

EBE 75
CATALOGO
TECNICO
TECHNICAL
CATALOGUE

METALFORM

secco

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Sistema integrato di profili, accessori e guarnizioni a taglio termico con profili aventi sezione di 73.5 mm, idoneo per la realizzazione di porte e finestre, rettangolari, sagomate o curve con o senza fissi laterali e superiori.

I **profili in metallo** componenti il sistema sono dello spessore di 15/10 mm e sono ottenuti tramite profilatura a freddo di nastri nei vari materiali previsti dal sistema.

Il **taglio termico** dei profili è realizzato tramite un estruso in poliammide rinforzato con fibra di vetro reso solidale alle parti in metallo esterne da una resina poliuretanicca ad alta densità, iniettata ad alta pressione. Il collegamento che si ottiene è continuo, privo di interruzioni e garantisce la massima resistenza torsionale e flettente.

La **costruzione dei telai** prevede l'unione tra i profili tramite saldatura in continuo delle sezioni in contatto e la successiva ripresa delle superfici in vista, o l'utilizzo di un sistema misto ad assiemaggio meccanico a saldatura interna che non necessita di riprese di finitura. Il sistema prevede la possibilità di alloggiare **vetri singoli o stratificati** (di sicurezza) a una o più camere.

Sistema porte:

Coplanarità delle ante;

Doppia guarnizione di tenuta per elevate caratteristiche prestazionali e acustiche;

Completa dotazione di accessori negli stessi materiali del profilo;

Cerniere a saldare, ad avvitare e a scomparsa per grandi portate;

Maniglie dedicate nei materiali previsti dal sistema;

Paraspifferi inferiore con guarnizione a pinna.

Sistema finestre:

Coplanarità delle ante;

Sistema di guarnizioni a giunto aperto per le massime prestazioni di resistenza all'aria, acqua e vento ed elevati valori di resistenza acustica;

Finestra a due ante con nodo centrale da 107 mm senza l'aggiunta di profili per l'inversione di battuta;

Completa dotazione di accessori:

Ferramenta per apertura ad anta ribalta a scomparsa per portate fino a 130 kg e classe RC3 all'effrazione

Ferramenta per apertura a vasistas per portate fino a 100 kg

Maniglie dedicate nei materiali previsti dal sistema.

Thermally insulated integrated system of profiles, accessories and gaskets with section of 73.5 mm suitable for rectangular, trapezoidal, arched shaped doors and windows with or without fixed side light.

The metal profiles that make up the system are 15/10 mm thick and are obtained from the cold-forming of the coils in the various materials available.

The profile thermal break is connected by means of a glass-fibre reinforced, extruded polyamide that becomes one with the external metal parts with the use of a high density polyurethane resin, injected at high pressure. The connection is continuous, without interruptions, guaranteeing maximum resilience to torsional and bending stress.

The assembly of the frames requires that the profiles be connected by welding together the sections in contact and then that the visible welds must be ground down neatly and finished, or by combining mechanical assembly and internal welding that does not require the retouching of the finish.

The system permits to use double or triple thermal insulated glazing with **single or stratified glass** (security glass).

Doors system:

Coplanarity of the doors;

Double sealing gasket for high performance and acoustics;

Complete with accessories in same material as profile;

Hinges to be welded, screwed or concealed for large capacities;

Selection of handles in materials provided for by the system;

Bottom draught excluder with fin gasket.

Windows system:

Coplanarity of the leaves;

System of open joint gaskets for maximum resistance to air, water and wind, as well as high levels of acoustic resistance;

Two-leaved window with 107 mm central section without the addition of profiles for reverting rebate;

All accessories furnished;

Hardware for opening of tilt-and-turn retractable window for capacities up to 130 kg and class RC3 break-in resistance;

Hardware for bottom-hung openings for capacities up to 100 kg;

Handles in the materials provided for by the system.

PRESTAZIONI

Sistema finestre

Trasmittanza termica (UNI EN 10077-2)

-Nodo tipo (acciaio inox) con $U_f=2,1 \text{ W/m}^2\text{K}$

-Finestra tipo (1230x1480 mm con $U_g1,0$) $U_w=1,5 \text{ W/m}^2\text{K}$

Isolamento acustico (UNI EN 717-1)

-Fino a 47 dB

Resistenza all'aria (UNI EN 12207)

-Classe 4

Resistenza all'acqua (UNI EN 12208)

-Classe 9A

Resistenza al vento (UNI EN 12210)

-Classe C5

Resistenza alla forza di azionamento (UNI EN 13115)

-Classe 1 - < 100 N

Prova carico verticale e torsione statica (UNI EN 13115)

-Classe 4 - 800 N / 350 N

Prova di durata a cicli di apertura (UNI EN 12400)

-Classe 2 - 10.000 cicli

Resistenza della giunzione a taglio termico (EN14024)

-Classe CW / TC2

PERFORMANCES

Windows system

Thermal transmittance (UNI EN 10077-2)

-Typical section (stainless steel) with $U_f=2,1 \text{ W/m}^2\text{K}$

-Typical window (1230x1480 mm with $U_g1,0$) $U_w=1,5 \text{ W/m}^2\text{K}$

Acoustic performance (UNI EN 717-1)

-Up to 47 dB

Air permeability (UNI EN 12207)

-Class 4

Watertightness (UNI EN 12208)

-Class 9A

Resistance to wind load (UNI EN 12210)

-Class C5

Operating forces (UNI EN 13115)

-Classe 1 - < 100 N

Mechanical properties (UNI EN 13115)

-Classe 4 - 800 N / 350 N

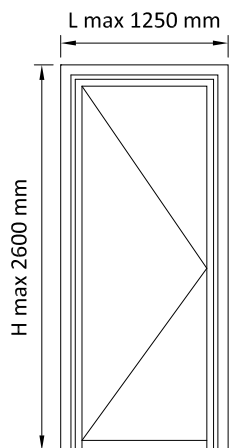
Resistance to repeated opening and closing (UNI EN 12400)

-Class 2 - 10 000 opening and closing movements

Thermal break resistance of joint (EN12024)

-Class CW / TC2

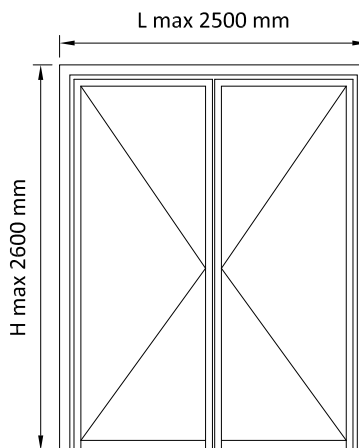
Limiti dimensionali - Maximum dimension



porta ad un anta
one-leaf doors

peso massimo anta*
*maximum leaf weight**

- AC1033 - 160 kg
- AC1037 - 250 kg
- AC1068 - 180 kg
- AC6023 - 200 kg



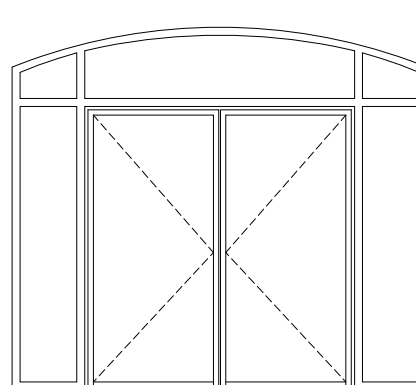
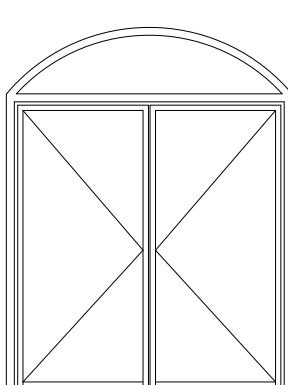
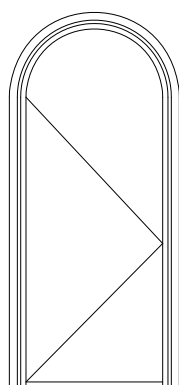
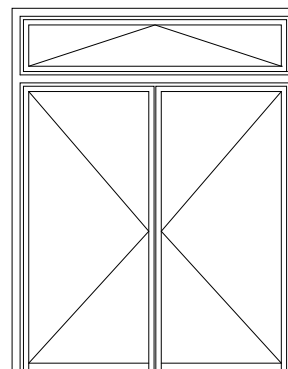
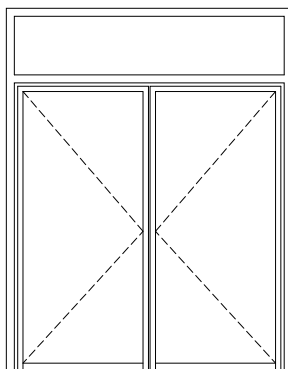
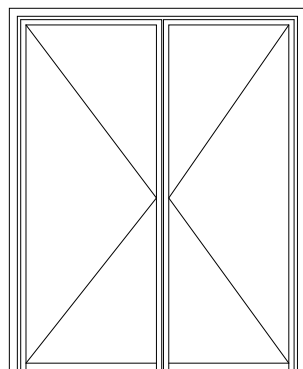
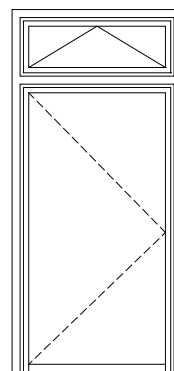
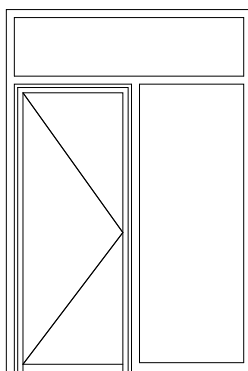
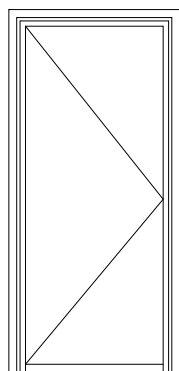
porta a due ante
two-leaf doors

peso massimo anta*
*maximum leaf weight**

- AC1033 - 160 kg
- AC1037 - 250 kg
- AC1068 - 180 kg
- AC6023 - 200 kg

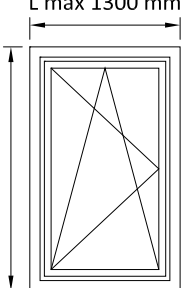
* cerniera aggiuntiva per H serramento > 2200 mm
additional hinge for doors with height > 2200 mm

Esempi tipologie realizzabili - Types of door



Limiti dimensionali - Maximum dimension

L max 1300 mm



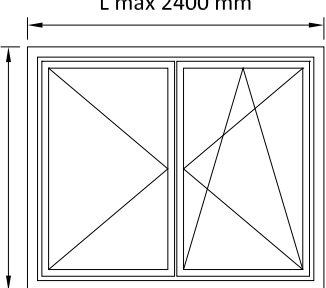
H max 2900 mm

finestra ad un anta
one-leaf opening windows

peso massimo anta
maximum leaf weight

AGE281 - 130 kg Easy
 AGE282 - 130 kg Easy

L max 2400 mm



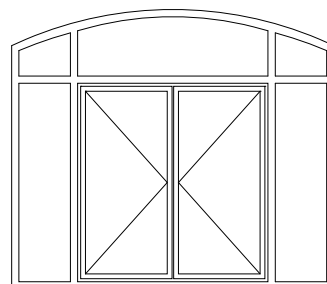
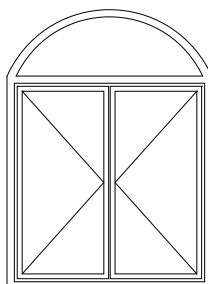
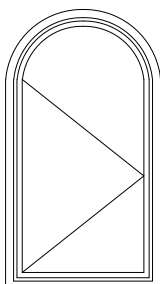
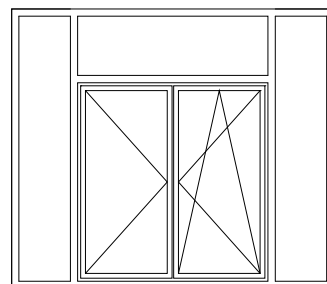
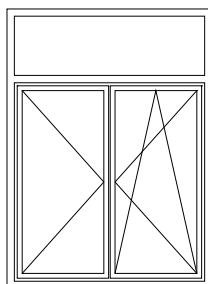
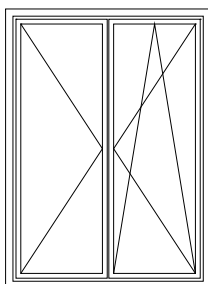
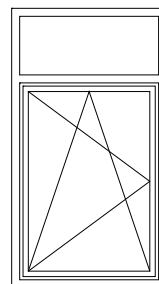
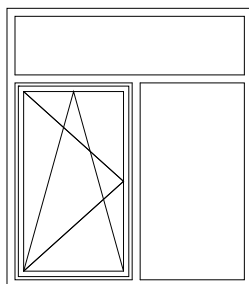
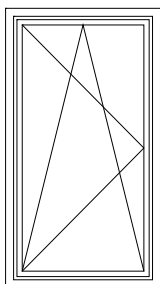
H max 2650 mm

finestra a due ante
two-leaf opening windows

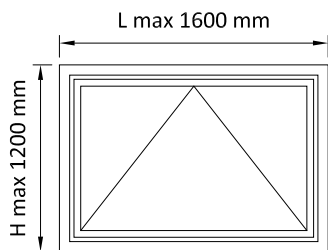
peso massimo anta
maximum leaf weight

AGE281 - 130 kg Easy
 AGE282 - 130 kg Easy
 AGE785 - 130 kg Easy
 AGE786 - 130 kg Easy

Esempi tipologie realizzabili - Types of window



Limiti dimensionali - Maximum dimension

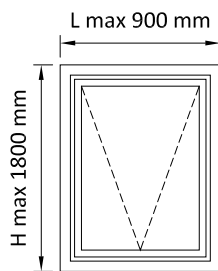


finestra a vasistas
bottom-hung window

peso massimo anta
maximum leaf weight

AG1264 - AG1274
AC2632/C - 100 kg

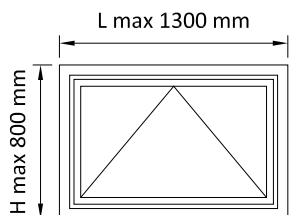
ferramenta e cremonese
hardware and cremone



finestra a sporgere
awning window

peso massimo anta
maximum leaf weight

AC1046 - 75 kg
AC1046M - 120 kg



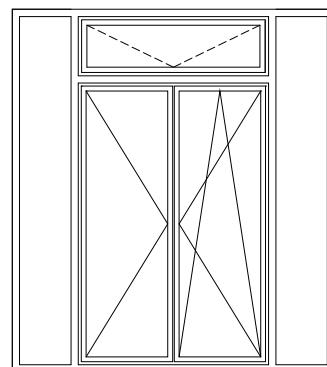
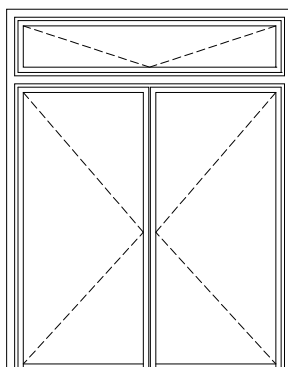
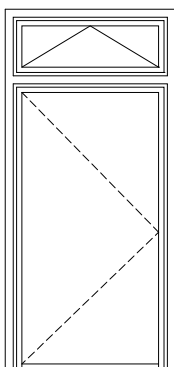
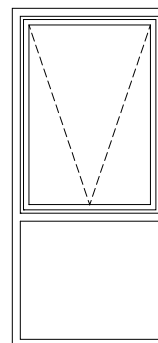
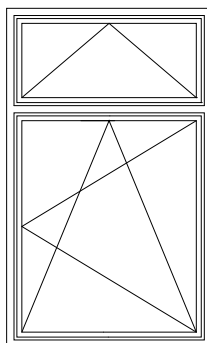
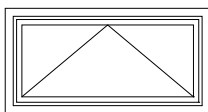
finestra a vasistas
bottom-hung window

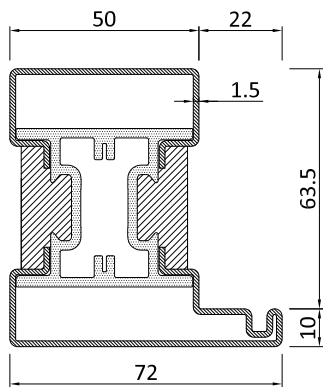
peso massimo anta
maximum leaf weight

AC1235
AC2632/C - 70 kg

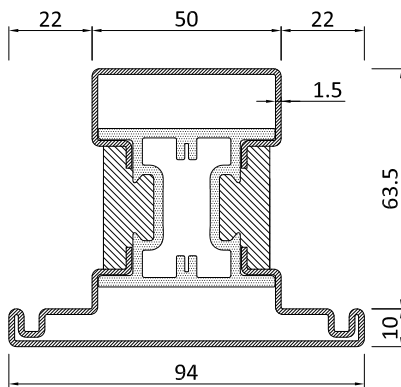
braccetti e cricchetto
stays and finger catch

Esempi tipologie realizzabili - Types of window

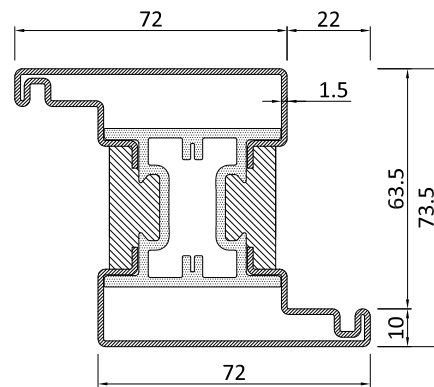




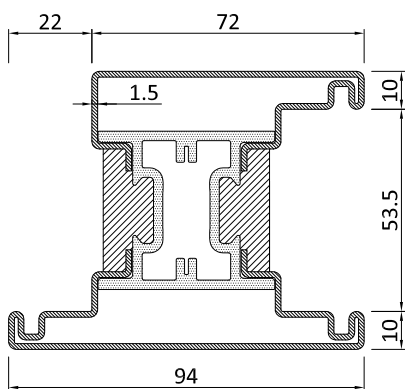
P.1601



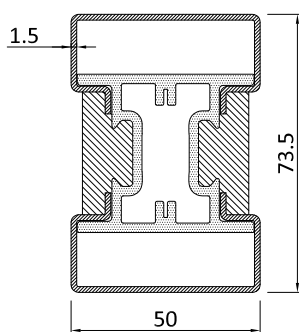
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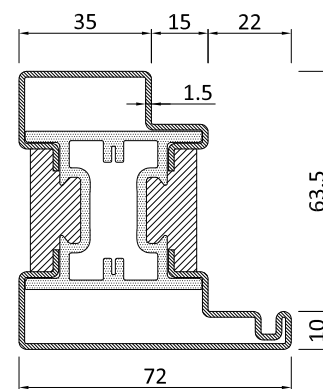
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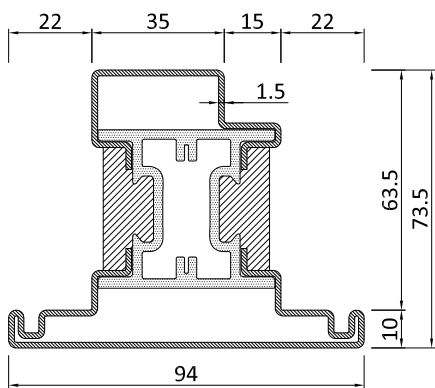
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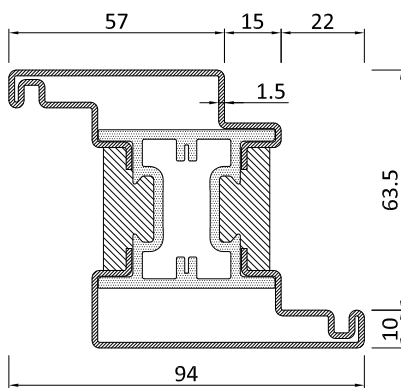
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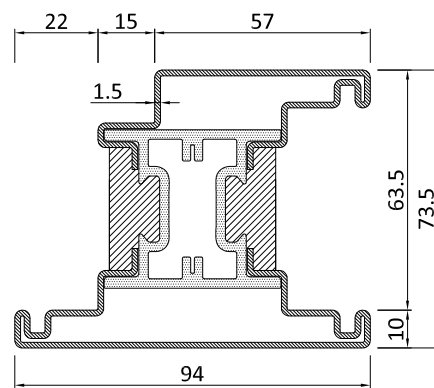
P.1611



P.1612

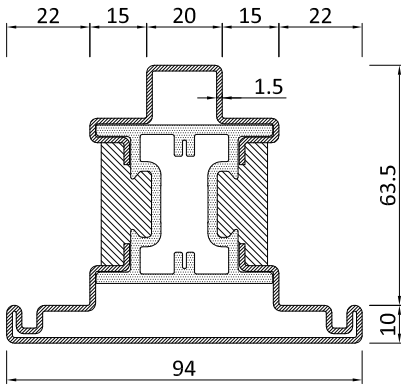


P.1613

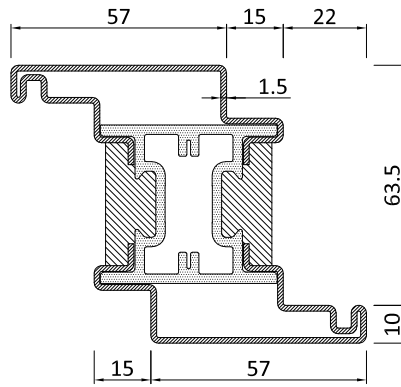


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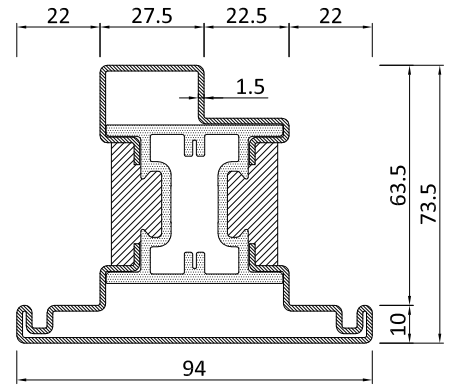
Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m	Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m
	ZN / I - CT	OT						ZN / I - CT	OT				
P.1601	4,59	4,50		25,24	21,92	6,0	P.1611	4,55	4,81		23,62	21,11	6,0
P.1602	5,13	5,43		27,63	37,36	6,0	P.1612	5,09	5,39		25,88	36,22	6,0
P.1603	5,16	5,48		30,04	34,49	6,0	P.1613	5,15	5,46		28,83	33,08	6,0
P.1605	5,70	6,06		33,18	47,37	6,0	P.1615	5,69	6,04		31,86	45,72	6,0
P.1610	4,02	4,22		21,49	12,17	6,0							



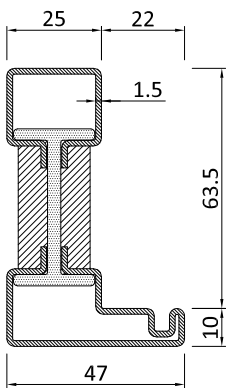
P.1622 Non fornito in acciaio zincato
Not in galvanized steel



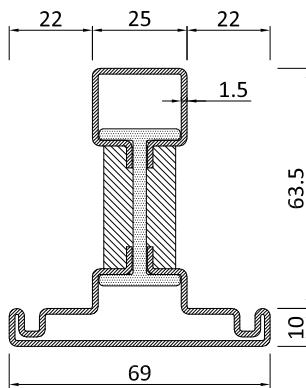
P.1623



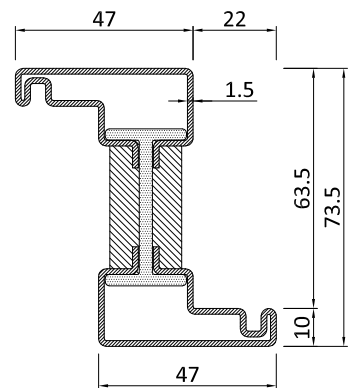
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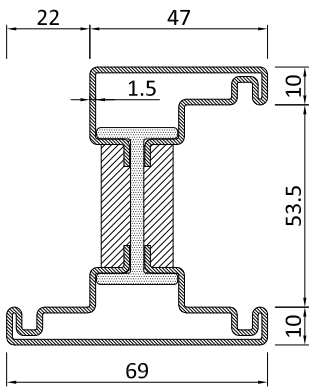
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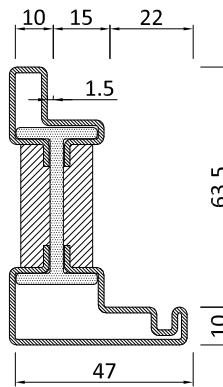
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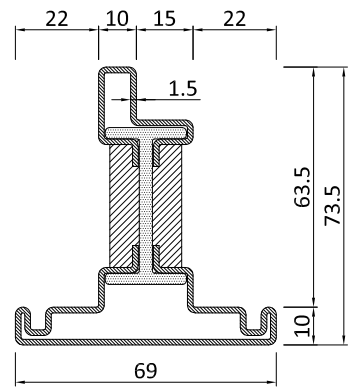
P.1703



P.1705

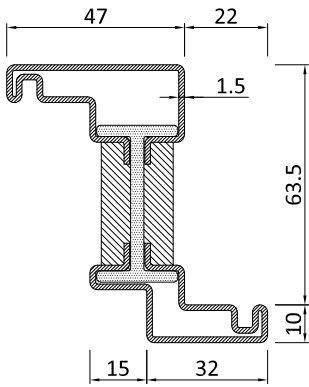


P.1711

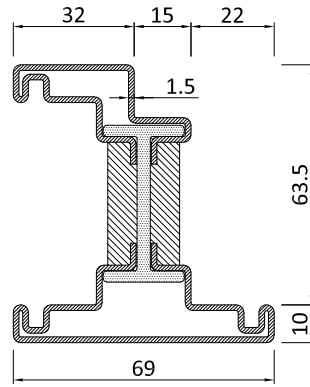


P.1712

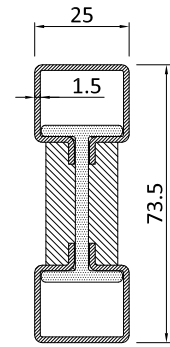
Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m	Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m
	ZN / I - CT	OT						ZN / I - CT	OT				
P.1622	5,15	5,46	0,38	24,05	35,22	3	P.1703	4,01	4,27	0,33	24,95	12,71	6
P.1623	5,14	5,44	0,38	27,65	31,70	6	P.1705	4,56	4,87	0,38	28,43	18,76	6
P.1627	5,13	5,43	0,38	25,00	36,05	3	P.1711	3,41	3,62	0,28	17,41	6,56	6
P.1701	3,43	3,64	0,28	19,26	6,59	6	P.1712	3,96	4,22	0,33	19,66	13,83	6
P.1702	3,98	4,24	0,33	19,28	14,14	6							



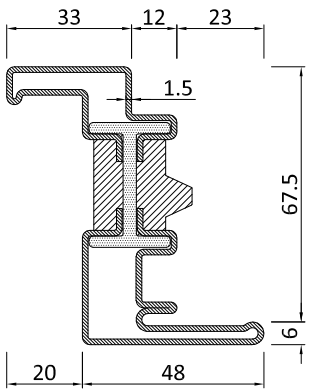
P.1713



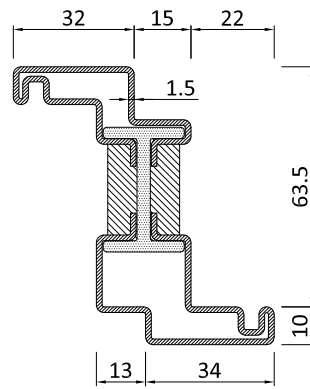
P.1715



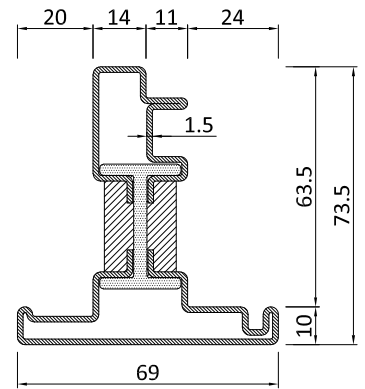
P.1720



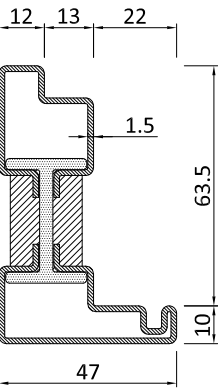
P.1233



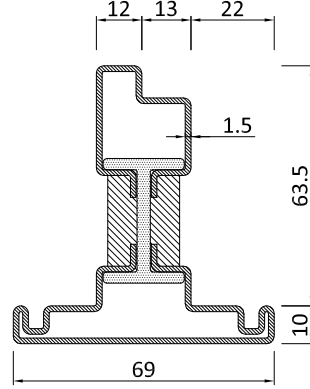
P.1723



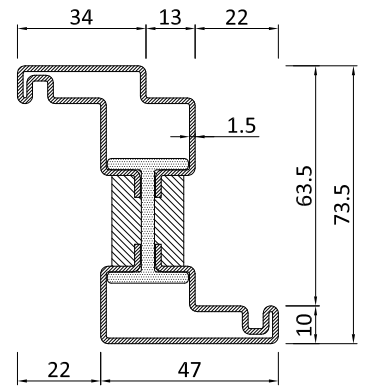
P.1724



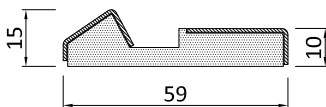
P.1727



P.1728

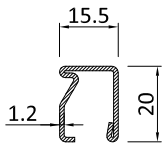


P.1729

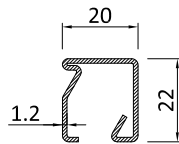


P.1630

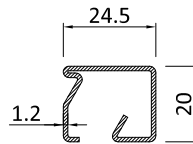
Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m	Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m
	ZN / I - CT	OT						ZN / I - CT	OT				
P.1713	3,96	4,22	0,33	23,64	12,21	6	P.1724	4,10	4,38	0,34	20,15	13,34	6
P.1715	4,51	4,82	0,38	26,96	18,06	6	P.1727	3,48	4,03	0,28	17,74	6,94	6
P.1720	2,85	3,01	0,23	15,15	2,16	6	P.1728	4,03	4,31	0,33	20,03	14,31	6
P.1233	4,21	4,50	0,35	24,52	9,86	6	P.1729	4,08	4,36	0,33	23,97	12,81	6
P.1723	4,03	4,31	0,33	22,71	12,31	6	P.1630	1,55	1,62	0,15			3



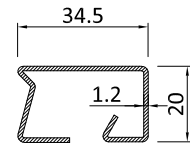
P.2007



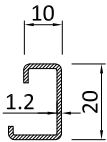
P.1007



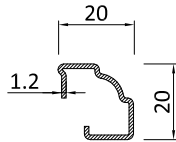
P.2008



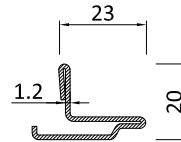
P.2009



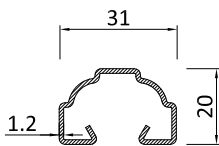
P.2015



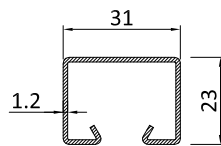
P.2028



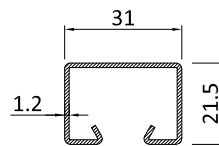
P.2038



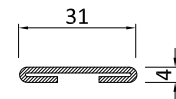
P.2030



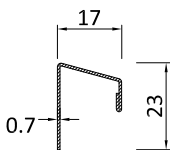
P.2031



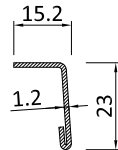
P.2032



P.2034



P.2027



P.1129

MATERIALE | MATERIAL

PZ _____ acciaio zincato | *galvanized steel*

PC _____ GZ acciaio corten grezzo | *untreated corteen steel*

PI _____ ST acciaio inox satinato | *satined stainless steel*

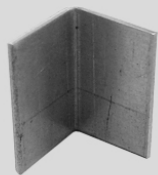
PI _____ SB acciaio inox scotch brite | *scotch brite stainless steel*

PI _____ L3 acciaio inox lucido | *polished stainless steel*

PB _____ BR ottone grezzo | *untreated brass*

Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m
	ZN / I - CT	OT				
P.2007	0,57	0,62	0,13			6
P.1007	0,70	0,75	0,16			6
P.2008	0,75	0,82	0,17			6
P.2009	0,91	0,99	0,20			6
P.2015	0,43	0,46	0,09			6
P.2028	0,48	0,52	0,11			6
P.2038	0,68	0,74	0,16			6
P.2030	0,73	0,79	0,17			6
P.2031	0,98	1,06	0,20			4
P.2032	0,95	1,03	0,19			4

Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m
	ZN / I - CT	OT				
P.2034	0,51	0,56	0,10			4
P.2027	0,51	0,56	0,10			3
P.1129	0,41	0,44	0,06			3



AC1014 acciaio zincato | *galvanised steel*
AC1014CZ acciaio corten | *corten steel*
AC1014ST inox satinato | *satinated stainless steel*
AC1014SB inox scotch brite | *scotch brite st. steel*
AC1014L3 inox lucido | *polished stainless steel*
AC1014BR ottone naturale | *natural brass*

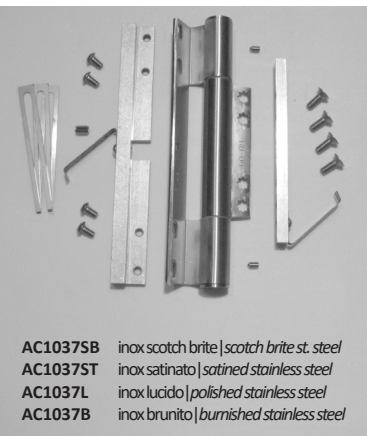
AC 1014

Accessorio inversione battuta
per porte
P.1612-P.1613

n.2 pz. per ogni angolo

Reverse closure kit for doors
P.1612-P.1613

n. 2 pieces for each corner



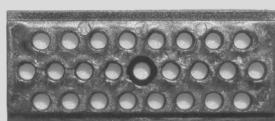
AC1037SB inox scotch brite | *scotch brite st. steel*
AC1037ST inox satinato | *satinated stainless steel*
AC1037L inox lucido | *polished stainless steel*
AC1037B inox brunito | *burnished stainless steel*

AC1037.

Cerniera a stilo ad avvitare con
viti e rinforzi
Peso massimo anta: 250 kg

*Hinge to be screwed with screws
and strengtheners*
Maximum leaf weight: 250 kg

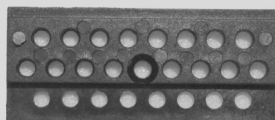
AISI 304



AC 1020M

Supporto per spessore vetro
Vetro da 23 a 44 mm

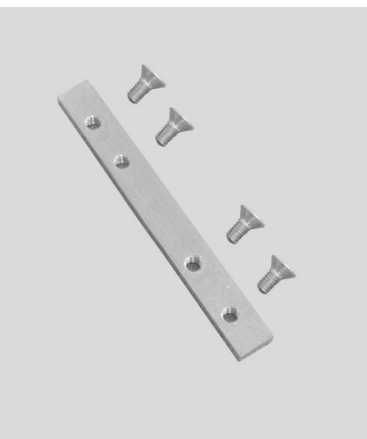
Glass spacer
Glass from 23 to 44 mm



AC 1020R

Supporto per spessore vetro
Vetro fino a 22 mm

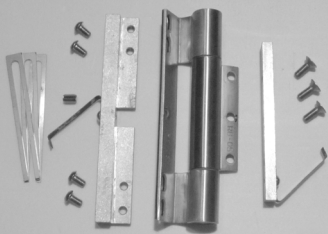
Glass spacer
Glass up to 22 mm



AC 1037/R

Rinforzo cerniera AC1037 su
profili ridotti

*Reinforcement for hinge AC1037
on reduced profiles*



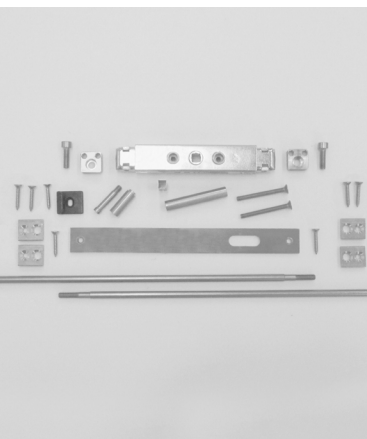
AC1033IZ inox verniciabile | *paintable stainless steel*
AC1033SB inox scotch brite | *scotch brite st. steel*
AC1033ST inox satinato | *satinated stainless steel*
AC1033L inox lucido | *polished stainless steel*
AC1033B inox brunito | *burnished stainless steel*
AC1033CZ corten grezzo | *untreated corten steel*
AC1033CT corten trattato | *treated corten steel*

AC1033.

Cerniera a stilo ad avvitare con
viti e rinforzi
Peso massimo anta: 160 kg

*Screw-on hinge with screws and
strengtheners*
Maximum leaf weight: 160 kg

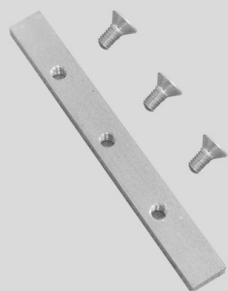
AISI 304



AC 1039

Kit cremonese per chiusura
orizzontale su sporgere

*Cremonese bolt set for horizontal
awning closing*



AC 1033/R

Rinforzo cerniera AC1033 su
profili ridotti

*Reinforcement for hinge AC1033
on reduced profiles*



AC 1040

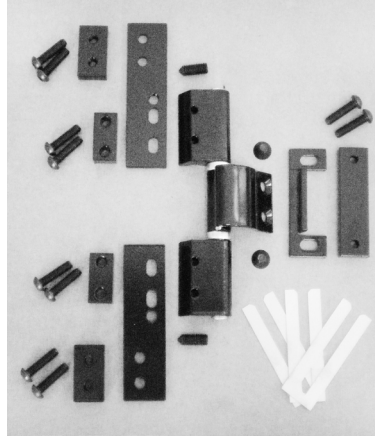
Kit chiusura porte seconda anta
Acciaio inox

Second leaf door closing kit
Stainless steel

**AC 1046**

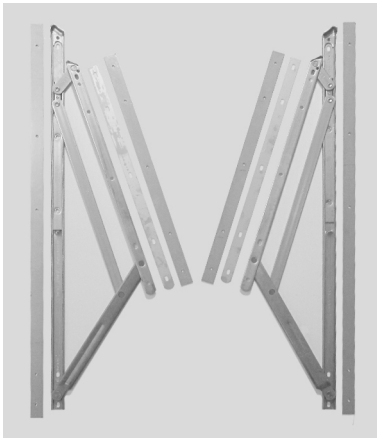
Coppia compassi apertura a sporgere
Acciaio inox
Peso massimo anta: 75 kg

Pair of side arms for awning opening
Stainless steel
Maximum leaf weight: 75 kg

**AC 1068**

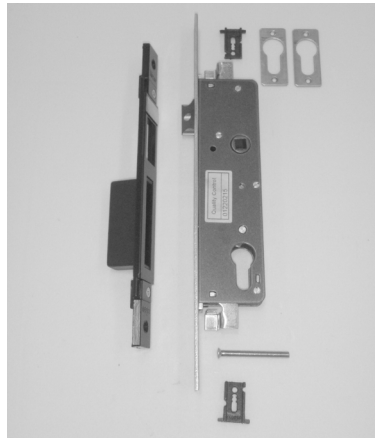
Cerniera a scomparsa per porta
Peso massimo anta: 180 kg
Massima apertura: 96°

Concealed hinge for door
Maximum leaf weight: 180 kg
Maximum opening: 96°

**AC 1046M**

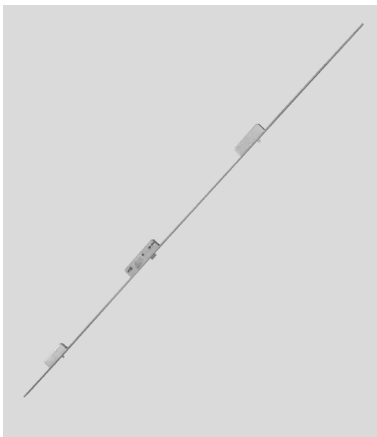
Coppia compassi apertura a sporgere
Acciaio inox
Peso massimo anta: 120 kg

Pair of side arms for awning opening
Stainless steel
Maximum leaf weight: 120 kg

**AC 1070**

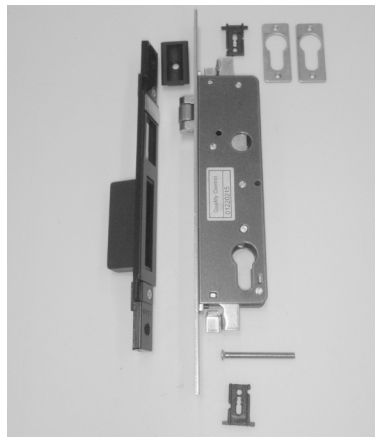
Serratura con scrocco e catenaccio

Lock with spring latch and bolt

**AC 1065W D-S**

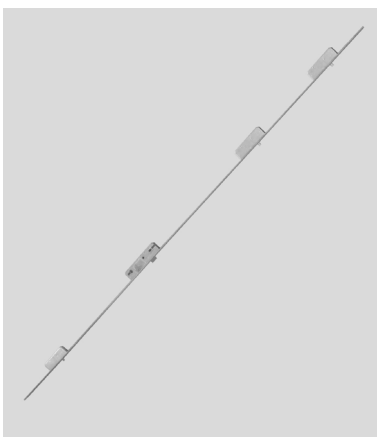
Serratura multipunto
Altezza anta da 2000 a 2300 mm

Multipoint lock
Leaf height from 2000 to 2300 mm

**AC 1071**

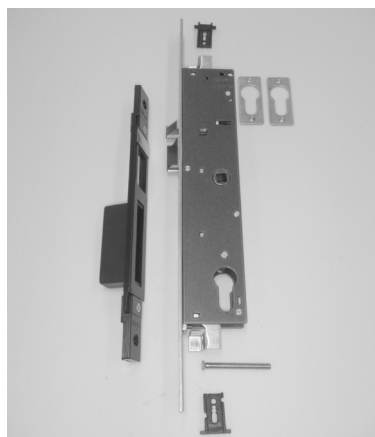
Serratura con rullo e catenaccio

Lock with roller and bolt

**AC 1067W D-S**

Serratura multipunto
Altezza anta oltre 2900 mm

Multipoint lock
Leaf height over 2900 mm

**AC 1072**

Elettroserratura

Electric lock



AC 1075

Deviatore per triplice chiusura

Deviator for three-point lock



AC 1219.

Scarico acqua per aperture interne in metallo

Metal drip for inward openings

AC 1219NE

Scarico acqua per aperture interne in plastica nera

Black plastic drip for inward openings

AC1219IZ inox verniciabile | *paintable stainless steel*
 AC1219SB inox scotch brite | *scotch brite st. steel*
 AC1219L inox lucido | *polished stainless steel*
 AC1219B inox brunito | *burnished stainless steel*
 AC1219CZ corten grezzo | *untreated corten steel*



AC 1080I

Rostro di sicurezza in acciaio inox
Completo di viti e rinforzi

*Stainless steel security pin
With screws and strengtheners*



AC 1235

Coppia limitatori per apertura a vasistas

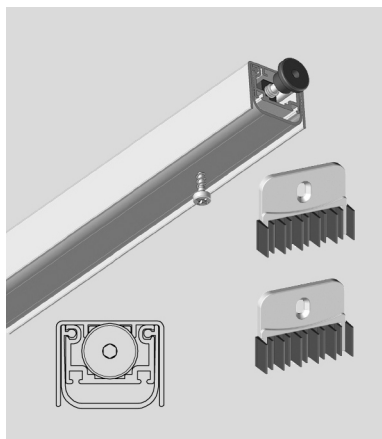
H min = 360 mm

Peso massimo anta: 70 kg

Friction stays for bottom-hung windows

H min = 360 mm

Maximum leaf weight: 70 kg



AC 1081

Paraspiffero automatico a ghigliottina

Guillotine type draught excluder

Dimensioni anta | *Leaf dimension*

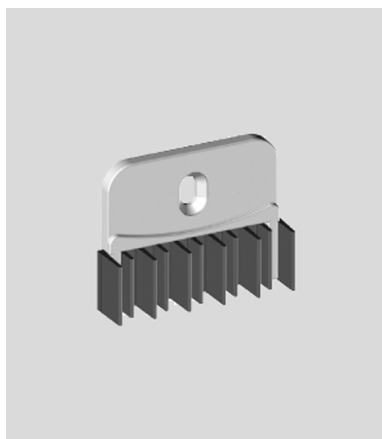
AC1081/A: 615 → 730 mm
 AC1081/B: 715 → 830 mm
 AC1081/C: 815 → 930 mm
 AC1081/D: 915 → 1030 mm
 AC1081/E: 1015 → 1130 mm
 AC1081/F: 1115 → 1230 mm



AC 1356

Meccanismo DK esterno per maniglie "Vitruvio"

External tilt and turn mechanism for "Vitruvio" handles



AC 1081 AT

Anschlagzubehör

Accessoire de butée

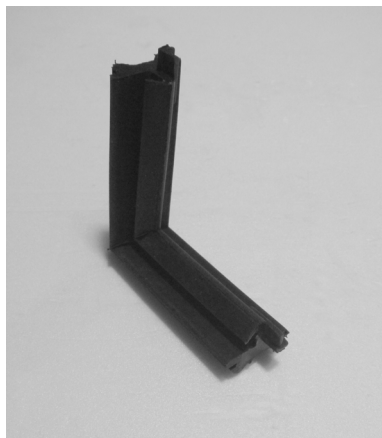


AC 1714.

Kit per finestra a due ante con fondini a saldare e in gomma per inversione battuta

Reverse closure kit for 2-leaf window weld-on fitting and rubber fitting

AC1714GZ acciaio zincato | *galvanized steel*
 AC1714CZ acciaio corten | *corten steel*
 AC1714I acciaio inox | *stainless steel*
 AC1714B ottone naturale | *natural brass*



AC 1716

Guarnizione d'angolo vulcanizzata per GE1701

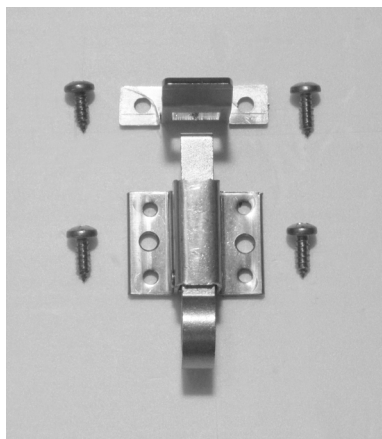
Vulcanised corner gasket for GE1701



AC 2632/C

Cerniera registrabile a due ali in acciaio zincato a saldare | Ø 16
Peso massimo anta: 100 kg

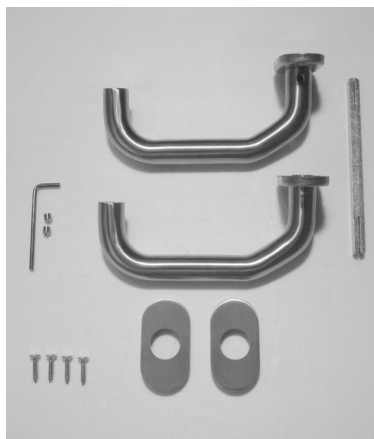
*Adjustable weld-on hinge in galvanised steel | Ø 16
Maximum leaf weight: 100 kg*



AC 1723I

Cricchetto ed incontro da avvitare in acciaio inox, per vasistas

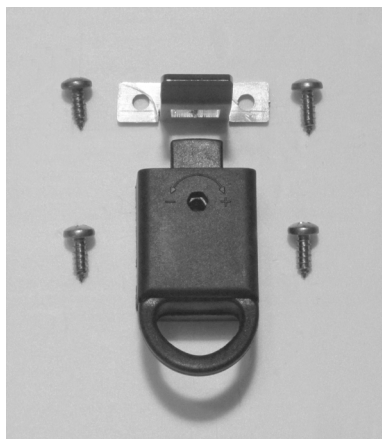
Screw-in latch and plate in stainless steel, for bottom-hung windows



AC 5002

Coppia di maniglie per porta in acciaio inox completa di viti

Pair of stainless steel door handles with screws



AC 1731S

Cricchetto ed incontro da avvitare in nylon nero, per vasistas

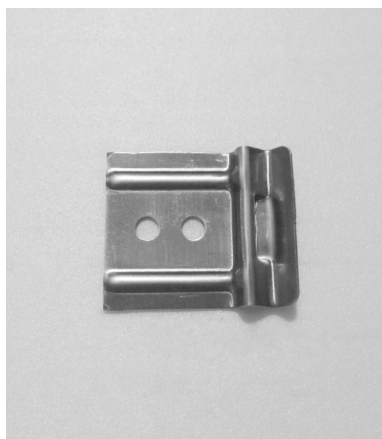
Screw-in latch and plate in black nylon, for bottom-hung windows



AC 5037

Maniglia con incontro in lega colore nero per apertura a sporgere
Completa di viti di fissaggio

*Handle with black alloy plate for projecting opening
With fixing screws*



AC 2608

Clips per fissaggio fermavetri P.2015 - P.2028 - P.2038

Clips for glazing bead P.2015 - P.2028 - P.2038



AC 5056

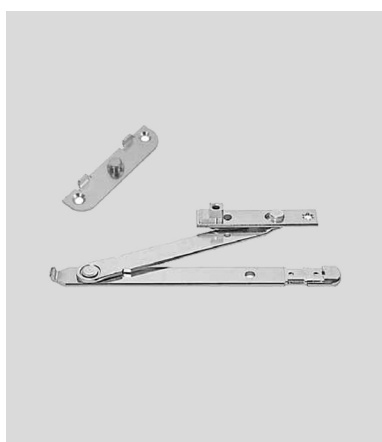
Maniglia DK per cremonese in acciaio inox scotch brite per P.1233
Completa di viti

*DK handle for cremone bolt in scotch-brite stainless steel for P.1233
With fixing screws*

**AC 6023**

Cerniera registrabile a due ali in acciaio zincato a saldare | Ø 20
Peso massimo anta: 200 kg

*Adjustable weld-on hinge in galvanized steel | Ø 20
Maximum leaf weight: 200 kg*

**AG 1386**

Limitatore di apertura frizionato per meccanismi A/R a scomparsa
Solo per meccanismi EASY

*Friction stay for tilt-turn mechanism, concealed hinges
Only for EASY mechanism*

**AG 6530**

Limitatore di corsa per meccanismi A/R

Opening limiter on tilt&turn mechanism

**CV 5001.**

Vite per boccia fermavetri

Screw for glazing bead bushing

TPS 4.2x16 mm

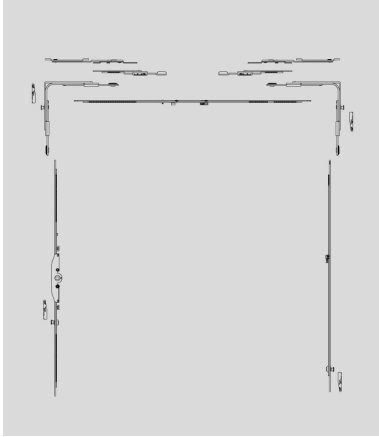
CV 5012.

Boccia per fermavetri

Bushing for glazing bead

CV5001 acciaio zincato | galvanized steel
CV5001I acciaio inox | stainless steel

CV5012 acciaio zincato | galvanized steel
CV5012I acciaio inox | stainless steel



AG 1264

Meccanismo vasistas con cremonese su montante laterale

Bottom-hung window mechanism with lateral cremonese bolt set EASY

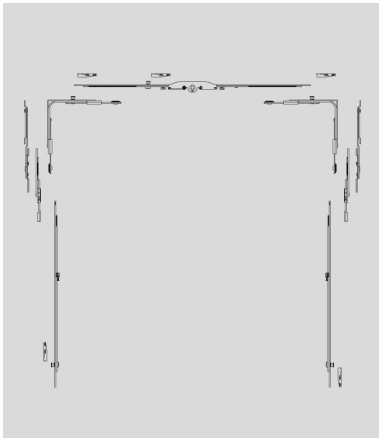
altezza - height

	560	661	861	1201	
	660	860	1200	1600	
	645-910	A1	B1	C1	D1
larghezza	911-1110	A2	B2	C2	D2
width	1111-1470	A3	B3	C3	D3
	1471-1860	A4	B4	C4	D4

Limiti dimensionali | Limits

Peso massimo anta | *Maximum leaf weight: 100 kg* 3 cerniere | *3 hinges*

Peso massimo anta | *Maximum leaf weight: 70 kg* 2 cerniere | *2 hinges*



AG 1274

Meccanismo vasistas con cremonese su traverso superiore

Bottom-hung window mechanism with top cremonese bolt set EASY

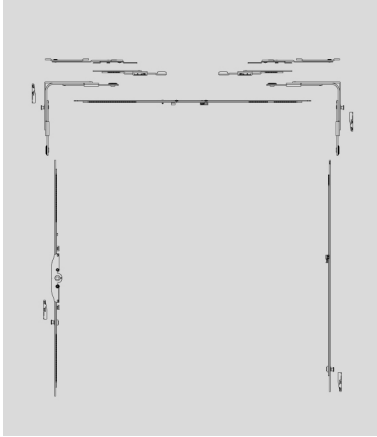
altezza - height

	350	661	861	1201	
	660	860	1200	1400	
	560-660	A1	B1	C1	D1
larghezza	661-860	A2	B2	C2	D2
width	861-1200	A3	B3	C3	D3
	1201-1600	A4	B4	C4	D4

Limiti dimensionali | Limits

Peso massimo anta | *Maximum leaf weight: 100 kg* 3 cerniere | *3 hinges*

Peso massimo anta | *Maximum leaf weight: 70 kg* 2 cerniere | *2 hinges*



AG 1264

Meccanismo vasistas con cremonese su montante laterale

Bottom-hung window mechanism with lateral cremonese bolt set EASY

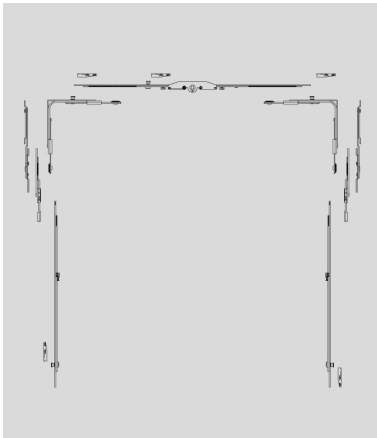
altezza - height

	560	661	861	1201	
	660	860	1200	1600	
	600-910	A1	B1	C1	D1
larghezza	911-1110	A2	B2	C2	D2
width	1111-1470	A3	B3	C3	D3
	1471-1860	A4	B4	C4	D4

Limiti dimensionali | Limits

Peso massimo anta | *Maximum leaf weight: 100 kg* 3 cerniere | *3 hinges*

Peso massimo anta | *Maximum leaf weight: 70 kg* 2 cerniere | *2 hinges*



AG 1274

Meccanismo vasistas con cremonese su traverso superiore

Bottom-hung window mechanism with top cremonese bolt set EASY

altezza - height

	350	661	861	1201	
	660	860	1200	1400	
	560-660	A1	B1	C1	D1
larghezza	661-860	A2	B2	C2	D2
width	861-1200	A3	B3	C3	D3
	1201-1600	A4	B4	C4	D4

Limiti dimensionali | Limits

Peso massimo anta | *Maximum leaf weight: 100 kg* 3 cerniere | *3 hinges*

Peso massimo anta | *Maximum leaf weight: 70 kg* 2 cerniere | *2 hinges*



AC 1001I

Kit per giunzione angolo
Acciaio inox

*Corner joint kit
Stainless steel*

P.1601



AC 1005I

Kit per giunzione angolo
Acciaio inox

*Corner joint kit
Stainless steel*

P.1612



AC 1002I

Kit per giunzione angolo
Acciaio inox

*Corner joint kit
Stainless steel*

P.1602



AC 1006I

Kit per giunzione angolo
Acciaio inox

*Corner joint kit
Stainless steel*

P.1613 cassa | frame



AC 1003I

Kit per giunzione angolo
Acciaio inox

*Corner joint kit
Stainless steel*

P.1603



AC 1007I

Kit per giunzione angolo
Acciaio inox

*Corner joint kit
Stainless steel*

P.1613 anta | leaf



AC 1004I

Kit per giunzione angolo
Acciaio inox

*Stainless steel
Corner joint kit
Stainless steel*

P.1611



AC 1008I

Kit per giunzione angolo
Acciaio inox

*Stainless steel
Corner joint kit*

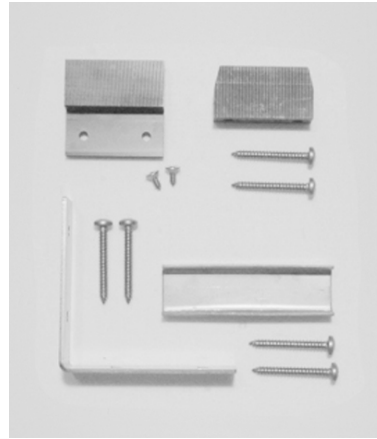
P.1612-P.1613



AC 1009I

Kit per giunzione angolo
Acciaio inox

*Corner joint kit
Stainless steel
P.1605*



AC 1023

Kit per giunzione 90° profili
maggiorati su giunto d'angolo

*Butt joint kit on corner section
for oversize profiles
Stainless steel*



AC 1013I

Kit per giunzione angolo
Acciaio inox

*Corner joint kit
Stainless steel
P.1610*



AC 1024ID

Kit per giunzione angolo destro
Acciaio inox

*Right corner joint kit
Stainless steel
P.1627-P.1612*



AC 1021

Kit per giunzione 90°
Acciaio inox

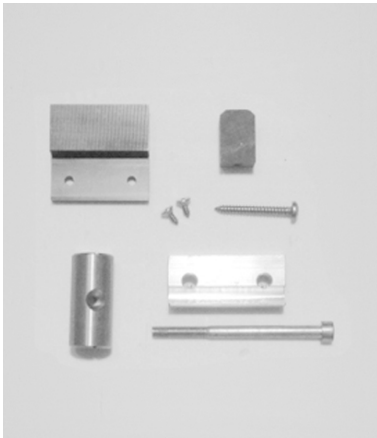
*Butt joint kit
Stainless steel
P.1605
P.1601
P.1602*



AC 1024IS

Kit per giunzione angolo sinistro
Acciaio inox

*Left corner joint kit
Stainless steel
P.1627-P.1612*



AC 1022

Kit per giunzione 90°
Acciaio inox

*Butt joint kit
Stainless steel
P.1622*



AC 1201I

Kit per giunzione angolo
Acciaio inox

*Corner joint kit
Stainless steel
P.1701 | P.1727*



AC 1202I

Kit per giunzione angolo
Acciaio inox

*Corner joint kit
Stainless steel*

P.1702 | P.1728

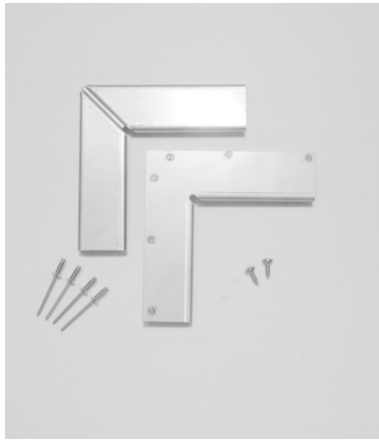


AC 1211I

Kit per giunzione 90°
Acciaio inox

*Butt joint kit
Stainless steel*

P.1702
1/2 - P.1701 | P.1705



AC 1203I

Kit per giunzione angolo
Acciaio inox

*Corner joint kit
Stainless steel*

P.1703



AC 1211IA

Kit per giunzione 90° profili
ridotti su giunto d'angolo
Acciaio inox

*Butt joint kit on corner section
for reduced profiles
Stainless steel*



AC 1207I

Kit per giunzione angolo
Acciaio inox

*Corner joint kit
Stainless steel*

P.1233

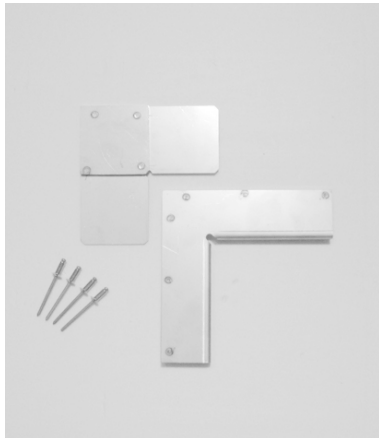


AC 1708I

Kit per giunzione angolo
Acciaio inox

*Corner joint kit
Stainless steel*

P.1724-P.1233



AC 1209I

Kit per giunzione angolo
Acciaio inox

*Corner joint kit
Stainless steel*

P.1705



AC 1729I

Kit per giunzione angolo
Acciaio inox

*Corner joint kit
Stainless steel*

P.1729

**AC 1730I**

Kit per giunzione angolo
Acciaio inox

*Corner joint kit
Stainless steel*

P.1720

**AC 1733IE**

Kit per giunzione angolo
Acciaio inox

*Corner joint kit
Stainless steel*

P.1713 cassa | frame

**AC 1731I**

Kit per giunzione angolo
Acciaio inox

*Corner joint kit
Stainless steel*

P.1711

**AC 1735I**

Kit per giunzione angolo
Acciaio inox

*Corner joint kit
Stainless steel*

P.1715

**AC 1732I**

Kit per giunzione angolo
Acciaio inox

*Corner joint kit
Stainless steel*

P.1712

**AC 1733I**

Kit per giunzione angolo
Acciaio inox

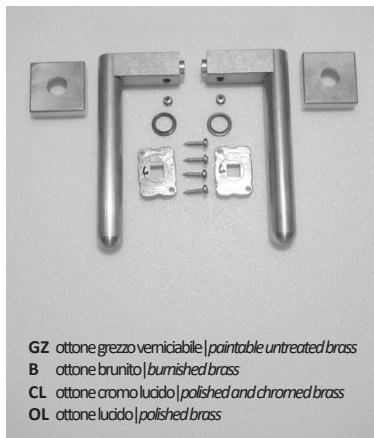
*Corner joint kit
Stainless steel*

P.1713 anta | leaf



ACV 075

Quadro per doppia maniglia
Spindle bar for double handle



ACV 944

Coppia maniglie per porta
"VITRUVIO" medium
bocchetta quadrata
L | tonda | sfera

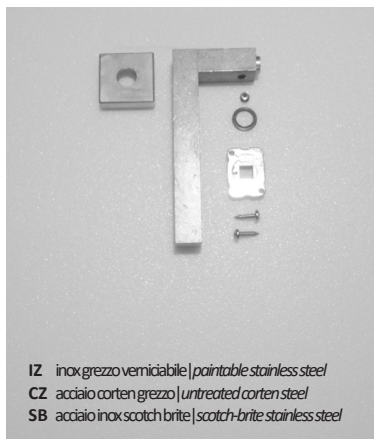
*Double door handlesets
"VITRUVIO" medium
square escutcheon
L | round | sphere*

GZ ottone grezzo verniciabile | *paintable untreated brass*
B ottone brunito | *burnished brass*
CL ottone cromo lucido | *polished and chromed brass*
OL ottone lucido | *polished brass*



