



**ESS47 ALUMINIUM SLIDER
SYSTEM AND HARDWARE
TECHNICAL MANUAL**

Luxury Aluminium By

ALUNET
SYSTEMS



Luxury Aluminium By

ALUNET
SYSTEMS

Making It Easy!

You asked, we listened. Making fabrication and installation easy!

Continually investing to add value to our customers whilst offering the best all-round performance aluminium products to the UK market, Alunet Systems' entire Aluna range provides premium security, luxurious durability, and robust functionality as standard.

Making it easy is a key attribute of the Aluna product family, as is never standing still with regards product design and differentiating product features. Made from marine grade aluminium our Aluna range is specifically designed and manufactured with enhanced corrosion resistance enabling a finished product that not only looks good immediately after installation, but it also continues to perform and retain that luxurious finish for years to come.

With Aluna, the premium aluminium range from Alunet Systems, you can fabricate and install an entire house project - Making It Really Easy!

There are several reasons that Aluna is fast becoming the go-to brand of choice in the UK for luxury aluminium, but here is an overview:

/// Everything we design and do has our customers at the heart, front, and centre.

/// Pas24 certified luxury aluminium across all of our Aluna range.

/// Unrivalled strength and durability. Aluna is strong, durable, lightweight and corrosion resistant to withstand any weather.

/// Excellent thermal efficiency.

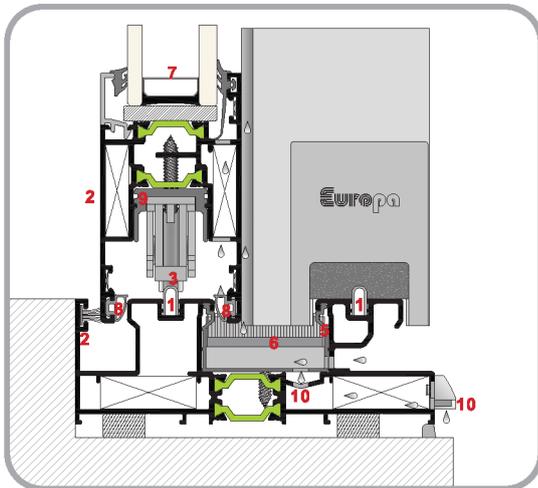
/// Secure and highly attractive.

/// We have a vast UK stock holding of our standard colours.

/// Available in all RAL colours on request.

/// Super Slim Sash and Clip In Bead available.

System's Technical Characteristics .



Basic Characteristics

- Stainless steel lamina on rail profiles for smooth sliding.
- Straight line design.
- Optional Lift & Slide mechanism.
- Optional multilocking mechanism.
- Plastic rail cover (PVC) for thermal insulation and protection from water.
- Elastic rail block seals (EPDM) for successive and in-wall systems.
- 30mm (maximum) double or triple glass for better thermal and sound insulation.
- Rubber tubular gaskets (EPDM) providing absolute seal to the sashes.
- Specially designed PVC profile addition in glass sash profiles for excellent adaptation of components and insulation improving.
- Two levels of channelling water (to the outer side of the frame), providing better drainage for the rails.
- Combined with EOS 60, EOS 68 & EUROPA 8500 Thermo for composite structure

Construction Types

- Successive.
- In wall.
- Successive with external fixed window.
- Composite structures.
- Fix & Slide.

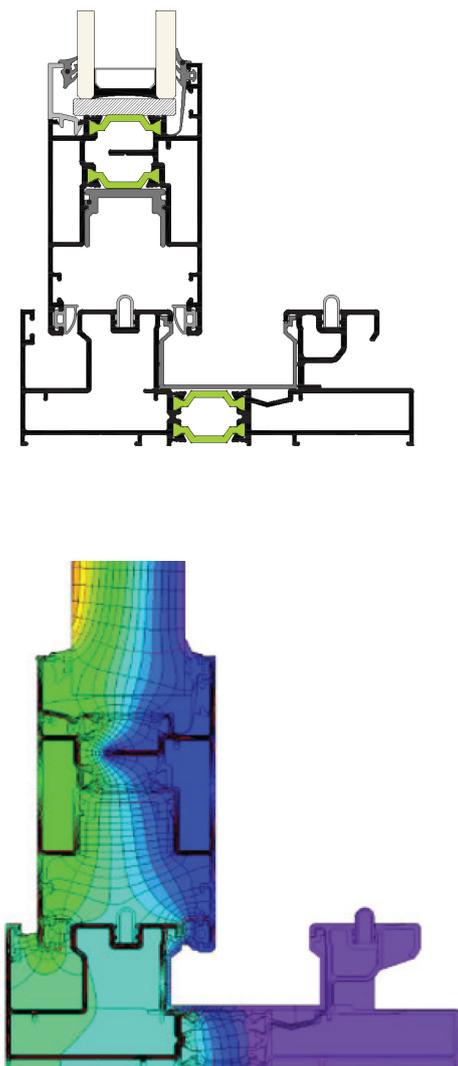
Certifications

- QUALICOAT: Powder coating process certification.
- EKANAL: Certified factor for air permeability, water tightness and resistance to wind load.
- IFT Rosenheim: Certified factor for air permeability, water tightness and resistance to wind load.
- DTI: Thermal coefficient.

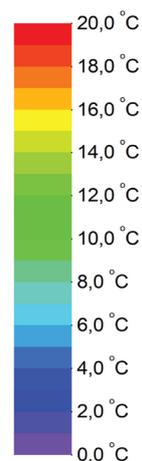
Technical Characteristics

- Aluminium Alloy EN AW 6060 T6
- Hardness 12 Webster
- Minimum coating thickness 75Qm
- Profile thickness 1,4mm
- Tolerance according to EN 12020-02
- Width of successive rail 120mm-183mm (two-three sashes)
- Width of glass sash 47mm
- Glazing thickness 24-30mm
- Polyamide width 22-26mm
- Thermal Coefficient of frame U_f from 2,7 to 5,4 $W/(m^2 \cdot K)$
- Maximum sash dimensions 2,5m x 2,7m
- Maximum sash weight 300 Kgr

System's Thermal Conductivity Characteristics



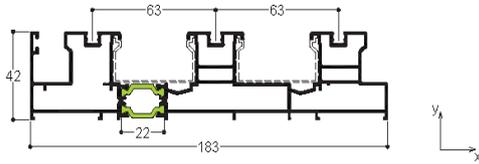
$U_f=4,18 W/(m^2K)$



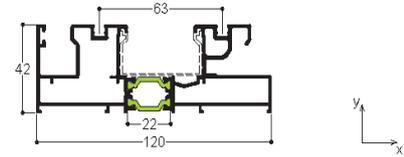
01a

General Profile Tables

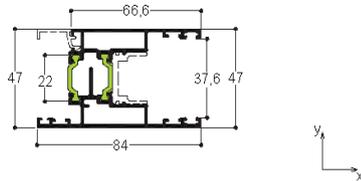
TH 8022	Length 6,0 m	Theor.Weight 3.093 gr/m
Triple Rail (Successive)		$I_{x(s)}=19,79\text{cm}^4$ $I_{y(s)}=340,12\text{cm}^4$



TH 80113	Length 6,0 m	Theor.Weight 2.157 gr/m
Double Rail (Successive)		$I_{x(s)}=13,93\text{cm}^4$ $I_{y(s)}=101,52\text{cm}^4$



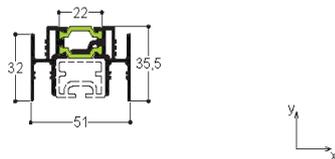
TH 8040	Length 6,0 m	Theor.Weight 1.577 gr/m
Glass Sash with Clip		$I_{x(s)}=17,49\text{cm}^4$ $I_{y(s)}=23,63\text{cm}^4$



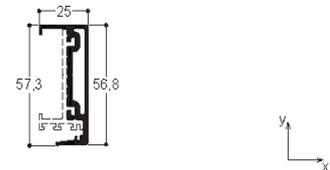
TH 80411	Length 6,0 m	Theor.Weight 1.027 gr/m
Interlock Profile 50mm with Clip		$I_{x(s)}=2,84\text{cm}^4$ $I_{y(s)}=9,94\text{cm}^4$



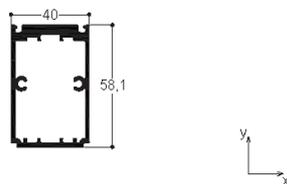
TH 8045	Length 6,0 m	Theor.Weight 1.177 gr/m
Adjoining Profile for Glass Sash		$I_{x(s)}=2,85\text{cm}^4$ $I_{y(s)}=11,47\text{cm}^4$



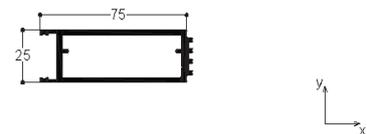
TV 80402	Length 6,0 m	Theor.Weight 845 gr/m
Interlock Profile 25mm		$I_{x(s)}=11,26\text{cm}^4$ $I_{y(s)}=0,94\text{cm}^4$



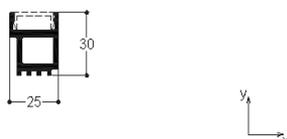
TV 00628	Length 6,0 m	Theor.Weight 1.489 gr/m
Reinforcement Profile		$I_{x(s)}=24,32\text{cm}^4$ $I_{y(s)}=12,23\text{cm}^4$



TV 12603	Length 6,0 m	Theor.Weight 1.368 gr/m
Reinforcement Profile		$I_{x(s)}=5,00\text{cm}^4$ $I_{y(s)}=32,50\text{cm}^4$



TV 00627	Length 6,0 m	Theor.Weight 721 gr/m
Reinforcement Grip		$I_{x(s)}=1,88\text{cm}^4$ $I_{y(s)}=1,73\text{cm}^4$

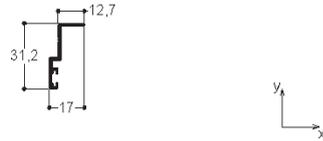


TV 80503	Length 6,0 m	Theor.Weight 133 gr/m
Clip for Glass Sash		



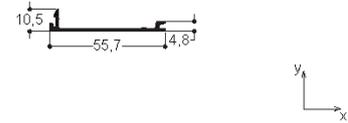
TV 80504	Length 6,0 m	Theor.Weight 208 gr/m
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Additional Profile for TH 80110	$I_x=0,83\text{cm}^4$	$I_y=0,13\text{cm}^4$
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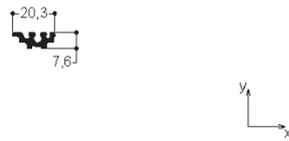
TV 80505	Length 6,0 m	Theor.Weight 279 gr/m
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Clip for Interlock Profile 50mm	$I_x=0,04\text{cm}^4$	$I_y=3,53\text{cm}^4$
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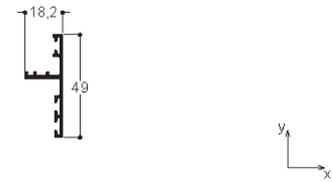
TV 80603	Length 6,0 m	Theor.Weight 203 gr/m
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Connector for Sash - Interlock 25mm	$I_x=0,03\text{cm}^4$	$I_y=0,21\text{cm}^4$
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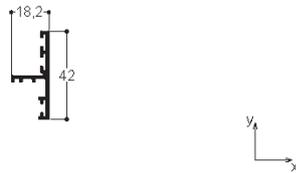
TV 80605	Length 6,0 m	Theor.Weight 362 gr/m
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Rain Cover for 34mm Rails	$I_x=2,44\text{cm}^4$	$I_y=0,29\text{cm}^4$
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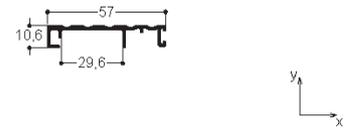
TV 8003	Length 6,0 m	Theor.Weight 340gr/m
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Rain Cover	$I_x=1,54\text{cm}^4$	$I_y=0,28\text{cm}^4$
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TV 47501	Length 6,0 m	Theor.Weight 408 gr/m
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Clip For Fixed Glass Sash	$I_x=0,13\text{cm}^4$	$I_y=5,33\text{cm}^4$
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TV 12503	Length 6,0 m	Theor.Weight 119 gr/m
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Cover for Reinforcement Profile	$I_x=0,02\text{cm}^4$	$I_y=0,22\text{cm}^4$
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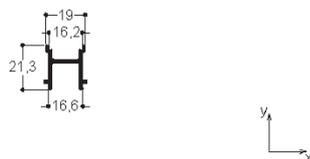
TV 27501	Length 6,0 m	Theor.Weight 162 gr/m
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Cover Cap	$I_x=0,01\text{cm}^4$	$I_{y(s)}=0,92\text{cm}^4$
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TV 8011	Length 6,0 m	Theor.Weight 279 gr/m
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Spacer for ROTO INLINE Lock		
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TV 5050	Length 6,0 m	Theor.Weight 150 gr/m
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Rod		
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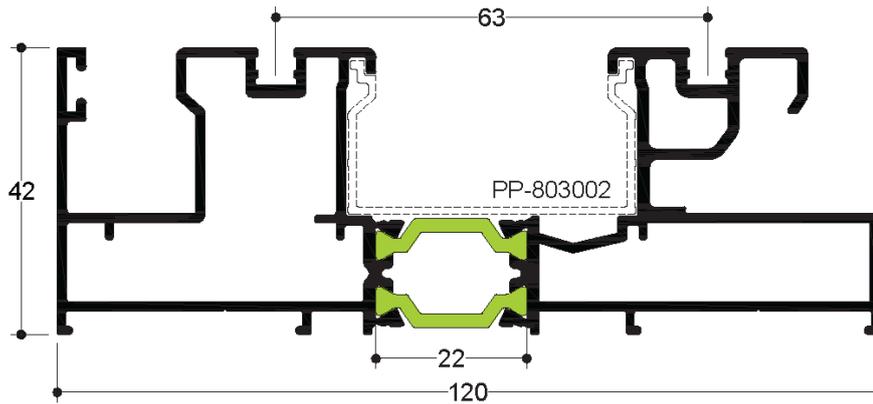


01b Profiles 1:1

TH 80113

6,0 m 2.157 gr/m

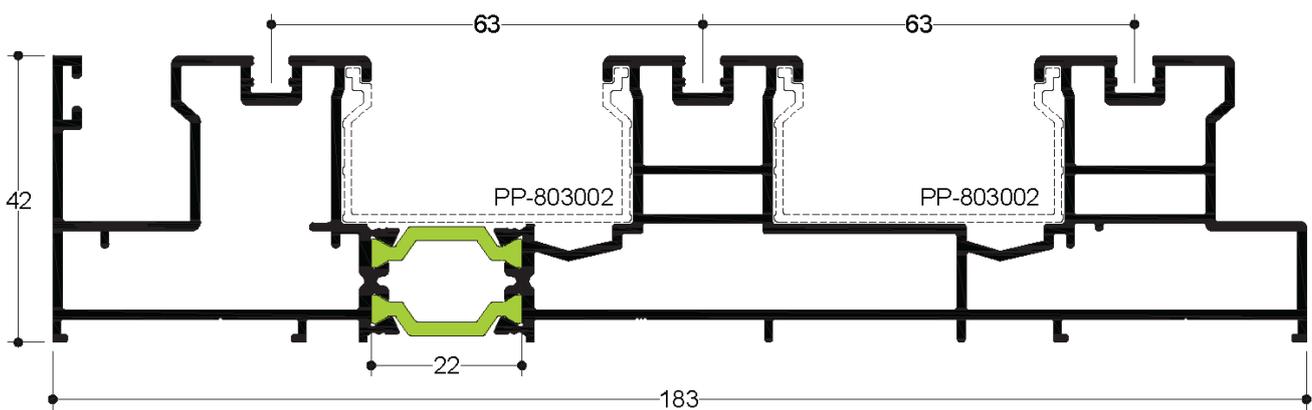
Double Rail (Successive)



TH 8022

6,0 m 3.093 gr/m

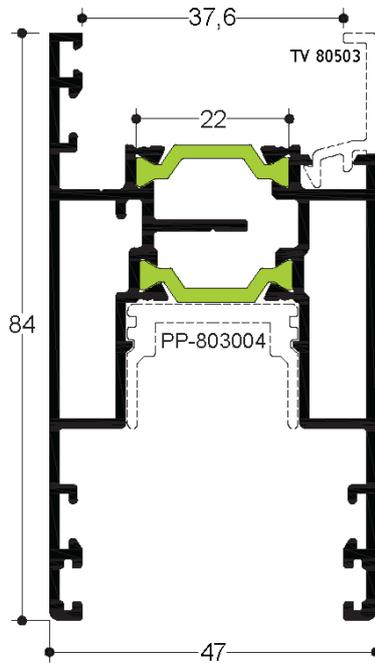
Triple Rail (Successive)



TH 8040

6,0 m | 1.577 gr/m

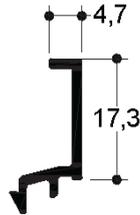
Glass Sash with Clip



TV 80503

6,0 m | 133 gr/m

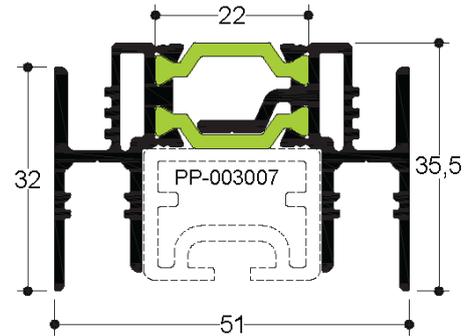
Clip For Glass Sash



TH 8045

6,0 m | 1.177 gr/m

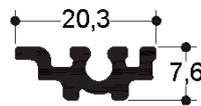
Adjoining Profile for Glass Sash



TV 80603

6,0 m | 203 gr/m

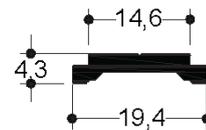
Connector for Sash - Interlock 25mm



TV 5050

6,0 m | 150 gr/m

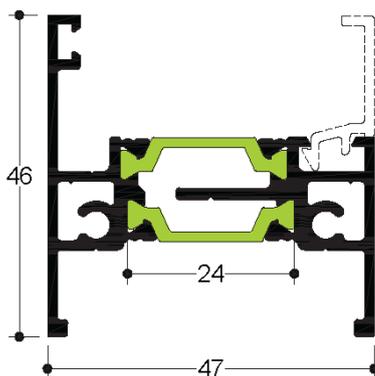
Rod



TH 80411

6,0 m | 1.027 gr/m

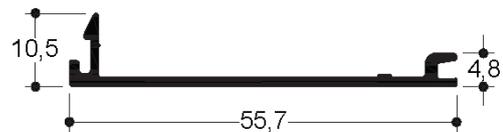
Interlock Profile 50mm with Clip



TV 80505

6,0 m | 279 gr/m

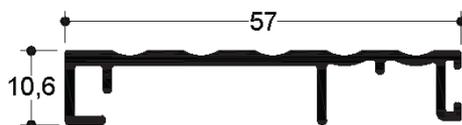
Clip for Interlock Profile 50mm



TV 47501

6,0 m | 408 gr/m

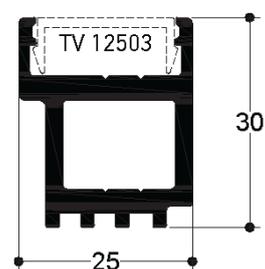
Clip For Fixed Glass Sash



TV 00627

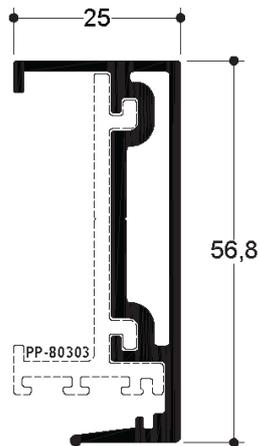
6,0 m | 721 gr/m

Reinforcement Grip



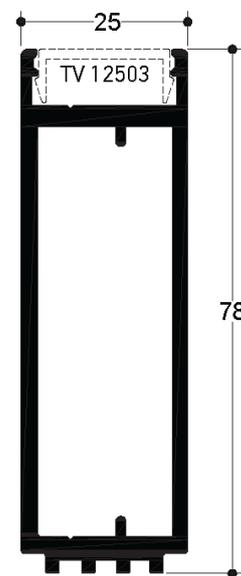
TV 80402

6,0 m | 845 gr/m
Interlock Profile 25mm



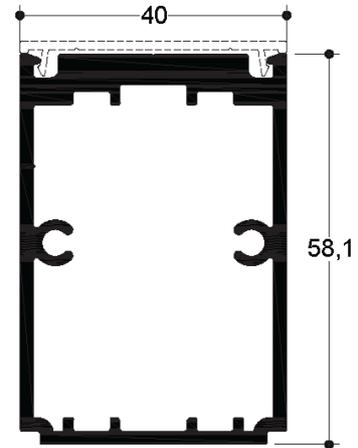
TV 12603

6,0 m | 1.368gr/m
Reinforcement Profile



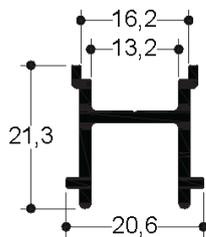
TV 00628

6,0 m | 1.489 gr/m
Reinforcement Profile



TV 8011

6,0 m | 279 gr/m
Spacer for ROTO INLINE Lock



TV 12503

6,0 m | 119 gr/m
Cover for Reinforcement Profile



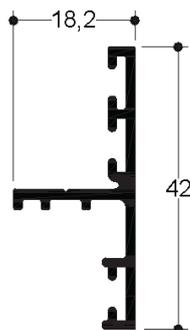
TV 27501

6,0 m | 162 gr/m
Sash Cap



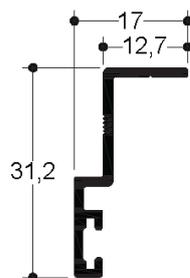
TV 8003

6,0 m | 340 gr/m
Rain Cover



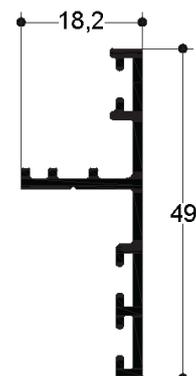
TV 80504

6,0 m | 208 gr/m
Additional Profile for TH 80110



TV 80605

6,0 m | 362 gr/m
Rain Cover for 34mm Rails

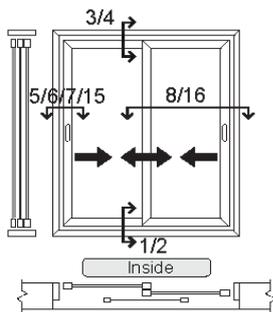


02

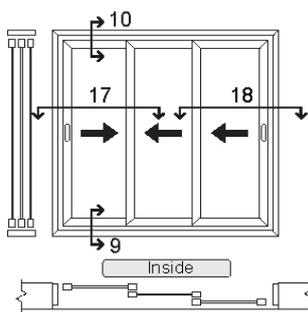
Sections

Successive Doors with Rail Height of 42mm

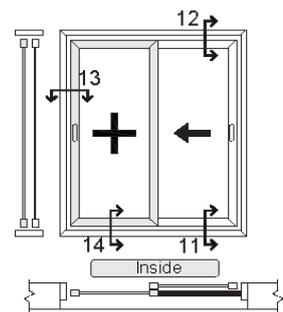
Successive Sliding or Lift & Slide



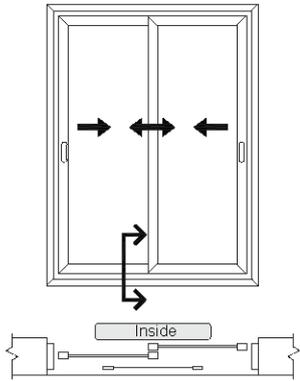
Three Sash Successive Sliding



Successive with Fixed Sash Sliding or Lift & Slide

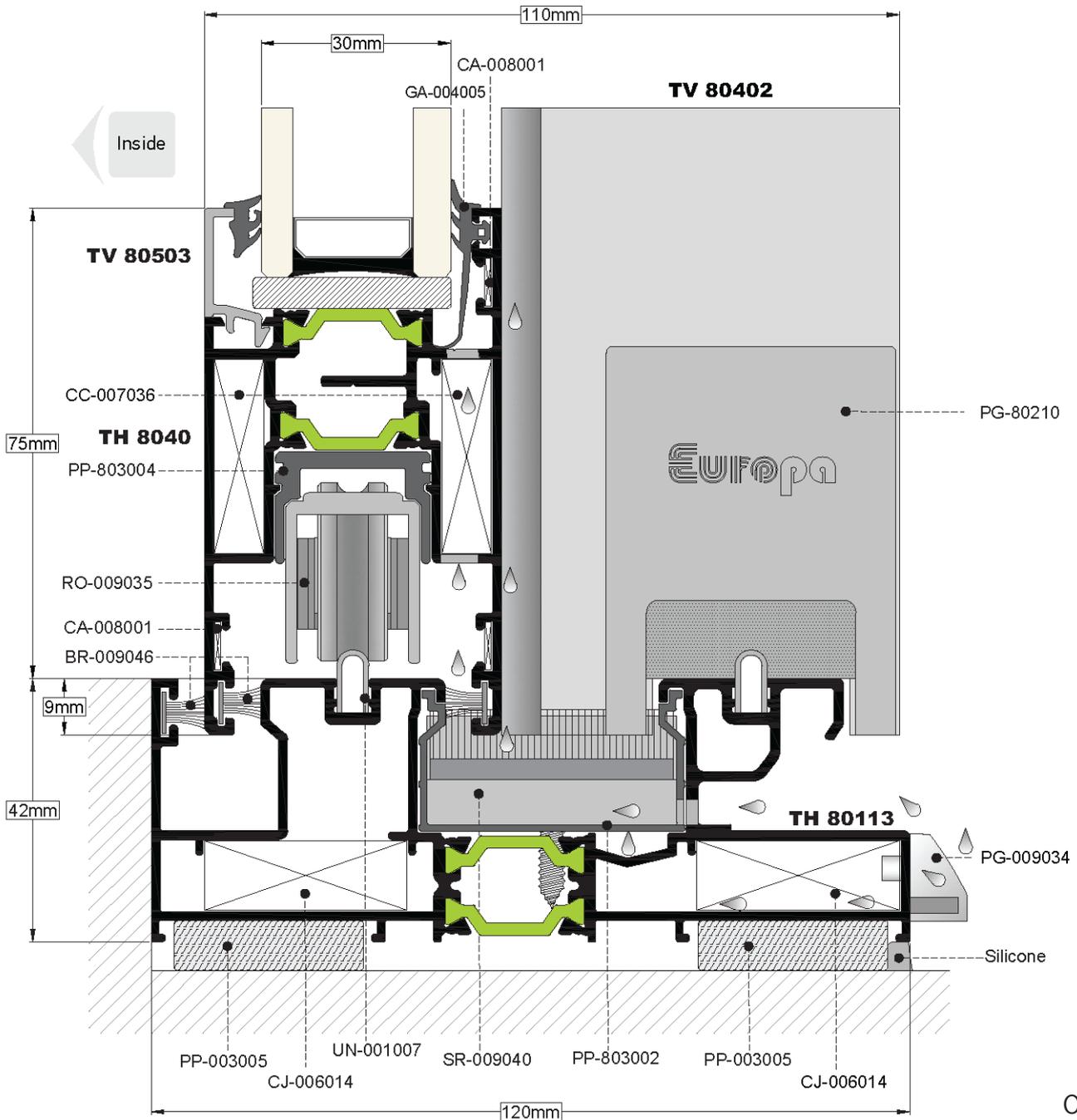


With Interlock Profile 25mm & 50mm We **can not** construct Three Sash Successive Lift & Slide

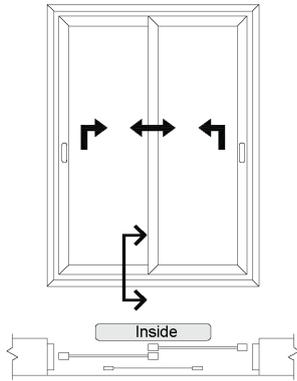


Section 1

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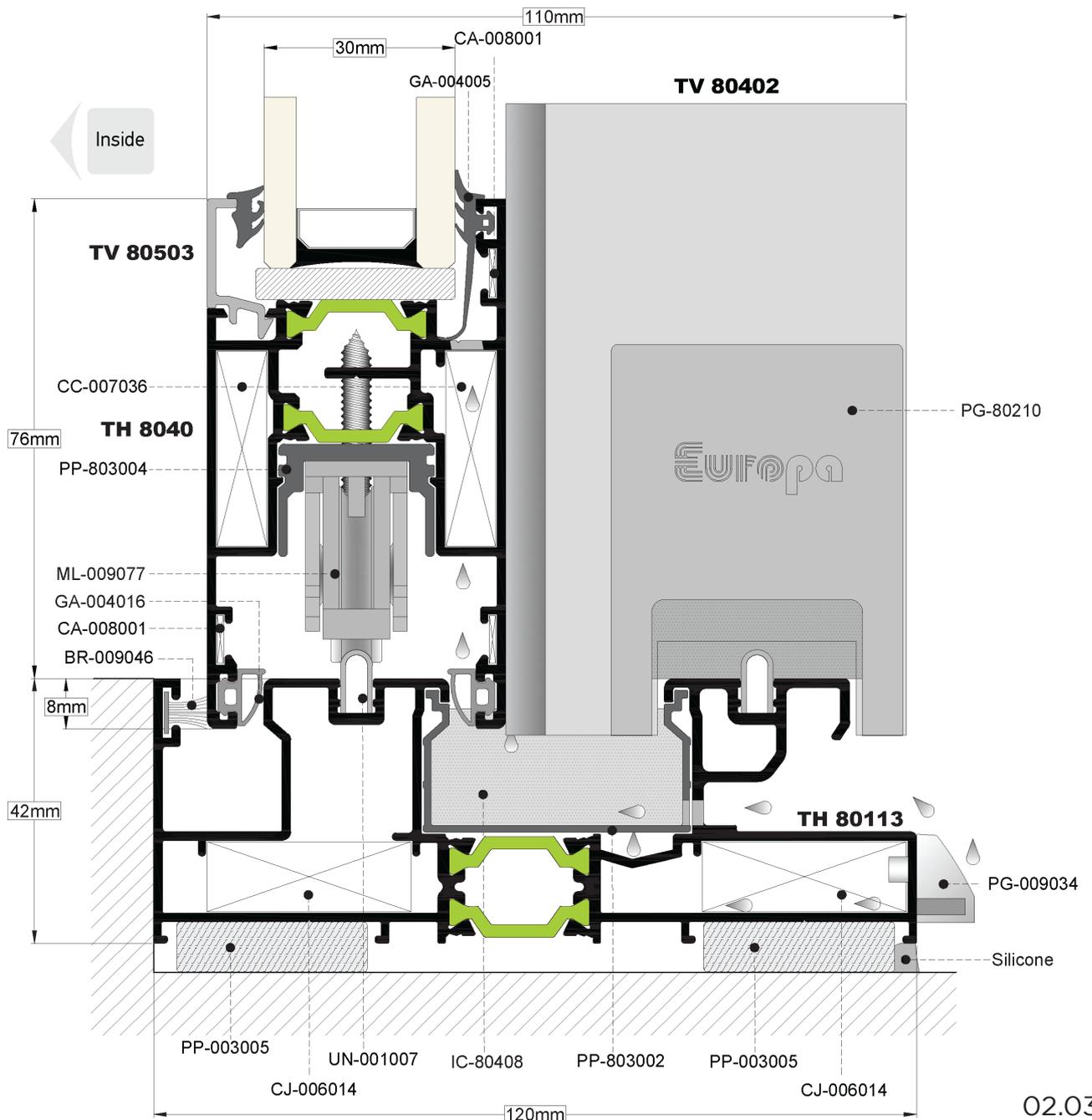


02.02



Section 2

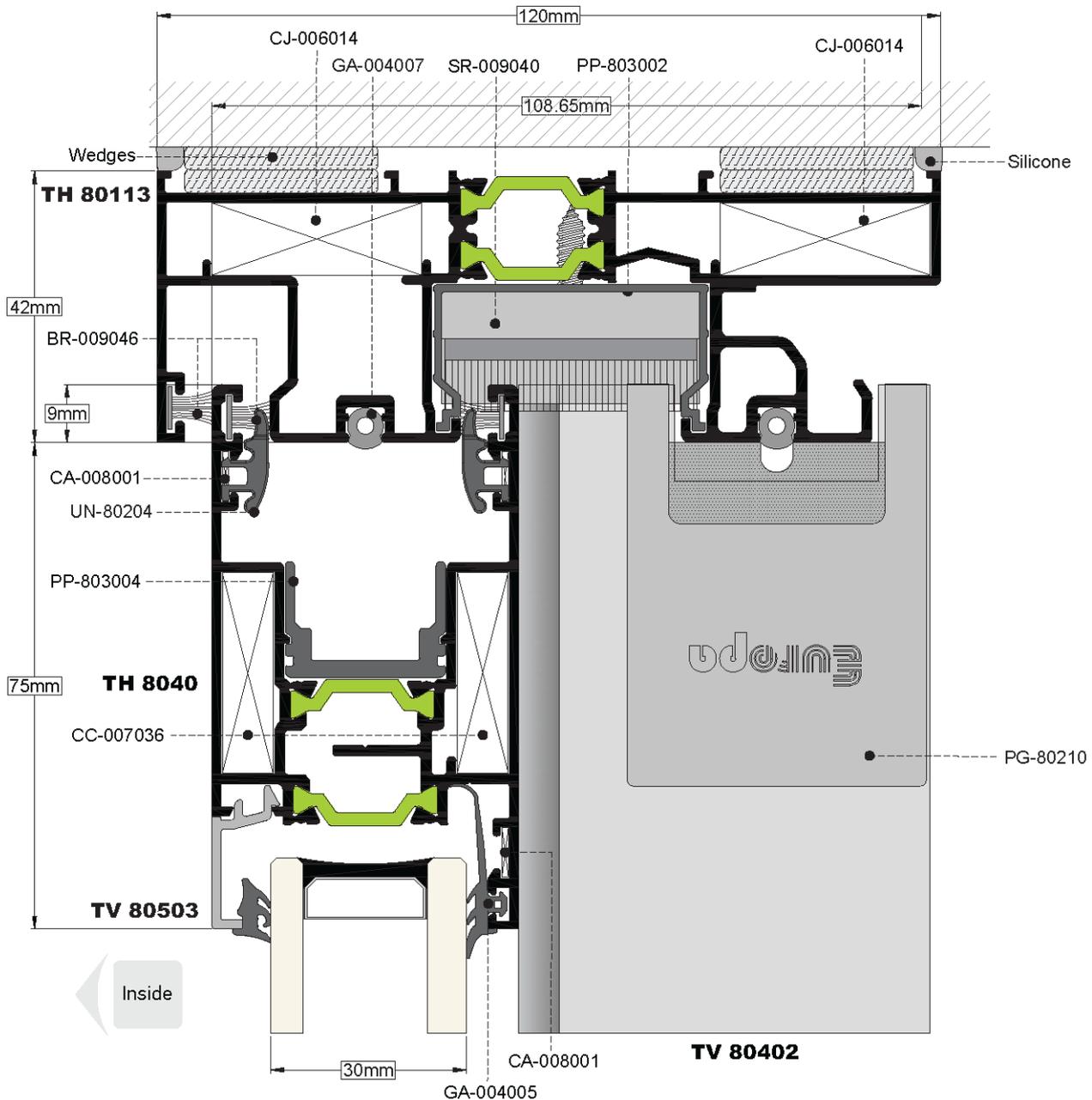
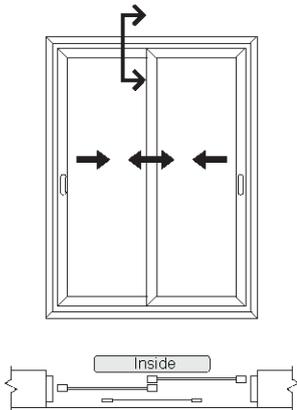
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02.03

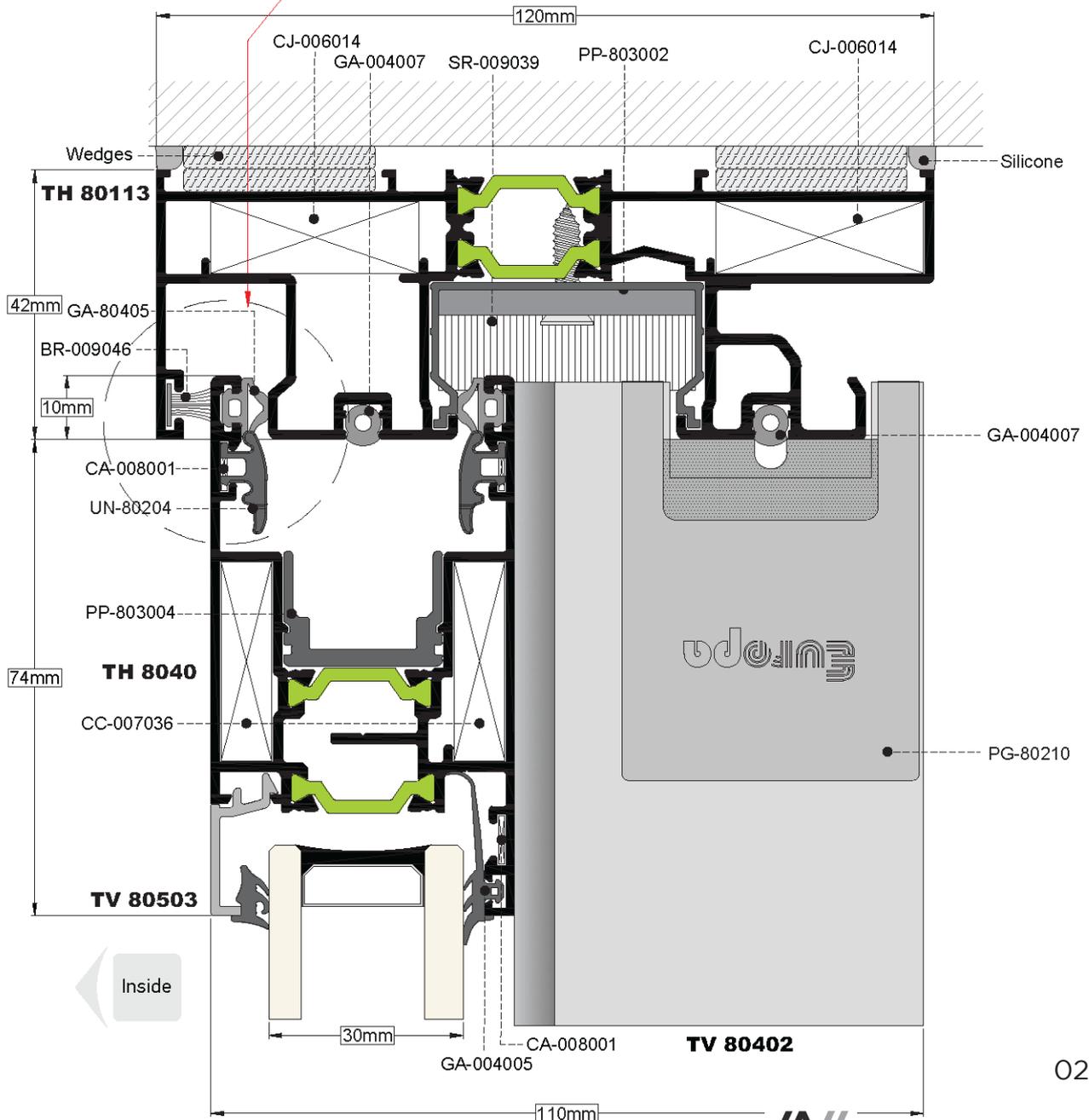
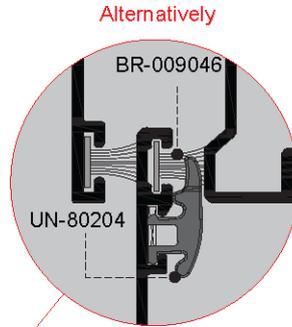
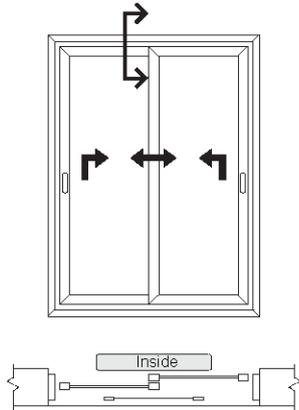
Section 3

