

Security Manual PAS23/24

2500 chamfered

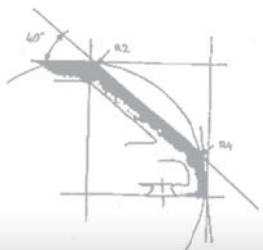
06.08



CONTENT

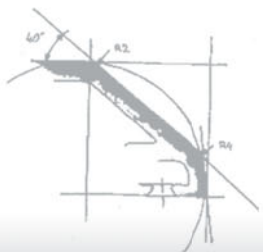
1. PAS23/24

- 1.1. General Statement
- 1.2. List Of Screw Types
- 1.3. Profile Guide
- 1.4. Mechanical Joints
- 1.5. Hardware Parts List
- 1.6. Fitment Of Hardware
- 1.7. General Arrangements
- 1.8. Glazing



PAS23/24

GENERAL STATEMENT
LIST OF SCREW TYPES
PROFILE GUIDE
MECHANICAL JOINTS
HARDWARE PARTS LIST
FITMENT OF HARDWARE
GENERAL ARRANGEMENTS
GLAZING



This technical manual must be read in conjunction with the main fabrication manual for the DECEUNINCK 2500 chamfered residential door system.

■ WELDING

All door frames are to be fully welded.

Midrails can be either welded or mechanically jointed.

To avoid weld contamination, heater plates and Teflon covers must be cleaned on a regular basis and replaced if any surface deterioration is found.

NOTE. TO AVOID INJURY, HEAT RESISTANT GAUNTLETS SHOULD BE WORN WHEN CLEANING OR REPLACING HEATER ELEMENTS.

Protective tape should be peeled back from the weld sufficiently to ensure tape is not trapped within the weld.

■ FABRICATION

To achieve the PAS 24 security test, all doors must be fully reinforced with the appropriate steel reinforcing.

The positioning of reinforcement retaining screws should be at no greater than 300mm centres and a maximum of 100mm in from each end.

Drainage carried out strictly in accordance with the Deceuninck 2500 chamfered Technical Manual.

■ HARDWARE

To achieve the PAS 24 security test all opening sashes must be fitted with the recommended hardware listed and illustrated within this manual.

■ HARDWARE RETAINMENT

To achieve the PAS 24 security test all hardware must be retained with the recommended screws listed and illustrated within this manual.

■ INSTALLATION

Installation should be carried out strictly in accordance with the Deceuninck 2500 chamfered Technical Manual.

■ MAXIMUM SIZES

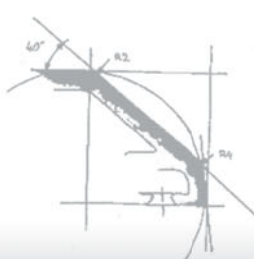
Please see below for details

Size Limitations and Performance Characteristics

Door Type	Length (up to a maximum of)	Height (including sill) (up to a maximum of)	Exposure category as given in Table 1 of PAS23-1:1999
Overall	2000mm	2100mm	1200 Class A3
Door	1000mm	2100mm	1200 Class A3
Sidelight	1000mm	2100mm	1200 Class A3

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It is important that good quality, high strength screws are used when fitting hardware, and that the screw manufacturers recommended pilot hole sizes are adhered to at all times. When fitting hardware, extreme care must be taken not to strip the thread as deterioration in performance will result. In order to achieve maximum fixing strength screws should not be removed and reinserted.

Recommended Screw Supplier



Star Business Park, Buxton Road, Bosley
Macclesfield, Cheshire. SK11 0PS
Tel: 01260 223311 Fax: 01260 223312

- ISO 9001:2000 Quality Assured window screw range, offering full traceability.
- Screws that exceed both the current and proposed requirements of BS7412, the British Standard for PVCU windows.
- Full Technical support including detailed specifications and independent laboratory reports on the excellent corrosion resistance of the plating (conducted in accordance with BS7479:1991).
- Conforms to and exceeds GGF Guidelines 6.8 July 2004 and BPF Guidelines Ref:W363/1 February 2001.
- Manufactured from high grade carbon steel or 100% stainless steel to provide maximum strength.
- Local Authority PVCU Frame Advisory Group (LAPFAG) approved supplier.
- Next day nationwide delivery from the largest stock holding distributors of screws in the UK.
- Competitive prices and a high standard of service and reliability.

Please telephone **01260 223311** or fax **01260 223311** if you require an **RapierStar** product guide, samples or quotation for the specialist security screws designed for use into reinforced or non-reinforced applications



Product range: SFG
Description: Shallow Pan Head, Phillips No.2 recess, with single deep thread and gimlet point.
Application: Friction stay to unreinforced PVCu windows
SFG 4.3 x **16 20 25**
Finish Z/S Quantity per box 1,000
e.g. SFG 4.3 x 25 Y



Product range: SSR
Description: Shallow Pan head, Phillips No.2 recess, with self tapping thread and self drilling point.
Application: Friction stay to reinforced PVC-U windows
SSR 3.9 x **16 19 25 29**
Finish Z/S Quantity per box 1,000
e.g. SSR 3.9 x 25 Y

It is important that good quality, high strength screws are used when fitting hardware, and that the screw manufacturers recommended pilot hole sizes are adhered to at all times. When fitting hardware, extreme care must be taken not to strip the thread as deterioration in performance will result. In order to achieve maximum fixing strength screws should not be removed and reinserted.

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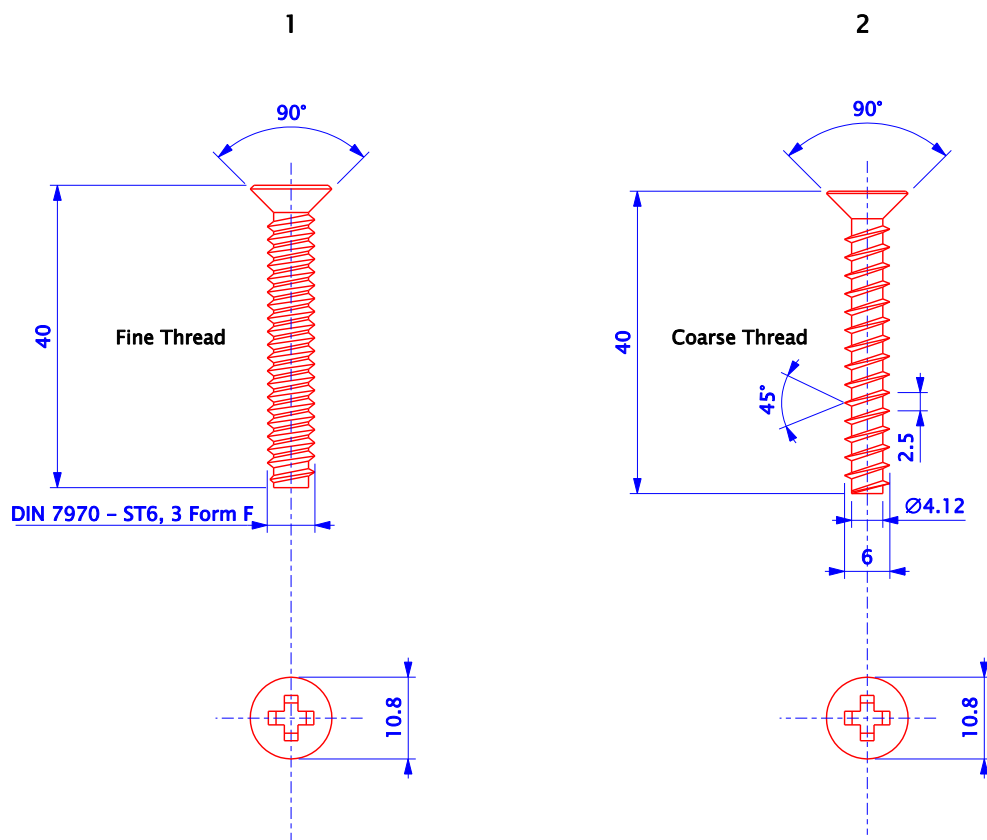
Product range: CFG
Description: Countersunk head, Phillips No.2 recess, with single deep thread and gimlet point.
Application: Hardware to unreinforced PVCu windows and doors
CFG 4.3 x **16 20 25 30 35 45 55 65**
Finish Z/Y/S Quantity per box 1,000
e.g. CFG 4.3 x 25 Y



Product range: CSR
Description: Countersunk head, Phillips No.2 recess, with self tapping thread and self drilling point.
Application: Hardware to reinforced PVC-U windows and doors.
CSR 3.9 x **13 16 19 25 32 38 45**
Finish Z/Y/S Quantity per box 1,000
e.g. CSR 3.9 x 25 Y

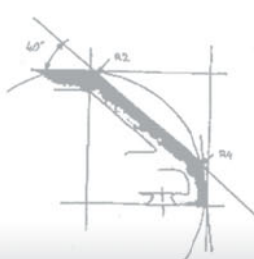
These are the screws supplied with the Dr. Hahn KT-E door hinge.

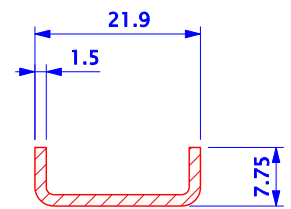
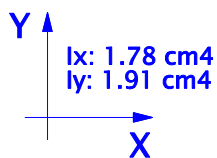
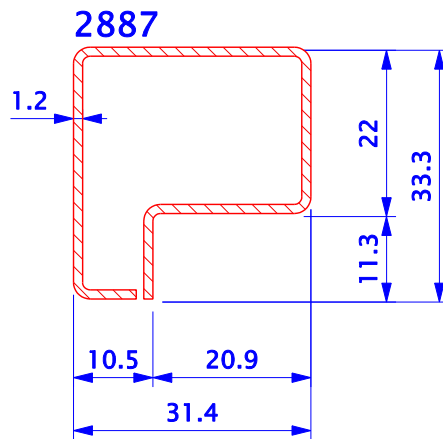
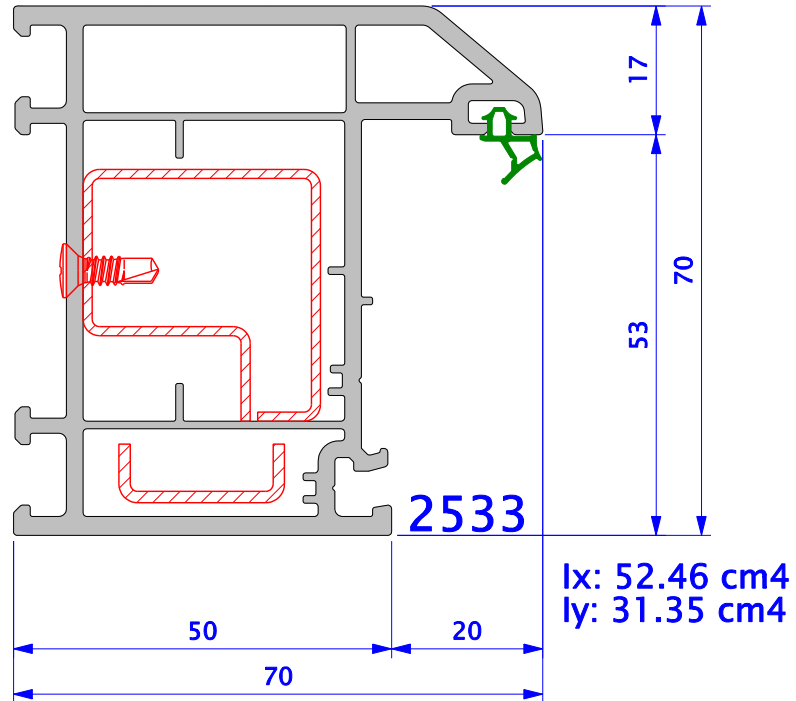
1. Screws with the finer thread should be used for fixing the hinge to the outer frame.
2. Screws with the coarser thread should be used for fixing the hinge to the sash.