ACV 065/R

Quadro per maniglia singola
Spindle bar for single handle

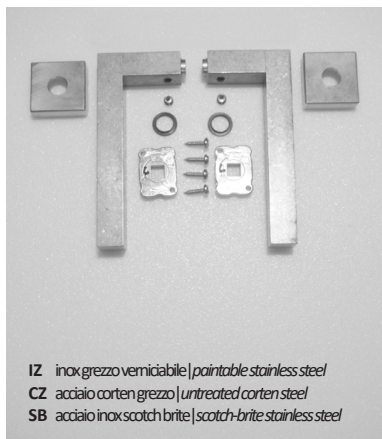


ACV 947

Singola maniglia per porta
"VITRUVIO" medium
bocchetta quadrata
L | quadra | tronca

*Single door handleset
"VITRUVIO" medium
square escutcheon
L | square | cut*

IZ inox grezzo verniciabile | *paintable stainless steel*
CZ acciaio corten grezzo | *untreated corten steel*
SB acciaio inox scotch brite | *scotch-brite stainless steel*



ACV 942

Coppia maniglie per porta
"VITRUVIO" medium
bocchetta quadrata
L | quadra | tronca

*Double door handlesets
"VITRUVIO" medium
square escutcheon
L | square | cut*

IZ inox grezzo verniciabile | *paintable stainless steel*
CZ acciaio corten grezzo | *untreated corten steel*
SB acciaio inox scotch brite | *scotch-brite stainless steel*

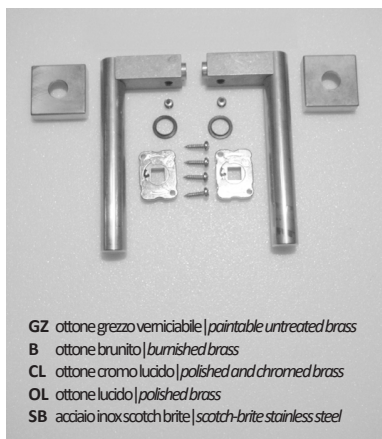


ACV 948

Singola maniglia per porta
"VITRUVIO" medium
bocchetta quadrata
L | tonda | tronca

*Single door handleset
"VITRUVIO" medium
square escutcheon
L | round | cut*

GZ ottone grezzo verniciabile | *paintable untreated brass*
B ottone brunito | *burnished brass*
CL ottone cromo lucido | *polished and chromed brass*
OL ottone lucido | *polished brass*
SB acciaio inox scotch brite | *scotch-brite stainless steel*

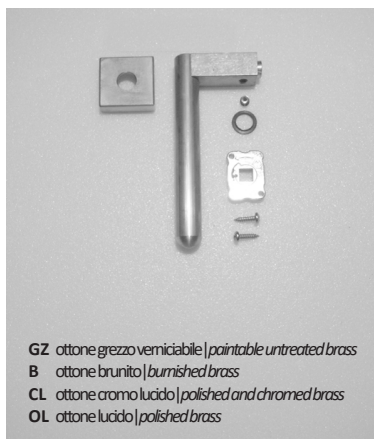


ACV 943

Coppia maniglie per porta
"VITRUVIO" medium
bocchetta quadrata
L | tonda | tronca

*Double door handlesets
"VITRUVIO" medium
square escutcheon
L | round | cut*

GZ ottone grezzo verniciabile | *paintable untreated brass*
B ottone brunito | *burnished brass*
CL ottone cromo lucido | *polished and chromed brass*
OL ottone lucido | *polished brass*
SB acciaio inox scotch brite | *scotch-brite stainless steel*

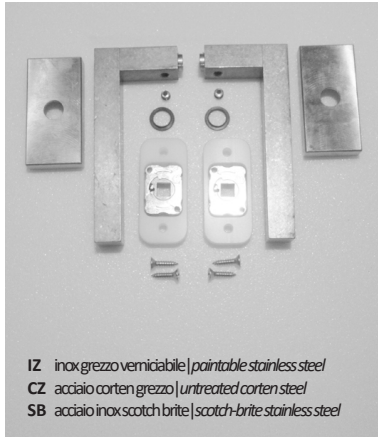


ACV 949

Singola maniglia per porta
"VITRUVIO" medium
bocchetta quadrata
L | tonda | sfera

*Single door handleset
"VITRUVIO" medium
square escutcheon
L | round | sphere*

GZ ottone grezzo verniciabile | *paintable untreated brass*
B ottone brunito | *burnished brass*
CL ottone cromo lucido | *polished and chromed brass*
OL ottone lucido | *polished brass*

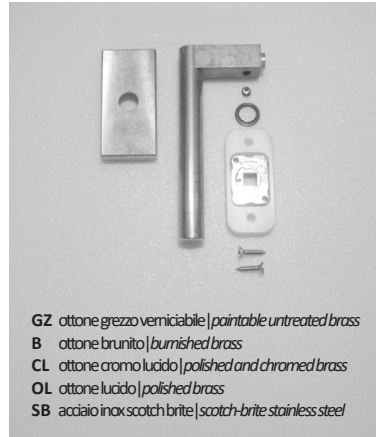


ACV 952

Coppia maniglie per porta
"VITRUVIO" medium
bocchetta rettangolare
L | quadra | tronca

*Double door handlesets
"VITRUVIO" medium
rectangular escutcheon
L | square | cut*

IZ inox grezzo verniciabile | paintable stainless steel
CZ acciaio corten grezzo | untreated corten steel
SB acciaio inox scotch brite | scotch-brite stainless steel

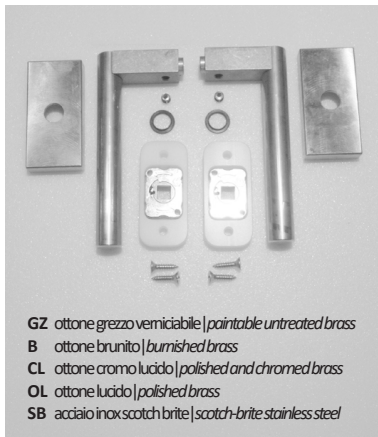


ACV 958

Singola maniglia per porta
"VITRUVIO" medium
bocchetta rettangolare
L | tonda | tronca

*Single door handleset
"VITRUVIO" medium
rectangular escutcheon
L | round | cut*

GZ ottone grezzo verniciabile | paintable untreated brass
B ottone brunito | burnished brass
CL ottone cromo lucido | polished and chromed brass
OL ottone lucido | polished brass
SB acciaio inox scotch brite | scotch-brite stainless steel

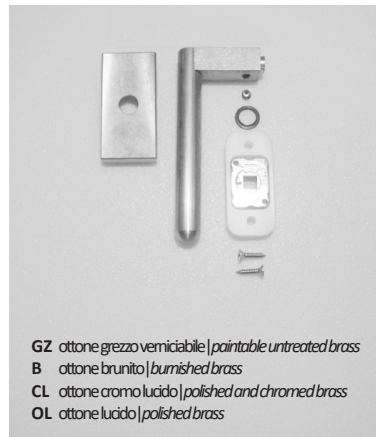


ACV 953

Coppia maniglie per porta
"VITRUVIO" medium
bocchetta rettangolare
L | tonda | tronca

*Double door handlesets
"VITRUVIO" medium
rectangular escutcheon
L | round | cut*

GZ ottone grezzo verniciabile | paintable untreated brass
B ottone brunito | burnished brass
CL ottone cromo lucido | polished and chromed brass
OL ottone lucido | polished brass
SB acciaio inox scotch brite | scotch-brite stainless steel



ACV 959

Singola maniglia per porta
"VITRUVIO" medium
bocchetta rettangolare
L | tonda | sfera

*Single door handleset
"VITRUVIO" medium
rectangular escutcheon
L | round | sphere*

GZ ottone grezzo verniciabile | paintable untreated brass
B ottone brunito | burnished brass
CL ottone cromo lucido | polished and chromed brass
OL ottone lucido | polished brass

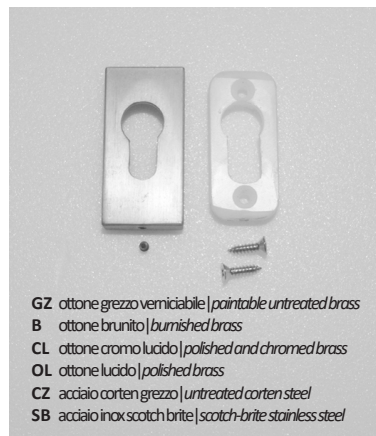


ACV 954

Coppia maniglie per porta
"VITRUVIO" medium
bocchetta rettangolare
L | tonda | sfera

*Double door handlesets
"VITRUVIO" medium
rectangular escutcheon
L | round | sphere*

GZ ottone grezzo verniciabile | paintable untreated brass
B ottone brunito | burnished brass
CL ottone cromo lucido | polished and chromed brass
OL ottone lucido | polished brass

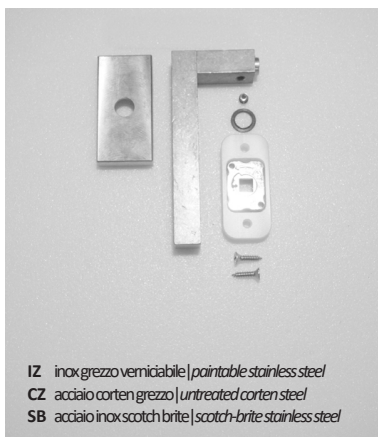


ACV 964

Bocchetta copri cilindro a profilo
europeo

*Euro profile cylinder escutcheon
plate*

GZ ottone grezzo verniciabile | paintable untreated brass
B ottone brunito | burnished brass
CL ottone cromo lucido | polished and chromed brass
OL ottone lucido | polished brass
CZ acciaio corten grezzo | untreated corten steel
SB acciaio inox scotch brite | scotch-brite stainless steel

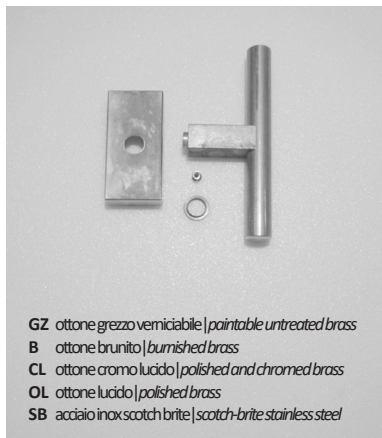


ACV 957

Singola maniglia per porta
"VITRUVIO" medium
bocchetta rettangolare
L | quadra | tronca

*Single door handleset
"VITRUVIO" medium
rectangular escutcheon
L | square | cut*

IZ inox grezzo verniciabile | paintable stainless steel
CZ acciaio corten grezzo | untreated corten steel
SB acciaio inox scotch brite | scotch-brite stainless steel



ACV 971

Maniglia per DK finestra "VITRUVIO" medium
T | tonda | tronca

DK window handle
"VITRUVIO" medium
T | round | cut

- GZ ottone grezzo verniciabile | *paintable untreated brass*
- B ottone brunito | *burnished brass*
- CL ottone cromo lucido | *polished and chromed brass*
- OL ottone lucido | *polished brass*
- SB acciaio inox scotch brite | *scotch-brite stainless steel*

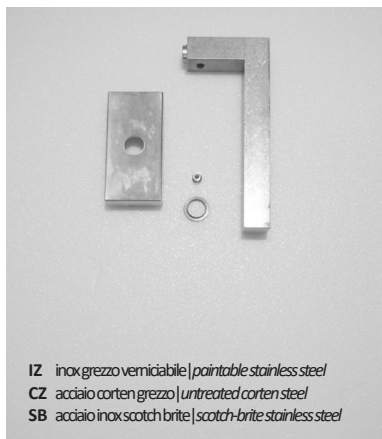


ACV 976

Maniglia per DK finestra "VITRUVIO" medium
KIDS

DK window handle
"VITRUVIO" medium
KIDS

- GZ ottone grezzo verniciabile | *paintable untreated brass*
- B ottone brunito | *burnished brass*
- CL ottone cromo lucido | *polished and chromed brass*
- OL ottone lucido | *polished brass*

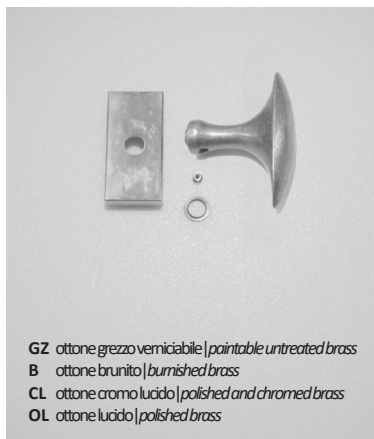


ACV 972

Maniglia per DK finestra "VITRUVIO" medium
L | quadra | tronca

DK window handle
"VITRUVIO" medium
L | square | cut

- IZ inox grezzo verniciabile | *paintable stainless steel*
- CZ acciaio corten grezzo | *untreated corten steel*
- SB acciaio inox scotch brite | *scotch-brite stainless steel*

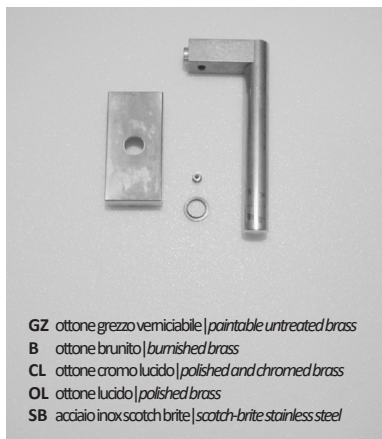


ACV 977

Maniglia per DK finestra "VITRUVIO" medium
OVALE

DK window handle
"VITRUVIO" medium
OVALE

- GZ ottone grezzo verniciabile | *paintable untreated brass*
- B ottone brunito | *burnished brass*
- CL ottone cromo lucido | *polished and chromed brass*
- OL ottone lucido | *polished brass*

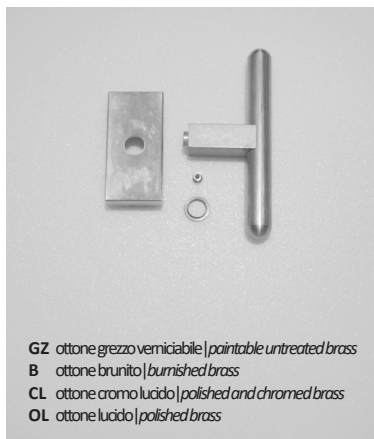


ACV 973

Maniglia per DK finestra "VITRUVIO" medium
L | tonda | tronca

DK window handle
"VITRUVIO" medium
L | round | cut

- GZ ottone grezzo verniciabile | *paintable untreated brass*
- B ottone brunito | *burnished brass*
- CL ottone cromo lucido | *polished and chromed brass*
- OL ottone lucido | *polished brass*
- SB acciaio inox scotch brite | *scotch-brite stainless steel*



ACV 979

Maniglia per DK finestra "VITRUVIO" medium
T | tonda | sfera

DK window handle
"VITRUVIO" medium
T | round | sphere

- GZ ottone grezzo verniciabile | *paintable untreated brass*
- B ottone brunito | *burnished brass*
- CL ottone cromo lucido | *polished and chromed brass*
- OL ottone lucido | *polished brass*

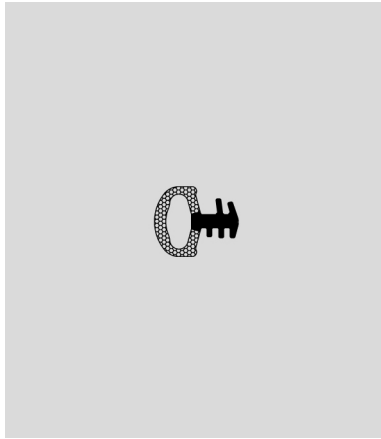


ACV 974

Maniglia per DK finestra "VITRUVIO" medium
L | tonda | sfera

DK window handle
"VITRUVIO" medium
L | round | sphere

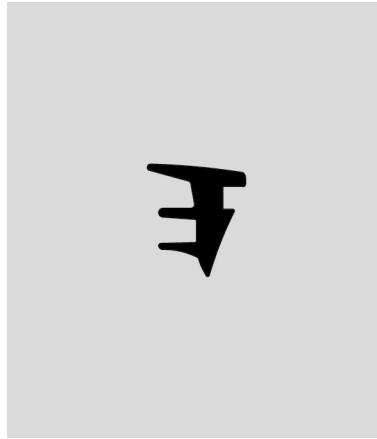
- GZ ottone grezzo verniciabile | *paintable untreated brass*
- B ottone brunito | *burnished brass*
- CL ottone cromo lucido | *polished and chromed brass*
- OL ottone lucido | *polished brass*



GE 1001TT

Guarnizione di battuta per porte e finestre

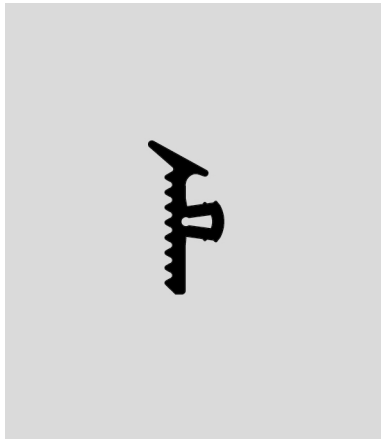
Gasket for doors and windows



GE 1012

Guarnizione interna fermavetro spessore 6-8 mm

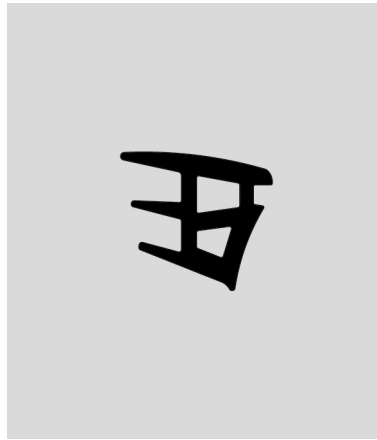
Internal gasket for 6-8 mm thick glazing bead



GE 1006

Guarnizione esterna vetro

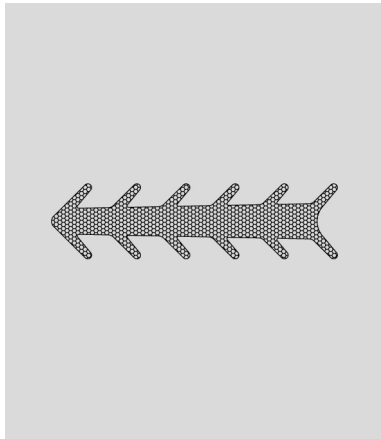
External gasket



GE 1013

Guarnizione interna fermavetro spessore 12-16 mm

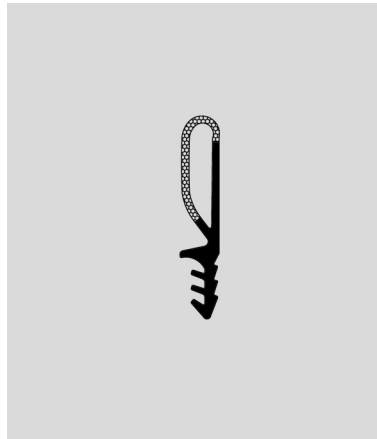
Internal gasket for 12-16 mm thick glazing bead



GE 1007TT

Guarnizione sotto vetro

Under glass gasket



GE 1200TT

Guarnizione di battuta interna per finestre

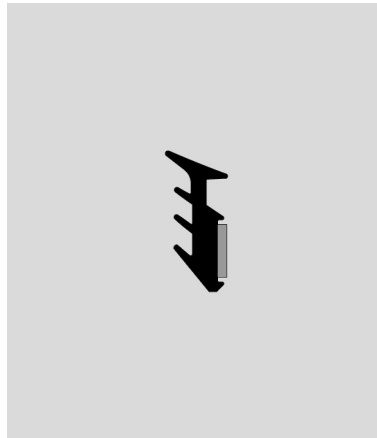
Internal gasket for windows



GE 1011

Guarnizione interna fermavetro spessore 3-4 mm

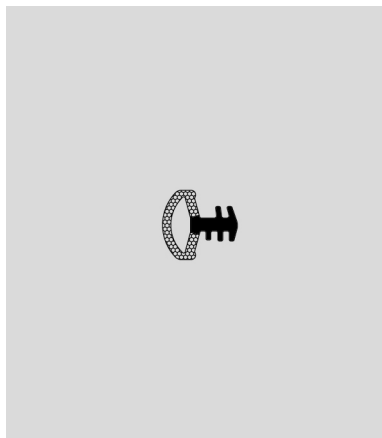
Internal gasket for 3-4 mm thick glazing bead



GE 1206

Guarnizione autoadesiva per lato esterno vetro su P.1233 | P.1724

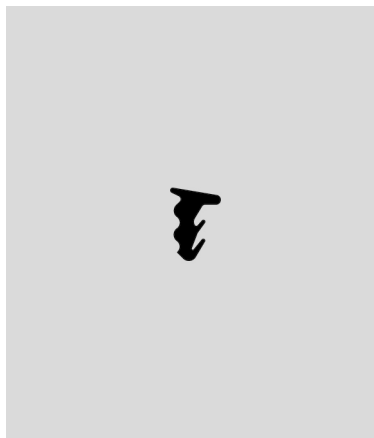
Self-adhesive external gasket for P.1233 | P.1724



GE 1233TT

Guarnizione di battuta per finestre

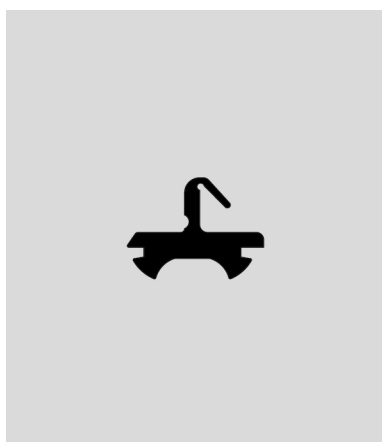
Gasket for windows



GE 2029

Guarnizione interna dividivetro P.2030 | P.2031 | P.2032

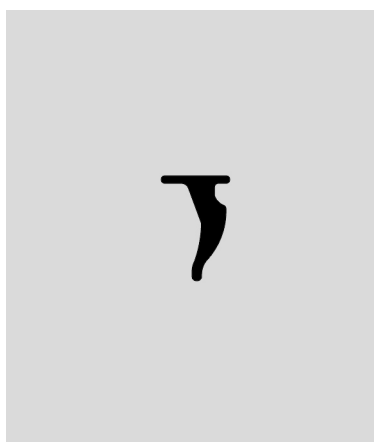
Internal gasket for glass divider on P.2030 | P.2031 | P.2032



GE 1701

Guarnizione centrale di battuta giunto aperto finestre telaio

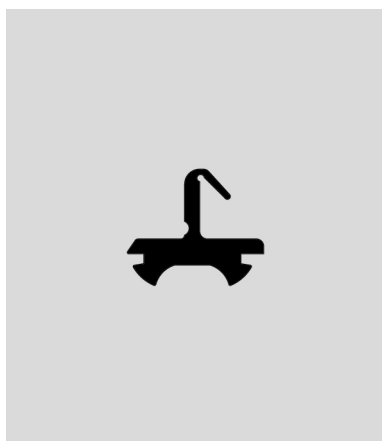
Central open-joint gasket for windows frame



GP 0095

Guarnizione interna fermavetro spessore 3 mm

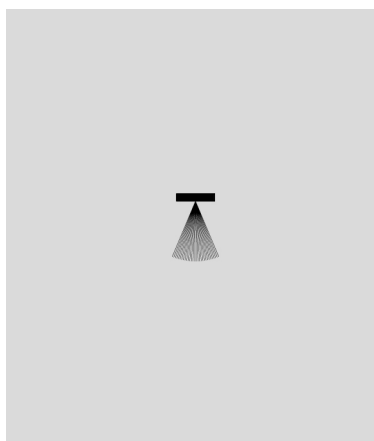
Internal gasket for glazing bead, 3mm thick



GE 1704

Guarnizione centrale di battuta giunto aperto finestre anta P.1724

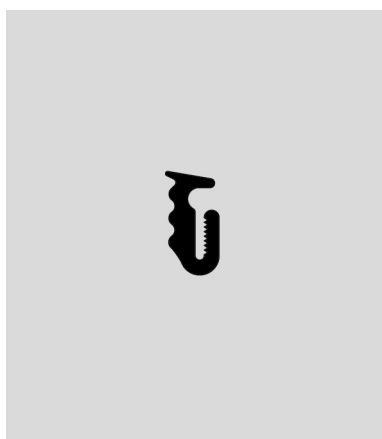
Central open-joint gasket for windows leaf P.1724



GU 0087

Spazzolino per porte su GU0120 H=8 mm

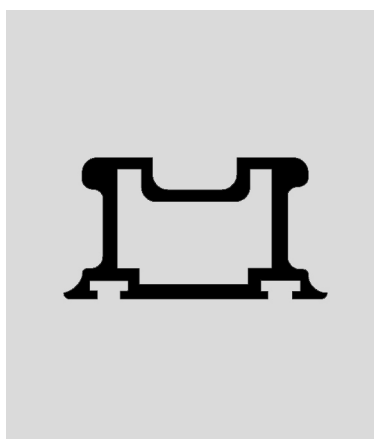
Brush for doors on GU0120 H=8 mm



GE 2028

Guarnizione interna per fermavetro P.2028

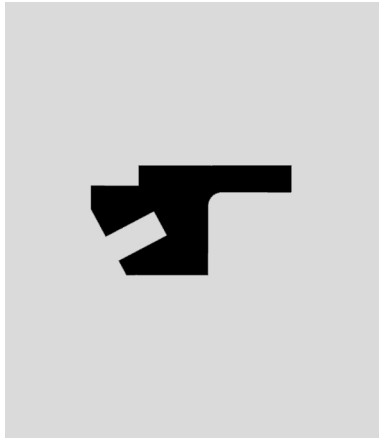
Gasket for glazing bead P.2028



GU 0120

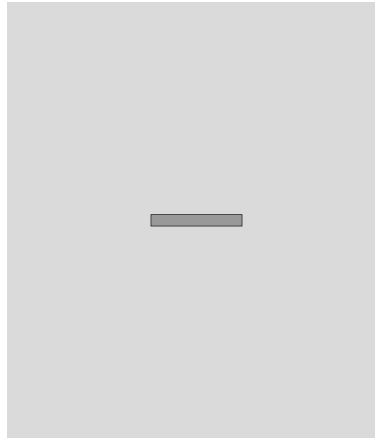
Estruso in PVC porta spazzolino per porte

Extruded PVC brush holder for doors

**GU 1034**

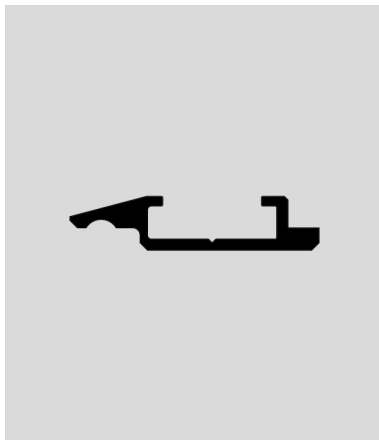
Estruso rigido in PVC per soglia porta P.1630

Rigid extruded PVC section for P.1630 threshold

**GU 2031**

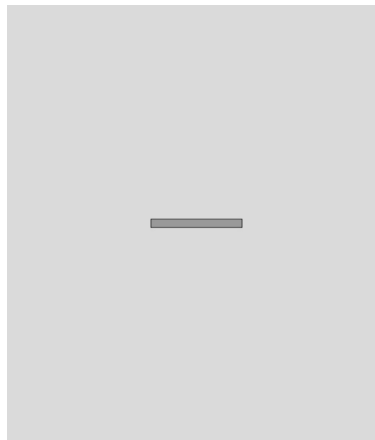
Biadesivo per dividivetro 12x1.5 mm

Double-sided tape for glass divider 12x1.5 mm

**GU 1702**

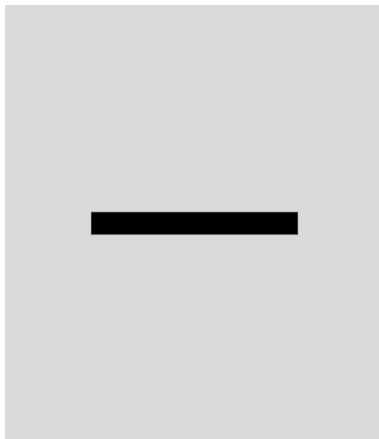
Estruso rigido in PVC per GE1701-GE1704

Rigid extruded PVC section for GE1701-GE1704

**GU 2032**

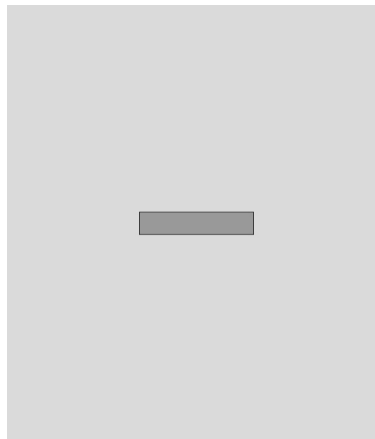
Biadesivo per dividivetro 12x1 mm

Bi-adhesive tape for glass divider 12x1 mm

**GU 1711**

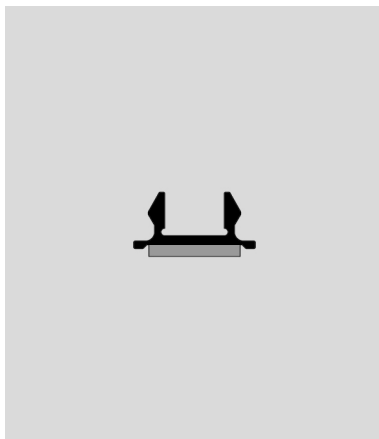
Profilo in PVC per scarico acqua aperture a sporgere

PVC profile for water drain in awning opening

**GU 2035**

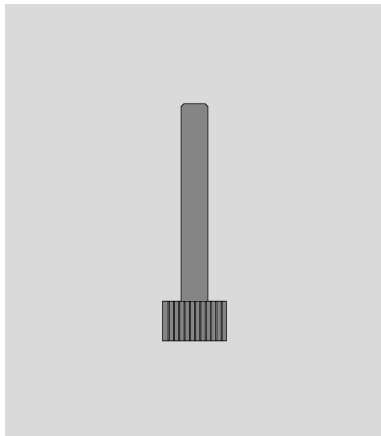
Piattina adesiva morbida per fondo giunto esterno vetro 15x3 mm

Soft adhesive shim for external window joint 15x3 mm

**GU 2030E**

Profilo in PVC con biadesivo per fissaggio dividivetro interno P.2030 | P.2031 | P.2032

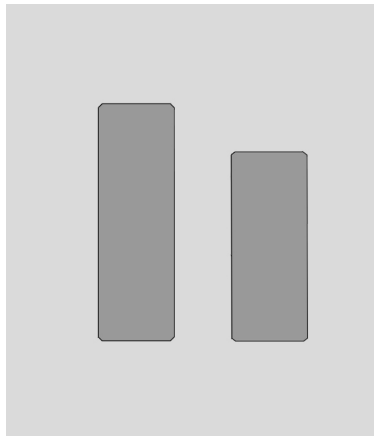
PVC profile with double-sided tape for fixing internal glass divider on P.2030 | P.2031 | P.2032



AT 1058

Fresa per lavorazione spacco
cerniera AC1068

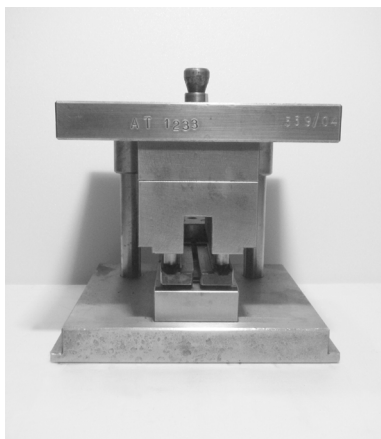
*Milling cutter for hinge slot
AC1068*



AT 1600

Ganasce di taglio per profili
EBE 75

*Cutting jaws for profiles
EBE 75*



AT 1233

Stampo per esecuzione fori di
fissaggio squadretta su profilo
P.1233 | P.1724

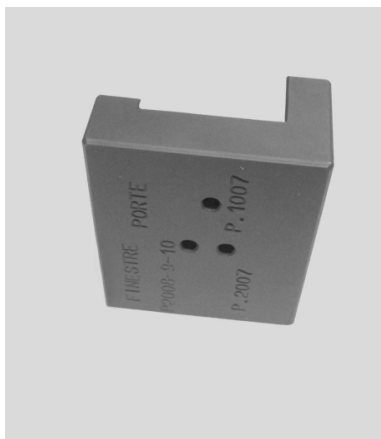
*Die for drilling holes for corner
plate on profile
P.1233 | P.1724*



AT 1601

Maschera per esecuzione fori
di fissaggio squadretta su profili
maggiorati

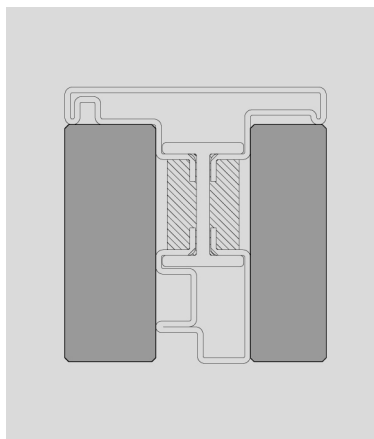
*Jig for drilling holes for corner
plate on oversized profiles*



AT 1234

Maschera per esecuzione fori
fissaggio fermavetri con boccole

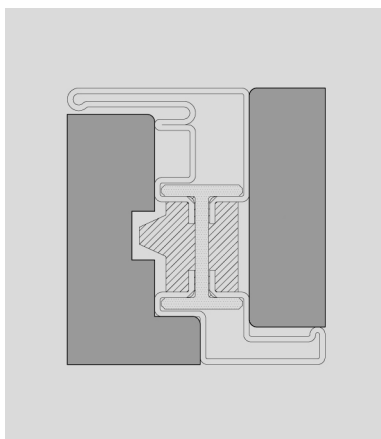
*Jig for drilling holes for glazing
bead with bushings*



AT 1724

Ganasce di taglio per profilo
P.1724

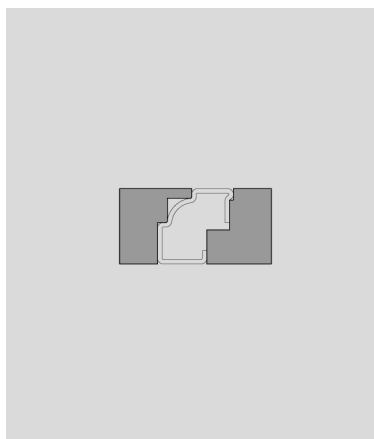
*Cutting jaws for
P.1724*



AT 1236

Ganasce di taglio per profilo
P.1233

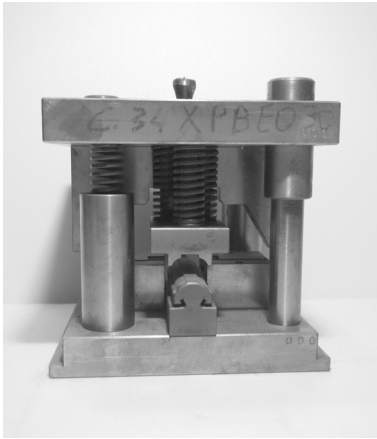
*Cutting jaws for
P.1233*



AT 2029

Ganasce di taglio per fermavetro
P.2028

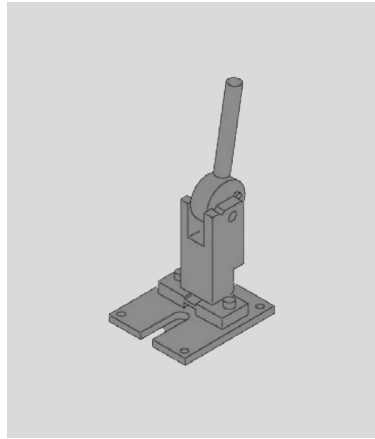
*Cutting jaws for glazing bead
P.2028*



AT 2030

Stampo per intestatura
P.2030

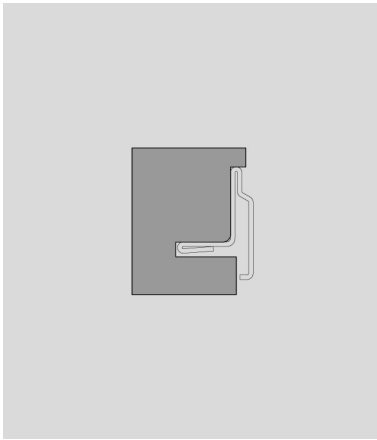
*Butt die for
P.2030*



ATG 311

Trancia manuale

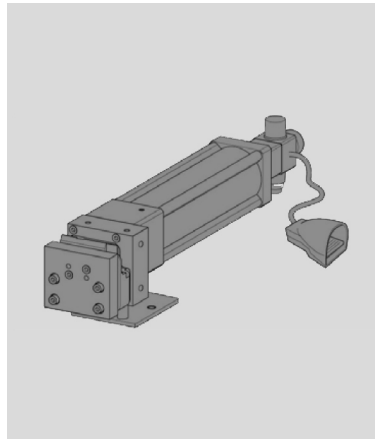
Manual punching machine



AT 2038

Ganasce di taglio per
P.2038

*Cutting jaws for
P.2038*



ATG 312

Trancia oleopneumatica

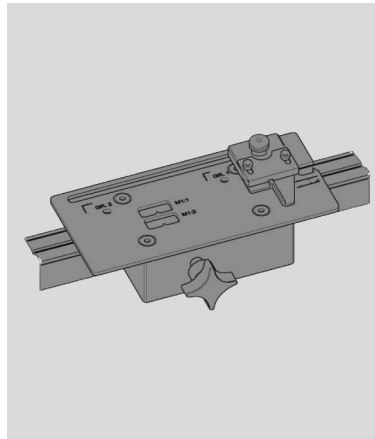
*Oil-pneumatic punching
machine*



AT 2828

Maschera per esecuzione fori
fissaggio fermavetri con clips

*Jig for drilling holes for glazing
bead with clips*



ATG 313

Asta millimetrata per trancia
oleopneumatica

*Rod divided into millimetres for
oil-pneumatic punching machine*



ATG 281

Kit dime per esecuzione fori
montaggio A/R cerniere a
scomparsa

*Template kit for drilling holes
for tilt-turn kit with concealed
hinges*

AGE 281-2-5-6

**SA 005/01**

Liquido neritore per brunitura
1 Kg

*Burnishing liquid
1 Kg*

SA 005/10

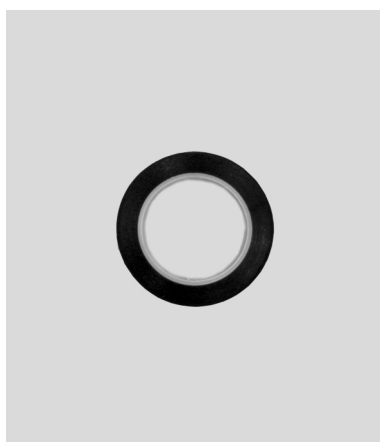
Liquido neritore per brunitura
10 Kg

*Burnishing liquid
10 Kg*

**SA 2002**

Spray solvente per rimozione
collanti su superfici in acciaio
inox

*Solvent adhesive remover spray
for stainless steel surfaces*

**SA 1024**

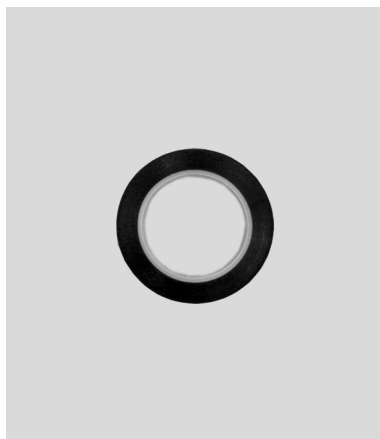
Nastro adesivo protettivo per
verniciatura
24 mm

*Adhesive tape for painting
24 mm*

**SA 2031**

Liquido deumidificante vetri

Glass dehumidifying liquid

**SA 1033**

Nastro adesivo protettivo per
verniciatura
33 mm

*Sticky tape for painting
33 mm*

**SA 2032**

Primer di adesione per profili
verniciati

*Adhesion primer for painted
profiles*

**SA 2001**

Spray detergente antimpronta
per superfici in acciaio inox

*Anti-fingerprint detergent spray
for stainless steel surfaces*

**SA 2033**

Liquido di adesione per
materiale plastico

Adhesion liquid for plastic



SA 3001

Acido per ossidazione corten

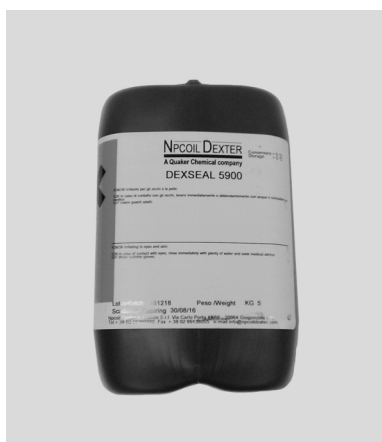
Oxidising acid for corten



SL 0021

Silicone nero per guarnizioni

Black silicone for gaskets



SA 3002

Passivante per ossidazione corten
25 Kg

*Passivating agent for corten
25 Kg*

SA 3002/5

Passivante per ossidazione corten
5 Kg

*Passivating agent for corten
5 Kg*



SA 3003

Cera d'api per finitura corten

Beeswax for Corten finishing

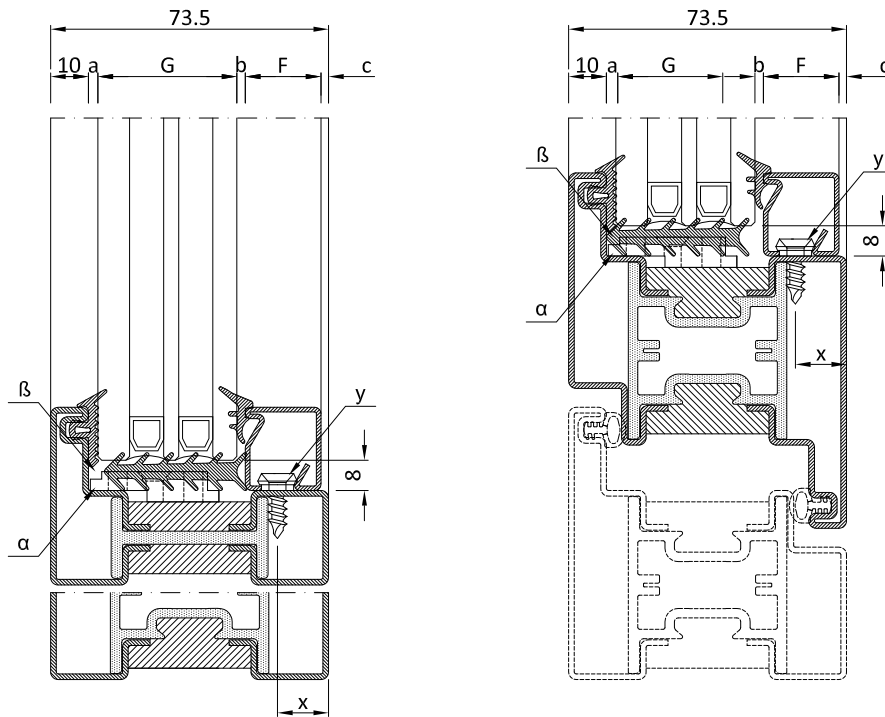


SL 0019

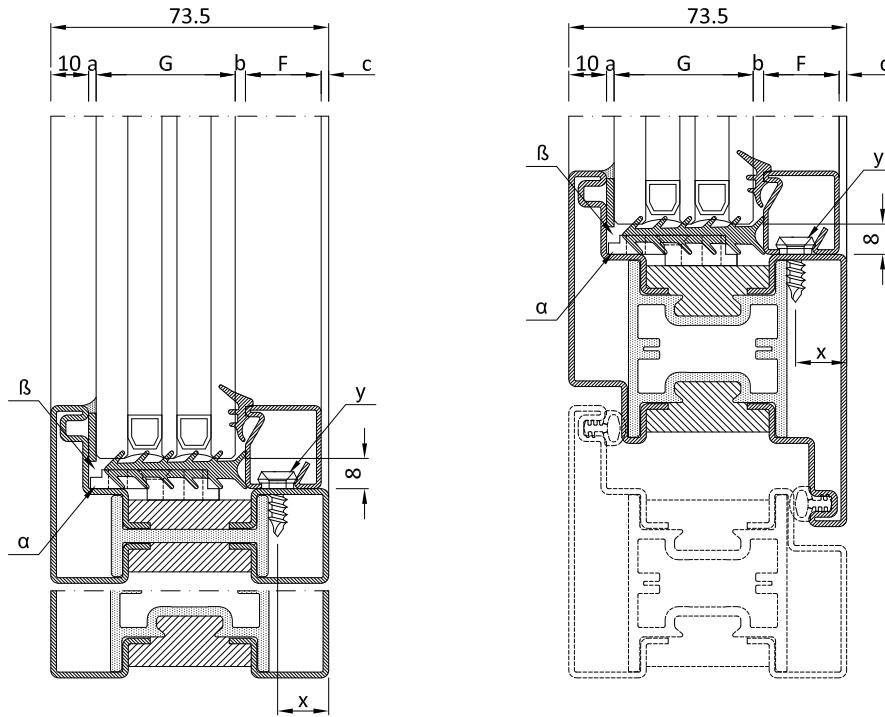
Sigillante a freddo per giunzione
angoli e traversi

*Cold sealant for corner and
transom joints*

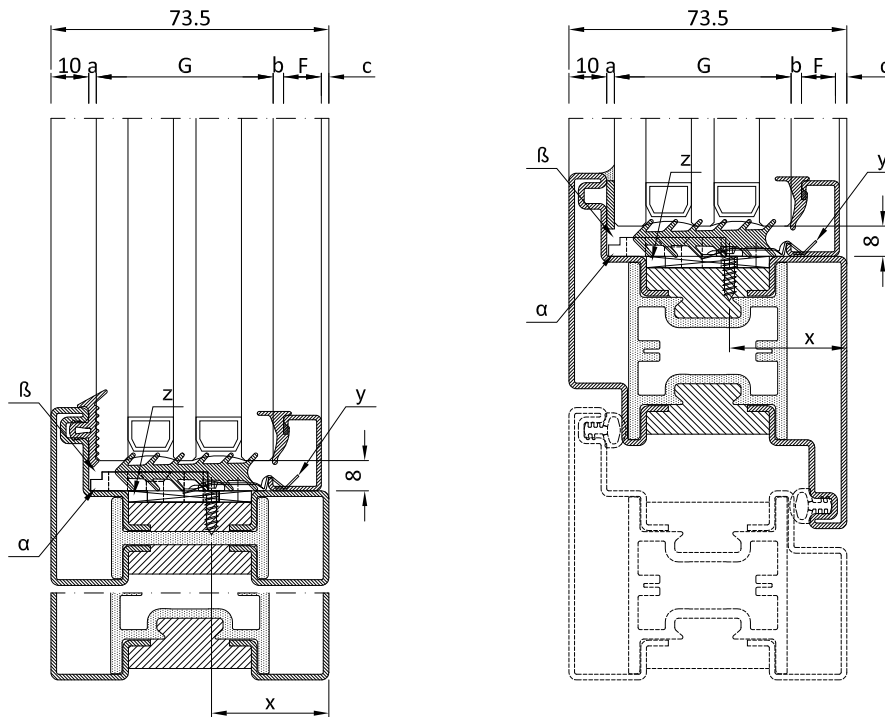
1 kg



F	G	Guarnizioni - gaskets										
fermavetro glazing bead	range vetro glass range	GE1006 3 mm 	GP0095 2 / 3 mm 	GE1011 3 / 4 mm 	GE1012 6 / 8 mm 	GE1013 12 / 16 mm 	asse fissaggio viti fermavetro securing axis for screws for the glazing beads	rientro fermavetro glazing beads gap	boccole e viti fissaggio fermavetro Bushings and screws for glazing bead fixing	spessore per vetro glass shim	guarnizione sotto vetro under glass gasket	
Code		a	b	b	b	b	x	c	y	α	β	
 P.2007	27 - 43	3	40	39	35	27	9.5	2	CV5001(i) CV5012(i)	AC1020M	GE1007TT	
			-	-	-	-						
41	40		37	31	7.5	0						
42	41		37	29								
-	-		-	-	13.5	2						
43	42		39	33								
 P.1007	22 - 38	35	34	30	22	11.5	0	CV5001(i) CV5012(i)	AC1020M	GE1007TT		
		-	-	-	-							
36	35	32	26	13.5	2							
37	36	32	24									
-	-	-	-	11.5	0							
38	37	34	28									
 P.2008	20 - 34	-	-	-	-	-	-	CV5001(i) CV5012(i)	AC1020M	GE1007TT		
		33	32	28	20							
-	-	-	-	16	0							
34	33	30	24									



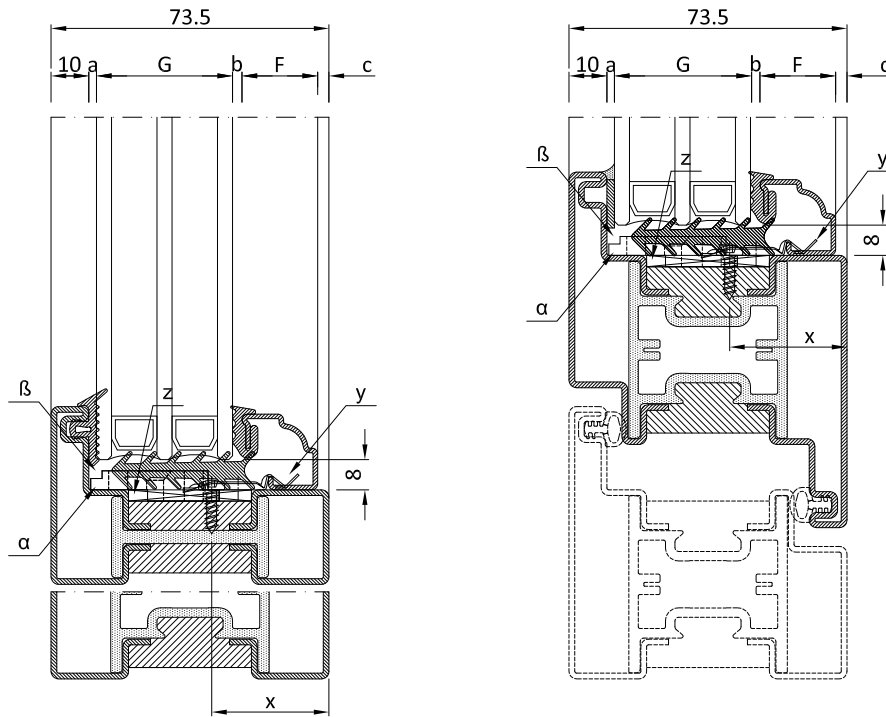
F	G	Guarnizioni - gaskets										
fermavetro glazing bead	range vetro glass range	GU2035 2 mm + sigillatura + sealing	GP0095 2 / 3 mm	GE1011 3 / 4 mm	GE1012 6 / 8 mm	GE1013 12 / 16 mm	asse fissaggio viti fermavetro securing axis for screws for the glazing beads	rientro fermavetro glazing beads gap	boccole e viti fissaggio fermavetro Bushings and screws for glazing bead fixing	spessore per vetro glass shim	guarnizione sotto vetro under glass gasket	
Code		a	b	b	b	b	x	c	y	α	β	
 P.2007	28 - 44	2	41 - 42	40 - 41	36 - 38	28 - 32	9.5	2	CV5001(i) CV5012(i)	AC1020M	GE1007TT	
			43 - 44	42 - 43	39 - 40	30 - 34	7.5	0				
 P.1007	23 - 39		36 - 37	35 - 36	31 - 33	23 - 27	13.5	2	CV5001(i) CV5012(i)	AC1020M	GE1007TT	
			38 - 39	37 - 38	33 - 35	25 - 29	11.5	0				
 P.2008	21 - 35									CV5001(i) CV5012(i)	AC1020M	GE1007TT
			34 - 35	33 - 34	29 - 31	21 - 25	16	0				



F		Guarnizioni - gaskets		G						
fermavetro glazing bead	range vetro glass range	GE1006 3 mm 	GP0095 3 mm 	spessore vetro glass thickness	asse fissaggio viti fermavetro securing axis for screws for the glazing beads	rientro fermavetro glazing beads gap	clips fissaggio fermavetro securing clips for glazing beads	spessore di compensazione * Shim *	spessore per vetro glass shim	guarnizione sotto vetro under glass gasket
Code		a	b	mm.	x	c	y	z	α	β
 P.2015	45	3	3	45	31	2	AC2608	3 mm.	AC1020M	GE1007TT
	47			47	29	0				

F		Guarnizioni - gaskets		G						
fermavetro glazing bead	range vetro glass range	GU2035 2 mm + sigillatura + sealing	GP0095 3 mm 	spessore vetro glass thickness	asse fissaggio viti fermavetro securing axis for screws for the glazing beads	rientro fermavetro glazing beads gap	clips fissaggio fermavetro securing clips for glazing beads	spessore di compensazione * Shim *	spessore per vetro glass shim	guarnizione sotto vetro under glass gasket
Code		a	b	mm.	x	c	y	z	α	β
 P.2015	46	2	3	46	31	2	AC2608	3 mm.	AC1020M	GE1007TT
	48			48	29	0				

*non fornito
*not included



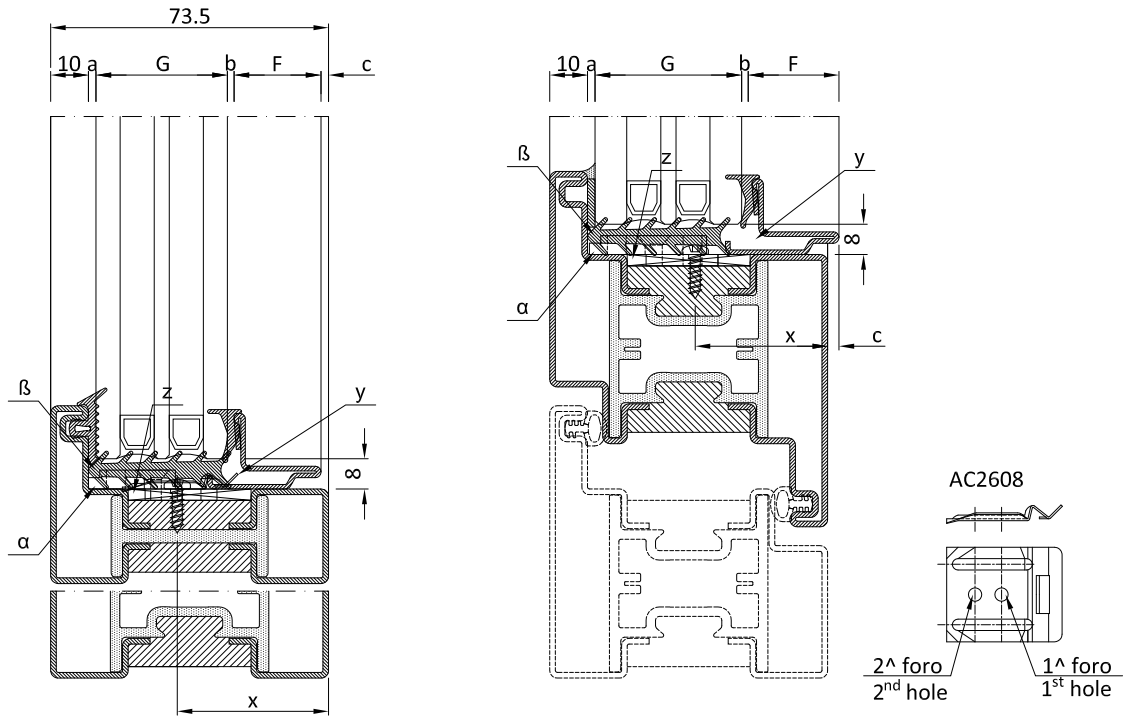
F		Guarnizioni - gaskets		G						
fermavetro glazing bead	range vetro glass range	GE1006 3 mm 	GE2028 2.5 mm 	spessore vetro glass thickness	asse fissaggio viti fermavetro securing axis for screws for the glazing beads	rientro fermavetro glazing beads gap	clips fissaggio fermavetro securing clips for glazing beads	spessore di compensazione * Shim *	spessore per vetro glass shim	guarnizione sotto vetro under glass gasket
Code		a	b	mm.	x	c	y	z	alpha	beta
 P.2028	32 - 38	3	2.5	32	34	6	AC2608	3 mm.	AC1020M	GE1007TT
				34	32	4				
				36	30	2				
				38	28	0				

F		Guarnizioni - gaskets		G						
fermavetro glazing bead	range vetro glass range	GU2035 2 mm 	GE2028 2.5 mm 	spessore vetro glass thickness	asse fissaggio viti fermavetro securing axis for screws for the glazing beads	rientro fermavetro glazing beads gap	clips fissaggio fermavetro securing clips for glazing beads	spessore di compensazione * Shim *	spessore per vetro glass shim	guarnizione sotto vetro under glass gasket
Code		a	b	mm.	x	c	y	z	alpha	beta
 P.2028	33 - 39	2	2.5	33	34	6	AC2608	3 mm.	AC1020M	GE1007TT
				35	32	4				
				37	30	2				
				39	28	0				

*non fornito
*not included

Taglio a 45° dei fermavetri effettuabile utilizzando la ganascia AT2029
45° cutting of the glazing beads done using the cutting jaw AT2029





F		Guarnizioni - gaskets		G						
fermavetro glazing bead	range vetro glass range	GE1006 3 mm 	GP0095 3 mm 	spessore vetro glass thickness	asse fissaggio viti fermavetro securing axis for screws for the glazing beads	rientro fermavetro glazing beads gap	clips fissaggio fermavetro securing clips for glazing beads	spessore di compensazione * Shim *	spessore per vetro glass shim	guarnizione sotto vetro under glass gasket
Code		a	b	mm.	x	c	y	z	α	β
 P.2038	32 - 38	3	3	32	40**	2	AC2608	3 mm.	AC1020R	GE1007TT
				34	38**	0				
				36	36**	-2				
				38	34**	-4				

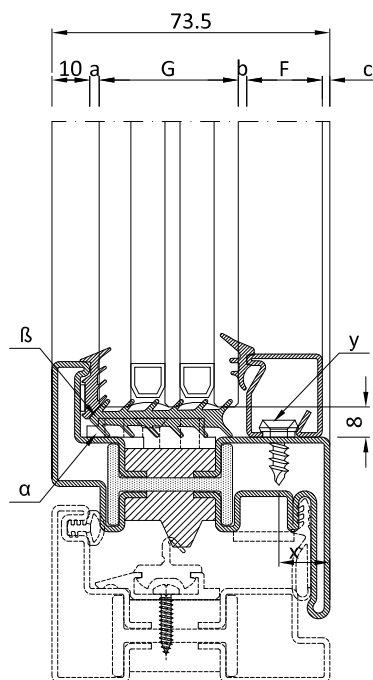
F		Guarnizioni - gaskets		G						
fermavetro glazing bead	range vetro glass range	GU2035 2 mm + sigillatura + sealing	GP0095 3 mm 	spessore vetro glass thickness	asse fissaggio viti fermavetro securing axis for screws for the glazing beads	rientro fermavetro glazing beads gap	clips fissaggio fermavetro securing clips for glazing beads	spessore di compensazione * Shim *	spessore per vetro glass shim	guarnizione sotto vetro under glass gasket
Code		a	b	mm.	x	c	y	z	α	β
 P.2038	33 - 39	2	3	33	40**	2	AC2608	3 mm.	AC1020R	GE1007TT
				35	38**	0				
				37	36**	-2				
				39	34**	-4				

*non fornito
*not included

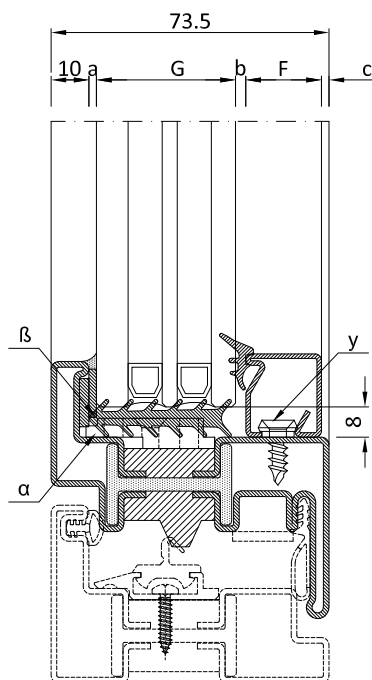
** fissare tramite il primo foro della clip
** screw in the upper hole of the clip

Taglio a 45° dei fermavetri effettuabile utilizzando la ganascia AT2038
45° cutting of the glazing beads done using the cutting jaw AT2038

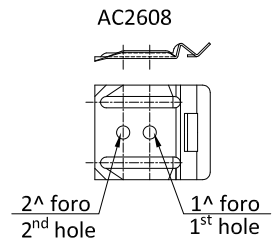
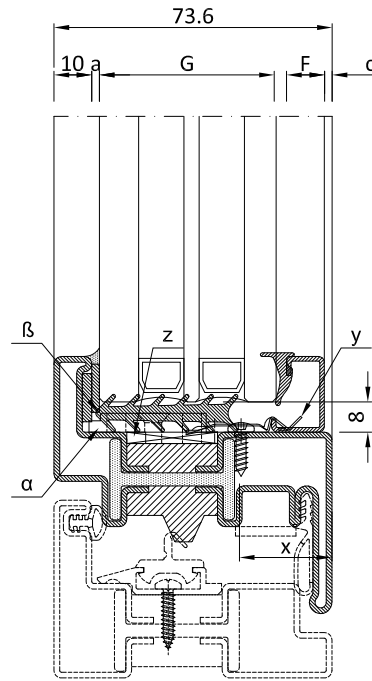




F	G	Guarnizioni - gaskets										
fermavetro glazing bead	range vetro glass range	GE1206 3 mm 	GP0095 2 / 3 mm 	GE1011 3 / 4 mm 	GE1012 6 / 8 mm 	GE1013 12 / 16 mm 	asse fissaggio viti fermavetro securing axis for screws for the glazing beads	rientro fermavetro glazing beads gap	boccole e viti fissaggio fermavetro Bushings and screws for glazing bead fixing	spessore per vetro glass shim	guarnizione sotto vetro under glass gasket	
Code		a	b	b	b	b	x	c	y	α	β	
 P.2007	27 - 43	3	40	39	35	27	9.5	2	CV5001(i) CV5012(i)	AC1020M	GE1007TT	
			-	-	-	-						
41	40		37	31	7.5	0						
-	-		-	-								
42	41		37	29	13.5	2	CV5001(i) CV5012(i)	AC1020M	GE1007TT			
-	-		-	-								
43	42		39	33	11.5	0						
-	-		-	-								
 P.1007	23 - 39		36	35	31	23	18	2	CV5001(i) CV5012(i)	AC1020M	GE1007TT	
			-	-	-	-						
37	36	33	27	16	0							
-	-	-	-									
38	37	33	25	18	2	CV5001(i) CV5012(i)	AC1020M	GE1007TT				
-	-	-	-									
39	38	35	29	16	0							
-	-	-	-									
 P.2008	20 - 34	31	30	26	18	18	2	CV5001(i) CV5012(i)	AC1020M	GE1007TT		
		-	-	-	-							
32	31	28	22	16	0							
-	-	-	-									
33	32	28	20	18	2	CV5001(i) CV5012(i)	AC1020R	GE1007TT				
-	-	-	-									
34	33	30	24	16	0							
-	-	-	-									
 P.2009	18 - 24	21	20	18 min.	-	18	2	CV5001(i) CV5012(i)	AC1020R	GE1007TT		
		-	-	-	-							
22	21	18	-	16	0							
-	-	-	-									
23	22	18	-	16	0							
-	-	-	-									
24	23	20	-	16	0							
-	-	-	-									