Scale 1:1



Section 4

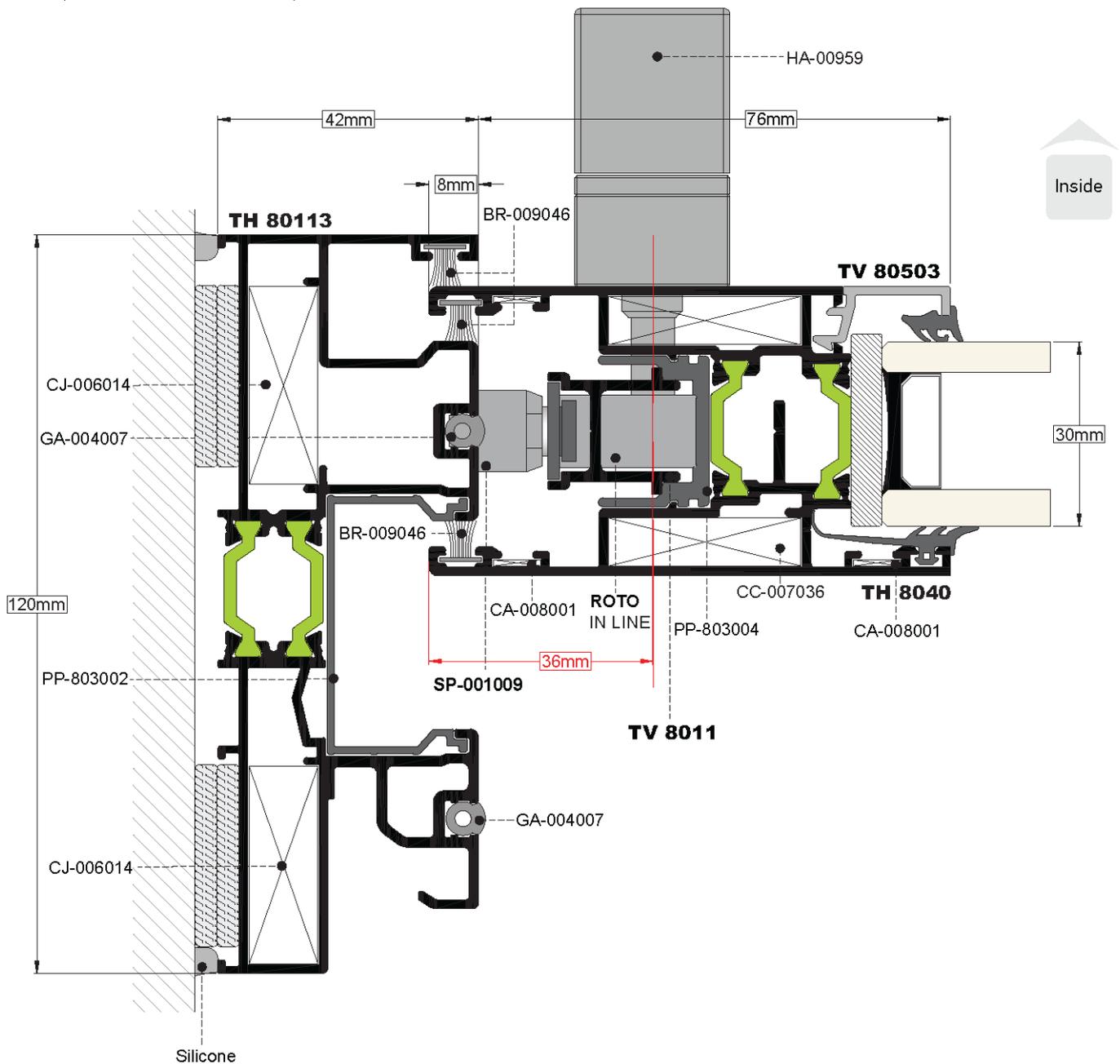
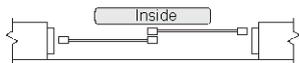
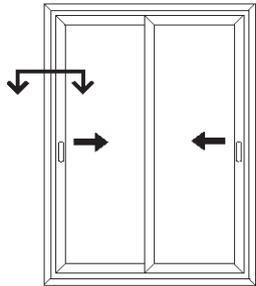
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02.05

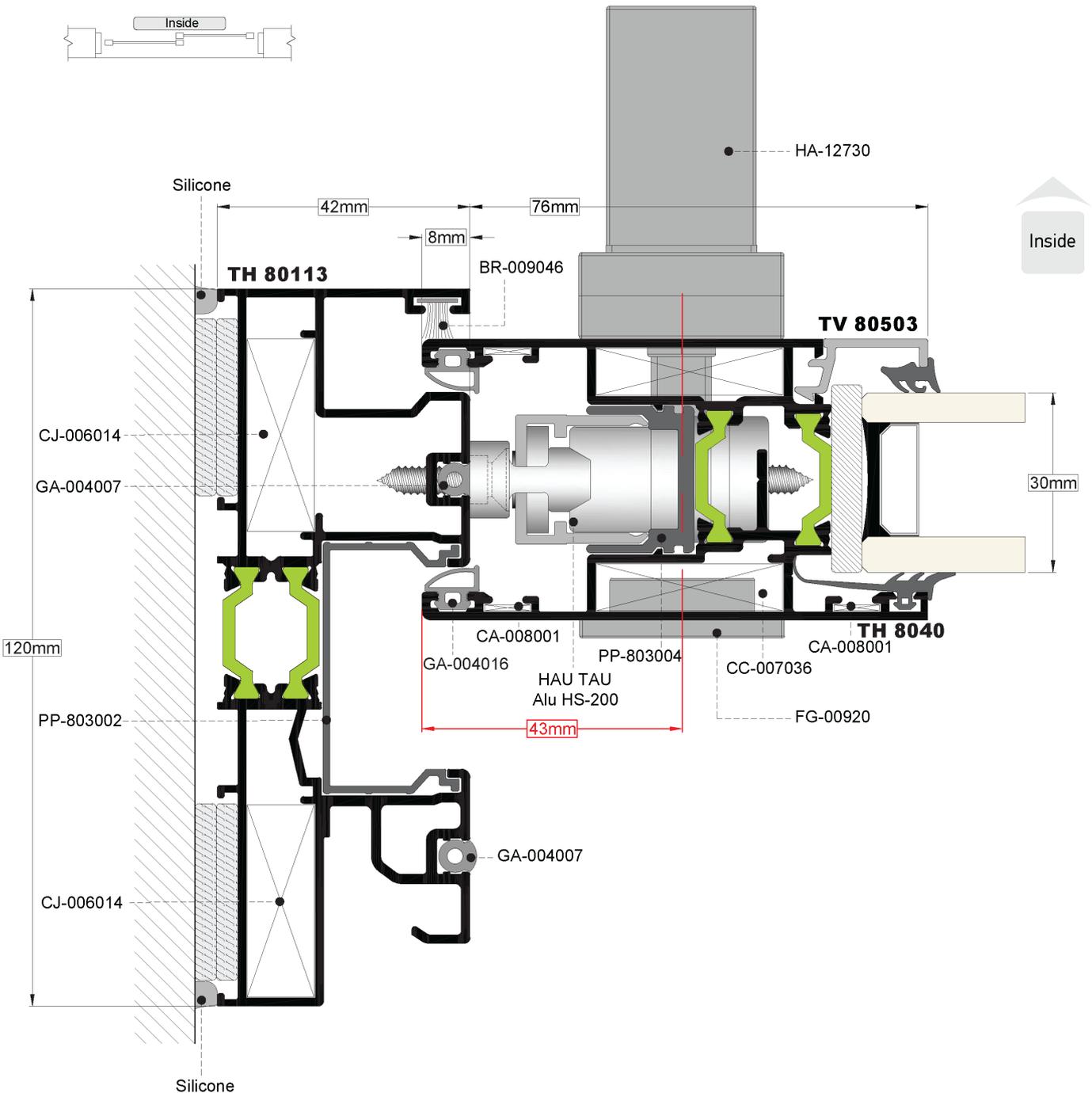
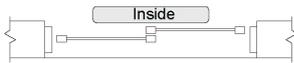
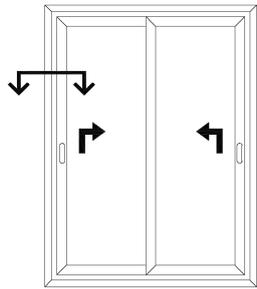
Section 5

Scale 1:1



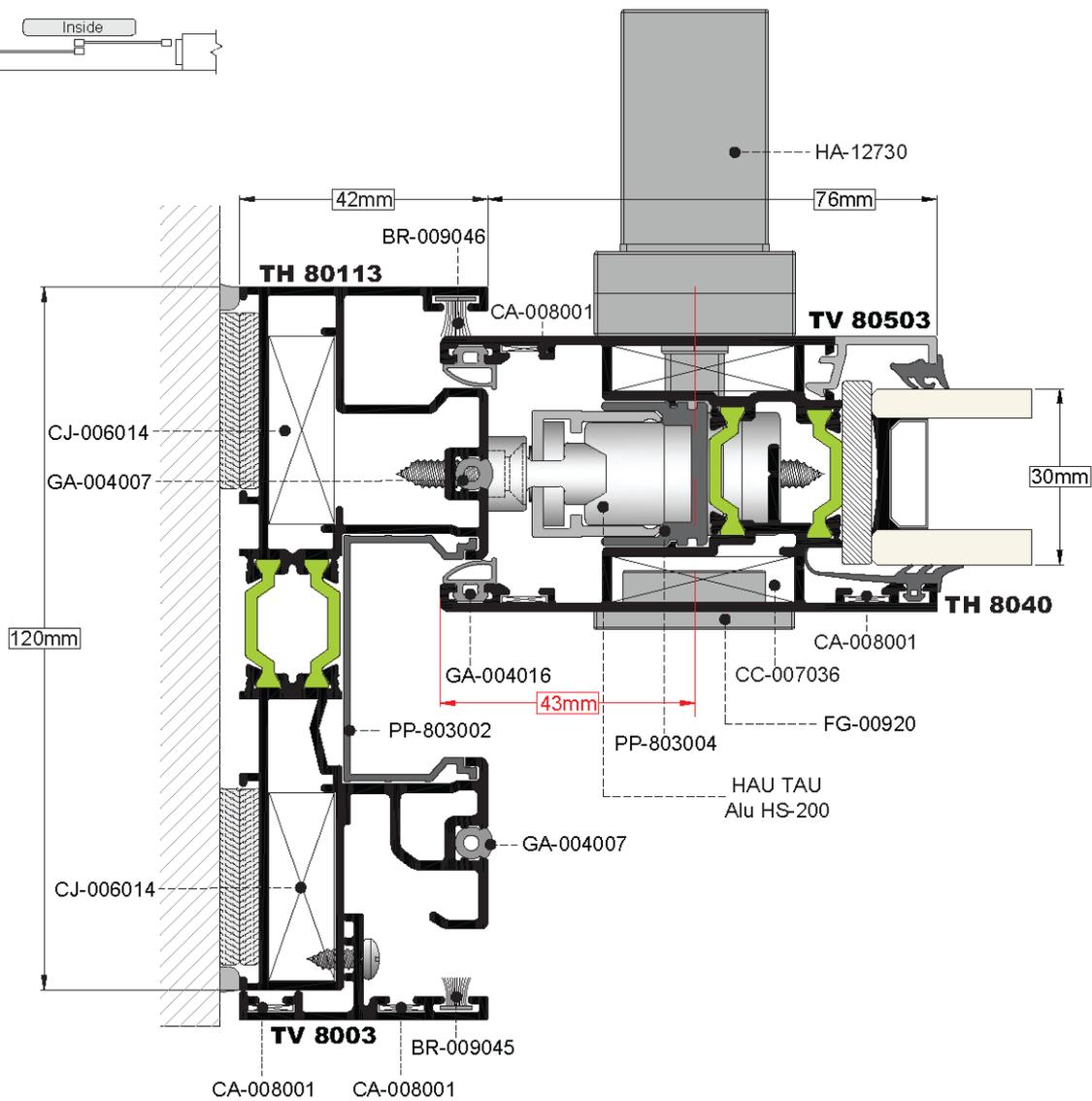
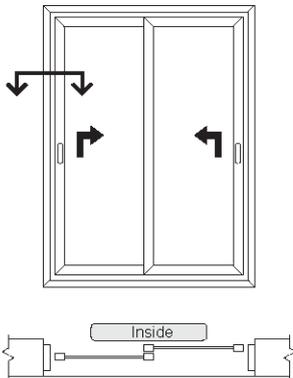
Section 6

Scale 1:1



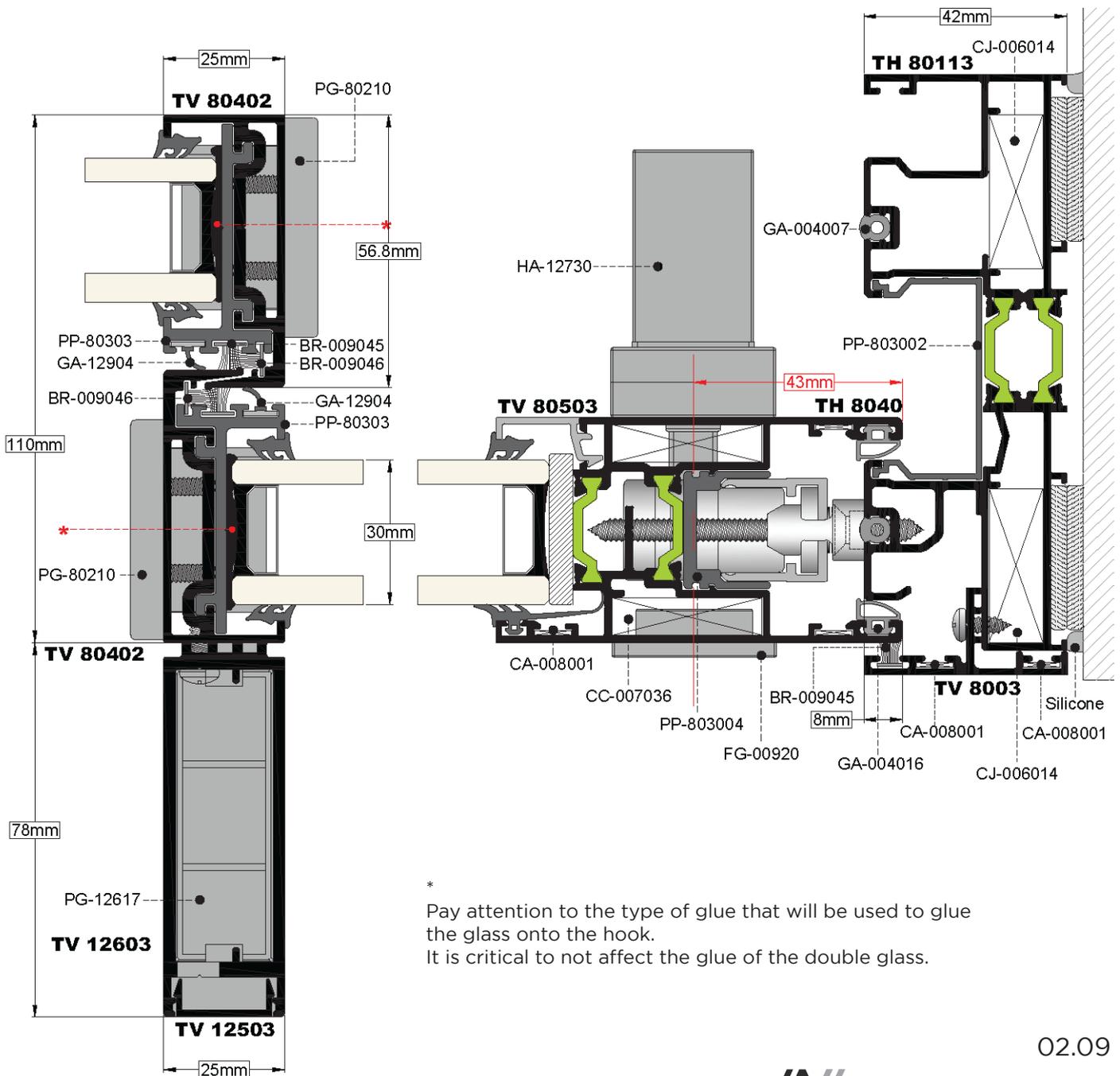
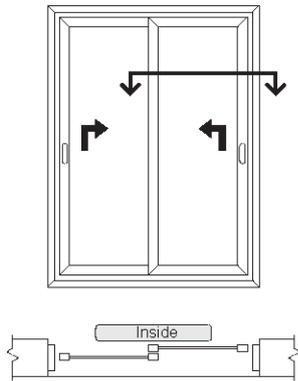
Section 7

Scale 1:1



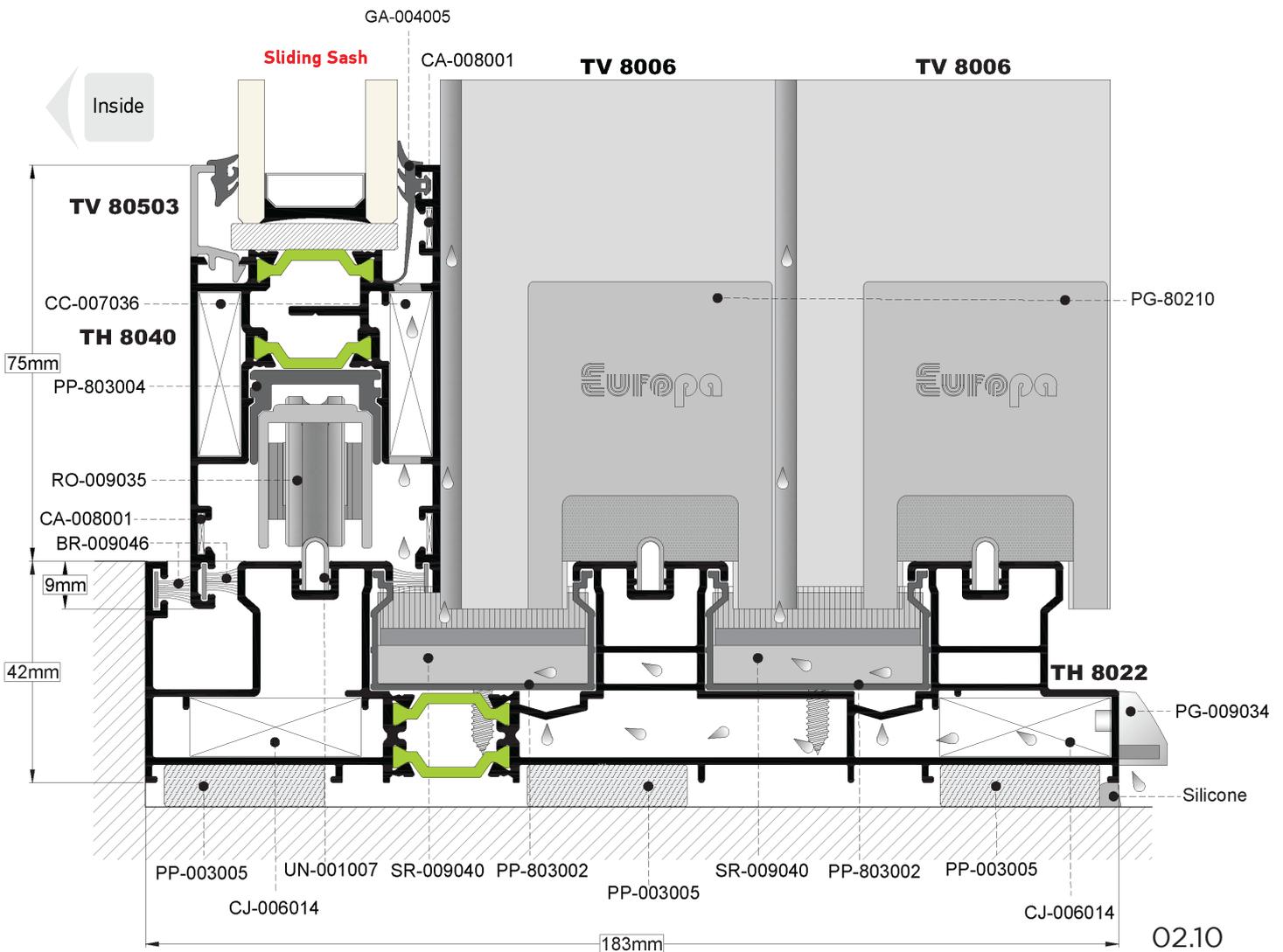
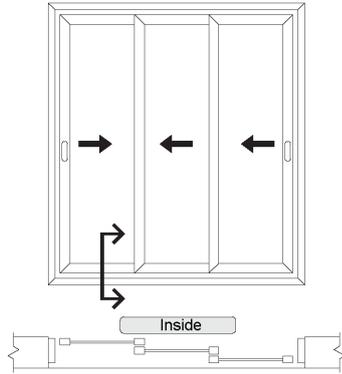
Section 8

Scale 1:1



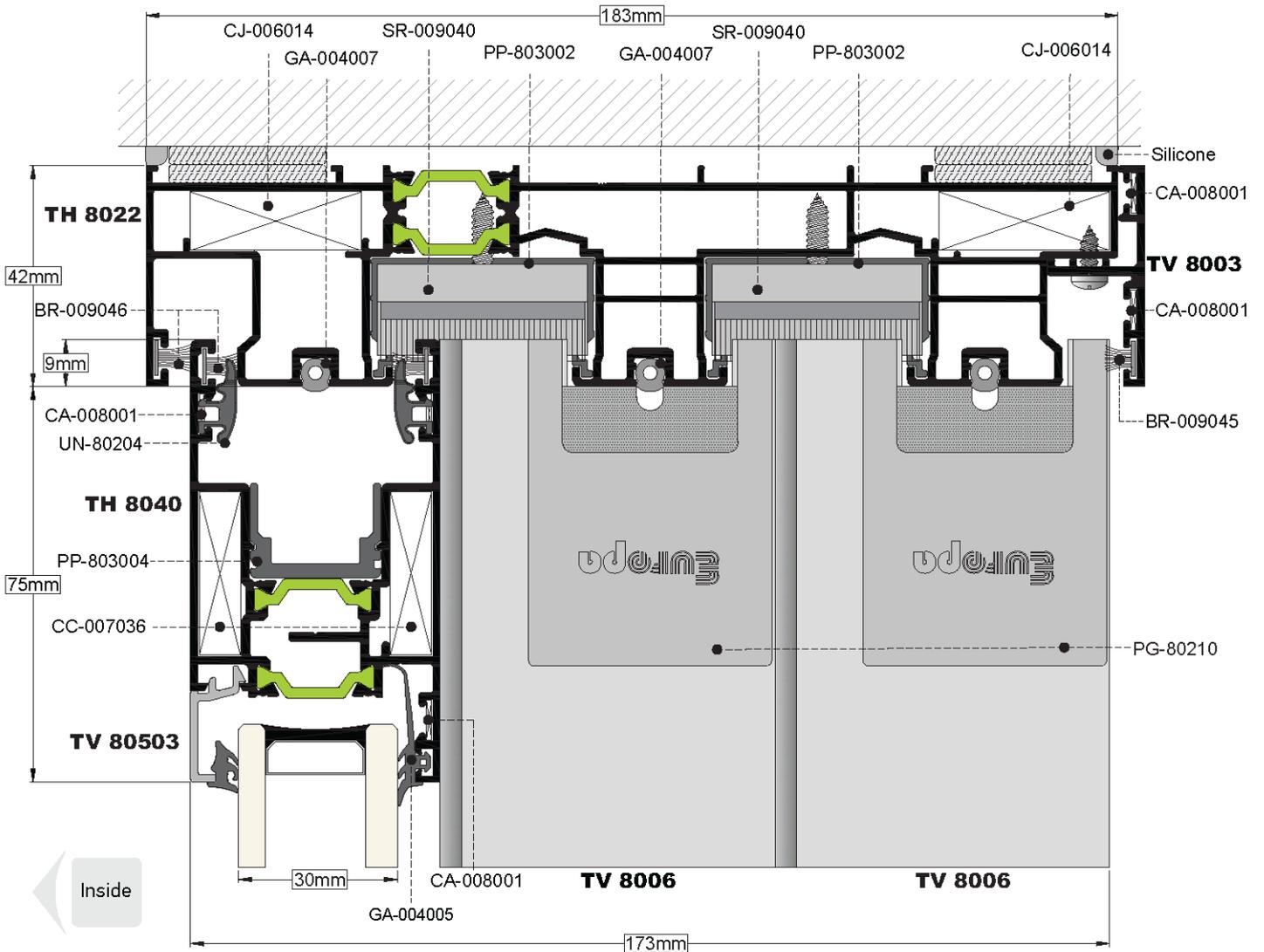
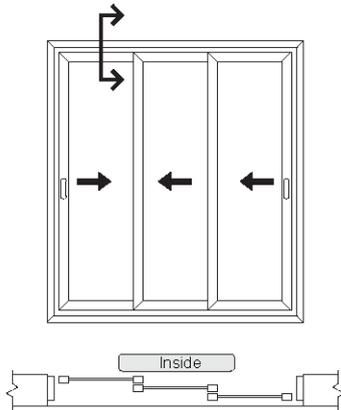
Section 9

Scale 1:1



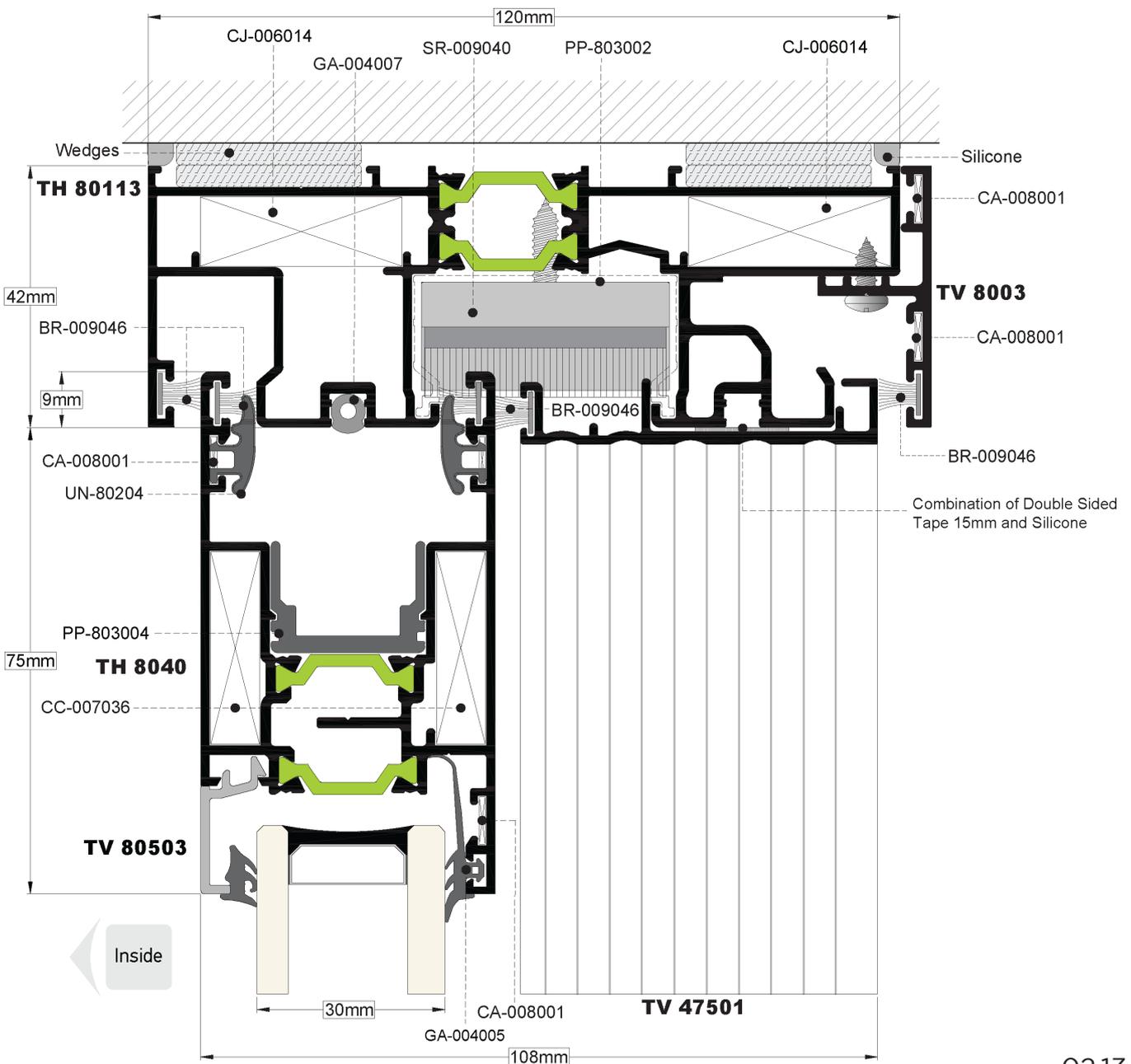
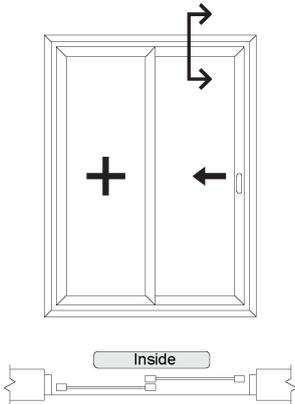
Section 10

Scale 1:1



Section 12

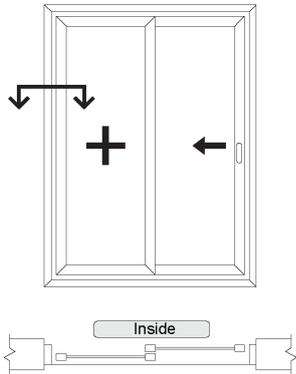
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02.13

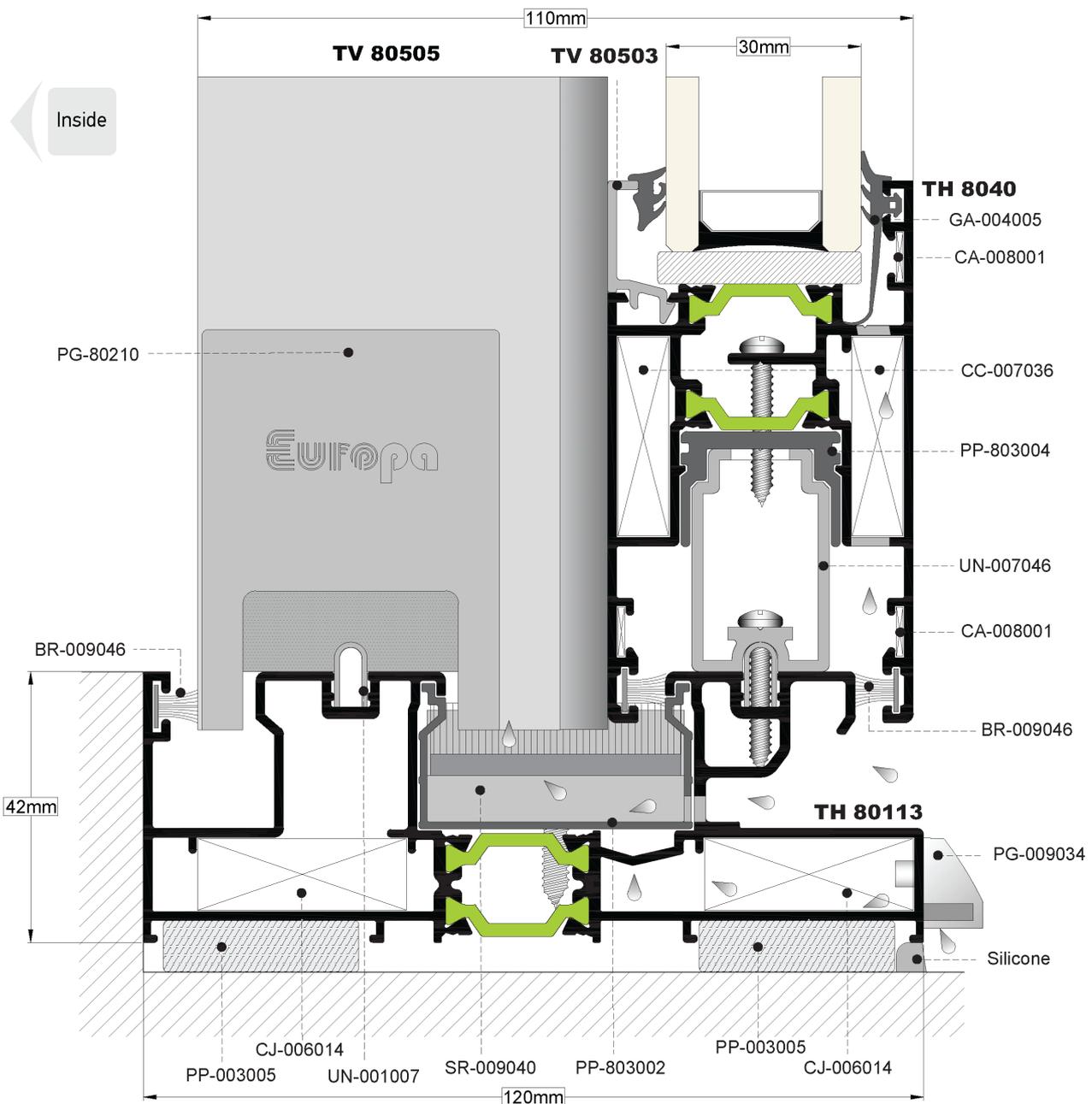
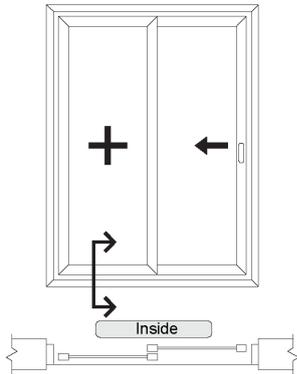
Section 13

Scale 1:1



Section 14

Scale 1:1

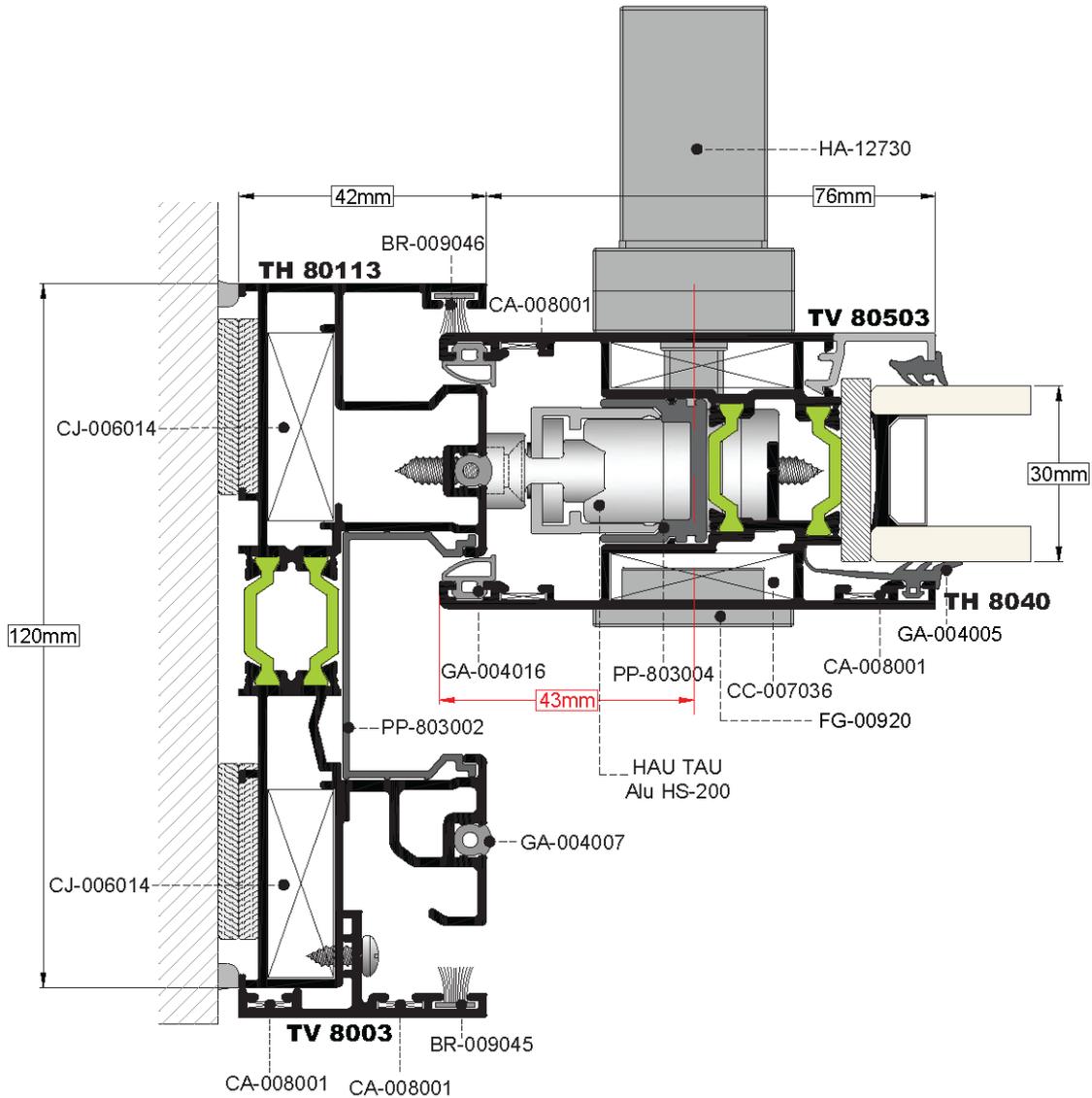
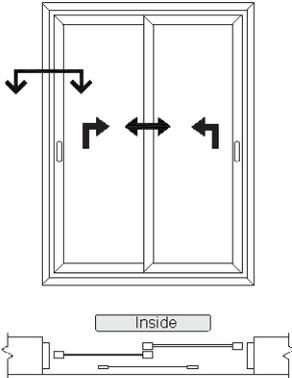


