

Service Bulletin 315

FlexTec Window Rivet Installation

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Summary	This bulletin covers the installation of FlexTec Window Rivets. The window rivets replace the previous Velcro attachments for greater stability and durability.			
Products Affected	FlexTec, FlexTec T, and FlexTec XL doors with windows			
Keywords	flextec, windows, rivets			
Tools and Equipment Required	Drill with 1/8" bit, Loctite 495			
Parts and Materials Required	H1180012-0x PARTS ASSY, FLEXTEC n WINDOW REPLACEMENT			
Related Media	N/A			
	Issue Date	February 2025	Status	Active



WARNING

Read and understand the entire service bulletin before proceeding.

When instructed to do so, follow lockout/tagout procedures before servicing the door.

Overview

This bulletin covers the installation of FlexTec Window Rivets. The window rivets replace the previous Velcro attachments for greater stability and durability.

Kit Contents

- H1210833-0A WINDOW ASSEMBLY,LOW-TEMP,20" X 20"
- R1210719-0 RIVET,2-PIECE,PLASTIC,BLACK,98295A300

PROCEDURE

Safety Information And the Meaning Of Signal Words

Technical content produced by Rytec includes safety information which must be read, understood, and followed to reduce the risk of death, personal injury, or equipment damage. This information is boxed to set it apart from other text. The boxed text identifies the nature of the hazard and appropriate steps to avoid it.

Each safety alert includes at least three components. The safety alert symbol may be general alert symbol or an alert symbol specific to the hazard. The safety signal word indicates the likelihood and potential severity of injury due to the hazard. The safety information contains information about the hazard and how to safely mitigate it.

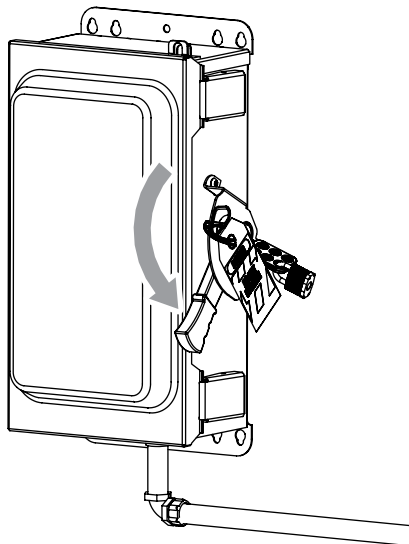
The following severities may exist for working with this kit:

	<table border="1"> <tr> <th colspan="2">DANGER</th></tr> <tr> <td colspan="2" data-bbox="354 514 966 577"> Danger indicates a hazardous situation which, if not avoided, will cause death or serious injury. </td></tr> </table>	DANGER		Danger indicates a hazardous situation which, if not avoided, will cause death or serious injury.	
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	<table border="1"> <tr> <th colspan="2">WARNING</th></tr> <tr> <td colspan="2" data-bbox="354 688 966 751"> Warning indicates a hazardous situation which, if not avoided, can cause death or serious injury. </td></tr> </table>	WARNING		Warning indicates a hazardous situation which, if not avoided, can cause death or serious injury.	
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Disconnect Power and Perform Lockout/Tagout

To prevent unexpected movement and exposure to hazardous voltages, disconnect the door from power and perform a lockout/tagout when instructed.

- 1 With the door panel in the down position, locate the disconnect switch. The disconnect switch may be a fused disconnect located near the System 4® controller or located on the controller itself.
- 2 Set the disconnect switch to the OFF position.



- 3 Perform a lockout/tagout on the disconnect switch.



Lockout
Tagout



CAUTION

Inform all users of the door when the door is out of service and when it is put back into service.

Prepare FlexTec Door for Window Replacement

- 1 Remove the existing FlexTec windows by tearing them free of the existing Velcro strips.



NOTICE

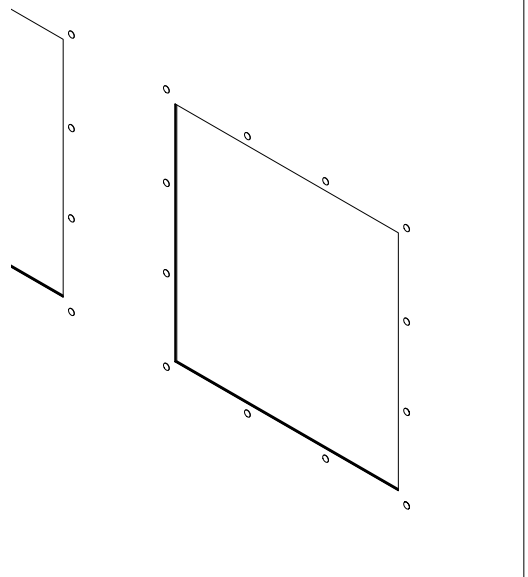
Do not remove the existing Velcro strips; doing so may damage the door panel and require additional replacement. The rivet windows can be installed with the Velcro strips in place.