F	G	Guarnizioni - gaskets									
fermavetro glazing bead	range vetro glass range	GU2035 2 mm + sigillatura + sealing	GP0095 2 / 3 mm	GE1011 3 / 4 mm	GE1012 6 / 8 mm	GE1013 12 / 16 mm	asse fissaggio viti fermavetro securing axis for screws for the glazing beads	rientro fermavetro glazing beads gap	boccole e viti fissaggio fermavetro Bushings and screws for glazing bead fixing	spessore per vetro glass shim	guarnizione sotto vetro under glass gasket
Code		a	b	b	b	b	x	c	y	α	β
 P.2007	28 - 44	2	41	40	36	28	9.5	2	CV5001(i) CV5012(i)	AC1020M	GE1007TT
			-	-	-	-					
 P.1007	24 - 40		42	41	38	32	7.5	0	CV5001(i) CV5012(i)	AC1020M	GE1007TT
			43	42	38	30					
 P.2008	19 - 35		44	43	40	34	13.5	2	CV5001(i) CV5012(i)	AC1020M	GE1007TT
			37	36	32	24					
 P.1007	24 - 40		38	37	34	28	11.5	0	CV5001(i) CV5012(i)	AC1020M	GE1007TT
			39	38	34	26					
 P.2008	19 - 35		40	39	36	30	18	2	CV5001(i) CV5012(i)	AC1020M	GE1007TT
			32	31	27	19					
 P.2009	18 - 25	33	32	29	23	16	0	CV5001(i) CV5012(i)	AC1020M	GE1007TT	
		34	33	29	21						-
 P.2009	18 - 25	35	34	31	25	18	2	CV5001(i) CV5012(i)	AC1020R	GE1007TT	
		22	21	18 min.	-						-
 P.2009	18 - 25	23	22	19	21	16	0	CV5001(i) CV5012(i)	AC1020R	GE1007TT	
		24	23	19	-						-
 P.2009	18 - 25	25	24	21	21	16	0	CV5001(i) CV5012(i)	AC1020R	GE1007TT	
		24	23	19	-						-

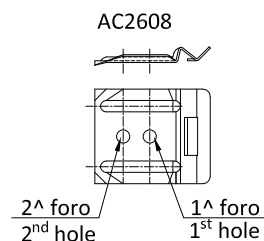
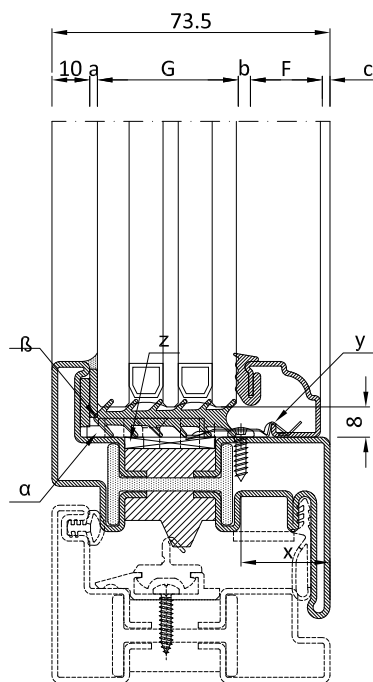


		Guarnizioni - gaskets		G						
fermavetro glazing bead	range vetro glass range	GE1206 3 mm 	GP0095 3 mm 	spessore vetro glass thickness	asse fissaggio viti fermavetro securing axis for screws for the glazing beads	rientro fermavetro glazing beads gap	clips fissaggio fermavetro securing clips for glazing beads	spessore di compensazione * Shim *	spessore per vetro glass shim	guarnizione sotto vetro under glass gasket
Code		a	b	mm.	x	c	y	z	α	β
	43	3	3	43	26**	2	AC2608	3 mm.	AC1020M	GE1007TT
	45			45	24**					

		Guarnizioni - gaskets		G						
fermavetro glazing bead	range vetro glass range	GU2035 2 mm + sigillatura + sealing	GP0095 3 mm 	spessore vetro glass thickness	asse fissaggio viti fermavetro securing axis for screws for the glazing beads	rientro fermavetro glazing beads gap	clips fissaggio fermavetro securing clips for glazing beads	spessore di compensazione * Shim *	spessore per vetro glass shim	guarnizione sotto vetro under glass gasket
Code		a	b	mm.	x	c	y	z	α	β
	44	2	3	44	26**	2	AC2608	3 mm.	AC1020M	GE1007TT
	46			46	24**					

*non fornito
*not included

** fissare tramite il primo foro della clip
** screw in the upper hole of the clip



F		Guarnizioni - gaskets		G						
fermavetro glazing bead	range vetro glass range	GE1206 3 mm 	GE2028 2.5 mm 	spessore vetro glass thickness	asse fissaggio viti fermavetro securing axis for screws for the glazing beads	rientro fermavetro glazing beads gap	clips fissaggio fermavetro securing clips for glazing beads	spessore di compensazione * Shim *	spessore per vetro glass shim	guarnizione sotto vetro under glass gasket
Code		a	b	mm.	x	c	y	z	α	β
 P.2028	32 - 38	3	2.5	32	34	6	AC2608	3 mm.	AC1020M	GE1007TT
				34	25**	4				
				36	23**	2				
				38	21**	0				

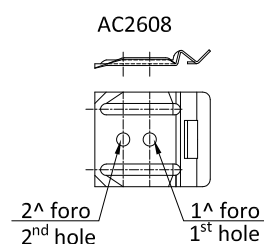
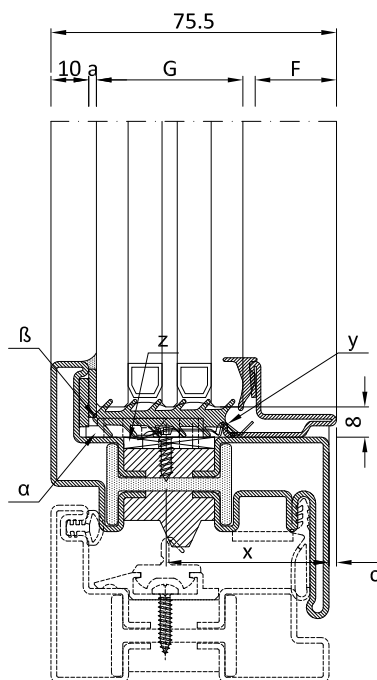
F		Guarnizioni - gaskets		G						
fermavetro glazing bead	range vetro glass range	GU2035 2 mm + sigillatura + sealing	GE2028 2.5 mm 	spessore vetro glass thickness	asse fissaggio viti fermavetro securing axis for screws for the glazing beads	rientro fermavetro glazing beads gap	clips fissaggio fermavetro securing clips for glazing beads	spessore di compensazione * Shim *	spessore per vetro glass shim	guarnizione sotto vetro under glass gasket
Code		a	b	mm.	x	c	y	z	α	β
 P.2028	33 - 39	2	2.5	33	34	6	AC2608	3 mm.	AC1020M	GE1007TT
				35	25**	4				
				37	23**	2				
				39	21**	0				

*non fornito
*not included

** fissare tramite il primo foro della clip
** screw in the upper hole of the clip

Taglio a 45° dei fermavetri effettuabile utilizzando la ganascia AT2029
45° cutting of the glazing beads done using the cutting jaw AT2029





F		Guarnizioni - gaskets		G						
fermavetro glazing bead	range vetro glass range	GE1206 3 mm 	GP0095 3 mm 	spessore vetro glass thickness	asse fissaggio viti fermavetro securing axis for screws for the glazing beads	rientro fermavetro glazing beads gap	clips fissaggio fermavetro securing clips for glazing beads	spessore di compensazione * Shim *	spessore per vetro glass shim	guarnizione sotto vetro under glass gasket
Code		a	b	mm.	x	c	y	z	α	β
 P.2038	32 - 38	3	3	32	40**	2	AC2608	3 mm.	AC1020M	GE1007TT
				34	38**	0				
				36	43	-2				
				38	41	-4				

F		Guarnizioni - gaskets		G						
fermavetro glazing bead	range vetro glass range	GU2035 2 mm + sigillatura + sealing	GP0095 3 mm 	spessore vetro glass thickness	asse fissaggio viti fermavetro securing axis for screws for the glazing beads	rientro fermavetro glazing beads gap	clips fissaggio fermavetro securing clips for glazing beads	spessore di compensazione * Shim *	spessore per vetro glass shim	guarnizione sotto vetro under glass gasket
Code		a	b	mm.	x	c	y	z	α	β
 P.2038	33 - 39	2	3	33	40**	2	AC2608	3 mm.	AC1020M	GE1007TT
				35	38**	0				
				37	43	-2				
				39	41	-4				

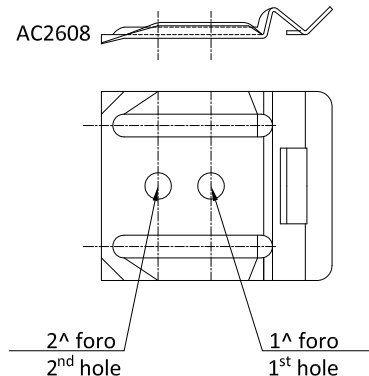
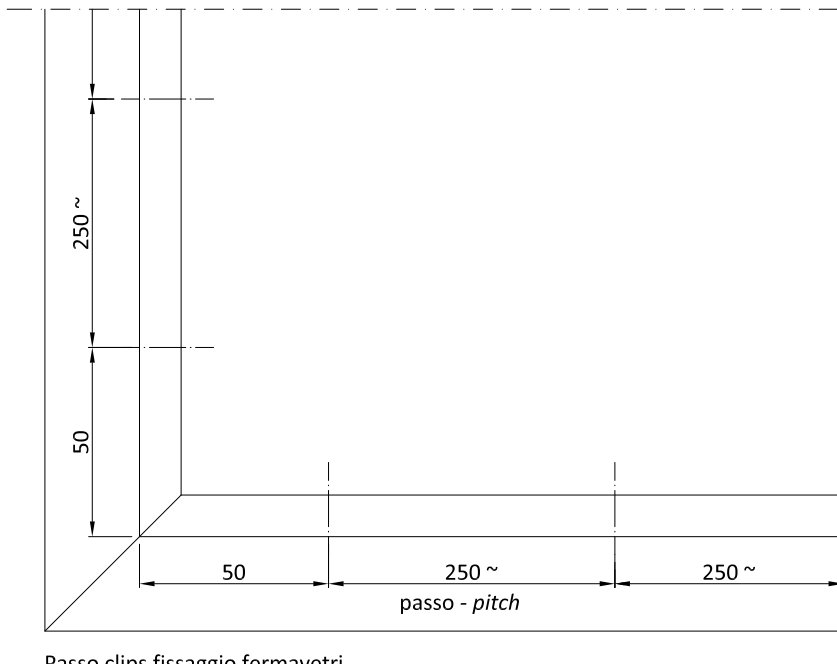
*non fornito
*not included

** fissare tramite il primo foro della clip
** screw in the upper hole of the clip

Taglio a 45° dei fermavetri effettuabile utilizzando la ganascia AT2038
45° cutting of the glazing beads done using the cutting jaw AT2038



P.2015 - P.2028 - P.2038

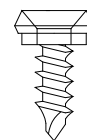
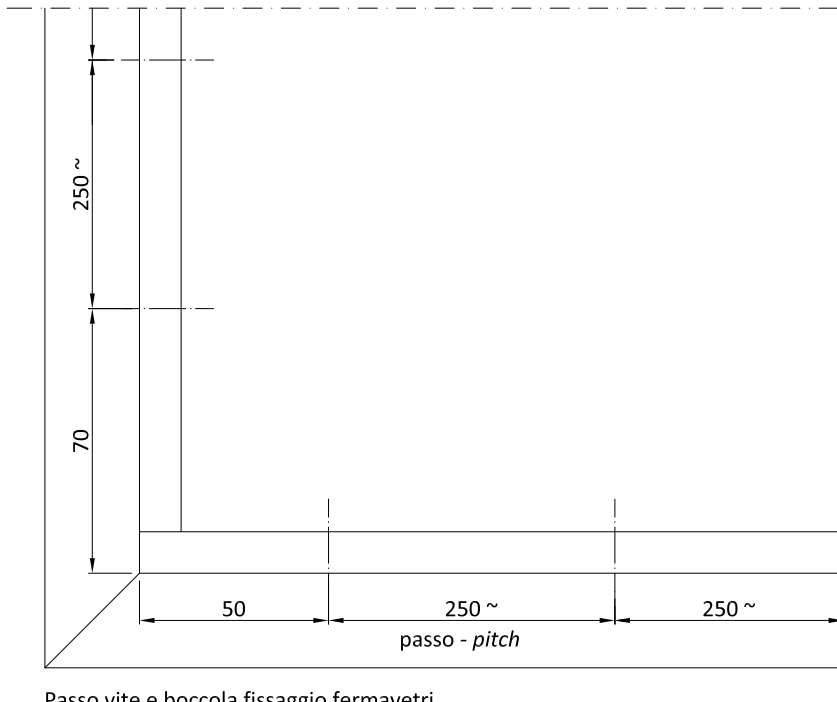


Passo clips fissaggio fermavetri
Clip pitch for fixing the glazing beads

Per il fissaggio utilizzare TCTC 3.5 x 9.5
For fixing use TCTC 3.5 x 9.5 screws

Fori eseguibili con maschera AT2828
Holes to be done with AT2828

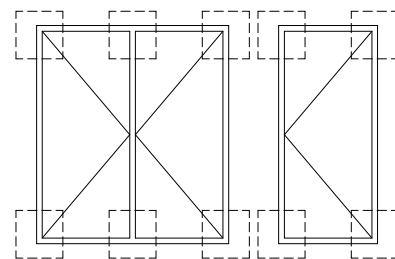
P.2007 - P.1007 - P.2008 - P.2009



CV5001 + CV5012
CV5001I + CV5012I

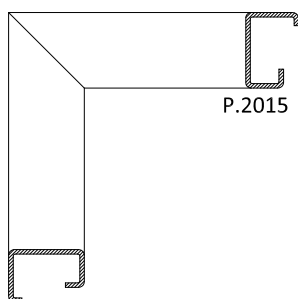
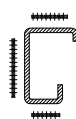
Passo vite e boccia fissaggio fermavetri
Clip pitch to fix glazing beads

Fori eseguibili con maschera AT1234
Holes to be done with AT1234

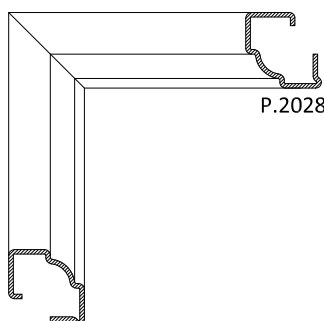
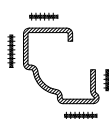


Acciaio zincato - Acciaio Corten - Acciaio inox
Saldare in continuo le superfici di contatto indicate

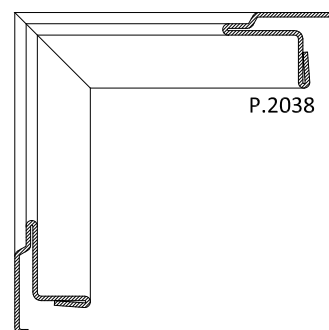
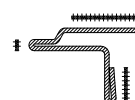
Galvanised steel - Cor-ten steel - Stainless steel
Seam-weld the shown areas



P.2015



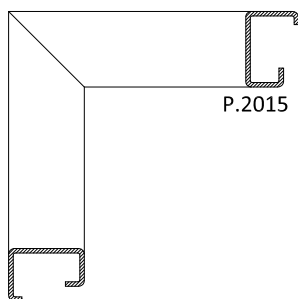
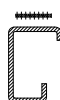
P.2028



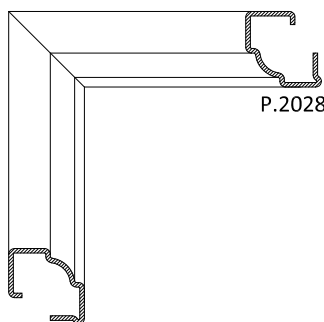
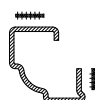
P.2038

Ottone
Saldare a TIG a punti le zone indicate.

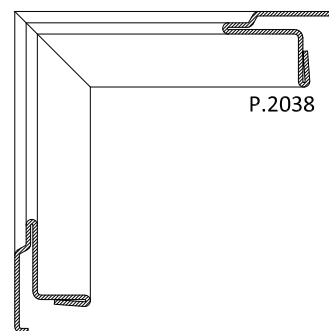
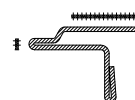
Brass
Spot weld (TIG) the marked areas.



P.2015



P.2028

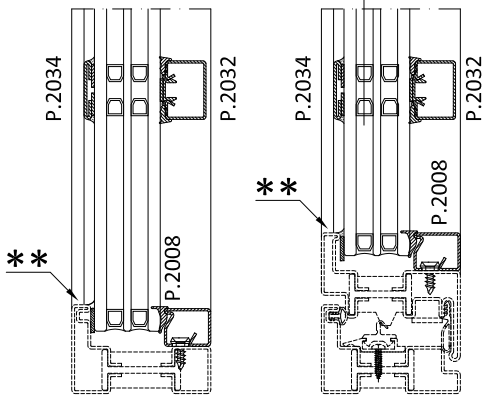
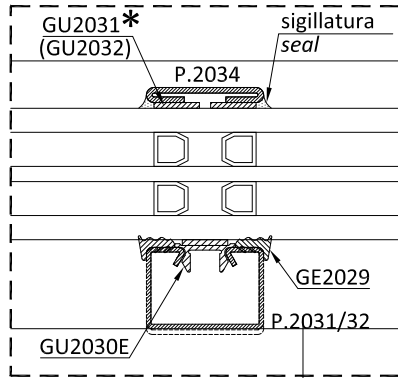


P.2038

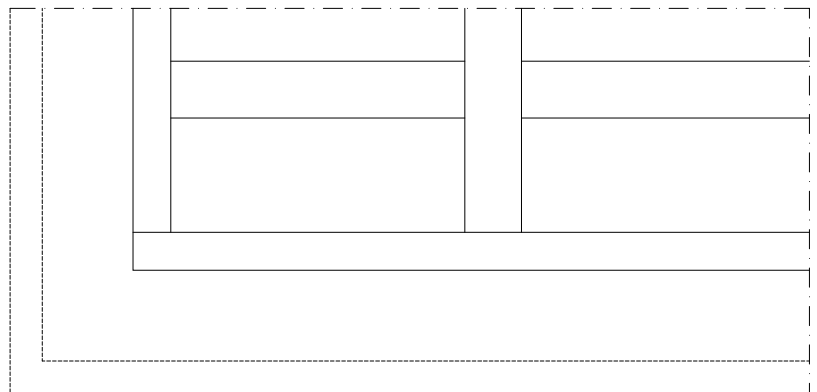
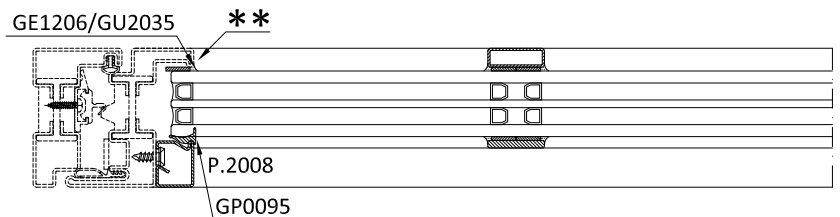
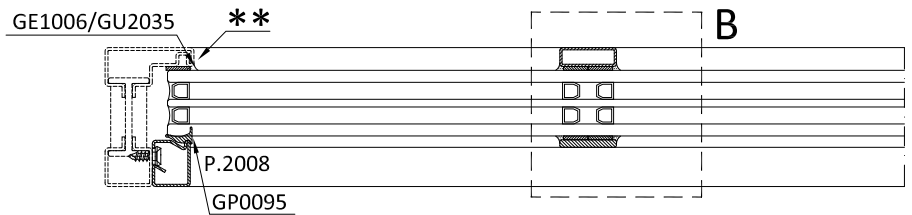
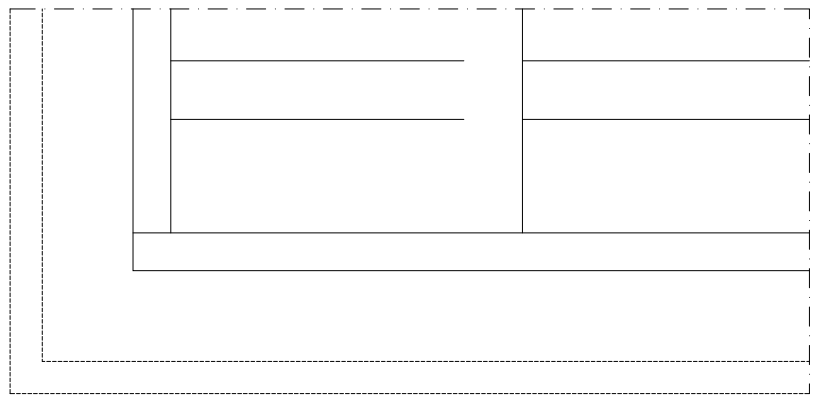
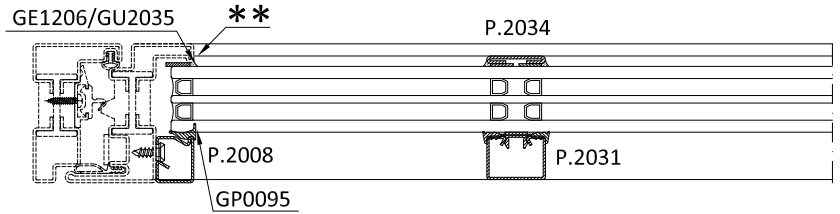
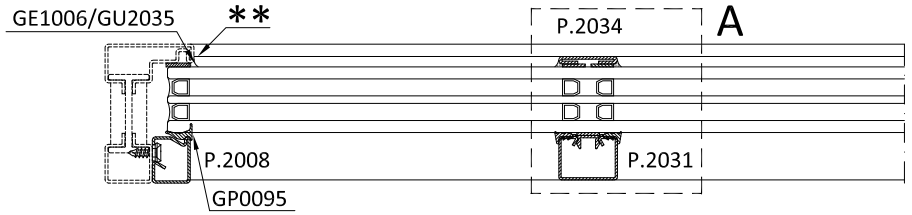
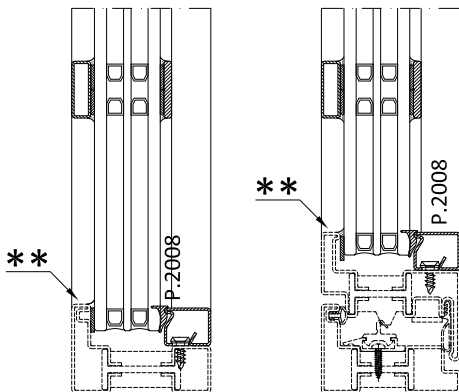
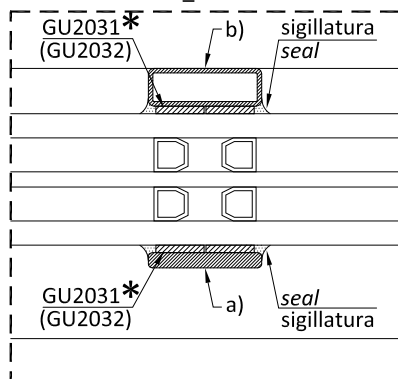
P.2028
Taglio a 45° dei fermavetri effettuabile utilizzando la ganascia AT2029
45° cutting of the glazing beads done using the cutting jaw AT2029

P.2038
Taglio a 45° dei fermavetri effettuabile utilizzando la ganascia AT2038
45° cutting of the glazing beads done using the cutting jaw AT2038

PARTICOLARE "A" _ DETAIL "A"



PARTICOLARE "B" _ DETAIL "B"

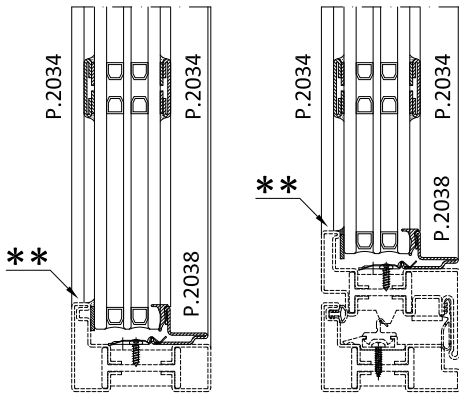
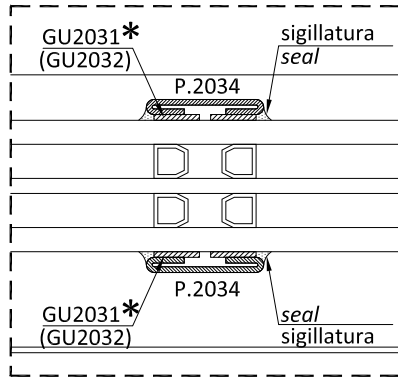


* Per utilizzo dividivetro SOLO orizzontali o SOLO verticali GU2031
 Per utilizzo dividivetro orizzontali e verticali GU2031 verticalmente GU2032 orizzontalmente
 For ONLY horizontal or ONLY vertical glazing beads use GU2031
 For horizontal and vertical glazing beads use GU2031 vertically and GU2032 horizontally

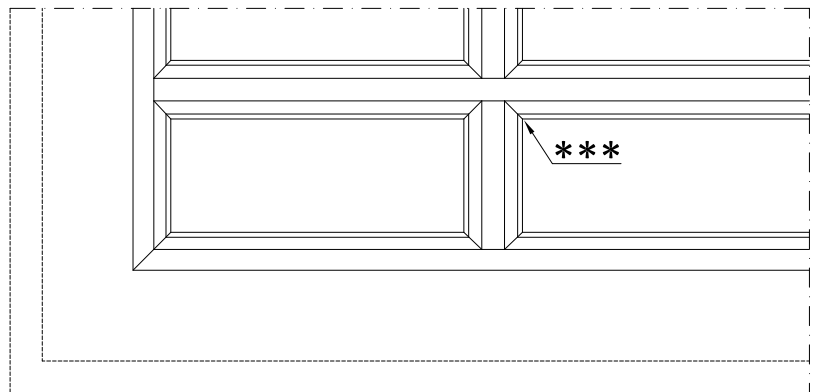
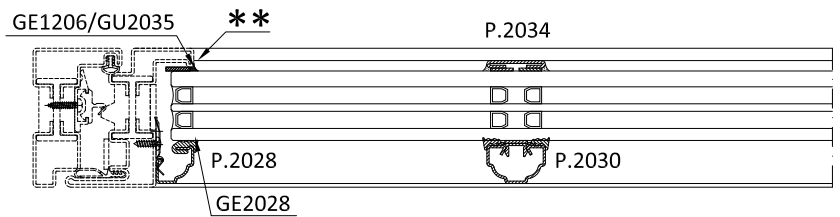
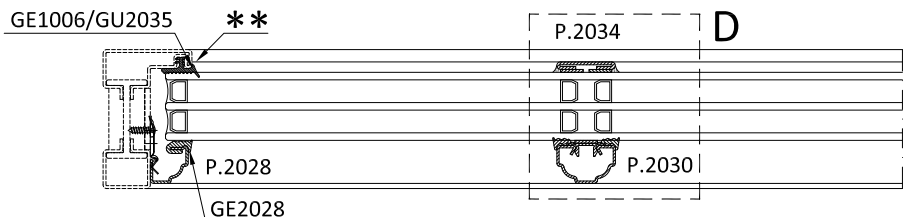
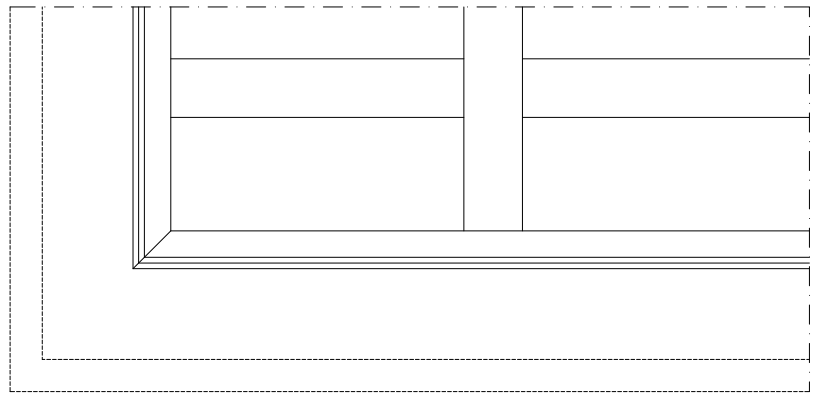
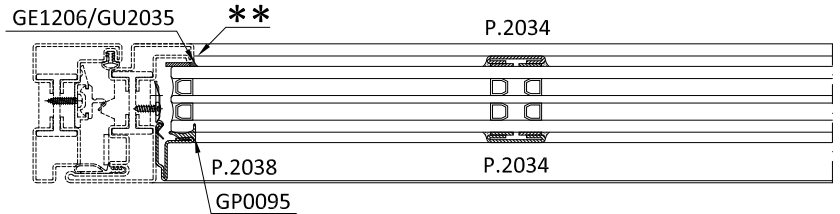
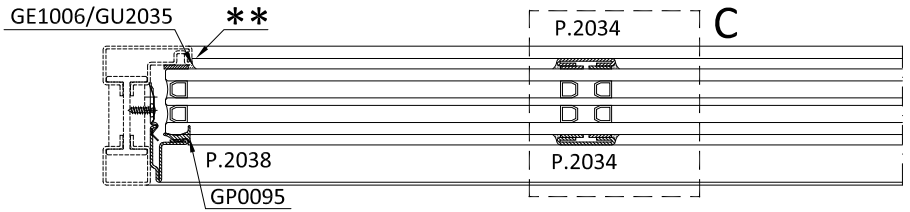
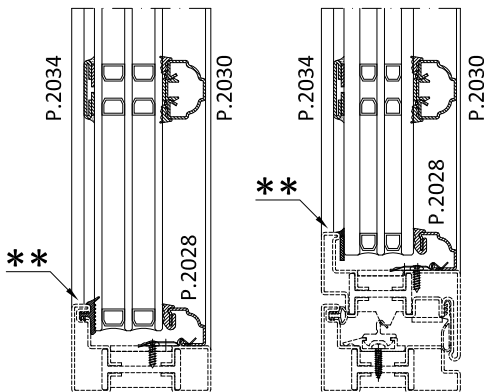
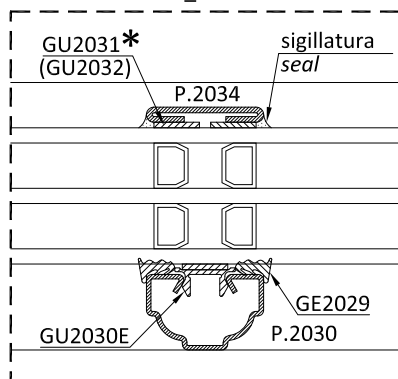
** Saldare o sigillare
 Weld or seal

a) profilo commerciale | section profile 30x4 mm
 b) profilo commerciale | section profile 30x10 mm

PARTICOLARE "C" _ DETAIL "C"



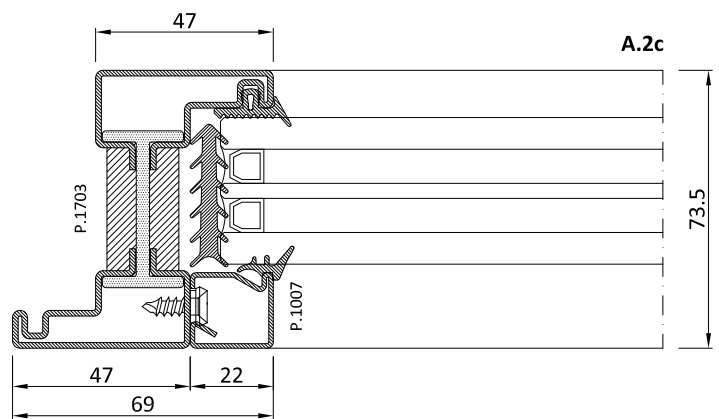
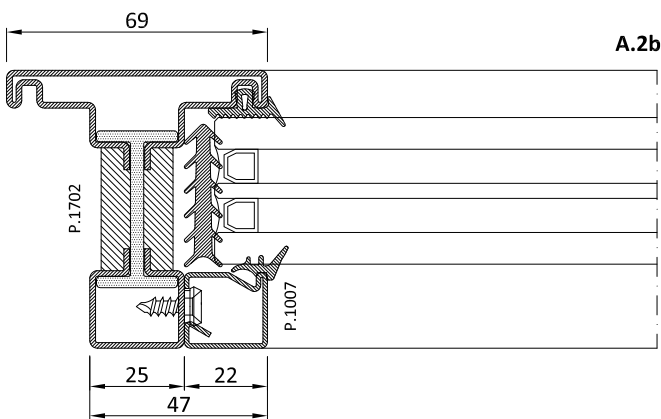
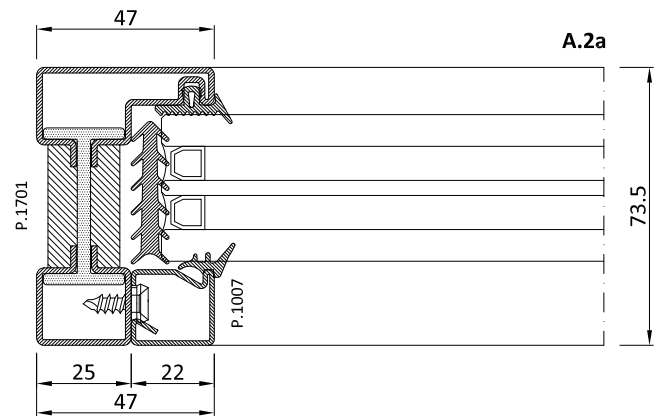
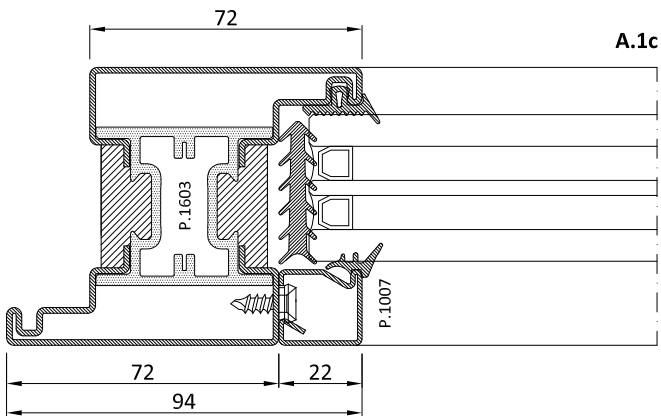
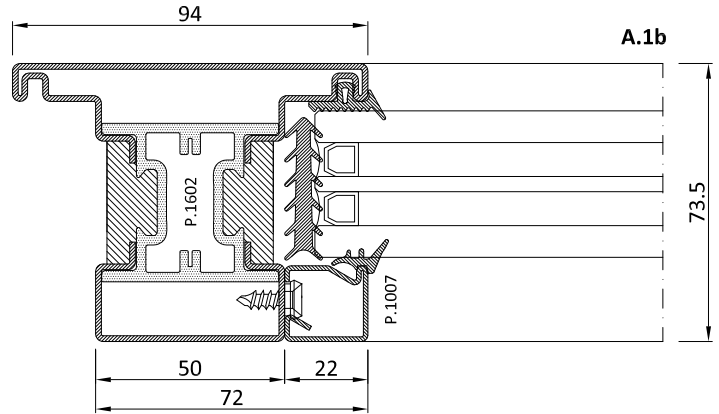
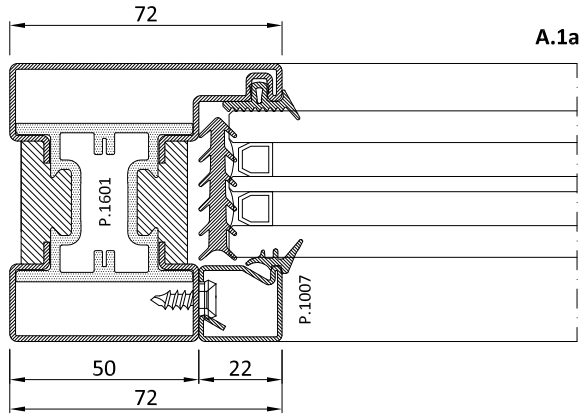
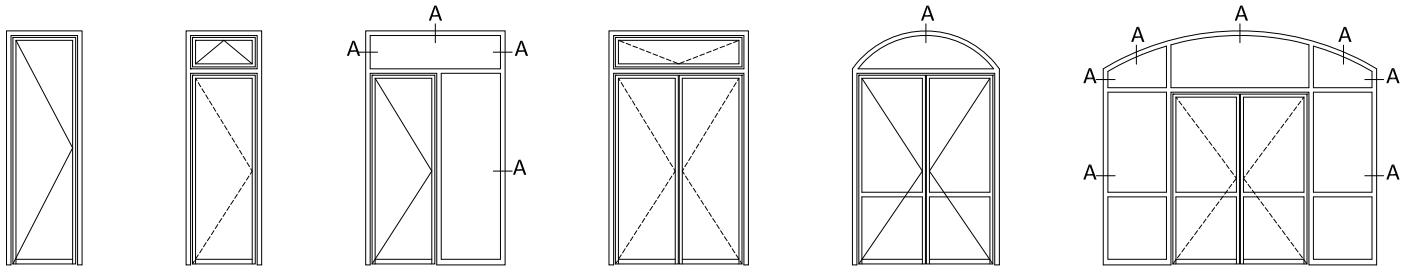
PARTICOLARE "D" _ DETAIL "D"

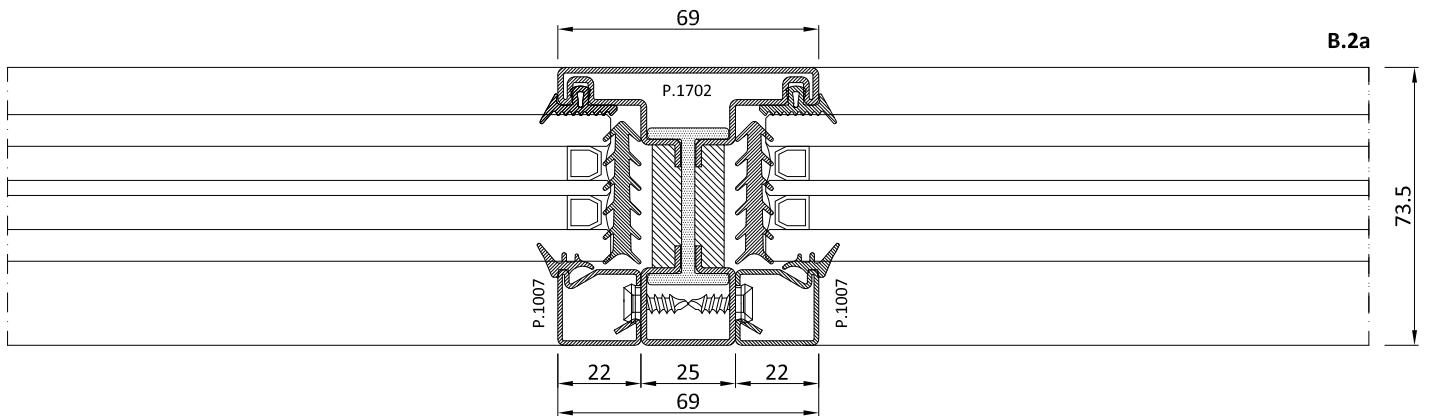
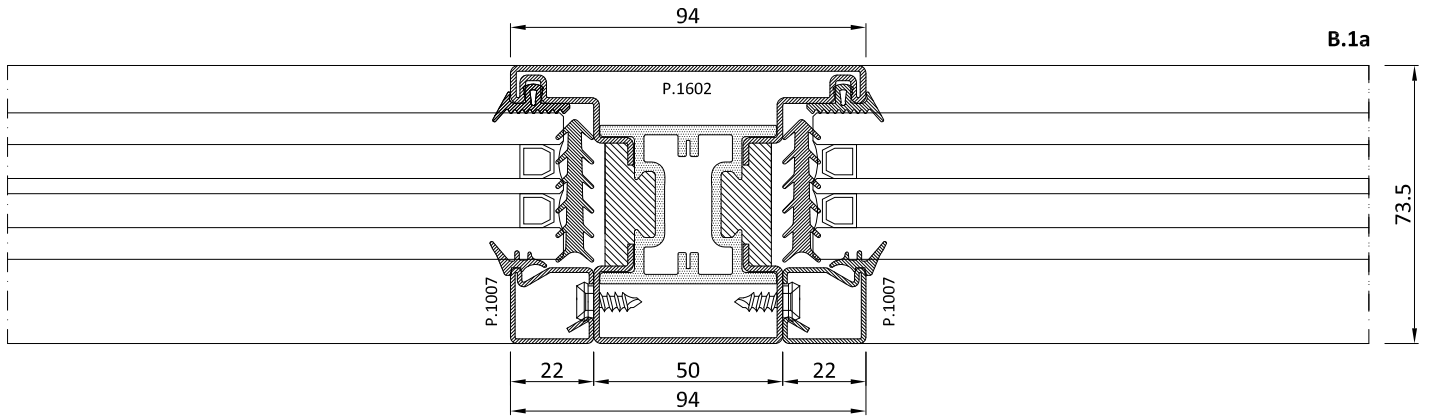
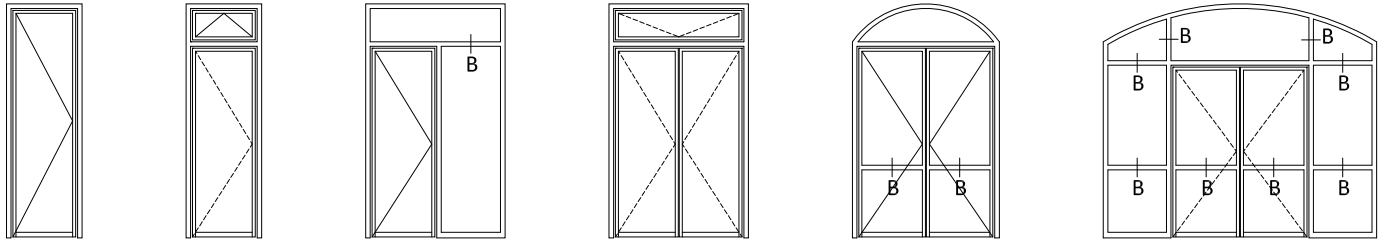


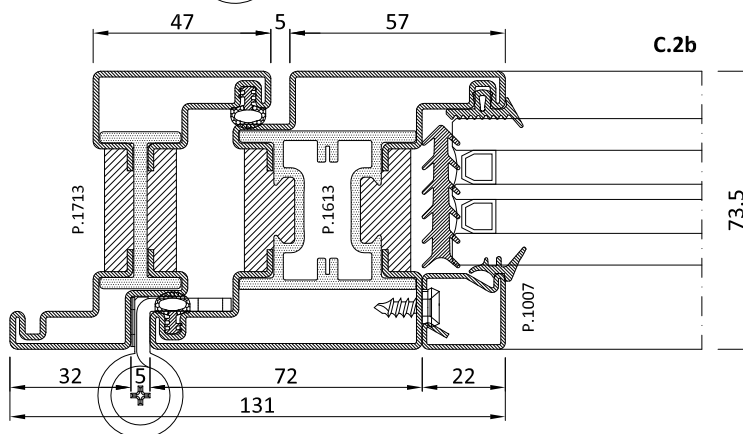
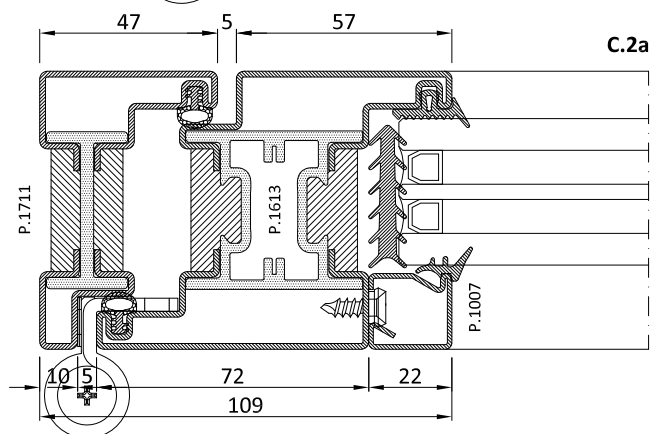
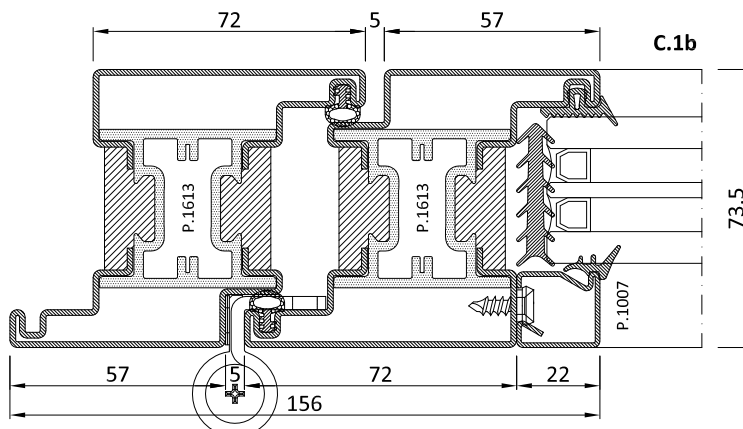
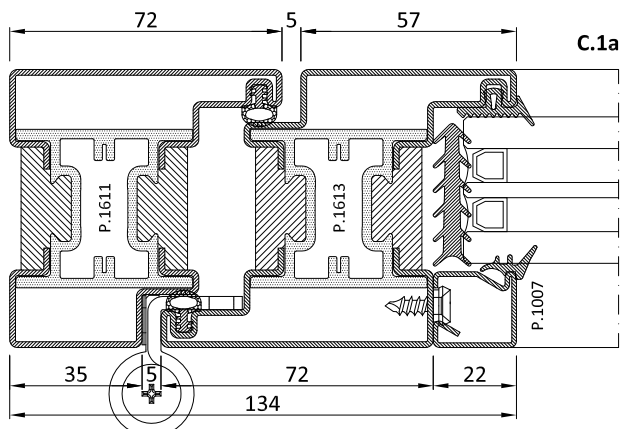
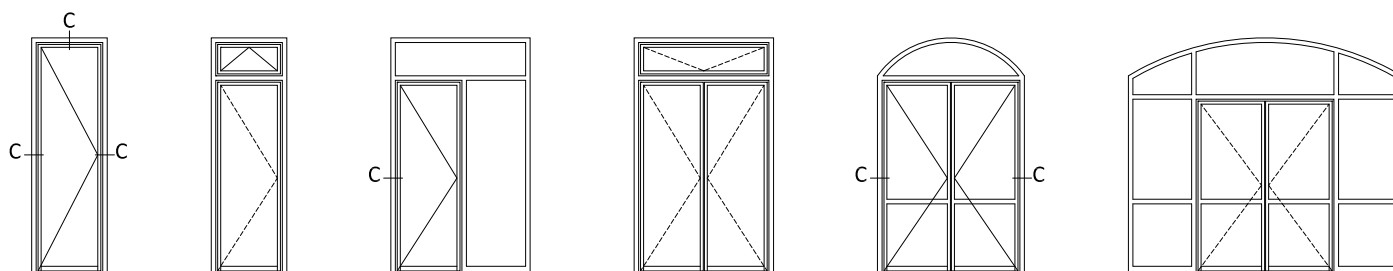
* Per utilizzo dividivetro SOLO orizzontali o SOLO verticali GU2031
 Per utilizzo dividivetro orizzontali e verticali GU2031 verticalmente GU2032 orizzontalmente
 For ONLY horizontal or ONLY vertical glazing beads use GU2031
 For horizontal and vertical glazing beads use GU2031 vertically and GU2032 horizontally

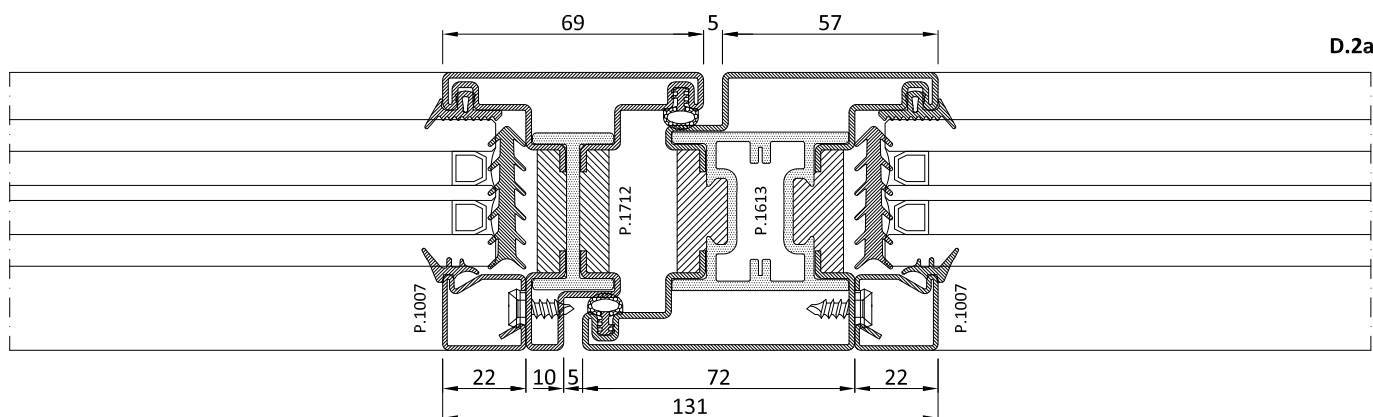
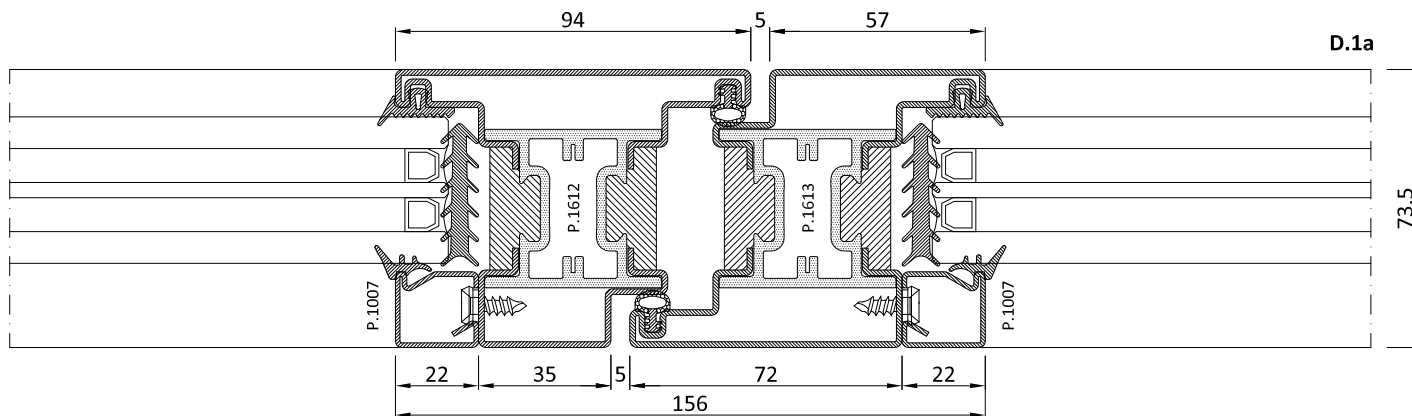
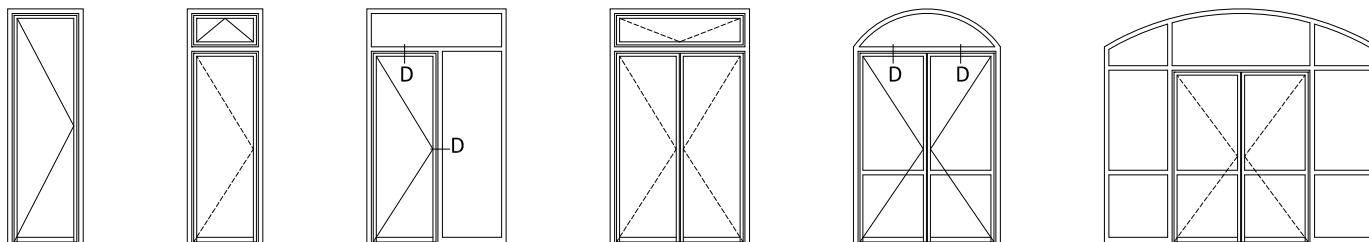
** Saldare o sigillare
 Weld or seal

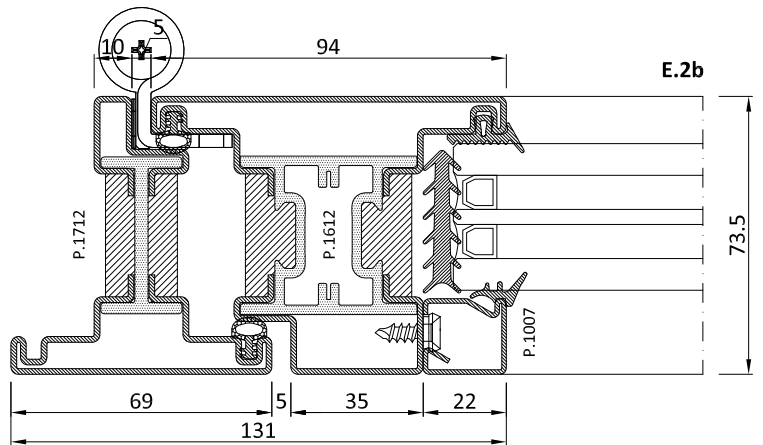
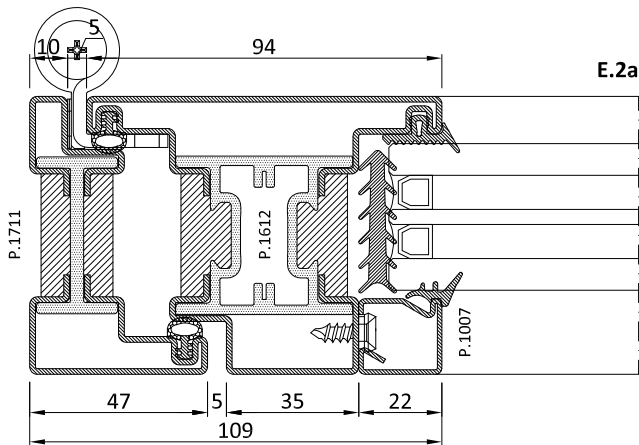
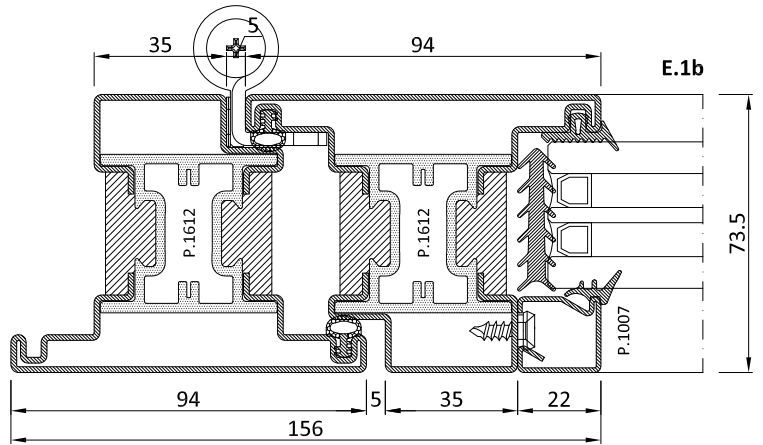
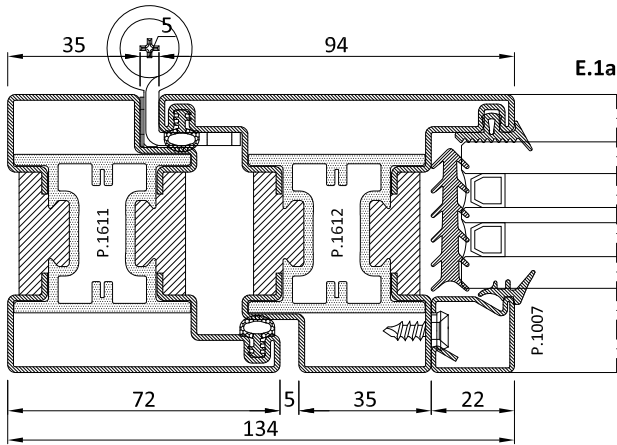
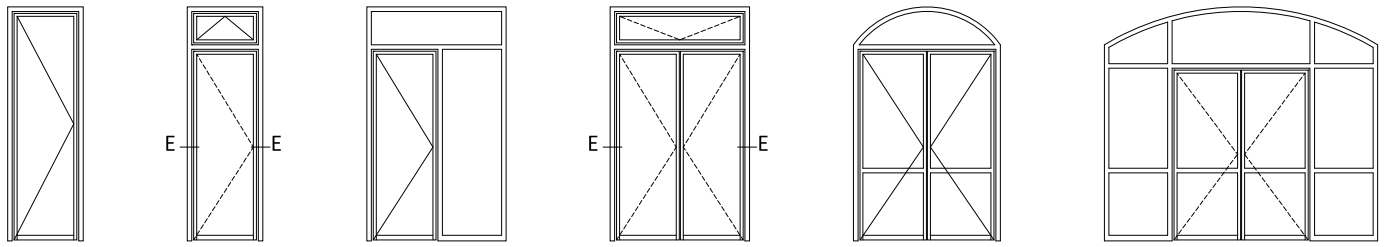
*** Lavorazione di intestatura effettuabile con stampo AT2030
 Processing of butt jointing carried out with a mould

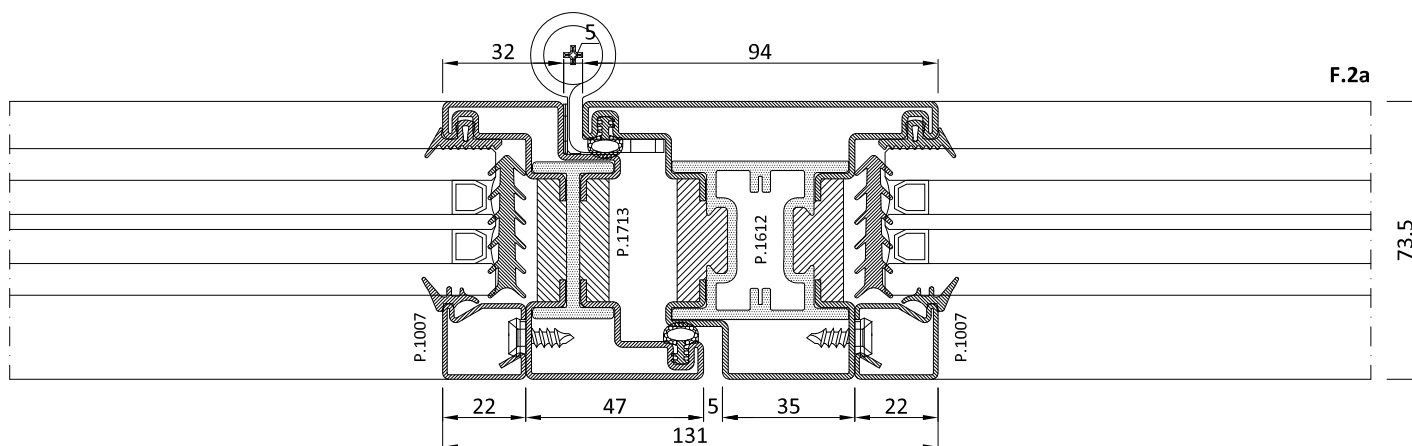
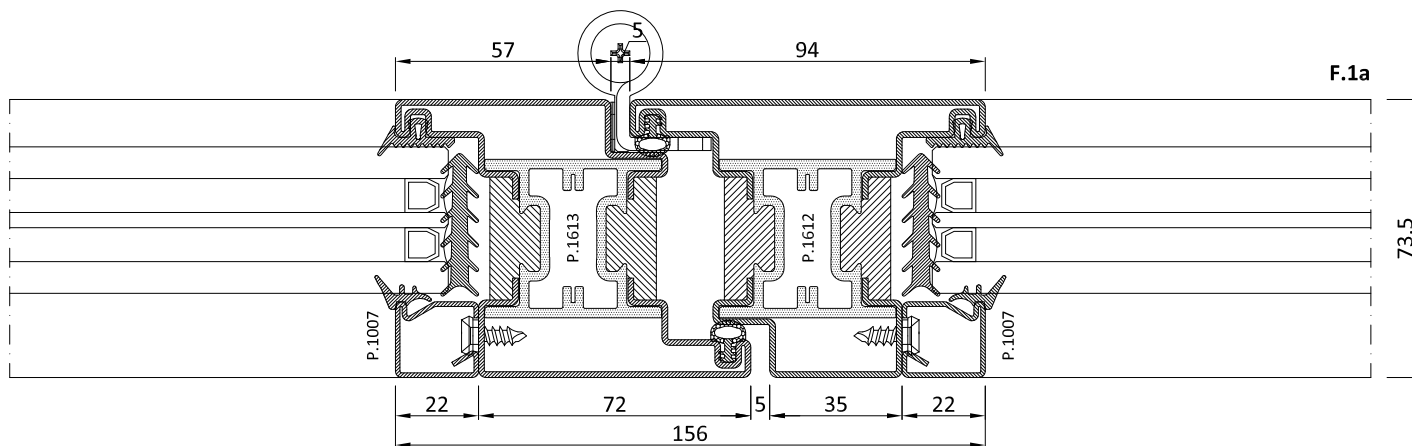
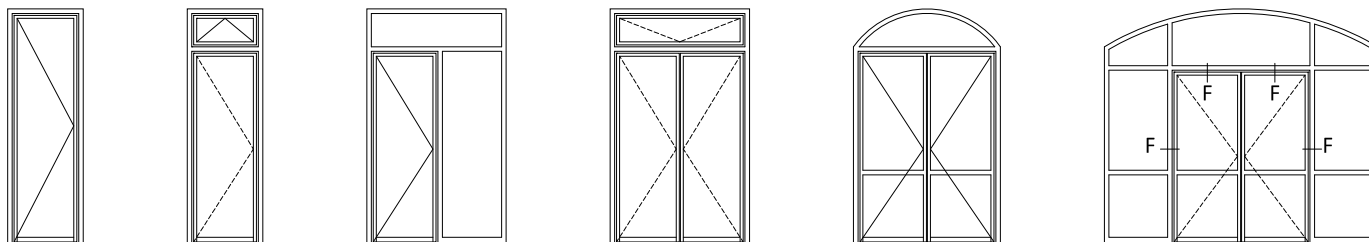


