
Attach the weather strip, starting at the top, then proceed to the corners and sides.



**Tip:** Soften the gaskets and weather strips with soapy water.



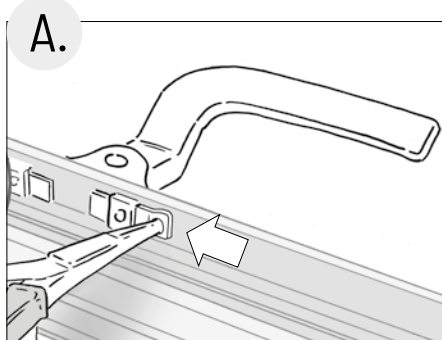
Press the glass gaskets into position. Start at the bottom and end at the top of the sash. Press the glass gasket in at all corners and then proceed to the sides. Be careful not to twist the gasket.



**Tip:** When replacing the gasket:  
An excess of 1 cm must be cut off from each side of the gasket. Cut off a slight amount from the corners and compress the gasket during installation.



[See video 5:22](#)



**A.+B. The espagnolette mechanism and handle are secured by re-installing the wedges.**

Control the handle for smooth operation.