- 2 Clean both sides of the FlexTec door panel using an approved cleaner.

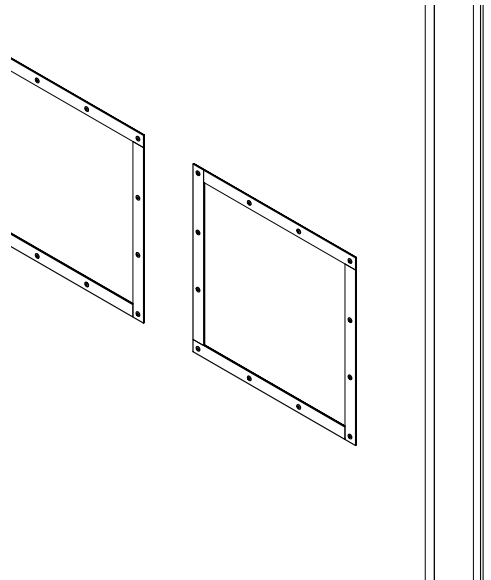
FlexTec Window and Rivet Orientation

- 1 Each FlexTec window has 12 rivets to hold it securely in place against the panel.

The flat head of the rivet faces the front of the panel.

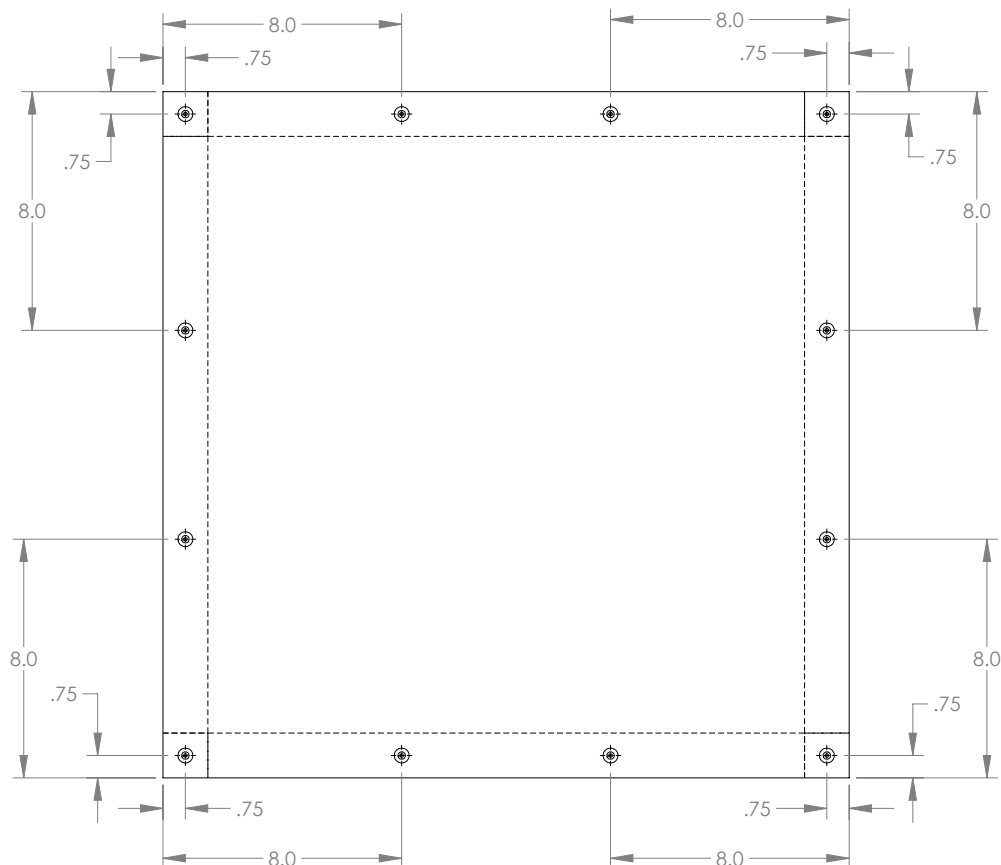


- 2 The window assembly and trimmed shank of the rivet faces the rear of the panel.



Installation

- 1 **If replacing a window** that did not use rivets, drill holes for the rivets with a 1/8" drill bit. The window assembly can be used as a template; it matches the following dimensions:
 - The corner rivets are offset from the edge of the window assembly to the center of the rivet by 0.75 inches.
 - Each of the two rivets adjacent to the corner rivets is offset from the center of the corner rivet to the center of the other rivet by 8.0 inches.



- 2 **Apply** a small amount of Loctite 495 to the trimmed shank of the rivet to help secure each rivet in place.
- 3 Starting with the corners, pass the rivet through the door panel and the window assembly. The rivet should be firmly attached and the panel should be tight with no bunching of the panel.

Resume Normal Operation

- 1 After installing the window assemblies, remove the lock-out tag-out from the door.
- 2 Operate the door for several cycles. Pay close attention to the areas of the panel around the window assemblies. There should be no unusual creasing or folding around the windows.