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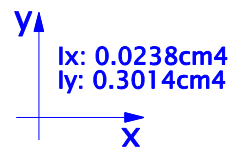
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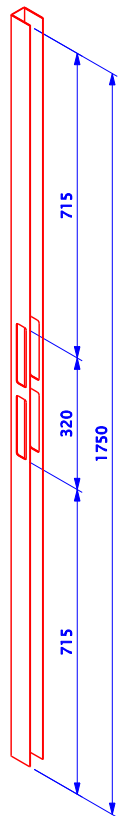
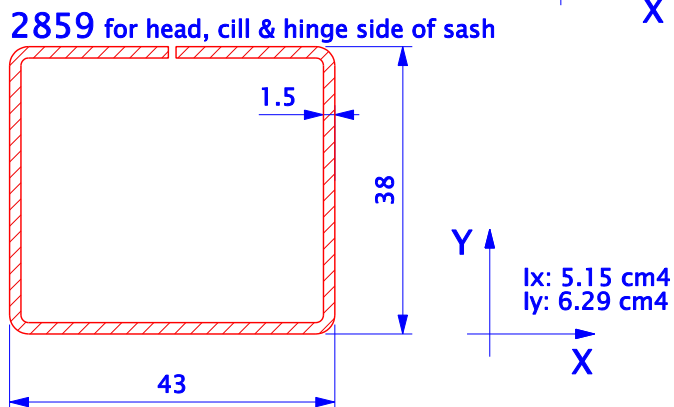
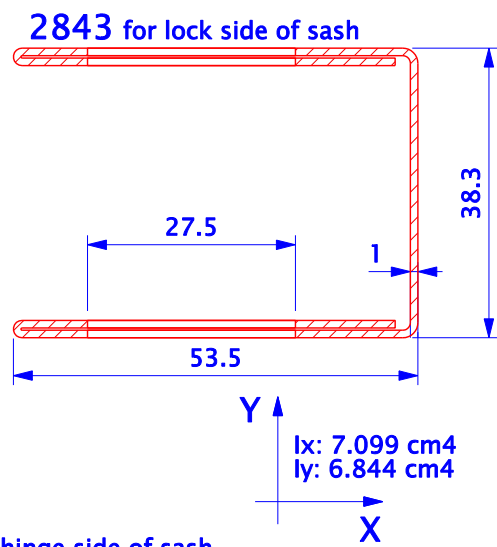
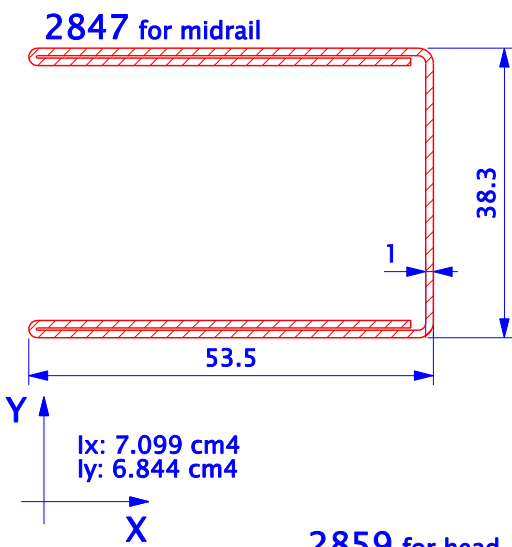
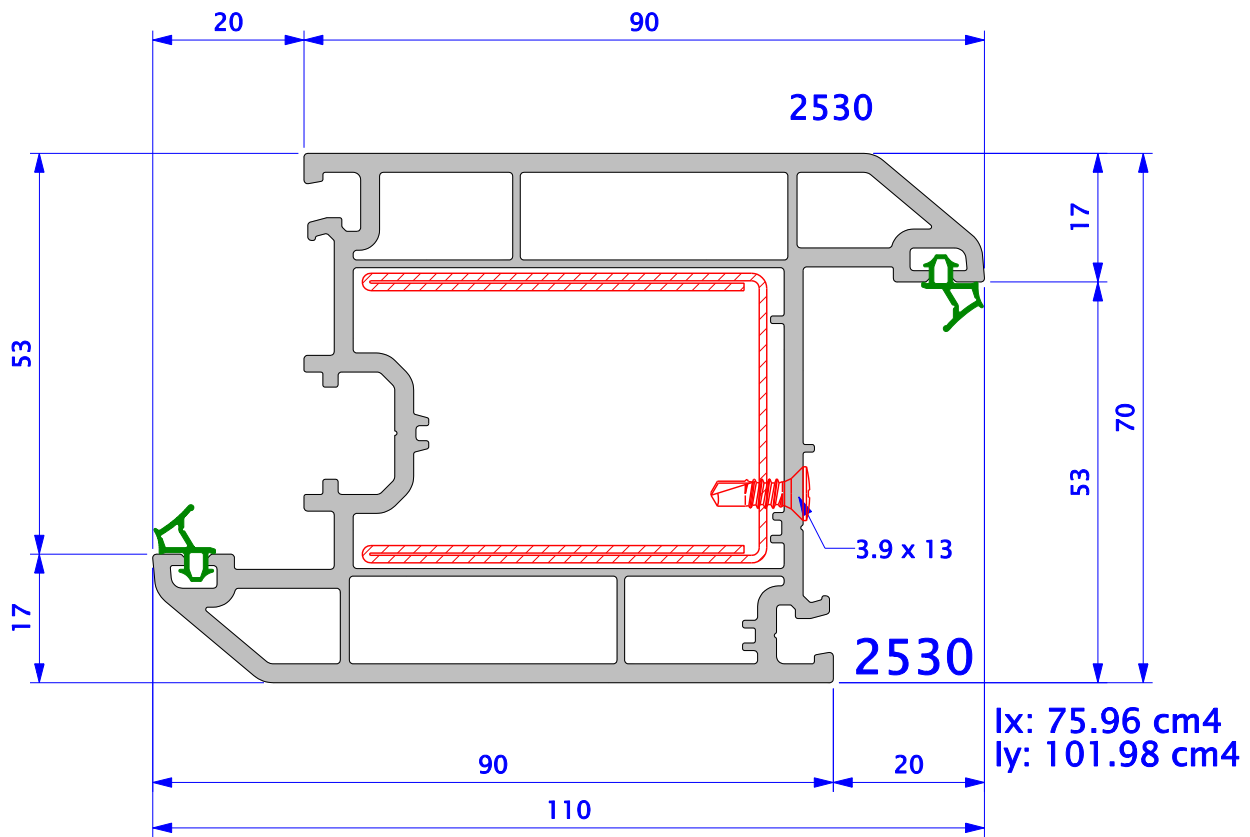


