

STC GH40 Greenhouse Assembly Instructions



Modular greenhouses, garden sheds, outdoor garden elements and accessories
Designed and manufactured by Rion
A Member of the Plasson Group



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Safety First

- Check the contents of the greenhouse packaging against the packing list and the required parts for your model on page 4 and following. **Do not begin assembly if any parts are missing.**
- Please read these *Assembly Instructions* completely before assembly and keep them in your records so you can refer to them if you wish to add options or make repairs.
- The instructions in this manual lead you through each step in the assembly process. It is important for you to follow them closely.
- We recommend that you use gloves during assembly.
- STC is not responsible for the misuse of tools or parts.
- If local building codes require permits or licenses make sure that they are acquired before beginning.
- Your Greenhouse should be securely anchored to the prepared foundation or the Modular Base (available as an option) using the recommended hardware.
- If you prepare a concrete foundation do not excavate and pour concrete in frozen ground.
- Exercise caution when lifting heavy assemblies.
- Do not attempt to assemble your Greenhouse in high winds.
- We recommend that you place your Greenhouse in a spot where it will receive direct sunlight and will be protected from the wind as much as possible. The door should not face prevailing winds.
- When your Greenhouse is fully assembled examine it for sharp edges and trim with a razor knife if necessary.
- Close all roof vents in high winds.
- It is important to clear your Greenhouse of snow in the winter.
- Make sure that the temperature in the greenhouse never exceeds 70° C (155° F). Ensure good ventilation during hot days or provide a shading screen (available as an option). This is especially important if you live in a hot climate.

Required Tools

Before you start assembly have the following available:

- Measuring tape
- Level
- Scissors
- Gloves
- Razor knife

Note: *You may find some parts easier to assemble if you first moisten them with soapy water.*

Concrete Foundation

- 70 mm x 6 mm (2³/₄" x 1/4") screws and concrete anchor set or expansion anchor. (See quantities on page 3.)
- Hammer
- Power drill and an 8 mm (5/16") masonry bit
- Screwdriver for screws or wrench for expansion anchors. A power tool with the appropriate bit is recommended.
- Two clamps to squeeze profiles (optional)

Note: *If you have purchased a Modular Base all hardware is included.*

Accessories

- Your Greenhouse comes with two roof vents. Additional roof vents (Part WIN31 for outside panels and Part WIN31A for inside panels) are available as an option.
- A Modular Base can be purchased for your Greenhouse's foundation.

Introduction

Congratulations on purchasing an STC Greenhouse. We are certain that it will give you many happy years of pleasure in your garden.

The drawings in this manual are designed for the greenhouse owner who has purchased a GH44, which consists of one front unit (GH40A), one back unit (GH40B) and two module units (GH40M). If you have purchased additional modules (PGHM) the instructions are indicated in the text.

The Greenhouse has been designed to be as easy to put together as it is beautiful to look at. Most of the work can be done by a single person. Only attaching the roof requires the help of a family member or neighbor for a short while.

Easy assembly methods eliminate the need for tools or special expertise.

- 1 Connect the specified parts.
- 2 Match the holes in the profiles and the connectors. Place a pin on the pin tool and push the pin through the lined-up holes to lock the parts in place. Many connections require pins on both sides.

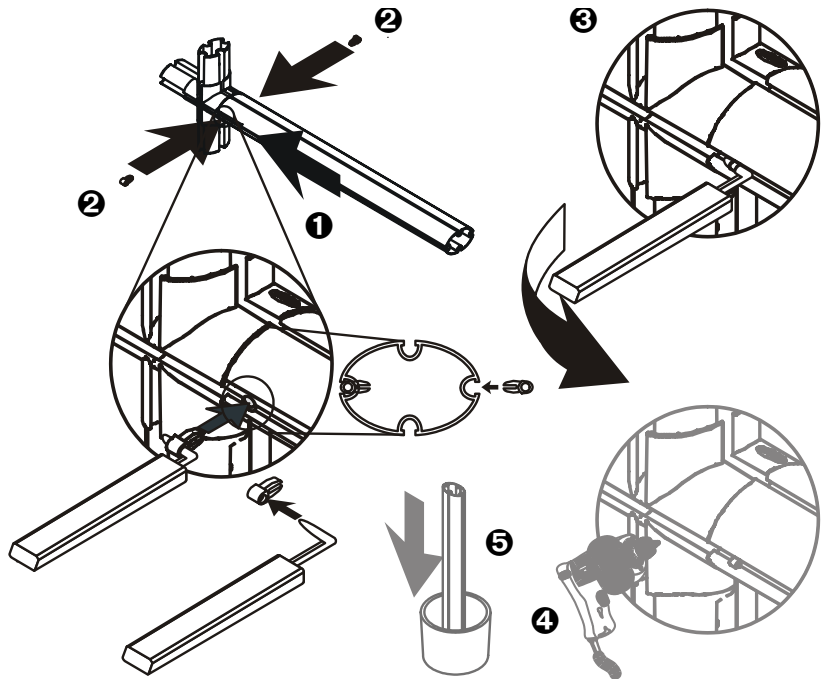
Note: *Extra pins are included.*

- 3 If you wish to disassemble the parts at any time, remove the pins using the pin tool. Place the end into the exposed hole and lever the pin out.
- 4 If a hole in the connector is missing, drill a hole with a 6 mm (1/4") drill bit through the assembled profile and then insert the pin.
- 5 In extremely rare cases connectors will not slip into some round or oval profiles. In this case place the affected part into 10 cm (4") of boiling water for 15 seconds before connecting.

Note: *In some models profiles have identification stickers. We recommend removing them as you work.*

Greenhouse assembly is done in the following steps:

- Prepare a Foundation for Your Greenhouse** (page 3)
- Identify Greenhouse Parts** (page 4)
- Prepare Your Parts for Assembly** (page 7)
- Lay Out the Greenhouse Frame** (page 8)
- Secure the Frame to the Foundation** (page 9)
- Assemble the Roof Pediments** (page 10)
- Assemble Roof Framework** (page 12)
- Cover the Greenhouse Roof** (page 13)
- Raise the Roof** (page 16)
- Cover the Walls** (page 17)
- Seal Panels** (page 19)
- Assemble the Doors** (page 20)
- Hang the Doors** (page 21)
- Final Touches** (page 22)



Prepare a Foundation for Your Greenhouse

Before assembling your new Greenhouse a proper foundation must be prepared. A number of anchoring options are possible, based on wind and ground conditions in your area. Make sure that you have checked with your local authorities regarding any required building permits.

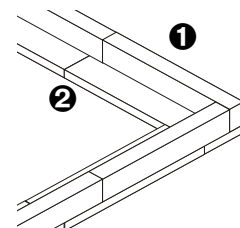
Decide at this time the final orientation of your Greenhouse. We recommend that you place your greenhouse in a spot where it will receive direct sunlight and will be protected from the wind as much as possible. The door should not face prevailing winds. It is important to clear your Greenhouse of snow in the winter.

Modular Base (Option)

If you have purchased the optional Greenhouse Modular Base follow the assembly instructions in the packaging. The Greenhouse Modular Base can be placed in an excavated hole or on the ground. In either case you will require approximately 0.17 cubic meters (6 cubic feet) per module of gravel or earth or other suitable material to fill the base. All required hardware is included.

Treated Wood Base

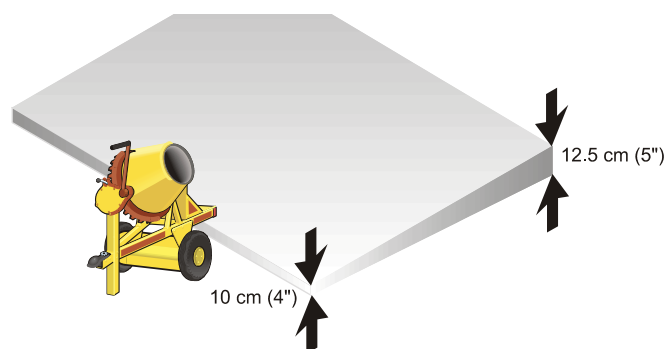
Build a framework composed of 4 × 6 (❶) and 2 × 6 (❷) treated lumber using deck screws or galvanized lag bolts and fill it with gravel or earth or other suitable material to fill the base up to the top surface of the 4 × 6 (❶). Attach the greenhouse frame through the connectors using screws that are 6 mm (1/4") in diameter and no less than 70 mm (2 3/4") long (not supplied). See hardware quantities, foundation measurements and filler specifications below.



Concrete Foundation

Prepare a poured concrete foundation according to local building codes. Do not excavate and pour concrete in frozen ground. Make sure that there is a slight slope for drainage.

Pour your foundation according to the size of the greenhouse model you have selected. Make sure that the foundation is at least 10 cm (4") larger than the size of the greenhouse.



Model	Modules	Foundation Width	Foundation Length
GH8×8	PGHF+PGHM+PGHM+PGHB	2.70 meter (8' 10")	2.70 meter (8' 10")
GH10×8	PGHF+PGHM+PGHM+PGHM+PGHB	2.70 meter (8' 10")	3.30 meter (10' 11")
GH12×8	PGHF+PGHM+PGHM+PGHM+PGHM+PGHB	2.70 meter (8' 10")	3.95 meter (12' 11")
GH14×8	PGHF+PGHM+PGHM+PGHM+PGHM+PGHM+PGHB	2.70 meter (8' 10")	4.55 meter (15')
GH16×8	PGHF+PGHM+PGHM+PGHM+PGHM+PGHM+ PGHM+PGHB	2.70 meter (8' 10")	5.20 meter (17')

The Greenhouse is secured to the concrete foundation using screws and concrete anchors or expansion anchors (not supplied). Use screws 6 (1/4") mm in diameter and no less than 70 (2 3/4") mm long. A drill with an 8 mm (5/16") masonry bit is required. Required quantities are shown below.

GH8×8	GH10×8	GH12×8	GH14×8	GH16×8	Description
20	24	28	32	36	70 mm × 6 mm (2 3/4" × 1/4") screw/anchor set or expansion anchor

Note: You may assemble the greenhouse on its base on a hard surface and move it to its final position when you have finished. Make sure that there are no obstructions between the assembly area and the final position.

Other Foundation Options

Wood Deck

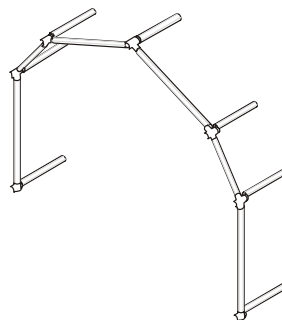
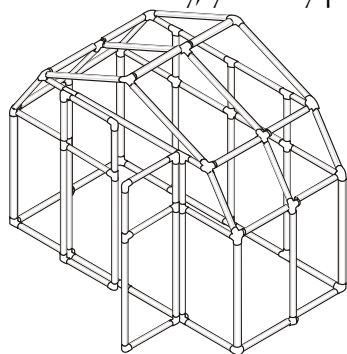
Your Greenhouse can be secured to a wood deck with screws (not supplied) through the frame connectors. Use screws that are 6 mm (1/4") in diameter and no less than 70 mm (2 3/4") long. Make sure that the wood deck itself is securely anchored to the ground. See hardware quantities and foundation measurements above.

Excavated Trench

Your Greenhouse can be placed in an excavated trench to anchor it to the ground. See the foundation measurements above for dimensions.

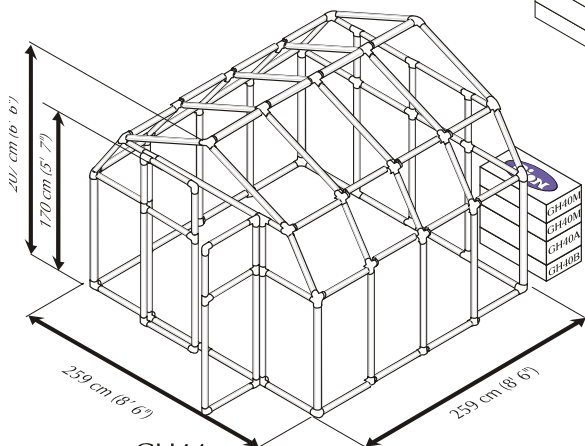
Identify Greenhouse Parts

Because of the Greenhouse modularity, you may purchase additional GH40M modules to fit your needs.

