

The Alumil logo is displayed in a dark blue, sans-serif font. The letter 'A' is stylized with a diagonal slash. The logo is positioned within a yellow triangular graphic element that points to the right.

**Alumil**



MAINTENANCE MANUAL



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# Maintenance Manual

The optimal and smooth functionality of ALUMIL systems depends on the correct and regular maintenance of all their parts, following the provided general guidelines. It should be highlighted that ALUMIL products are of high quality, on condition that they are carefully maintained. An experienced maintenance technician must conduct inspections, perform necessary maintenance tasks, and fill in the Periodic Maintenance Log & Records. All materials and spares to be used should adhere to ALUMIL's standards.

## 1. Cleaning

- / Coated aluminium parts should be cleaned with solvent-free, non-abrasive, and pH-neutral detergent solution.
- / After cleaning, thoroughly rinse the aluminium part with clear water, and dry it using an absorbing or microfiber cloth, especially the corners and bottom profiles.
- / Do not use a water hose or pressure washer.



The following precautions need to be followed before the cleaning process:

- / The correct surface coating needs to be identified before the cleaning procedure.
- / Care should always be given to all the other materials that may be affected by the type of cleaning.
- / Cleaners should not be mixed.
- / Cleaning should be conducted during mild weather conditions, avoiding surfaces that are overheated or extremely cold .
- / Tools with hard edges or rough surfaces such as metal scrapers, sandpaper, etc. must not be used as they can harm the surface finish. Cleaning should be performed using a soft cloth.



## 1.1 Protective foil

Such foil is usually applied to the coated surface during fabrication, in order to avoid mechanical and/or other damage (e.g. cement, lime or paint). Clear tapes should be removed after a period not exceeding three months from the installation process. If further protection is required, new tape should be applied. Tape should be applied and removed as recommended by the tape supplier.

Any residue from the tape should be removed as soon as possible. Follow the instructions mentioned above.

Do not under any circumstances use strong solvents or solutions containing:

- / Chlorinated Hydrocarbons
- / Esters
- / Ketones
- / Abrasive cleaner or polish



## 1.2 Frequency of cleaning

The cleaning frequency depends on several factors, including:

- / The geographical location of the construction
- / The environmental setting of the building
- / The extent of atmospheric pollution
- / The prevailing wind
- / The protection of the building by neighboring structures
- / The possibility of airborne debris (e.g., sand/dust etc.) causing erosive wear of the coating
- / Changes in environmental conditions during the building's lifespan (e.g., rural becomes industrial)
- / The powder coating composition, for example:
  - ▶ Standard polyester– most regular cleaning
  - ▶ Super durable polyester- medium frequency cleaning



Marine - C4 Coastal



Industrial – C5I



Swimming Pool

The frequency of cleaning depends in part on the required standard of appearance and the requirements to remove deposits, which could, during prolonged contact with either the powder film or the metal substrate (if exposed), cause damage. Both anodised and painted aluminium should be cleaned regularly. For urban non-littoral areas that are not subjected to aggressive elements like air pollution or salty air, it is sufficient to clean the aluminium whenever you clean the glass.

In urban areas or areas by the sea, as well as in regions that are not exposed to rainfall, aluminium should be cleaned more often and thoroughly because the risk of coating degradation is higher there. This is because wind-blown salt and other pollutants may adhere to the surface and will not be cleaned away with rainfall.

Records of the cleaning schedules and frequencies shall be kept and maintained with Periodic Maintenance Log & Records.

