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Technical Manual

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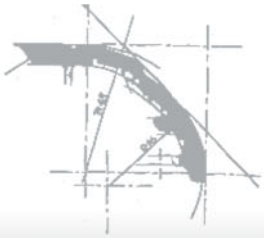
08.08

Technical data

CONTENT



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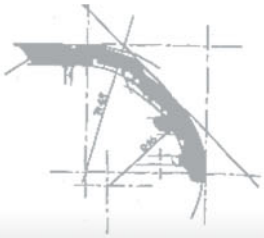
GENERAL

MAIN PROFILES
ACCESSORY PROFILES
PROFILE SHEET
WINDOW & DOOR TYPES



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MAIN PROFILES

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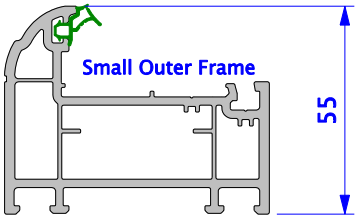

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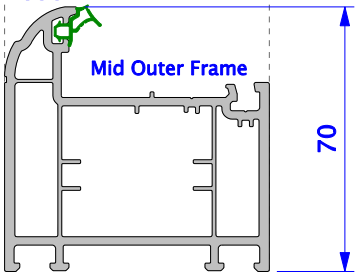

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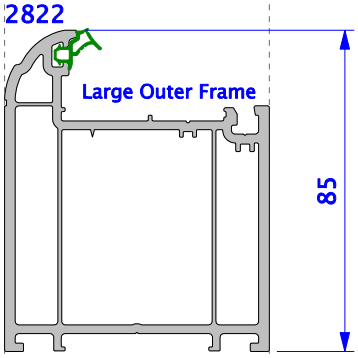

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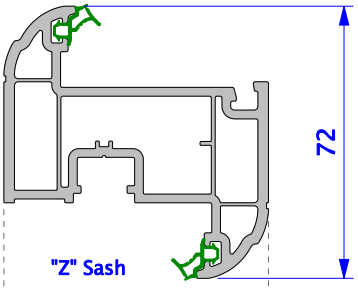

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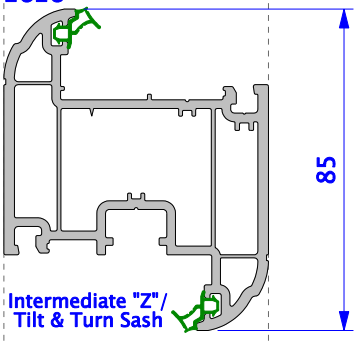

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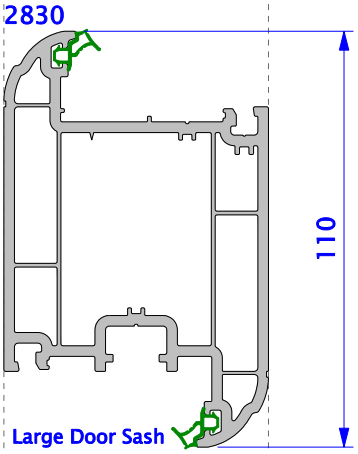

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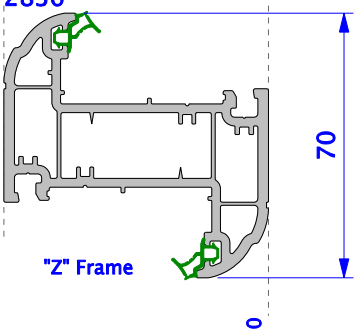

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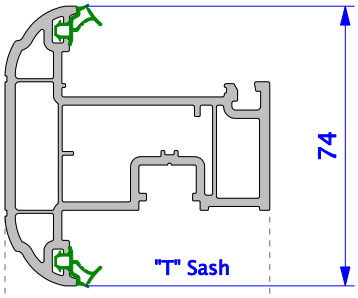

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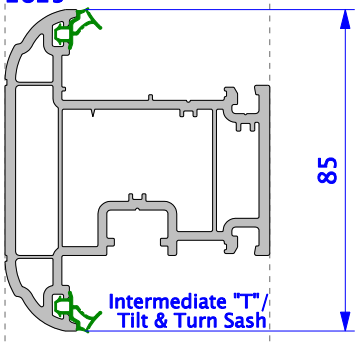

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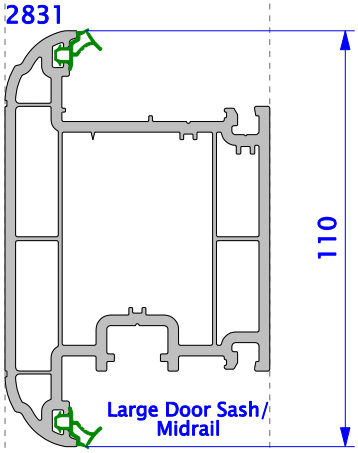

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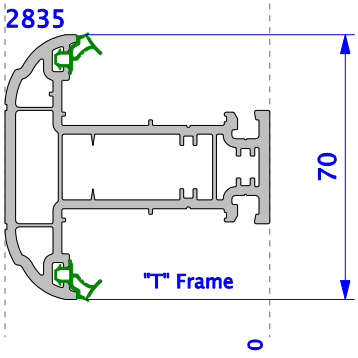

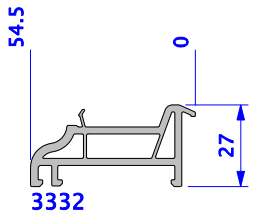
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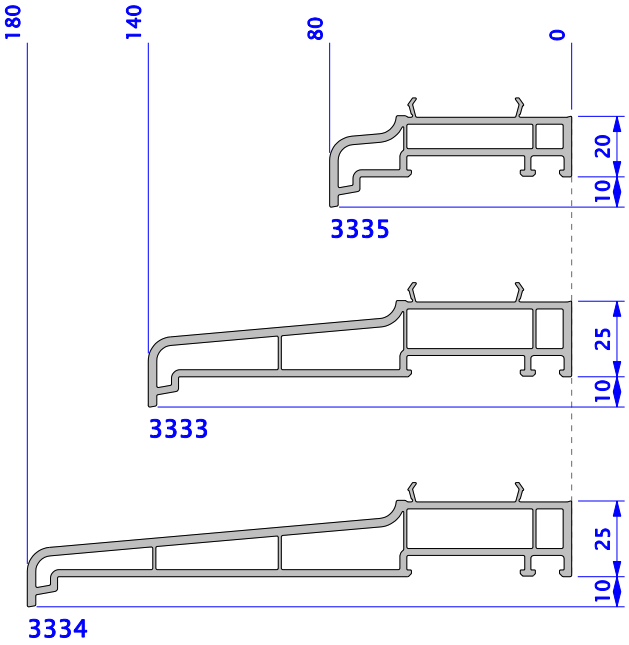
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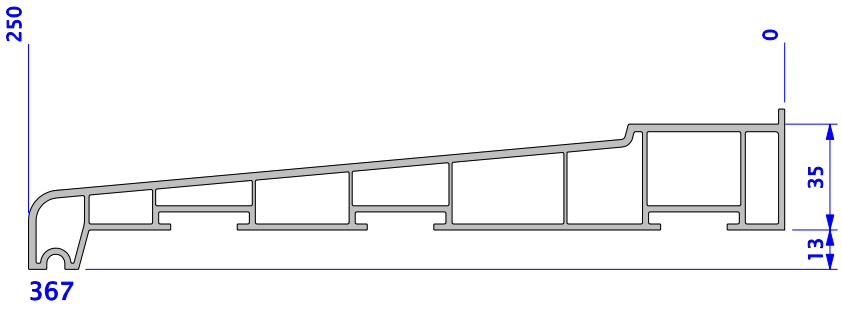
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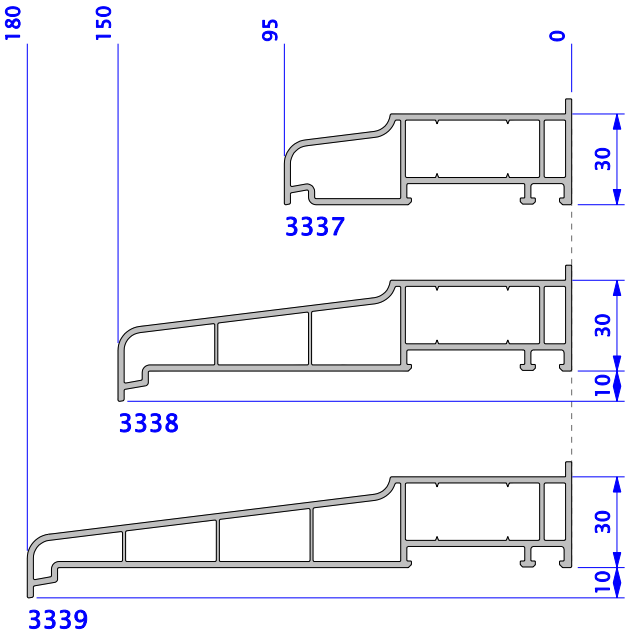
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Glazing beads

See Glazing table: chapter 2.5

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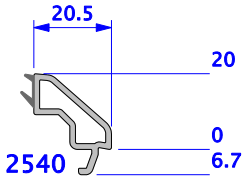

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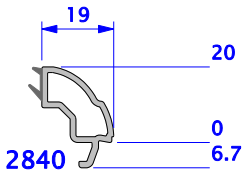

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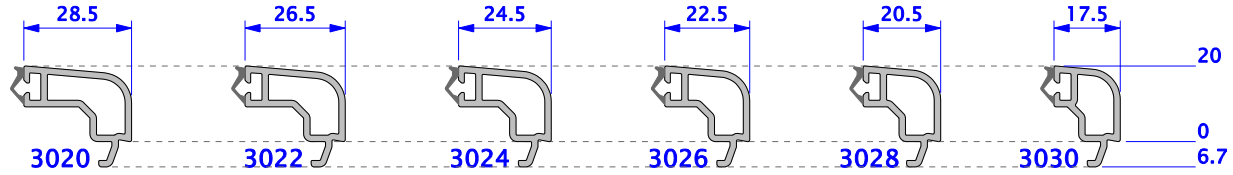

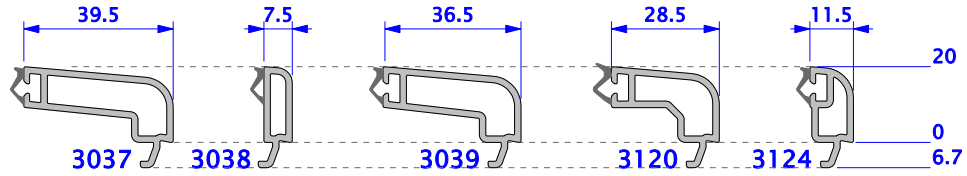

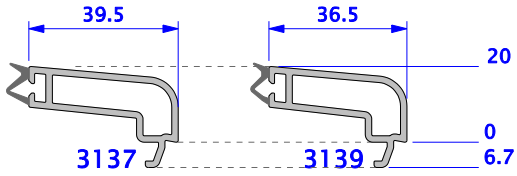

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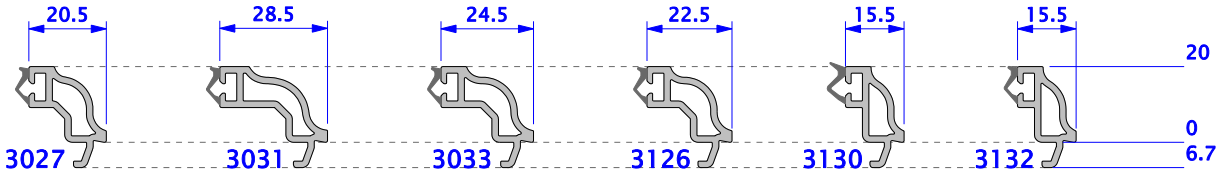

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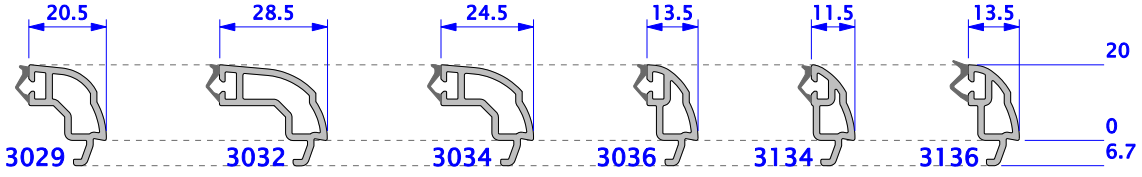
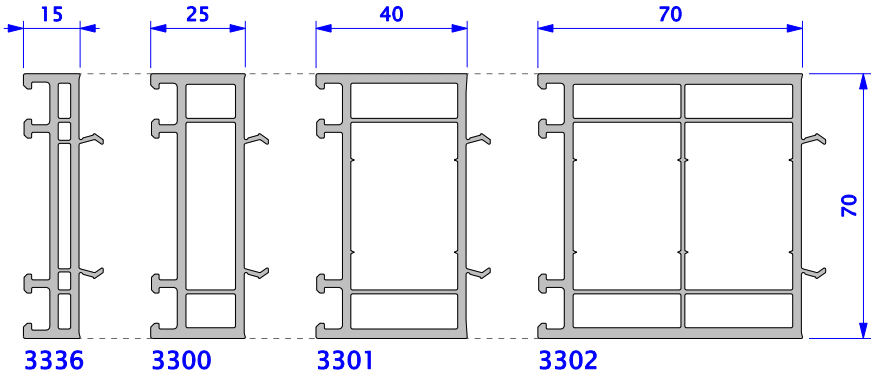
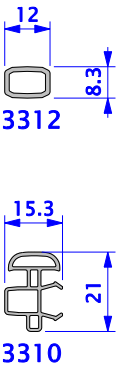
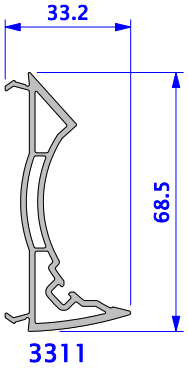


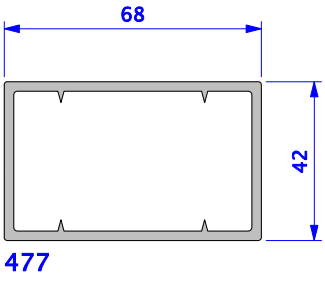
Extension & coupling profiles

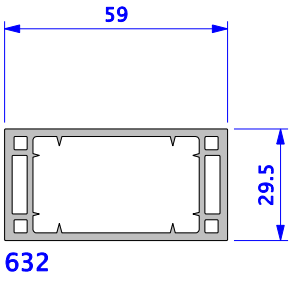
ACCESSORY PROFILES

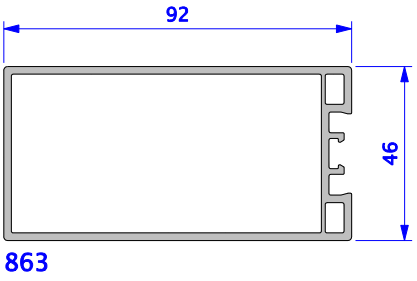


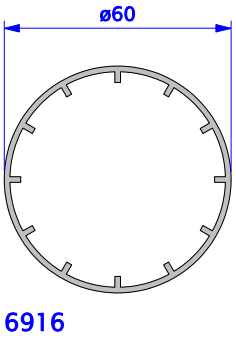


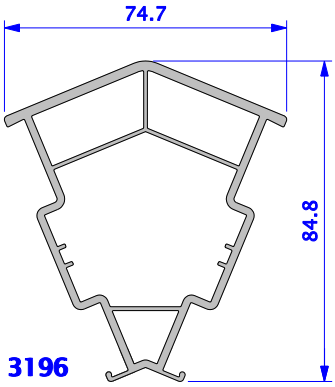


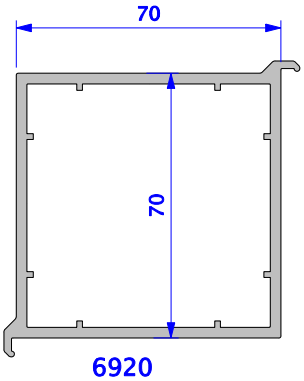


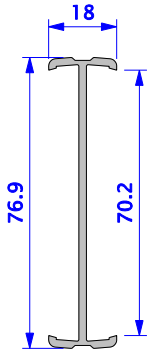


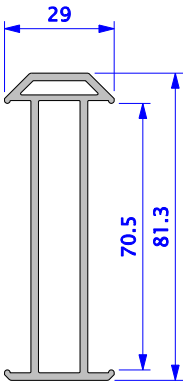


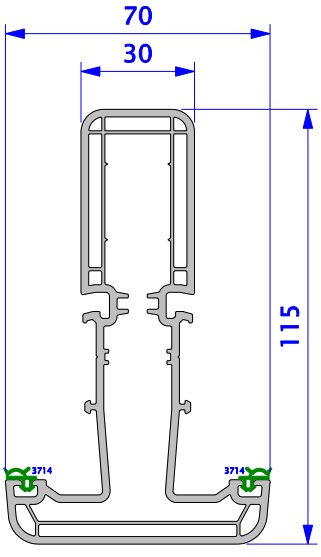


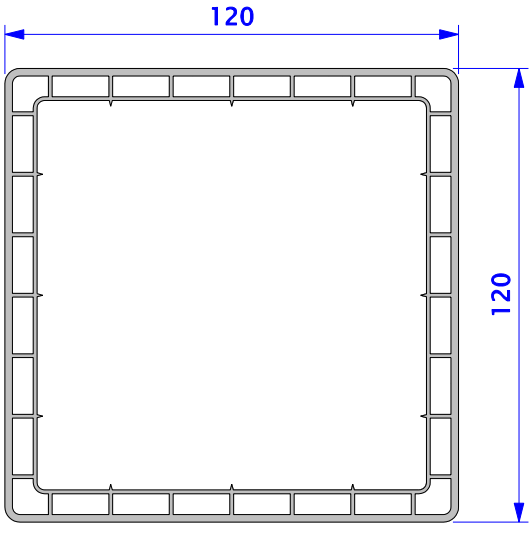


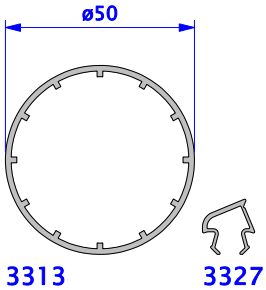


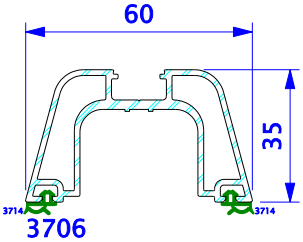


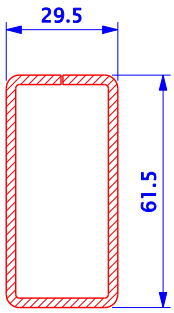












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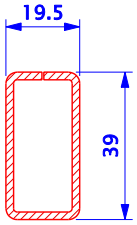

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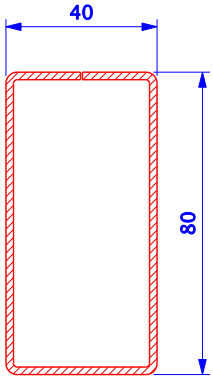

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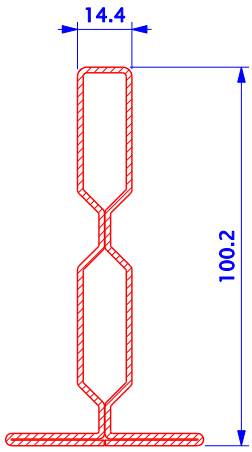

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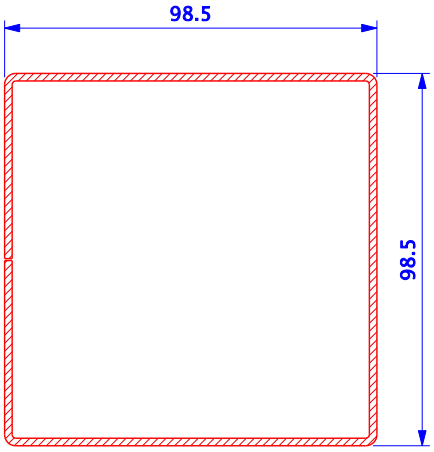

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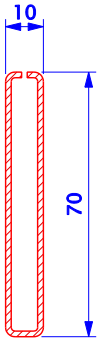

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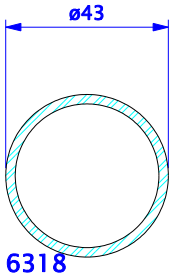

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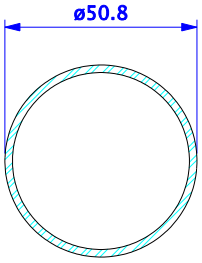

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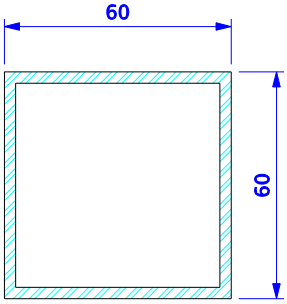

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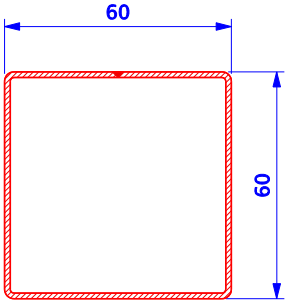

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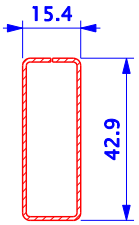

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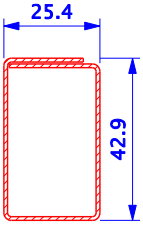

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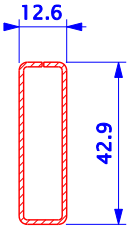

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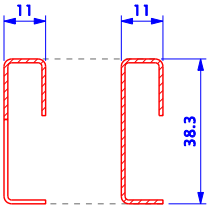

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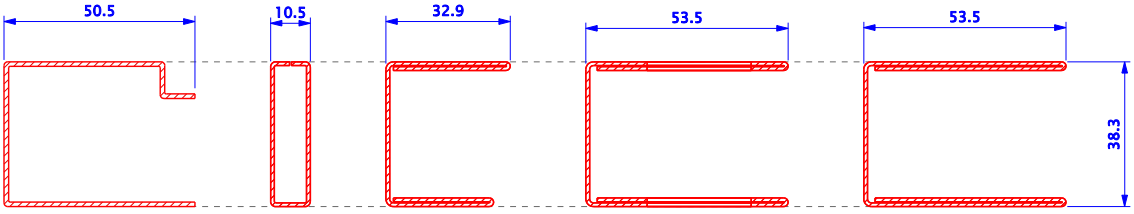

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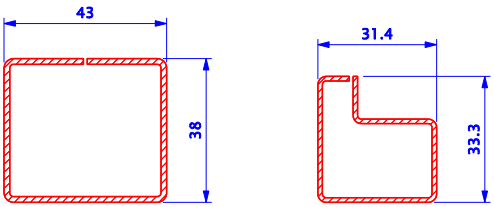

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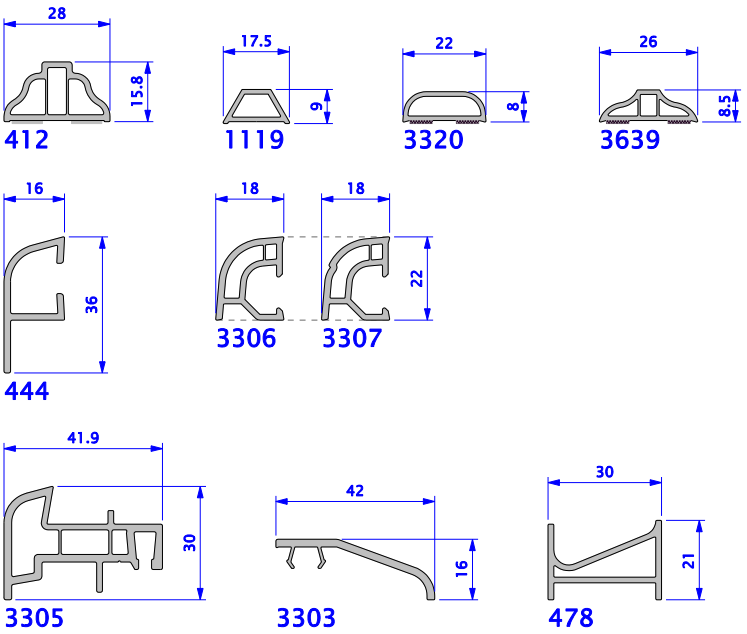
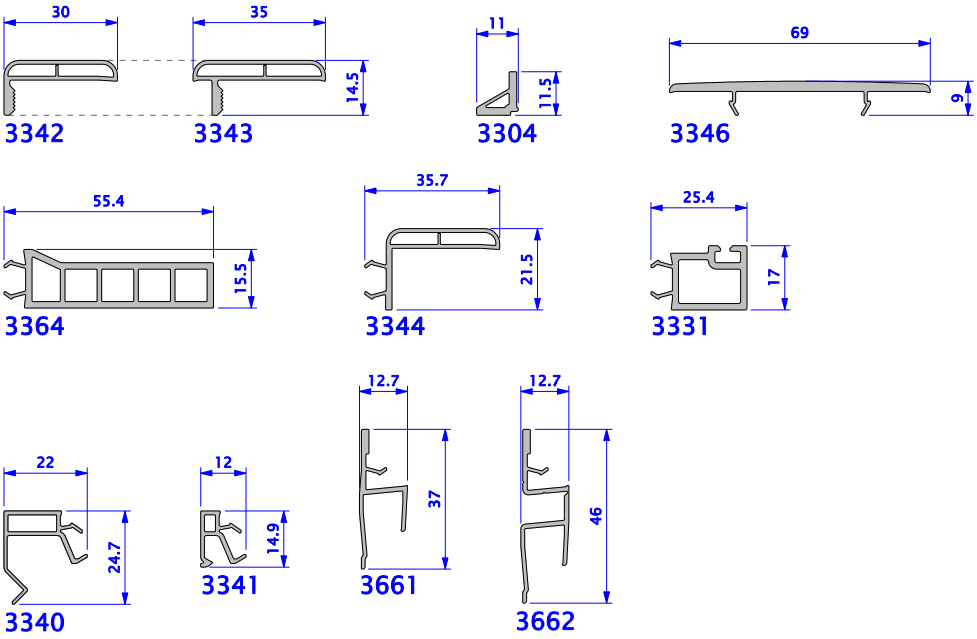
Finishing profiles

Drip rails & georgian bars

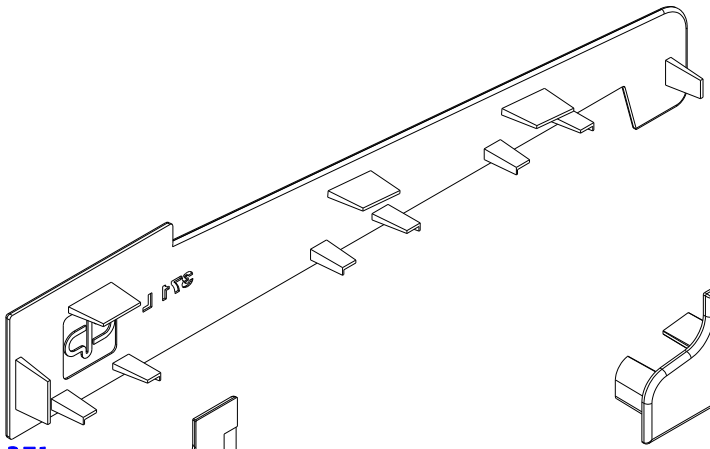


PVC universal



Miscellaneous

ACCESSORY PROFILES



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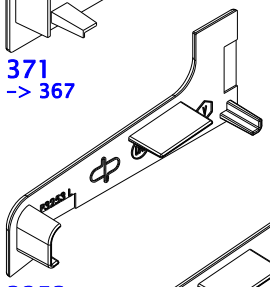

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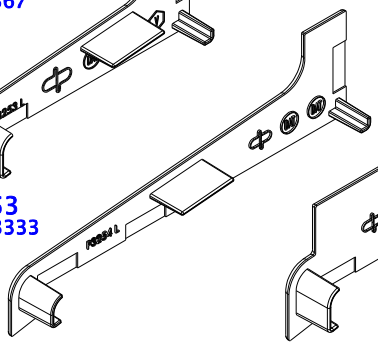

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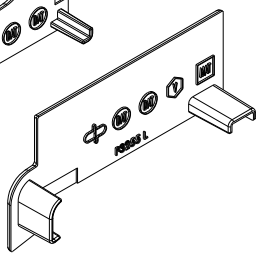

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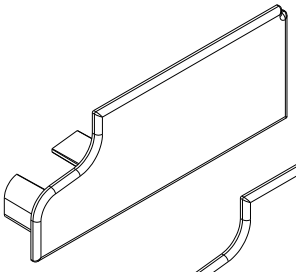

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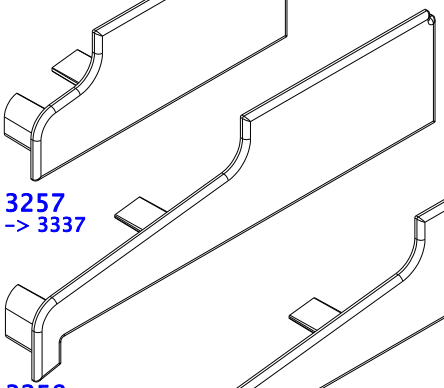

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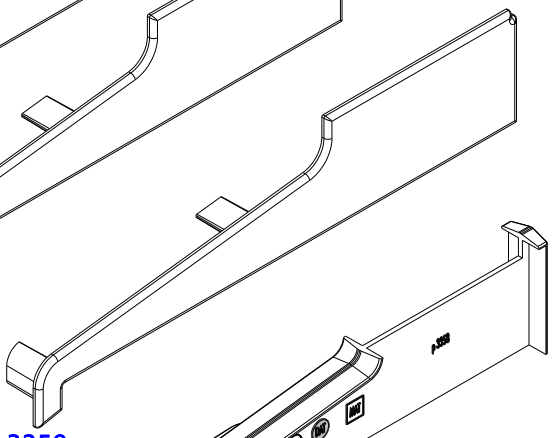

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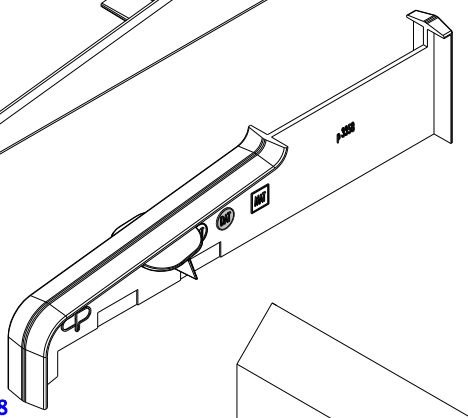

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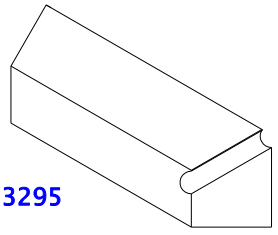

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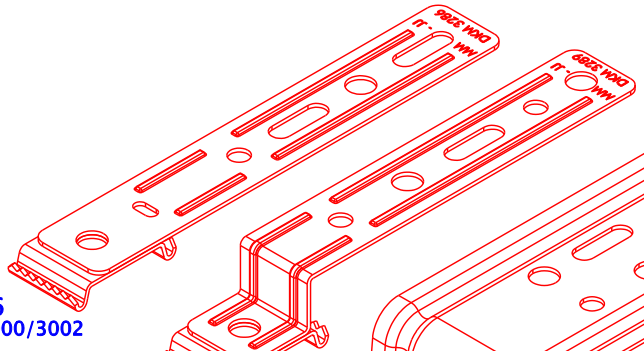

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3289
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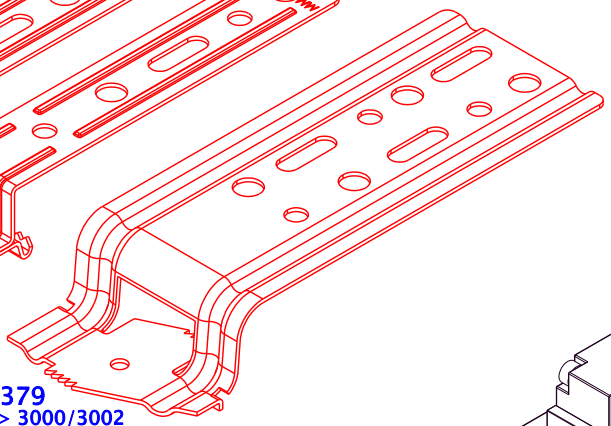

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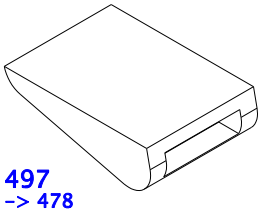

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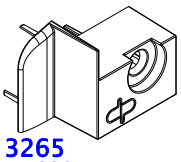

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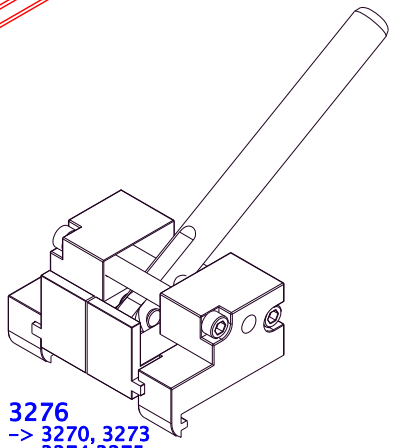

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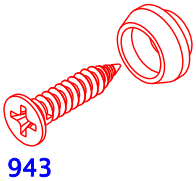

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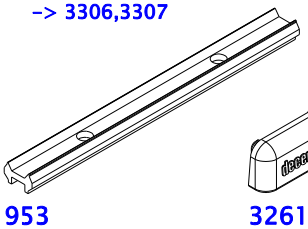

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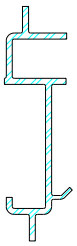
3321

ACCESSORY PROFILES



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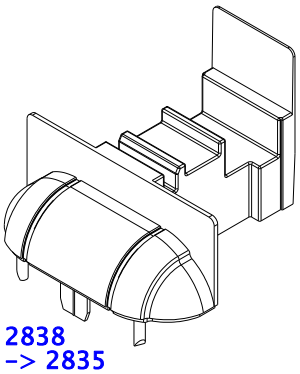

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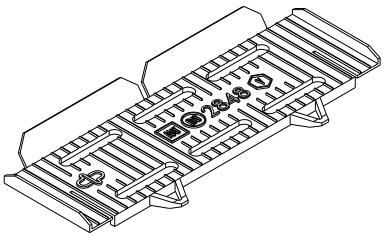

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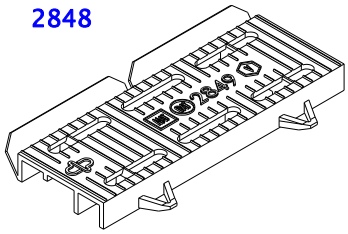

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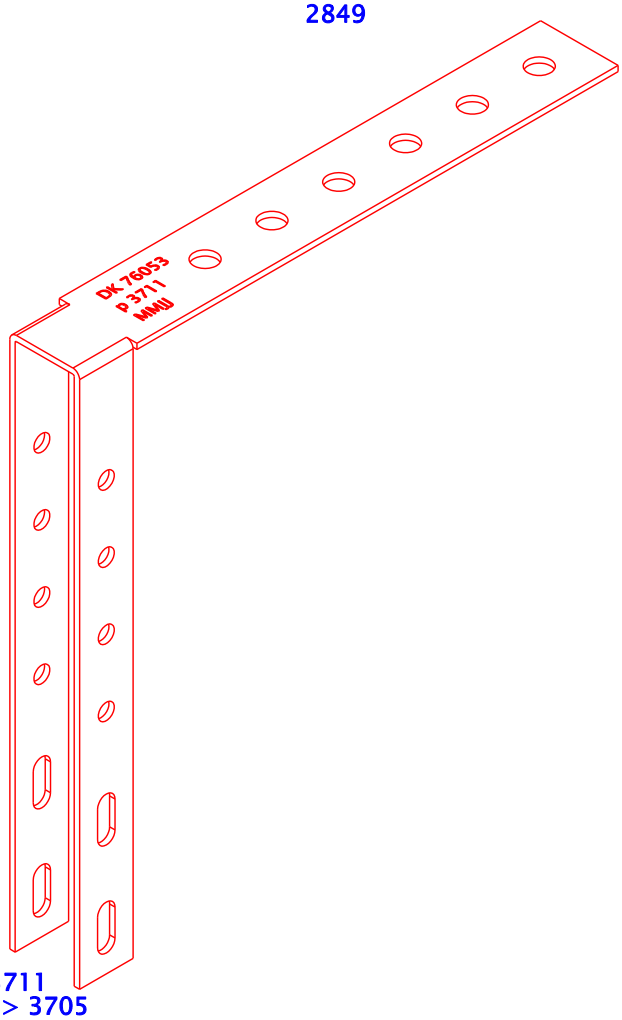

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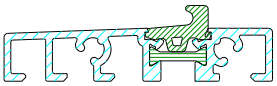

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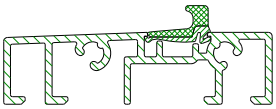

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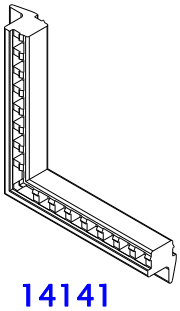

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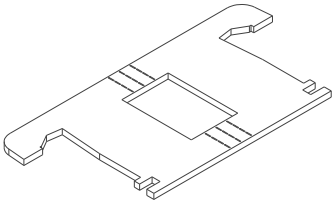

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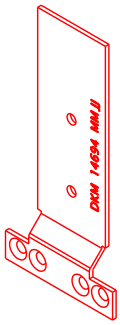

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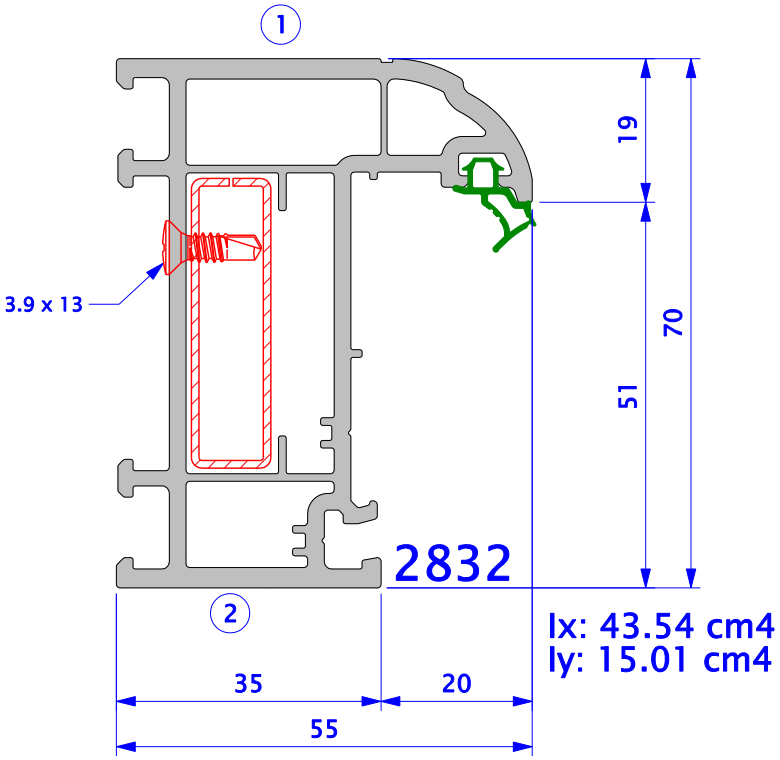

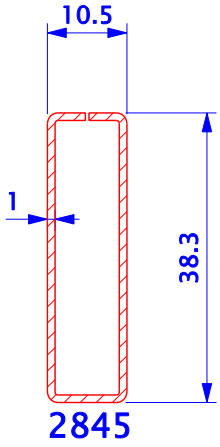

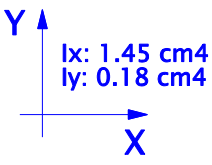

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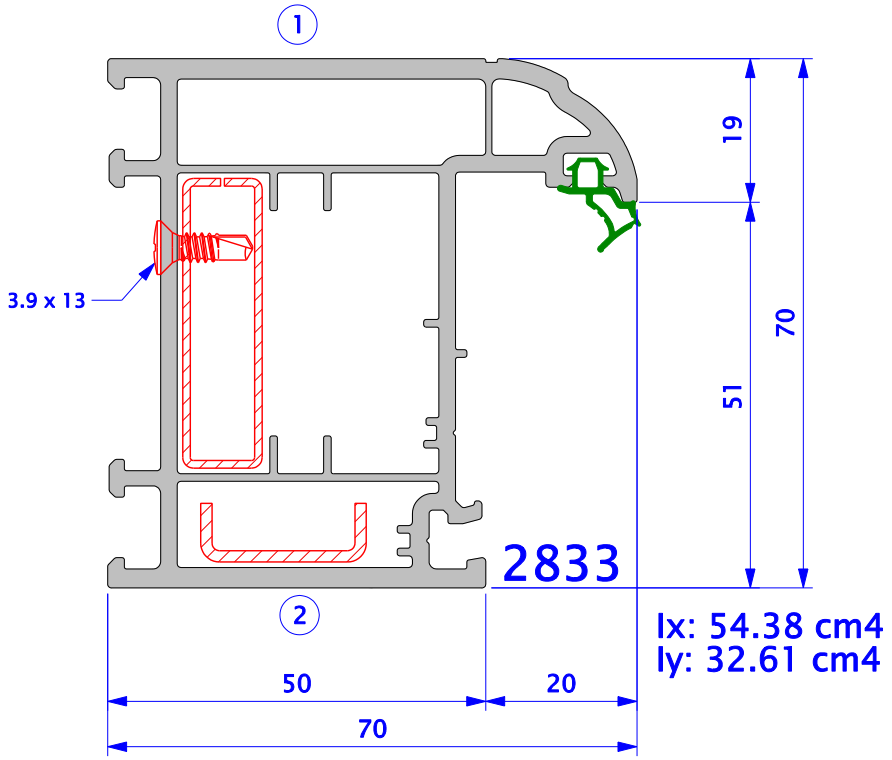

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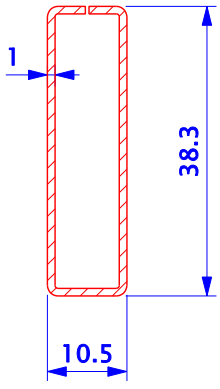

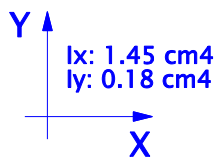

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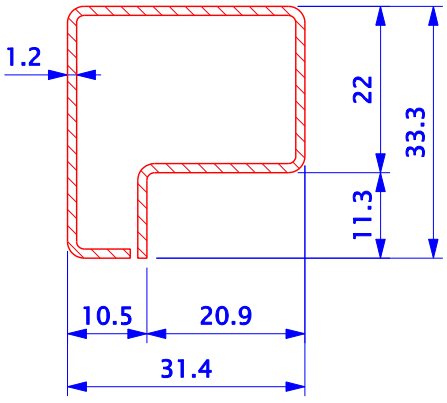

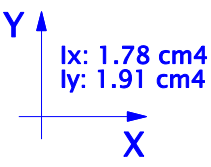

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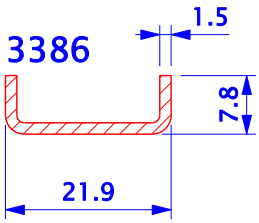

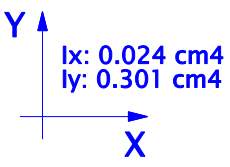

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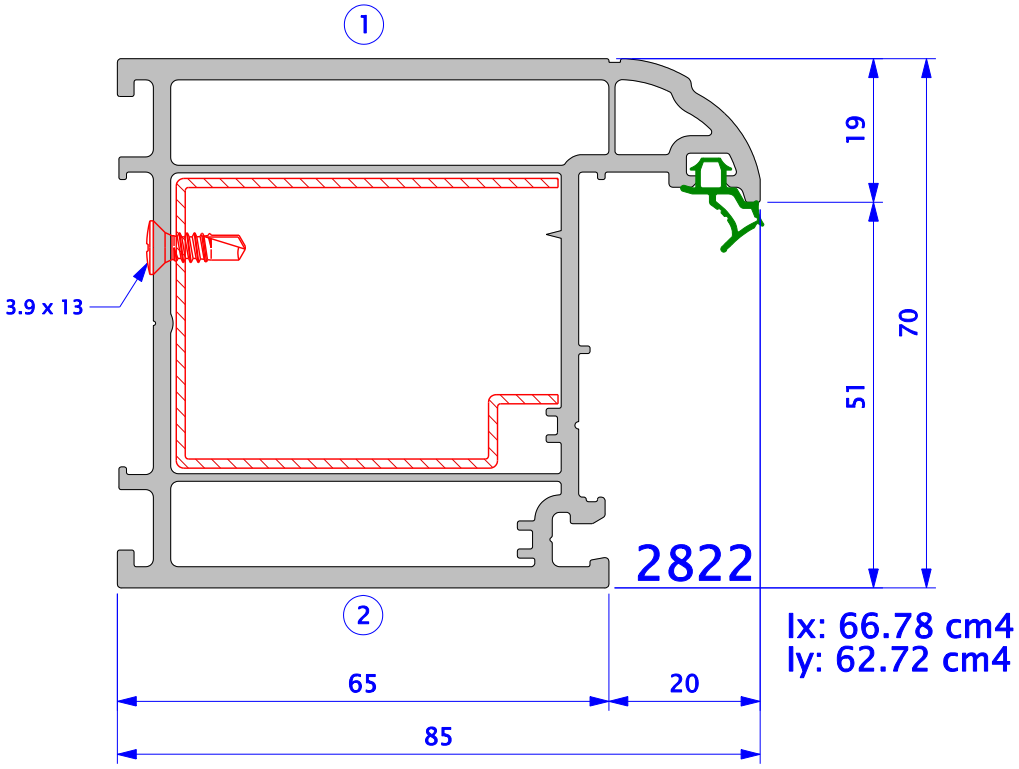

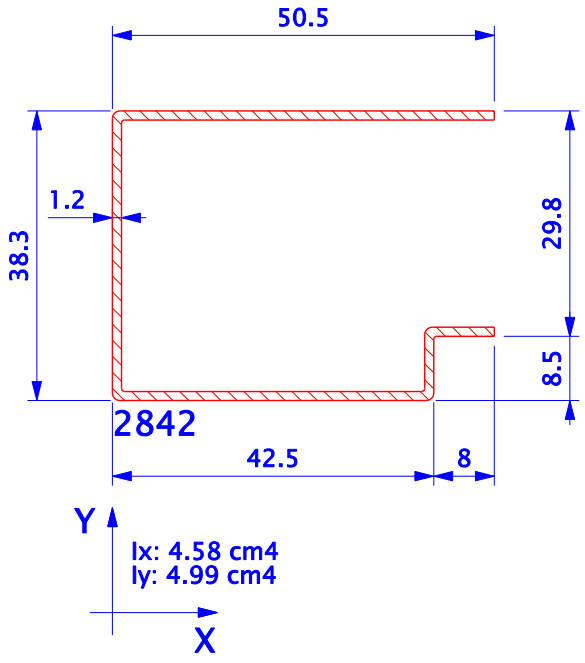

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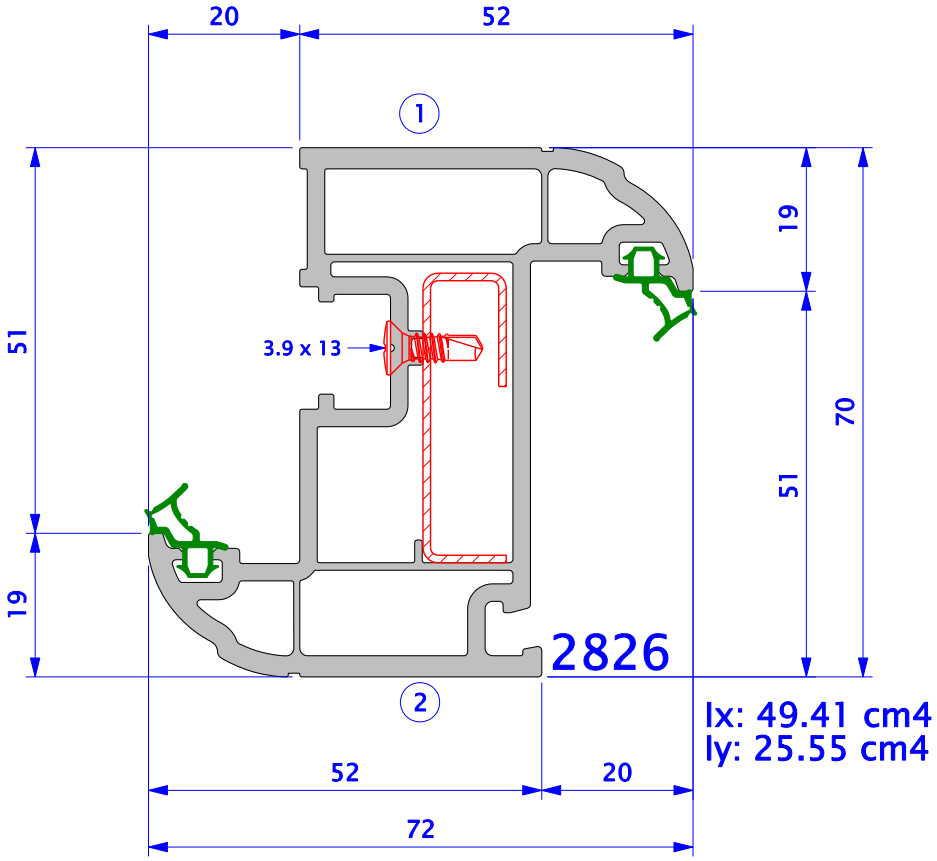

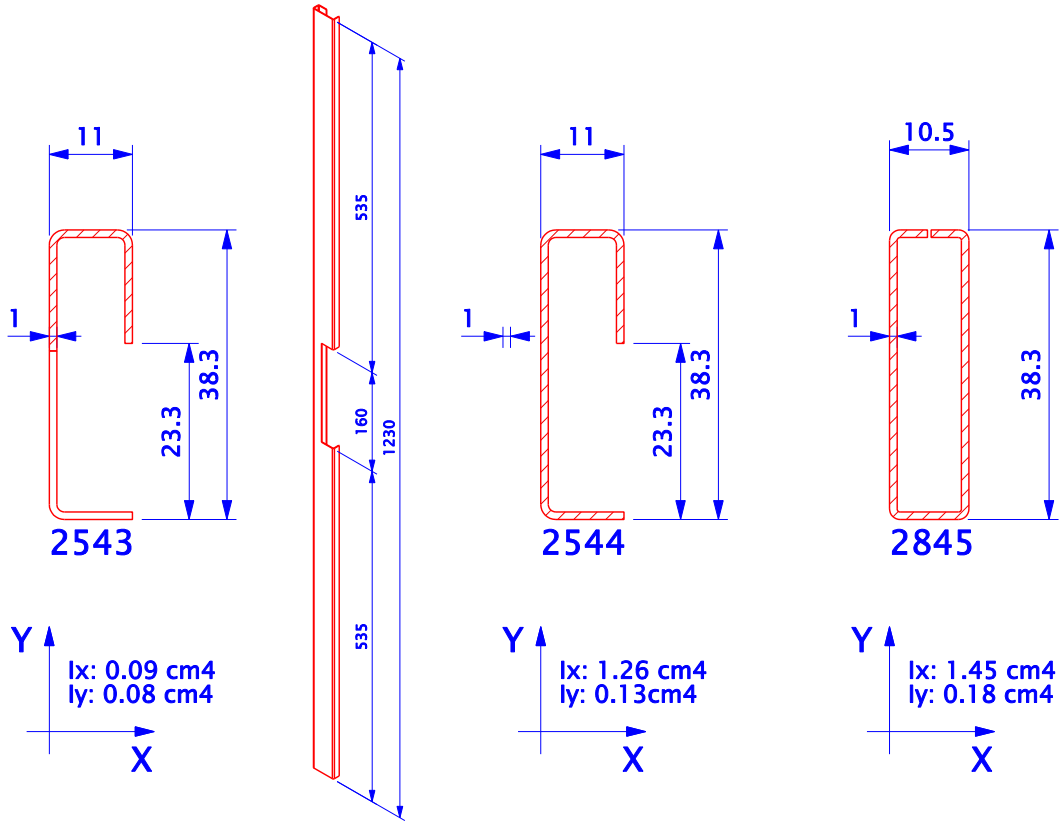

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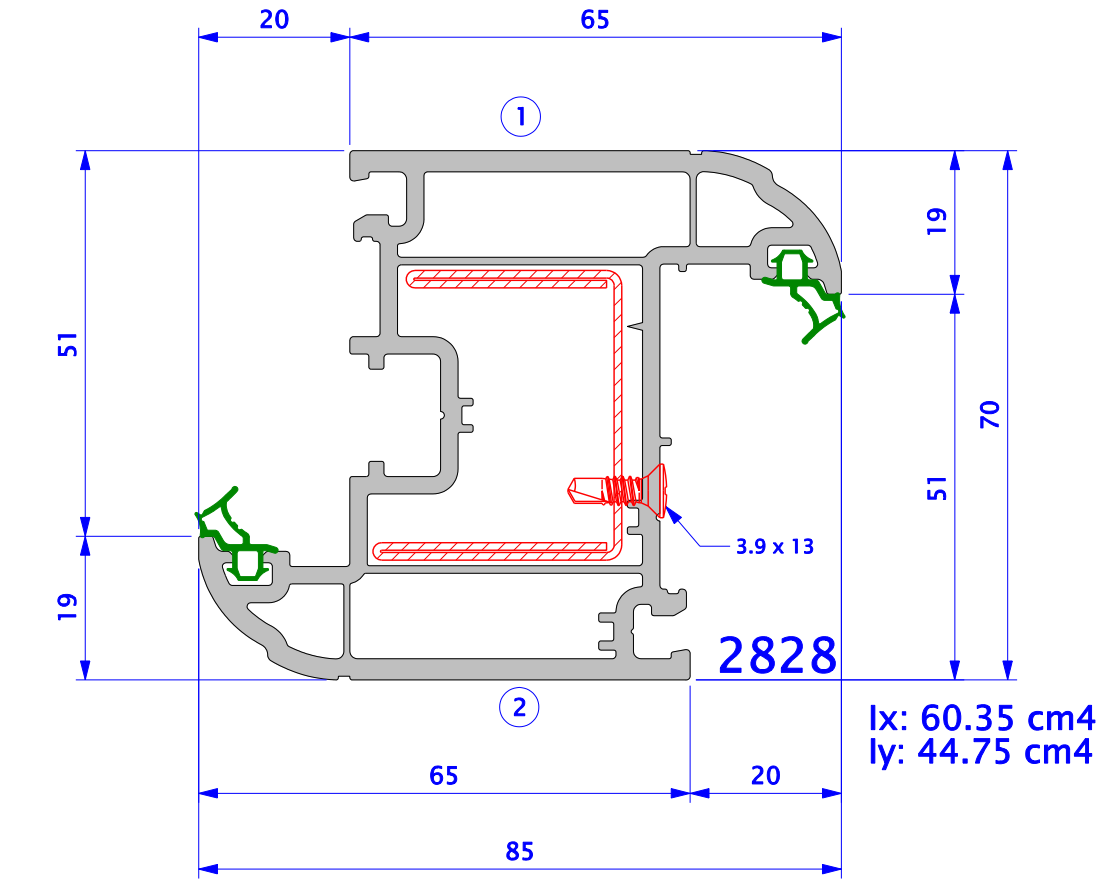

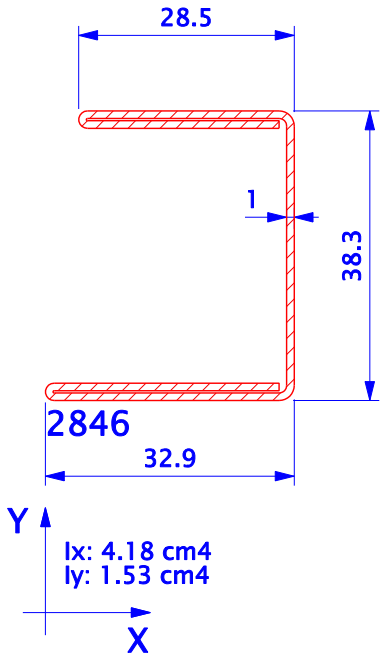

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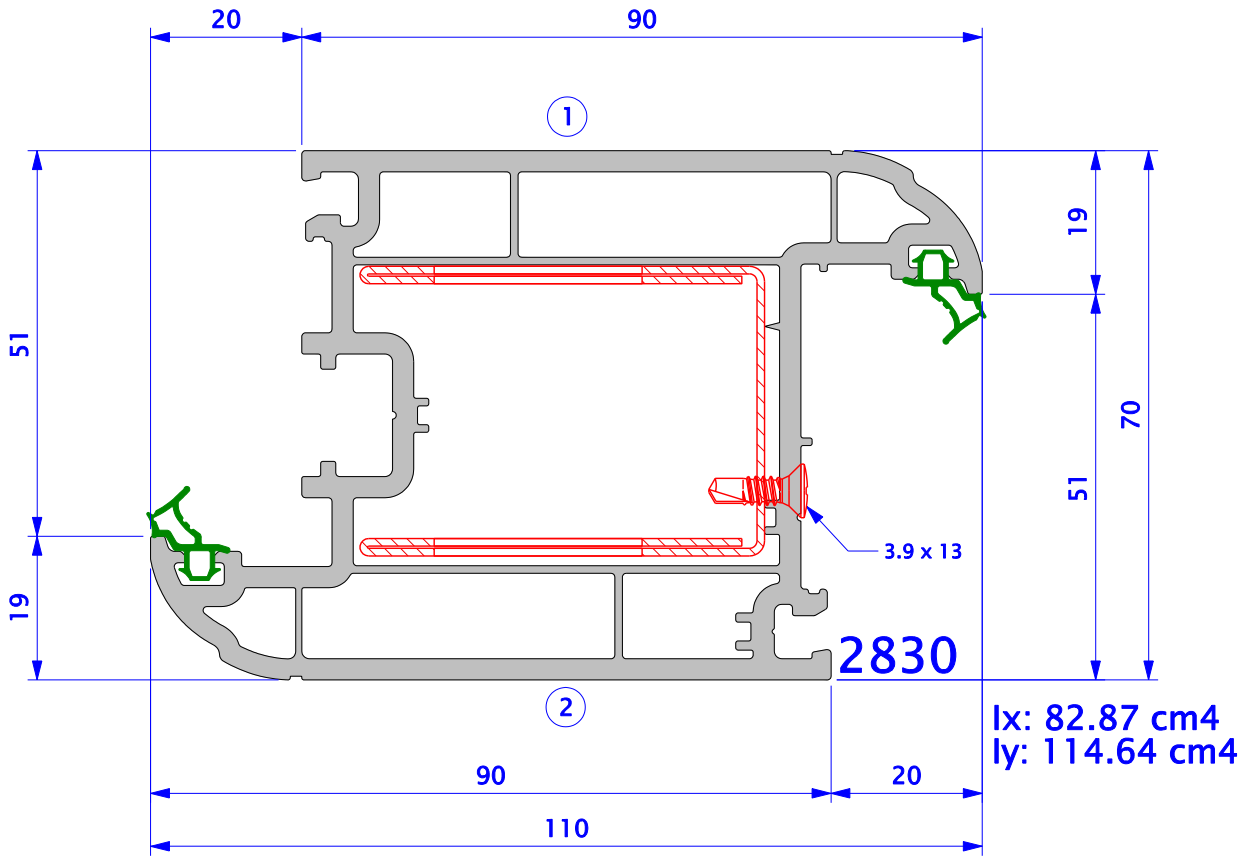

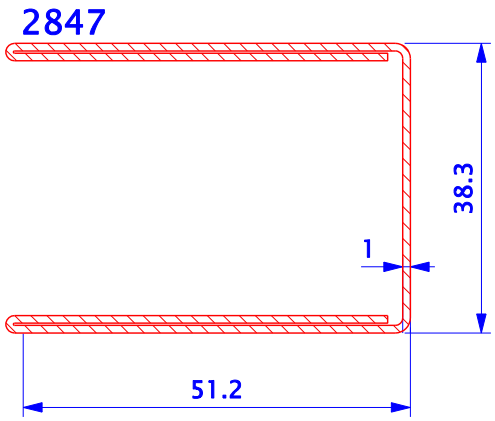

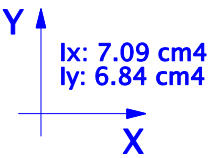

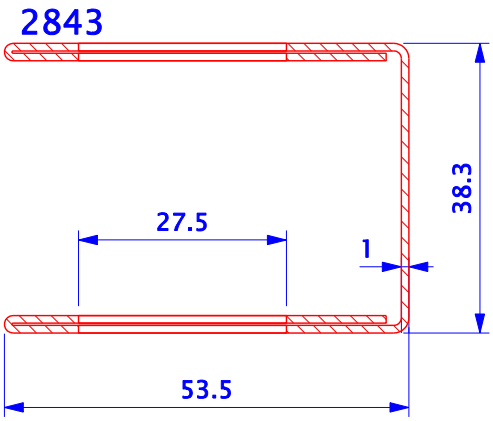

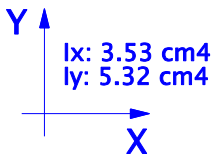

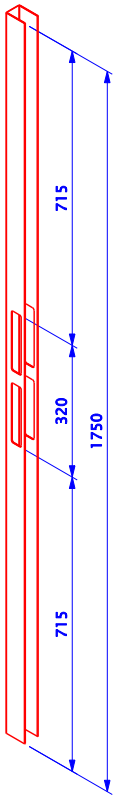

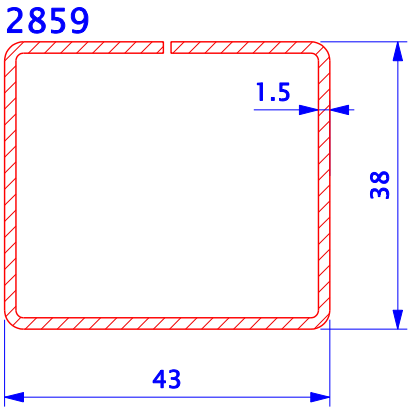

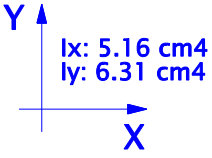

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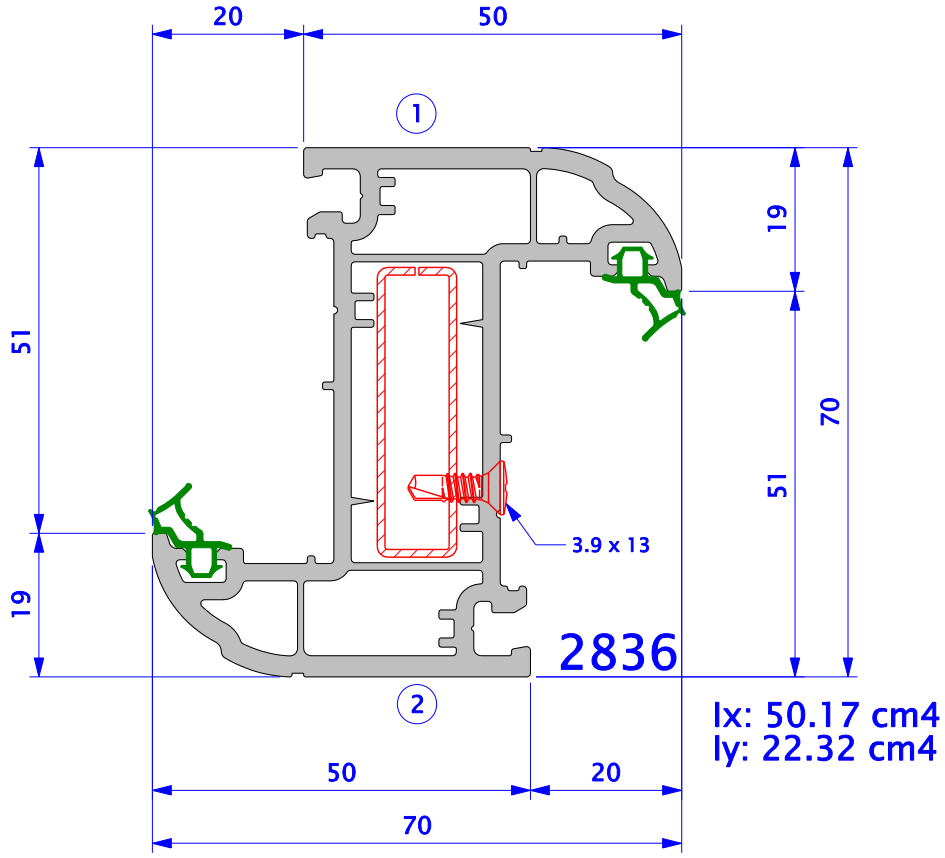
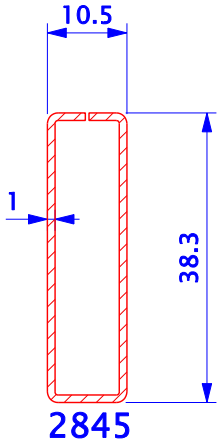
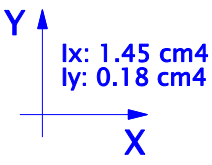


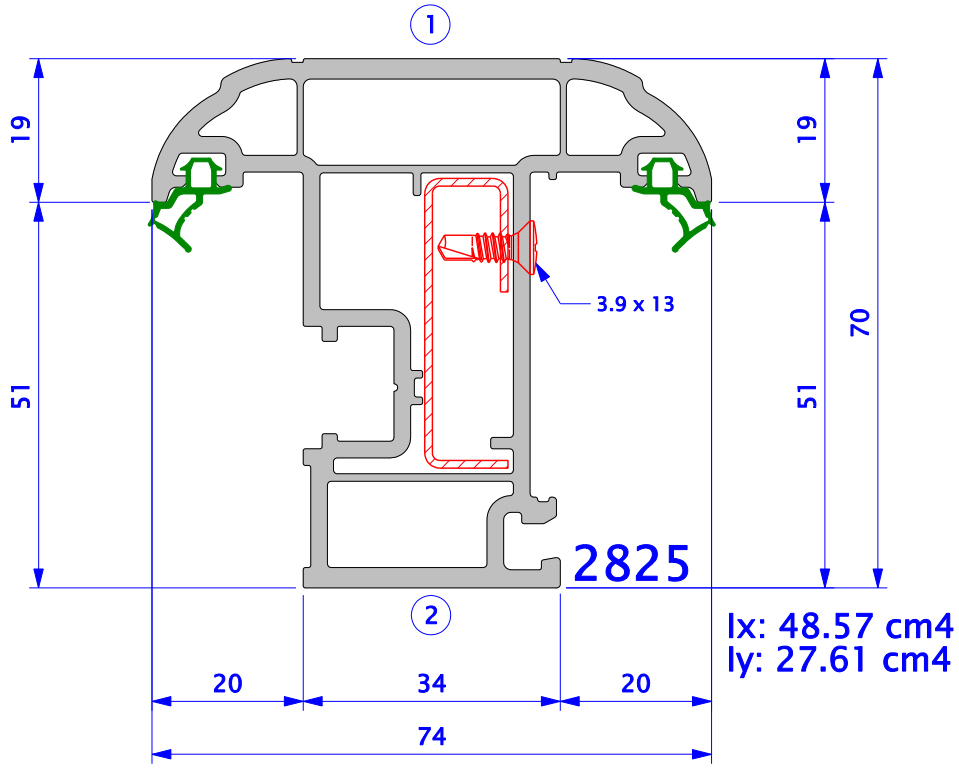
Ix: 50.17 cm4
Iy: 22.32 cm4

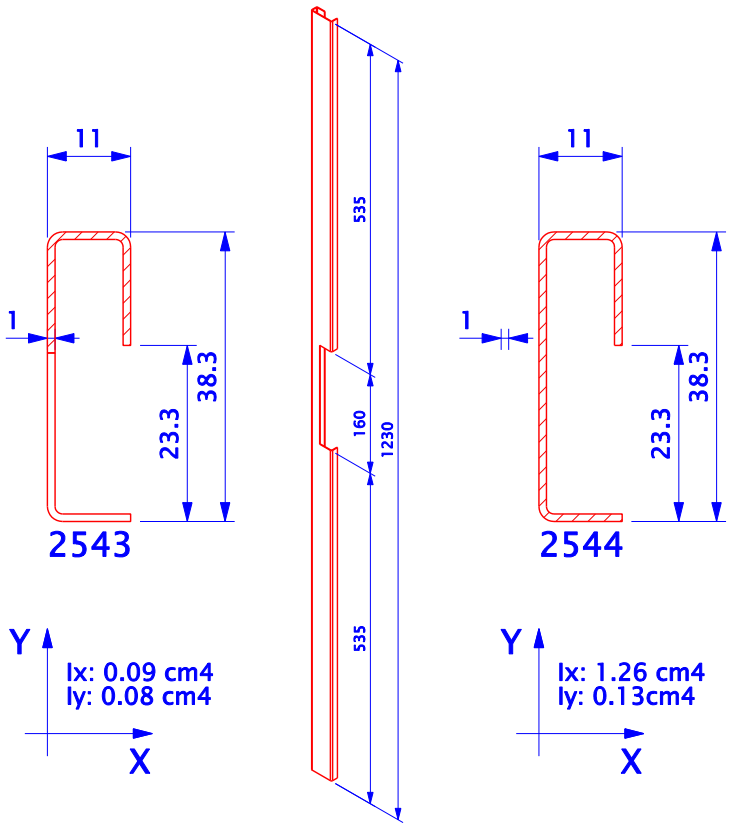




Ix: 1.45 cm4
Iy: 0.18 cm4

PROFILE SHEET





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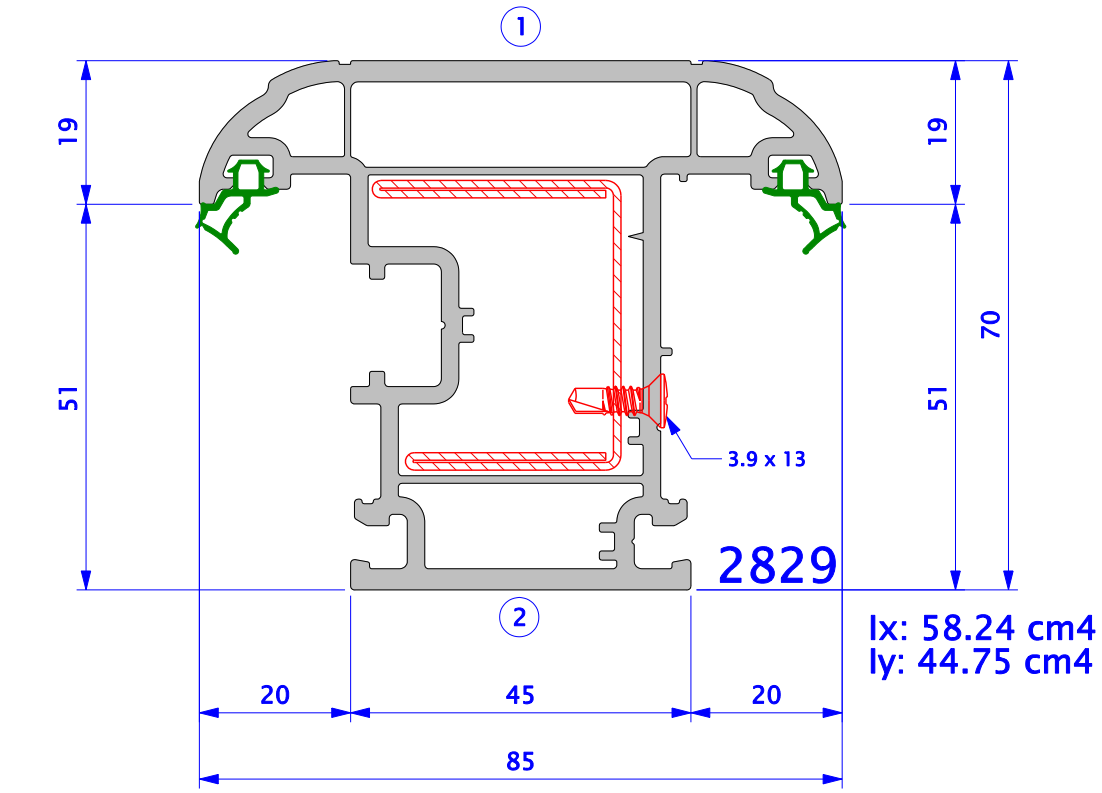

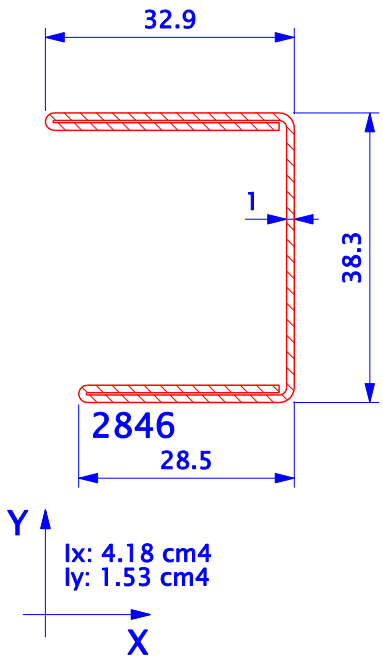

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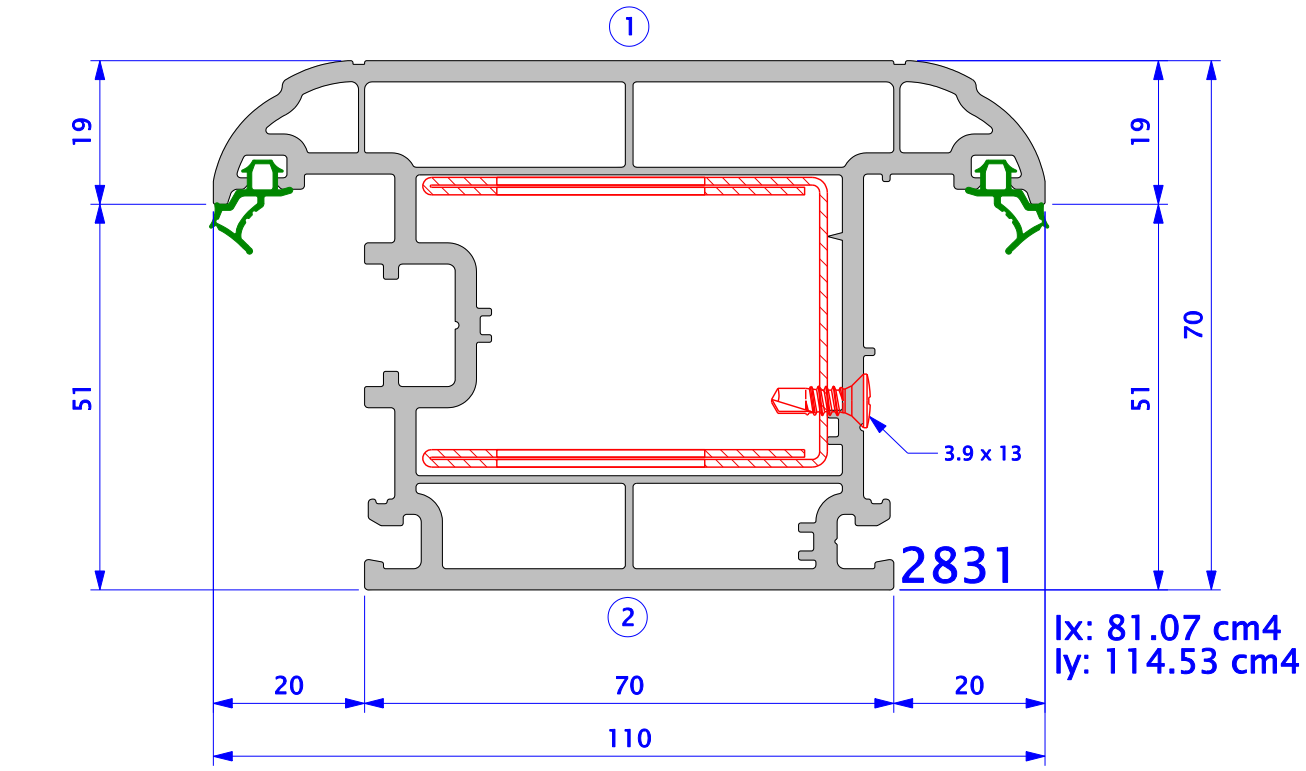

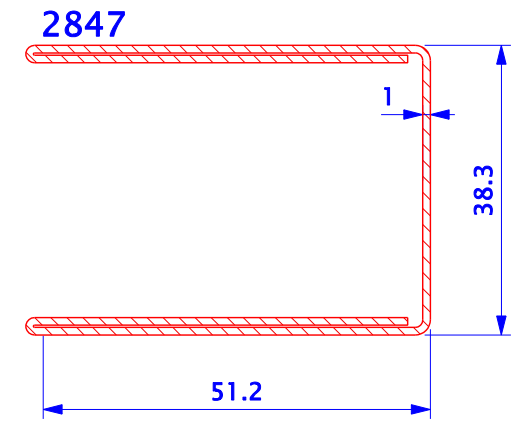

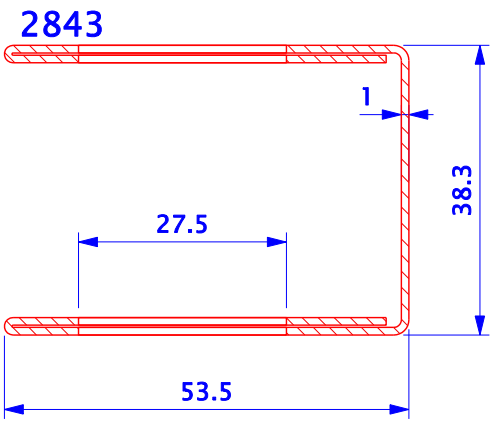

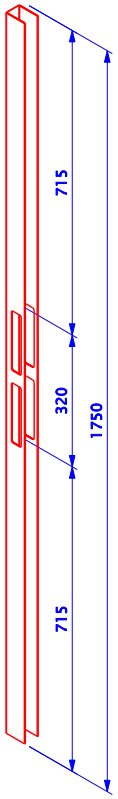

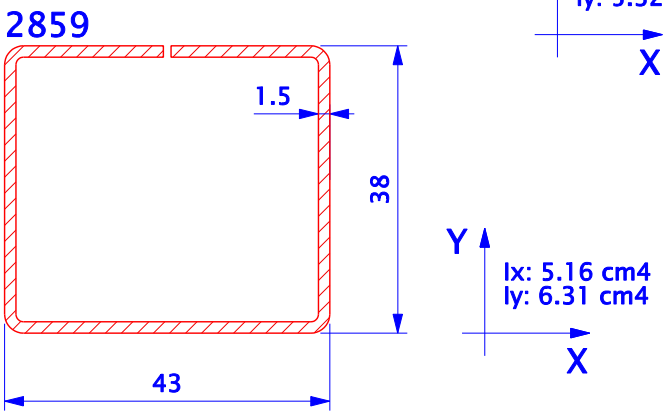

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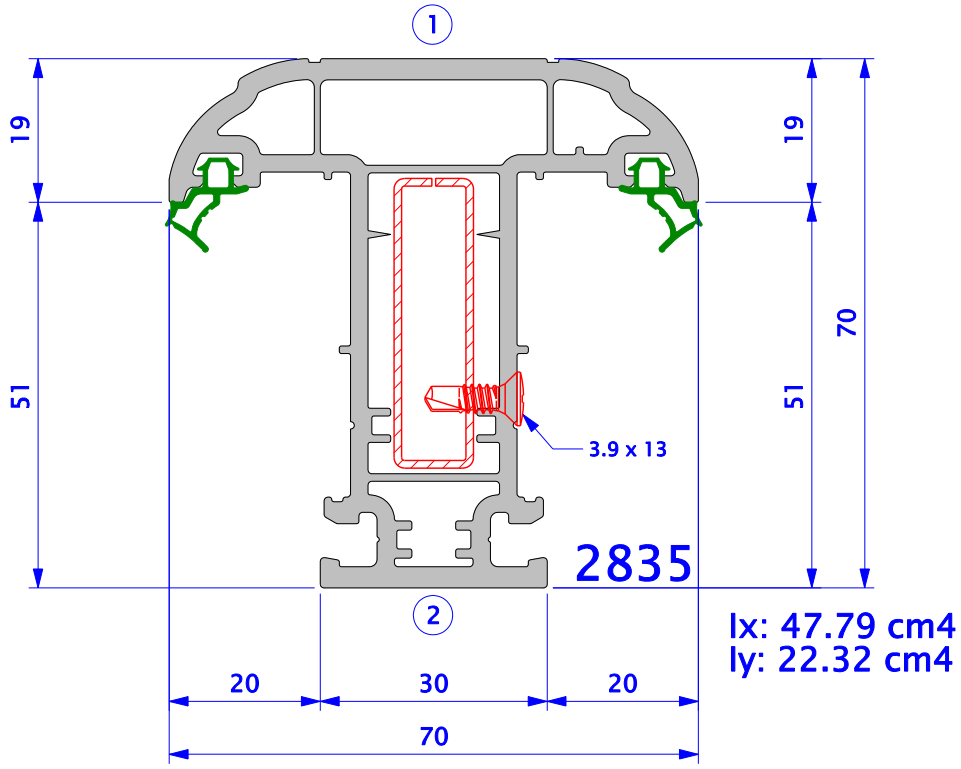
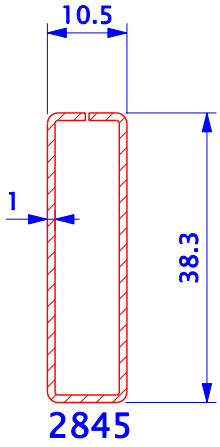
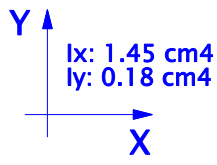
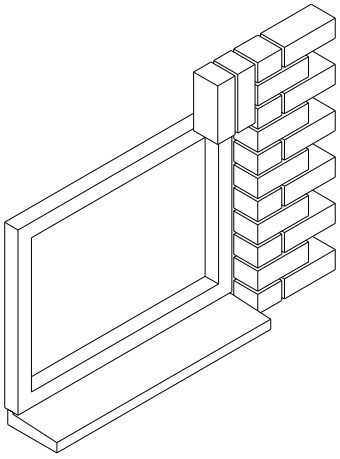