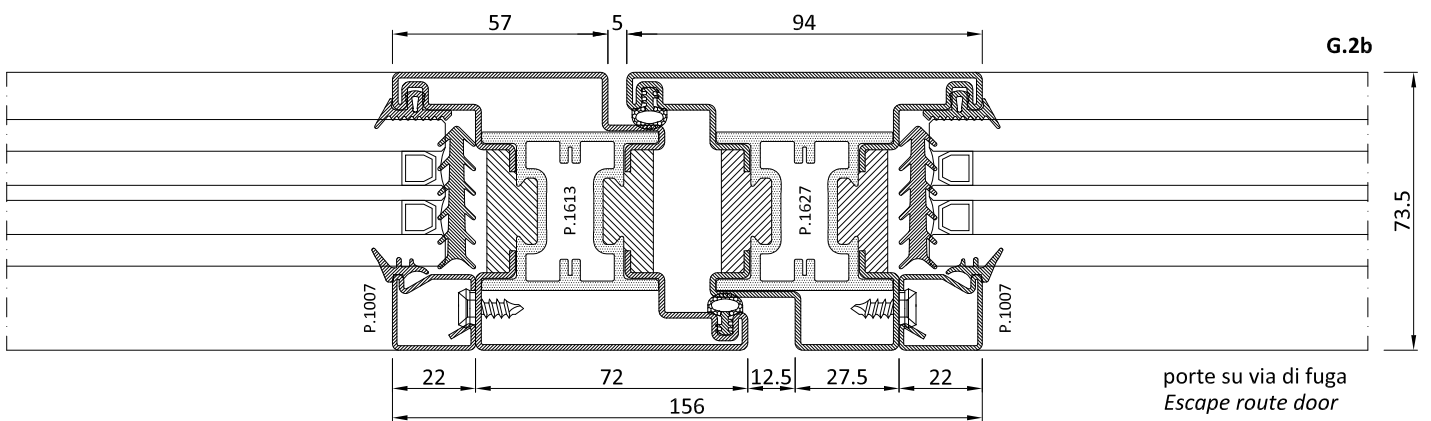
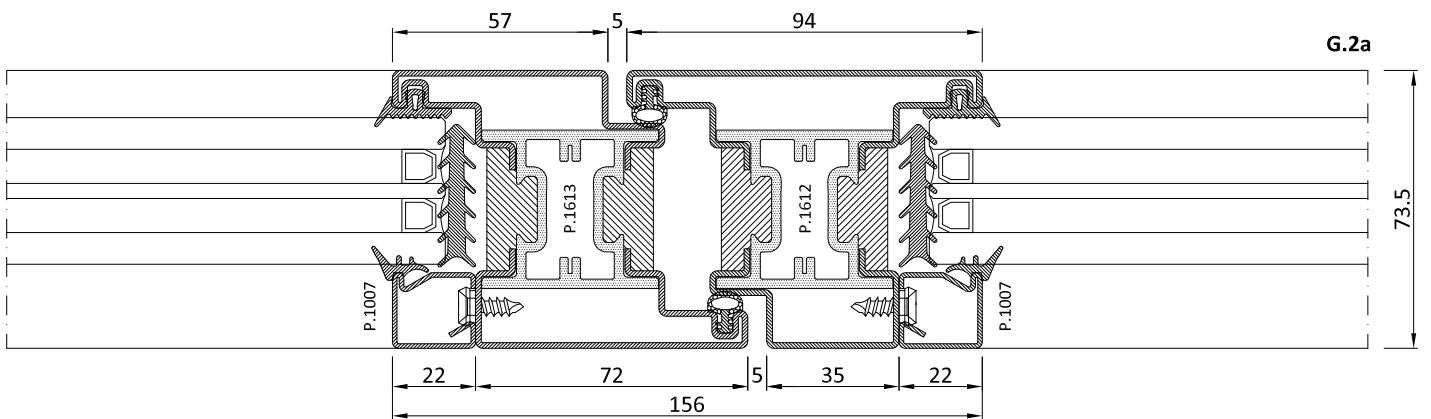
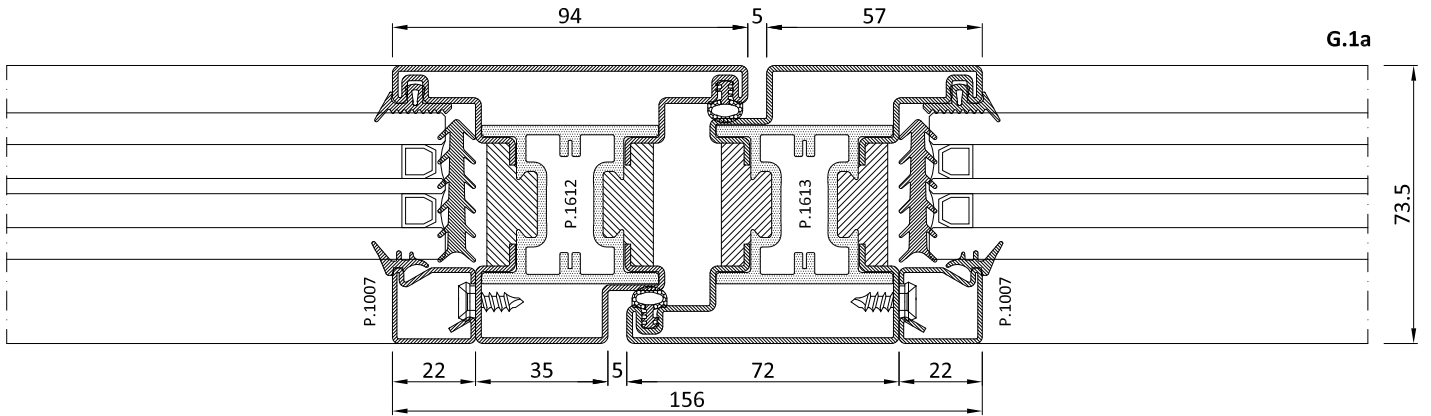
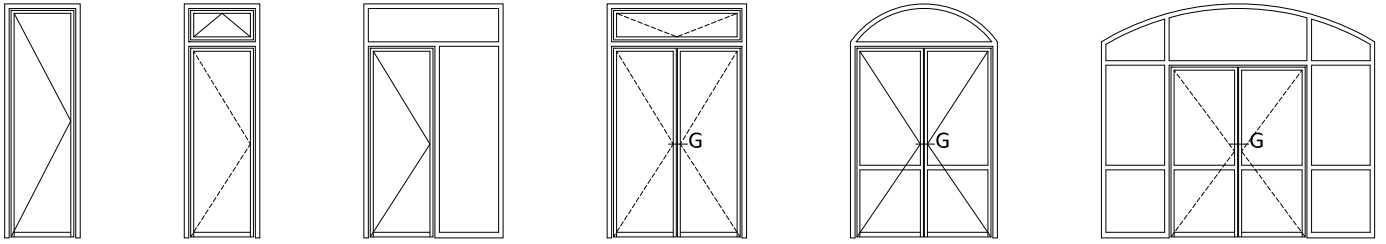


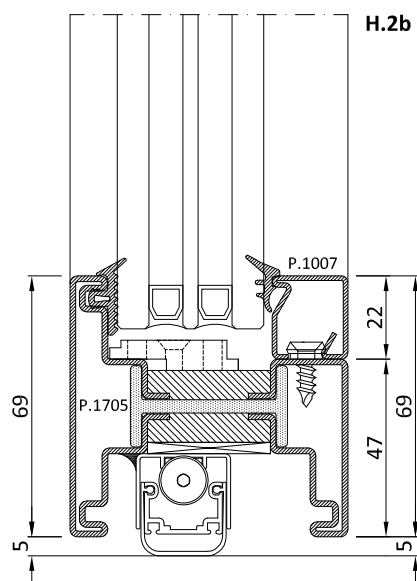
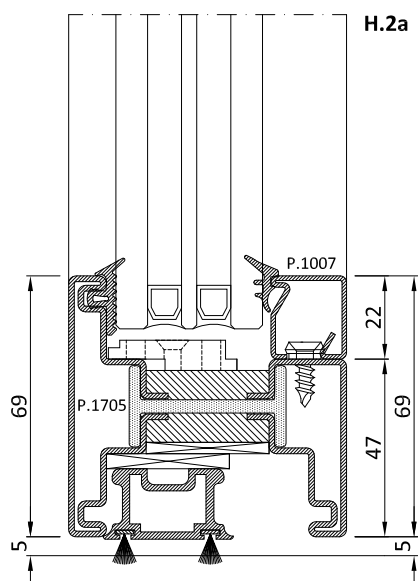
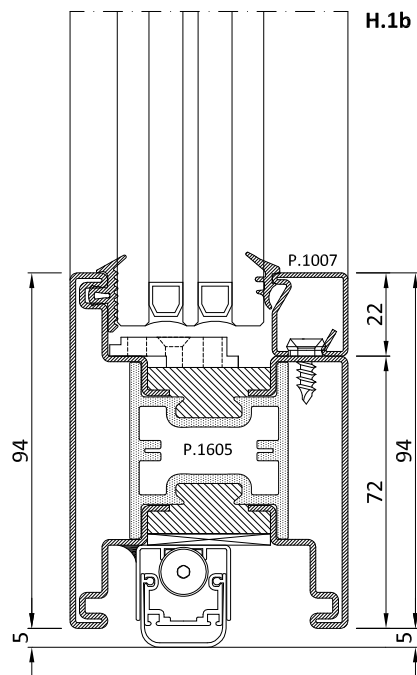
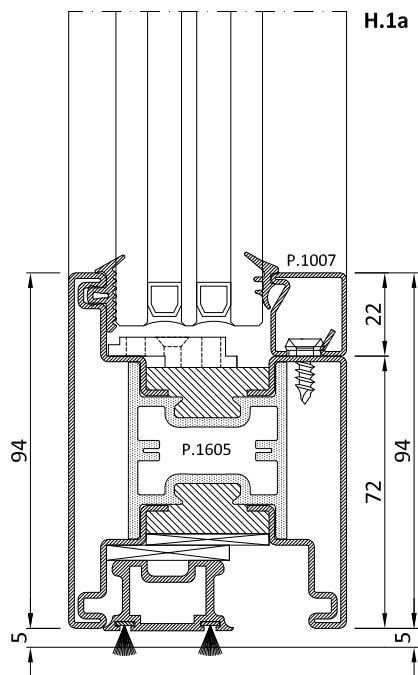
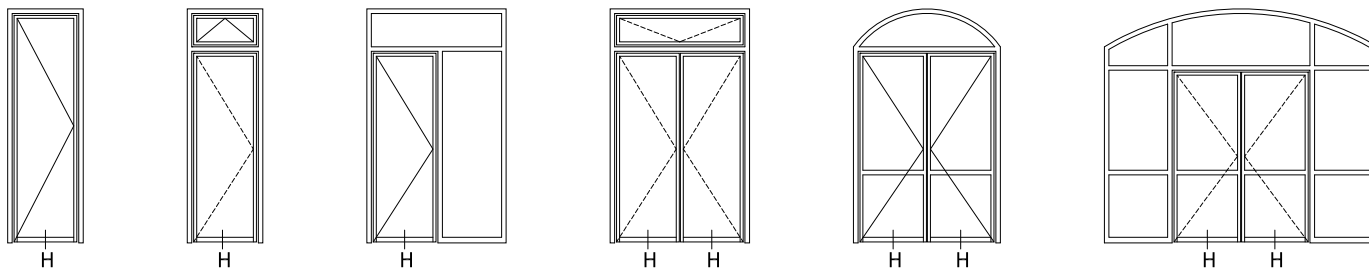


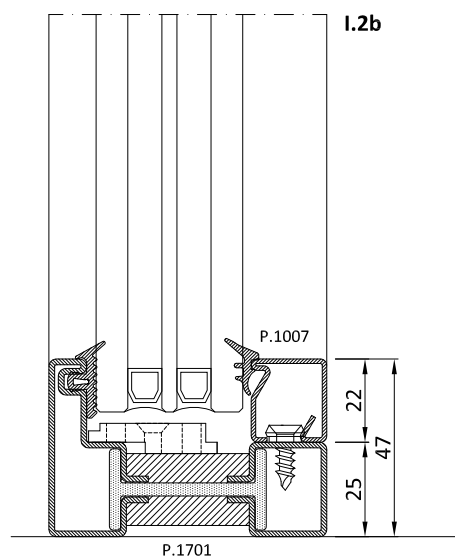
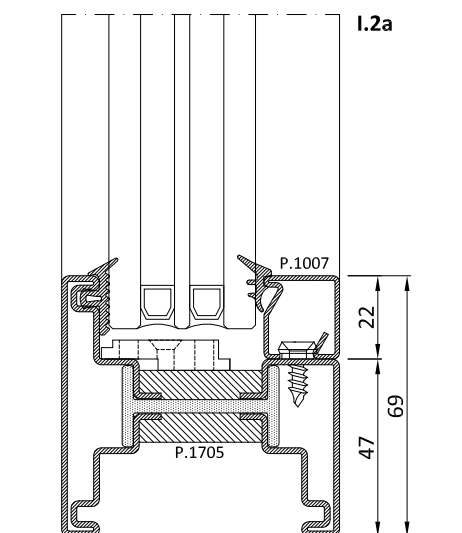
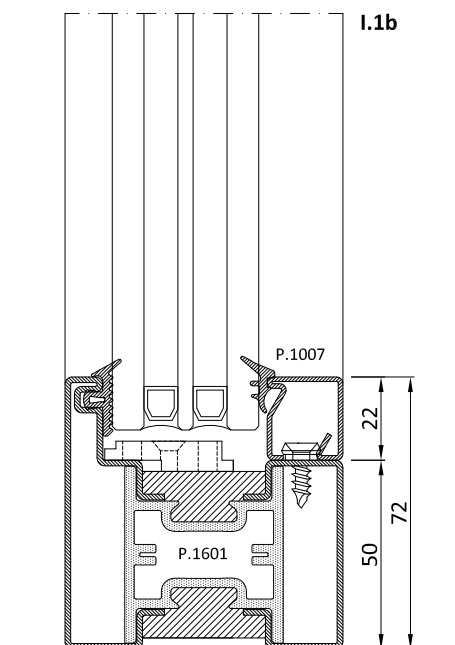
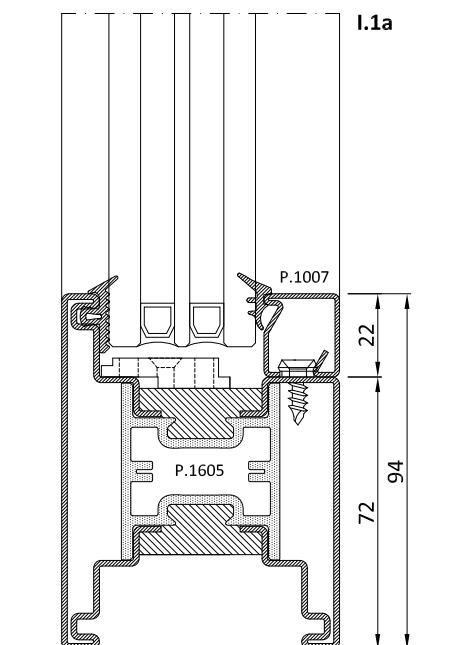
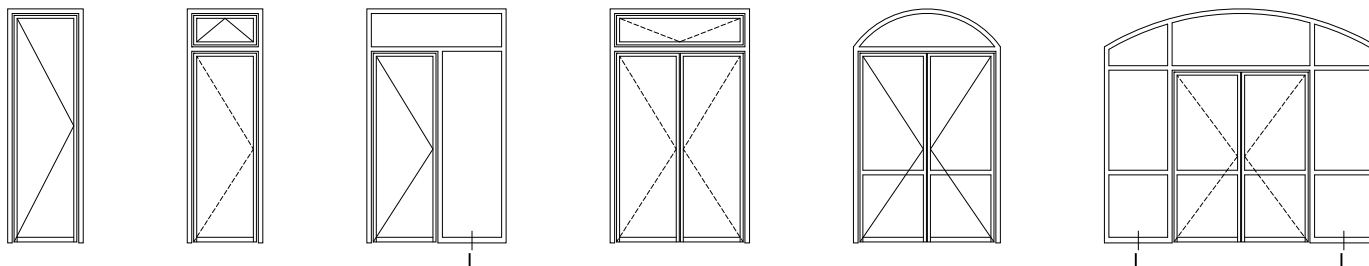


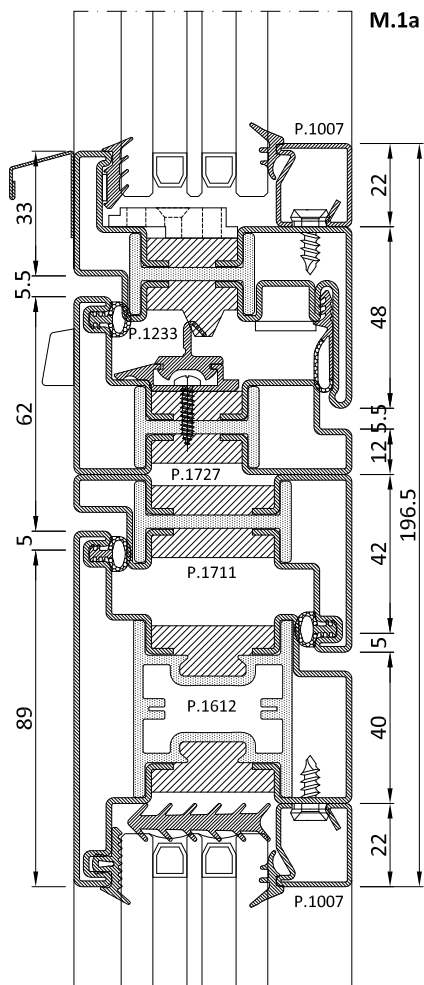
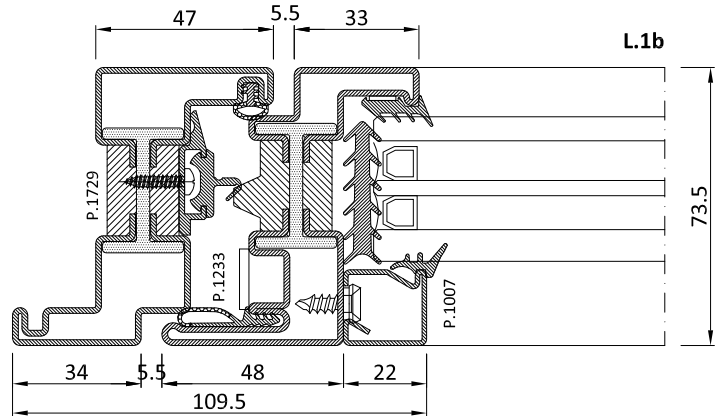
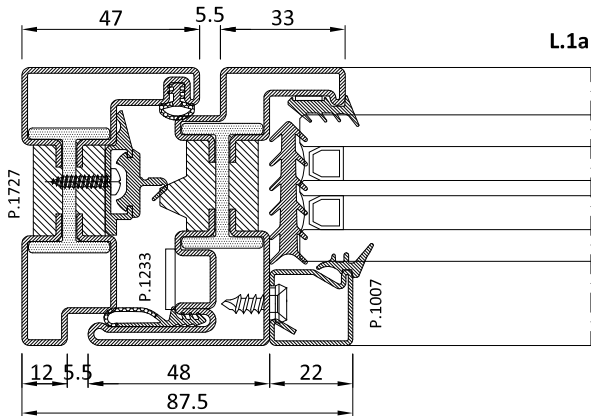
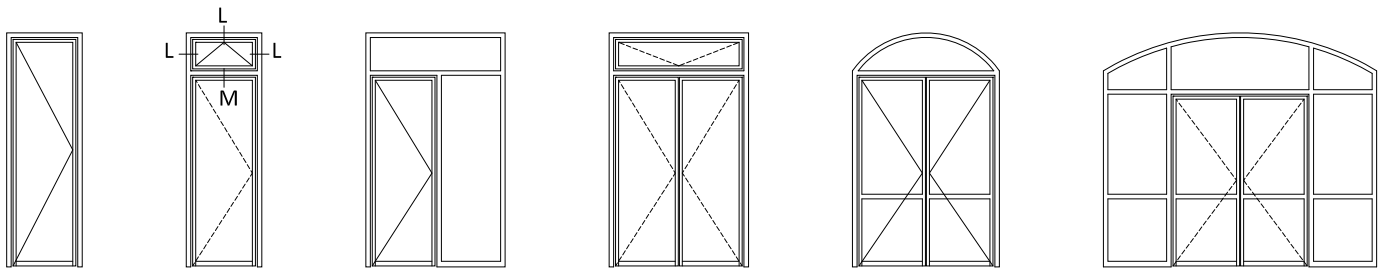


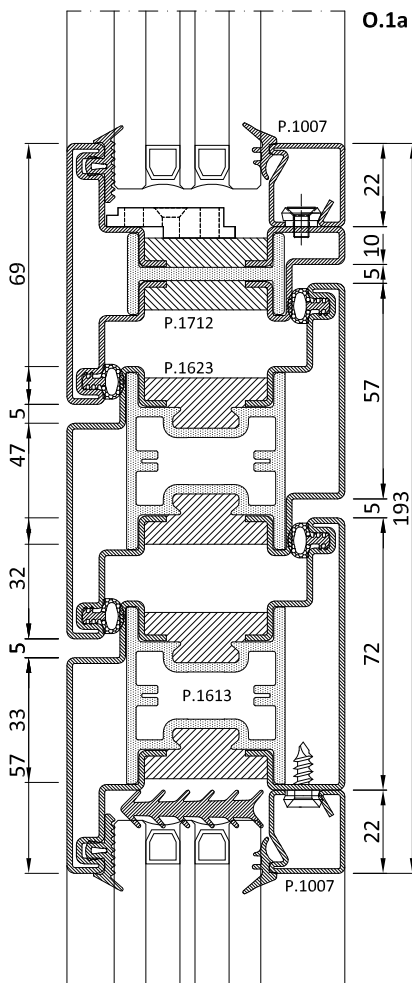
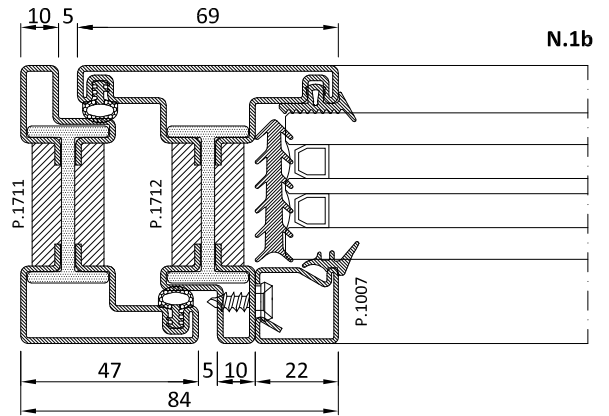
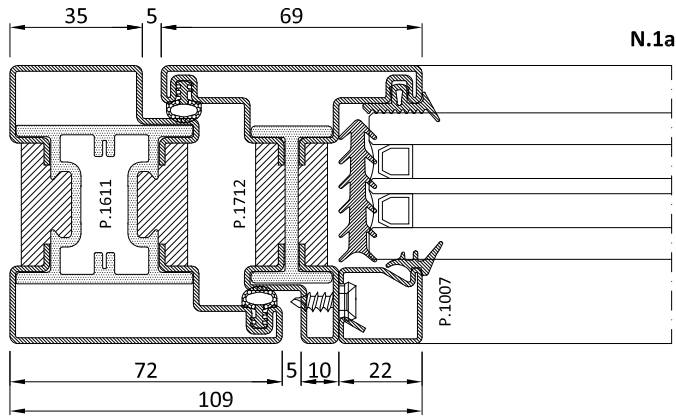
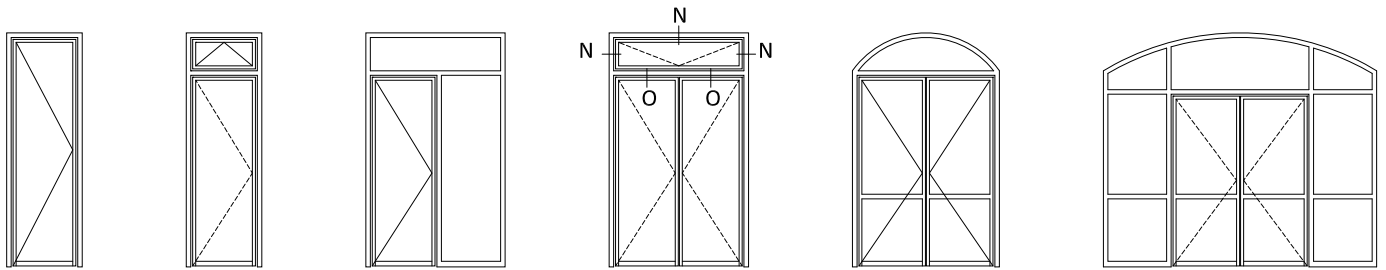


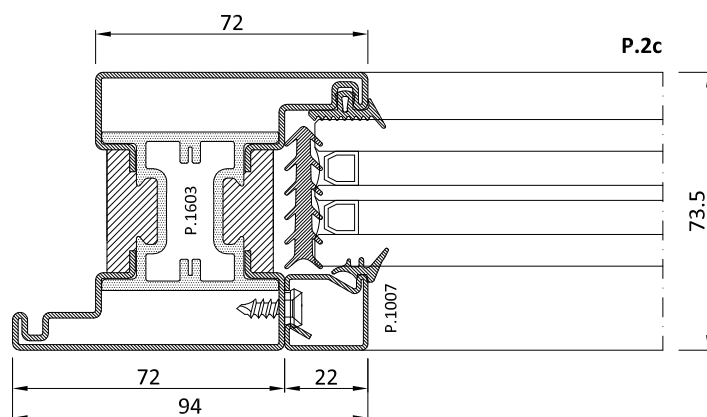
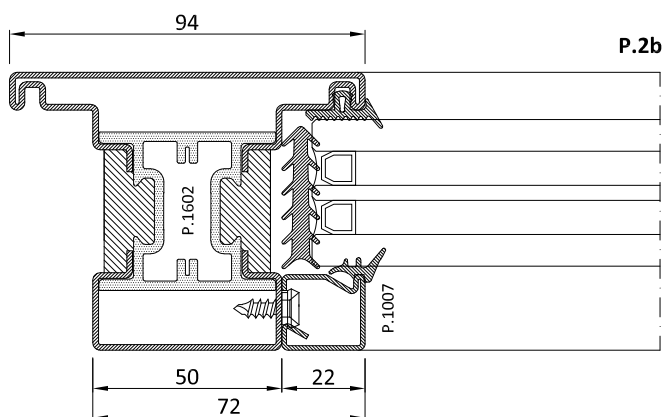
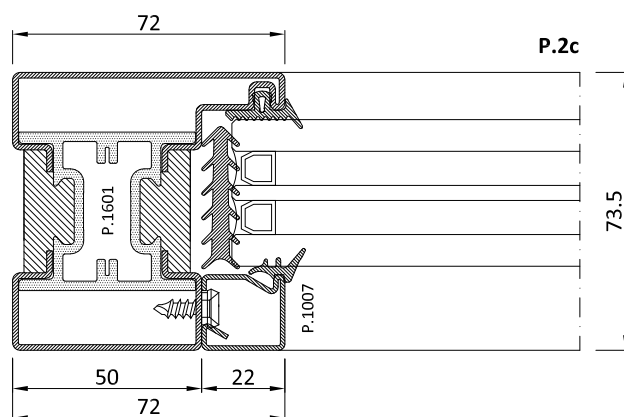
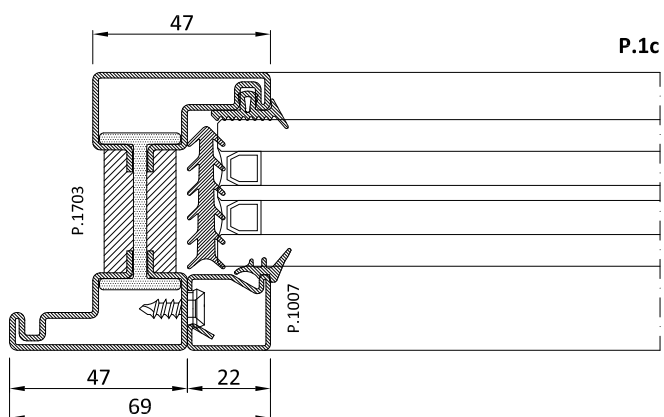
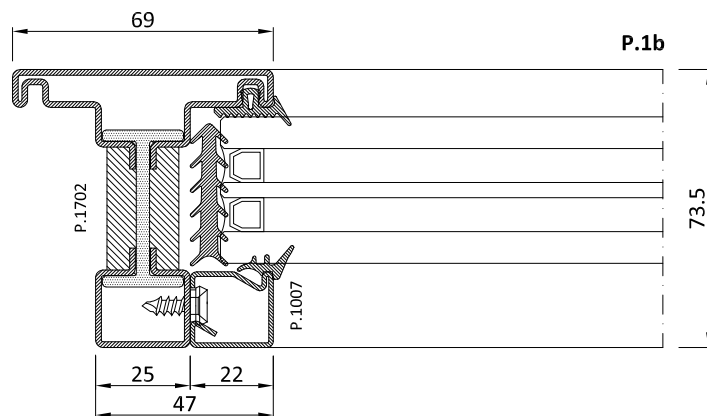
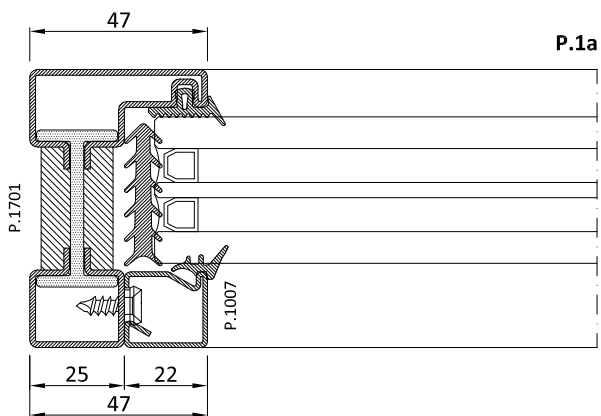
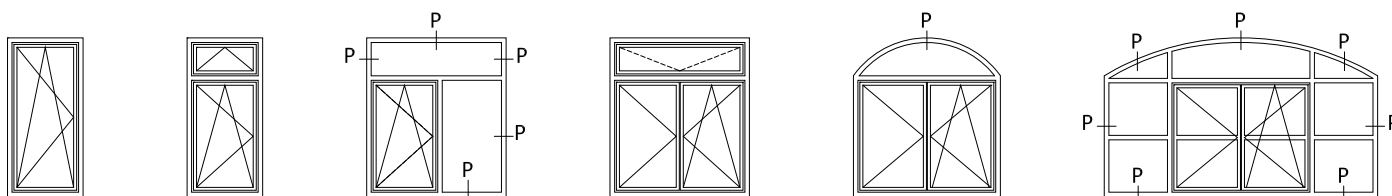


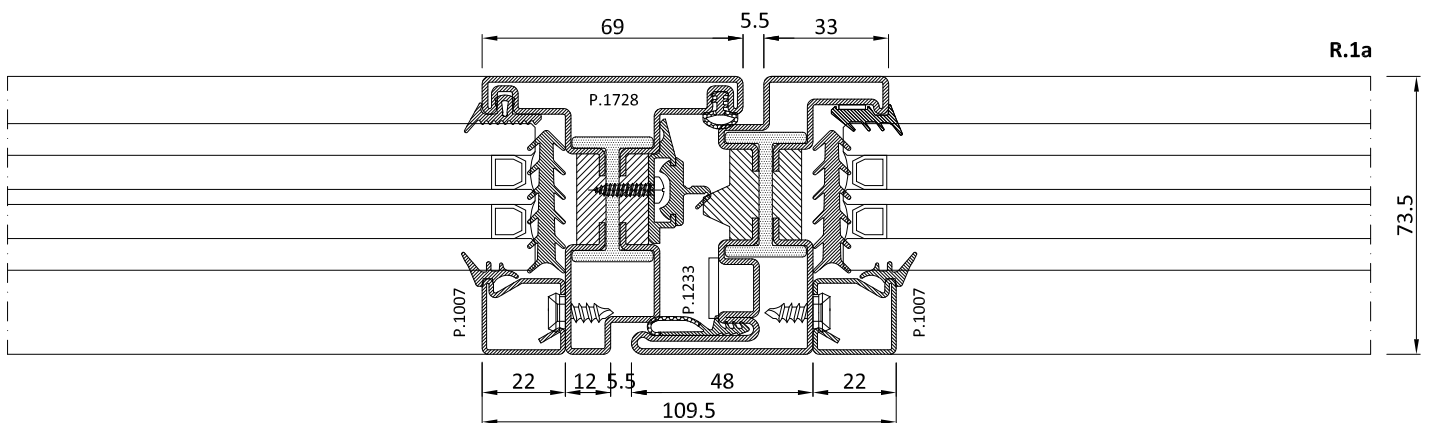
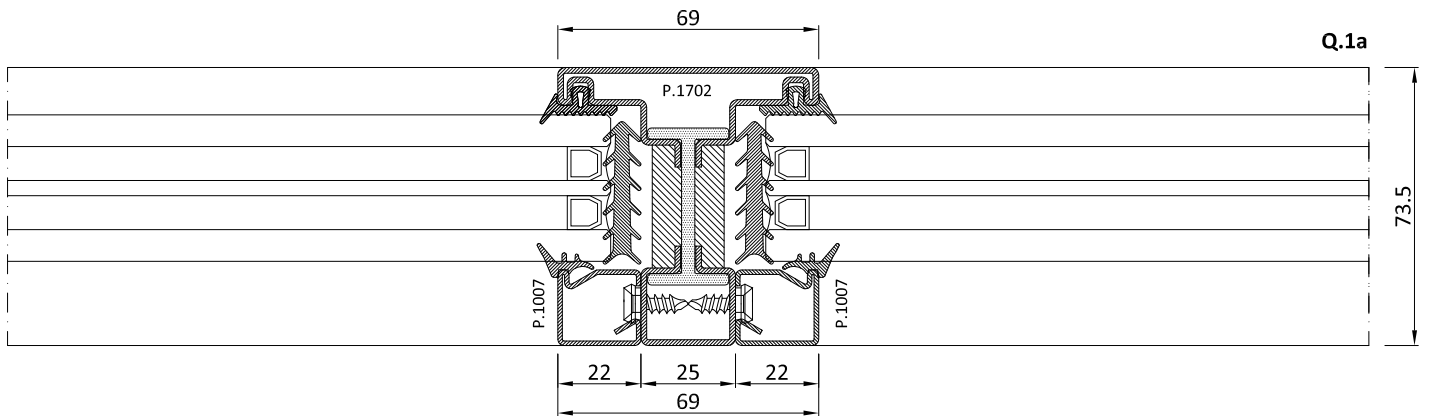
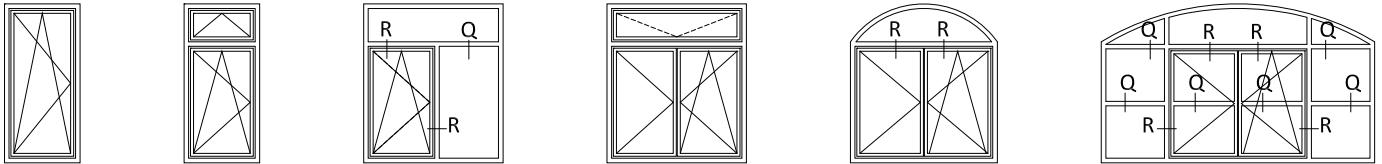


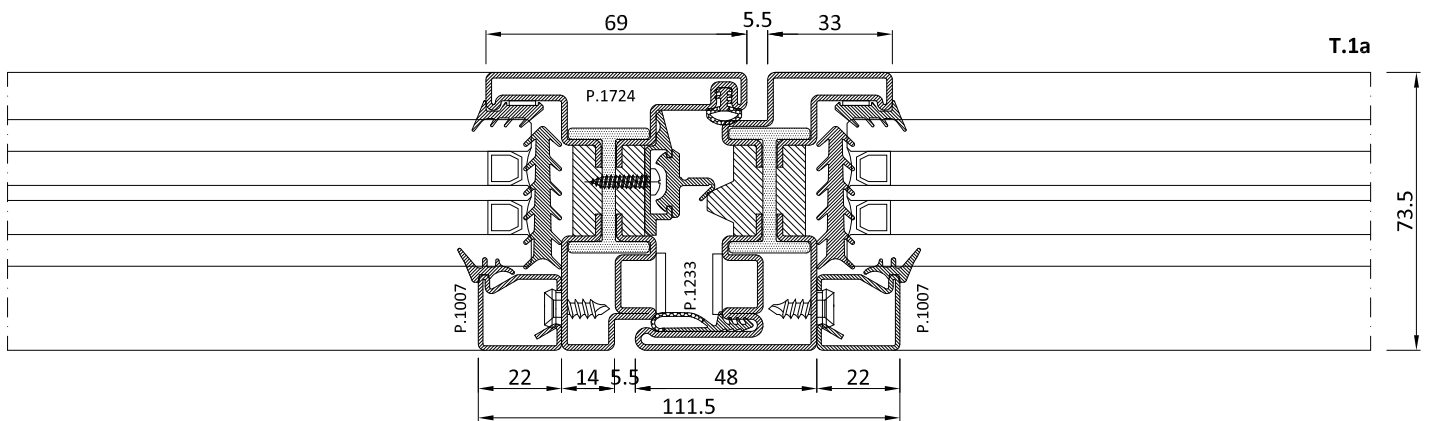
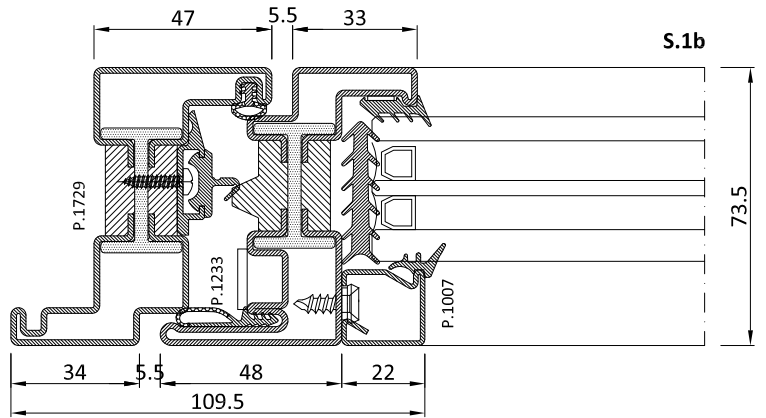
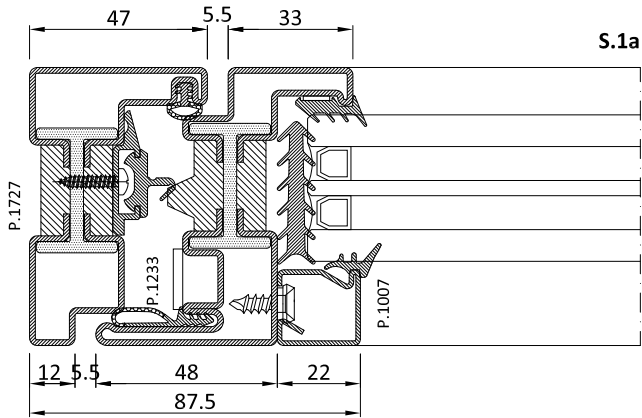
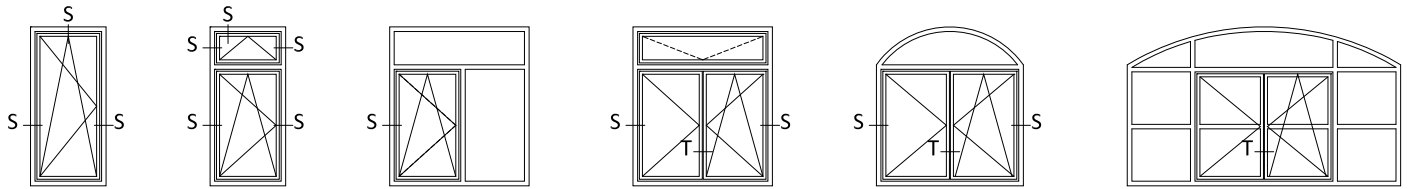


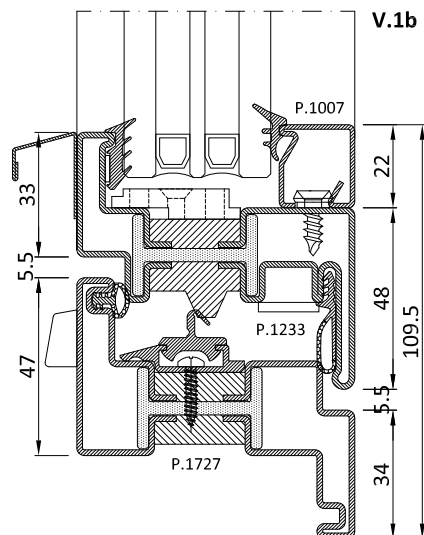
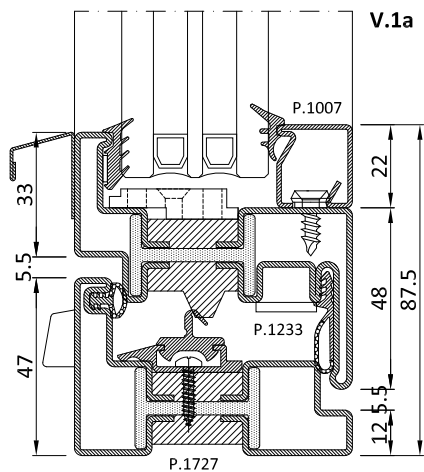
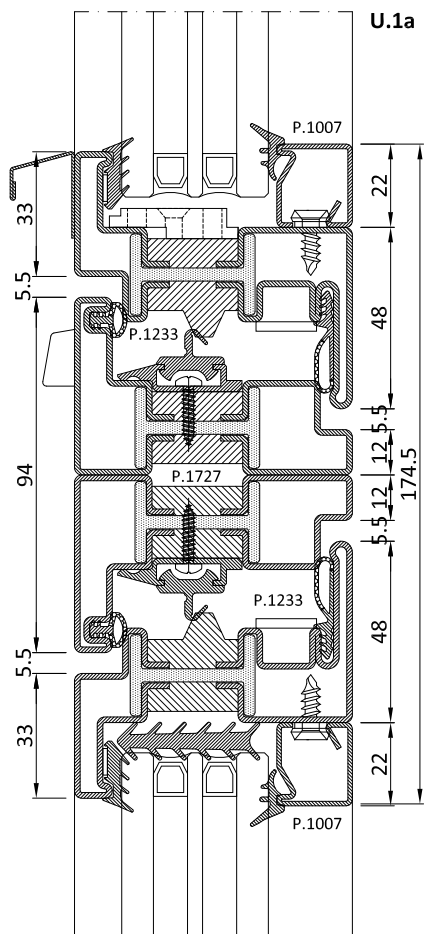
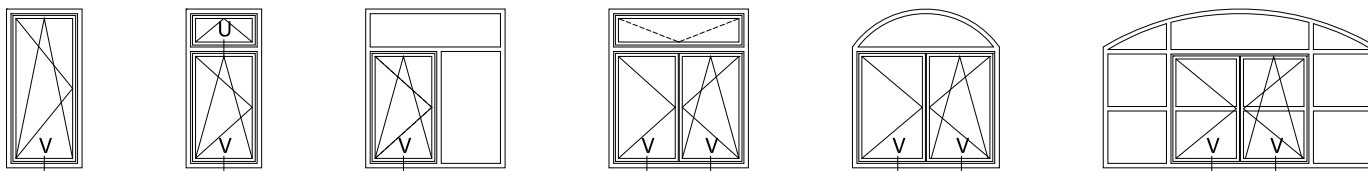


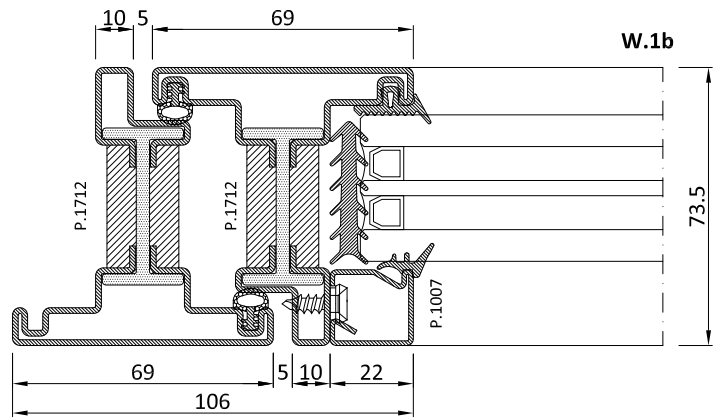
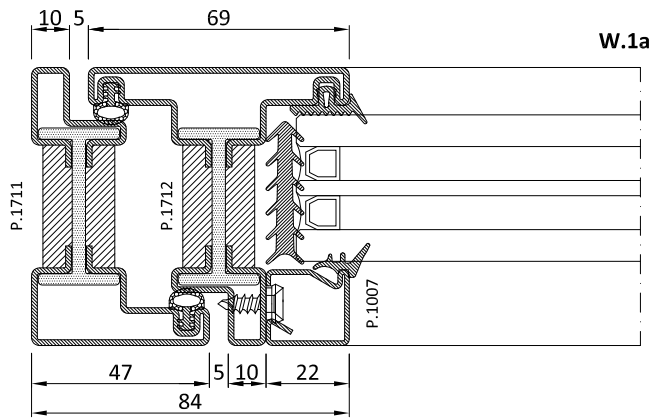
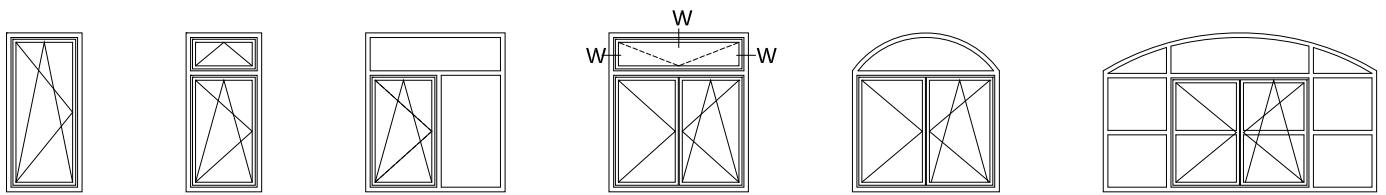


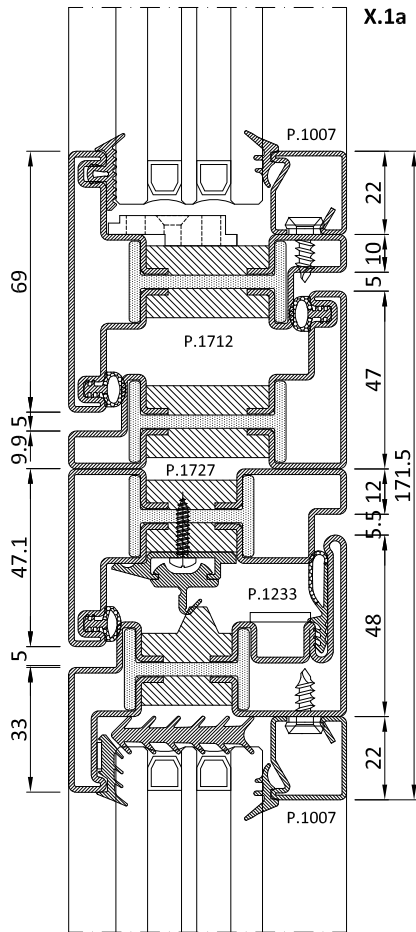
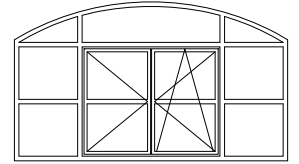
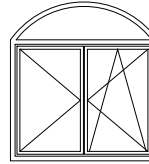
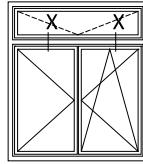
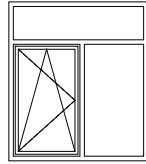
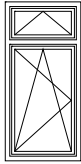
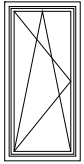


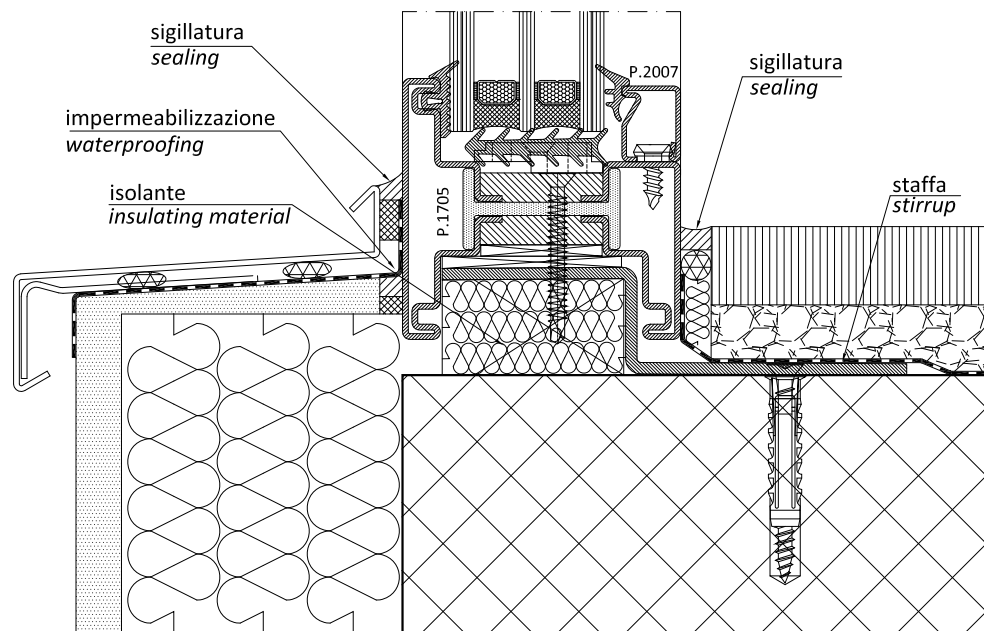
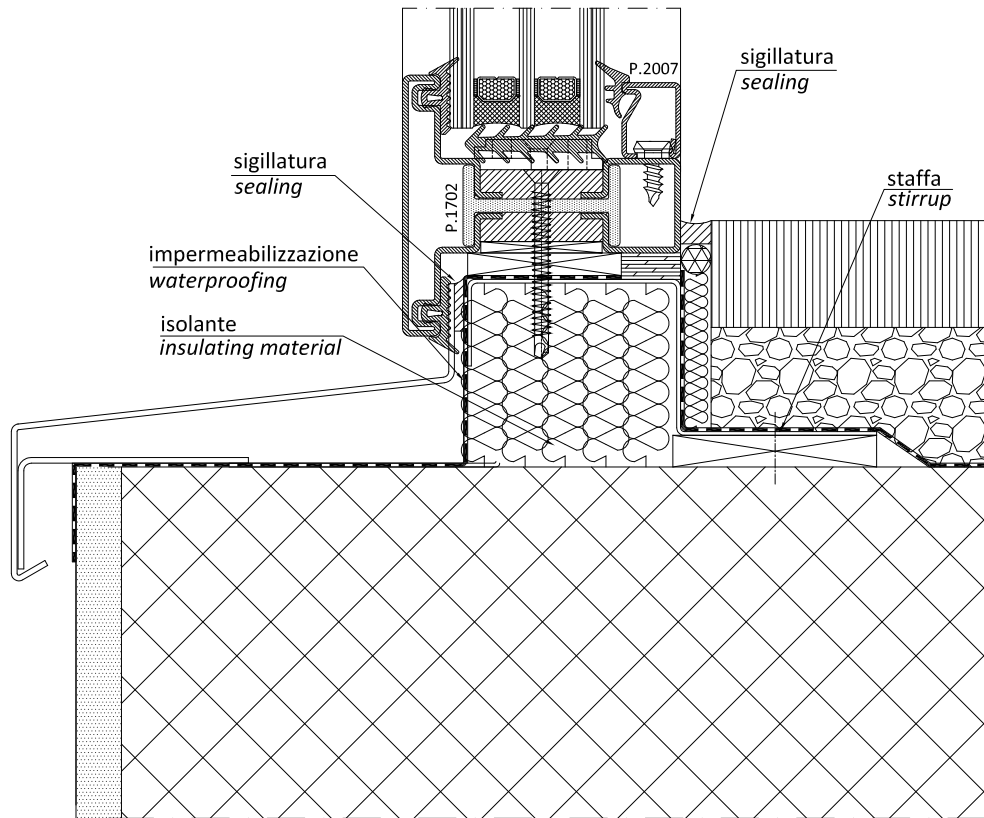


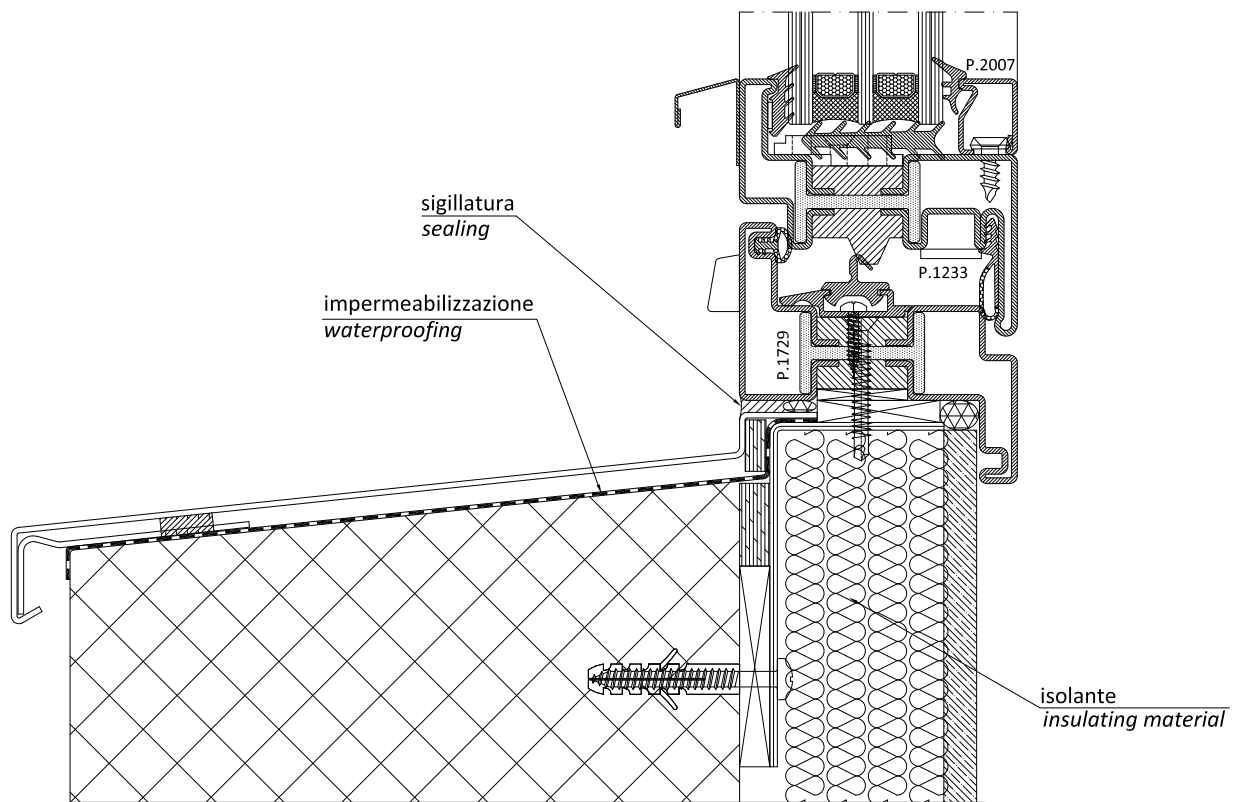
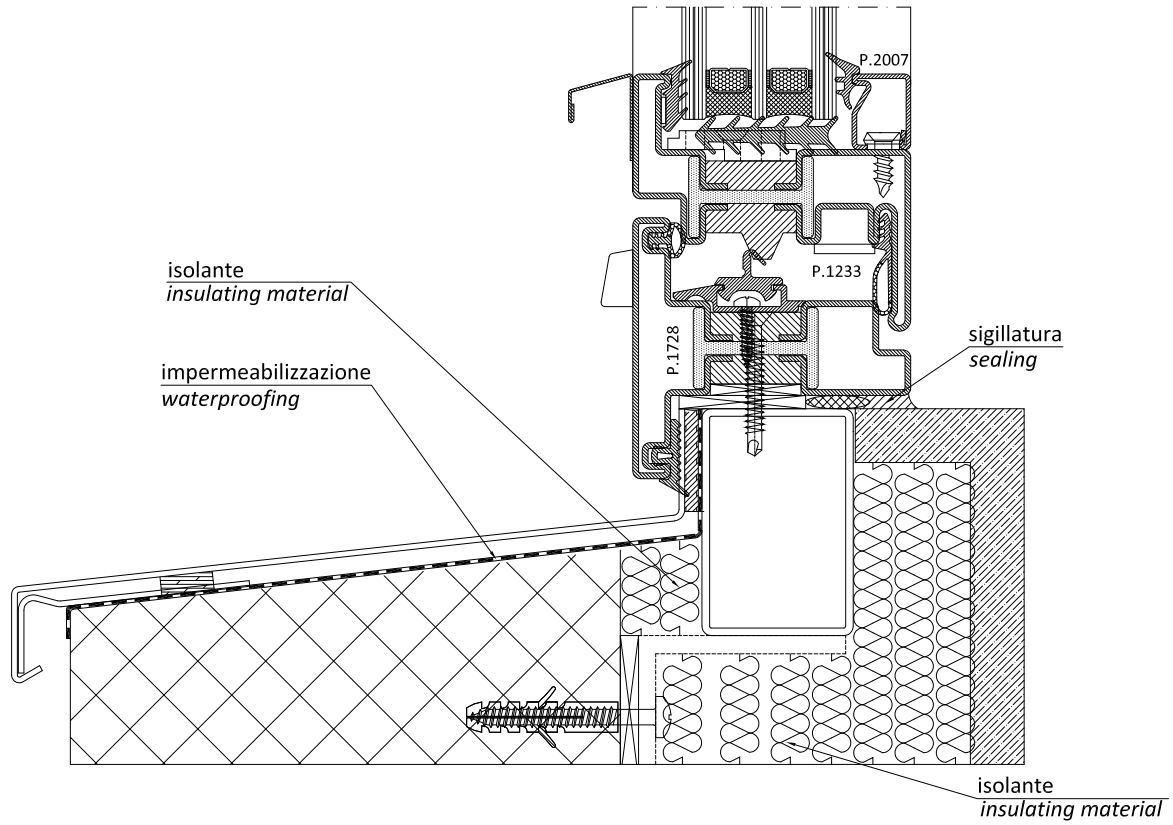


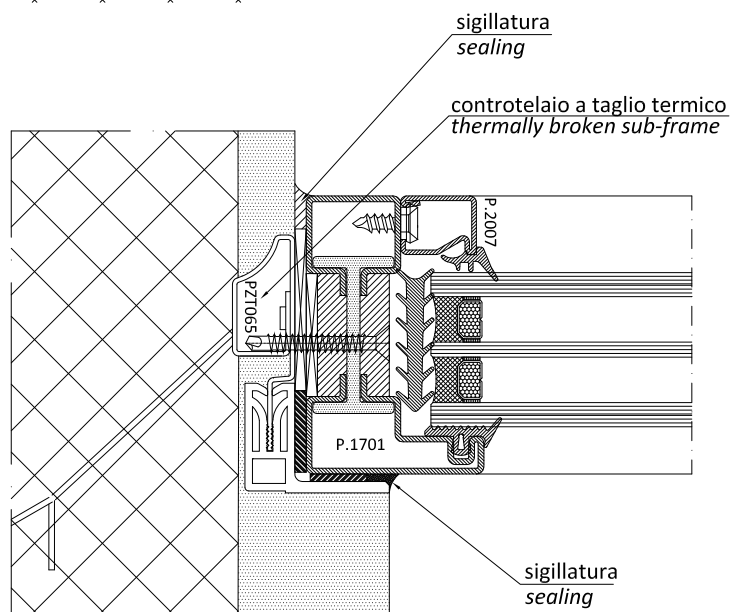
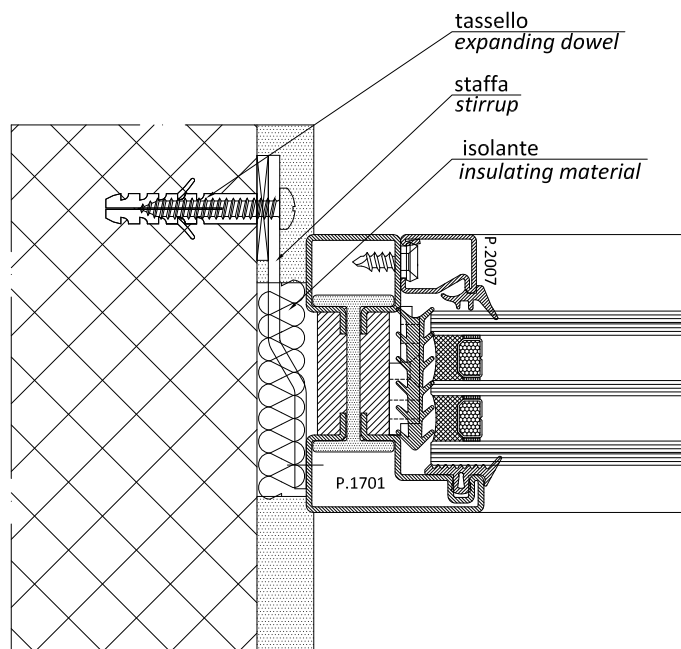
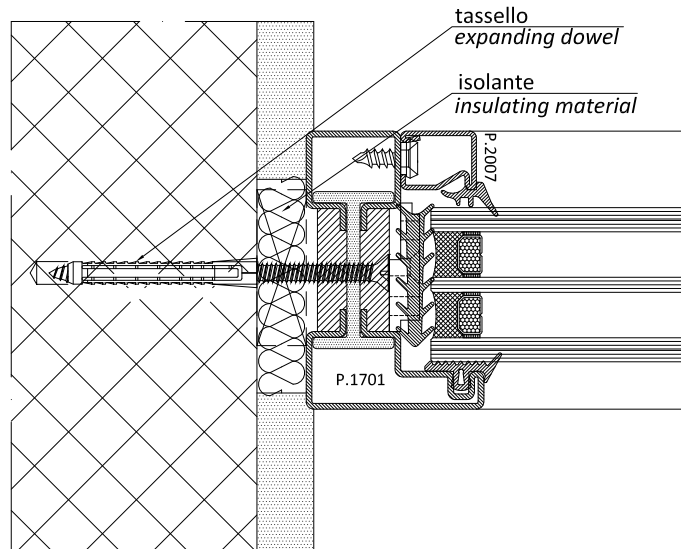