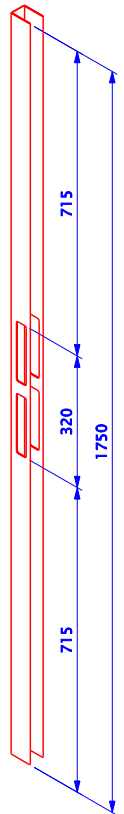
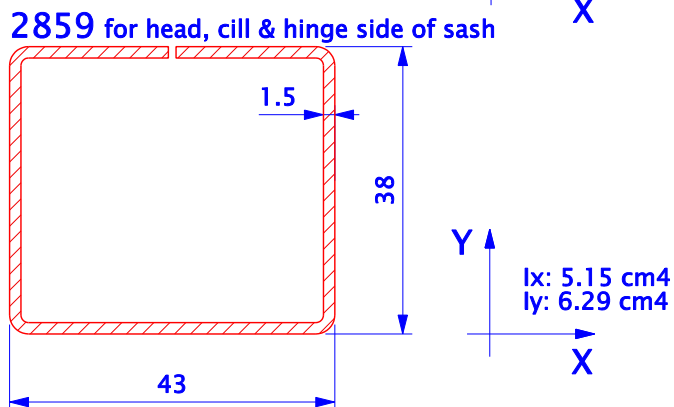
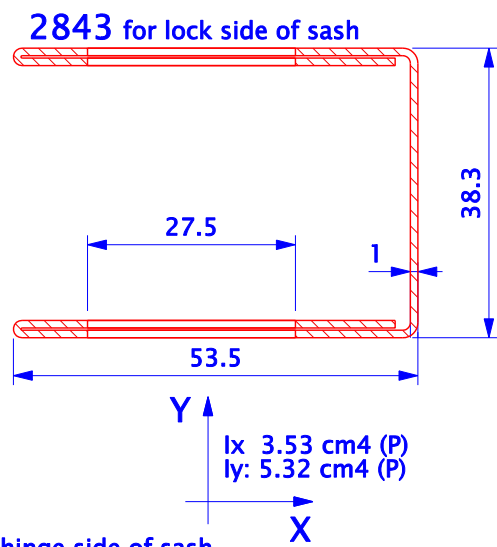
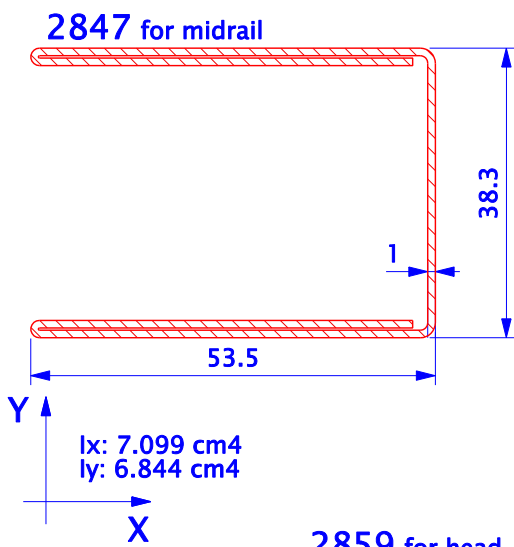
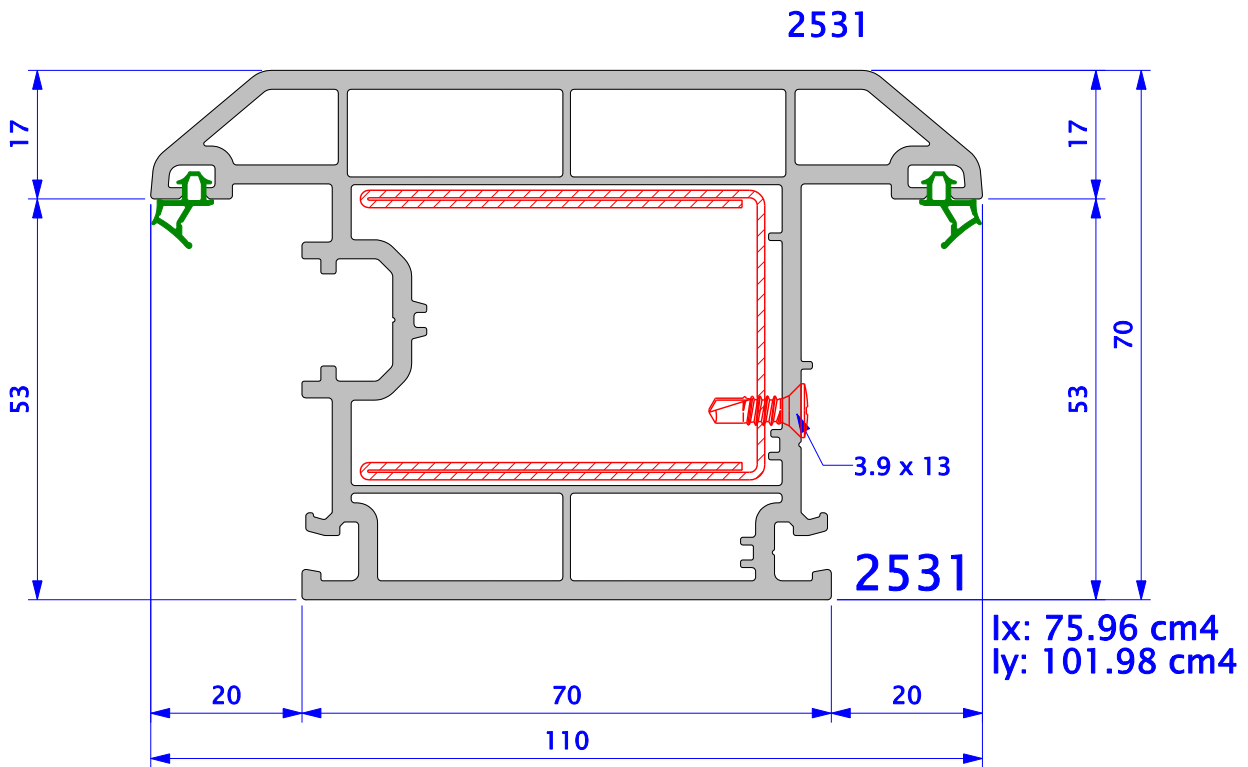


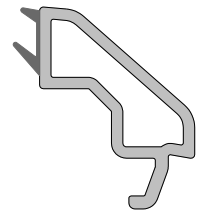
Optional reinforcement for additional strength. Not compulsory for PAS 23/24 test

3386

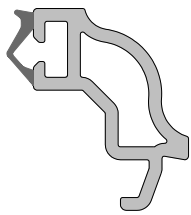




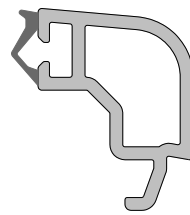




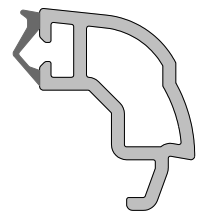
2540
28mm bead
Chamfered



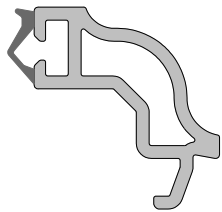
3027
28mm bead
Retro



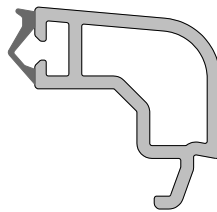
3028
28mm bead
Standard



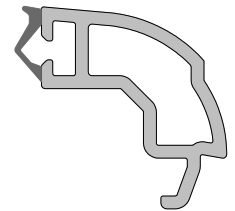
3029
28mm bead
Contemporary



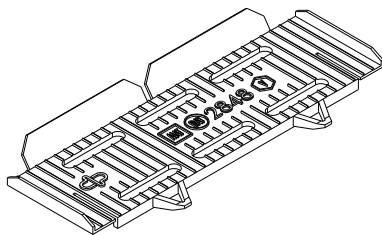
3033
24mm bead
Retro



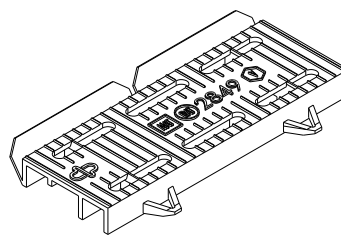
3024
24mm bead
Standard



3034
24mm bead
Contemporary



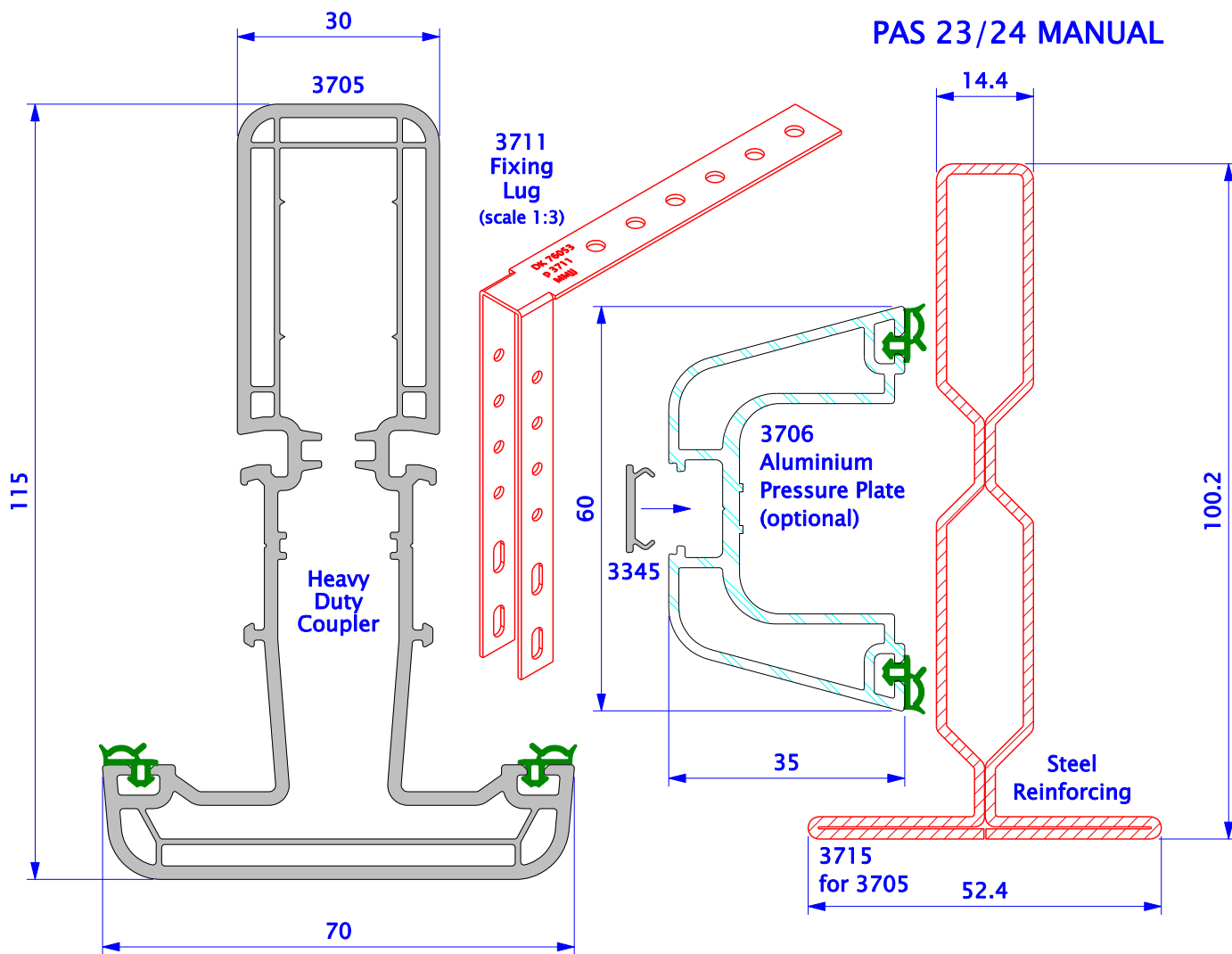
2848
Glazing Block



2849
Glazing Block

Profile Guide

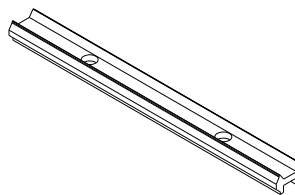
PAS 23/24 MANUAL



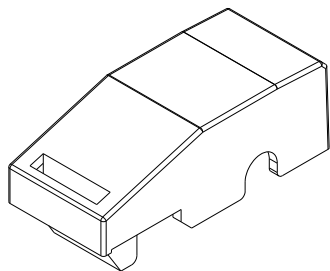
3808
Frame Seal
for use with
3705 Coupler



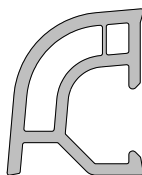
943
Screw-On Stud
for
3306



953
Aluminium
Rail
for 3306



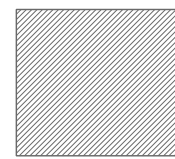
DRB001
Anti-Jemmy/
Lifting Wedge
(Window Widgets Product)