02.15



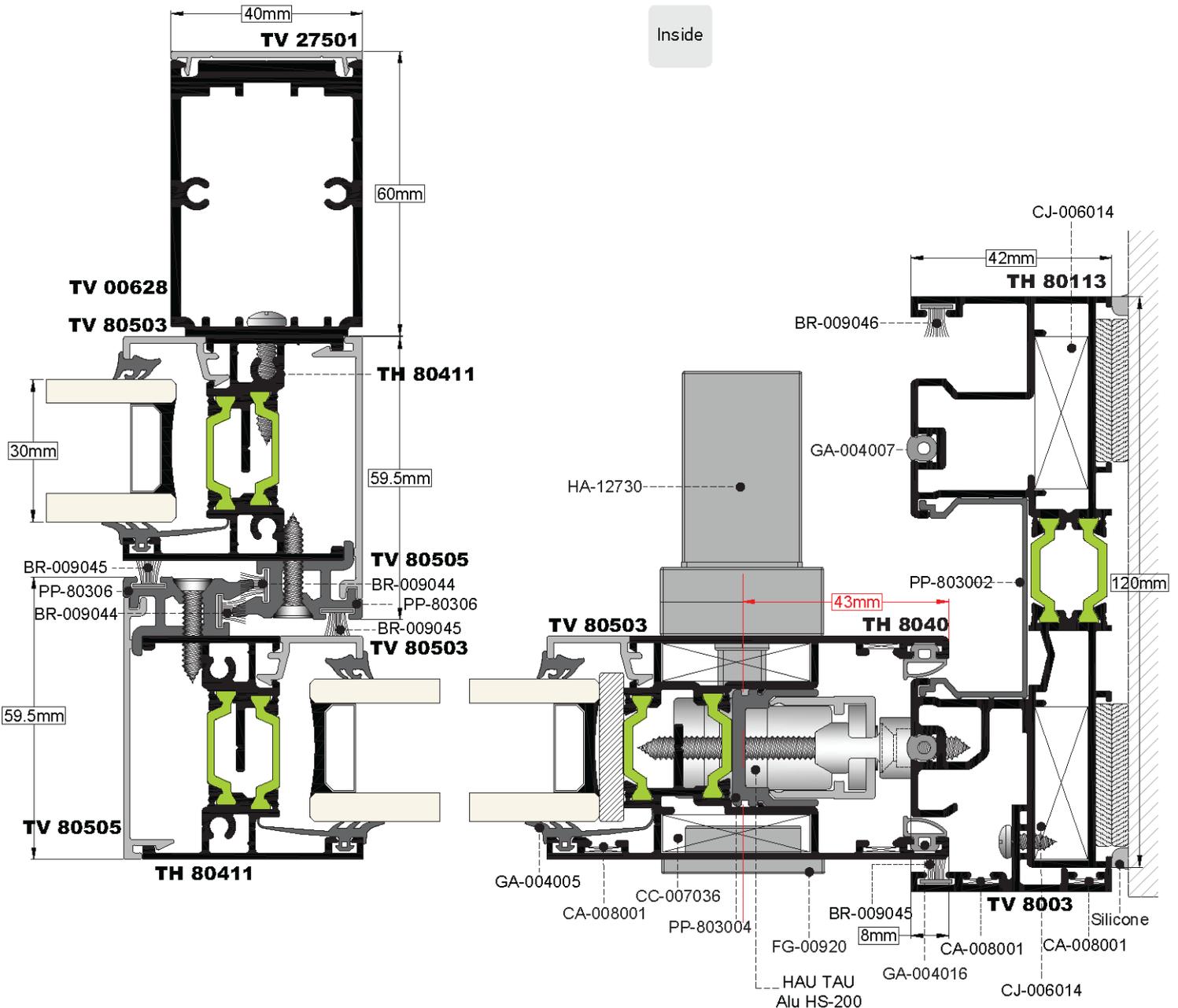
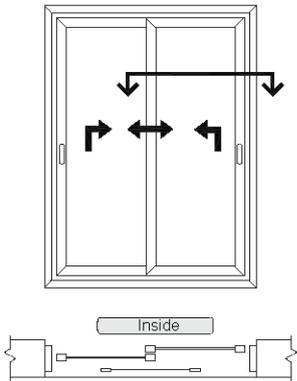
Section 15

Scale 1:1



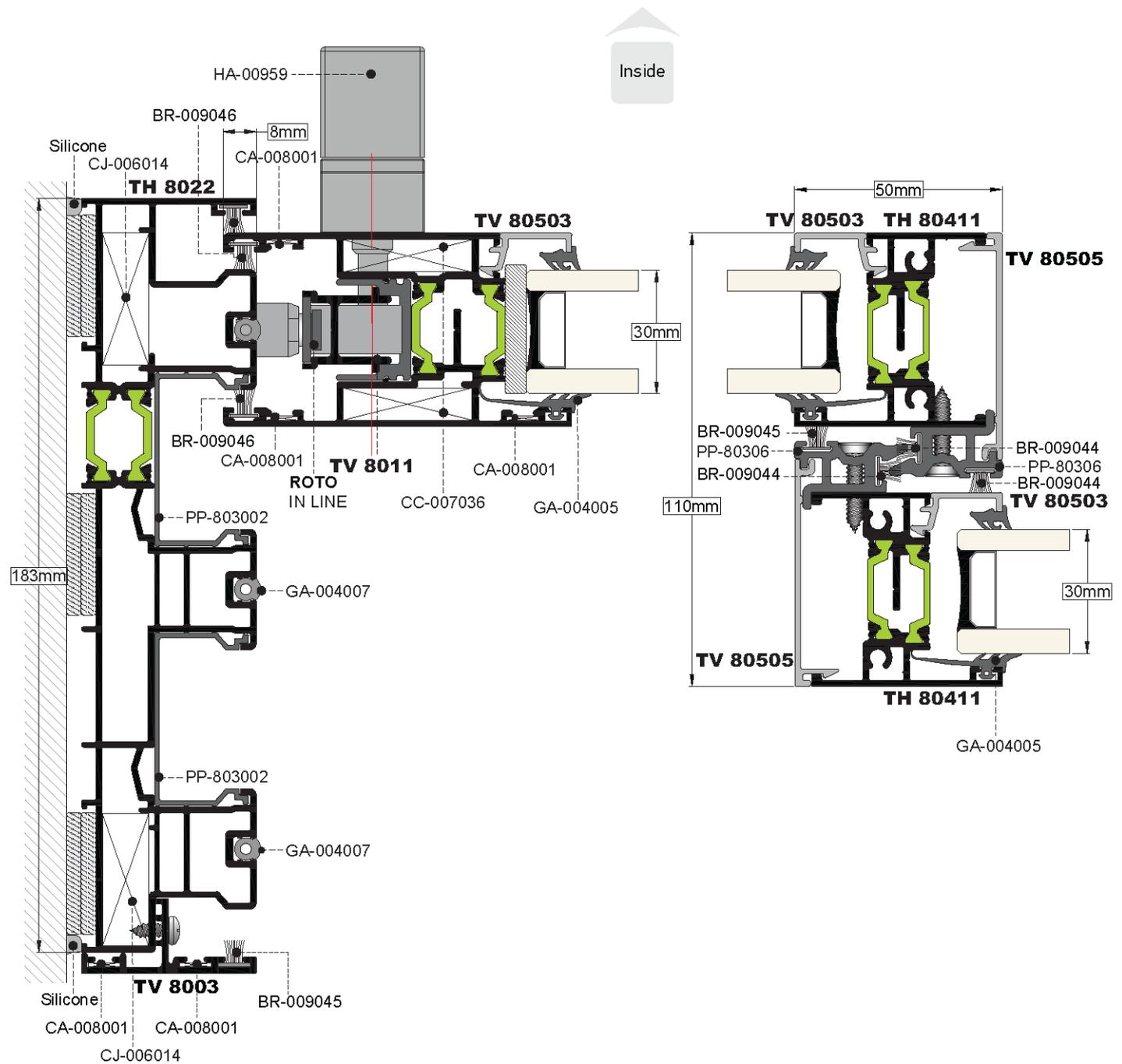
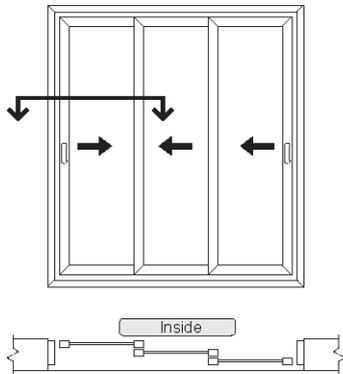
Section 16

Scale 1:1



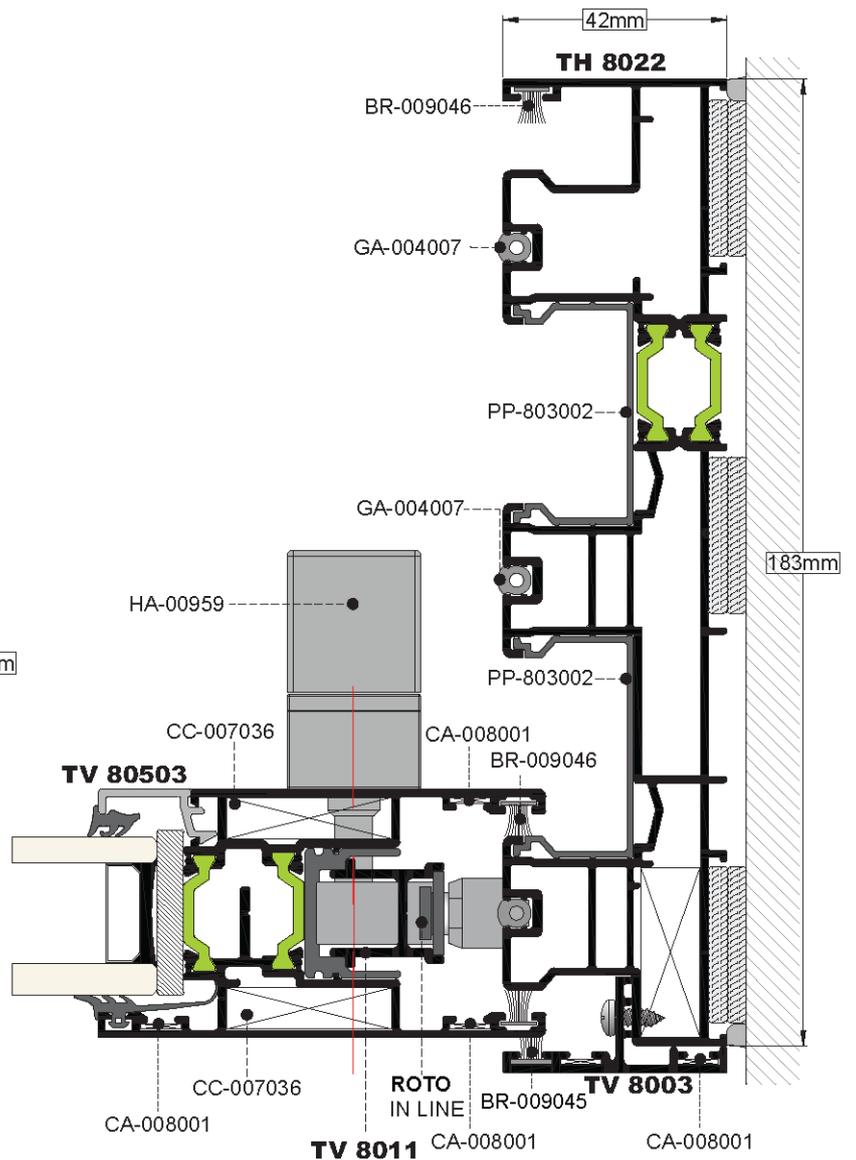
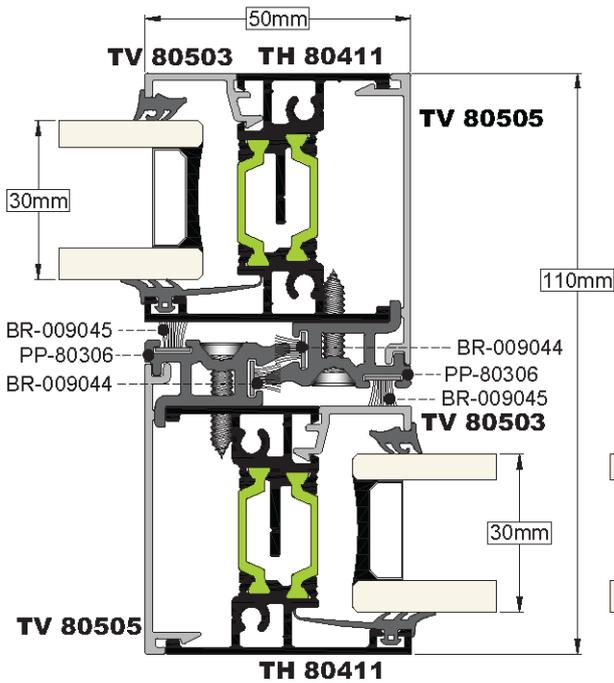
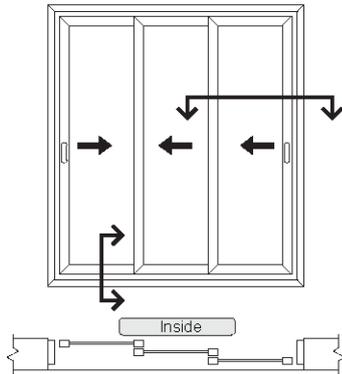
Section 17

Scale 1:1



Section 18

Scale 1:1

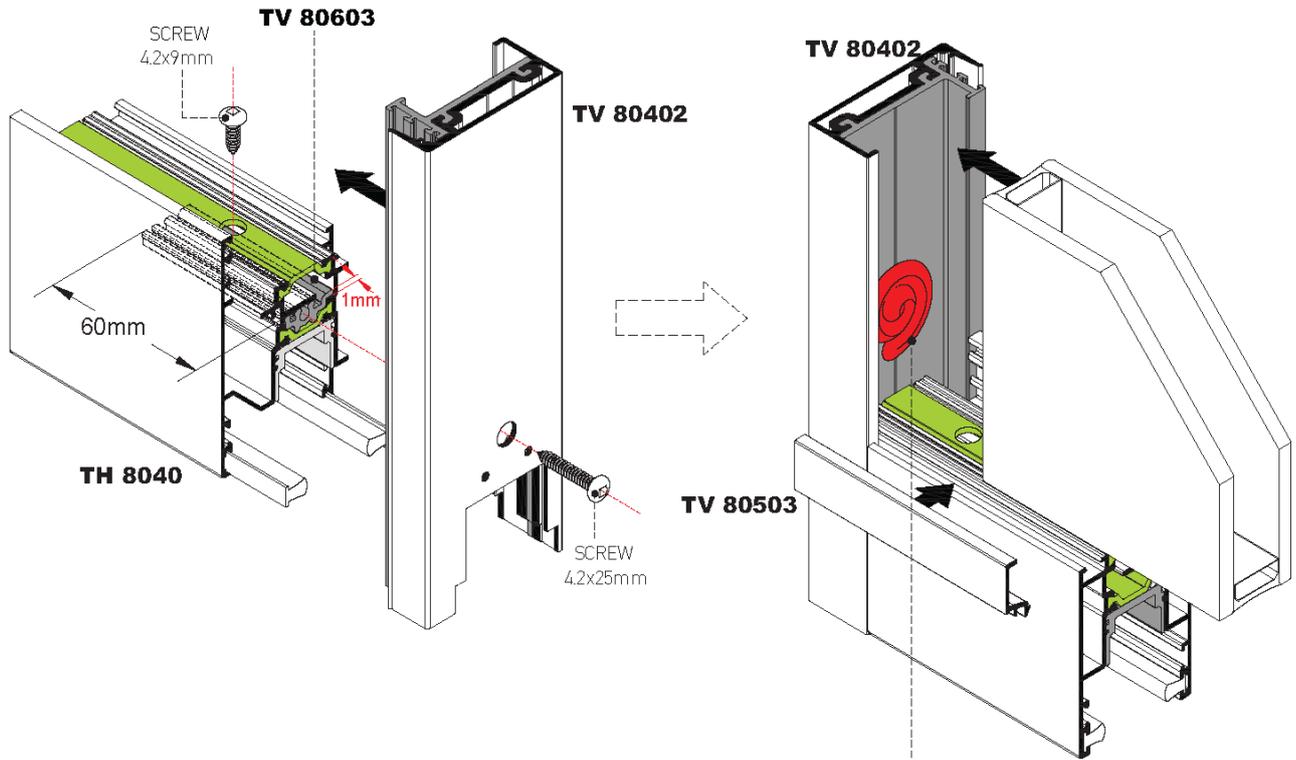




03

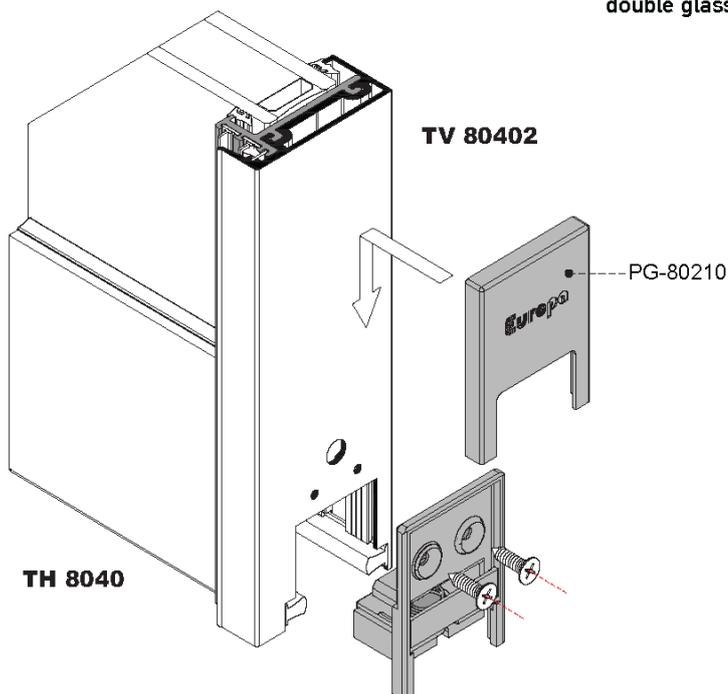
Machining

Assembly of Sash on Successive's Interlock 25mm

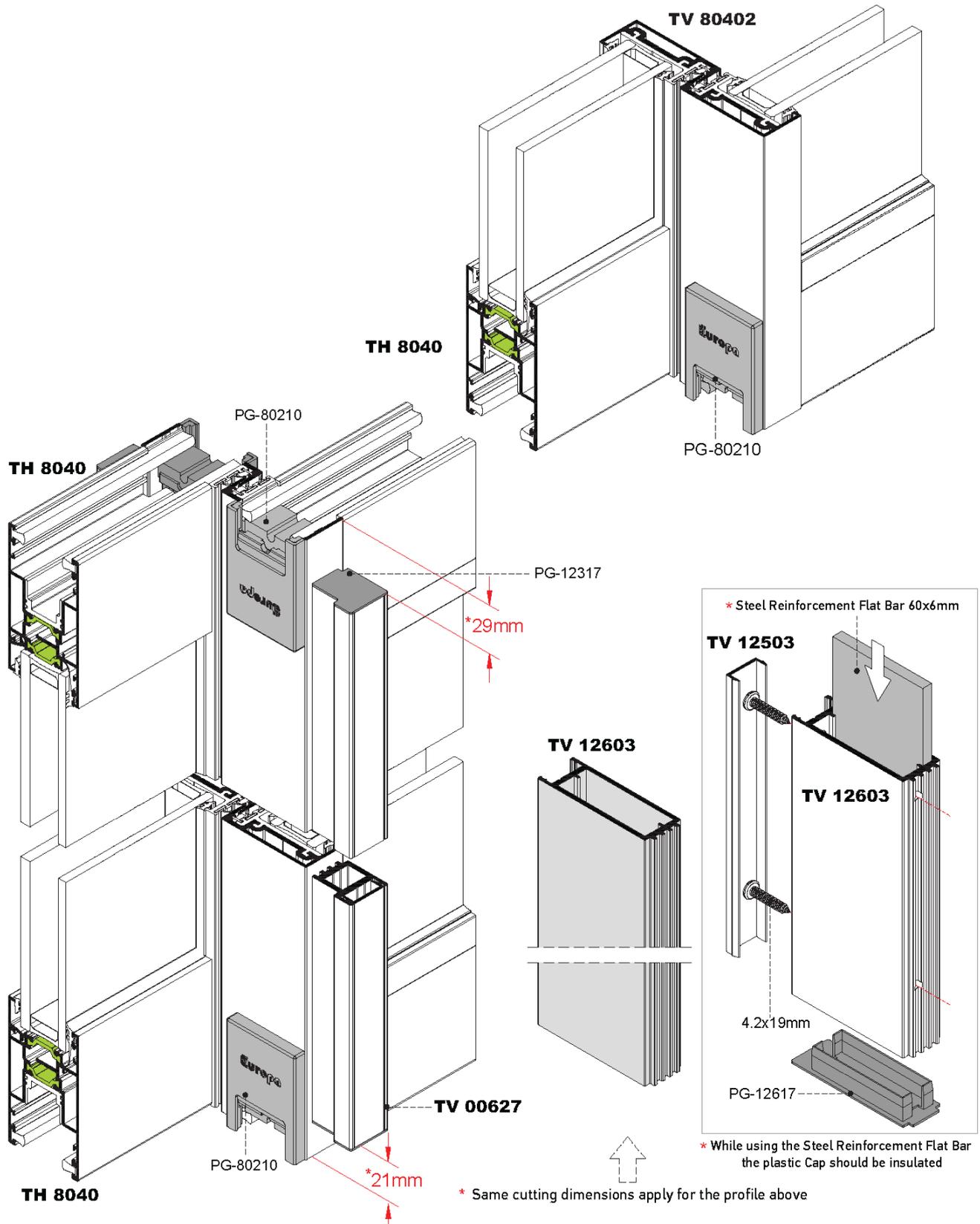


At the connection of interlock with sash, the use of silicone is required for better sealant.

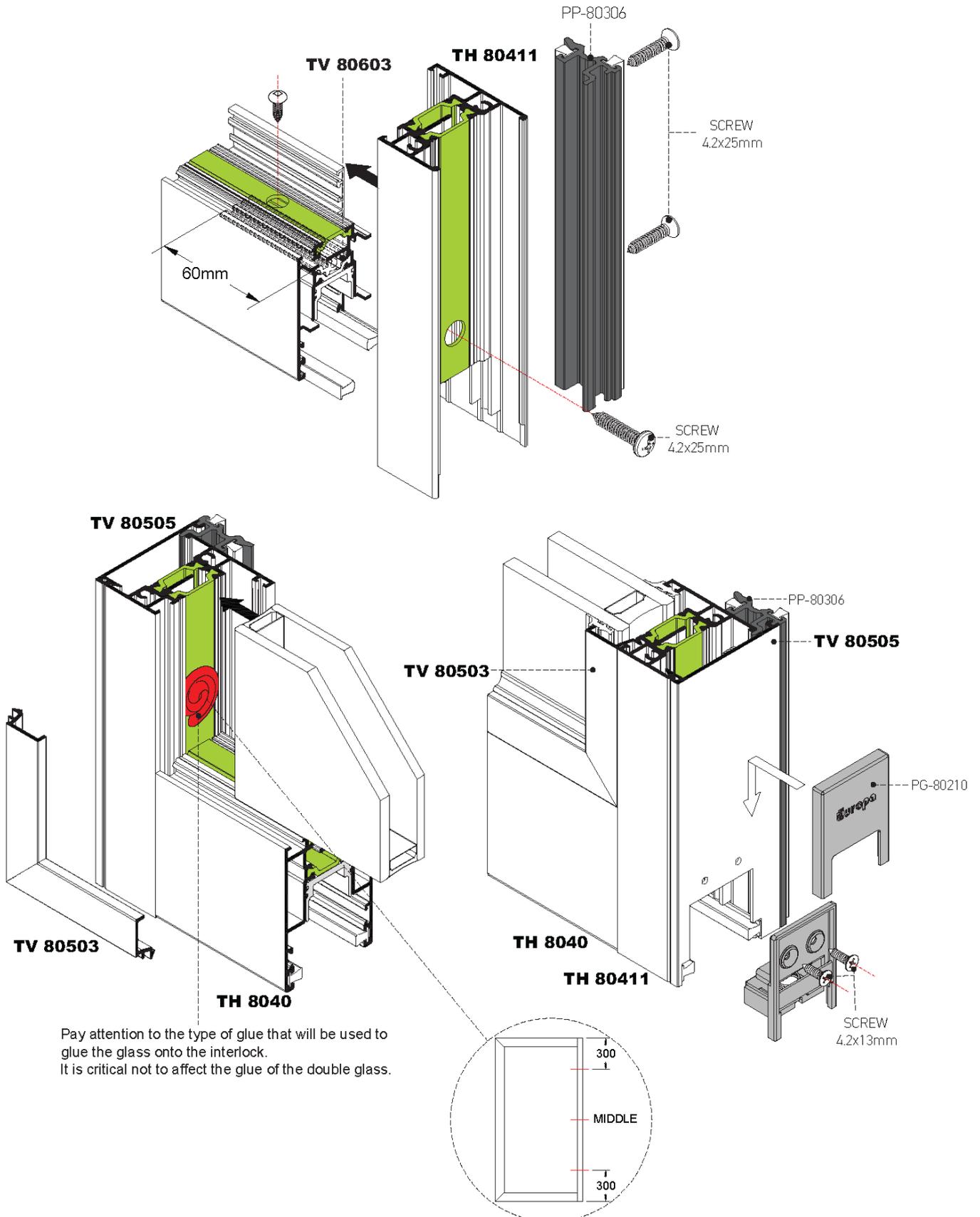
Pay attention to the type of glue that will be used to glue the glass onto the interlock. It is critical not to affect the glue of the double glass.



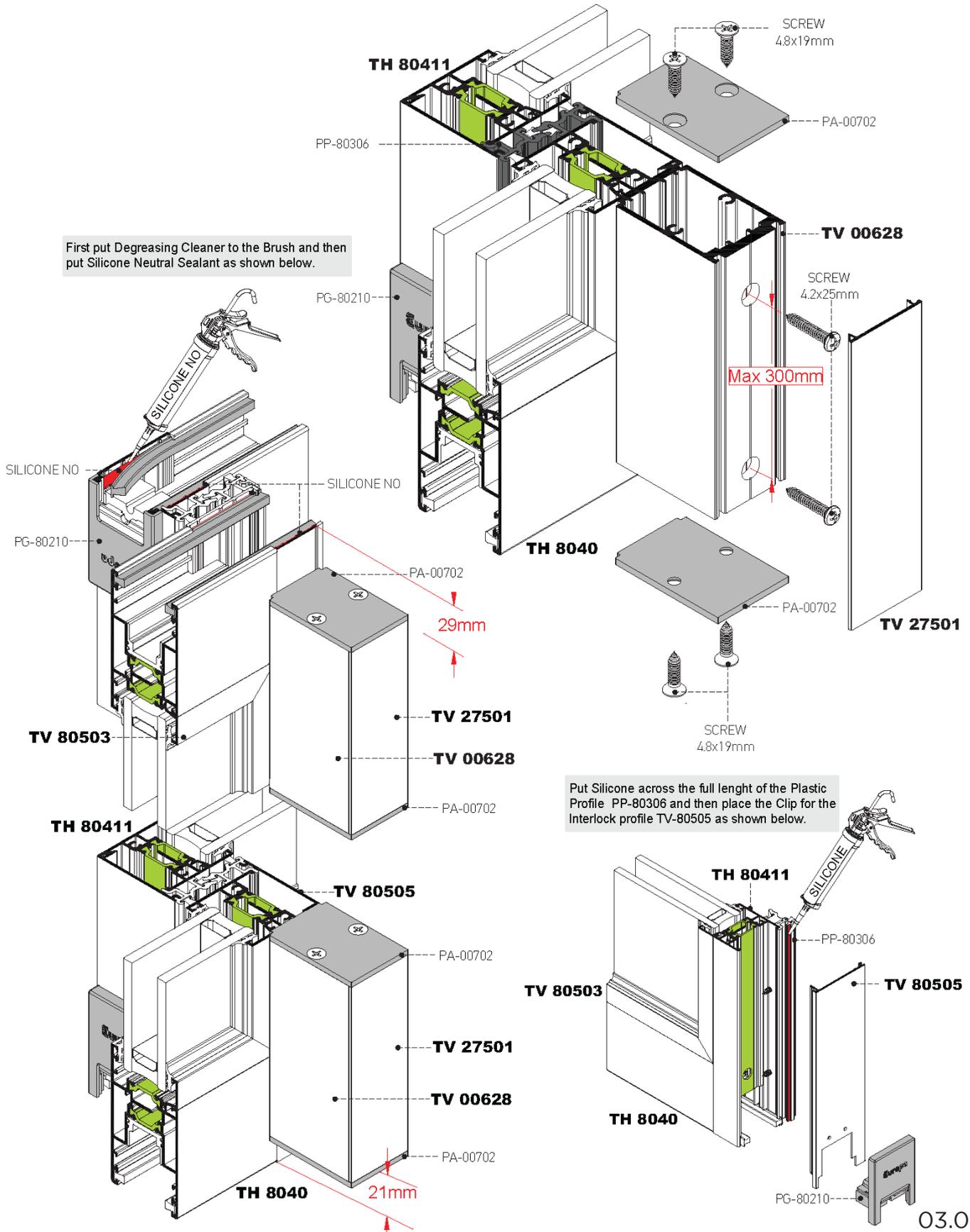
Reinforcement Profiles for Interlock 25mm



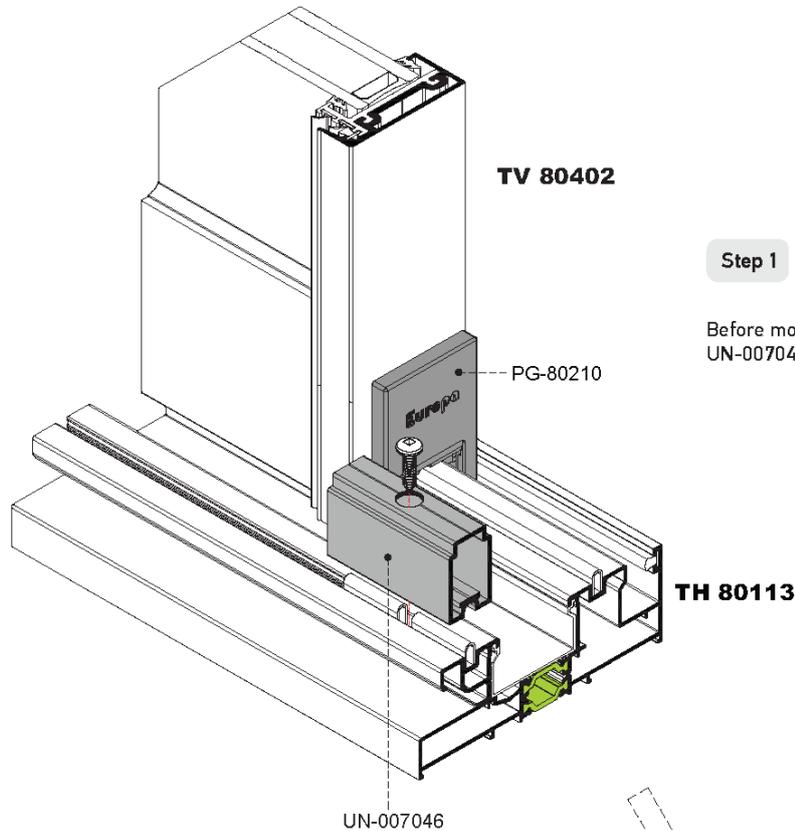
Assembly of Sash on Successive's Interlock 50mm



Reinforcement Profiles for Interlock 50mm



Addition for Successive with Fixed Sash



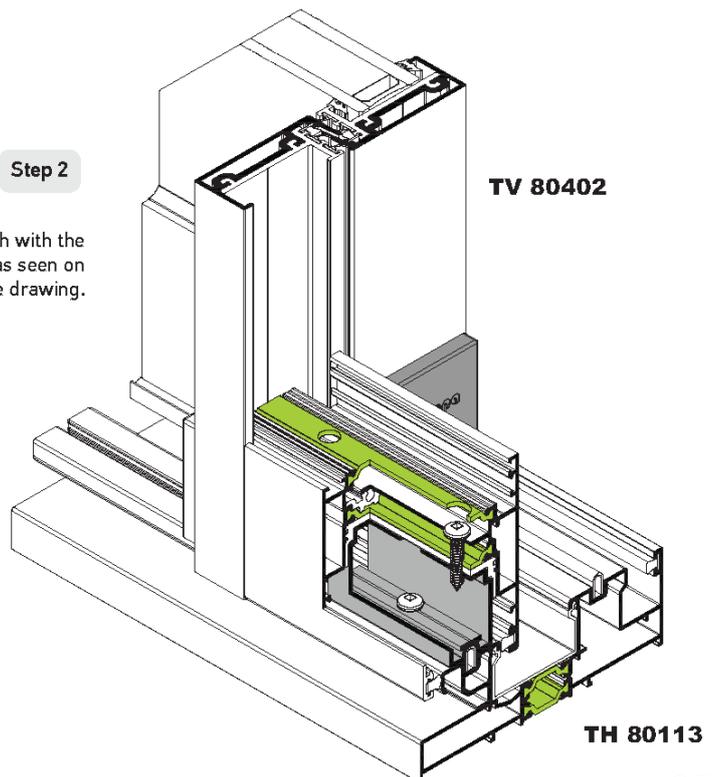
Step 1

Before mounting the sash on the rail, fix UN-007046 component on the rail.

UN-007046

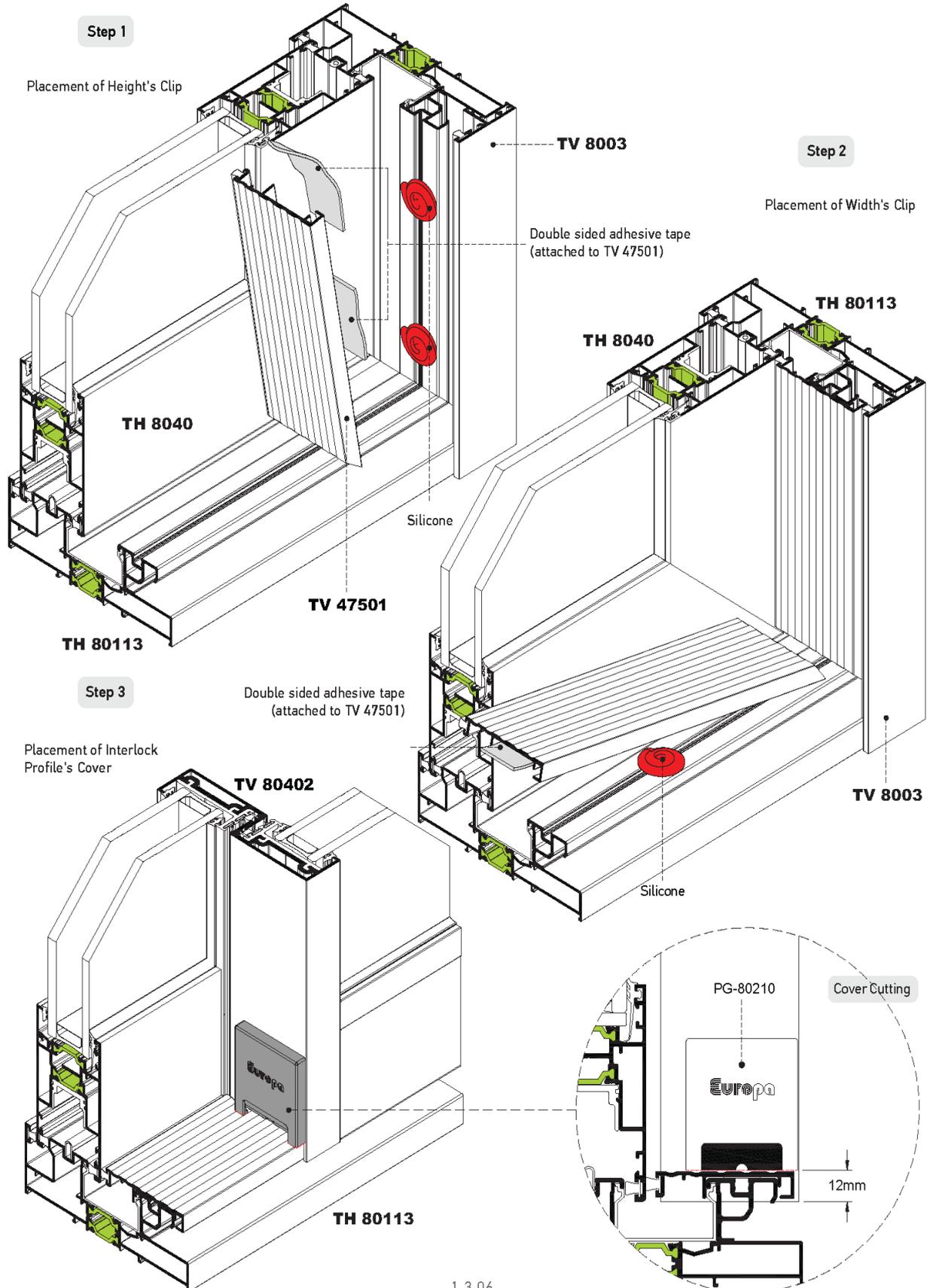
Step 2

Then, we fix the sash with the UN-007046 component as seen on the drawing.