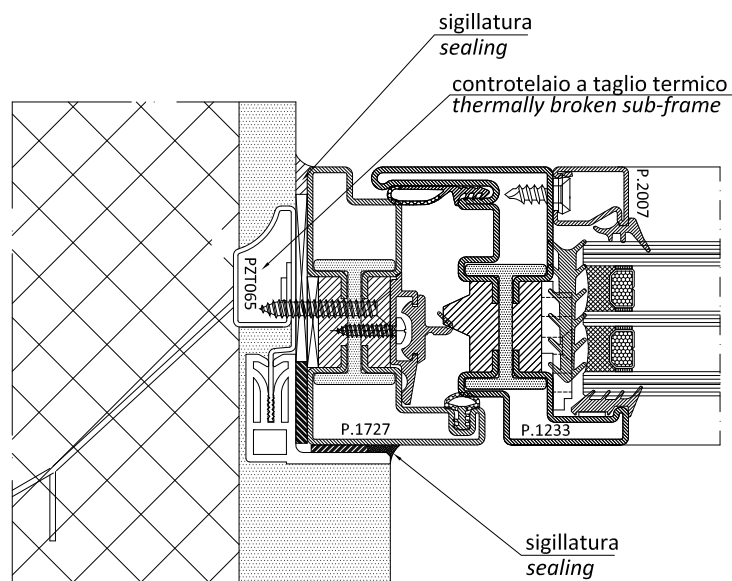
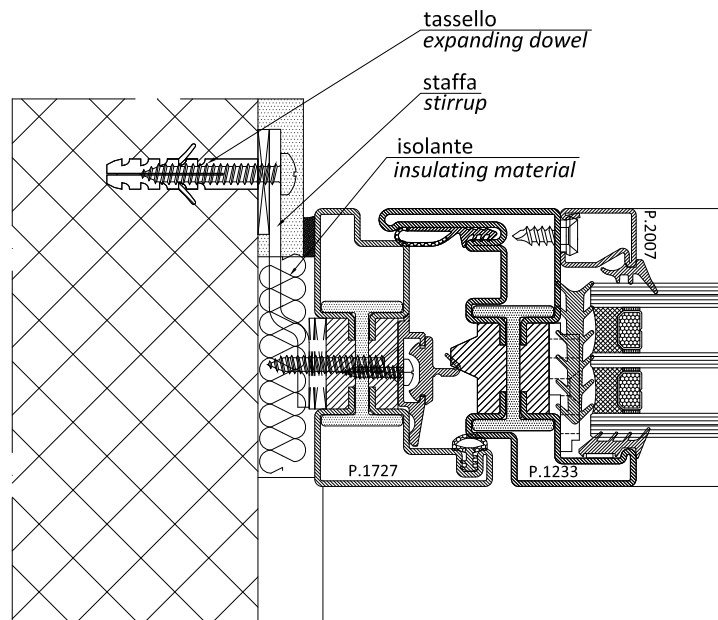
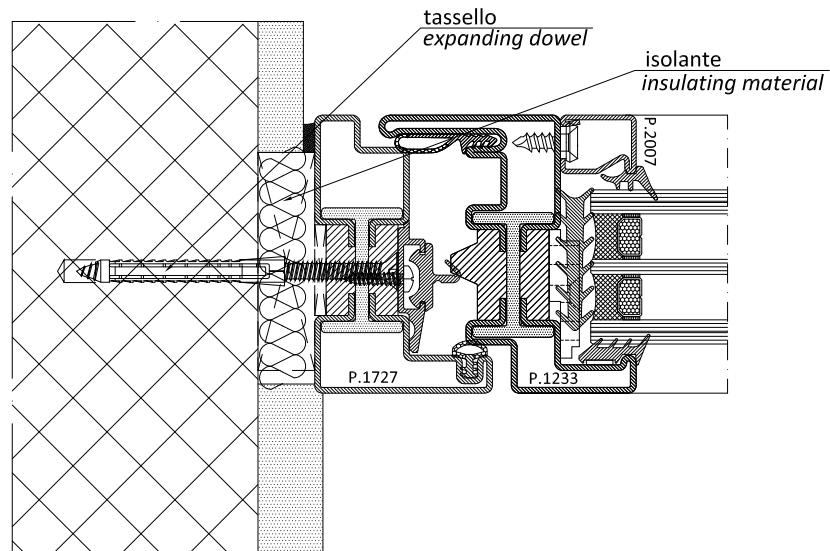




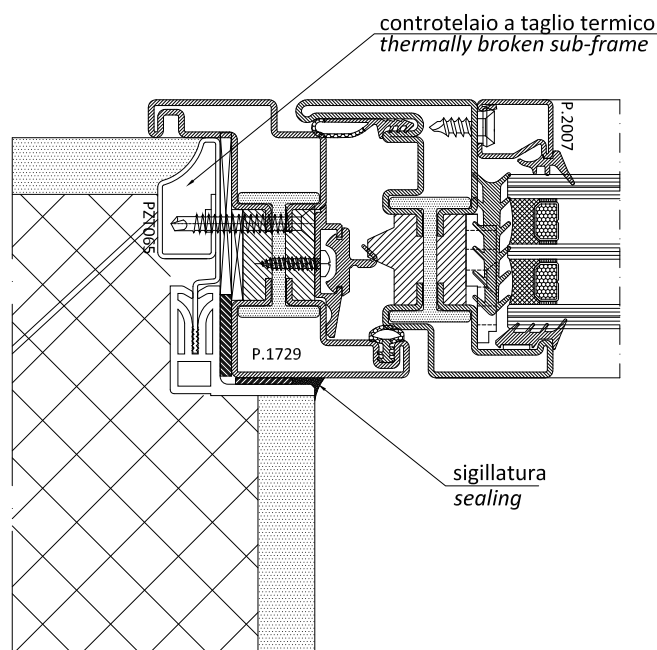
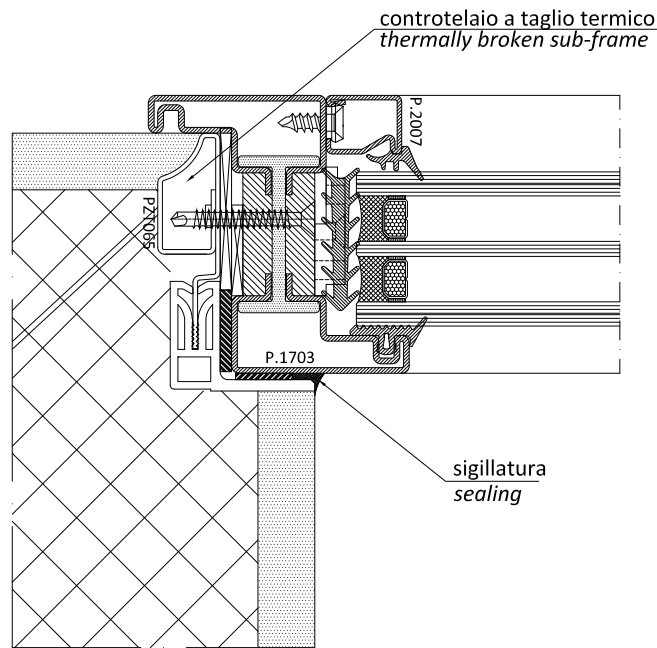




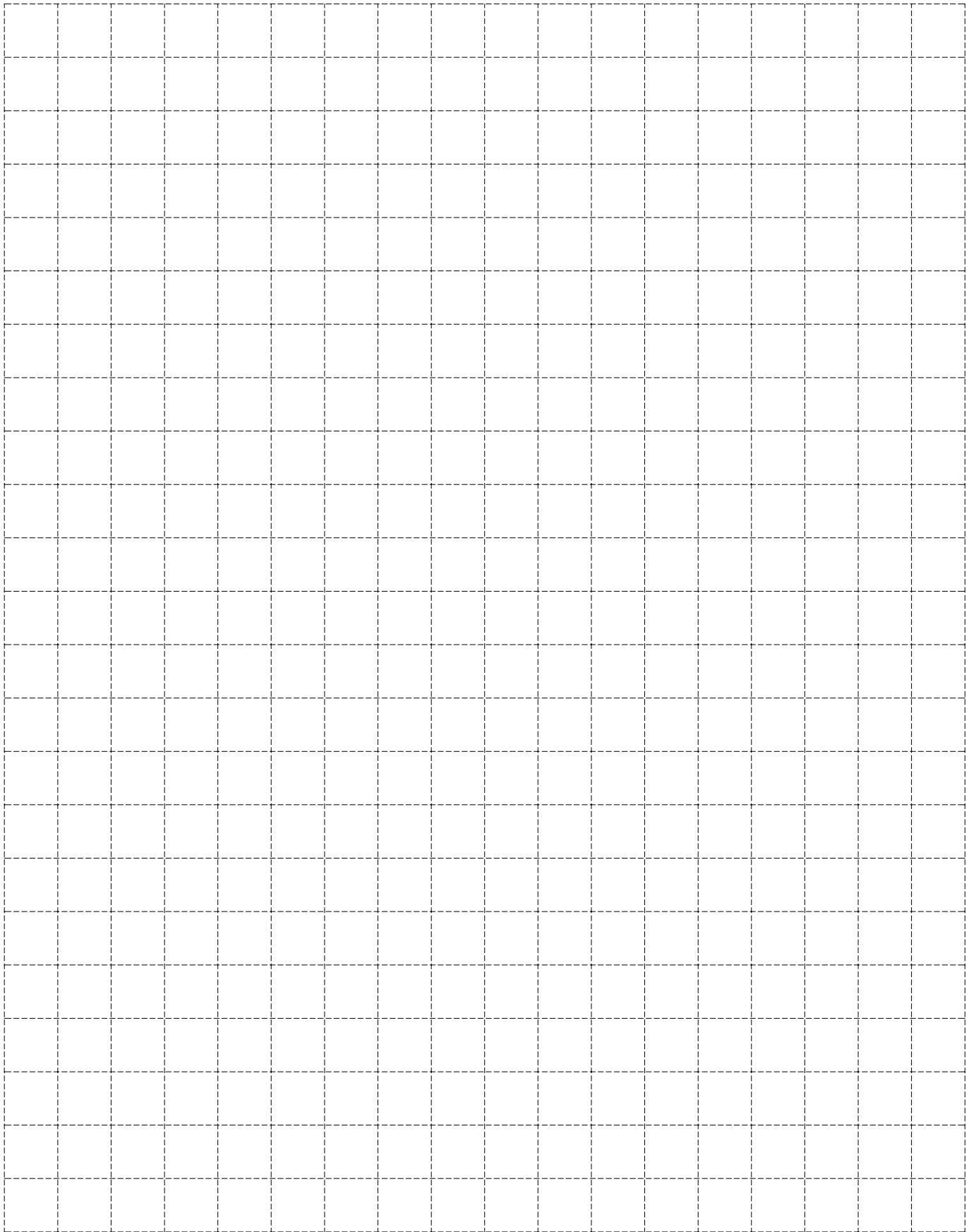




Applicare viti di fissaggio profilo a muro in corrispondenza dell'asse cerniere
Apply anchoring screws to the hinge axis



Applicare viti di fissaggio profilo a muro in corrispondenza dell'asse cerniere
Apply anchoring screws to the hinge axis



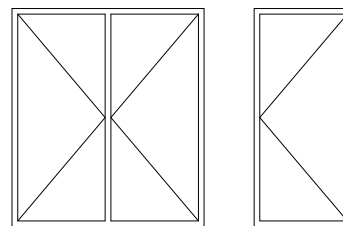
Distinta di taglio e lista componenti | Cutting list and components list

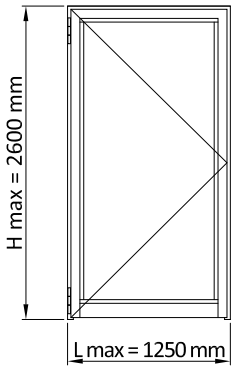
Le distinte di taglio e le liste accessori individuate per le diverse tipologie sono state redatte per un serramento tipo.

E' compito dei tecnici specializzati delle ditte produttrici analizzare criticamente tali indicazioni al fine di verificare la compatibilità del tipo e numero di accessori previsti con il serramento oggetto della commessa reale.

The cutting and hardware lists, which have been identified for the different typologies, have been produced for a standard window.

The specialized technicians of the window manufacturers will have to critically analyze such information in order to verify the compatibility of both the type and the number of accessories provided with the window object of the real order.

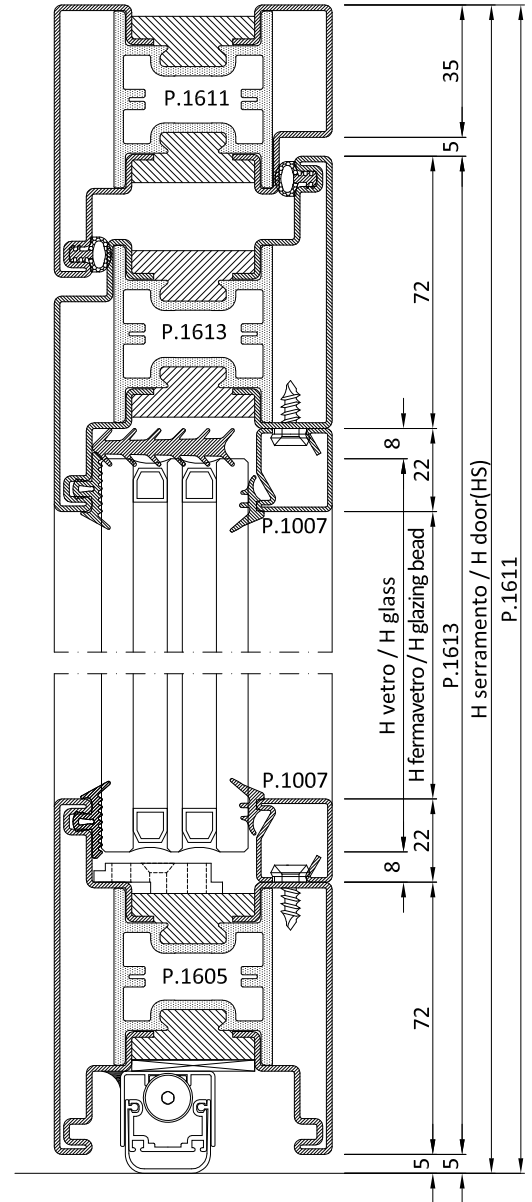




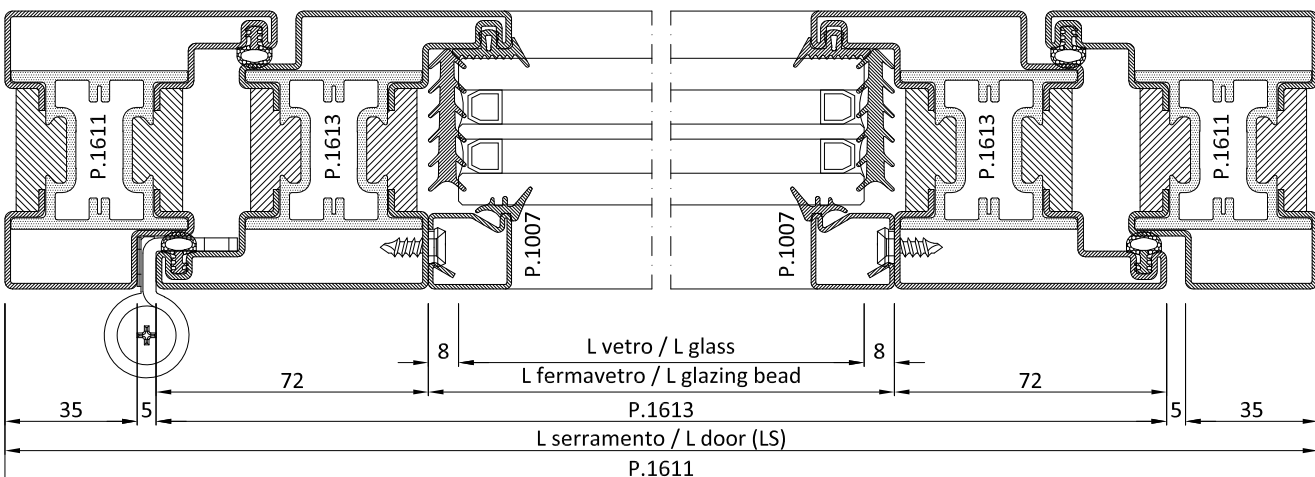
PROFILI		PROFILES			
Cod.	Descrizione	Description	n°	Dim.	Taglio Cutting
Telaio Frame					
P.1611	Profilo a "L" telaio	"L" profile frame	1	LS	45° 45°
P.1611	Profilo a "L" telaio	"L" profile frame	1	HS	45° 90°
P.1611	Profilo a "L" telaio	"L" profile frame	1	HS	90° 45°
Anta Leaf					
P.1613	Profilo a "Z" anta	"Z" profile leaf	1	LS-80	45° 45°
P.1613	Profilo a "Z" anta	"Z" profile leaf	1	HS-45	45° 90°
P.1613	Profilo a "Z" anta	"Z" profile leaf	1	HS-45	90° 45°
P.1605	Profilo zoccolo	Socle profile	1	LS-224	90° 90°
Fermavetri Glazing Beads					
P.1007	Fermavetro	Glazing bead profile	2	LS-224	90° 90°
P.1007	Fermavetro	Glazing bead profile	2	HS-233	90° 90°
Vetri Glass unit					
-	Vetrocamera	Insulated glass	1	LS-240 x HS-205	

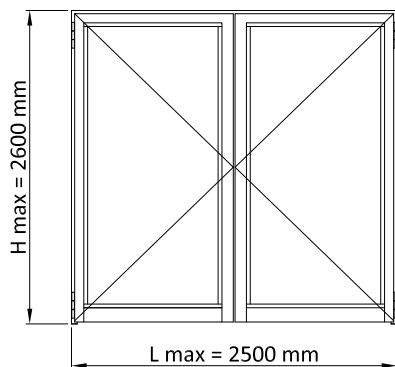
ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
AC1004*	Kit squadrette per P.1611	Corner joint kit for P.1611	2
AC1007*	Kit squadrette per P.1613	Corner joint kit for P.1613	2
AC1021*	Cavallotto per P.1605	Butt joint kit P.1605	2
AC1020 ..	Supporto spessore vetro	Glass support	6
AC1033 ..	Cerniera a stilo	Road hinges	Var.
AC1065/6/7..	Serratura multipunto	Multi-point lock	1
AC1081/..	Paraspiffero automatico	Authomatic door seal	1
ACV9...	Maniglia "Vitruvio"	"Vitruvio" handle	1
CV5001(i)	Vite per boccola fermavetro	Screw for glazing bead bushing	Var.
CV5012(i)	Boccola per fermavetro	Bushing for glazing bead	Var.

GUARNIZIONI		GASKETS	
Cod.	Descrizione	Description	n° Dim.
GE1001TT	Guarnizione esterna di battuta	Rebating gasket	1 2xLS+4xHS
GE1006	Guarnizione esterna vetro	External gasket	1 2xLS+2xHS
GE1007TT	Guarnizione sottovetro	Gasket to put under the glass	1 2xLS+2xHS
GE..	Guarnizione interna vetro	Internal gasket	1 2xLS+2xHS

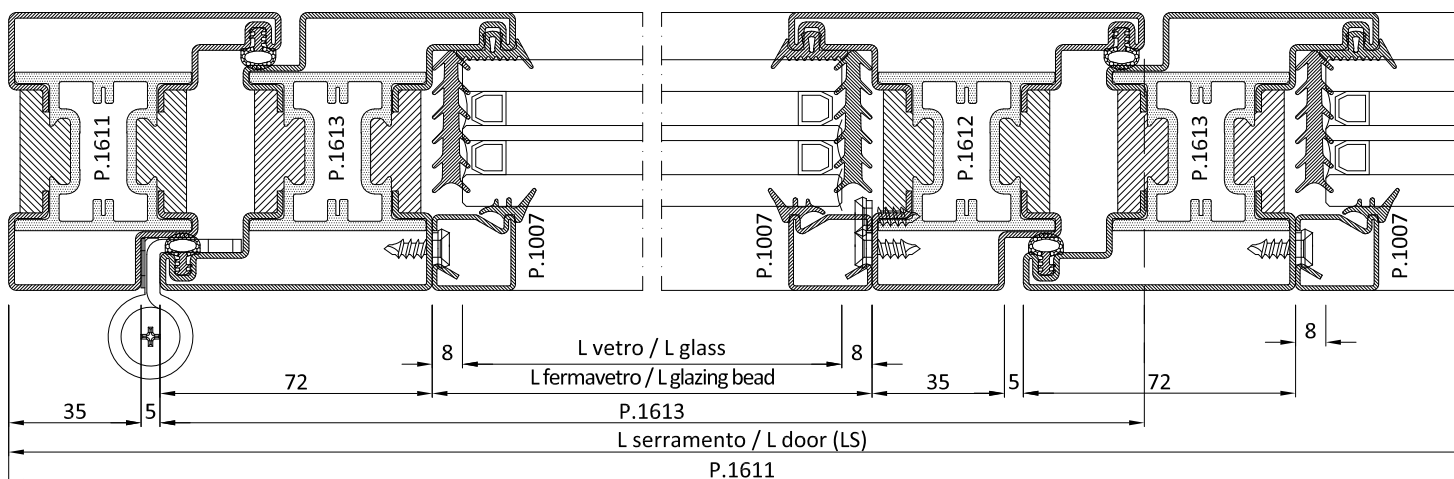


* solo con profili ottone
only with brass profiles





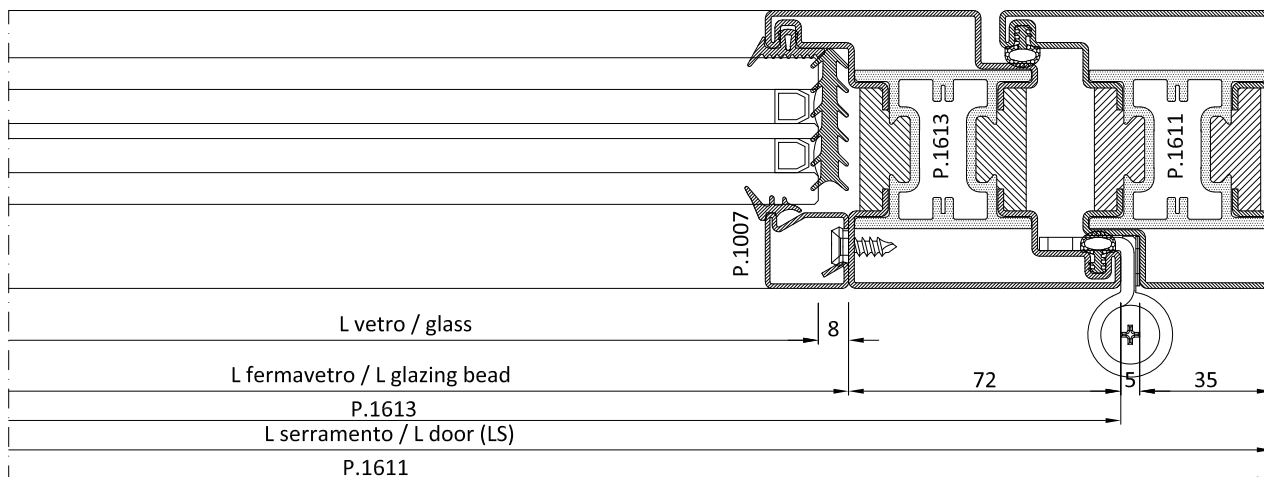
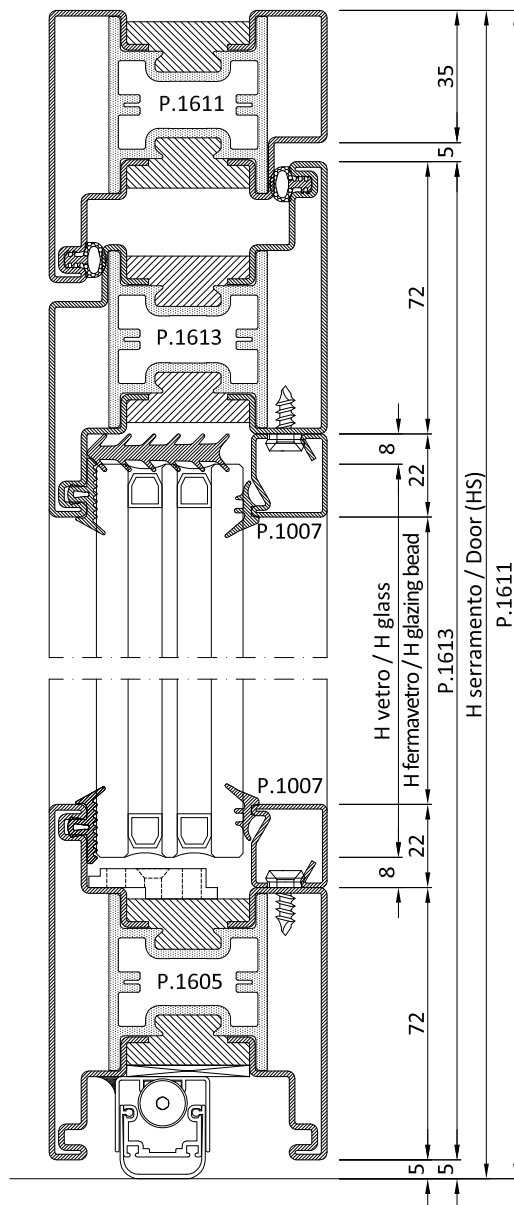
PROFILI		PROFILES				
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
Telaio		Frame				
P.1611	Profilo a "L" telaio	"L" profile frame	1	LS	45°	45°
P.1611	Profilo a "L" telaio	"L" profile frame	1	HS	45°	90°
P.1611	Profilo a "L" telaio	"L" profile frame	1	HS	90°	45°
Anta		Leaf				
P.1613	Profilo a "Z" anta	"Z" profile leaf	2	(LS-48)/2	45°	45°
P.1613	Profilo a "Z" anta	"Z" profile leaf	2	HS-45	45°	90°
P.1613	Profilo a "Z" anta	"Z" profile leaf	1	HS-45	90°	45°
P.1612	Profilo a "T" anta	"T" profile leaf	1	HS-45	90°	45°
P.1605	Profilo zoccolo	Socle profile	2	(LS-336)/2	90°	90°
Fermavetri		Glazing Beads				
P.1007	Fermavetro	Glazing bead profile	4	(LS-336)/2	90°	90°
P.1007	Fermavetro	Glazing bead profile	4	HS-233	90°	90°
Vetri		Glass unit				
-	Vetrocamera	Insulated glass	2	(LS-368)/2 x HS-205		



ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
AC1004*	Kit squadrette per P.1611	Corner joint kit for P.1611	2
AC1007*	Kit squadrette per P.1613	Corner joint kit for P.1613	3
AC1008*	Kit squadrette per P.1612-13		1
AC1021*	Cavallotto per P.1605	Butt joint kit P.1605	4
AC1014	Fondino inversione battuta	Steel ending cap for reverting rebate	2
AC1020 ..	Supporto spessore vetro	Glass support	12
AC1033 ..	Cerniera a stilo	Road hinges	Var.
AC1040	Kit catenaccio 2^ anta	Kit for closing second leaf	1
AC1065/6/7..	Serratura multipunto	Multi-point lock	1
AC1081/..	Paraspiffero automatico	Authomatic door seal	2
ACV9...	Maniglia "Vitruvio"	"Vitruvio" handle	1
CV5001(i)	Vite per boccola fermavetro	Screw for glazing bead bushing	Var.
CV5012(i)	Boccola per fermavetro	Bushing for glazing bead	Var.

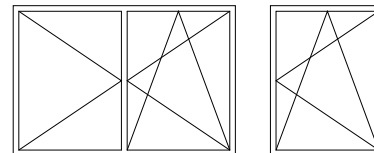
GUARNIZIONI		GASKETS	
Cod.	Descrizione	Description	n° Dim.
GE1001TT	Guarnizione esterna di battuta	Rebating gasket	1 2xLS+6xHS
GE1006	Guarnizione esterna vetro	External gasket	1 2xLS+4xHS
GE1007TT	Guarnizione sottovetro	Gasket to put under the glass	1 2xLS+4xHS
GE..	Guarnizione interna vetro	Internal gasket	1 2xLS+4xHS

* solo con profili ottone
only with brass profiles



Distinta di taglio e lista componenti | Cutting list and components list

Le distinte di taglio e le liste accessori individuate per le diverse tipologie sono state redatte per un serramento tipo.
E' compito dei tecnici specializzati delle ditte produttrici analizzare criticamente tali indicazioni al fine di verificare la compatibilità del tipo e numero di accessori previsti con il serramento oggetto della commessa reale.



*The cutting and hardware lists, which have been identified for the different typologies, have been produced for a standard window.
The specialized technicians of the window manufacturers will have to critically analyze such information in order to verify the compatibility of both the type and the number of accessories provided with the window object of the real order.*

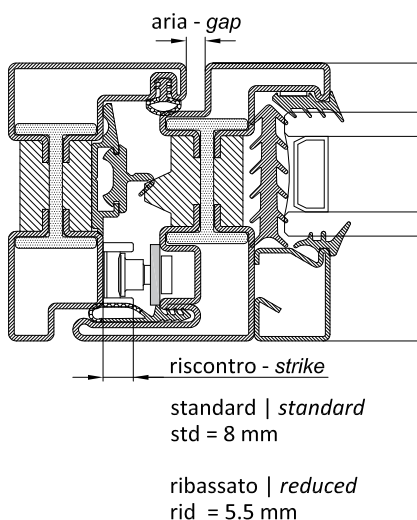
La tabella seguente va attentamente letta prima del taglio dei profili | The following table should be carefully read before the profiles cutting

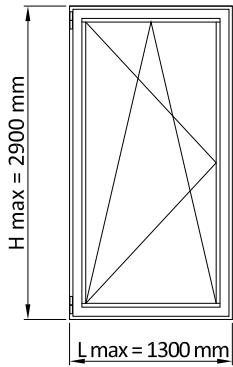
In essa è riportata la misura da considerare nella distanza tra telaio anta e telaio fisso nella produzione di finestre in funzione della tipologia, del tipo di cerniera e della larghezza delle ante da produrre.

It shows the measurement to follow between the leaf and the fixed frame in the production of windows depending on the typology, the hinge type and the width of the leaf to be produced.

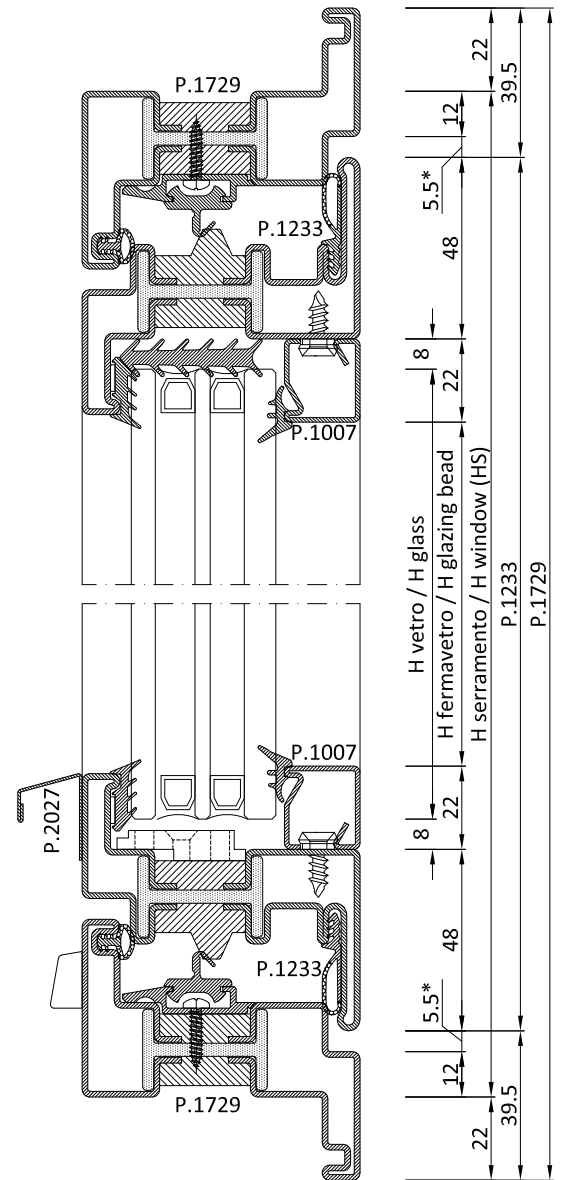
			larghezza anta (cava ferramenta in mm) leaf width (hardware slot in mm)				
			280 360	361 480	481 600	601 800	> 800
AR Easy DK Easy	AGE 281(2)	aria - gap	-	5,5	5,5	5,5	5,5
	AGE 281(2)-286(5) AGE 281(2)-786(5)	riscontro - strike	-	std	std	std	std

NB
gli incontri ribassati devono essere installati
solamente sul lato cremonese
*reduced strikes should be installed only on
cremone vertical side*



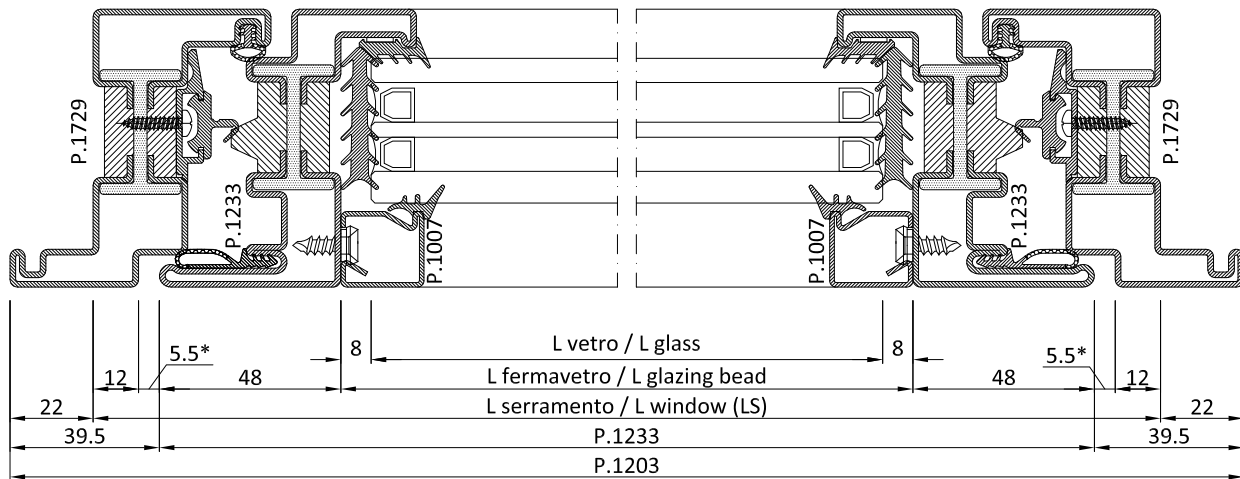


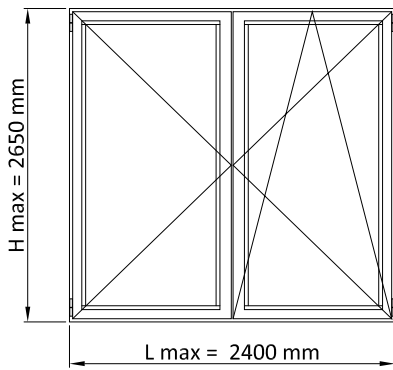
PROFILI		PROFILES			
Cod.	Descrizione	Description	n°	Dim.	Taglio Cutting
Telaio					
Frame					
P.1729	Profilo a "Z" telaio	"Z" profile frame	2	LS+44	45° 45°
P.1729	Profilo a "Z" telaio	"Z" profile frame	2	HS+44	45° 45°
Anta					
Leaf					
P.1233	Profilo a "Z" anta	"Z" profile frame	2	LS-35	45° 45°
P.1233	Profilo a "Z" anta	"Z" profile frame	2	HS-35	45° 45°
P.2027	Profilo battiacqua	Water drip profile	2	LS-105	90° 90°
Fermavetri					
Glazing Beads					
P.1007	Fermavetro	Glazing bead profile	2	LS-131	90° 90°
P.1007	Fermavetro	Glazing bead profile	2	HS-175	90° 90°
Vetri					
Glass unit					
-	Vetrocamera	Insulated glass	1	LS-147 x HS-147	
ACCESSORI					
HARDWARE					
Cod.	Descrizione	Description	n°		
AC1729i*	Kit squadrette per P.1729	Corner joint kit for P.1729	4		
AC1207i*	Kit squadrette per P.1233	Corner joint kit for P.1233	4		
AC1716	Guarnizione d'angolo	Vulcanised corner gasket	4		
AC1219	Scarico acqua	Water drip	Var.		
AGE281/2..	Meccanismo Anta Ribalta	Tilt and Turn mechanism	1		
ACV97..	Maniglia "Vitruvio"	"Vitruvio" handle	1		
AC1356	Meccanismo DK	External tilt & turn mechanism	1		
AC1020	Supporto spessore vetro	Glass support	6		
CV5001(i)	Vite per boccola fermavetro	Screw for glazing bead bushing	Var.		
CV5012(i)	Boccola per fermavetro	Bushing for glazing bead	Var.		
GUARNIZIONI					
GASKETS					
Cod.	Descrizione	Description	n°	Dim.	
GE1233TT	Guarnizione esterna di battuta	External rebating gasket	1	2xLS+2xHS	
GE1701	Guarnizione giunto aperto	Open joint system gasket	1	2xLS+2xHS	
GU1702	Estruso PVC giunto aperto	Open joint system PVC profile	1	2xLS+2xHS	
GE1200TT	Guarnizione interna di battuta	Internal rebating gasket	1	2xLS+2xHS	
GE1206	Guarnizione esterna vetro	External gasket	1	2xLS+2xHS	
GE1007TT	Guarnizione sottovetro	Gasket to put under the glass	1	2xLS+2xHS	
GE..	Guarnizione interna vetro	Internal gasket	1	2xLS+2xHS	



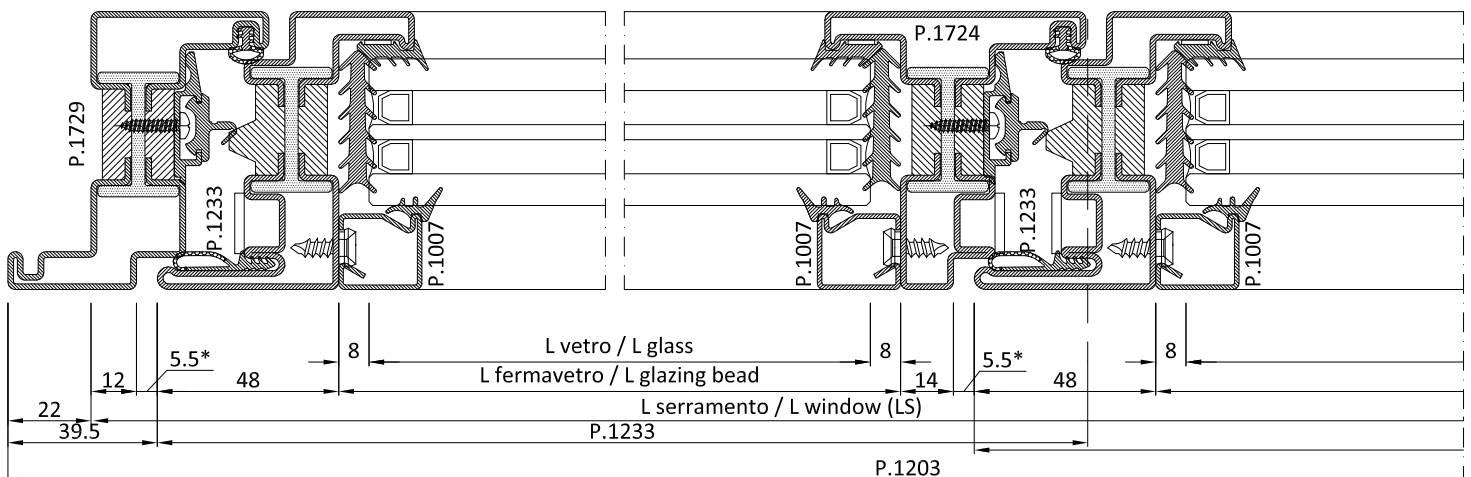
* vedi tabella 4.1.5
see chart 4.1.5

* solo con profili ottone
only with brass profiles



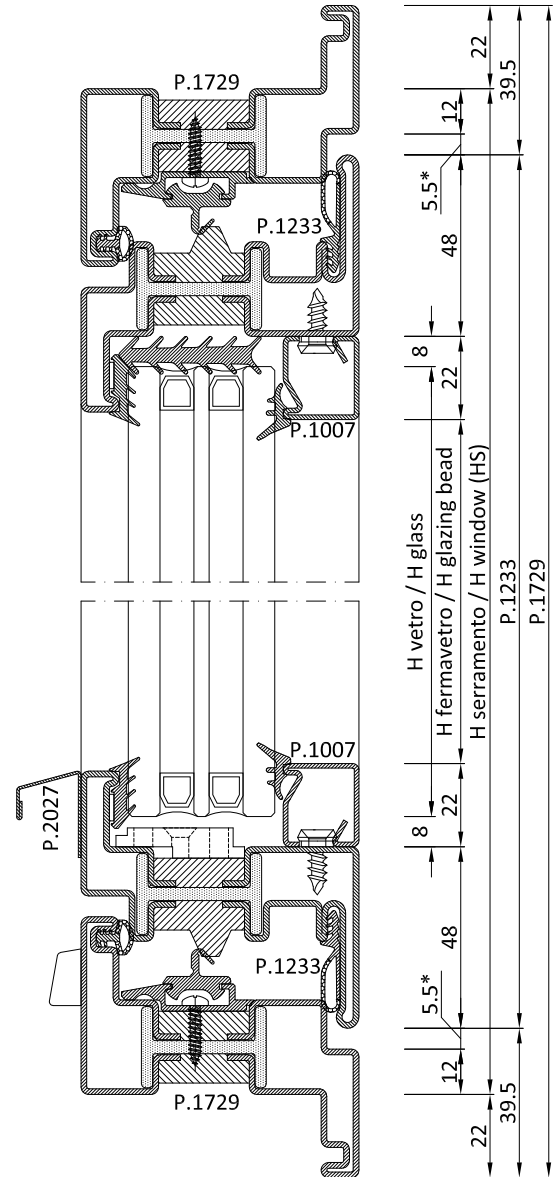


PROFILI		PROFILES				
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
Telaio		Frame				
P.1729	Profilo a "Z" telaio	"Z" profile frame	2	LS+44	45°	45°
P.1729	Profilo a "Z" telaio	"Z" profile frame	2	HS+44	45°	45°
Anta		Leaf				
P.1233	Profilo a "Z" anta	"Z" profile frame	4	(LS-6.5)/2	45°	45°
P.1233	Profilo a "Z" anta	"Z" profile frame	3	HS-35	45°	45°
P.1724	Profilo a "T" anta	"T" profile frame	1	HS-33	45°	45°
P.2027	Profilo battiacqua	Water drip profile	1	(LS-77.5)/2	90°	90°
P.2027	Profilo battiacqua	Water drip profile	2	(LS-145.5)/2	90°	90°
Fermavetri		Glazing Beads				
P.1007	Fermavetro	Glazing bead profile	4	(LS-198.5)/2	90°	90°
P.1007	Fermavetro	Glazing bead profile	4	HS-175	90°	90°
Vetri		Glass unit				
-	Vetrocamera	Insulated glass	2	[(LS-231.5)/2] x HS-147		



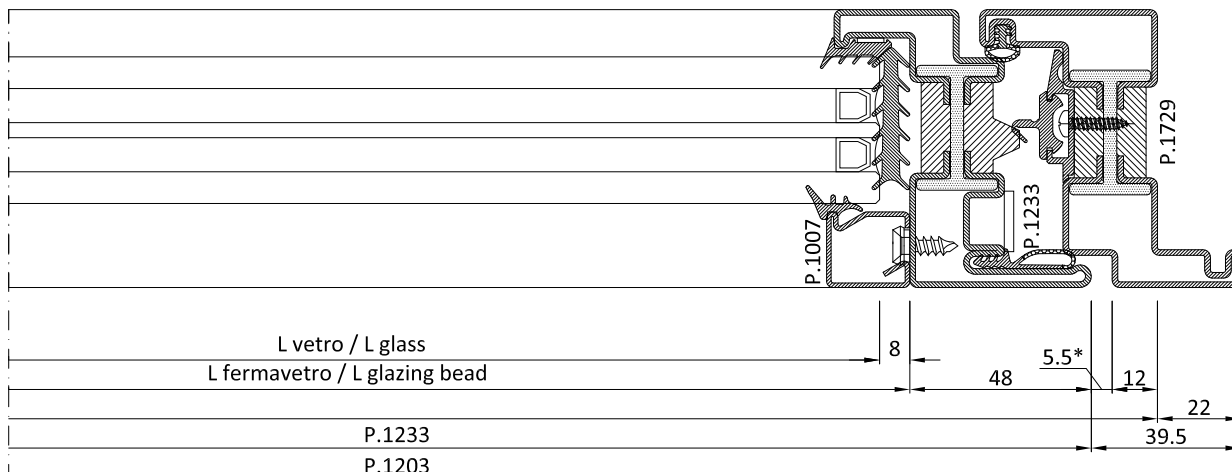
ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
AC1729I*	Kit squadrette per P.1729	Corner joint kit for P.1729	4
AC1207I*	Kit squadrette per P.1233	Corner joint kit for P.1233	6
AC1708I*	Kit squadrette per P.1233-1724	Corner joint kit for P.1233-1724	2
AC1716	Guarnizione d'angolo	Vulcanised corner gasket	4
AC1219	Scarico acqua	Water drip	Var.
AC1714	Kit inversione battuta 2ª anta	2nd leaf reverse closure kit	1
AGE281/2..	Meccanismo Anta Ribalta 1ª anta	1st leaf tilt/turn mechanism	1
AGE785/6..	Meccanismo Anta Ribalta 2ª anta	2nd leaf tilt/turn mechanism	1
ACV97..	Maniglia "Vitruvio"	"Vitruvio" handle	1
AC1356	Meccanismo DK	External tilt & turn mechanism	1
AC1020	Supporto spessore vetro	Glass support	12
CV5001(i)	Vite per boccia fermavetro	Screw for glazing bead bushing	Var.
CV5012(i)	Boccola per fermavetro	Bushing for glazing bead	Var.

GUARNIZIONI		GASKETS	
Cod.	Descrizione	Description	n° Dim.
GE1233TT	Guarnizione esterna di battuta	External rebating gasket	1 2xLS+3xHS
GE1701	Guarnizione giunto aperto	Open joint system gasket	1 2xLS+3xHS
GE1704	Guarnizione giunto aperto P.1724	Open joint system gasket P.1724	1 1xHS
GU1702	Estruso PVC giunto aperto	Open joint system PVC profile	1 2xLS+3xHS
GE1200TT	Guarnizione interna di battuta	Internal rebating gasket	1 2xLS+3xHS
GE1206	Guarnizione esterna vetro	External gasket	1 2xLS+4xHS
GE1007TT	Guarnizione sottovetro	Gasket to put under the glass	1 2xLS+4xHS
GE..	Guarnizione interna vetro	Internal gasket	1 2xLS+4xHS



* vedi tabella 4.1.5
see chart 4.1.5

** solo con profili ottone
only with brass profiles



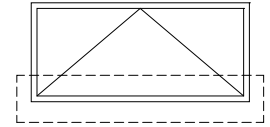
Distinta di taglio e lista componenti | Cutting list and components list

Le distinte di taglio e le liste accessori individuate per le diverse tipologie sono state redatte per un serramento tipo.

E' compito dei tecnici specializzati delle ditte produttrici analizzare criticamente tali indicazioni al fine di verificare la compatibilità del tipo e numero di accessori previsti con il serramento oggetto della commessa reale.

The cutting and hardware lists, which have been identified for the different typologies, have been produced for a standard window.

The specialized technicians of the window manufacturers will have to critically analyze such information in order to verify the compatibility of both the type and the number of accessories provided with the window object of the real order.



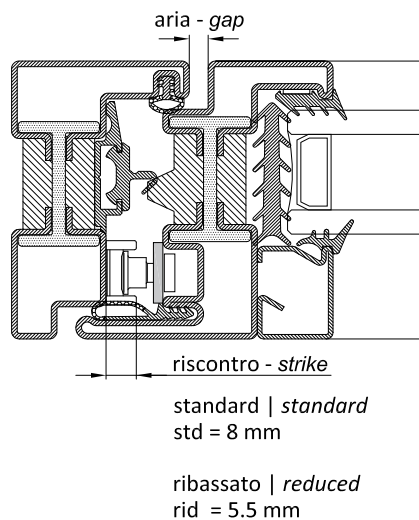
La tabella seguente va attentamente letta prima del taglio dei profili | The following table should be carefully read before the profiles cutting

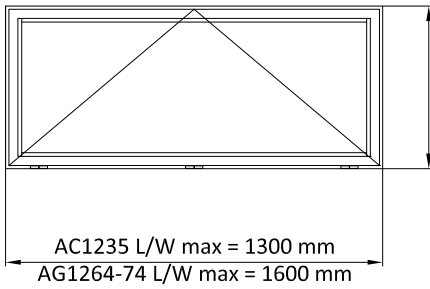
In essa è riportata la misura da considerare nella distanza tra telaio anta e telaio fisso nella produzione di finestre in funzione della tipologia, del tipo di cerniera e della larghezza delle ante da produrre.

It shows the measurement to follow between the leaf and the fixed frame in the production of windows depending on the typology, the hinge type and the width of the leaf to be produced.

			larghezza anta (cava ferramenta in mm) leaf width (hardware slot in mm)	
			< 480	> 480
Vasistas	AG 1264	aria - gap	6	5
Bottom hung	AG 1274	riscontro - strike	std	std

NB
gli incontri ribassati devono essere installati solamente sul lato cremonese
reduced strikes should be installed only on cremone vertical side



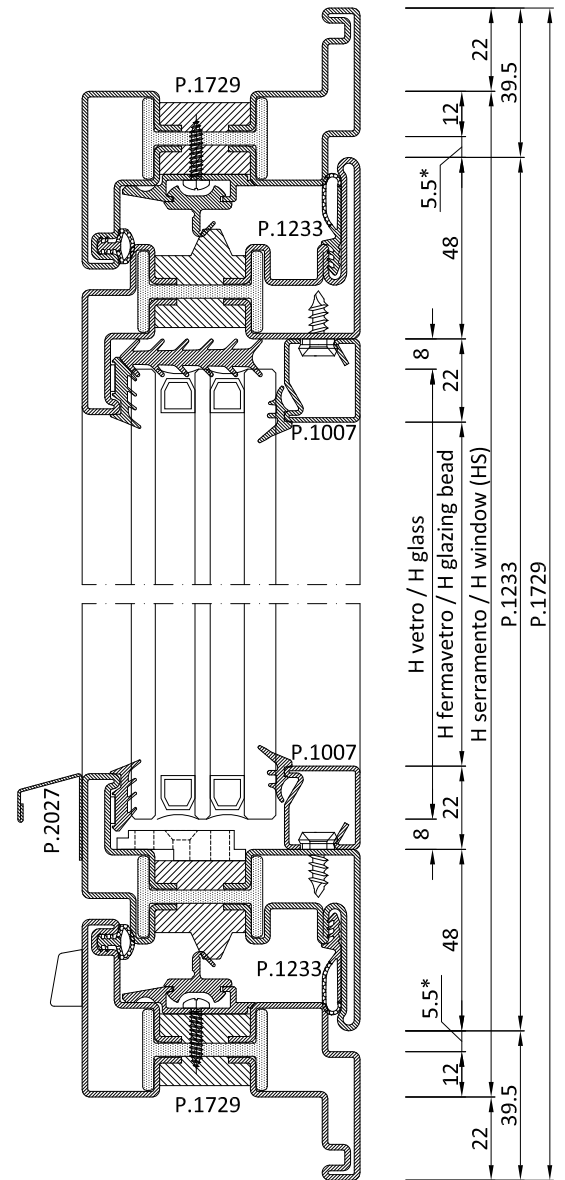


AC1235 H max = 800 mm
AG1264-74 H max = 1200 mm

PROFILI		PROFILES			
Cod.	Descrizione	Description	n°	Dim.	Taglio Cutting
Telaio					
Frame					
P.1729	Profilo a "Z" telaio	"Z" profile frame	2	LS+44	45° 45°
P.1729	Profilo a "Z" telaio	"Z" profile frame	2	HS+44	45° 45°
Anta					
Leaf					
P.1233	Profilo a "Z" anta	"Z" profile frame	2	LS-35	45° 45°
P.1233	Profilo a "Z" anta	"Z" profile frame	2	HS-35	45° 45°
P.2027	Profilo battiacqua	Water drip profile	2	LS-105	90° 90°
Fermavetri					
Glazing Beads					
P.1007	Fermavetro	Glazing bead profile	2	LS-131	90° 90°
P.1007	Fermavetro	Glazing bead profile	2	HS-175	90° 90°
Vetri					
Glass unit					
-	Vetrocamera	Insulated glass	1	LS-147 x HS-147	

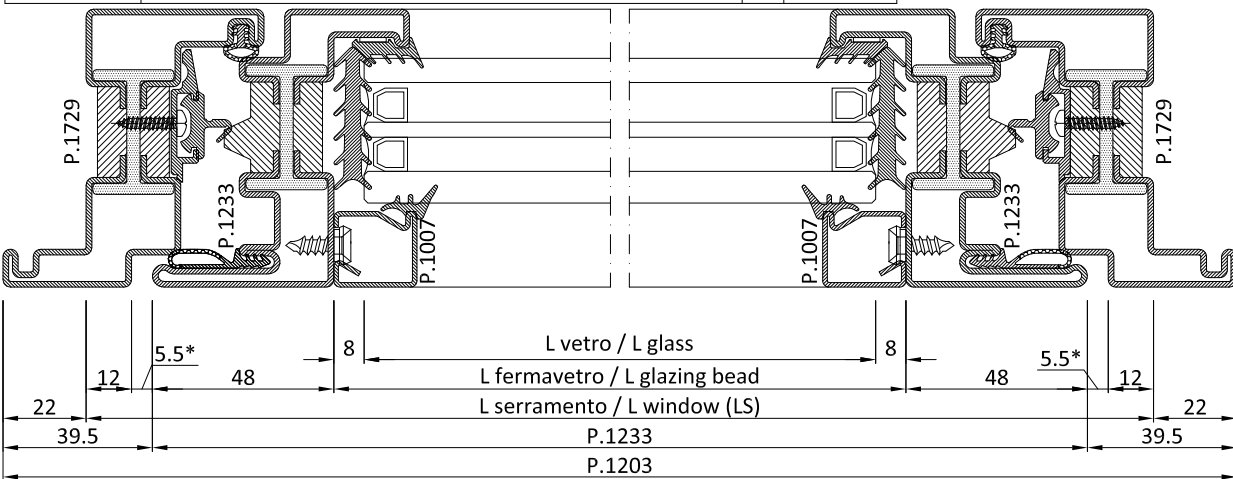
ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
AC1729I*	Kit squadrette per P.1729	Corner joint kit for P.1729	4
AC1207I*	Kit squadrette per P.1233	Corner joint kit for P.1233	4
AC1716	Guarnizione d'angolo	Vulcanised corner gasket	4
AC1219	Scarico acqua	Water drip	Var.
AC2632/C	Cerniera a saldare	Weld-on hinges	2/3
AG1264/74..	Meccanismo Vasistas	Bottom hung mechanism	1
ACV97..	Maniglia "Vitruvio"	"Vitruvio" handle	1
AC1356	Meccanismo DK	External tilt & turn mechanism	1
AC1020	Supporto spessore vetro	Glass support	6
CV5001(i)	Vite per boccola fermavetro	Screw for glazing bead bushing	Var.
CV5012(i)	Boccola per fermavetro	Bushing for glazing bead	Var.