3066
Clip-On
Drip Rail



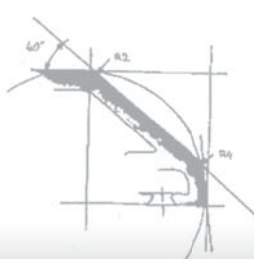
3266
End Cap
for
3306 Drip Rail



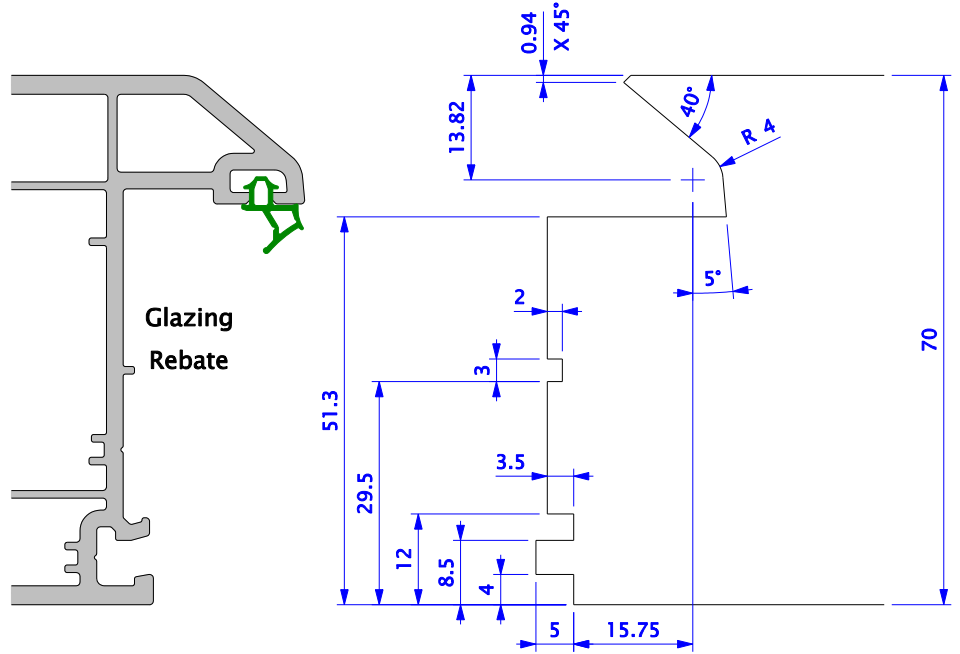
2559
Polyethylene Block for
mechanically joined midrail
(2531)

PAS23/24

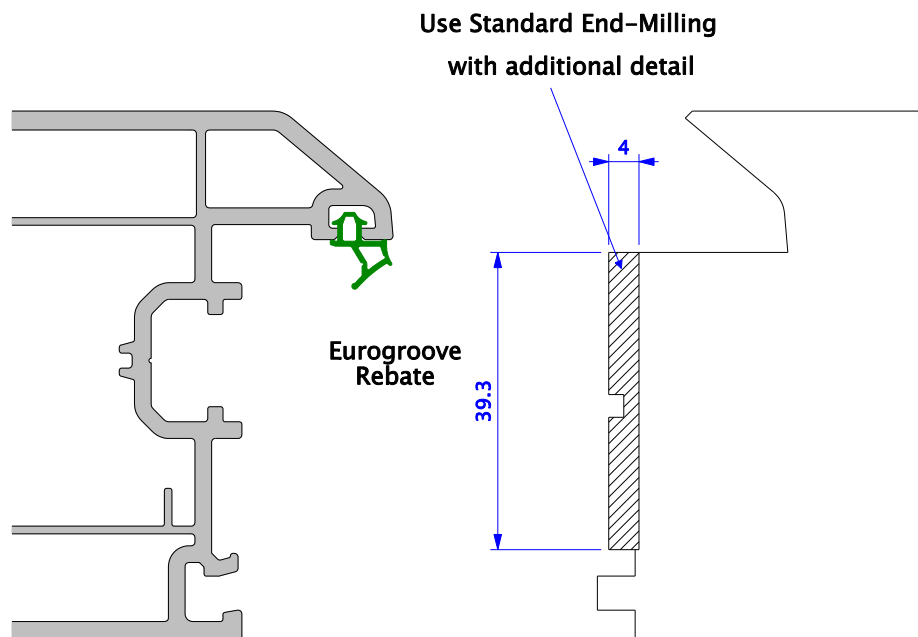
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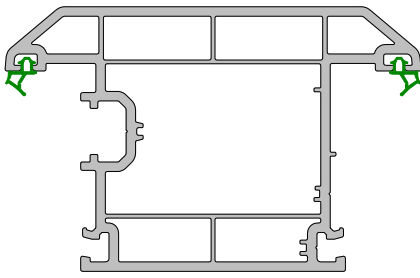


Standard End-Milling

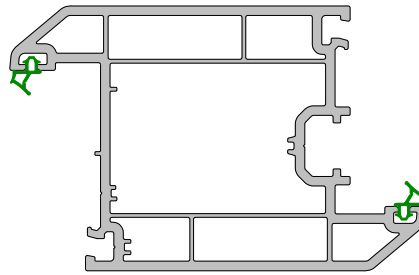


Eurogroove Rebate End-Milling



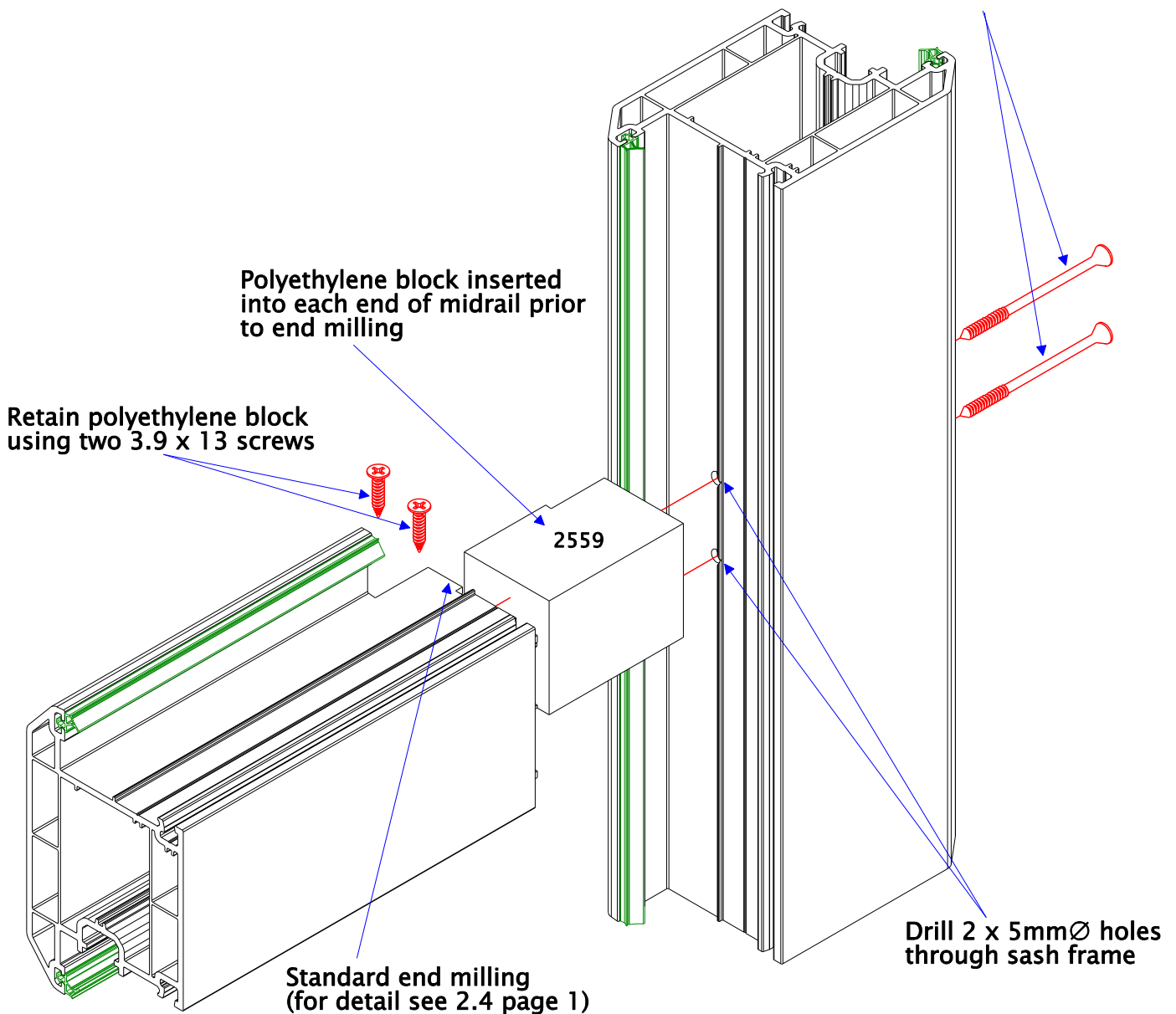


2531
Midrail



2530
Sash Frame

Screw through sash frame
into polyethylene block using
two 4.8 x 95 element screws

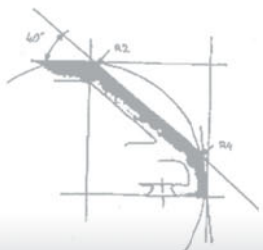


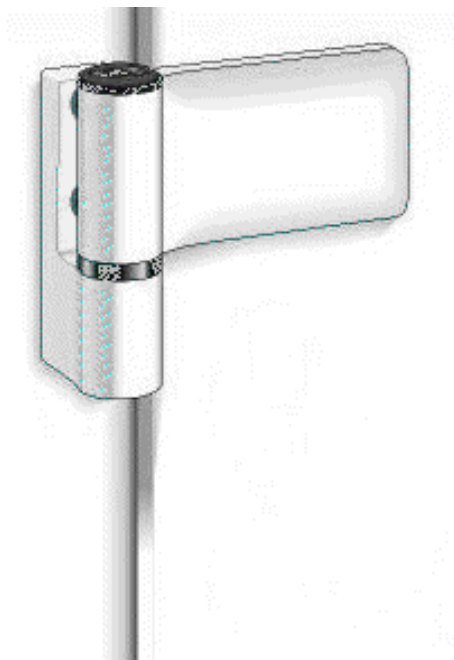
IMPORTANT NOTE:

All mechanical joints should be sealed
against the ingress of water, using a
good quality silicone sealant.