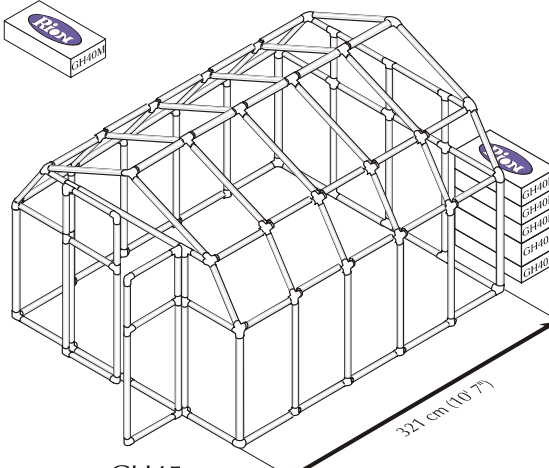


GH40A + GH40B

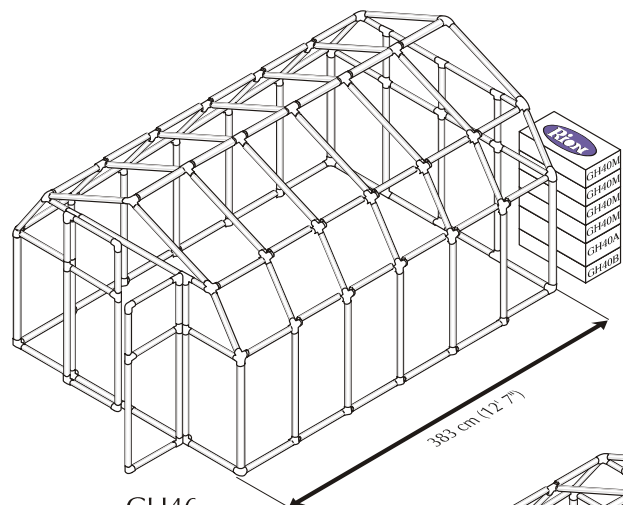
GH40M



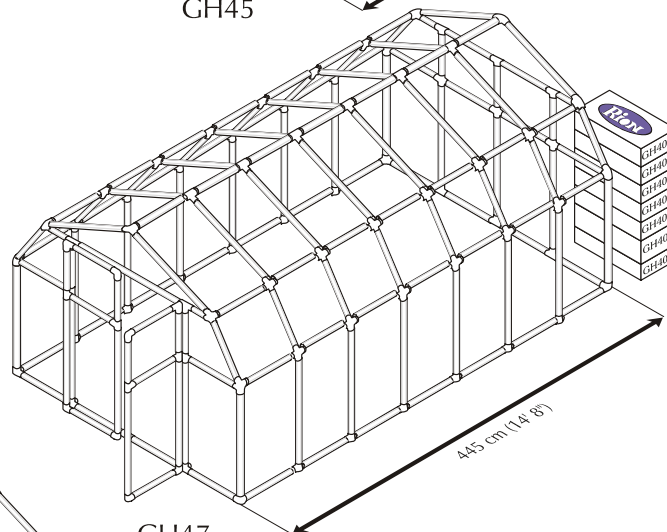
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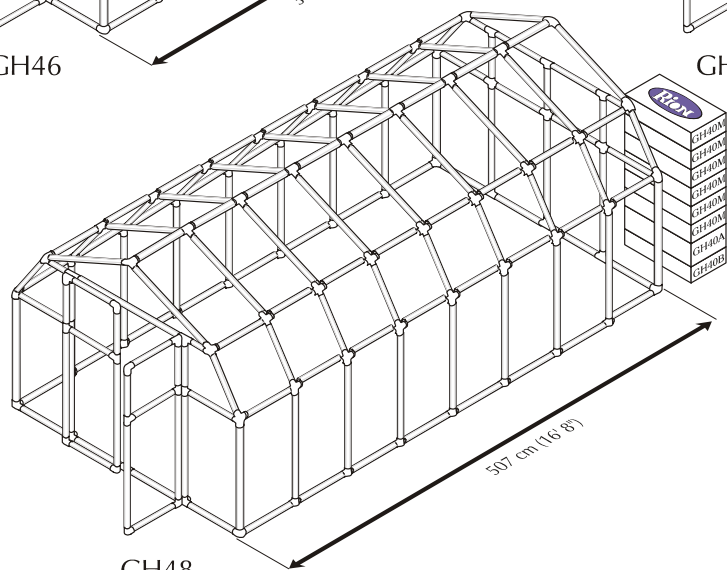
GH45



GH46



GH47



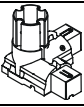



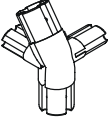

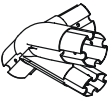
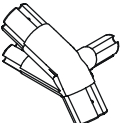
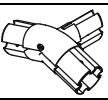
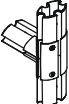
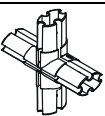






GH48






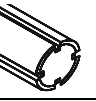









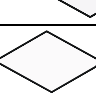
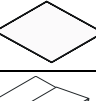


Take a minute to make sure you have everything you need.



Note: Do not proceed with assembly if any parts are missing.

The part code is stamped on each connector. Profiles are listed in order by size, largest to smallest. Panels are identified with stickers.

Exact dimensions can be found in the packing list.

	Part Code	GH8×8	GH10×8	GH12×8	GH14×8	GH16×8	Description
	01	4	4	4	4	4	Corner Frame Connector
	2D	11	13	15	17	19	Frame Connector
	15	1	1	1	1	1	Doorway Frame Connector
	3A	2	2	2	2	2	Left Rib Connector
	4A	2	2	2	2	2	Right Rib Connector
	5A	15	20	25	30	35	Rib Connector
	6A	2	2	2	2	2	Left Pediment Connector
	7A	2	2	2	2	2	Right Pediment Connector
	8A	2	2	2	2	2	Top Pediment Connector
	09	11	11	11	11	11	T-Oval Connector
	10	3	3	3	3	3	Oval Junction Connector
	18	4	4	4	4	4	Corner Oval Connector
	18B	2	2	2	2	2	Door Latch Connector
	B2	16	18	20	22	24	Base Profile (50 cm, 1' 7 ¹¹ / ₁₆ "
	R1	4	4	4	4	4	Round Profile (113 cm, 3' 8 ¹ / ₂ "
	R8	4	4	4	4	4	Round Profile (80.2 cm, 2' 7 ⁹ / ₁₆ "
	R2	4	4	4	4	4	Round Profile (53.4 cm, 1' 8"
	E4R	1	1	1	1	1	Right Upper Door Lintel (36.4 cm, 1' 2 ¹ / ₂ "
	E4L	1	1	1	1	1	Left Upper Door Lintel (36.4 cm, 1' 2 ¹ / ₂ "
	E1R	1	1	1	1	1	Right Lower Door Lintel (113 cm, 3' 8 ¹ / ₂ "
	E1L	1	1	1	1	1	Left Lower Door Lintel (113 cm, 3' 8 ¹ / ₂ "

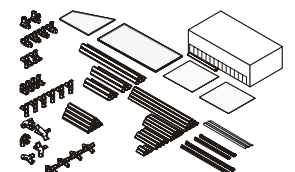
	Part Code	GH8×8	GH10×8	GH12×8	GH14×8	GH16×8	Description
	E27R	1	1	1	1	1	Right Upper Door Hinge (34.4 cm, 1' 1 ⁹ / ₁₆ "
	E27L	1	1	1	1	1	Left Upper Door Hinge (34.4 cm, 1' 1 ⁹ / ₁₆ "
	DoorW41	1	1	1	1	1	Door Handle Assembly
	E26R	1	1	1	1	1	Right Lower Door Hinge (108 cm, 3' 6 ¹ / ₂ "
	E26L	1	1	1	1	1	Left Lower Door Hinge - (108 cm, 3' 6 ¹ / ₂ "
	SROD	1	1	1	1	1	Door Latch Rod
	E12	1	1	1	1	1	Oval Profile (116.2 cm, 3' 9 ³ / ₄ "
	E1	9	11	13	15	17	Oval Profile (113 cm, 3' 8 ¹ / ₂ "
	E26	1	1	1	1	1	Oval Profile (108 cm, 3' 6 ¹ / ₂ "
	E6	2	4	6	8	10	Oval Profile (85 cm, 2' 9 ⁷ / ₁₆ "
	E2	6	41	48	55	62	Oval Profile (54 cm, 1' 9 ¹ / ₄ "
	E25	6	6	6	6	6	Oval Profile (46.3 cm, 1' 6 ¹ / ₄ "
	E4	3	3	3	3	3	Oval Profile (39.4 cm, 1' 3 ¹ / ₂ "
	E27	2	2	2	2	2	Oval Profile (34.4 cm, 1' 1 ⁹ / ₁₆ "
	E5	4	4	4	4	4	Oval Profile (13.4 cm, 5 ¹ / ₄ "
	SR1	2	2	2	2	2	Inner Round Profile (40 cm, 1' 3 ³ / ₄ "
	D1	2	2	2	2	2	Side Cap
	D2	3	4	5	6	7	Middle Cap
	PN1	14	16	18	20	22	Wall Panel - (59.7 × 118.3 cm) (1' 11 ¹ / ₂ " × 3' 10 ⁹ / ₁₆ "
	PN2	4	6	8	10	12	Lower Roof Panel - (60.5 × 66.7 cm) (1' 11 ¹³ / ₁₆ " × 2' 2 ¹ / ₄ "
	PN2A	4	4	4	4	4	Lower Roof Panel (side) - (61.7 × 66.7 cm) (2' 5 ⁵ / ₁₆ " × 2' 2 ¹ / ₄ "
	PN5L	2	2	2	2	2	Side Panel (Left) - (58.1 × 44.9 cm) (1' 10 ⁷ / ₈ " × 1' 5 ¹ / ₁₆ "
	PN5R	2	2	2	2	2	Side Panel (Right) - (58.1 × 44.9 cm) (1' 10 ⁷ / ₈ " × 1' 5 ¹ / ₁₆ "
	PN8R	2	2	2	2	2	Pediment Panel Half (Right)
	PN8L	2	2	2	2	2	Pediment Panel Half (Left)
	ST7	4	4	4	4	4	Window Couplers
	PN9	2	2	2	2	2	Upper Back Wall Panel - (59.9 × 44.7 cm) (1' 11 ⁹ / ₁₆ " × 1' 5 ³ / ₈ "
	PN40	4	6	8	10	12	Top Roof Panel - (60.5 × 97.6 cm) (1' 11 ¹³ / ₁₆ " × 3' 2 ³ / ₈ "
	PN40A	2	2	2	2	2	Top Roof Panel (outside) (60.21 × 96.9 cm) (2' 5 ⁵ / ₁₆ " × 3' 2 ³ / ₈ "
	PN41	2	2	2	2	2	Door Panel (bottom) - (51.8 × 113.5 cm) (1' 10 ⁷ / ₈ " × 3' 8 ¹ / ₁₆ "
	PN43	2	2	2	2	2	Door Panel (top) - (51.8 × 39.9 cm) (1' 10 ⁷ / ₈ " × 1' 3 ¹ / ₁₆ "
	WIN33	2	2	2	2	2	Roof Vent
	WINH31	2	2	2	2	2	Roof Vent Handles (packages of 2)

	Part Code	GH8×8	GH10×8	GH12×8	GH14×8	GH16×8	Description
	GSC10	2	2	2	2	2	Back Pediment Strengthening Bar
	GSC12 (inside E12)	1	1	1	1	1	Front Pediment Strengthening Bar
	DSN	1	1	1	1	1	Door Sealer (roll)
	GF	1	1	1	1	1	Flexible Glazing Seal (roll)
	RA1	4	5	6	7	8	RA Glazing Element (57.3 cm, 1' 10 ⁹ / ₁₆ "
	RB4	6	8	10	12	14	RB Glazing Element (84.8 cm, 2' 9 ³ / ₈ "
	RB6	4	4	4	4	4	RB Glazing Element (80 cm, 2' 7 ¹ / ₂ "
	RB1	10	12	14	16	18	RB Glazing Element (57.3 cm, 1' 10 ⁹ / ₁₆ "
	RC5	10	12	14	16	18	RC Glazing Element (95.5 cm, 3' 1 ⁵ / ₈ "
	RC1	10	12	14	16	18	RC Glazing Element (66.6 cm, 2' 2 ¹ / ₄ "
	RC3	4	5	6	7	8	RC Glazing Element (58 cm, 1' 10 ³ / ₈ "
	RD1	16	20	24	28	32	RD Glazing Element (56.9 cm, 1' 10 ³ / ₈ "
	PIN1	3	4	5	6	7	Connector Pin (packages)
	GT1	2	2	2	2	2	Pin and Glazing Tool
	SF	1	1	1	1	1	Soft Foam Roof Insulation (roll)
SUPP1		3	4	5	6	7	Roof Reinforcement Kit (Packets)
	AS 70	6	8	10	12	14	Cable screw
	AW5	1	1	1	1	1	Allen Wrench
	Hook1	3	4	5	6	7	Top Catch
	CAB40	3	4	5	6	7	Cable
Door Kit							
	LAT1	1	1	1	1	1	Inner Door Latch
	PS1"/14	3	3	3	3	3	Inner Door Latch Screw
	PIP4	1	1	1	1	1	Door Threading Tube
	PLPCE	1	1	1	1	1	T-Hinge Insert
	18D	1	1	1	1	1	Handle Module Connector

The assembly drawings below are designed for the greenhouse owner who has purchased a GH8×8, which consists of one GH40A, two GH40Ms, and one GH40B. If you have purchased a model with more GH40M modules the instructions are indicated in the text.

Prepare Your Parts for Assembly

Remove everything from your packages and sort them according to part type. Since assembly is done from taking parts from every box, it is best to put everything together. The boxes are printed with a ruler to help you distinguish between profiles.