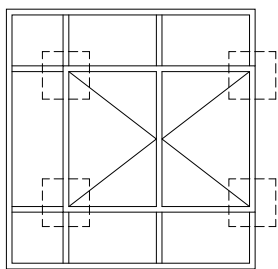
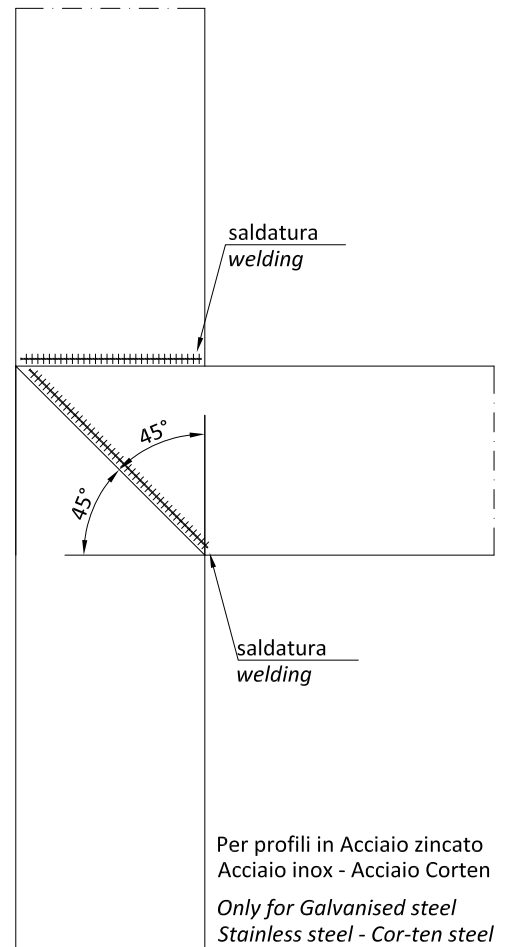
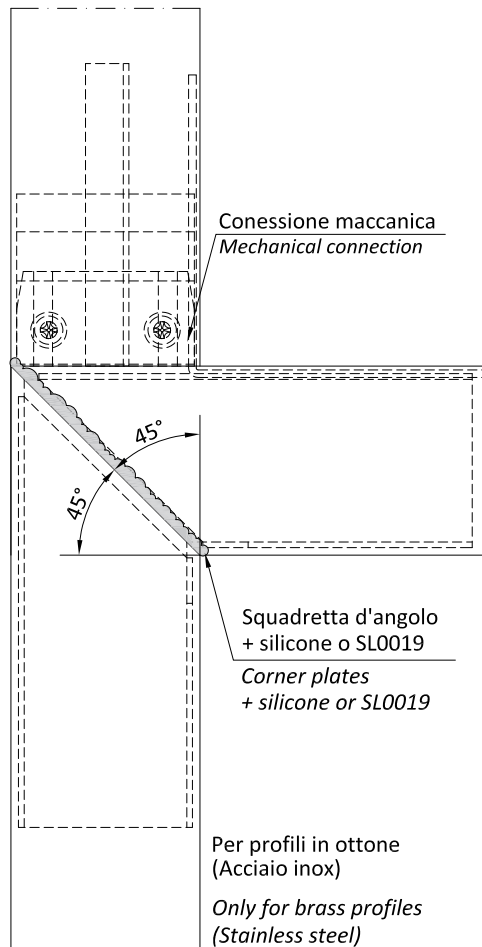
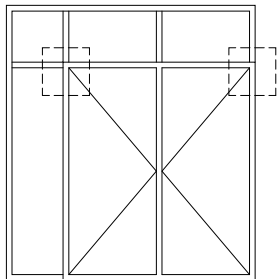
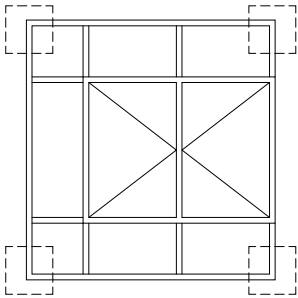
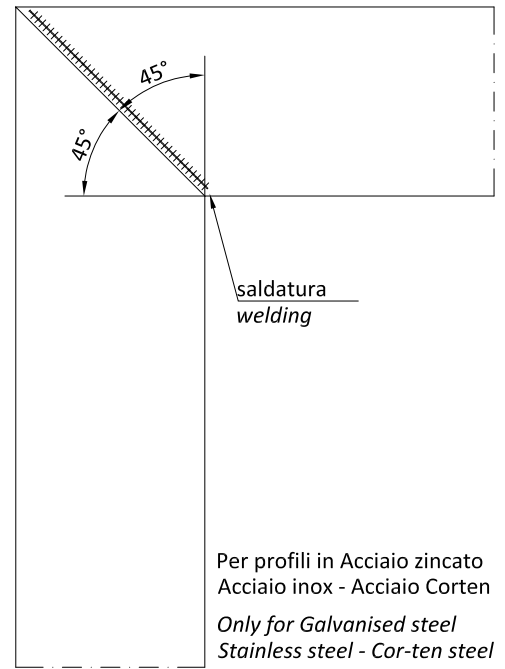
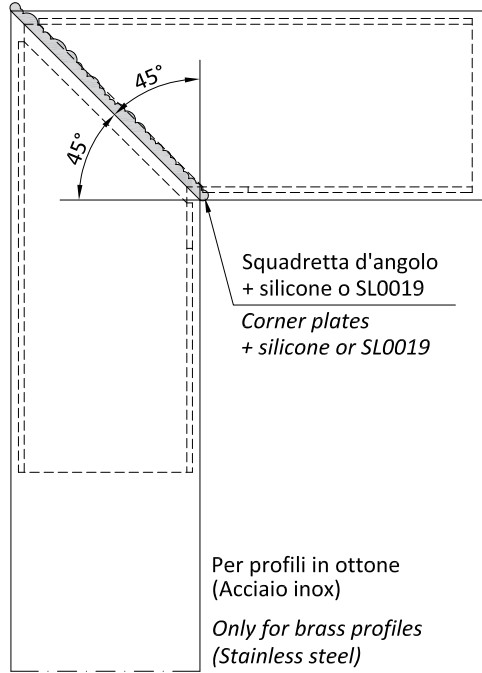
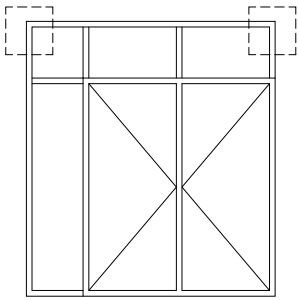
GUARNIZIONI		GASKETS	
Cod.	Descrizione	Description	n° Dim.
GE1233TT	Guarnizione esterna di battuta	External rebating gasket	1 2xLS+2xHS
GE1701	Guarnizione giunto aperto	Open joint system gasket	1 2xLS+2xHS
GU1702	Estruso PVC giunto aperto	Open joint system PVC profile	1 2xLS+2xHS
GE1200TT	Guarnizione interna di battuta	Internal rebating gasket	1 2xLS+2xHS
GE1206	Guarnizione esterna vetro	External gasket	1 2xLS+2xHS
GE1007TT	Guarnizione sottovetro	Gasket to put under the glass	1 2xLS+2xHS
GE..	Guarnizione interna vetro	Internal gasket	1 2xLS+2xHS

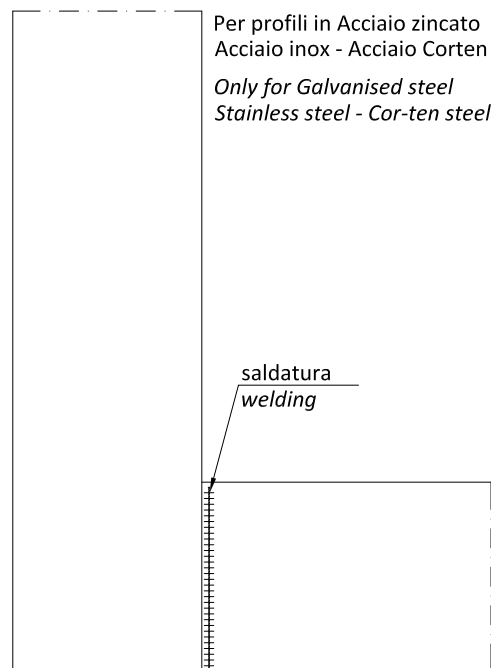
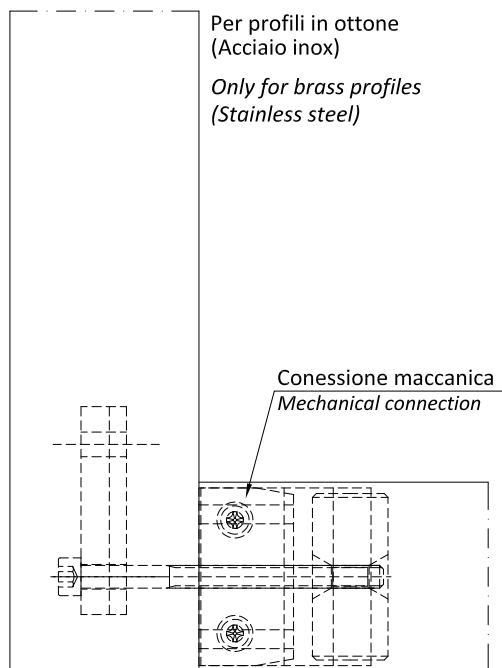
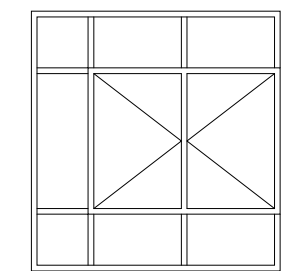
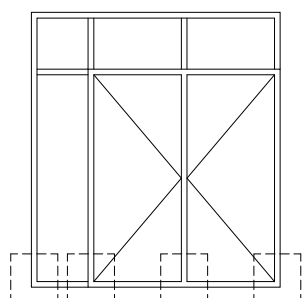
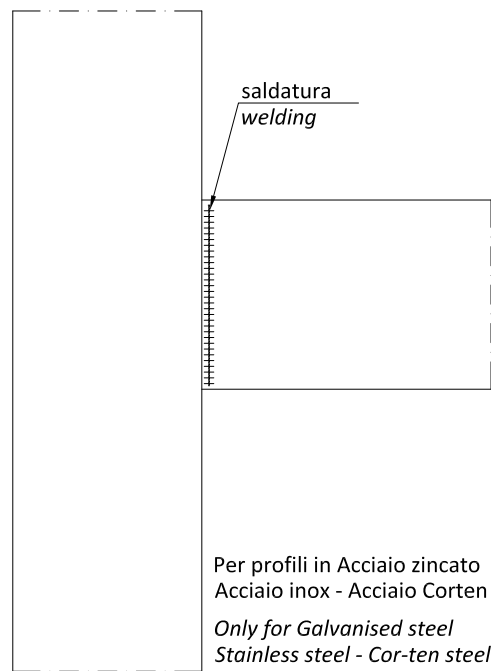
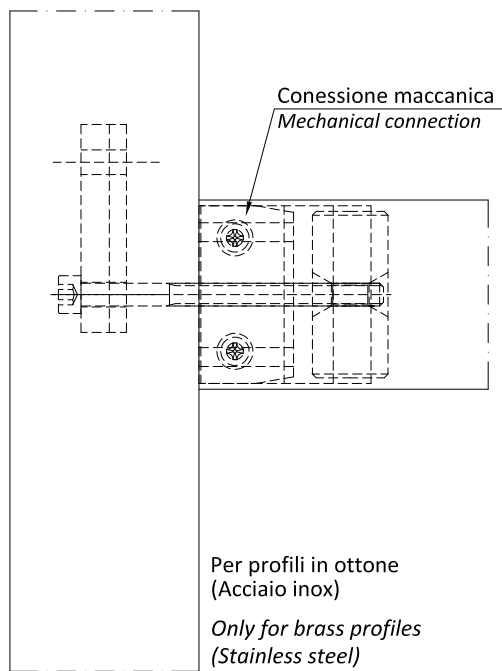
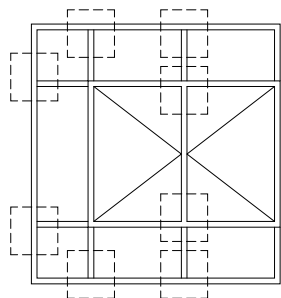
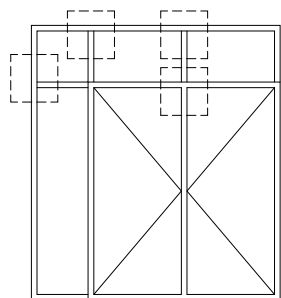


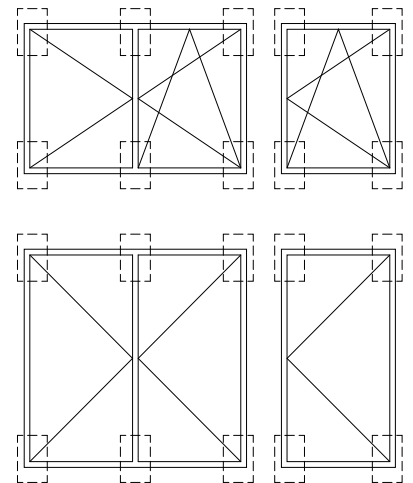
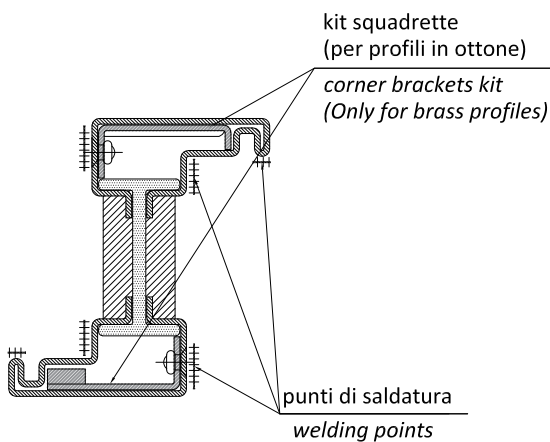
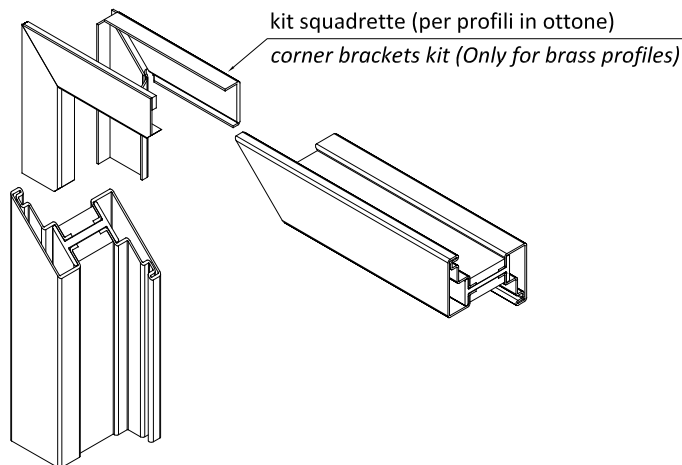
* vedi tabella 4.1.9
see chart 4.1.9

* solo con profili ottone
only with brass profiles









Per profili in ottone (Acciaio inox)
Only for brass profiles (Stainless steel)

Ottone

Utilizzare le squadrette di allineamento, sigillare tutte le superfici di contatto tra i profili che non vanno saldate. Saldare a TIG a punti le zone indicate.

Brass

Use corner brackets, seal all surfaces in touch with profiles that are not to be seam-welded. Spot weld (TIG) the marked areas.

Acciaio zincato - Acciaio Corten - Acciaio inox

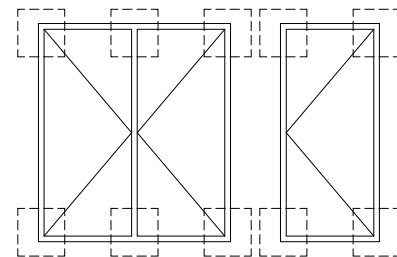
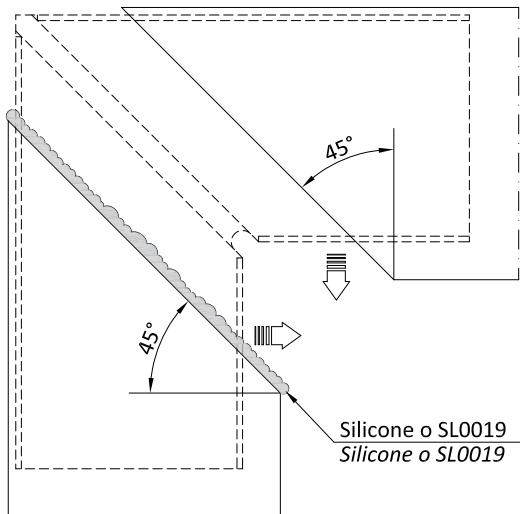
Saldare in continuo le superfici di contatto.

Galvanised steel - Cor-ten steel - Stainless steel

Seam-weld all contact surfaces.

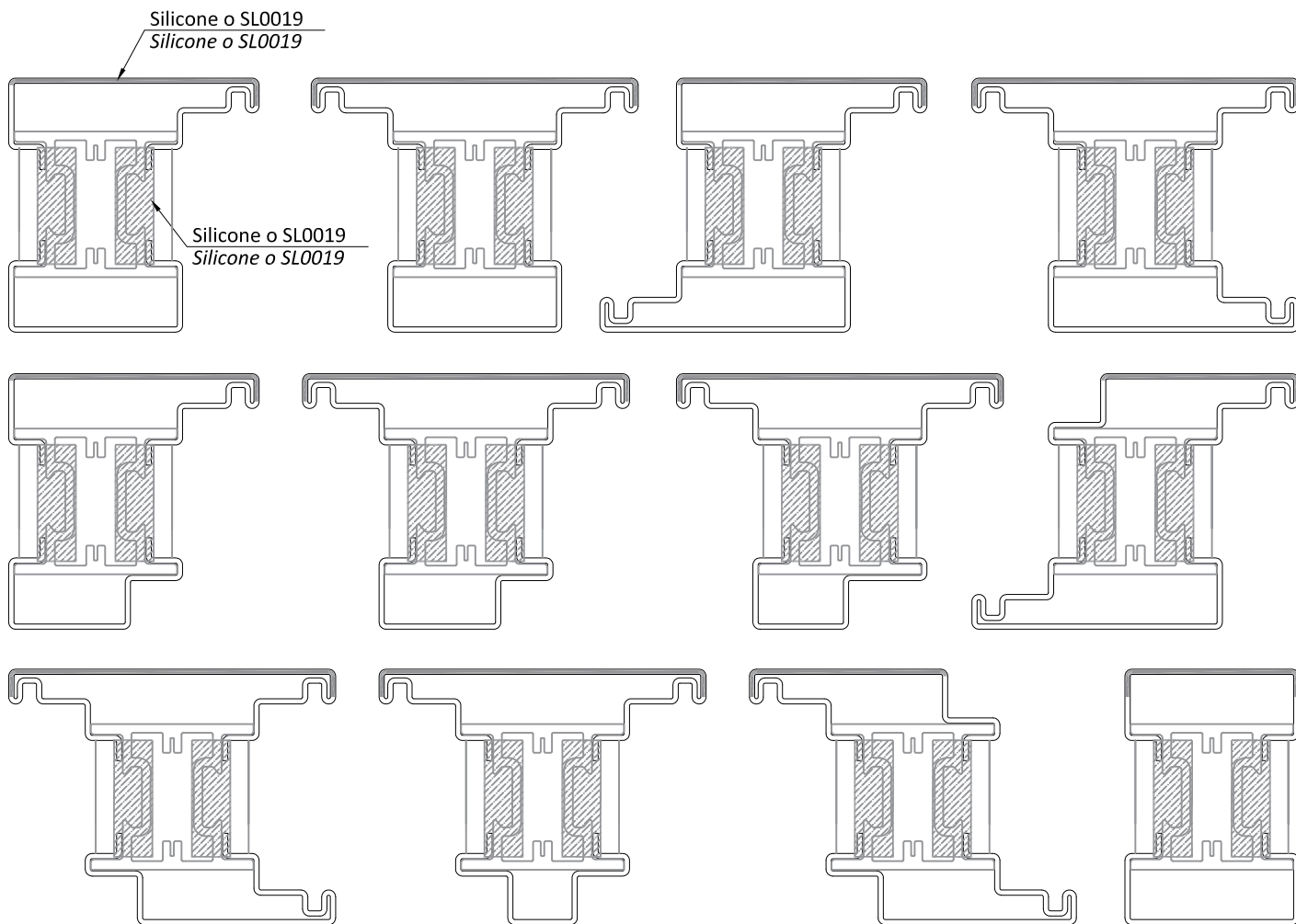
Profilo	Profile	Kit squadrette	Corner brackets set
Codice	Code	Codice	Code
P.1601-P.1601		AC 1001I	
P.1602-P.1602		AC 1002I	
P.1603-P.1603		AC 1003I	
P.1611-P.1611		AC 1004I	
P.1612-P.1612		AC 1005I	
P.1613-P.1613		AC 1006I	telaio / frame
P.1613-P.1613		AC 1007I	anta / leaf
P.1612-P.1613		AC 1008I	
P.1605-P.1605		AC 1009I	
P.1610-P.1610		AC 1013I	
P.1627 P.1612		AC 1024ID	
P.1627-P.1612		AC 1024IS	

Profilo	Profile	Kit squadrette	Corner brackets set
Codice	Code	Codice	Code
P.1701-P.1701		AC 1201I	
P.1702-P.1702		AC 1202I	
P.1703-P.1703		AC 1203I	
P.1233-P.1233		AC 1207I	
P.1705-P.1705		AC 1209I	
P.1724-P.1233		AC 1208I	
P.1720-P.1720		AC 1730I	
P.1711-P.1711		AC 1711I	
P.1712-P.1712		AC 1732I	
P.1713-P.1713		AC 1733I	anta / leaf
P.1713-P.1713		AC 1733IE	telaio / frame
P.1715-P.1715		AC 1735I	

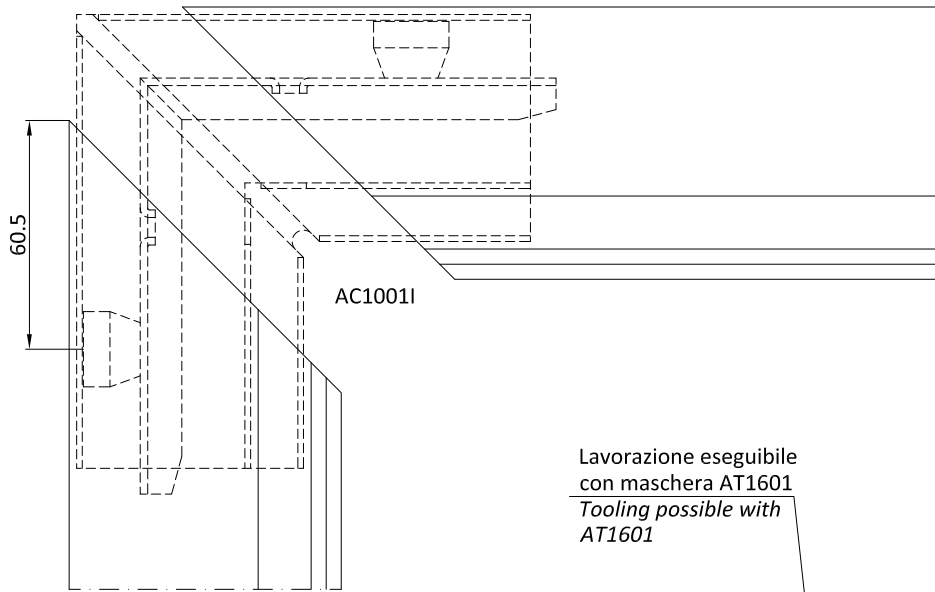


- 1) inserire la squadretta
- 2) siliconare nelle zone indicate
- 3) accostare i profili
- 4) procedere con la saldatura (vedasi pagine successive)

- 1) insert the bracket
- 2) seal in the specified areas
- 3) align the profiles
- 4) weld (see following pages)

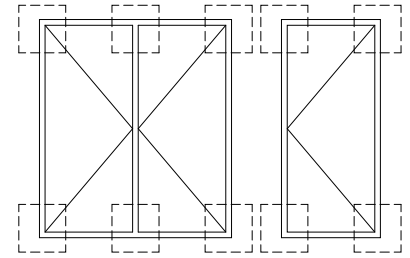


Sigillare con silicone o sigillante a freddo SL0019 nelle zone evidenziate (sempre lato esterno profilo)
 Seal with silicone or cold-working sealant SL0019 in the areas marked (always on the outer side of the profile)



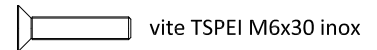
AC1001I

Lavorazione eseguibile
con maschera AT1601
Tooling possible with
AT1601



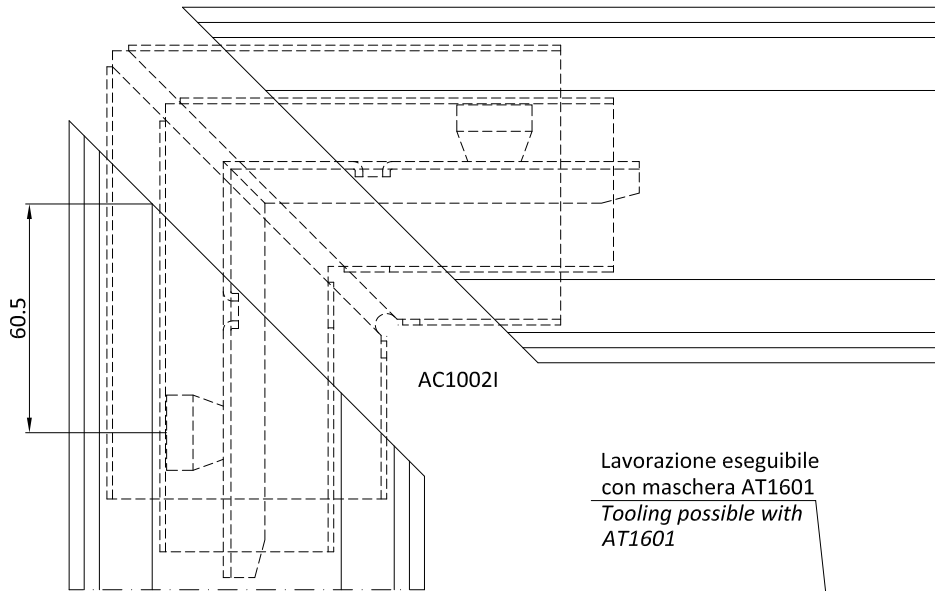
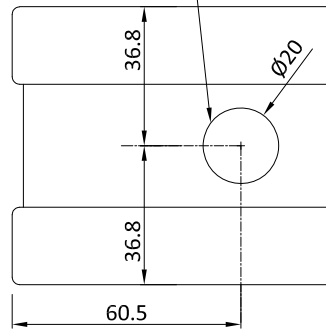
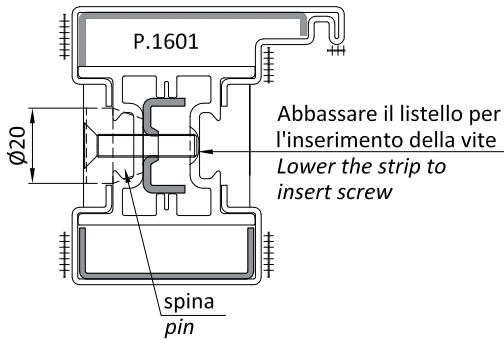
Saldare a TIG con materiale di riporto
nelle zone indicate con +++++

Sigillare tutte le superfici di contatto
esterne con silicone o SL0019



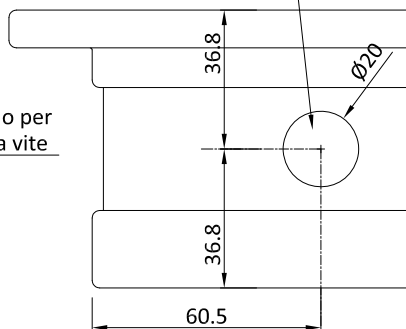
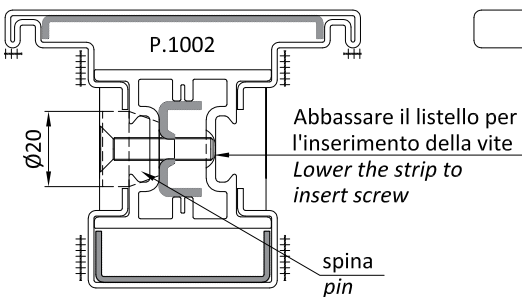
TIG welding with filler material in the
areas indicated with +++++

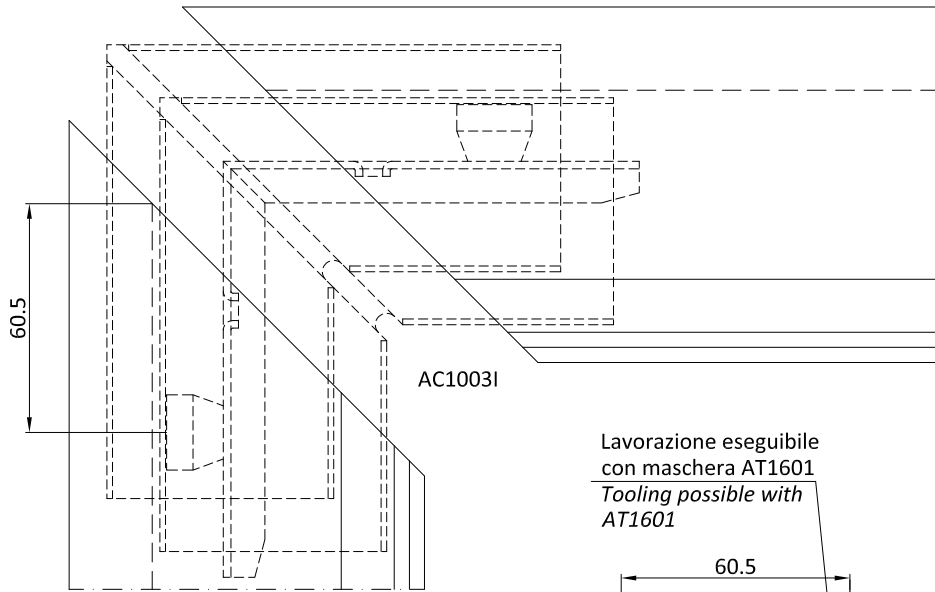
Seal all the external contact surfaces
with silicone our SL0019



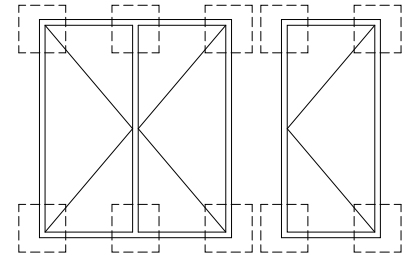
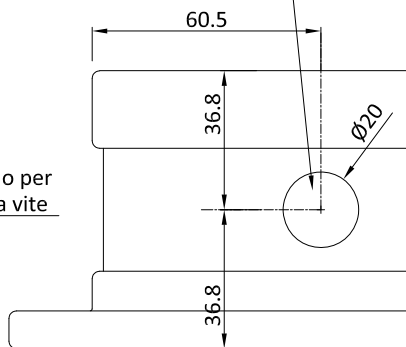
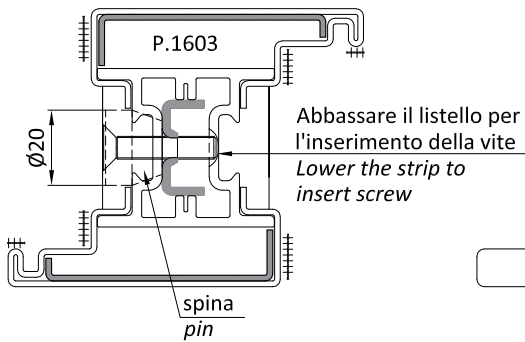
AC1002I

Lavorazione eseguibile
con maschera AT1601
Tooling possible with
AT1601



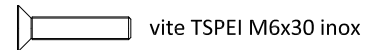


Lavorazione eseguibile
con maschera AT1601
Tooling possible with
AT1601



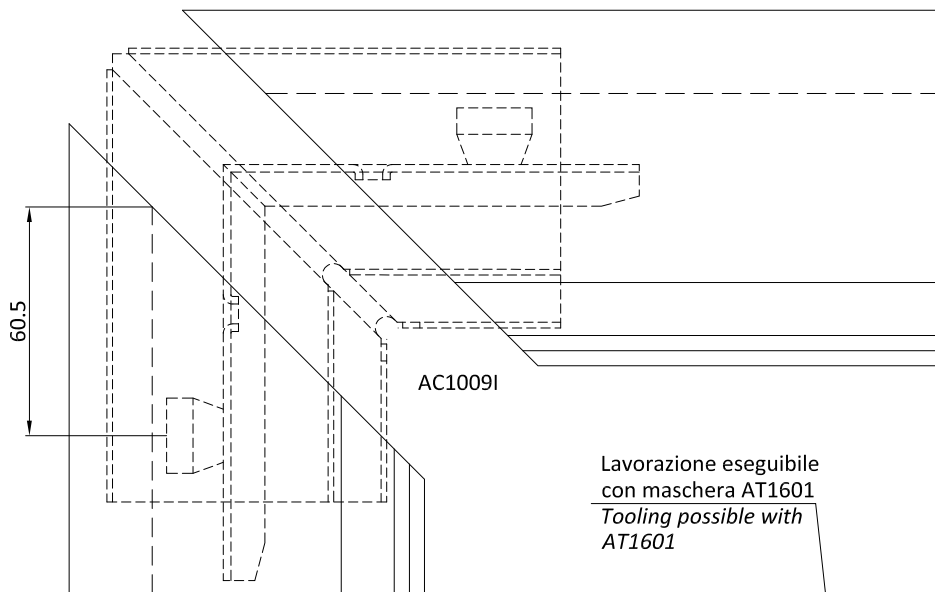
Saldare a TIG con materiale di riporto
nelle zone indicate con +++++

Sigillare tutte le superfici di contatto
esterne con silicone o SL0019

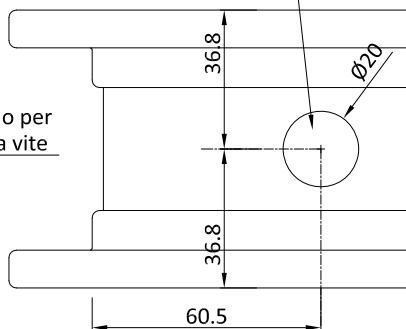
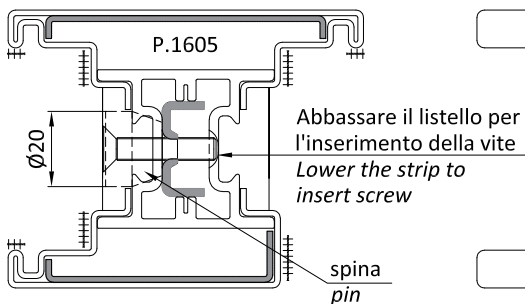


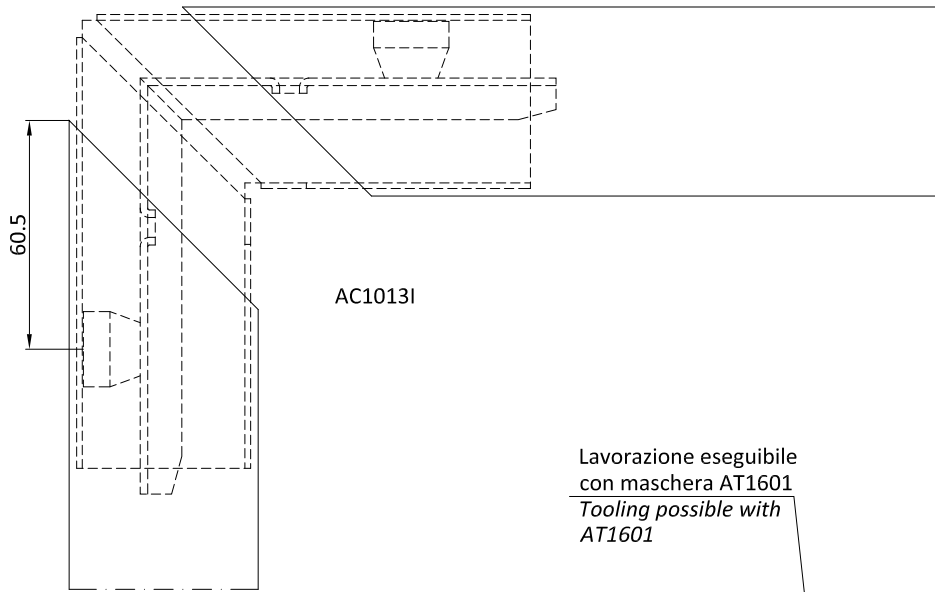
TIG welding with filler material in the
areas indicated with +++++

Seal all the external contact surfaces
with silicone our SL0019



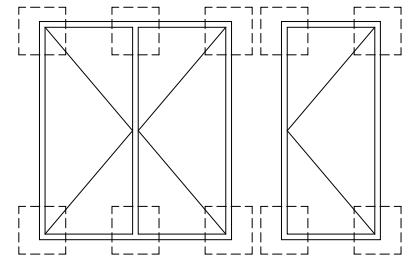
Lavorazione eseguibile
con maschera AT1601
Tooling possible with
AT1601





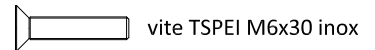
AC1013I

Lavorazione eseguibile
con maschera AT1601
Tooling possible with
AT1601



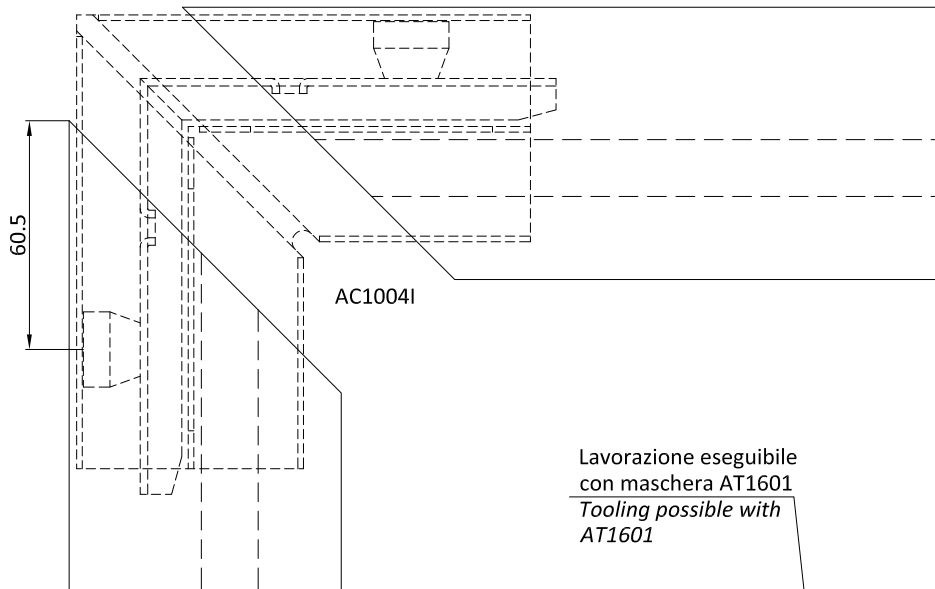
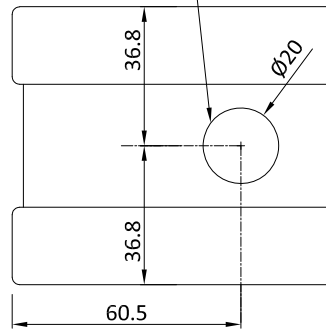
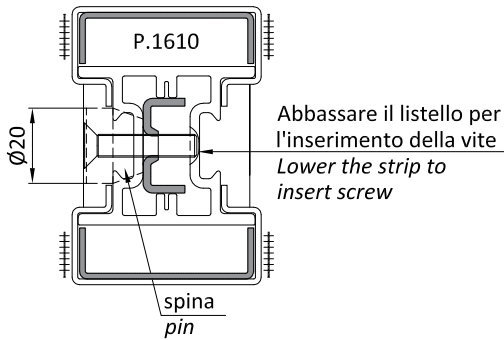
Saldare a TIG con materiale di riporto
nelle zone indicate con +++++

Sigillare tutte le superfici di contatto
esterne con silicone o SL0019



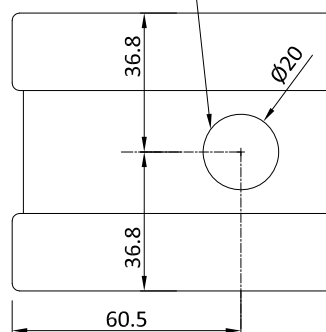
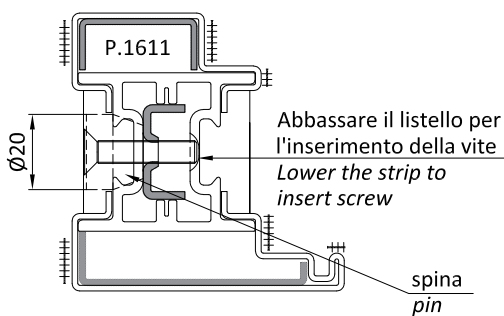
TIG welding with filler material in the
areas indicated with +++++

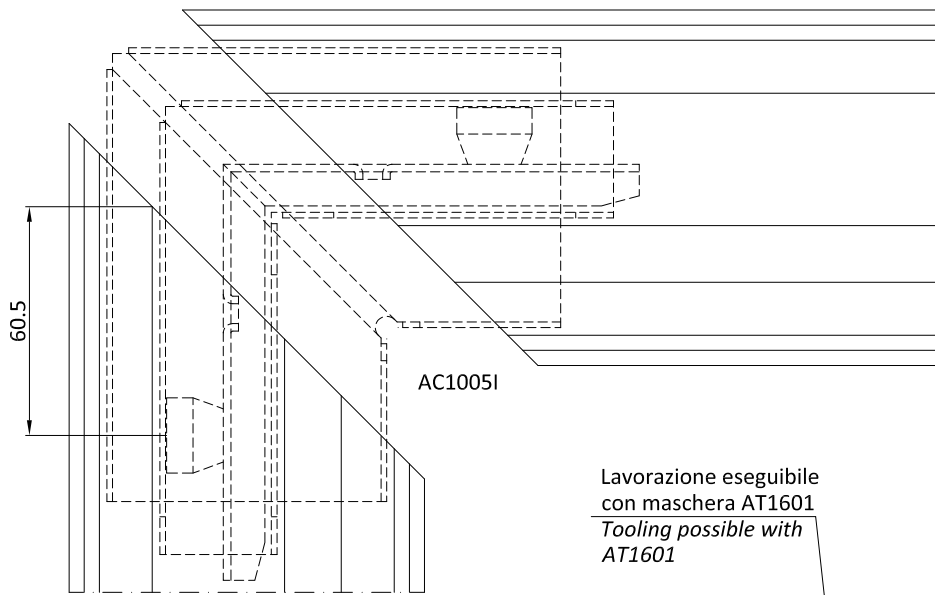
Seal all the external contact surfaces
with silicone our SL0019



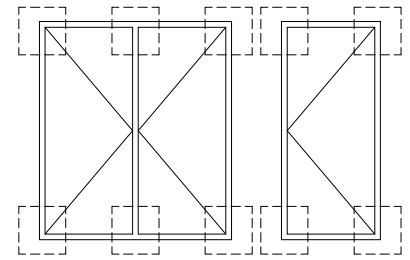
AC1004I

Lavorazione eseguibile
con maschera AT1601
Tooling possible with
AT1601



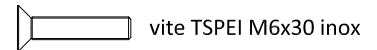


Lavorazione eseguibile
con maschera AT1601
Tooling possible with
AT1601



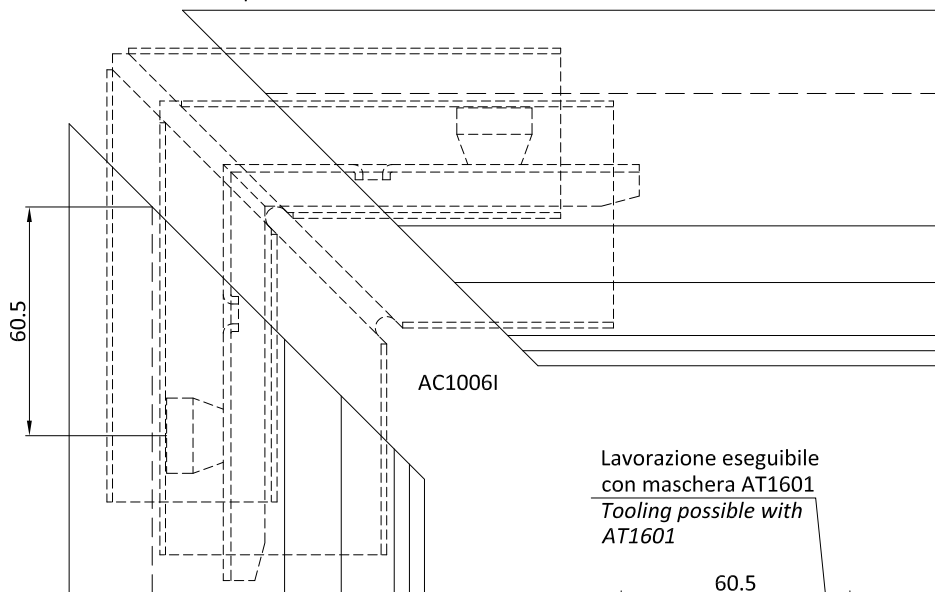
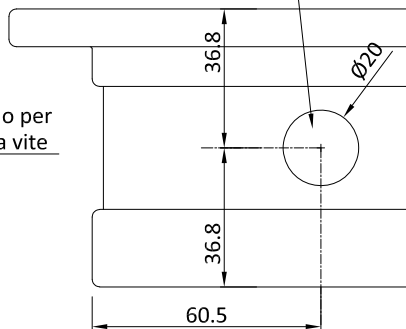
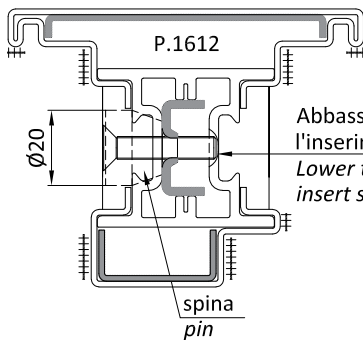
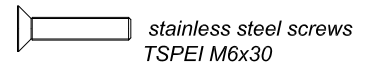
Saldare a TIG con materiale di riporto
nelle zone indicate con +++++

Sigillare tutte le superfici di contatto
esterne con silicone o SL0019

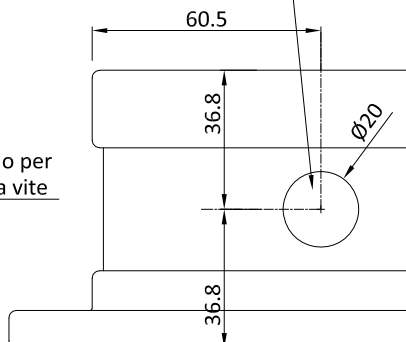
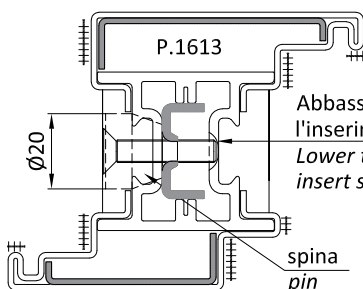


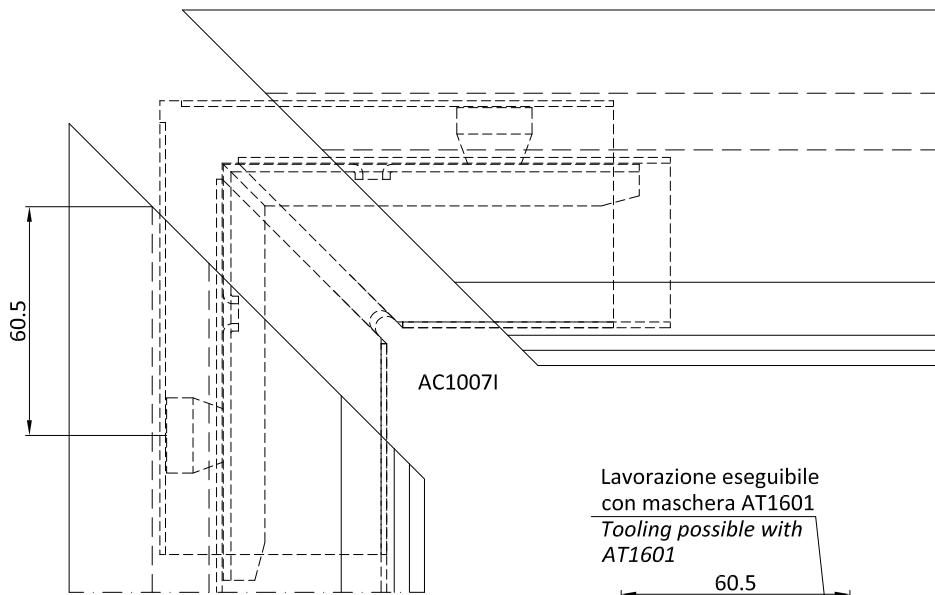
TIG welding with filler material in the
areas indicated with +++++

Seal all the external contact surfaces
with silicone our SL0019

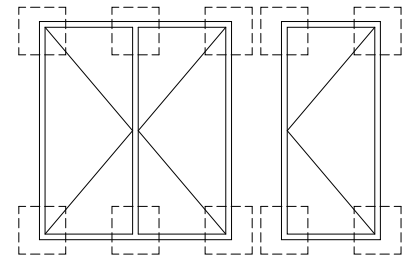
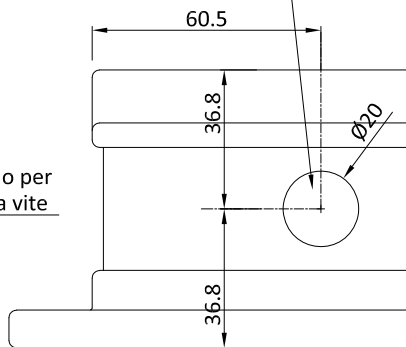
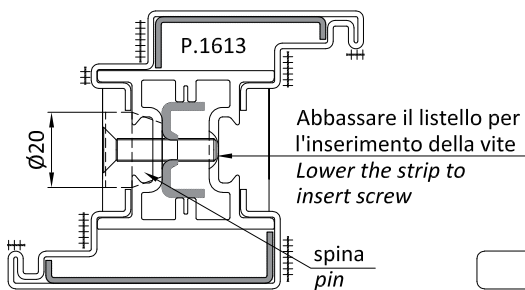


Lavorazione eseguibile
con maschera AT1601
Tooling possible with
AT1601



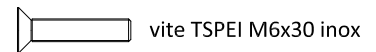


Lavorazione eseguibile
con maschera AT1601
Tooling possible with
AT1601



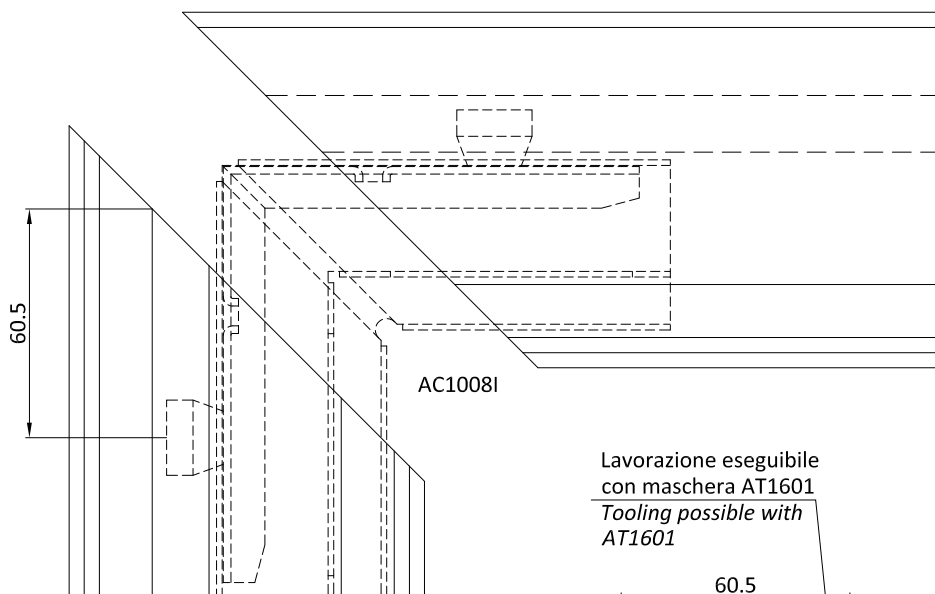
Saldare a TIG con materiale di riporto
nelle zone indicate con #####

Sigillare tutte le superfici di contatto
esterne con silicone o SL0019

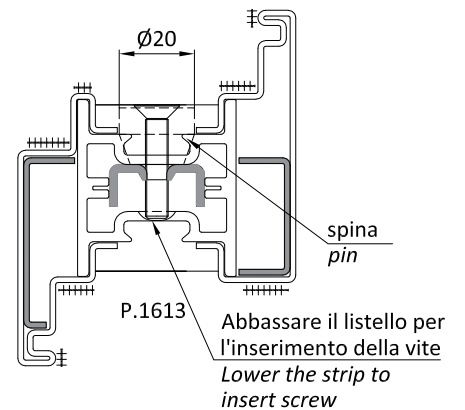
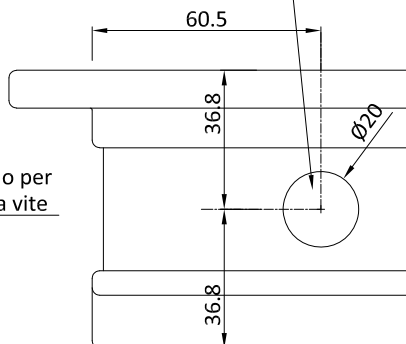
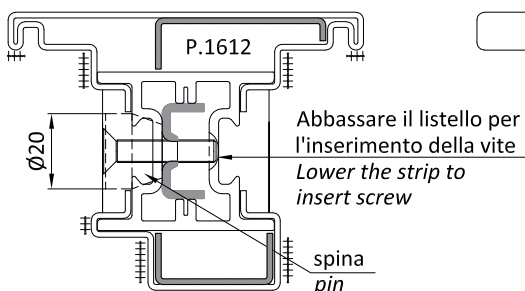


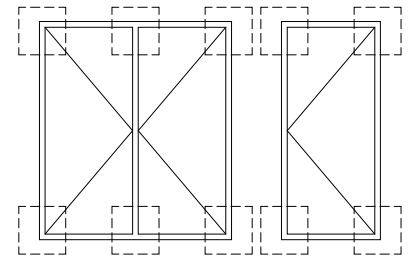
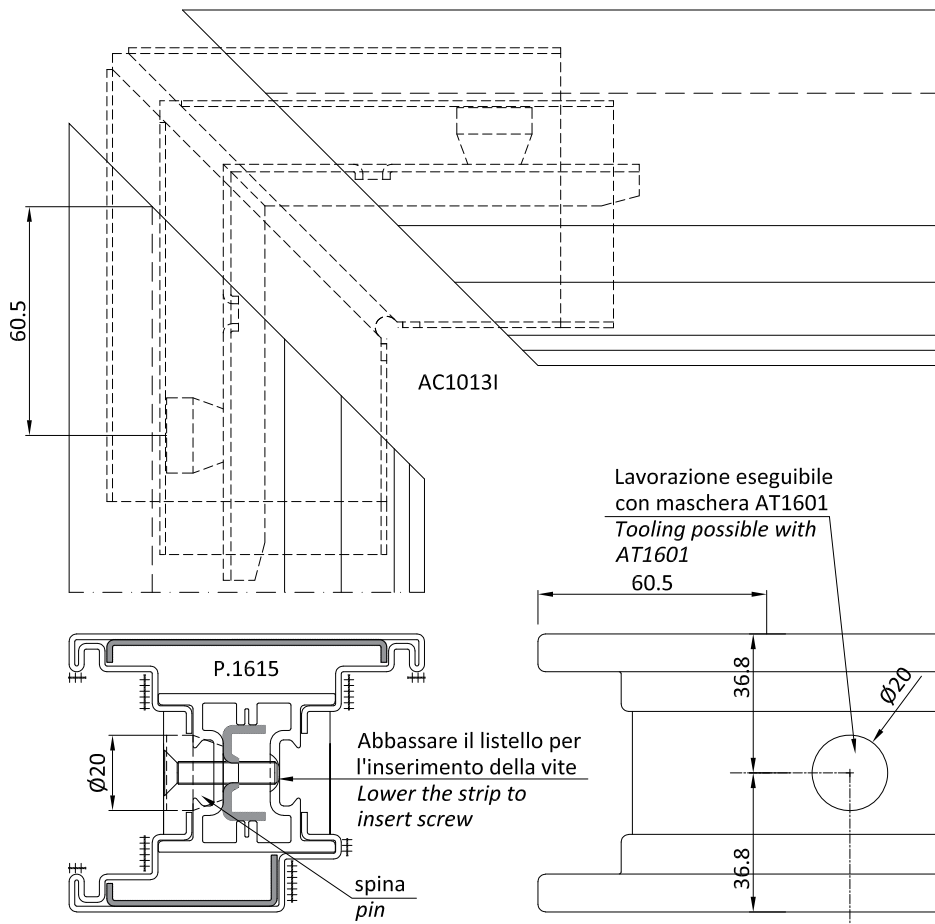
TIG welding with filler material in the
areas indicated with #####

Seal all the external contact surfaces
with silicone our SL0019



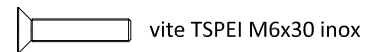
Lavorazione eseguibile
con maschera AT1601
Tooling possible with
AT1601





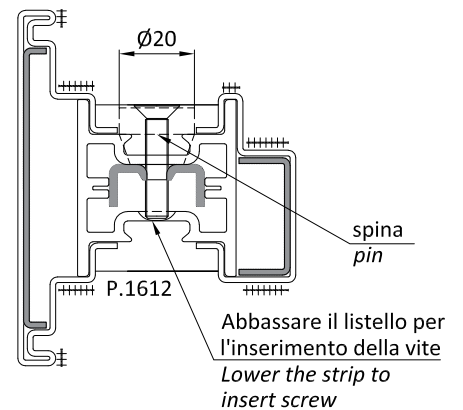
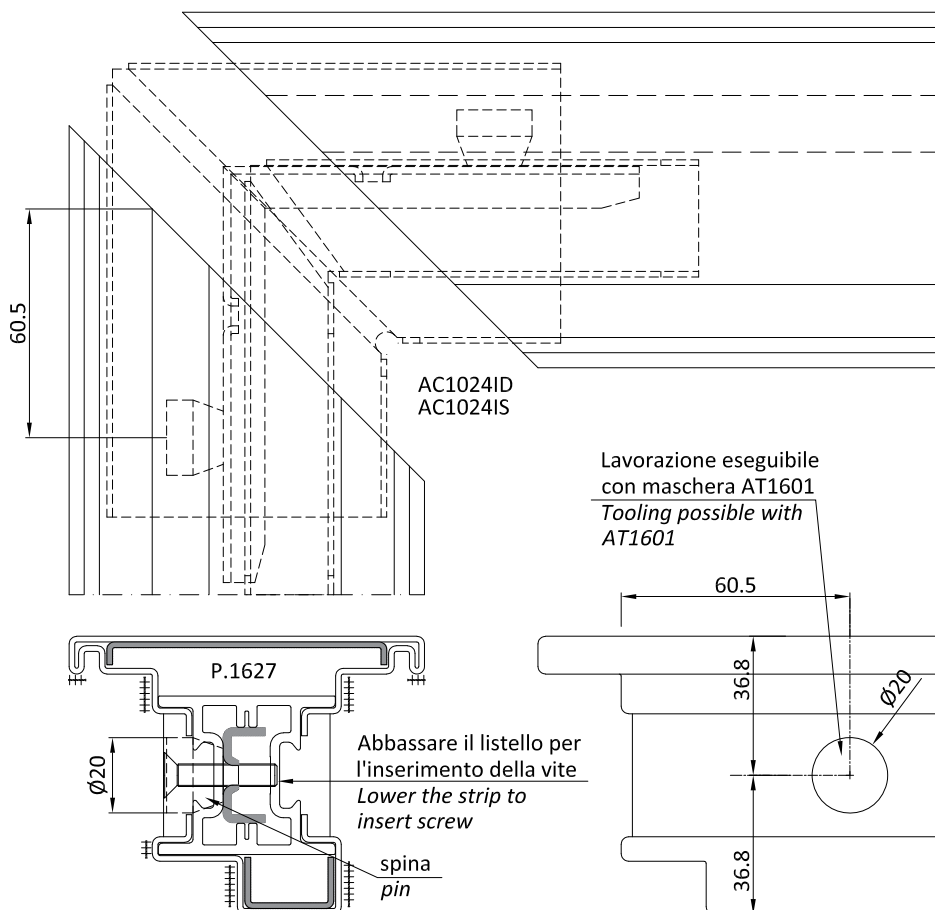
Saldare a TIG con materiale di riporto nelle zone indicate con +++++

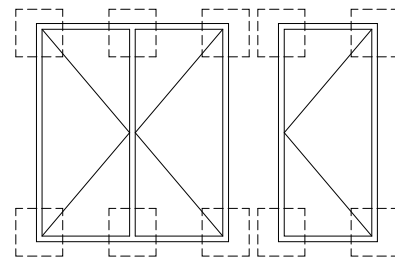
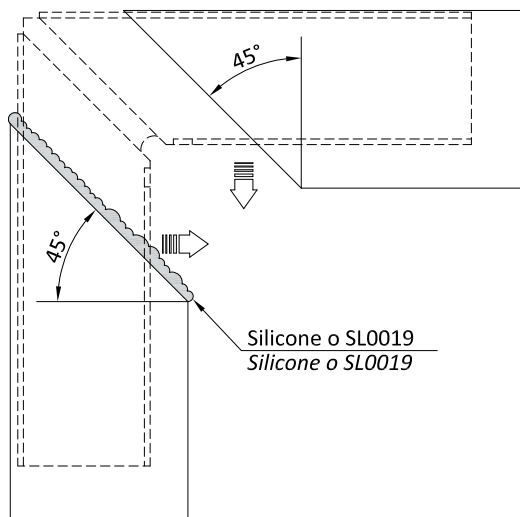
Sigillare tutte le superfici di contatto esterne con silicone o SL0019



TIG welding with filler material in the areas indicated with +++++

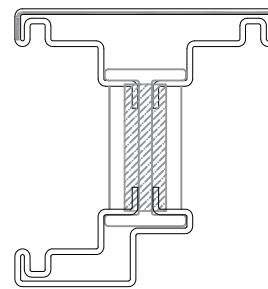
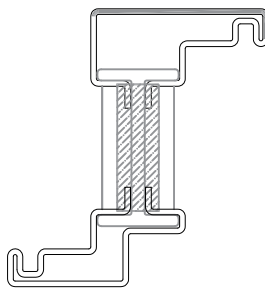
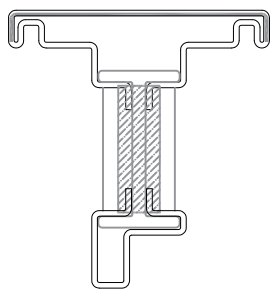
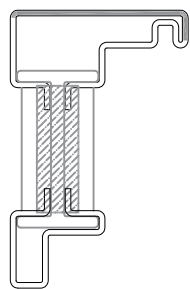
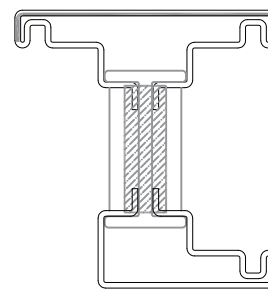
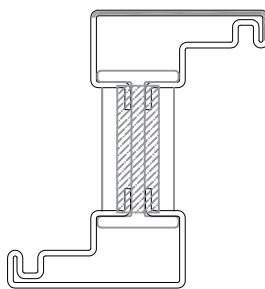
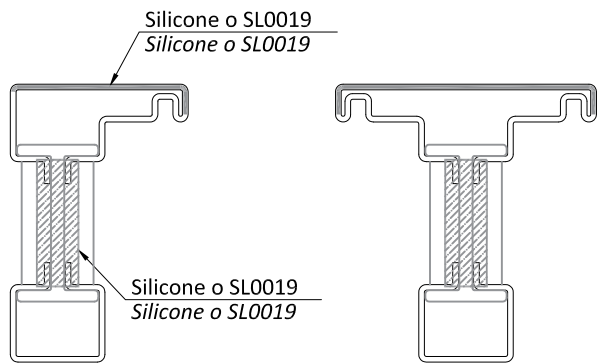
Seal all the external contact surfaces with silicone our SL0019




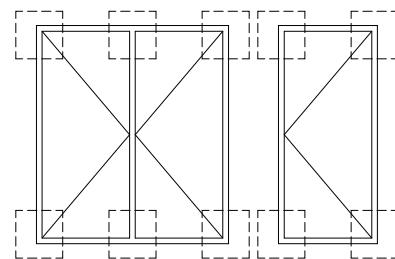
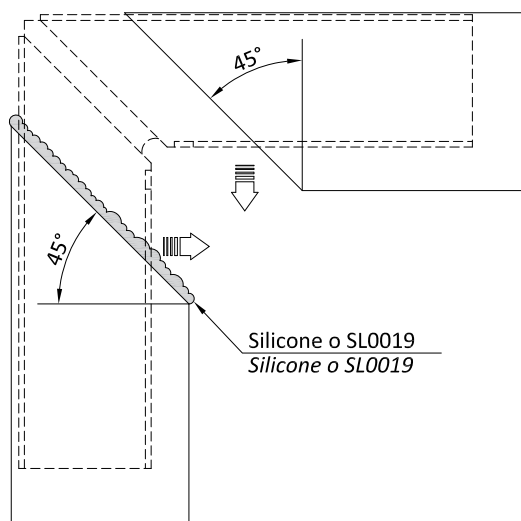


- 1) inserire la squadretta
- 2) siliconare nelle zone indicate
- 3) accostare i profili
- 4) procedere con la saldatura (vedasi pagine successive)

- 1) insert the bracket
- 2) seal in the specified areas
- 3) align the profiles
- 4) weld (see following pages)

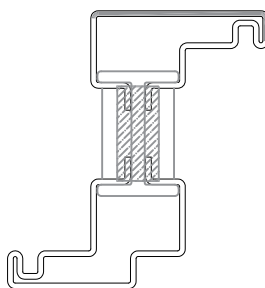
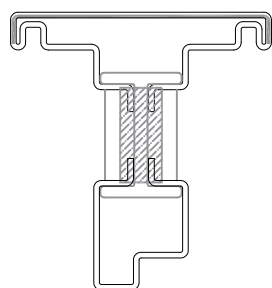
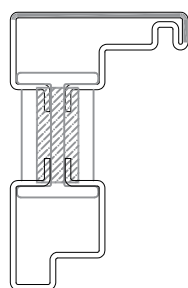
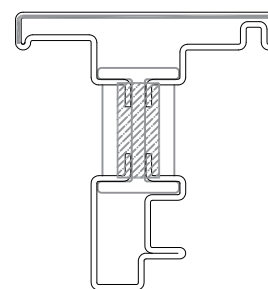
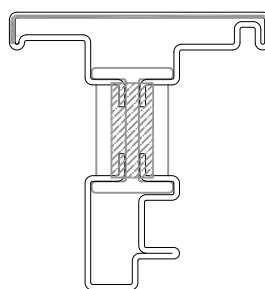
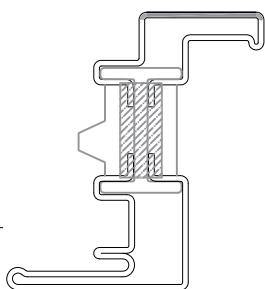
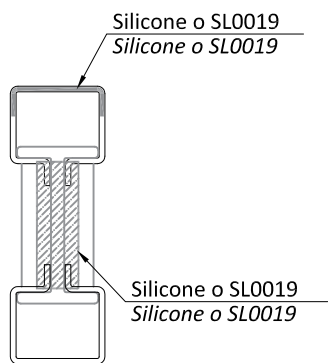




 Sigillare con silicone o sigillante a freddo SL0019 nelle zone evidenziate (sempre lato esterno profilo)
 Seal with silicone or cold-working sealant SL0019 in the areas marked (always on the outer side of the profile)

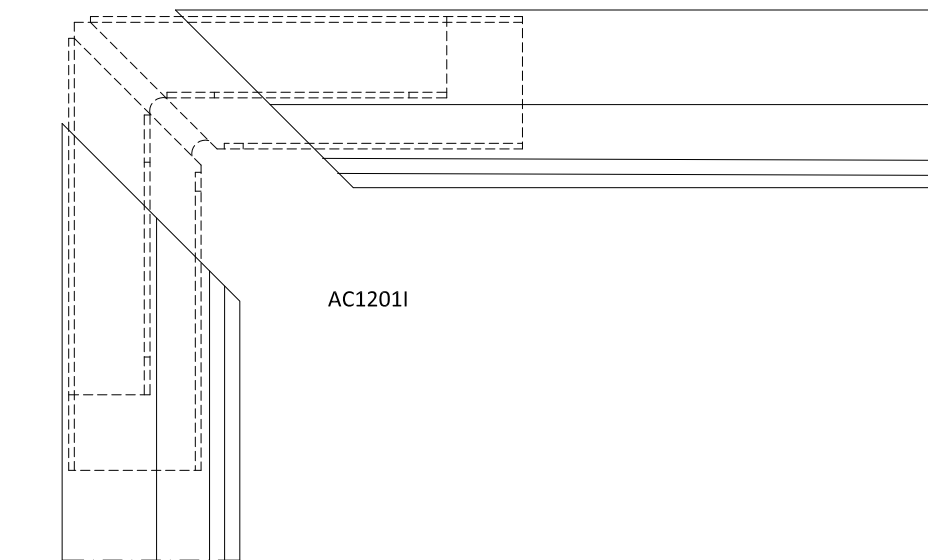


- 1) inserire la squadretta
- 2) siliconare nelle zone indicate
- 3) accostare i profili
- 4) procedere con la saldatura (vedasi pagine successive)