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KT-E K201_0008

Available via Winkhaus

TEL :01536 316000

FAX :01536 416516

DESCRIPTION

'Hahn KT-E'

Universal hinge from aluminium for plastic doors

Direct mounting on frame and door

For upstand ranges from 15 to 23mm.

Variable adjustment in 5 directions with door mounted on hinges

Variable horizontal adjustment +/- 5mm

Variable vertical adjustment + 3mm

Adjustment of sealing pressure, in small steps within the upstand range

Tested in accordance with RAL-RG 607/8: II / 100kg (K-H / K-H) *



The lock required for PAS 23/24 is the standard GTS Door Lock (Part No. 56231) 35mm backset.

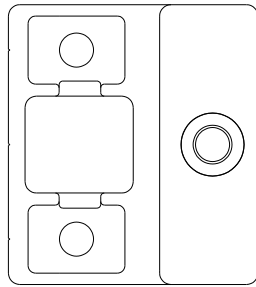
Kit consists of:
Handle Operated Latch/Dead Lock
2 No. Hook Bolts
2 No. Mushroom Cams



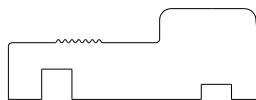
Top Shoot Bolt
(Part No. 55209)

Available via MACO

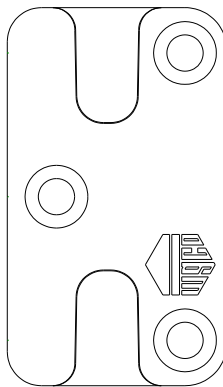
TEL: 01795 433900
FAX: 01795 433901



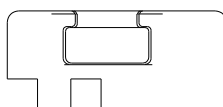
354046



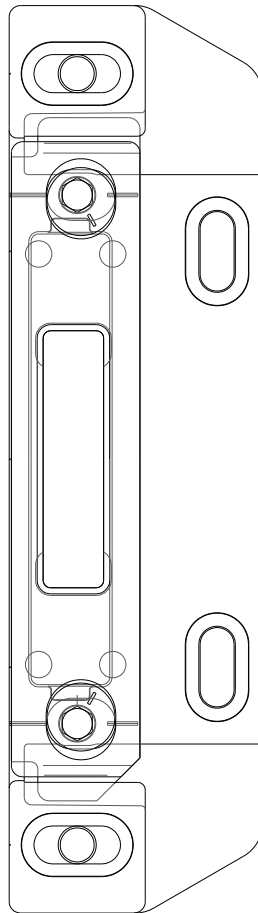
Single Slot
Shootbolt Striker



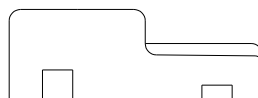
96470



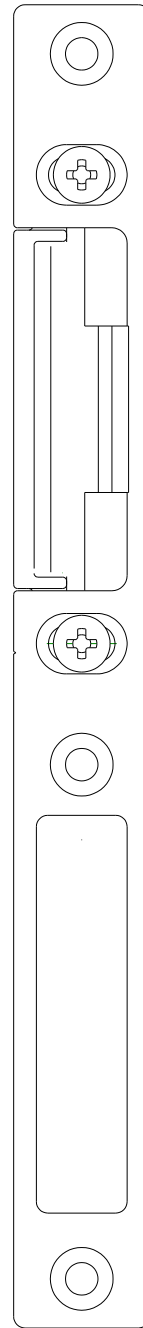
i.S. Mushroom
Striker



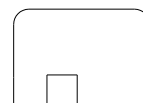
29949



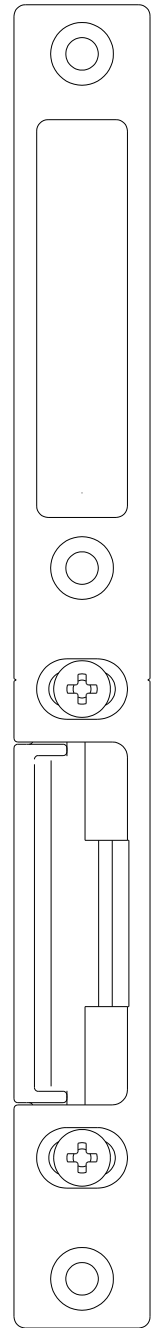
Hookbolt
Striker



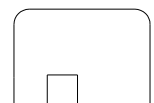
26983



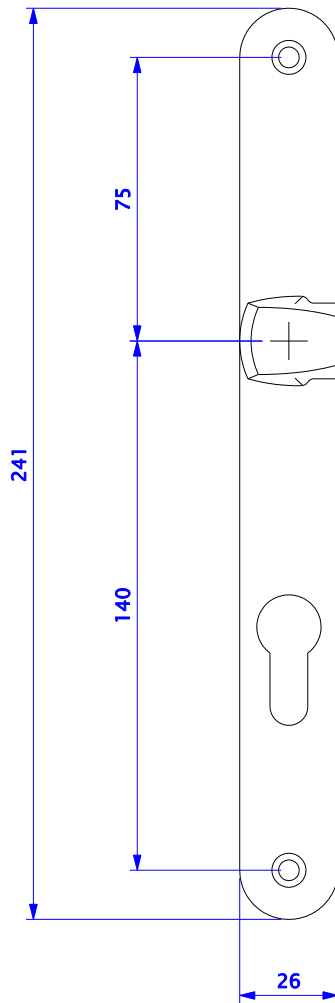
Latch Plate
Left hand



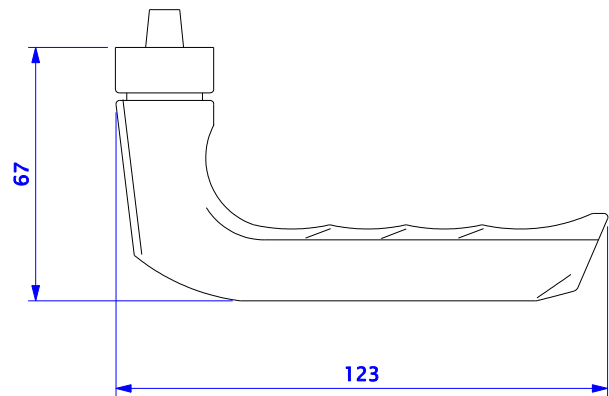
26982



Latch Plate
Right hand



Hoppe Part Number – 113/3623N
For Eurocylinder.





212 Double Profile Cylinder

Technical InformationMaterial Spec.

Cylinder Body & Plug
Key
Pin, Standard & Mushroom Driver
Spring
Cam & Coupling
Inside Coupling Rivet
Circlip Retainer
Fixing Screw

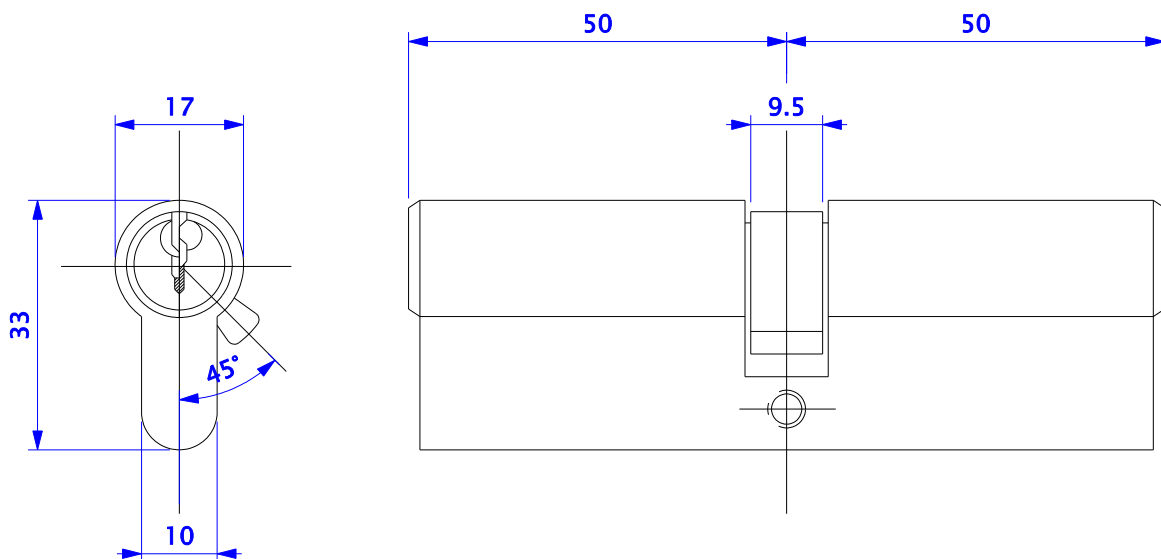
Standard

Hot drawn brass bar CW614N M-S to EN 12167:98
Roller brass strip CW612N H 150 TO EN 1652:97
Hot drawn brass bar CW612N NM
Inox Steel X10CrNi to ISO 6931-1:94
Sintered steel SINTC11 to DINV30910
Steel CB4FF to UNI 7356-74
Steel C72 to UNI EN 10270/1
Steel CB4FF to UNI 7356-74

Box Qty

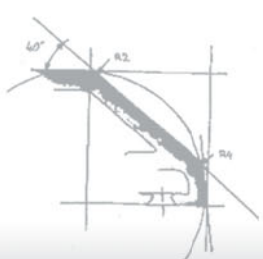
10

- ⇒ 5 pin double profile cylinder
- ⇒ Successfully tested to EN 1303 : 1998 – Building Hardware–
Cylinders for Locks – Requirements and test methods
- ⇒ EN 1303 Classification: 16 – 0 – 13
- ⇒ Available in a range of lengths to suit all major door profiles
- ⇒ Cylinder in nickle plated brass or polished brass finish
- ⇒ Supplied with M5 X 80mm nickle plated or polished brass screw
- ⇒ Supplied with three keys