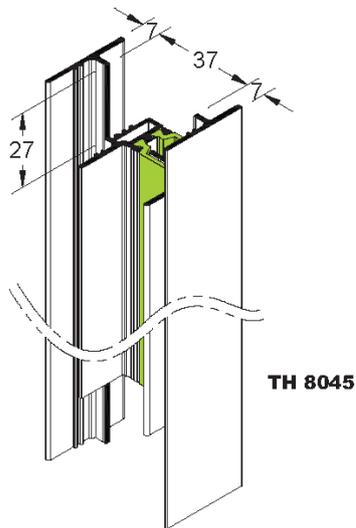


03.05

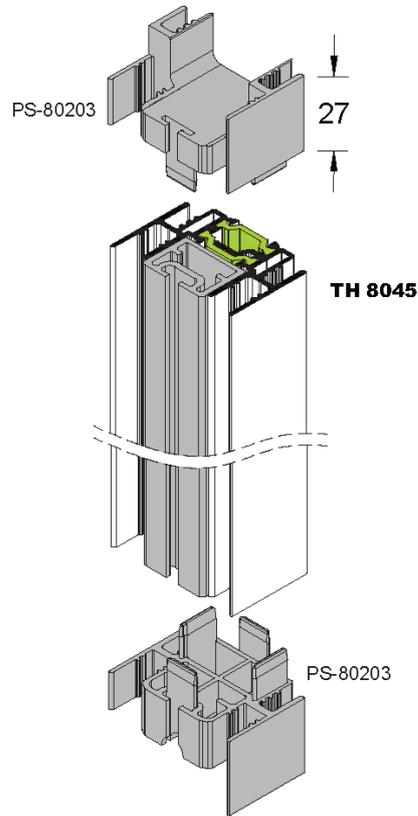
Assembly Cover Profile For Rail with Fixed Sash



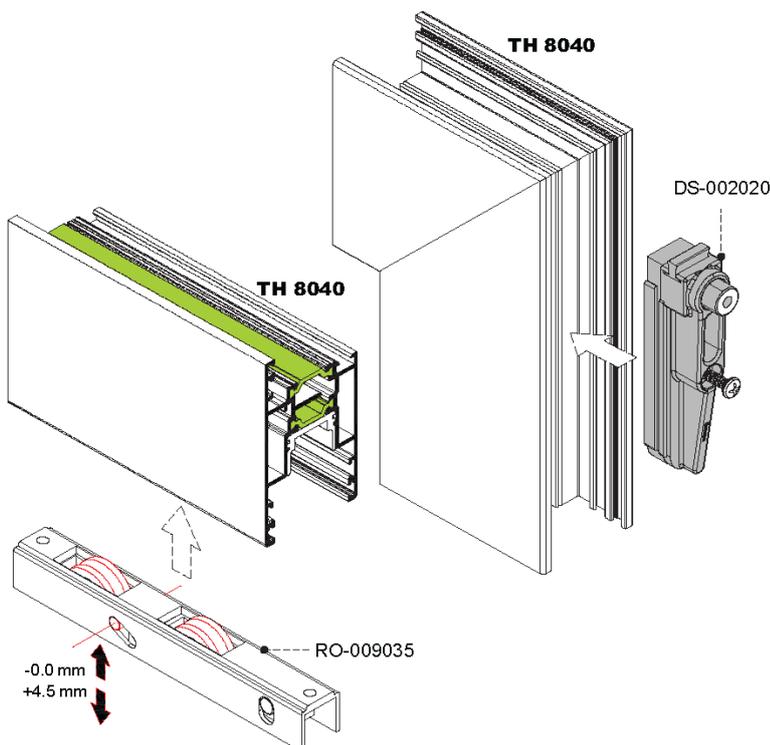
Milling Process of Adjoining Profiles for a Double Joint Sash



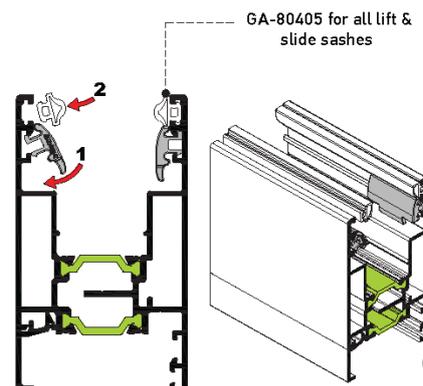
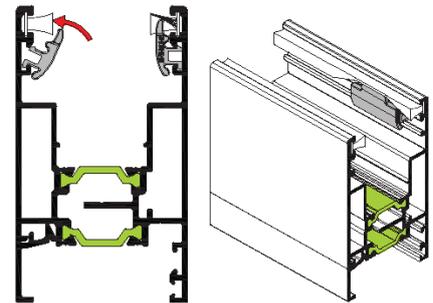
Plastic Cups for Adjoining Profiles of a Double Joint Sash



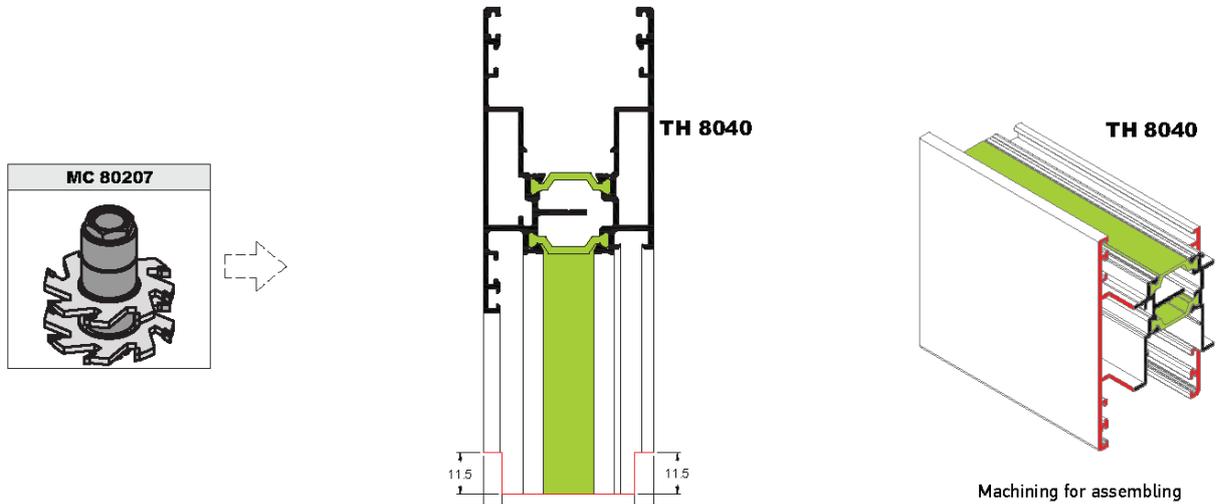
Installation of Damping Stopper and Rollers to Glass Sash



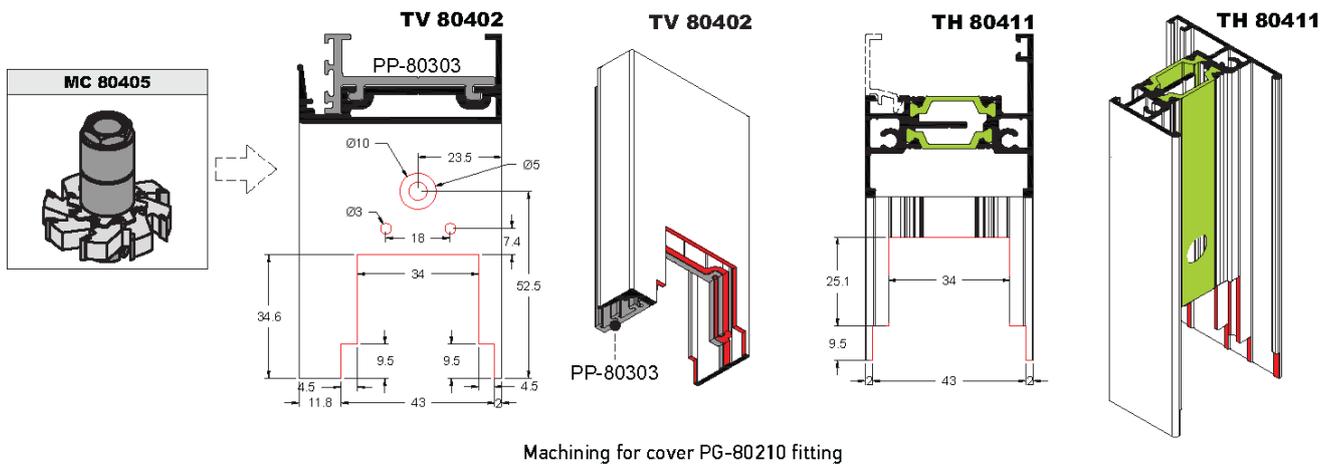
Mounting UN-80204 on a simple slide glass sash.
[in special cases it can be used on a lift & slide sash as well]



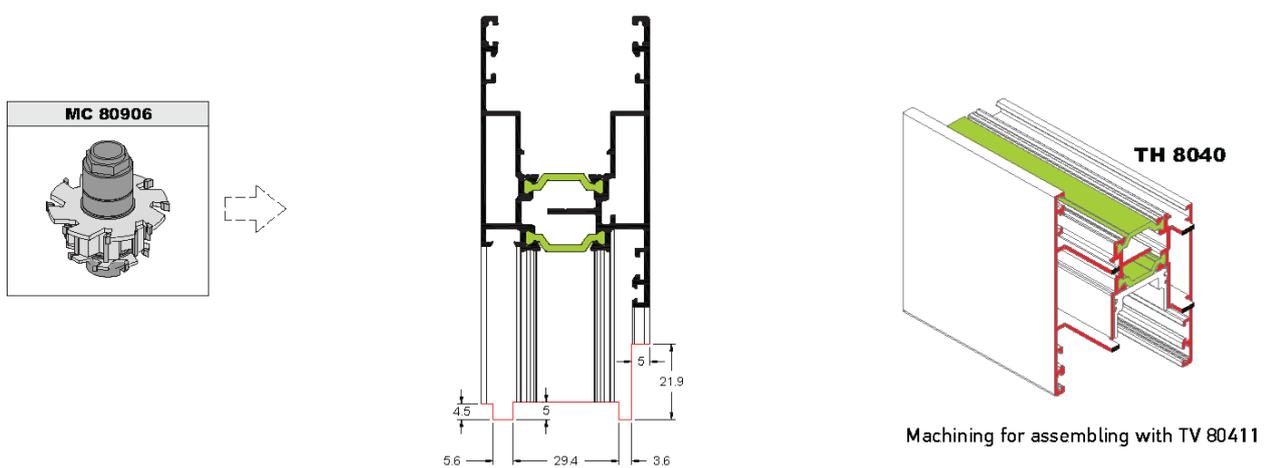
Glass Sash Milling for 25mm Interlock Profile



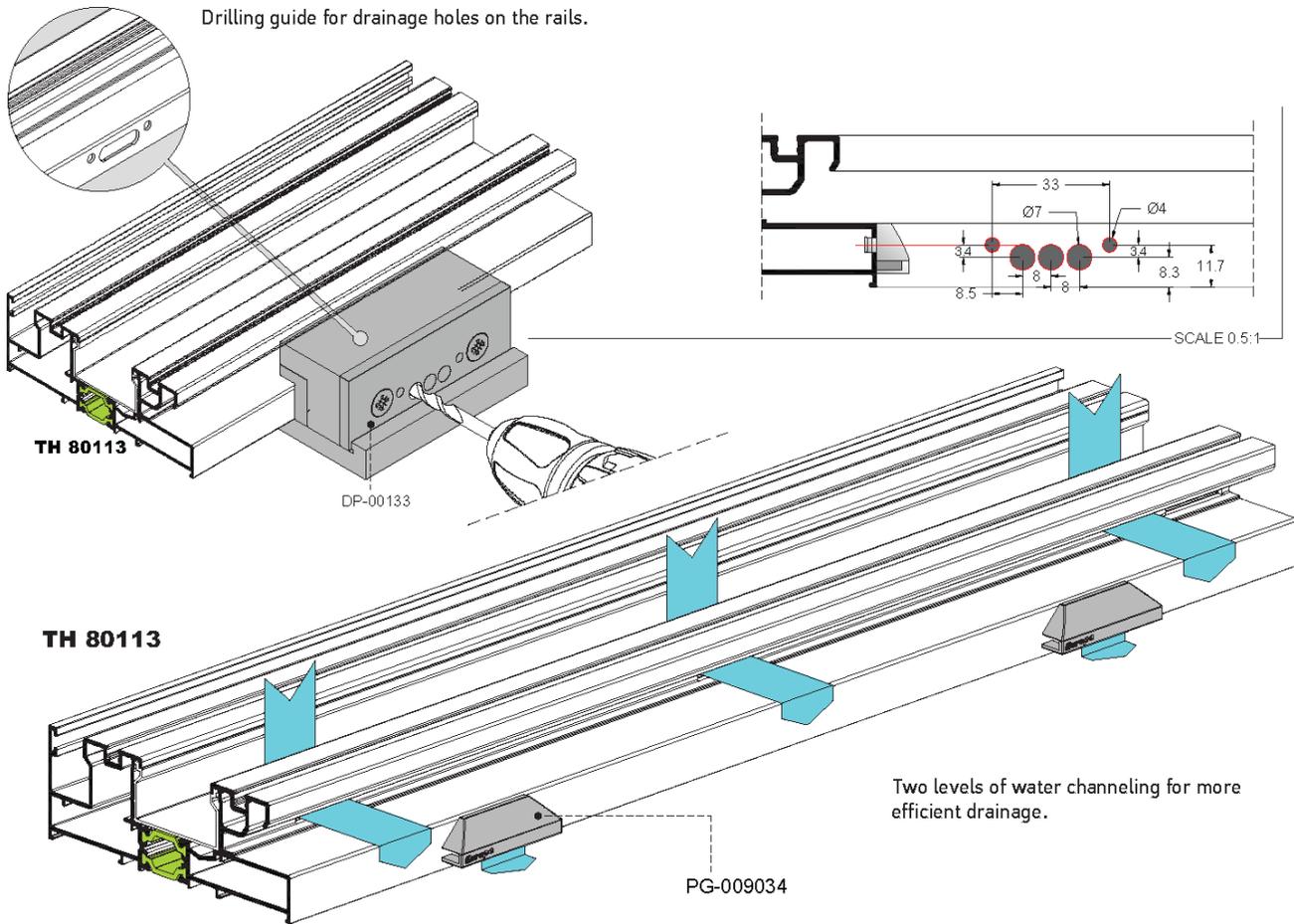
Milling for 25mm & 50mm Interlock Profile



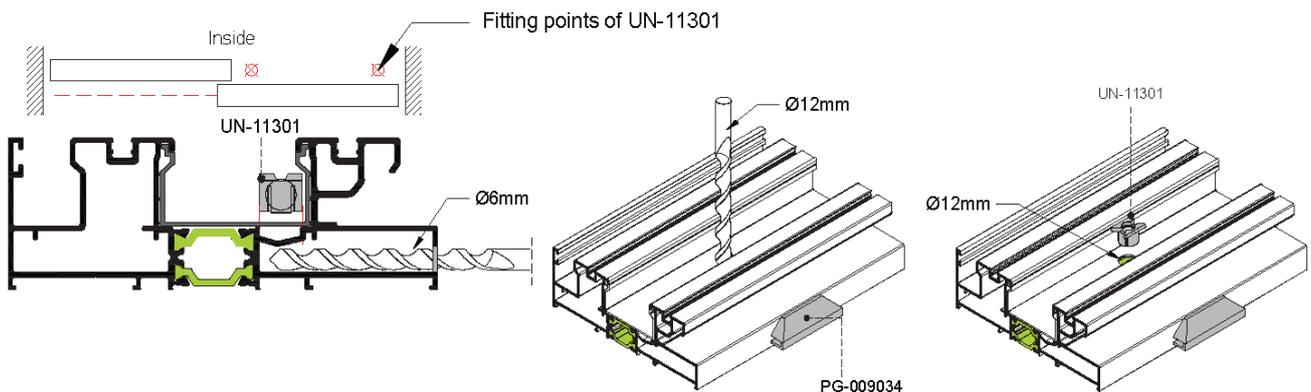
Glass Sash Milling for 50mm Interlock Profile



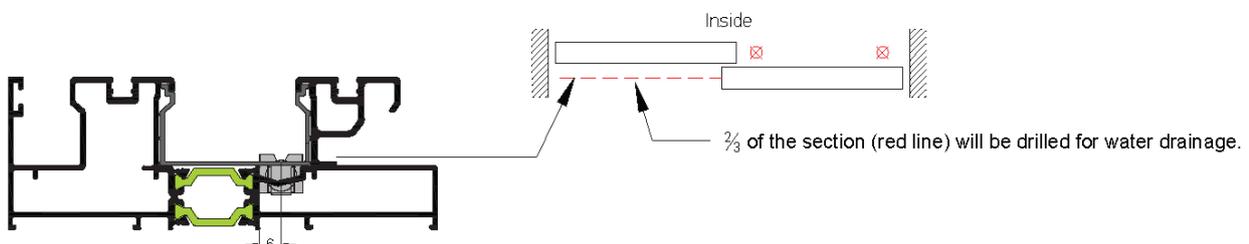
Water Drainage Holes on Rails



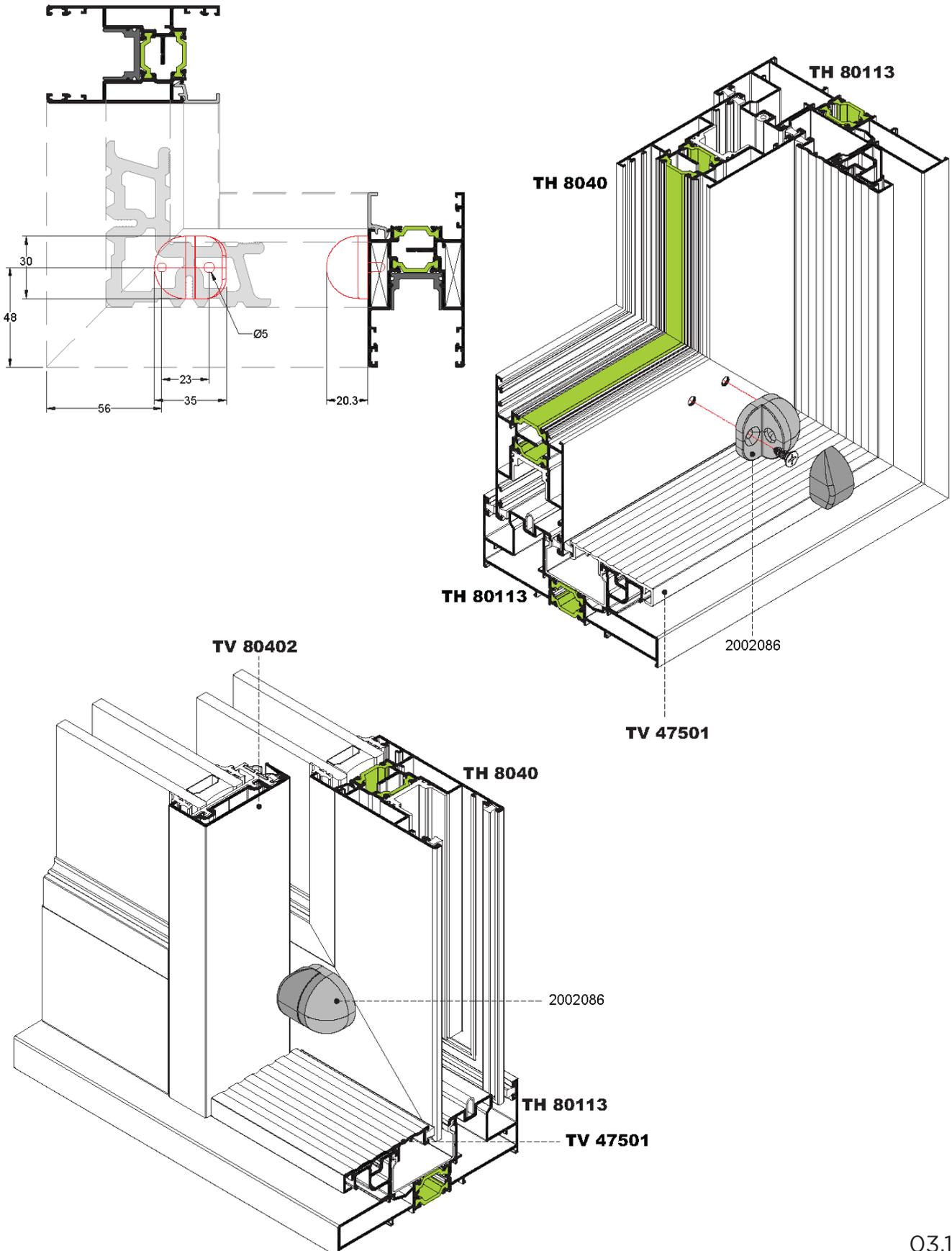
Non-Return Valve UN-11301 Installation for the Rails: TH 80113, TH 8022



Water Drainage holes

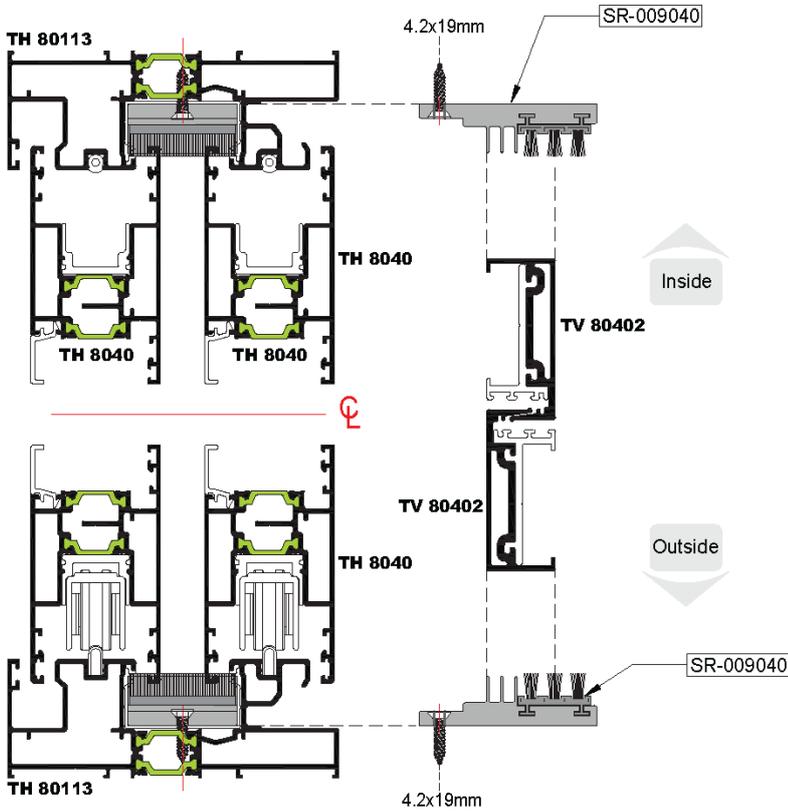


Glass Sash Stopper for Successive

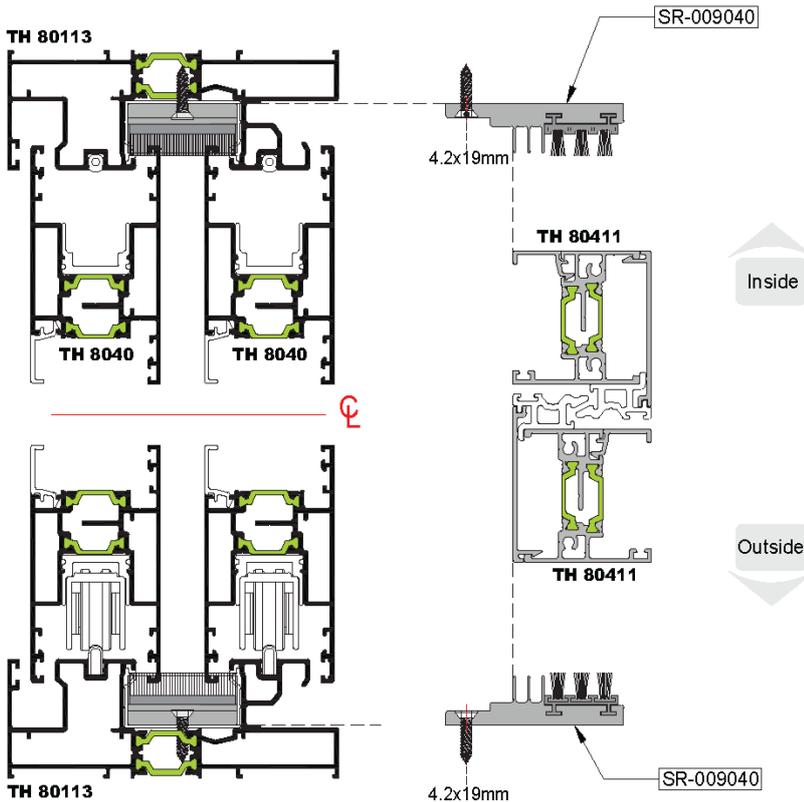


Sealing Plugs for Rails with 42mm Height for Simple Sliding Sash

With 25mm Interlock

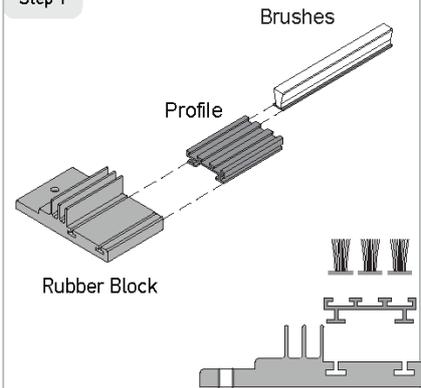


With 50mm Interlock

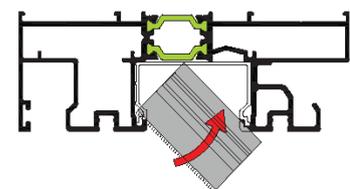


Installation of Upper Sealing Plug

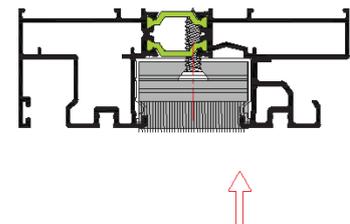
Step 1



Step 2

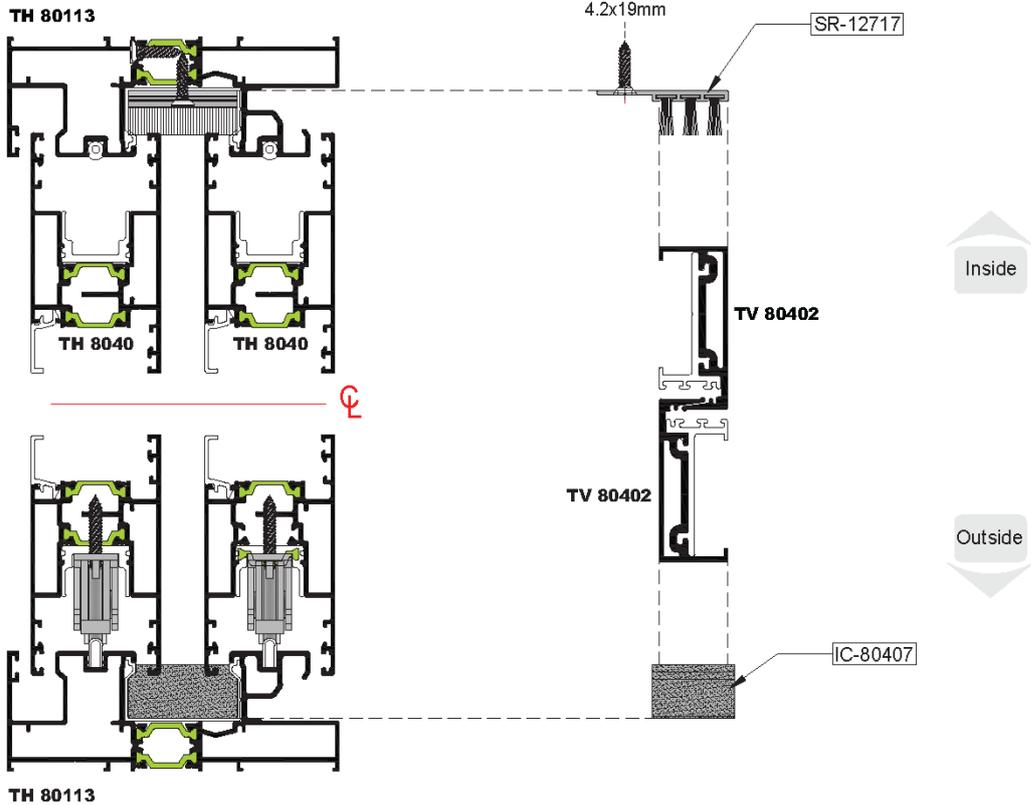


Step 3

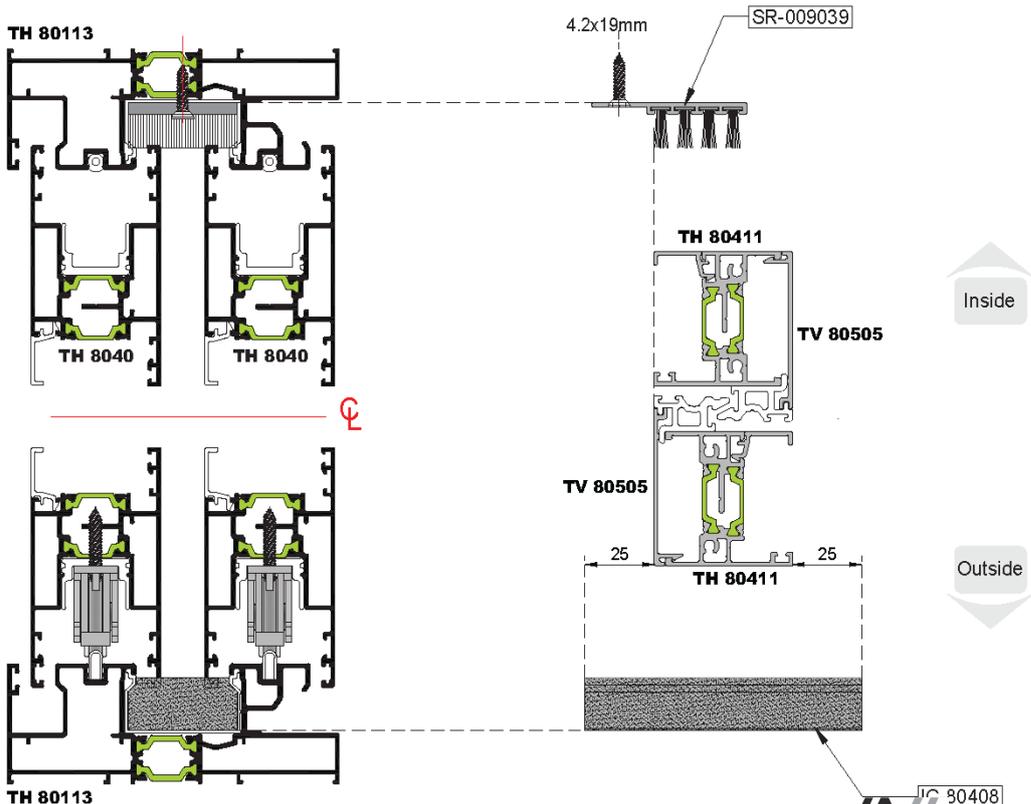


Sealing Plugs for Rails with 42mm Height for Lift & Slide Sash

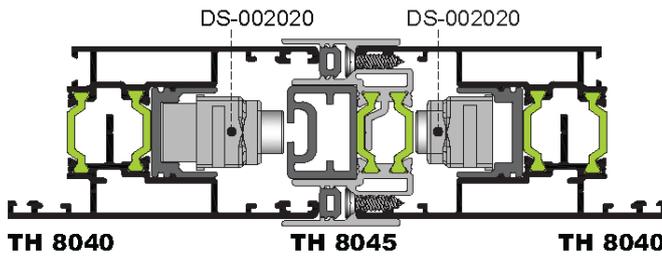
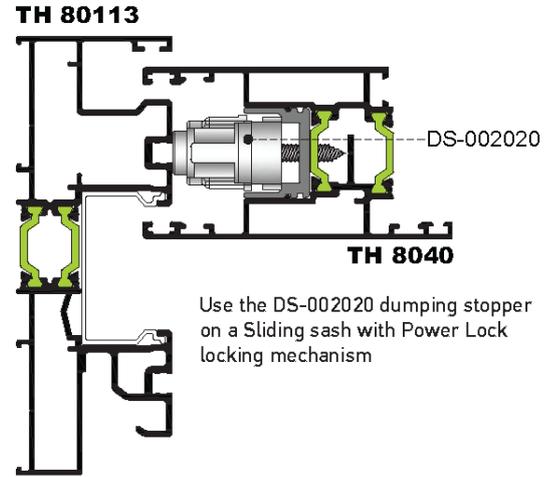
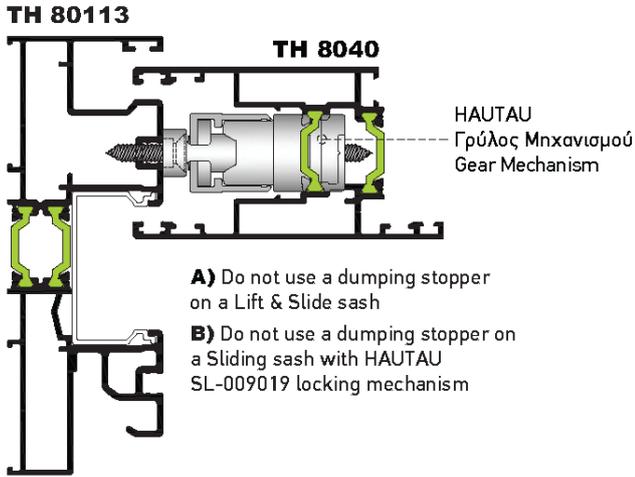
With 25mm Interlock



With 50mm Interlock

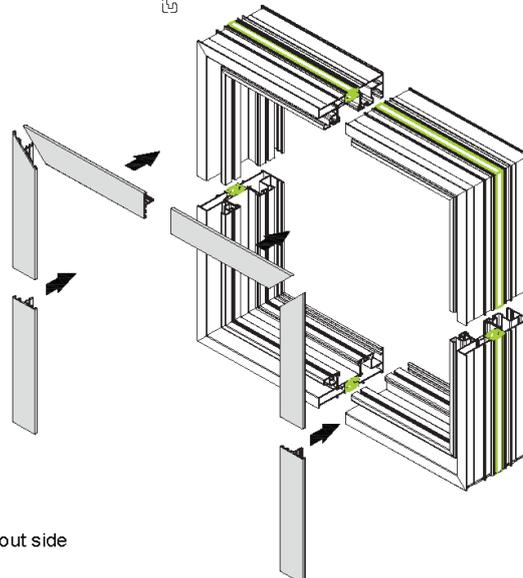
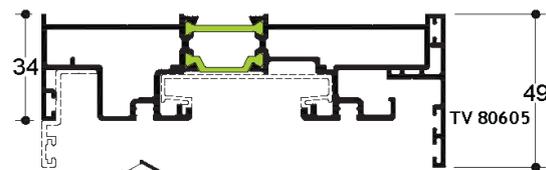
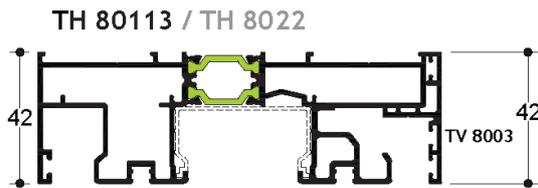


Use of Dumping Stoppers Depending on Type of the Construction



For double joint sash systems, on the sash with adjoining profile, use DS-002020 without the addition.

Right Use of TV 8003 & TV 80605



The profiles TV 8003 & TV 80605 are placed on the out side of Successive Rail, as in the drawing.

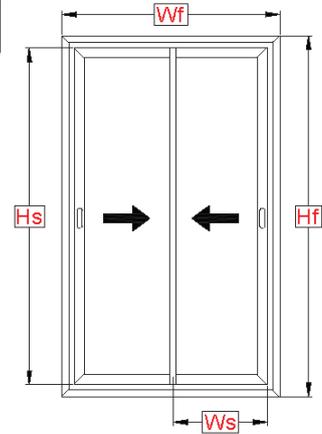
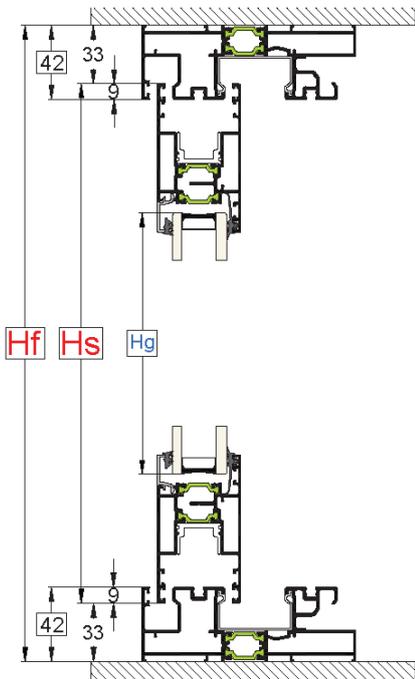


04

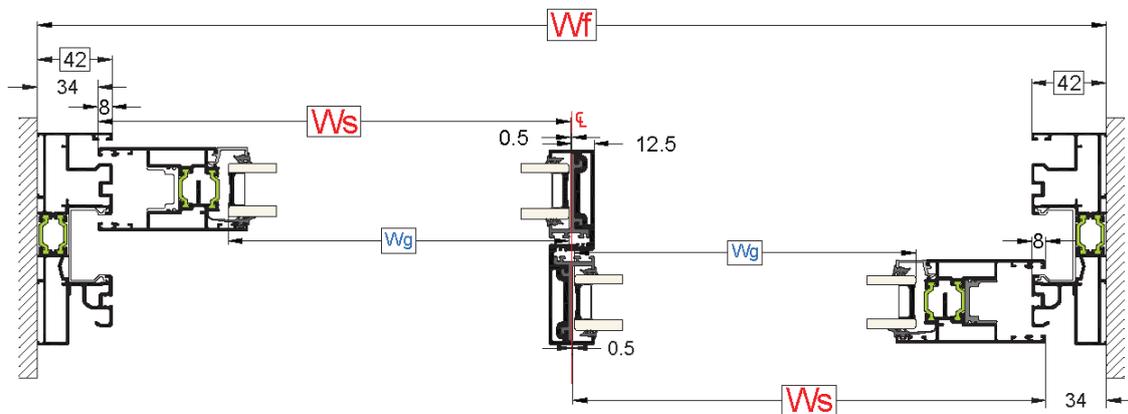
Cutting Instructions

Double Sash Successive System | Rail 42mm Height | Interlock 25mm Sliding or Lift & Slide

The cutting standards are calculated in order to give as the SAME dimension of glazing for every sash



- Hf = Rail height
- Wf = Rail width
- Hs = Sash height
- Ws = Sash width
- Hg = Glass height
- Wg = Glass width

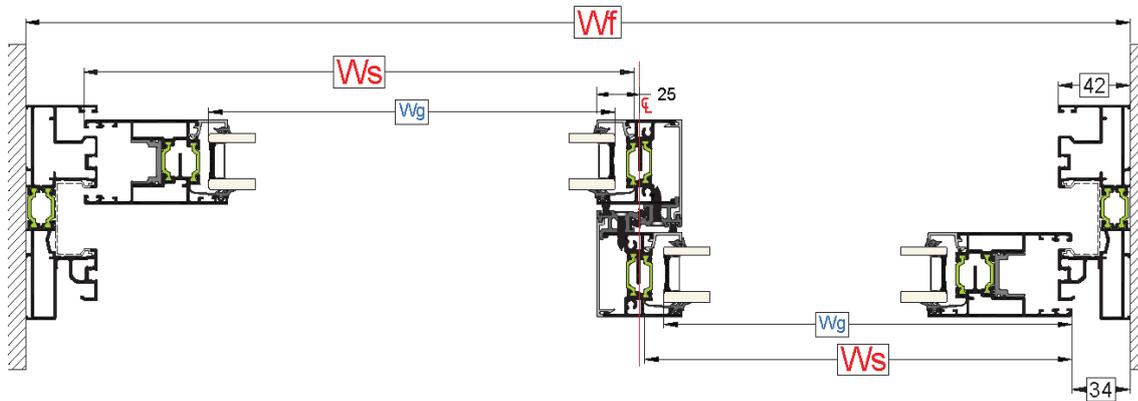
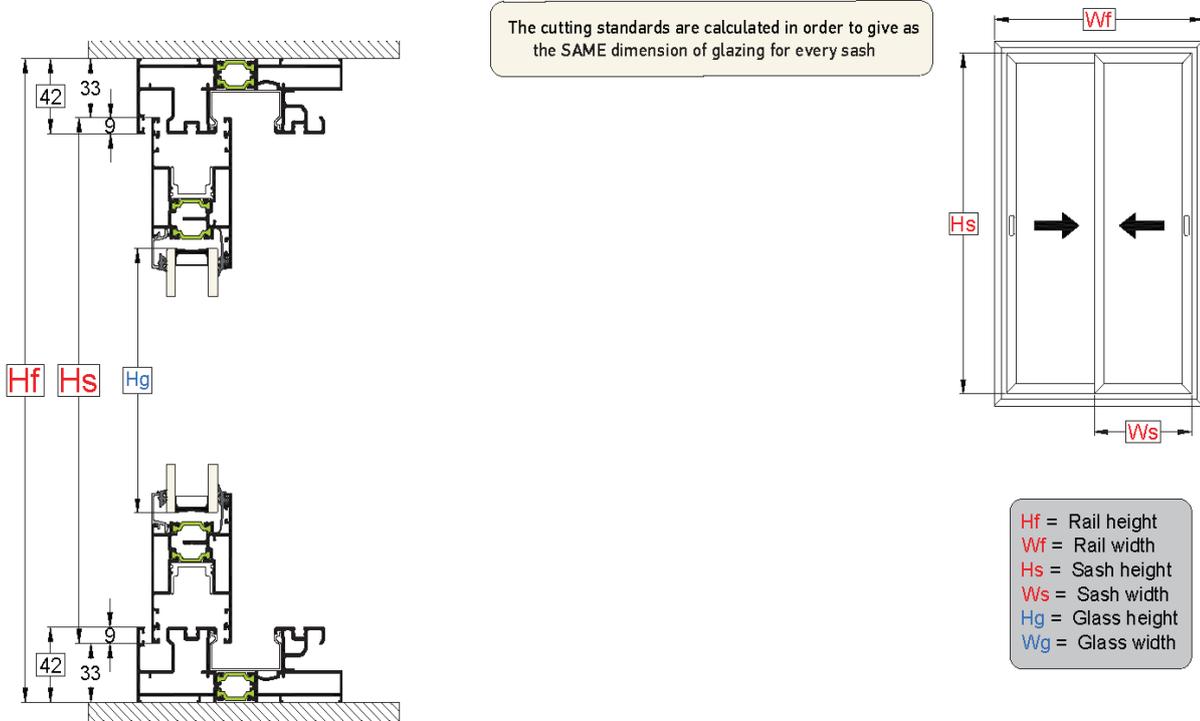


	Sash width (Ws)	Profiles	Cutting Type	Sash height (Hs)	Profiles	Cutting Type
Glass Sash	$W_s = \frac{W_f - 69\text{mm}}{2}$	TH 8040: 4 Pcs		$H_s = H_f - 66\text{mm}$	TH 8040: 2 Pcs	

	Glass width (Wg)	Glass height (Hg)	Interlock 25mm	Height (Hs)	Profiles	Cutting Type
Glazing	$W_g = W_s - 74\text{mm}$	$H_g = H_s - 146\text{mm}$		$H_f - 66\text{mm}$	TV 80402: Pcs	

NOTE:
The cutting standards are theoretic.
Calculations were based on ideal conditions and joining.