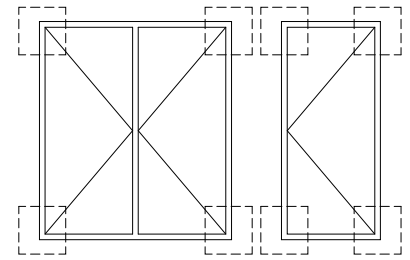
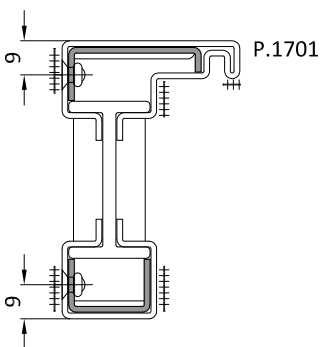
- 1) insert the bracket
- 2) seal in the specified areas
- 3) align the profiles
- 4) weld (see following pages)



 Sigillare con silicone o sigillante a freddo SL0019 nelle zone evidenziate (sempre lato esterno profilo)
 Seal with silicone or cold-working sealant SL0019 in the areas marked (always on the outer side of the profile)




AC1201I




Saldare a TIG con materiale di riporto nelle zone indicate con #####

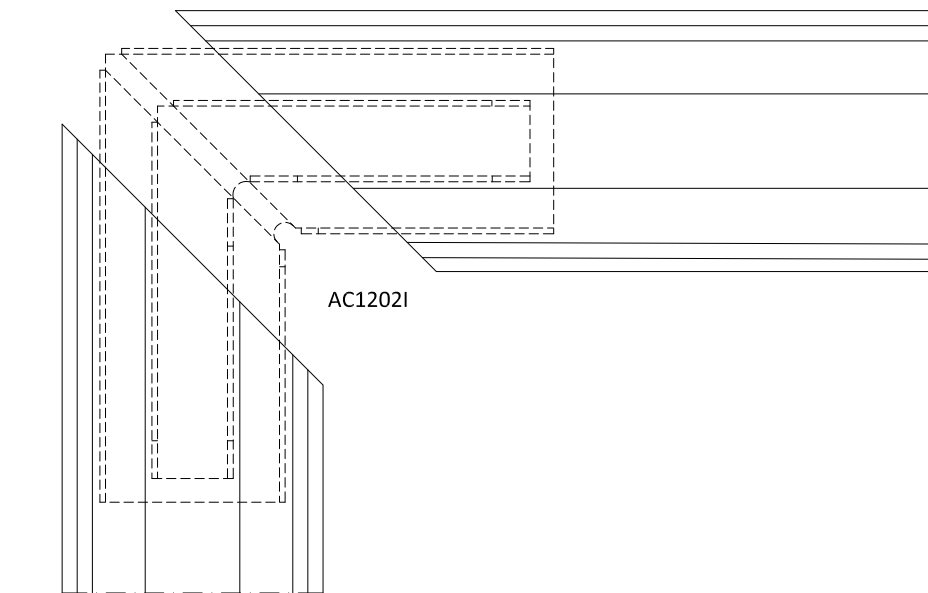
Sigillare tutte le superfici di contatto esterne con silicone o SL0019

 Rivetti svasati Ø 4

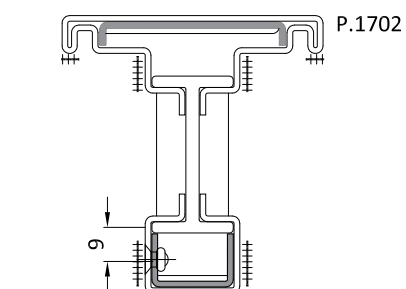
TIG welding with filler material in the areas indicated with #####

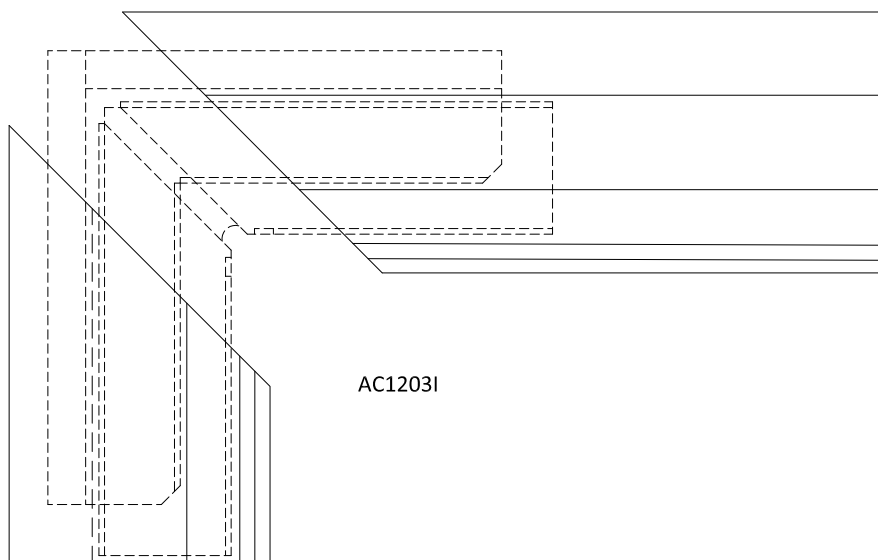
Seal all the external contact surfaces with silicone our SL0019

 Countersunk rivets Ø 4

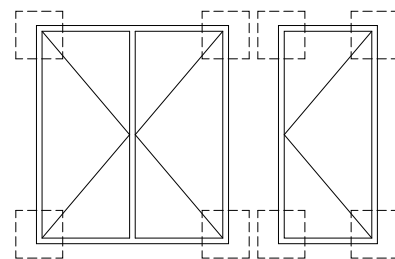
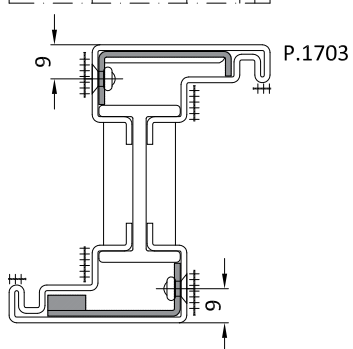


AC1202I






AC1203I




Saldare a TIG con materiale di riporto nelle zone indicate con #####

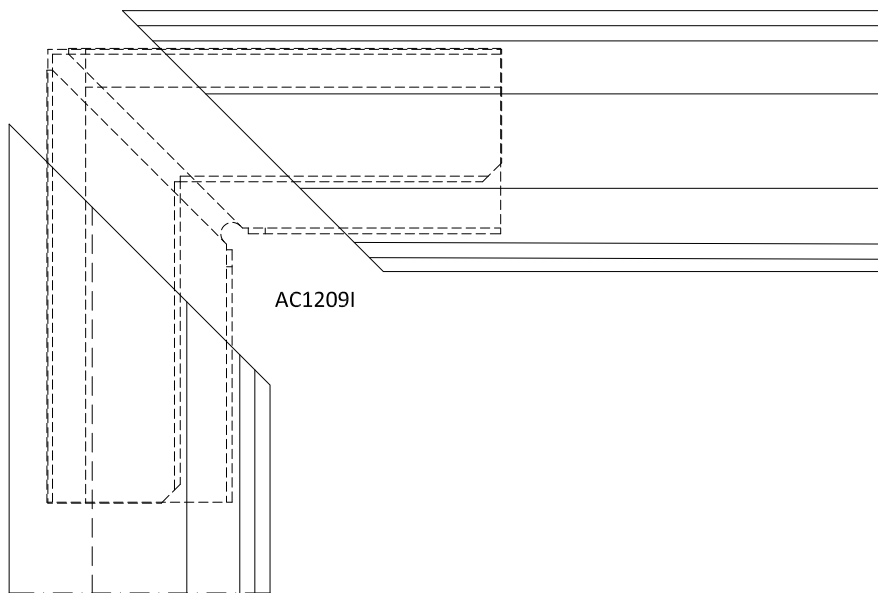
Sigillare tutte le superfici di contatto esterne con silicone o SL0019

 Rivetti svasati Ø 4

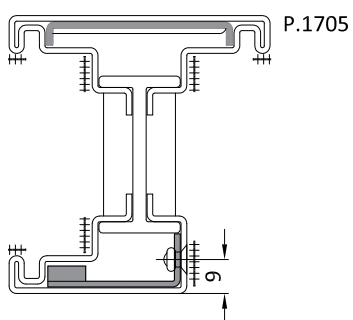
TIG welding with filler material in the areas indicated with #####

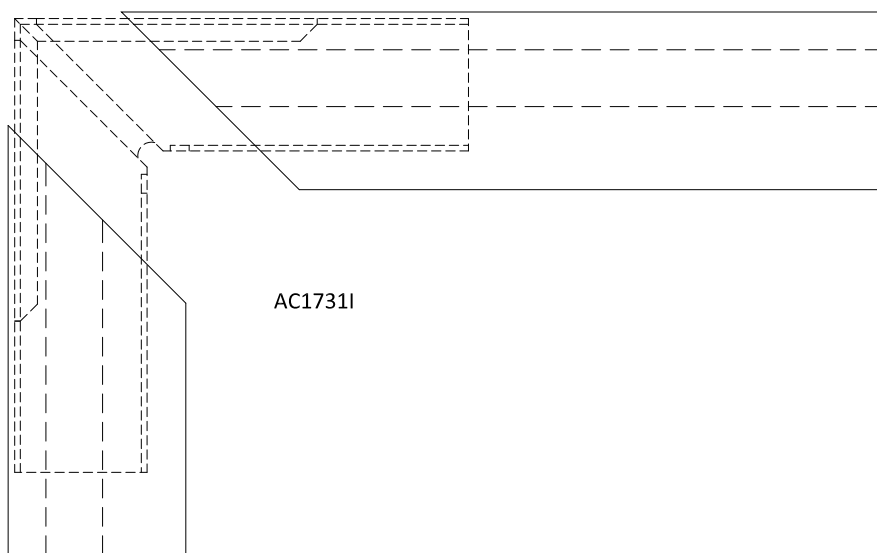
Seal all the external contact surfaces with silicone our SL0019

 Countersunk rivets Ø 4

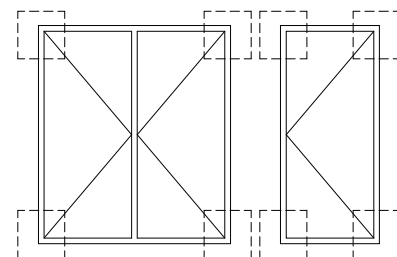


AC1209I






AC1731I




Saldare a TIG con materiale di riporto nelle zone indicate con #####

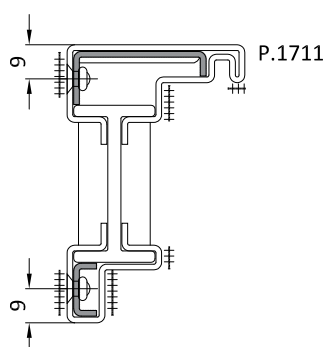
Sigillare tutte le superfici di contatto esterne con silicone o SL0019

 Rivetti svasati Ø 4

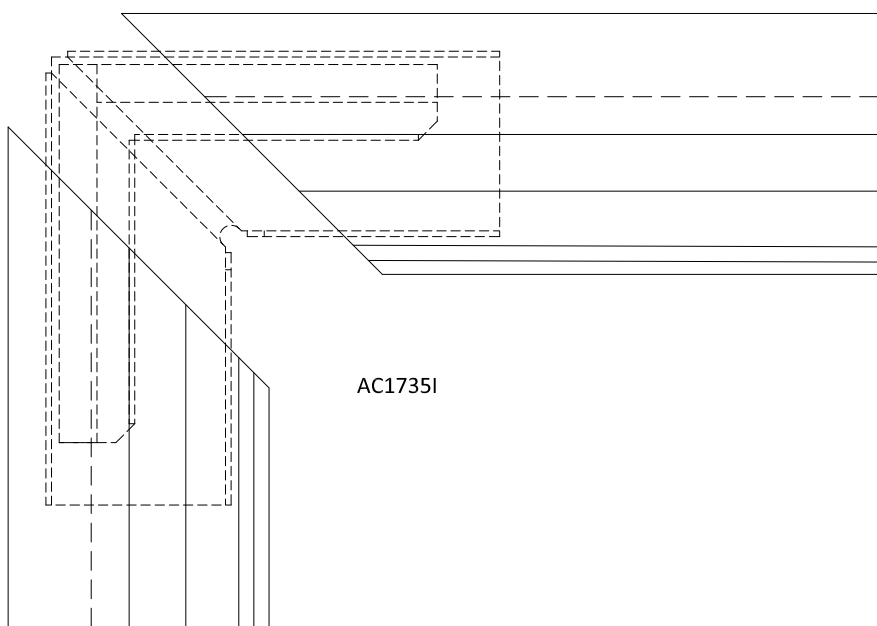
TIG welding with filler material in the areas indicated with #####

Seal all the external contact surfaces with silicone our SL0019

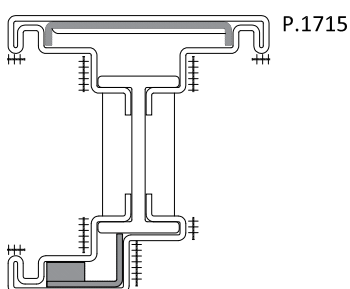
 Countersunk rivets Ø 4



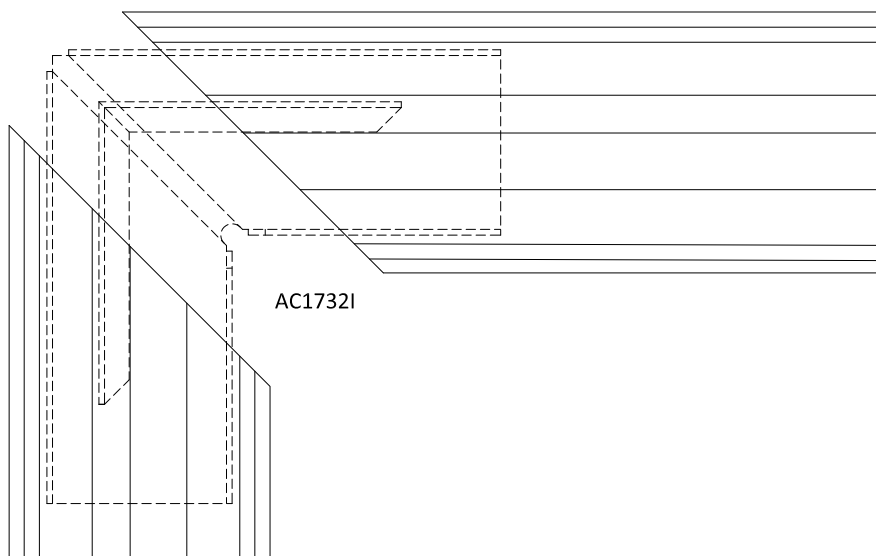
P.1711



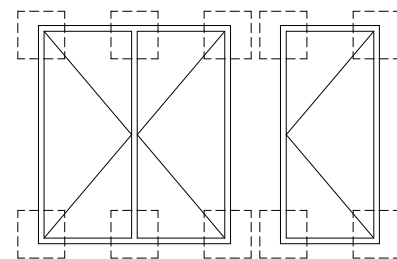
AC1735I



P.1715




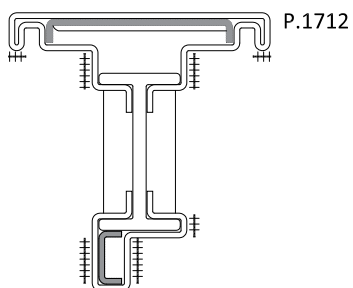
AC1732I



Saldare a TIG con materiale di riporto nelle zone indicate con +++++

Sigillare tutte le superfici di contatto esterne con silicone o SL0019


 Rivetti svasati Ø 4

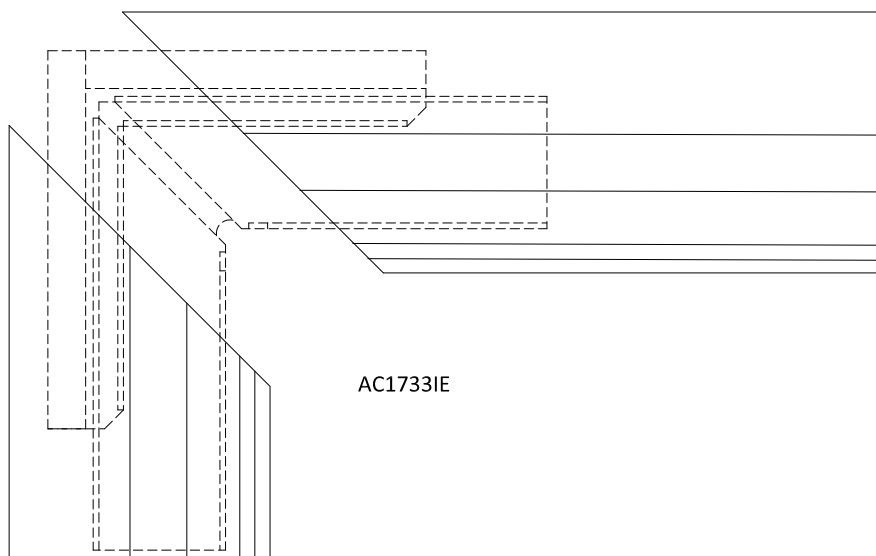


P.1712

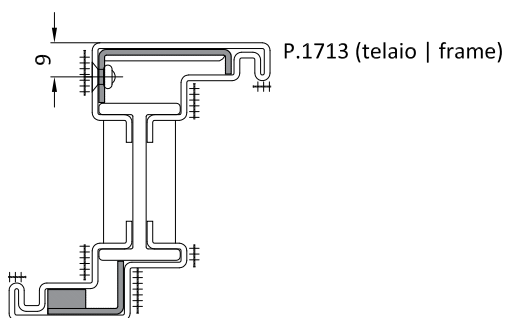
TIG welding with filler material in the areas indicated with +++++

Seal all the external contact surfaces with silicone our SL0019

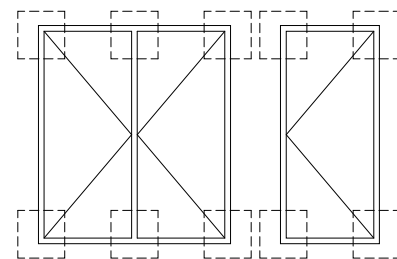
 *Countersunk rivets Ø 4*



AC1733IE




P.1713 (telaino | frame)




Saldare a TIG con materiale di riporto nelle zone indicate con +-----

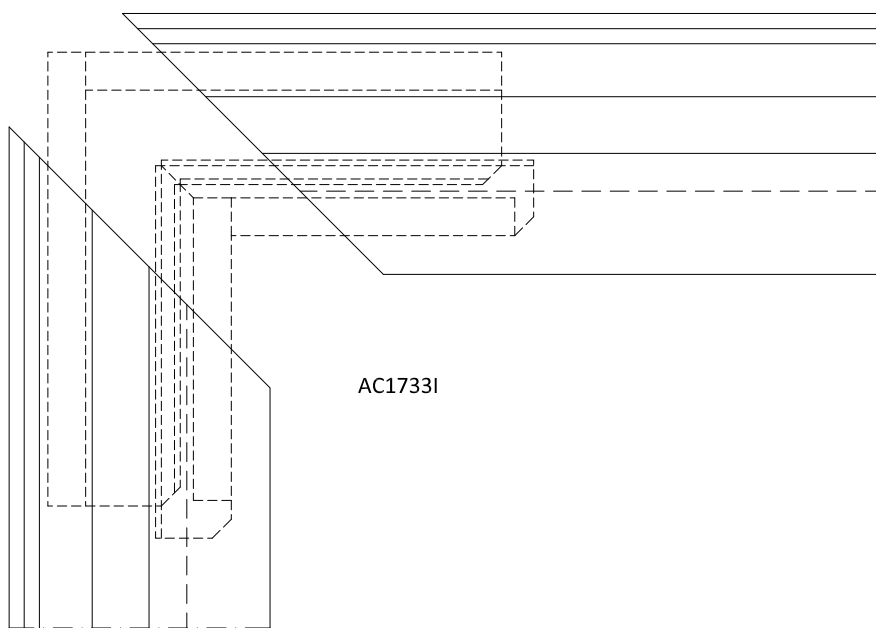
Sigillare tutte le superfici di contatto esterne con silicone o SL0019

 Rivetti svasati Ø 4

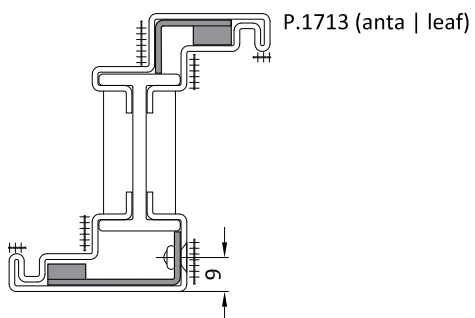
TIG welding with filler material in the areas indicated with +-----

Seal all the external contact surfaces with silicone our SL0019

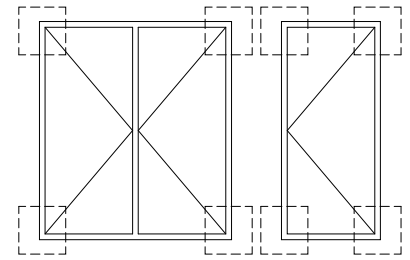
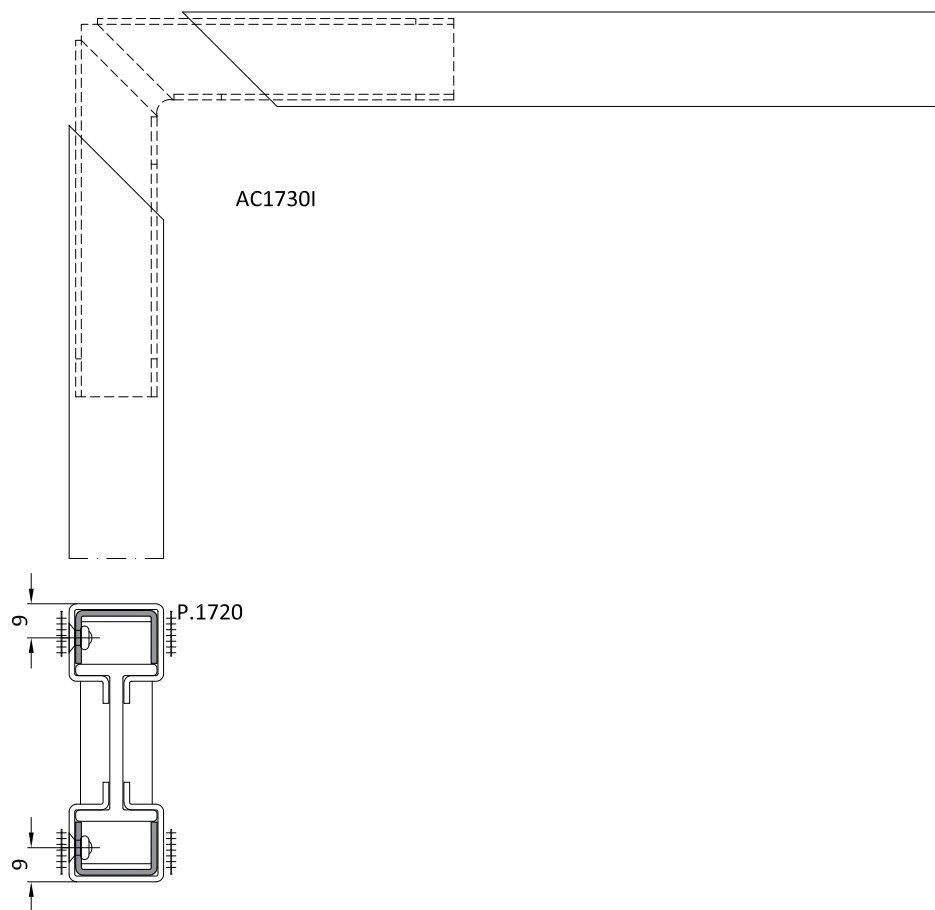
 Countersunk rivets Ø 4



AC1733I




P.1713 (anta | leaf)




Saldare a TIG con materiale di riporto nelle zone indicate con +++++

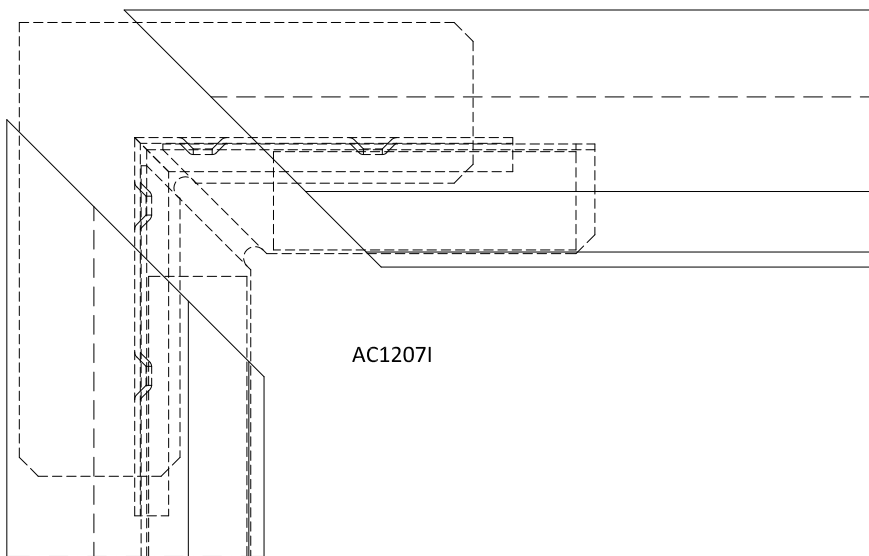
Sigillare tutte le superfici di contatto esterne con silicone o SL0019

 Rivetti svasati $\varnothing 4$

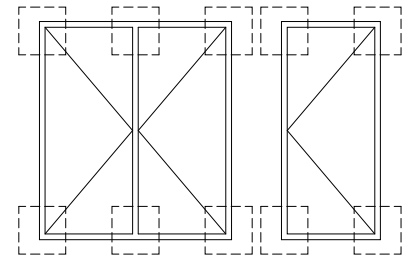
TIG welding with filler material in the areas indicated with +++++

Seal all the external contact surfaces with silicone our SL0019

 Countersunk rivets $\varnothing 4$




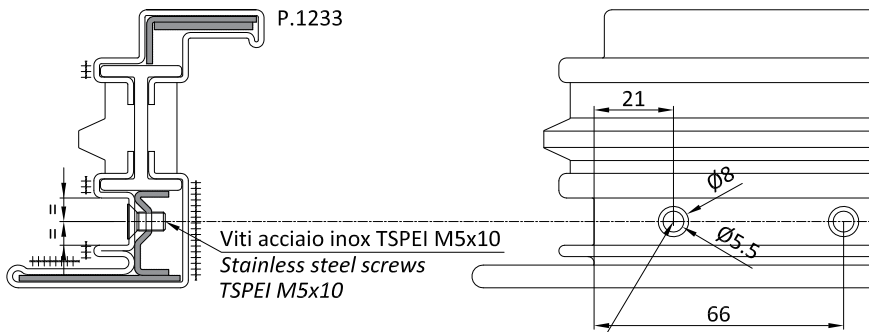
AC1207I



Saldare a TIG con materiale di riporto nelle zone indicate con +++++

Sigillare tutte le superfici di contatto esterne con silicone o SL0019

 Rivetti svasati $\varnothing 4$




P.1233


Viti acciaio inox TSPEI M5x10
Stainless steel screws
TSPEI M5x10


TIG welding with filler material in the areas indicated with +++++

Seal all the external contact surfaces with silicone our SL0019

 Countersunk rivets $\varnothing 4$


Fori imbutiti per Viti TSPEI M5x10 con stampo AT1233
Deep-drawn holes for TSPEI M5x10 screws with
mould AT1233


Saldare a TIG con materiale di riporto nelle zone indicate con 

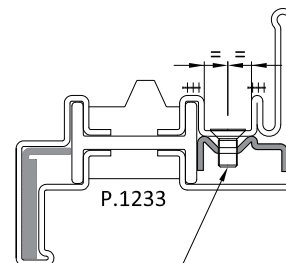
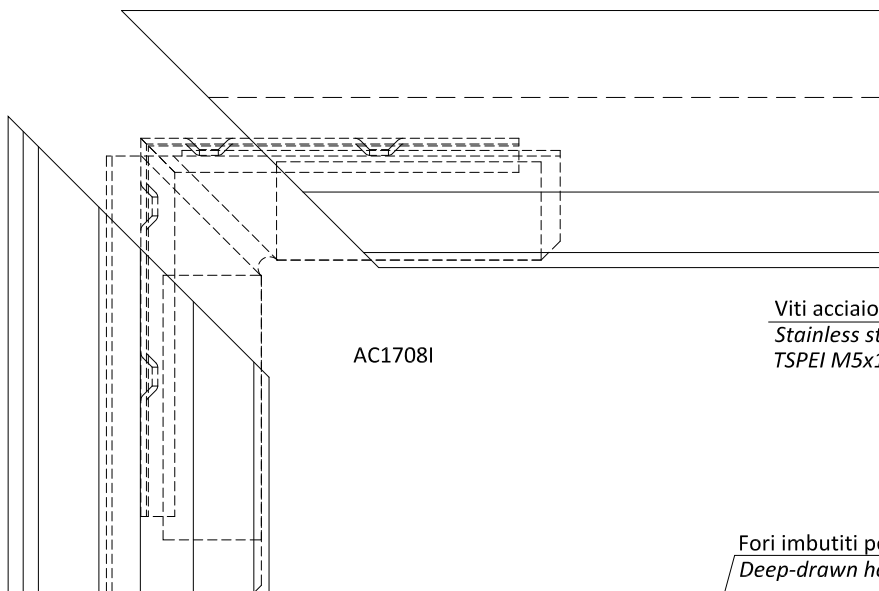
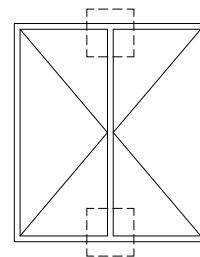
TIG welding with filler material in the areas indicated with 

Sigillare tutte le superfici di contatto esterne con silicone o SL0019

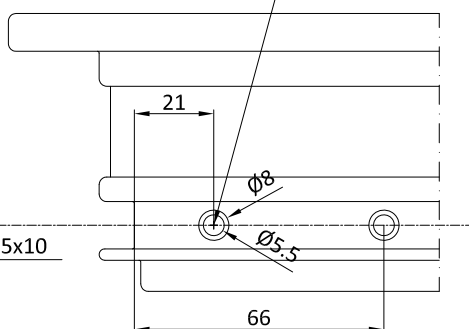
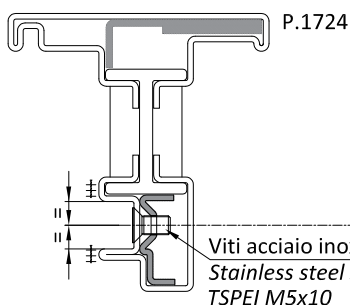
Seal all the external contact surfaces with silicone our SL0019

 Rivetti svasati $\varnothing 4$

 Countersunk rivets $\varnothing 4$

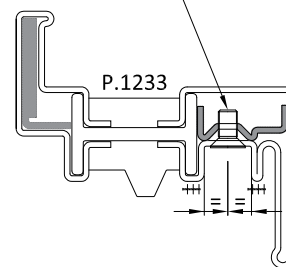
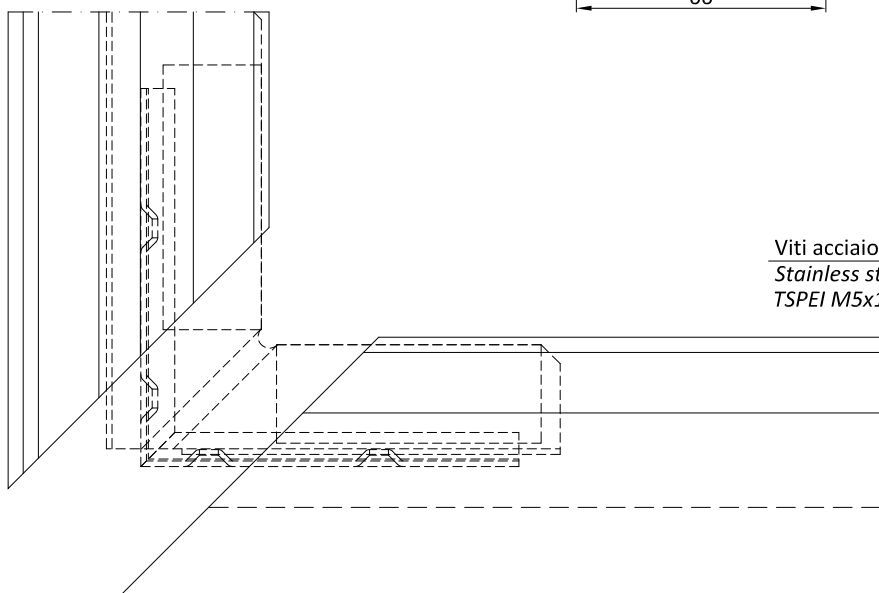


Viti acciaio inox TSPEI M5x10
Stainless steel screws
TSPEI M5x10

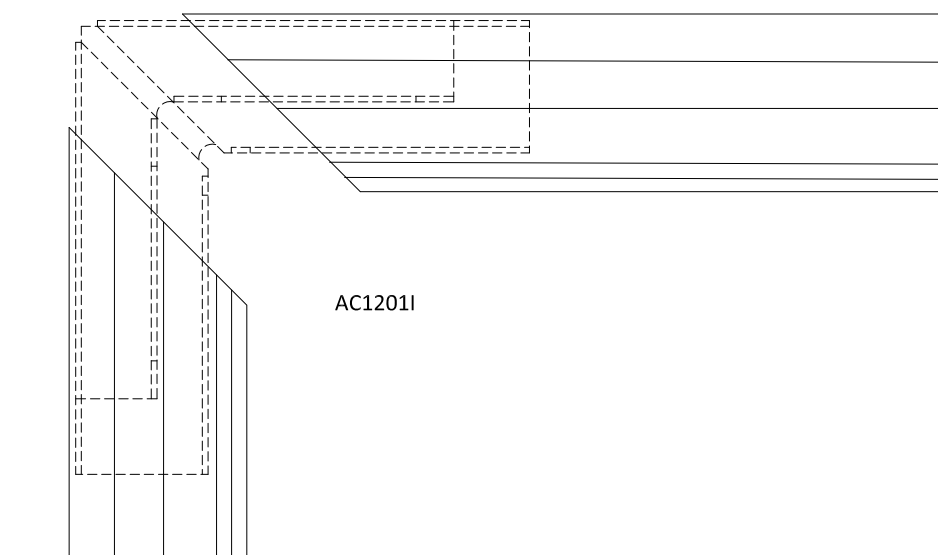


Fori imbutiti per Viti TSPEI M5x10 con stampo AT1233
Deep-drawn holes for TSPEI M5x10 screws with mould AT1233

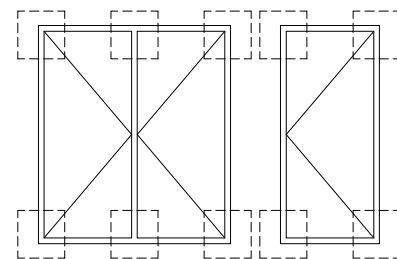
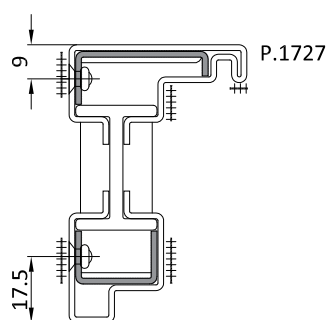
Viti acciaio inox TSPEI M5x10
Stainless steel screws
TSPEI M5x10



Viti acciaio inox TSPEI M5x10
Stainless steel screws
TSPEI M5x10




AC1201I




Saldare a TIG con materiale di riporto nelle zone indicate con +++++

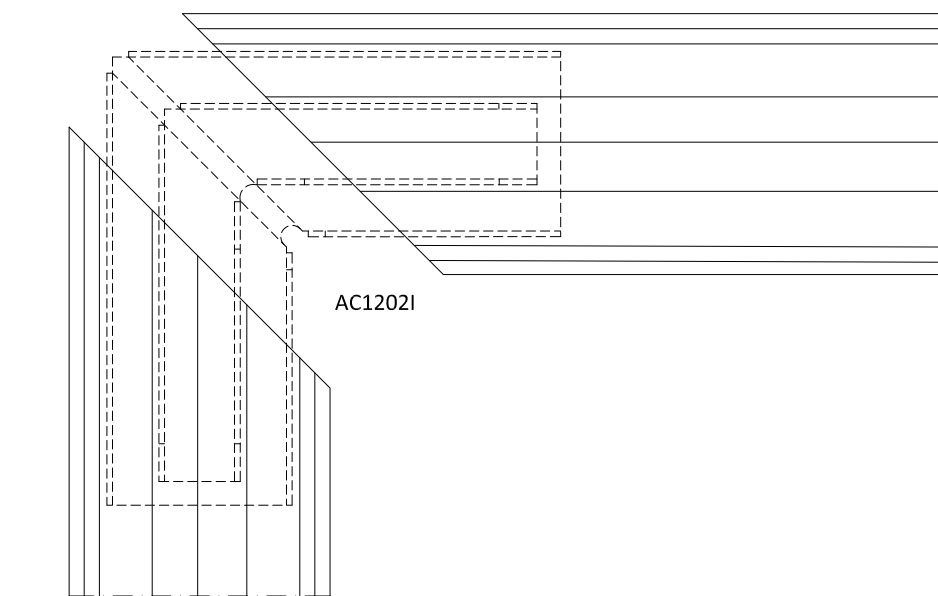
Sigillare tutte le superfici di contatto esterne con silicone o SL0019

 Rivetti svasati Ø 4

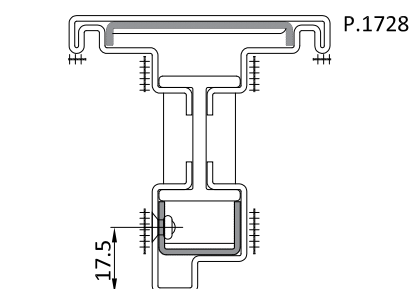
TIG welding with filler material in the areas indicated with +++++

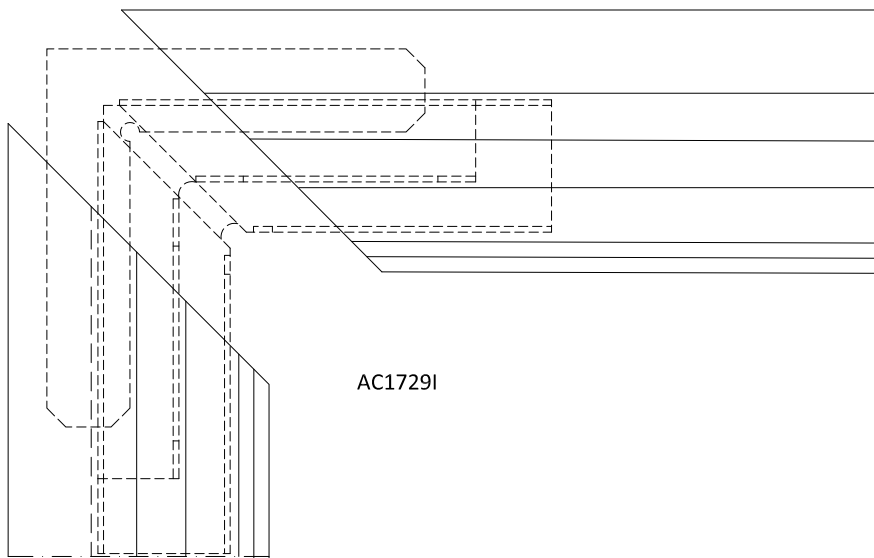
Seal all the external contact surfaces with silicone our SL0019

 Countersunk rivets Ø 4

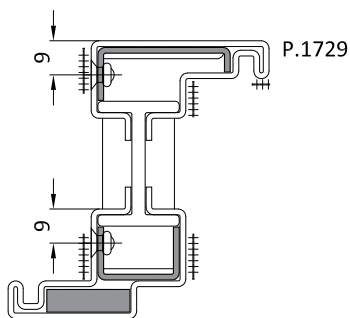


AC1202I

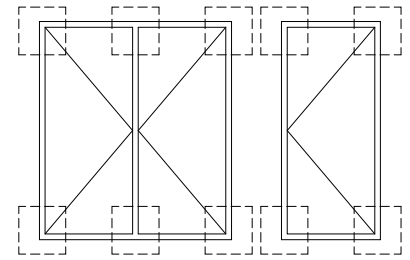




AC1729I




P.1729




Saldare a TIG con materiale di riporto nelle zone indicate con +++++

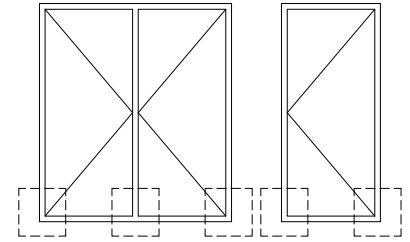
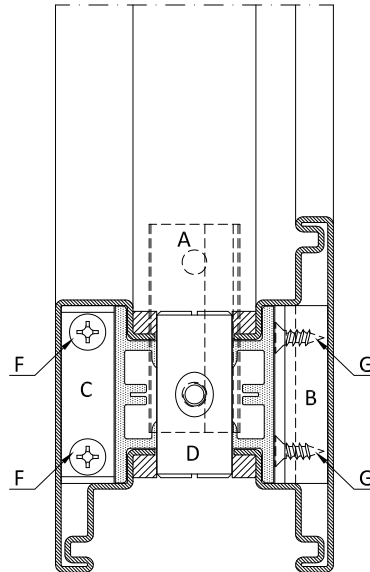
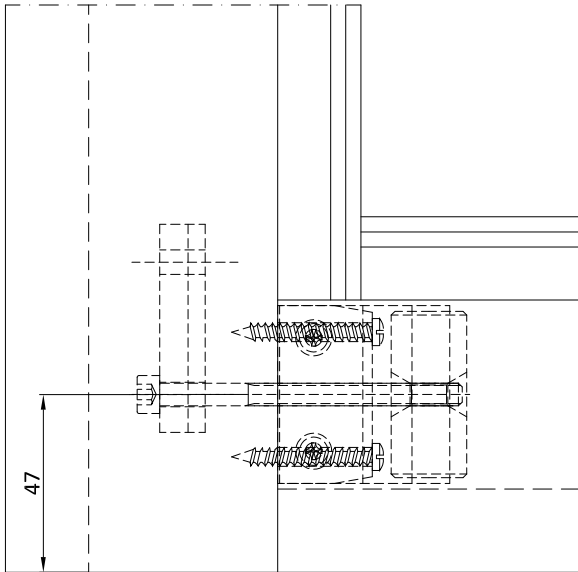
Sigillare tutte le superfici di contatto esterne con silicone o SL0019

 Rivetti svasati Ø 4

TIG welding with filler material in the areas indicated with +++++

Seal all the external contact surfaces with silicone our SL0019

 Countersunk rivets Ø 4



Saldare a TIG con materiale di riporto nelle zone indicate con

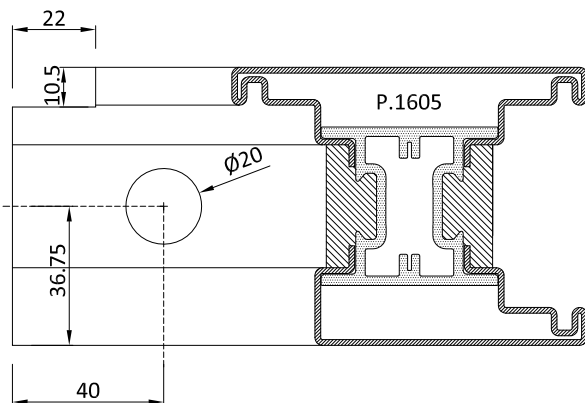
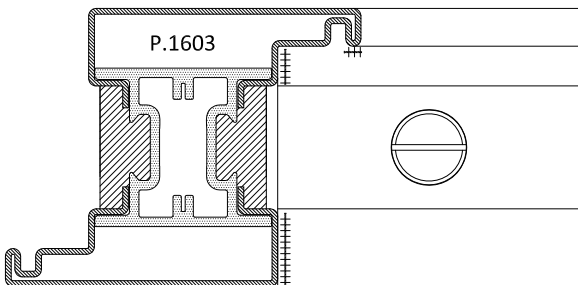
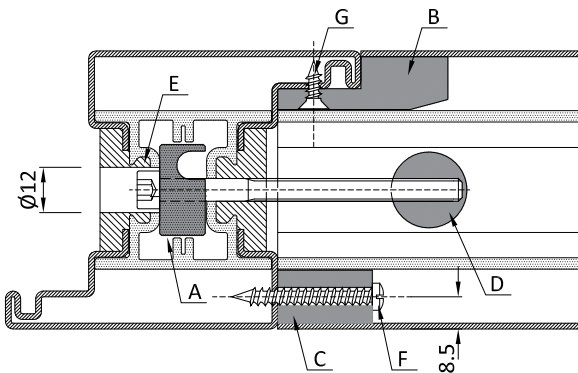
Sigillare tutte le superfici di contatto con silicone o SL0019

- A) Inserto di fissaggio
- B) Cavallotto di allineamento lato esterno
- C) Cavallotto di allineamento lato interno
- D) Tirante per cavallotto
- E) Vite acciaio inox TCEI M6x80
- F) Vite acciaio inox TC 4.8x38
- G) Vite autofilettante TSTC 3.9x9.5

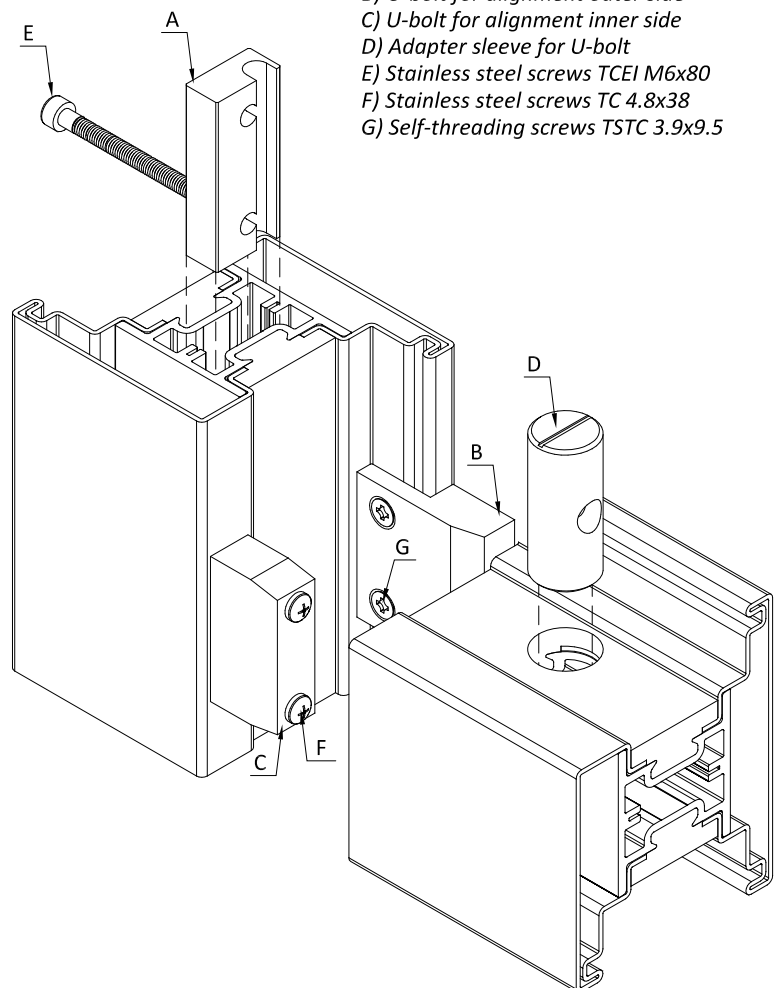
TIG welding with filler material in the areas indicated with

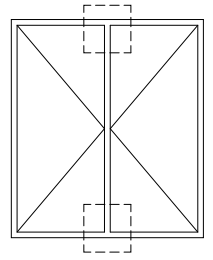
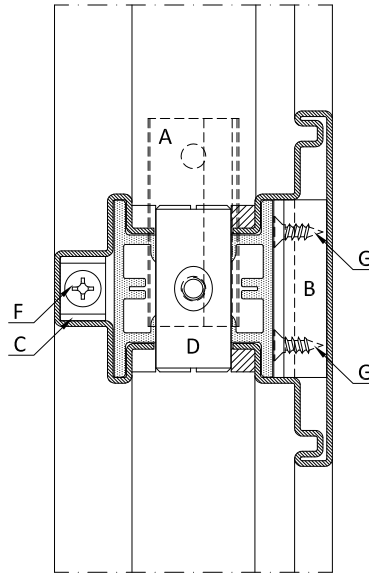
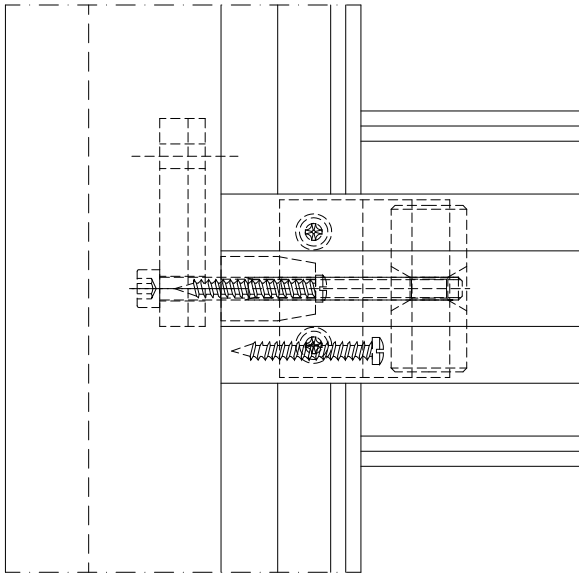
Seal all the external contact surfaces with silicone or SL0019


- A) Anchoring insert
- B) U-bolt for alignment outer side
- C) U-bolt for alignment inner side
- D) Adapter sleeve for U-bolt
- E) Stainless steel screws TCEI M6x80
- F) Stainless steel screws TC 4.8x38
- G) Self-threading screws TSTC 3.9x9.5



Lavorazione valida per profili P.1601 - P.1602 - 1605
Tooling valid for profiles P.1601 - P.1602 - P.1605






Saldare a TIG con materiale di riporto nelle zone indicate con 

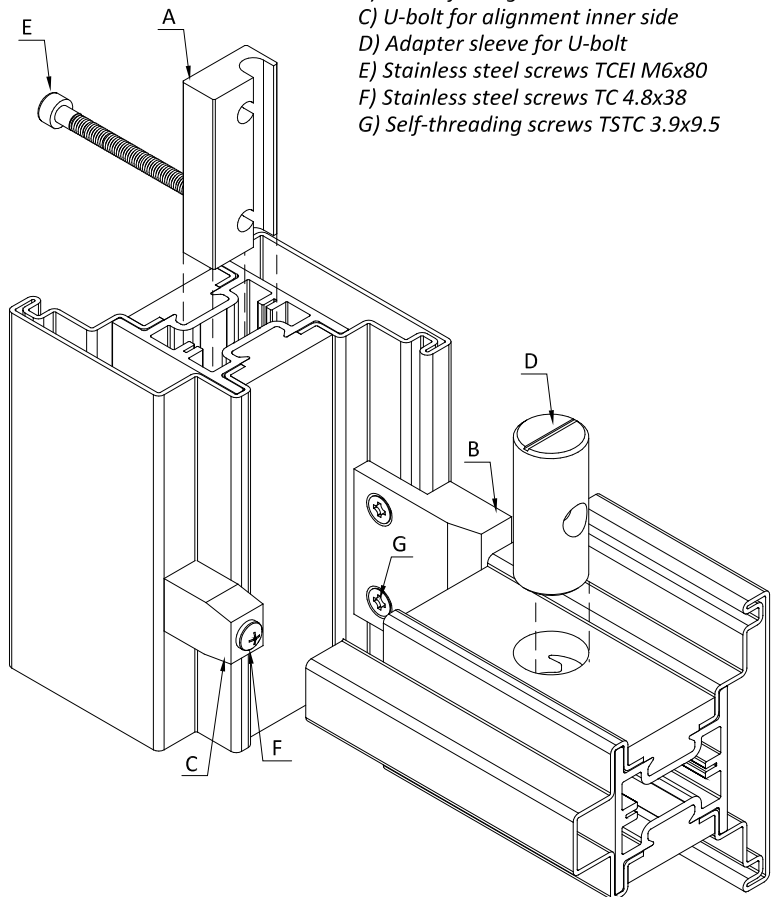
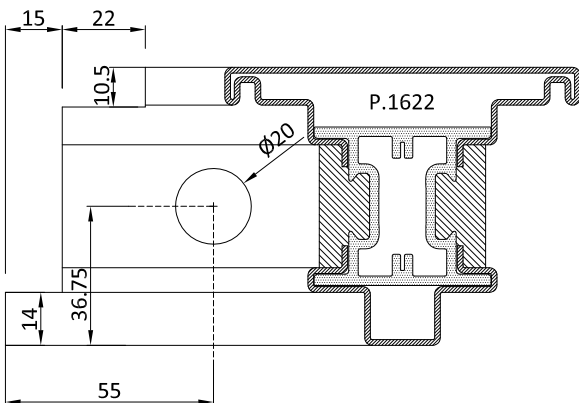
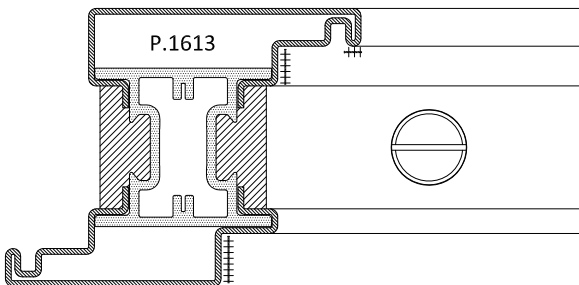
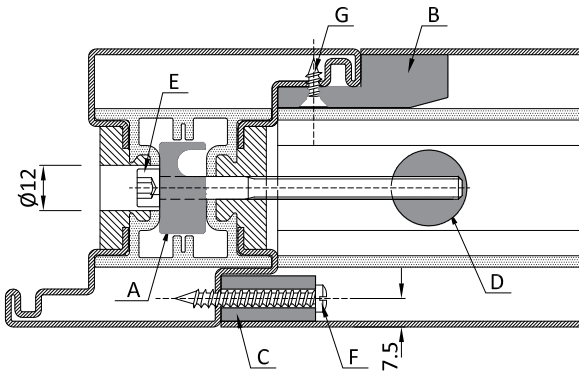
Sigillare tutte le superfici di contatto con silicone o SL0019

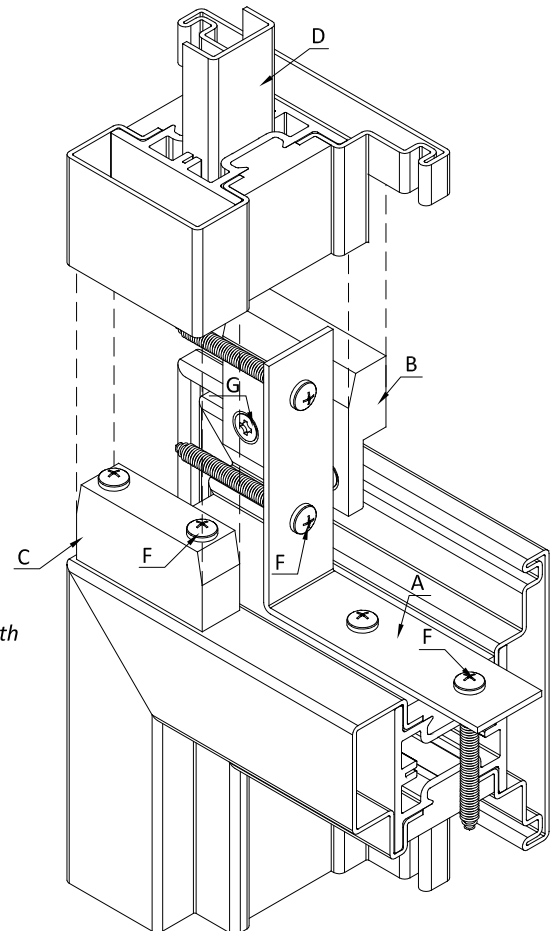
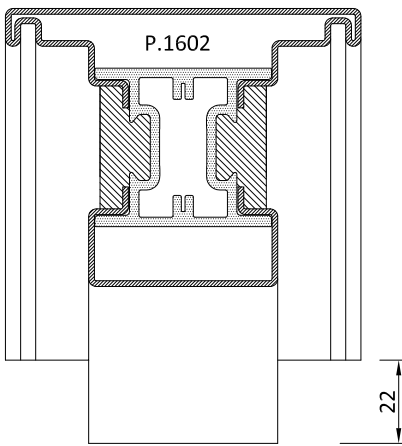
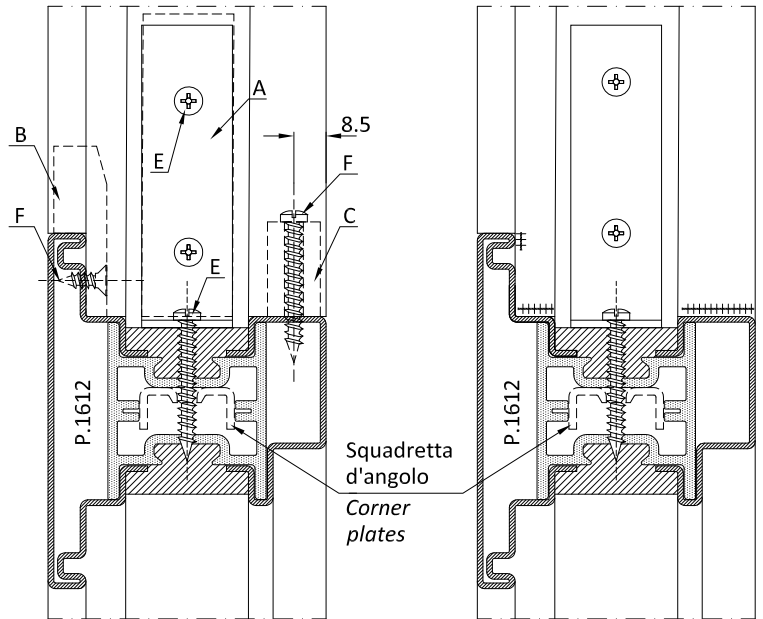
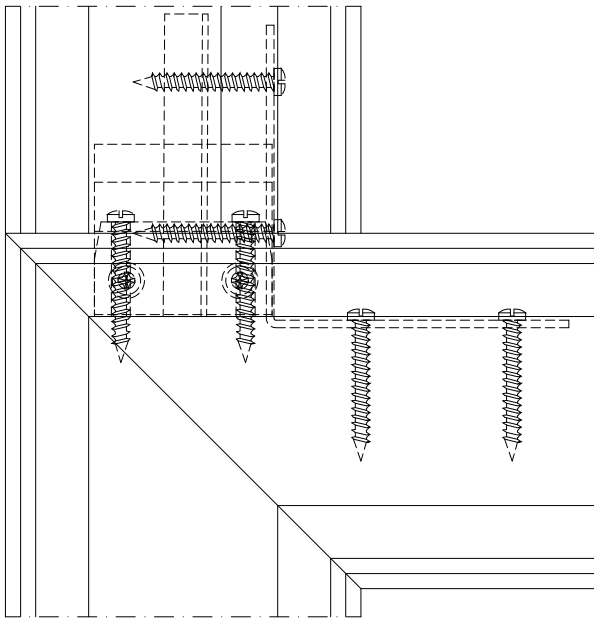
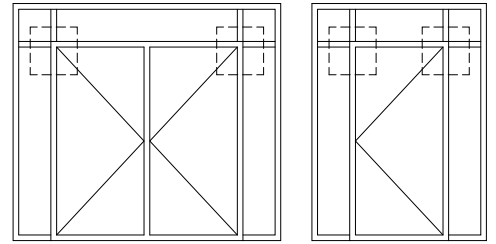
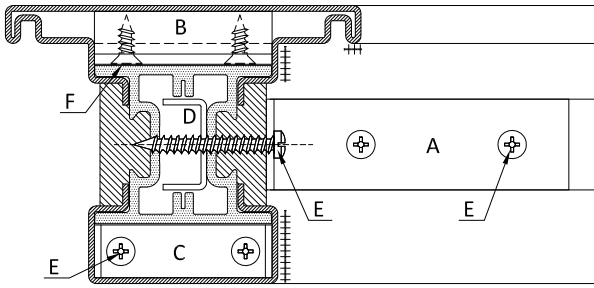
- A) Inserto di fissaggio
- B) Cavallotto di allineamento lato esterno
- C) Cavallotto di allineamento lato interno
- D) Tirante per cavallotto
- E) Vite acciaio inox TCEI M6x80
- F) Vite acciaio inox TC 4.8x38
- G) Vite autofilettante TSTC 3.9x9.5

TIG welding with filler material in the areas indicated with 

Seal all the external contact surfaces with silicone or SL0019

- A) Anchoring insert
- B) U-bolt for alignment outer side
- C) U-bolt for alignment inner side
- D) Adapter sleeve for U-bolt
- E) Stainless steel screws TCEI M6x80
- F) Stainless steel screws TC 4.8x38
- G) Self-threading screws TSTC 3.9x9.5





Saldare a TIG con materiale di riporto nelle zone indicate con +++++

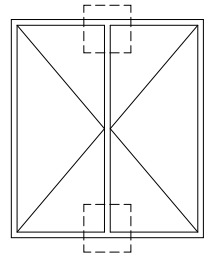
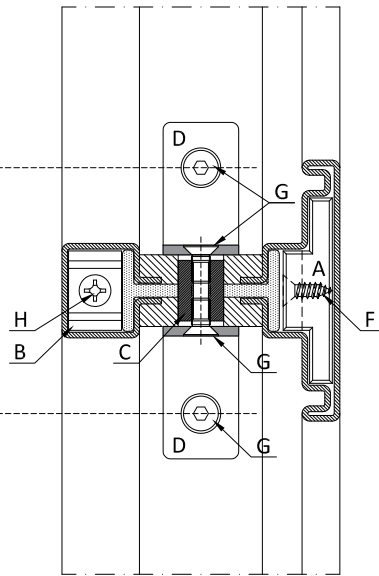
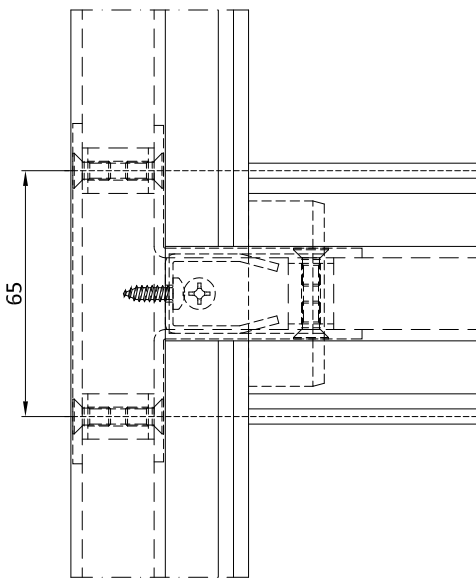
TIG welding with filler material in the areas indicated with +++++