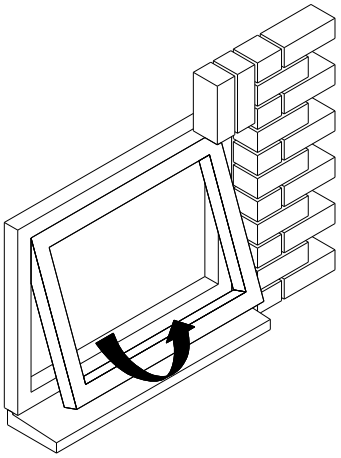




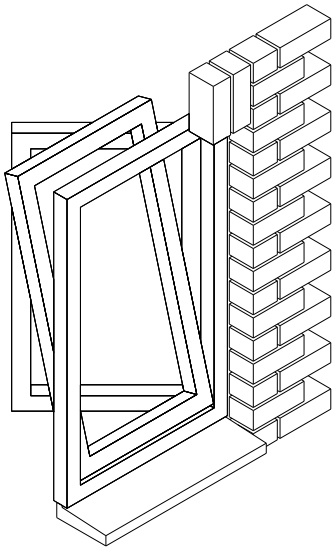
WINDOW TYPES



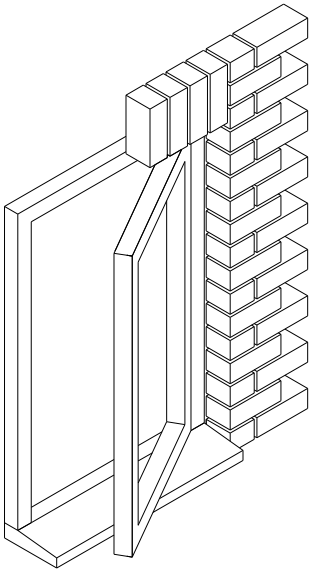
Fixed Pane



Open-Out Top Hung Casement

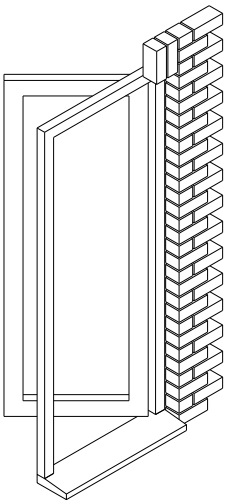


Tilt & Turn

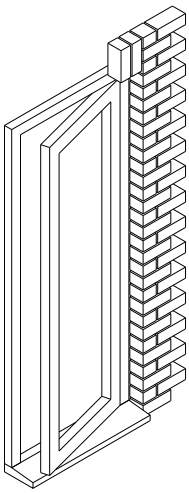


Open-Out Side Hung Casement

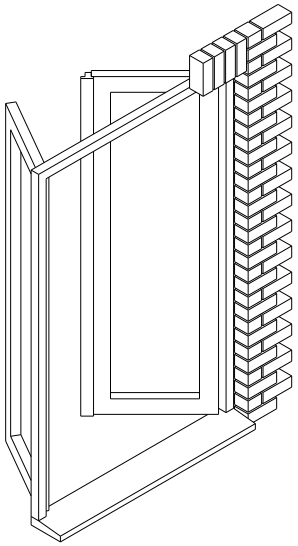
DOOR TYPES



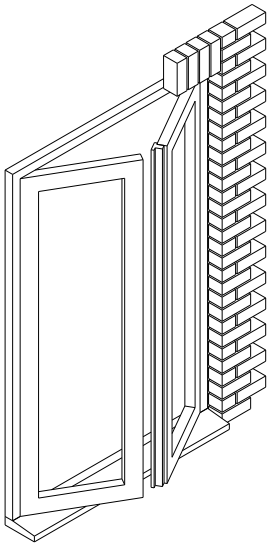
Open-In Single Door



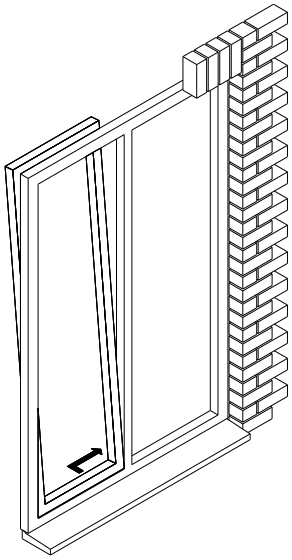
Open-Out Single Door



Open-in Double Door



Open-Out Double Doors

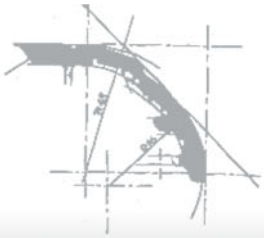


Tilt & Slide Patio

2800 decorative

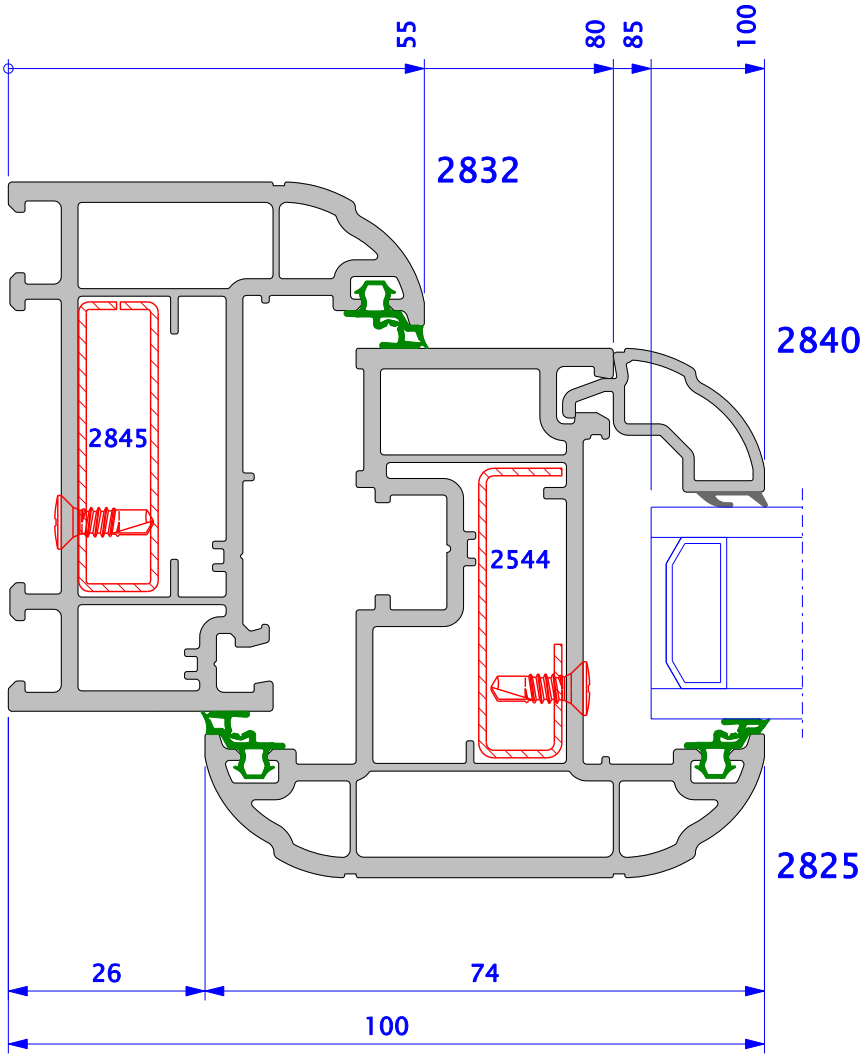
FABRICATION

SECTIONS
DRAINAGE & DECOMPRESSION
V-WELDING
HARDWARE
GLAZING TABLE
USE OF ACCESSORIES
FABRICATION TOOLS
WINDOW SECTIONS
CUTTING SIZES
GLASS DISPLACEMENTS

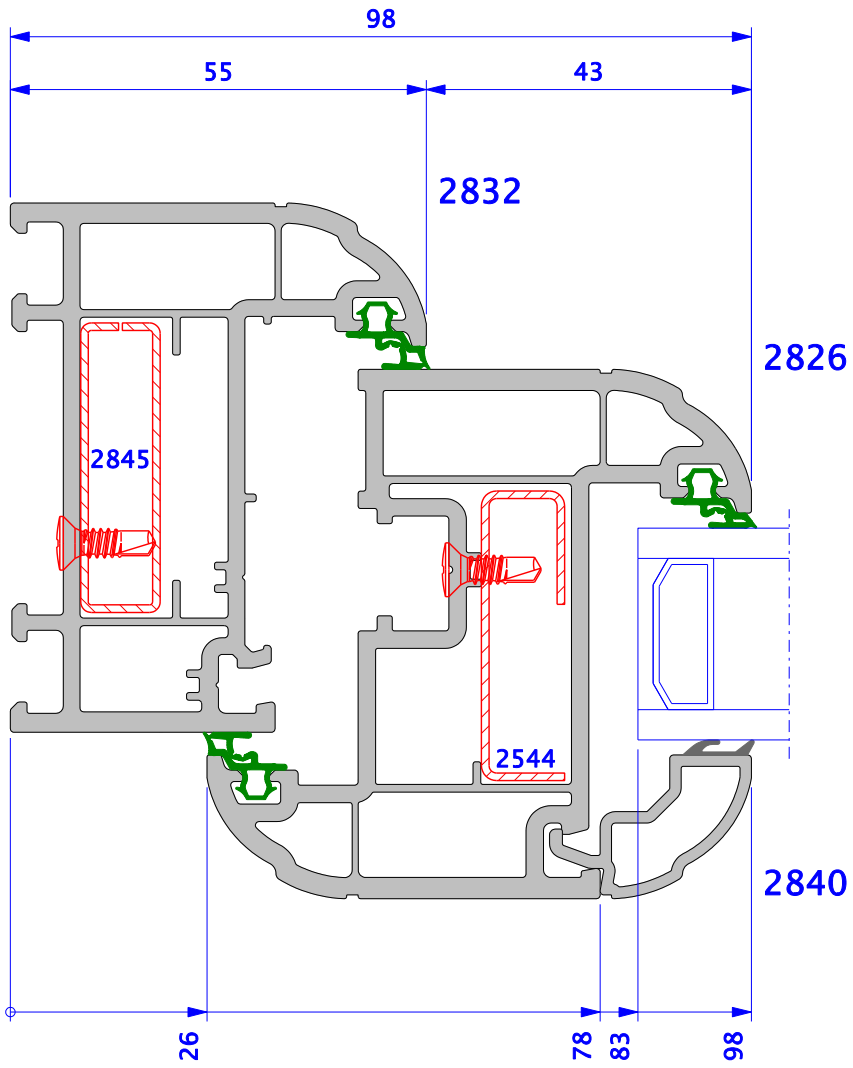


deceuninck

SECTIONS



SECTIONS



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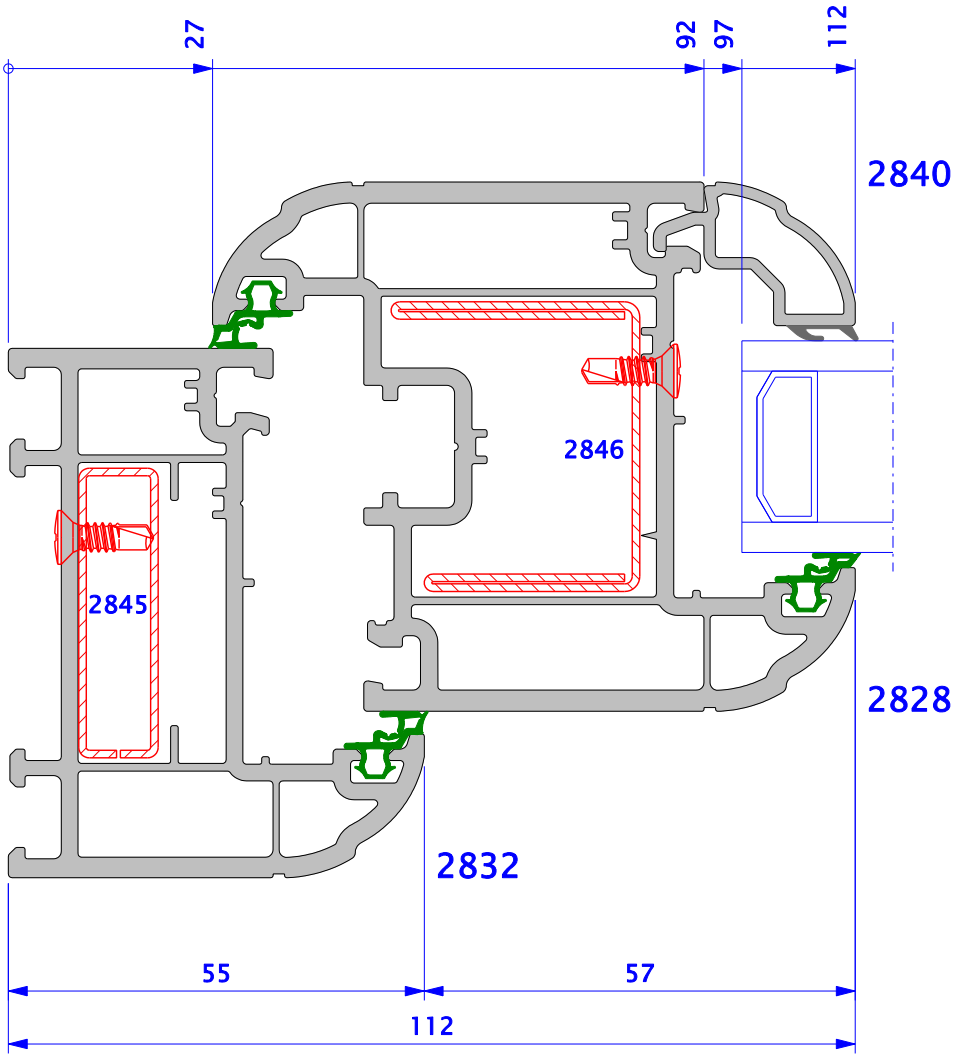

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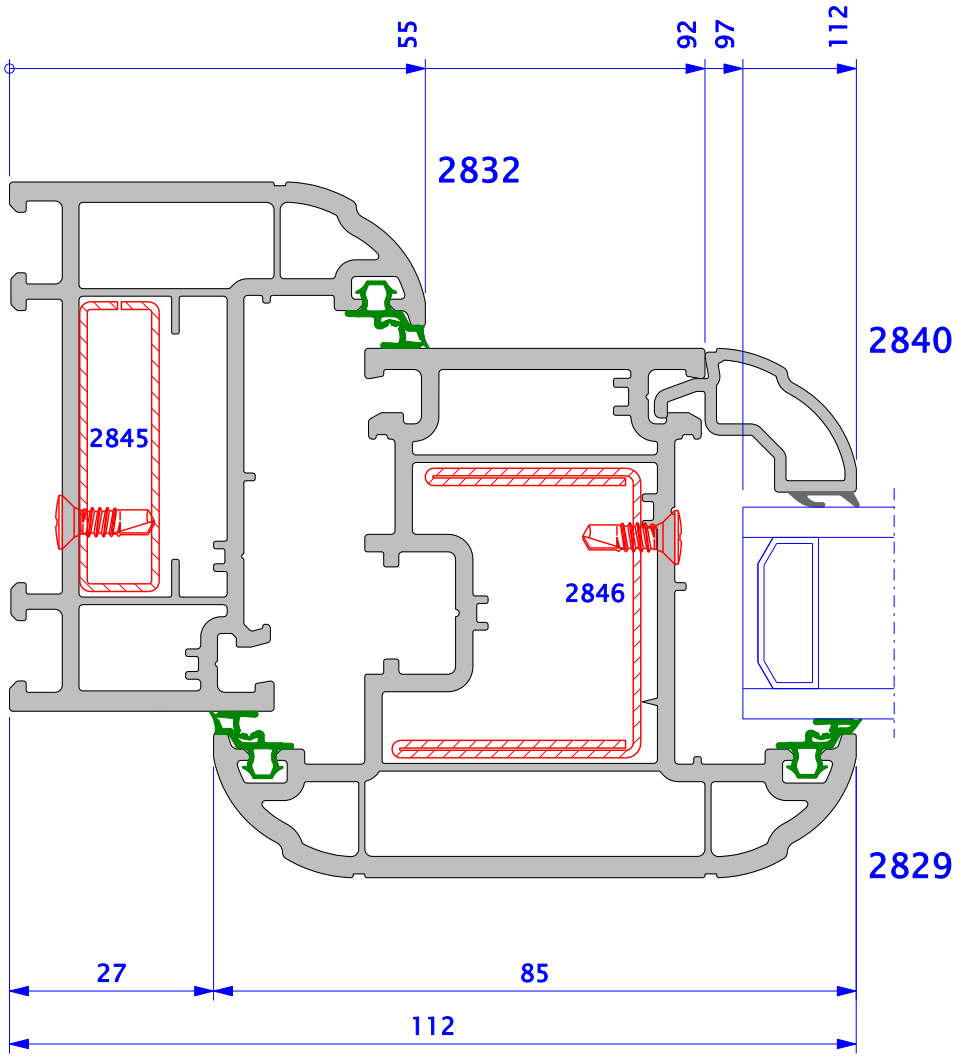

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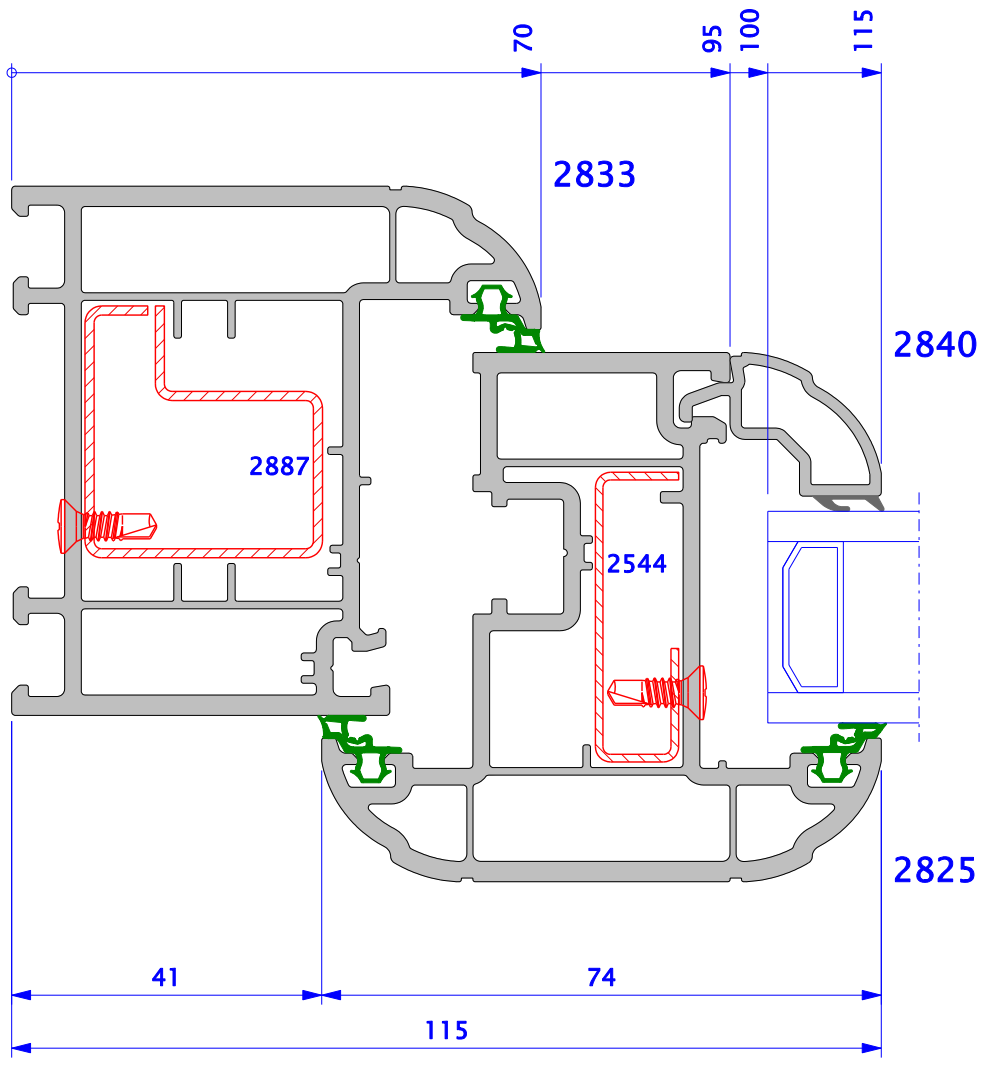

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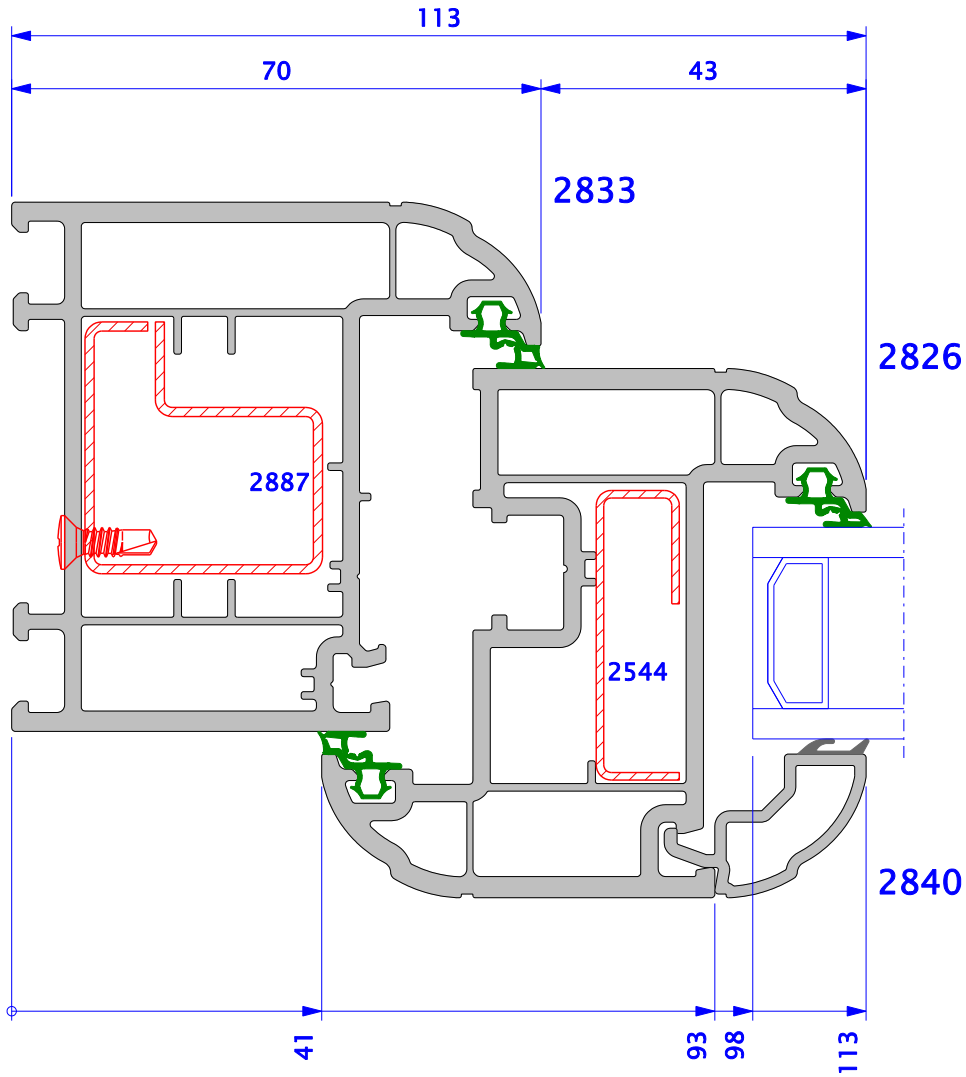

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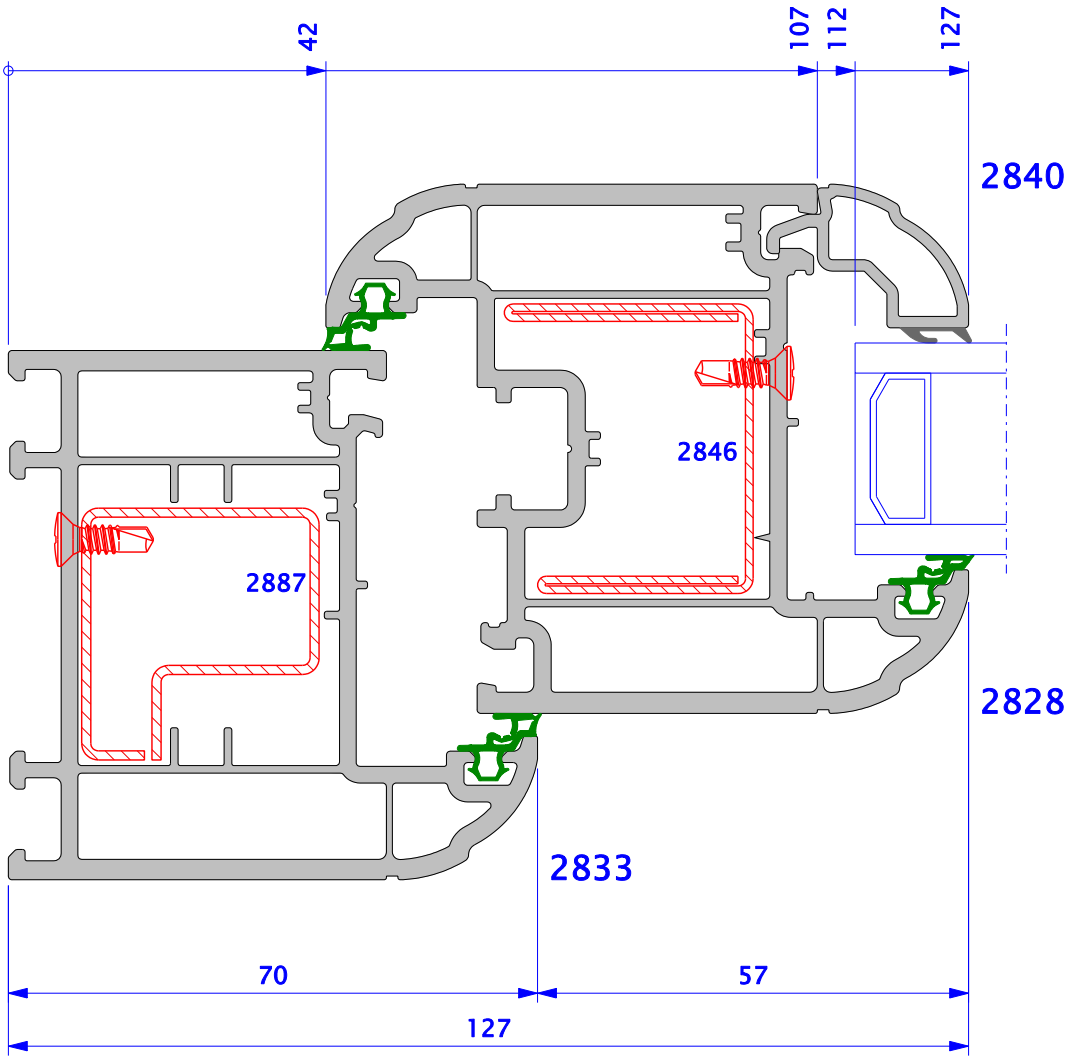

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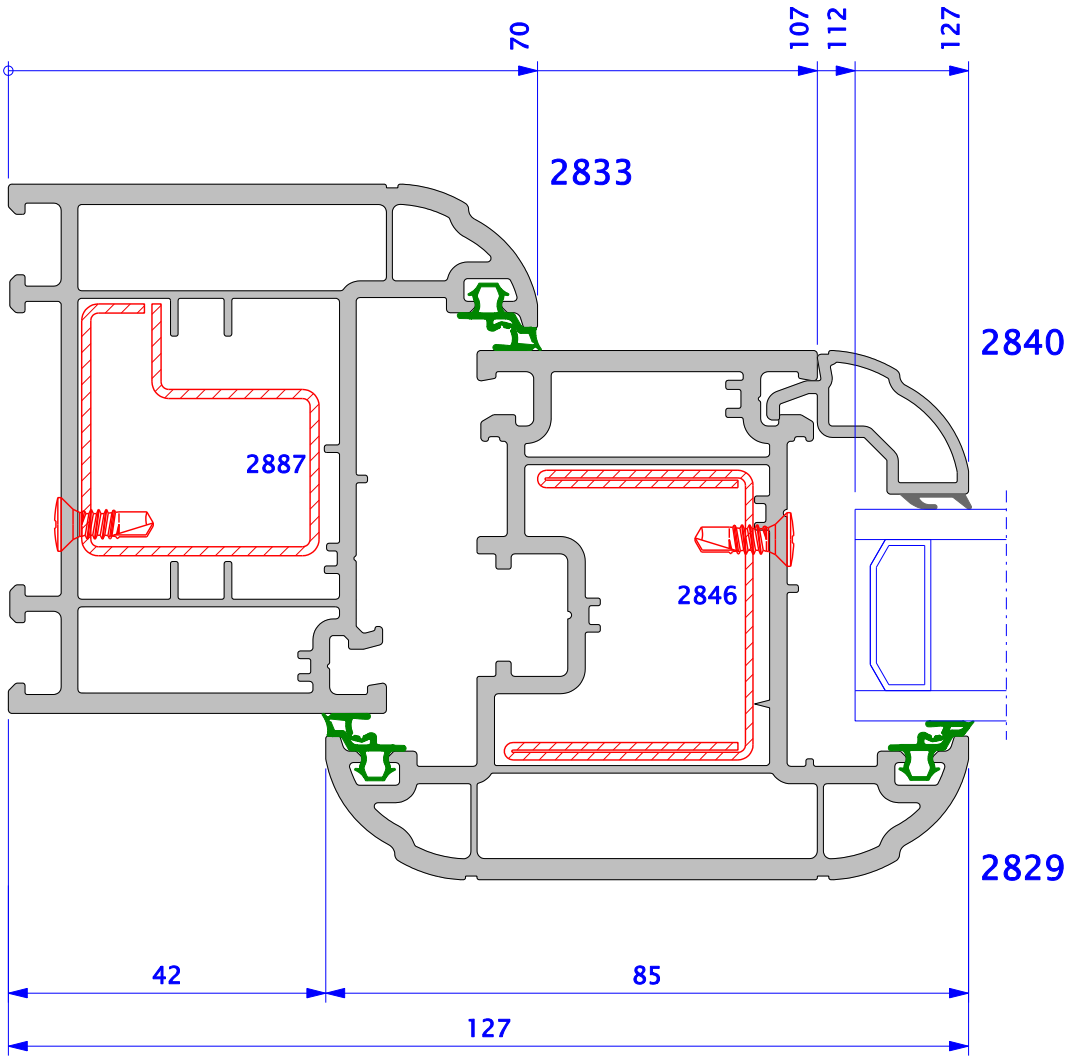

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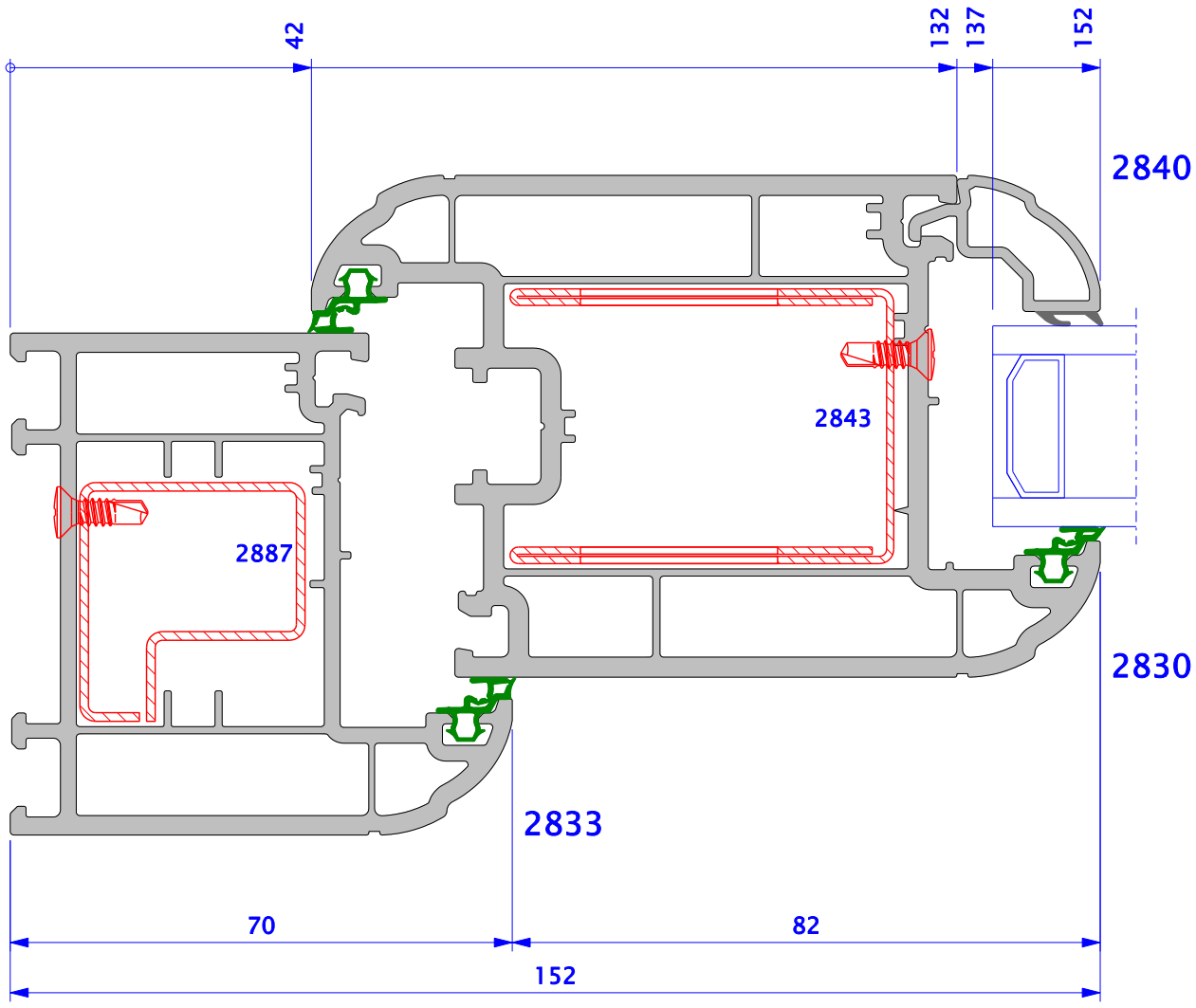

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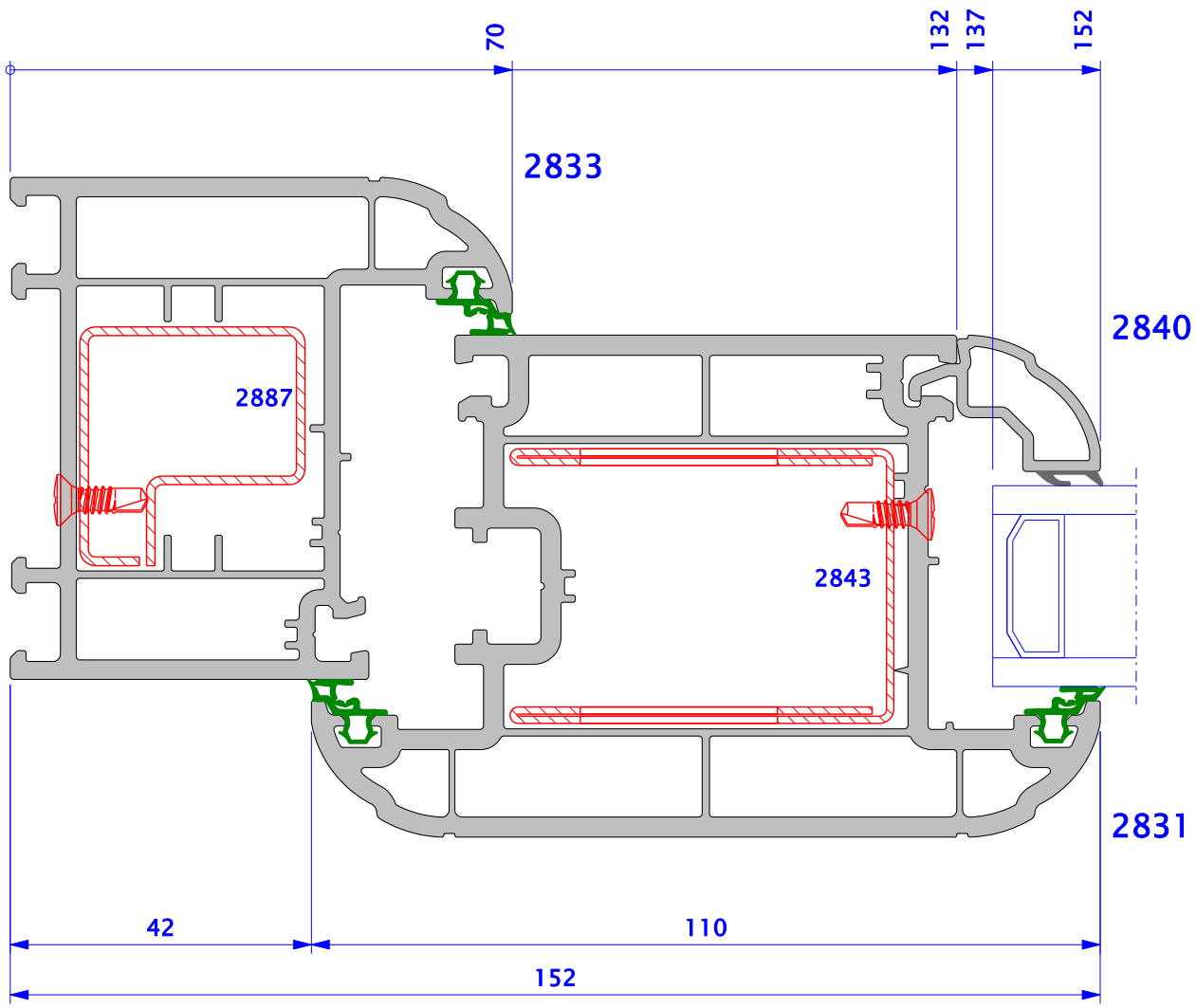

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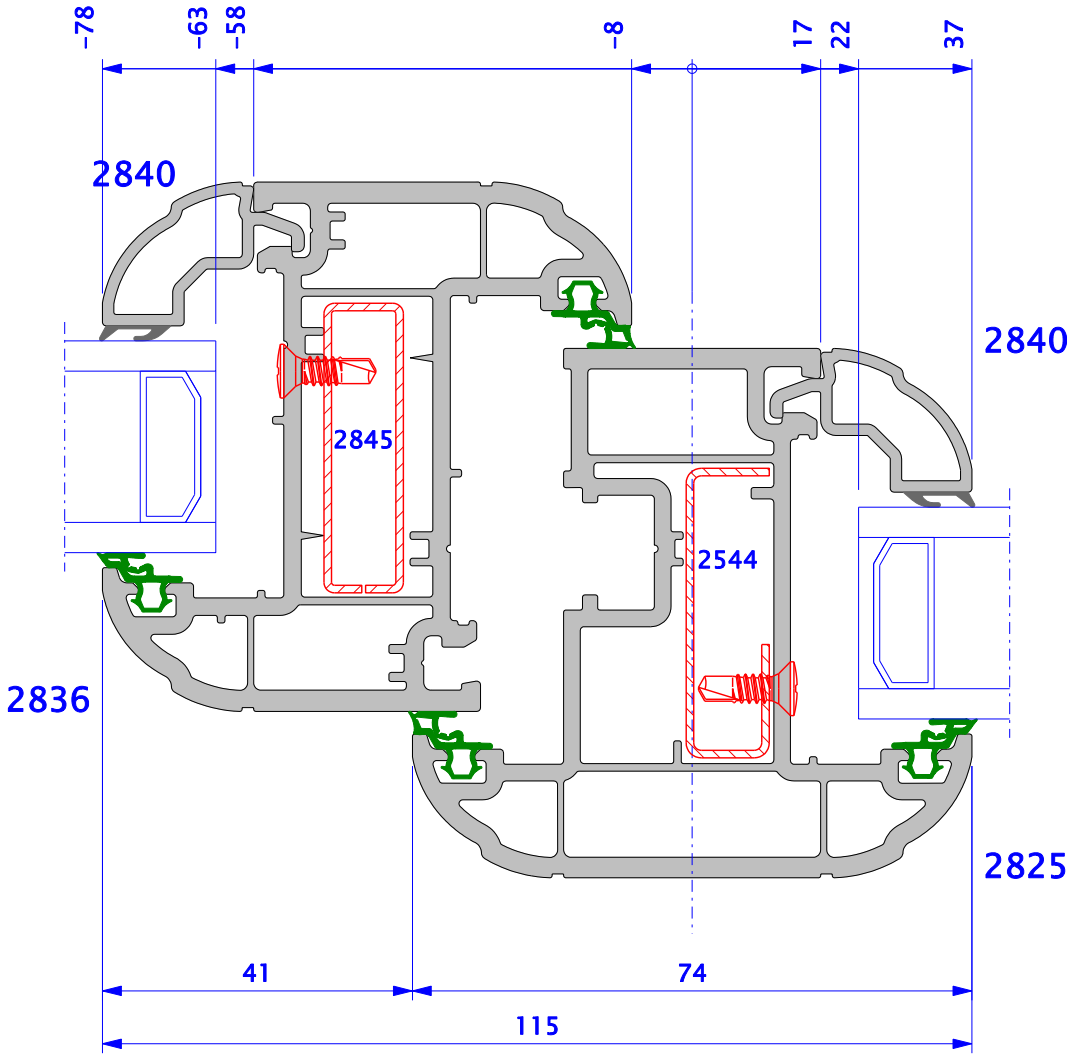

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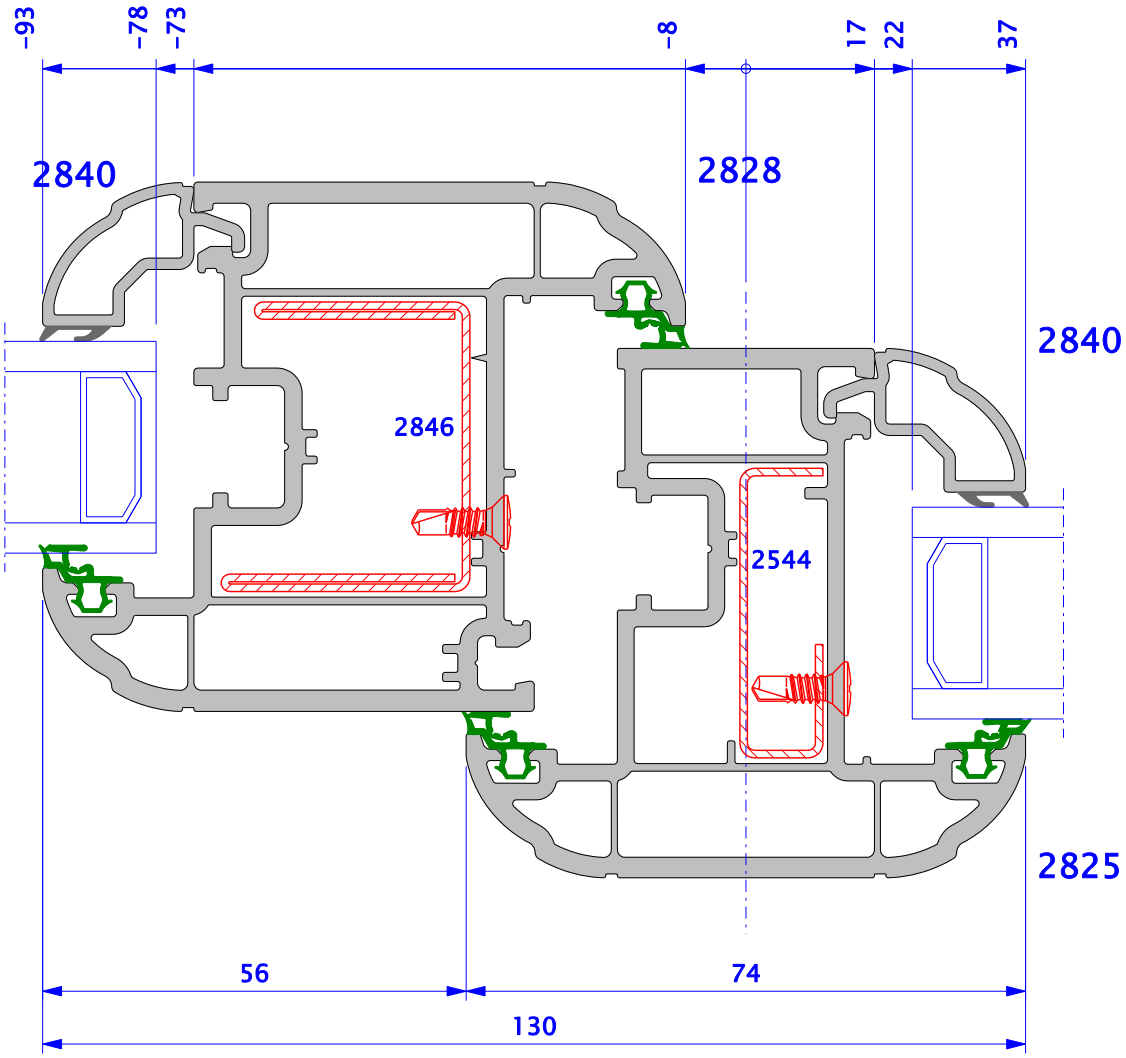

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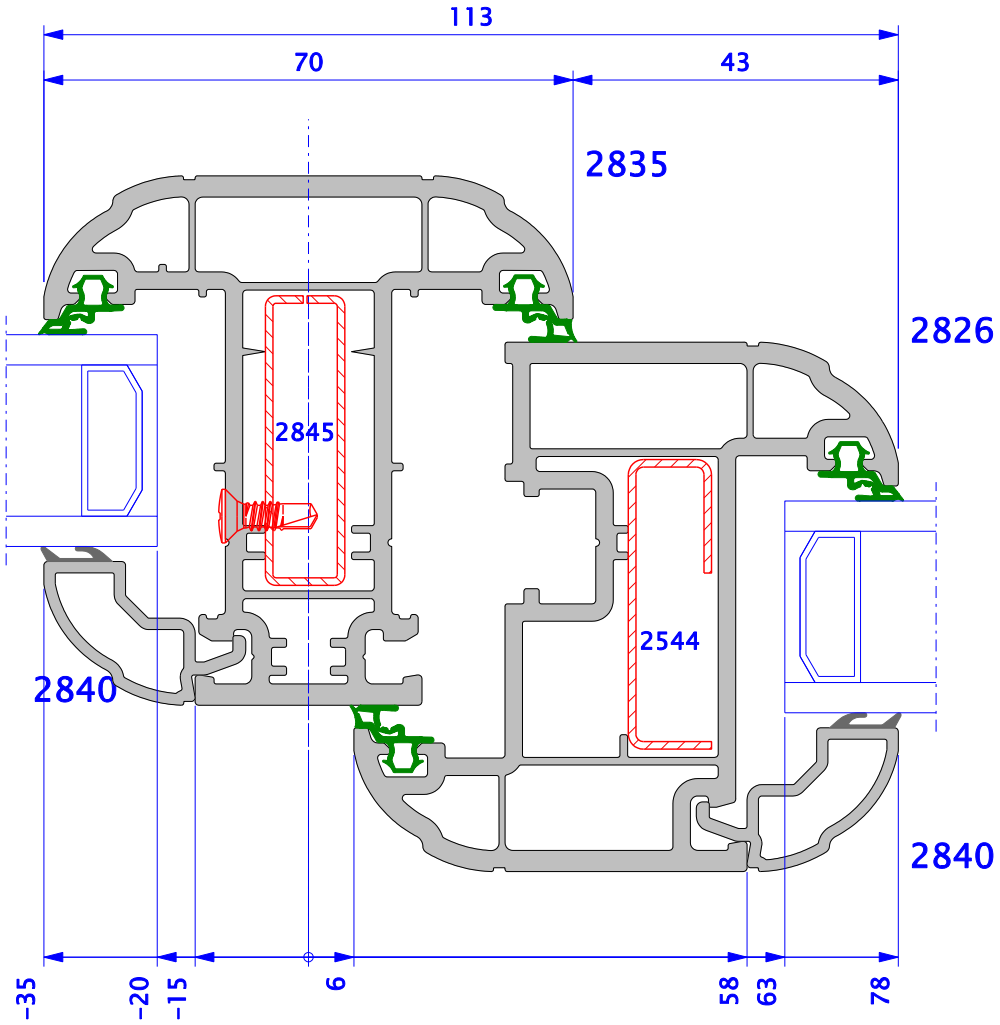

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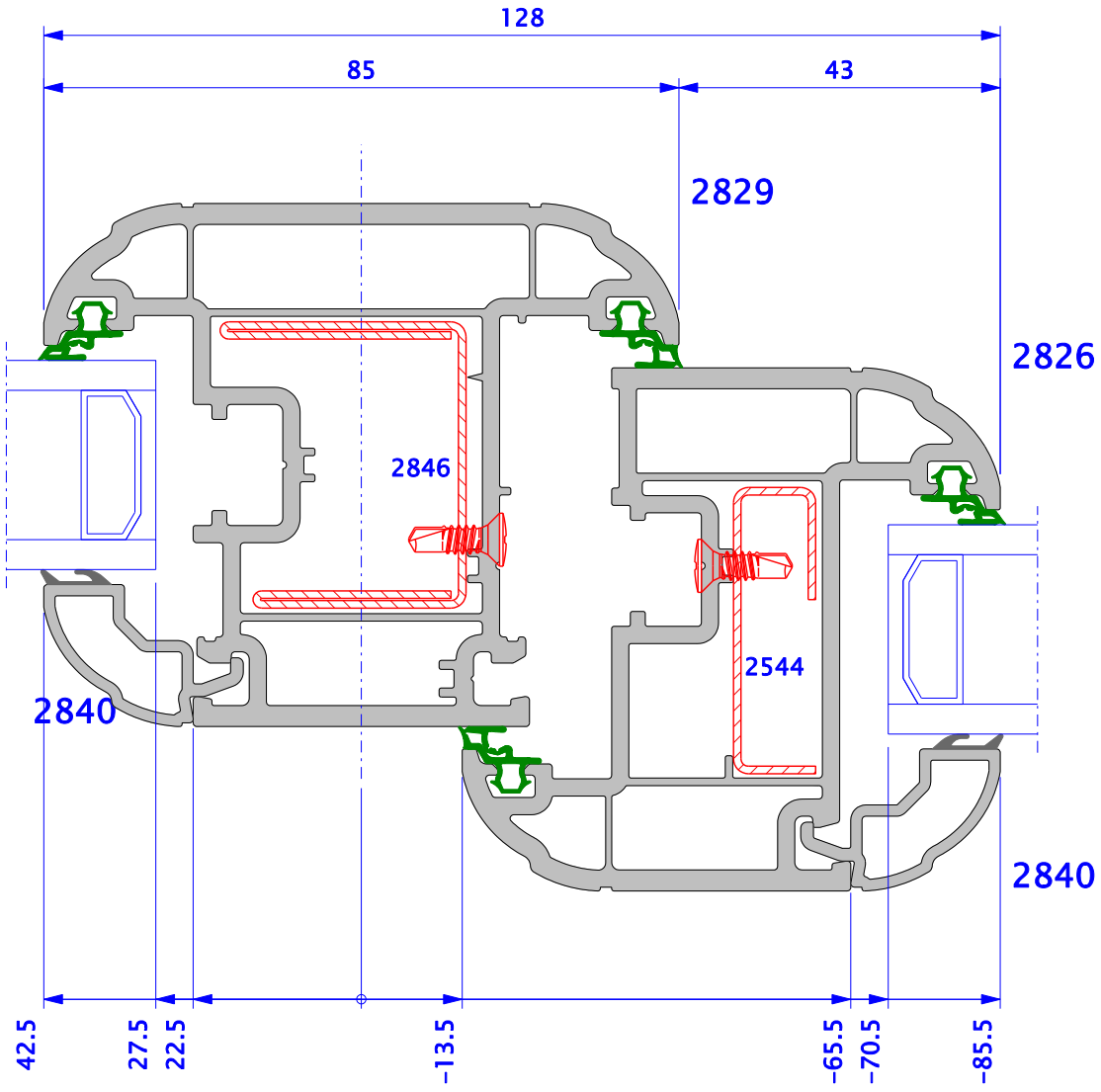
128
85
43
2829
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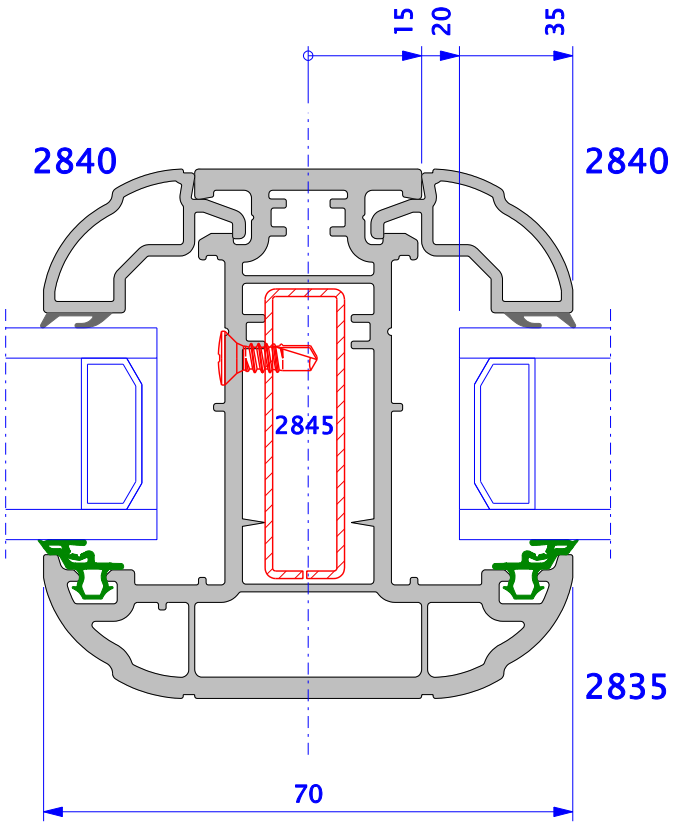
2840
42.5
27.5
22.5
-13.5
-65.5
-70.5
-85.5

SECTIONS



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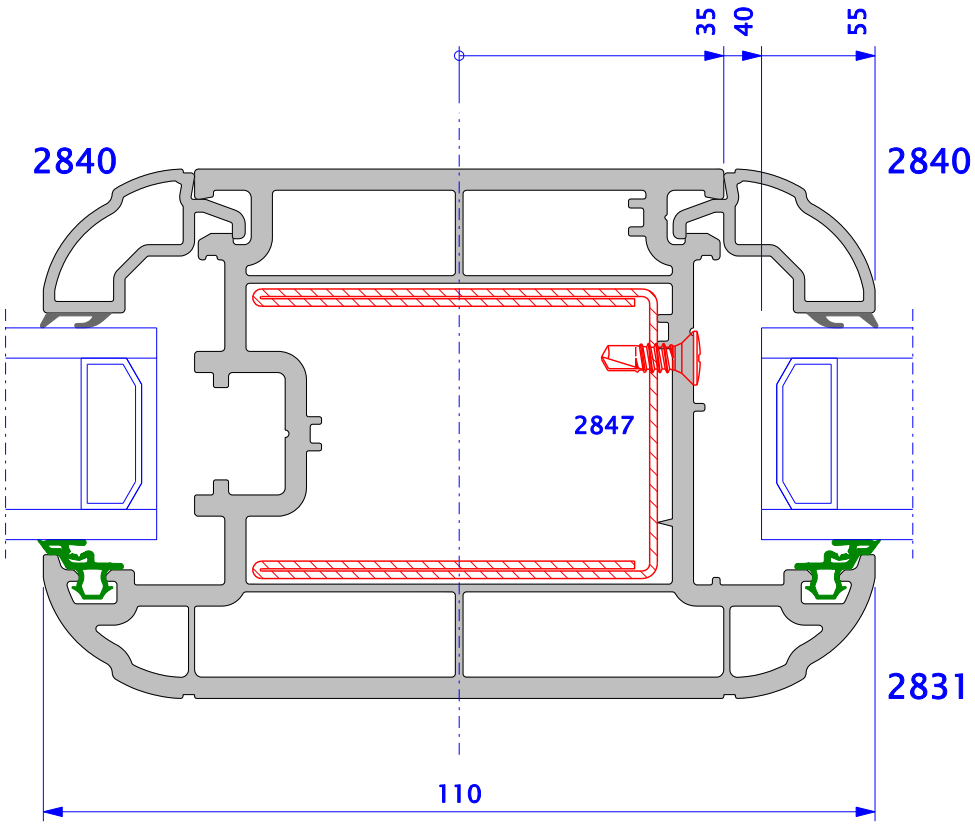

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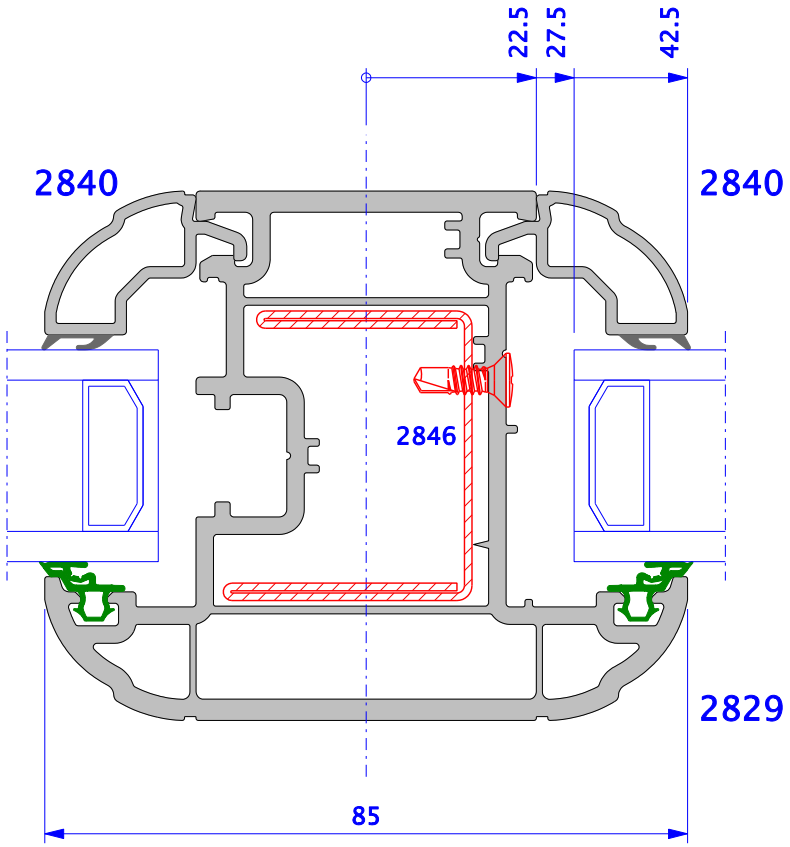

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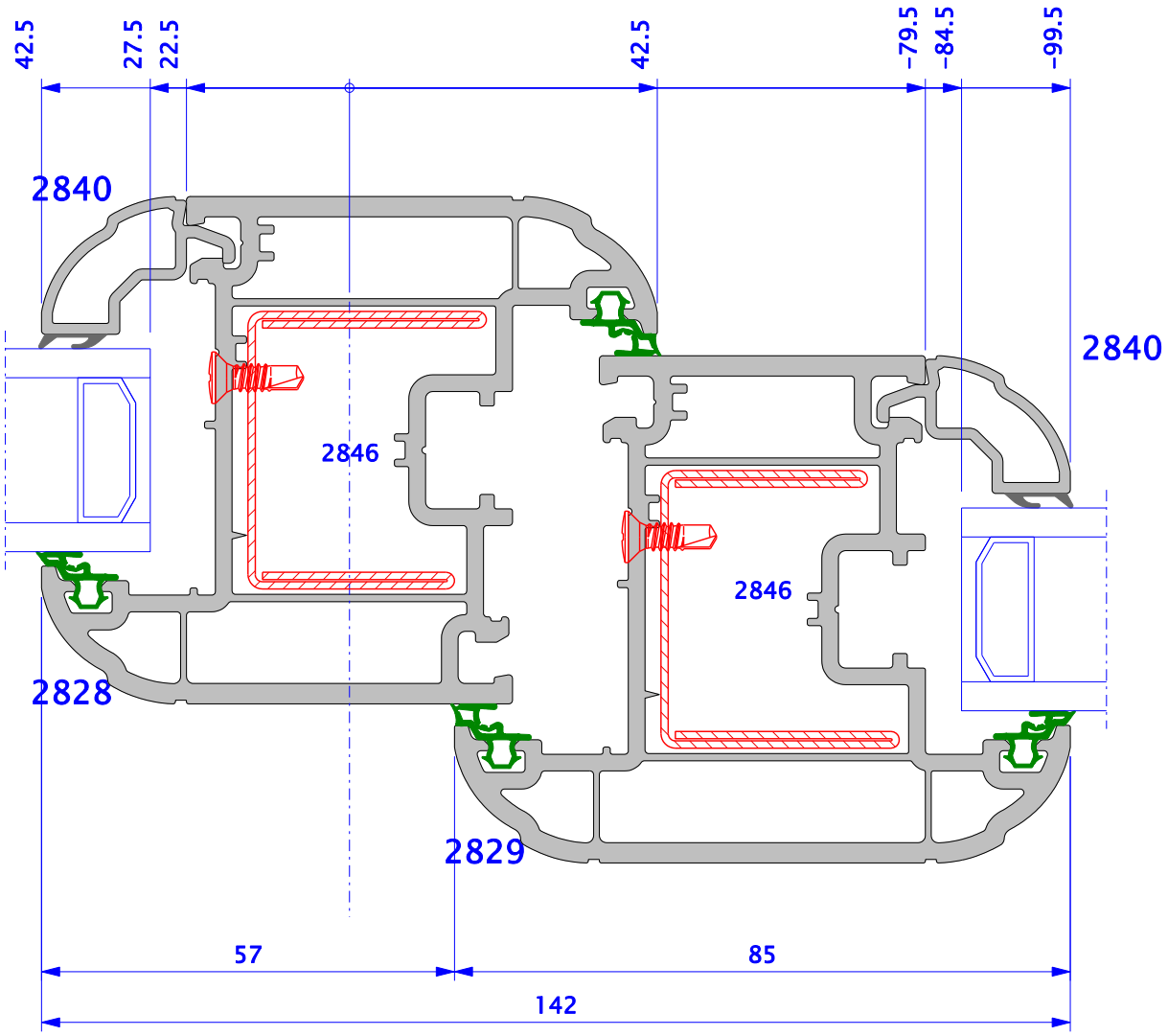
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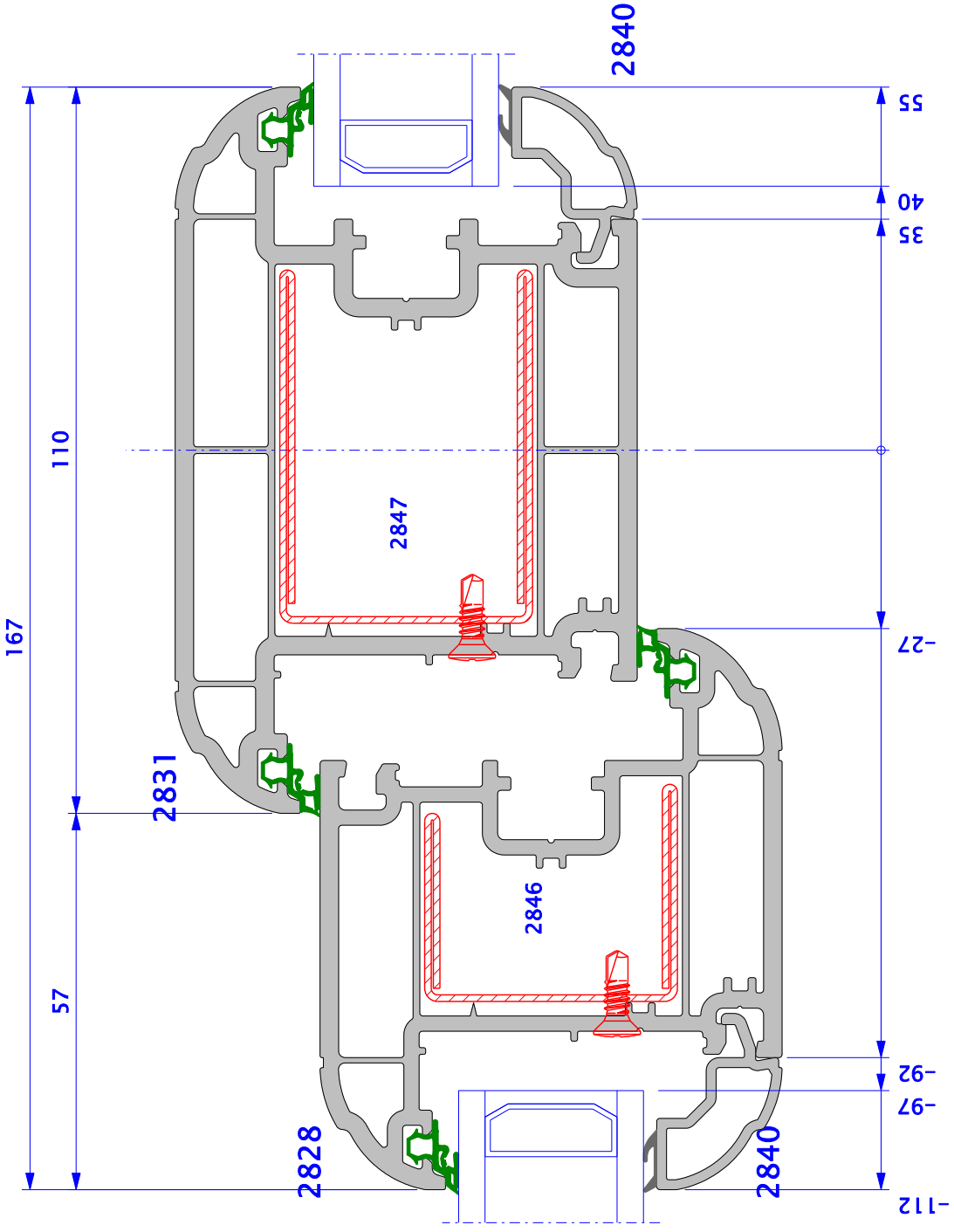
57
85
142

SECTIONS



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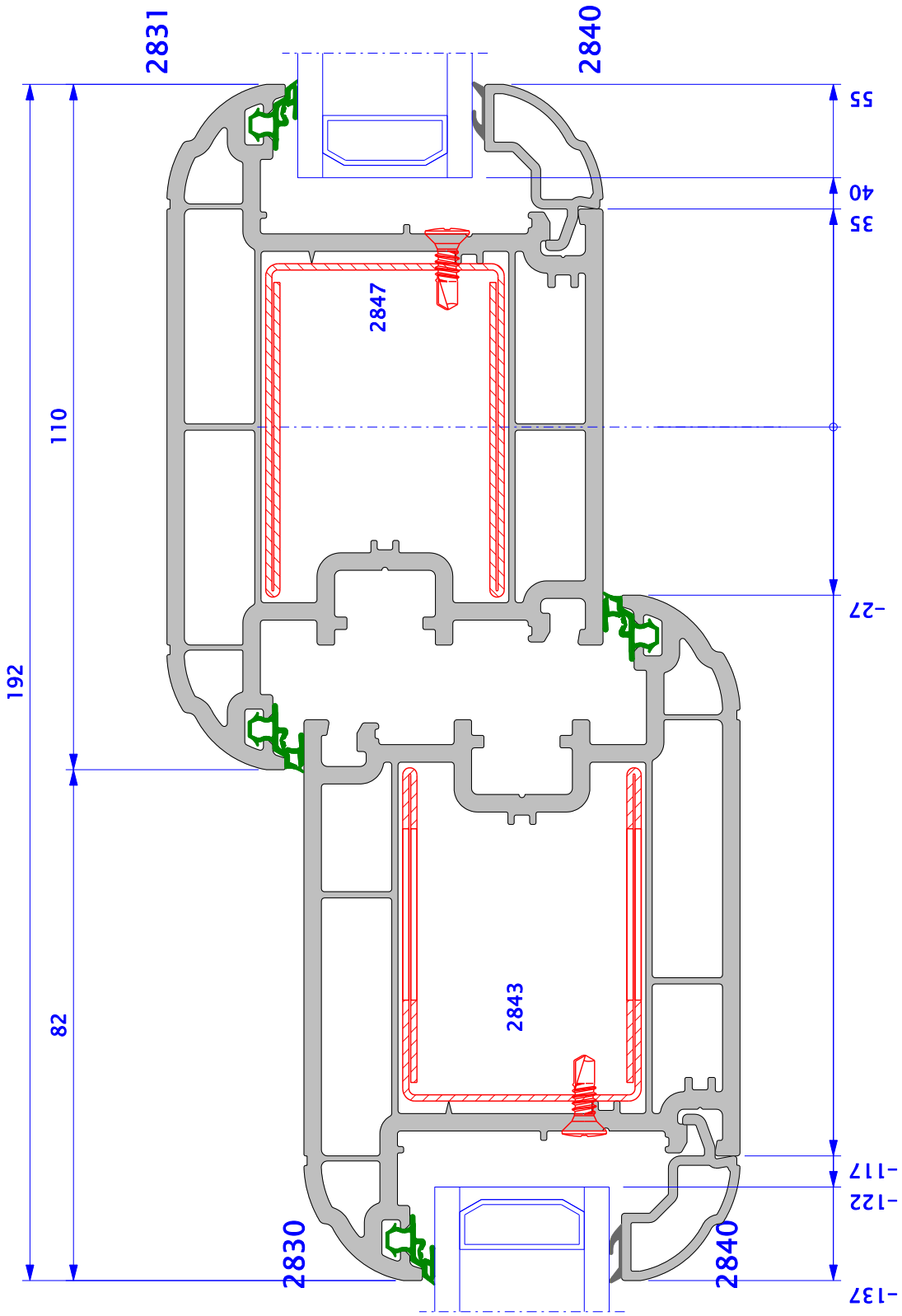

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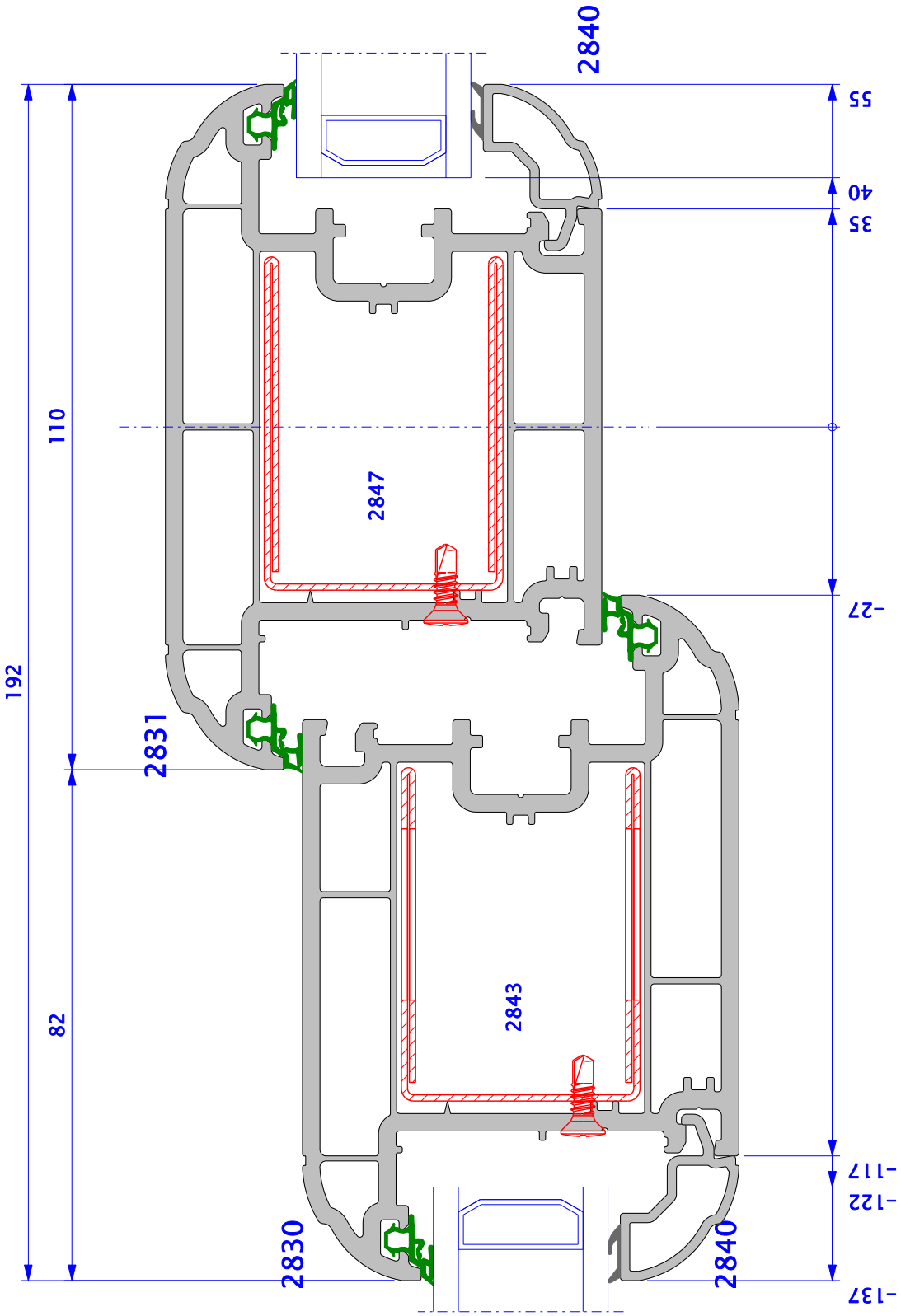

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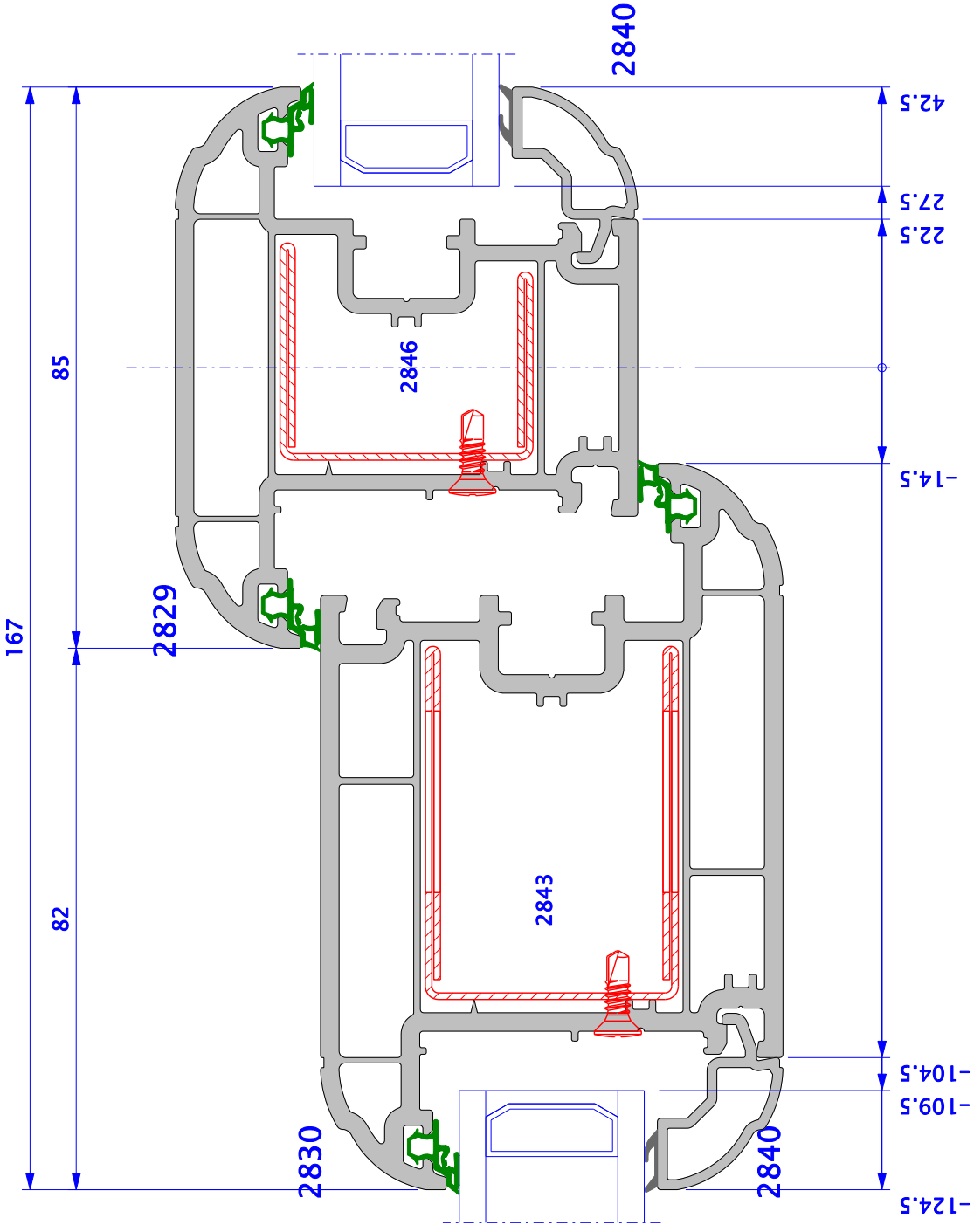
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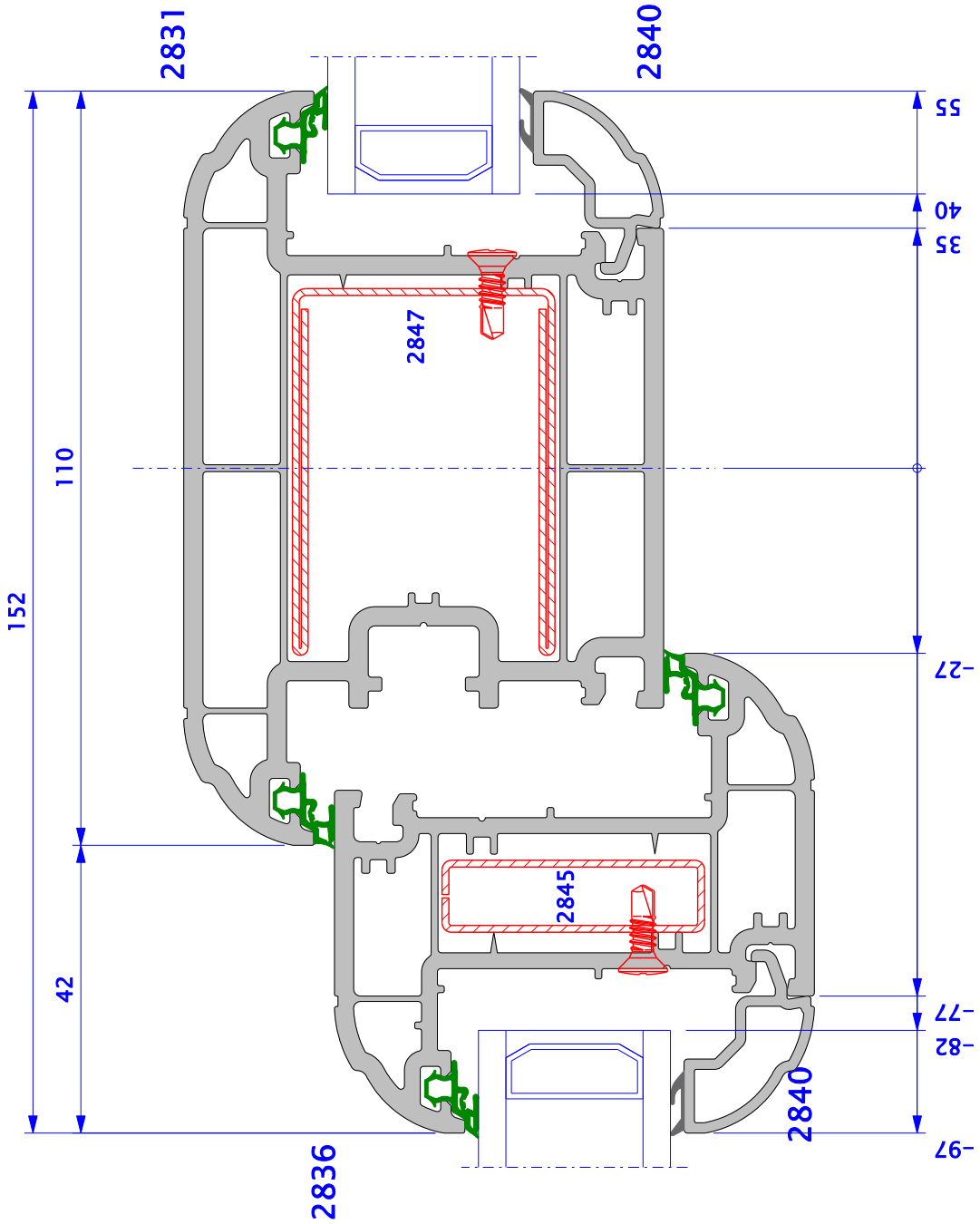
2840
124.5

SECTIONS



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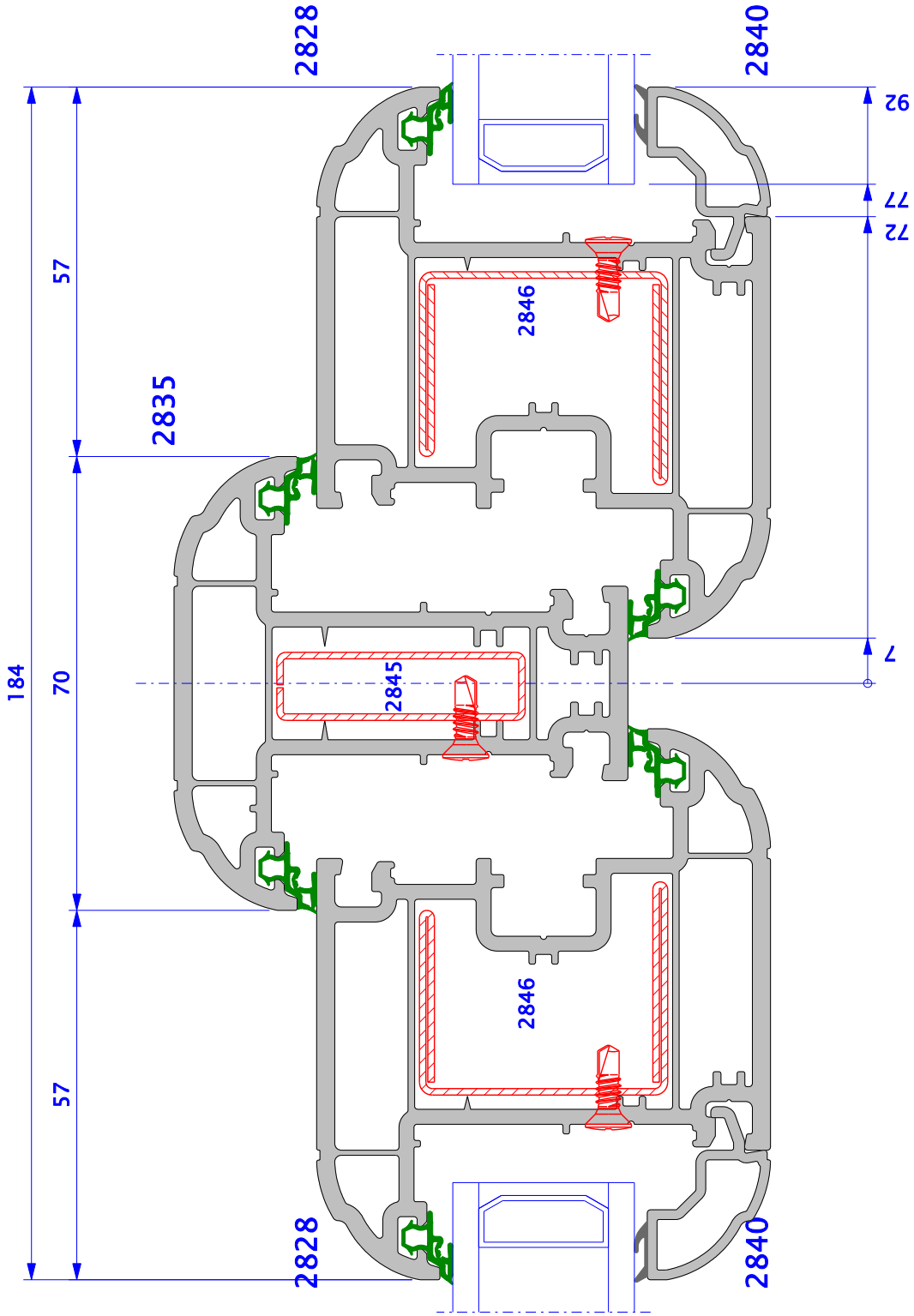

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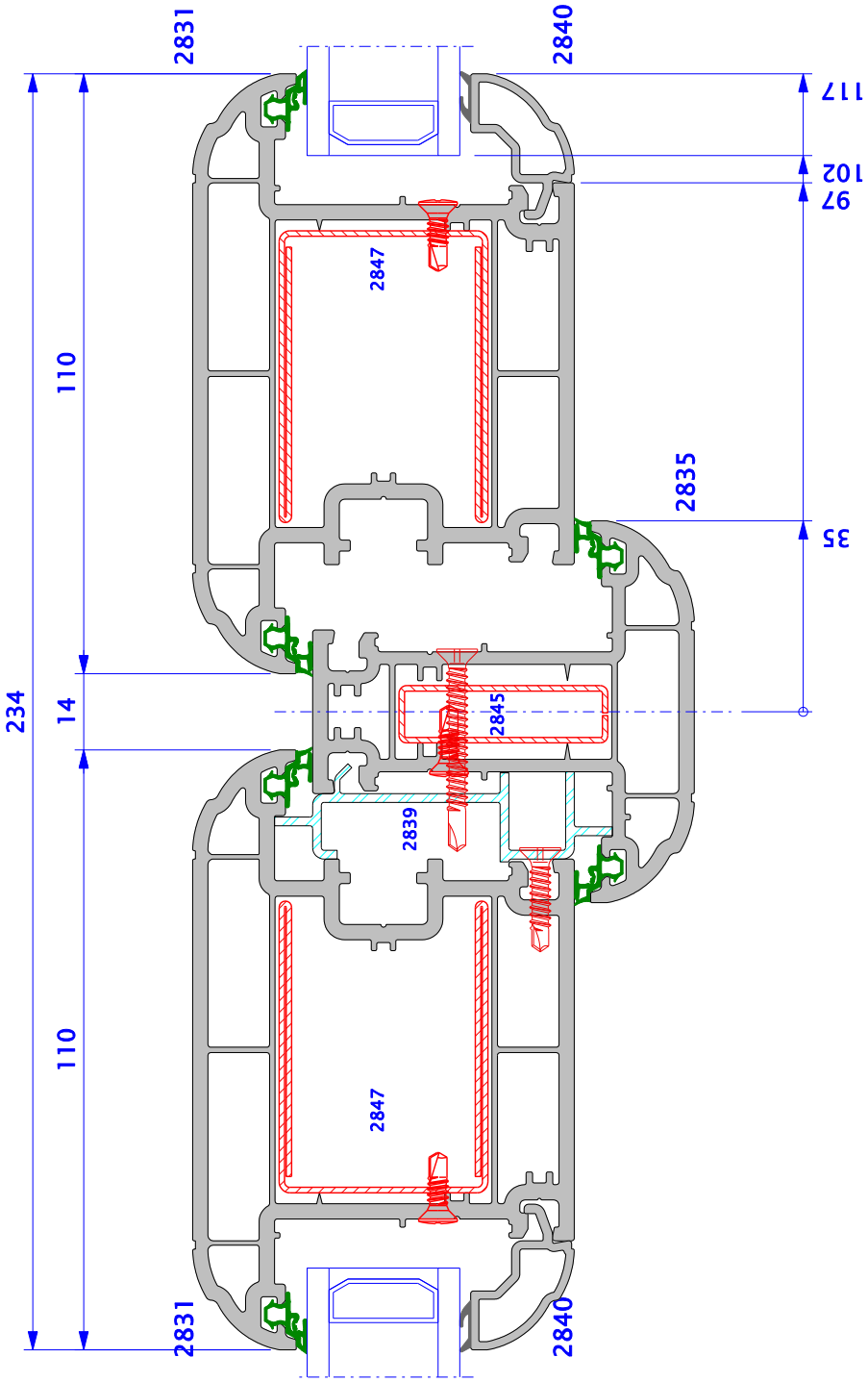
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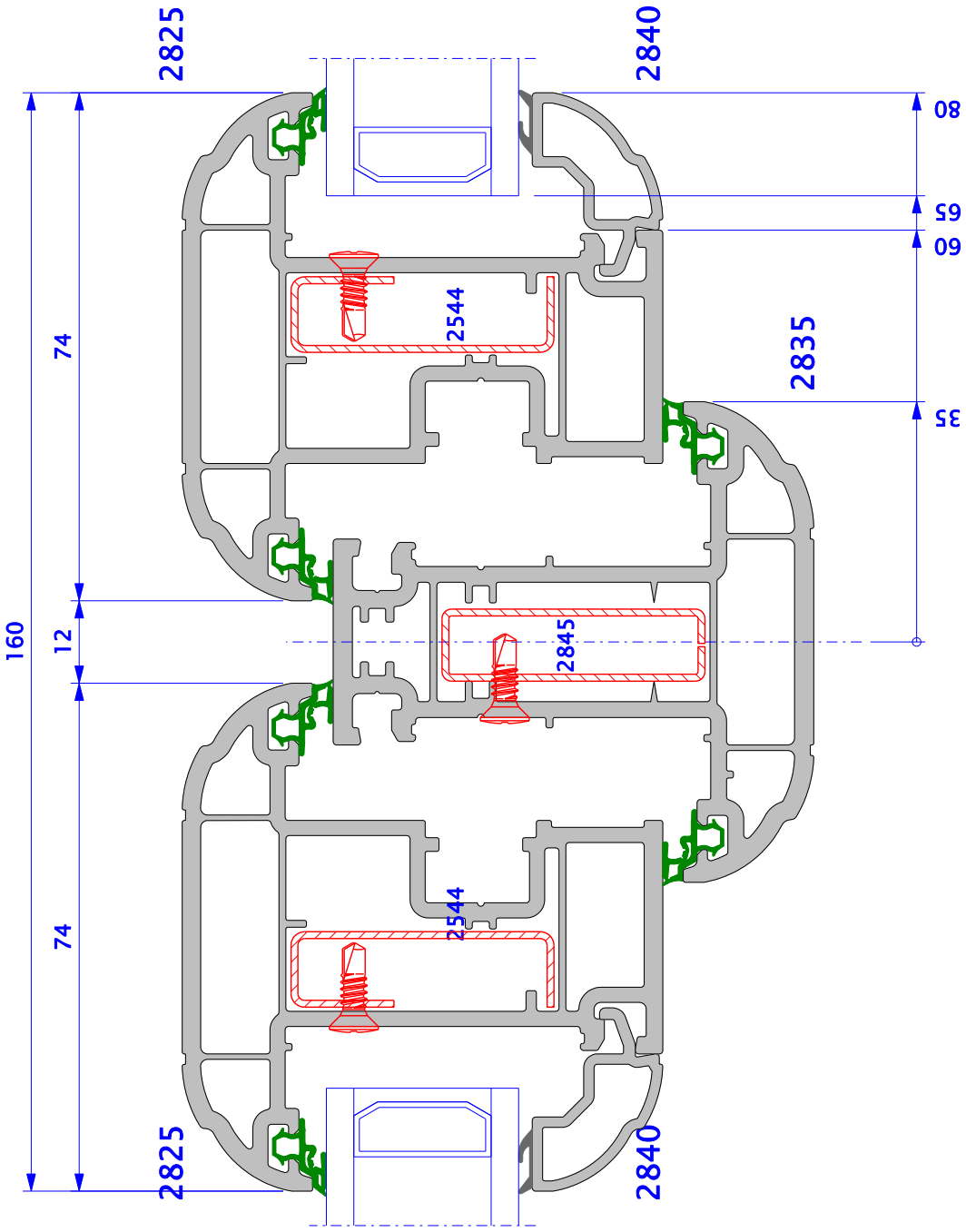
2840