Double Sash Successive System | Rail 42mm Height | Interlock 50mm Sliding or Lift & Slide



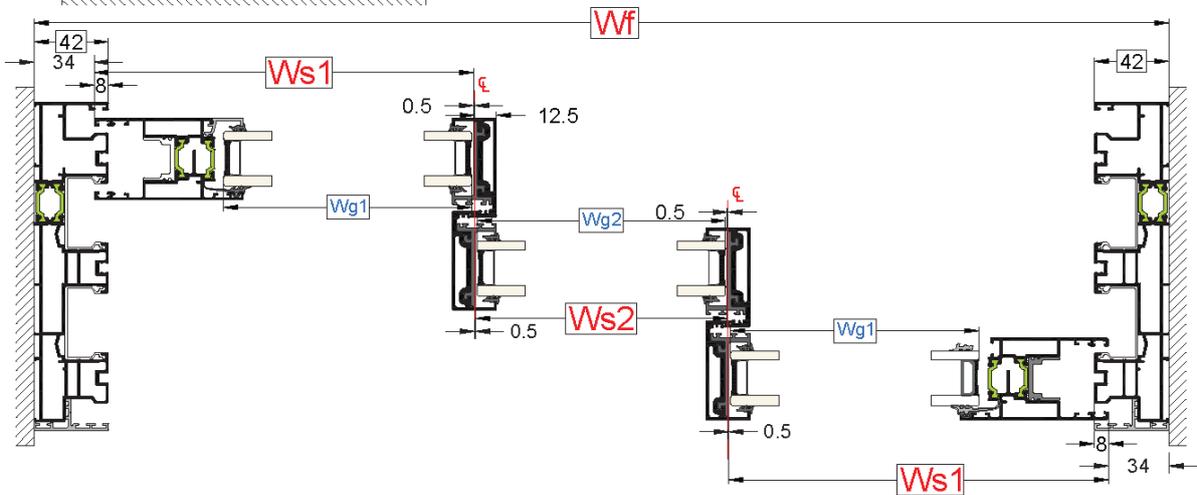
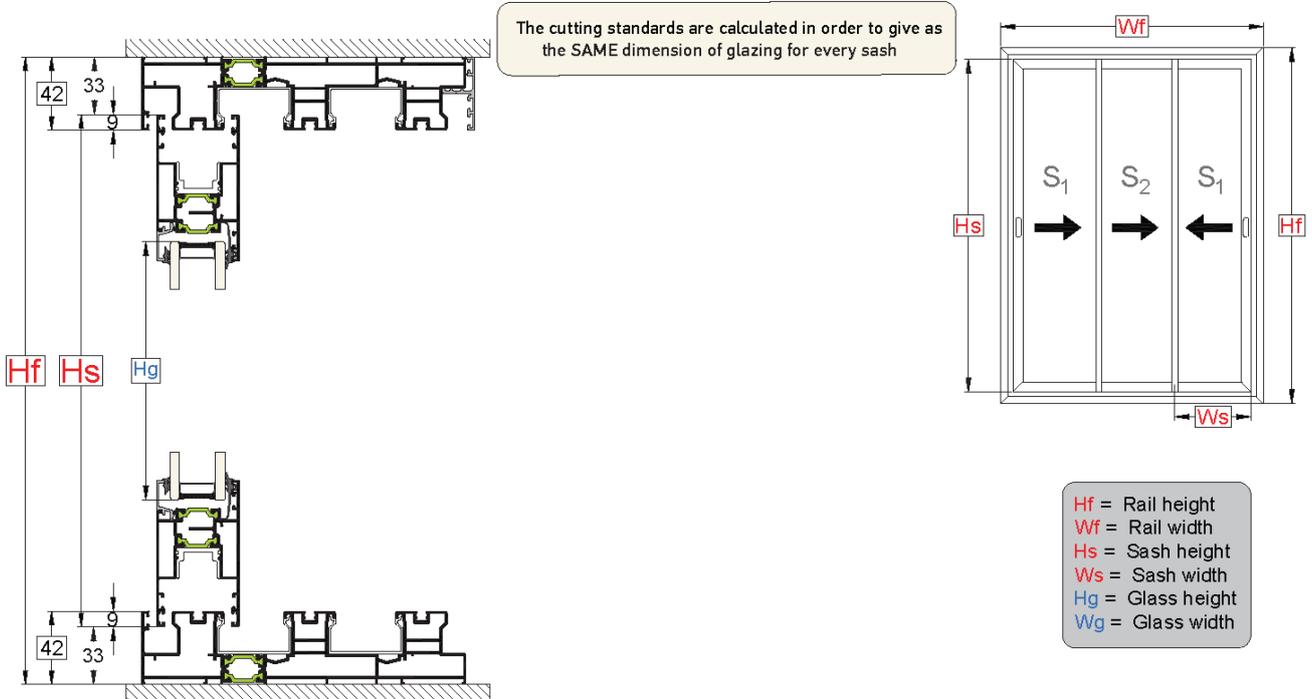
	Sash width (Ws)	Profiles	Cutting Type	Sash height (Hs)	Profiles	Cutting Type
Glass Sash	$Ws = \frac{Wf - 74mm}{2}$	TH 8040: 4 Pcs		Hs = Hf - 66mm	TH 8040: 2 Pcs	

	Height (Hs)	Profiles	Cutting Type
Interlock	Hf - 66mm	TH 80411 Pcs TV 80505: 2 Pcs	

	Glass width (Wg)	Glass height (Hg)
Glazing	$Wg = Ws - 84mm$	$Hg = Hs - 146mm$

NOTE:
The cutting standards are theoretic.
Calculations were based on ideal conditions and joining.

Triple Sash Successive System | Rail 42mm Height | Interlock 25mm | Sliding



	Sash width (Ws)	Profiles	Cutting Type
Glass Sash	$Ws1 = \frac{Wf + 2mm}{3}$	TH 8040: 4 Pcs	
	$Ws2 = \frac{Wf - 214mm}{3}$	TH 8040: 2 Pcs	

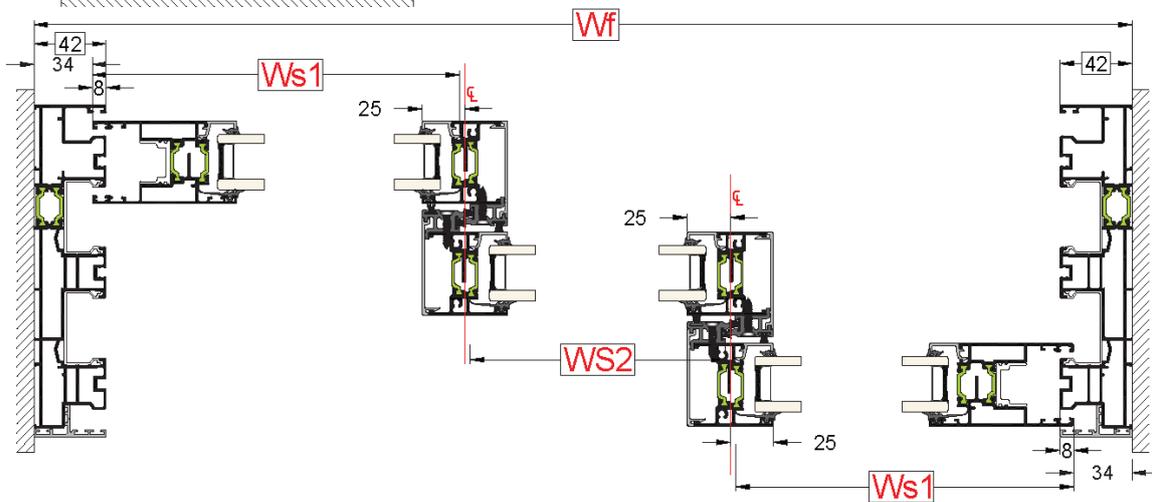
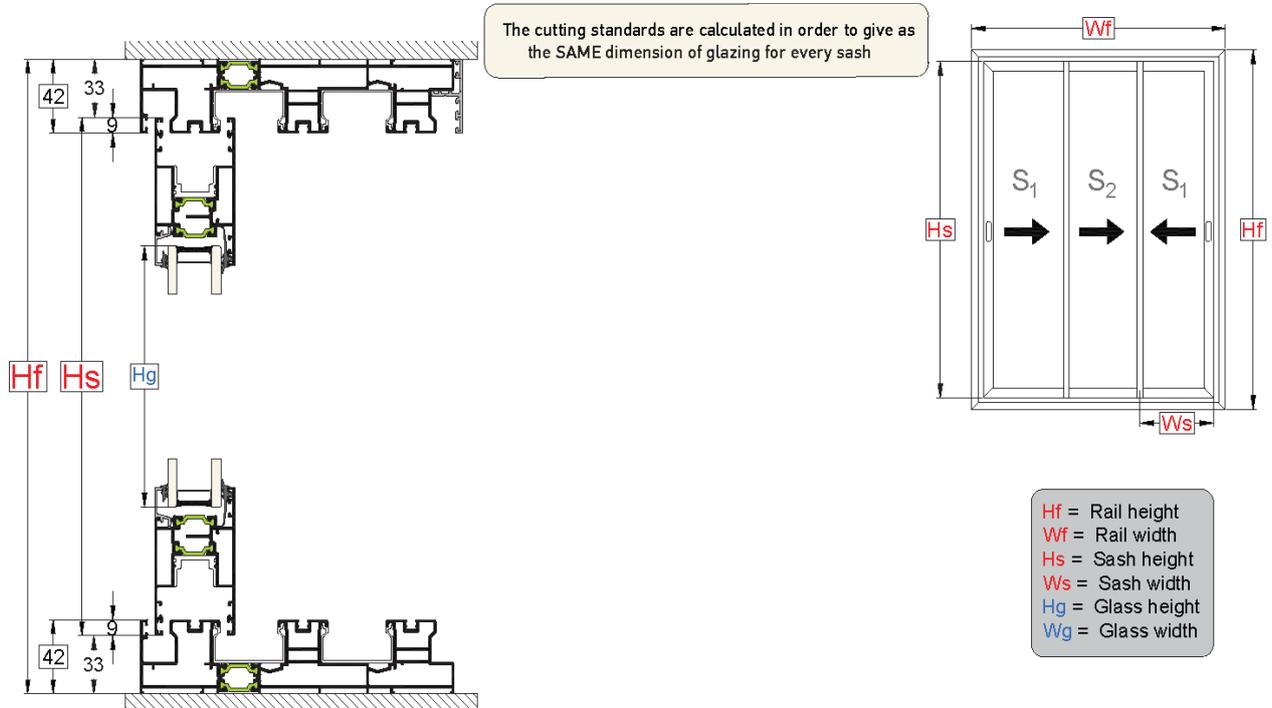
Sash height (Hs)	Profiles	Cutting Type
$Hs = Hf - 66mm$	TH 8040: 2 Pcs	

	Glass width (Wg)	Glass height (Hg)
Glazing	$Wg1 = Ws1 - 74mm$ $Wg2 = Ws2 - 2mm$	$Hg = Hs - 146mm$

Interlock 25mm	Height (Hs)	Profiles	Cutting Type
	$Hf - 66mm$	TV 80402: 4 Pcs	

NOTE:
The cutting standards are theoretic.
Calculations were based on ideal conditions and joining.

Triple Sash Successive System | Rail 42mm Height | Interlock 50mm | Sliding



	Sash width (Ws)	Profiles	Cutting Type
Glass Sash	$Ws1 = \frac{Wf - 19mm}{3}$	TH 8040: 4 Pcs	
	$Ws2 = \frac{Wf - 205mm}{3}$	TH 8040: 2 Pcs	

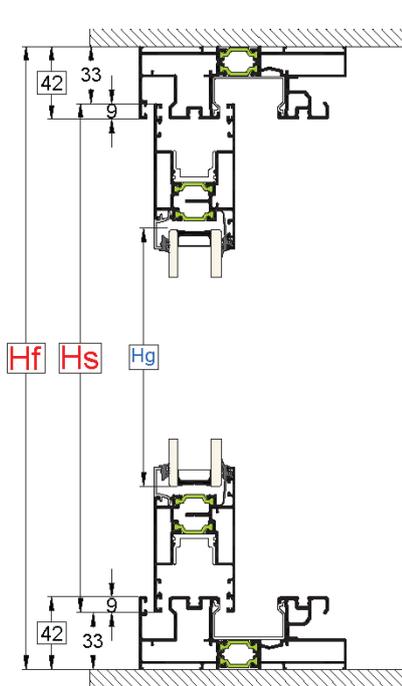
Sash height (Hs)	Profiles	Cutting Type
$Hs = Hf - 66mm$	TH 8040: 2 Pcs	

	Glass width (Wg)	Glass height (Hg)
Glazing	$Wg1 = Ws1 - 84mm$ $Wg2 = Ws2 - 22mm$	$Hg = Hs - 146mm$

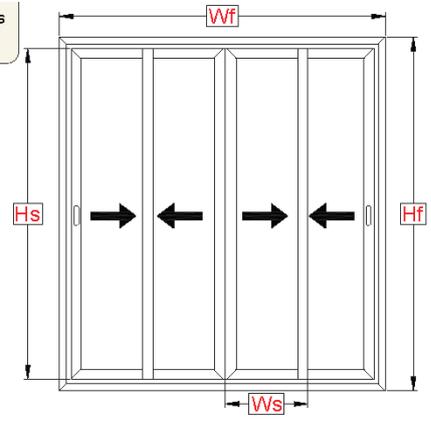
	Height (Hs)	Profiles	Cutting Type
Interlock 50mm	$Hf - 66mm$	TH 80411 4 Pcs TV 80505: 4 Pcs	

NOTE:
The cutting standards are theoretic.
Calculations were based on ideal conditions and joining.

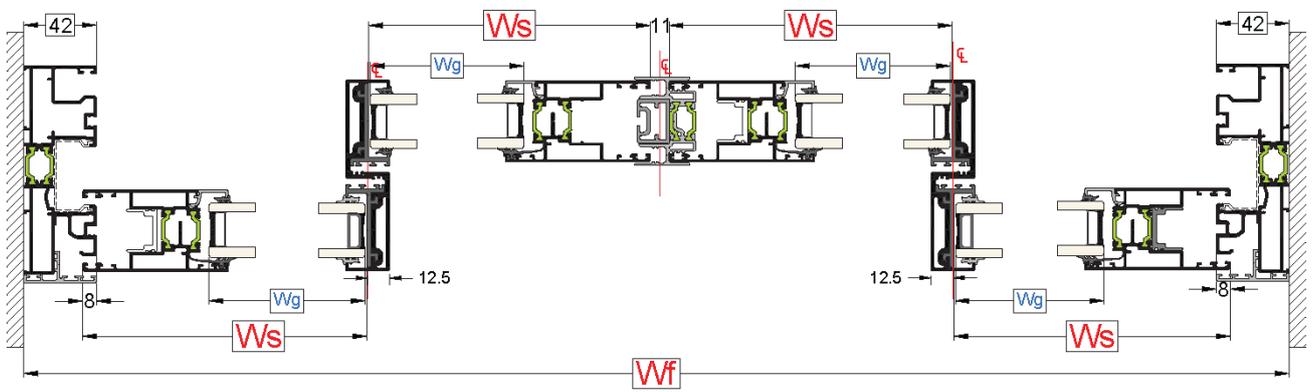
Quadruple Sash Successive Double Joint Sash System | Rail 42mm Height Sliding or Lift & Slide



The cutting standards are calculated in order to give as the SAME dimension of glazing for every sash



- Hf = Rail height
- Wf = Rail width
- Hs = Sash height
- Ws = Sash width
- Hg = Glass height
- Wg = Glass width



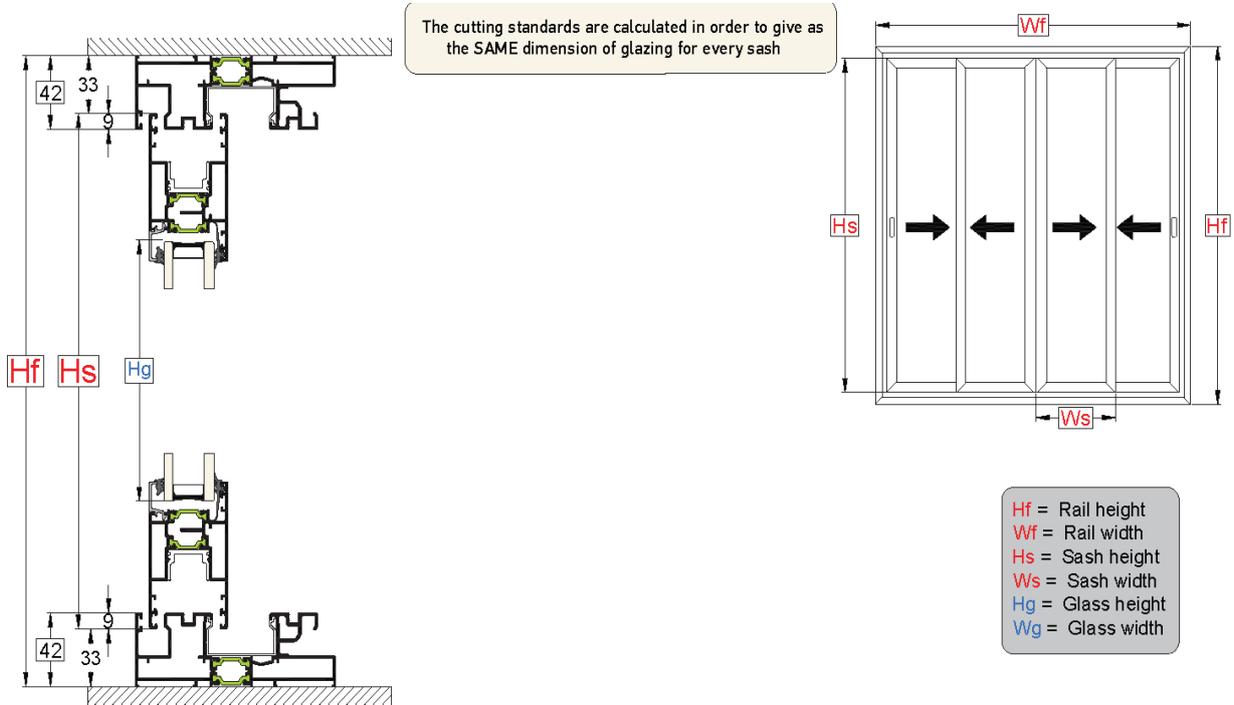
	Sash width (Ws)	Profiles	Cutting Type	Sash height (Hs)	Profiles	Cutting Type
Glass Sash	$Ws = \frac{Wf - 81mm}{4}$	TH 8040: 8 Pcs		Hs = Hf - 66mm	TH 8040: 4 Pcs	

	Glass width (Wg)	Glass height (Hg)	Interlock 25mm	Height (Hs)	Profiles	Cutting Type
Glazing	$Wg = Ws - 74mm$	$Hg = Hs - 146mm$	Interlock 25mm	Hf - 66mm	TV 80402: 4 Pcs	
			Adjoining Profile	Hs - 54mm	TH 8045: 1 Pc	

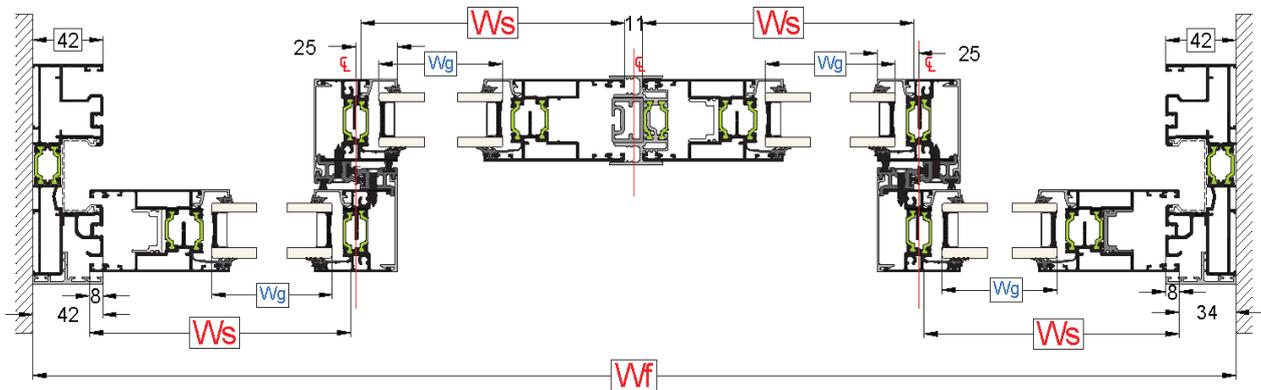
Adjoining with caps

NOTE:
The cutting standards are theoretic.
Calculations were based on ideal conditions and joining.

Quadruple Sash Successive Double Joint Sash System | Rail 42mm Height | Sliding or Lift & Slide



- Hf = Rail height
- Wf = Rail width
- Hs = Sash height
- Ws = Sash width
- Hg = Glass height
- Wg = Glass width



	Sash width (Ws)	Profiles	Cutting Type	Sash height (Hs)	Profiles	Cutting Type
Glass Sash	$W_s = \frac{W_f - 92\text{mm}}{4}$	TH 8040: 8 Pcs		$H_s = H_f - 66\text{mm}$	TH 8040: 4 Pcs	

	Height (Hs)	Profiles	Cutting Type
Interlock 50mm	Hf - 66mm	TH 80411: 4 Pcs TV 80505: 4 Pcs	
Adjoining Profile	Hs - 54mm	TH 8045: 4 Pcs	
Adjoining with caps			

	Glass width (Wg)	Glass height (Hg)
Glazing	$W_g = W_s - 84\text{mm}$	$H_g = H_s - 146\text{mm}$

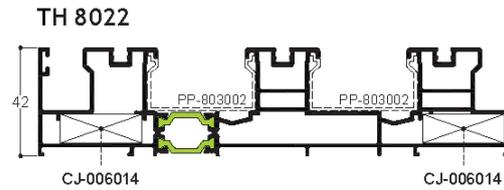
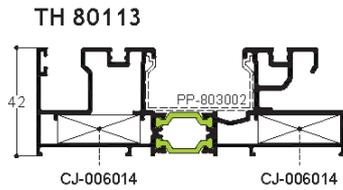
NOTE:
The cutting standards are theoretic.
Calculations were based on ideal conditions and joining.



05

Accessories

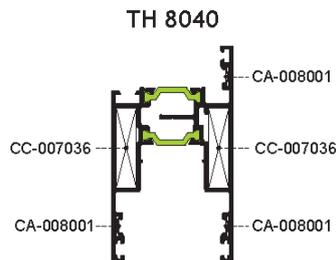
Quadruple Sash Successive Double Joint Sash System | Rail 42mm Height | Sliding or Lift & Slide



TV 80605

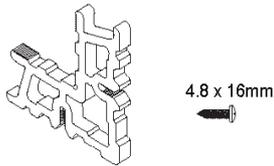


Corner Joints and Alignment Corner for Sashes



CC-007036 (PS-10)

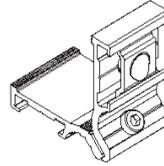
Dimensions
30.9 x 7.6 mm



Corner Joint for TH 8040

CJ-006014 (PS-11)

Dimensions
31.7 x 10 mm



Corner Joint for Rails

CA-008001 (1951)

Dimensions
1.2 x 7.6 mm



Alignment Corner for glass Sash and Shutter Sash

PP-803004 (PS-4)

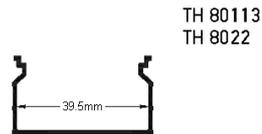
Συσκευασία - Package
6-meter



Plastic Adapter for Glass Sash

PP-803002 (PS-2)

Συσκευασία - Package
6-meter



Plastic Cover for Rails

PP-80303

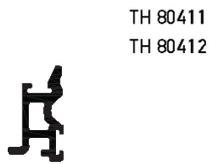
Συσκευασία - Package
6-meter



Plastic Spacer

PP-80306

Package
6 meter



Plastic Spacer for Interlock 50mm

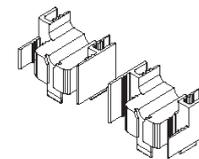
PP-003007 (ML-9)

Package
5 meter



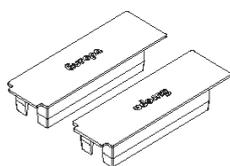
Plastic Addition for TH 8045 Profile

PS-80203



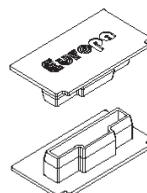
Plastic Cap for Glass Adjoining TH 8045

PG-12617



Plastic Cap for Reinforcement Profile TV 12603

PG-12220



Plastic Cap for Reinforcement Profile TV 12621

PG-12317



Plastic Cap for Reinforcement Profile TV 00627

PG-80210

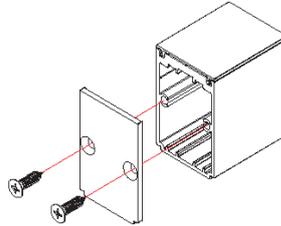


Plastic cap for Interlock Profiles & Adjoining Profile of 65mm

PA-00702

Aluminium

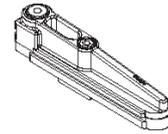
Painted same color as window profiles



Cover for Reinforcement Profile TV-00628

PS-002020

(PS-18)



Damping Stopper for Glass Sash

ST-002002 (2002 086)

Color
01/02



Stopper for Successive Sashes

UN-001007 (R.10085)



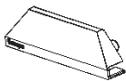
Inox Lamina for Rail

UN-11301



Non-Return Valve

PG-009034 (KL-12)



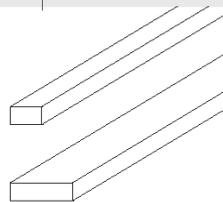
Plastic Plug for Water Drainage Europa

PP-003004
(FL-31)

Dimensions
14mm x 8mm x 2 m

PP-003005
(FL-32)

Dimensions
30mm x 8mm x 2 m

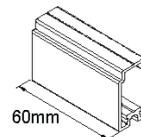


Plastic Spacer For Rails

UN-007046

(PS-9)

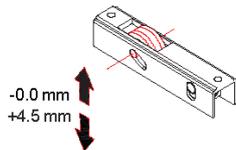
Dimensions



Aluminium Component for Fixed Sash

RO-009036

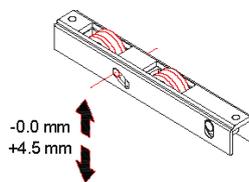
TH 8040



Single Roller for Glass Sash

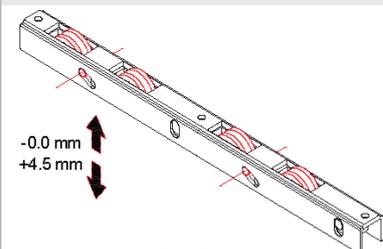
RO-009035

TH 8040



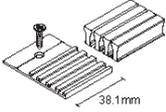
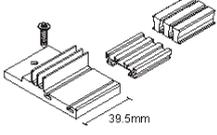
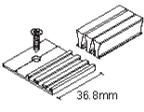
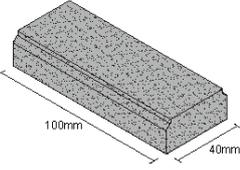
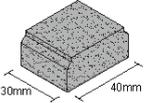
Double Roller for Glass Sash

RO-80701



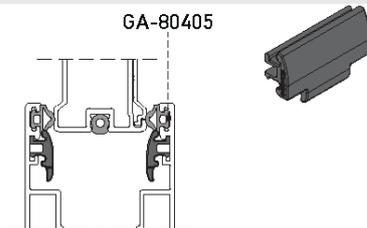
Quadrable Roller for Glass Sash

Sealing Plugs for Rails with 42mm Height

SR-009039 (PS-6)	SR-009040	SR-12717	With 25mm Interlock	
				
			Simple Sliding	Lift & Slide
			Upper	SR-009040 [x1] SR-12717 [x1]
			Lower	SR-009040 [x1] IC-80407 [x1]
			With 50mm Interlock	
			Simple Sliding	Lift & Slide
			Upper	SR-009040 [x1] SR-009039 [x1]
			Lower	SR-009040 [x1] IC-80408 [x1]
IC-80408	IC-80407			
				

UN-80204

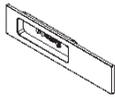
Glass sash Spacer (Use on the top horizontal side of the sash)



For Lift & Slide Glass Sash on 42mm rails

FG-00920

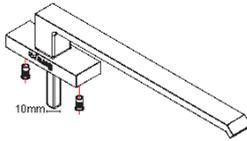
Color
01 | 02 | 07 | 10



External Finger Grip

HA-12730 EUROPA L. PENTHESILEA
27.5cm

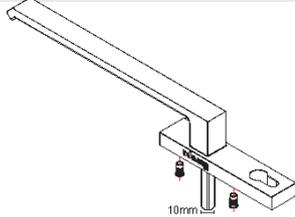
Color
01 | 02 | 07 | 10



Lever Handle for Lift & Slide Sashes

HA-00958 EUROPA L. PENTHESILEA
27.5cm

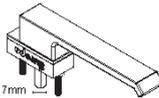
Color
01 | 02 | 07 | 10



Lever Handle for Lift & Slide Sashes with Cylinder

HA-00959 EUROPA PENTHESILEA
17cm

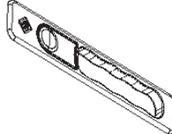
Color
01 | 02 | 07 | 10



Lever Handle for Sliding Sashes

HA-12735 MASTER

Color
01 | 02 | 06



External Master Pulling Handle

SP-001009 (59-616431)



Inox Nest for Locking Mechanism
IN LINE ROTO

ML-009014 (184797)

Single



HAUTAU Locking Bold

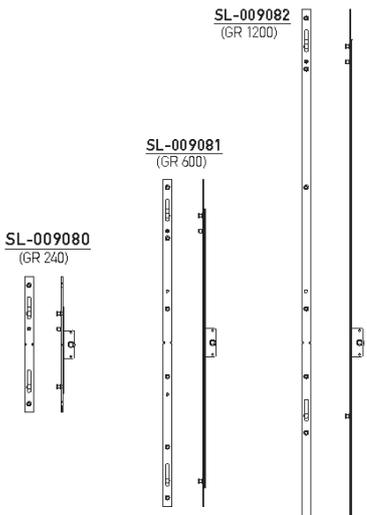
ML-009013 (184737)

Double



HAUTAU Locking Bold

IN LINE ROTO Locking Mechanism



SL-009082
(GR 1200)

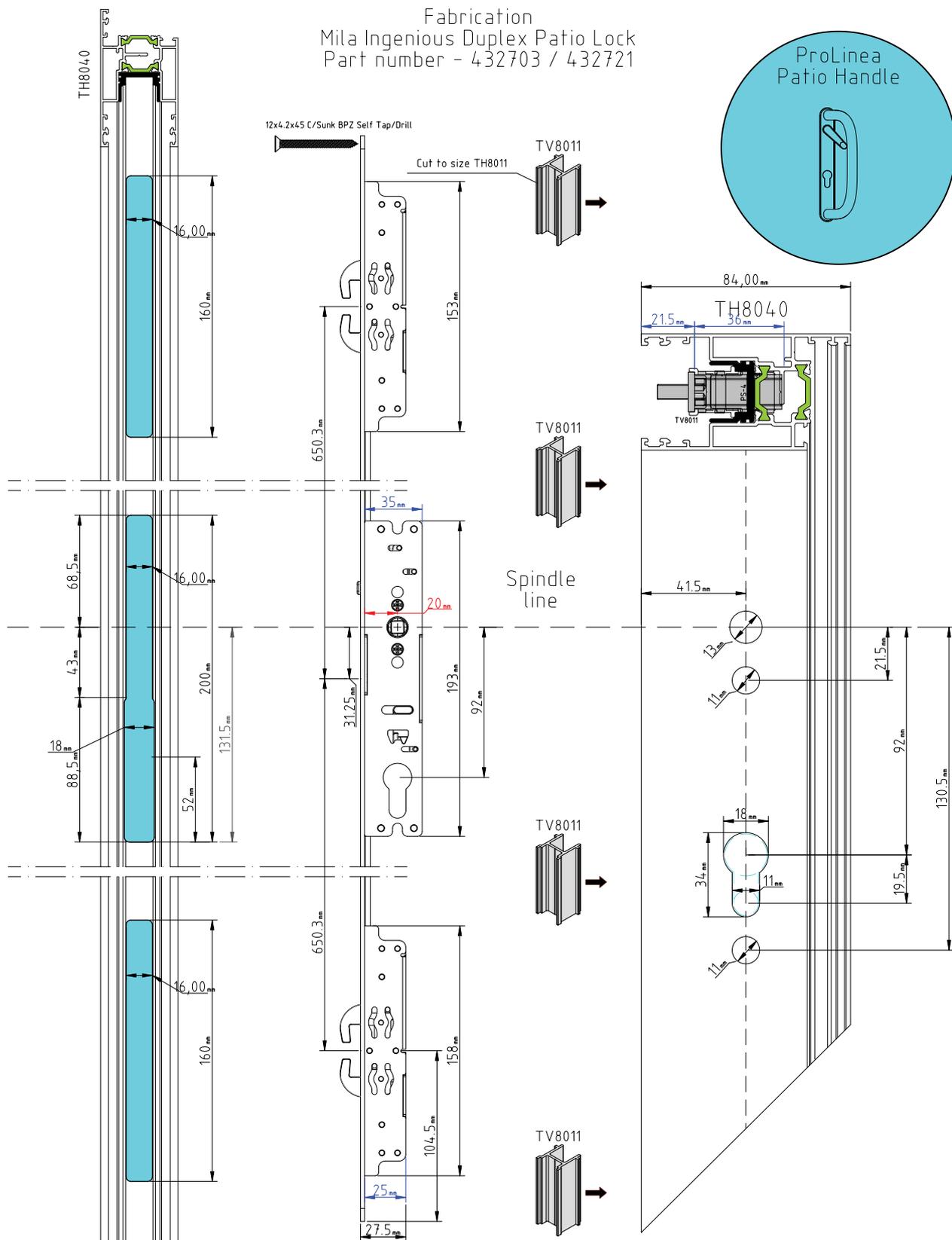
SL-009081
(GR 600)

SL-009080
(GR 240)

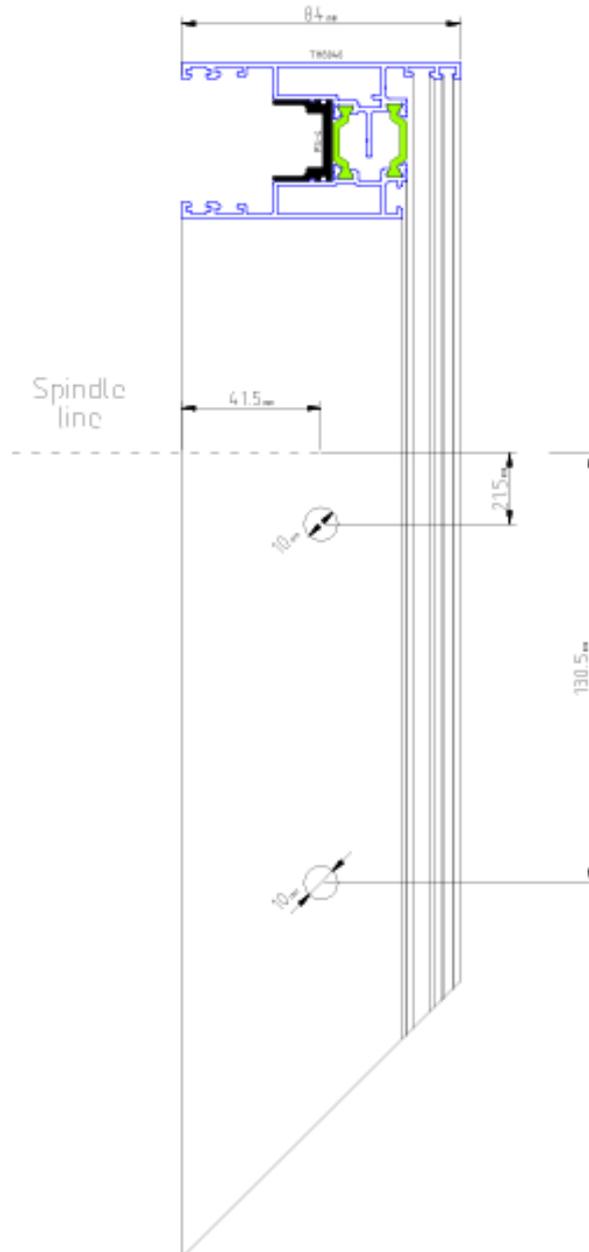
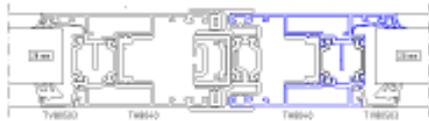
SL-009080: 240mm 2 locking points 2 screws (GR 240)
SL-009081: 580mm 2 locking points 6 screws (GR 600)
SL-009082: 1180mm 3 locking points 9 screws (GR 1200)