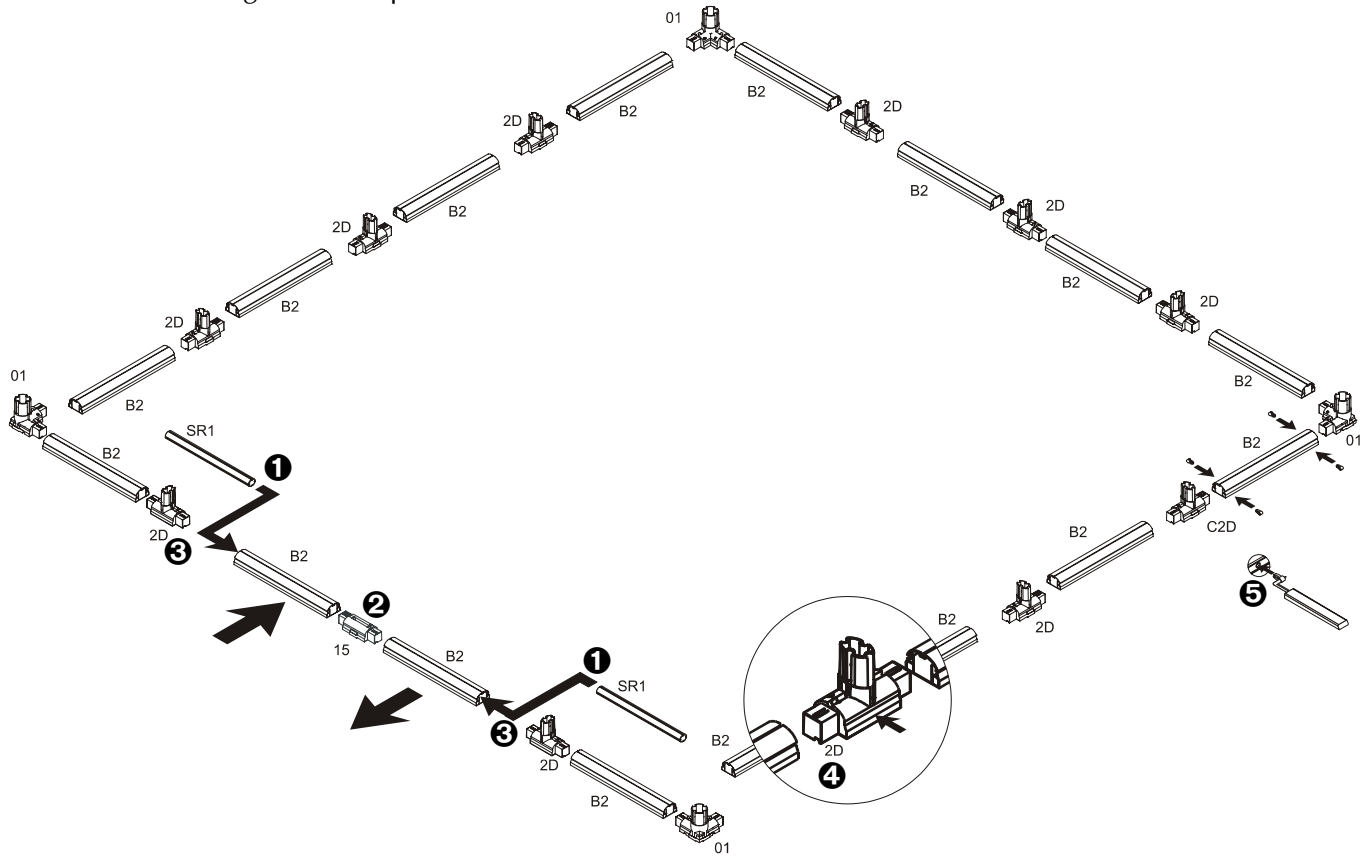
Note: Protect unassembled panels from the sun to prevent identification stickers from adhering to the glazing.

Lay Out the Greenhouse Frame

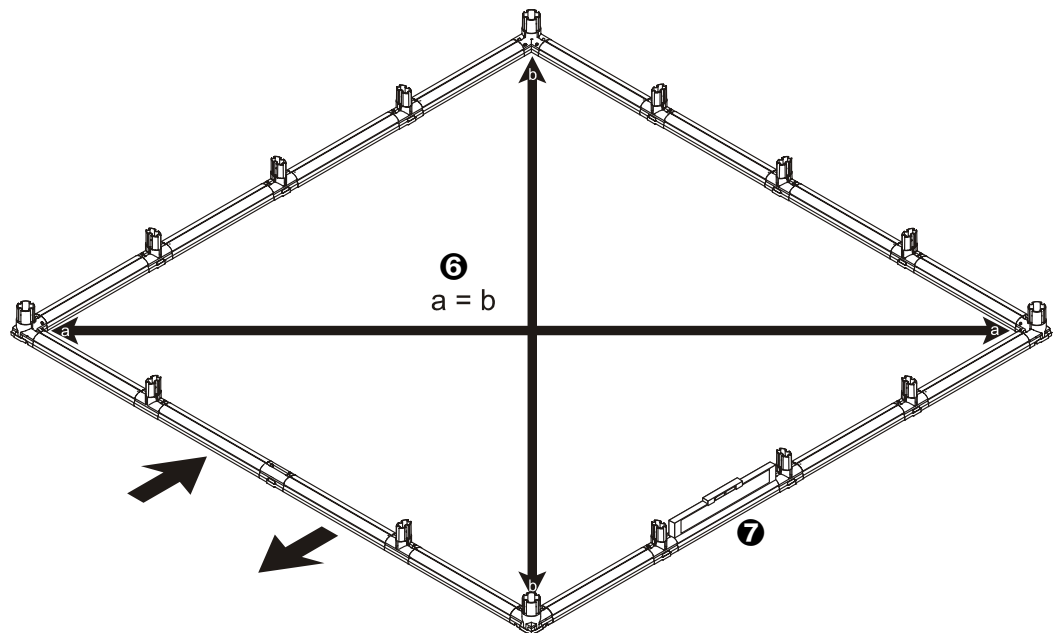
Decide in which direction the door will face and place the parts on the prepared foundation or wood deck.

Note: If you are using a modular base or other foundation option (see page 3) assemble the base on a flat surface (such as a driveway or a garage) and then move it into position when you are done.

- 1 Slide the SR1 profiles into the two B2 frame profiles that will be used for the doorway.
- 2 Place the two prepared B2 frame profiles on either side of the 15 connector.
- 3 Place a 2D connector on both sides.
- 4 Place the other parts of the frame in place and push them together. Make sure that the channel of the 2D connectors faces outward. Each base connector is stamped with an arrow pointing to the outside direction.
- 5 Lock the frame together with pins.



- 6 Make sure that the frame is perfectly rectilinear by measuring the diagonals and verifying that they are the same.
- 7 Use a level to make sure that the frame is level.



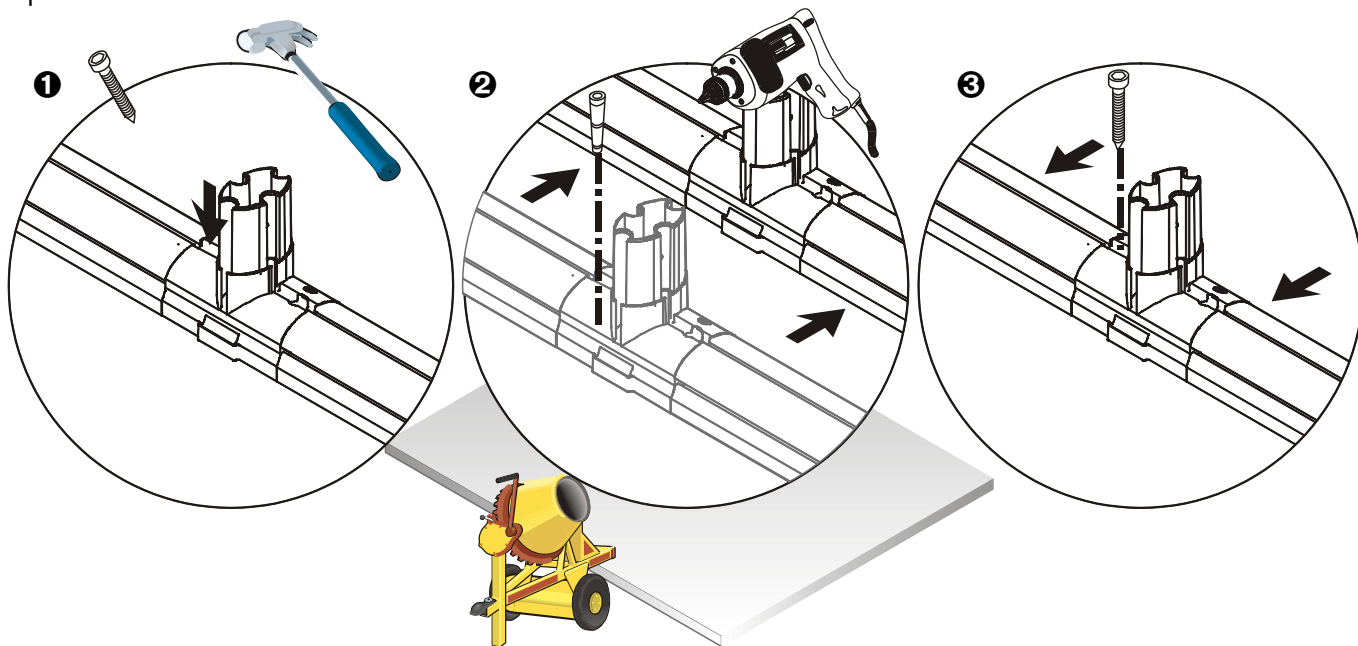
Secure the Frame to the Foundation

Make sure you have the proper hardware before beginning this step. (See page 3.)

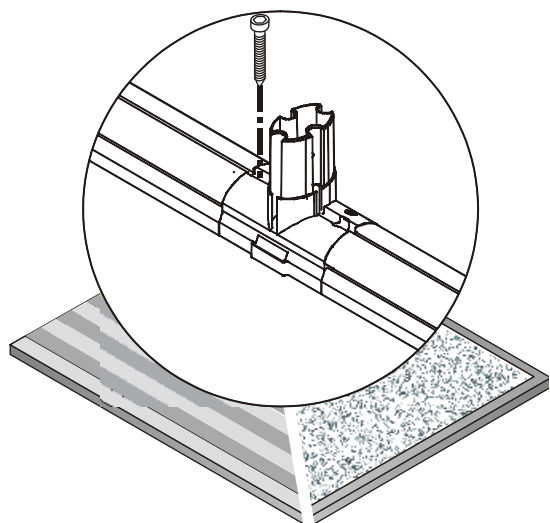
Note: If you are using a modular base and filler you may assemble the greenhouse on a hard surface and move it to its final position when you have finished. Make sure that there are no obstructions between the assembly area and the final position.

Concrete Foundation

- 1 Mark the foundation through each connector using a scribe or screw.
- 2 Carefully move the frame and then drill holes using a 8 mm ($\frac{5}{16}$ ") masonry bit. Insert concrete anchors or expansion anchors (not supplied) in each hole.
- 3 Move the frame back into place. Make sure that it is still perfectly rectilinear. Secure the screws/anchors in place.



Modular Base, Wood Deck, or Treated Foundation



Insert screws into the frame connector holes and secure them to the base.

Note: If you have purchased the Modular Base all necessary hardware is included.

Assemble the Roof Pediments

❶ Put ST7 couplers on the PN8R and PN8L pediment panel halves as shown. The tops of each coupler are trimmed to match the angle of the panel.

Note: The outside surface of the panels have special UV protection, indicated by the logo and the plastic identification strip. Remove plastic ID strips when as panels are locked in place.

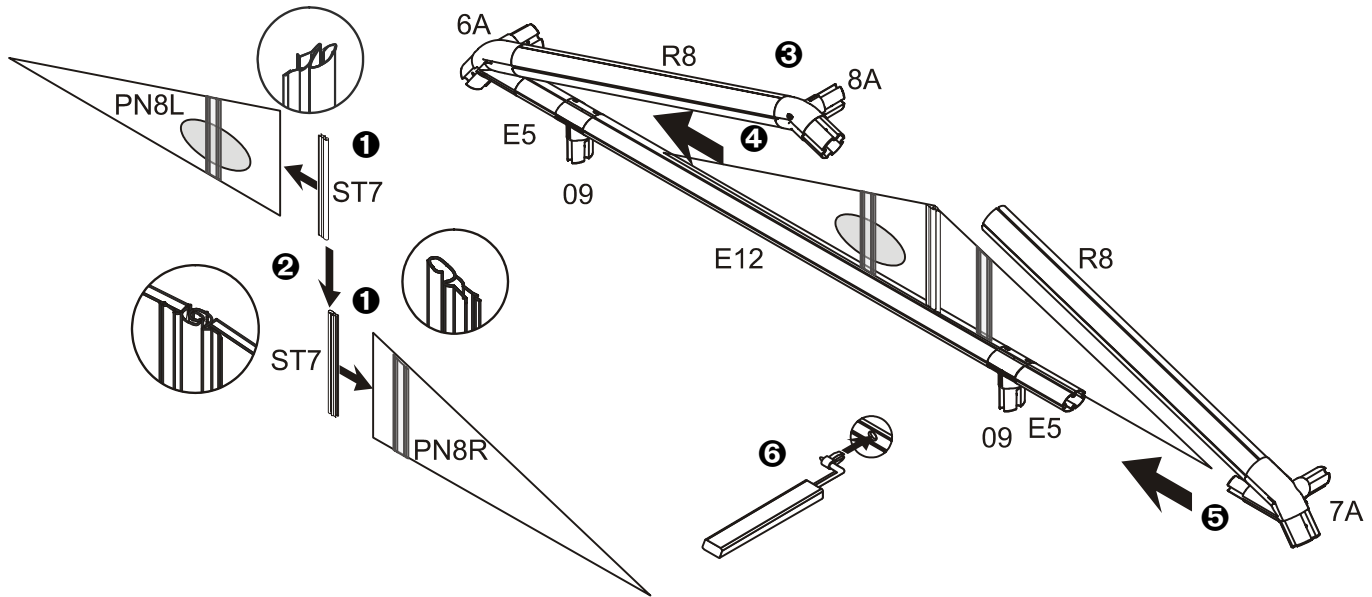
❷ Slide the two pediment panel halves together.

❸ Assemble all parts of the front pediment except for the 7A connector and the R8 profile. Take care that the internal metal strengthening bar in the E12 profile remains in place.

❹ Slide the assembled PN8R/PN8L pediment panel into the open space of the pediment.

❺ Complete the front pediment with the 7A connector and the R8 profile, taking advantage of the flexibility of the profiles.