SECTIONS



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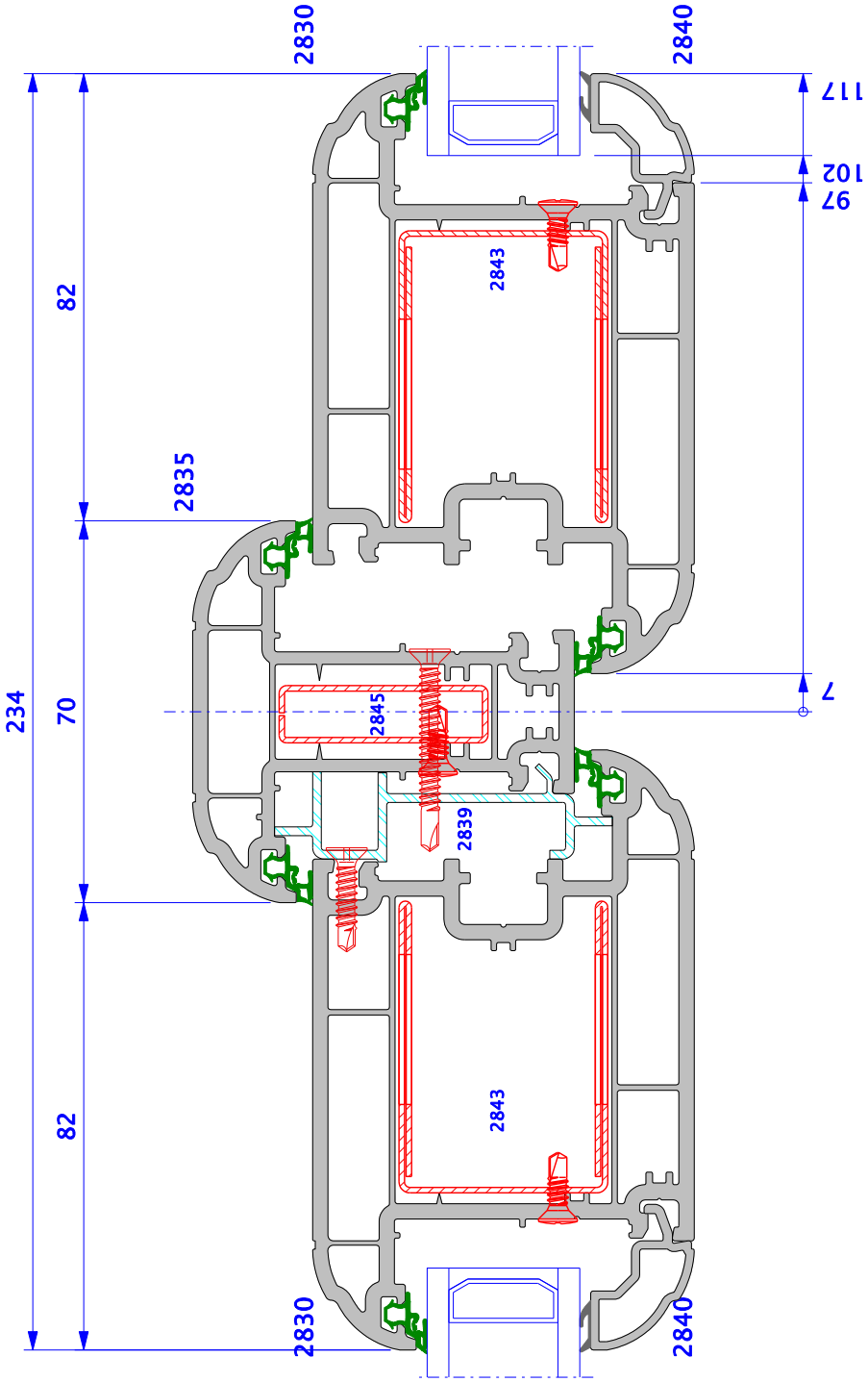
2830
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82
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234
70
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7
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82
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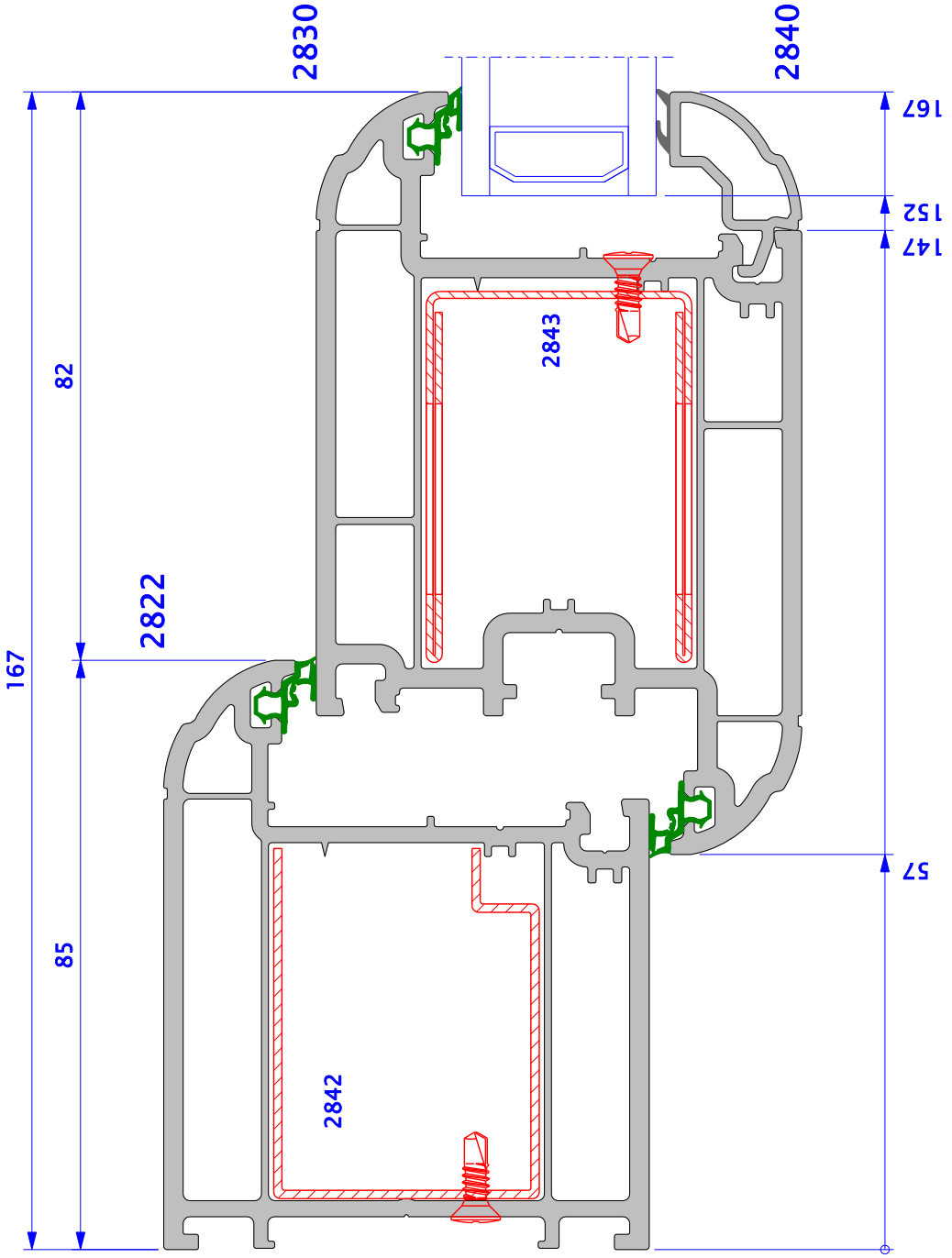
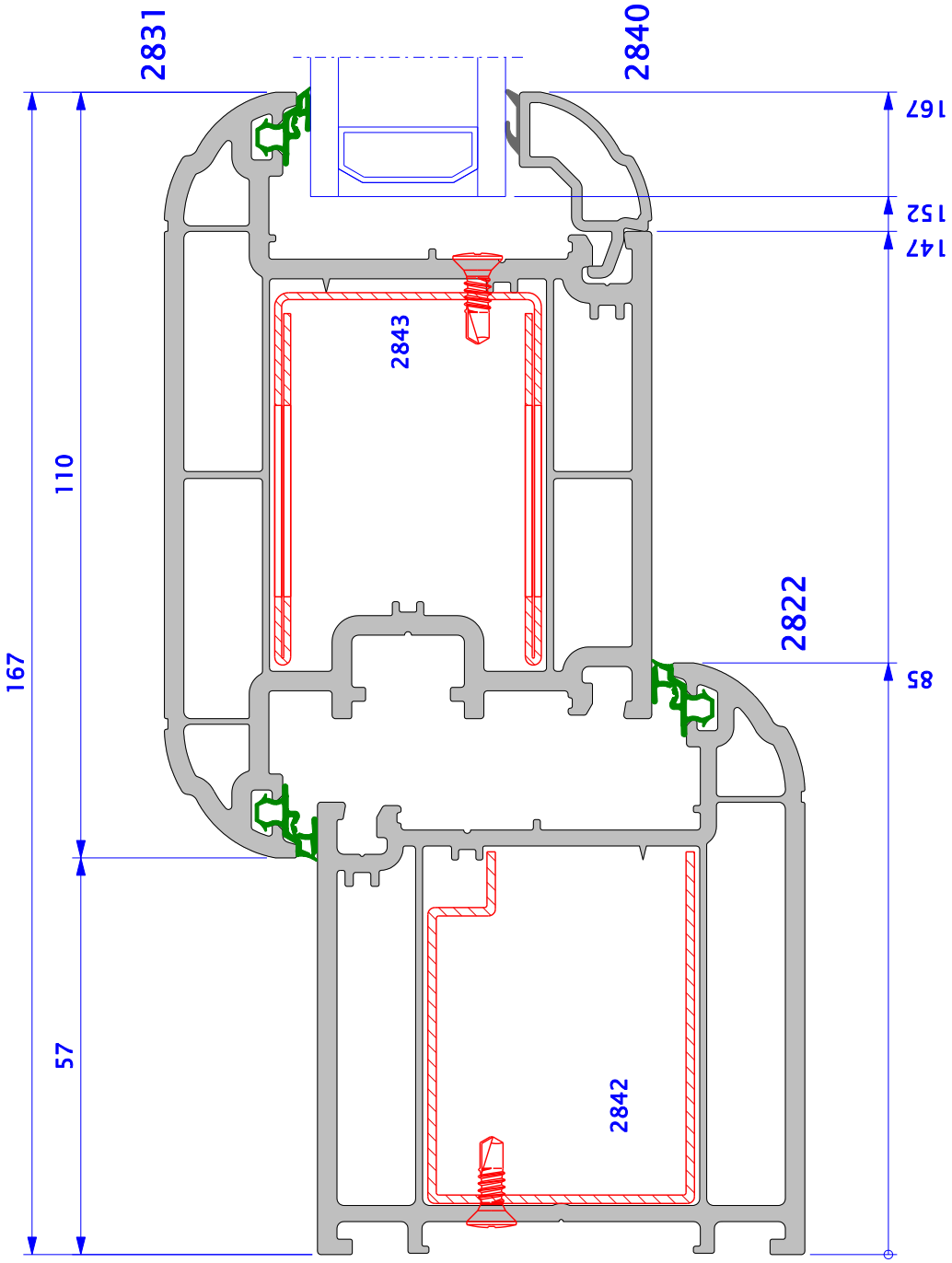
2840

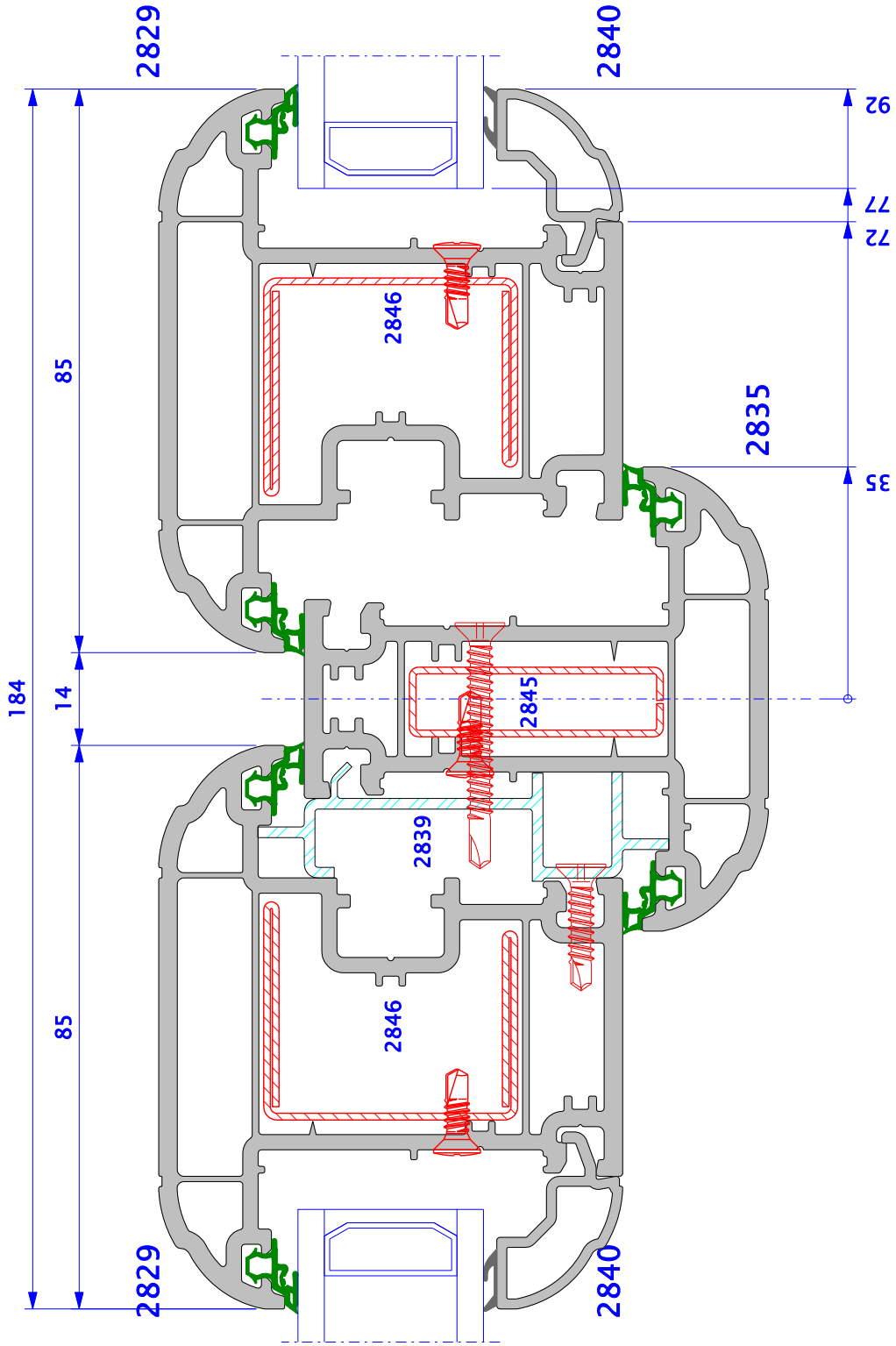
SECTIONS



SECTIONS



SECTIONS


2829
2840
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77
72
2846
85
2835
35
184
14
2845
2839
2846
85
2829
2840

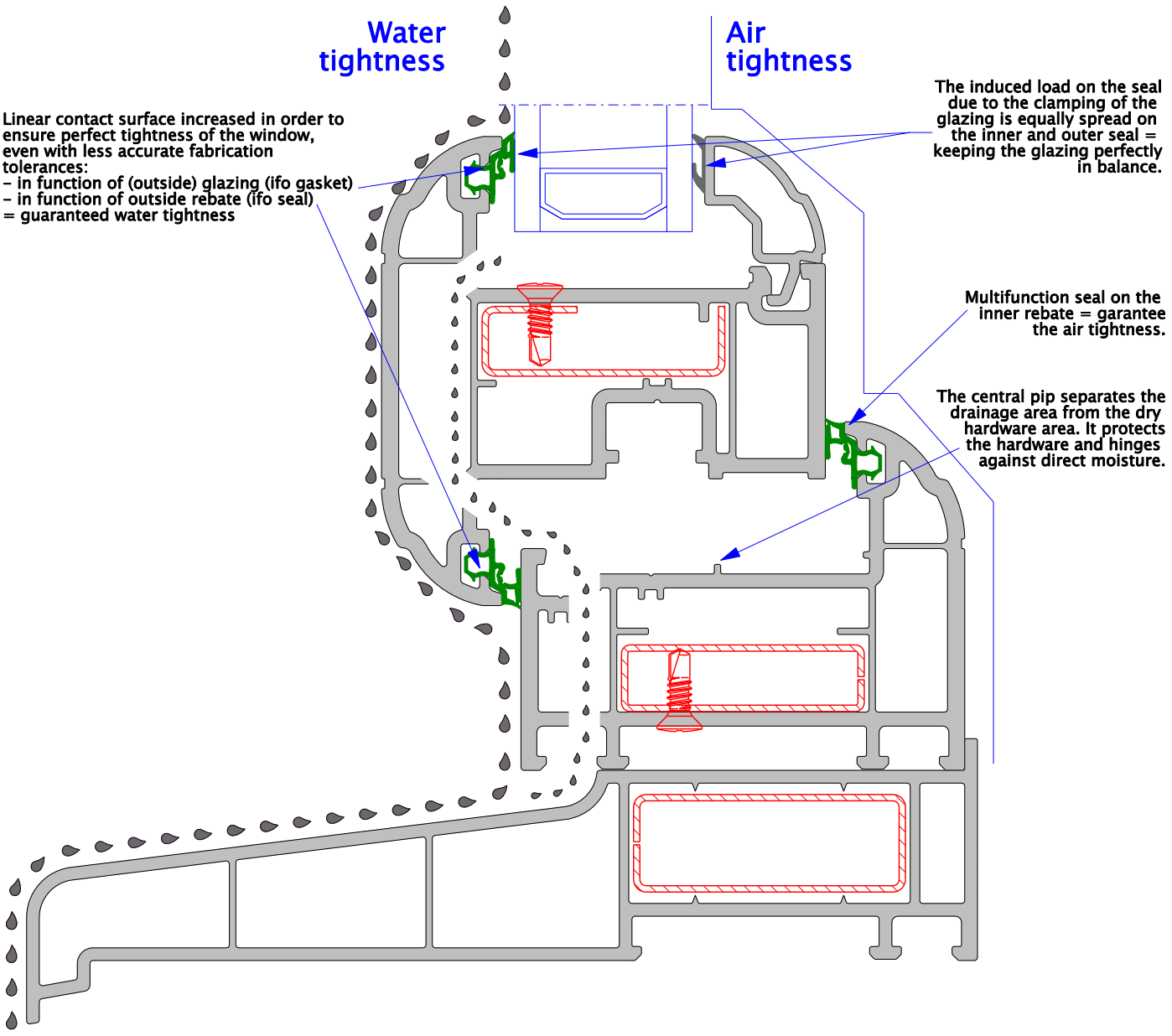
DRAINAGE & DECOMPRESSION

Why ?

- The 70mm system window is designed on a 'Pressure Equalized' basis.
  The correct positioning of decompression and drainage slots is essential to achieve the optimum performance capabilities of the window.

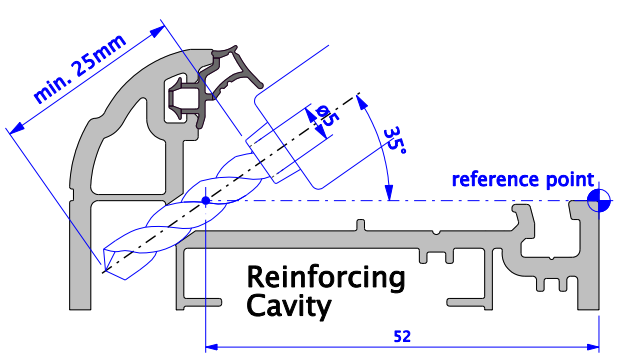
- The central chambers of the profiles are designed to retain any reinforcement required. Care must be taken to ensure that the slots do not cut into and expose the central chamber area.

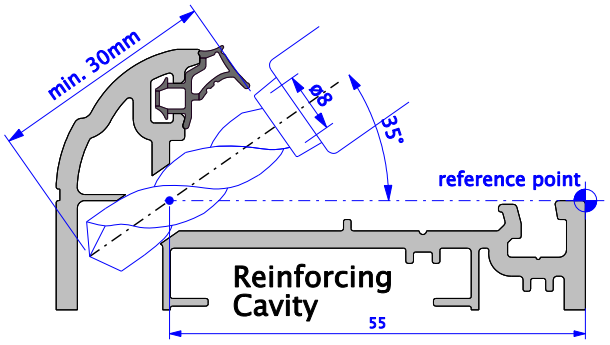
- Either slots or holes can be used to decompress and drain profiles.
  The recommended slot size = 27 x 5mm
  The recommended hole size = ø 8mm
  Decompression can also be achieved by partial gasket removal
  The recommended gasket removal = Minimum 2 X 25mm



Machine settings

- The standard setting for angled cavity drainage is between 30°-40°. If possible, 35° is recommended, for 30° & 40° a specific tuning of the machines is required.
  Below are examples of how angled cavity drainage should be set to prevent the risk of breaking through into the reinforcing cavity and also to eliminate the risk of profile or gasket damage.





- The miller/drill needs to project a min of 25mm/30mm to avoid damaging the profile or gasket
- Ensure that the tip of the 8mm drill breaks through both internal webs as shown above especially if set at 30°.

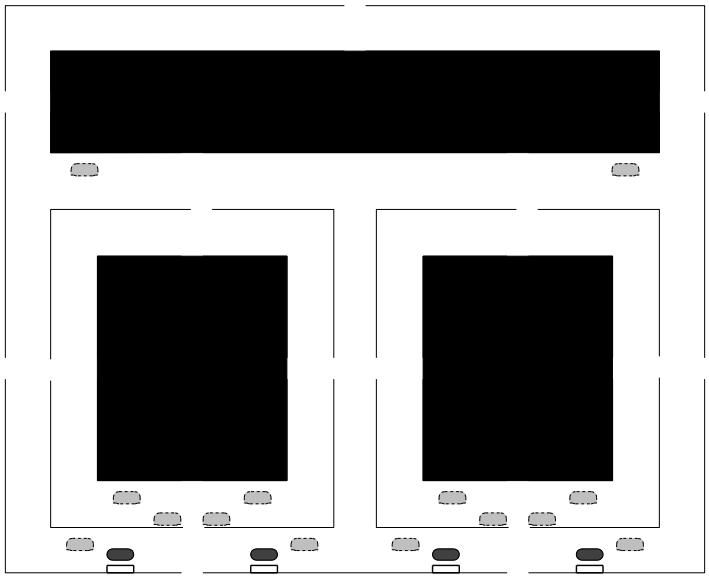
Configuration

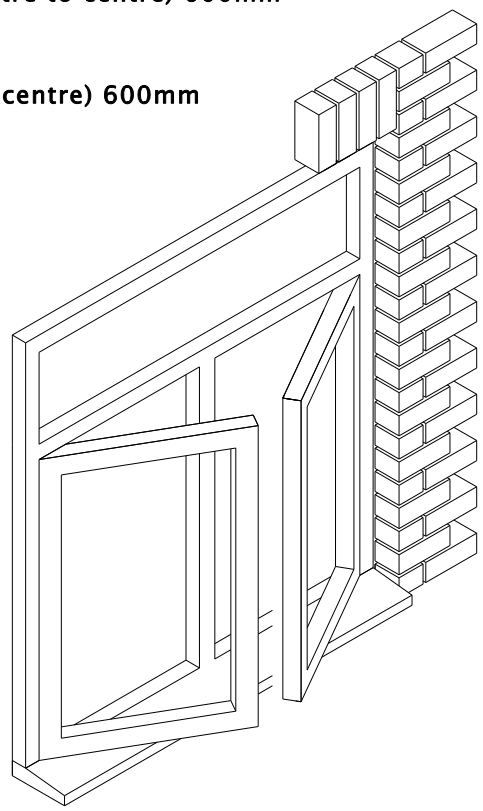
- Drain hole preparation (per section) :
  minimum 2 holes (out of each corner) per profile (see specific drawings)
  ① Cavity (drainage area):
    - slot min. 27mm long x 5mm wide, spacing (Centre to Centre) 600mm
    - or 8mm drilling, spacing 600mm

  ② Concealed (drainage area):
    - slot min. 27mm long x 5mm wide, spacing (Centre to centre) 600mm
    - or 8mm drilling, spacing 600mm

  ③ Face (drainage area):
  slot min. 27mm long x 5mm wide, spacing (Centre to centre) 600mm
    - or 8mm drilling, spacing 600mm

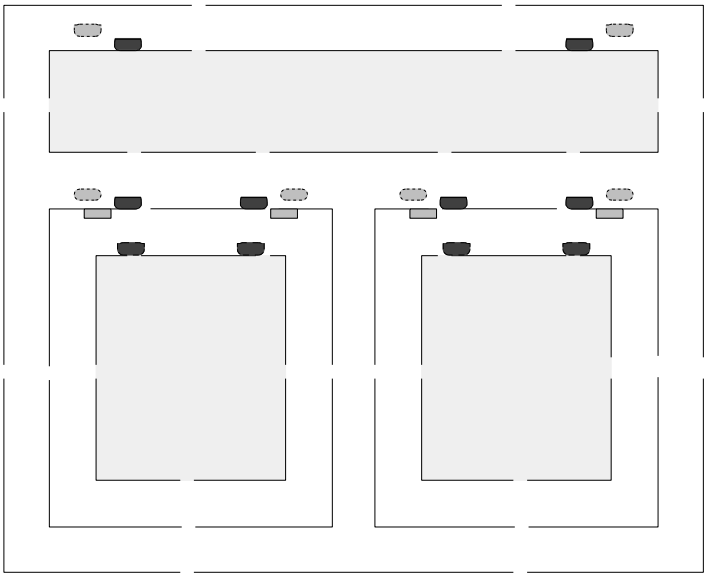
Typical drainage slot positions

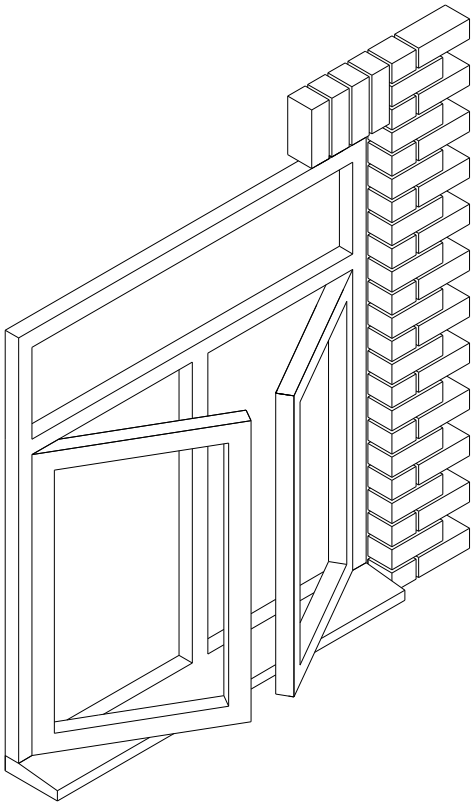




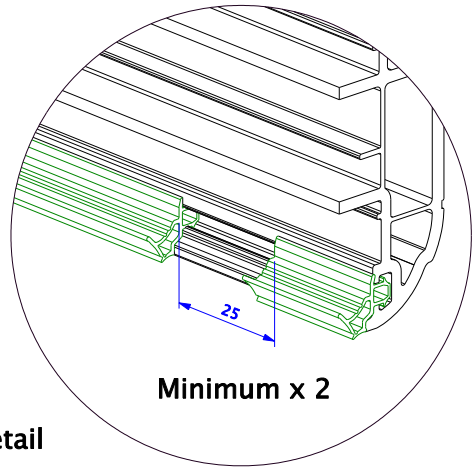
- decompression preparation (per section) :
  - o inner (decompression area) :
    - slot min. 27 mm long x 5 mm wide (minimum 2)
    - or 8 mm drilling (min. 2)
  - o outer (decompression area) :
    - slot min. 27 mm long x 5 mm wide (min. 2)
    - or 8 mm drilling (min. 2)

Typical decompression slot positions





o Alternatively these two slots or holes can be replaced by a partialy removing the external gasket over a distance of 25mm adjacent to each of the drainage slots in the bottom of each frame.



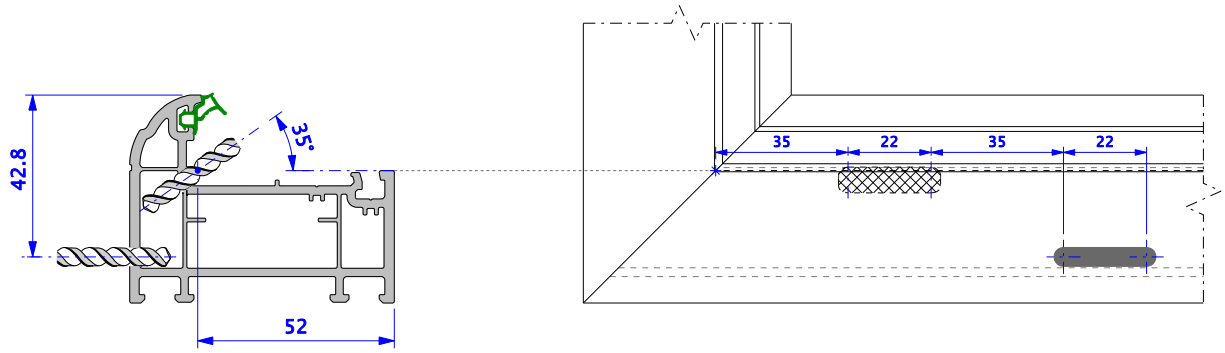
Minimum x 2

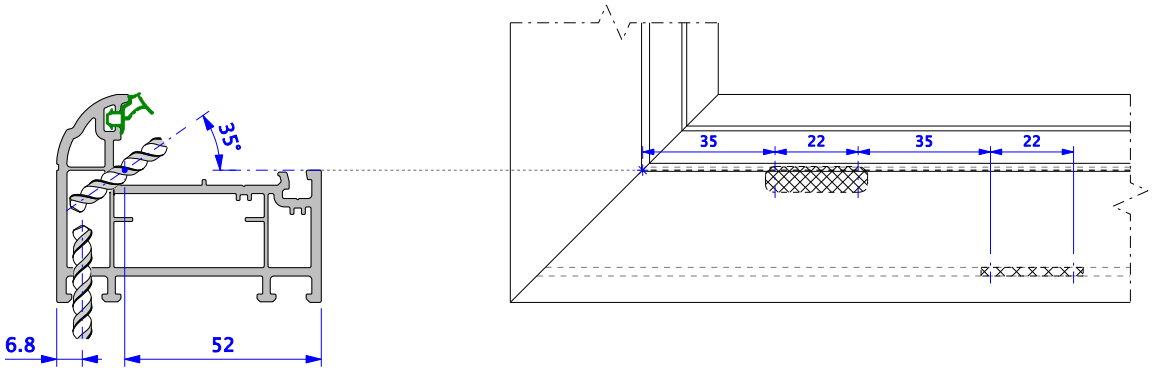
Detail

Drainage ø5 mm

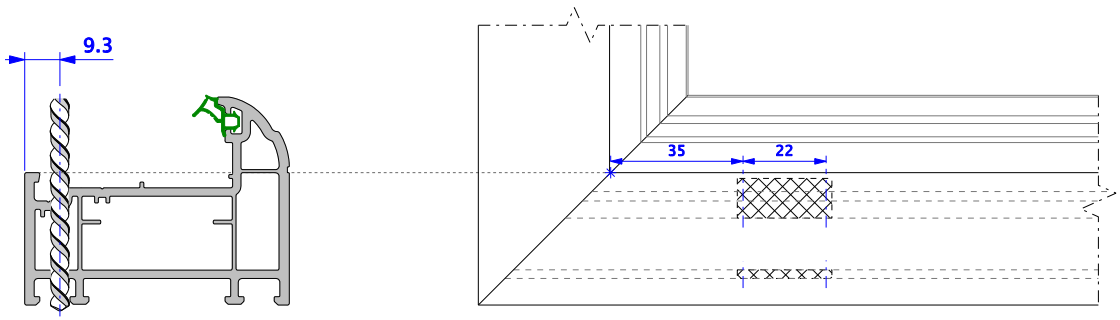
2832

Internally beaded





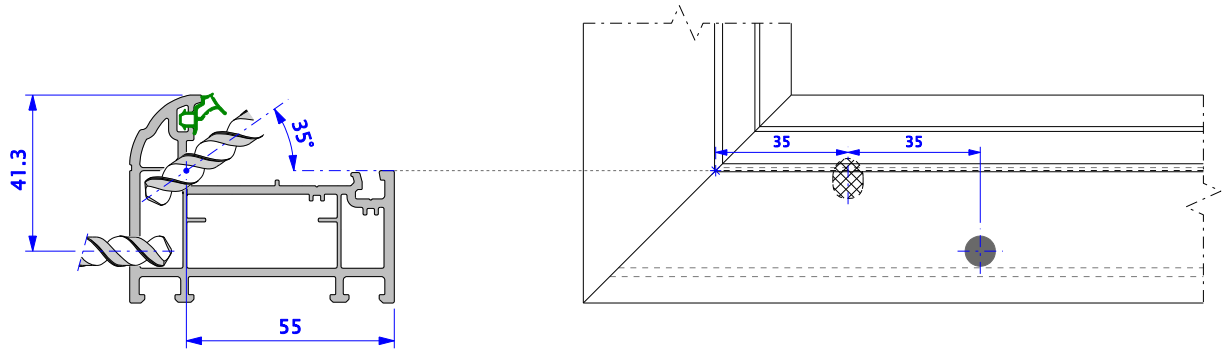
Externally beaded

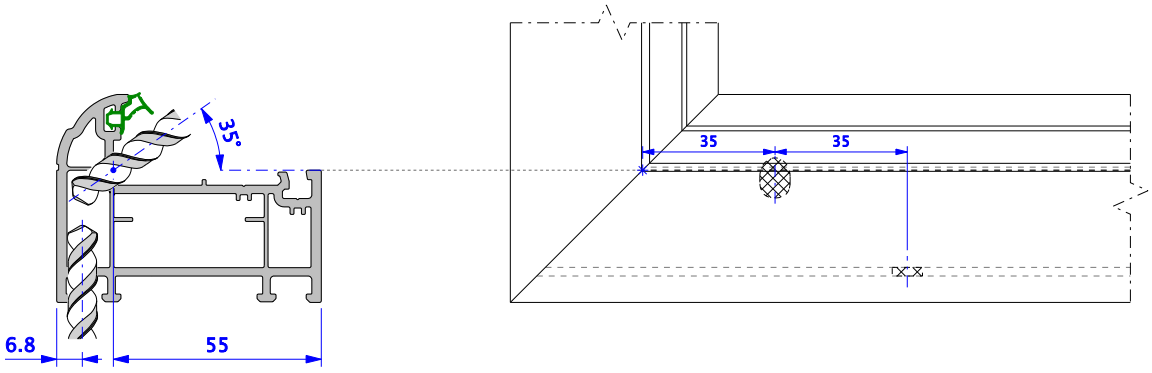


Drainage ø8 mm

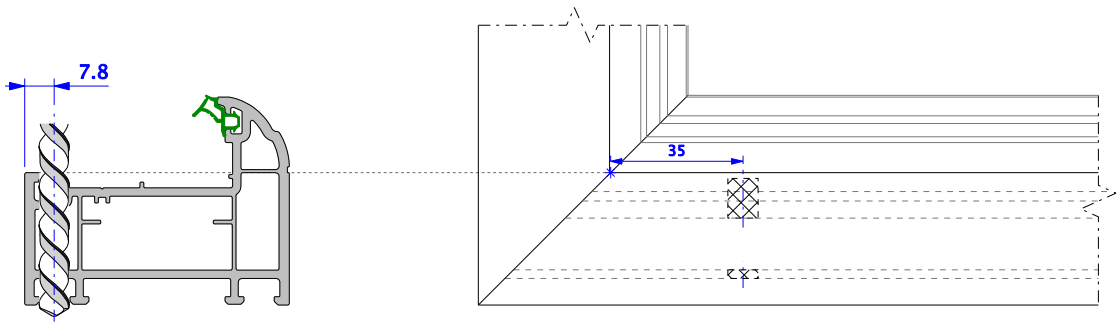
2832

Internally beaded





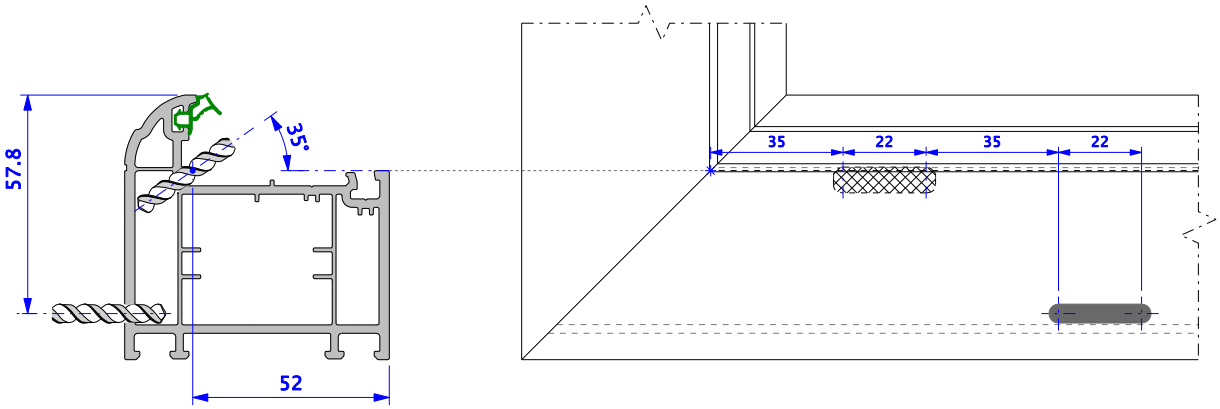
Externally beaded

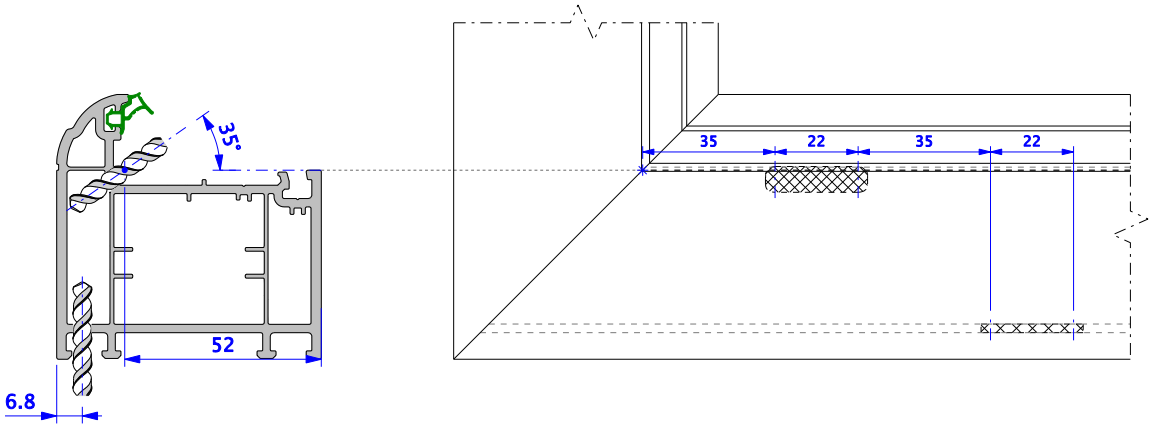


Drainage ø5 mm

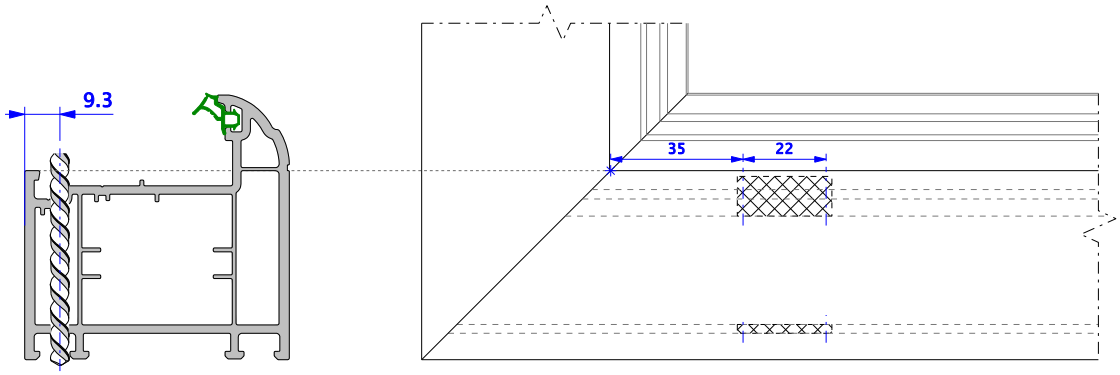
2833

Internally beaded





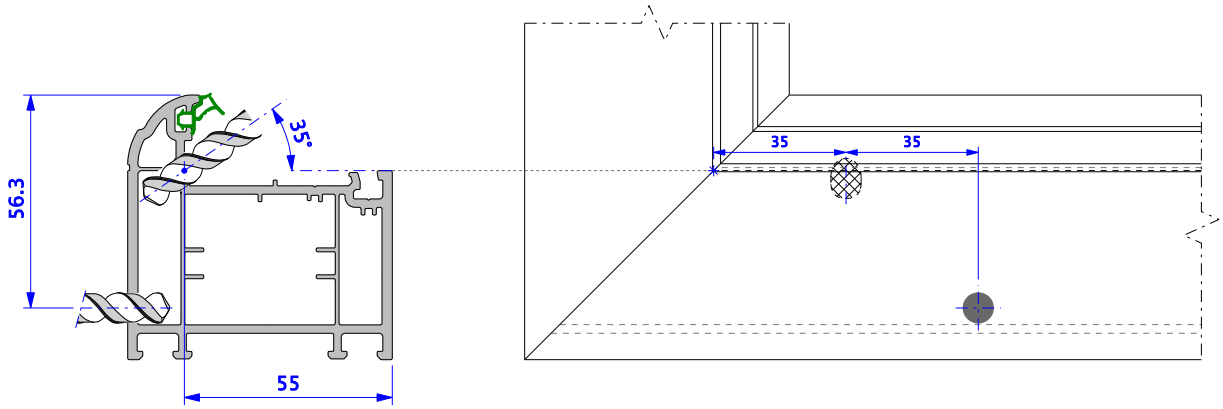
Externally beaded

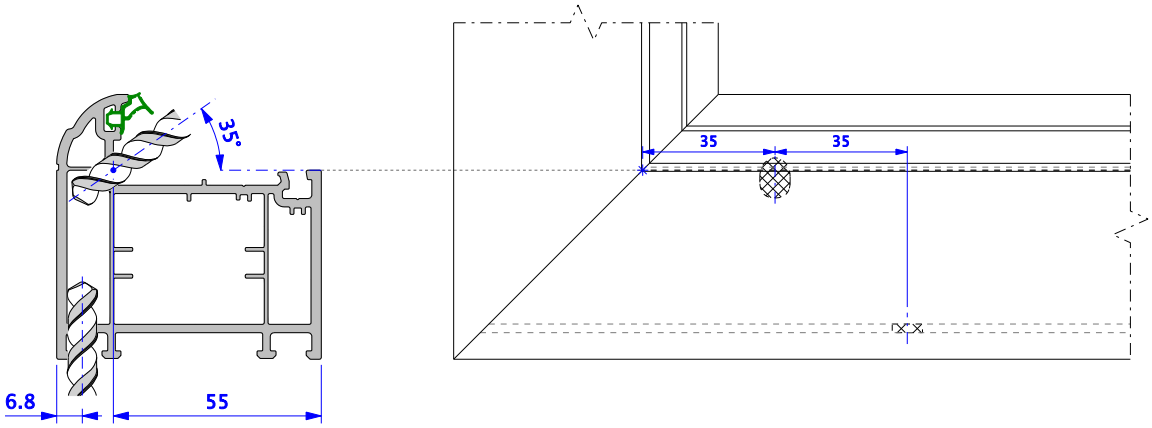


Drainage ø8 mm

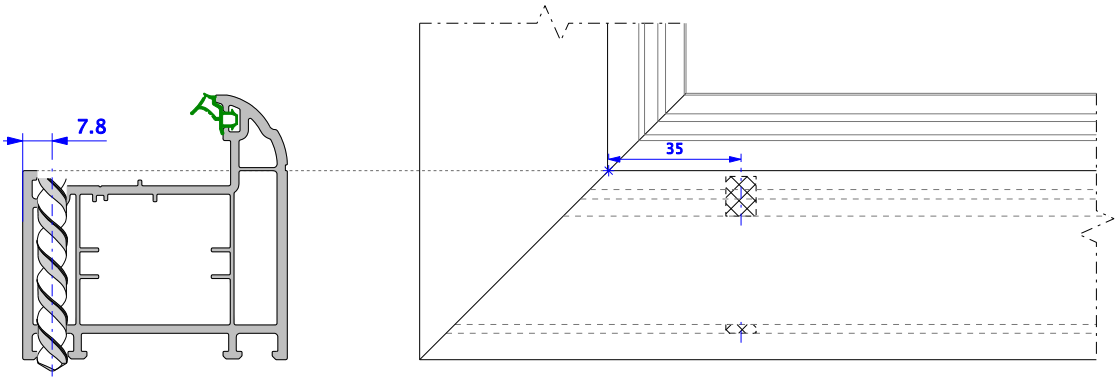
2833

Internally beaded





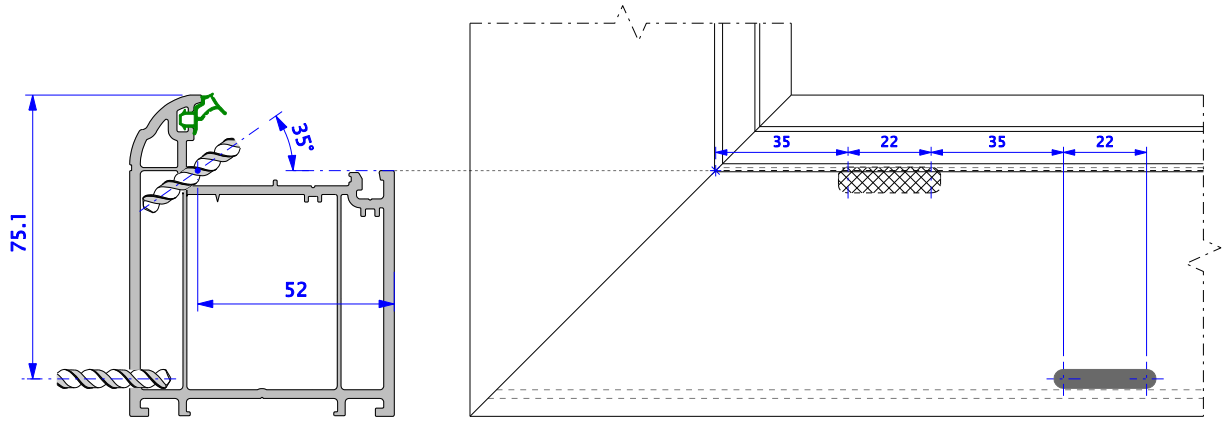
Externally beaded

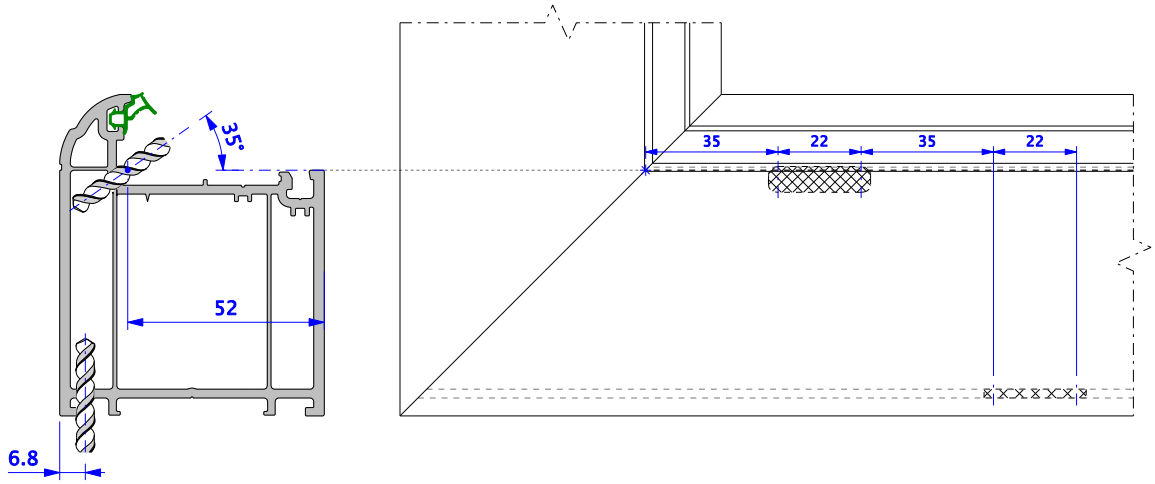


Drainage ø5 mm

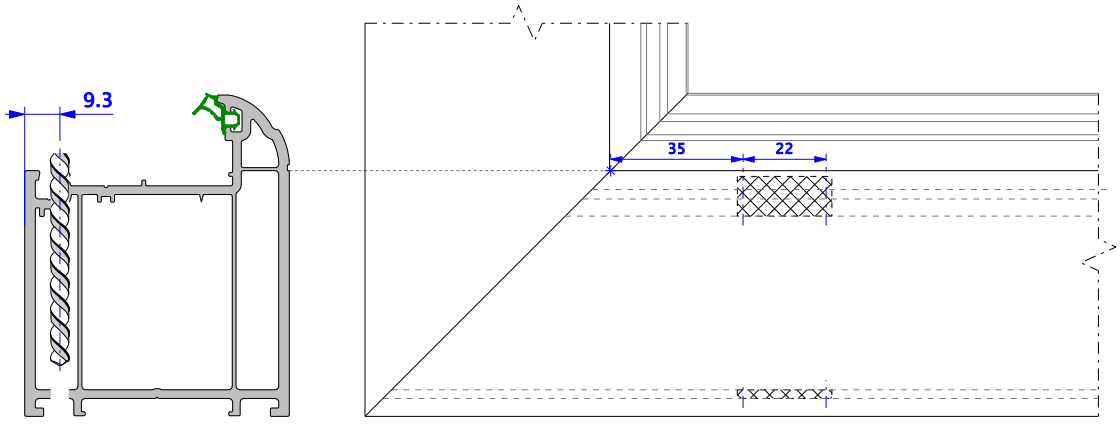
2822

Internally beaded





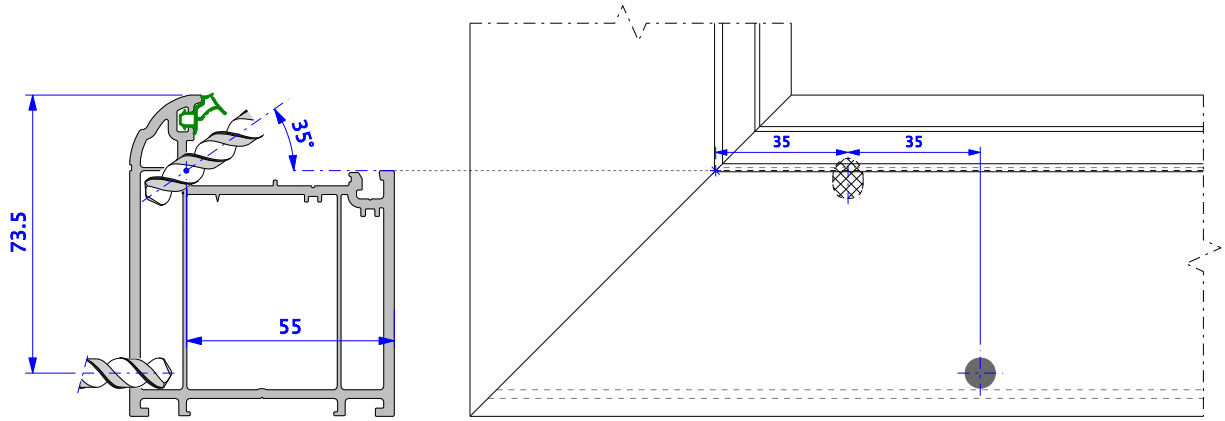
Externally beaded

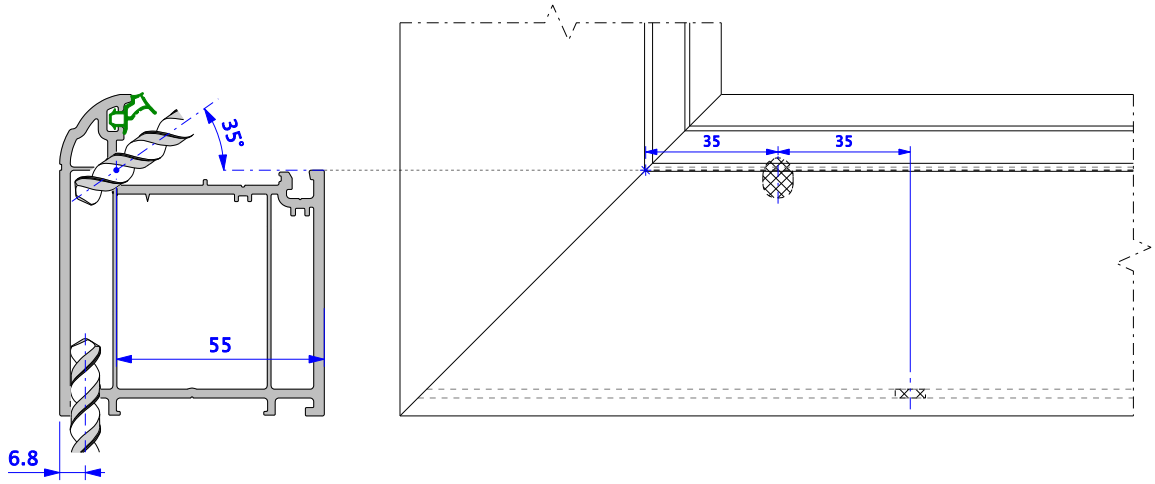


Drainage ø8 mm

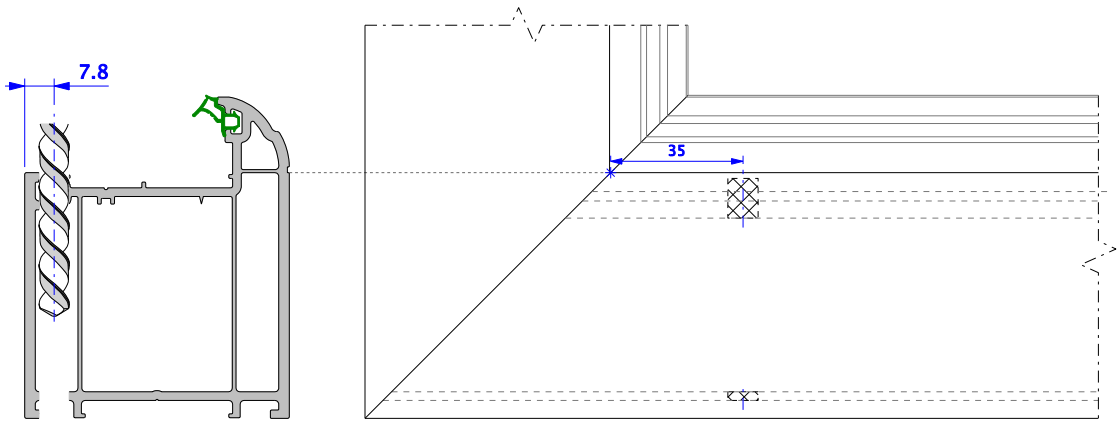
2822

Internally beaded





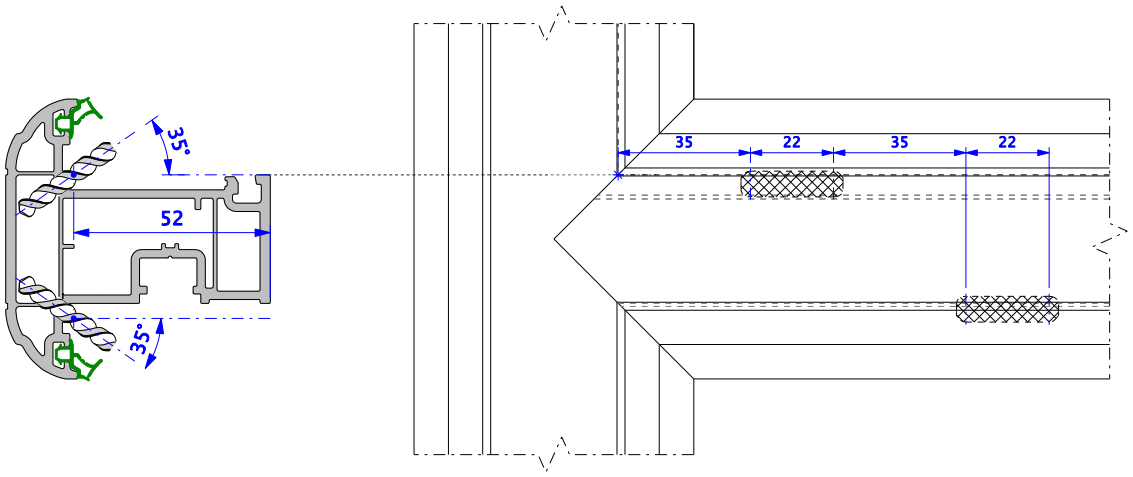
Externally beaded



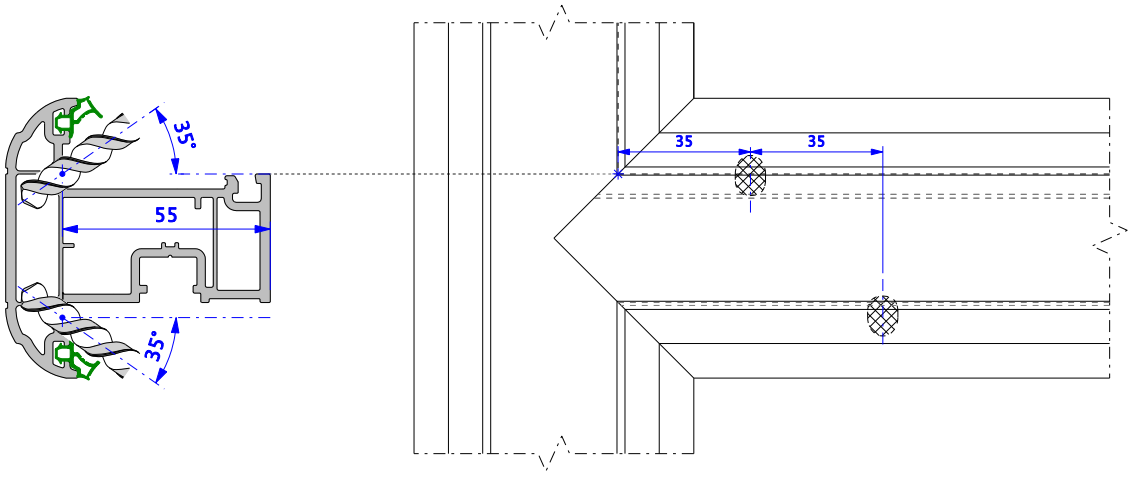
Drainage ø5 & 8 mm

2825

drainage ø5mm



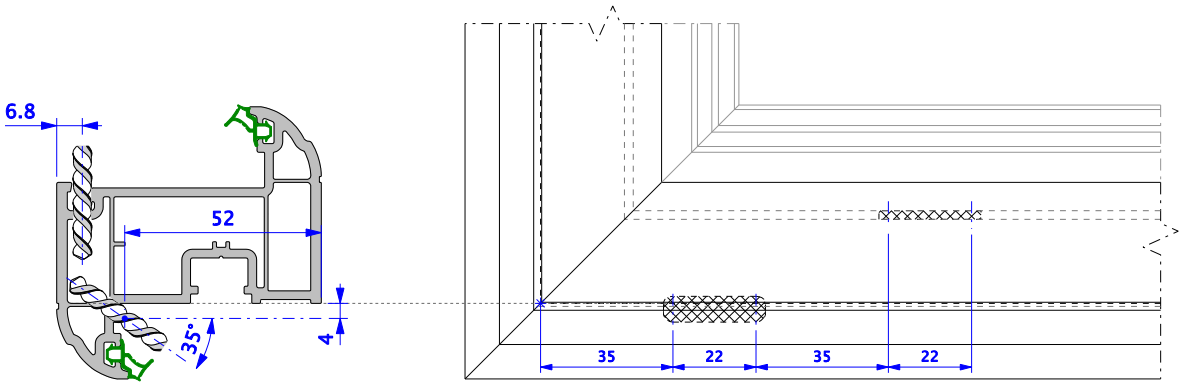
drainage ø8mm



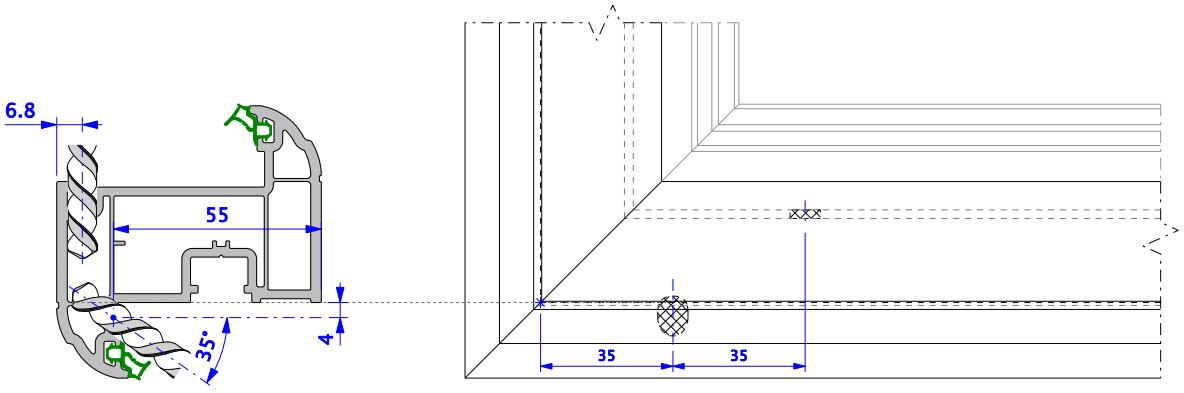
Drainage ø5 & 8 mm

2826

drainage ø5mm



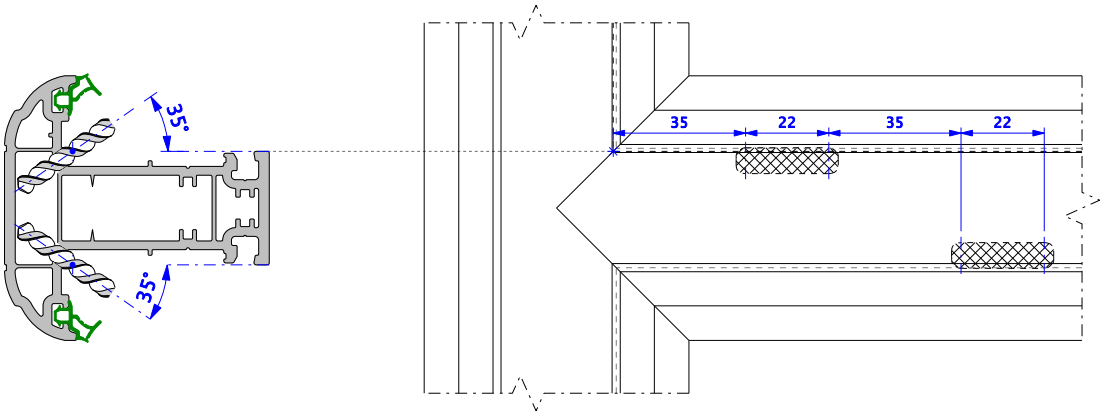
drainage ø8mm



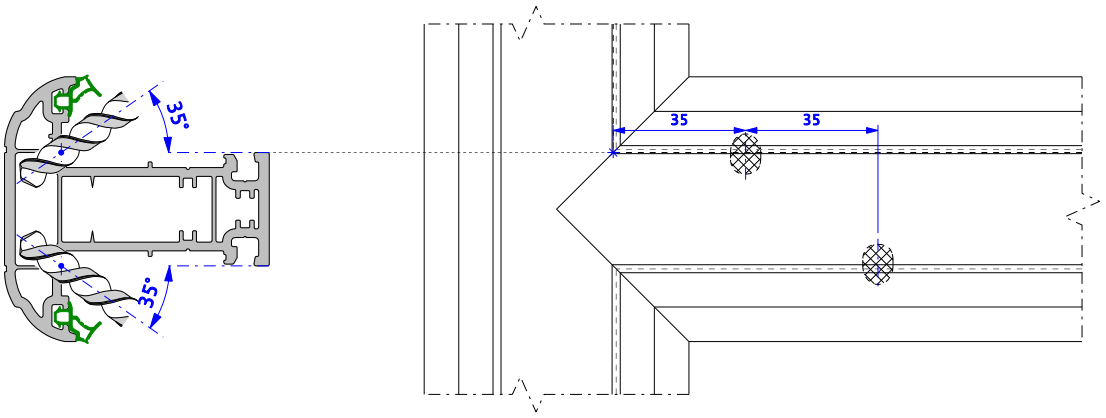
Drainage ø5 & 8 mm

2835

drainage ø5mm



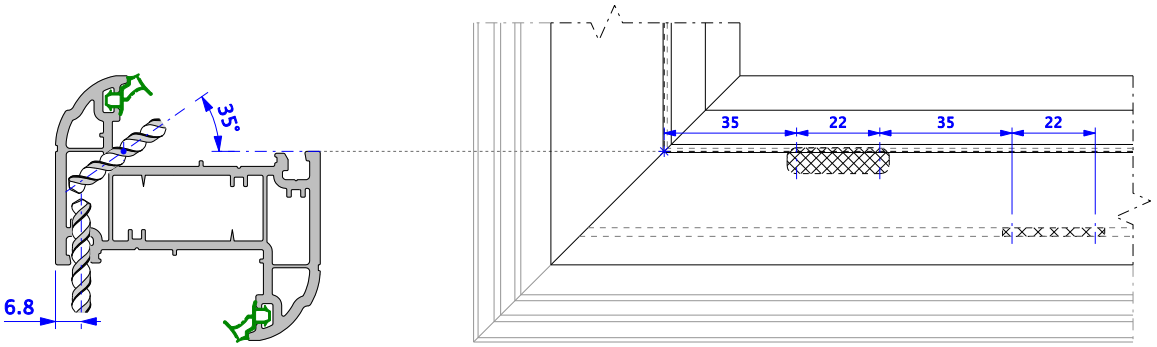
drainage ø8mm



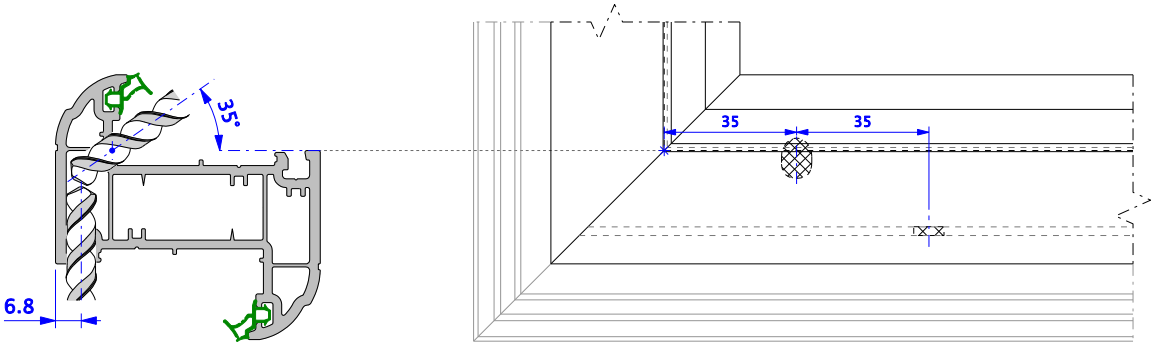
Drainage ø5 & 8 mm

2836

drainage ø5mm



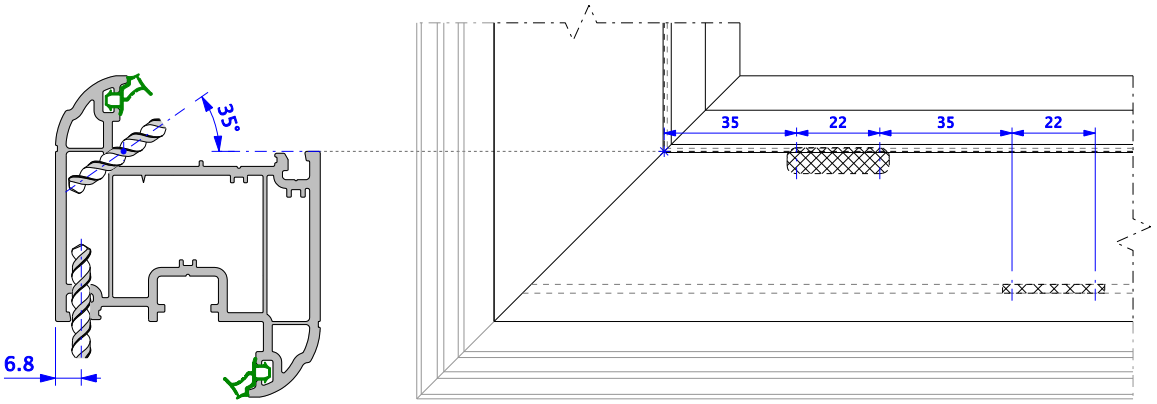
drainage ø8mm



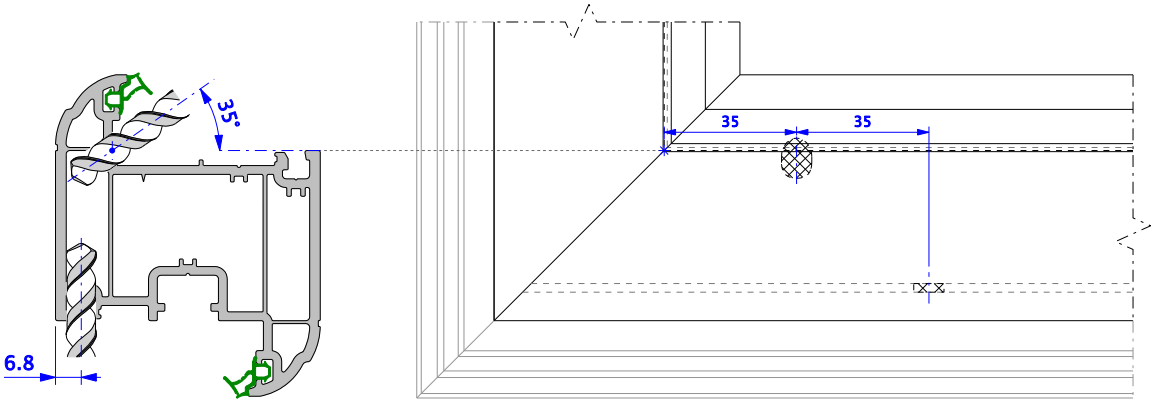
Drainage ø5 & 8 mm

2828

drainage ø5mm



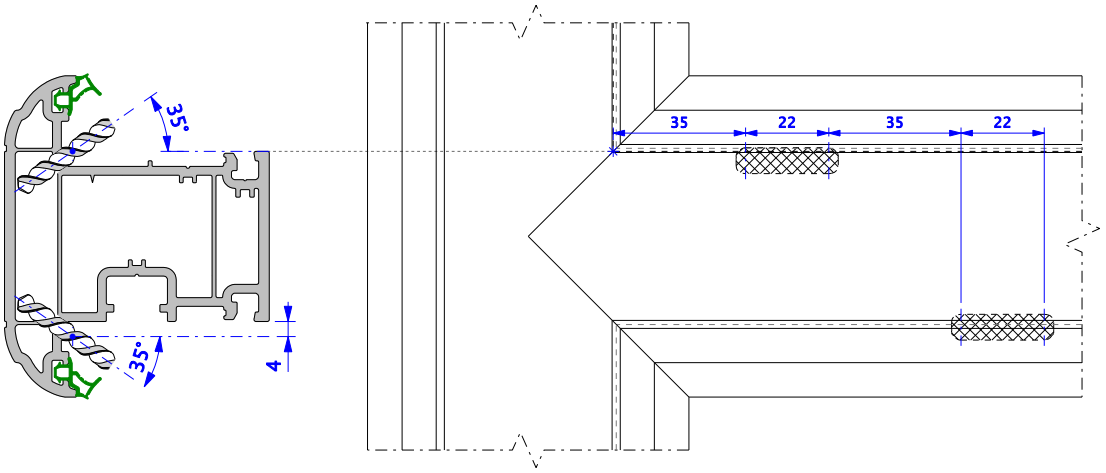
drainage ø8mm



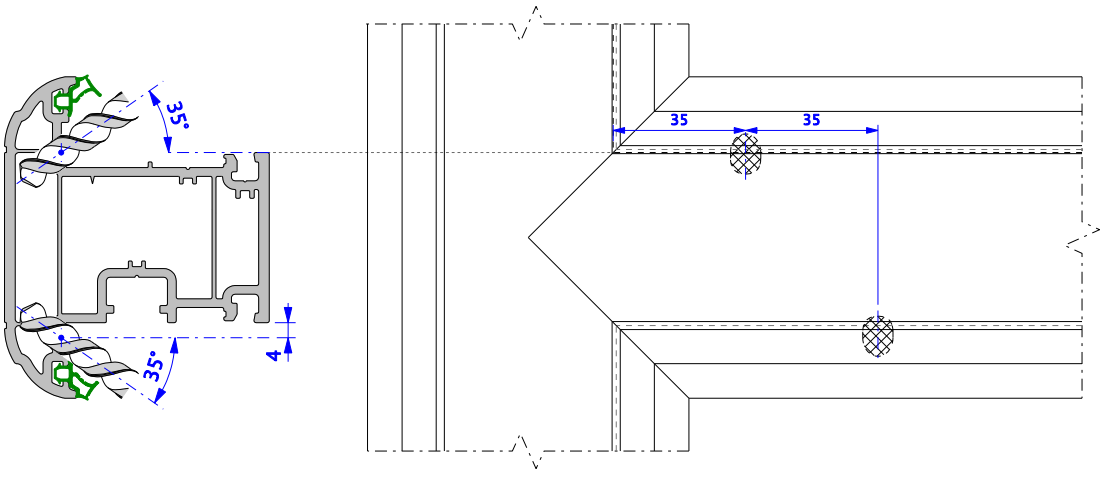
Drainage ø5 & 8 mm

2829

drainage ø5mm



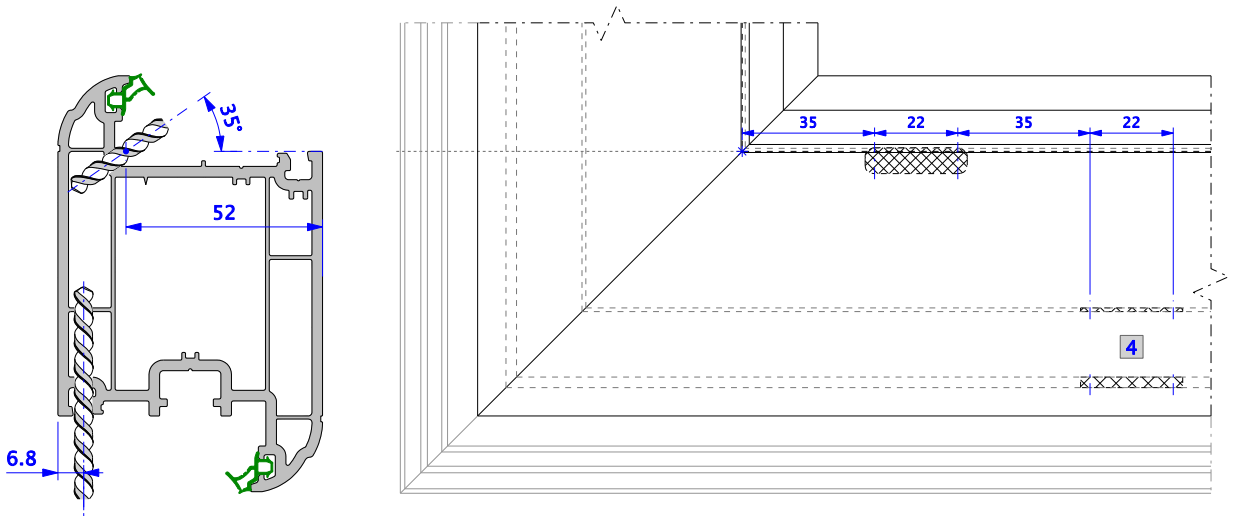
drainage ø8mm



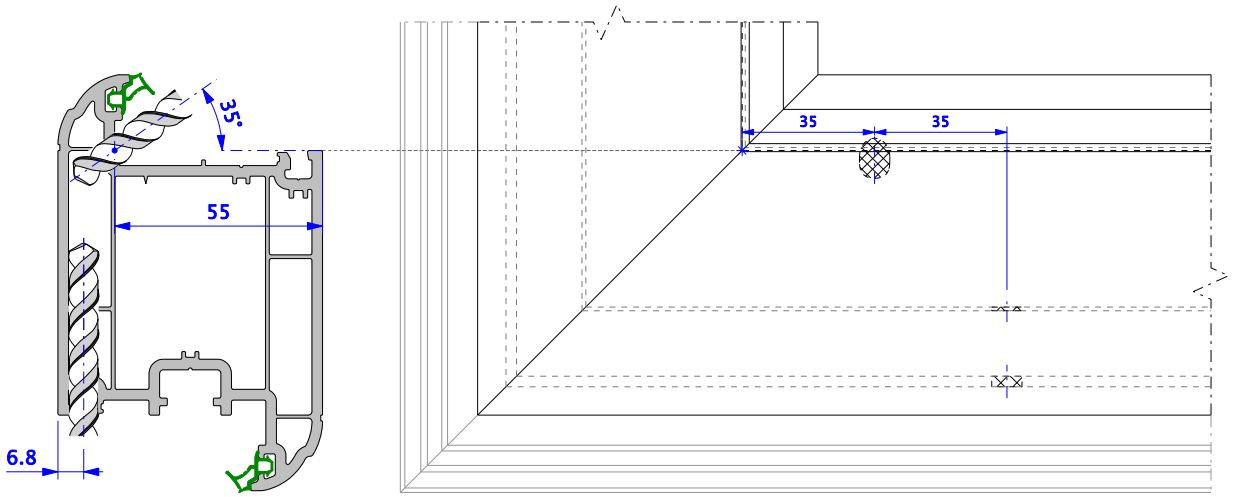
Drainage ø5 & 8 mm

2830

drainage ø5mm



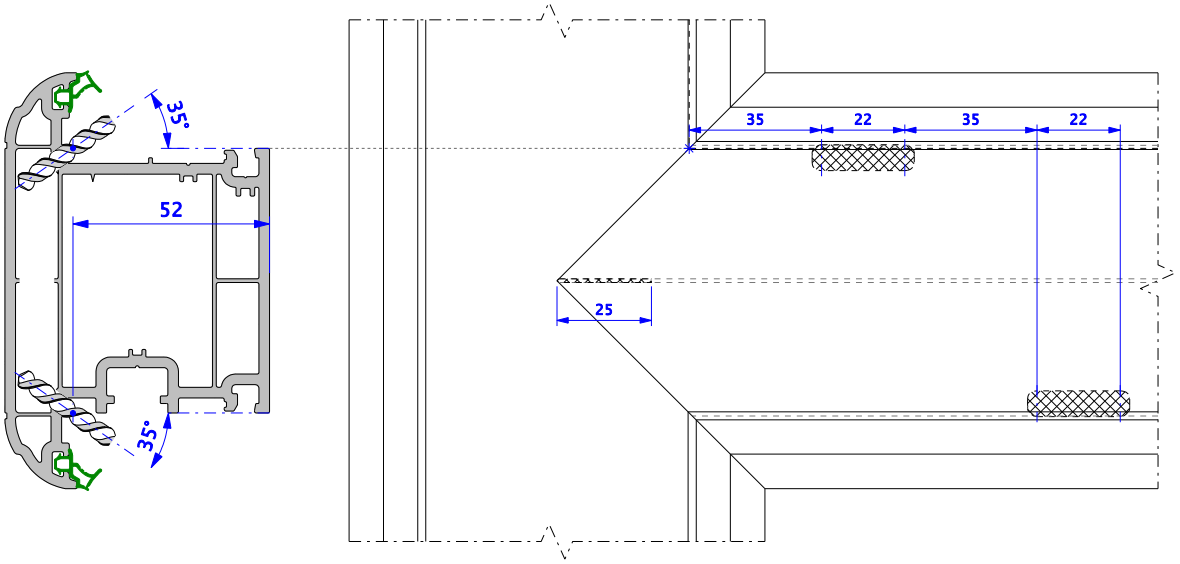
drainage ø8mm



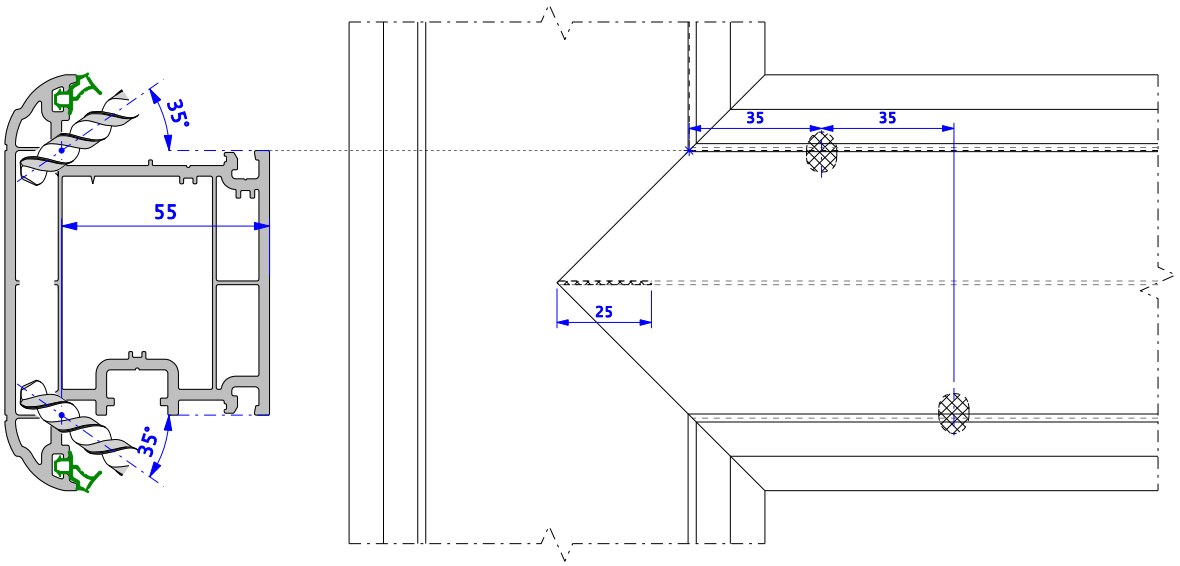
Drainage ø5 & 8 mm

2831

drainage ø5mm



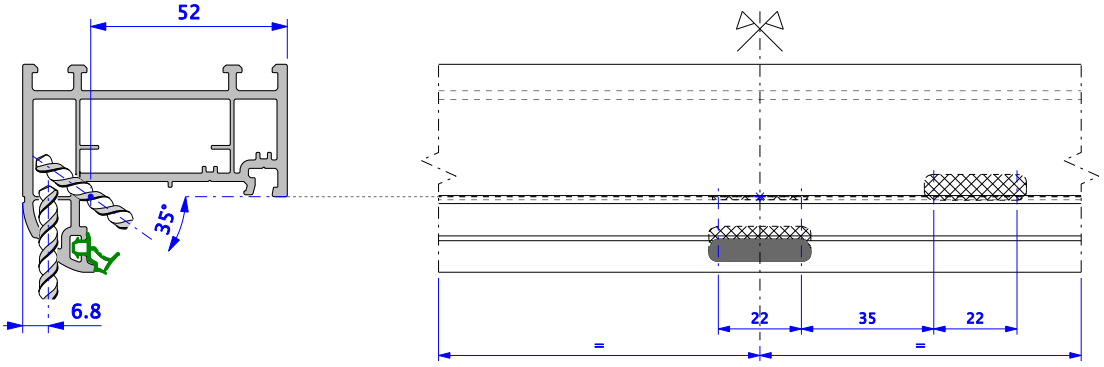
drainage ø8mm



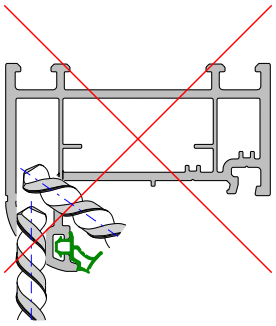
Decompression ø5 & (ø8) mm

2832

decompression ø5mm



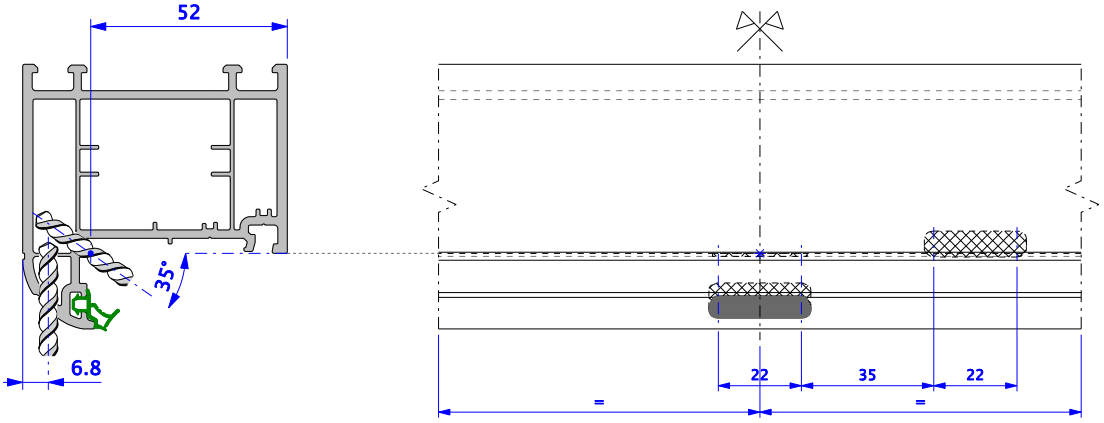
decompression ø8mm (NOT DONE)