00=Unpainted, 01=White, 02=Black, 03=Silver, 04=Brown, 05=Bronze, 06=Grey,
07=Anodized, 08=Nickel, 10=Black Anodized, 11=Chrome, 12=Nickel mat, 13=Chrome mat

Fabrication
Mila Ingenious Duplex Patio Lock
Part number - 432703 / 432721

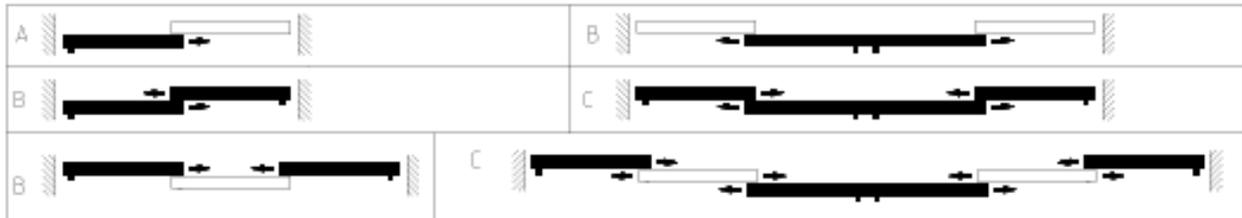


Fabrication for Meeting / Double Joint
Slave door handle details
Mila Ingenious Duplex Patio Lock
Part number - 432703 / 432721

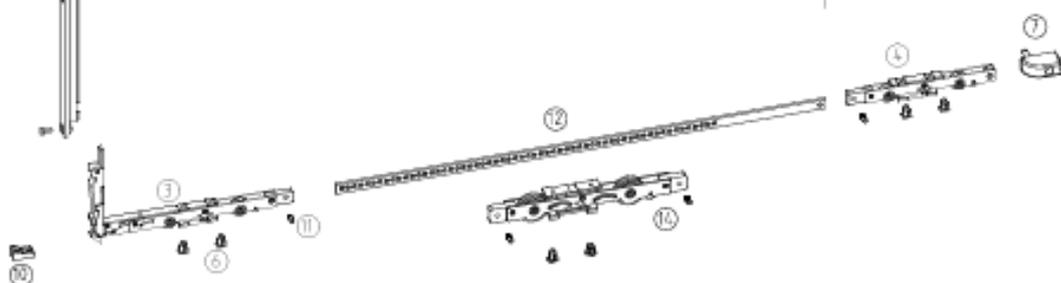
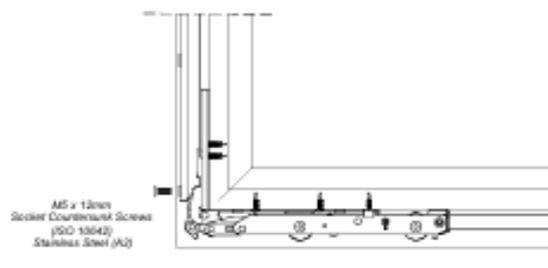


Mila Alu-HS 250 Hardware

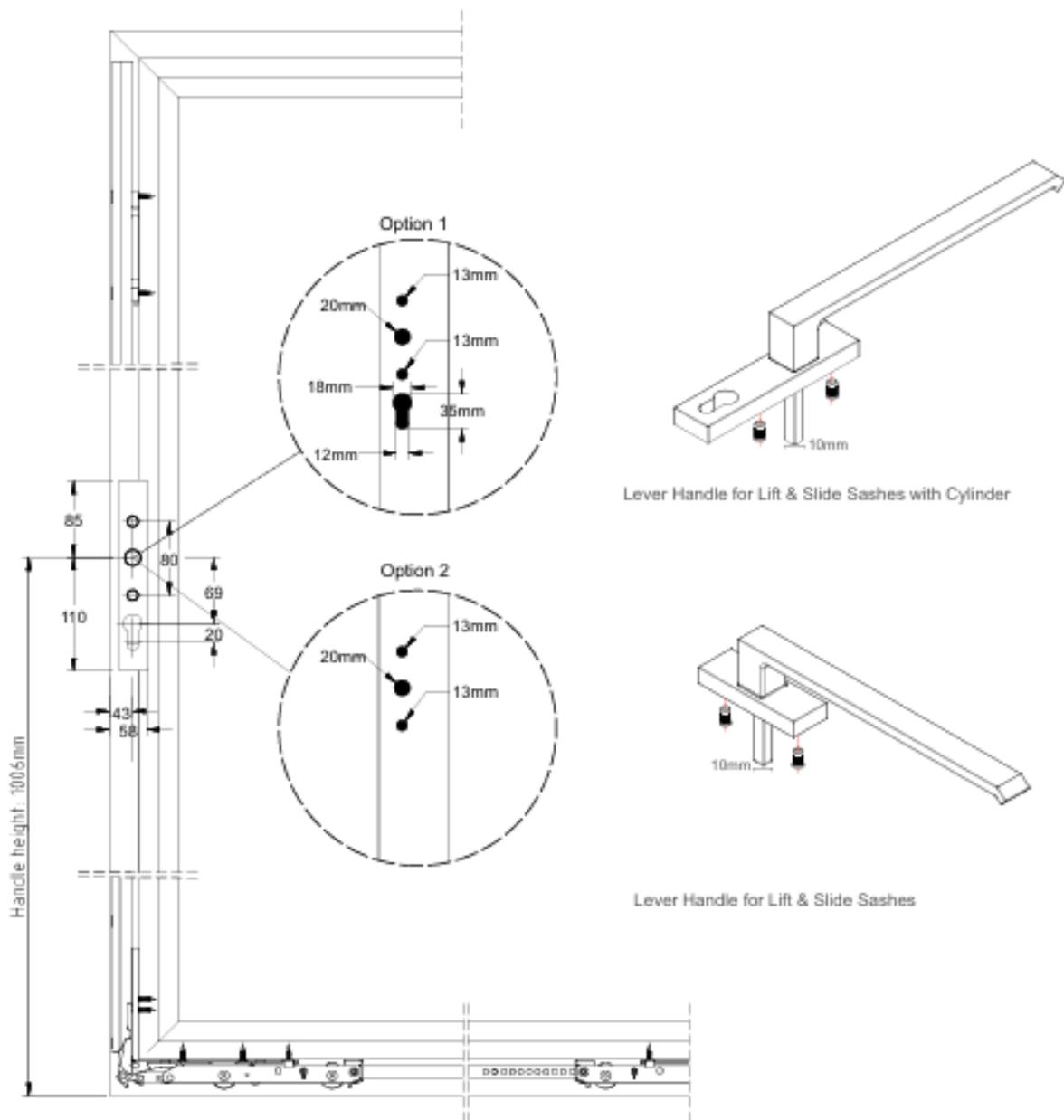
Patio Schemes



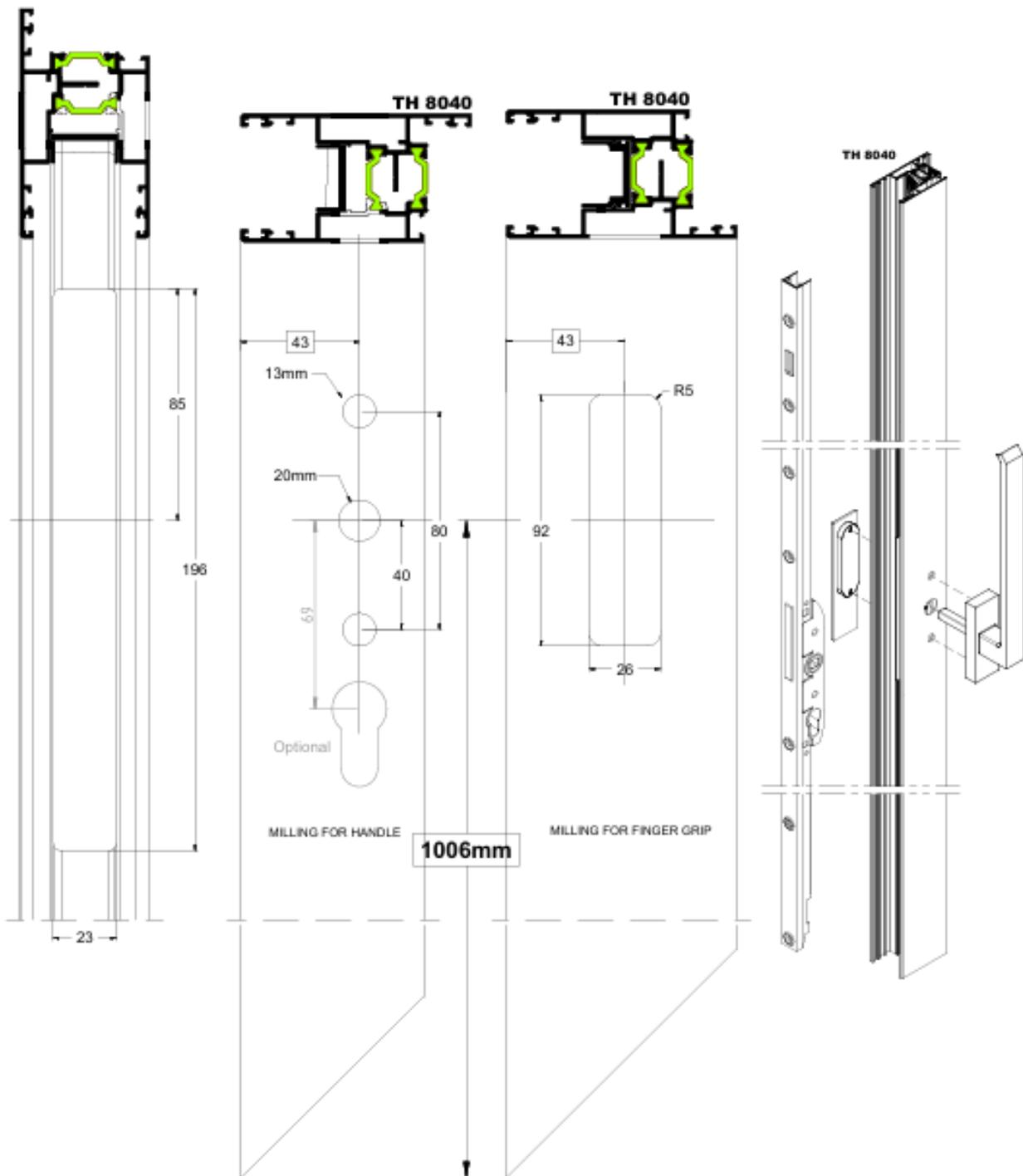
Items Required			Description	Code
A	B	C		
1	2	4	Accessories carton JTSM06 (3,4,5,6,7,10,11,13 and 18 screw pack)	105109
1	2	4	Internal Patio Handle Non-Locking Internal Patio Handle with Cyl.Hole Internal & External Patio Handle No Cylinder Int & External Patio Handle with Cylinder Int. Patio Handle No cylinder w/ Ext.Finger Pull	105000 105020 105040 105080 105080
1	2	4	Drive Gear (2,12)	Size 2000mm 105100 2500mm 105101 3000mm 105102
1	2	4	Connecting bar (12) supplied with drive gear	Size 850mm 105409 1260mm 105413
1	2	4	Additional Locking Point, Pair (5)	105440
OPTIONAL			Middle roller (14) Sash width 2000mm+ or sash weight 200-250kg it is recommended to add a middle roller	105420



Lift and Slide Mila Alu-HS 250 L&S Lock



Mila Alu-HS 250 Hardware





GA-004007 (FL-01)



Cover Gasket for Rails

GA-004005 (BL-05)



(E.P.D.M.) Glazing Gasket

GA-12407 to GA-12412



GA-12407 2mm
GA-12408 3mm
GA-12409 4mm
GA-12410 5mm
GA-12411 6mm
GA-12412 7mm

Glass Weatherstrips (E.P.D.M.): 2-7mm

GA-004016 (PS-35)

For every side of the sash except the top side



Gasket for Lift & Slide Glass Sash

GA-80405

For Glass Sashes on 34 & 42mm rails



For the top horizontal side of lift & slide Sash

GA-12904



Gasket for Interlock Profiles

GA-004006 (ENS-7)



Gasket for Profile TH 8045

6mm - 4P to 8mm - 4P



BR-009044: 6mm
BR-009045: 7mm
BR-009046: 8mm

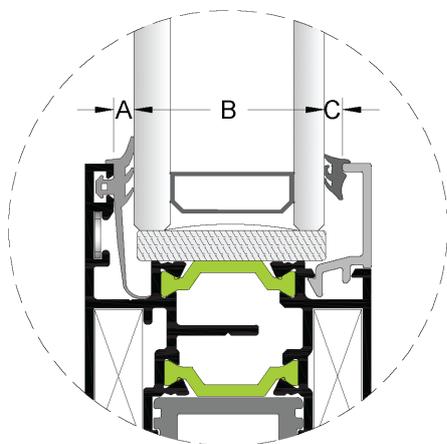
Brush

Note:

The table shows the theoretically width for the glasses that can use. There can be many combinations for the total thickness of the glass. Also you can use 2 clips together in order to have the maximum thickness of glass. By the customers requirements, there are glasses at the market that offers very good thermal insulation and sound reduction.

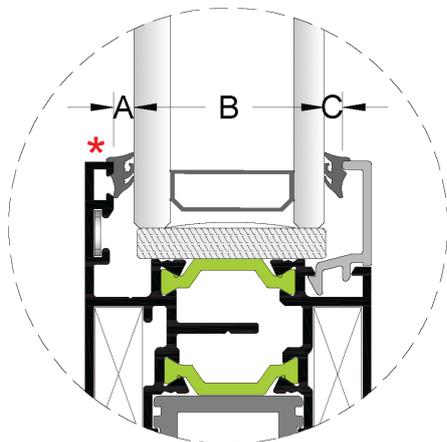
Attention:

For the sealant of the glasses either inside or outside from the frame, **use of silicone is not recommended.**

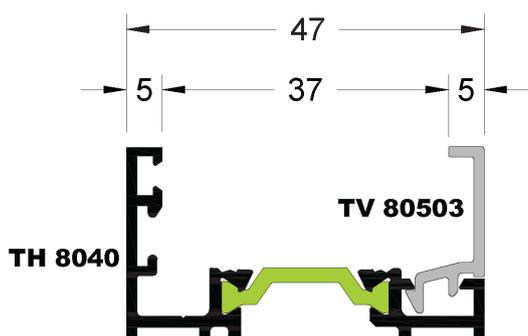


TOTAL SPACE (mm)	OUTSIDE		GLASS		INSIDE	
	CODE	A (mm)	B (mm)	C (mm)	CODE	
37	GA-12408	3	30*	4	GA-12409	
37	GA-004005	3	29	5	GA-12410	
37	GA-004005	3	28	6	GA-12411	
37	GA-004005	3	27	7	GA-12412	
37	GA-004005	3	26	8	GA-004024	
37	GA-004005	3	24	10	GA-004028	

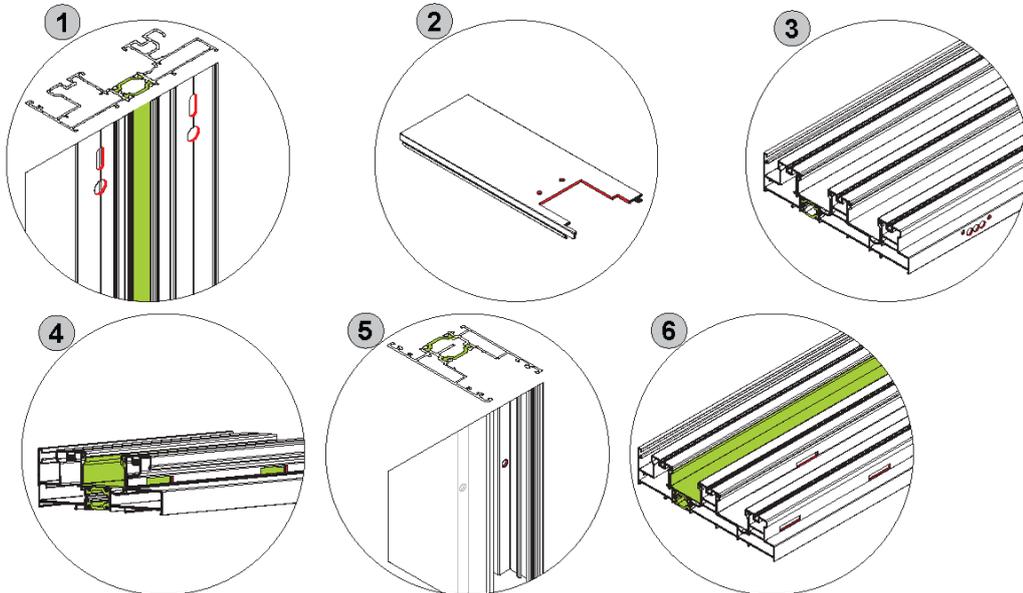
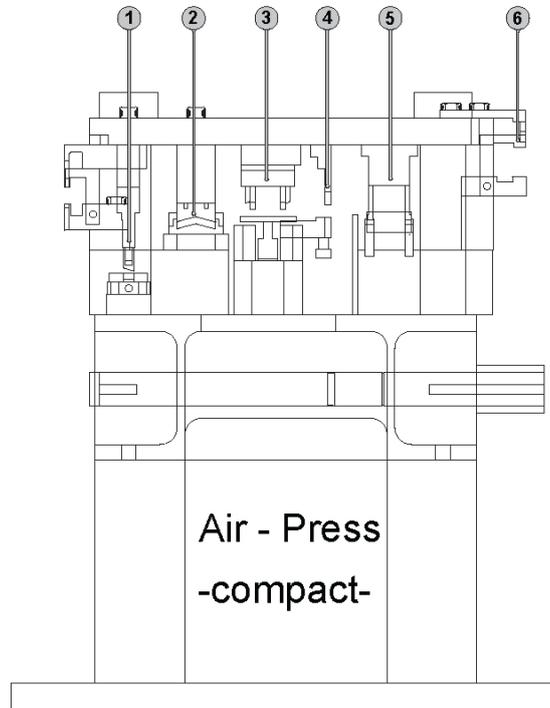
* Glass Weatherstrips GA-12408 (3mm) & GA-12409 (4mm) are recommended for Glass 30mm. Numbers are not absolute



Wedges positioning on the glass Sash



Punching machine steps

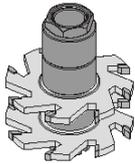


1. Punching tool for rail and sash corner joints CJ-006014 (TH 80113, TH8022)
2. Punching tool for Interlock TV 8006, TV 80505
3. Punching tool for Water Drainage (TH 80113, TH 80110, TH 80111, TH 8022, TH 80112)
4. Punching tool for rail's weep hole TH 80113
5. Punching tool for TH 8040
6. Punching tool for rail's weep hole TH 8022.



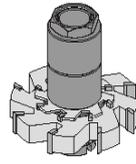
For the correct and safe use of punching machine we care to lubricate the cutting tools often.
Recommended that the pressure be above 6 bar

MC 80207



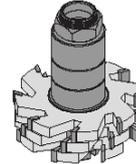
Glass Sash Milling for 25mm Interlock

MC 80405



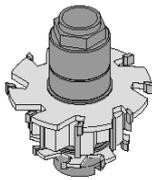
Milling for 25mm & 50mm Interlock

PS-15



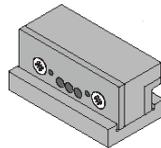
Milling for TH 8045 profile

MC 80906



Glass Sash Milling for 50mm Interlock TH 80411

DP-00133



Drilling Guide for Water Drainage

For the above milling disk tools contact the accessories department.

Instructions for the Casement's Constructions

-The aluminum-constructor should always know the profile gamut and their abilities.

-He has to provide solutions and give the right construction details/requirements in every project.

-To select the appropriate profile sections that meet the requirements of the project, based on the strength diagrams found in the technical catalogs.

-He also has to construct and put the right subframe based on the type of casement.

-He has to cut and mill the profile the right way and of course treat all these points of joint with anticorrosive materials, providing protection from corrosion.

-Place sealants on the profile flanges during assembly to create a seal and direct water to the exterior of the frame through the weep holes.

-Always calculate a gap of 5mm (minimum) on each side between the subframe and the frame, for easy installation and alignment of the frame and at the same time for better insulation with the addition of the sealing material inside the gap.

-During placement, put silicone at the bottom side between the subframe and the marble, in order to avoid water leaks.

-Construct all the necessary water weep holes, according to the position of casement. Create openings in order to flow out the sediments from the bottom side of every shutter sash, providing protection from corrosion.

-Use only the correct accessories, as published in the catalogues and use the appropriate welding adhesive depending on the material (epdm rubber, pvc plastic, etc.) for their joint, or welding with the profile to ensure waterproofing of the structure.

-To properly support the glass panes of the configuration for its proper operation and to fasten the construction to the masonry with stainless steel or galvanized screws to prevent corrosion as stated in the technical catalogs.

-In thermal break systems, in cases of heat with intense sunlight, on painted dark shades, linear expansion may appear on the outer side of the sash for the duration of the natural phenomenon.

To deal with the above natural phenomenon, it is recommended to place reinforcing profiles (on the inside), at the heights of the sashes where the arc appears. Moreover, for further improvement of the phenomenon, the use of reinforced panel (for example sea plywood) or reinforced laminate glass pane on the internal part of the structure or/and security multipoint lock with conical hook bolts is suggested for opening systems. The use of reinforced laminate glass pane on the internal part of the structure is also suggested for sliding systems. The intensity of the phenomenon is restricted when there is enough shading or when the casement windows are painted in light-colored hues and it is changing according to the location of the structure.

-Never hesitate to ask for assistance from our technical advisors any time.

Instructions for the Casement's Constructions

-The regular cleaning of painted profile surfaces will keep them in satisfactory condition.

-Cleaning is considered necessary when dust and pollution are evident on the surface of the profile and should be done by using a soft sponge and a mixture of water and cleaning-product with a pH of 5.5-8, followed by washing with clean water.

-The cleaning products should not affect the surface or change its appearance, therefore hard sponge, sponge of wire, or diluters must be avoided. The frequency of cleaning depends on the location of the construction and the desired appearance.

-Especially in industrial and coastal areas, the frequency of cleaning should be proportional to the deposits of dirt or salts on the profile's surface, which are corrosive. We would like to point out that alkaline material, such as cement, lime, and gypsum should not stay adhered to the surface. Also not approved tapes should not be stuck directly on the painted surface.

-The protective film, which is put on when the profile leaves the production line, should be removed after casement installation, because its exposure to the sunlight could cause defects to the surface.

-Apart from cleaning the outer surface, in order to ensure the proper operation of the structure its required to clean the profile's internal elements, such as tires, brushes, mechanisms, etc.

-Especially the moving parts of the construction mechanisms should be lubricated at regular intervals for proper operation.

-Strict adherence to the instruction mentioned above, in combination with the use of a special glue directly to the points where the paint is scratched during the works, will keep the shiny appearance and strength of the profile, by avoiding as well, any possible problems of corrosion.

Electrostatic Paint

Look-Appearance

The covering of important surfaces must be examined under the correct visual angle from 2m distance (The QUALICOAT'S specifications rebates 3m distance). Various defects in the surface should not be visible from that distance.

Geometrical Characteristics

Dimensions

For a critical dimension of 50mm there is no tolerance of (+/-) 0.40mm, which means that the dimension varies from, 49.60 to 50.40mm.

Straightness

For a piece of metal 6m length the maximum swept allowed is 3mm. The check can be done by supporting the piece of metal on its two edges on a stable plane table, in a way that its variation will be restricted by its weight. Then, the maximum swept in the middle of the piece should not exceed 3mm.

Bending

For the medium dimensions profile the bending tolerance is 2mm at the edge of a 5-6 m long piece of metal. To check the bending, the piece of metal has to be put on a stable level table, one edge of the profile must be kept attached to the table's edge and the variation must be measured, from the table's level at the other end of the profile.

Weight of Profiles

The weight of profile is theoretical and it is based on profiles dimensions with tolerance according to EN12020-2. Also the stated weight of profiles does not include the weight of paint.



06

Static Diagrams

Maximum Dimensions & Maximum Weight

Sash maximum dimensions		
Max Sash width [m]	Max Sash height H [m]	Surface (m ²)
2.5	2.7 **	7.0

** For sashes exceeding 2.7m height, the construction has to be calculated considering all the technical needs of the project.

Maximum Weight for Simple System:

- 2 Single Rollers = 50Kg
- 2 Double Rollers = 100Kg
- 2 Quadruple Rollers = 180Kg

Maximum Weight for Lift and Slide System:

- 1 Set = 200Kg *

Maximum Glass Weight:

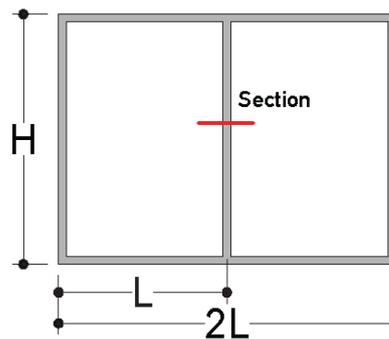
- 4 + 4 : 20 Kg/m²
- 4 + 5 : 22.5 Kg/m²
- 5 + 5 : 25 Kg/m²
- 6 + 5 : 27.5 Kg/m²
- 6 + 6 : 30 Kg/m²

*The ESS 47 allows constructions with a maximum weight per sash 300Kg. This limit should not be exceeded even if the rollers are able for more weight.

Example for Understanding the Diagram

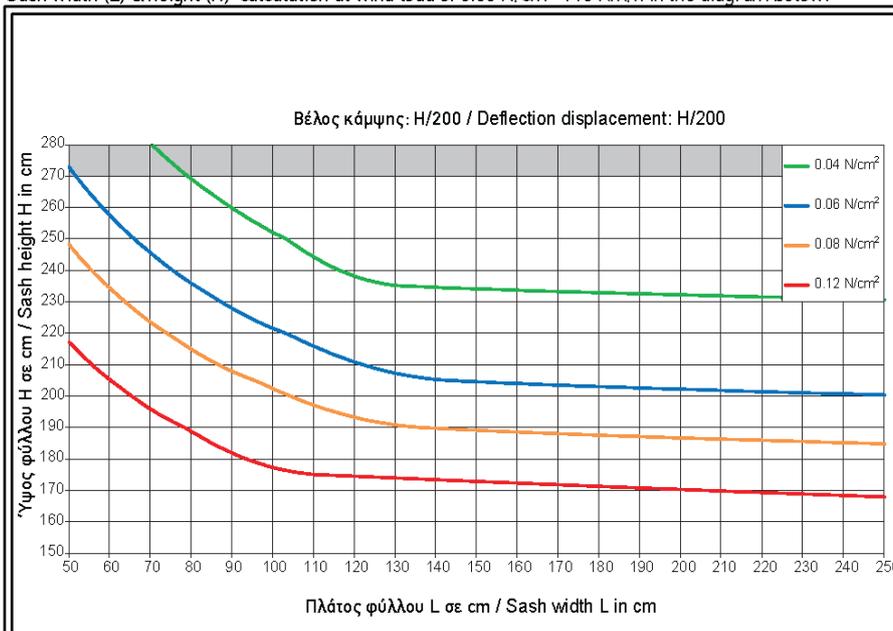
The diagrams show the maximum dimensions (width and sash height) in 4 different wind loads

1. 0.04N/cm² 92Km/h █
2. 0.06N/cm² 113Km/h █
3. 0.08N/cm² 130Km/h █
4. 0.12N/cm² 159Km/h █

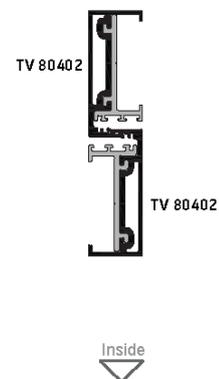


Sash width (L)= 130 cm.
Sash height (H)= 260 cm.
Construction dimensions 260 x 260cm.

Sash width (L) & height (H) calculation at wind load of 0.06 N/cm² 113 Km/h in the diagram below.



Interlock profiles 25mm with reinforcement



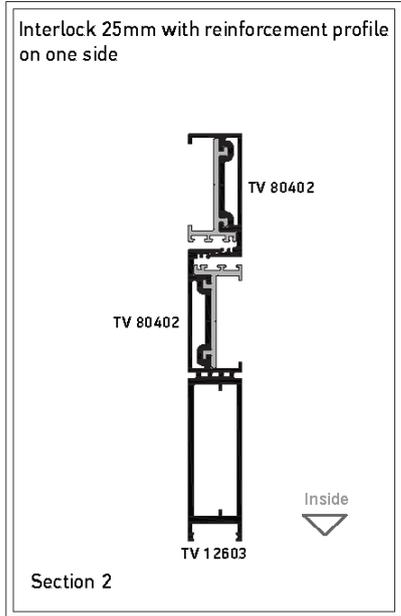
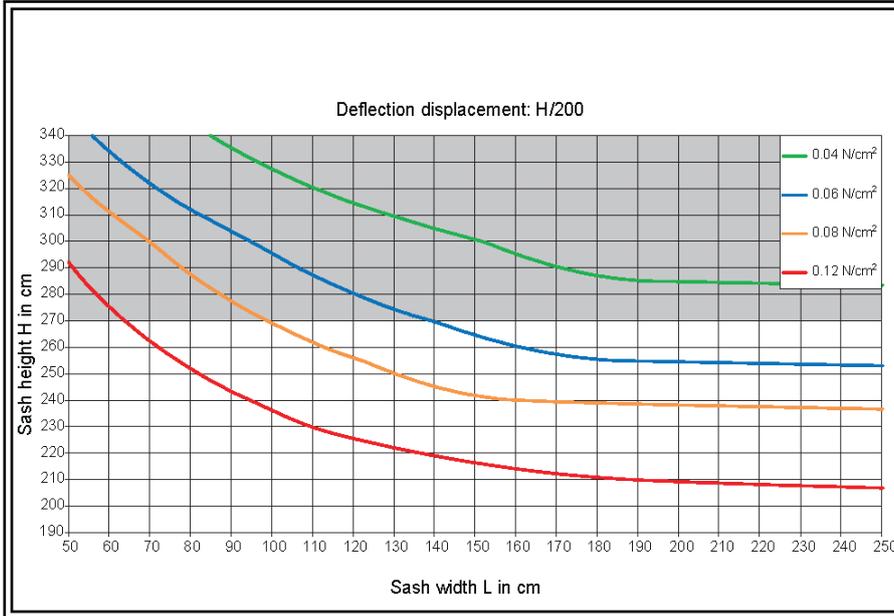
Section 1

Note:

The glazing is not included in the diagrams calculation. Glazing depending on the type and thickness it increases the maximum dimensions of the sash.



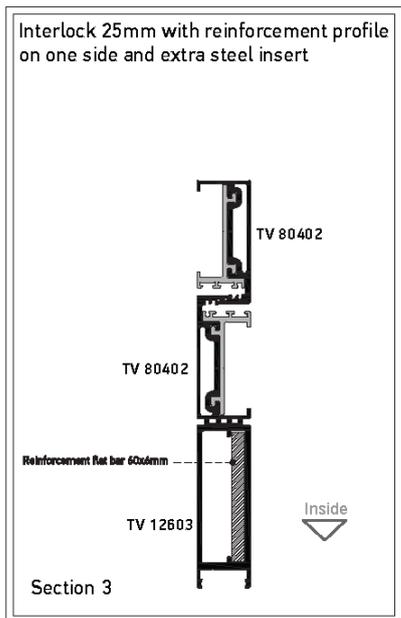
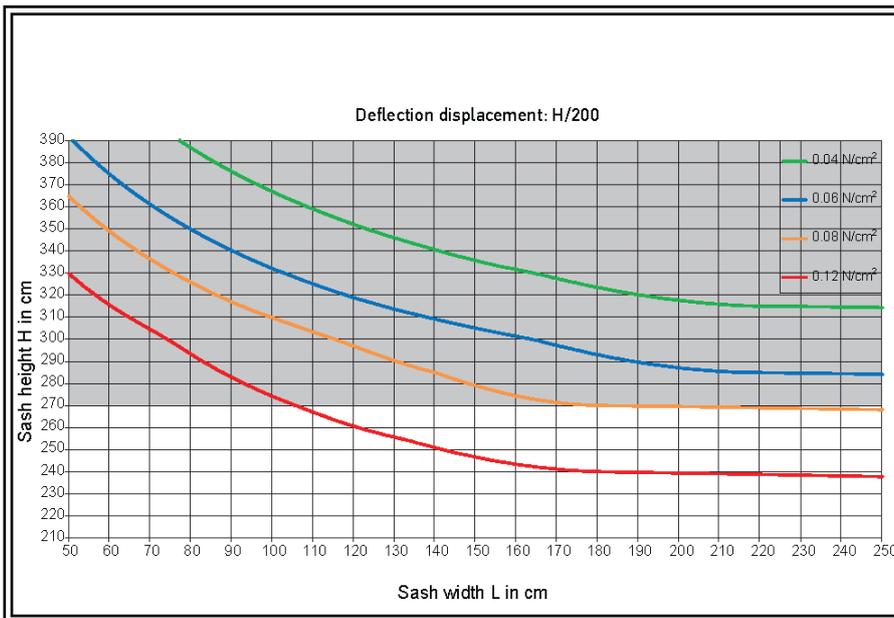
For constructions that their height is in the gray area, has to be calculated considering all the technical needs of the project.



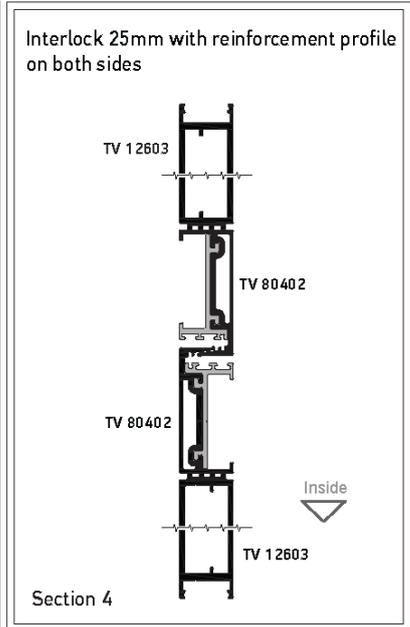
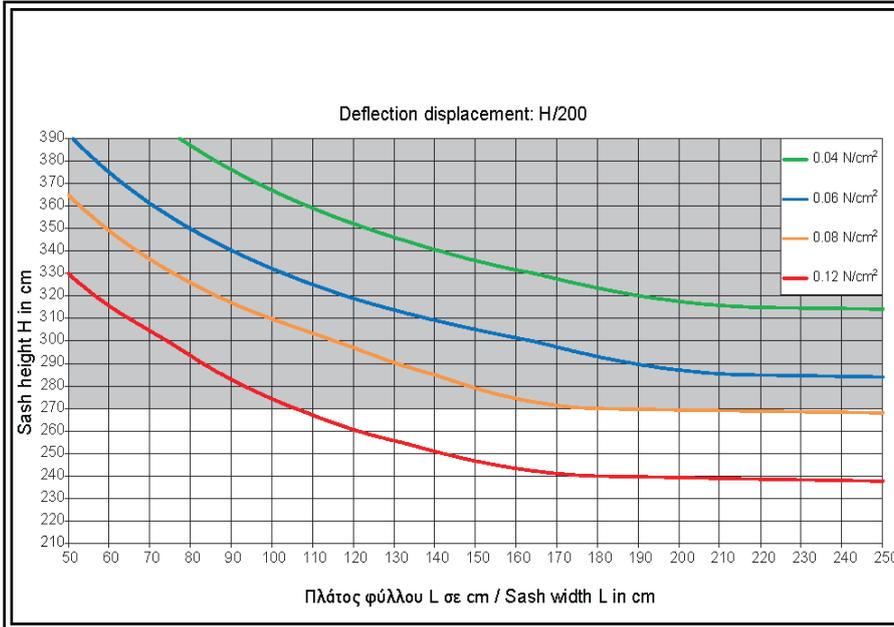
Ανεμοπιέσεις / Wind loads

- 0.04N/cm² 92Km/h —
- 0.06N/cm² 113Km/h —
- 0.08N/cm² 130Km/h —
- 0.12N/cm² 159Km/h —

The figures shown in the strength diagrams are based on the assumption that the reinforcement profile TV 12603 must be screwed to the interlock profile with screws spaced no more than 200mm apart.



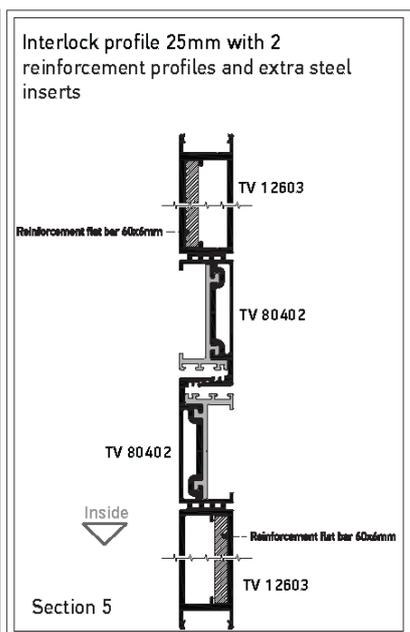
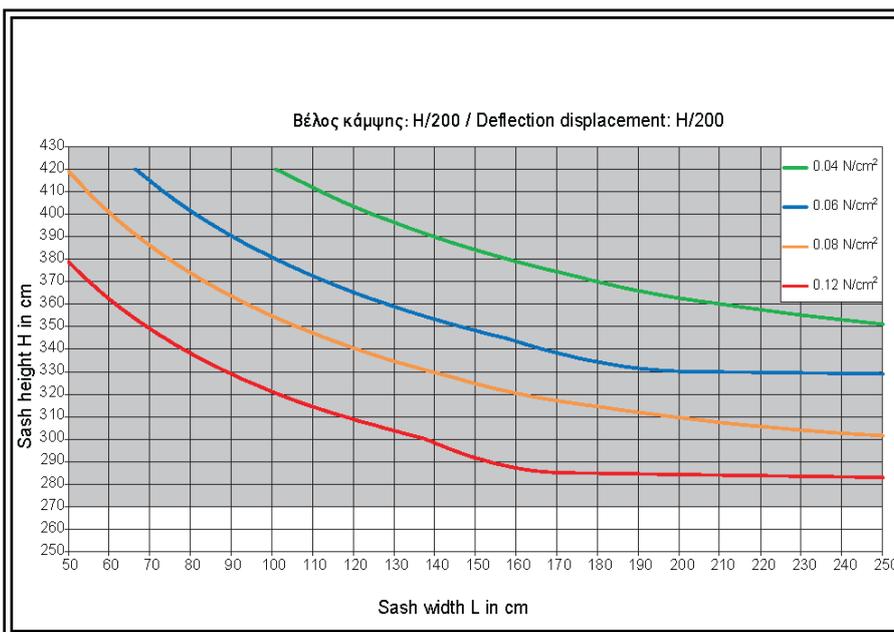
For constructions that their height is in the gray area, has to be calculated considering all the technical needs of the project.