The recommended frequencies are shown in the table below:

Climate		Temperate			Non - Temperate		
Environment		Class 1	Class 2	Anodization	Class 1	Class 2	Anodization
<b>Normal - C3 Inland</b>		12 months	18 months	24 months	9 months	15 months	18 months
<b>Marine - C4 Coastal</b>	2000 to 5000 m from coastline	12 months	18 months	24 months	9 months	15 months	18 months
	500 to 2000 m from coastline	6 months	9 months	12 months	6 months	6 months	9 months
	50 to 500 m from coastline	3 months	6 months	9 months	3 months	3 months	3 months
<b>Industrial - C5I</b>	2000 to 5000 m from source of pollution	12 months	18 months	24 months	9 months	15 months	18 months
	500 to 2000 m from source of pollution	6 months	9 months	12 months	6 months	6 months	9 months
	50 to 500 m from source of pollution	3 months	6 months	9 months	3 months	3 months	6 months
<b>Swimming Pool</b>	Greater than 2 m from edge of pool	3 months	3 months	3 months	3 months	3 months	3 months

Type of Climate		Temperature Range	Highest Temperature with RH $\geq$ 95%
<b>Temperate</b>		-33°C to 35°C	25°C
<b>Non Temperate</b>	<b>Warm Arid</b>	-20°C to 40°C	27°C
	<b>Extremely Warm Arid</b>	3°C to 55°C	28°C
	<b>Tropical</b>	5°C to 40°C	33°C

## 2. Maintenance

Periodic inspection of the elements is highly significant. The frequency of the inspections depends on the type, the location, and the number of operation cycles of each opening, and should be performed as described in the table below:

Use	Frequency
<b>Intensive use of systems (Schools, Hospitals, commercial buildings etc.)</b>	At least once per 3 months
<b>Normal or rare use of systems</b>	At least once per 6 months
<b>Panic doors (EN 1125)</b>	At least once per month
<b>Systems that are related to safety</b> <b>Systems in heavy environmental conditions (e.g. industrial areas, nearby sea or rivers)</b>	More regularly, according to each country's legislation

Irregularities observed during maintenance, should be immediately reported to a specialist repair technician



## 2.1 Drainage slots

In hinged systems, clean the dust and dirt gathered between the gaskets and the frame with a vacuum cleaner.

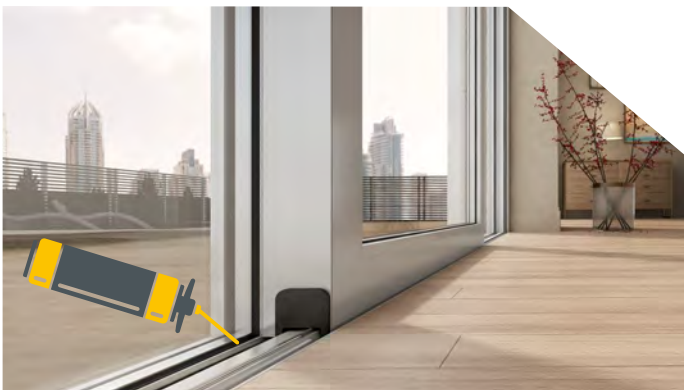


In sliding systems or folding doors, clean the dirt from the bottom profile using a vacuum cleaner.

Unblock the drainage slot using a stick or a cotton bud.

The guide rails must be cleaned at least once every three months, using a soft cloth to remove any blocking item.