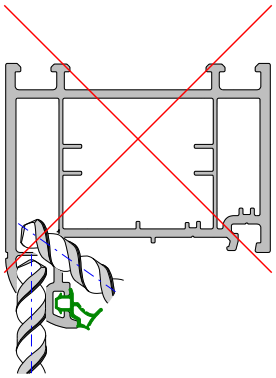
Decompression ø5 & (ø8) mm

2833

decompression ø5mm



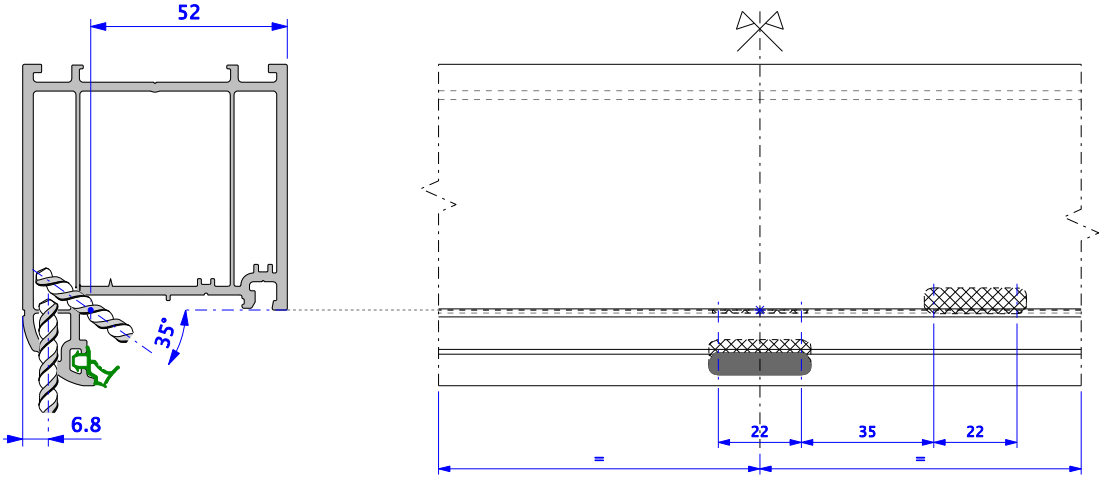
decompression ø8mm (NOT DONE)



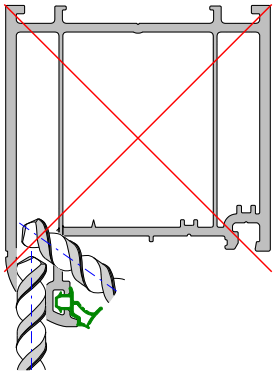
Decompression ø5 & (ø8) mm

2822

decompression ø5mm



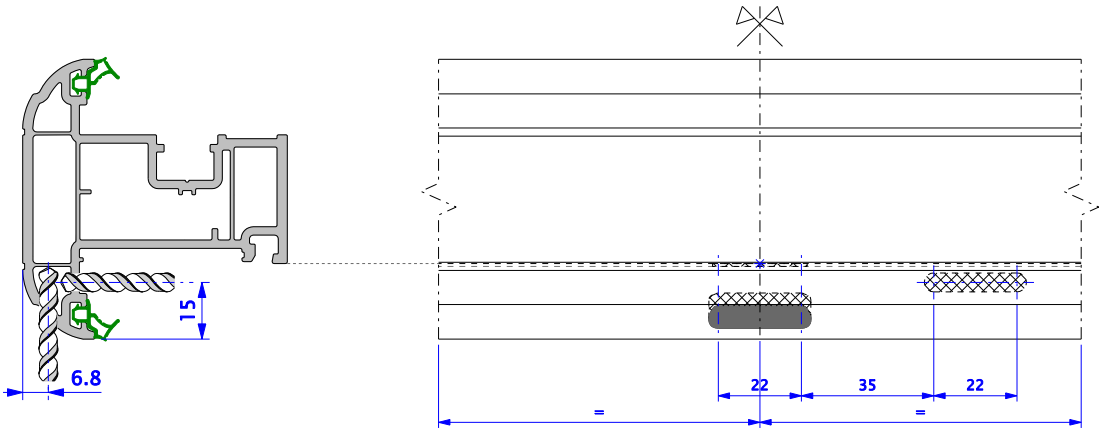
decompression ø8mm (NOT DONE)



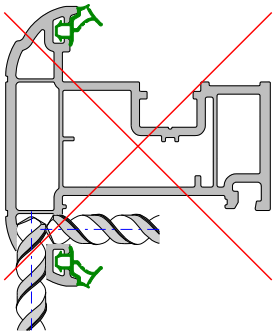
Decompression ø5 & (ø8) mm

2825

decompression ø5mm



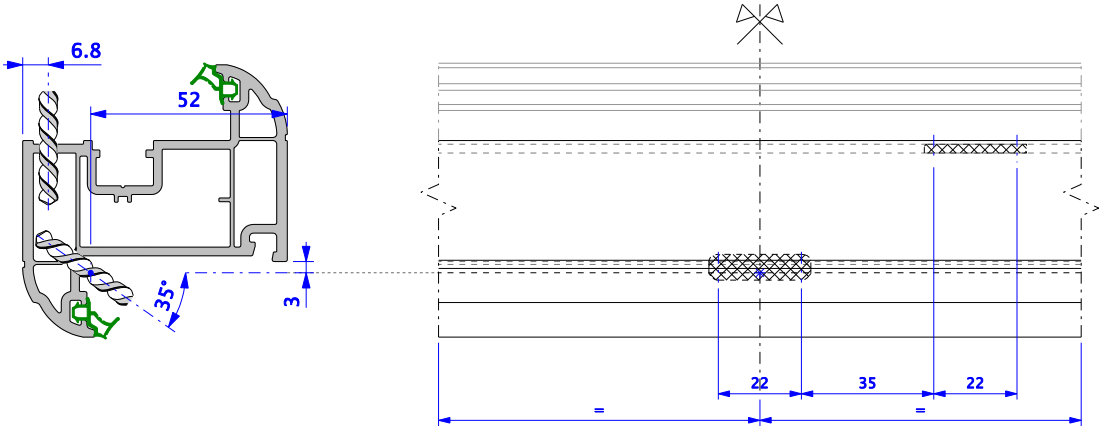
decompression ø8mm (NOT DONE)



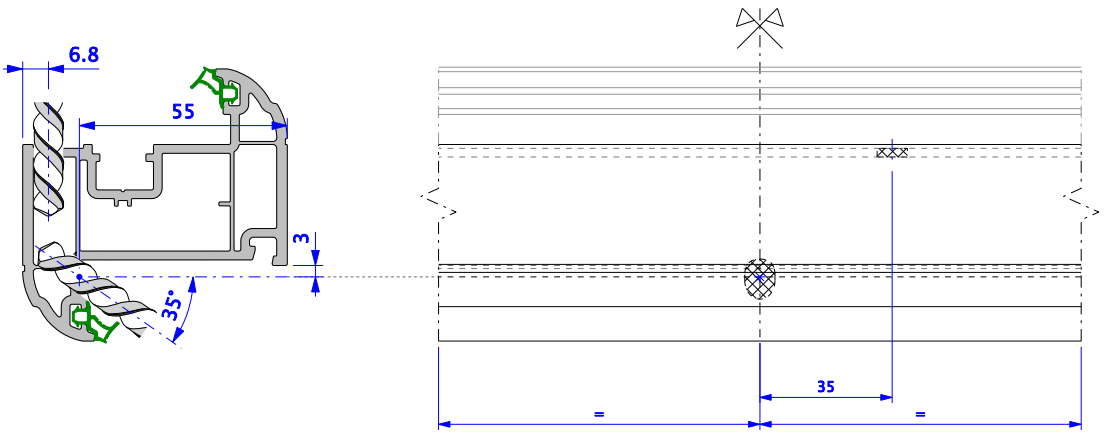
Decompression ø5 & ø8 mm

2826

decompression ø5mm



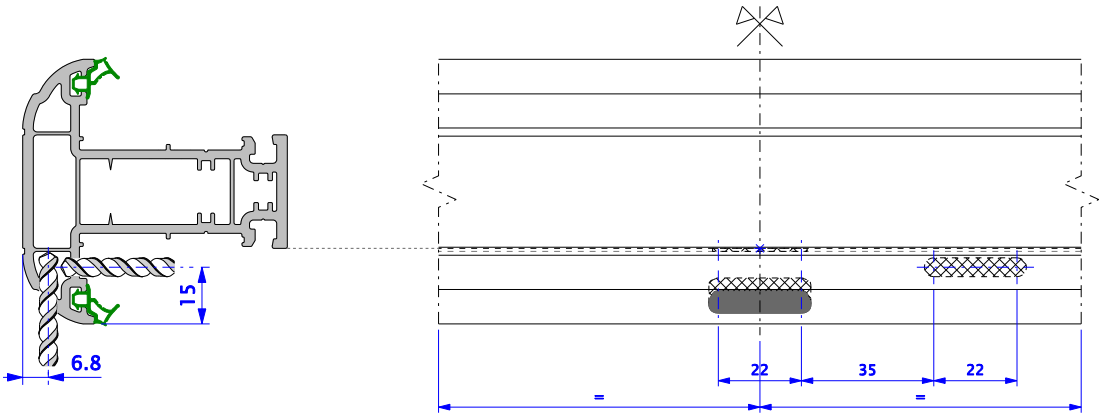
decompression ø8mm



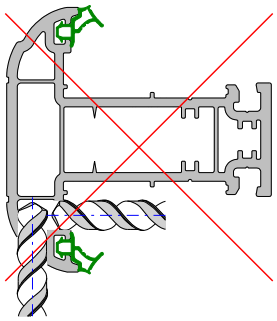
Decompression ø5 & (ø8) mm

2835

decompression ø5mm



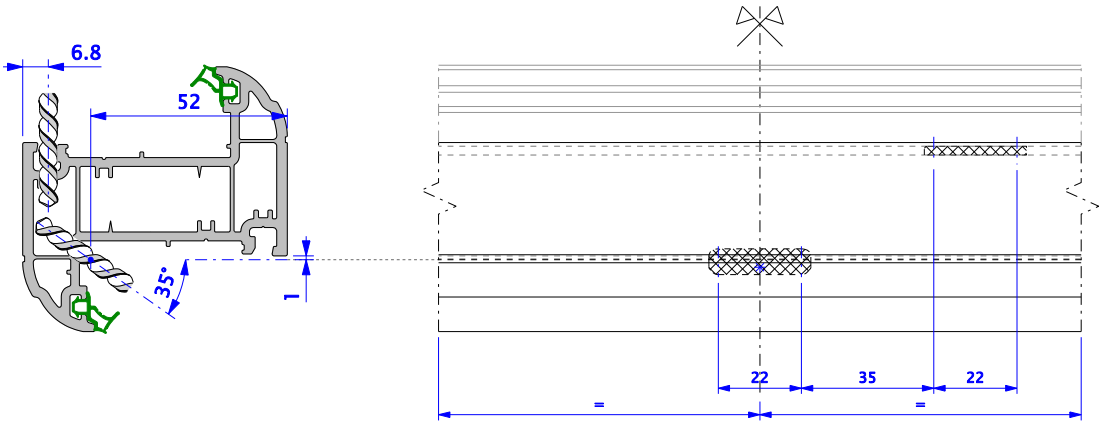
decompression ø8mm (NOT DONE)



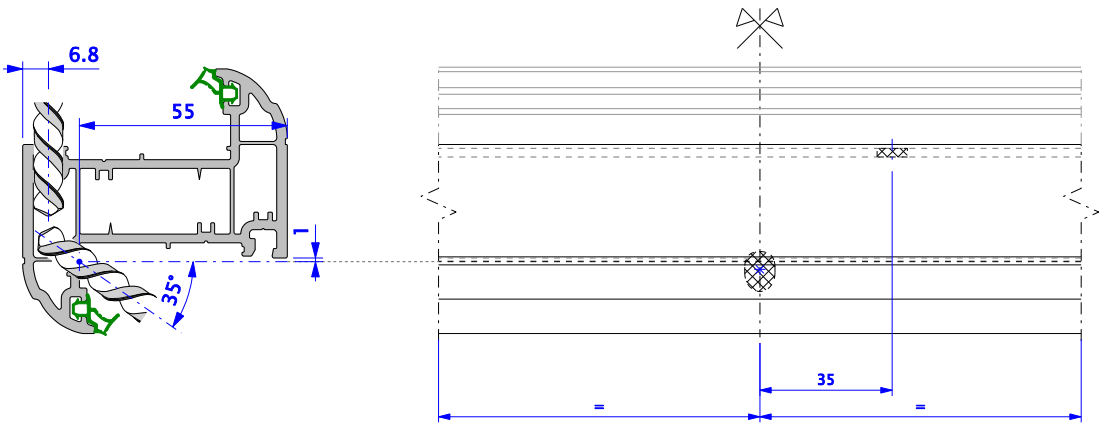
Decompression ø5 & (ø8) mm

2836

decompression ø5mm



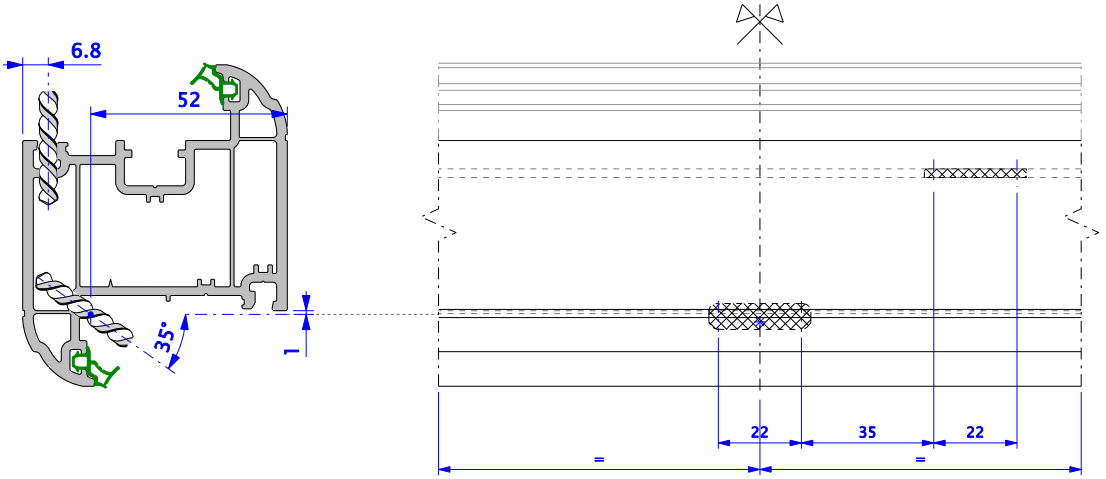
decompression ø8mm



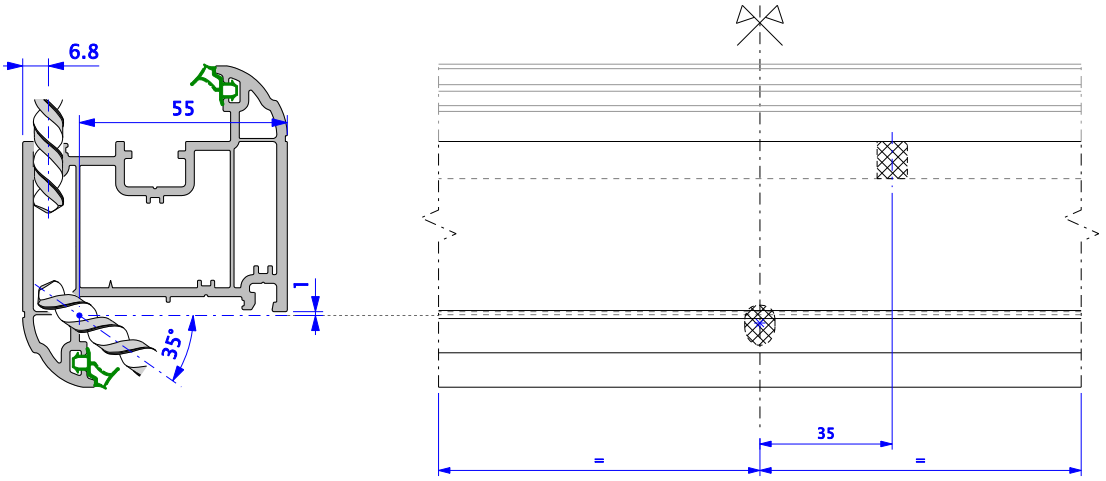
Decompression ø5 & ø8 mm

2828

decompression ø5mm



decompression ø8mm

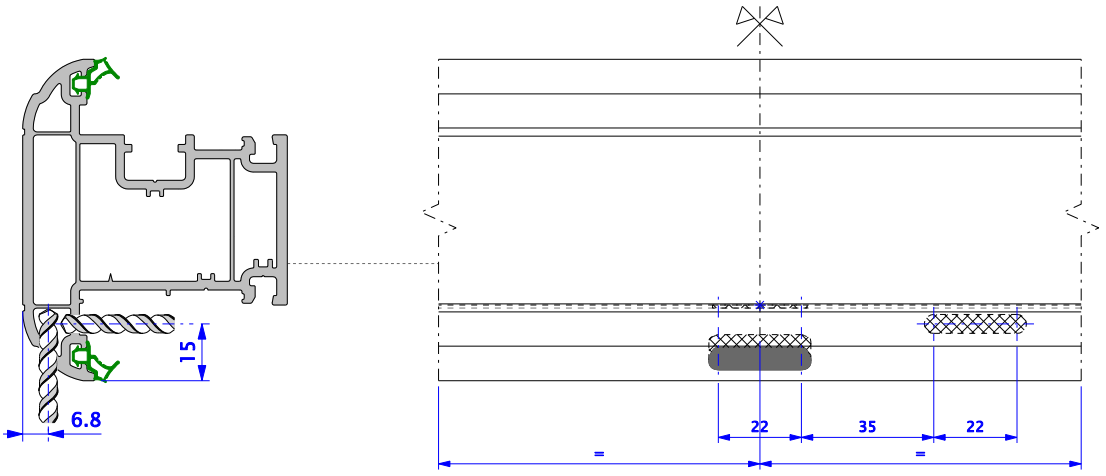


Decompression ø5 & (ø8) mm

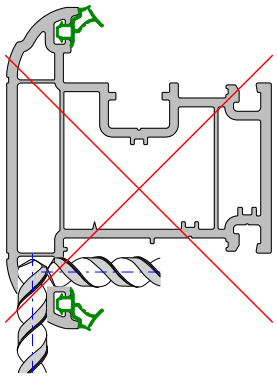
2829

DECOMPRESSION

decompression ø5mm



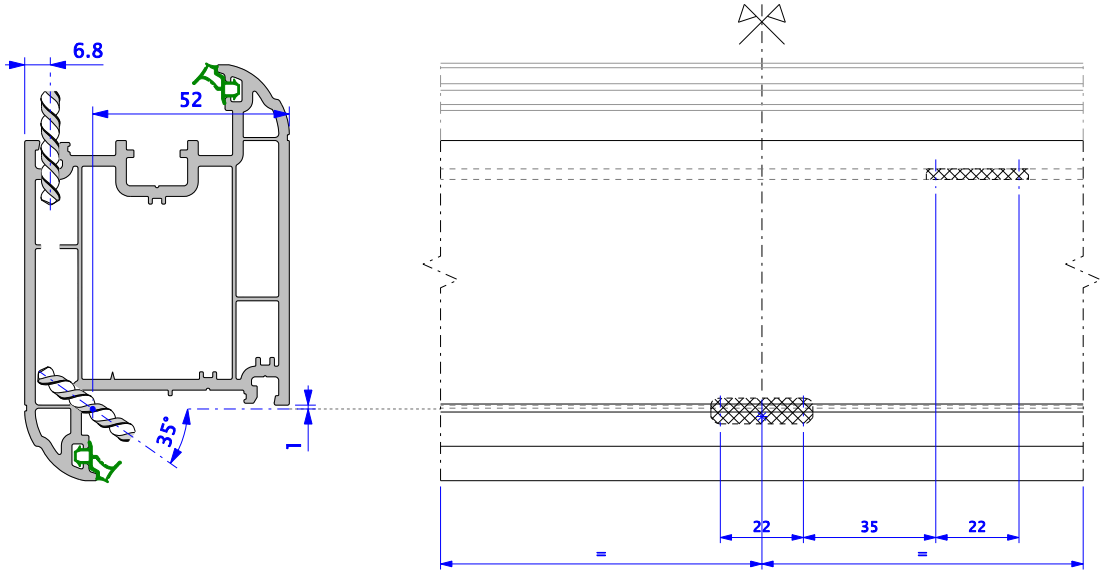
decompression ø8mm (NOT DONE)



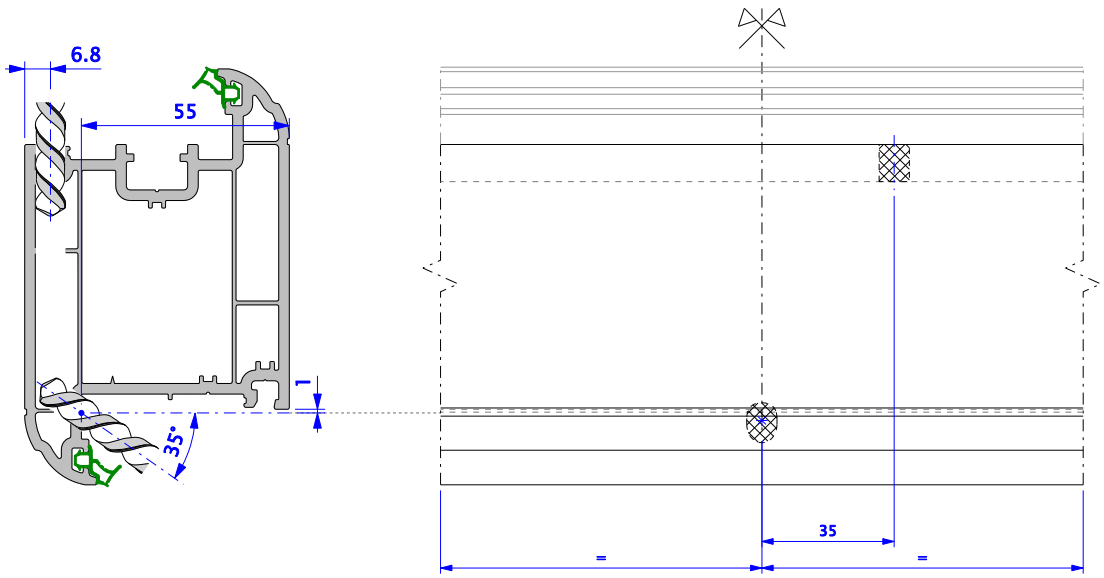
Decompression ø5 & (ø8) mm

2830

decompression ø5mm



decompression ø8mm

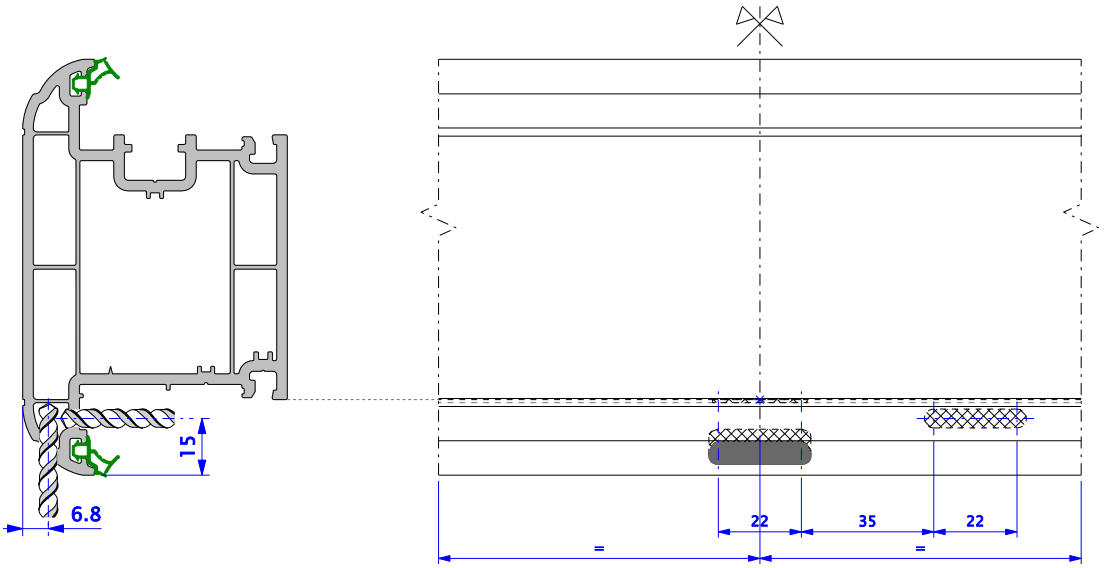


Decompression ø5 & (ø8) mm

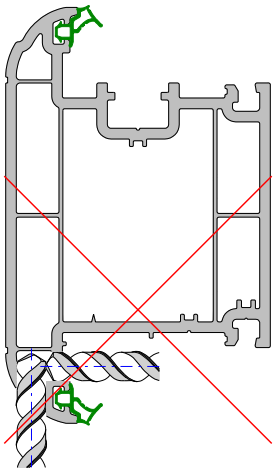
2831

DECOMPRESSION

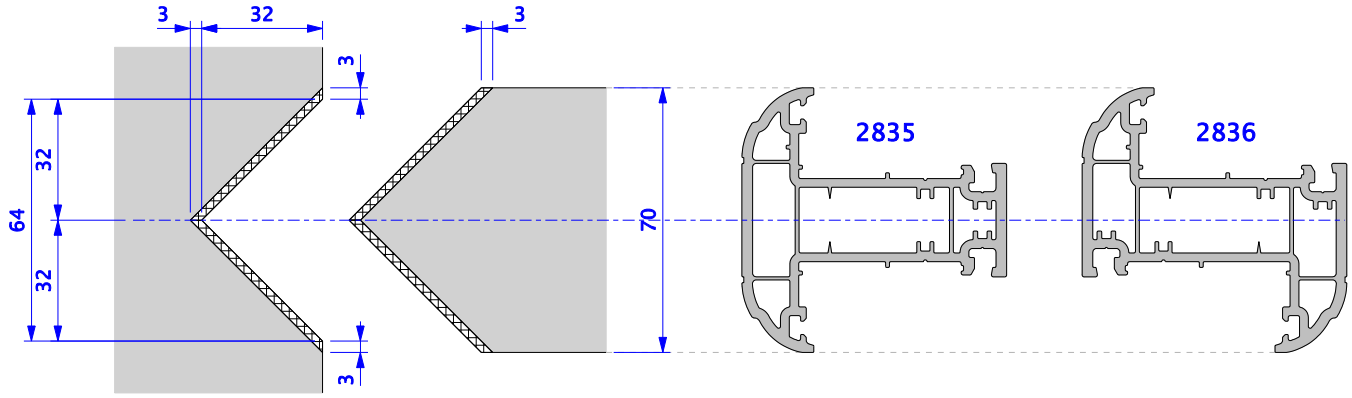
decompression ø5mm

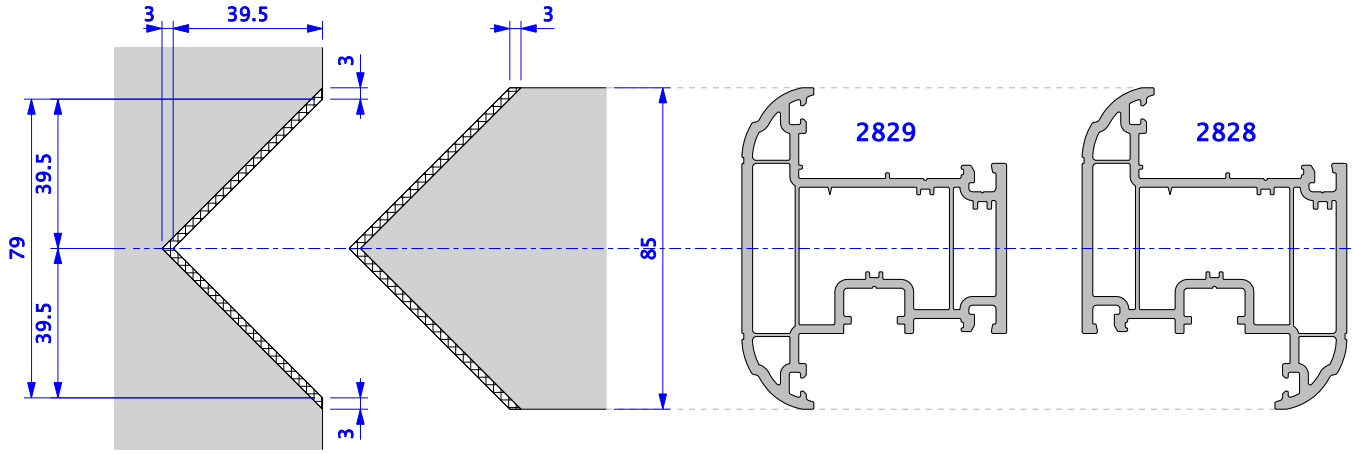


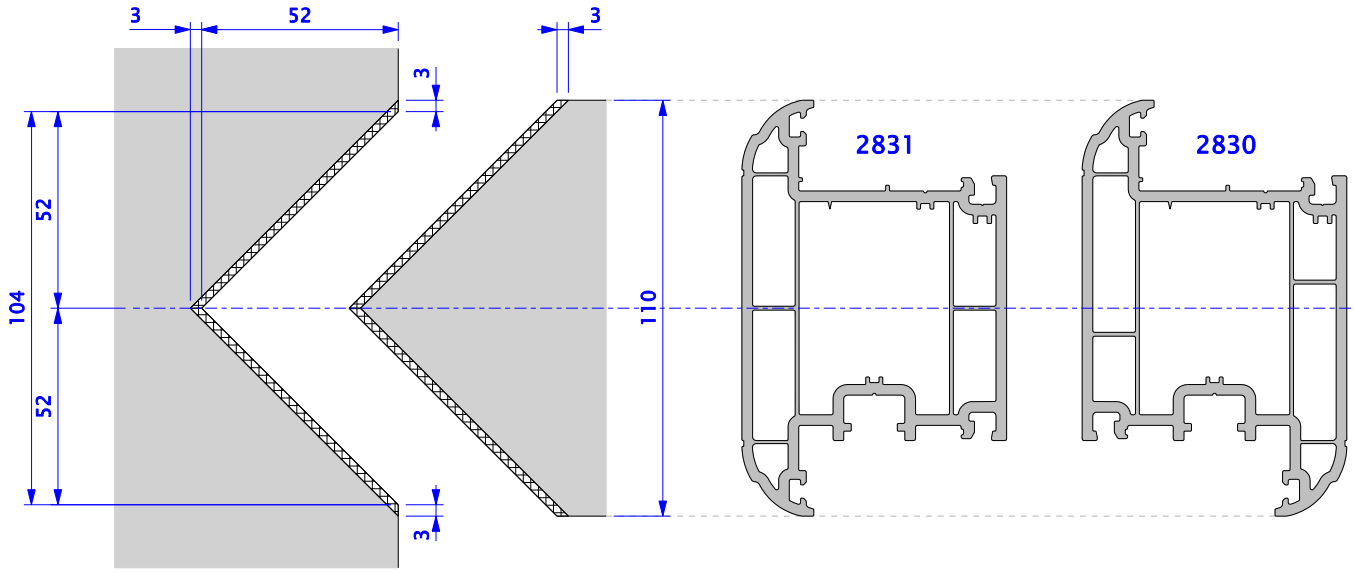
decompression ø8mm (NOT DONE)



V-WELDING

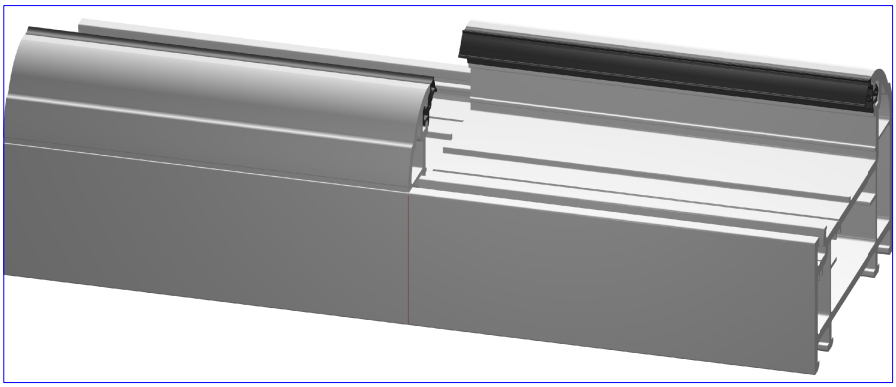

3
32
3
3
64
32
32
3
70
2835
2836


3
39.5
3
3
79
39.5
39.5
3
85
2829
2828

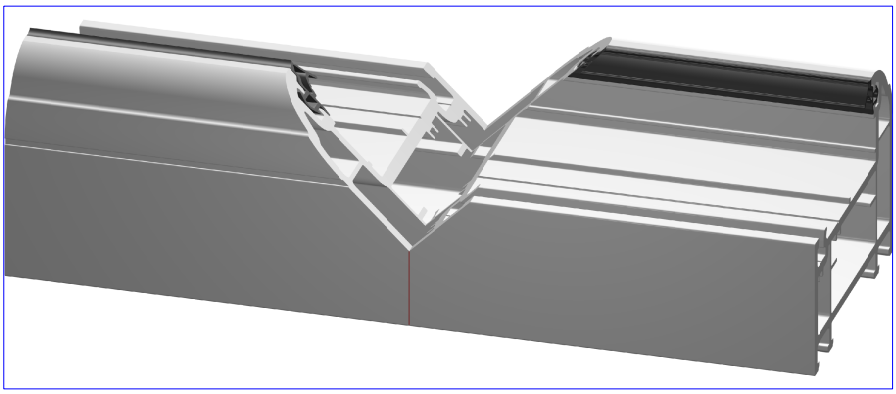

3
52
3
3
104
52
52
3
110
2831
2830

V-WELDING

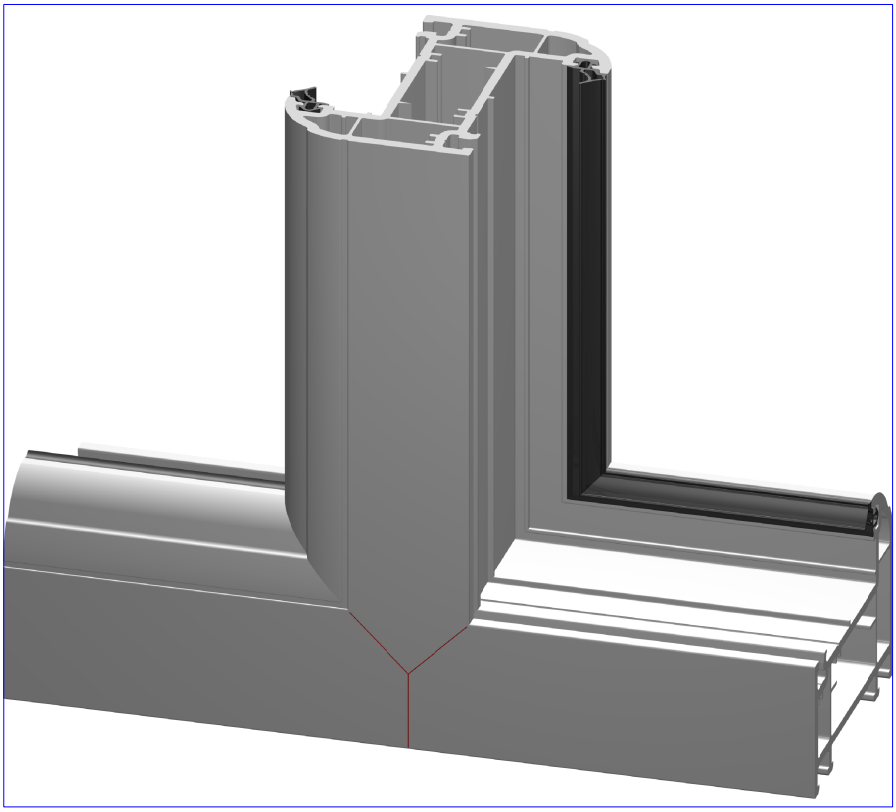
1. Reverse butt weld



2. V-notch profiles

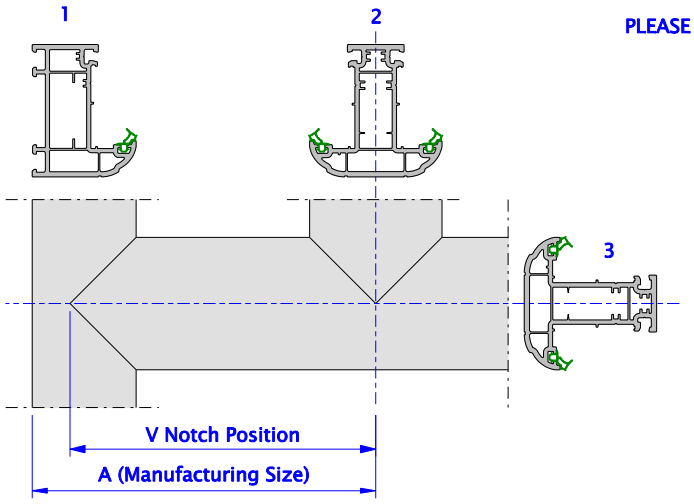


3. Weld-in reversible



V-WELDING

Outerframe to Centre of "V" Notch

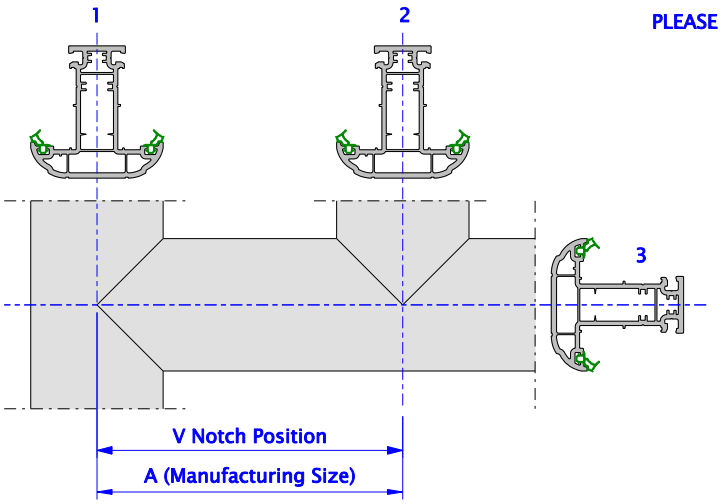


WELDED TRANSOMS/MULLIONS

PLEASE NOTE: NO ALLOWANCE HAS BEEN MADE FOR WELD

Outerframe 1	Transom /Mullion 2	Transom /Mullion 3	V Notch position
2832	2835/ 2836	2835/ 2836	A-20
2833	2835/ 2836	2835/ 2836	A-35
	2828/ 2829	2828/ 2829	A-27.5
	2830/ 2831	2830/ 2831	A-15
2822	2835/ 2836	2835/ 2836	A-50
	2828/ 2829	2828/ 2829	A-42.5
	2830/ 2831	2830/ 2831	A-30

Centre of Transom-Mullion to Centre of "V" Notch

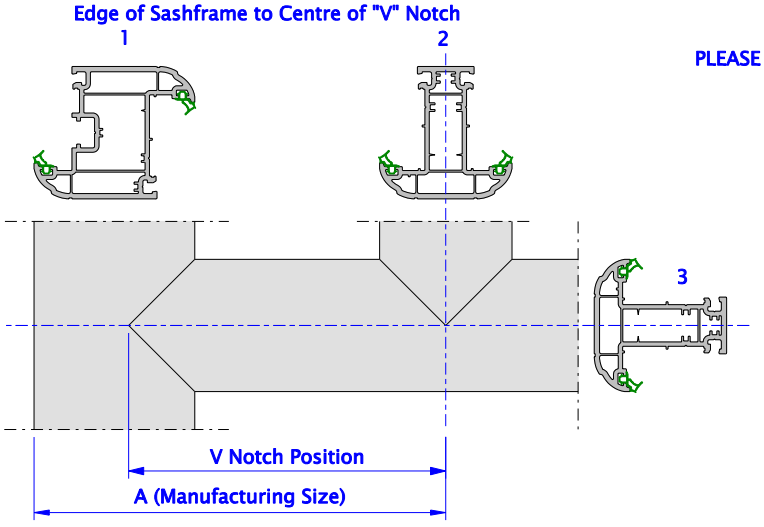


WELDED TRANSOMS/MULLIONS

PLEASE NOTE: NO ALLOWANCE HAS BEEN MADE FOR WELD

Transom /Mullion 1	Transom /Mullion 2	Transom /Mullion 3	V Notch position
2835/ 2836	2835/ 2836	2835/ 2836	A
2828/ 2829	2535/ 2536	2535/ 2536	A-7.5
	2828/ 2829	2828/ 2829	A
	2830/ 2831	2830/ 2831	A+12.5
2830/ 2831	2535/ 2536	2535/ 2536	A-20
	2828/ 2829	2828/ 2829	A-12.5
	2830/ 2831	2830/ 2831	A

Edge of Sashframe to Centre of "V" Notch



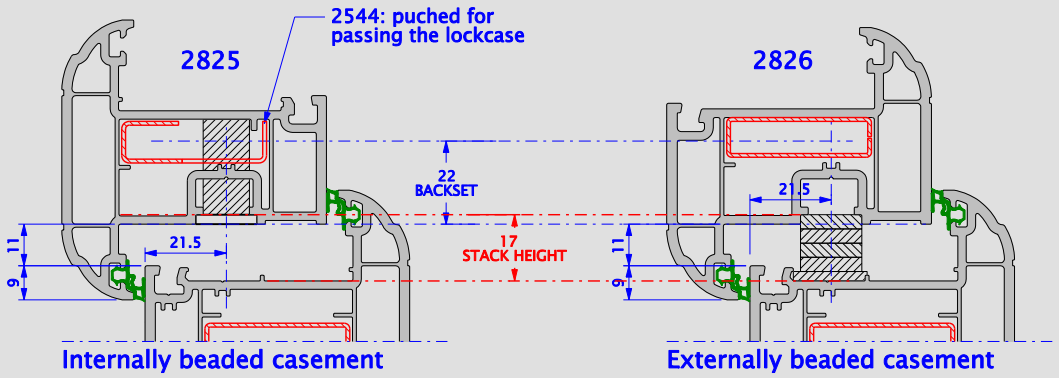
WELDED TRANSOMS/MULLIONS

PLEASE NOTE: NO ALLOWANCE HAS BEEN MADE FOR WELD

Sash Frame 1	Transom /Mullion 2	Transom /Mullion 3	V Notch position
2828/ 2829	2535/ 2536	2535/ 2536	A-54
	2828/ 2829	2828/ 2829	A-42.5
	2830/ 2831	2830/ 2831	A-30
2830/ 2831	2535/ 2536	2535/ 2536	A-75
	2828/ 2829	2828/ 2829	A-67.5
	2830/ 2831	2830/ 2831	A-55

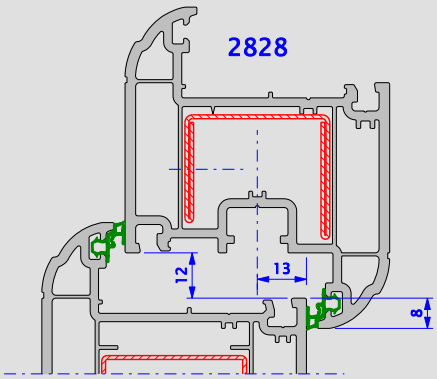
HARDWARE

CASEMENT WINDOW

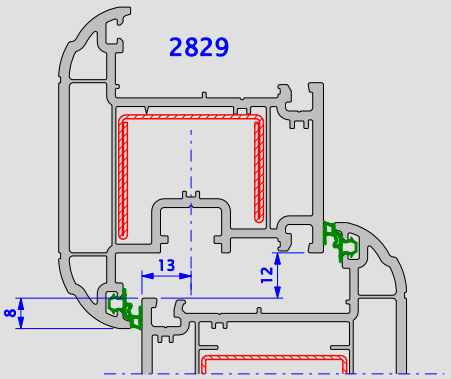


* 30mm Minimum Spindle Length

TILT & TURN

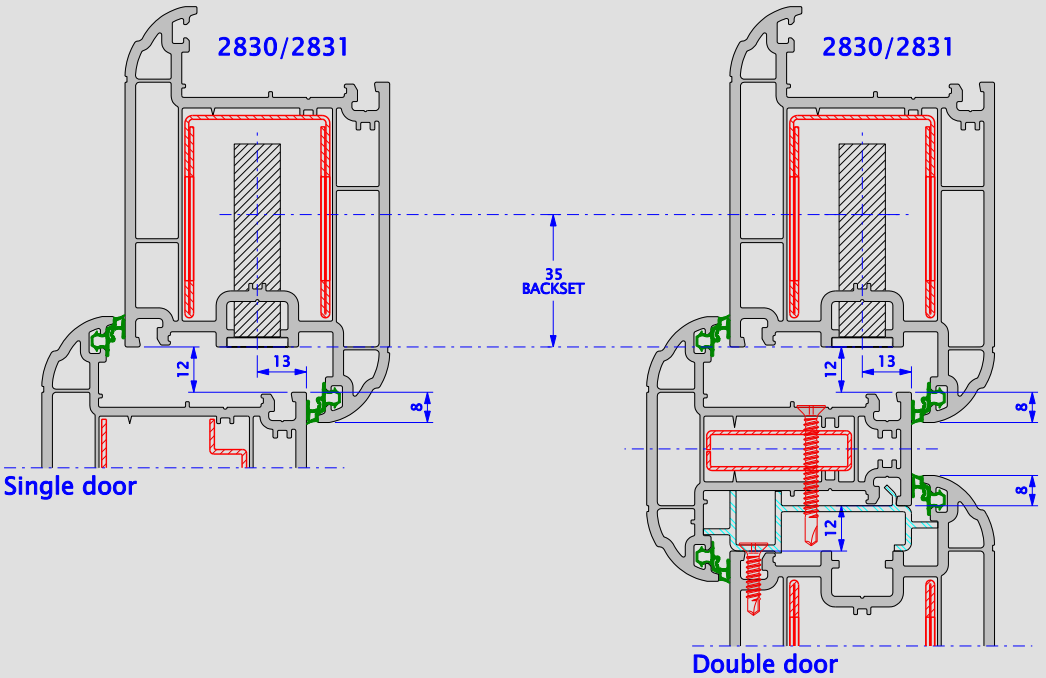


OUTWARD OPENING



* 35mm Minimum Spindle Length

DOOR



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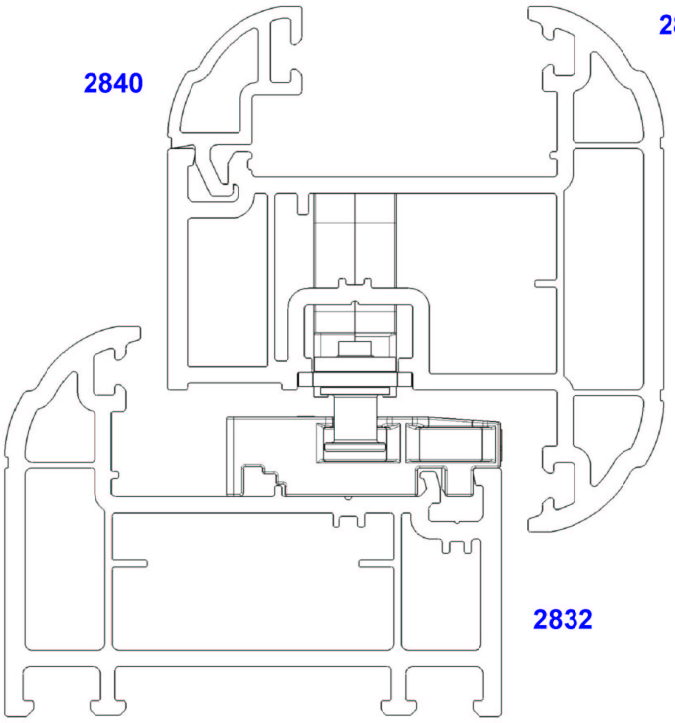
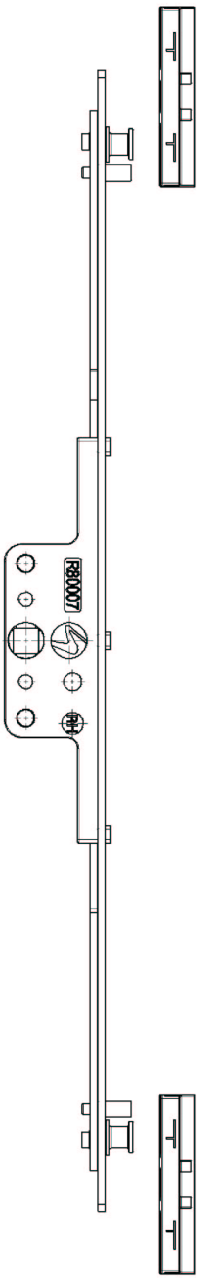
DEFENDER LOCKING SYSTEM





PART CODES	SASH REBATE (mm)	HOUSING	DESCRIPTION
DLG0350H	300-389	R90007	UNIVERSAL KEEP
DLG0450H	390-519		
DLG0590H	520-649		
DLG0710H	650-779		
DLG0850H	780-909		
DLG0970H	910-1039		
DLG1150H	1040-1169		
DLG1250H	1170-1299		
DLG1370H4	1300-1430		

Offset bars are available on request.
For more detailed information please contact our technical department.

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Securistyle Ltd
Kingsmead Industrial Estate, Princess Elizabeth Way, Cheltenham, Gloucestershire, GL51 7RE.
Email: info@securistyle.co.uk **Tel**:+44 (0) 1242 221200 **Main Fax No**:+44 (0) 1242 520828

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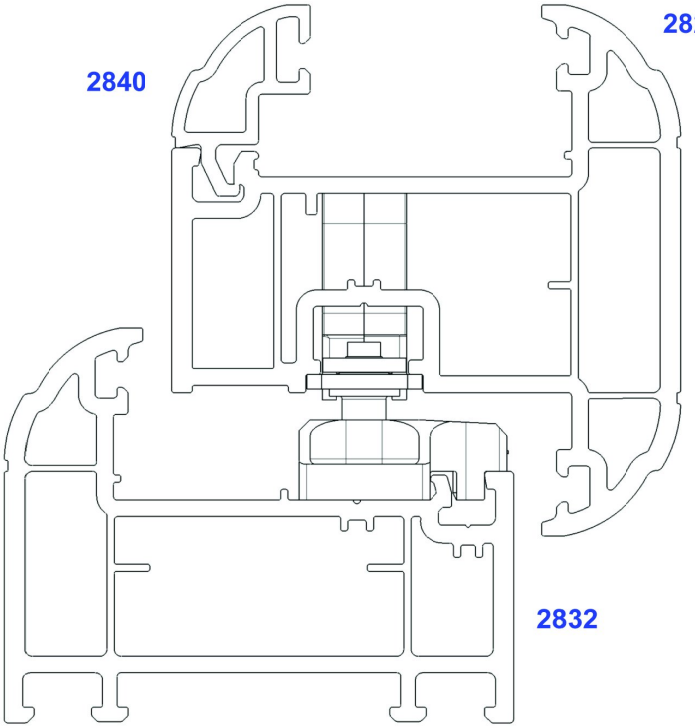
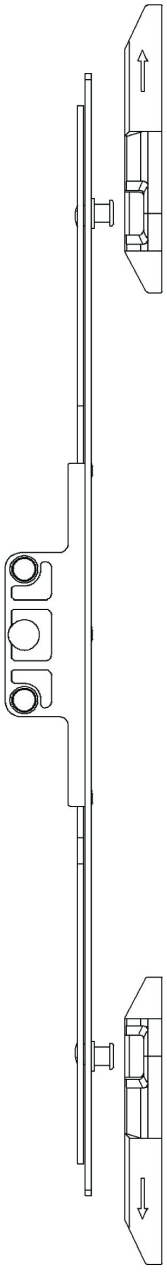
VECTOR EXCLUDER LOCKING SYSTEM





PART CODES	SASH REBATE (mm)	HOUSING	DESCRIPTION
HLG0350H	300-389	HL40	LEFT HAND KEEP
HLG0450H	390-519	HR40	RIGHT HAND KEEP
HLG0590H	520-649		
HLG0710H	650-779		
HLG0850H	780-909		
HLG0970H	910-1039		
HLG1150H	1040-1169		
HLG1250H	1170-1299		
HLG1370H4	1300-1430		

Offset bars are available on request.
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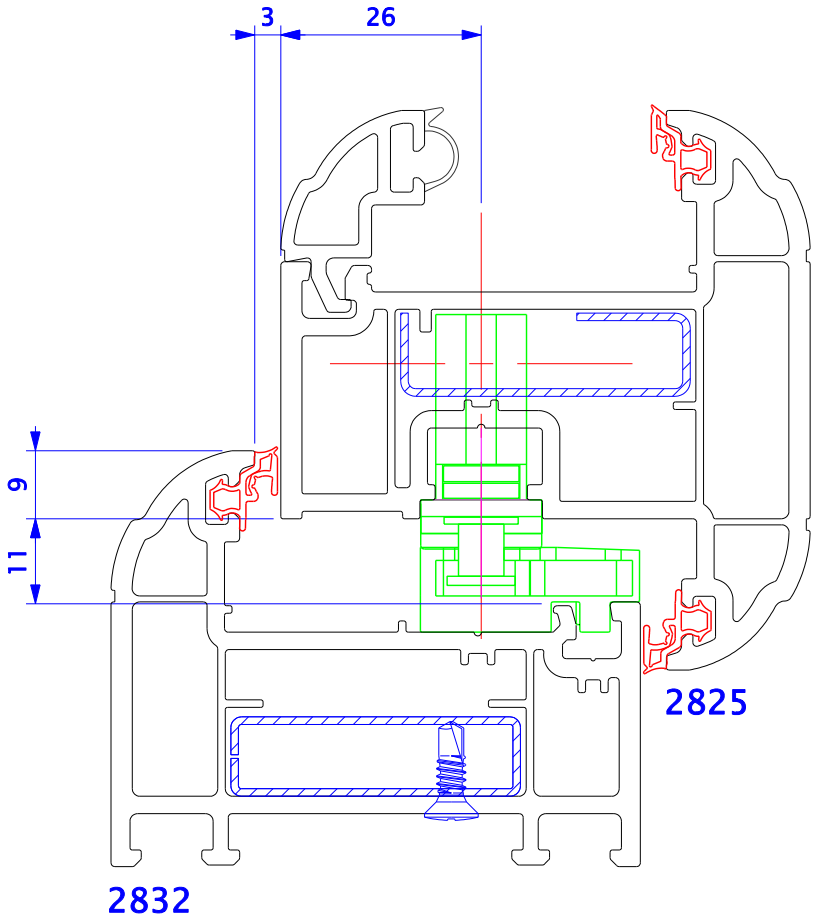
Securistyle Ltd
Kingsmead Industrial Estate, Princess Elizabeth Way, Cheltenham, Gloucestershire, GL51 7RE.
Email: info@securistyle.co.uk **Tel:**+44 (0) 1242 221200 **Main Fax No:**+44 (0) 1242 520828

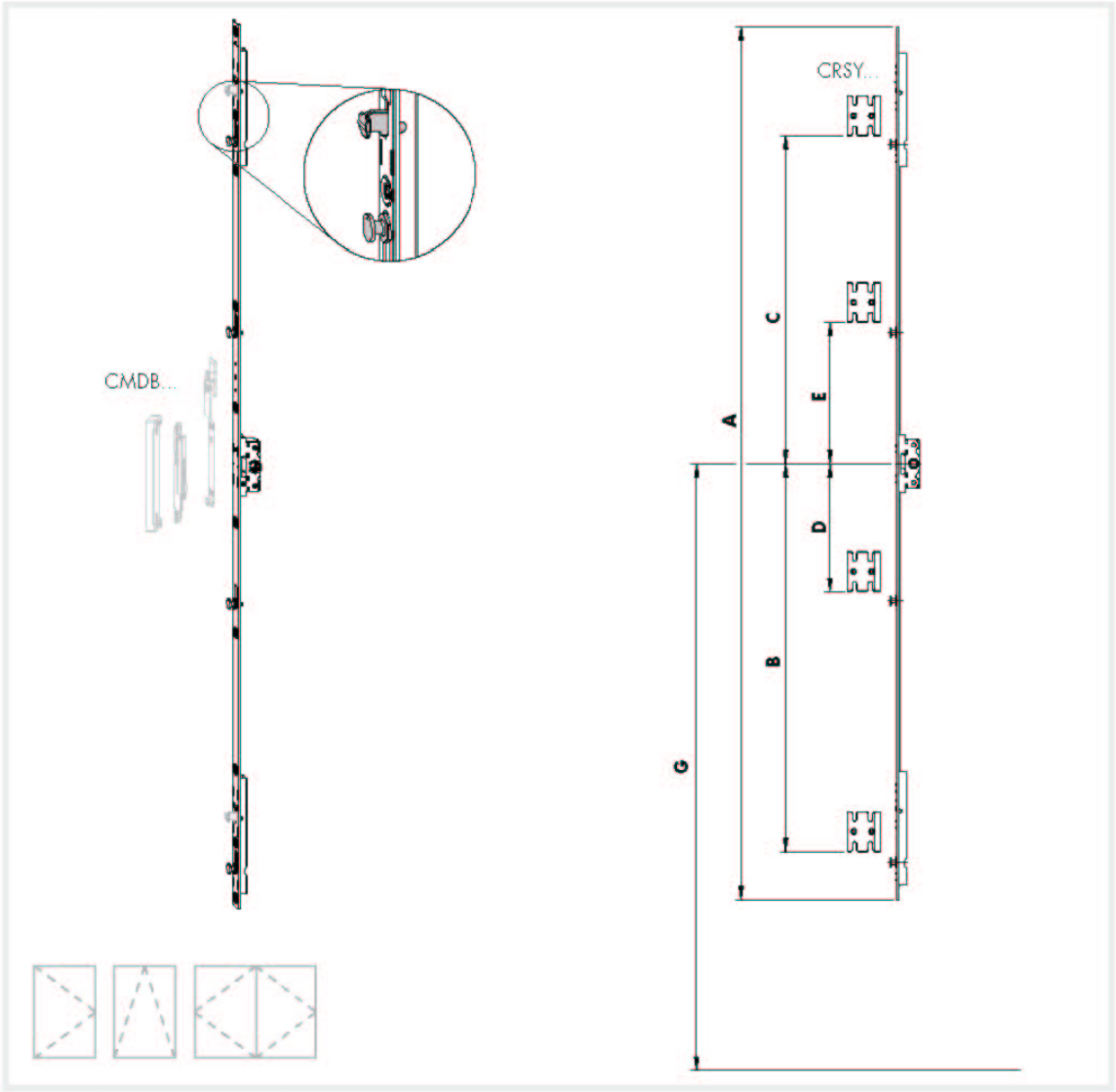

3
26
9
11
2825
2832

20 mm Backset Drive Gear

8 mm Cam height

CASEMENT

CGMD



Product number	Description	FFH (mm)	Dimensions (mm)							
			A	B	C	D	E	G		
CGMD5080-...	Gearing DF 20 Gr. 45 2S 2H	450 - 650	400	150	73	-	-	200 - 300	2	6
CGMD5090-...	Gearing DF 20 Gr. 65 2S 2H	651 - 850	600	250	173	-	-	300 - 400	2	8
CGMD5100-...	Gearing DF 20 Gr. 85 2S 2H	851 - 1050	800	350	273	-	-	400 - 500	2	8
CGMD5110-...	Gearing DF 20 Gr. 105 4S 2H	1051 - 1200	1000	450	373	144	164	500 - 600	4	10
CGMD5120-...	Gearing DF 20 Gr. 125 4S 2H	1201 - 1400	1140	520	443	144	164	600 - 700	4	12

Striker	CRSY0070-...	-	1
Restrictor Bag	CMDB0081-...	right	3
	CMDB0082-...	left	3

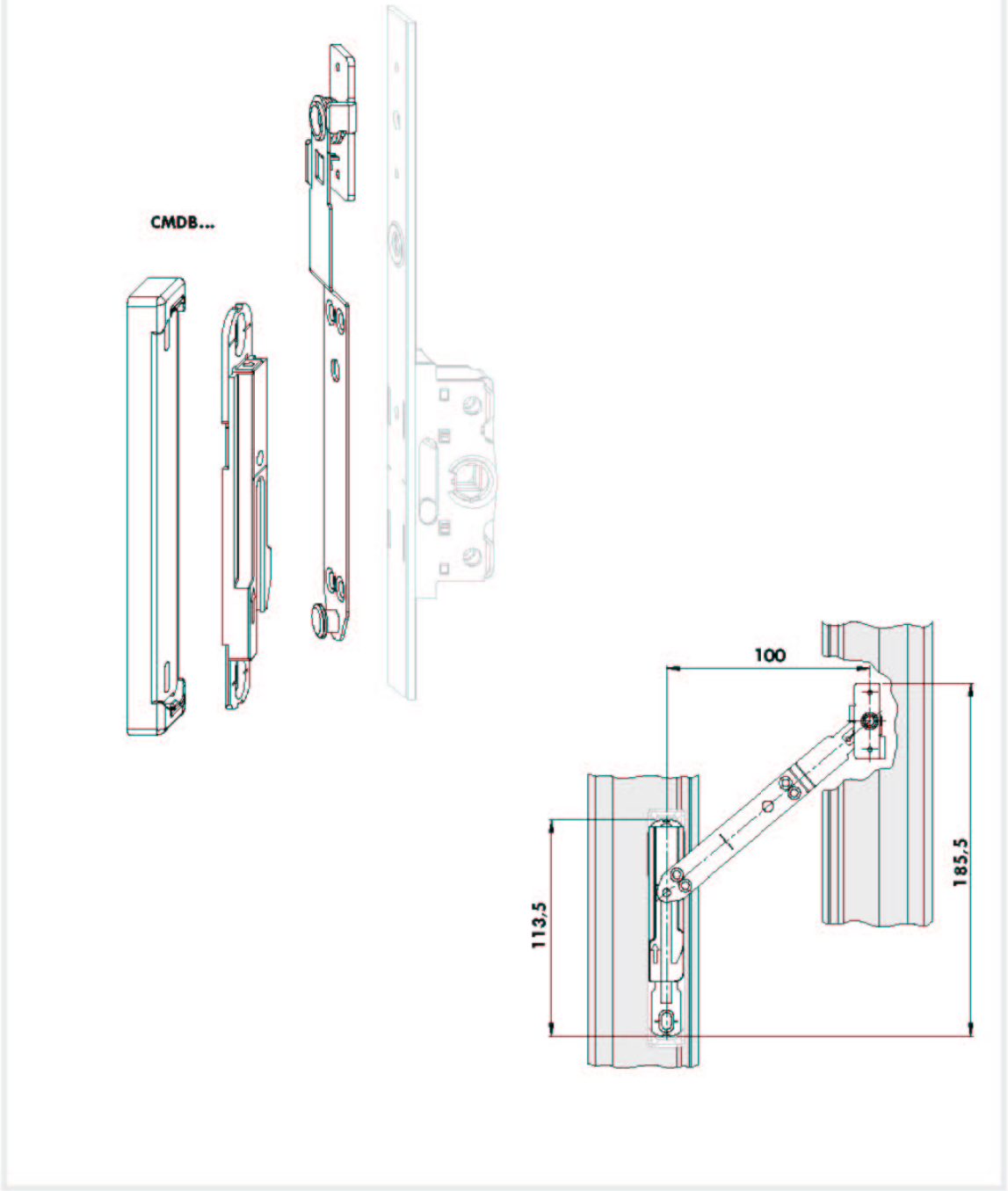
SIEGENIA AUBI

Restrictor

Restrictor Bag

CASEMENT

CMDB



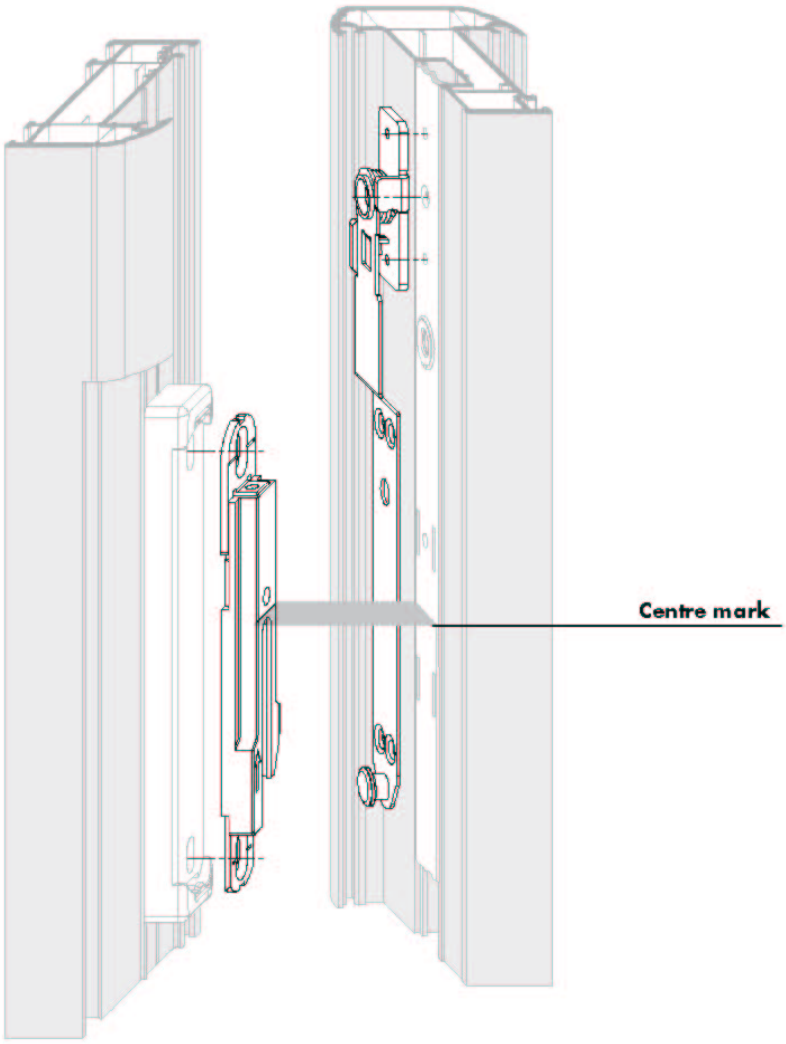
Order Number	Restrictor Bag	Execution	
CMDB0081-...	Restrictor Bag A3180	RH	3
CMDB0082-...	Restrictor Bag A3180	LH	3

Restrictor Bag

Profile Deceunick 2800

CASEMENT

CMDB



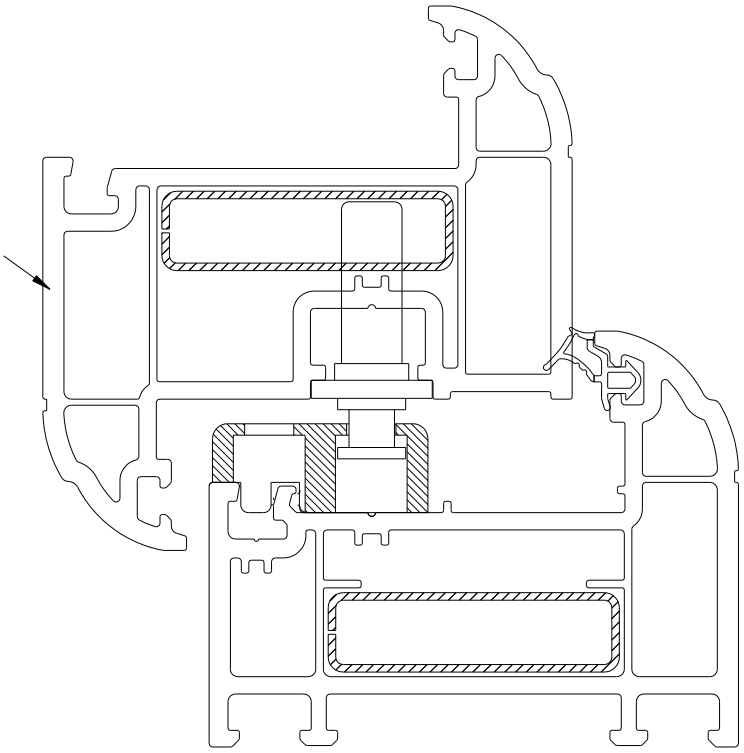
Deceunick 2800 Page Page 3

Casement windows.

Locking side.

Outer Frames: 2832 & 2833
Sash Frames: 2826 & 2825

2826 sash shown



Lock details: 19mm backset / 8mm cam height / 16mm faceplate / handle spindle 30mm

Espagnolettes:

Mila 3 series	*Mushroom (shown)*	*Pt. No.*	*030501/12*
Mila 6 series	*Mushroom (S/steel)*	*Pt. No.*	*033802*
Mila 3 series SB	*Shootbolt*	*Pt. No.*	*038000*
Mila 8 series SB	*Shootbolt*	*Pt. No.*	*037424*

Strikers for above:

Mila 3 or 7 series	*M36 (shown)*	*Pt. No.*	*039257*
Mila 6 series	*T.B.A.*	*Pt. No.*	*T.B.A.*
Mila 3 series SB	*M7000*	*Pt. No.*	*038735*
Mila 8 series SB	*M8036*	*Pt. No.*	*038811 & 12*

Friction stays 17mm stack height:

Mila standard	*Cotswold*	*Pt. No.*	*023120 etc*
Mila defender	*Securistyle*	*Pt. No.*	*028042 etc*
Mila fearless	*Cotswold*	*Pt. No.*	*023580 etc*
Mila vector	*Securistyle*	*Pt. No.*	*028392 etc*
Mila heavy duty	*Cotswold*	*Pt. No.*	*023172 etc*

Other additional hardware:

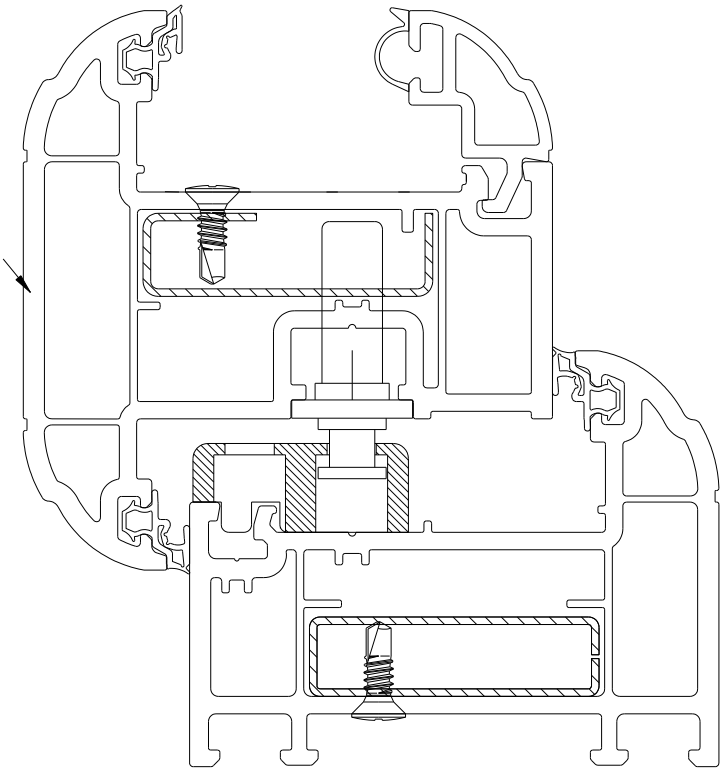
Hinge protector	*Twin prong none route*	*Pt. No.*	*420050 & 420092*
Packer for above	*T.B.A.*	*Pt. No.*	*T.B.A.*
H block & Griff bolt	*(Only use with fearless stays)*	*Pt. No.*	*039541 & 023888*
SC Hinge protector set		*Pt. No.*	*023904*

Casement windows.

Locking side.

Outer Frames: 2832 & 2833
Sash Frames: 2826 & 2825

2825 sash shown



Lock details: 19mm backset / 8mm cam height / 16mm faceplate / handle spindle 30mm

Espagnolettes:

Mila 3 series	*Mushroom (shown)*	*Pt. No.*	*030501/12*
Mila 6 series	*Mushroom (S/steel)*	*Pt. No.*	*033802*
Mila 3 series SB	*Shootbolt*	*Pt. No.*	*038000*
Mila 8 series SB	*Shootbolt*	*Pt. No.*	*037424*

Strikers for above:

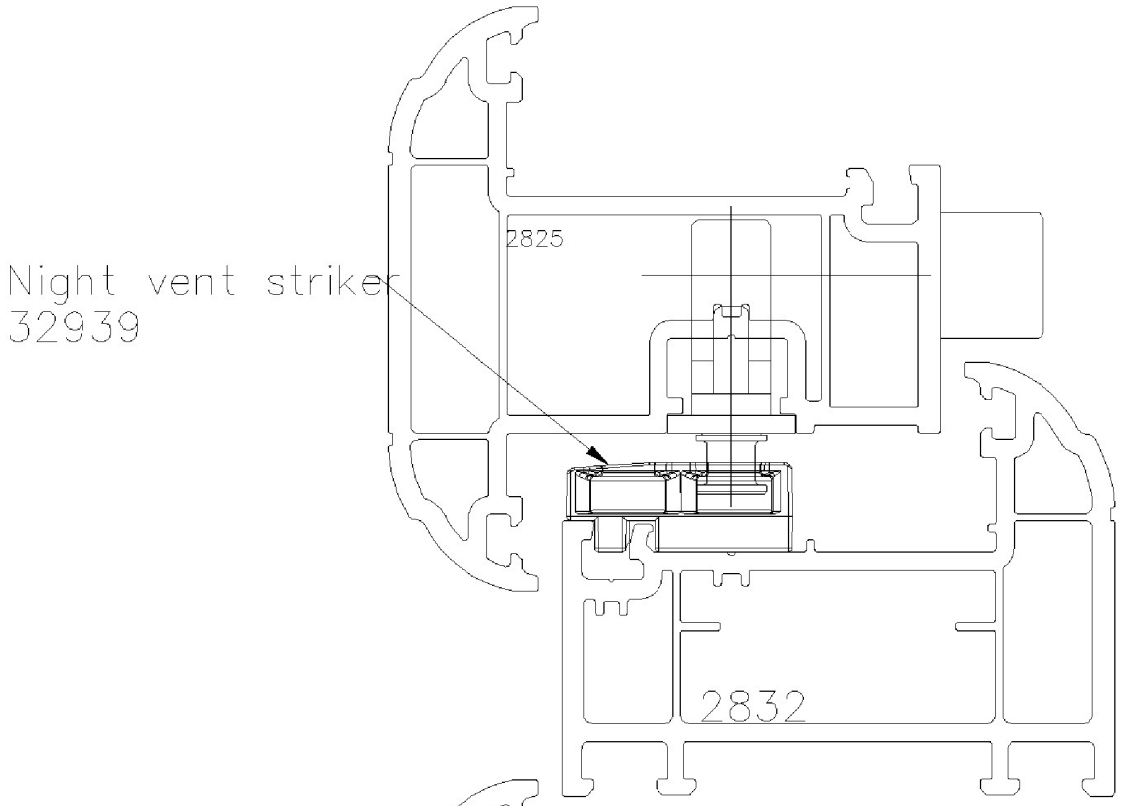
Mila 3 or 7 series	*M36 (shown)*	*Pt. No.*	*039257*
Mila 6 series	*T.B.A.*	*Pt. No.*	*T.B.A.*
Mila 3 series SB	*M7000*	*Pt. No.*	*038735*
Mila 8 series SB	*M8036*	*Pt. No.*	*038811 & 12*

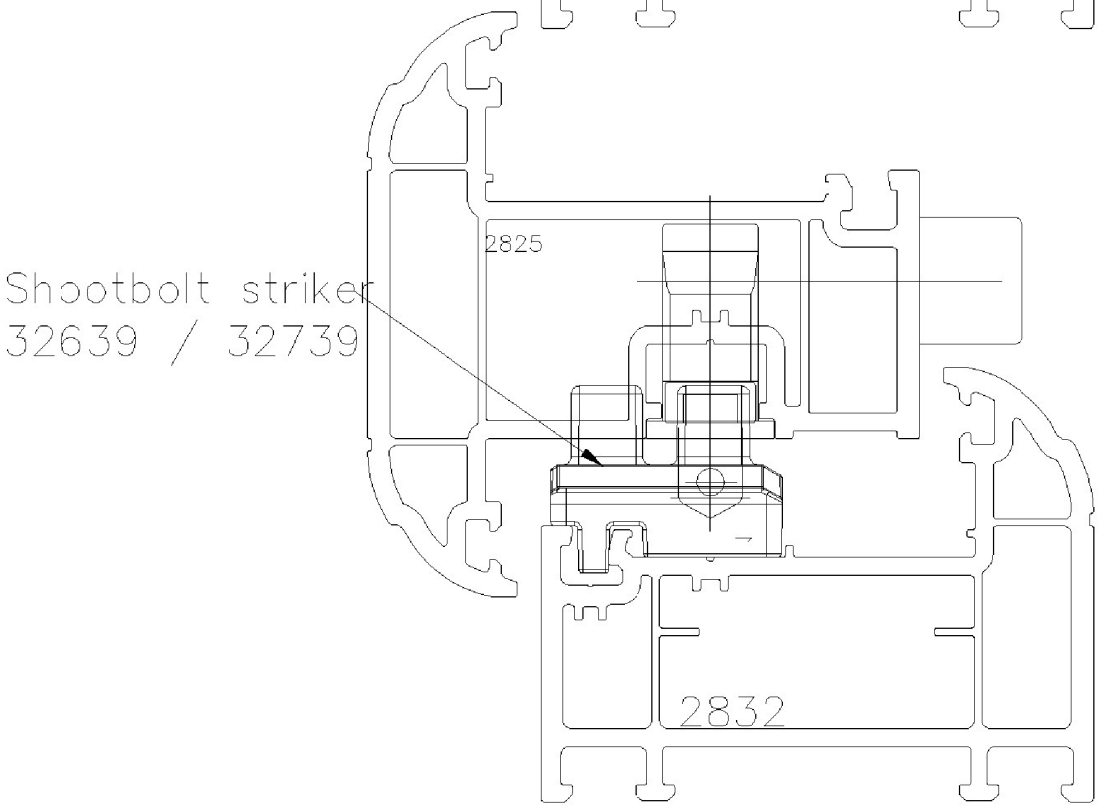
Friction stays 17mm stack height:

Mila standard	*Cotswold*	*Pt. No.*	*023120 etc*
Mila defender	*Securistyle*	*Pt. No.*	*028042 etc*
Mila fearless	*Cotswold*	*Pt. No.*	*023580 etc*
Mila vector	*Securistyle*	*Pt. No.*	*028392 etc*
Mila heavy duty	*Cotswold*	*Pt. No.*	*023172 etc*

Other additional hardware:

Hinge protector	*Twin prong none route*	*Pt. No.*	*420050 & 420092*
Packer for above	*T.B.A.*	*Pt. No.*	*T.B.A.*
H block & Griff bolt	*(Only use with fearless stays)*	*Pt. No.*	*039541 & 023888*
SC Hinge protector set		*Pt. No.*	*023904*


Night vent striker
32939
2825
2832

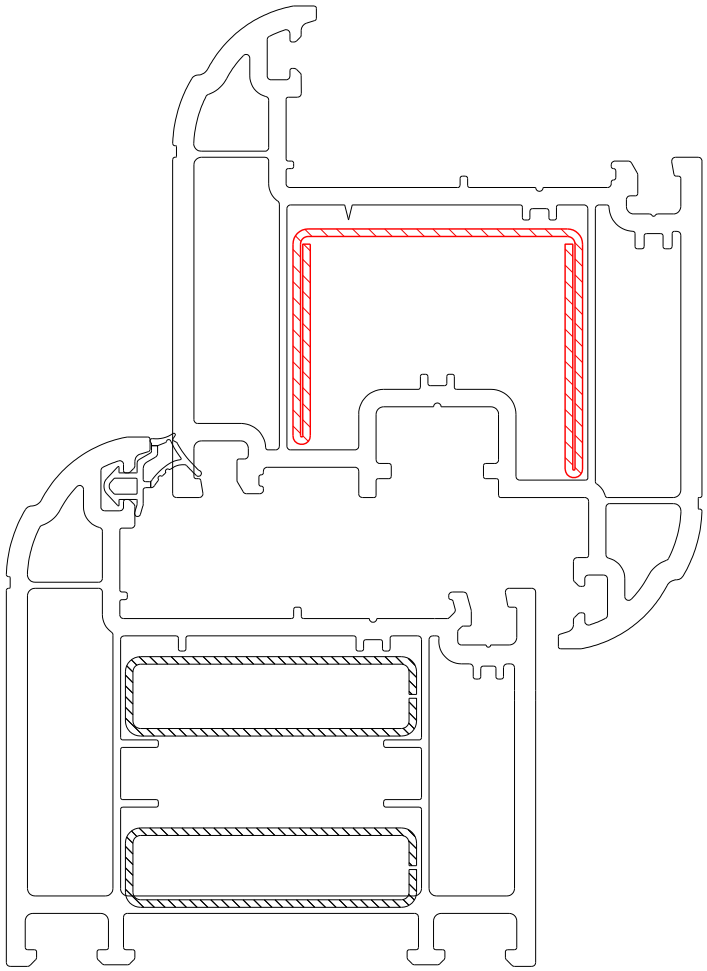

Shootbolt striker
32639 / 32739
2825
2832

MILA

Tilt Turn windows.

Locking side.

Outer Frames: 2832
Sash Frames: 2828 & 2829



Details: *16mm backset / 16mm faceplate / 13 eurogroove position*

Mila Garant T.B.T.

Base plate	*Execution 50/4*	*Pt. No.*	*610506 etc*
T.B.T. striker	*5410*	*Pt. No.*	*675410*
Roller cam striker	*2040*	*Pt. No.*	*372040*

Siegenia Si Line T.B.T.