❻ Lock the pediment in place using pins and remove the ID strips from the panels.



Complete Doorway Pediment

❶ Attach the E4R and R2 profiles to the lower right pediment. The E4R profile has a sticker indicating the up direction.

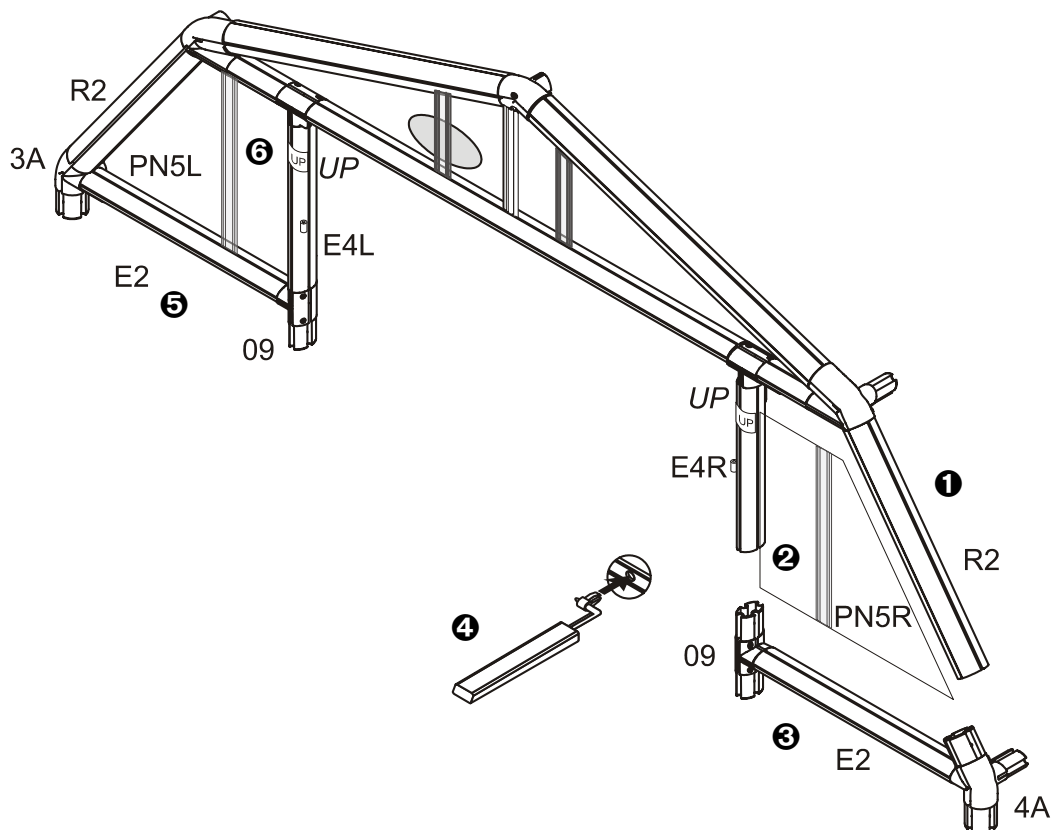
❷ Slide the PN5R panel in place. Make sure that the plastic ID strip faces out.

❸ Connect the 4A and 09 connectors to an E2 profile and put it in place taking advantage of the flexibility of the profiles.

❹ Lock the panel with pins.

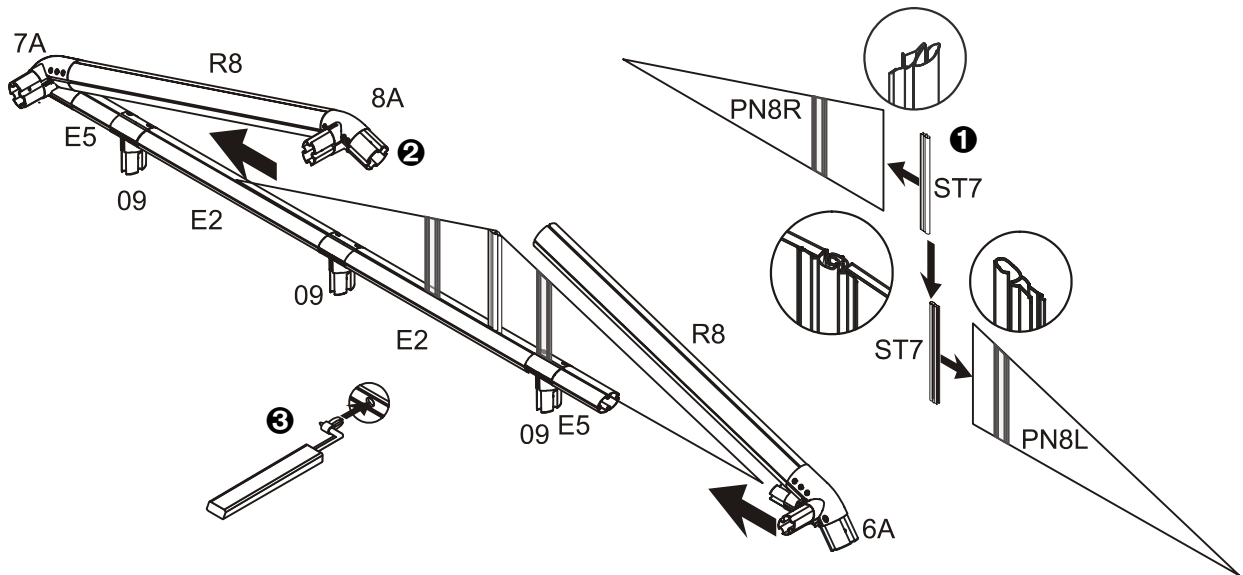
❺ Assemble the lower left pediment in the same way. Note the "UP" sticker on the E4R profile.

❻ Remove the ID strips from the panels.



Back Pediment

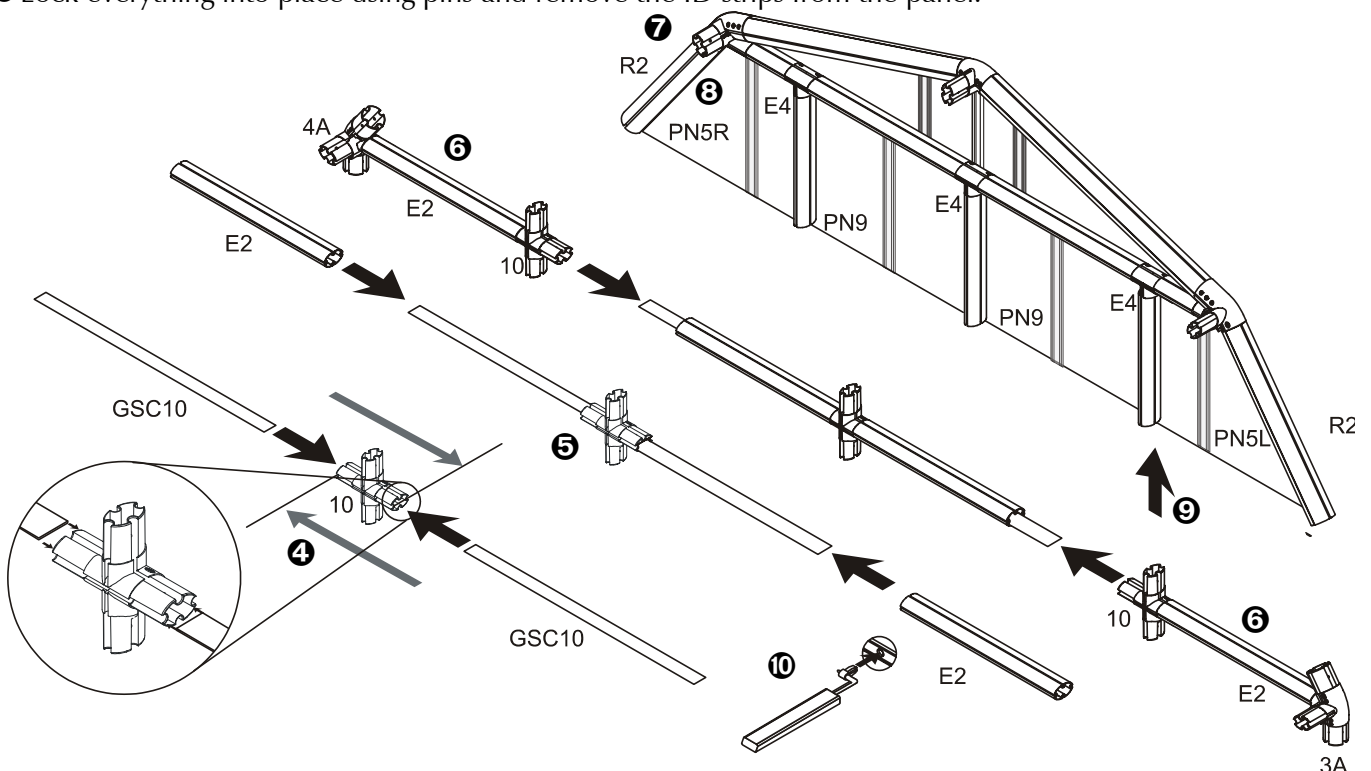
- ❶ Put ST7 couplers on the PN8R and PN8L pediment panel halves with the ID plastic strip facing outside. The tops of each coupler are trimmed to match the angle of the panel. Slide the two pediment panel halves together.
- ❷ Assemble all parts of the back pediment except for the 7A connector and the R8 profile and slide the assembled PN8R/PN8L pediment panel into the open space of the pediment. Complete the back pediment, taking advantage of the flexibility of the profiles.
- ❸ Lock the pediment in place using pins and remove the ID strips from the panels.



- ❹ Slide two GSC10 strengthening bars into both sides of a 10 connector, one in the upper section and the other in the lower section. They will overlap inside the connector and their ends will be flush with the far end.
- ❺ Slide two E2 profiles over the GSC10 strengthening bars. The ends of the strengthening bars will extend beyond the E2 profiles.
- ❻ Complete the back pediment support with the 10 connectors, E2 profiles and 4A and 3A connectors as shown.
- ❼ Put the remaining profiles on the back pediment top.
- ❸ Slide the back pediment panels in as shown. Make sure that the plastic ID strip faces the outside.

Note: If you have purchased one or more optional Louvered Windows insert them instead of the PN9 panels.

- ❾ Put the back pediment support in place, taking advantage of the flexibility of the profiles.
- ❿ Lock everything into place using pins and remove the ID strips from the panel.



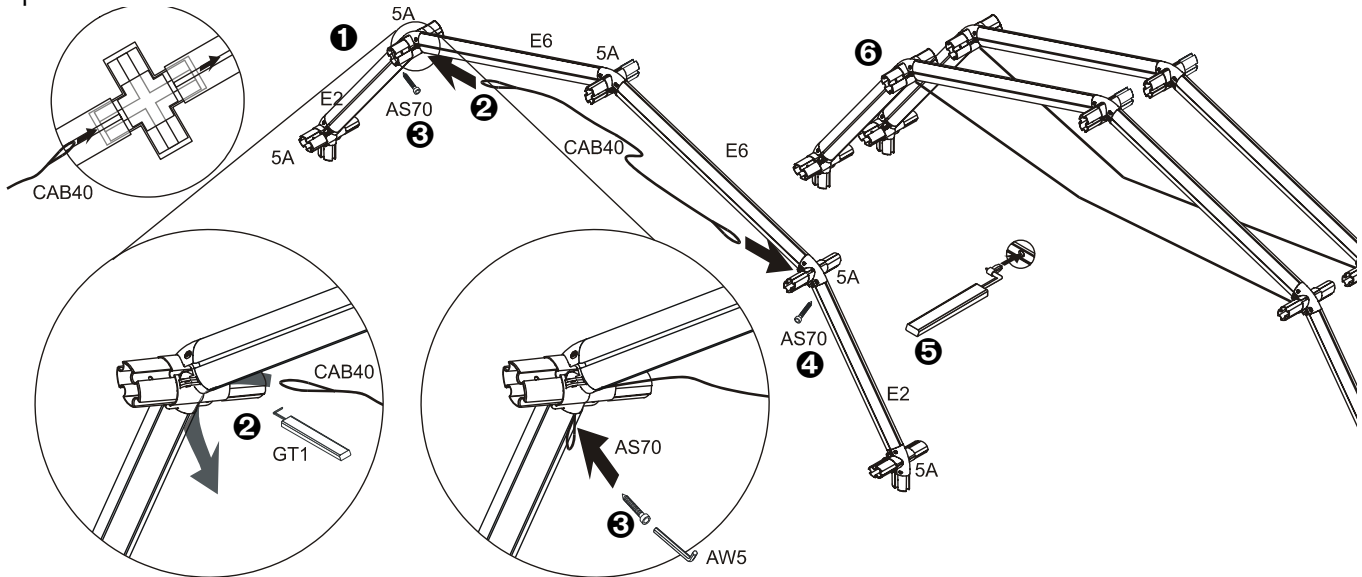
Assemble Roof Framework

Note: Assemble the roof in an area not too far away from the completed base.

- 1 First assemble the first arch.
- 2 Slip one end of the CAB40 cable through the 6 mm (1/4") channel on the underneath side of the 5A connector. You may use the GT1 pin and glazing tool to assist you. **The cable does not go through the central hole of the connector.**
- 3 Screw an AS70 screw using the AW5 Allen wrench through the CAB40 cable and the pin holes in both sides of the connector.

Note: The end of the screw should not extend beyond the outside channel of the E2 profile so it won't interfere with the placement of the RB1 glazing element (page 13).

- 4 Repeat the previous two steps for the 5A connector on the other side of the arch.
- 5 Lock the parts in place using pins.
- 6 Repeat steps 1 through 5 for the rest of the arches according to the number of GH40M modules you have purchased.