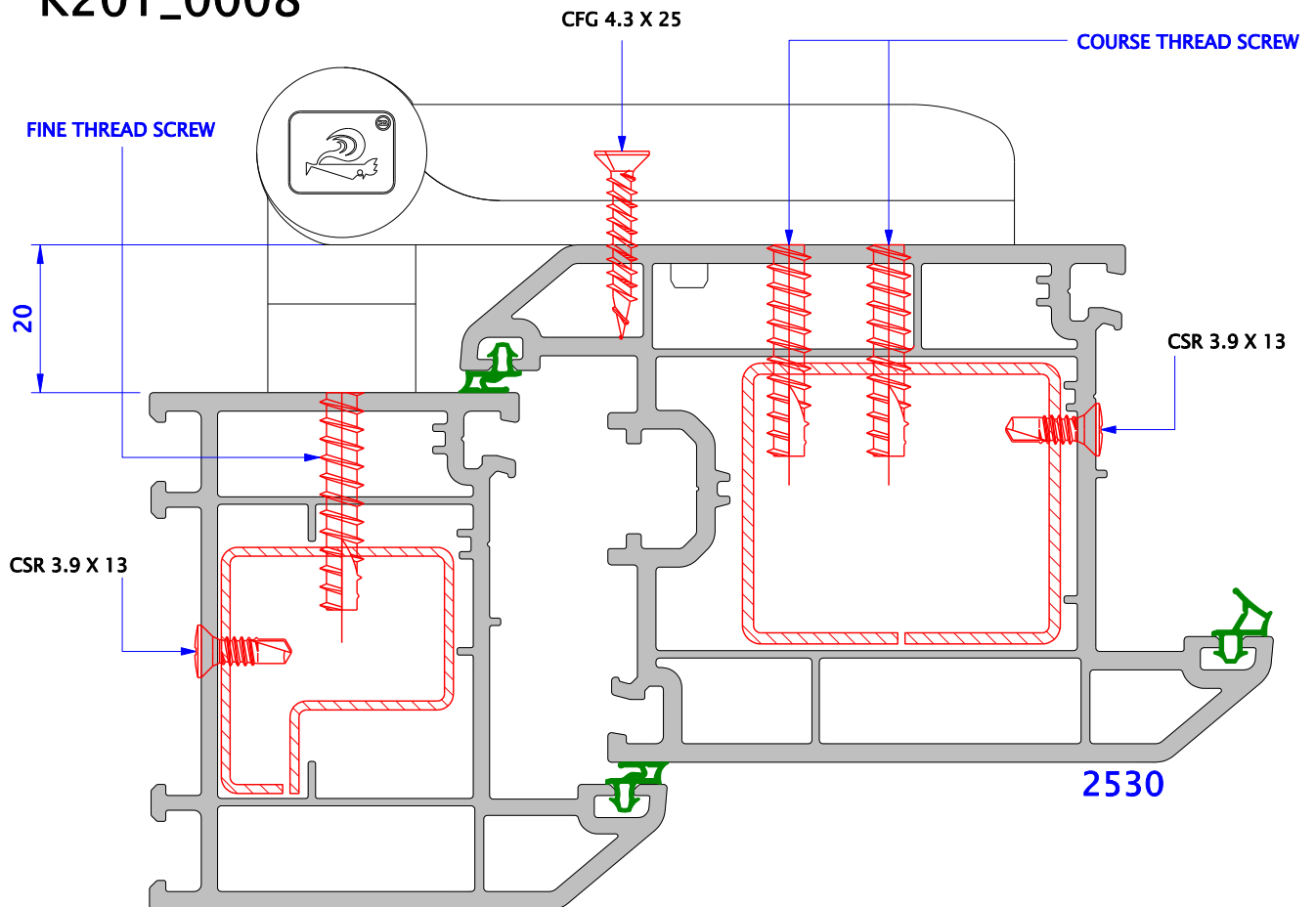
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KT-E TYPE HINGE K201_0008



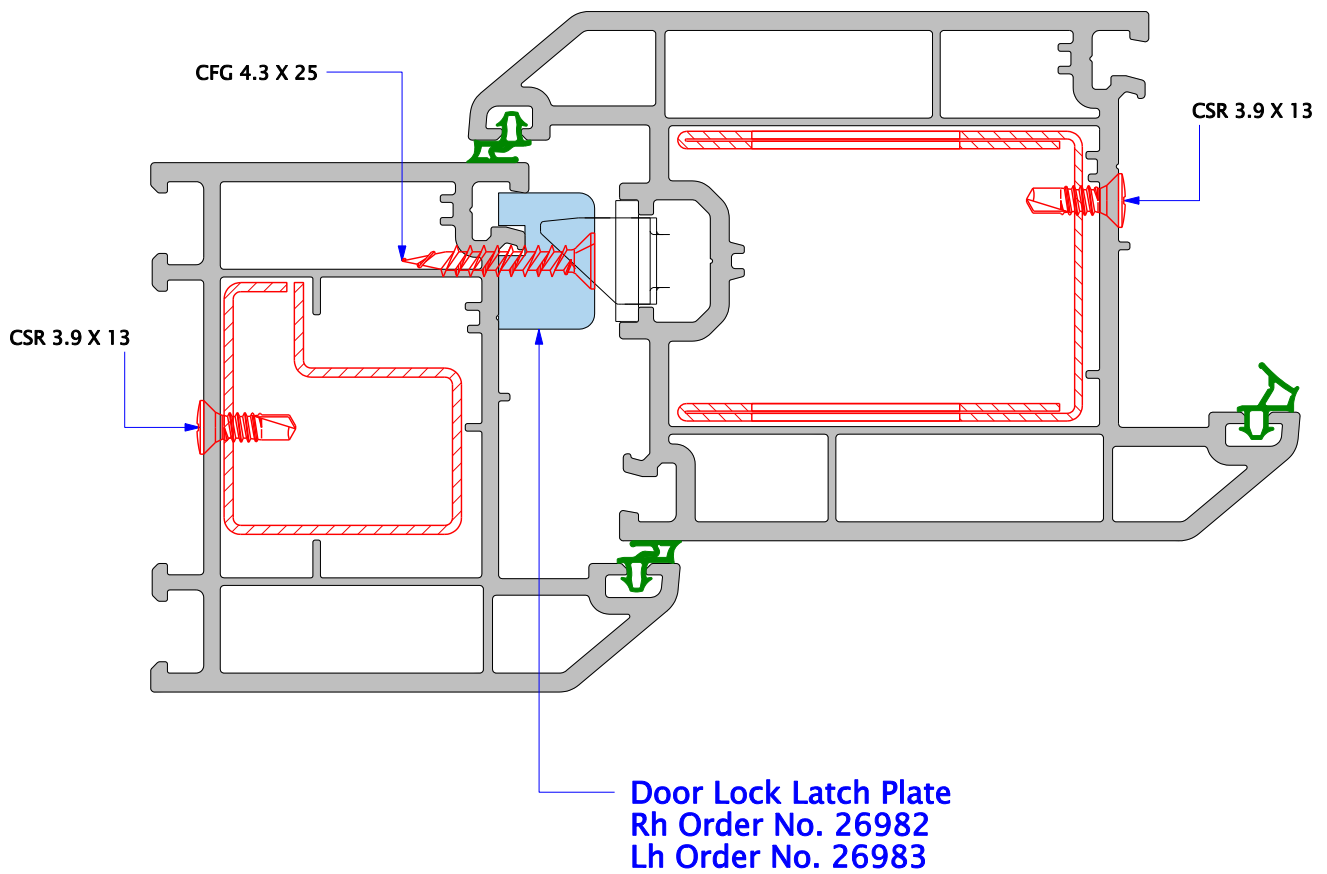
Hinge positions on door

Always fit a minimum of 3 hinges per door.

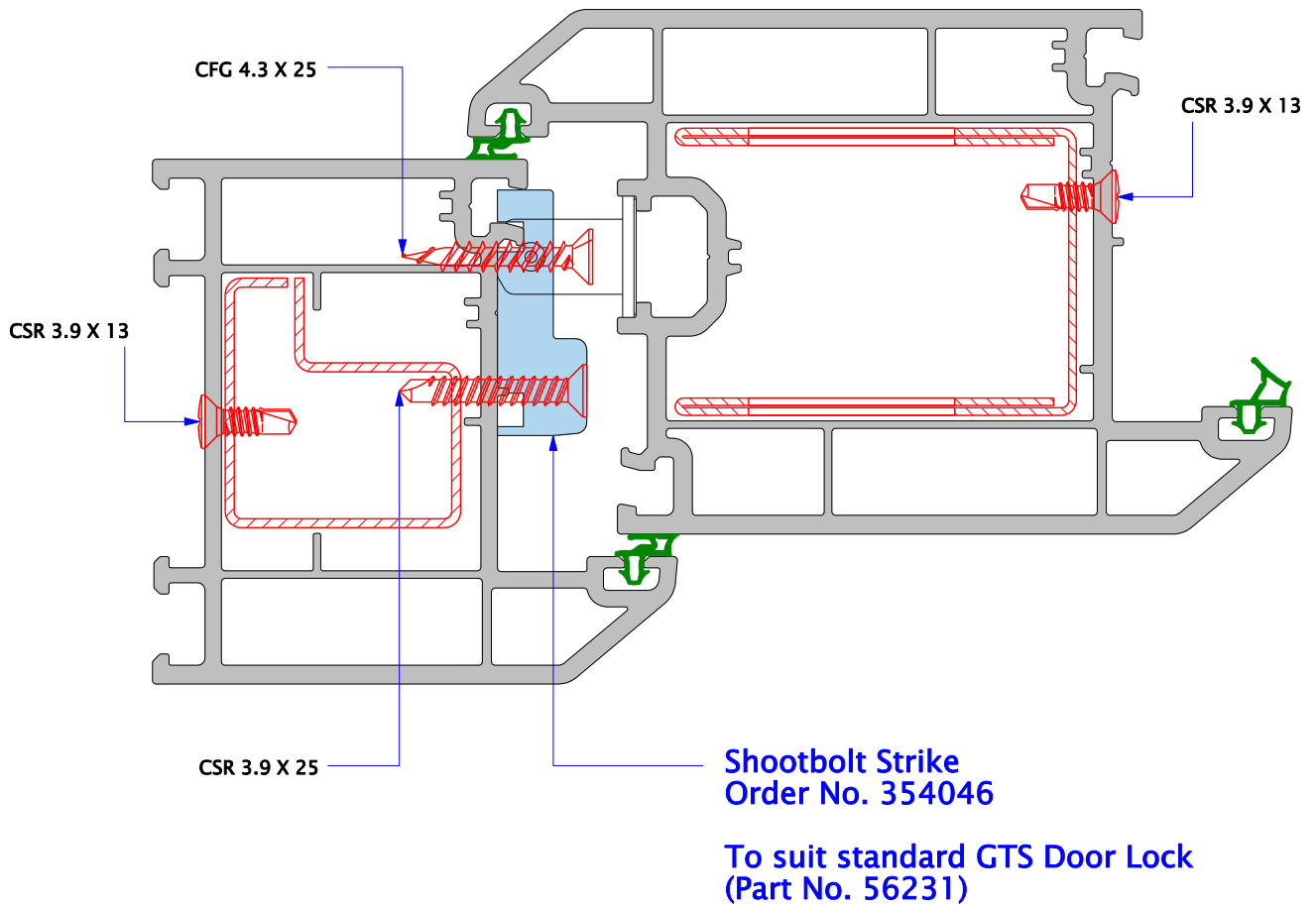
Top and bottom hinges should be fitted at approximately 250mm from the top and bottom of the door to the centre line of the flag