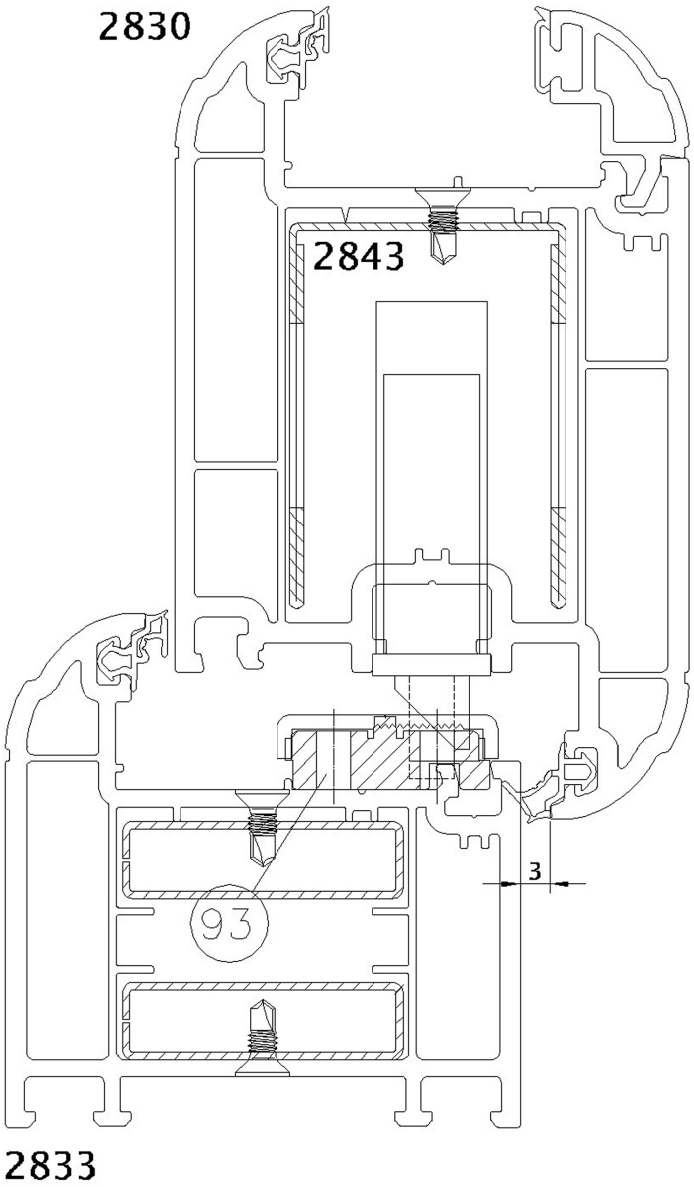
Rebated corner hinge	*Universal*	*Pt. No.*	*310548 or 310552*
Stay angle	*Universal*	*Pt. No.*	*351532*
T.B.T. striker	*2040*	*Pt. No.*	*364210*
Roller cam striker	*2040*	*Pt. No.*	*372040*
Basic bag	*13mm*	*Pt. No.*	*311110 or 311112*

HARDWARE REF.

LOCKMASTER HOOK LOCK

LOCKMASTER KEEP SET

LOCKMASTER PACKERS No. 93



Carl F

deceuninck

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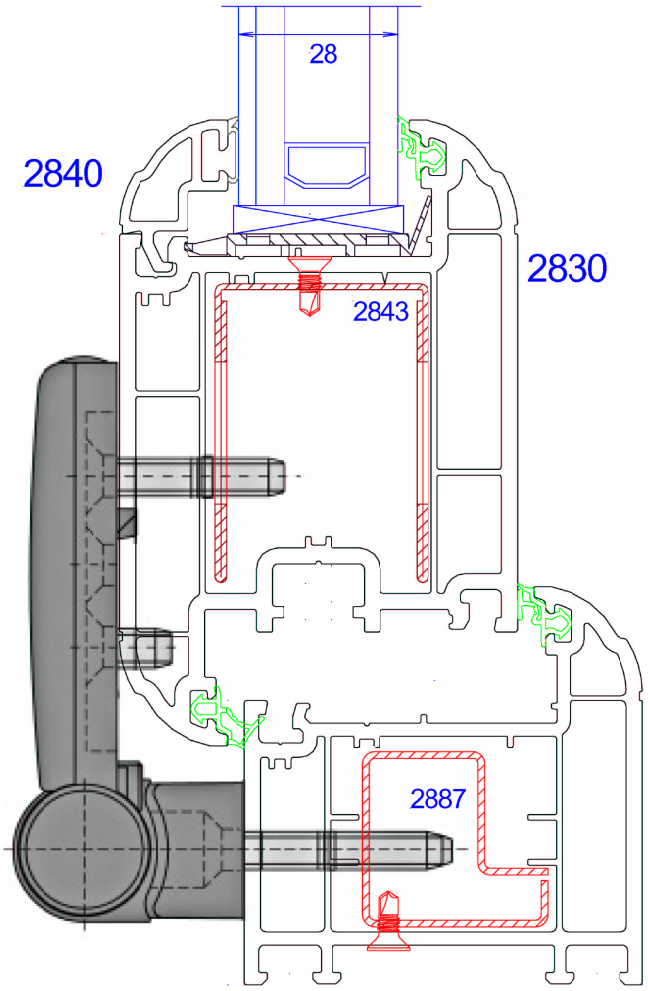
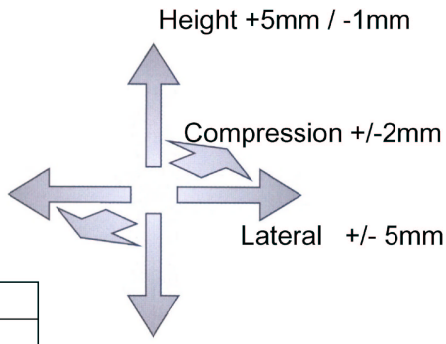
simonswerk

Residential Doors

3-WayAdjustable Hinge
Simonswerk K4145





Part Number	Description
42.7300.30.145	K4145 White Flag Hinge
42.7300.32.145	K4145 Brown Flag Hinge

42.7300.00.001	K4145 Hinge Jig
42.7300.00.009	K4145 Telescopic Multi Jig

Carl F

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HARDWARE

Carl F

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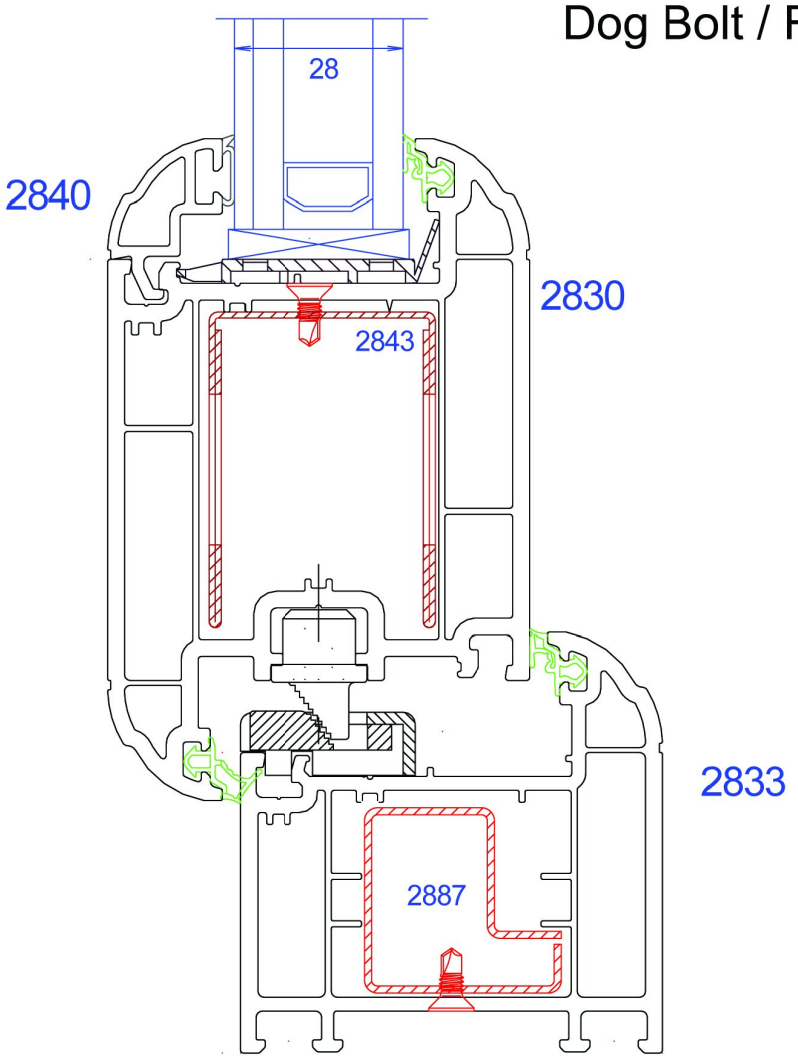
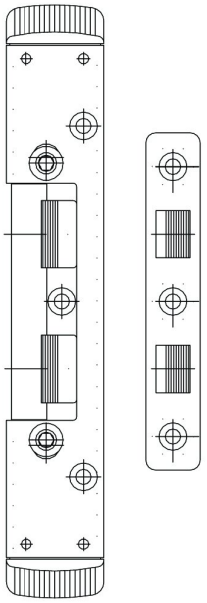
FUHR MULTISAFE

Dog Bolt / Residential Doors



Frame Plate



Sash Plate

Dog Bolt – Frame and Sash
No routing required.

Part No.	Product
40.2205.50.009	50009 16mm Sash Plate – Silver finish
40.2205.50.488	50488 Frame Plate – Silver Finish

Carl F

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Tyson Courtyard, Weldon South Ind Estate, CORBY, Northants. NN18 8AZ
Tel 01536 401155 Fax 01536 401157 e-mail sales@carlf.co.uk

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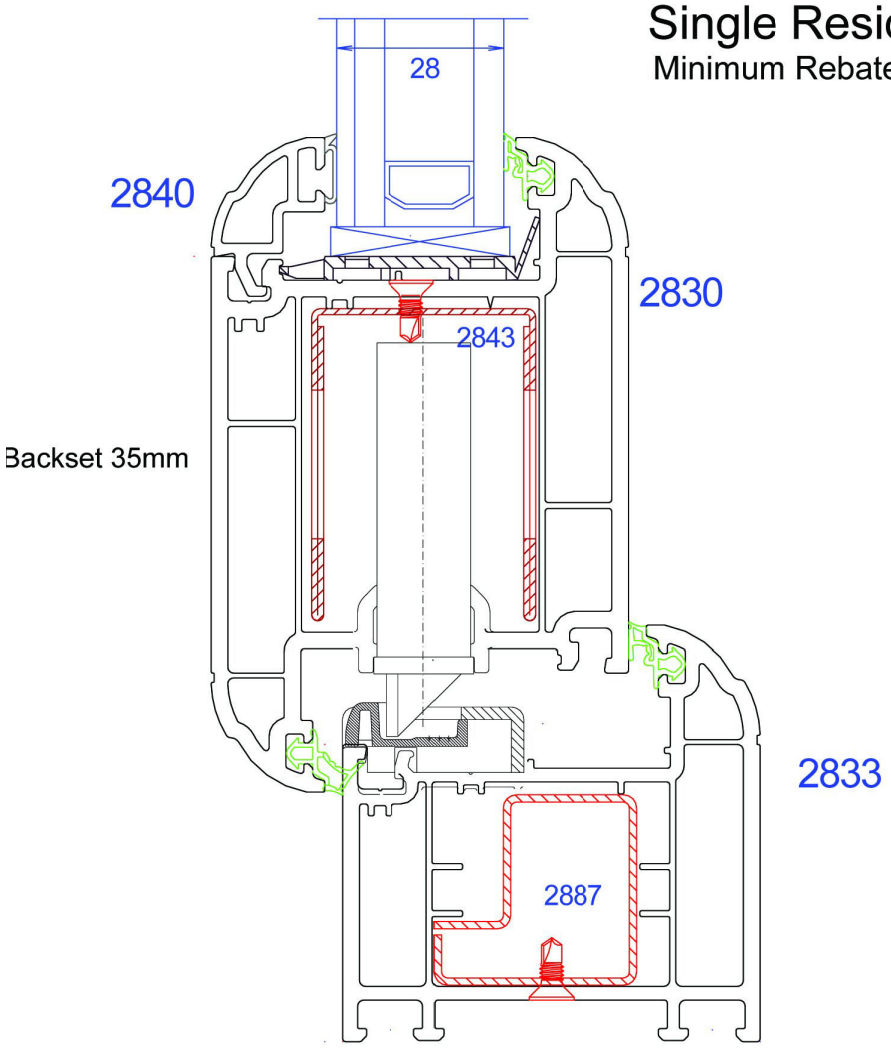
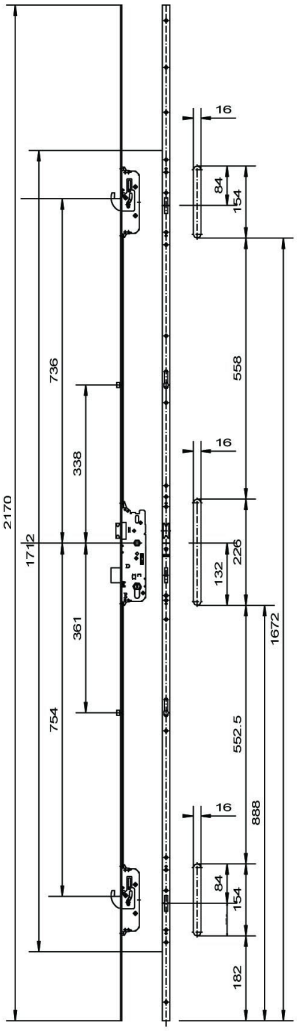
FUHR MULTISAFE

Single Residential Doors

Minimum Rebate Size 1830mm





Part Number	Description
42.3856.92.353	Lever operated 856 Type 3 (hooks)
42.3859.92.353	Split spindle 859 Type 3 (hooks)

42.4211.47.462	Centre Plate (Latch & Deadbolt) Left
42.4212.47.462	Centre Plate (Latch & Deadbolt) Right
42.4201.48.108	Hook Plate
42.4202.55.677	Roller Plate

42.4511.55.557	One-piece keep Left
42.4512.55.557	One-piece keep Right

Carl F

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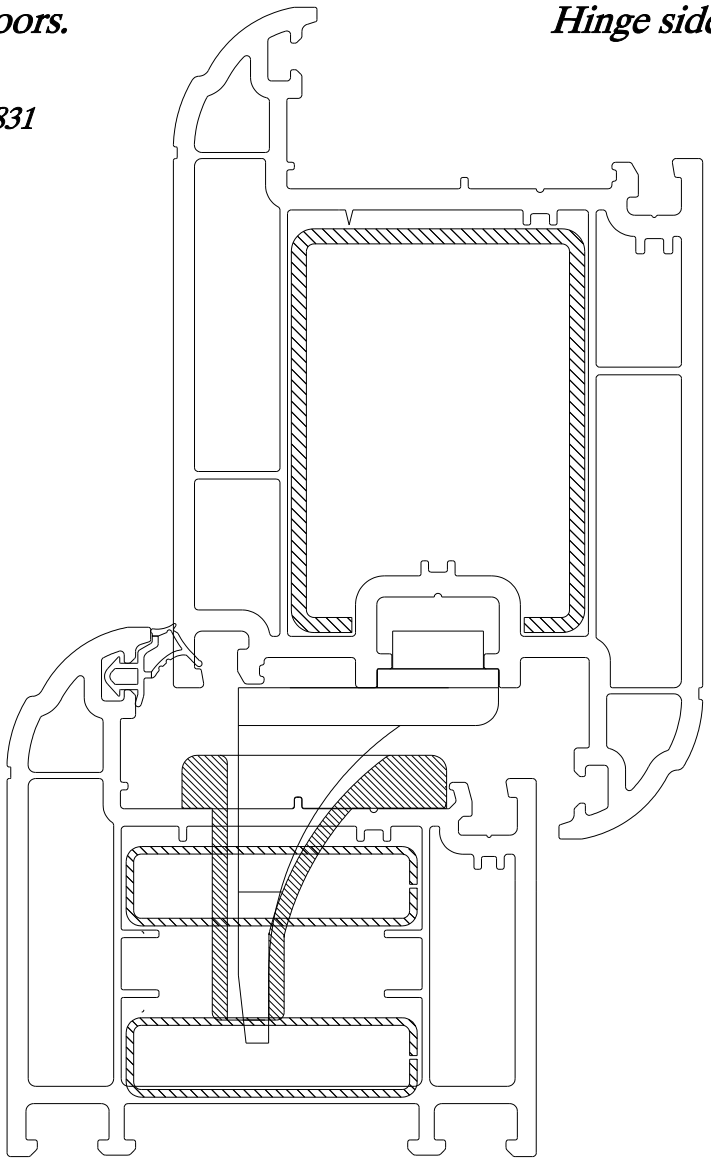
Tyson Courtyard, Weldon South Ind Estate, CORBY, Northants. NN18 8AZ
Tel 01536 401155 Fax 01536 401157 e-mail sales@carlf.co.uk

Single Residential doors.

Hinge side.

Outer Frames: 2833
Sash Frames: 2830 & 2831



Hinge details: 22mm step height / Ovolo rebate / 13mm eurogroove axis

Hinges:

Mila Evolution	*19/22 (Packer no. 024518)*	*Pt. No.*	*024322c*
Inspiration	*Flag*	*Pt. No.*	*027860*
Pendulum 13mm	*Eurogroove butt*	*Pt. No.*	*027076*

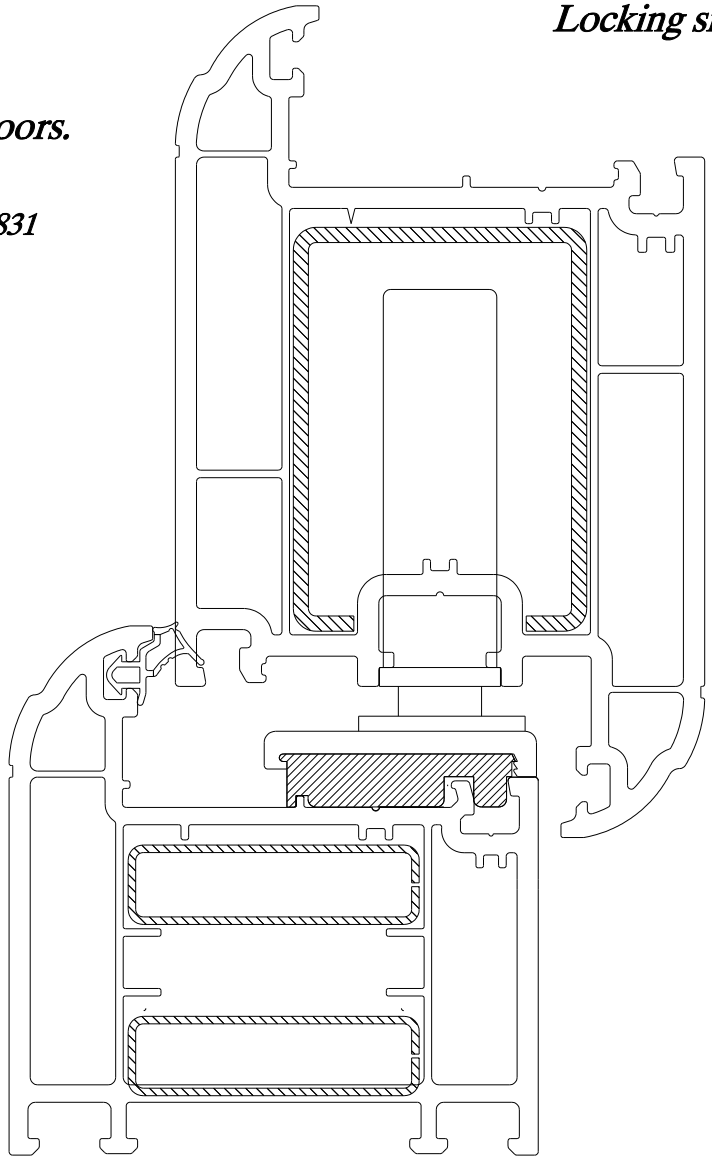
Other additional hardware:

Fearless hinge bolt	*Route in (shown)*	*Pt. No.*	*023891 & 023899*
Hinge protector	*Twin prong none route*	*Pt. No.*	*420092 & 420050*
Packer no. for above	*13*	*Pt. No.*	*420113*
90 degree friction arm	*Siegenia*	*Pt. No.*	*060305 & 060362*
Cylinder	*45 / 45*	*Pt. No.*	*049052/3*

Single Residential doors.

Outer Frames: 2833
Sash Frames: 2830 & 2831

Locking side.



Lock details: 35mm backset / 16mm faceplate / 13mm eurogroove axis

Strikers:

Latch & deadbolt	*K.F.V. 25.967E*	*Pt. No.*	*403256 RH 403261 LH*
Hook	*K.F.V. 2825.967V*	*Pt. No.*	*407832*
Pin	*K.F.V. 2325.967V*	*Pt. No.*	*405134*
Shootbolt	*K.F.V. 7325.967V*	*Pt. No.*	*405895*
Roller cam	*Siegenia 2040*	*Pt. No.*	*372040*

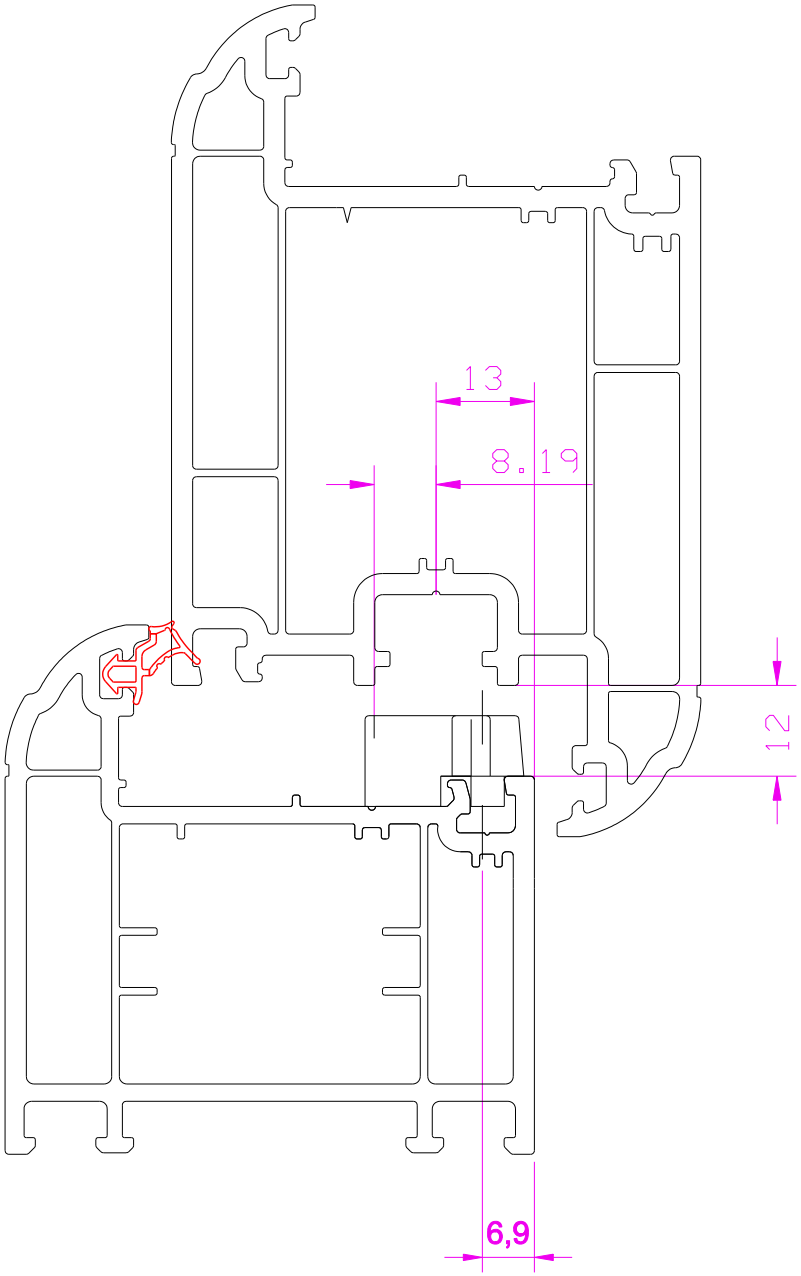
Alternative strikers (On packers):

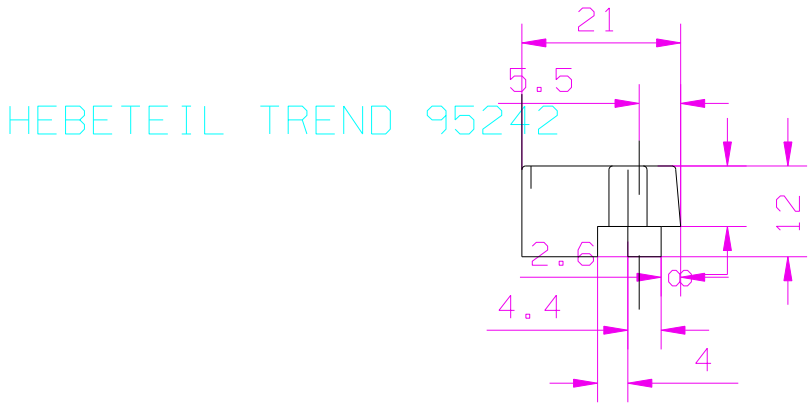
Latch & deadbolt	*Universal*	*Pt. No.*	*420001c RH 420007c LH*
Hook & Pin	*Universal*	*Pt. No.*	*420031cs*
Shootbolt	*Universal*	*Pt. No.*	*420341*
Packer No	*13*	*Pt. No.*	*420113*
Roller cam	*Siegenia 2040*	*Pt. No.*	*372040*

Uni-Keep Aluminium one piece strikers (shown):

AS 7921 lock	*2 Hook 2 Roller (Opposing)*	*Pt. No.*	*421030 RH 421031 LH*
AS 4921 lock	*2 Hook 2 Roller*	*Pt. No.*	*421010 RH 421011 LH*
M/Fear lock	*2 Hook 2 Roller*	*Pt. No.*	*421052 RH 421053 LH*
Mila Master lock	*2 Hook/Pin 4 Roller*	*Pt. No.*	*421092 RH 421093 LH*
Packer No.	*40*	*Pt. No.*	*421640*

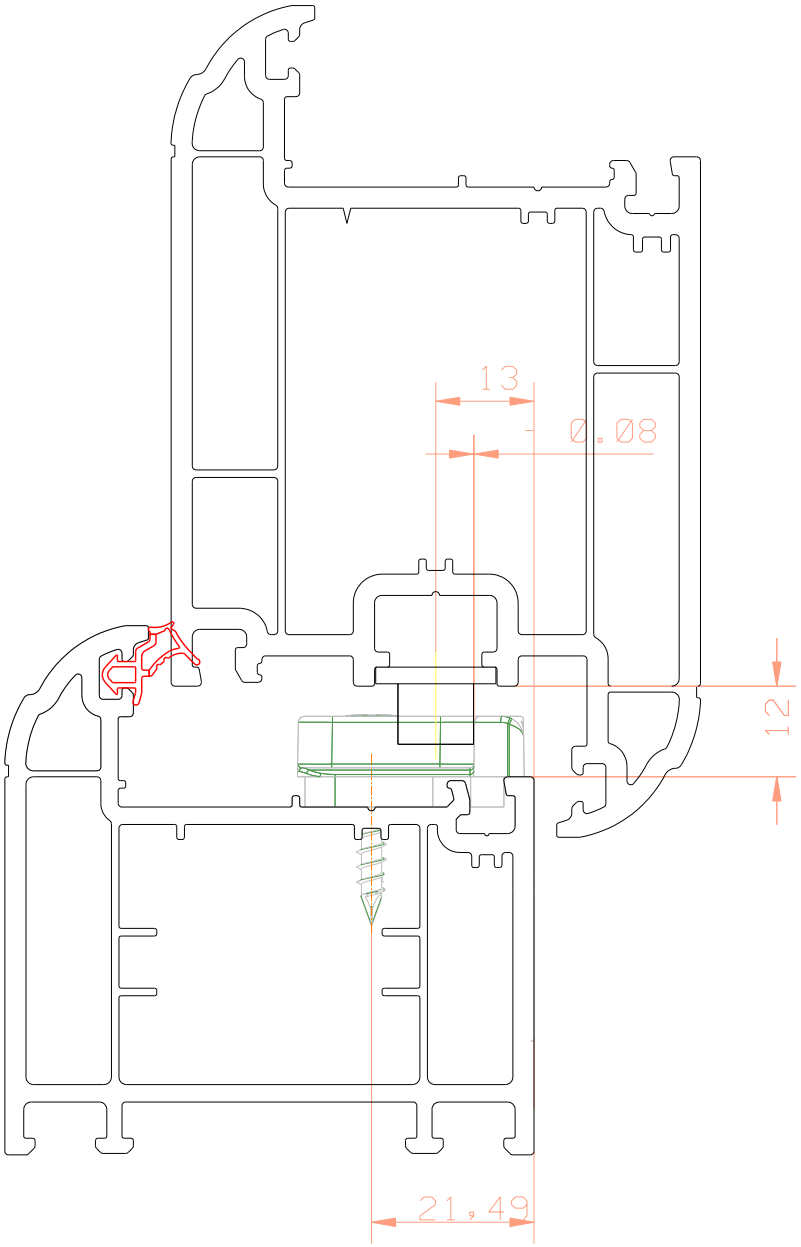
Sash Lifter



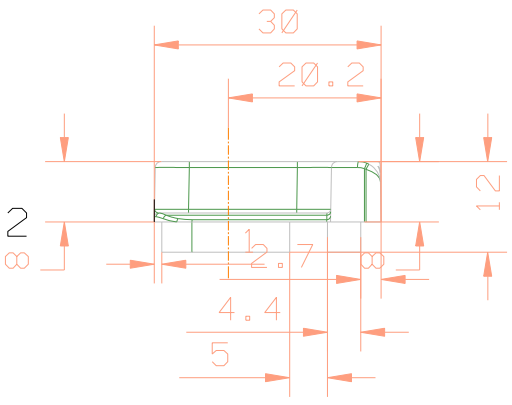


HEBETEIL TREND 95242

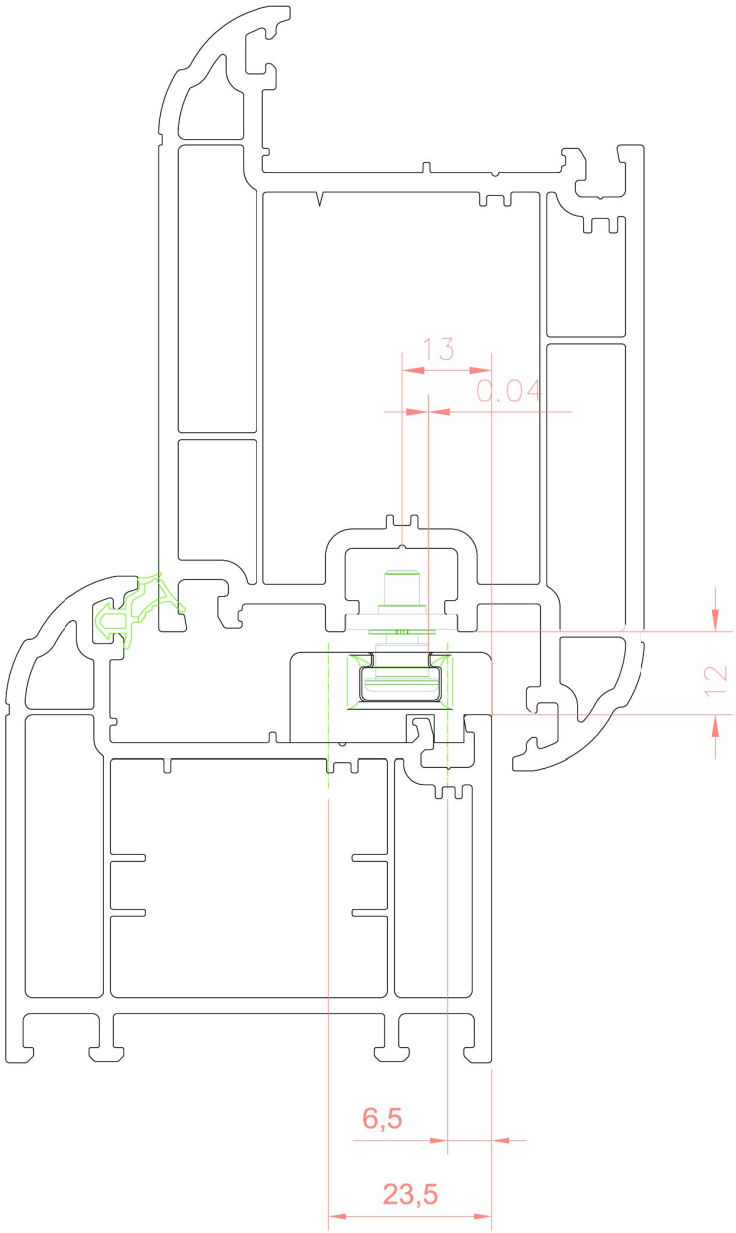
Standard Striker

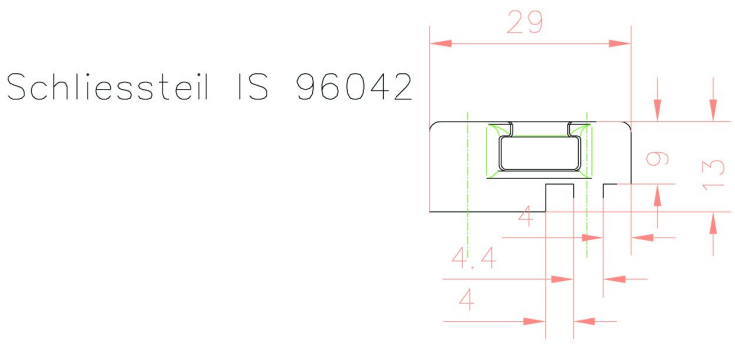


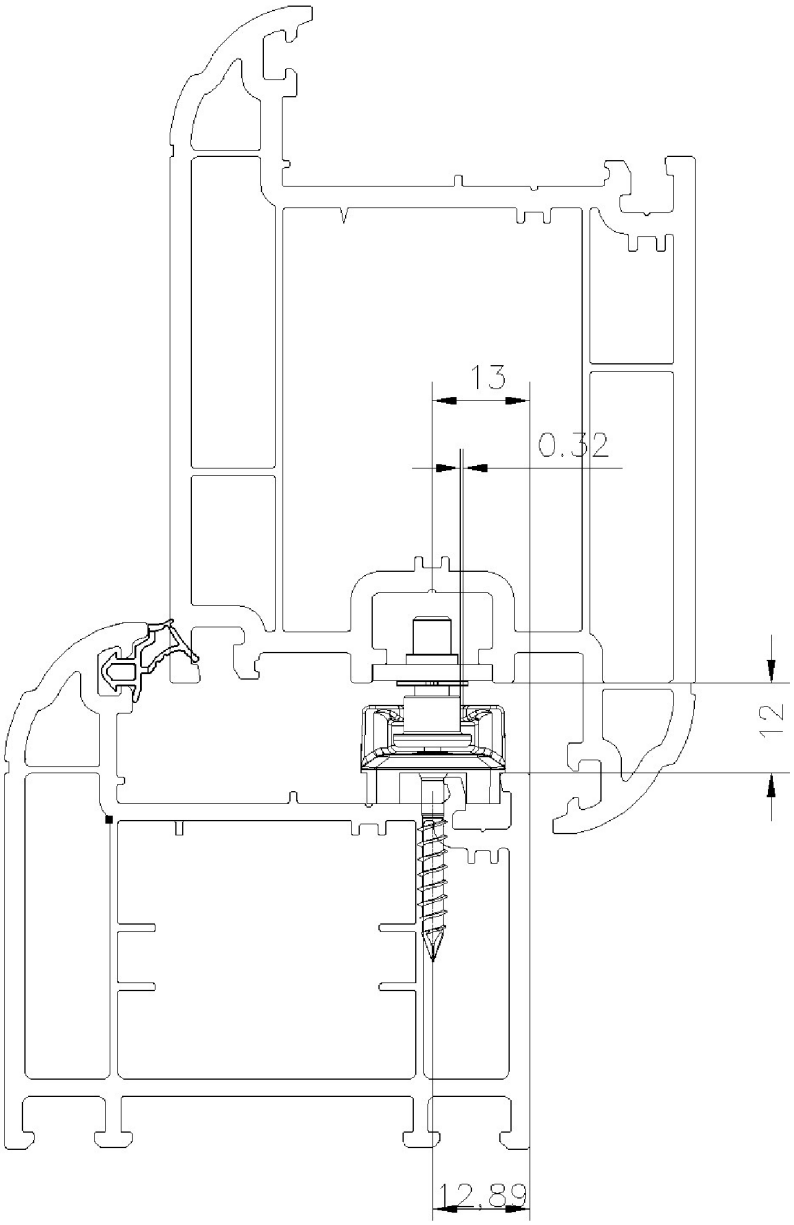
SCHLIESSTEIL 34Ø42



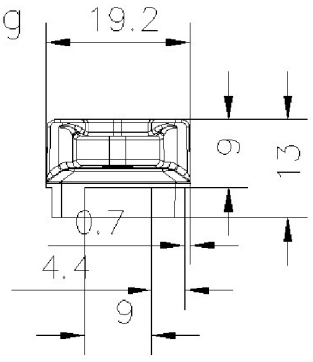
Mushroom – Striker







Schliessteil IS f. KD-Beschlag
97042 (Zn.Nr. 351865)



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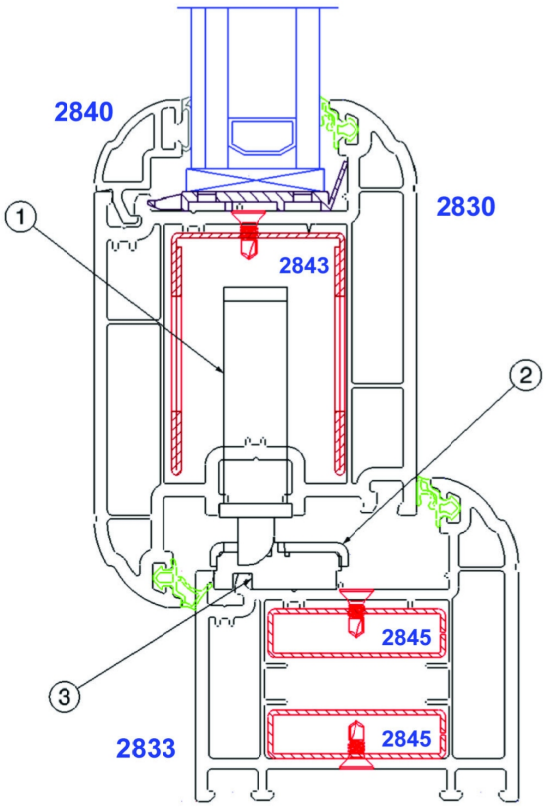
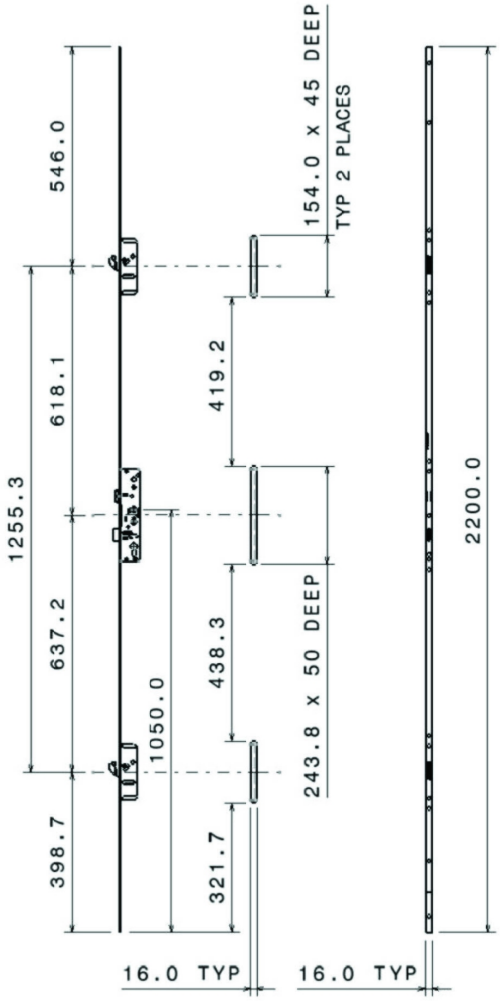
deceuninck

2800 decorative

SINGLE RESIDENTIAL DOORS

Minimum Rebate Size 2200mm. Backset 35mm





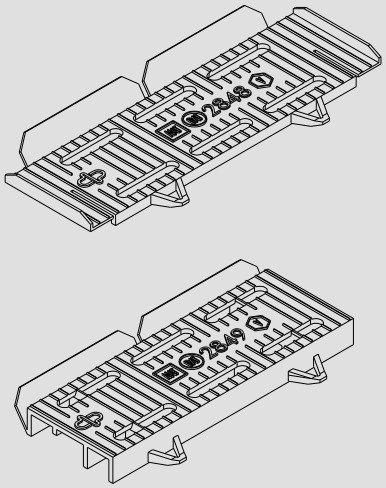
No	Part	Part Description	Quantity
1	ML132A	2 HOOK, 1 D/BOLT MULTI-POINT DOOR LOCK	1
2	MK200PCL	LH KEEP FOR u-PVC	1
2	MK201PCR	RH KEEP FOR u-PVC	1
3	PLP093	DECEUNINCK 2800 PACKER	1

For more detailed information, please contact our technical department.

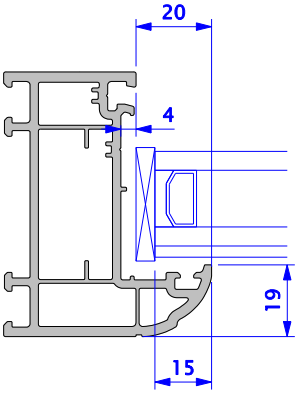
securistyle
innovation in window hardware

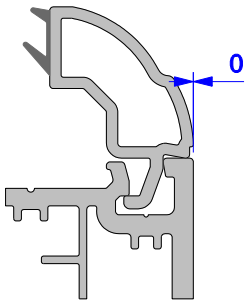
Securistyle Ltd
Kingsmead Industrial Estate, Princess Elizabeth Way, Cheltenham, Gloucestershire, GL51 7RE.
Email: info@securistyle.co.uk **Tel:**+44 (0) 1242 221200 **Main Fax No:**+44 (0) 1242 520828

GLAZING TABLE

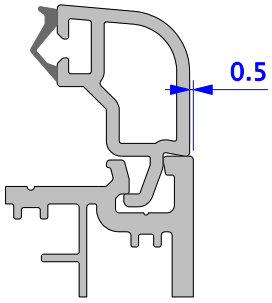


DECORATIVE	CHAMFERED	RETRO	CONTEMPORARY	STANDARD	
				3137 (39.5)	3 4
				3037 (39.5)	5 6
				3139 (36.5)	7 8
				3039 (36.5)	9 10
				3120 (28.5)	15 16
		3031 (28.5)	3032 (28.5)	3020 (28.5)	17 18
				3022 (26.5)	19 20
		3033 (24.5)	3034 (24.5)	3024 (24.5)	21 22
		3126 (22.5)		3026 (22.5)	23 24
	2540 (20.5)	3027 (20.5)	3029 (20.5)	3028 (20.5)	25 26
2840 (19)		3130 (15.5)		3030 (17.5)	28 29
		3132 (15.5)			30 31
			3036 (13.5)		32 33
			3134 (11.5)	3124 (11.5)	34 35
				3038 (7.5)	38 39



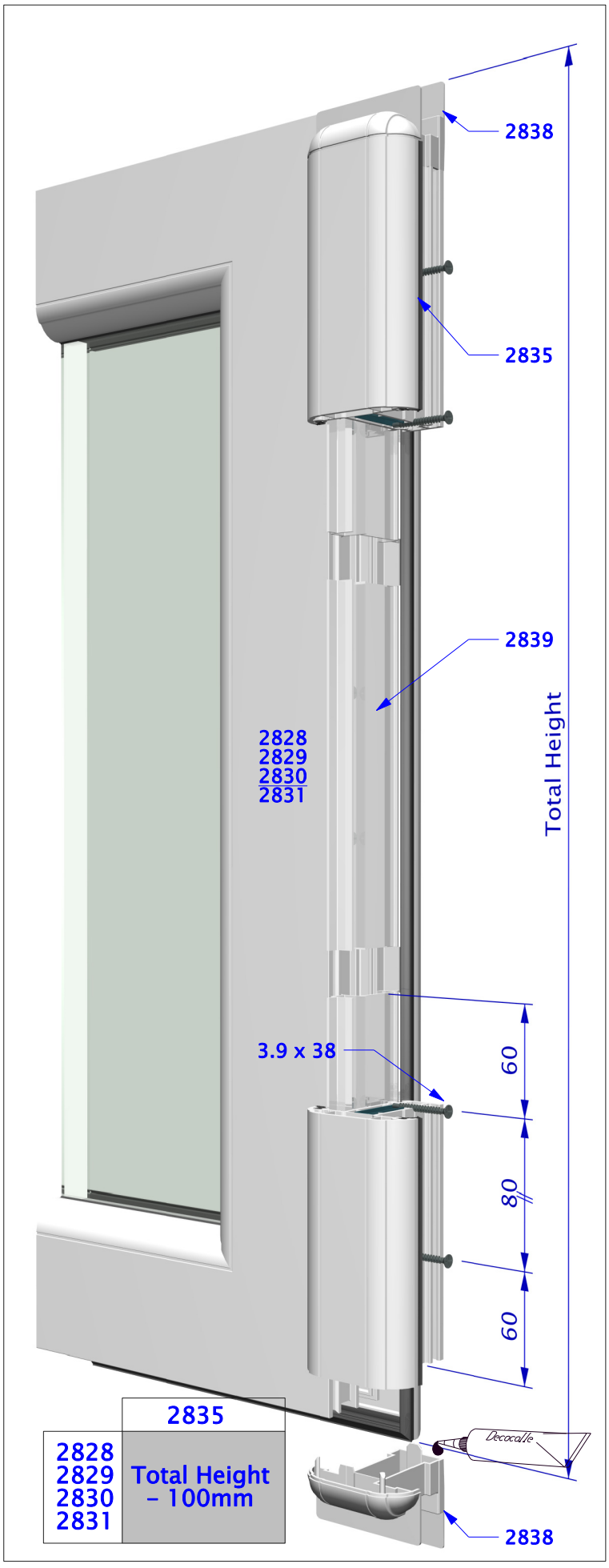


Decorative

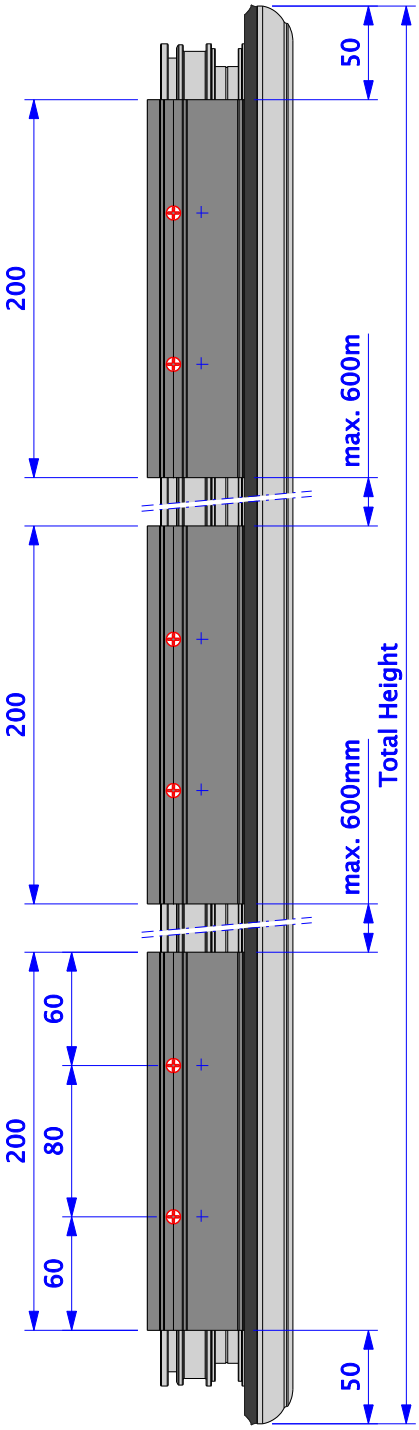


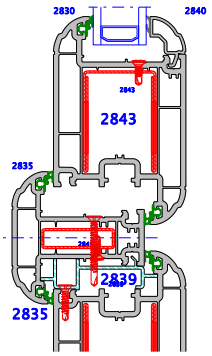
Standard
Contemporary
Retro
Chamfered

Assembly of false mullion



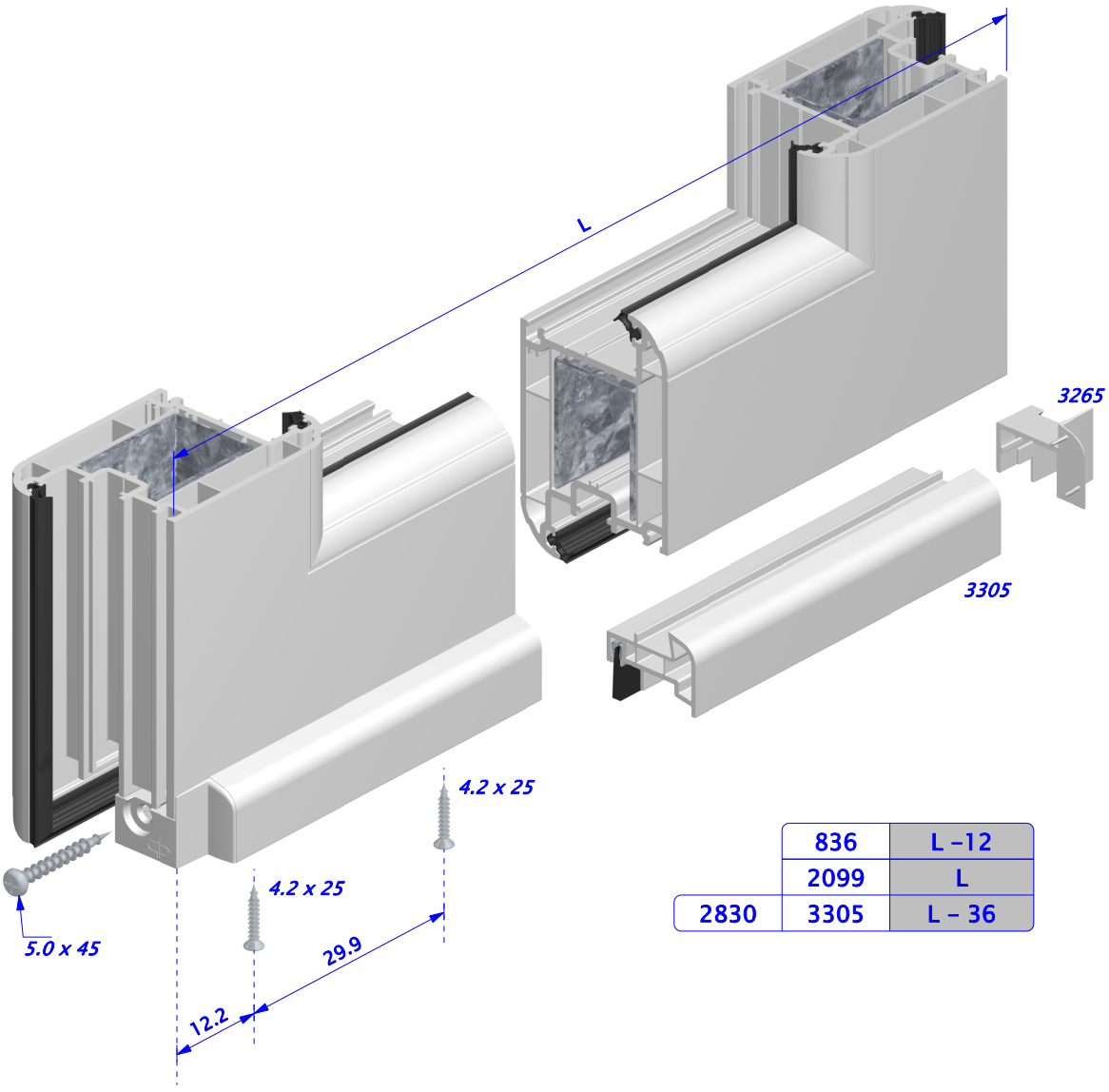
USE OF ACCESSORIES



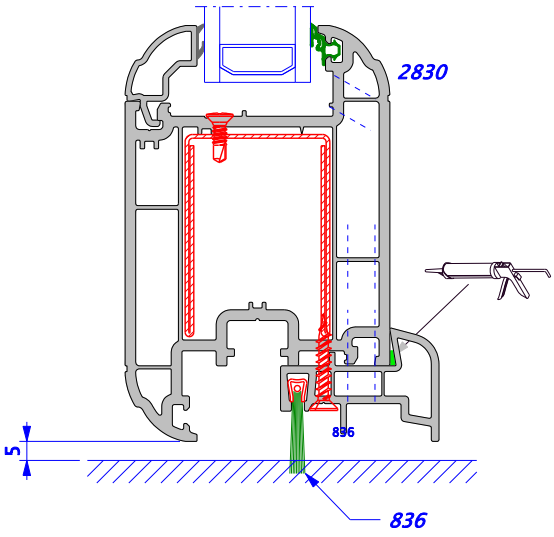


Assembly of 3305

USE OF ACCESSORIES

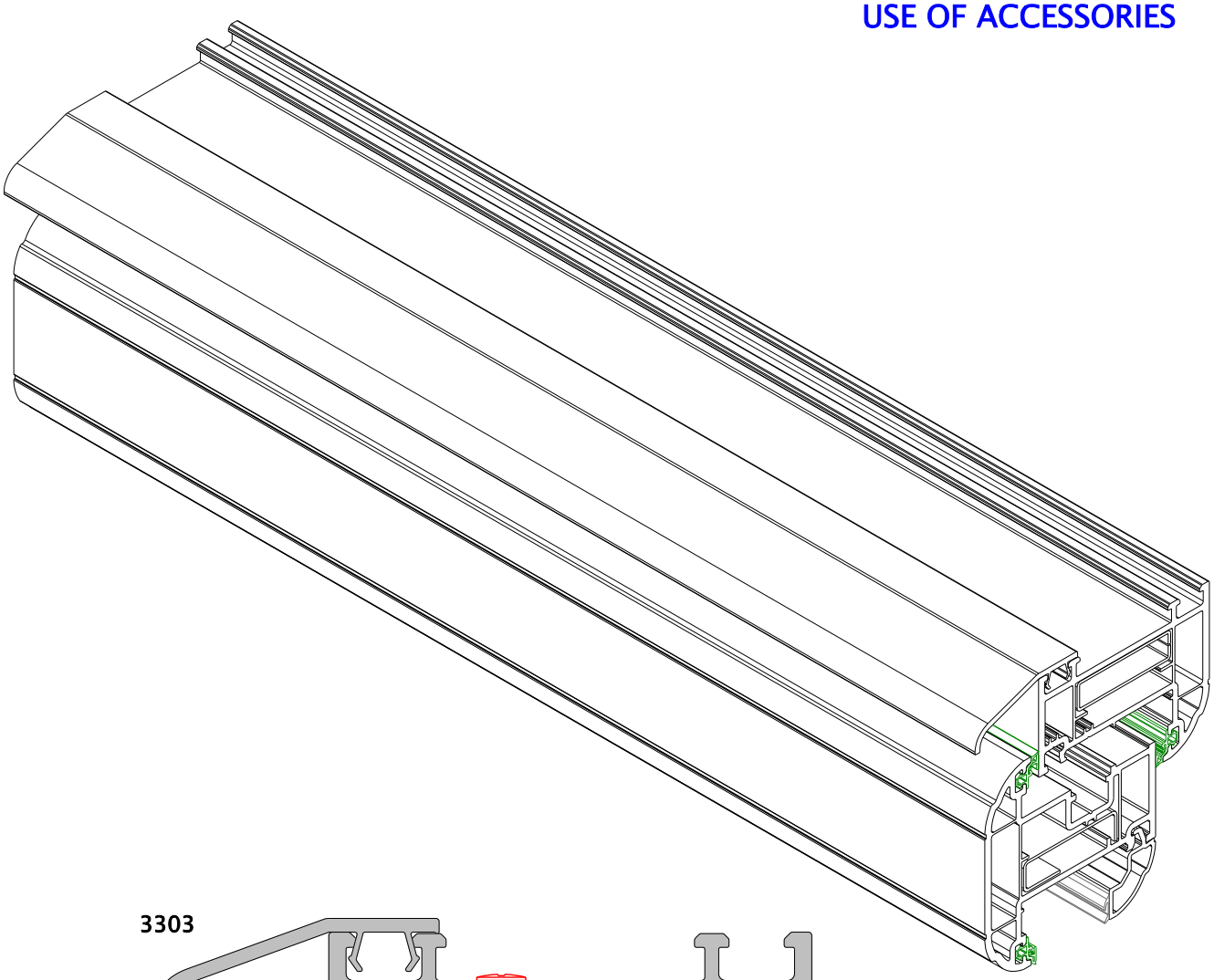


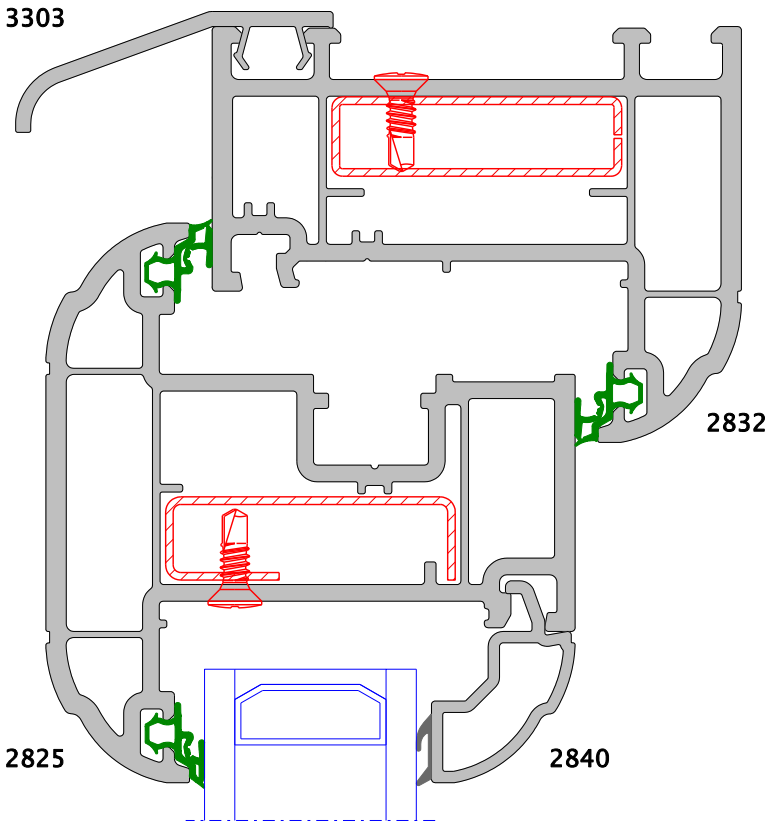
	836	L -12
	2099	L
2830	3305	L - 36



3303 Clip-On Head Drip

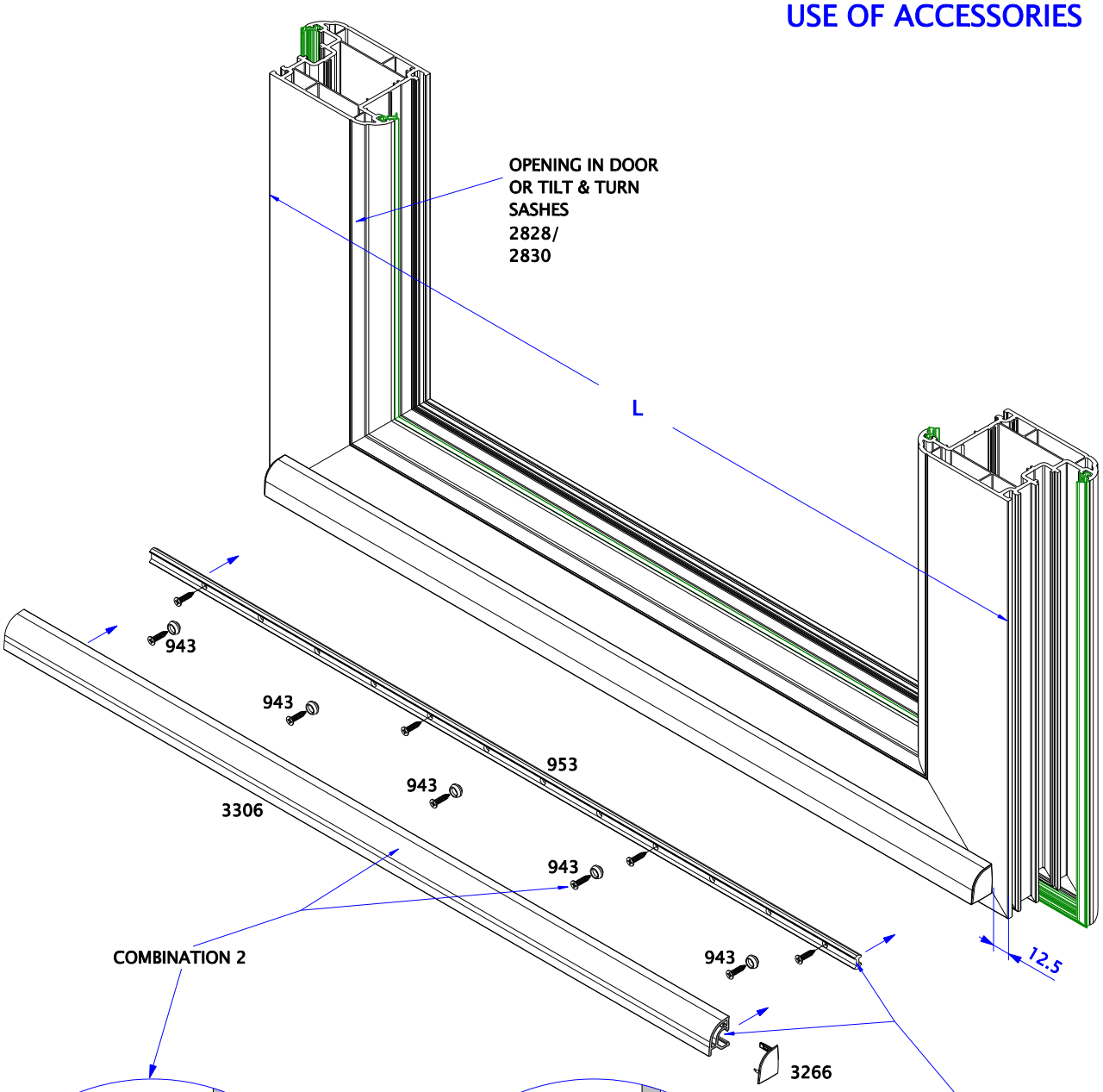
USE OF ACCESSORIES

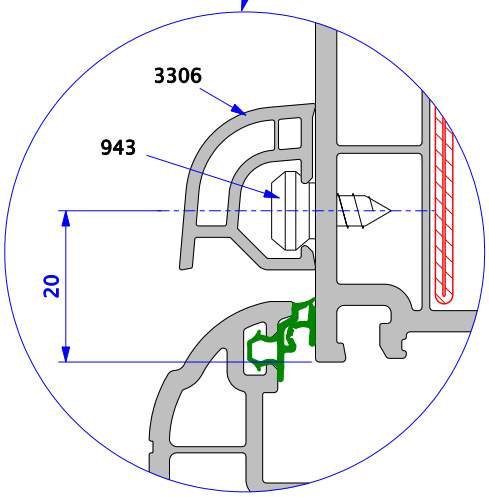




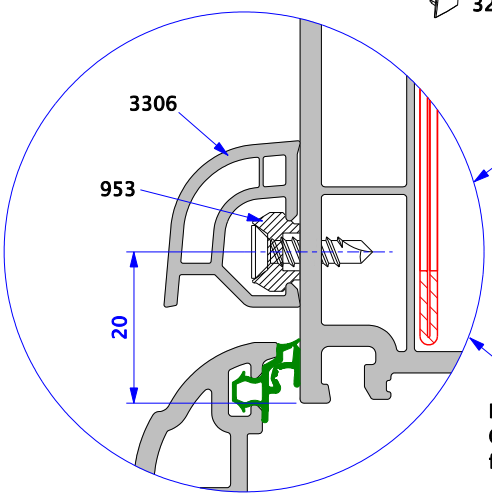
Drip Rails

USE OF ACCESSORIES





USING STUDS
943

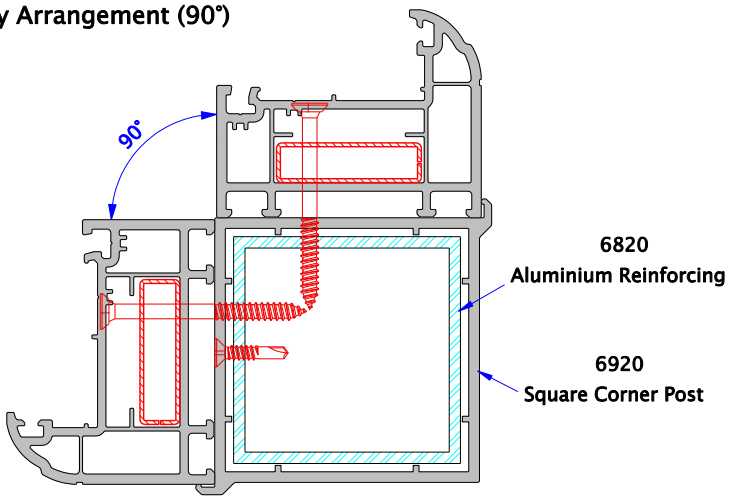


USING ALI RAIL
953

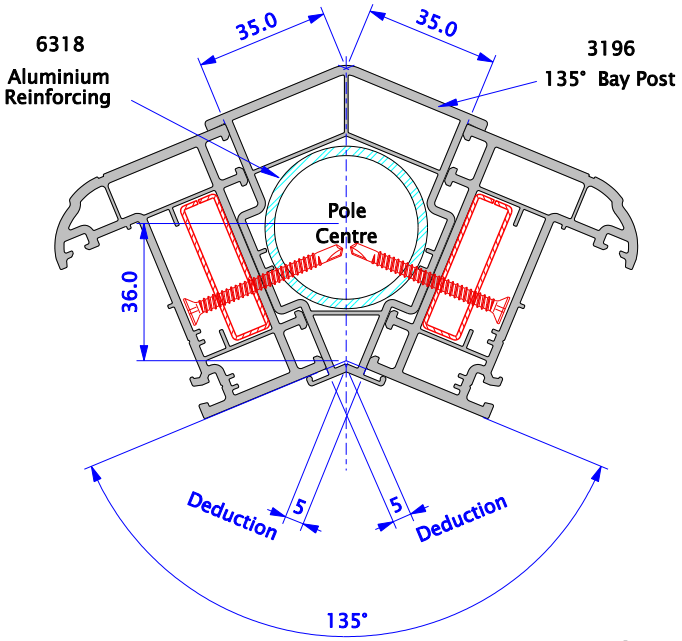
IMPORTANT
Combination 1 should always be used for foiled and coloured profiles.

3306	SHORT LEG SASH SIZE	L -28
943	40 ⊕--> 150	150 <-- ⊕ 40
953	25 ⊕ --> 200	200 <-- ⊕ 25

Fixed Angle Bay Arrangement (90°)

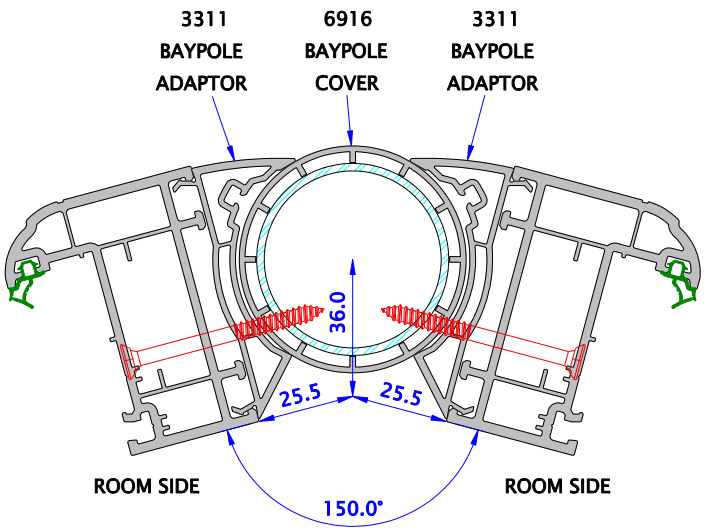


Fixed Angle Bay Arrangement (135°)



NOTE : At installation, ALL joints must be silicone sealed against the ingress of water

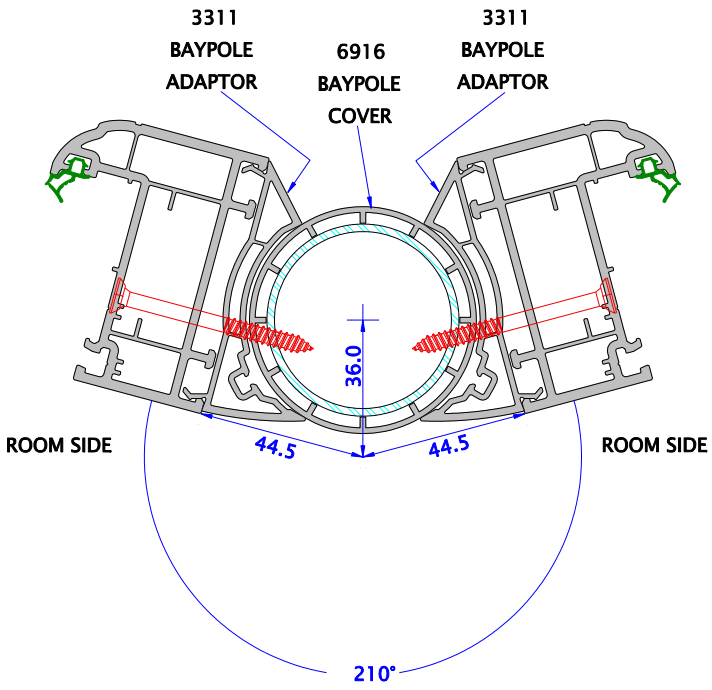
USING 3311 BAYPOLE ADAPTOR WITH 6916 60mm BAYPOLE COVER



EXAMPLE SHOWN AT 150° INTERNAL CILL ANGLE
WITH A FRAME DEDUCTION OF 25.5mm AND
A POLE CENTRE OF 36.0mm

INTERNAL CILL ANGLE	FRAME DEDUCTION	POLE CENTRE
180	35.0	35.0
178	34.5	35.0
176	34.0	35.0
174	33.0	35.0
172	32.5	35.0
170	32.0	35.0
168	31.5	35.0
166	30.5	35.5
164	30.0	35.5
162	29.5	35.5
160	29.0	35.5
158	28.0	35.5
156	27.5	36.0
154	27.0	36.0
152	26.5	36.0
150	25.5	36.0
148	25.0	36.5
146	24.5	36.5
144	23.5	37.0
142	23.0	37.0
140	22.5	37.5
138	21.5	37.5
136	21.0	38.0
134	20.0	38.0
132	19.5	38.5
130	18.5	38.5
128	18.0	39.0
126	17.0	39.5
124	16.5	39.5
122	15.5	40.0
120	15.0	40.5
118	14.0	41.0
116	13.0	41.5
114	12.5	41.5
112	11.5	42.0
110	10.5	42.5
108	9.5	43.5
106	8.5	44.0
104	7.5	44.5
102	6.5	45.0
100	5.5	45.5
98	4.5	46.5
96	3.5	47.0
94	2.5	48.0
92	1	49.0
90	0	49.5

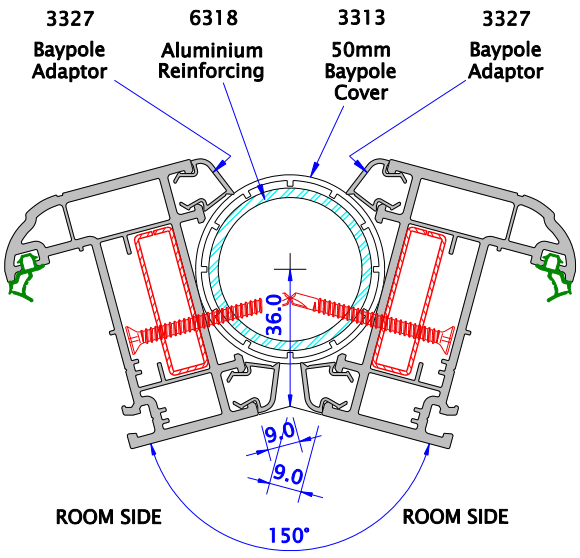
USING 3311 BAYPOLE ADAPTOR WITH 6916 60mm BAYPOLE COVER



EXAMPLE SHOWN AT 210° INTERNAL CILL ANGLE
WITH A FRAME DEDUCTION OF 44.5mm AND
A POLE CENTRE OF 36.0mm

INTERNAL CILL ANGLE	FRAME DEDUCTION	POLE CENTRE
180	35.0	35.0
182	35.5	35.0
184	36.0	35.0
186	37.0	35.0
188	37.5	35.0
190	38.0	35.0
192	38.5	35.0
194	39.0	35.5
196	40.0	35.5
198	40.5	35.5
200	41.0	35.5
202	42.0	35.5
204	42.5	36.0
206	43.0	36.0
208	44.0	36.0
210	44.5	36.0
212	45.0	36.5
214	46.0	36.5
216	46.5	37.0
218	47.0	37.0
220	48.0	37.5
222	48.5	37.5
224	49.0	38.0
226	50.0	38.0
228	50.5	38.5
230	51.0	38.5
232	52.0	39.0
234	53.0	39.5
236	53.5	39.5
238	54.5	40.0
240	55.0	40.5
242	56.0	41.0
244	57.0	41.5
246	58.0	41.5
248	58.5	42.0
250	59.5	42.5
252	60.5	43.5
254	61.0	44.0
256	62.0	44.5
258	63.0	45.0
260	64.0	45.5
262	65.5	46.5
264	66.5	47.0
266	67.5	48.0
268	69.0	49.0
270	70.0	49.5

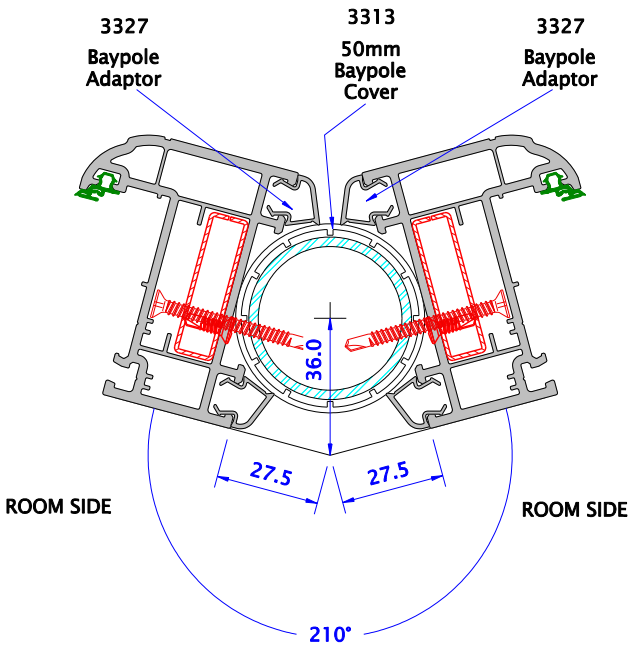
USING 3327 BAYPOLE ADAPTOR WITH 3313 50mm BAYPOLE COVER



EXAMPLE SHOWN AT 150° INTERNAL CILL ANGLE
WITH A FRAME DEDUCTION OF 9.0mm AND
A POLE CENTRE OF 36.0mm

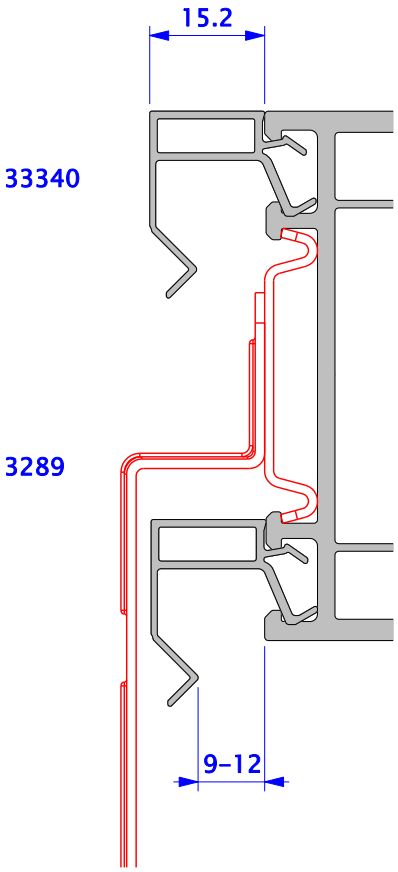
INTERNAL CILL ANGLE	FRAME DEDUCTION	POLE CENTRE
180	18.0	35.0
178	17.5	35.0
176	17.0	35.0
174	16.0	35.0
172	15.5	35.0
170	15.0	35.0
168	14.5	35.0
166	13.5	35.5
164	13.0	35.5
162	12.5	35.5
160	12.0	35.5
158	11.0	35.5
156	10.5	36.0
154	10.0	36.0
152	9.5	36.0
150	9.0	36.0
148	8.0	36.5
146	7.5	36.5
144	7.0	37.0
142	6.0	37.0
140	5.5	37.5
138	4.5	37.5

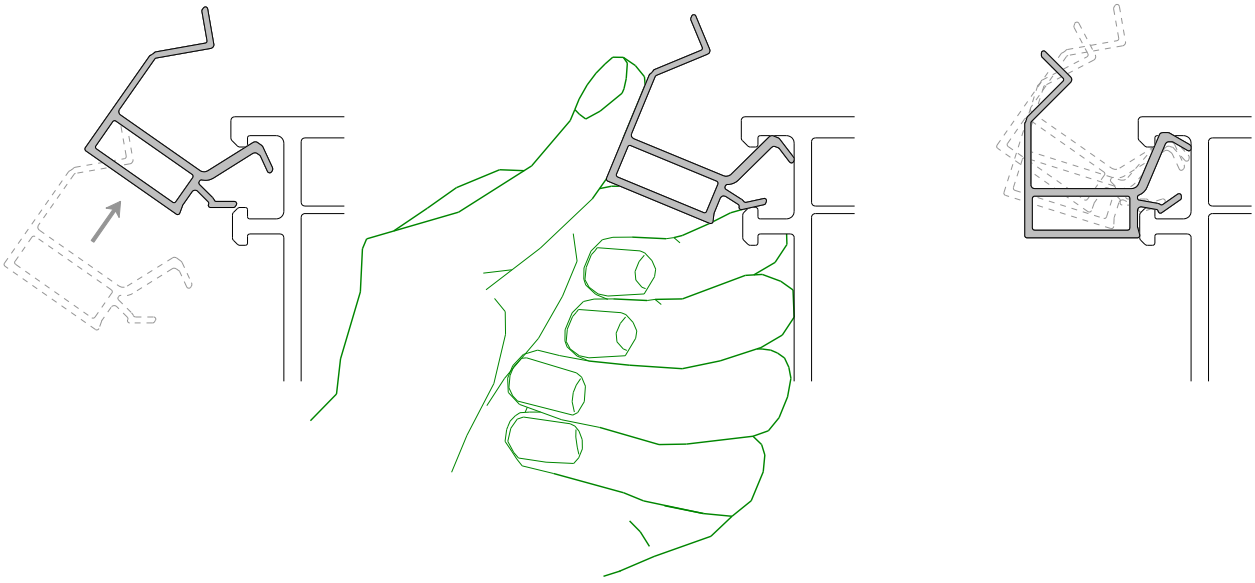
USING 3327 BAYPOLE ADAPTOR WITH 3313 50mm BAYPOLE COVER



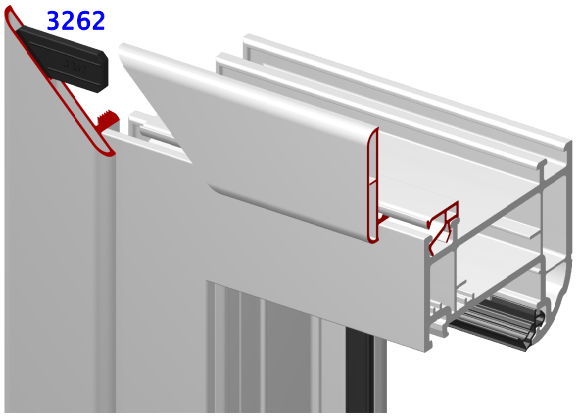
EXAMPLE SHOWN AT 210° INTERNAL CILL ANGLE
WITH A FRAME DEDUCTION OF 27.5mm AND
A POLE CENTRE OF 36.0mm

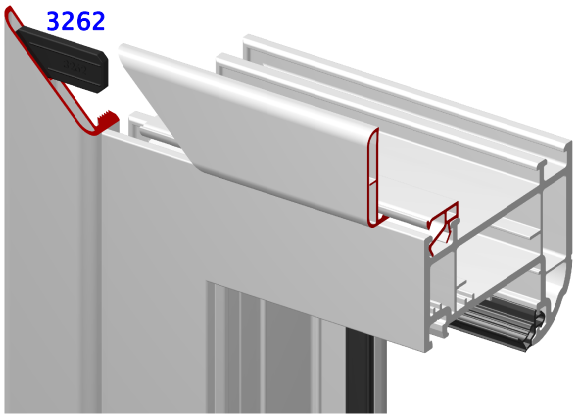
INTERNAL CILL ANGLE	FRAME DEDUCTION	POLE CENTRE
180	18.0	35.0
182	18.5	35.0
184	19.0	35.0
186	20.0	35.0
188	20.5	35.0
190	21.0	35.0
192	21.5	35.0
194	22.5	35.5
196	23.0	35.5
198	23.5	35.5
200	24.0	35.5
202	25.0	35.5
204	25.5	36.0
206	26.0	36.0
208	27.0	36.0
210	27.5	36.0
212	28.0	36.5
214	29.0	36.5
216	29.5	37.0
218	30.0	37.0
220	31.0	37.5
222	31.5	37.5

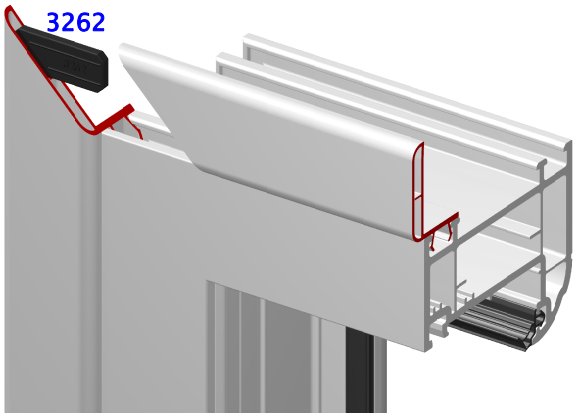

15.2
33340
3289
9-12

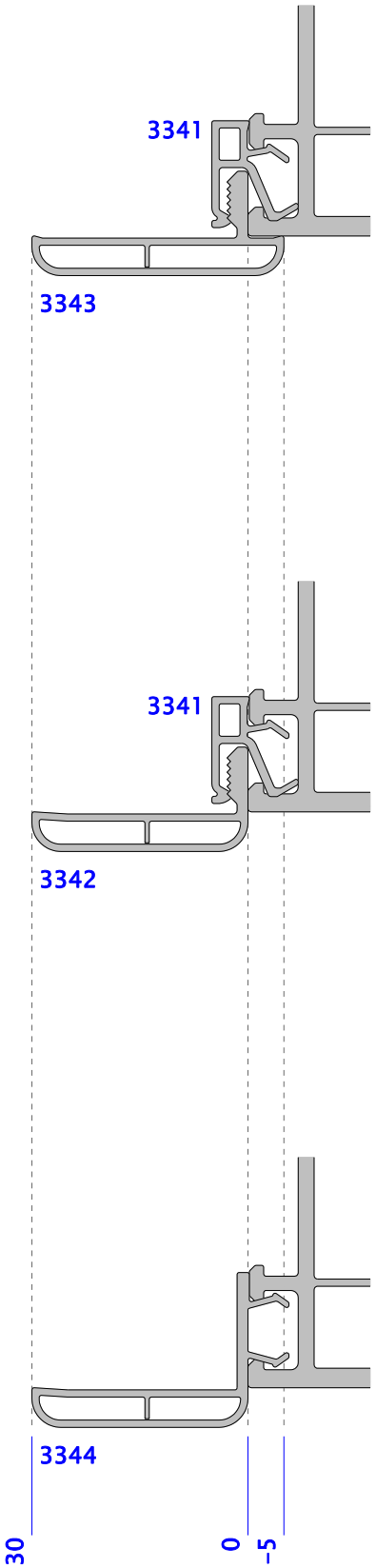


Assembly of 3341-3342/3343/3344

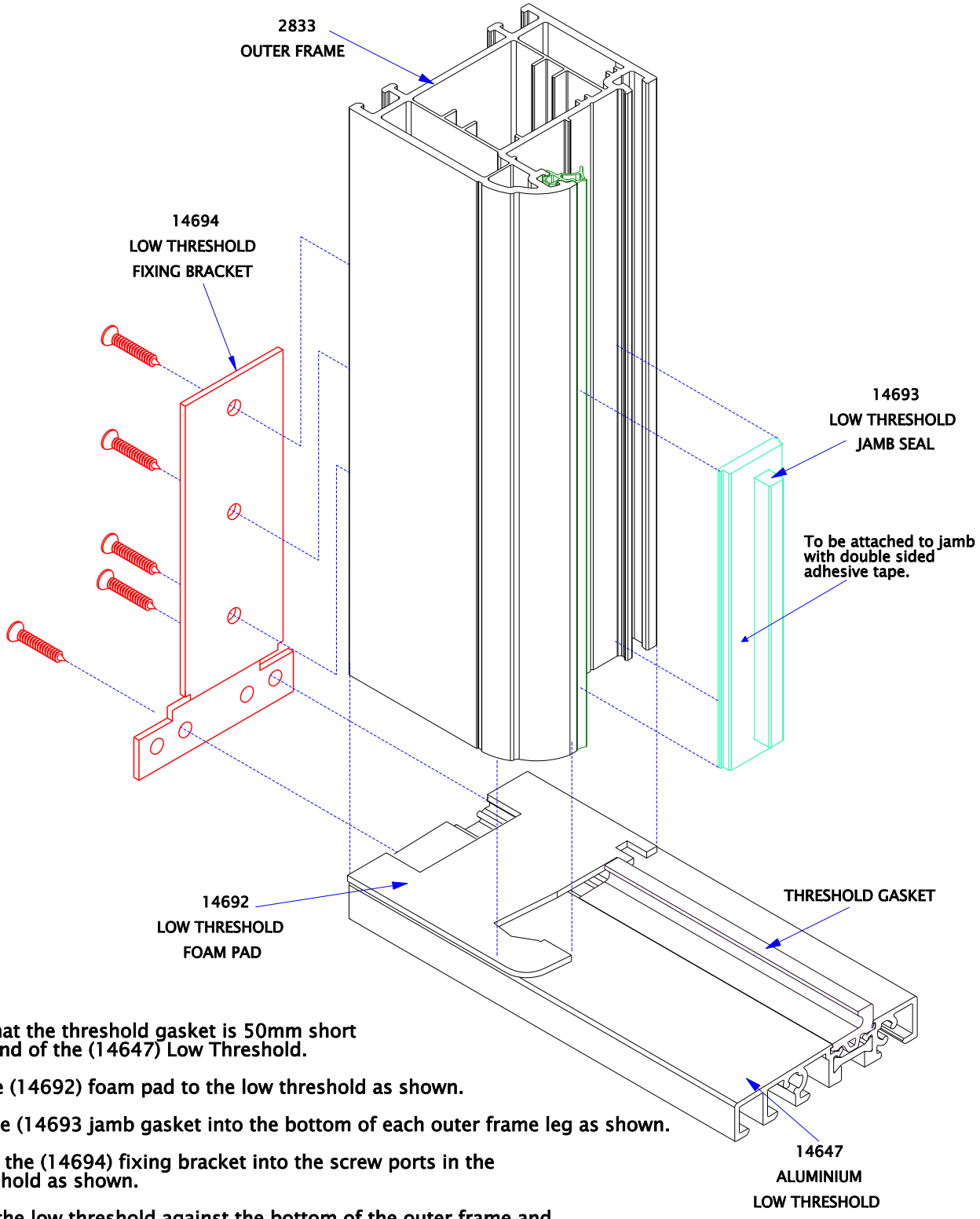








For use with single doors only.