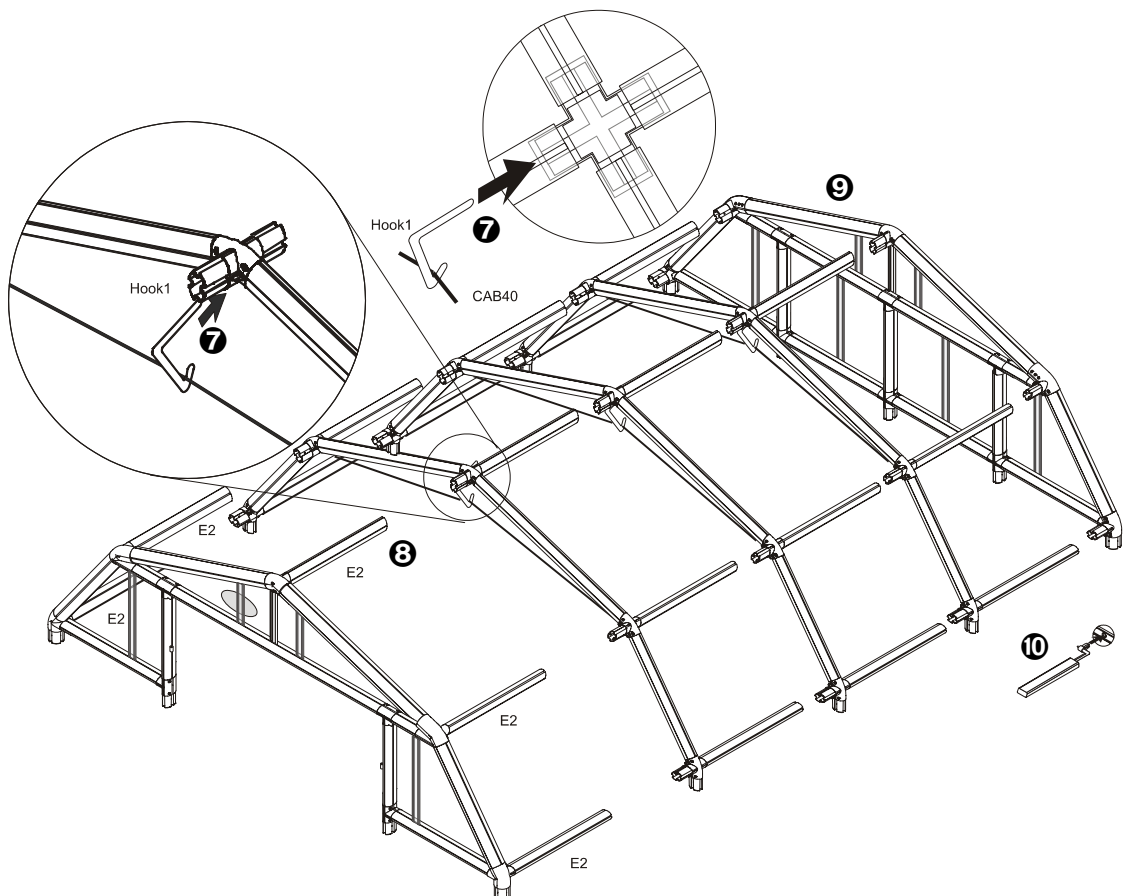


- 7 Grasp the center of each CAB40 cable with the Hook1 Top Catch and slide it into the top 5A connector as shown.

- 8 Add E2 profiles to the front pediment and lock the parts in place using pins.

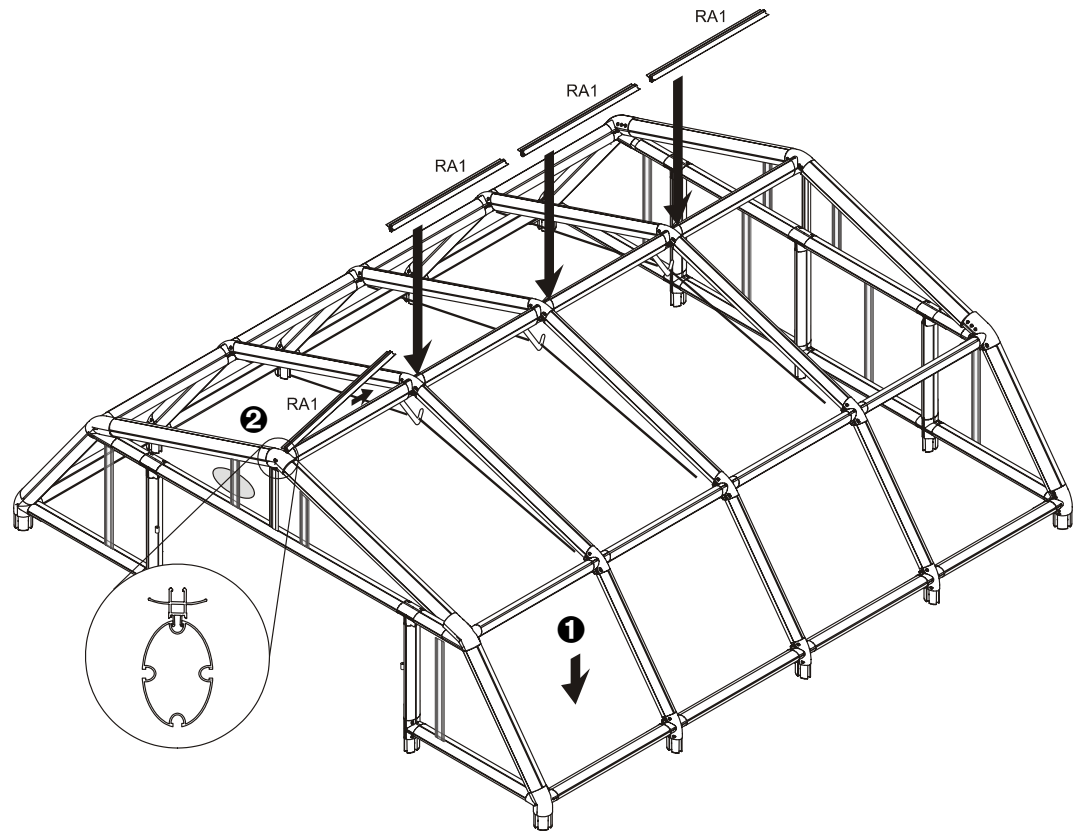
- 9 Add E2 profiles to the completed ribs according to the number of modules you have purchased and lock them into place with pins.

- 10 Complete the roof by attaching the back pediment. Lock it into place with pins.

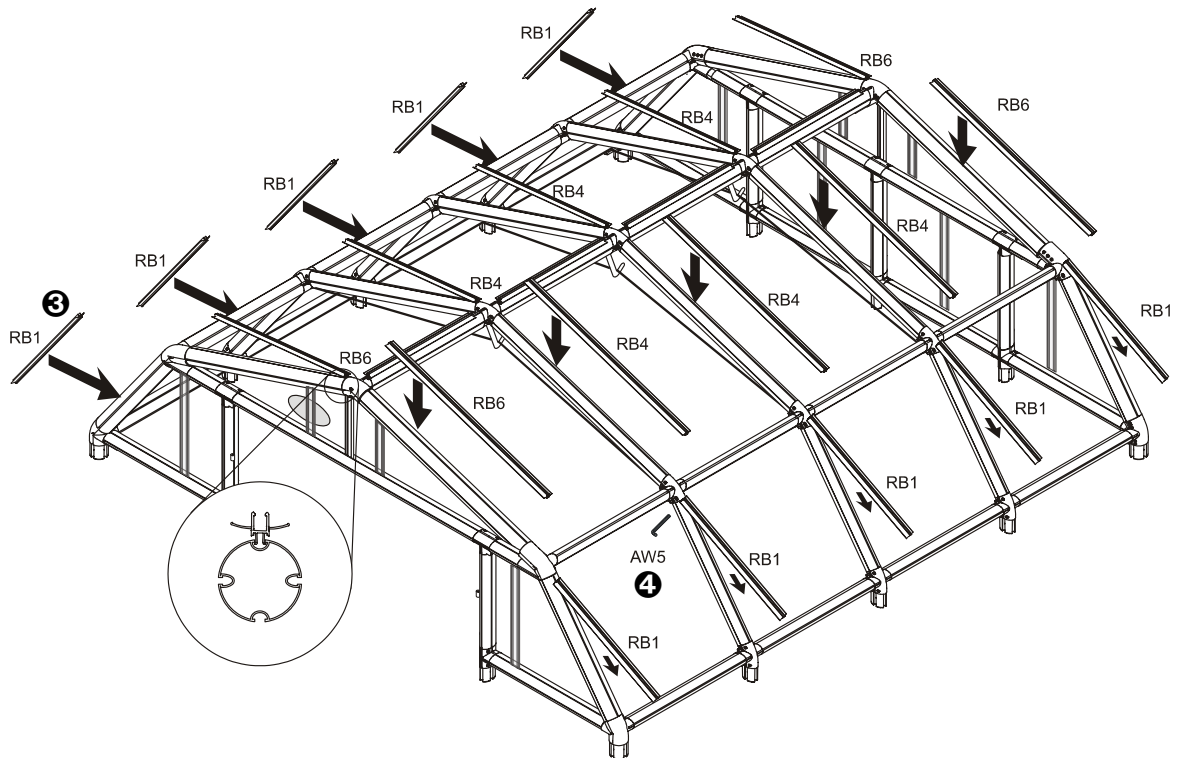


Cover the Greenhouse Roof

- 1 Step in the framework of the lower window to reach the top of the roof conveniently.
- 2 Place RA1 glazing elements on the top of the roof by placing one end in the top channel and pushing it down along the length of the profile.



- 3 Place RB1, RB4, and RB6 glazing elements along the arches where shown. Place one end of the RB elements in the channels of the profiles and slide them down the length of the profile.

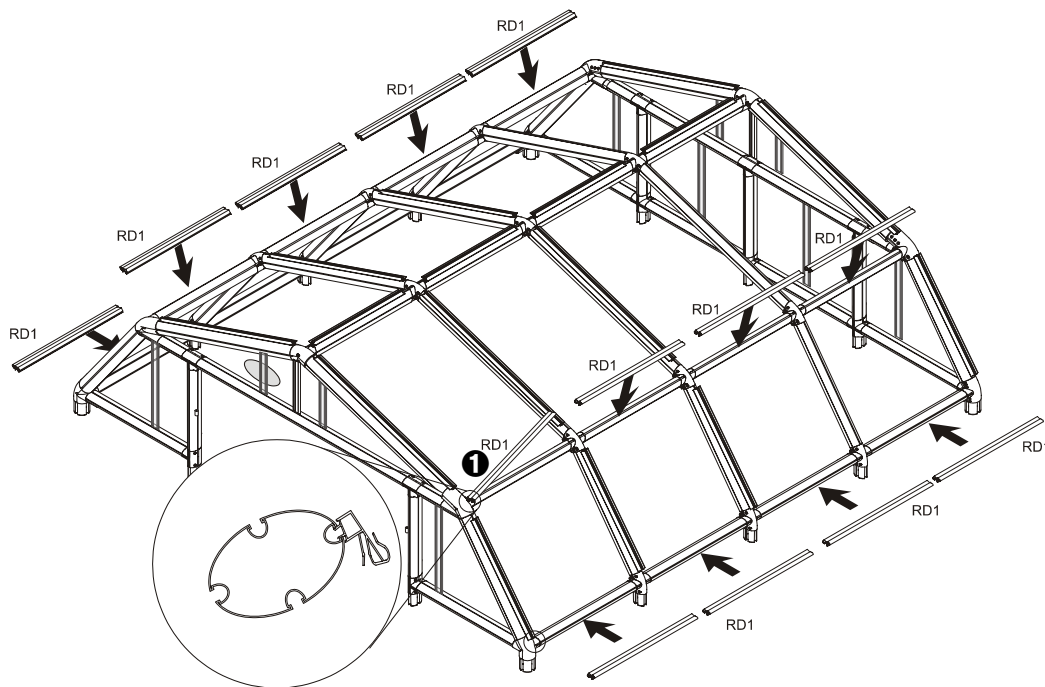


Note: If you have difficulty inserting the top of the RB1 glazing element slightly loosen the AS70 screw holding in the CAB40 cable.

- 4 Tighten the AS70 screws holding the CAB40 cables with the AW5 Allen wrench.

- Place RD1 elements where shown by placing one end in the channel and pushing it down along the length of the profile.

Note: You may find it easier to insert RD elements into profiles by pushing them in from the top while rolling the element downwards.