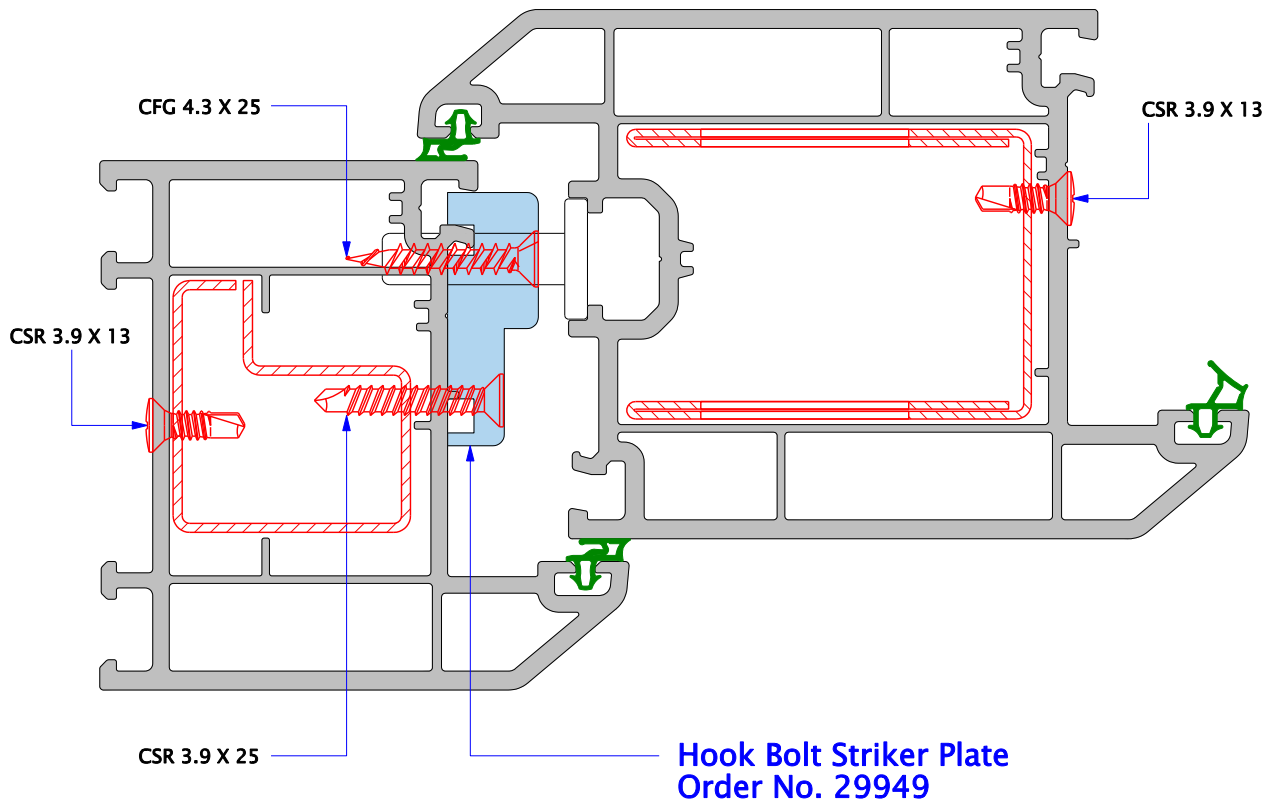
If 3 hinges are fitted the centre hinge should be fitted on the vertical centre line of the door.

If 4 hinges are fitted they should be fitted equally spaced between the top & bottom hinges.



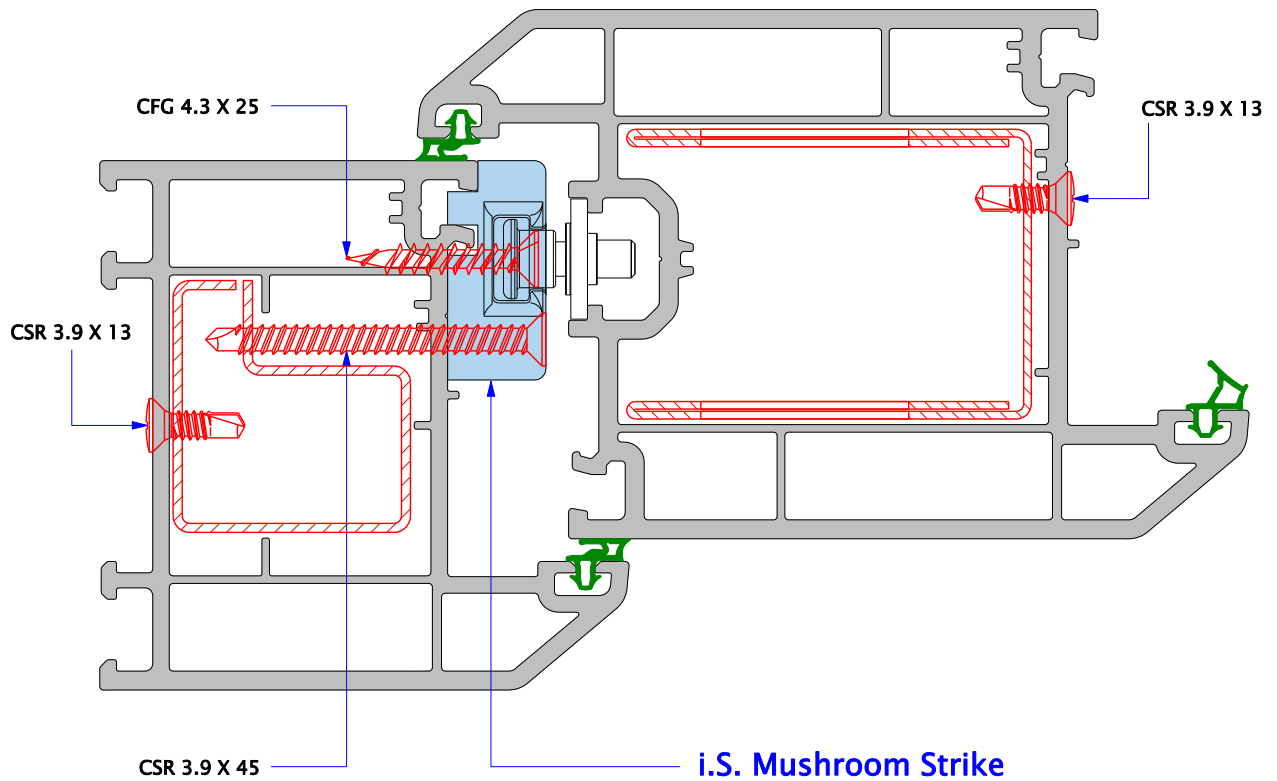
To suit standard GTS Door Lock (Part No. 56231)





Hook Bolt Striker Plate
Order No. 29949

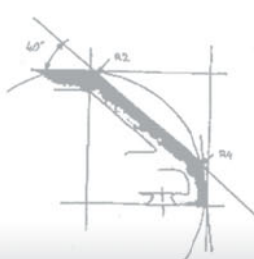
To suit standard GTS Door Lock
(Part No. 56231)



To suit standard GTS Door Lock
(Part No. 56231)

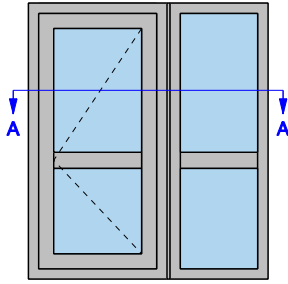
PAS23/24

GENERAL STATEMENT
LIST OF SCREW TYPES
PROFILE GUIDE
MECHANICAL JOINTS
HARDWARE PARTS LIST
FITMENT OF HARDWARE
GENERAL ARRANGEMENTS
GLAZING