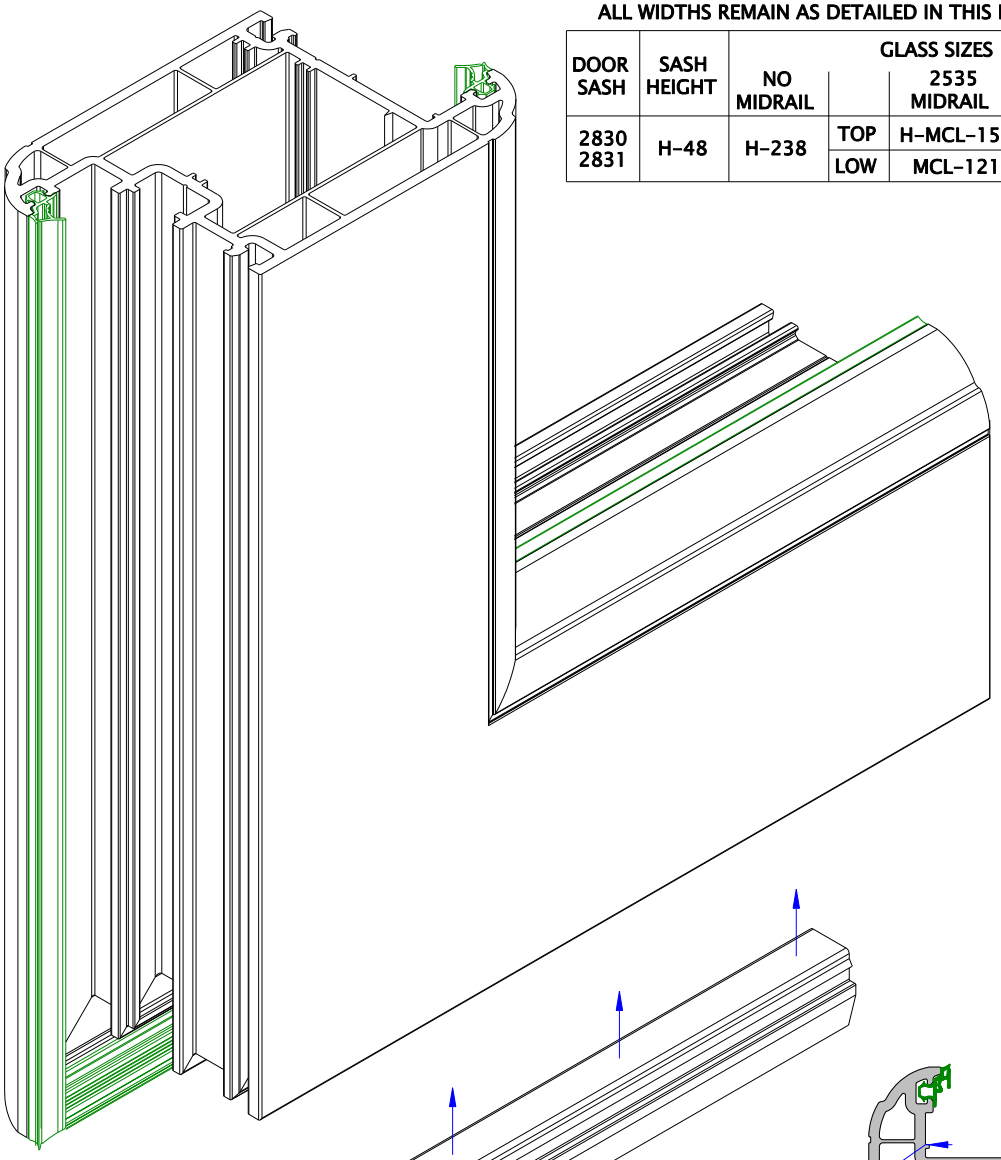
1. Ensure that the threshold gasket is 50mm short at each end of the (14647) Low Threshold.
2. Apply the (14692) foam pad to the low threshold as shown.
3. Attach the (14693 jamb gasket into the bottom of each outer frame leg as shown.
4. Screw fix the (14694) fixing bracket into the screw ports in the low threshold as shown.
5. Position the low threshold against the bottom of the outer frame and apply hand pressure to compress the foam pad, screw fix through the holes in the fixing bracket into the outer frame as shown.
6. Trim away excess from foam pad around chamfer on frame up stand.

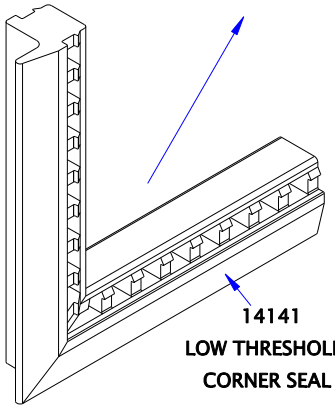
For use with single doors only

CUTTING EQUATIONS - ALL SIZES ARE NETT

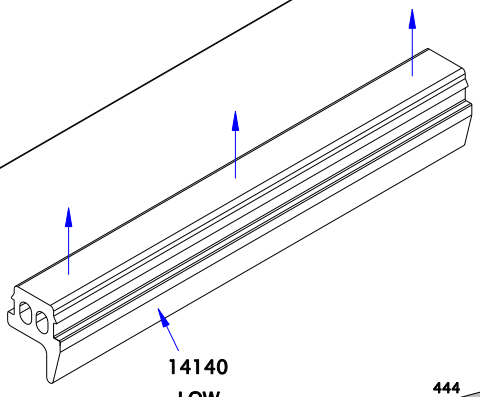
ALL WIDTHS REMAIN AS DETAILED IN THIS MANUAL

DOOR SASH	SASH HEIGHT	NO MIDRAIL	GLASS SIZES	2535 MIDRAIL	2531 MIDRAIL
2830 2831	H-48	H-238	TOP	H-MCL-157	H-MCL-177
			LOW	MCL-121	MCL-141





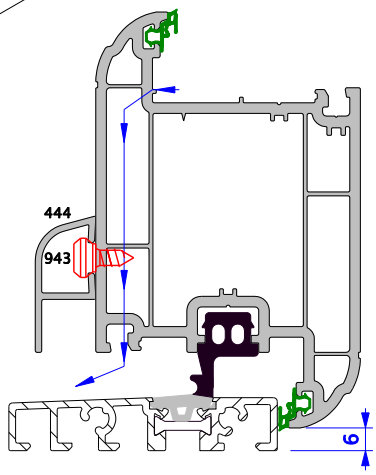
14141
LOW THRESHOLD
CORNER SEAL



14140
LOW
THRESHOLD
GASKET

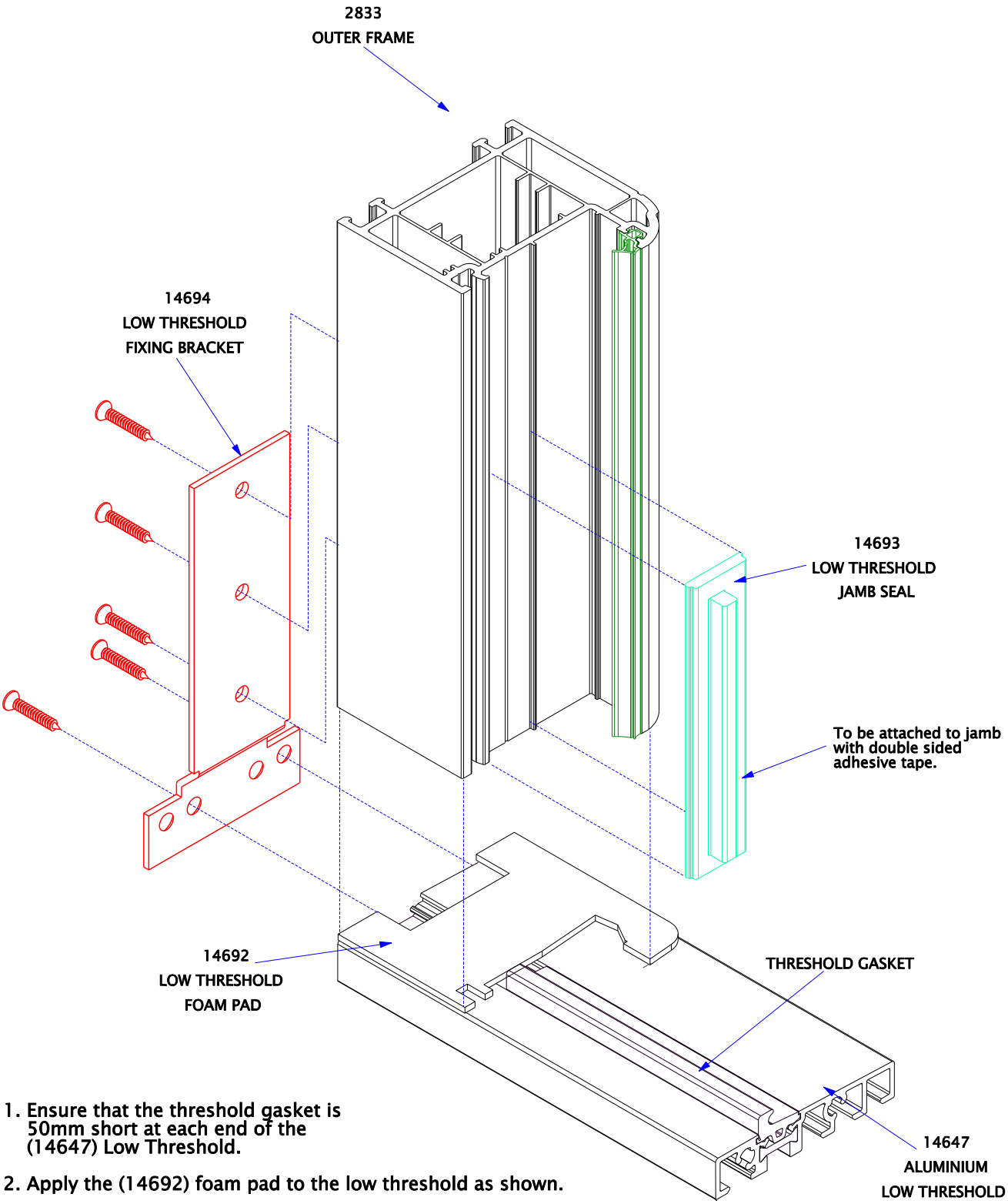
1. Insert the 14141 threshold corner seals into the bottom corners of the door sash as shown.

2. Measure between the two inserted corner seals , cut the 14140 threshold gasket to size and insert into the bottom of the door sash as shown.



CROSS-SECTION
THROUGH ASSEMBLY

For use with single doors only.

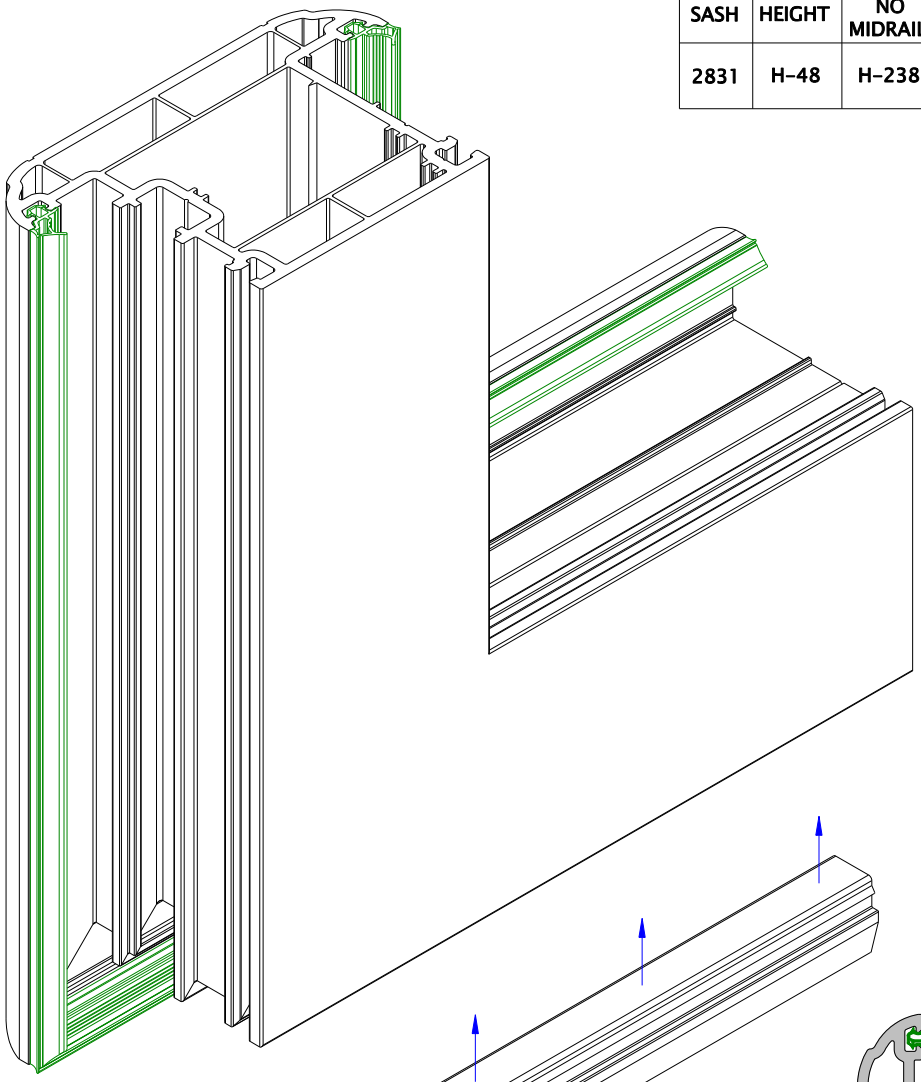


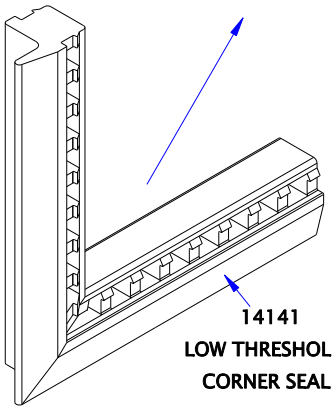
1. Ensure that the threshold gasket is 50mm short at each end of the (14647) Low Threshold.
2. Apply the (14692) foam pad to the low threshold as shown.
3. Attach the (14693 jamb gasket into the bottom of each outer frame leg as shown.
4. Screw fix the (14694) fixing bracket into the screw ports in the low threshold as shown.
5. Position the low threshold against the bottom of the outer frame and apply hand pressure to compress the foam pad, screw fix through the holes in the fixing bracket into the outer frame as shown.
6. Trim away excess from foam pad around chamfer on frame up stand.

For use with single doors only.

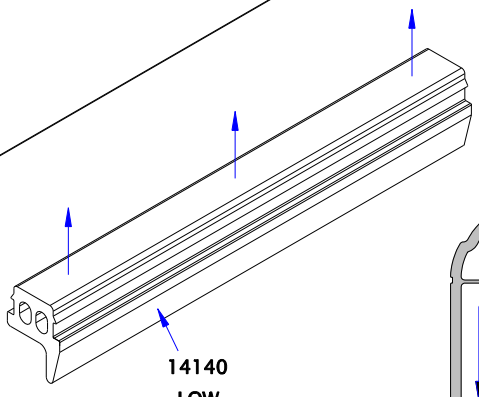
CUTTING EQUATIONS - ALL SIZES ARE NETT
ALL WIDTHS REMAIN AS DETAILED IN THIS MANUAL

DOOR SASH	SASH HEIGHT	GLASS SIZES			
		NO MIDRAIL		2535 MIDRAIL	2531 MIDRAIL
2831	H-48	H-238	TOP	H-MCL-157	H-MCL-177
			LOW	MCL-121	MCL-141





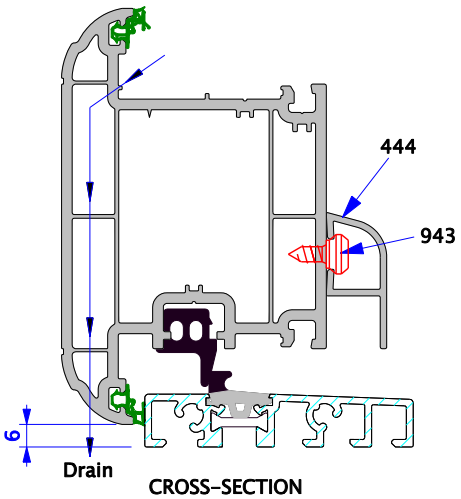
14141
LOW THRESHOLD
CORNER SEAL



14140
LOW
THRESHOLD
GASKET

1. Insert the 14141 threshold corner seals into the bottom corners of the door sash as shown.

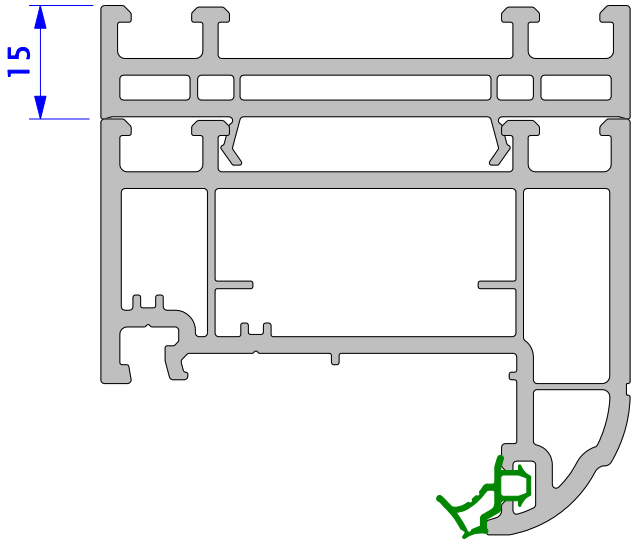
2. Measure between the two inserted corner seals , cut the 14140 threshold gasket to size and insert into the bottom of the door sash as shown.



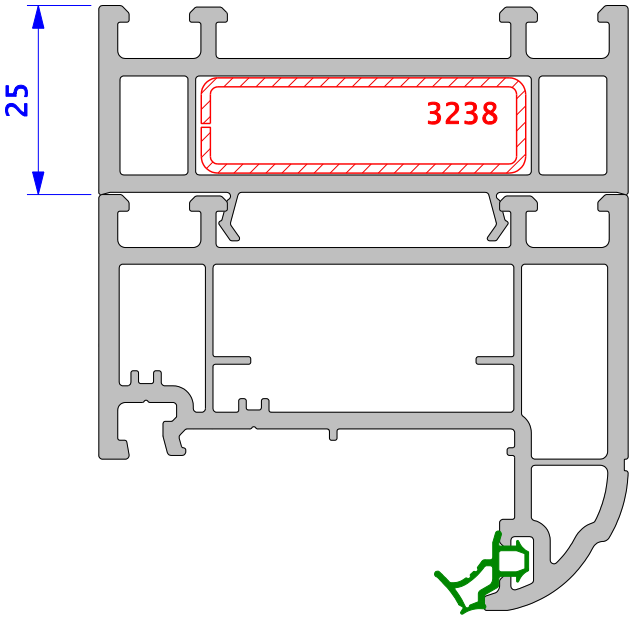
CROSS-SECTION
THROUGH ASSEMBLY

USE OF ACCESSORIES

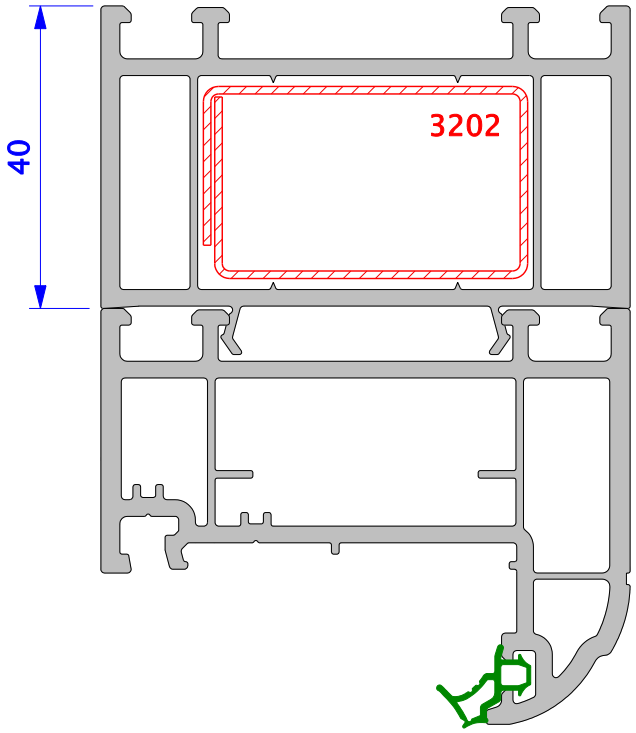
3336 – 15mm



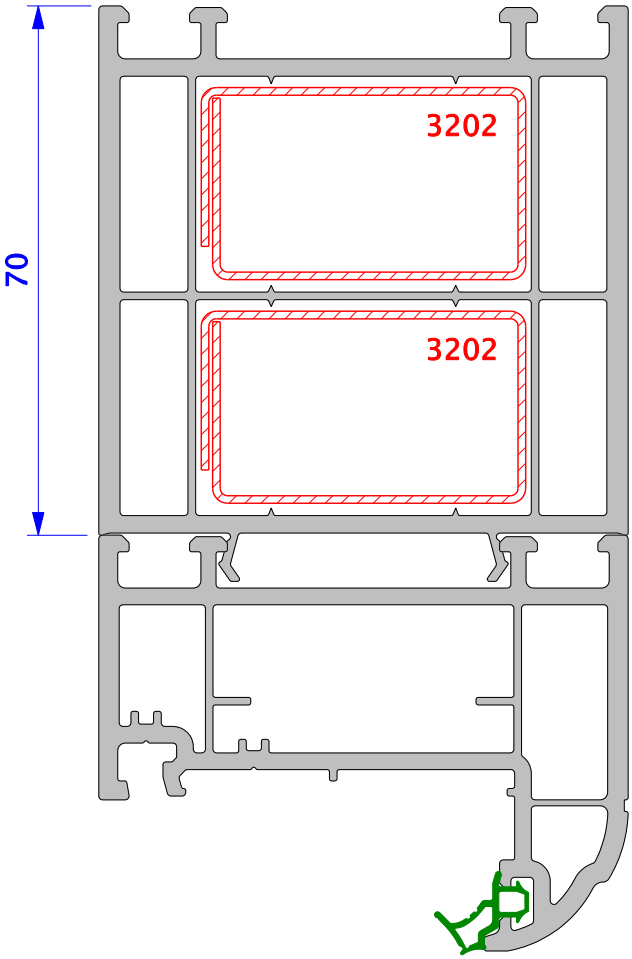
3300 – 25mm



3301 – 40mm

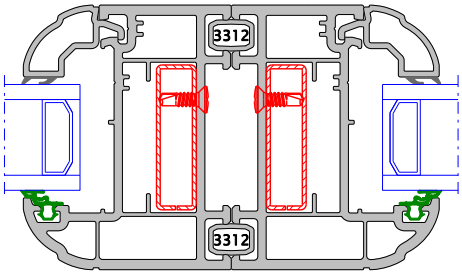


3302 – 70mm

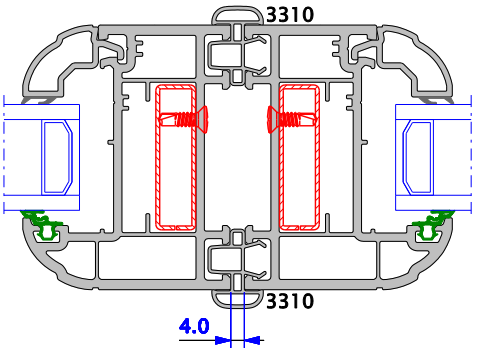


NOTE: At installation,ALL joints must be silicone sealed against the ingress of water.

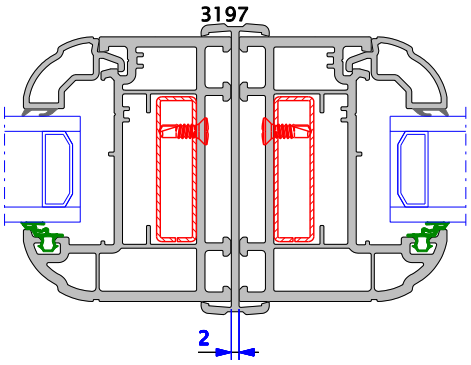
3312
2-Part Concealed Frame To Frame Coupler



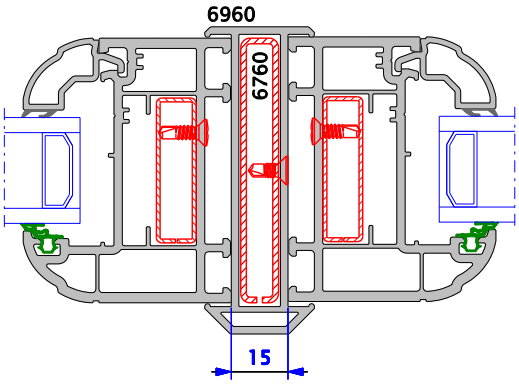
3310
2-Part Overlapping Frame To Frame Coupler



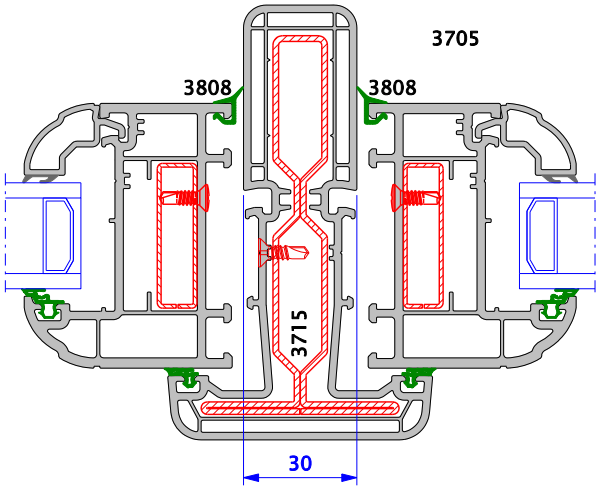
3197
Overlapping Frame To Frame Coupler



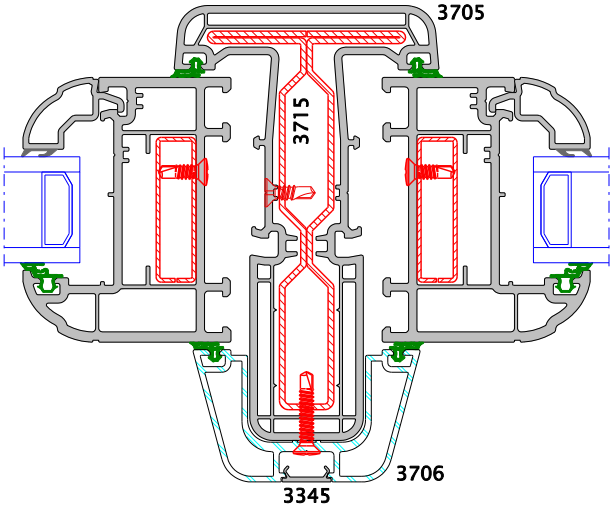
6960
Reinforced Frame to Frame Coupler



3705
Reinforced Frame To Frame Coupler
Option 1 - 3808 Seal



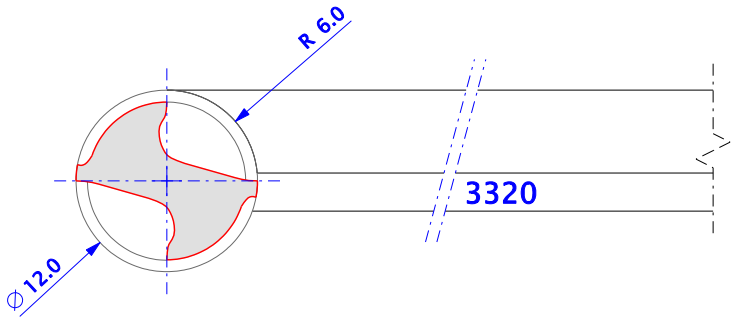
3705
Reinforced Frame To Frame Coupler
Option 2 - 3706 Pressure Plate



NOTE. We recommended that all relevant exposed joints are sealed on site with silicone against the ingress of water.

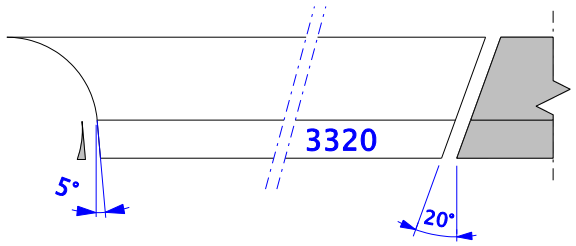
3320 Georgian Bar

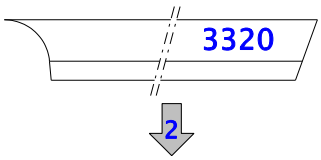
USE OF ACCESSORIES

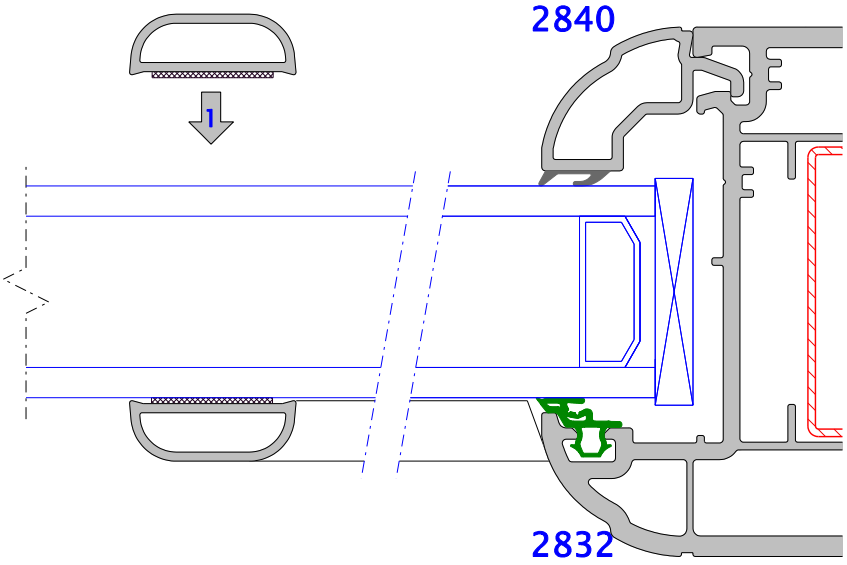


When using glazing beads other than the one ilustrated below, use the list showing the cut angle relating to each bead.

Bead	Cut Angle
3027	Square Cut
3028	5°
3029	6°
3033	Square Cut
3024	5°
3034	5°







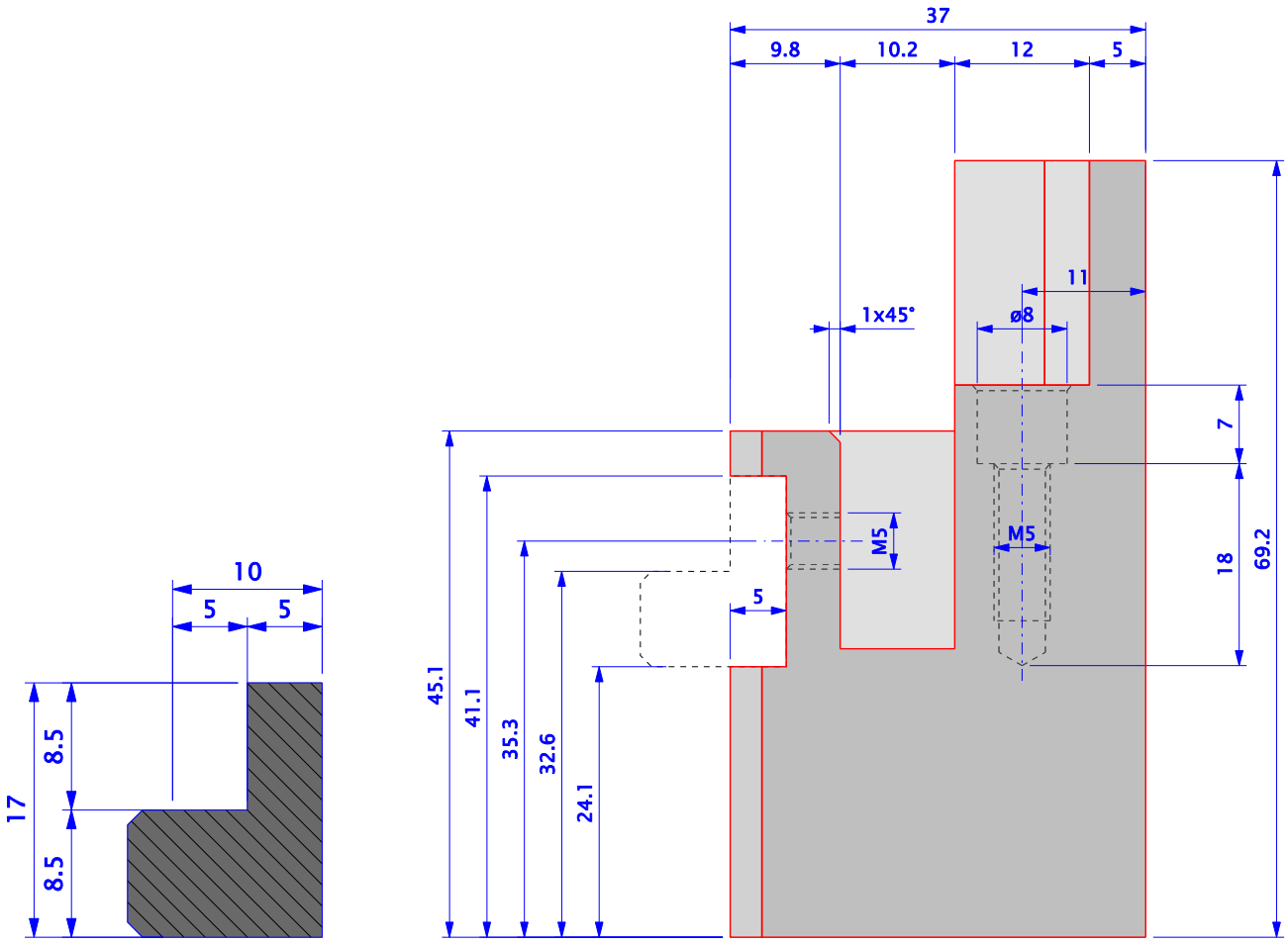
Application

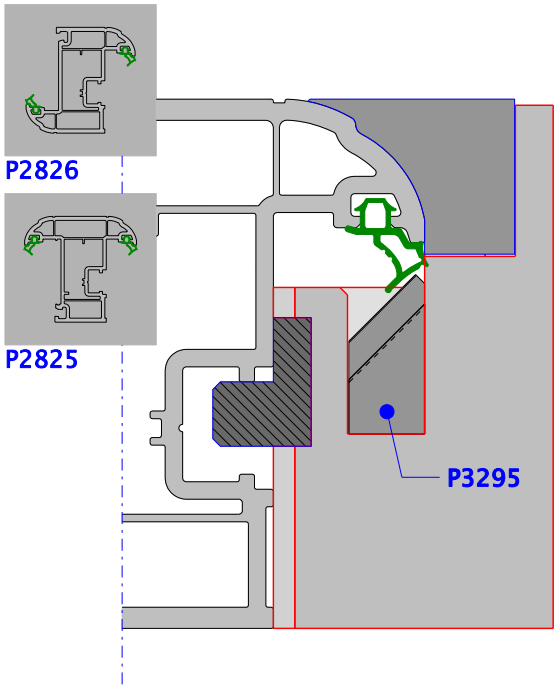
Ensure the glass is clean before applying the georgian bar.

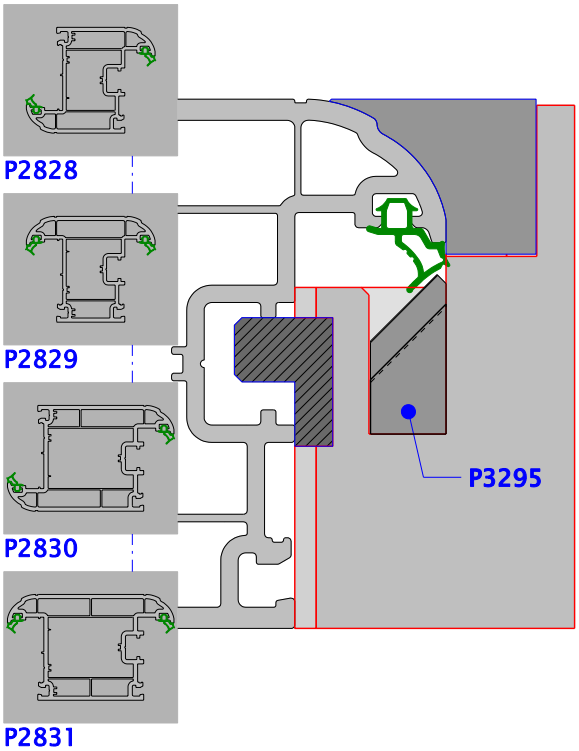
Use a 16.0mm x 1.0mm double sided tape to apply the georgian bar to the glass.

Welding support blocks

P2825/P2826/P2828/P2829/P2830/P2831 (OPTION 1)

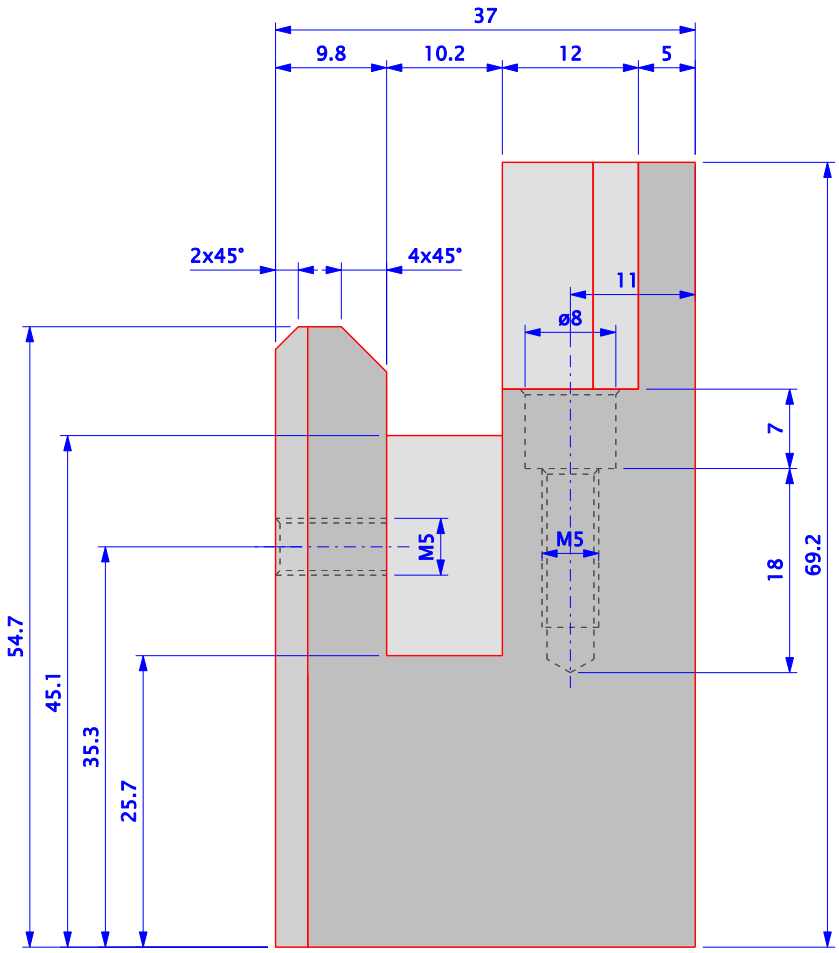


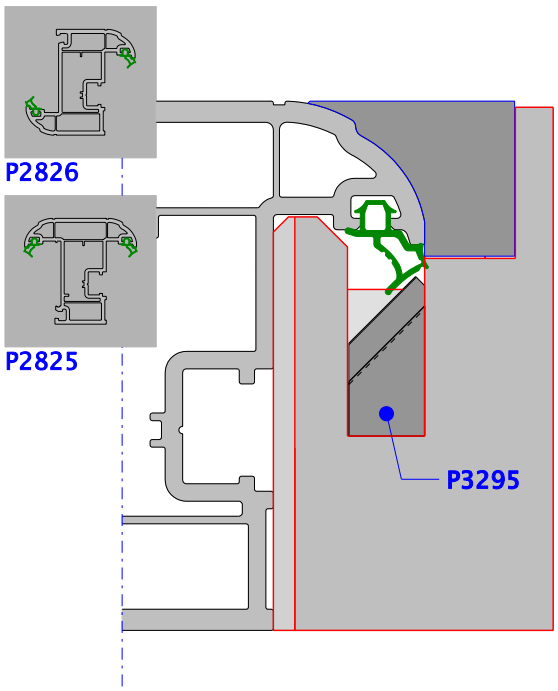


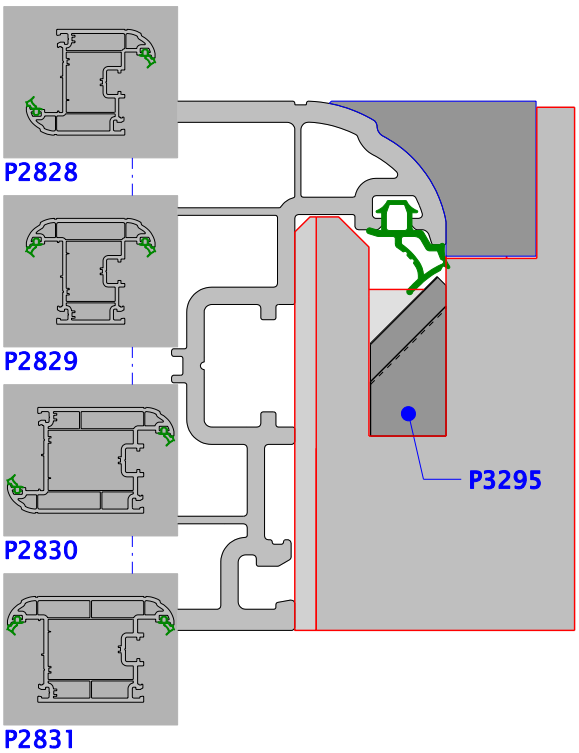


Welding support blocks

P2825/P2826/P2828/P2829/P2830/P2831(OPTION 2)

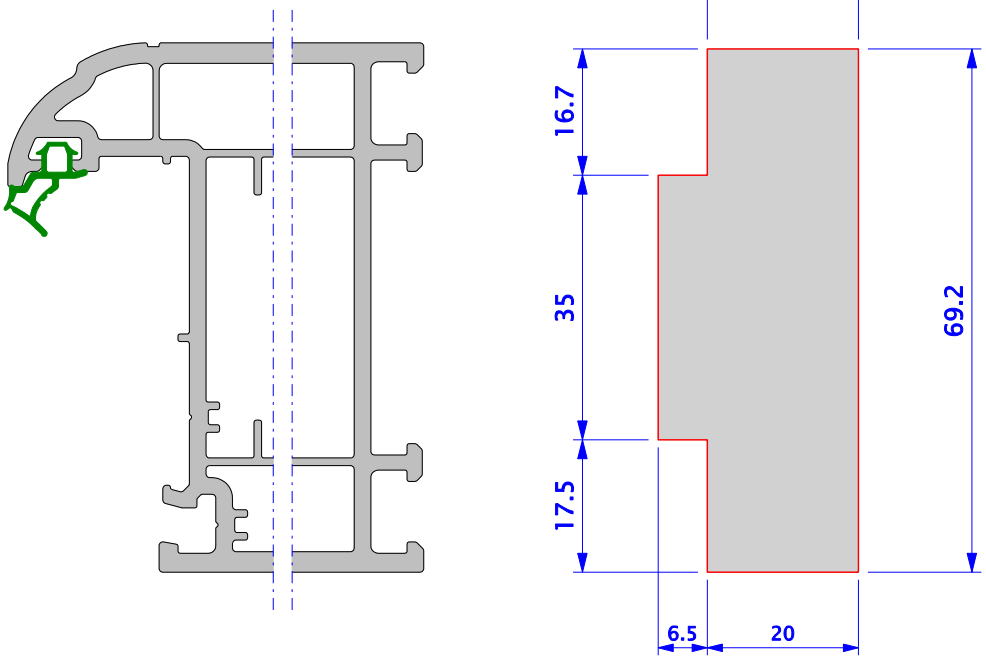






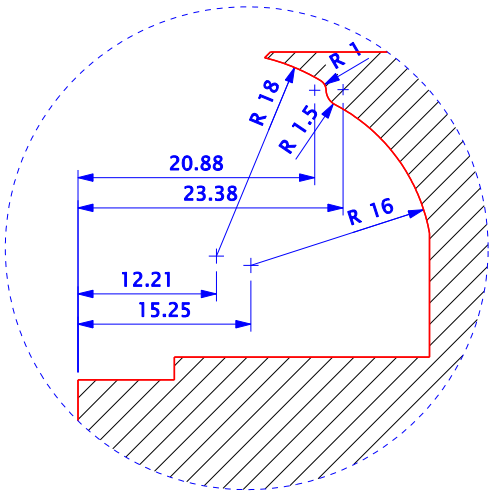
Welding support blocks

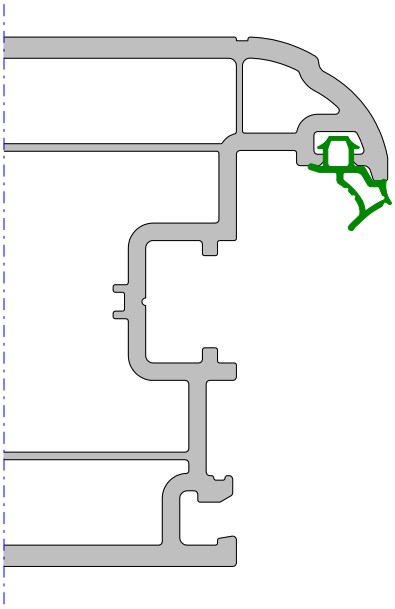
Frame – 2832/2833/2822

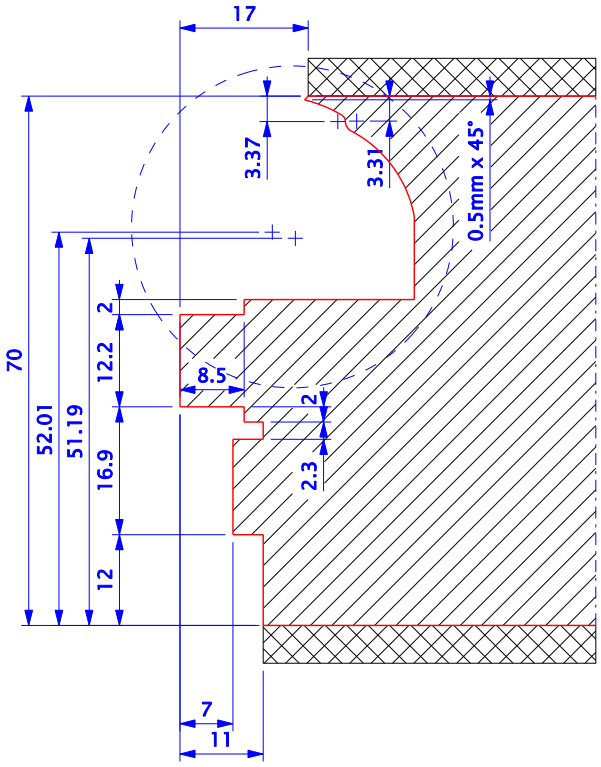


Corner cleaning

Sash - 2828/2829/2830/2831

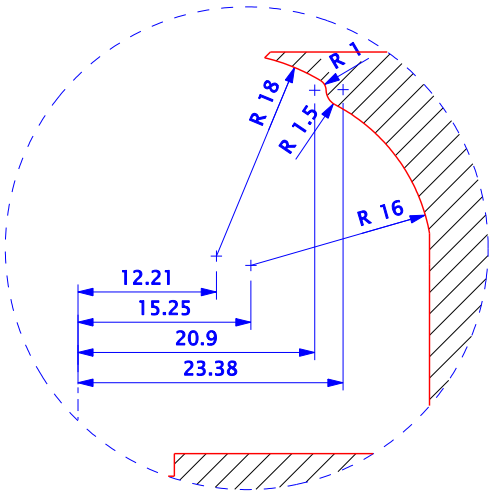


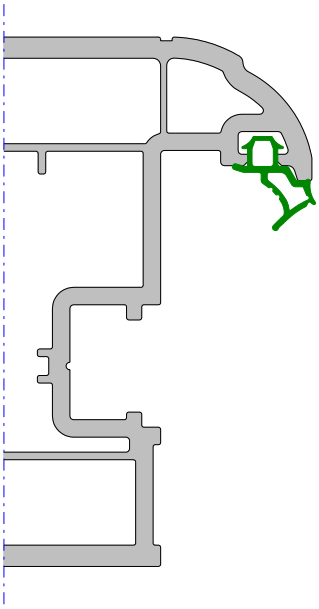


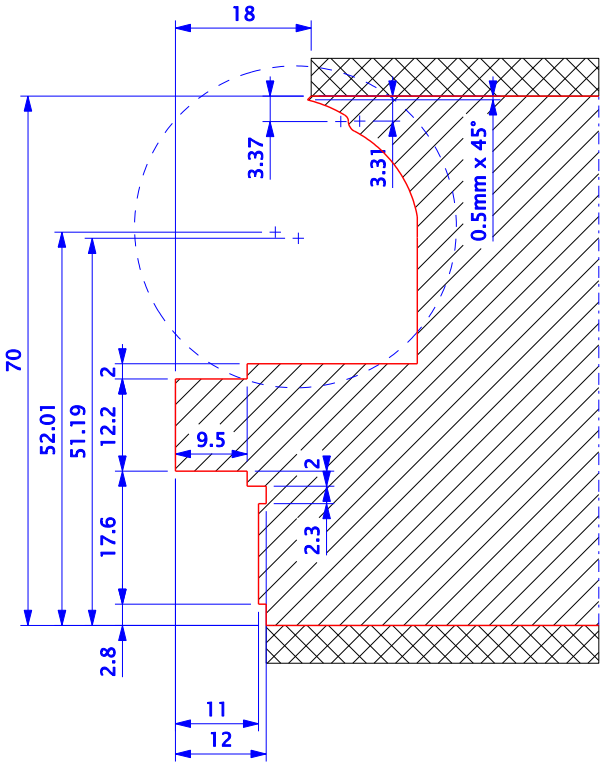


Corner cleaning

Sash - 2825/2826

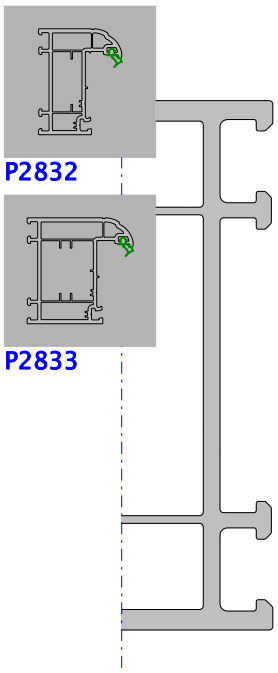


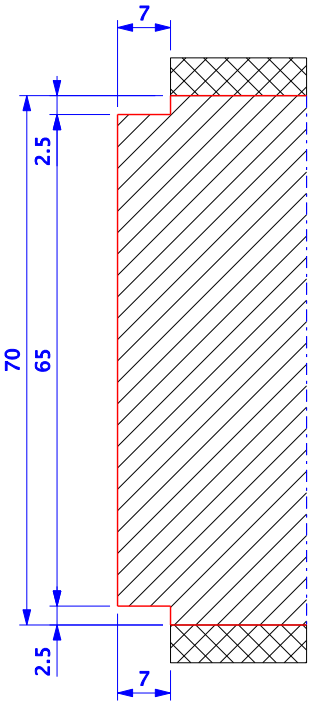


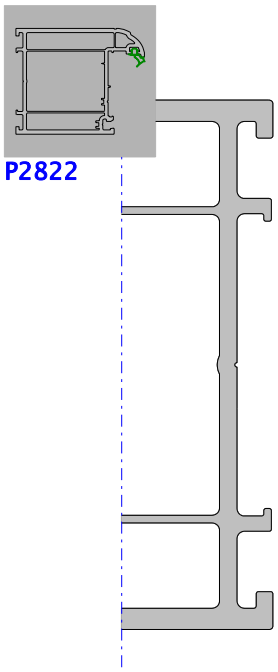


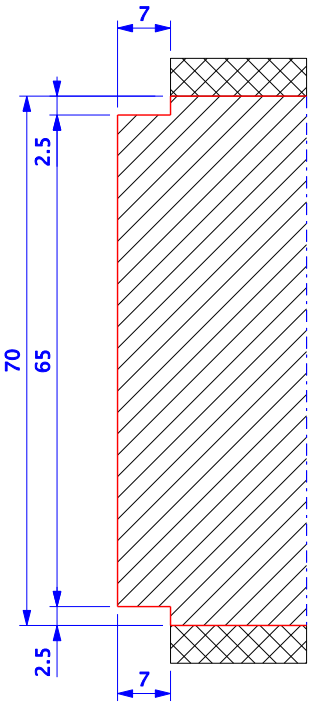
Corner cleaning

Frame – 2832/2833/2822



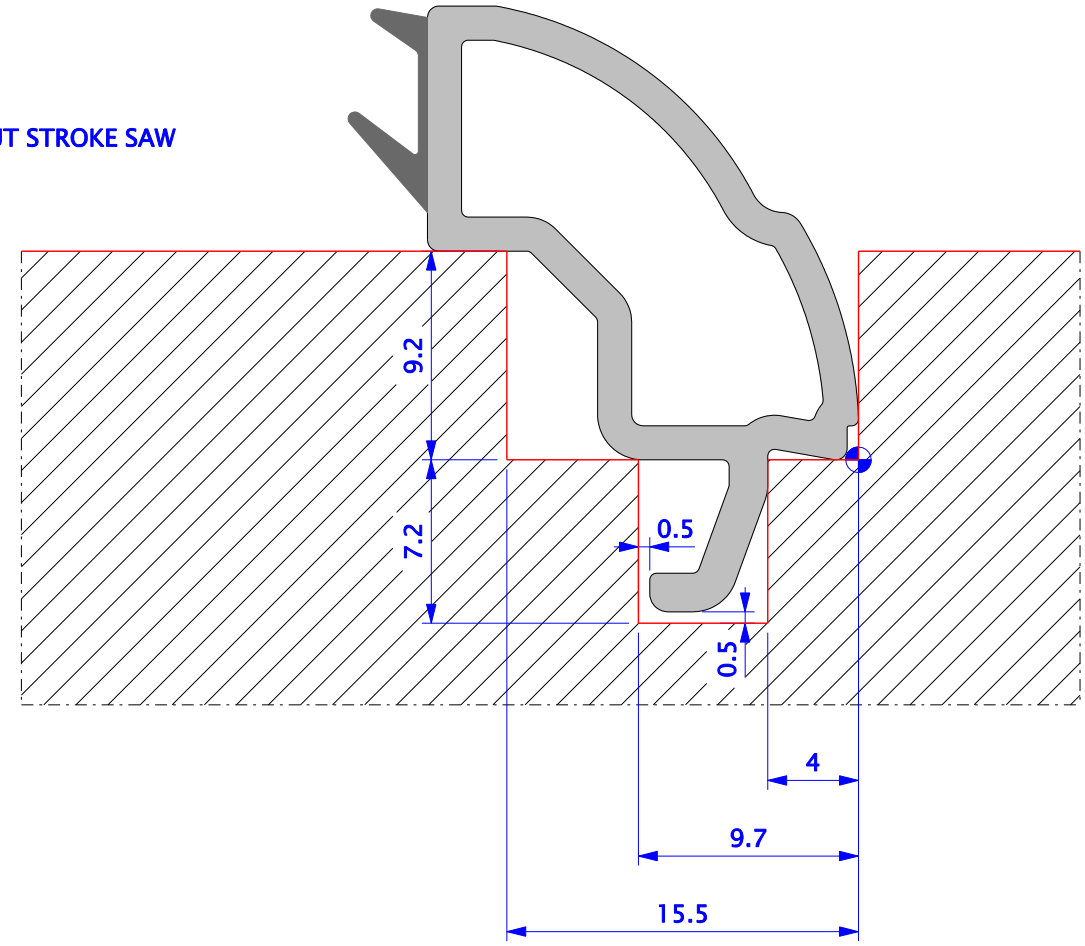




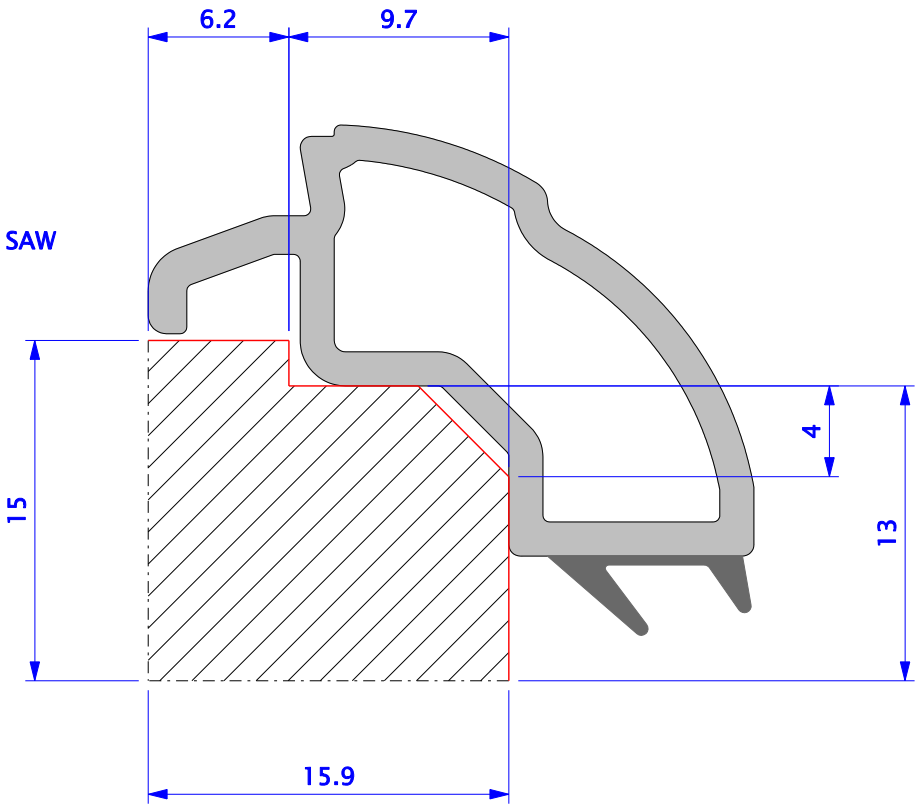


Glazing bead support for saw

OUT STROKE SAW

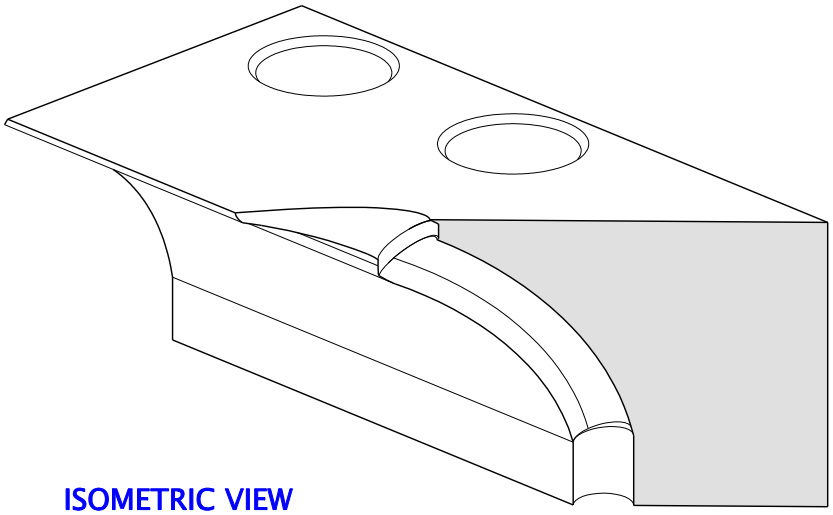


DOWN STROKE SAW



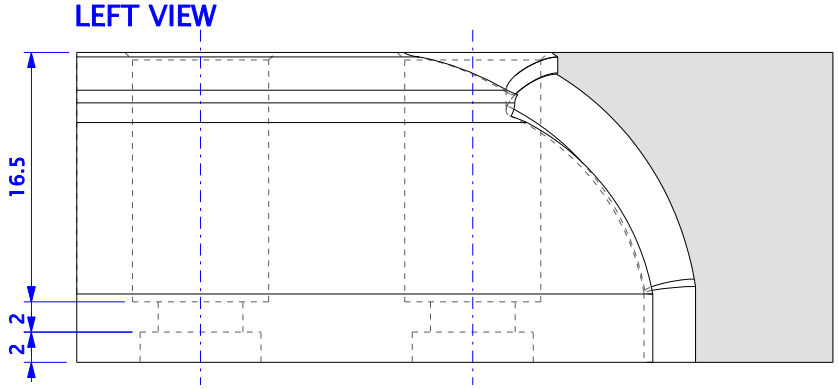
Welding support blocks

Design restrictor

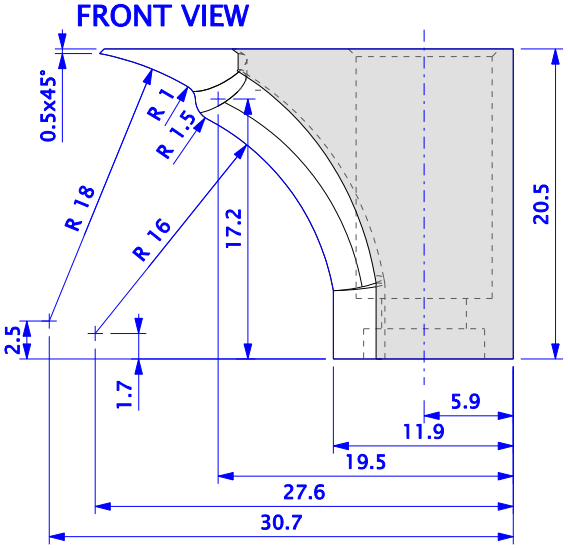


ISOMETRIC VIEW

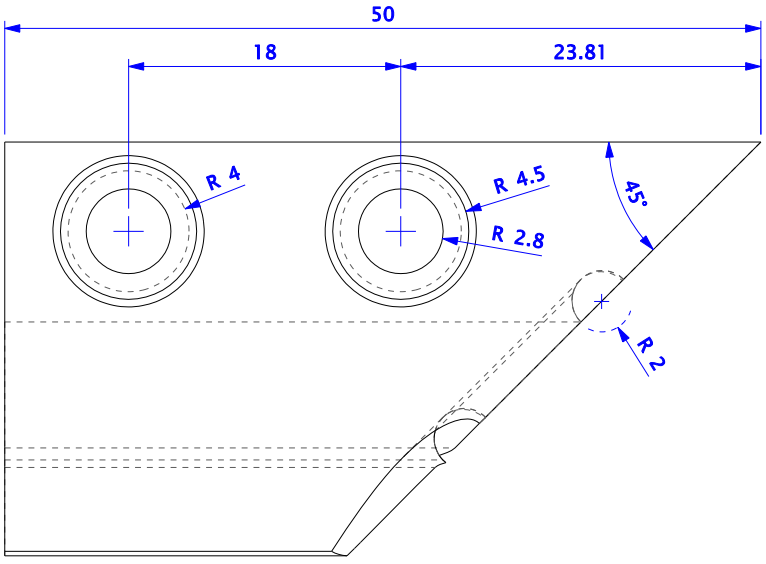
LEFT VIEW



FRONT VIEW

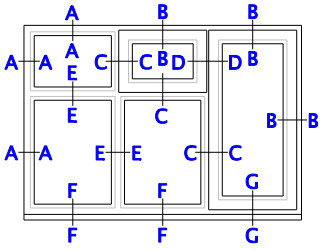


TOP VIEW

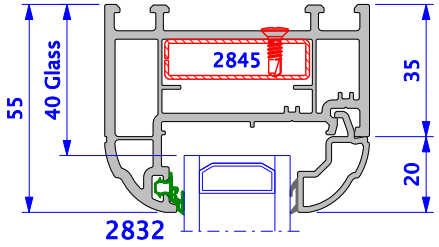


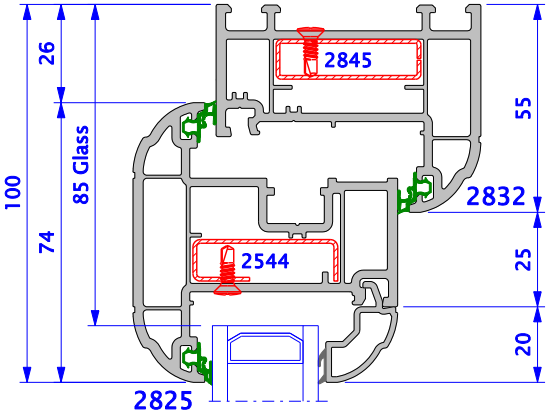
Internally Beaded Casement
Small Outer Frame

WINDOW SECTIONS

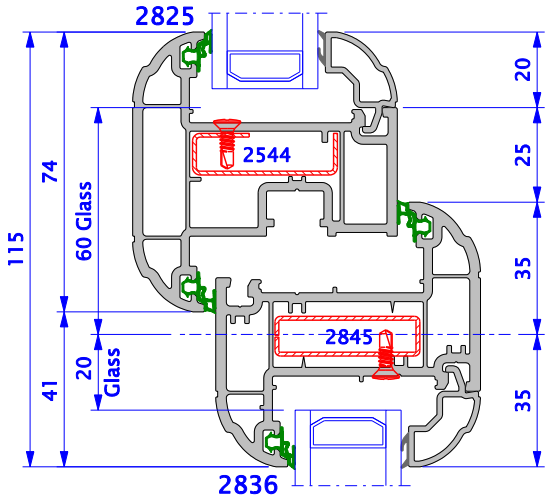


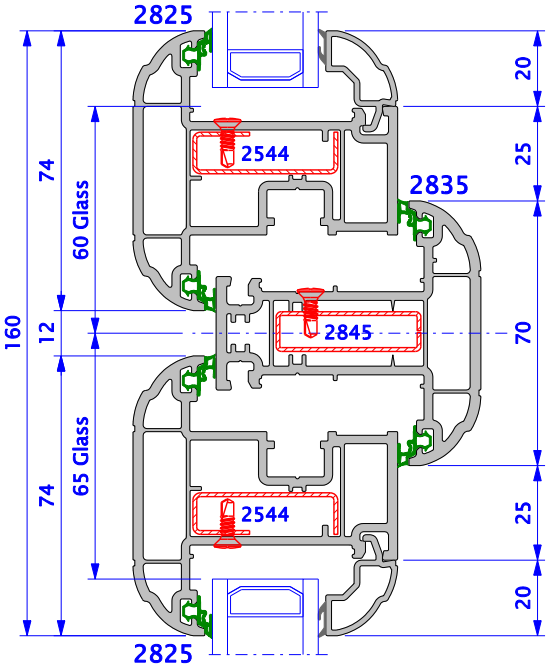
Section A-A



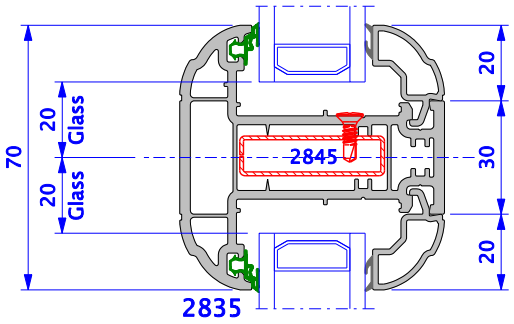


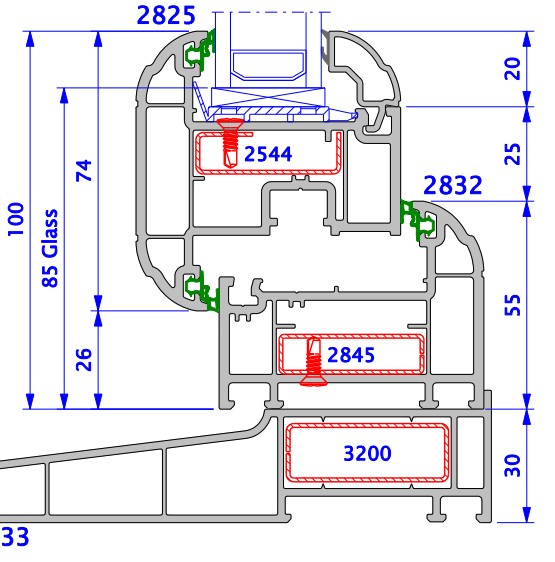
Section C-C



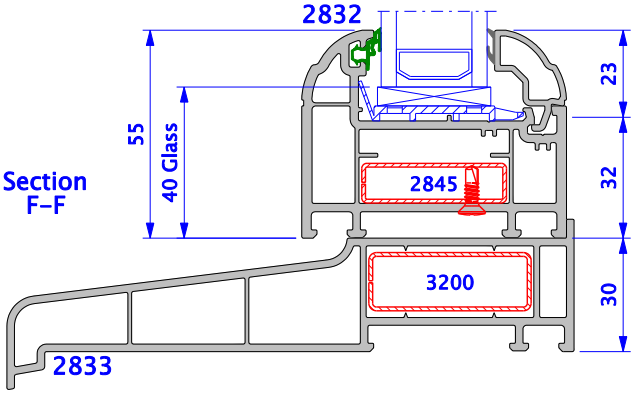


Section E-E

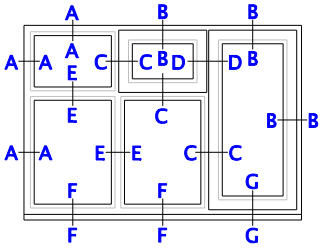




Section F-F

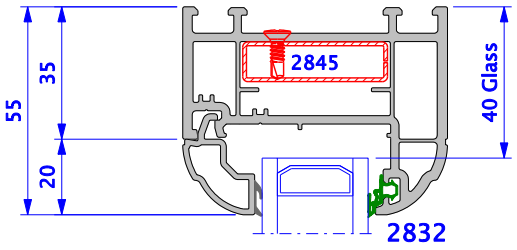


Externally Beaded Casement
Small Outer Frame

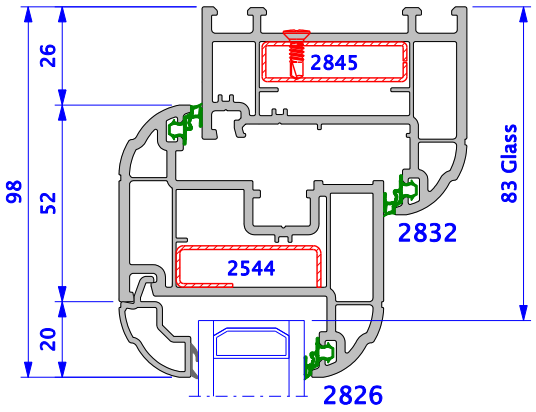


WINDOW SECTIONS

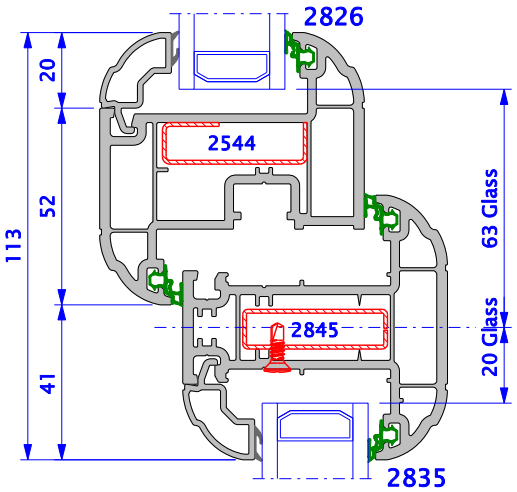
Section A–A



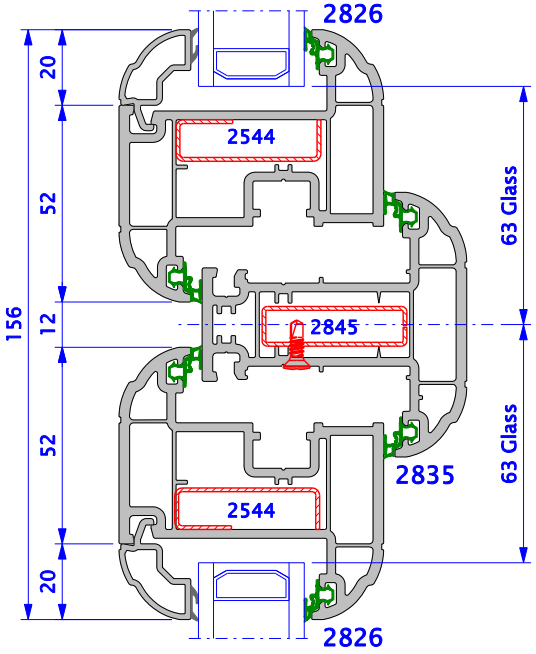
Section B–B



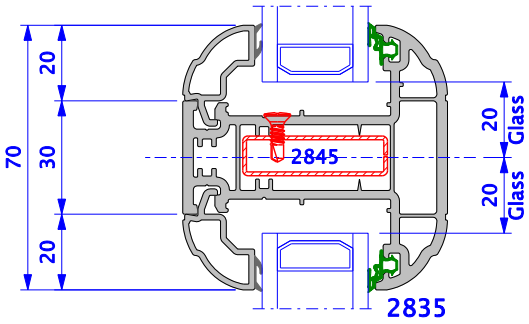
Section C–C



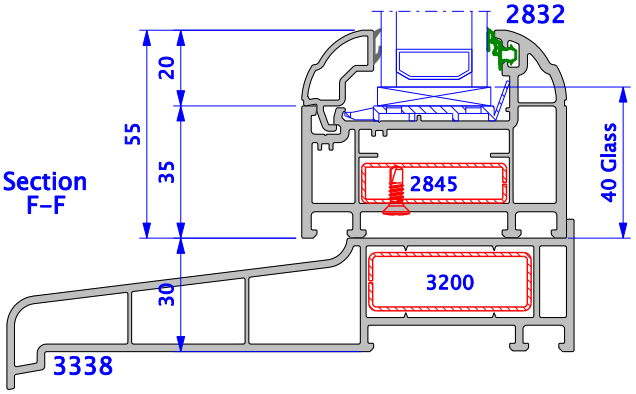
Section D–D



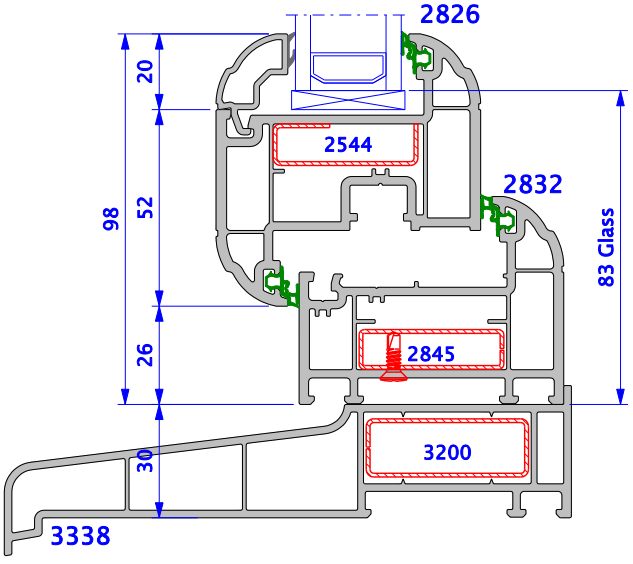
Section E–E



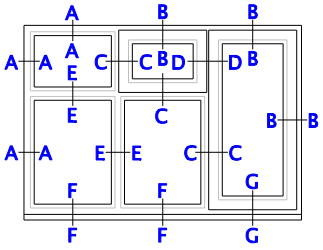
Section F–F



Section G–G

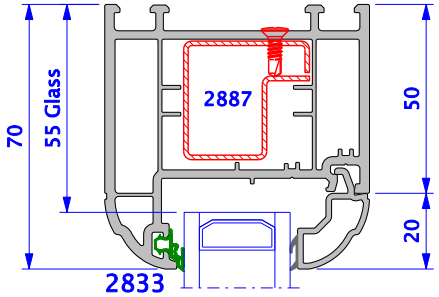


Internally Beaded Casement
Large Outer Frame

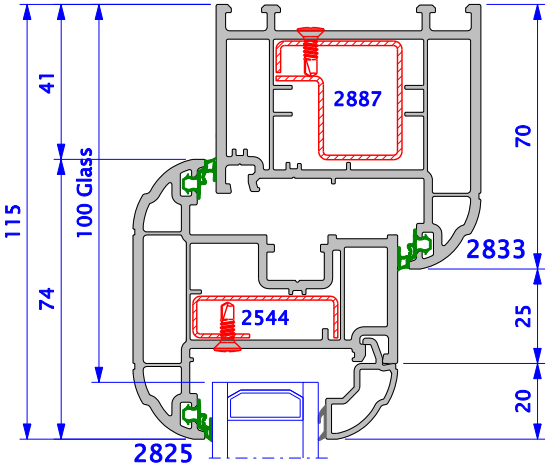


WINDOW SECTIONS

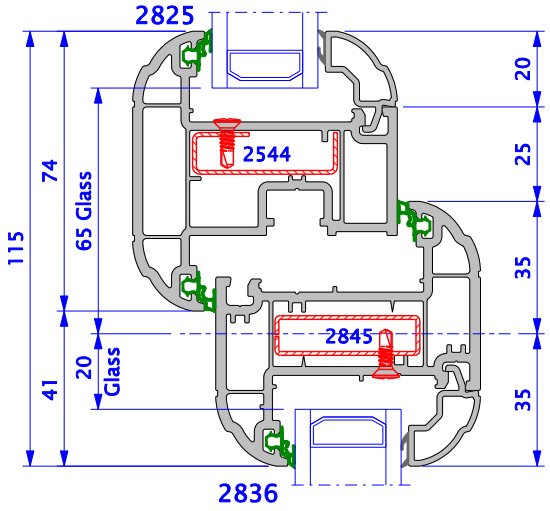
Section A–A



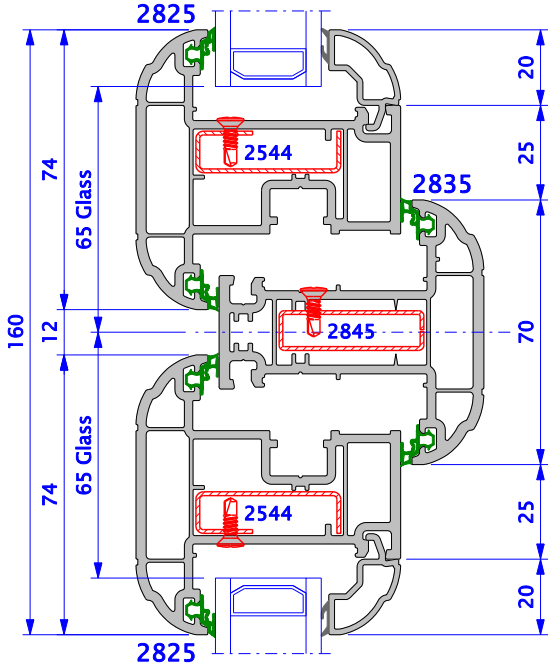
Section B–B



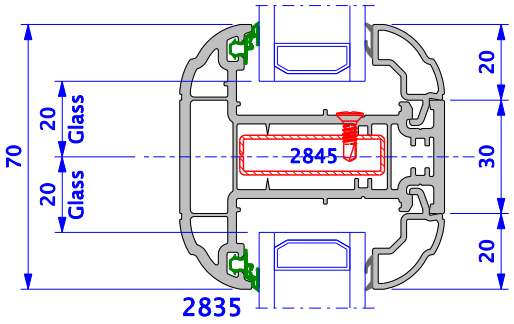
Section C–C



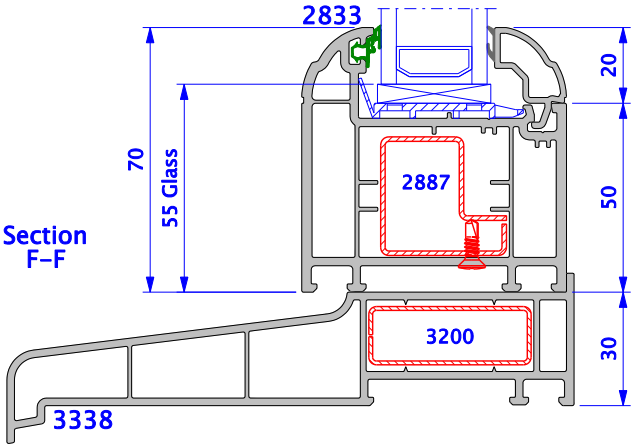
Section D–D



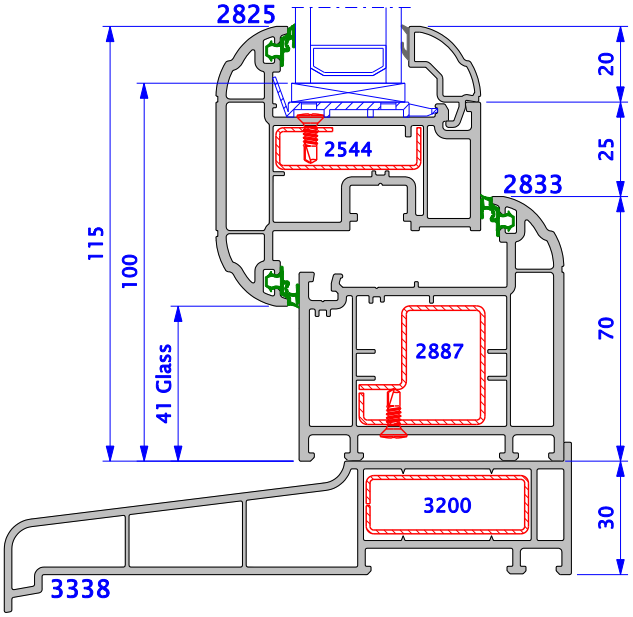
Section E–E



Section F–F

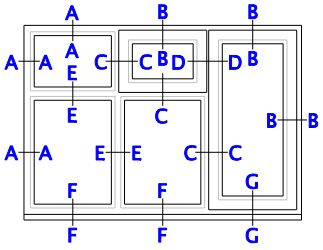


Section G–G

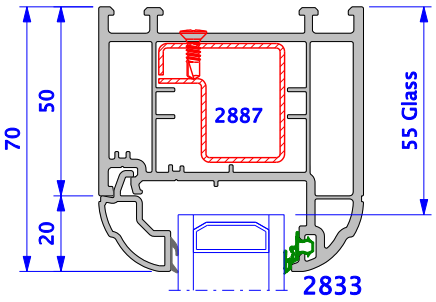


WINDOW SECTIONS

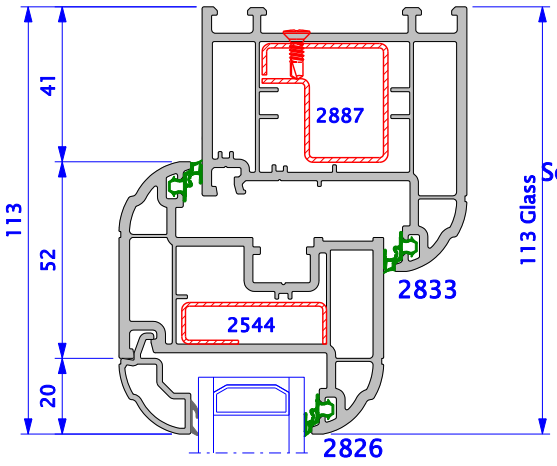
Externally Beaded Casement
Large Outer Frame