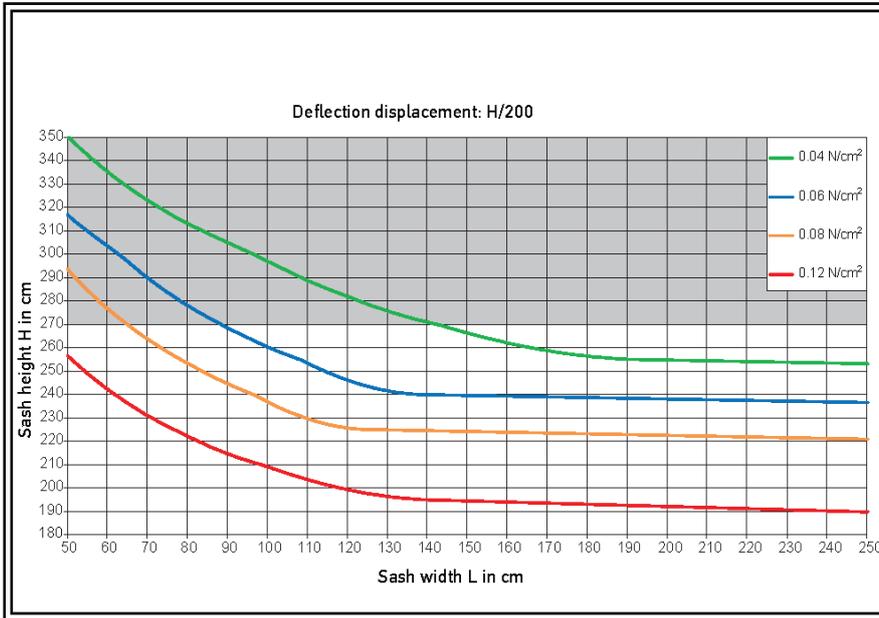
Ανεμοπιέσεις / Wind loads

- 0.04N/cm² 92Km/h █
- 0.06N/cm² 113Km/h █
- 0.08N/cm² 130Km/h █
- 0.12N/cm² 159Km/h █

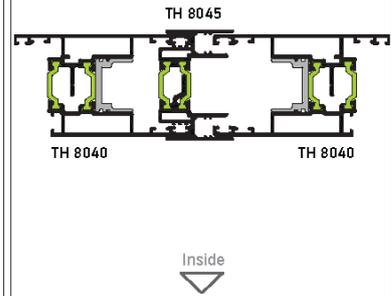
The figures shown in the strength diagrams are based on the assumption that the reinforcement profile TV 12603 must be screwed to the interlock profile with screws spaced no more than 200mm apart.



For constructions that their height is in the gray area, has to be calculated considering all the technical needs of the project.



Adjoining profile and glass sashes without reinforcement profiles

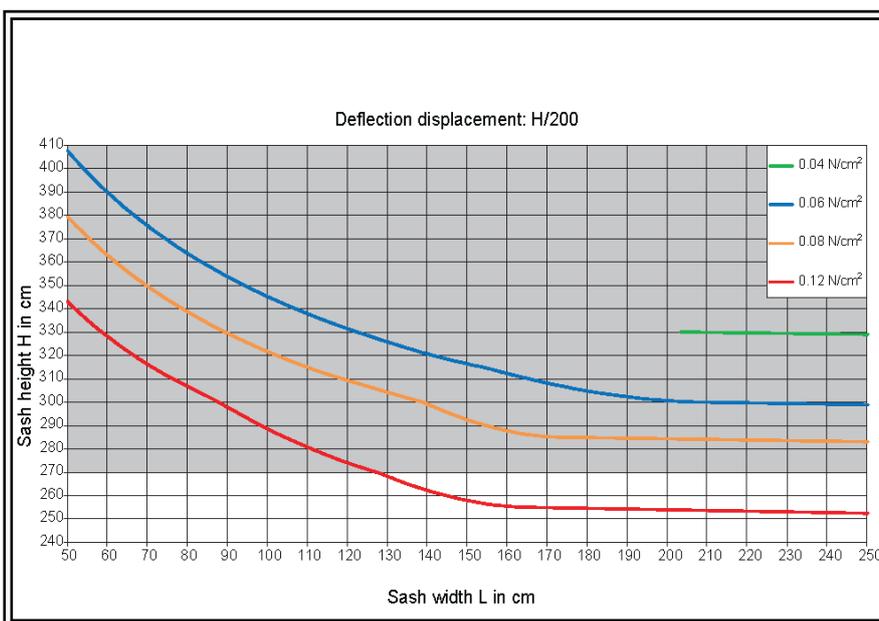


Section 6

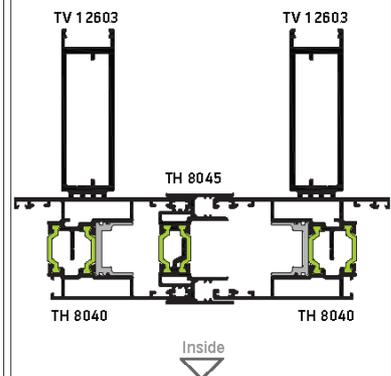
Ανεμοπιέσεις / Wind loads

- 0.04N/cm² 92Km/h —
- 0.06N/cm² 113Km/h —
- 0.08N/cm² 130Km/h —
- 0.12N/cm² 159Km/h —

The figures shown in the strength diagrams are based on the assumption that the reinforcement profile TV 12603 must be screwed to the interlock profile with screws spaced no more than 200mm apart.

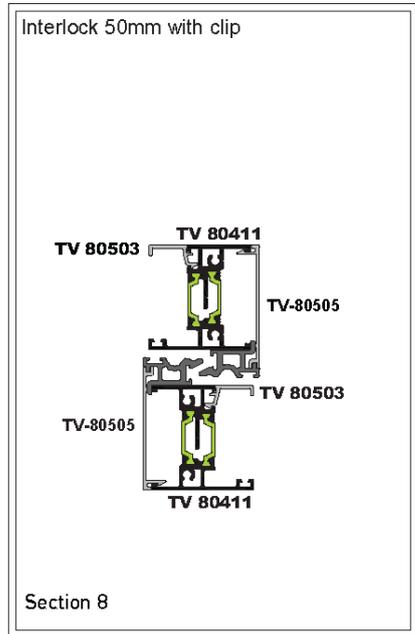
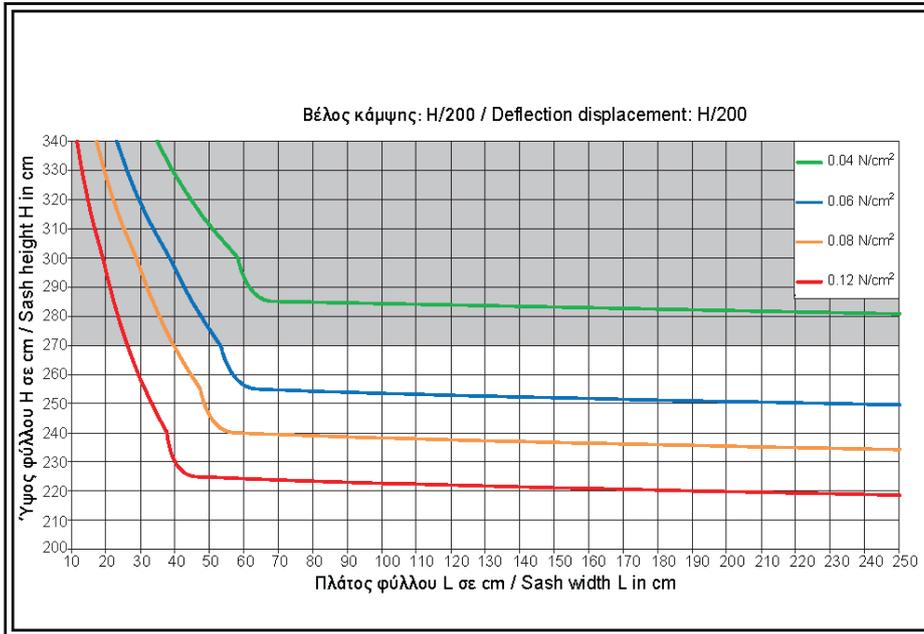


Adjoining profile and glass sashes with reinforcement profiles



Section 7

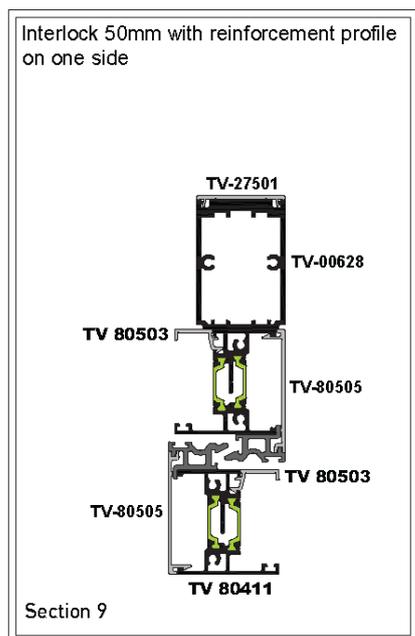
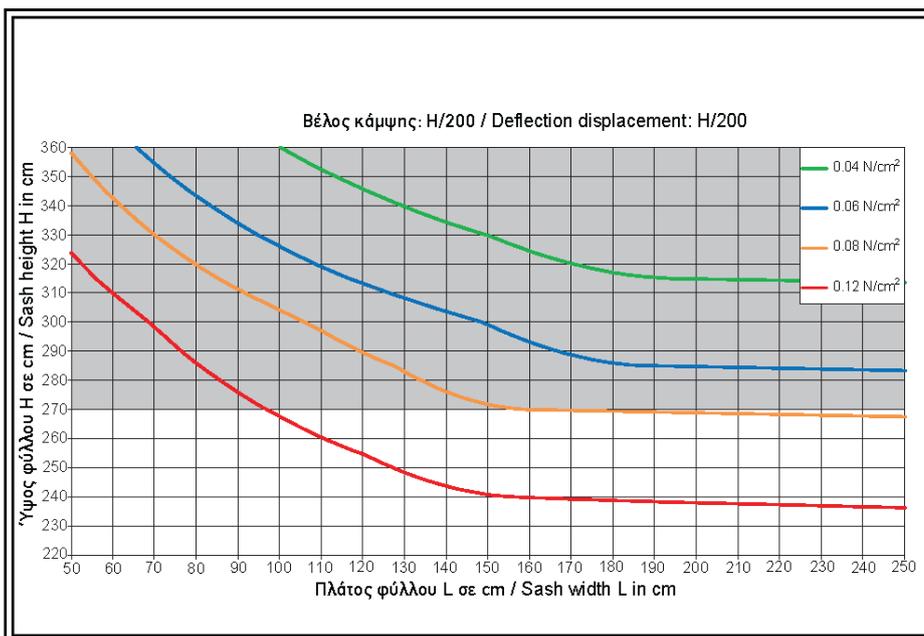
For constructions that their height is in the gray area, has to be calculated considering all the technical needs of the project.



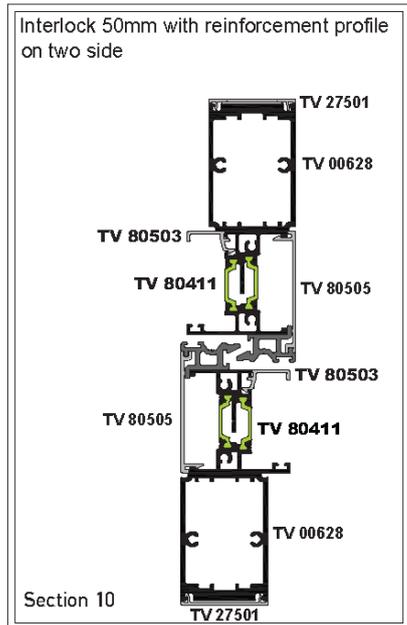
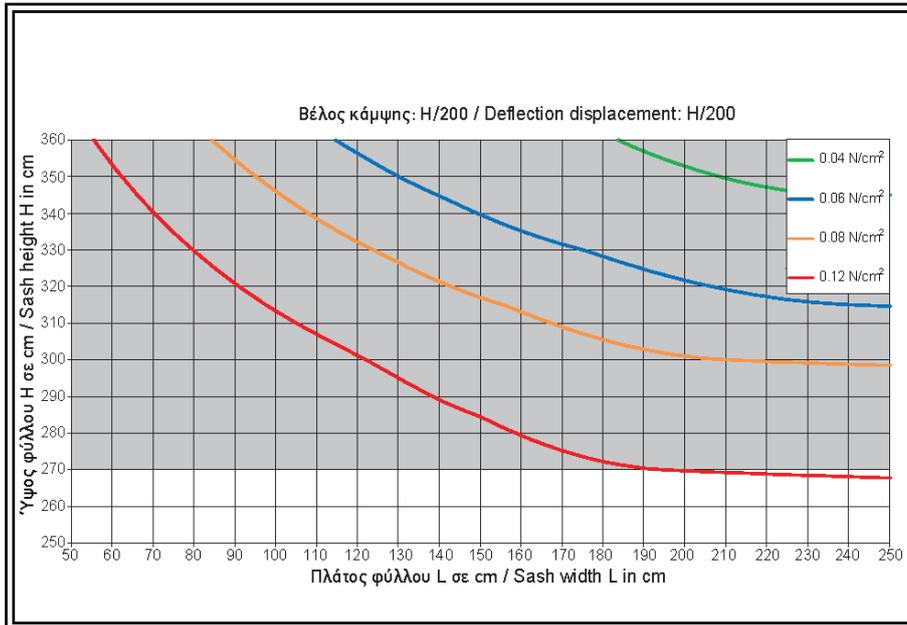
Ανεμοπιέσεις / Wind loads

- 0.04N/cm² 92Km/h █
- 0.06N/cm² 113Km/h █
- 0.08N/cm² 130Km/h █
- 0.12N/cm² 159Km/h █

The figures shown in the strength diagrams are based on the assumption that the reinforcement profile TV 00628 must be screwed to the interlock profile with screws spaced no more than 200mm apart.



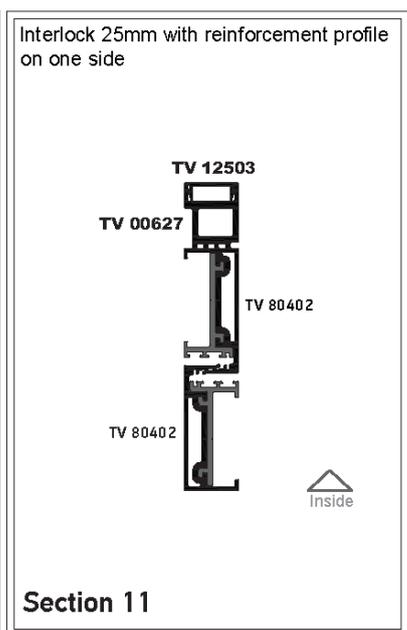
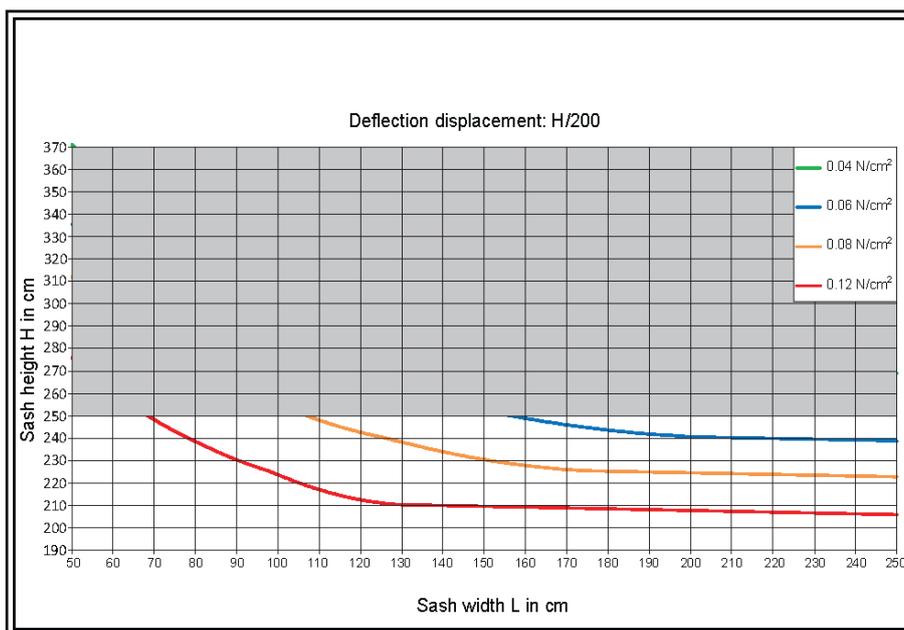
For constructions that their height is in the gray area, has to be calculated considering all the technical needs of the project.



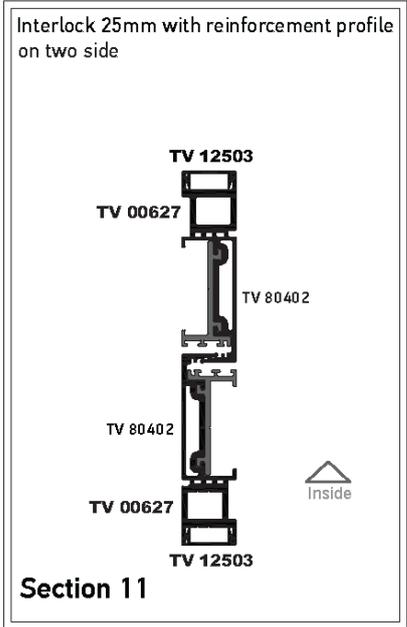
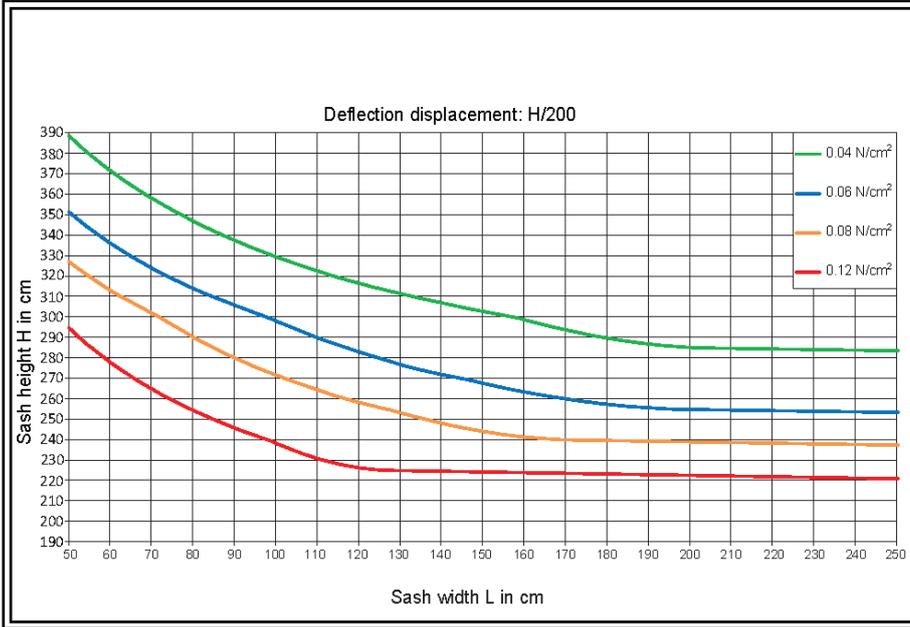
Ανεμοπιέσεις Wind loads

- 0.04N/cm² 92Km/h —
- 0.06N/cm² 113Km/h —
- 0.08N/cm² 130Km/h —
- 0.12N/cm² 159Km/h —

The figures shown in the strength diagrams are based on the assumption that the reinforcement profile TV 00628 & TV 00627 must be screwed to the interlock profile with screws spaced no more than 200mm apart.



For constructions that their height is in the gray area, has to be calculated considering all the technical needs of the project.



Ανεμοπιέσεις Wind loads

- 0.04N/cm² 92Km/h █
- 0.06N/cm² 113Km/h █
- 0.08N/cm² 130Km/h █
- 0.12N/cm² 159Km/h █

The figures shown in the strength diagrams are based on the assumption that the reinforcement profile TV 00627 must be screwed to the interlock profile with screws spaced no more than 200mm apart.

For constructions that their height is in the gray area, has to be calculated considering all the technical needs of the project.

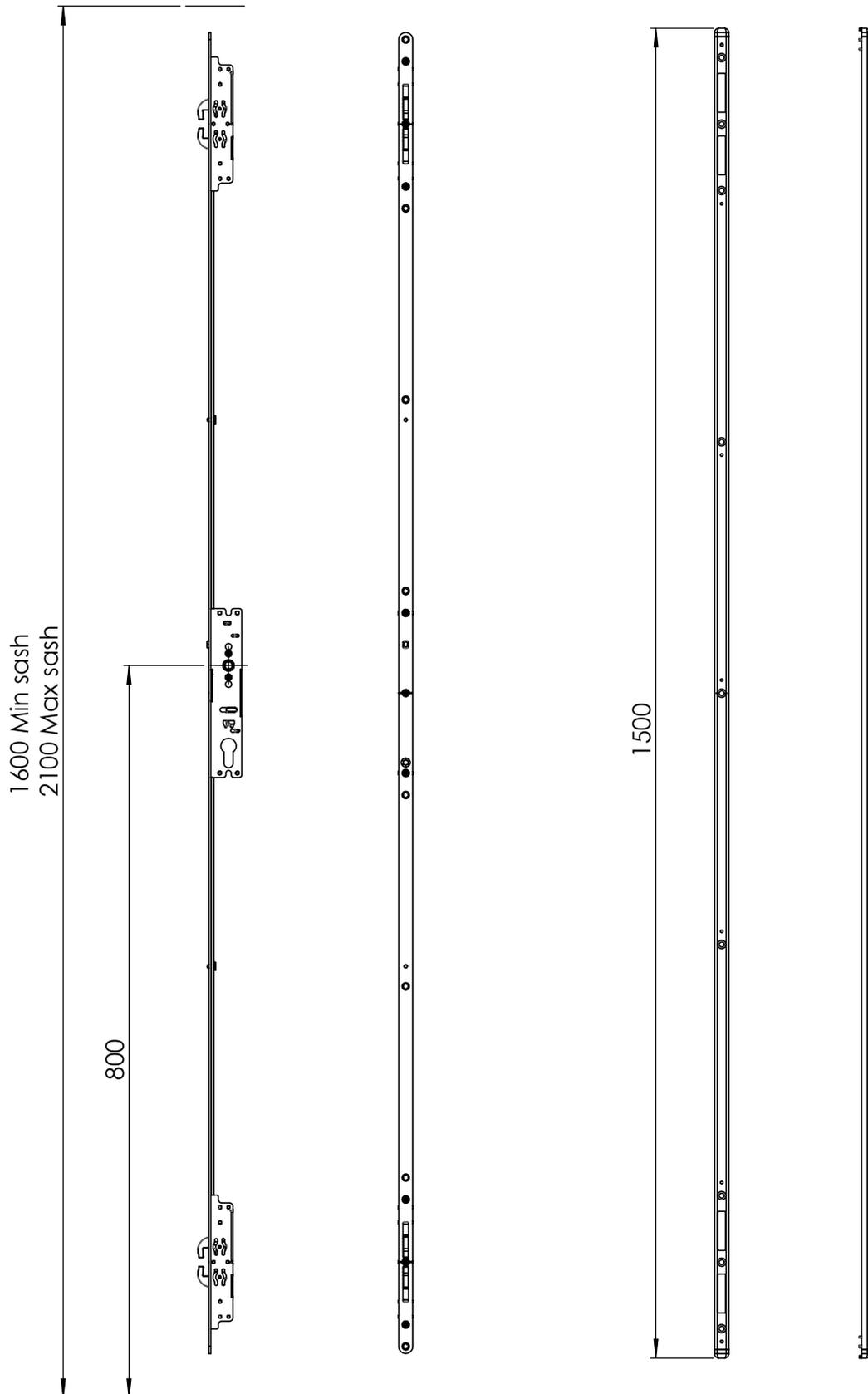
07

Technical Bulletins

Inline Slider Lock

8004
Duplex Patio Lock

8003
One Piece Keep



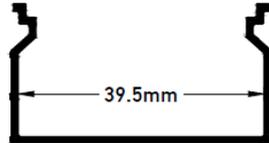
08

Fabrication Manual

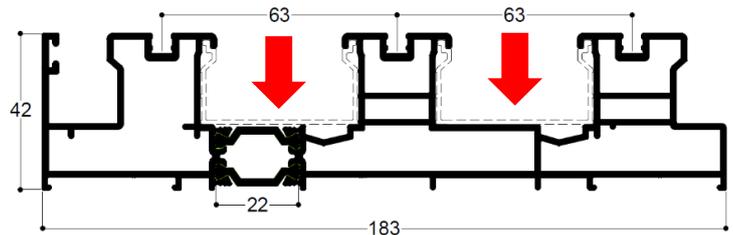
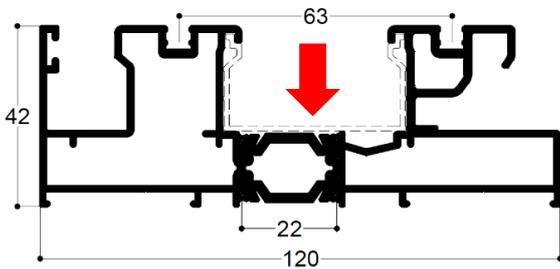
Make sure to insert the plastics into the following profiles BEFORE cutting

Screw the plastics on to the profiles (near to the end) to hold in place whilst cutting.

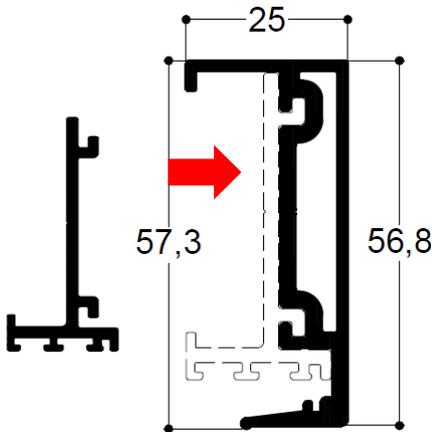
Profile code: TH 80113
Plastic code: PS 2



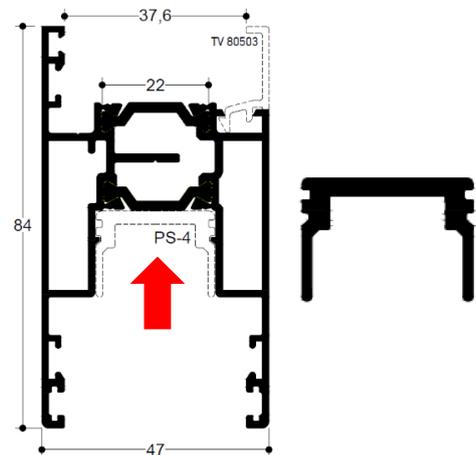
Profile code: TH 8022
Plastic code: PS 2 (x2)



Profile code: TV 80402
Plastic code: PP-80303



Profile code: TH 8040
Plastic code: PS 4



When cutting the door sash TOP & BOTTOM be sure to cut 2 of each:

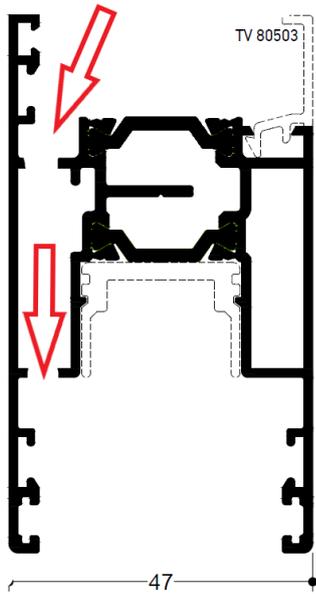
2x



2x



Drainage



Sash Bottoms TH 8040

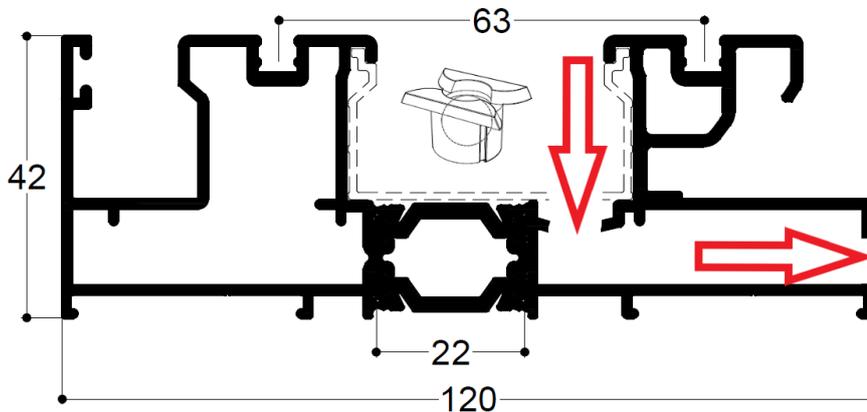
Drill 2 or 3, sets of 5mm holes (depending on sash width) through the front edge of the sash as shown.

Outer face of sash (big side)



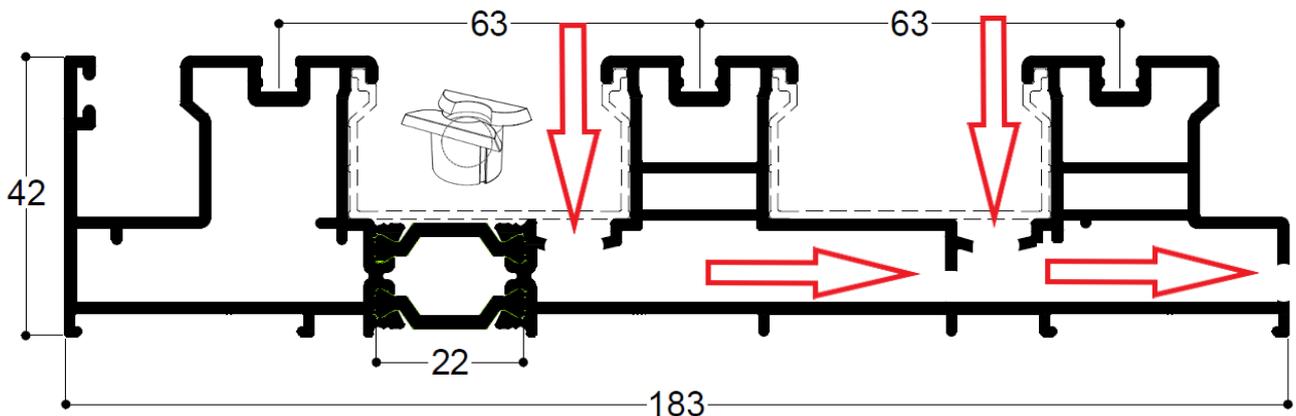
2 Track Frame TH-80113 + 3 Track Frame TH-8022

Use a router to cut 5mm drain slots, in the front edge of the frame profiles.

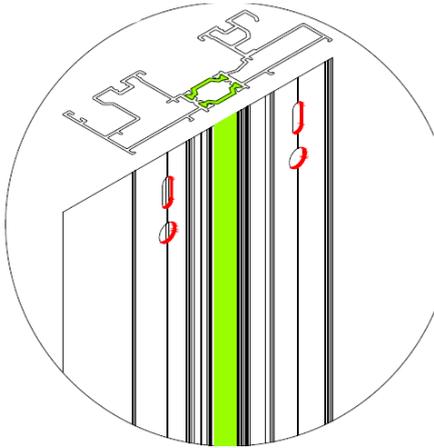


Also router slots in the top of the frame as shown.

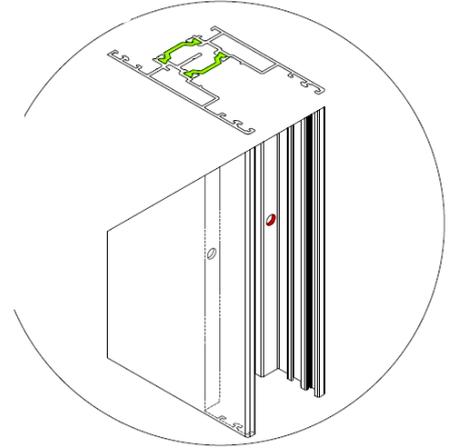
On the side of the door that will be inside the building you will need to drill 12 mm holes instead; this is to take the non-return valve.



Routing & Prep



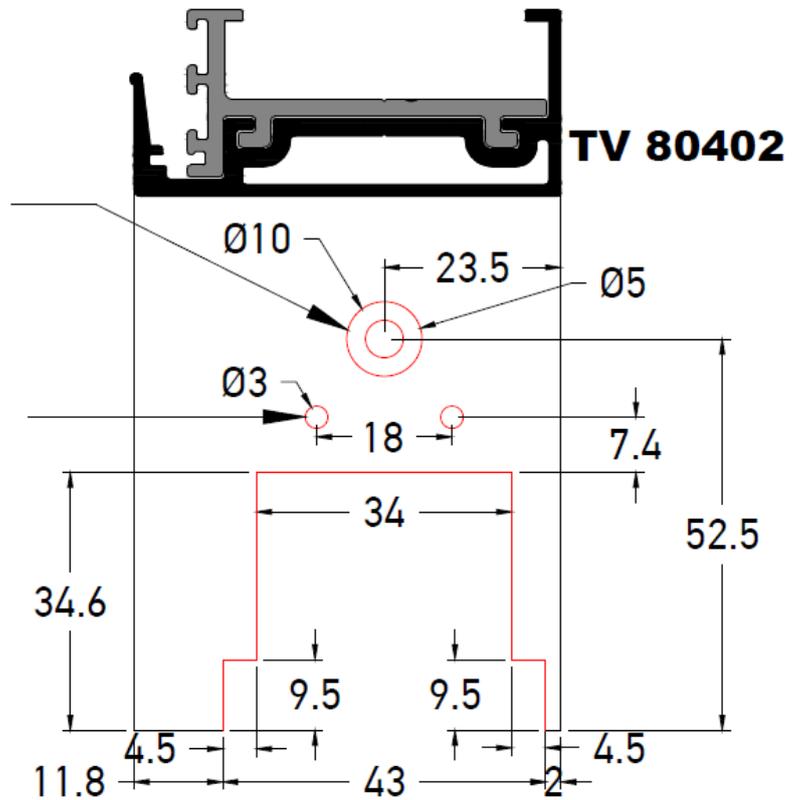
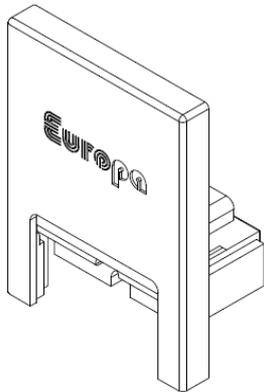
Make sure to punch the frame and sash before assembly.



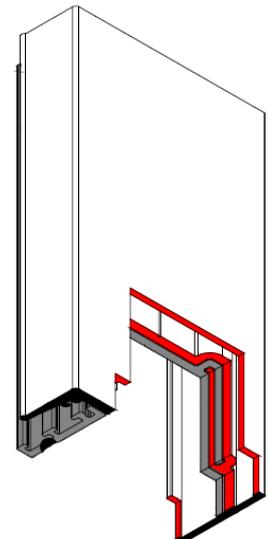
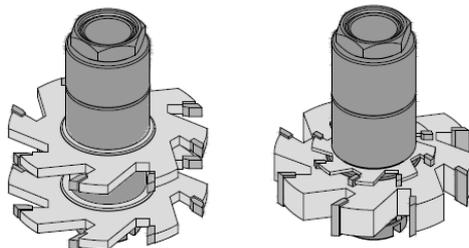
Interlock prep

Interlock connection screw hole (countersink this hole)

Use PG-80210 Interlock cover cap as a guide to drill these holes

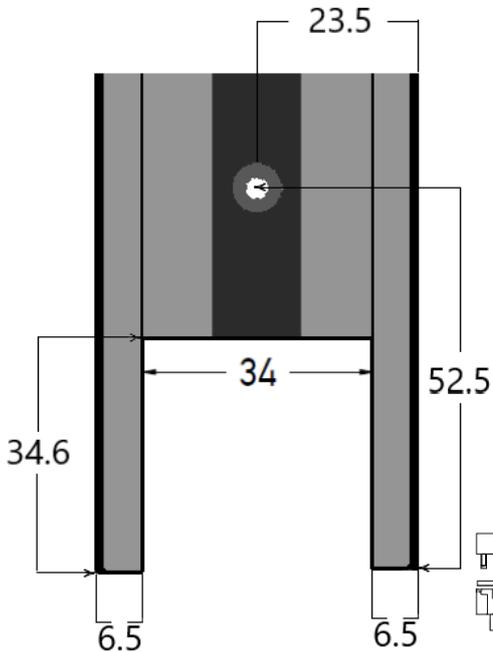


Either router out or use an end miller for these details. End miller blades available from us.



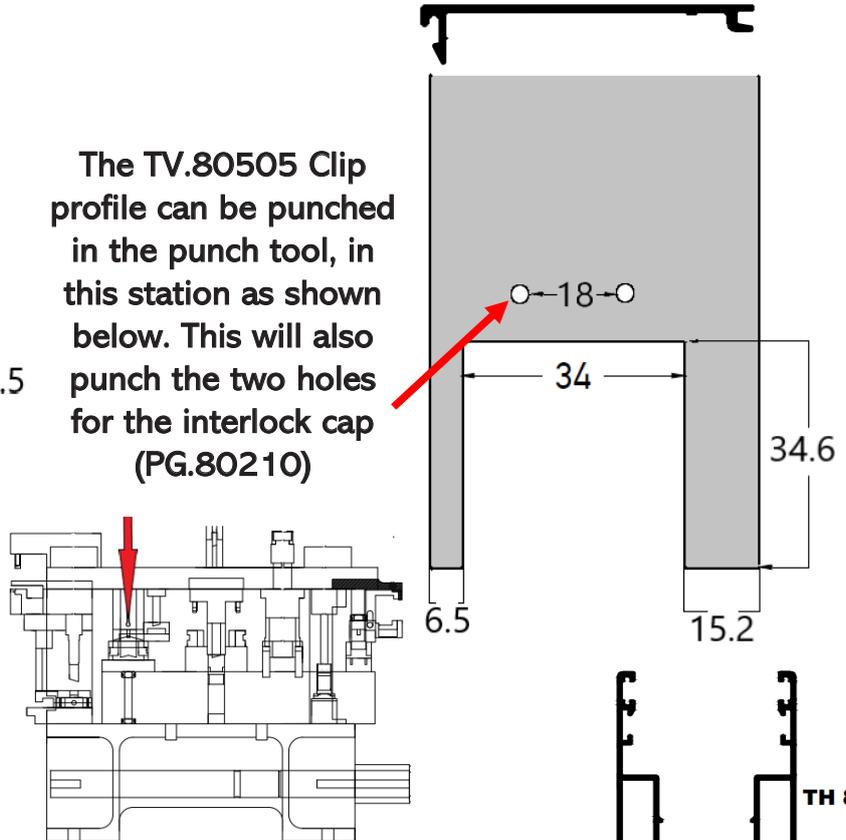
50mm interlock.