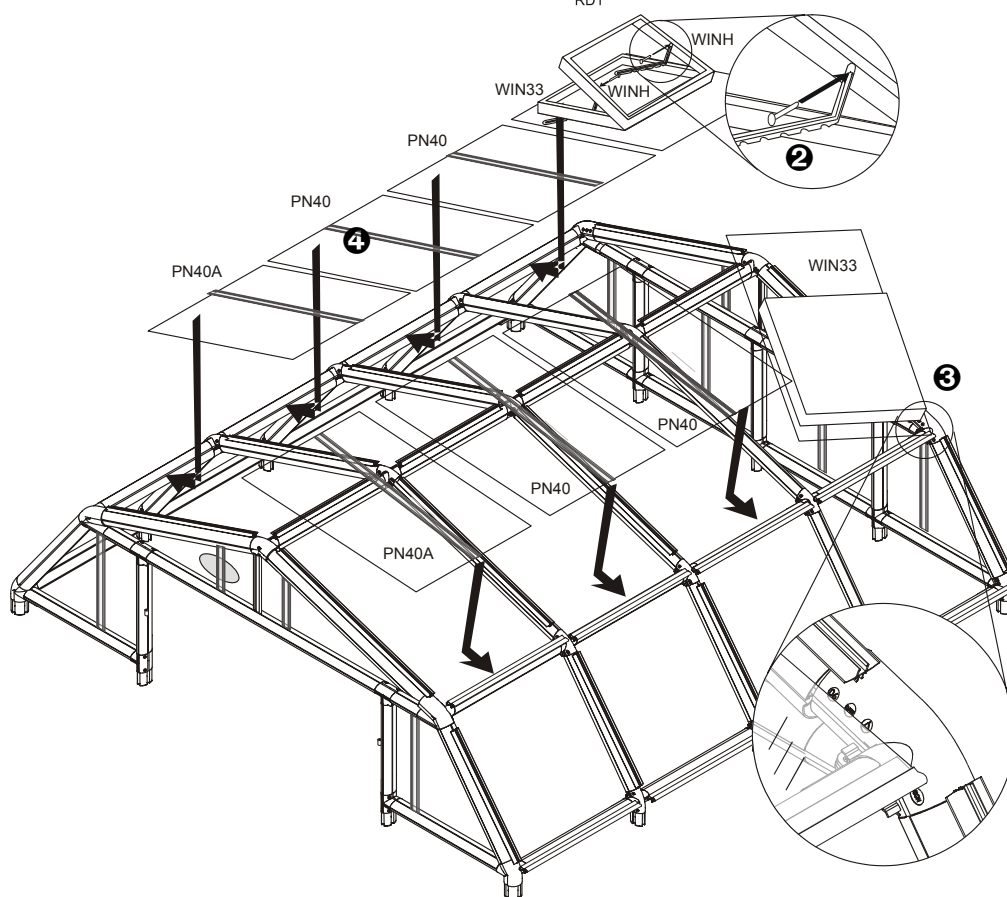
- Assemble the two WINH handles to each WIN33 Roof Vent using the included pins.

- Place the PN40 panels, PN40A side panels, and the roof vents in place by sliding one corner into the RD1 glazing element. Continue until they are fully inserted.

- Remove the ID strips from the panels.

Note: Additional Roof Vents are available as an option.

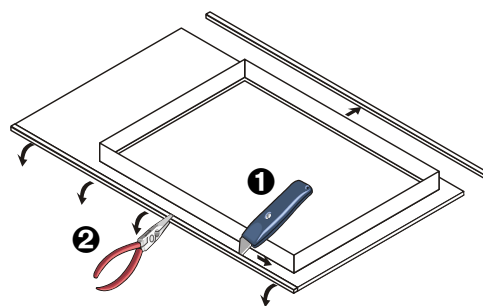
Caution: Close windows in high winds. Automatic window openers are available as an option.



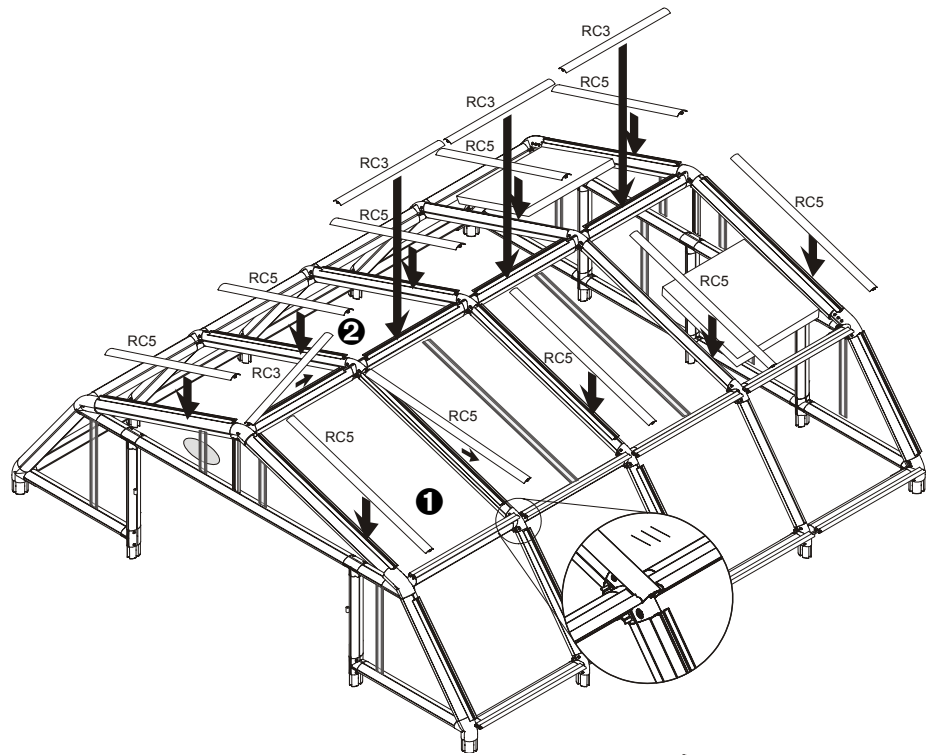
It is recommended to place windows at the front or the back of your greenhouse. Additional WIN33 Windows can be installed by substituting them for PN40 panels as follows:

- After assembling a WIN33 window handles trim 6 mm (1/4") from each side with a razor knife or hacksaw.
- Remove the cut portion.

Continue with step 3 above.

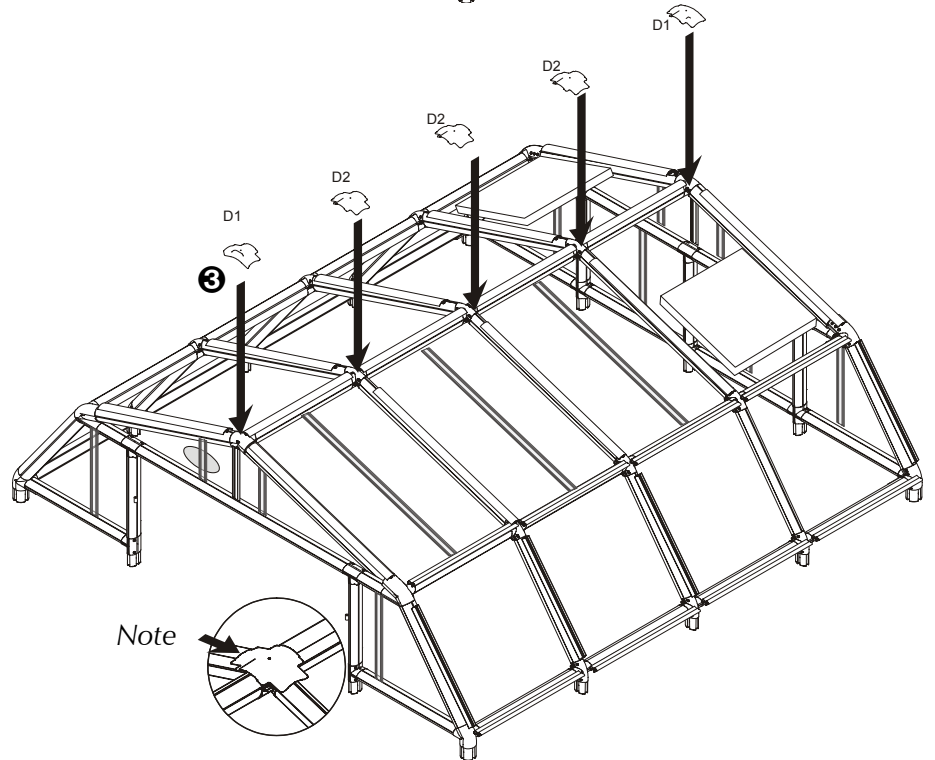


- ❶ Lock the sides of the Roof Vents and the PN40 using RC5 glazing elements. Make sure that the end of the RC glazing elements are in line with the bottom of the RD elements.
- ❷ Finish locking the panels into place by placing RC3 glazing elements across the top of the roof.



- ❸ Snap the roof caps in place on the top rib intersections.

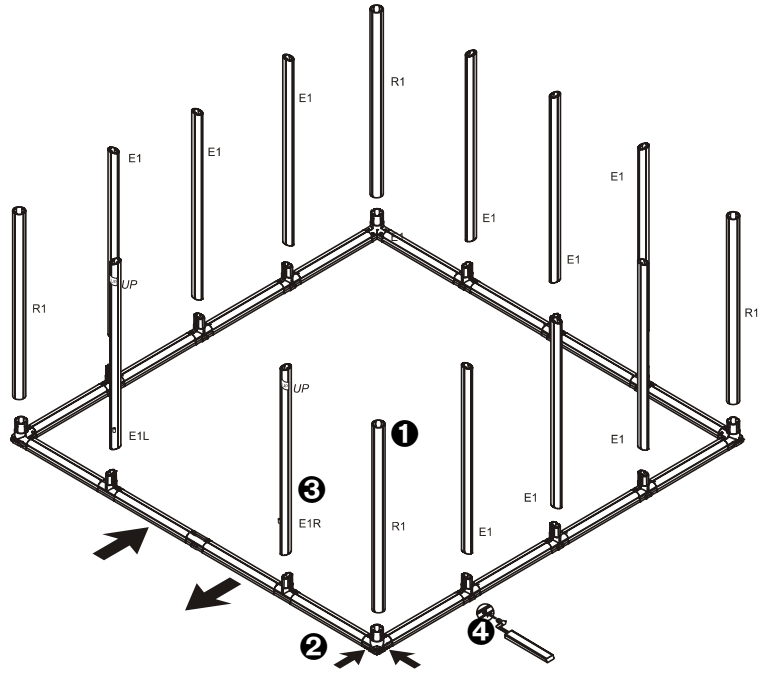
Note: If you need to remove the roof caps push them on one side and then lift.



Raise the Roof

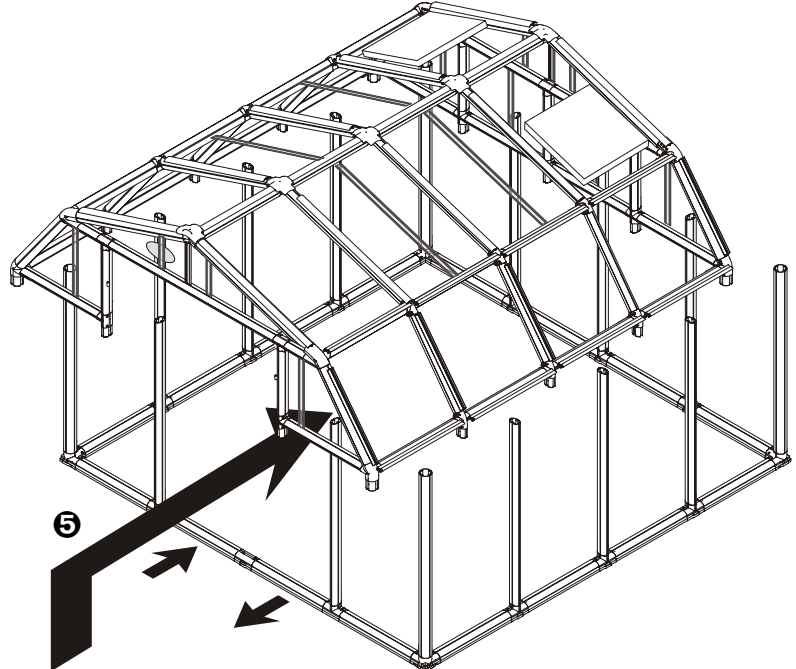
- 1 Put the R1 round profiles in place.
- 2 Insert two pins in each R1 profile to lock them in place. Do not insert pins in the inner (panel) channels. Add the E1 oval profiles until the frame is completed.
- 3 Attach the E1R and E1L profiles to the doorway of the frame. Each of these profiles has a sticker indicating the up direction.
- 4 Put the rest of the E1 profiles in place and lock them secure with pins.

Note: If there is no wind you may install the PN1 panels before putting the roof in place (page 17).



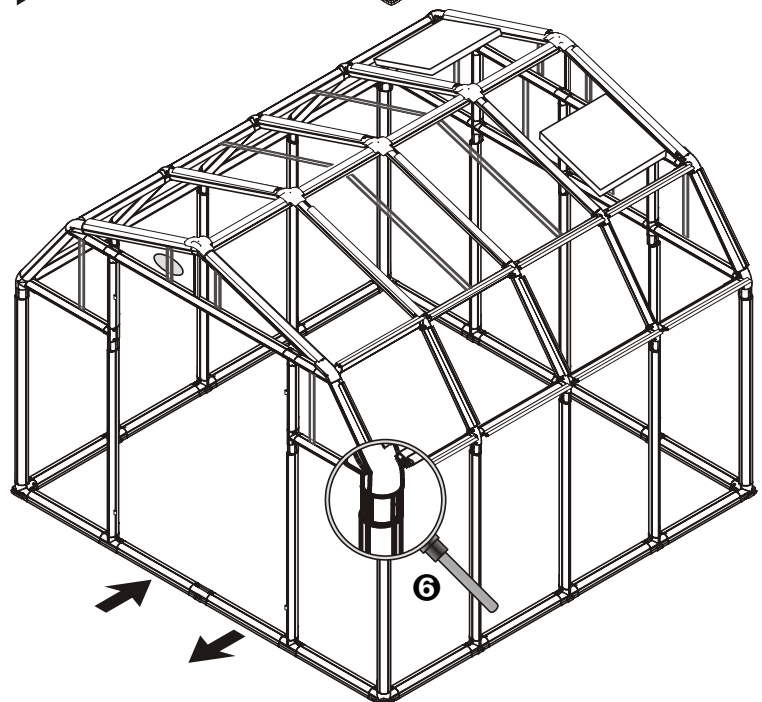
- 5 Make sure that the roof is in the same orientation as the base and door. Lift the roof from both edges and walk through the door towards the back wall.