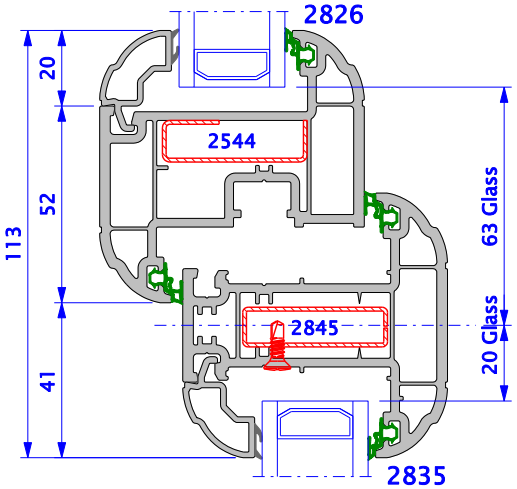
Section A–A



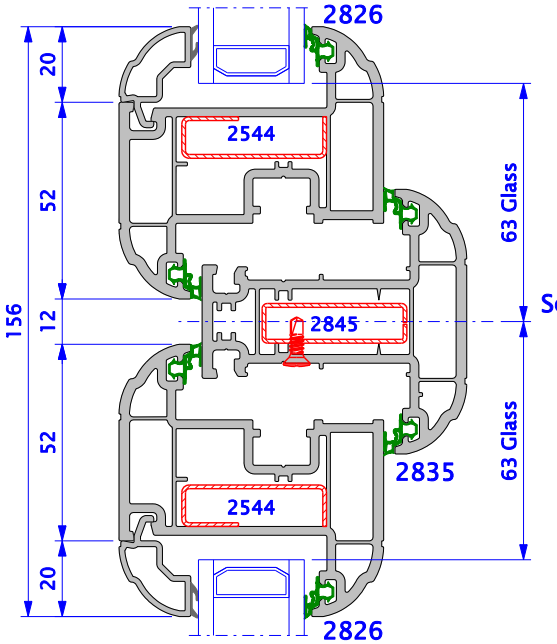
Section B–B



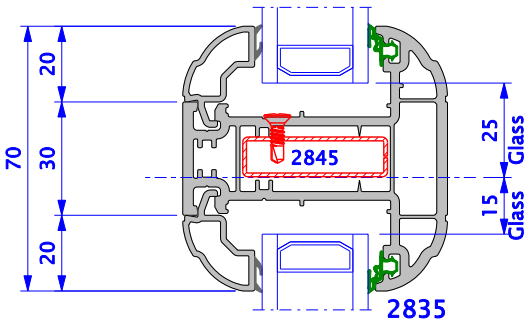
Section C–C



Section D–D



Section E–E



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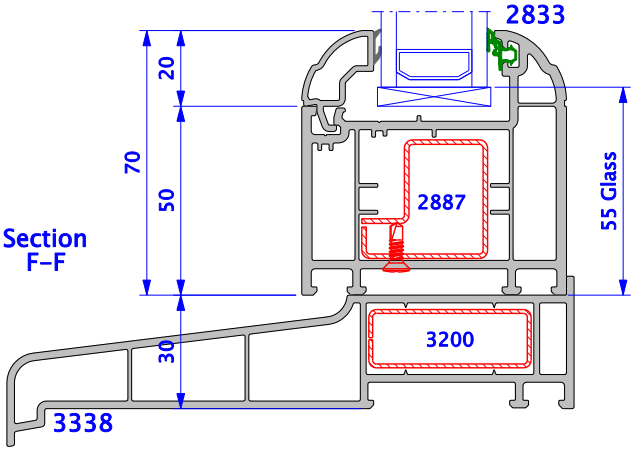
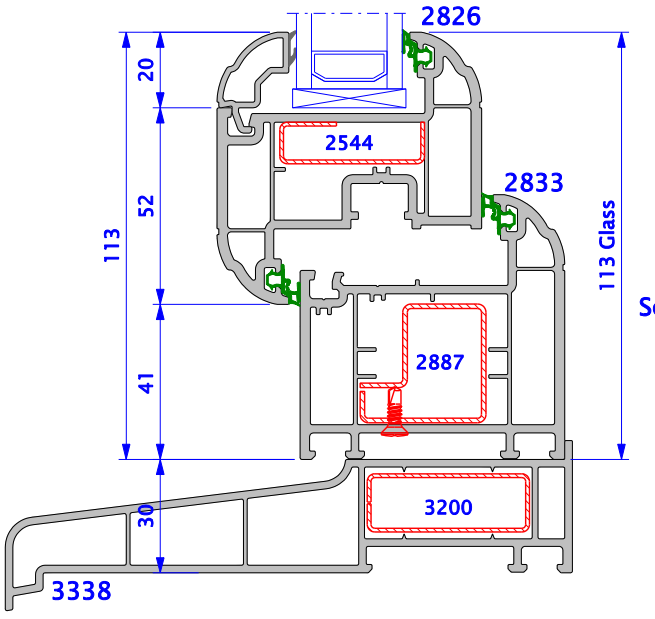
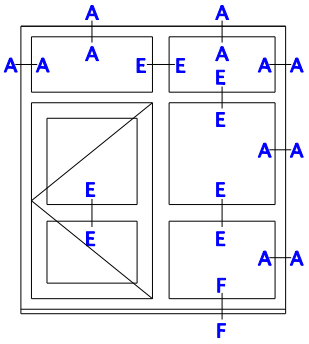


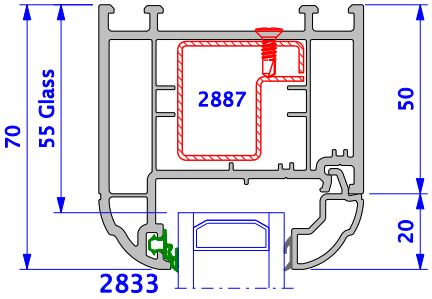
Section G–G



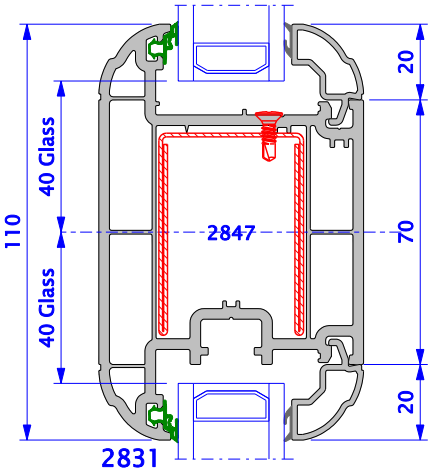
Open-In Doors (Fixed Sections)

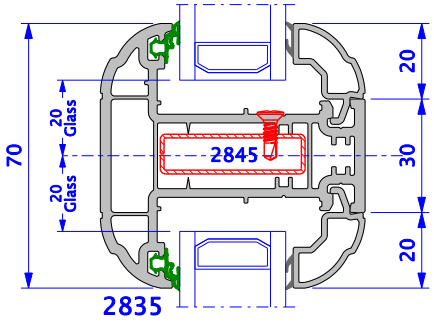


Section A-A



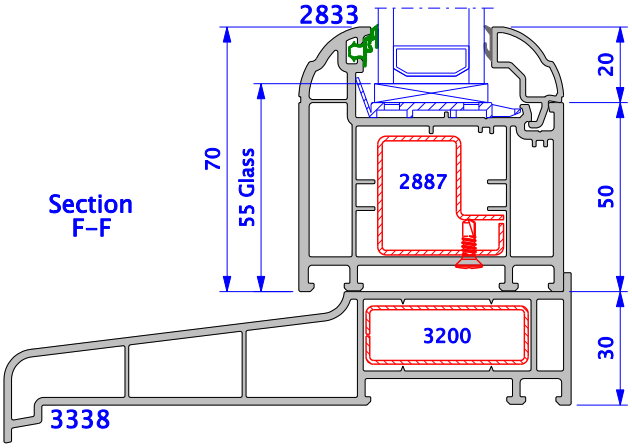
Section E-E



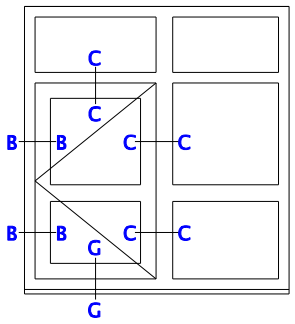


Section E-E

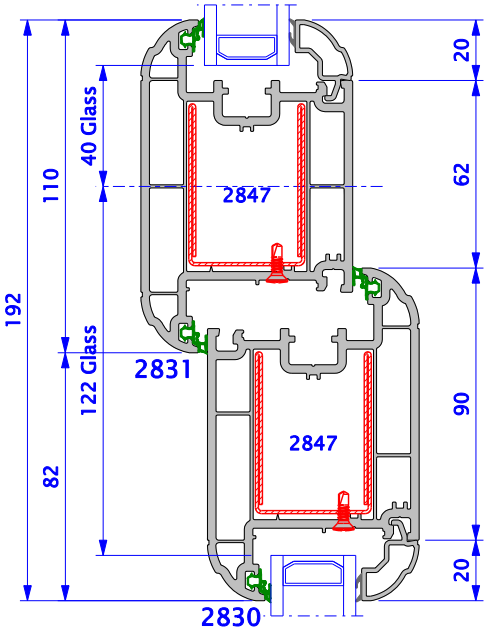
Section F-F



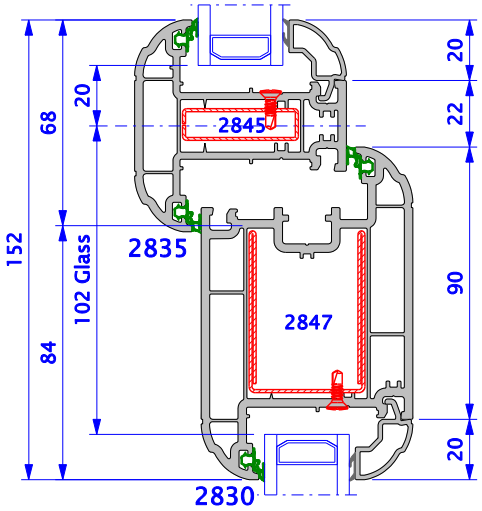
Open-In Doors (Sash Sections)



Section C-C



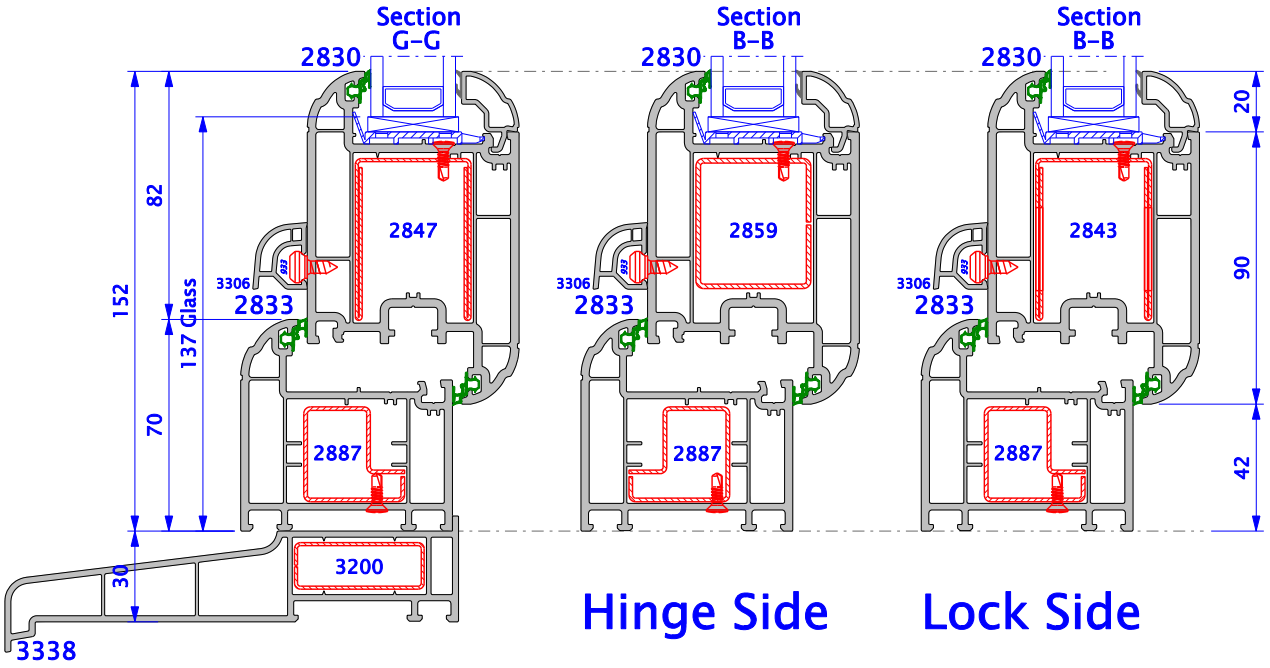
Section C-C



Section G-G

Section B-B

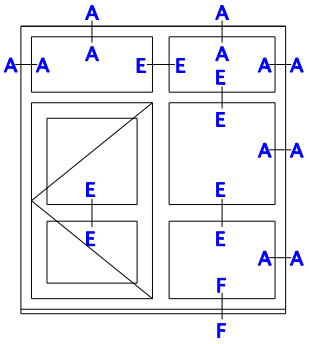
Section B-B



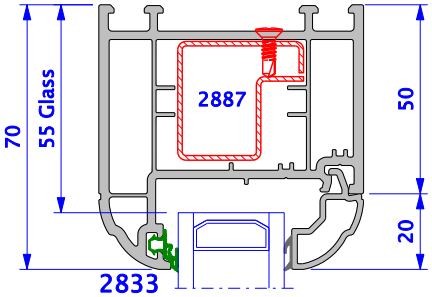
Hinge Side

Lock Side

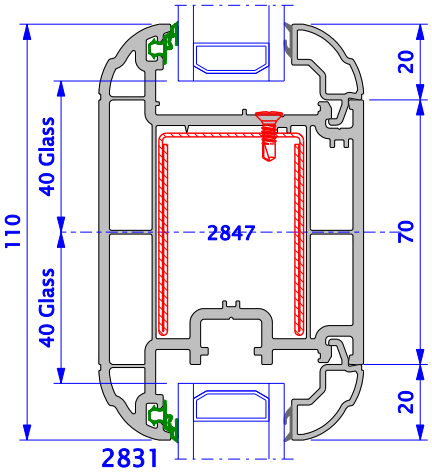
Open-Out Doors (Fixed Sections)

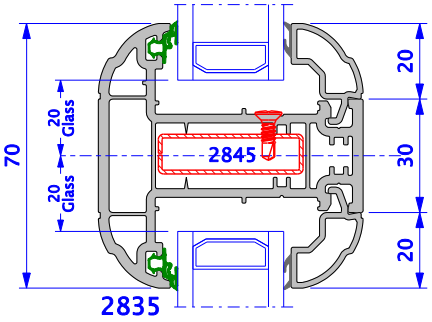


Section A-A



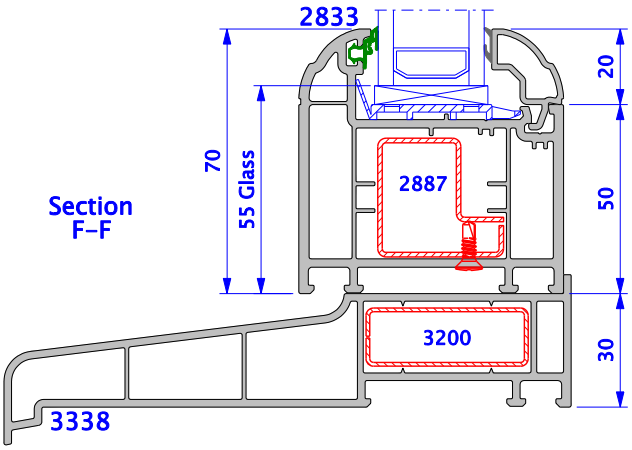
Section E-E



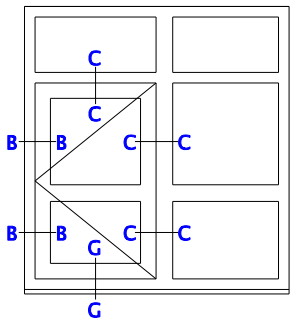


Section E-E

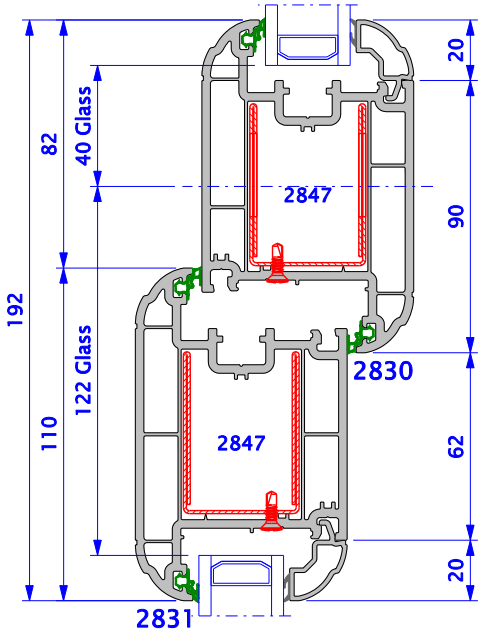
Section F-F



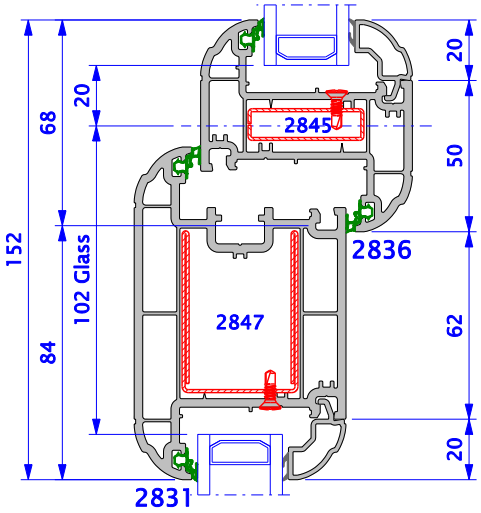
Open-Out Doors (Sash Sections)



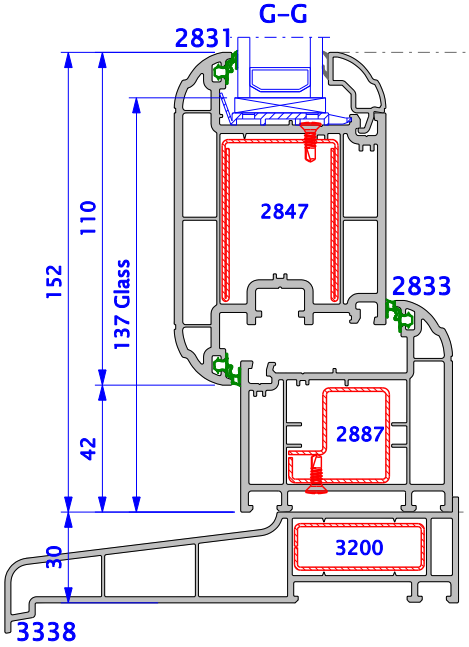
Section C-C



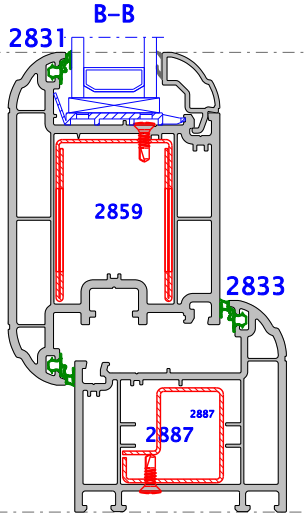
Section C-C



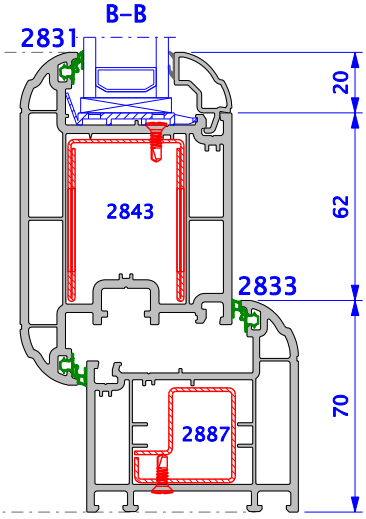
Section G-G



Section B-B

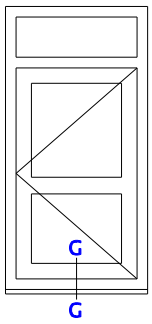


Section B-B

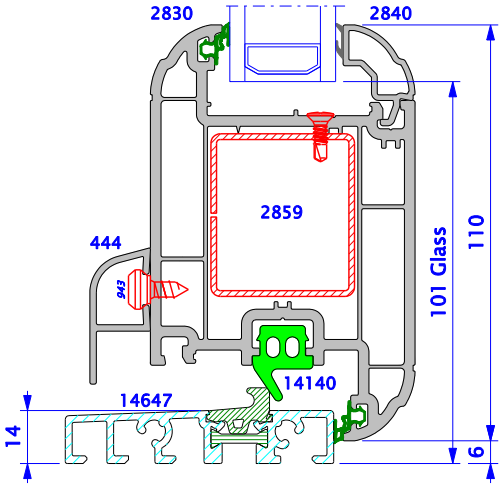


Hinge Side

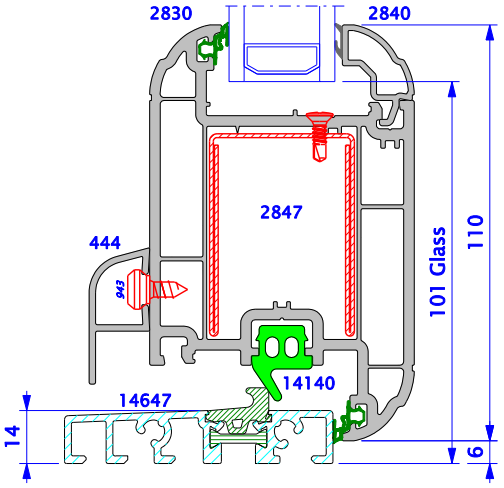
Lock Side



Open-In

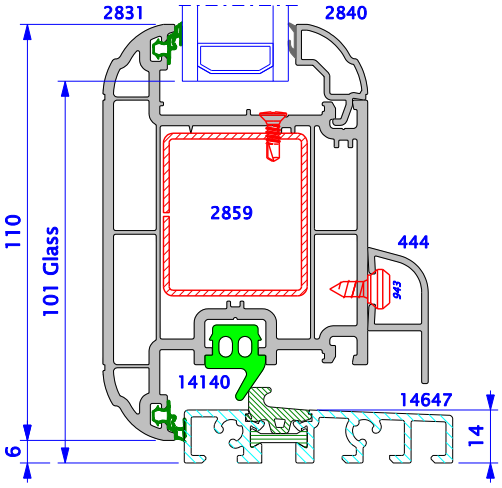


Reinforcement Option A

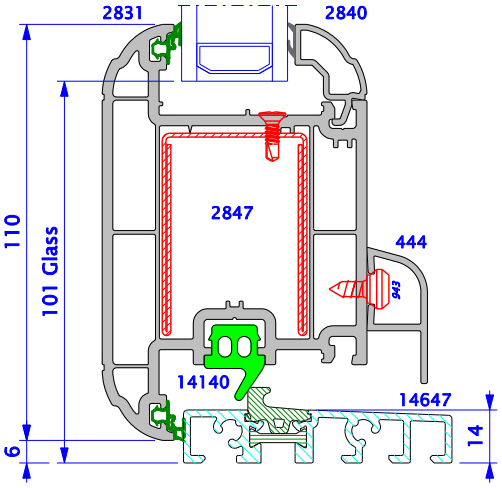


Reinforcement Option B

Open-Out



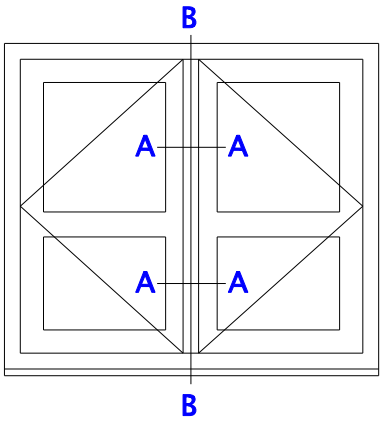
Reinforcement Option A



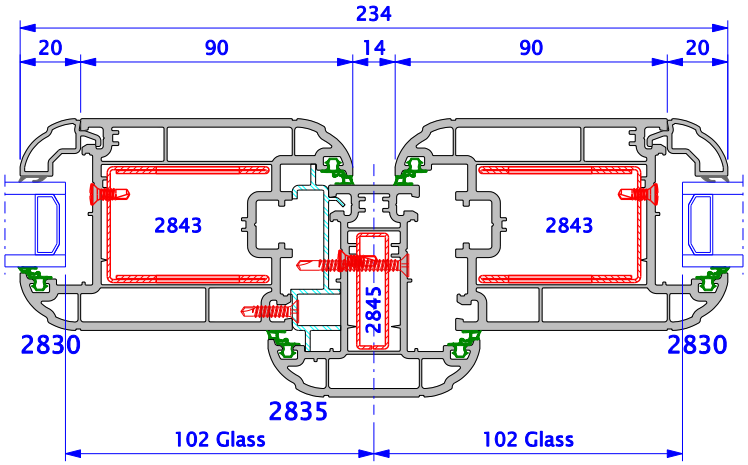
Reinforcement Option B

WINDOW SECTIONS

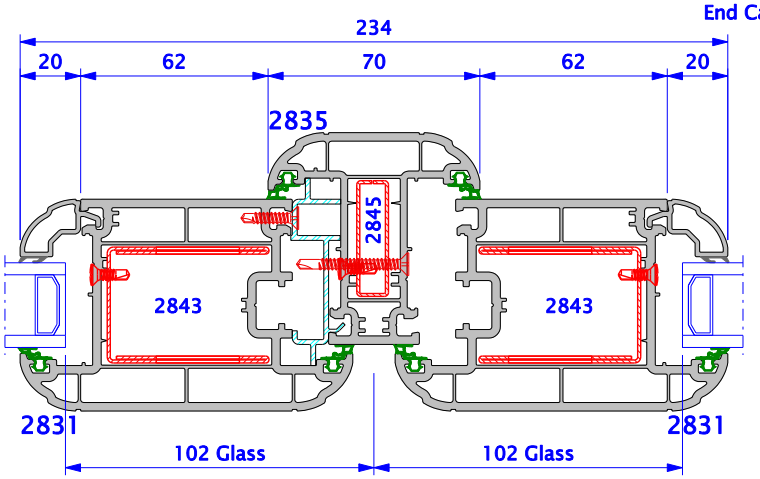
Double Doors



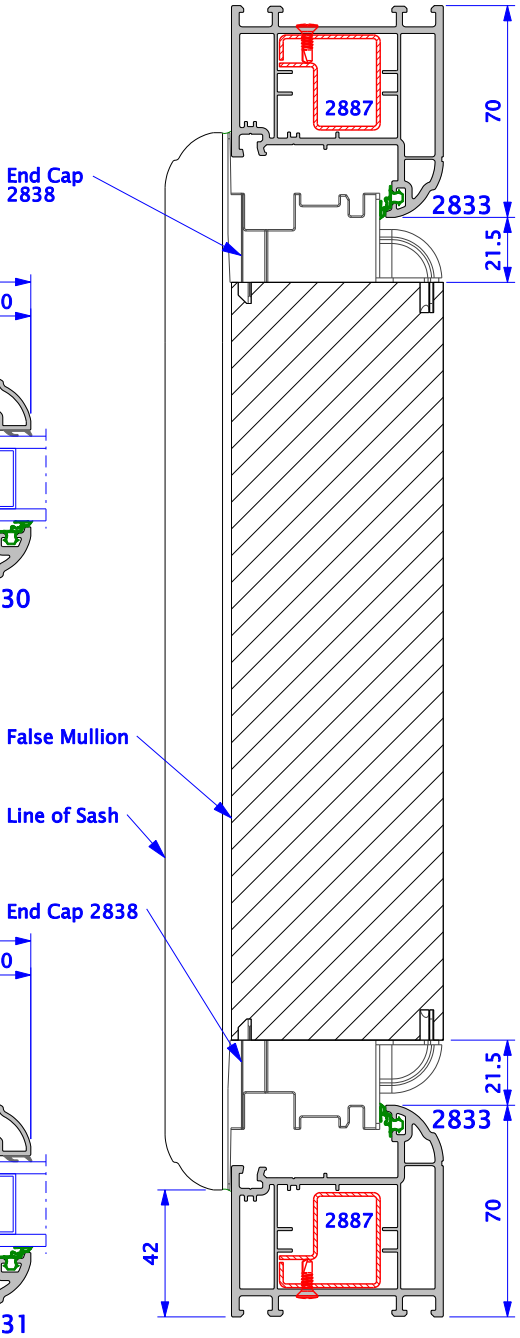
Section A–A



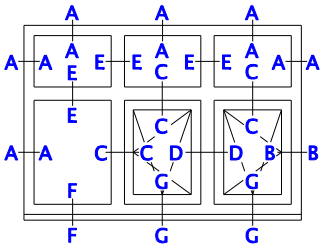
Section A–A



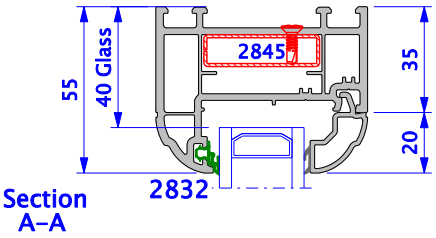
Section B–B



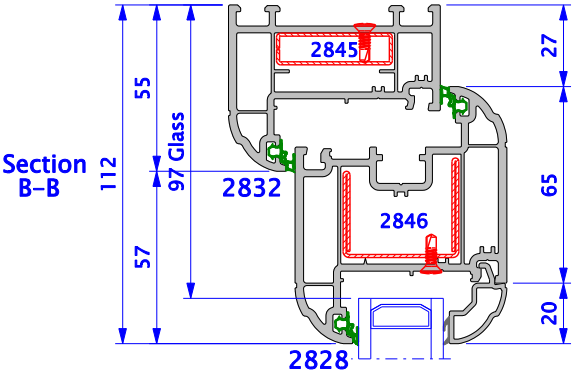
Tilt & Turn
Small Outer Frame



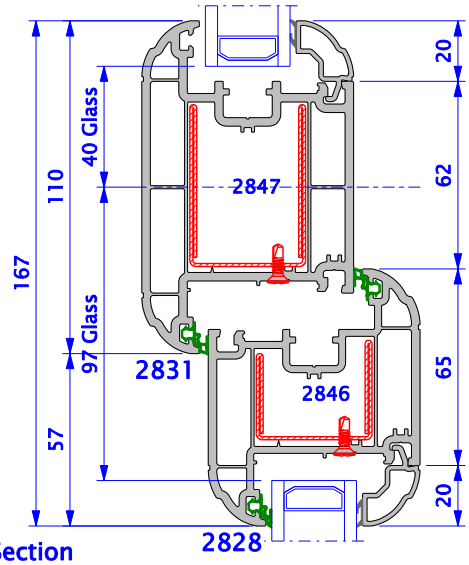
WINDOW SECTIONS



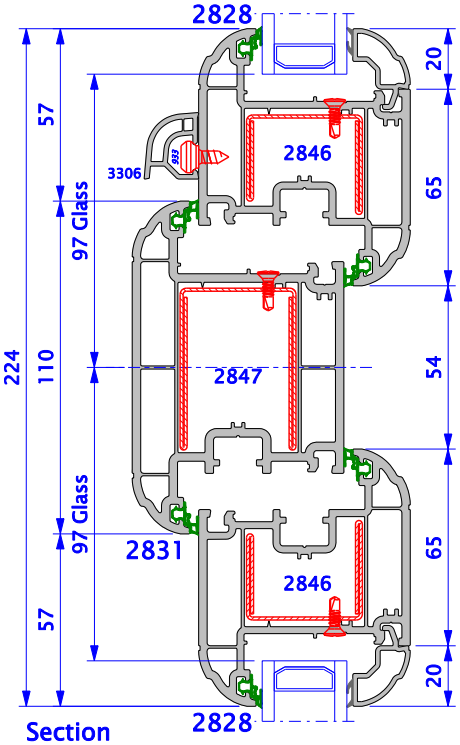
Section A–A



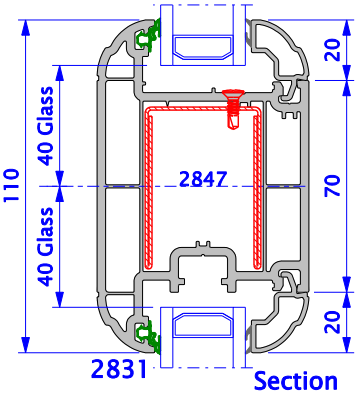
Section B–B



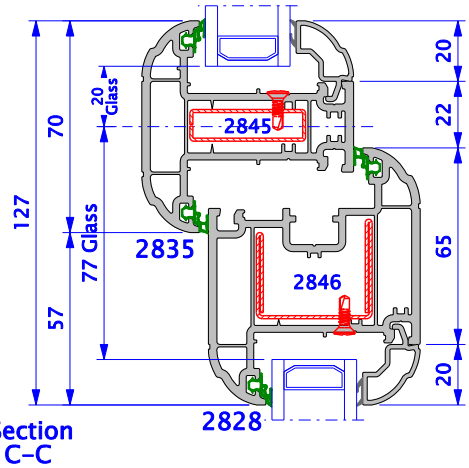
Section C–C



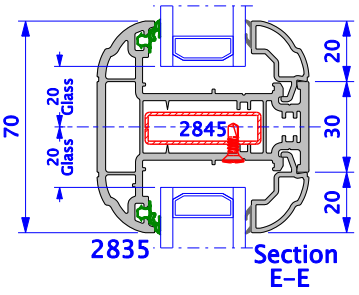
Section D–D



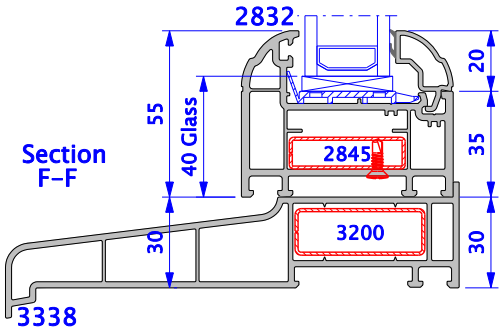
Section E–E



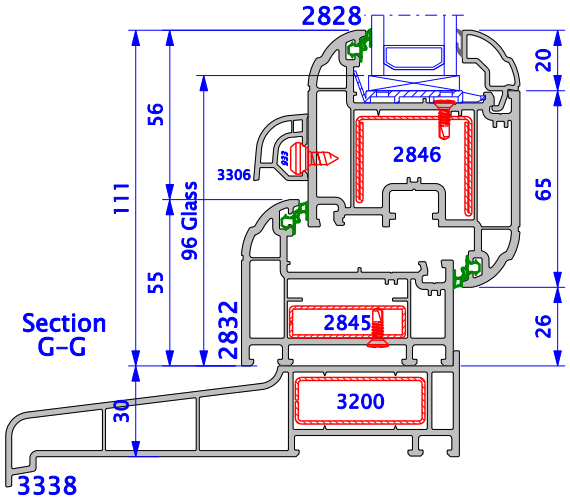
Section C–C



Section E–E

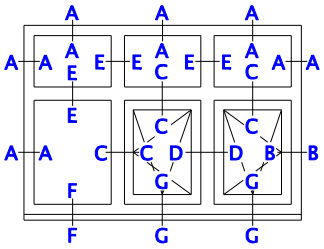


Section F–F

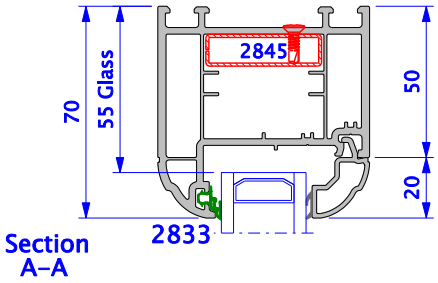


Section G–G

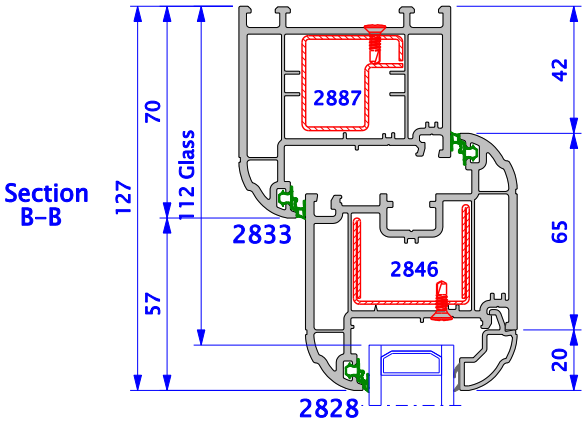
Tilt & Turn
Large Outer Frame



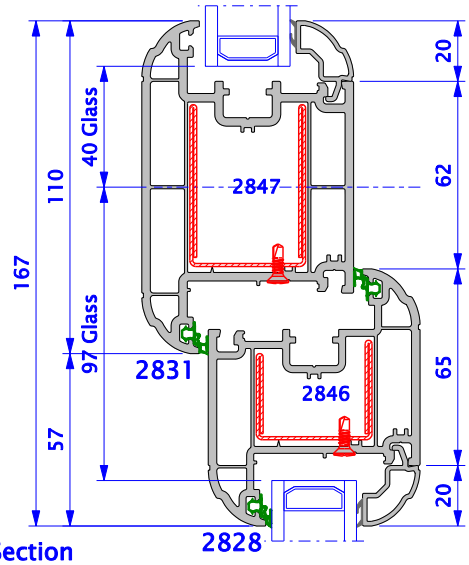
WINDOW SECTIONS



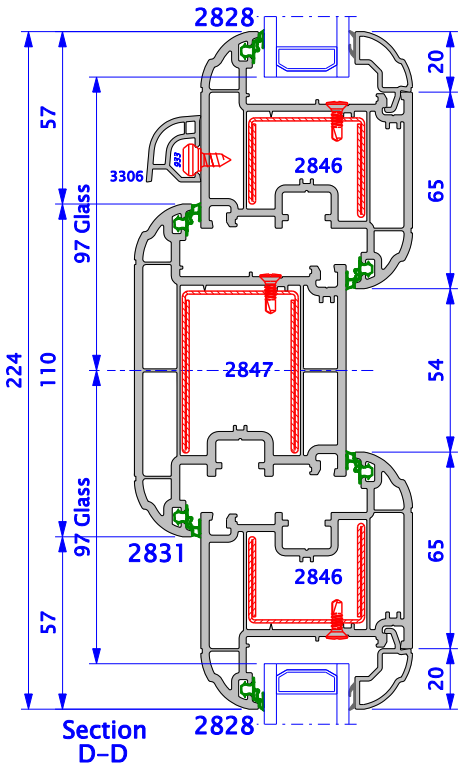
Section A–A



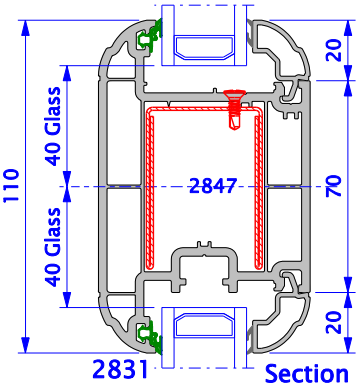
Section B–B



Section C–C



Section D–D



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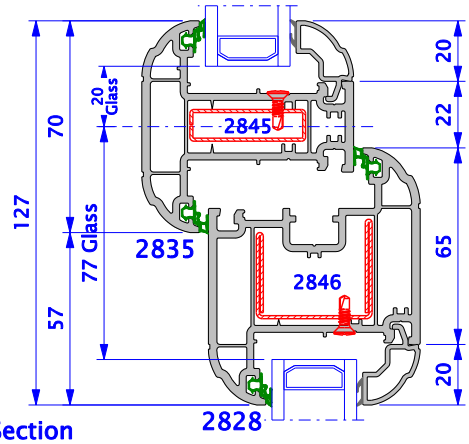

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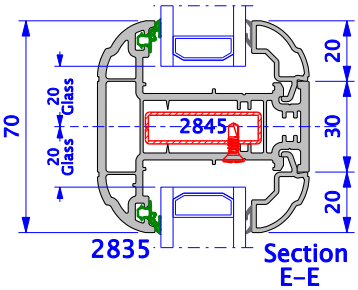

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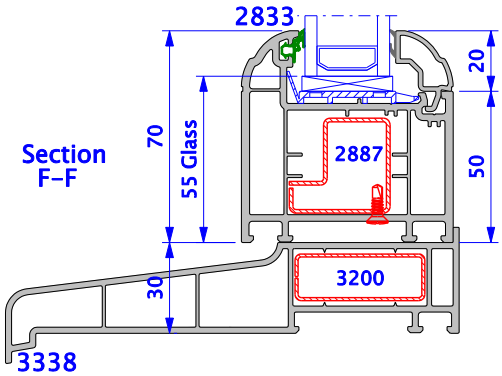

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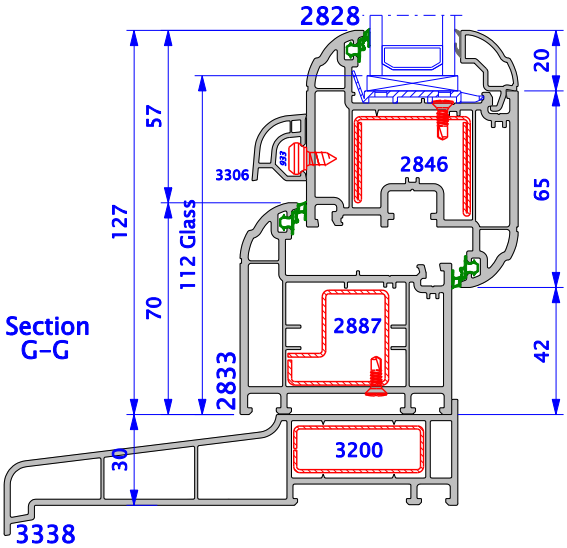
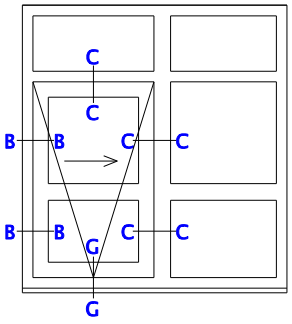


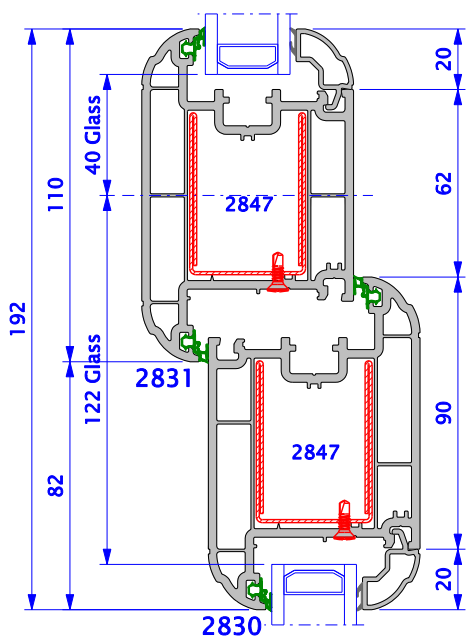
Section G–G

Tilt & Slide Patio

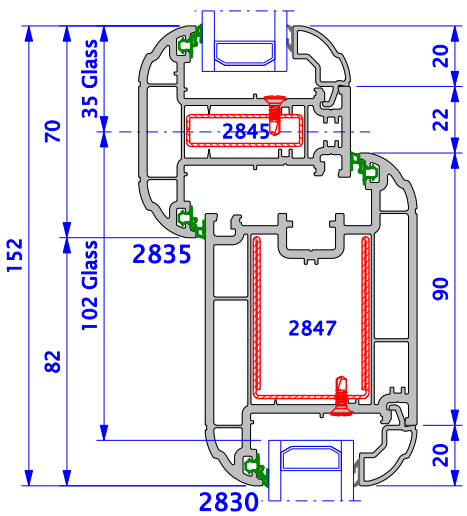
WINDOW SECTIONS



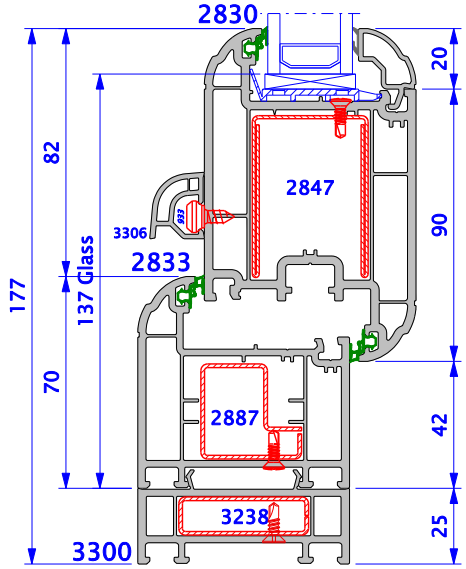
Section C-C



Section C-C



Section G-G



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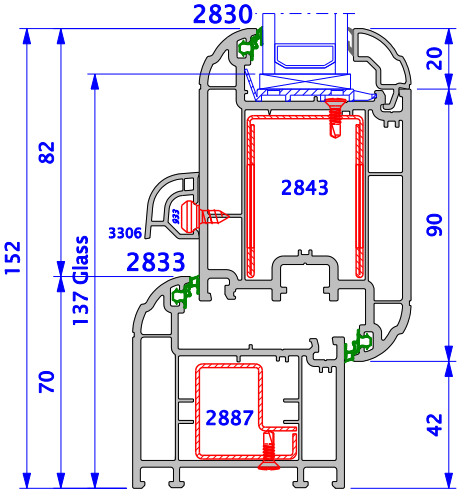
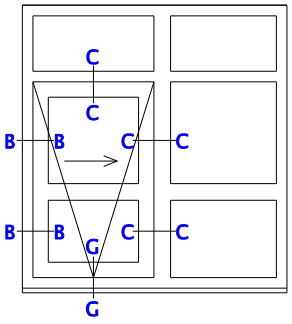


Lock Side

Tilt & Slide Patio

WINDOW SECTIONS



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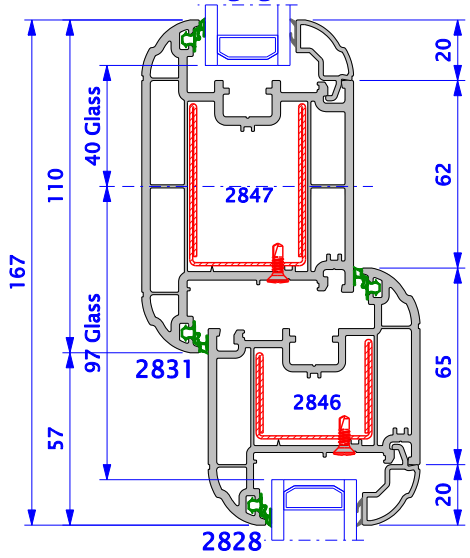

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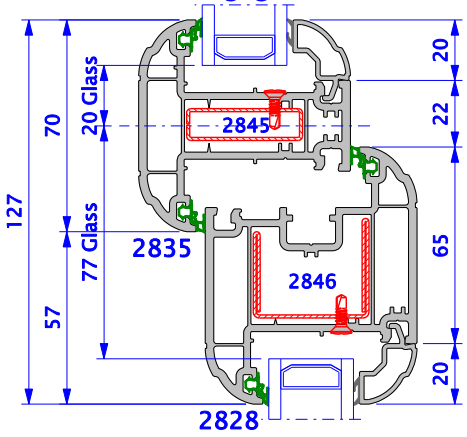

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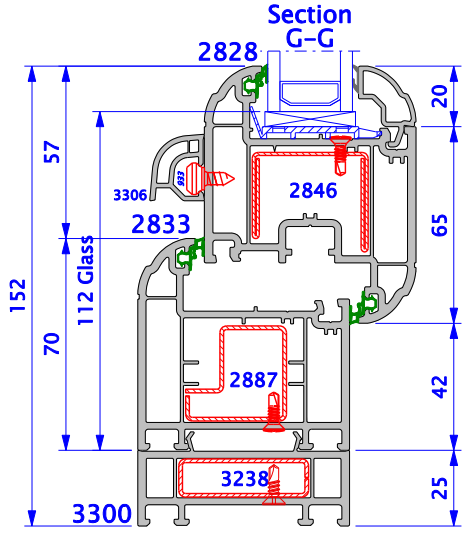

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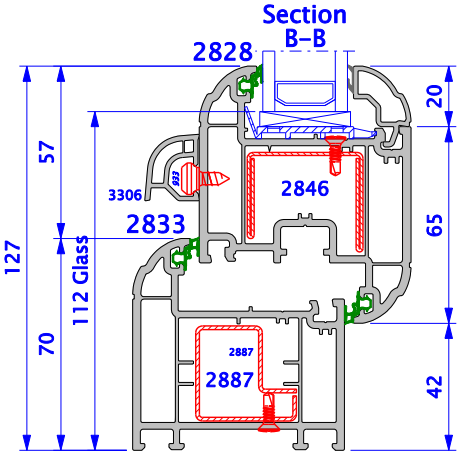
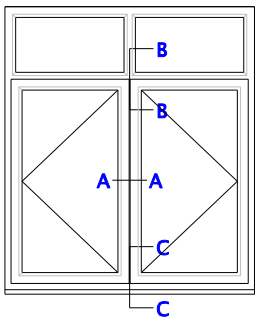
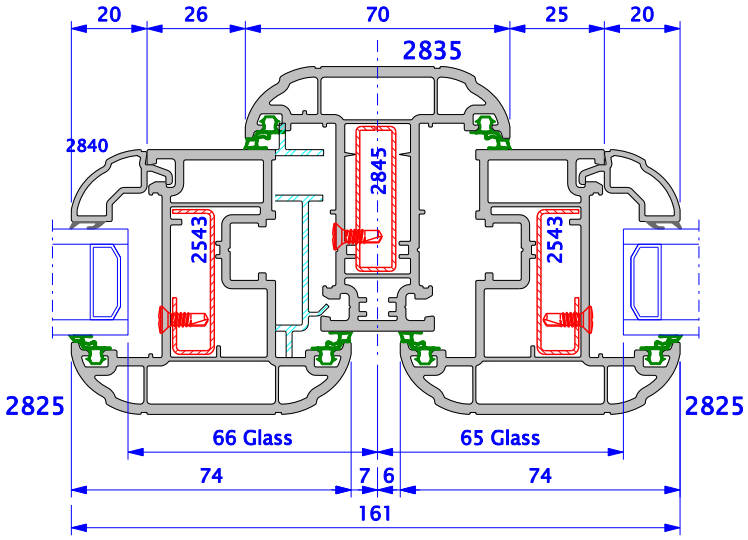


Lock Side

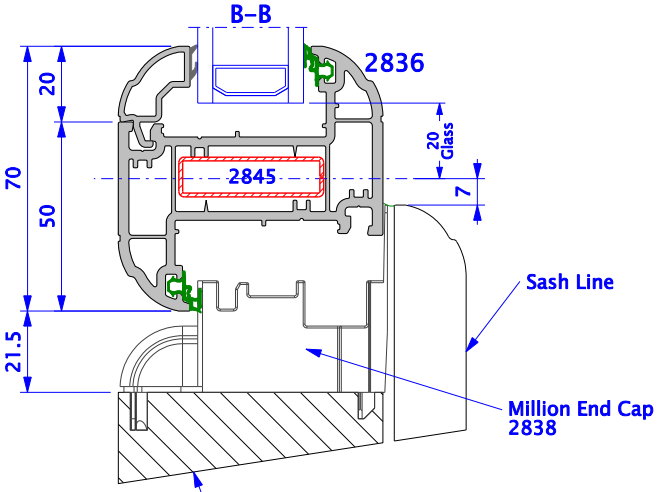
French Windows



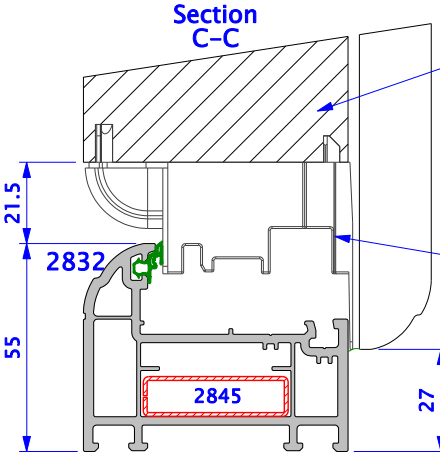
Sectio
A–A



Section
B–B



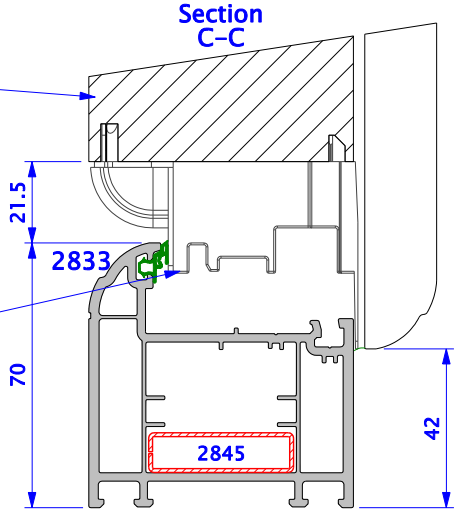
Section
C–C



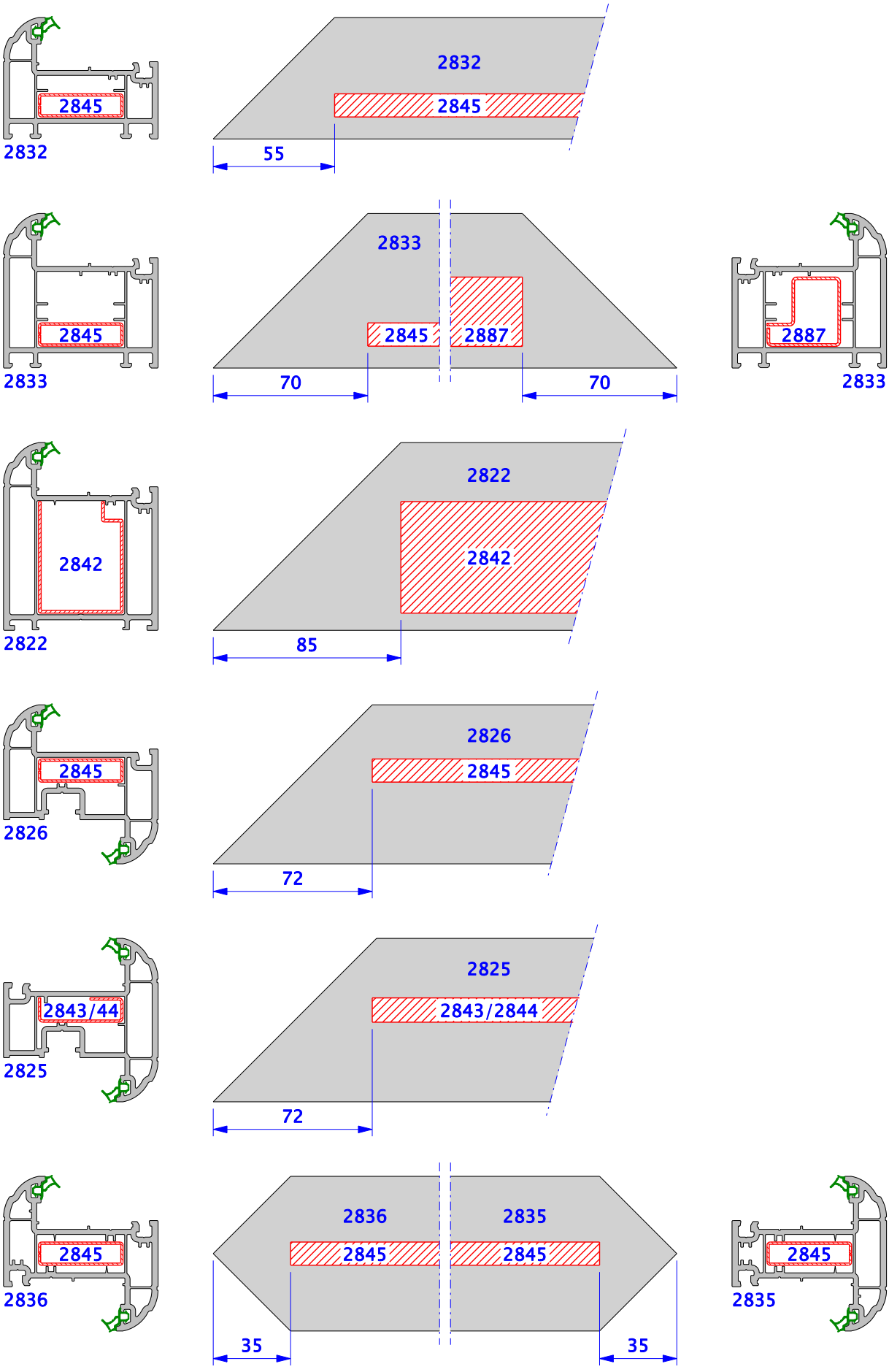
False Mullion
2835

Million End Cap
2838

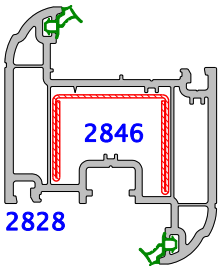
Section
C–C

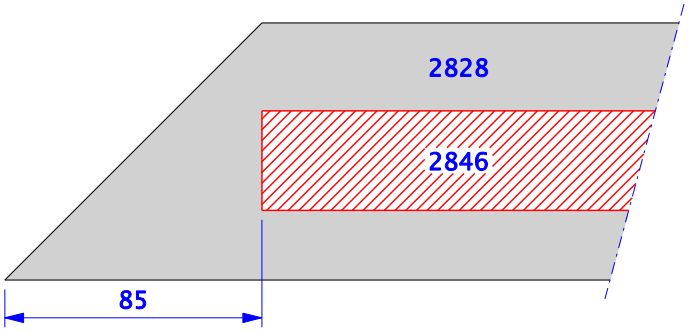


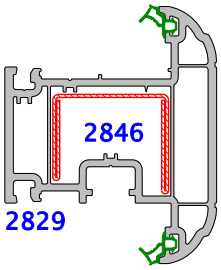
CUTTING SIZES

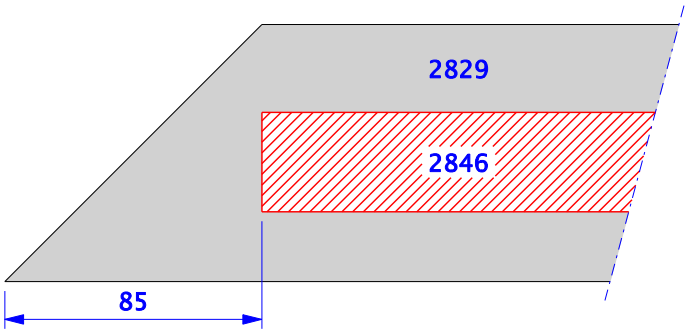


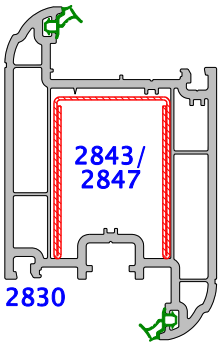
CUTTING SIZES

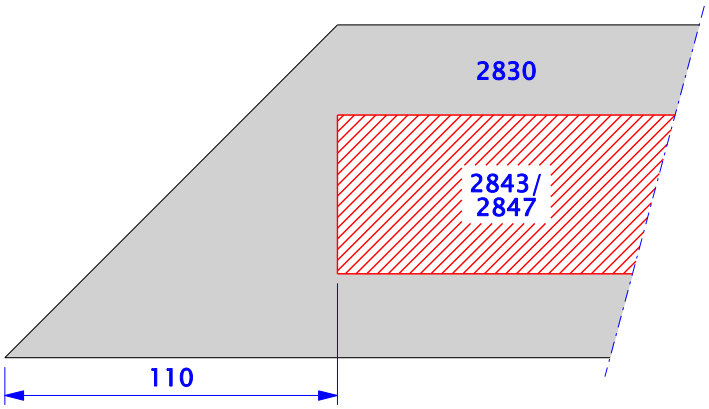


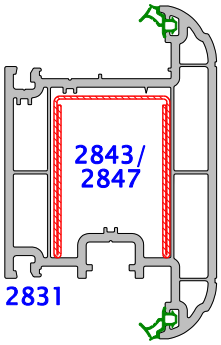


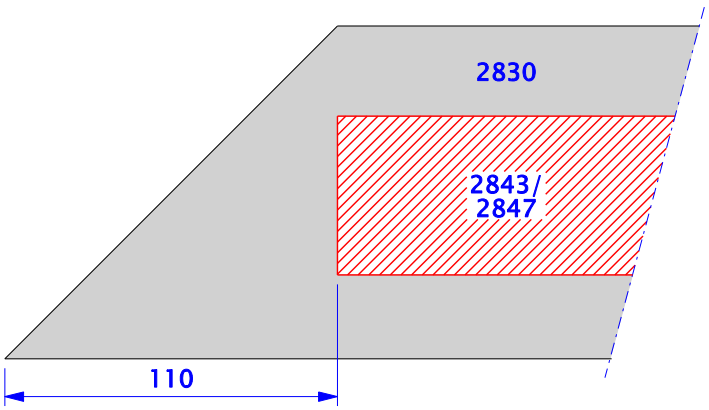




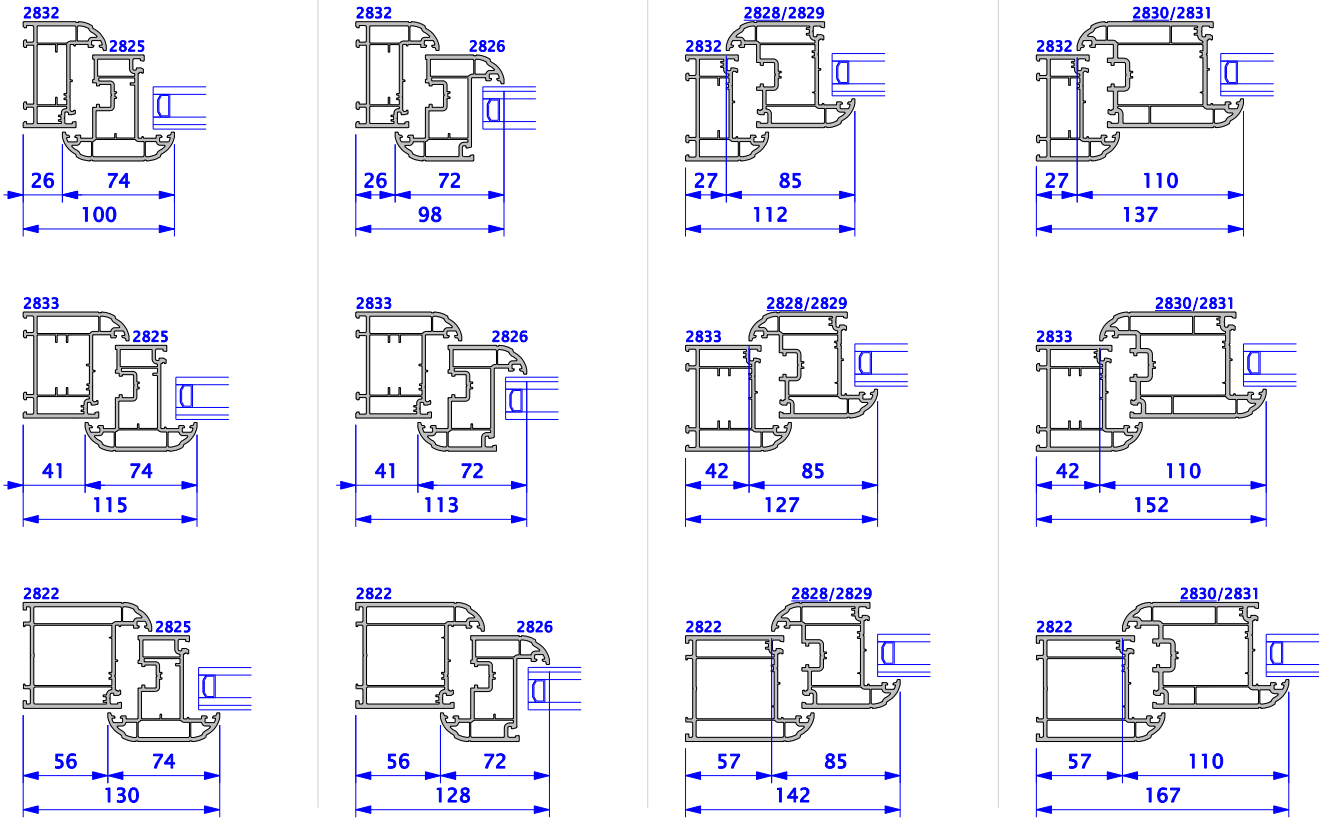


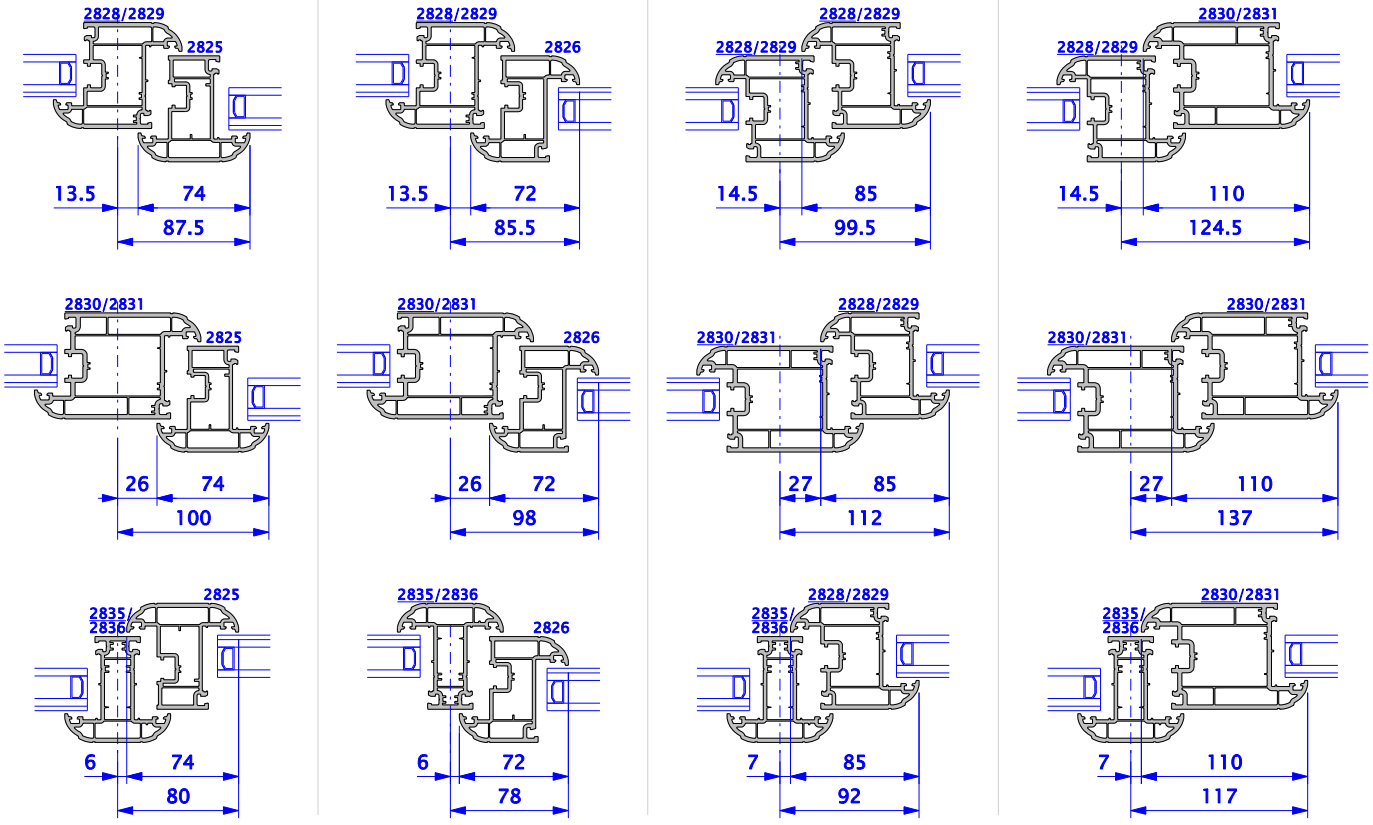






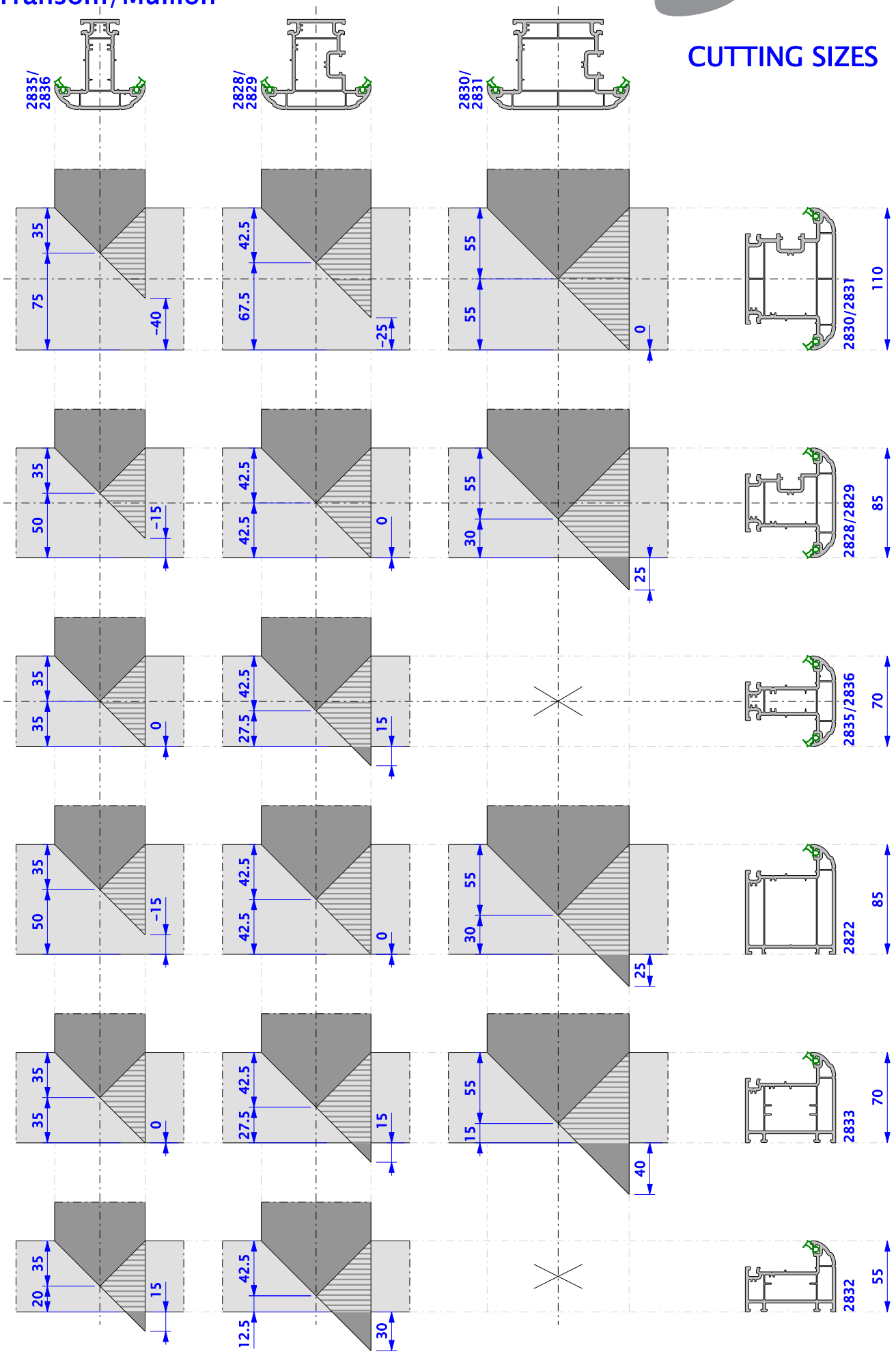
CUTTING SIZES



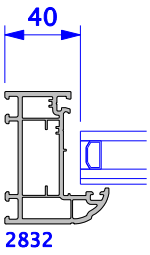


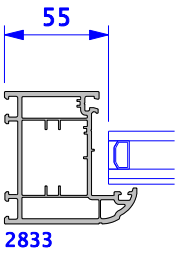
Transom/Mullion

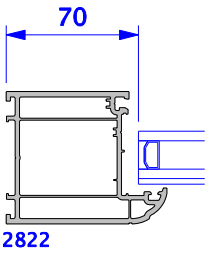
CUTTING SIZES

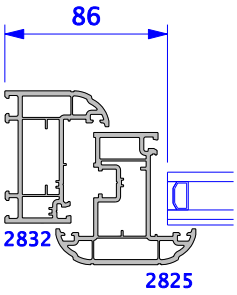


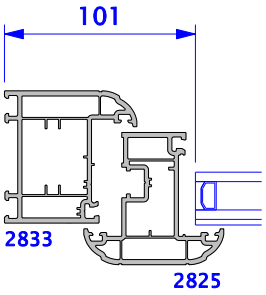
GLASS DISPLACEMENTS

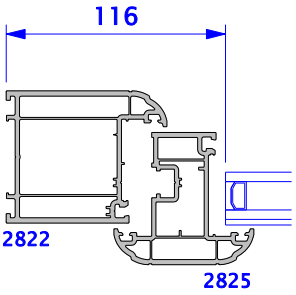


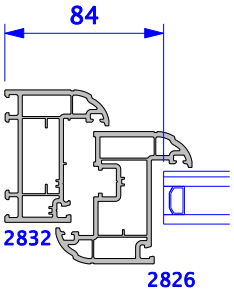


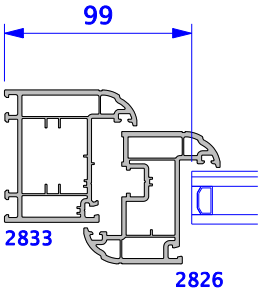


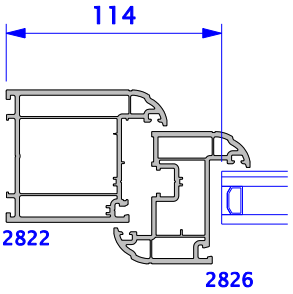


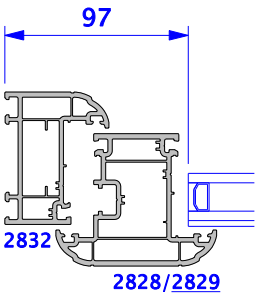


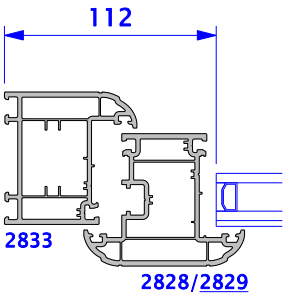


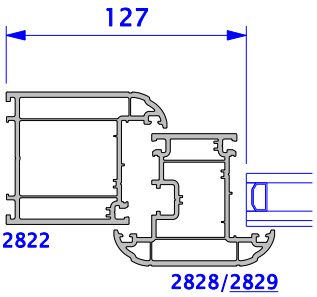


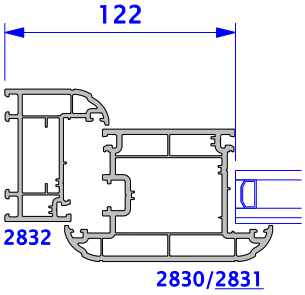


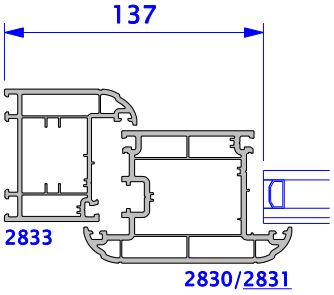


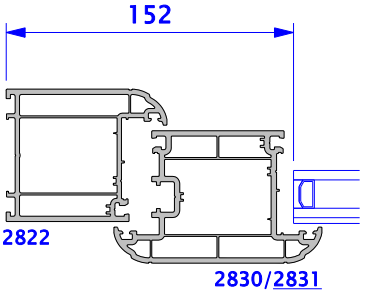




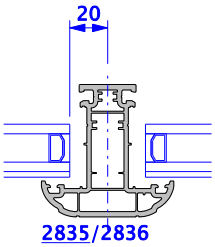


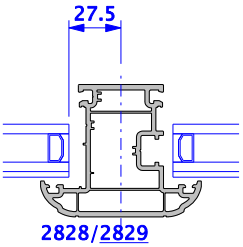


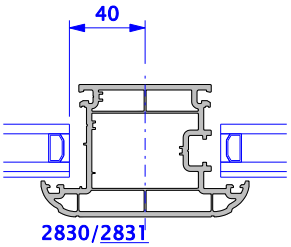


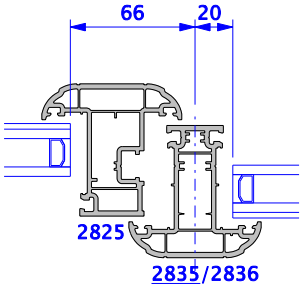


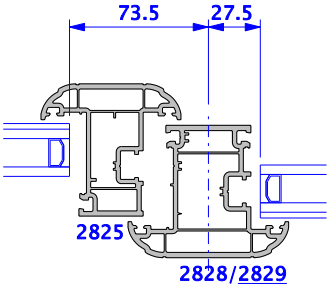
GLASS DISPLACEMENTS

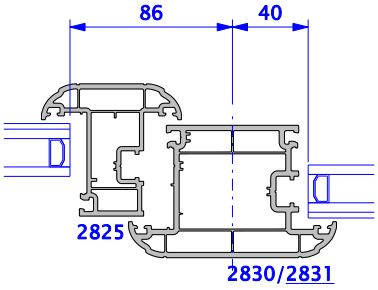


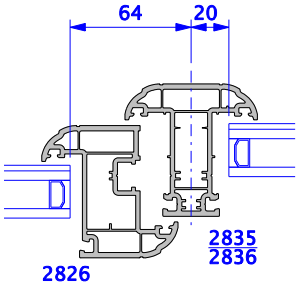


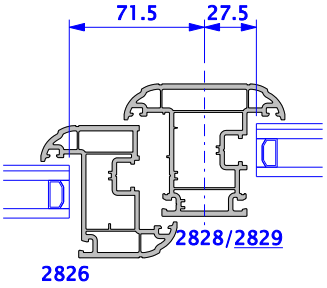


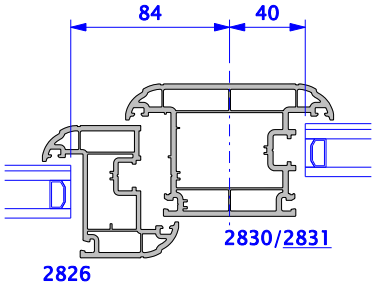


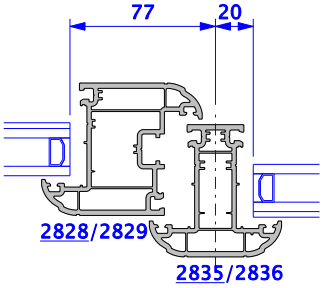


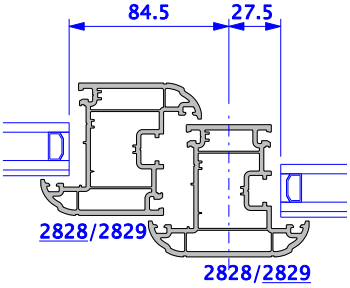


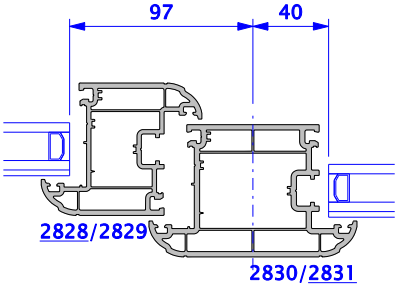


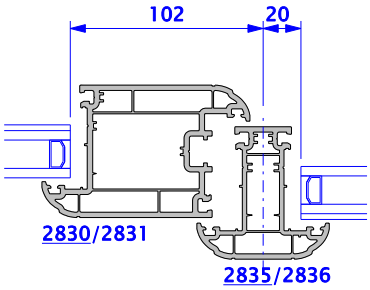


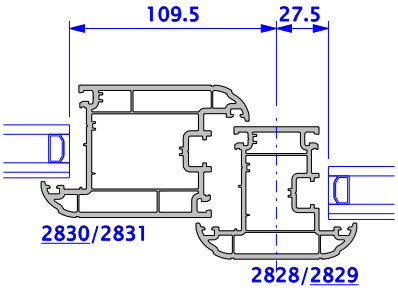


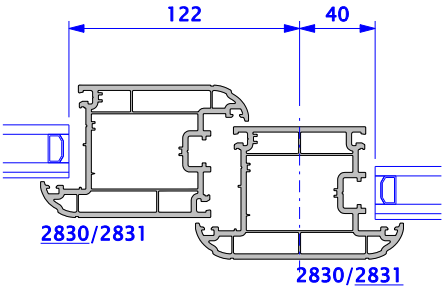












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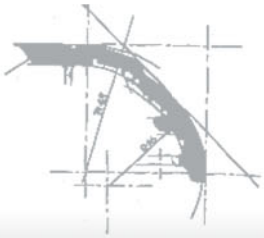
INSTALLATION

GENERAL GUIDELINES
INSTALLATION DETAILS



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Check the structure around the openings for any defects such as cracked mortar joints and that suitable lintels are in place. Report any defects to the customer in writing and agree on the method of proceeding.

NOTE. PVCU windows and doors are not designed to be load bearing

Check the openings for any service cables (e.g. TV Aerial cables or telephone lines), mark these on the survey and agree with customer on the method of handling.

Determine the exposure category of the site and ensure that the replacement windows and doors are suitable.

Ensure compliance with Building Regulations as these affect replacement products. Particular attention is drawn to the requirements of Approved Documents L (Conservation of Energy), M (Access) and N (safety). Also, the fitting of replacement windows and doors should not worsen the existing provision in respect of Approved Documents F (Ventilation) and B (Egress). Photographic evidence of existing windows and doors should be considered in respect of queries raised by FENSA inspectors etc.

Ensure there are no obstructions, either internally or externally, that will prevent the new windows or doors from functioning correctly (e.g. external rainwater pipes or internal taps).

Check that the design of product falls within the following recommended maximum size range:

Product	Maximum Width (mm)	Maximum Height (mm)
Top hung casement sash	1200	1200
Side hung casement sash	700	1400
Tilt & Turn sash	1500	1500
Single hinged door	1000	2100
Double opening door	2000	2100
Tilt & Slide Patio sash	1000	2200
French window sashes	700	1400

The majority of sizes stated above are based on actual performance tests (refer to section 4.4 for full details and guidelines on maximum sizes for multi-lights and exposure categories).

Reference to be made to the hardware supplier to confirm suitability of selected components for the sizes intended.

GENERAL GUIDELINES

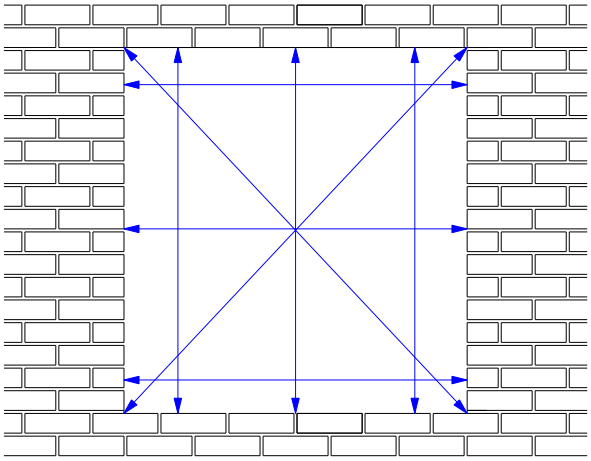


FIG 1

Take measurement of the width,height and diagonals as shown in Fig 1. The smallest measurement taken determines the tight overall width & height sizes.

The deductions shown in Table 1. should then be made all round the perimeter to allow for expansion and contraction, dependant on the size and finish of the new frames.
The sizes left are the manufacturing sizes for the new frames.

Determine if projecting sub-cills are to be fitted and where included ensure that a minimum projection of 25mm is provided beyond the structure.

Measure internal reveal sizes and compare with external opening sizes to ensure that opening lights are not impeded; this is important for inward opening doors and tilt & turn windows in particular. The thickness of external rendering should be checked for clearance of outward opening lights.

The survey should also determine the installation method to be used (e.g. through the frame fixing or with lugs) and ensure compliance with system designer and industry recommendations.

Width/Height of opening	White PVCU	Non White PVCU
Up to 1.5m	5mm	7.5mm
1.5m to 3.0m	5mm	7.5mm
3.0m* to 4.5m	7.5mm	11.0mm
Over 4.5m*	10.0mm	14.0mm

Table 1.

Deductions shown are per side not total.

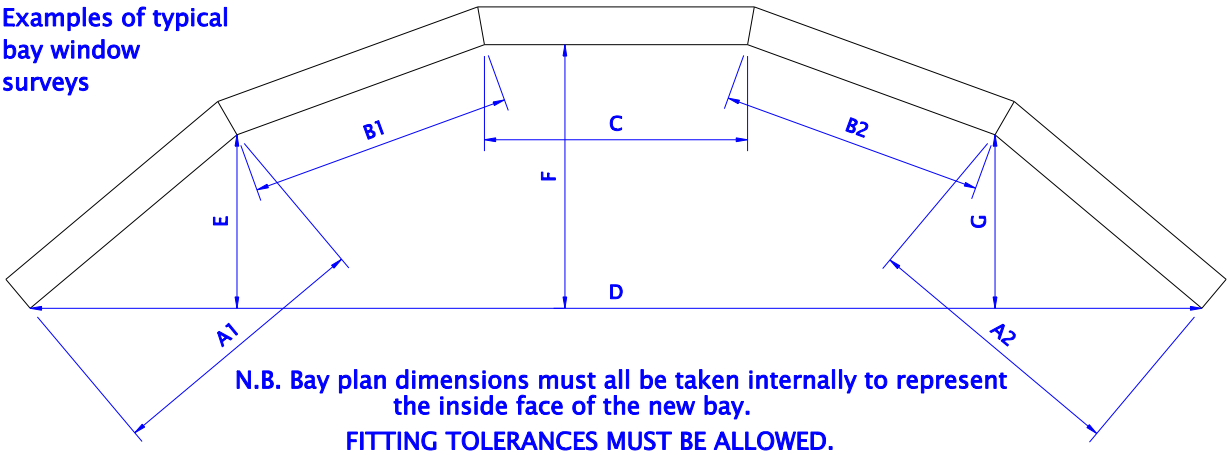
* Frames over 3.0m should idealy be coupled.

When surveying a bay window, make a note of the materials above the window (e.g. brickwork, hanging tiles, tiled roof, etc) as structural bay windows are required to have jacking poles to prevent any structural movement above the bay window. (Refer to section 3.2 Structural Bay Windows for details)

We recommend that for all bay window installations, the advice of a structural engineer is sought, to determine if the installation is load bearing.