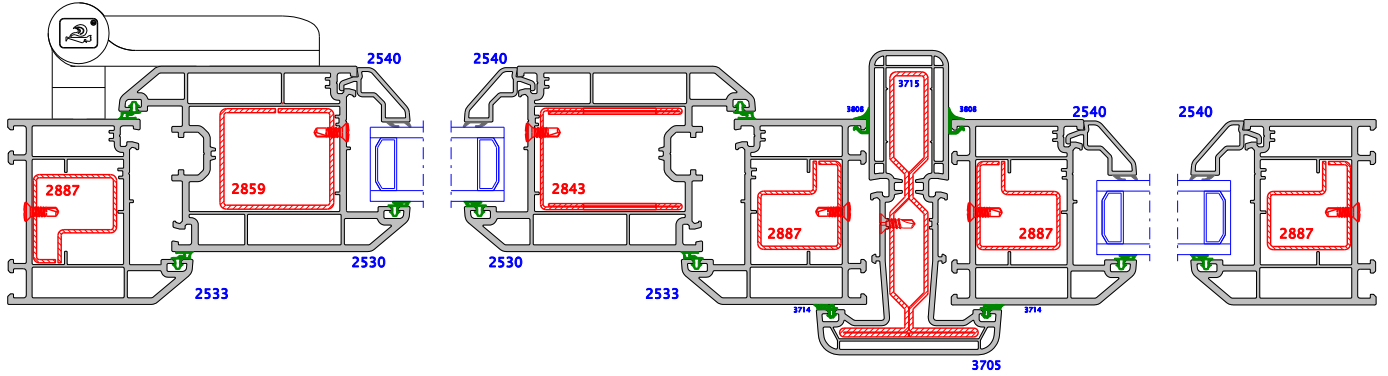


Horizontal Sections

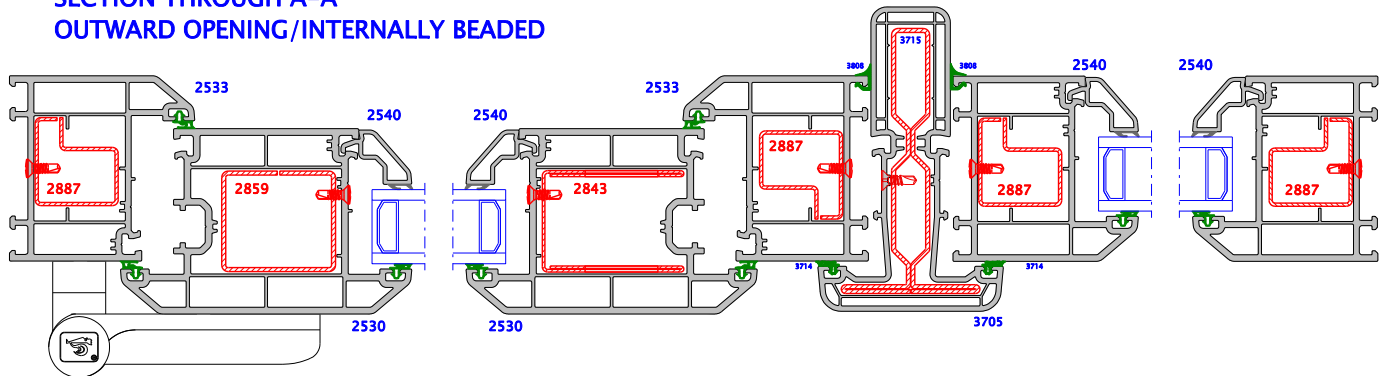
PAS 23/24 MANUAL



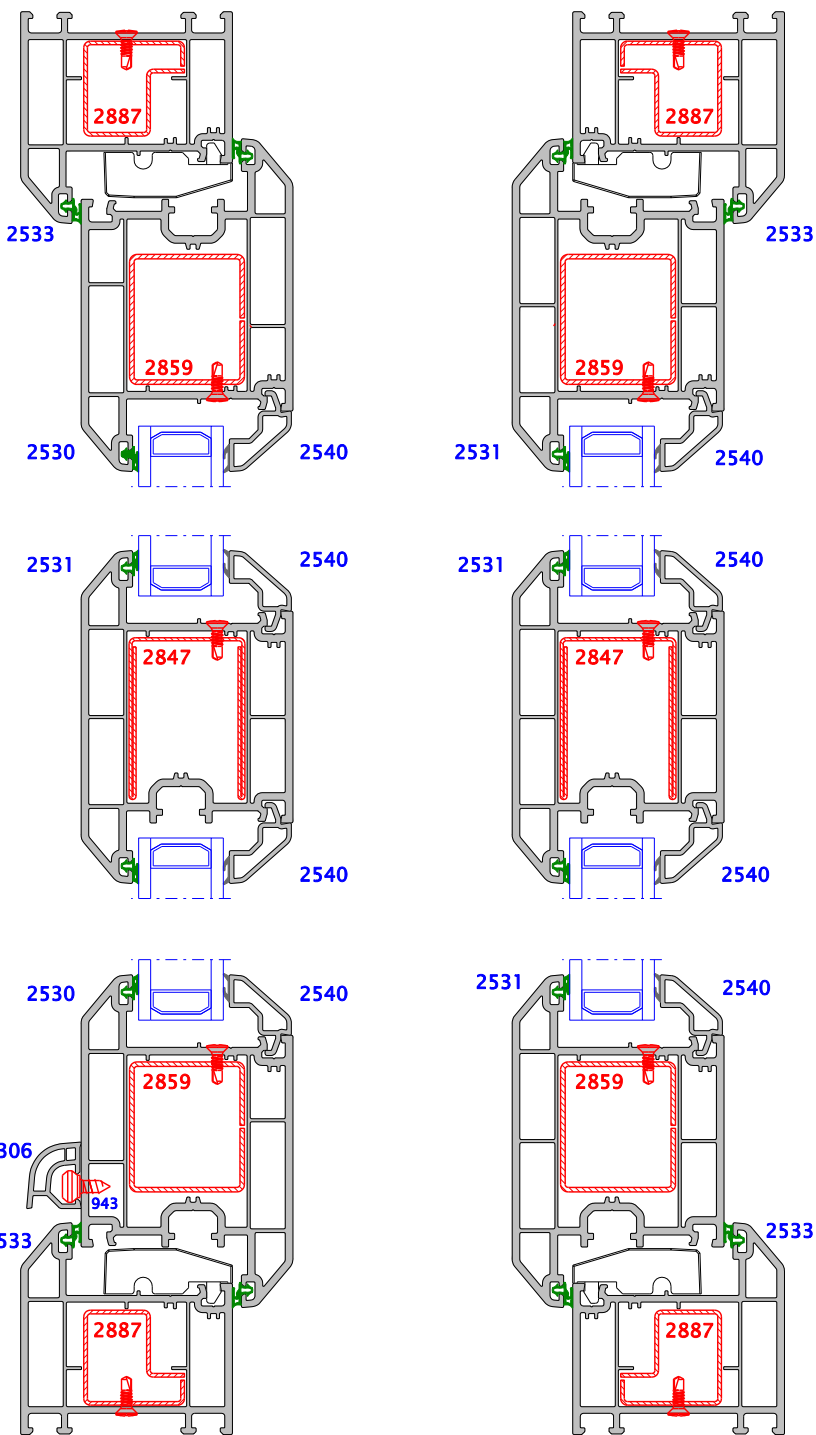
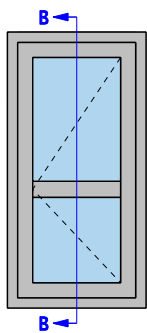
SECTION THROUGH A-A
INWARD OPENING/INTERNALLY BEADED



SECTION THROUGH A-A
OUTWARD OPENING/INTERNALLY BEADED



Vertical Sections

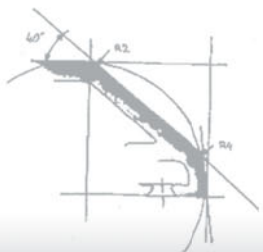


SECTION THROUGH B-B
INWARD OPENING
INTERNALLY BEADED

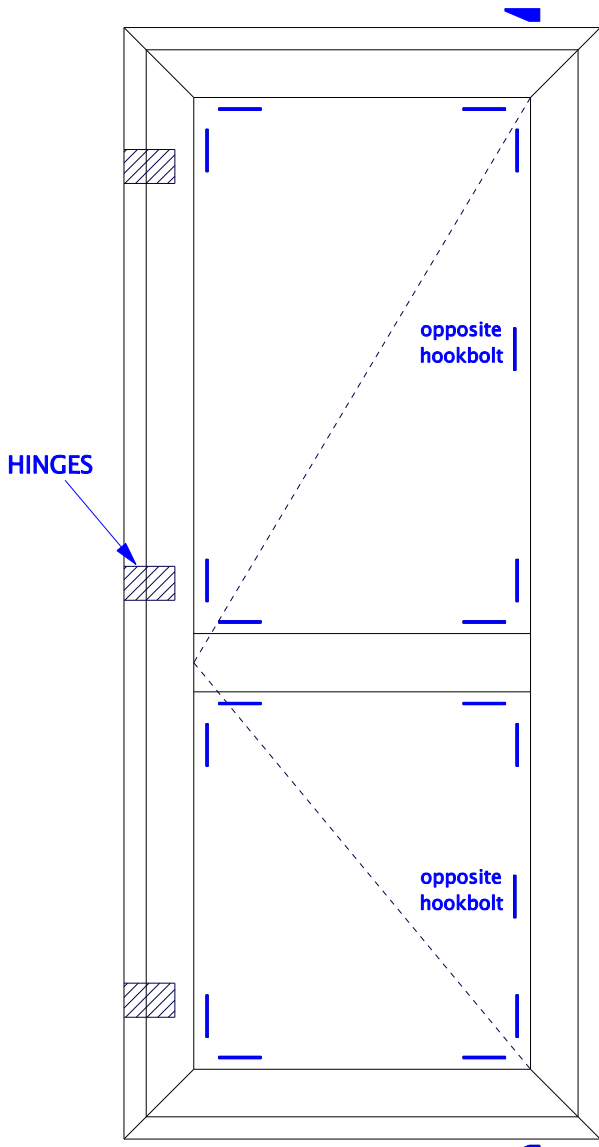
SECTION THROUGH B-B
OUTWARD OPENING
INTERNALLY BEADED

PAS23/24

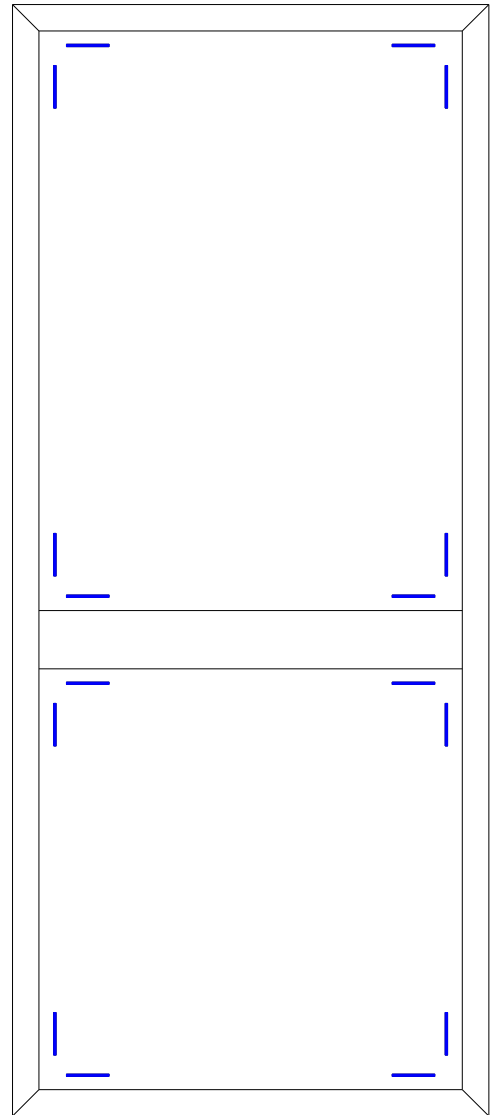
GENERAL STATEMENT
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These diagrams are intended as guidelines only.
 Glazing packers should have maximum centres of 500mm and be a maximum of 150mm from corner of unit.
 Deceuninck recommends the positioning glazing packers behind locking points and hinge bolts.



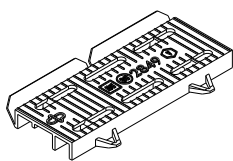
TYPICAL OPENING DOOR



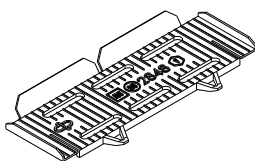
TYPICAL FIXED SIDE PANEL

— GLAZING BLOCKS

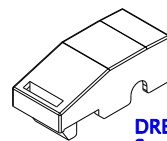
ANTI-JEMMY/
LIFTING WEDGE



2848
(for use at sides of glazing only)



2849
(for use below glazing only)



DRB001
Supplier details:
Window Widgets
(01452) 300912