Note: You will need the help of another person for a short while to lift the roof and put it in place.



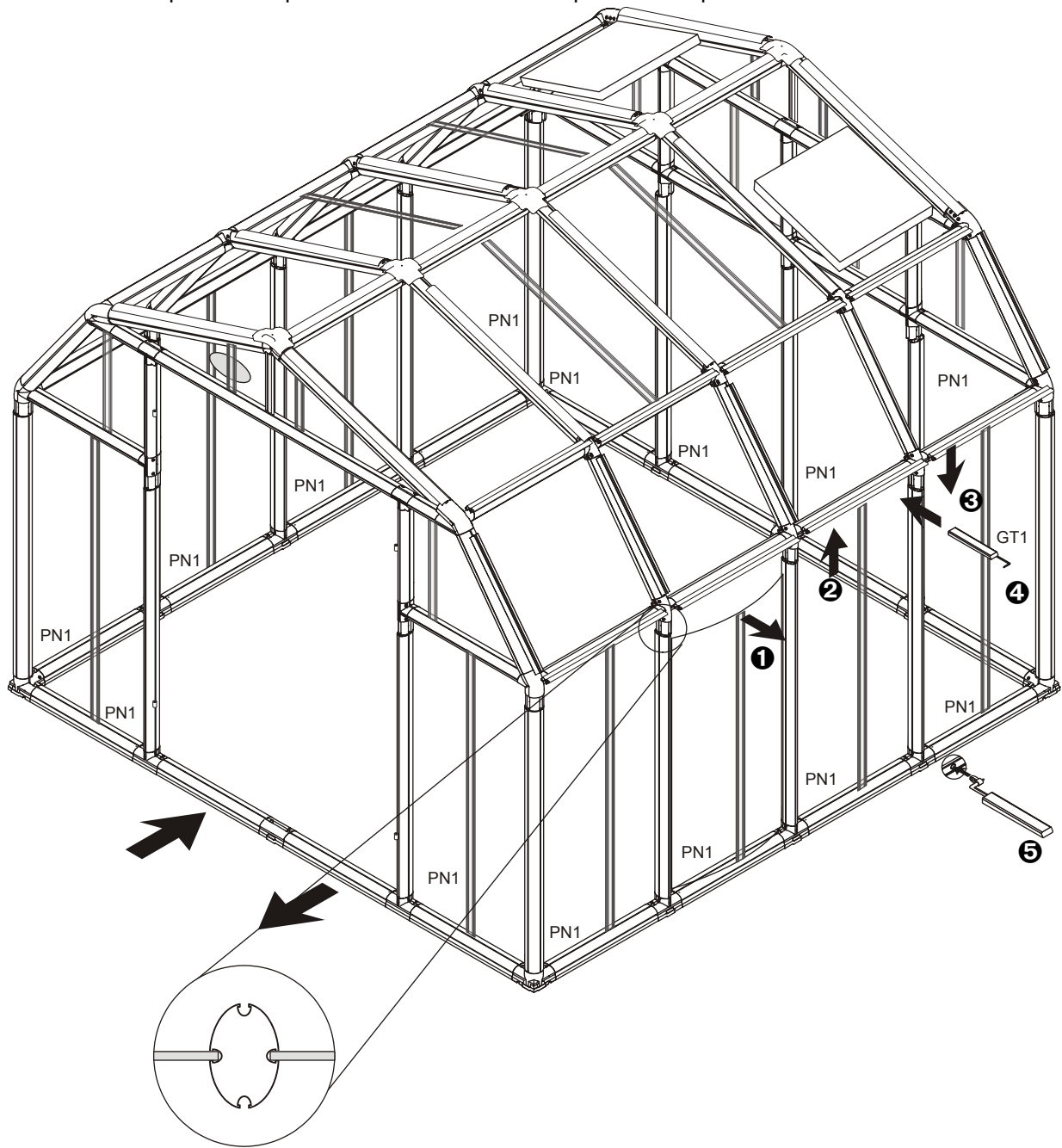
- 6 Place the roof on the columns and circle around the greenhouse and insert the first 1 cm (1/2") of the roof connectors into the columns.

Note: Do not insert the connectors all of the way into the columns at this time in order to provide enough space to install the panels in the next step.

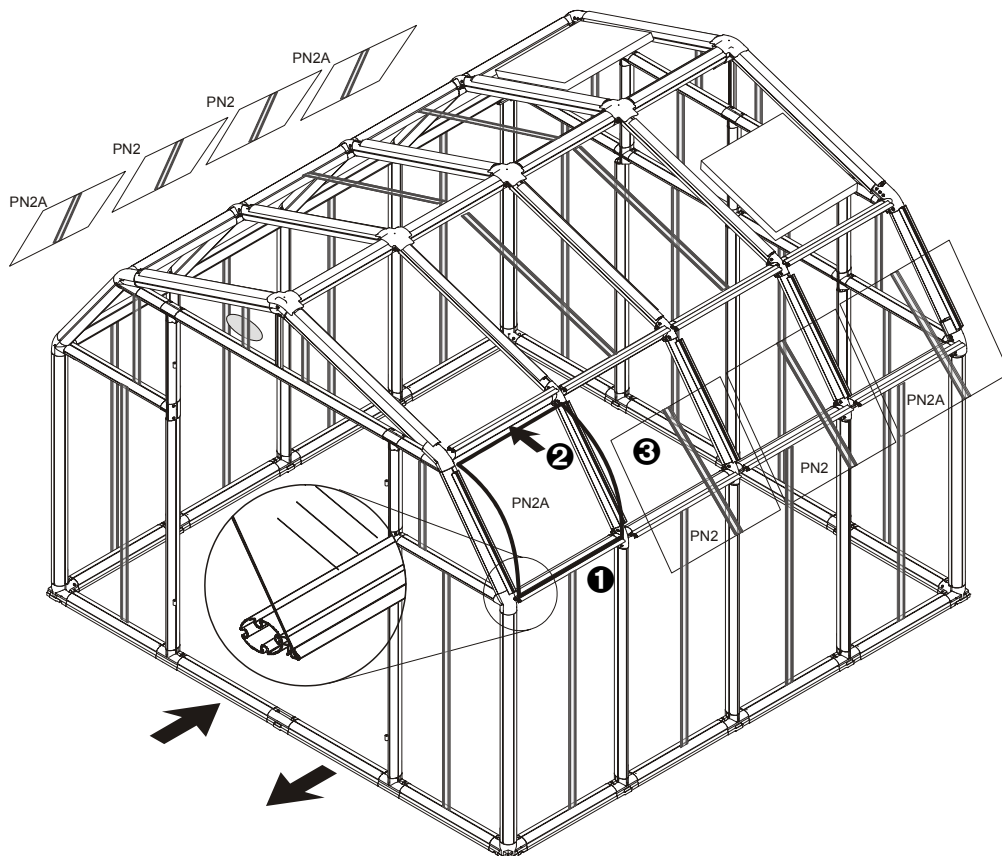


Cover the Walls

- ❶ Take a PN1 panel with the plastic ID strip facing out, and put the panel in place by gently curving it so that it enters the side channels of the columns.
- ❷ Slide the top of the panel into the channel in the bottom of the roof.
- ❸ Lower the panel towards the frame. Continue with this procedure until all of the PN1 panels are finished.
- ❹ Panel by panel, circle around the greenhouse and lower the roof into place. Use the GT1 glazing tool to guide the corners of the PN1 panel into the channels.
- ❺ Lock the roof in place with pins and remove the ID strips from the panels.

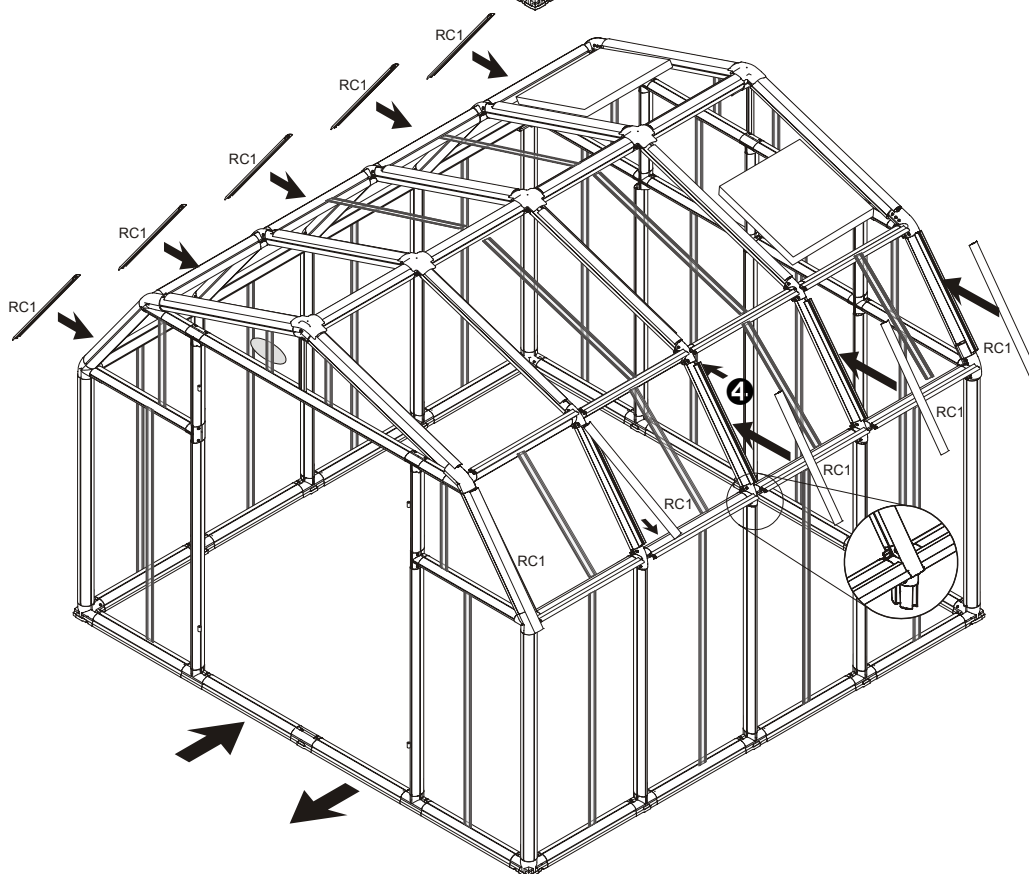


- ❶ Making sure that the plastic ID strip faces out, slide a PN2A panel in the lower RD1 element.
- ❷ Bend the panel until it enters the upper RD1 element.
- ❸ Continue with the rest of the PN2 and PN2A panels.



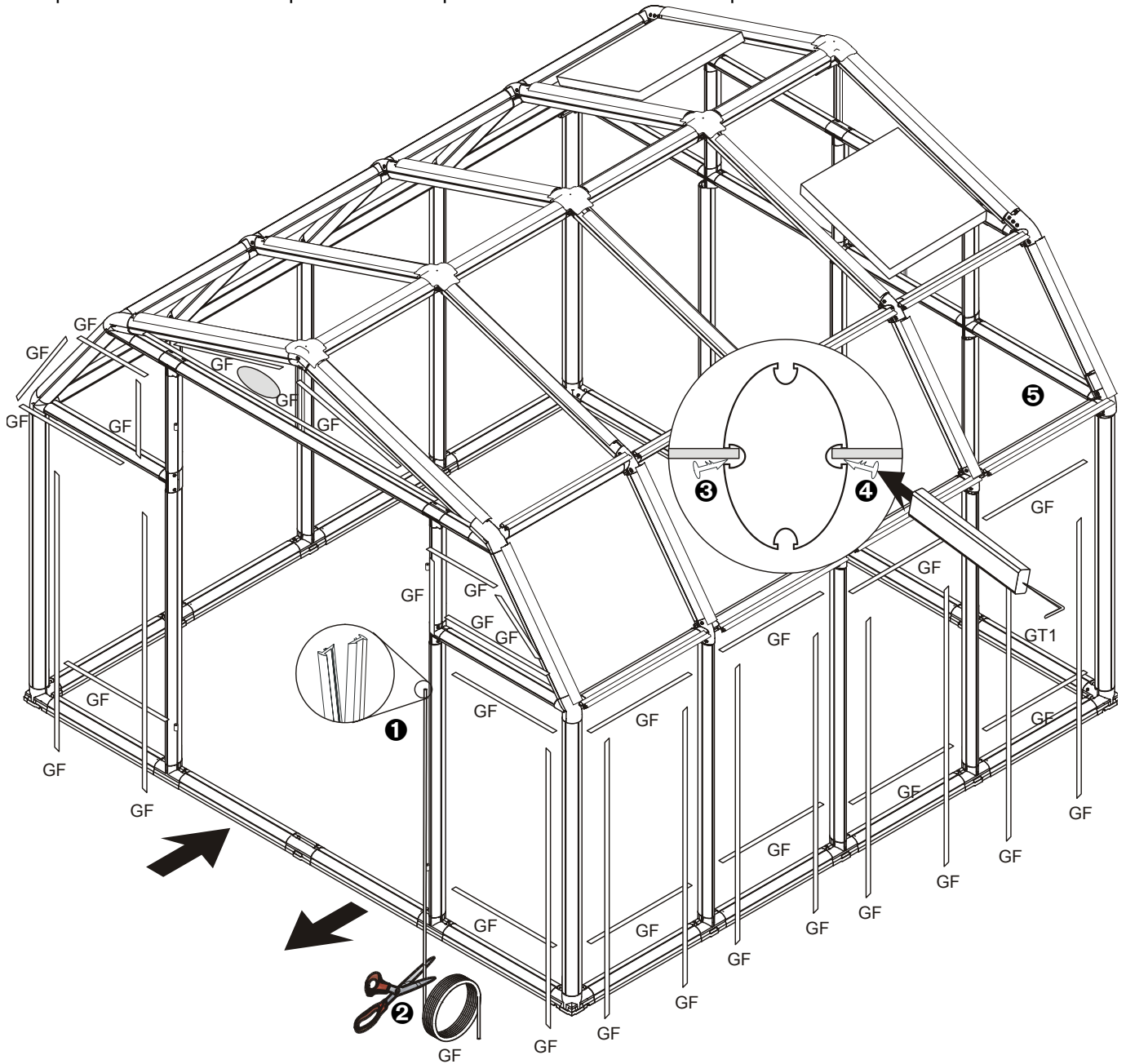
- ❹ Lock the lower panels into place using RC1 glazing elements. Make sure that the end of the RC glazing elements are in line with the bottom of the RD elements.