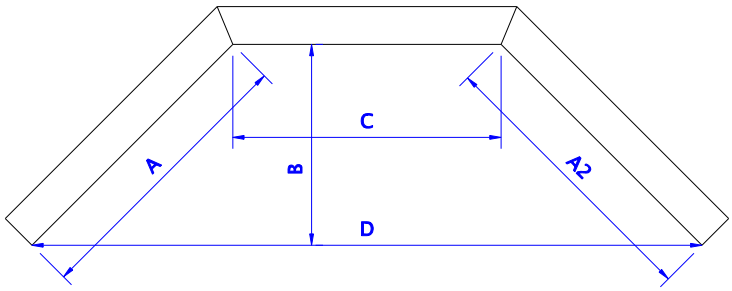
When surveying a bay window, internal cill dimensions are required although fitting tolerances and trimming allowances must be taken into account.

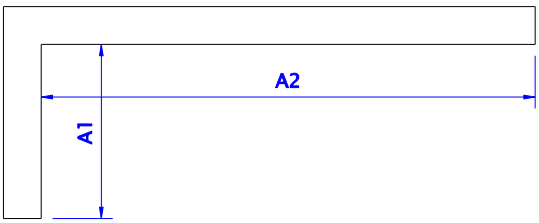
Examples of typical bay window surveys

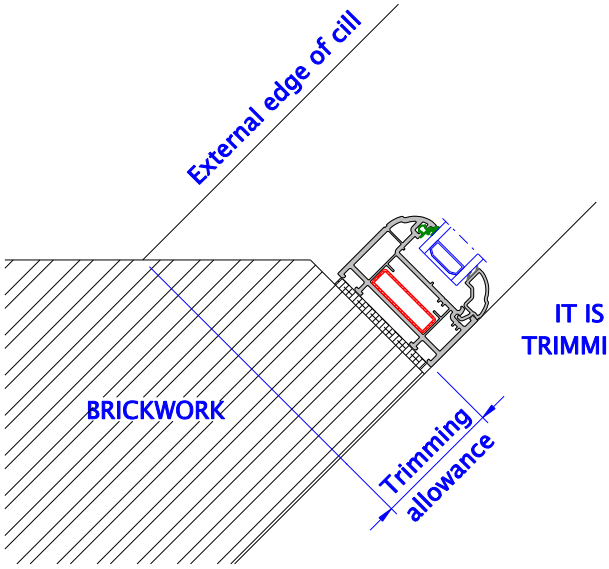


N.B. Bay plan dimensions must all be taken internally to represent the inside face of the new bay.

FITTING TOLERANCES MUST BE ALLOWED.







IT IS ESSENTIAL THAT SUFFICIENT TRIMMING ALLOWANCE IS ACCOUNTED FOR ON THE SURVEY

Transportation

When transporting glazed or unglazed frames, they should be firmly secured in an upright position on clean resilient packing. This will help prevent scratching of the surface of the profile. Frames stored on site should be treated in the same way and should be carried securely and placed in position without heavy impact. PVCu has a high resistance to weather, corrosion, and most materials found on building sites. However, as PVCu frames are delivered to the installer in a "completely finished" condition, care taken in transport, storage and handling will prove beneficial, thus ensuring a good installed appearance and customer satisfaction.

The protective tape on the PVCU frame(s) should be removed on completion of the installation, prior to final cleaning.

Protection

CEMENT, PLASTER AND SAND will not effect the properties of PVCu and may be easily cleaned from the surface – though care should be taken to avoid scratching. They may block drainage channels and so these should be checked and cleaned carefully before handover. Cement and plaster will corrode and spoil the action of gear and fittings so they should be cleaned off immediately.

TAR AND BITUMEN may stain the surface of white PVCu and contact should be avoided during storage and installation

SILICONE SEALANTS generally will have no effect on PVCu and may be used with confidence. However, mastic and sealant systems which include solvent based primers must not be used. If you are in doubt, consult the sealant supplier.

- Before removal of existing windows, it is of extreme importance that the following points are checked:-

  1. Check the structure around the opening for any defects such as cracked mortar joints and report any defects in writing to the customer before proceeding.
  2. Check the new windows have not been damaged in transit and that they have been manufactured in accordance with the customers original order.
  3. Check that the measurements of the new windows are correct so that they will fit into the aperture once the existing windows have been removed.

- Move any items of furniture away from the window aperture in order to avoid damage whilst removing the existing window or installing the new window.
- Cover carpets and soft furnishings with dust sheets so as to minimise the possibility of damage and to facilitate the "cleaning-up operation" after the installation.
- Using a craft knife or similar, score around the perimeter of the existing frame on the inside, where the plaster or wall decoration meets the frame. In most cases this will minimise damage.
- Remove all opening sashes and glass from the main frame
- Saw through any mullions or transoms and break these out of the main frame.
- Saw through verticals of main frame as far as possible without causing damage to internal reveals or structure.
- Protecting plaster and renderings with a bearing block, use a levering bar between the structure and the main vertical frame, to carefully lever the verticals inwards, and then complete the saw cut. Remove the vertical members completely from the aperture.
- Using the same procedure, remove the horizontal members of the outer frame from the aperture.
- Clean the aperture and remove where possible any mastic from the structure.
- Remove all debris from the site.
- Removal of sub-cills

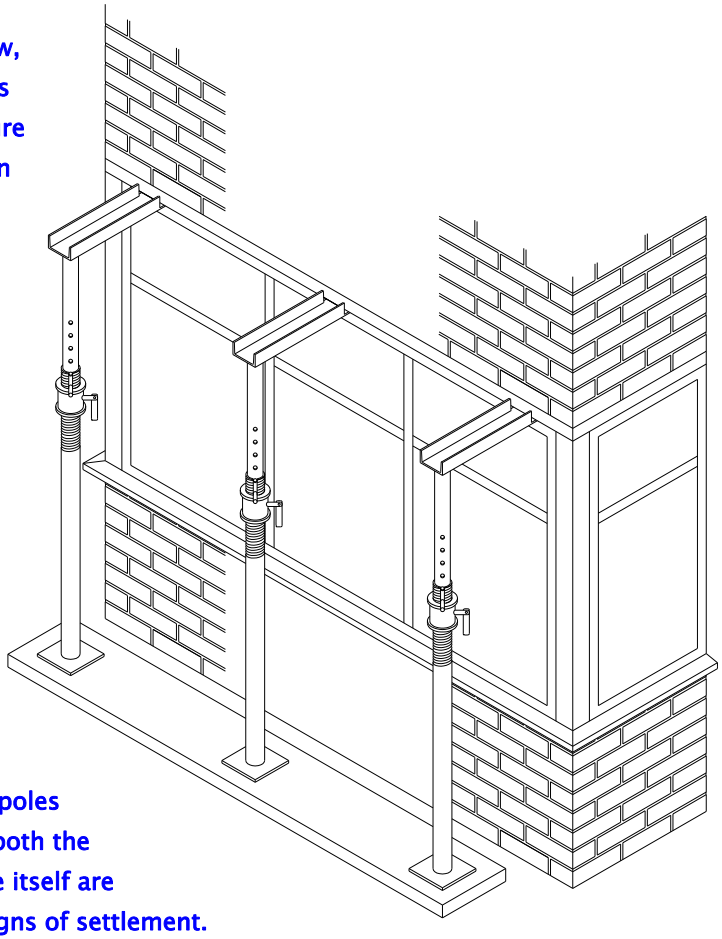
  Sub-cills - and sometimes heads, windowboards and mullions are often `horned' into the fabric of the aperture. This may conceal damp proof courses and lead to difficulties in removal. Great care must be taken when cutting and levering these items to reduce damage to plaster, renders and brickwork to a minimum. If the DPC is damaged, then it must be replaced.

- Removal of `Box-Sash' windows

  Most box-sash windows pre-date cavity walls, and are built into the internal reveals of solid brickwork. The sashes are removed fully glazed.

  1. Remove the mitred beading from around the frame.
  2. Cut the sash cords to release the weights.
  3. Remove the bottom sash, then take off the parting bead and take out top sash.
  4. Cut the outer frame from the aperture, leaving the horns in the structure.
  5. Remove the counterweights from the sash box.
  6. Remove the sub-cill, if this is not part of the outer frame.

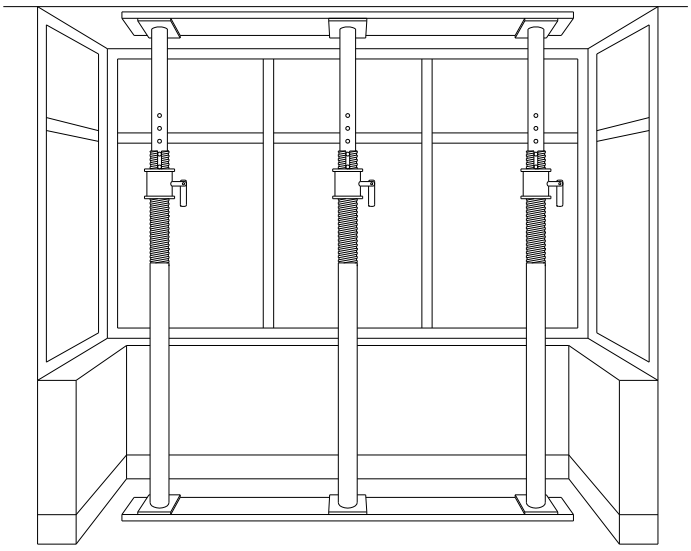
In order to maintain the structural integrity when replacing a bay window, it is essential that temporary supports are used. Care must be taken to ensure that they are placed in such a position to support all the super-structure without causing damage to ceilings or floors. In some cases temporary supports are needed both internally and externally



After supporting the bay structure the windows should be removed carefully, ensuring that the minimum of damage is caused to the reveals, plaster finishings and trims. Any trims that will be re-used should be carefully checked for defects such as rotting, and appropriate action should be taken

It is recommended that load bearing poles are removed one at a time, and that both the temporary supports and the structure itself are closely monitored to check for any signs of settlement.

Any heavy furniture in the upper floor bay area should be cleared before removing the old bay window.



Changes to the building regulations make it necessary to use jacking poles on structural bays. Checks should be made with your local building control department or seek the services of a structural engineer if you have any uncertainty regarding this area of an installation

For details on jacking poles see section 3.2, Structural Bay Windows

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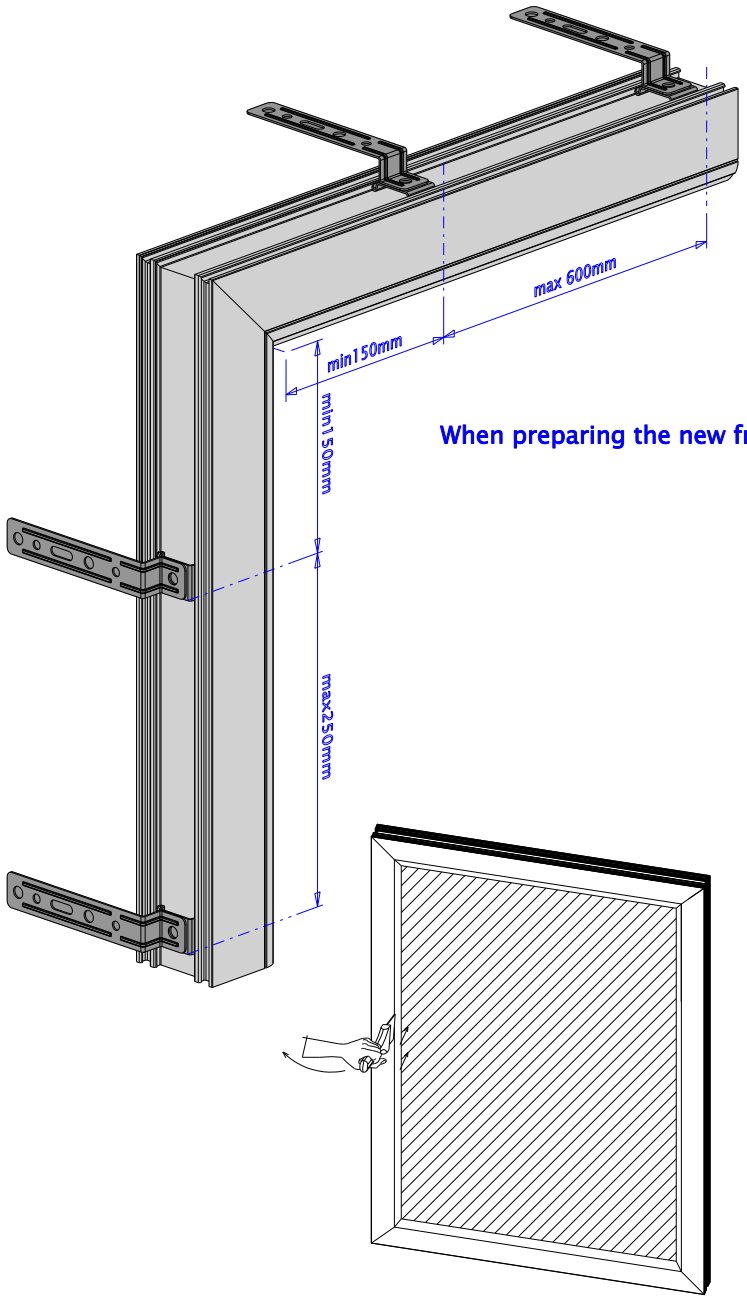
GENERAL GUIDELINES



When preparing the new frame, the following points should be followed :-

If you are using fixing brackets, these should be firmly attached to the outer frame, starting at no less than 150mm from the corners and at no more than 600mm centres.

If you are to screw through the main outer frame into the structure, then the glass in the appropriate fixed light must be removed.
If the window is too heavy for convenient handling, the glass units may have to be removed.
Choosing one of the longest beads first, push a sharp chisel or rigid putty knife into the bead/ frame joint at approximately the centre point.
Apply force to lift the bead up and out.
Starting at the end of the next bead, the remainder can now easily be removed.
Make a note of the positions of each bead to ensure correct poitioning later.

Carefully remove the glass unit, taking care not to disturb the packers. When windows are received unglazed see section 5.6, Glazing Packer Position.
Store any glass you have removed safely away from where you are working.

With sash windows it may be more convenient to remove the sash or sashes. To remove the sash from the frame, open the sash to its full extent and keep fully supported. Carefully remove the screws from the friction stays on either the sash or frame. Refitting is the reverse of this procedure. It is important to ensure that the screws locate into the original fixing holes. Finally, check for squareness of vent in frame aperture.

If a cill is required and has been supplied separately from the window, then it must now be attached. If the cill is to be fixed to the window frame with screws, always screw from the underside of the cill into the frame. It is important that fixings do not penetrate drainage channels.

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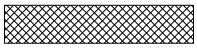
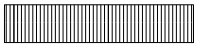
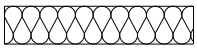
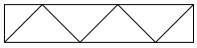
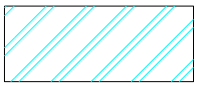
LEGEND

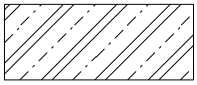

Adhesive tape

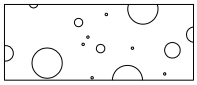

Silicone


Insulation (flange)

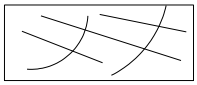

Insulationpanel

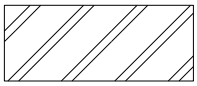

Aluminium

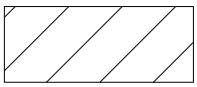

Bluestone

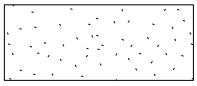

Concrete

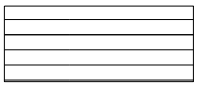

Glass

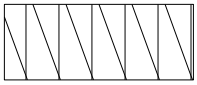

Wood

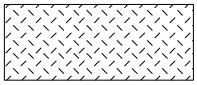

External wall

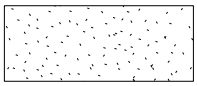

Internal wall

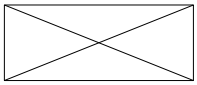

Mortar


Multi-ply board


Adhesive tape

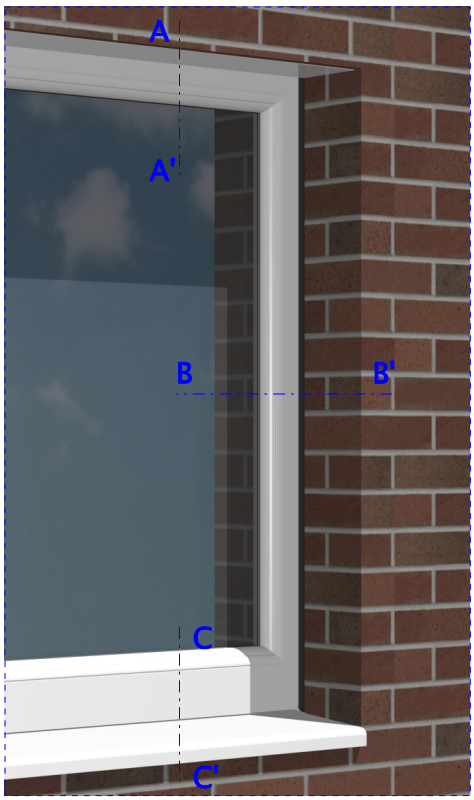

Sand


Stucco

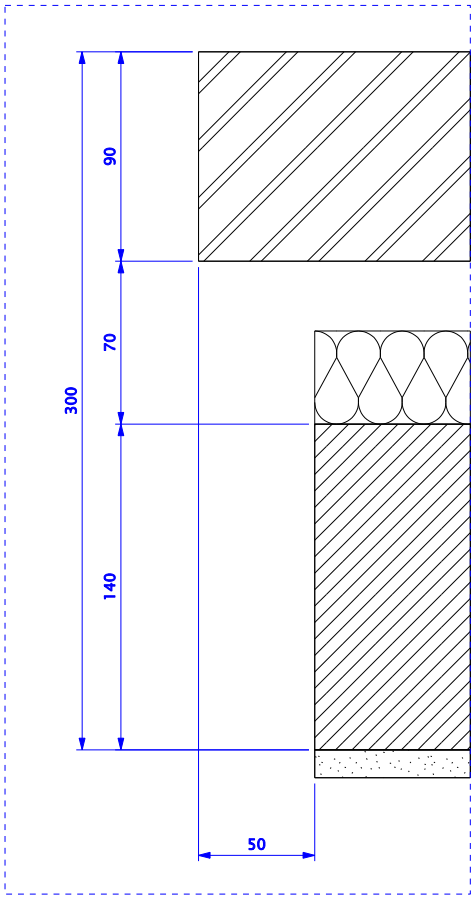

Wood

PVC cill 3334/2833/3651_3655

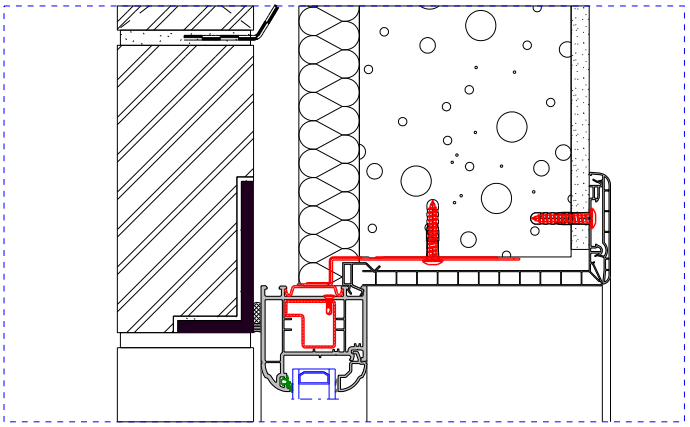
INSTALLATION DETAILS



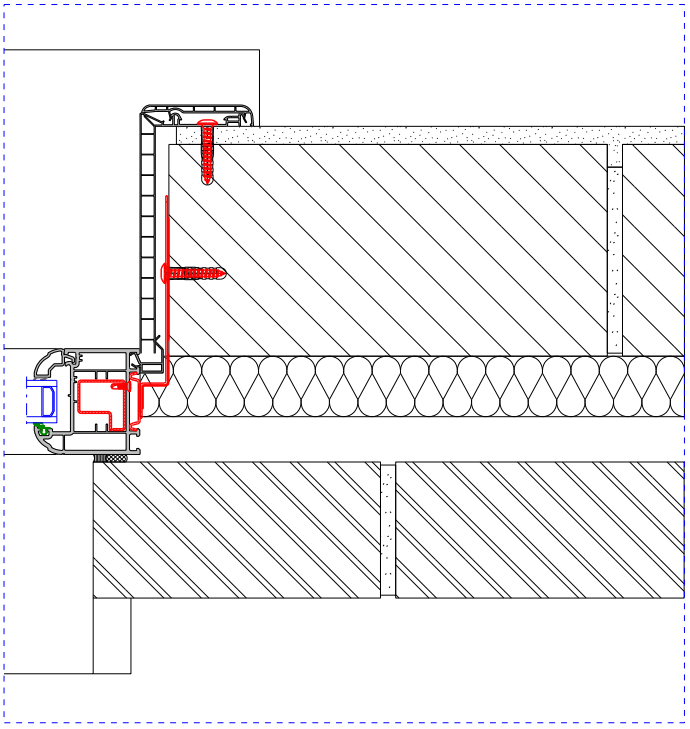
Wallsection



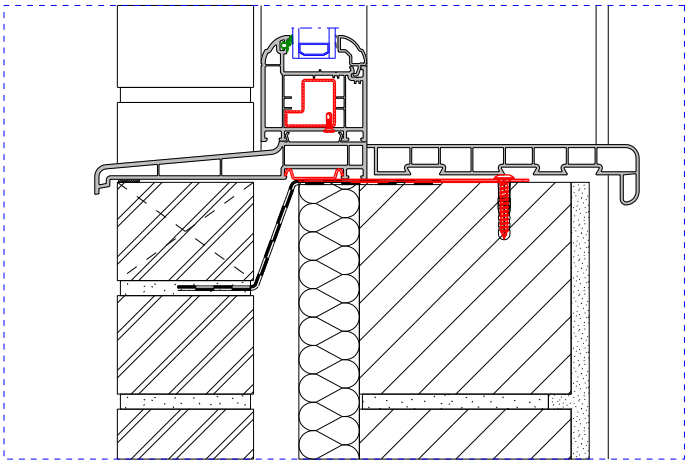
Section A-A'

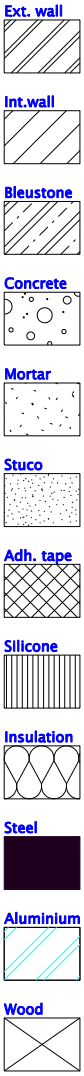


Section B-B'



Section C-C'





1. Offer the window into the aperture, bedding in the appropriate manner as illustrated on the following page, temporarily wedging it into position making sure it is level & plumb. Ensure perimeter clearances are retained by using appropriate fixing packers. Mechanical fixings should be made through the packers. The packers themselves must be made of a non-degradable material (e.g. plastic).
2. Fix the window into the aperture using either fixing brackets or by drilling and fixing through the outer frame. Fixing locations should be no closer than 150mm from corners and intermediate transoms/mullion joints and at max. 600mm centres elsewhere (see Fig 1.)
Windows over 1800mm wide should be fixed centrally at both head and cill.
A minimum of 2 fixings per jamb must be achieved.
THe use of polyurethane foam is permitted where it is impractical to achieve mechanical fixing in the normal way. The manufacturers guidelines must be followed for application. Foam fixing will not be accepted as a sole means of fixing a frame.

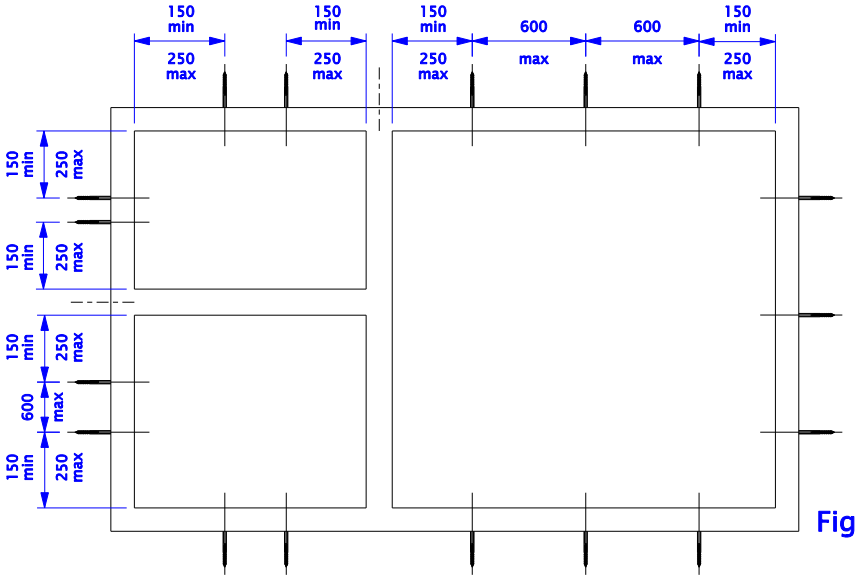


Fig 1.

3. If it is necessary to fix through the bottom member of the outer frame, where water can collect, adequate sealing over screw heads is recommended. Where possible, fixing brackets should be used for this application.
4. Re-fit any of the glass units you have removed, making sure they are sitting on the necessary glazing blocks. (Refer section 5.6 Glazing Packer Positions).
5. Re-fit the glazing beads taking extreme care not to damage the glass.
6. Re-fit sash or sashes you have removed. See section 3.1, New Frame Preparation.
7. Check the window for correct operation before proceeding with the mastic seal or making good.

DRAINAGE

It is essential that our recommendations for securing the glass in place are followed. Specifically, care must be taken to ensure that glazing blocks or spacers do not obstruct drainage of the water from the glazing rebate.

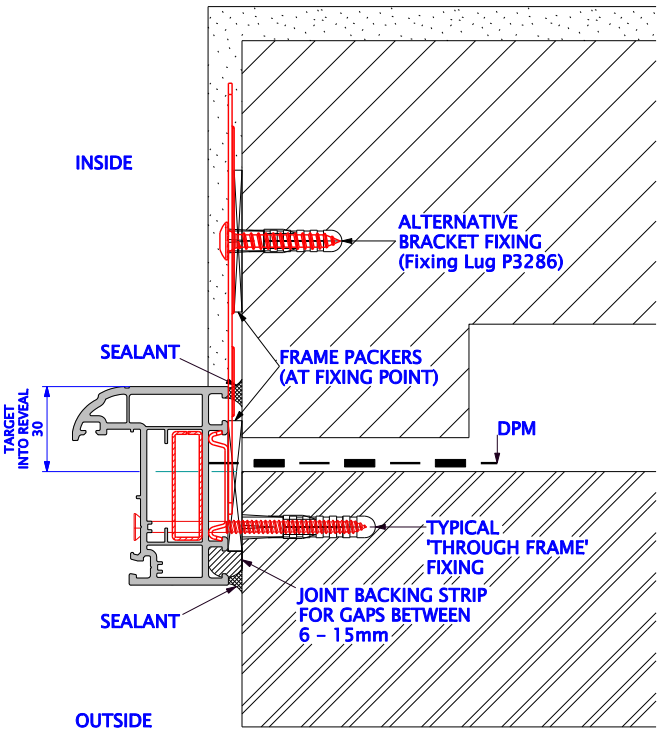
INSTALLATION DETAILS

The details contained in "Limiting thermal bridging and air leakage : Robust Construction details for dwellings and similar buildings" (TSO 2001) are applicable to new build applications under Building Regulations (Approved Document L) but also make good practice on replacement work where possible.

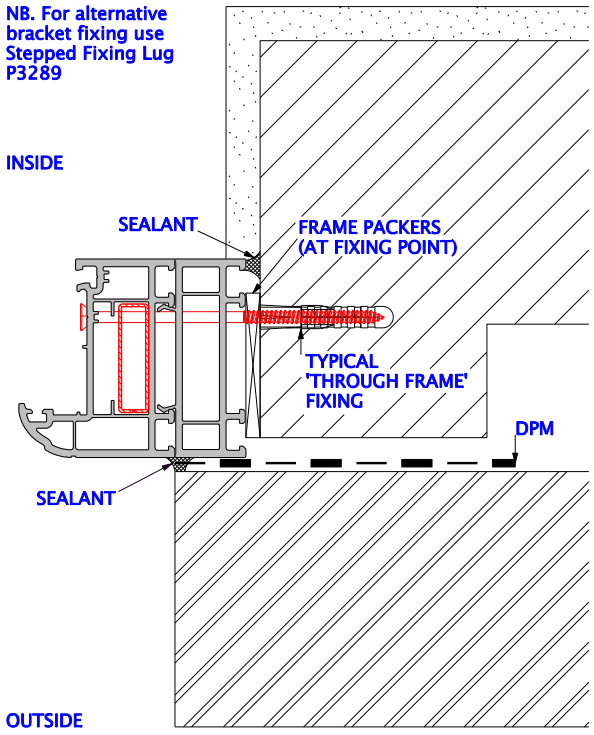
Frame fixings should penetrate a minimum of 25mm into timber and 40mm into plugged brick or block work. Separate fixing details apply when fixing to timber kit framing, steelwork and thin gauge metal pressings. In all situations the facility for PVC U frames to expand and contract must be provided.

Details shown on following page provide further examples of fixing PVCU frames.

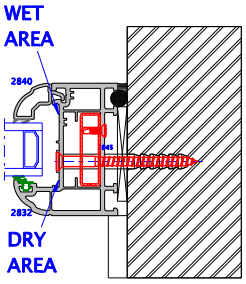
Typical Jamb Detail:
Section through flush reveal:



Typical Jamb Detail:
Section through stepped/rebated reveal:

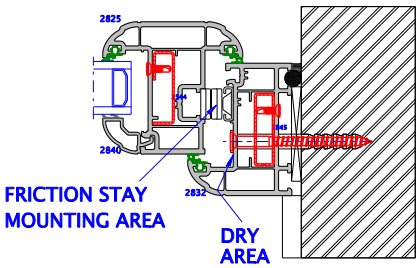


INSTALLATION DETAILS



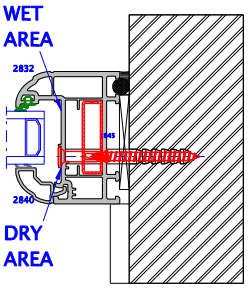
Typical through the frame fixing showing screw in dry area.
Typical for all externally beaded fixed glass situations.

EXTERNAL BEAD FIXED



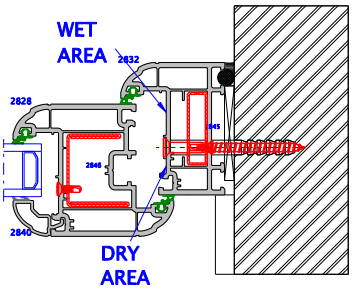
Typical through the frame fixing showing screw in dry area.
Typical for all opening out windows avoiding the friction stay mounting area and for residential doors which open outwards.

OPEN OUT



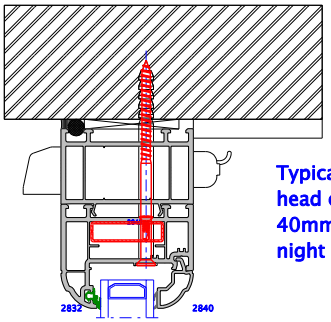
Typical through the frame fixing showing screw in dry area.
Typical for all internally beaded fixed glass situations.

INTERNAL BEAD FIXED

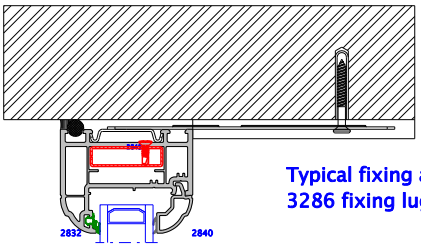


Typical through the frame fixing showing screw in dry area.
Typical for opening in windows such as tilt & turn also for residential doors which open inwards.

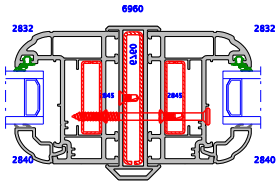
OPEN IN



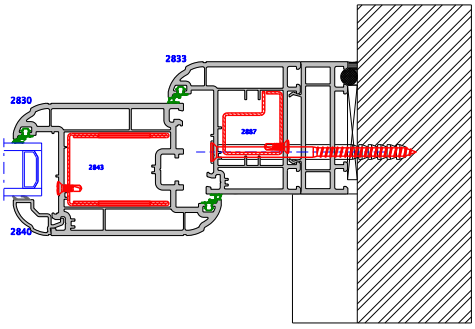
Typical fixing through the head example shows 3301 40mm add-on used for a night ventilation arrangement



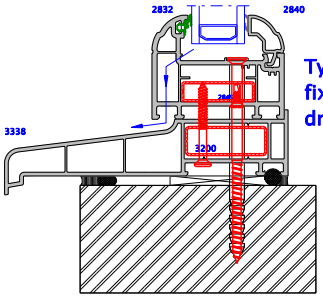
Typical fixing at head using 3286 fixing lugs.



Typical arrangement of frame to frame coupling example shows two 2832 outerframes coupled with 6960 overlaping coupler.



Typical fixing with deep plaster line roomside using 3300 25mm add-on
Hinge side shown



Typical through the frame fixing showing screw in dry area.

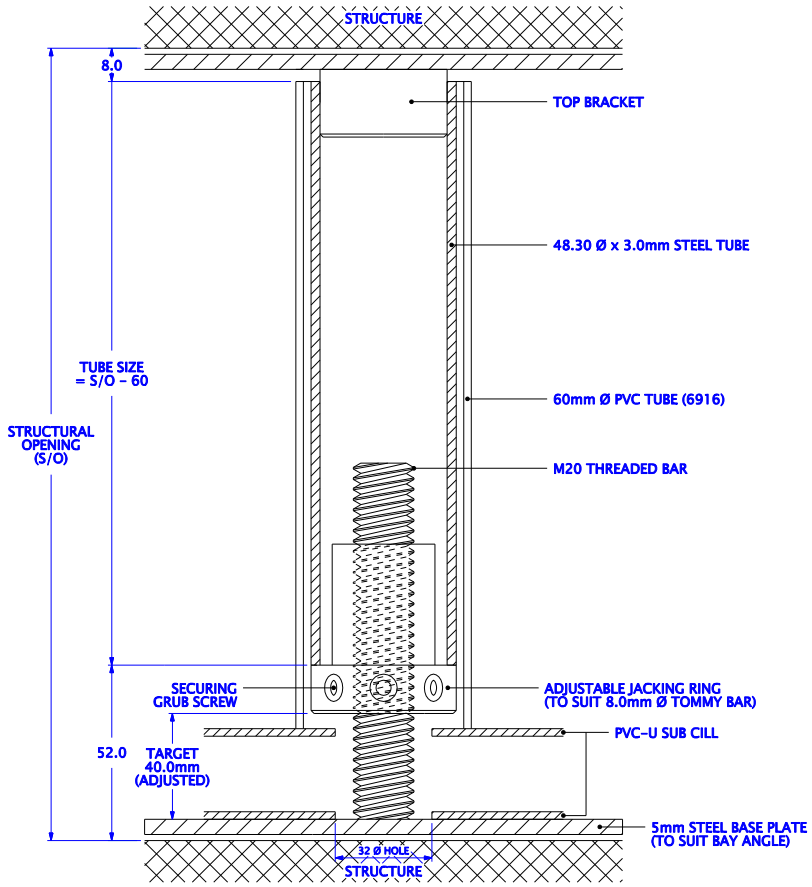
It is expected that bay windows will shortly come under Building Regulations at least with regard to structural integrity. Currently FENSA inspectors will check that provision has been made for suitable corner posts to suit load bearing situations. Future requirements may well see demands for calculations on loads applicable and how these are met by the bay system used.

Deceuninck have teamed up with specialist supplier Nicholls & Cooke of Southampton to develop a range of adjustable structural jacking corner post designs to suit the 2800 Series for both splayed and square bay types.

For splayed bays two options exist – one using 6916 PVC tube with 3311 frame adaptor and the second uses the smaller 3313 tube with 3327 clip in adaptors to provide an option with slimmer sightlines. For square bays 6920 PVC tube is used. In all situations Deceuninck have opted to use seam welded galvanized steel tubing for the structural element to maximise load bearing. Standard aluminium bay tubes are unlikely to have the required mechanical strength.

Bearing Plates:
Bearing plates should be made from steel with a minimum thickness of 3mm, or aluminium with a minimum thickness of 5mm.
The area of the bearing plate should be a minimum of 1800 sq.mm.
Provision must be made to prevent the plate moving relative to the bay pole.
The bearing plate must completely cover the end of the bay pole.

Further details of the system can be found in a separate publication “Manual for the construction of the Nicholls & Cooke Structural Bay System for the Deceuninck 2800 System”.



Site glazing to be completed as required. The contractor must utilize the glazing methods described within this technical manual. The location of glazing packers to be suitable for each application. Glass units must be installed clear of designated 'wet' areas in the framing and be packed to prevent opening lights from dropping.

On completion of glazing, and the attachment of any special fittings, the contractor will check the correct functioning of all windows and doors installed making adjustments where necessary.

The contractor will be reponsible for cleaning the framing and glass with approved agents. The protective tape on the framing should then be removed.

The contractor will carefully point an approved low modulus silicone sealant to the joint gap between frame and structure on the outside (Fig 1.). Care should be taken not to seal the drainage path for such as metal lintels.
The 'Robust Detailing' methods referred to in Approved Document B of the Building Regulations stipulate that and additional seal line is also placed to the inside gap between frame and structure on new build applications. The use of backing strips for gaps between 6mm – 15mm should be adopted, and the sealant manufacturers guidelines followed (Fig 2.).

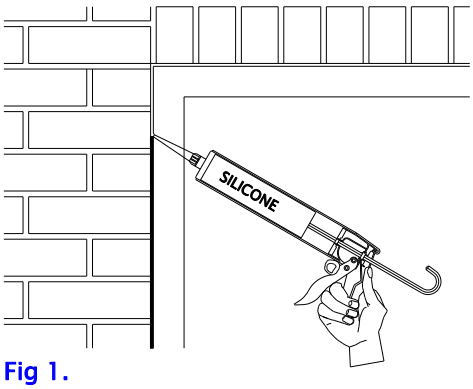


Fig 1.

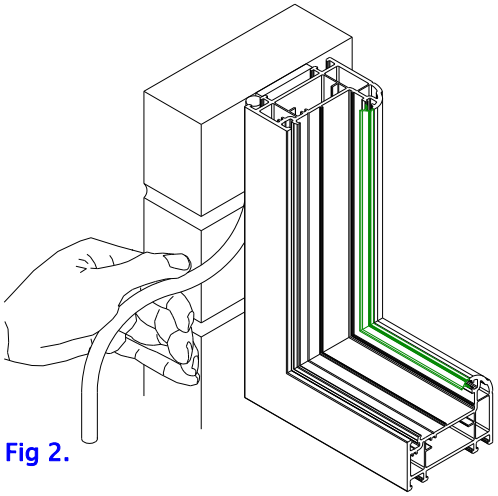
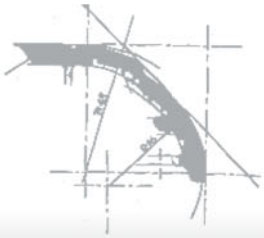


Fig 2.

2800 decorative

PERFORMANCE

CALCULATION OF WIND PRESSURE
REINFORCEMENT GUIDELINES
THERMAL PERFORMANCE
CERTIFICATES



deceuninck

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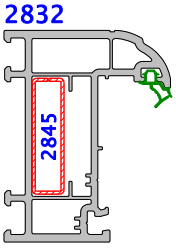
CALCULATION OF WIND PRESSURE

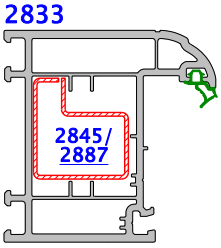
2832



The calculated Ei values in this section are the true inertia values adjusted with the modulus of elastisity of materials used within our various section, values used are as follows:-

Material	Modulus
P.V.C.u	2,500
Steel	205,000

2833



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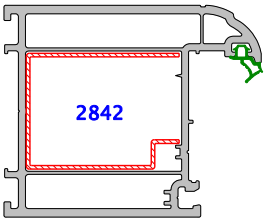

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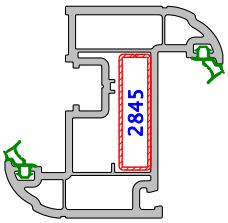

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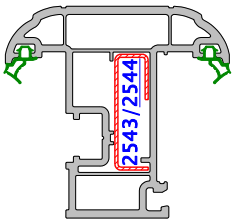

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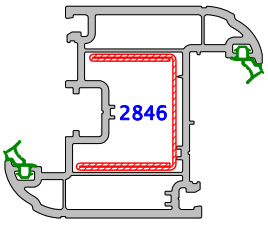

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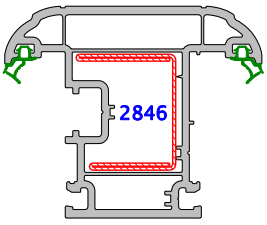

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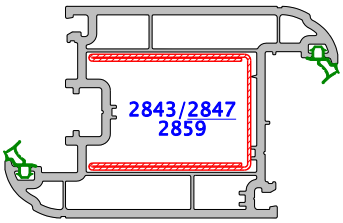

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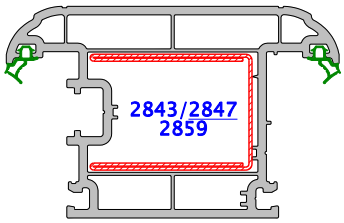
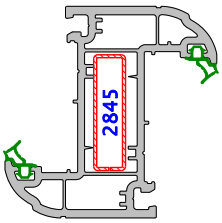


2836



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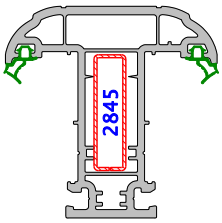


Combined Ei Values

Profile	Reinforcing	Eix Value (x10⁷)	Eiy Value (x10⁷)
2832	/	1,12	0,39
	+2845	4.11	0,76
2833	/	1,40	0,84
	+2845	4.39	1,21
	+2887	5,10	4,75
2822	/	1,67	1,57
	+2842	11,07	11.80
2826	/	1,24	0.64
	+2845	4,23	1,01
2825	/	1,21	0,69
	+2543	1,41	0,86
	+2544	3,80	0,96
2828	/	1,51	1,12
	+2846	10,08	4,26
2829	/	1,46	1,12
	+2846	10,03	4,26
2830	/	2,07	2,87
	+2843	16,63	16,89
	+2847		
	+2859	12,65	15,81
2831	/	2,03	2,86
	+2843	16,59	16,88
	+2847		
	+2859	12,61	15,80
2836	/	1,25	0,56
	+2845	4,24	0,93
2835	/	1,19	0,56
	+2845	4,18	0,93

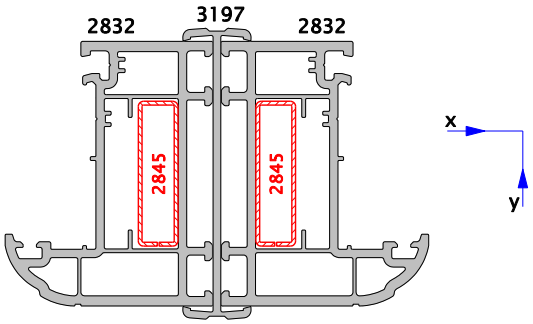
NOTE:-THE POSITIONING OF REINFORCEMENT SCREWS SHOULD BE NO GREATER THAN 300mm CENTRES AND A MAXIMUM OF 100mm IN FROM EACH END.

Coupled Sections

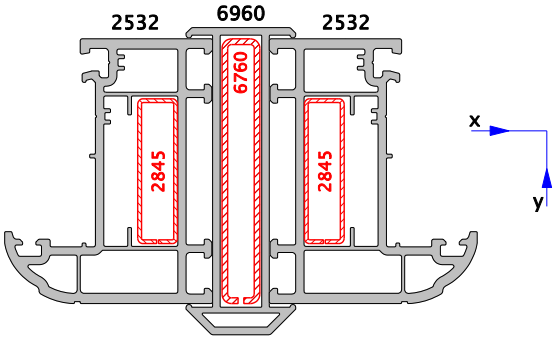
The calculated Ei values in this section are the true inertia values adjusted with the modulus of elastisity of materials used within our various section, values used are as follows:-

Material	Modulus
PVCU	2,500
Steel	205,000

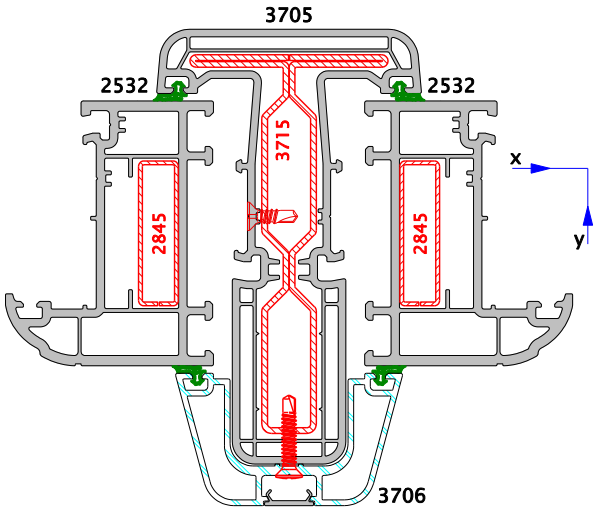
COUPLED SECTIONS MUST BE SECURED TOGETHER AT MAXIMUM 300mm CENTRES



Profiles	Coupler	Reinforcings	Eix Value (x 10 ⁹)	Eiy Value (x 10 ⁹)
2832 x 2	3197	2845 x 2	8.61	1.53



Profiles	Coupler	Reinforcings	Eix Value (x 10 ⁹)	Eiy Value (x 10 ⁹)
2832 x 2	6960	2845x2 & 6760	30.07	2.36



Profiles	Coupler	Reinforcings	Eix Value (x 10 ⁹)	Eiy Value (x 10 ⁹)
2532 x 2	3705	2845x2 & 3715	124.9	11.25

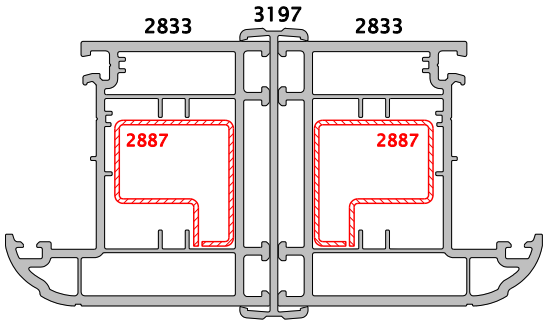
NOTE:-THE POSITIONING OF REINFORCEMENT SCREWS SHOULD BE NO GREATER THAN 300mm CENTRES AND A MAXIMUM OF 100mm IN FROM EACH END.

Coupled Sections

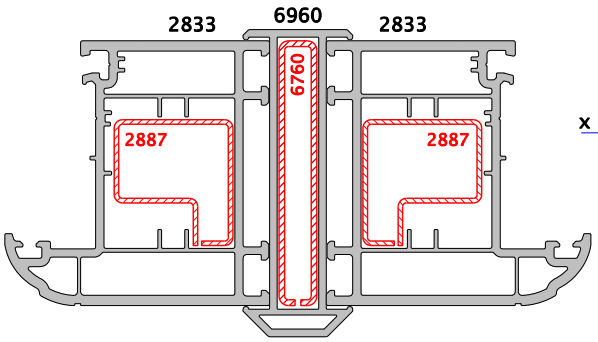
The calculated Ei values in this section are the true inertia values adjusted with the modulus of elastisity of materials used within our various section, values used are as follows:-

Material	Modulus
PVCU	2,500
Steel	205,000

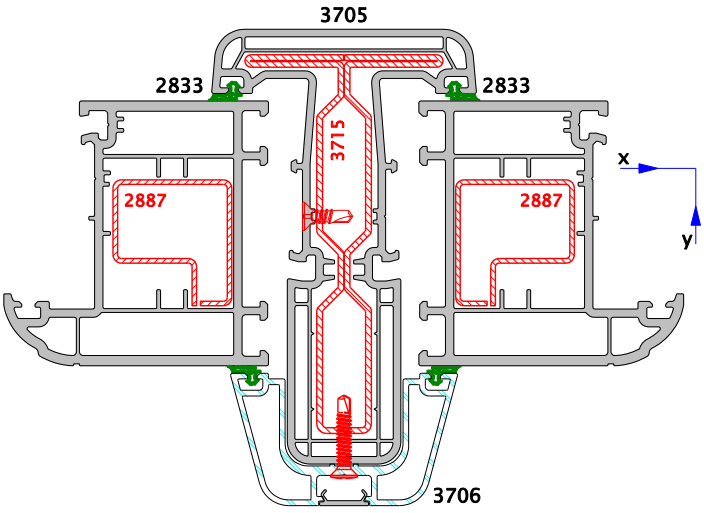
COUPLED SECTIONS MUST BE SECURED TOGETHER AT MAXIMUM 300mm CENTRES



Profiles	Coupler	Reinforcings	Eix Value (x 10 ⁹)	Eiy Value (x 10 ⁹)
2833 x 2	3197	2887 x 2	10.49	9.53



Profiles	Coupler	Reinforcings	Eix Value (x 10 ⁹)	Eiy Value (x 10 ⁹)
2833 x 2	6960	2887x2 & 6760	31.95	10.36



Profiles	Coupler	Reinforcings	Eix Value (x 10 ⁹)	Eiy Value (x 10 ⁹)
2833 x 2	3705	2887x2 & 3715	126.78	19.25

NOTE:-THE POSITIONING OF REINFORCEMENT SCREWS SHOULD BE NO GREATER THAN 300mm CENTRES AND A MAXIMUM OF 100mm IN FROM EACH END.

Requests for wind loading / exposure category calculations for windows and doors to the above standard can be dealt with in the following way:

1) Standard Method

Based upon BS 6399, this provides conservative safe results with a minimum of site data required and is particularly suited to smaller projects.
The following data must be supplied:

a) Site Post Code
b) Height to the top of the structure (eaves or ridge) containing the highest window
c) Details of individual window sizes and styles
d) Colour / finish of the PVC-U profile being used

The programme used will determine the 'Effective Wind Load' for the site to which a safe 'Net Pressure Co-Efficient' factor would be applied in accordance with BS 6375:2004 to provide a maximum wind load value for the windows. The reinforcing requirements of individual windows can then be assessed.

For wind load calculations in line with BS 6399 methods detailed on this page and/or window/scheme design service, please use the blank calculation request form on the following page.
Completed forms should be forwarded for the attention of the Technical Dept:

Fax. 01249 810921
Email. mark.castle@deceuninck.com

PLEASE ENSURE ALL RELEVANT DATA IS SUPPLIED

Data for Wind Load Calculation

Requested by: .....

Client Ref: .....

Date: ...../...../.....

Project Postcode: .....

Height of Building Eaves: .....

Proposed Window Detail(s): (Please identify style, overall size and break sizes)

(Please use additional page or your own survey sheet should the space provided not be sufficient to show all window/door styles)

Data for Scheme Design (If this service is required, please tick relevant boxes)

Finish: White ☐ Foiled/Decoroc ☐ Note. Coloured profile will require full reinforcement

Glazing Size: 28 mm ☐ 24 mm ☐ Other ☐ (Please specify) .....

Glazing Bead Style: Standard ☐ Retro ☐ Contemporary ☐ Chamfered ☐

Sash Style: Decorative ☐

BS 8213 Compliance: Will window cleaning be carried out by resident? Yes ☐ No ☐
(If no, a letter confirming this should be supplied by the contractor)

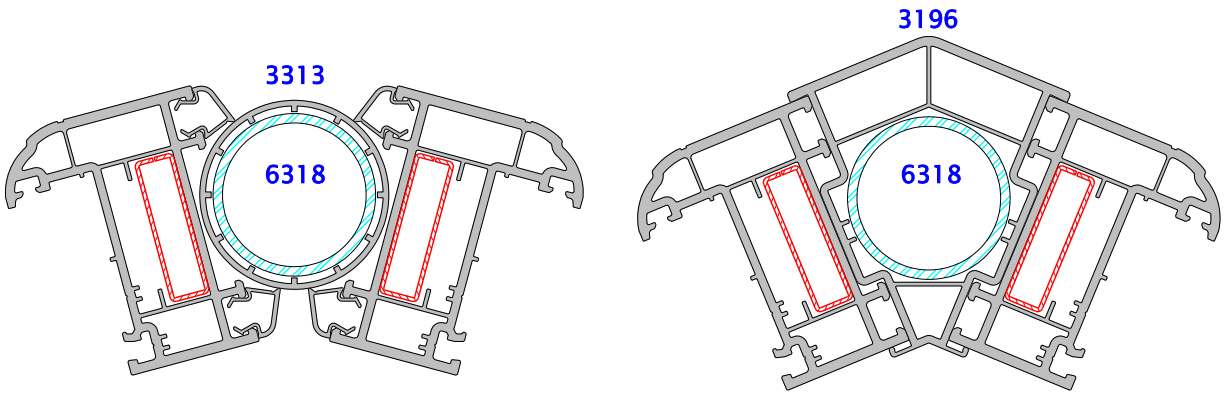
Data for Deceuninck Records

Project Size Rating: A < 25 ☐ B < 100 ☐ C ≥ 100 ☐
(Total No. of windows/doors involved)

NOTE. For calculation to 'Directional/Hybrid method', please also supply the following building details:

- Plan with overall sizes and orientation of the front face (North facing = 0°)
- Elevation(s) with overall height and location of windows

This form must be completed in full to enable an accurate and complete calculation to be made.



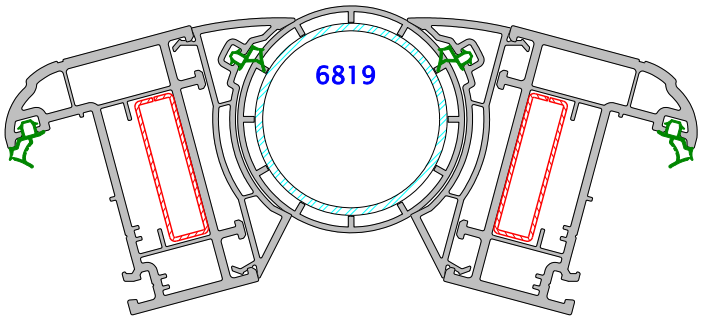
Typical configurations using 6318 Bay Pole

The table below represents the MAXIMUM loadings for 6318 ∅ 43.0mm bay pole.
These figures must be read in conjunction with the following pages :-

Section 3.1, page 3
Section 3.1, page 6
Section 3.2, page 4

BAY POLE 6318	
Height of pole in mm	Maximum load (kN)
1000	18.1
1100	17.3
1200	15.7
1300	13.4
1400	10.8
1500	10.0
1600	9.2
1700	7.6
1800	7.0
1900	6.4
2000	5.7
2100	5.4

We recommend that for all bay window installations, the advice of a structural engineer is sought to determine if the installation is load bearing. If the bay installation IS load bearing, the engineer will be able to determine the load.



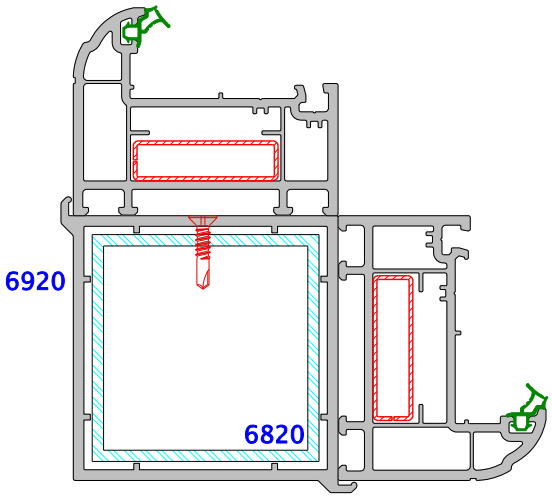
Typical configuration using 6819 Bay Pole

The table below represents the MAXIMUM loadings for 6819 ∅ 50.8 bay pole.
These figures must be read in conjunction with the following pages :-

Section 3.1, Surveying Bay Windows
Section 3.1, Bay Window Removal
Section 3.2, Transportation & Protection

BAY POLE 6819	
Height of pole in mm	Maximum load (kN)
1000	19.0
1100	18.2
1200	17.5
1300	16.7
1400	15.9
1500	15.2
1600	11.7
1700	10.4
1800	9.7
1900	8.9
2000	8.1
2100	7.4

We recommend that for all bay window installations, the advice of a structural engineer is sought to determine if the installation is load bearing. If the bay installation IS load bearing, the engineer will be able to determine the load.



Typical configuration using 6820 Square Bay Post

The table below represents the MAXIMUM loadings for 6820 Square bay post.
These figures must be read in conjunction with the following pages :-

Section 3.1, Surveying Bay Windows
Section 3.1, Bay Window Removal
Section 3.2, Transportation & Protection

BAY POST 6820	
Height of pole in mm	Maximum load (kN)
1000	47.2
1100	47.0
1200	45.1
1300	43.7
1400	42.4
1500	40.6
1600	38.9
1700	37.2
1800	37.0
1900	35.5
2000	33.8
2100	28.7

We recommend that for all bay window installations, the advice of a structural engineer is sought to determine if the installation is load bearing. If the bay installation IS load bearing, the engineer will be able to determine the load.

REINFORCEMENT GUIDELINES

Specification

■ STEEL REINFORCING

Is roll formed band-galvanised sheet steel of the type DIN EN 10 142 Fe P02 G.
Corrosion resistance in accordance with DIN EN 10147.

■ ALUMINIUM REINFORCING

Extrusions are extruded from 6060-T6 or 6063, complying with the recommendations of BS 1474.

Regulations

NOTE :- THESE REGULATIONS ARE TO BE USED ONLY FOR THE MANUFACTURE OF WINDOWS THAT DO NOT REQUIRE A SPECIFIED WIND LOADING RATING.
FOR DETAILS OF MAXIMUM TRANSOM/MULLION LENGTHS IN WINDOWS WHICH DO REQUIRE WIND LOAD RATINGS, SEE SECTION 4.1, Wind Loading.

PVCu Profile	Regulation
Small Outer Frame 2832 Large Outer Frame 2833 Outer Frame 2822	For window frames surrounded by brickwork/masonry reinforce where width or height exceeds 2000mm. For combination frames not surrounded by brick/ masonry, reinforce all members exceeding 1200mm.
"Z" Sash 2826 "T" Sash 2825	Where width or height exceeds 1000mm.
"Z" Frame 2836 "T" Frame 2835	Where width or height exceeds 1000mm.
Door Sash 2830 Doors Sash/Midrail 2831	Regardless of whether the profile is being used as a sash or a transom/mullion/midrail, reinforce where width or height exceeds 1000mm.
"Z" Tilt & Turn Sash 2828 "T" Tilt & Turn Sash 2829	Where width or height exceeds 1000mm.

■ IMPORTANT NOTES

All reinforcement cut lengths must be a minimum of 85% of the cut length of the P.V.C.u. profile, and must be inserted in one continuous length, not multiples of short pieces.
All coloured or woodgrain profiles must be fully reinforced, regardless of span, as this is an aid to heat transfer as well as support.
The positioning of reinforcement retaining screws should be no greater than 300mm centres and a maximum of 100mm in from each end.
For enhanced security Deceuninck recommend that all hardware is fixed to reinforcement

Dimensions based on overall frame size

Product	Maximum Width (mm)	Maximum Height (mm)	Maximum Perimeter (mm)
Fixed Light	2000	2000	8000
Top hung casement sash	1200	1200	-
Side hung casement sash	700	1400	-
Multilight casement window *	2400	2400	7600
Tilt & Turn sash	1200	1350	-
Multilight tilt & turn window **	3000	3000	9000
French window	1200	1200	-
Single opening door	1000	2100	-
Double opening door	2000	2400	-
Tilt & Slide Patio	2410	2200	-

* Maximum transom/mullion length including frame 1450mm
** Maximum transom/mullion length including frame 1500mm using 2859 reinforcement

Note.
All maximum size dimensions are based on BS7412 test sample results at the BSI:

Single Casement – Locally reinforced outer frame & fully reinforced sash members
Single Tilt & Turn – Fully reinforced sash
Multilight Casement – Fully reinforced sash members and transom/mullions where applicable using 2845 reinforcement.
Multilight Tilt Turn – Fully reinforced
All Door types – Fully reinforced

THERMAL PERFORMANCE

Thermal Performance

The 2006 revision to Approved Document L 'Conservation of fuel & power' is split into 4 parts came into effect on the 6th April 2006. A summary of requirements is listed for each: -

ADL1A - new dwellings:

* Based on Dwelling Emissions Rate (DER) not exceeding Target Emissions Rate (TER) - SAP calculation method.
* Max area rated U value 2.2 W/m2K (unchanged)
* No solar overheating
* Measured air permeability
* Owner to be given operating instructions

ADL1B - existing dwellings: -

a) Replacement windows
* Max whole window U value 2.0 W/m2K
* BRFC Rating of Band E min.
* Centre pane glass U value of 1.20 W/m2K

b) Extensions
* Max whole window U value 1.80 W/m2K (max 25% window area)
* BFRC Rating of Band D (max 25% window area)
* Centre pane glass U value of 1.20 W/m2K (max 25% window area)
* Trade offs possible

c) Conservatories
* No specific changes < 30m2
* Max whole window U value 2.0 W/m2K
* BFRC Rating of Band D min.
* Centre pane glass U value of 1.20 W/m2K

ADL2A - existing buildings (not dwellings)

* Buildings Emission Rate (BER) must not exceed Target Emission Rate (TER) - SBEM software calculations used
* Max whole window U value 2.20 W/m2K
* No solar overheating
* Measured air permeability
* Owner to be given operating instructions

ADL2B - existing buildings (not dwellings)

a) Replacement windows
* Max area rated U value 2.2 W/m2K
* BFRC Rating of Band E min. (domestic in character)
* Centre pane glass U value of 1.20 W/m2K

b) Extensions
* Extensions over 100m2 to comply with ADL2A
* Max whole window U value 1.80 W/m2K
* BFRC Rating of Band D (domestic in character)
* Centre pane glass U value of 1.20 W/m2K
* Trade offs possible

c) Conservatories
* Max whole window U value 2.0 W/m2K
* BFRC Rating of Band E min.
* Centre pane glass U value of 1.20 W/m2K

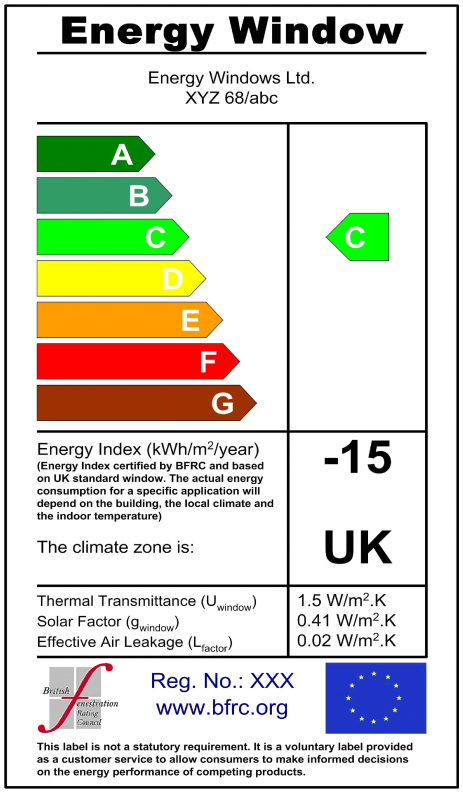
Notes

* Energy Rating for certain building categories has been introduced for the first time as a means of demonstrating compliance with Building Regulations. Please refer to the following page for details of the scheme.

THERMAL PERFORMANCE

Energy Rating

- Energy Rating of whole windows and doors is an additional means of demonstrating compliance with Building Regulations – refer appropriate sections of Approved Document L of the Building Regulations (effective 6th April 2006)
- The scheme operates a system of Banding of Energy Rating values from A to G – Band A is the most thermally efficient.
- Deceuninck products have been simulated for energy efficiancy in accordance with standard EN 10077 – 2: 2003 and ratings have been obtained in Bands from E through to A. Movement between Bands is most easily achieved by varying the specification of the glass unit.
- The higher energy efficient Bands of C and above normally require the use of 'warm edge' spacer bar technology within the glass unit.
- Windows and doors which have an energy rating in Band C or better, can also carry the Energy Efficiency lable through the best practice in Housing scheme operated through the Energy Saving Trust on behalf of the UK government.



The following table is a guide to understanding how different U values can be achieved by using various methods of manufacture for the double glazed unit.

Table A1 Indicative U-Values (W/m2K) for windows and rooflights with wood or PVCu frames, and doors

	Gap between panes			Adjustment for rooflights in dwellings [3]
	6mm	12mm	16mm or more	
Single glazing		4.8		+0.3
Double glazing (air filled)	3.1	2.8	2.7	
Double glazing (low-E, n=0.2)[1]	2.7	2.3	2.1	
Double glazing (low-E, n=0.15)	2.7	2.2	2.0	
Double glazing (low-E, n=0.1)	2.6	2.1	1.9	
Double glazing (low-E, n=0.05)	2.6	2.0	1.8	
Double glazing (argon filled)[2]	2.9	2.7	2.6	
Double glazing (low-E, n=0.2, argon filled)	2.5	2.1	2.0	
Double glazing (low-E, n=0.1, argon filled)	2.3	1.9	1.8	
Double glazing (low-E, n=0.05, argon filled)	2.3	1.8	1.7	+0.2
Triple glazing	2.4	2.1	2.0	
Triple glazing (low-E, n=0.2)	2.1	1.7	1.6	
Triple glazing (low-E, n=0.1)	2.0	1.6	1.5	
Triple glazing (low-E, n=0.05)	1.9	1.5	1.4	
Triple glazing (argon filled)	2.2	2.0	1.9	
Triple glazing (low-E, n=0.2, argon filled)	1.9	1.6	1.5	
Triple glazing (low-E, n=0.1, argon filled)	1.8	1.4	1.3	
Triple glazing (low-E, n=0.05, argon filled)	1.7	1.4	1.3	
Solid wooden door [4]		3.0		

Notes

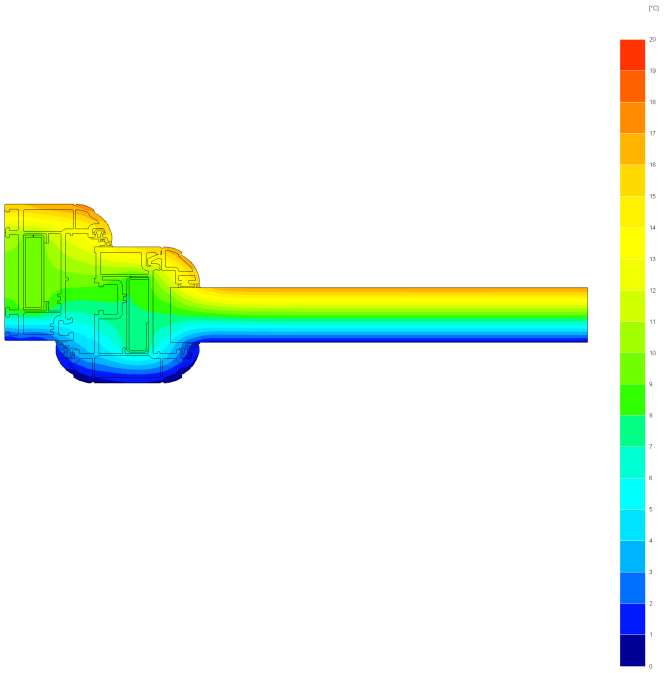
[1] The emissivities quoted are normal emissivities. (Correct emissivity is used in the calculation of glazing U-values) Uncoated glass is assumed to have a normal emissivity of 0.89.

[2] The gas mixture is assumed to consist of 90% argon and 10% air.

[3] No correction needs to be applied to rooflights in buildings other than dwellings.

[4] For doors which are half-glazed the U-value of the door is the average of the appropriate window U-value and that of the non-glazed part of the door (e.g. 3.0W/m²K for a wooden door)

From the table on page 3 of this section we can see that using a combination of a double glazed unit of :-
4/20/4 (Low-E,∈n=0.15) air filled, the Deceuninck 2800 window system complies with the revised legislation.



The U-value of this section is 1.73 W/m²K.

Quality Statement

To Deceuninck, our customers represent the key to expansion. As such, we have to do our utmost to be recognised by those customers as a trustworthy partner who consistently delivers quality.

Every member of our company, with his or her specific responsibility and authority, can contribute in an active manner to the continuous quality improvement of our products, processes, services and communication.

In saying this, we are all aware of the importance of the quality notion in the broadest sense of the word.
Setting up a quality system according to the requirements of ISO 9001 is one of the elements destined to contribute to an increasing 'quality consciousness' with every person working within this company.

Quality Management System

The Quality Management System within Deceuninck Ltd. is an integral part to achieving our customer satisfaction. It is our foundation for success, our guide for continuous improvement, and above all a neccessity in gaining international accreditation.

This accreditation, issued by The Lloyds Register, certifies that the Quality Management System of Deceuninck Ltd. has been approved by Lloyds Register Quality Assurance to the Quality Management System Standard ISO 9001:2000.

The Quality Management System is applicable to;
The manuafacture of extruded PVC-U profiles for use in the building industry and for the fabrication of windows and door. Factoring of extruded PVC-U profiles and associated metal reinforcements and fixings for the building industry.

Approval Certificate No. LRQ 0870823

This section outlines the precautions to be taken in handling p.v.c.u. profiles manufactured by Deceuninck.

Deceuninck extruded profiles are manufactured from a p.v.c.u. composition which is a blend of p.v.c.u. and a variety of additives such as stabilisers, fillers, plasticisers, pigments, etc.

■ POTENTIAL HAZARDS

■ Toxicity – Inhalation of monomer

A constituency of P.V.C. is VCM which is a carcinogen. However, the release of VCM into the atmosphere in an extrusion plant only produces trace levels considerably lower than require monitoring. Therefore at fabrication stage, where the only application of heat is at welding, the emission can be considered zero.

■ Toxicity – Inhalation of dust

P.V.C. dust is considered a "nuisance dust" defined as producing no irreversible change in living tissues when exposures are kept under reasonable control, e.g. to a hygiene level standard of 10 mg per cubic metre.

As dust in fabrication can only be produced by dry sanding, then this is the only area where there is an element of risk and suitable face masks should be worn

■ Toxicity – Ingestion

In fabrication the only possibility of ingestion is of dust or saw dust. Any toxic ingredients which may be present in raw material are not readily extracted from the fully compounded material from which dust or saw dust at fabrication level is formed. Therefore such material can again only be termed "nuisance dust" and normal precautions should be taken.

■ Toxicity – Dermatology

P.V.C. is not considered a skin irritant or sensitising agent.

■ Toxicity – Fire – Ignition and burning characteristics

Most p.v.c. compositions, under normal conditions of storage and use, are not flammable, but in common with other organic materials they can be consumed by fire. When p.v.c. products are stored it must be recognised that the packages and pallets themselves are a fire risk and are generally a much more likely route for rapid fire spread.

■ Toxicity – Fire – Decomposition products

The major products of combustion/decomposition of p.v.c. compositions are carbon dioxide, carbon monoxide and hydrogen chloride, additionally, many other minor decomposition products have been identified. Carbon monoxide and hydrogen chloride are toxic with threshold limit values–50 ppm and 5ppm respectively, and inhalation must be avoided. In addition hydrogen chloride is corrosive in the presence of moisture. The nature and proportion of such decomposition products will vary according to the formulation, though there will not normally be additional hazard, toxic or corrosive, to that associated with carbon monoxide and hydrogen chloride.

■ Toxicity – Fire – Decomposition products (continued)

Most available fire extinguishers are effective in fighting fires involving p.v.c., although due note should be taken of the particular situation (e.g. when live electrical equipment is nearby) which may restrict the use of some media. Advice should be sought from the local fire authority as to the most suitable types of extinguisher to be installed. In the event of small localised fire, immediate action should be taken by personnel in the vicinity using available extinguishers. Care should be taken to avoid inhalation of decomposition fumes. When the fire has been extinguished, ventilation should be increased to clear the fumes as quickly as possible.

It is important to advise the fire fighting personnel, including the fire brigade, to wear acid resistant protective clothing and full face masks. The fire brigade should also be notified that p.v.c. compositions are involved. Suitable breathing equipment should be worn by fire fighters exposed to the products of combustion. Qualified medical aid should be sought in the event of anything more than very temporary irritation to the skin, eyes, throat, etc, is experienced. As highly corrosive hydrogen chloride is given off during the combustion of p.v.c., directly affected areas should be cleaned down to remove corrosive decomposition on equipment etc, as soon as possible after the fire has been extinguished.

■ VENTILATION AND EXTRACTION

Good ventilation should be provided in any working area where p.v.c. is handled. Any activity which can lead to dust or fumes being generated should be dealt with by suitable extraction equipment as far as is reasonably practical.

Extra attention should be paid to the provision of adequate extraction when machinery or parts of machinery are being cleaned.

Compressed air should not be used to avoid the generation of dust.

■ RECOMMENDED FIRST AID TREATMENT

■ Inhalation of noxious fumes

The patient should be removed as rapidly as possible into fresh air. Artificial repiration should be applied if necessary. Seek expert medical attention.

■ Eye injuries

Dust or swarf should be flushed from the eye by irrigation with water. Seek expert medical attention

■ Ingestion

Medical attention should be sought immediately

■ General

It is important when summoning medical attention that the doctor or hospital is fully advised in detail of the nature of the product being handled.

Specification

P.V.C.u. profiles are extruded from impact modified unplasticised polyvinyl chloride, tested to BS 2782, profiles are extruded to conform to BS 7413.
P.V.C.u. compound has a fire resistance to BS 476, part 7, class 1. P.V.C.u. extruded hollow profile has a fire resistance to BS 476, part 7, class 2.
P.V.C.u. profiles are multi-chambered and have a main wall thickness of between 2.3mm and 3.0mm.
Gaskets are weldable multifunctional triple hardness Thermoplastic Elastomer.
White P.V.C.u. profiles are extruded to RAL No. 9016.

Storage

The profiles are packed in two ways:-
a) Loose packed in polyethylene sleeves.
b) Bulk packed in stillages in polyethylene shrink-wrap
When racked the package should be opened at both ends, to provide vetilation through the profile and prevent condensation.
Profiles should not be stored in the open and protection should be provided from moisture and direct sunlight.
All profiles should be stored fully supported along their length in a flat and straight condition. Uneven support over long periods will lead to sagging and distortion of the profiles.
To avoid damage such as scratching, profiles should be lifted from the stack and NOT dragged along it's full length.
When processed, profiles should be stored at a minimum of 17° c. Profiles stored at lower temperatures should be brought into the work area long enough in advance for the profile to warm through, up to a minmum of 17° c. Welding below the recommended temperature will produce stresses which can lead to cracking.
Stock rotation should be performed on a regular basis to ensure that old profile is not left at the bottom of the stack.

Waste disposal

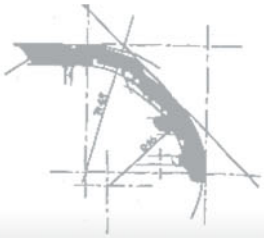
Disposal of waste is controlled by the "pollution prevention and control act 1999". Before disposing of contaminated waste compositions, it is recommended that advice be sought from the waste disposal officer of the local authority concerned.

The information contained in this text is to the best of our knowledge true and accurate. However, since the conditions under which our products are used are beyond our control, recommendations are made without warranty or guarantee. This statement does not affect the statutory rights of a consumer.

2800 decorative

GENERAL GUIDELINES

WELDING
INSTALLATION OF GLASS



deceuninck

WELDING

OBSERVE HEALTH & SAFETY REGULATIONS AT ALL TIMES. USE ANY PROTECTIVE WEAR SUPPLIED TO ENSURE SAFE USE OF MACHINERY FOR YOURSELF AND OTHERS AROUND YOU.

■STORAGE

Ensure profiles are stored flat to reduce risks of deformation
Allow profile to aclimatise to the manufacturing enviroment temperature before use

■SAW

Ensure bed/back fences are clear of swarf
Check profile sits correctly on blocks/machine bed
Check cut size of profile at regular intervals
Keep working area around saw clean & tidy

■PREPARATION

■REVERSE BUTT WELDING

Check temperature of heater plate
Ensure back fences are set in-line (180°)
Clean off weld sprue neatly

■V NOTCHING

Check setting for V notch depth according to profile being welded-in
Ensure any measured lines are correct (measure twice, cut once)
Ensure rebate shoulder alignment is correct

■REINFORCING

Familiarise yourself with the reinforcing guidelines within the technical manual
All reinforcing to be fitted in one continuous length (wherever possible)
Screw fixing/spacings as specified in the technical manual

■DRAINAGE

Ensure the correct drainage method is used for the frame type (int/ext bead, etc)
Ensure the area is kept free from swarf

■ROUTING

Check handing of sashes and door handles prior to routing

■WELDING

Check daily/periodically:-temperature of heater plates, condition of Teflon, cleanliness of Teflon
Change Teflon as required
During the welding process, make physical checks of the welds including dimensional checks

■SASHES

Check condition of weld blocks, file off any small burrs that could scratch the sections
Ensure weld blocks are fitted correctly
Check handing to ensure drains are welded correctly

■FRAMES

Work out the best method for welding the individual frame to allow for any remaining reinforcing to be inserted during welding
Check measurement of frame sections
Butt up any corresponding V notches to ensure they match up
Ensure all fences are set correctly to support the profile
Check the correct sections have been used
Ensure all sections in the welder are the correct way, i.e. large face/small face up, drainage is correct
Remember, "it's not wrong, 'til it's welded", so double check before starting the welding process
Insert any remaining reinforcing prior to final weld cool-off, i.e. through mid-rail welds, etc.

WELDING

■ CLEANING OFF

Insert reinforcing screws to remaining sections

Check finished frame size is within manufacturing tolerances

Check all grooves are clean

Chip out weld sprue from any internal edges

■ HANGING

Ensure handing of sashes is correct against work sheet specification

Ensure all keeps are fitted in the correct position

Check operation of locking mechanism within the keeps

■ BEADING & QUALITY CONTROL

Check frame for size, square & style, any discrepancies should be reported and rectified

Ensure mitred beads are a snug fit but not too tight as this will damage the ends and make them hard to insert when glazing.

Finally check for smooth operation of all components prior to placing product in the dispatch area

BE AWARE OF COMPANY HEALTH & SAFETY PROCEDURES ALONG WITH OBSERVING COMPANY QUALITY PROCEDURES

WELDING

1. IMPORTANCE OF THE WELDING PROCESS

The joining of the corners is one of the most critical operations when manufacturing windows & doors. This takes place in the welding process, in which a number of parameters influence the quality. A good weld is essential for the strength of the frame and should resist minimal forces. Moreover, the welding is also important for obtaining the correct frame dimensions.

2. THE WELDING CYCLE

After the correct positioning and clamping (clamping pressure) of the profiles, both are pushed against the heating plate (melting pressure) which reaches a controlled temperature. Firstly, a quantity of the material is melted due to the heat transfer and the movement (melting path) of the welding heads. Because the movement is mechanically restricted, a heat transfer will only take place during a fixed time (heating time) in a second stage. Here the heating plate is retracted (interface), after which the profiles are pressed together with a controlled force (assembly pressure) and over a limited distance (assembly path). The profiles are then kept in this position for a controlled time (assembly time).

3. REQUIREMENTS BEFORE WELDING

The profiles must be conditioned for at least 24 hours until the temperature reaches at least 15° C over the entire section. During storage no deformations should take place. This means that the profiles have to be stored horizontally making sure that the distance between the points of support are not longer than 1 metre.
Any packaging should be opened (e.g. at the front), or completely removed to allow any condensation to evaporate. Correct cutting dimensions require special attention when sawing. The saw blade needs to have sufficient and sharp enough cutting teeth, of which the rotation speed and the feed must also be adapted. The welding surface must not be damaged and free from any impurities. It is also imperative to maintain a clean welding surface when inserting the reinforcements, avoiding any dirt build-up caused (e.g. by greasy hands).

4. THE WELDING MACHINE

We can distinguish 2 principles depending on how the tables are moving towards each other. When the motion is perpendicular to the heating plate surface, then we talk about a parallel motion, which is mostly the case for single head welding machines. When using multi-head welding machines the movement is at a 45° angle (to the heating plate surface), this is called a diagonal motion. Most machines are equipped with adjustable restrictor knives in the clamping shoes. The distance of the knives is also decisive for the welding quality. The optimum distance can vary between 1 and 2mm in the end poisition. If the knives are heated, it is very important that the temperature does not exceed 40° C.

5. THE WELDING PROCESS, THE WELDING PARAMETERS

5.1. POSITIONING

Both profiles must be positioned correctly in the machine. This implies that the profiles are level and are completely pushed against the profile support blocks. Adapted support blocks are required to avoid deformation during clamping. The pressure of the clamping shoes onto the profiles needs to be sufficiently high to prevent the movement of profiles during welding.

5.2. MELTING

Heated welding plates are used to heat the profiles. The welding plate is equipped with a thermostat and is covered with a Teflon film on the outside. This avoids profiles sticking to the welding plate when contact is made. The thermostat must be attached in such a way that the heat build-up is spread equally over the entire surface and that a minimum power of 2 W/cm one-sided welding surface is guaranteed. An initial temperature of 255-260° C is required for the compound used. We pass into the melting phase when the profiles are pushed against the heating plate. By controlling the melting pressure we create a melting time of between 10 and 12 seconds. This is the time required by the machine to reach the end of the movement, the so-called melting path. This limited movement is a machine setting.

WELDING

■ 5.3 HEATING

The material needs to be sufficiently heated in its depth to obtain a good welded joint. In order to achieve this, the profiles are pushed against the heating plates for a further 20 seconds. There is no further movement in this stage.

■ 5.4 REPOSITIONING

Obviously, the removing/release of the welding plate is necessary to obtain a good welded joint of the profiles. The stage, in which this takes place, must be as short as possible. On the other hand this stage should not be forced to quickly. However, if we interrupt the cycle at this point, we obtain a so-called "welding interval". Due to this interval the welding surfaces can be observed and provide us with information concerning the heat transfer.

■ 5.5 ASSEMBLY & COOLING

The profiles must be pushed together to reach the ultimate fusion of the profiles. Here another movement takes place, which can be influenced by the machine setting. The profiles are kept in this position for at least 30 seconds. This period is called the assembly phase or the cooling phase.

■ 5.6 OVERVIEW OF WELDING PARAMETERS

■ 5.6A TEMPERATURE

Heating plate temperature: 255-260° C

■ 5.6B PRESSURE

Clamping pressure: minimum in order to prevent movement of profiles
maximum so that a deformation does not take place
In reality this pressure will vary between 4 and 6 bar.

Melting pressure: Adjusted in order to obtain a melting time between 10 and 12 seconds at 255° C - 260° C heating plate temperature.

Assembly pressure: Regulated so that the pressure in the weld reaches 0.85N/mm² or between (0.5 and 1.4N/mm²)

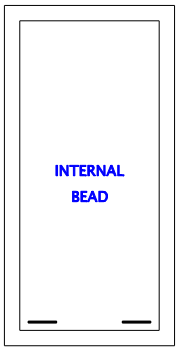
■ 5.6C TIME

Melting time : 10 to 12 seconds
Heating time : 20 seconds
Cooling time : minimum 30 seconds

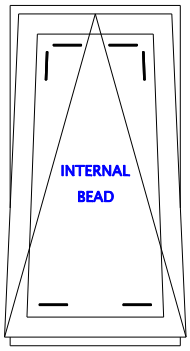
■ 5.6D TRAVEL

Melting travel : 2/3 total travel
Assembly travel : 1/3 total travel

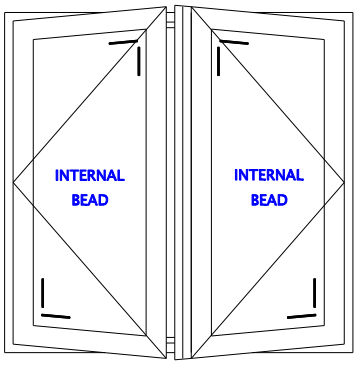
Glazing blocks and packers should be fitted at maximum centres of 500 mm and be a maximum of 150 mm from the corner of the unit, unless otherwise stated.



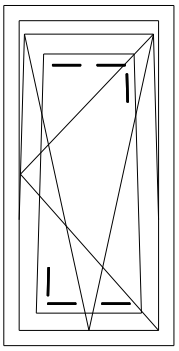
FIXED LIGHTS



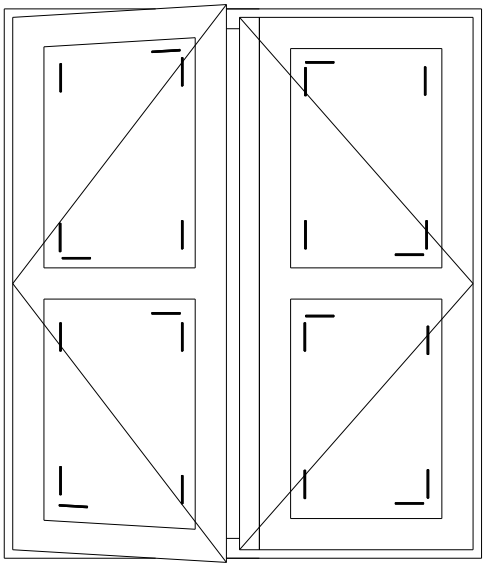
TOP HUNG



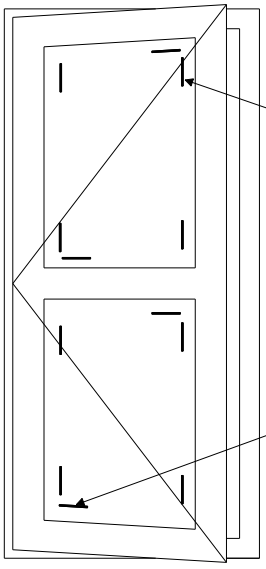
FRENCH WINDOWS



TILT & TURN

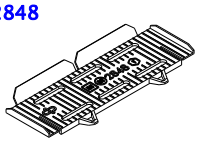


DOUBLE RESIDENTIAL DOORS



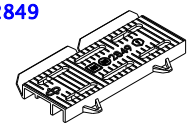
RESIDENTIAL DOORS

2848



To be used at sides only.

2849



To be used at bottom of glass only

Note.
These diagrams are intended as a guideline only.