TH.8041 1 Profile Routing

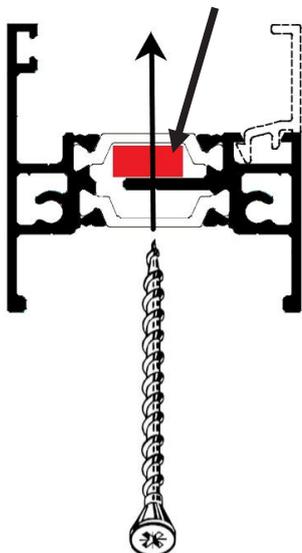


TV.80505 Profile Punching

The TV.80505 Clip profile can be punched in the punch tool, in this station as shown below. This will also punch the two holes for the interlock cap (PG.80210)



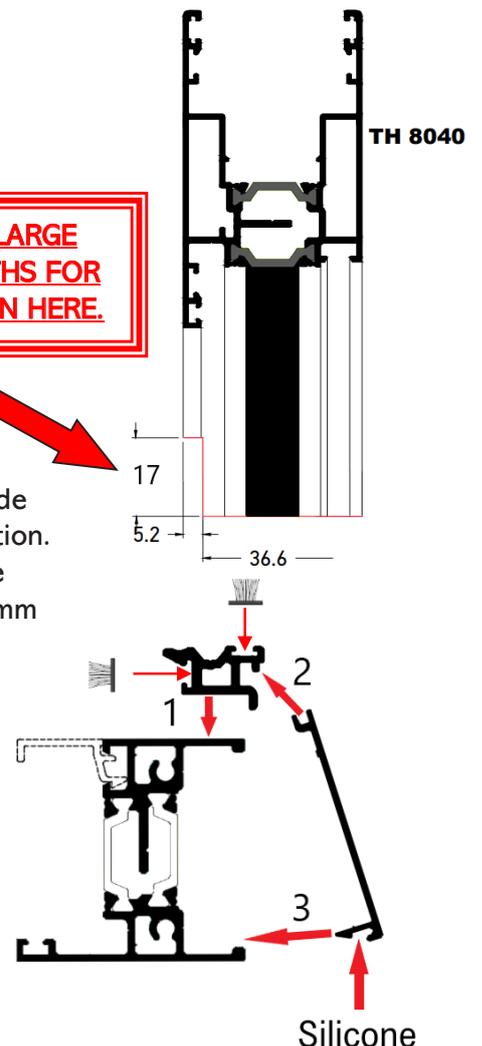
When screwing the interlock on to the sash profile, be sure to place a 6mm packer between the thermal break and the strengthener as shown below. This is to stop the profile from bending when the screw goes in.



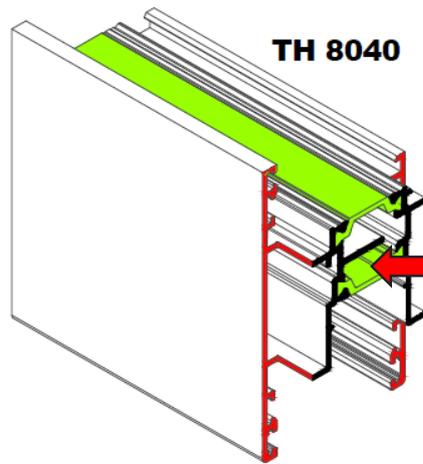
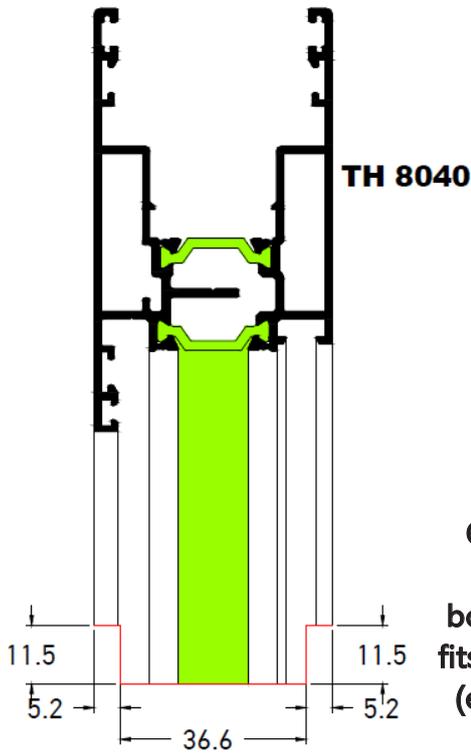
ONLY ROUTER OUT THE LARGE FACE OF YOUR SASH WIDTHS FOR THIS INTERLOCK, AS SHOWN HERE.

Interlock assembly.

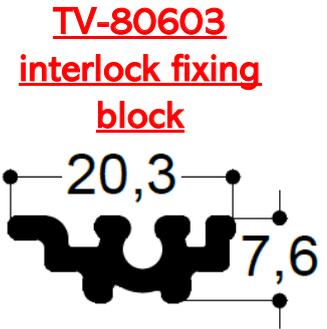
1. Screw the plastic onto the interlock profile, on either side depending on interlock position. These screws are seen so we suggest to use black 19-25mm screws.
2. push the hook side of the clip into the plastic.
3. Clip the other side onto the interlock profile (run a bead of silicone down this edge to stop the plate from sliding after fixing).



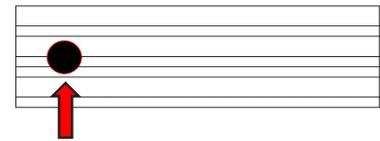
Sash prep.



Cut this detail from the 90 degree cuts on the top/ bottom sash widths so that it fits inside the interlock profile. (end milling blade available)



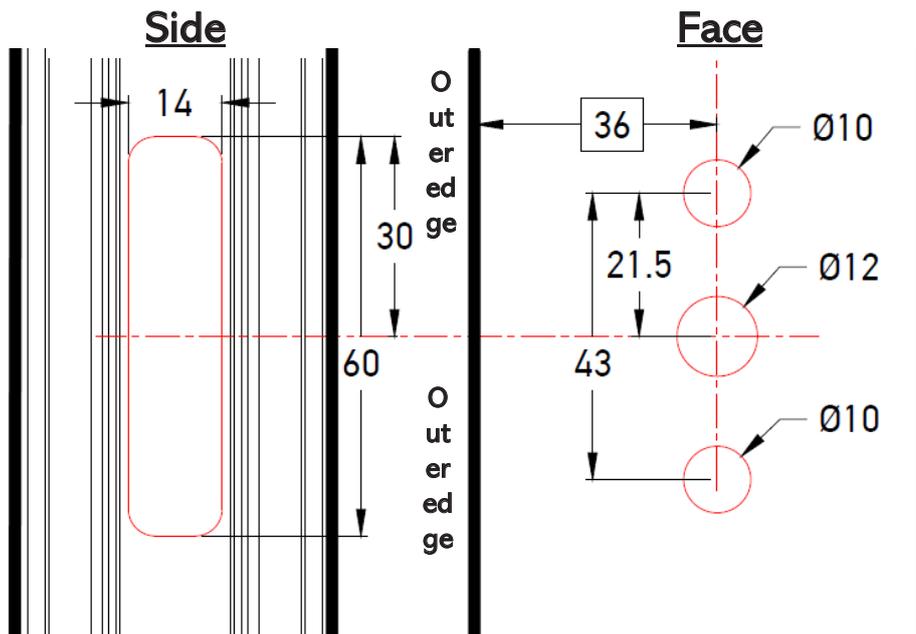
These come as a 6m bar length and will need to be cut down to approx. 60mm. they need screwing into the bottom chamber of the sash. This is what allows the interlock to be screwed on to the sash.



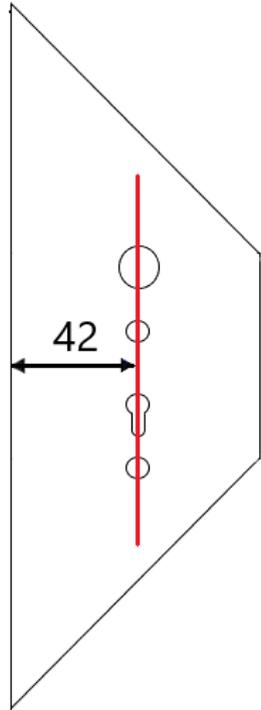
Make sure the screw holding the plate in goes through the end of the plate to allow for the interlock fixing screw to be inserted

Lock Preps

Inline Roto Lock Strip (1000mm spindle height)



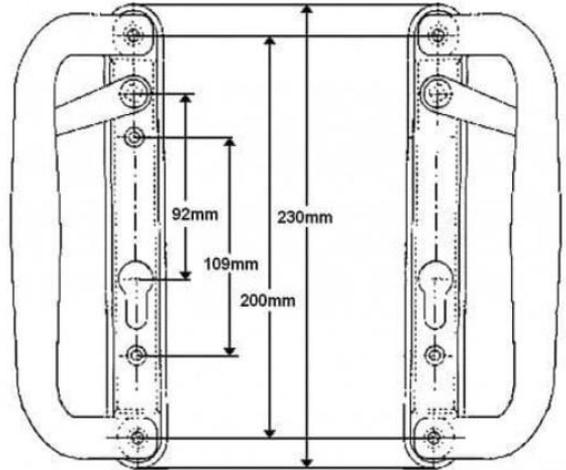
Double hook lock strip.



Centre line of handle holes = 42mm

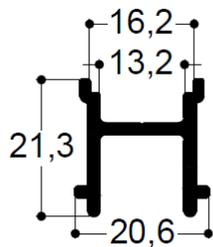
MILA Handle

Note: Pull handles are detachable via fixings from the back side so you can change the handing if you so need to making these handles universal.



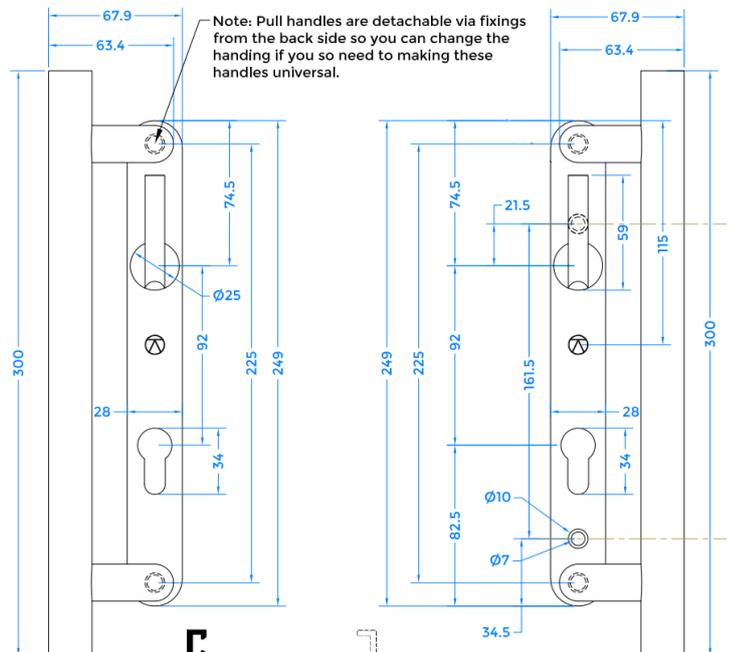
TV 8011

The TV8011 lock spacer add on should be cut down and fitted between the hooks on this lock strip. 2 small pieces should be cut for the ends also.

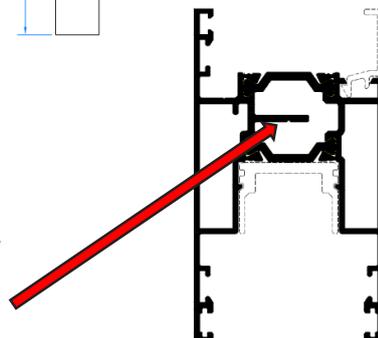


Coastal Handle.

Note: Pull handles are detachable via fixings from the back side so you can change the handing if you so need to making these handles universal.



Screw lock strip on with 45/50mm countersunk screws (3.9 or 4.2mm) Making sure that the screw goes through this section.



Lift & Slide (1008 spindle height)

On Lift and slide sash the following gaskets should be used instead of the wool pile around the sashes:



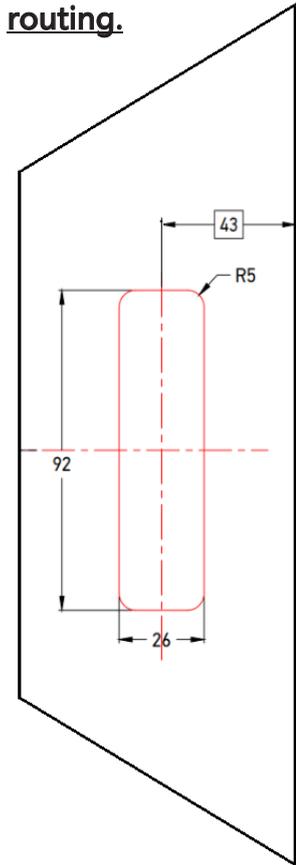
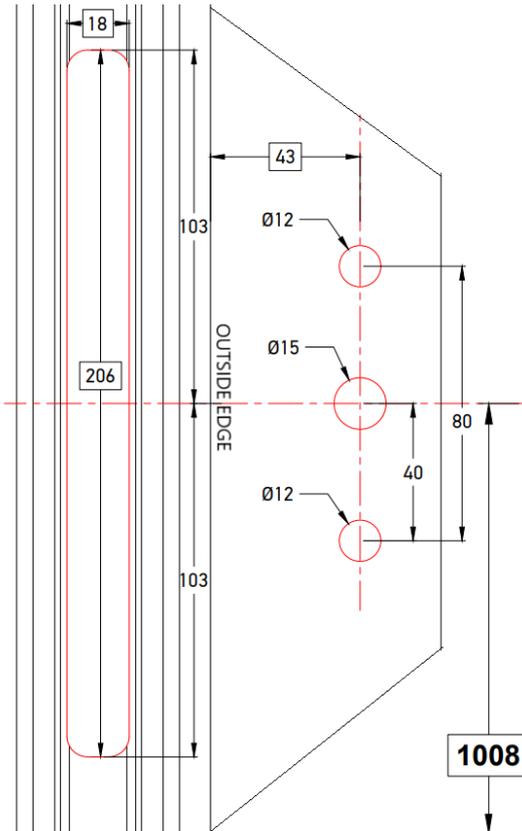
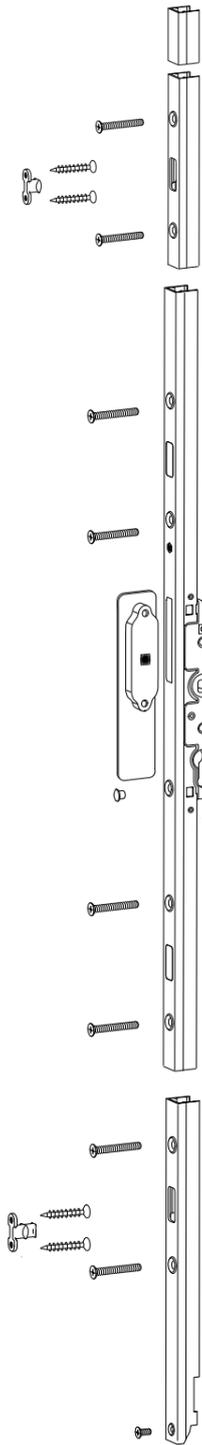
GA-80405
Sash top gasket



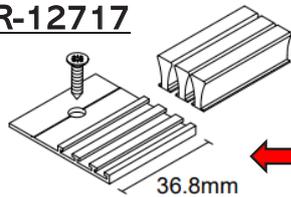
PS-35
Sash gasket
(all other sides)

Lever handle & side routing.

Pull handle routing.

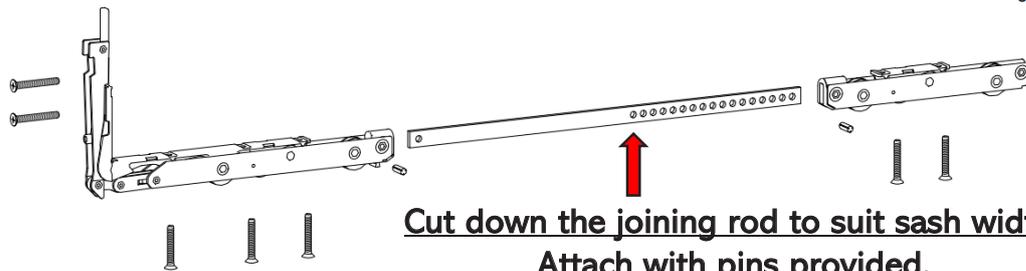
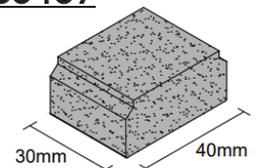


Top
SR-12717



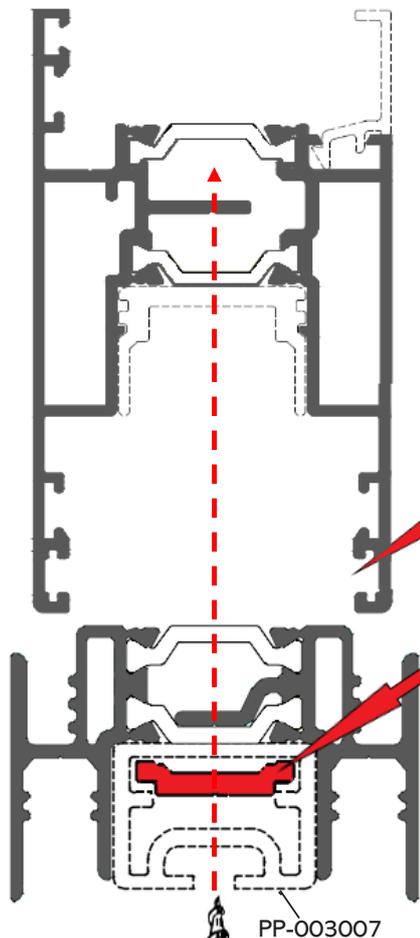
Swap the PS-7 draught excluders in the frame for These draught excluders.

Bottom
IC-80407



TH-8045 Sash adjoining profile.

1. Cut all profiles according to cutting list
2. Slide the Rod (TV5050) into the plastic (PP-003007)
3. Place both the rod and plastic into the TH-8045
4. Put the Caps (PS-80203) on to the ends of the TH-8045
5. Pre drill the plastic and screw through the plastic, rod, TH-8045 and into the metal strengthener in the sash with 4.2x70mm screws every 200mm as shown below.



NO BRUSHPILE IN SASH

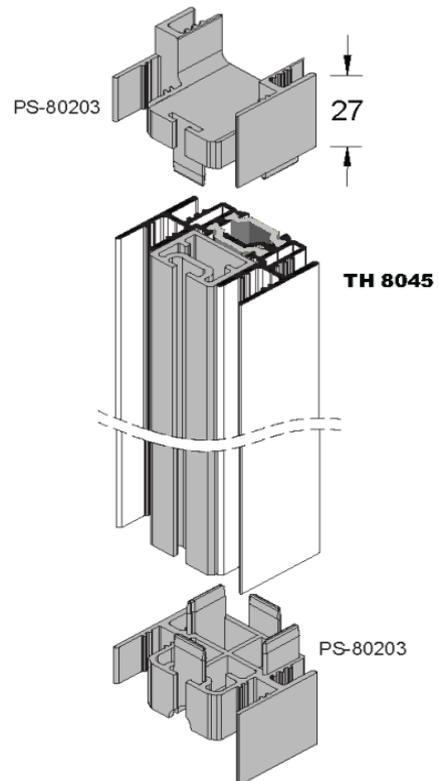
TV5050 Rod

PP-003007

Pre drill the plastic so
the screw head sits on
the metal

4.2x70mm screws
at least every
200mm

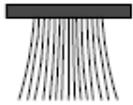
PS-80203 Caps



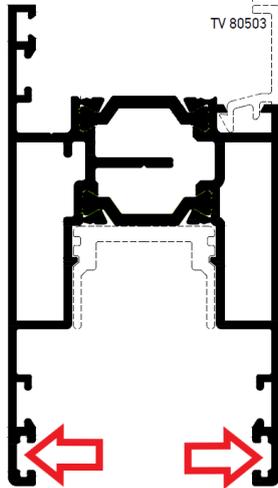
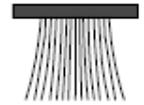
When your Adjoining post is screwed into place on to the sash profile you can place the keep (receiver) in the centre of the plastic (PP-003007) and screw on, making sure the screws go through at least 2 skins of metal

(ideally into the sash metal also for extra security).

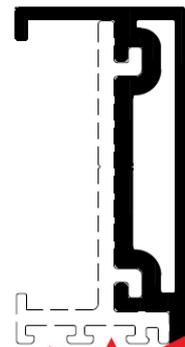
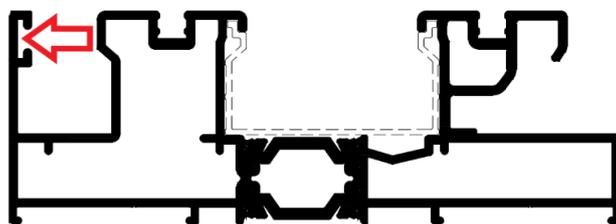
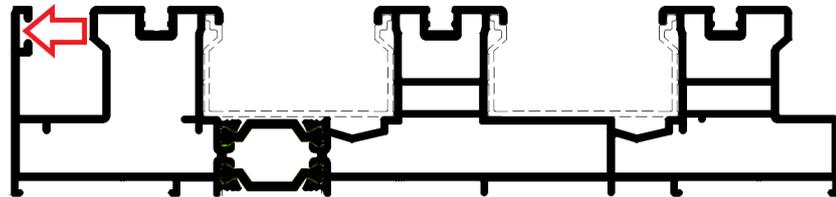
Brush pile 7mm 4P



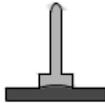
Slide the brush pile in at the following places (⇨)



TV 80503

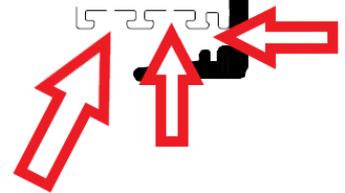


Optional interlock gasket
GA-12904



Interlock

3x Brush pile OR 2x brush pile and 1x gasket
(on the outer edge for external doors)

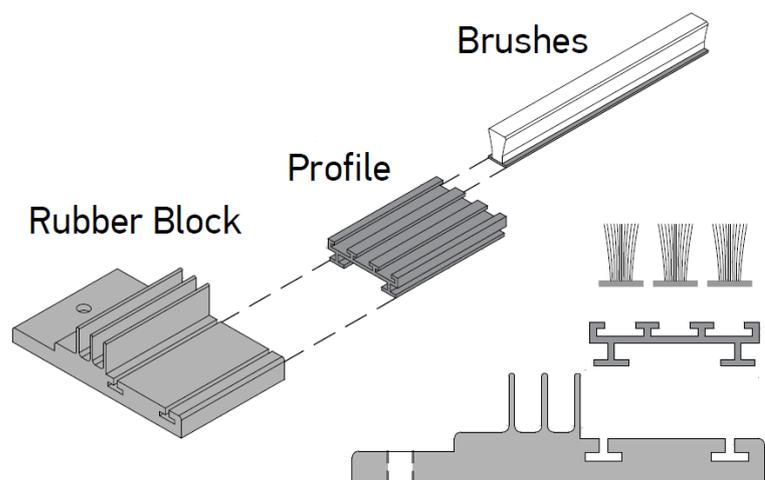


Anti lift & Draught excluding blocks PS-7.

Piece the blocks together as shown.

You will need one for both the top and bottom of the frame, wherever two doors are interlocking. Slide these in before assembling the frame.

Mark the centres where the doors will interlock and silicone the bottom block in place, so the rubber fins are aligned with your marks (brush pile to the inside of the building)

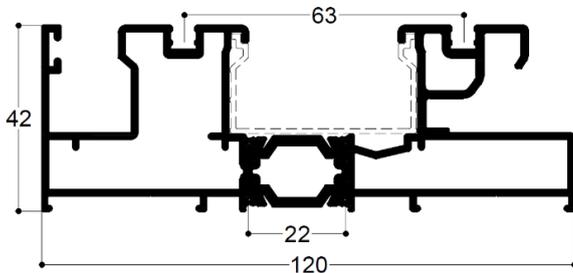


Trim top rubber block down in width by 1mm so it slides easily in the frame (as they will need to be slid out of the way to get the doors in)

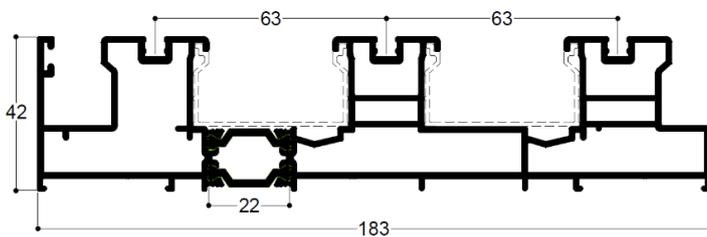
Assembly instructions

Frames

Be sure to add the track to the bottom of the frame before assembly



**2x frame cleats
Per corner**



Be sure to silicone the full circumference and also fill the end of the sections with drain holes in them before putting corners together.

When inserting the Cleats into the frame, make sure the connector clips in to the punched holes on the profile on both sides before tightening the cleat screw.

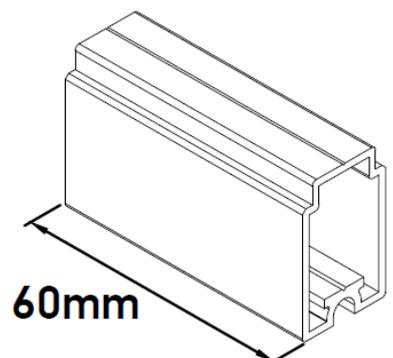
When tightening the cleat screw, manipulate the corner with your hand to line the profiles up.

When the frame is together, apply FL-01 cover gasket around the frame to fill the track slot (only on the sections with moving doors, do not insert on the fixed pane section)

This side to outside

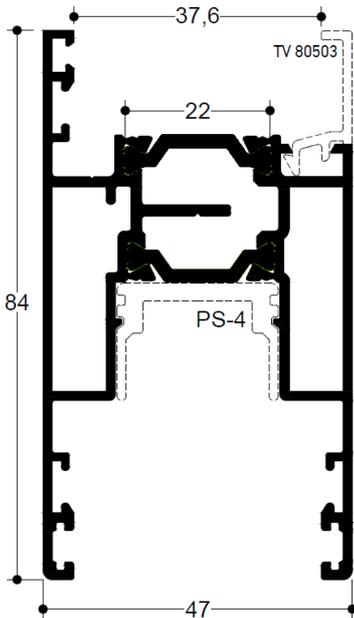


If there is a fixed pane on your door, PS-9 fixed sash blocks will need to be placed on the frame. Screw on two blocks to the bottom and two to the height (pre drill with 4mm then open top hole to clear the screw head.) approx. 150mm from the edge of the sash, small pieces of track can be used to line the blocks up.



08.10

Sash Assembly.

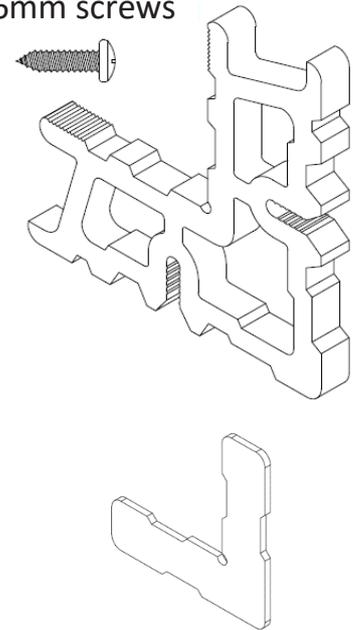


- 2x Sash cleats (PS-10)**
- 3x Chevrons (E-47)**
- Per sash corner (45 degree)**

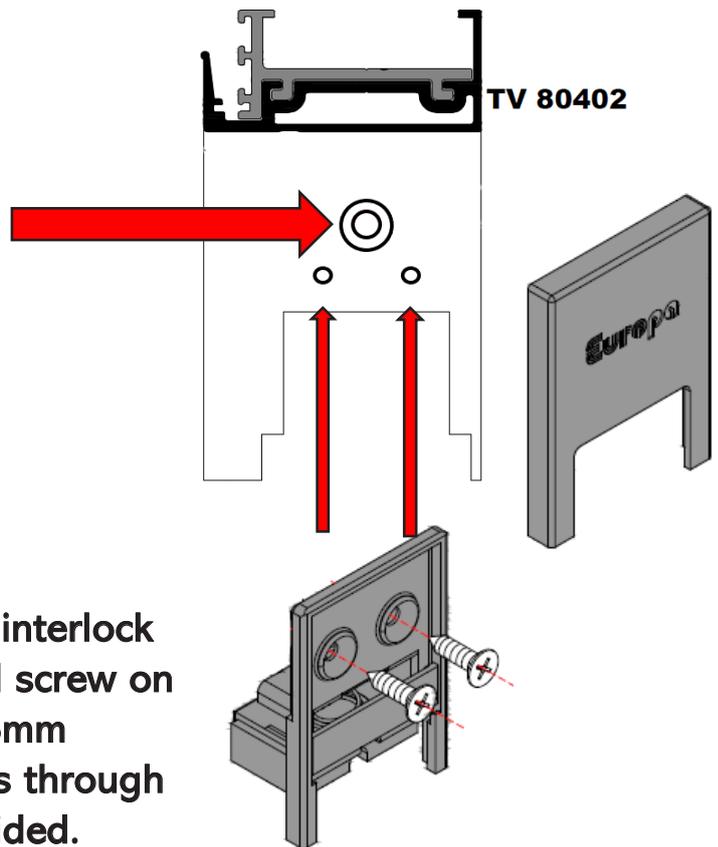
Make sure to silicone the entire end of the bar before assembling

Use screws no longer than 16mm as they will bottom out on the cleat.

4.2x16mm screws



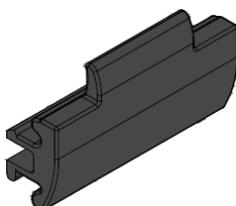
Silicone and screw the interlock onto the sash with either a 48/50mm self-tapping screw or you can tap the adaptor and put a machine screw in.



Piece together the interlock cap (PG.80210) and screw on with short (16mm countersunk) screws through the holes provided.

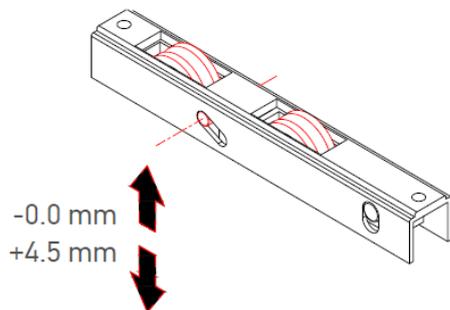
UN-80204

Place 4 of these anti rattle clips into the top of each sash, on either side, to stop the door from moving when in the frame

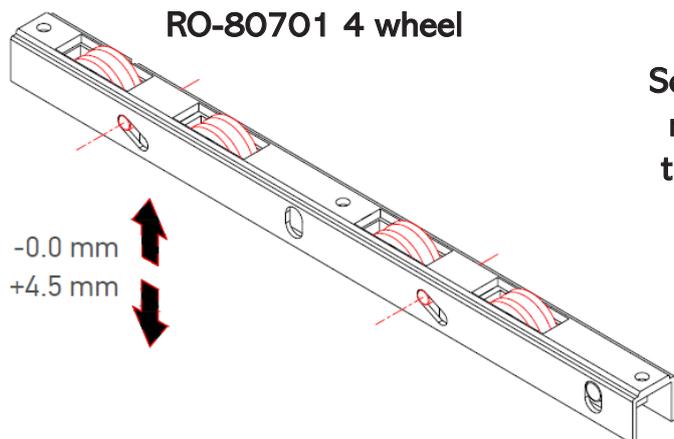


Wheels

PS-12 2 wheel



RO-80701 4 wheel



Each individual wheel can hold up to 25kg.

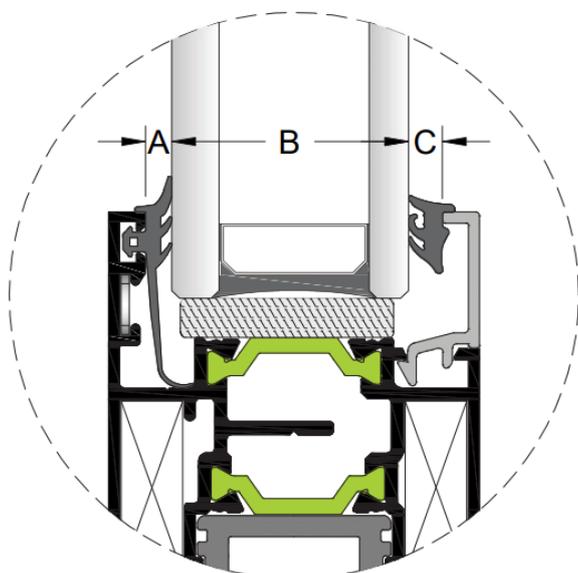
(2 wheel PS12 = up to 50kg each)
(4 wheel RO-80701 = up to 100kg each)
These are also available with metal wheels which hold 50kg each for very heavy doors.

Screw the wheels on to the bottom of the moving sash with the adjuster screw to the outside, approximately 100-150mm from the corner of the sash.
(25 mm self-drilling screws)

Gaskets

Using the BL-05 captive gasket (E-gasket) use the table below to find the code for the correct wedge gasket for the glass.

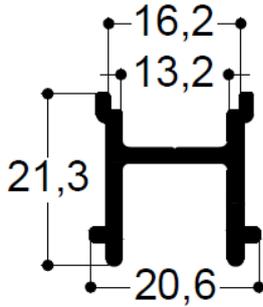
BL-05



TOTAL SPACE	OUTSIDE		GLASS	INSIDE	
(mm)	CODE	A (mm)	B (mm)	C (mm)	CODE
37	GA-004005	3	32	2	GA-12407
37	GA-004005	3	31	3	GA-12408
37	GA-004005	3	30	4	GA-12409
37	GA-004005	3	29	5	GA-12410
37	GA-004005	3	28	6	GA-12411
37	GA-004005	3	27	7	GA-12412
37	GA-004005	3	26	8	GA-004024
37	GA-004005	3	24	10	GA-004028

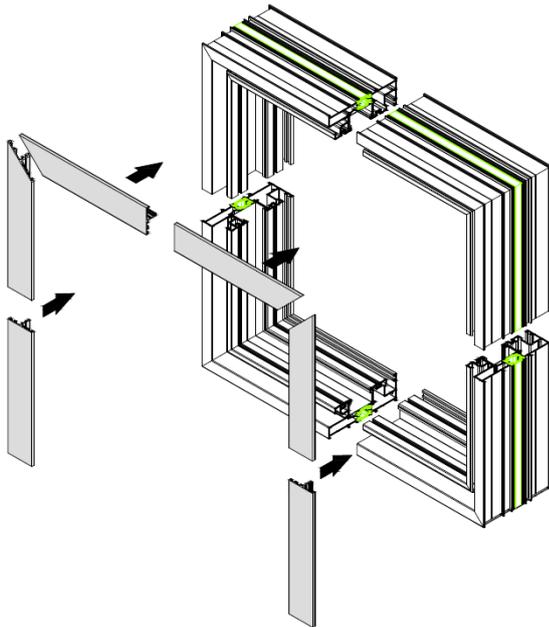
Lock strip.

TV-8011 Lock adaptor



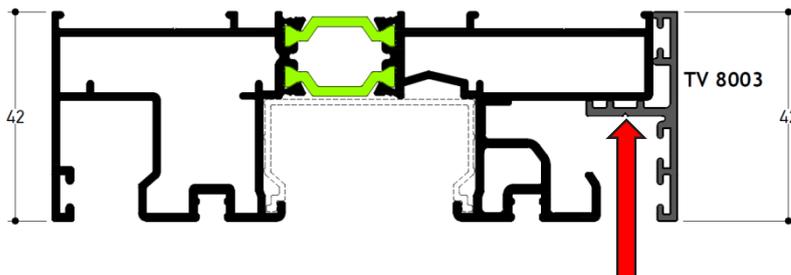
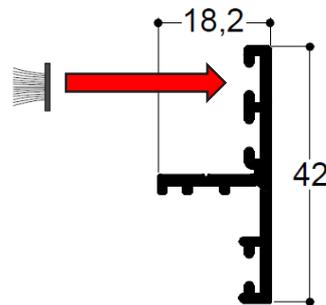
1. Place lock strip into the sash
2. Screw on handle loosely to centralise lock strip
3. Measure and cut TV-8011 lock adaptor profiles (x2) to the end of the lock strip
4. Screw through lock strip and adaptor with 48-50mm screws
5. Tighten handle screws.

TV-8003 Weather bar (optional)



BEFORE putting the doors into the frame, you can screw on the weather bar to the HEIGHTS of the frame (not the top yet). Cut the weather bar at a 45 degree angle on the top edge as shown (90 degree on the bottom)

Put brush pile into the weather bar.



Screw the weather bar on the sides as shown with 16mm screws. Once the doors are in, the top weather bar can be attached.

Finishing touches.

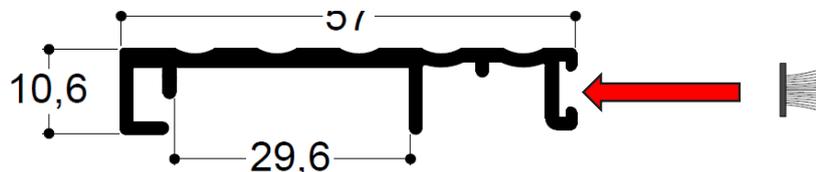
Put the doors into the frame. If there is a fixed pane, mark off where the fixed pane blocks are on the frame, so you know where to screw the pane on. Slide the fixed sash in and screw on with 48-50mm screws, making sure to screw the heights first to make sure the sash is all the way back, before screwing the bottom of the sash down.

Place the other door(s) in and mark off the locking positions on the lead door. Carry these marks over to the frame and use them to screw the keep(s) in the correct position

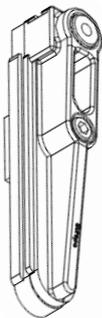
Be sure to slide the top Draught excluder(s) into place between the interlocks and screw in.

If there is a fixed sash

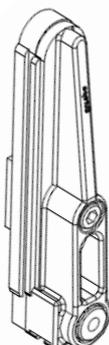
Once the doors are in and working you can cut the TV-47501 tread (cover) plates:



Where the plates meet cut the tread plate at a 45-degree angle, so they meet cleanly in the corner. On the 90-degree cut edge you can either butt it up to the interlock cap or router the end out, so it fits around the cap. Put brush pile in the edge as shown and then silicone the plates in.

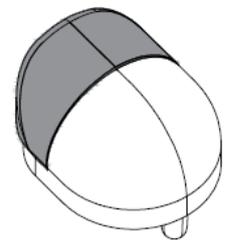


PS-18



Anti-lift blocks and stoppers

After the doors are in you can screw on the PS-18 anti-lift/ damper blocks to the top and bottom of the lead door. A small piece of brush pile can be added to the end of these so that it cleans the track when you operate the door.



2002-086

Screw on these stoppers (2002-086) to the bottom of the sash to stop the handle from hitting the interlock. (Available in all standard colours)

Fitting the glass.

Place packers so the weight of the glass is on the wheels/fixed sash blocks.

Bond the glass to the interlock with:

Soudal SMX506 Bonding adhesive (recommended) and shuffle glaze into the interlock side first. Apply the beads then apply wedge gasket (wedge both sides of the interlock)



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