## 2.2 Gaskets and pile seals

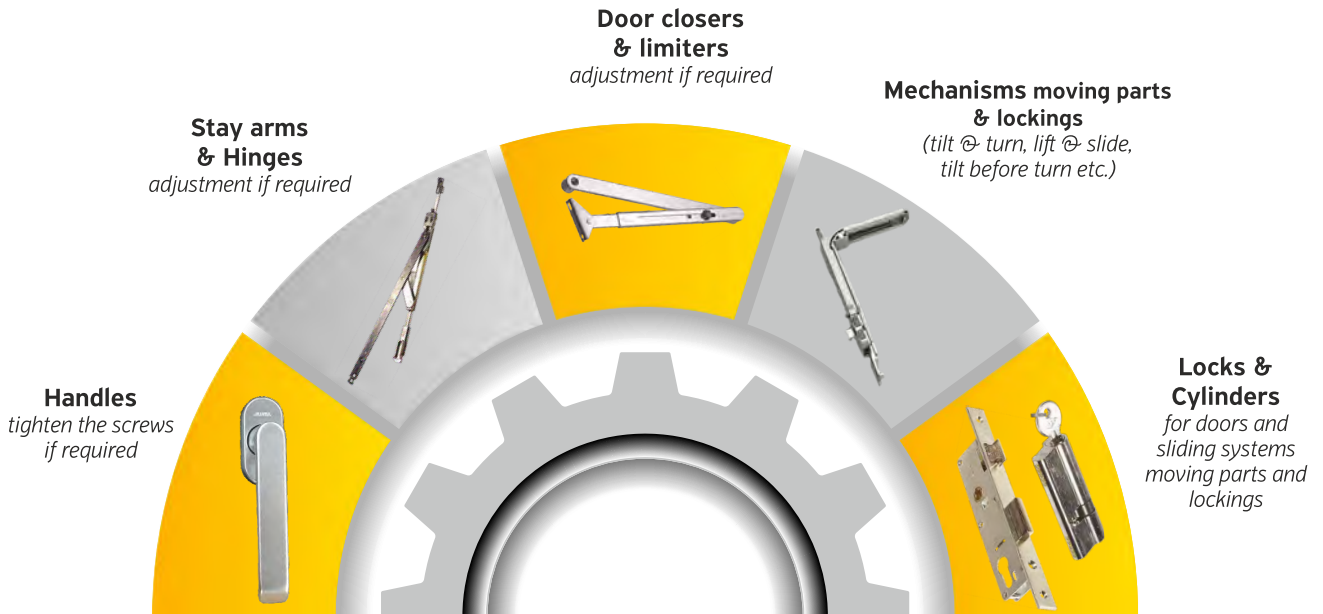


All gaskets need to be properly maintained by being carefully cleaned and applying silicone spray annually. The pile seals need to be visually checked for damage.



## 2.3 Hardware and accessories

Lubricate and check the operation of all moving parts for smoothness and unobstructed function on accessories of the categories below:



!! Apply a reasonable amount of lubricant and wipe any excess from the surface.

## 2.4 Screws and fixing systems

All parts should be correctly fastened. Inspect the fastening, and in case of loose screws or parts, their required tightening or replacement should be immediately performed by authorised and specialised staff.

All screws should be tightened with moderate force and always following the hardware used. In case of excessive force, there is a risk of stripping the screw or breaking the hardware.



## 2.5 Electrical components



- / Cable connection check must follow each country's electrical equipment installation legislation.
- / Repairs and maintenance of the motor and/or lock should only be performed by qualified technicians.
- / Before maintenance or repairs always disconnect the motor from the power supply.
- / Ensure that water never enters the motor housing, even during cleaning

## 2.6 Stainless steel pull handles



Under humid conditions, brown spots may appear on the surface (this may be accelerated in coastal areas). These spots do not affect the strength, integrity, or longevity of the material; it is simply a superficial discolouration that requires cleaning to restore the inox to its original appearance.

If brown spots appear on the inox, they can easily be removed simply by using a common cleaner for stainless surfaces and a Scotchbrite-type sponge that cleans and restores its appearance.



### 3. Periodic Maintenance Log & Records Template

Date	Task description	Area of maintenance	Person responsible	Comments
eg. 24/02/2021	Inspection of Stay arms	Room 115	Mr Qualified Technician	Lubrication with EX-7672040000

For cleaning and maintenance products please contact an ALUMIL representative.

Available codes	Description
<b>EX-7707100000</b>	ALU CLEANER 1LT ALUMIL
<b>EX-7700000500</b>	QUANTUM SILICONE SPRAY 400ML
<b>EX-7672040000</b>	MECHANISM LUBRICATOR 0,4kg



The above mentioned instructions safeguard a proper functionality of ALUMIL systems. It is duly noted that ALUMIL bears no liability for any damages due to improper maintenance and use of the aluminium constructions. Moreover ALUMIL shall not be responsible for any misuse of aluminum constructions for a purpose for which they were not intended to.



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