Note: You may now remove the plastic ID strips from the panels.



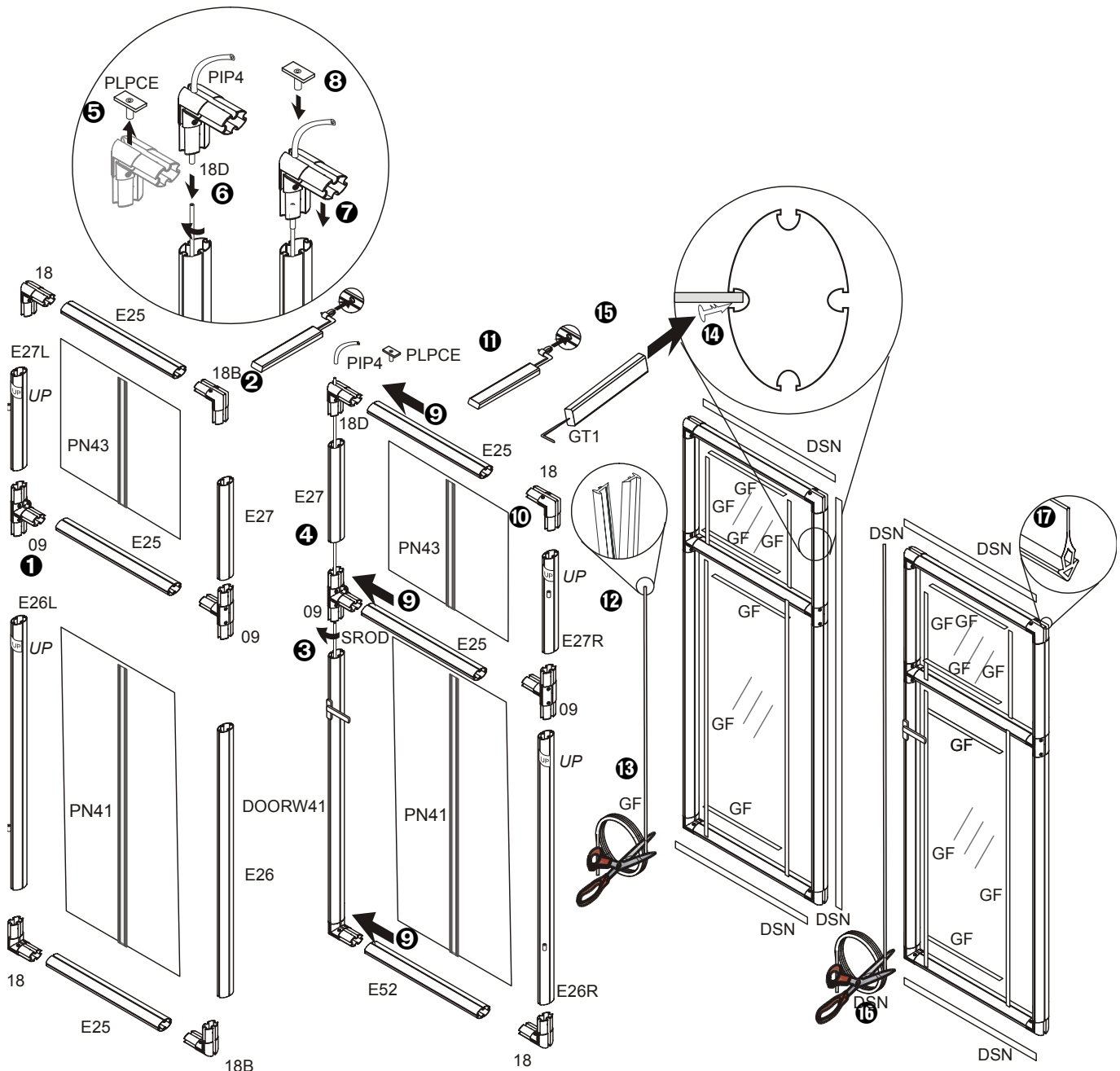
Seal Panels

- 1 Take the roll of GF sealer, divide it as shown, and pull out enough for one side of a PN1 panel.
- 2 Cut it to length.
- 3 Align it with the channel of the column profile with the double ridge facing the panel.
- 4 Push it in to seal the panel using the GT1 glazing tool if needed.
- 5 Repeat for the other PN1 panels and the panels in the front and back pediments.



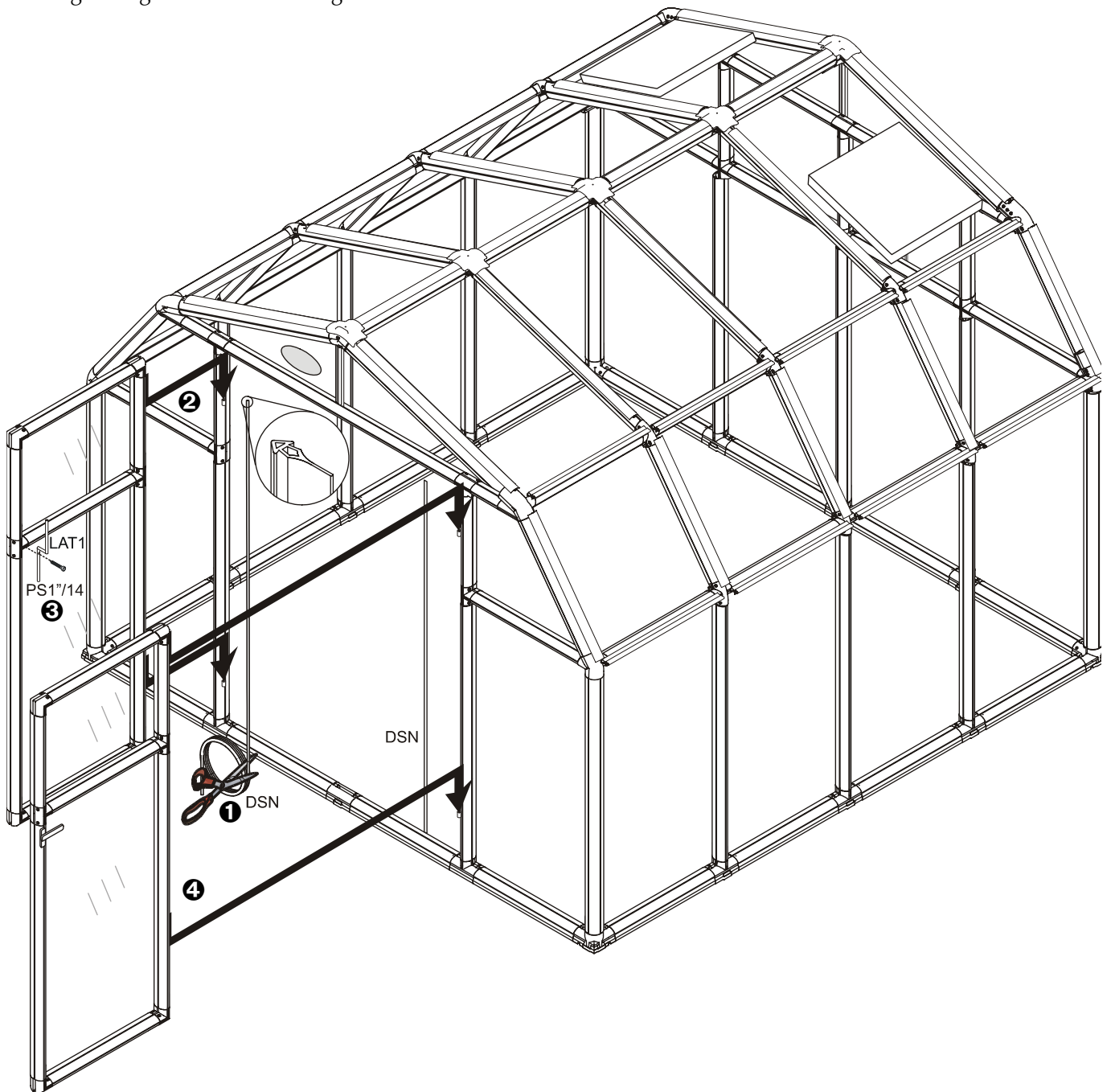
Assemble the Doors

- ❶ Assemble the left door. Make sure that the plastic ID strips of the panels face out and that the E27L and E26L are oriented with the "UP" sticker in the correct direction.
- ❷ Lock the connectors in place with pins.
- ❸ Screw the SROD door locking rod into the DOORW41 Door Handle Profile.
- ❹ Slide the 09 T-Oval Connector and the E27 profile over the SROD door locking rod.
- ❺ Remove the PLPCE T-Hinge Insert from the 18D connector and set aside.
- ❻ Thread the PIP4 Threading Tube through the hole in the 18D Corner Connector and push it over the end of the SROD door locking rod.
- ❼ Carefully set the 18D connector on the E27 profile so the SROD door locking rod goes through the hole.
- ❽ Discard the PIP4 Threading Tube, and reattach the PLPCE T-Hinge Insert to the 18D connector.
- ❾ Attach the E2 profiles to the assembled door handle unit, making an "E" shape.
- ❿ Slide the two panels into place. Make sure that the plastic ID strips of the panels face out. Assemble the rest of the parts of the door, making sure that the E27R and E26R are oriented with the "UP" sticker in the correct direction.
- ⓫ Lock the connectors in place with pins. You may now remove the plastic ID strips.
- ⓬ Take the roll of GF sealer and divide it as shown.
- ⓭ Measure GF sealer for the edges of all four panels and cut it to length.
- ⓮ Align the GF sealer with the channels of the column profiles with the double ridge facing the panels.
- ⓯ Push them in to seal the panel using the GT1 glazing tool if needed.
- ⓰ Measure DSN Door Sealer for the top and bottom of each door and for the two sides without hinges.
- ⓱ Place the DSN Door Sealer in the channels of the outside of both doors.



Hang the Doors

- 1 Cut two pieces of DSN Door Sealer and place in the channels of the hinged lintels.
- 2 Hang the left door on the hinges.
- 3 On the inside part of the door screw the LAT1 Inner Door Latch into the profile using the PS1"/14 Inner Door Latch Screw.
- 4 Hang the right door on the hinges.



Final Touches

Go inside your new Greenhouse and seal any gaps between the PN2 and PN2A panels and the profiles using SF soft foam insulation. Cut pieces of SF soft foam insulation 2.5 cm (1") long, remove the adhesive backing, and place where shown, making sure that the area is clean and dry.

Congratulations! Your Greenhouse is now completed. You will find it easy to clean and maintain.

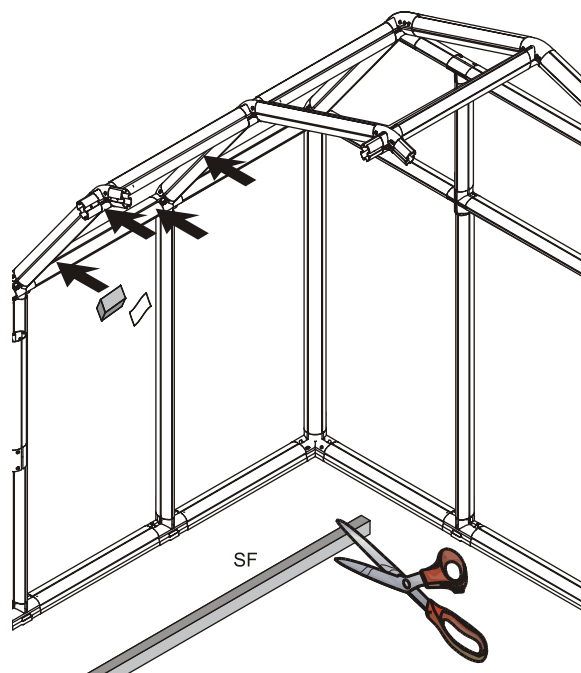
Put this manual in a safe place so you can refer to it if you decide to add options or need to make a repair.

For your safety and convenience, please take note of the following:

- Examine your Greenhouse for sharp edges and trim with a razor knife if necessary.
- It is important to clear your Greenhouse of snow in the winter.
- Make sure that the temperature in the greenhouse never exceeds 70° C (155° F). Ensure good ventilation during hot days or provide a shading screen (available as an option). This is especially important if you live in a hot climate.
- Always close roof vents in high winds.

Rion offers a wide range of options for your new Greenhouse, including modular shelves, irrigation systems, additional windows, automatic window openers, and others.

Thank you for your purchase. We wish you many years of pleasure with your greenhouse. Please feel free to contact us with any questions, comments, or suggestions.



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MLGH40STCE 8 July 2003