Sigillare tutte le superfici di contatto con silicone o SL0019

Seal all the external contact surfaces with silicone or SL0019

- A) Squadretta giunzione 90°
- B) Cavallotto di allineamento lato esterno
- C) Cavallotto di allineamento lato interno
- D) Rinforzo interno
- E) Vite acciaio inox TC 4.8x38
- F) Vite autofilettante TSTC 3.9x9.5

- A) Corner bracket 90°
- B) U-bolt for alignment outer side
- C) U-bolt for alignment inner side
- D) Internal reinforcement
- E) Stainless steel screws TC 4.8x38
- F) Self-threading screws TSTC 3.9x9.5



Saldare a TIG con materiale di riporto nelle zone indicate con

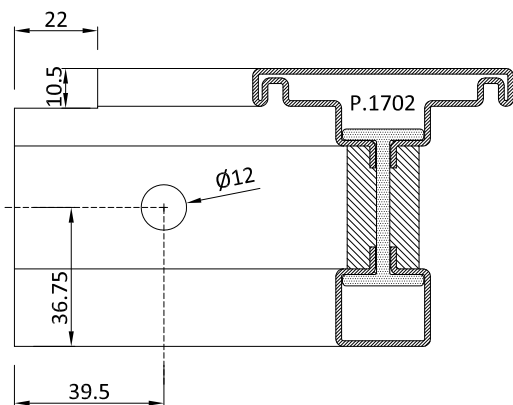
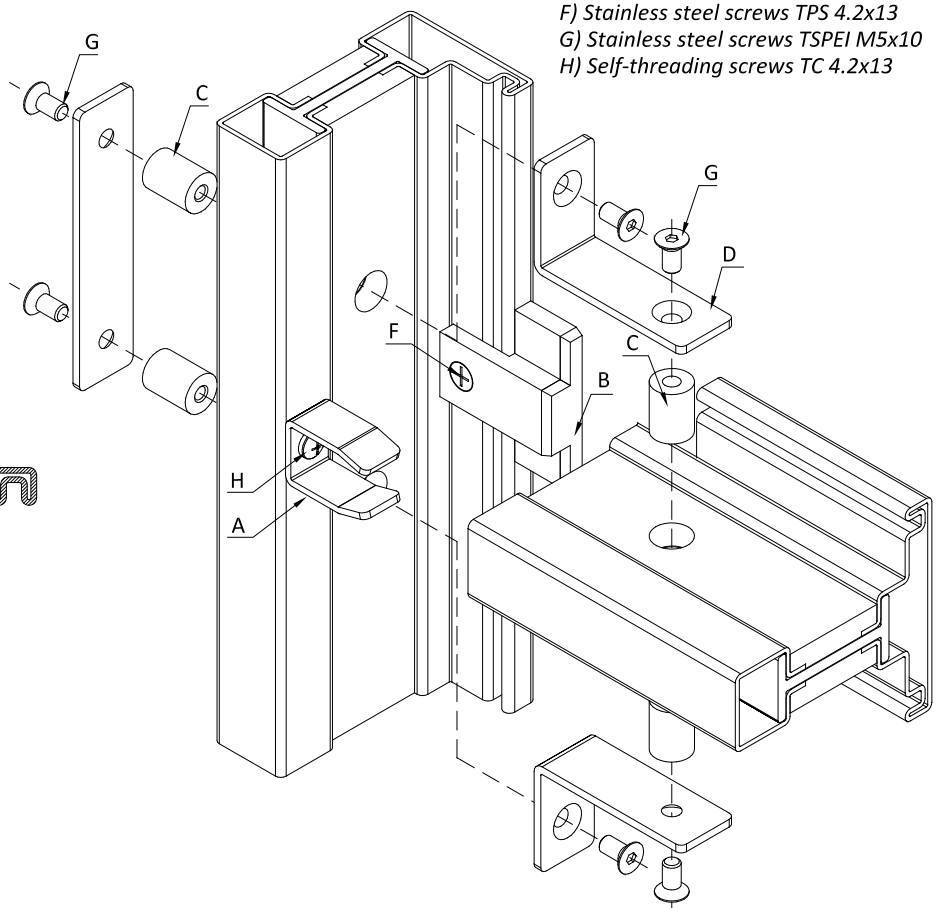
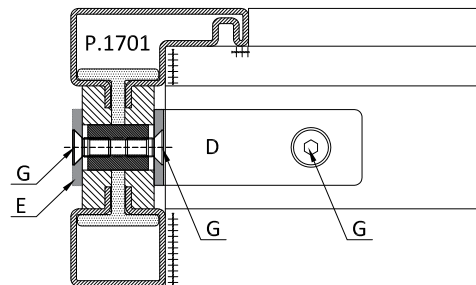
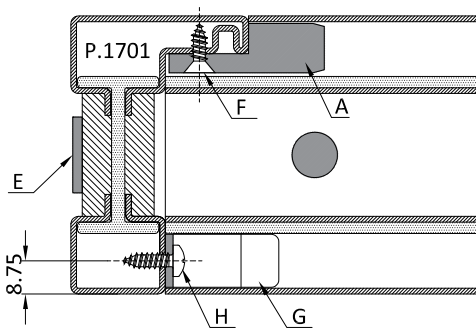
Sigillare tutte le superfici di contatto con silicone o SL0019

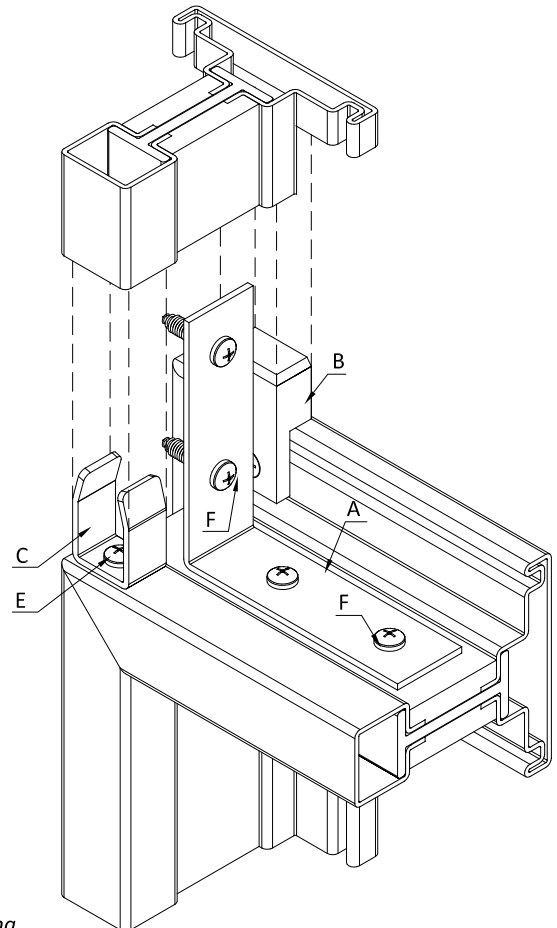
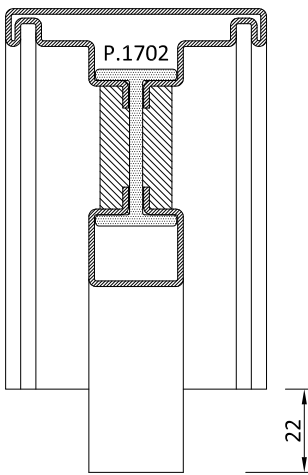
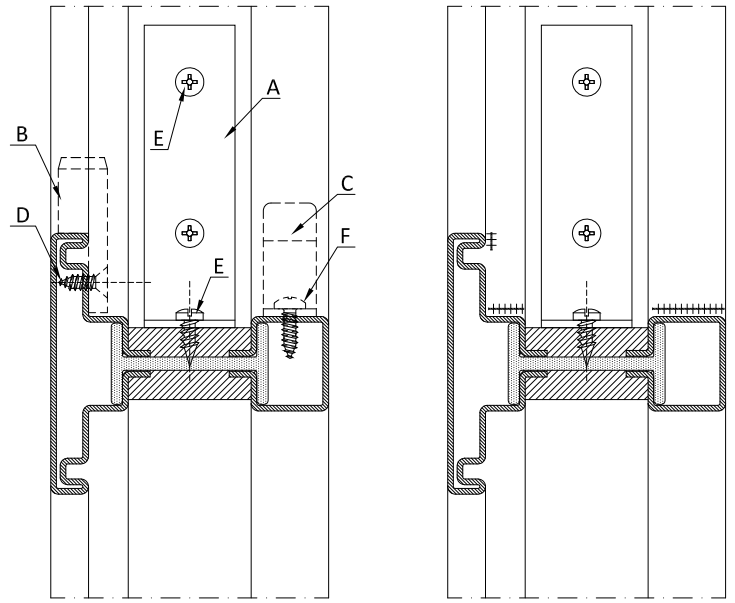
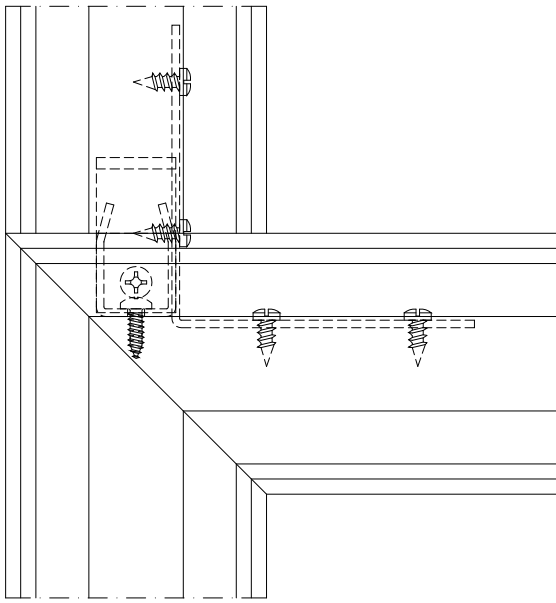
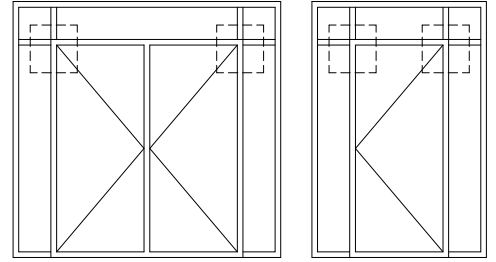
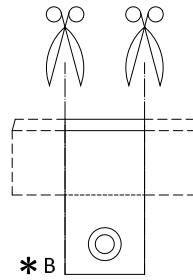
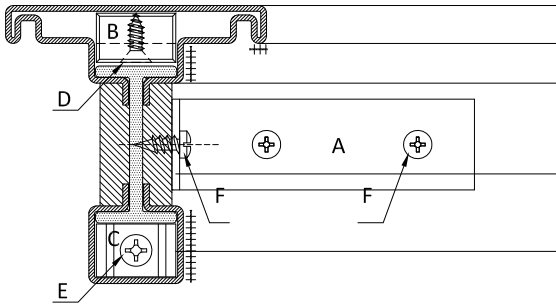
- A) Cavallotto di allineamento lato interno
- B) Cavallotto di allineamento lato esterno
- C) Bussola filettata
- D) Squadretta di tiraggio
- E) Piastrina di fissaggio
- F) Vite acciaio inox TPS 4.2x13
- G) Vite acciaio inox TSPEI M5x10
- H) Vite autofilettante TC 4.2x13

TIG welding with filler material in the areas indicated with

Seal all the external contact surfaces with silicone or SL0019

- A) U-bolt for alignment inner side
- B) U-bolt for alignment outer side
- C) Threaded bush
- D) Corner bracket
- E) Fixing plate
- F) Stainless steel screws TPS 4.2x13
- G) Stainless steel screws TSPEI M5x10
- H) Self-threading screws TC 4.2x13





Saldare a TIG con materiale di riporto nelle zone indicate con +++++

TIG welding with filler material in the areas indicated with +++++

Sigillare tutte le superfici di contatto con silicone o SL0019

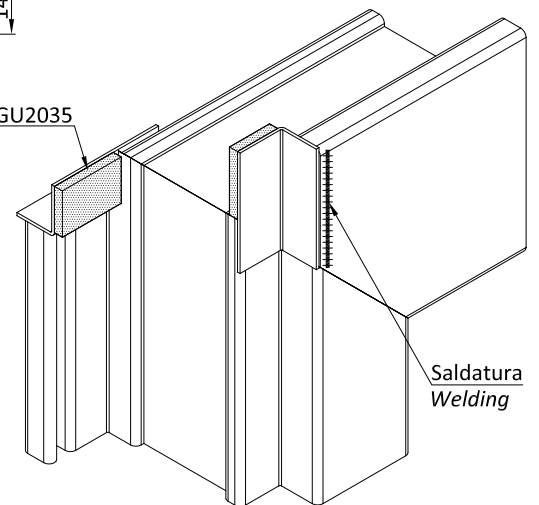
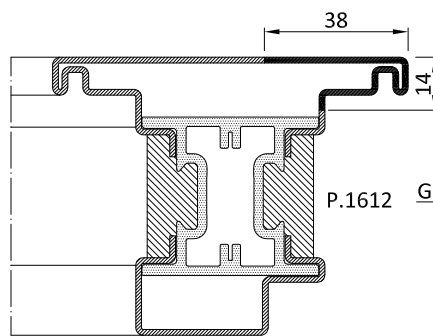
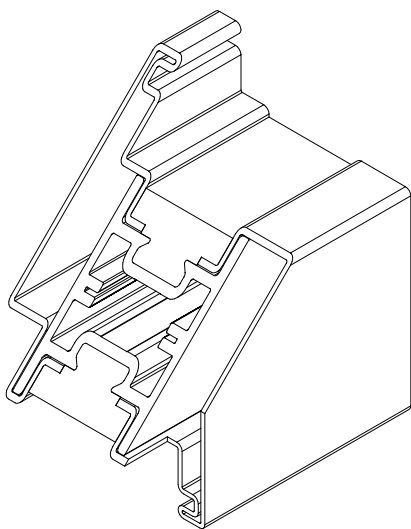
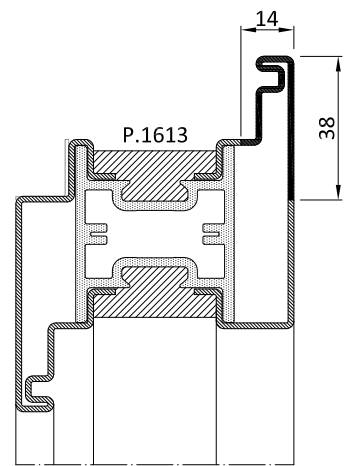
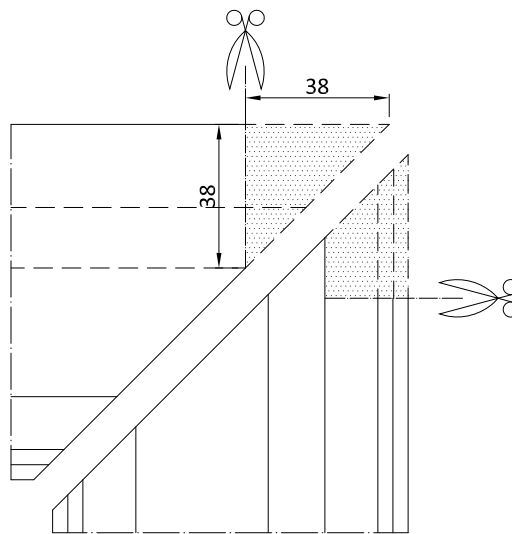
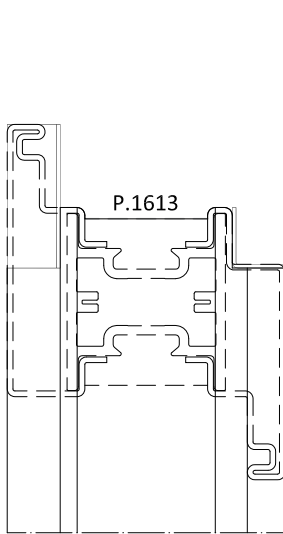
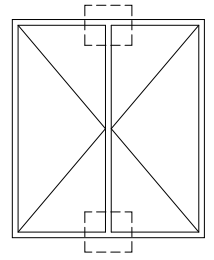
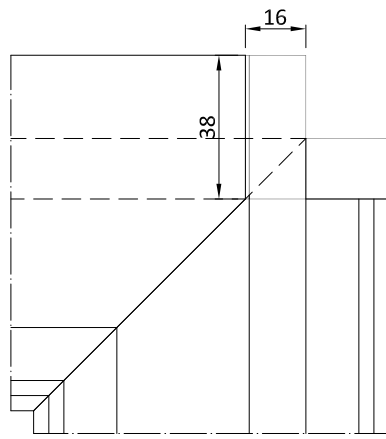
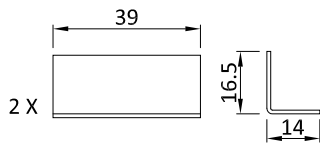
Seal all the external contact surfaces with silicone or SL0019

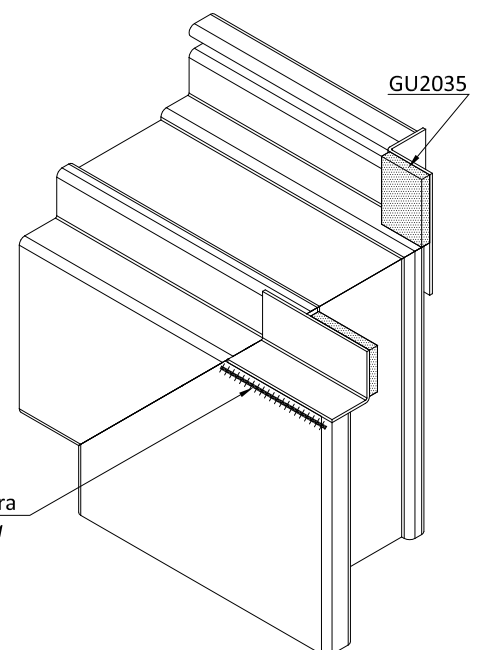
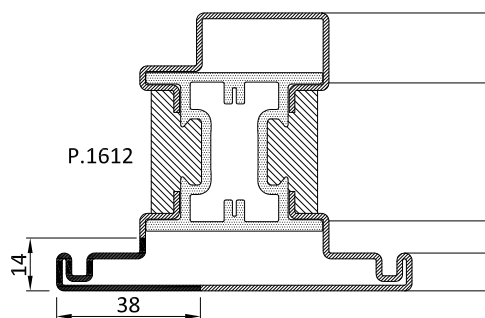
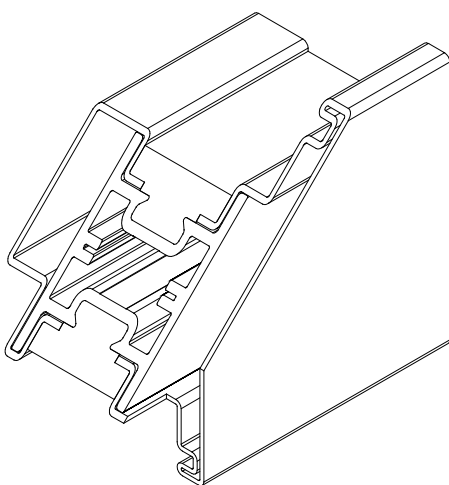
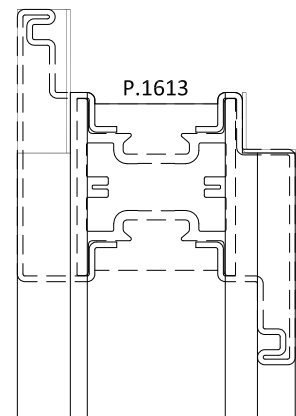
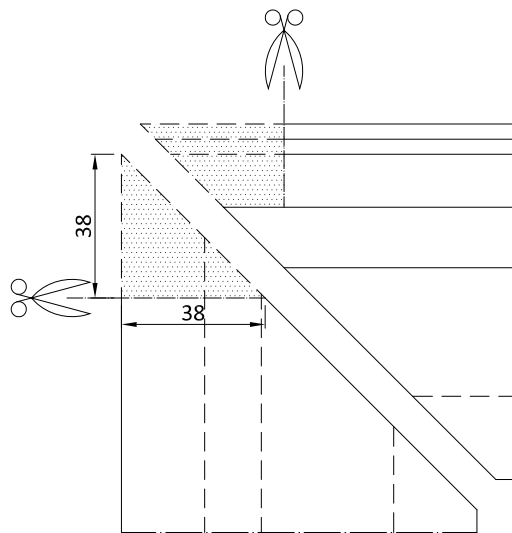
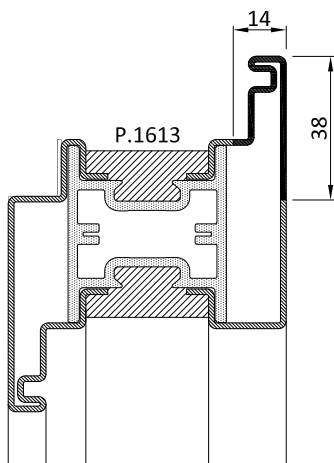
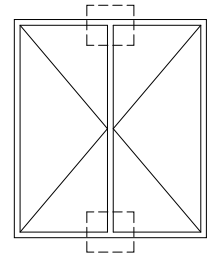
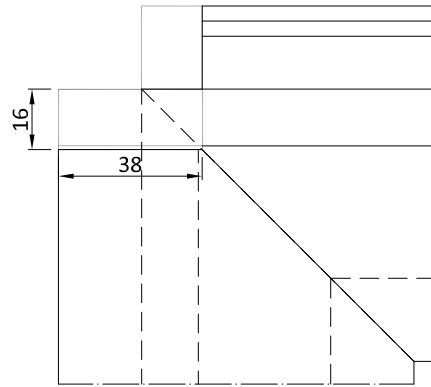
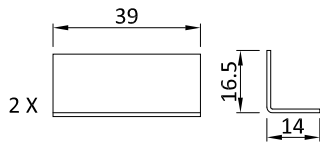
- A) Squadretta giunzione 90°
- B) Cavallo di allineamento lato esterno
- C) Cavallo di allineamento lato interno
- D) Vite acciaio inox TPS 4.2x13
- E) Vite autofilettante TC 4.2x12.7
- F) Vite autofilettante TE 4.8x20

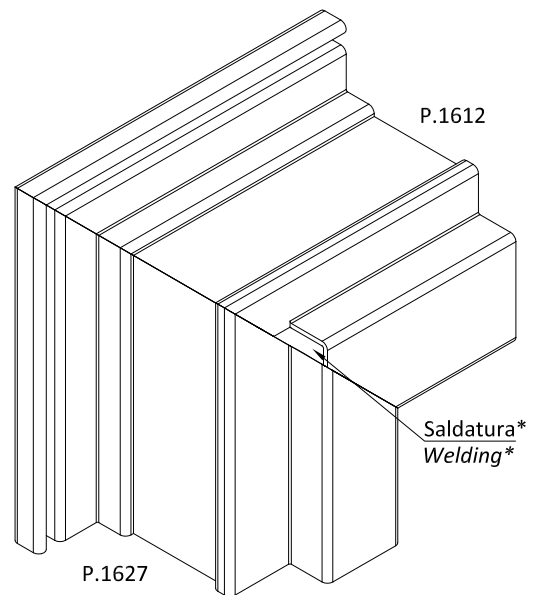
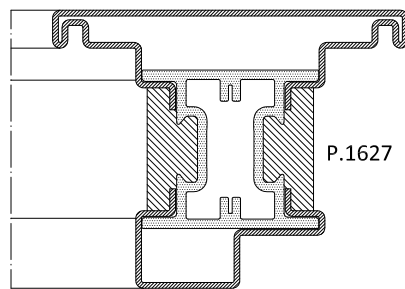
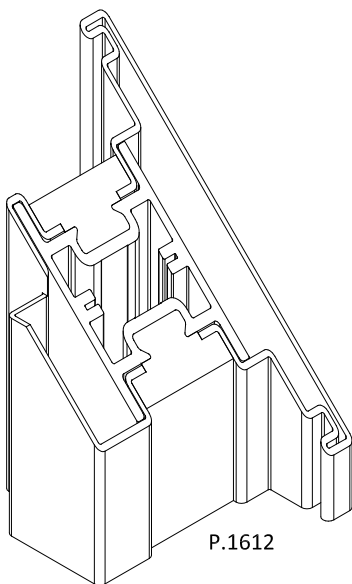
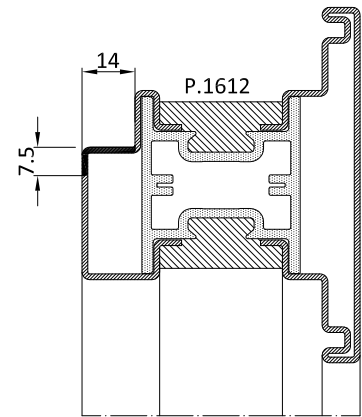
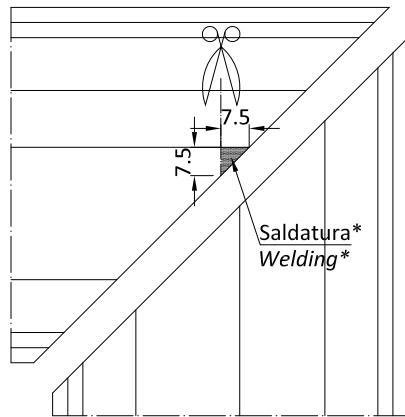
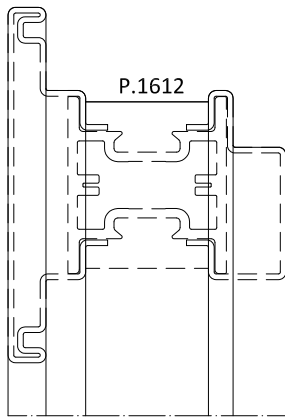
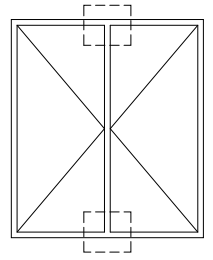
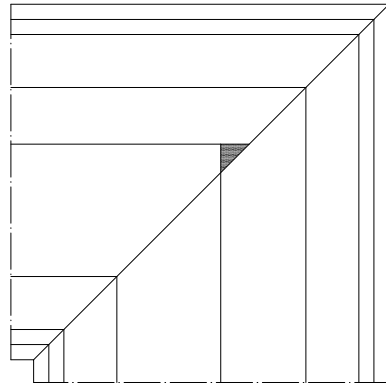
- A) Corner bracket 90°
- B) U-bolt for alignment outer side
- C) U-bolt for alignment inner side
- D) Stainless steel screws TPS 4.2x13
- E) Self-threading screws TC 4.2x12.7
- F) Self-threading screws TE 4.8x20

* Tagliare le alette del cavallo B come da disegno

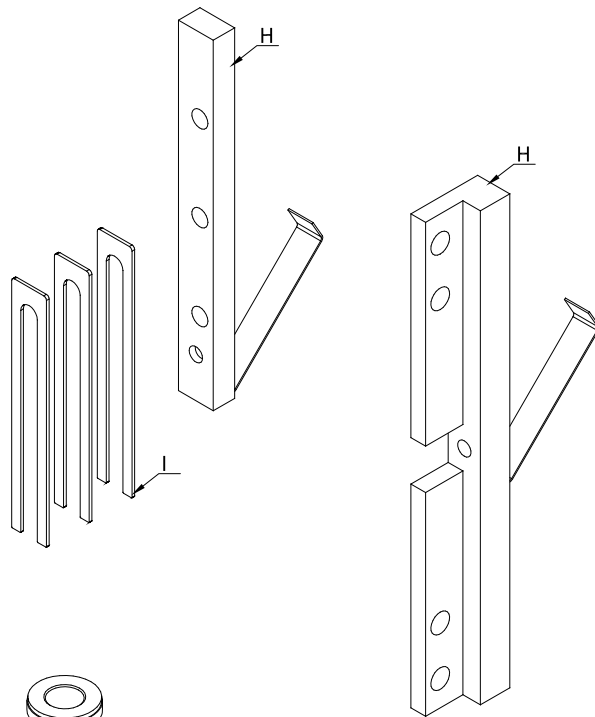
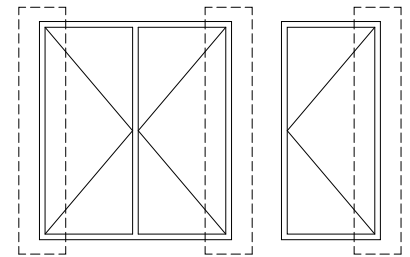
* Angles of U-connection piece B have to be cut according the drawing





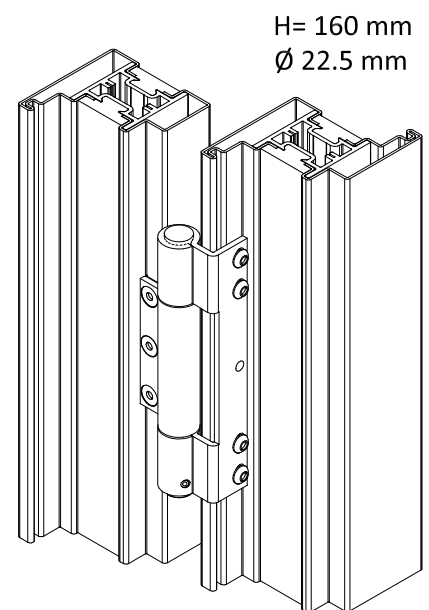
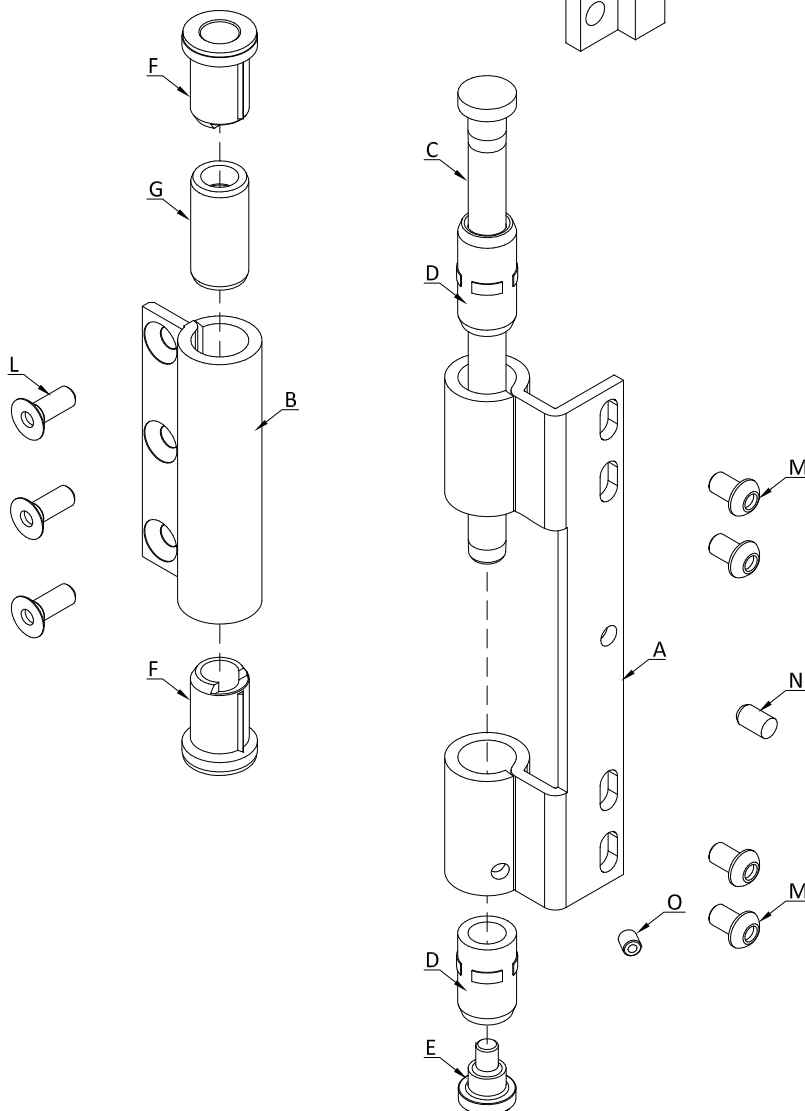


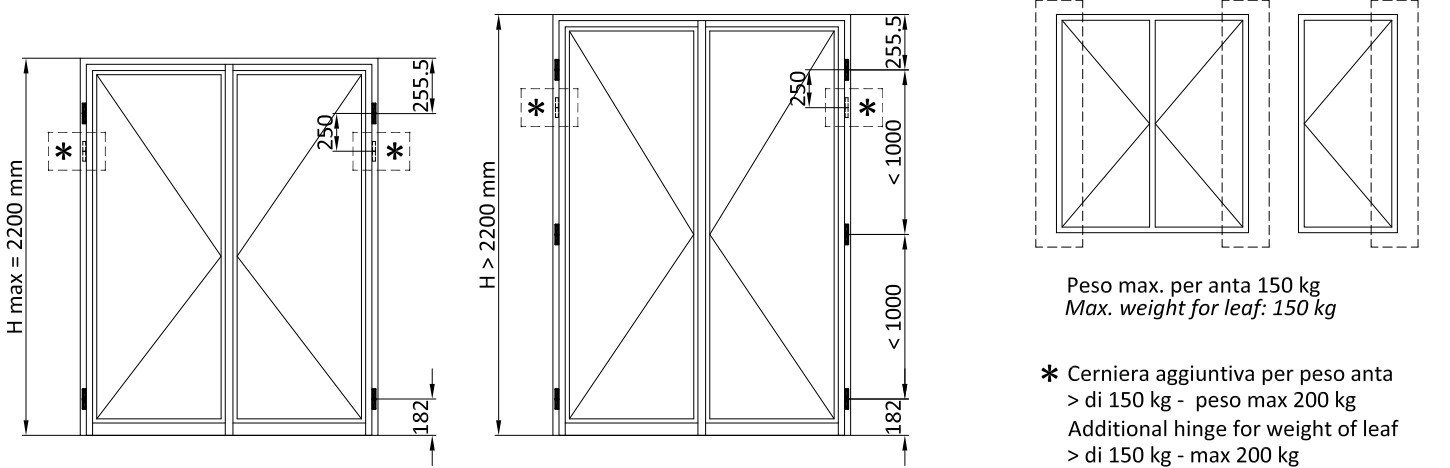
* Saldare con materiale di riporto
* Welding with filler material



- A) Corpo cerniera A
- B) Corpo cerniera B
- C) Perno
- D) Distanziatore
- E) Tappo a vite
- F) Boccola antifrizione
- G) Distanziatore
- H) Rinforzi interni
- I) Distanziale di regolazione
- L) Viti acciaio inox TSPEI M6 x 16
- M) Vite acciaio inox testa a bottone M6 x 10
- N) Spina inox Ø 6 x 10 da inserire dopo la regolazione dell'anta
- O) Grano M5 x 6

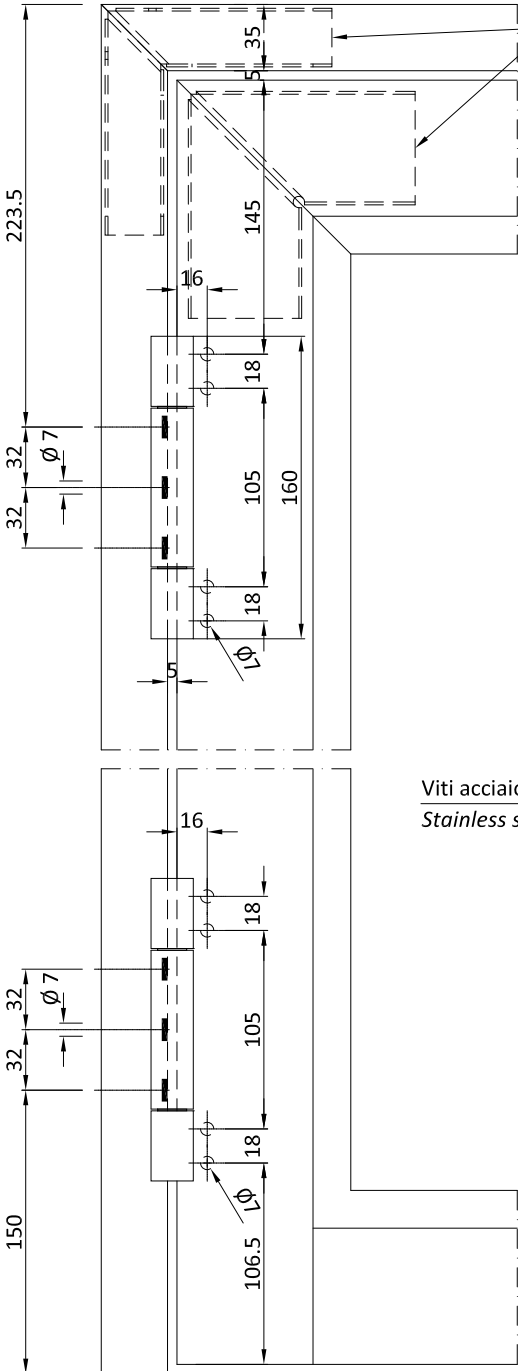
- A) Body of the hinge A
- B) Body of the hinge B
- C) Pin
- D) Spacer
- E) Screw cap
- F) Antifriction bushing
- G) Spacer
- H) Internal reinforcements
- I) Regulating spacer
- L) Stainless steel screws TSPEI M6 x 16
- M) Stainless steel button head screws M6 x 10
- N) Stainless steel pin Ø 6 x 10 to insert after regulating the leaf
- O) Dowel M5x6





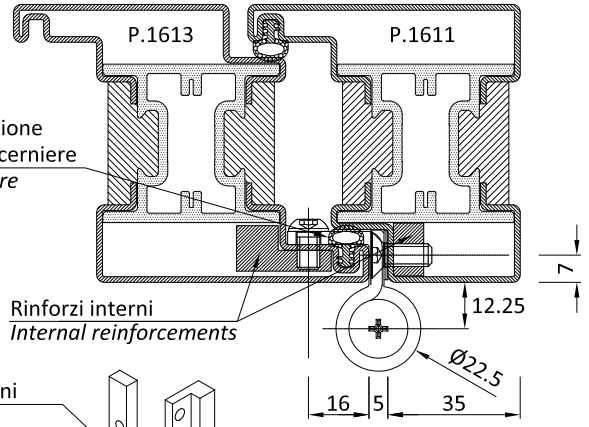
Peso max. per anta 150 kg
Max. weight for leaf: 150 kg

* Cerniera aggiuntiva per peso anta > di 150 kg - peso max 200 kg
Additional hinge for weight of leaf > di 150 kg - max 200 kg



Squadrette angolo
Corner plates

GE1001TT - tagliare la guarnizione dove interseca le cerniere
GE1001TT - cut the gasket where the hinges cross



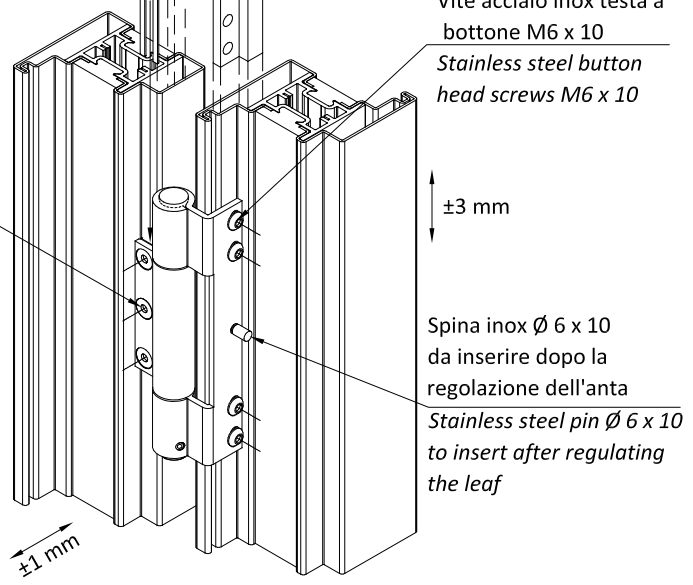
Rinforzi interni
Internal reinforcements

Distanziale di regolazione
Regulating spacer

Rinforzi interni
Internal reinforcements

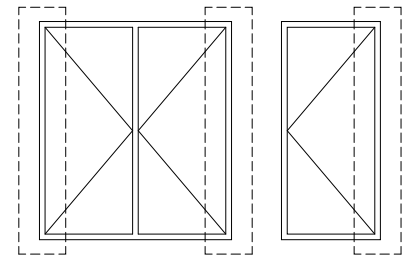
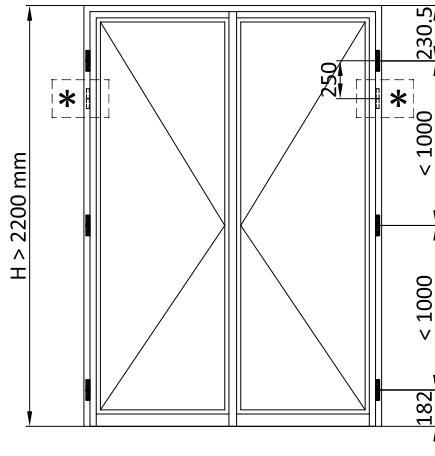
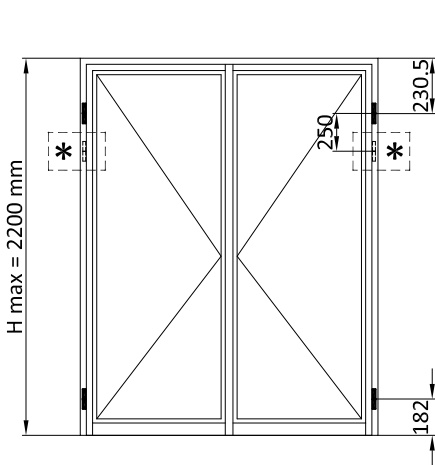
Vite acciaio inox testa a bottone M6 x 10
Stainless steel button head screws M6 x 10

Viti acciaio inox TSPEI M6 x 16
Stainless steel screws TSPEI M6 x 16



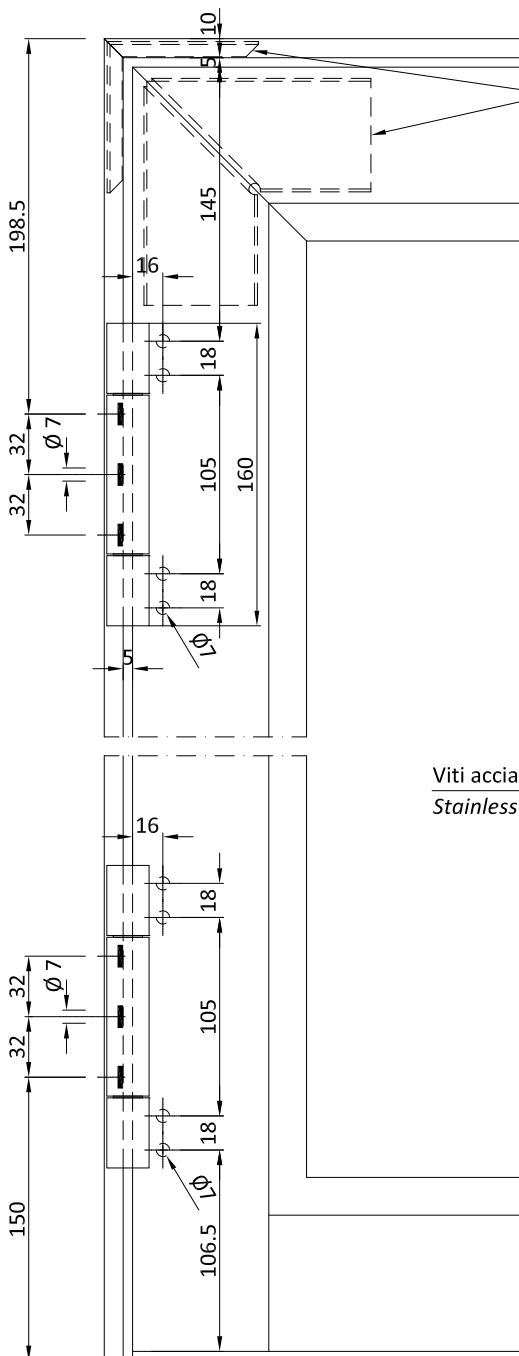
Spina inox Ø 6 x 10 da inserire dopo la regolazione dell'anta
Stainless steel pin Ø 6 x 10 to insert after regulating the leaf

- La lavorazione può essere effettuata anche in posizioni intermedie dell'altezza della porta.
- La lavorazione SX è speculare alla DX.
- La lavorazione è valida anche per le aperture esterne.
- Tooling can also be carried out in intermediate positions.
- Tooling is the same on the right and on the left.
- Tooling can be done also on external openings.



Peso max. per anta 150 kg
Max. weight for leaf: 150 kg

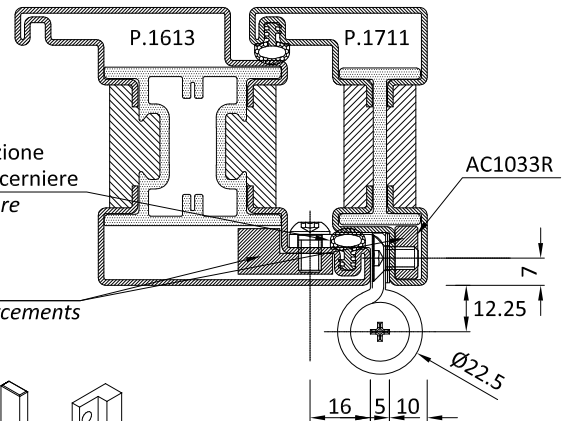
* Cerniera aggiuntiva per peso anta > di 150 kg - peso max 200 kg
Additional hinge for weight of leaf > di 150 kg - max 200 kg



Squadrette angolo
Corner plates

GE1001TT - tagliare la guarnizione dove interseca le cerniere
GE1001TT - cut the gasket where the hinges cross

Rinforzi interni
Internal reinforcements



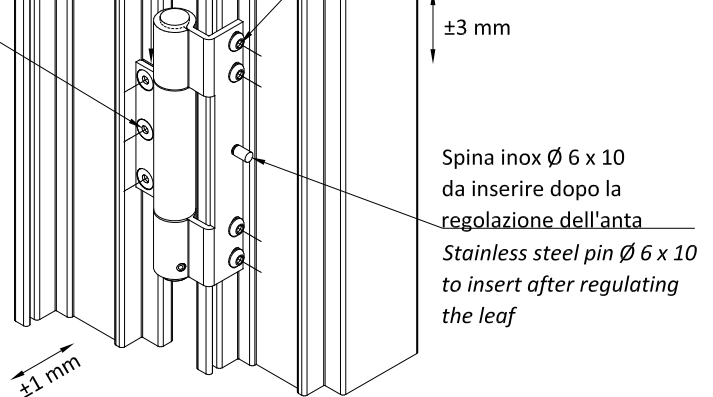
AC1033/R

Distanziale di regolazione
Regulating spacer

Rinforzi interni
Internal stiffeners

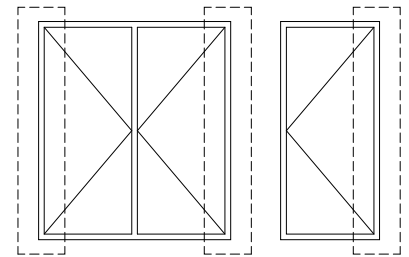
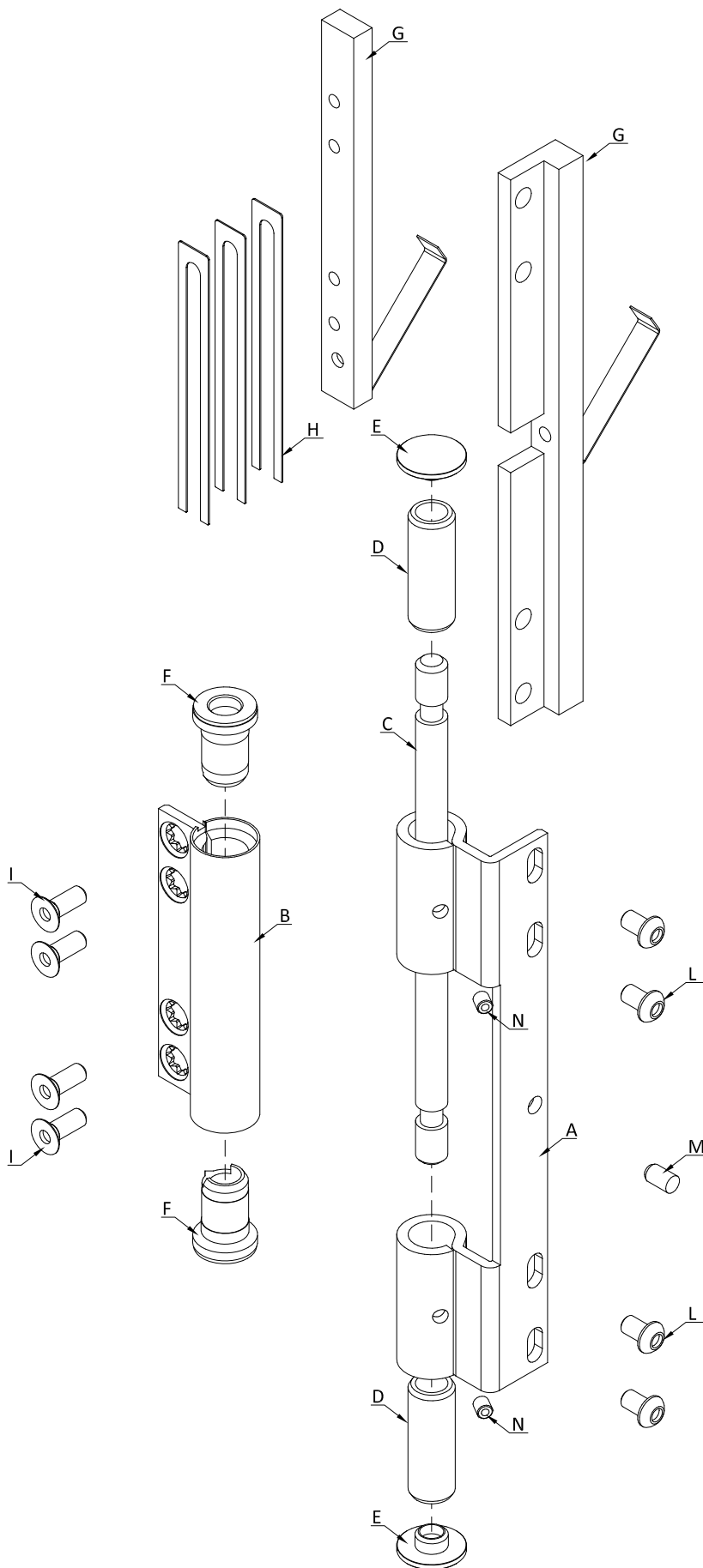
Vite acciaio inox testa a bottone M6 x 10
Stainless steel button head screws M6 x 10

Viti acciaio inox TSPEI M6 x 16
Stainless steel screws TSPEI M6 x 16



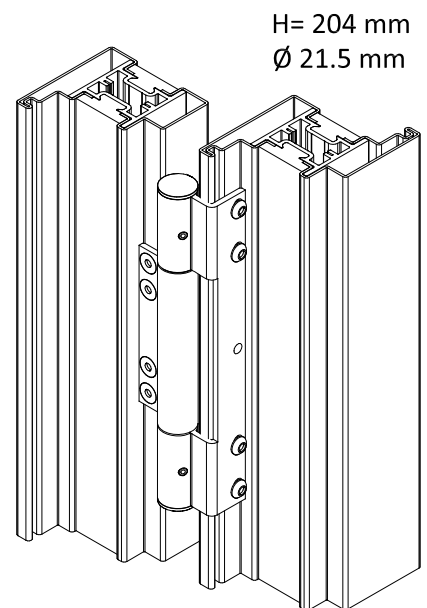
Spina inox Ø 6 x 10 da inserire dopo la regolazione dell'anta
Stainless steel pin Ø 6 x 10 to insert after regulating the leaf

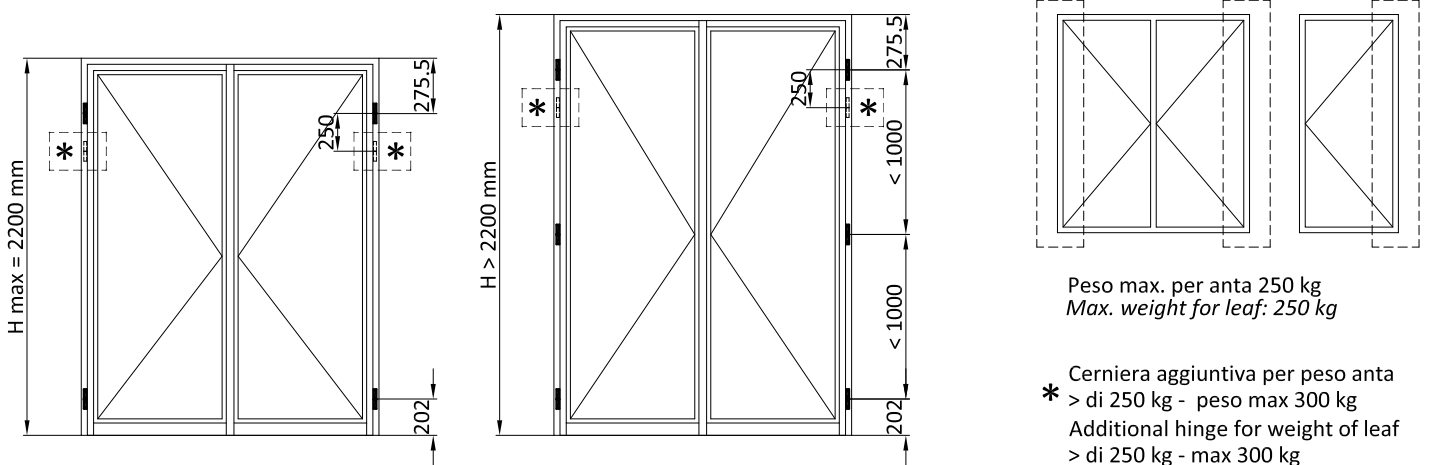
- La lavorazione può essere effettuata anche in posizioni intermedie dell'altezza della porta.
- La lavorazione SX è speculare alla DX.
- La lavorazione è valida anche per le aperture esterne.
- Tooling can also be carried out in intermediate positions.
- Tooling is the same on the right and on the left.
- Tooling can be done also on external openings.



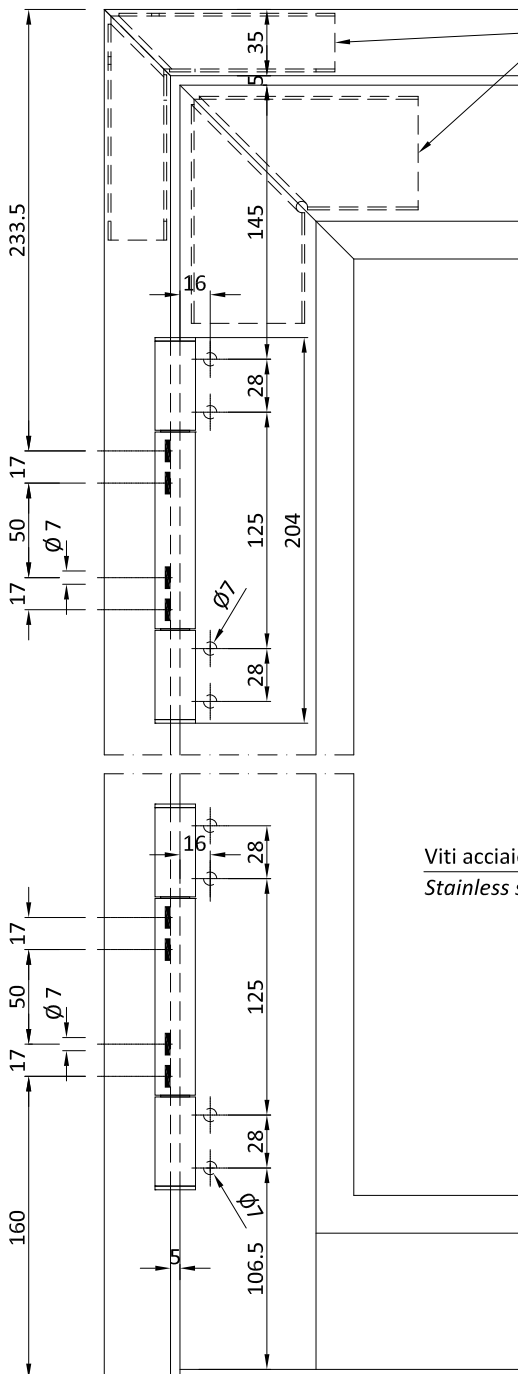
- A) Corpo cerniera A
- B) Corpo cerniera B
- C) Perno
- D) Distanziatore
- E) Tappo di finitura
- F) Boccola antifrizione
- G) Rinforzi interni
- H) Distanziale di regolazione
- I) Viti acciaio inox TSPEI M6 x 16
- L) Vite acciaio inox testa a bottone M6 x 10
- M) Spina inox $\varnothing 6 \times 10$ da inserire dopo la regolazione dell'anta
- N) Grano M5 x 6

- A) Body of the hinge A
- B) Body of the hinge B
- C) Pin
- D) Spacer
- E) Ending cap
- F) Antifriction bushing
- G) Internal reinforcements
- H) Regulating spacer
- I) Stainless steel screws TSPEI M6 x 16
- L) Stainless steel button head screws M6 x 10
- M) Stainless steel pin $\varnothing 6 \times 10$ to insert after regulating the leaf
- N) Dowel M5x6



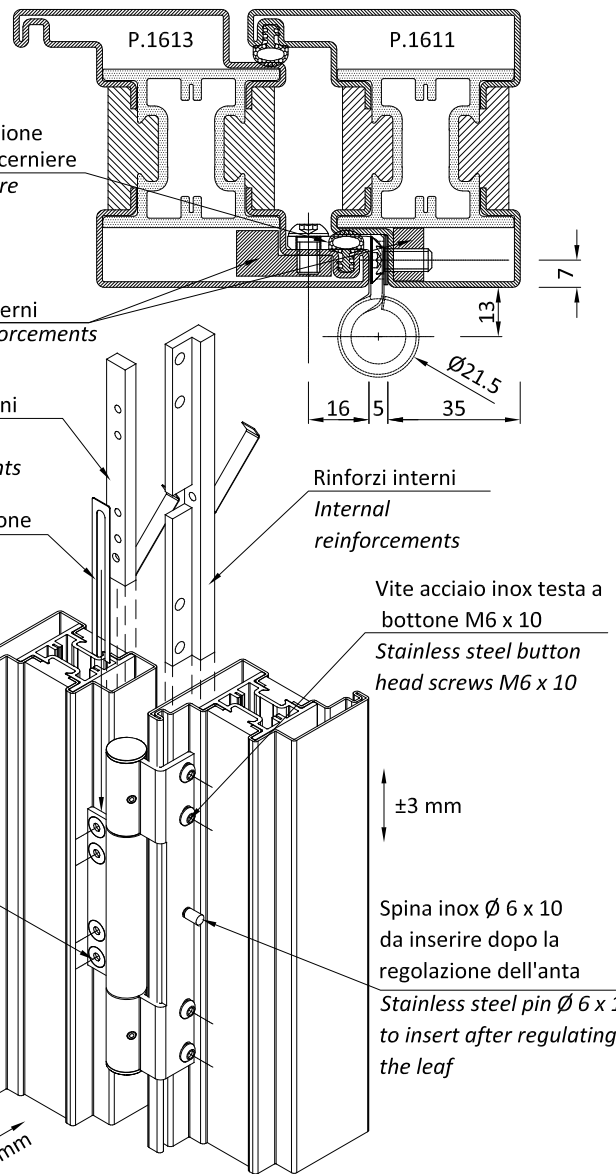


* Cerniera aggiuntiva per peso anta > di 250 kg - peso max 300 kg
Additional hinge for weight of leaf > di 250 kg - max 300 kg



Squadrette angolo
Corner plates

GE1001TT - tagliare la guarnizione dove interseca le cerniere
GE1001TT - cut the gasket where the hinges cross



Rinforzi interni
Internal reinforcements

Rinforzi interni
Internal reinforcements

Distanziale di regolazione
Regulating spacer

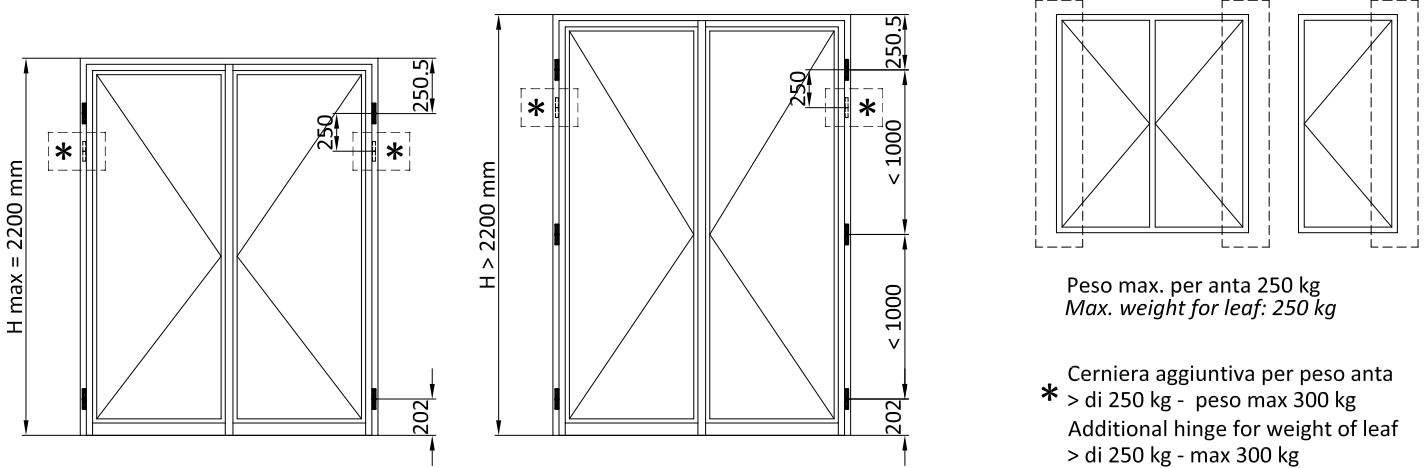
Rinforzi interni
Internal reinforcements

Vite acciaio inox testa a bottone M6 x 10
Stainless steel button head screws M6 x 10

Vite acciaio inox TSPEI M6 x 16
Stainless steel screws TSPEI M6 x 16

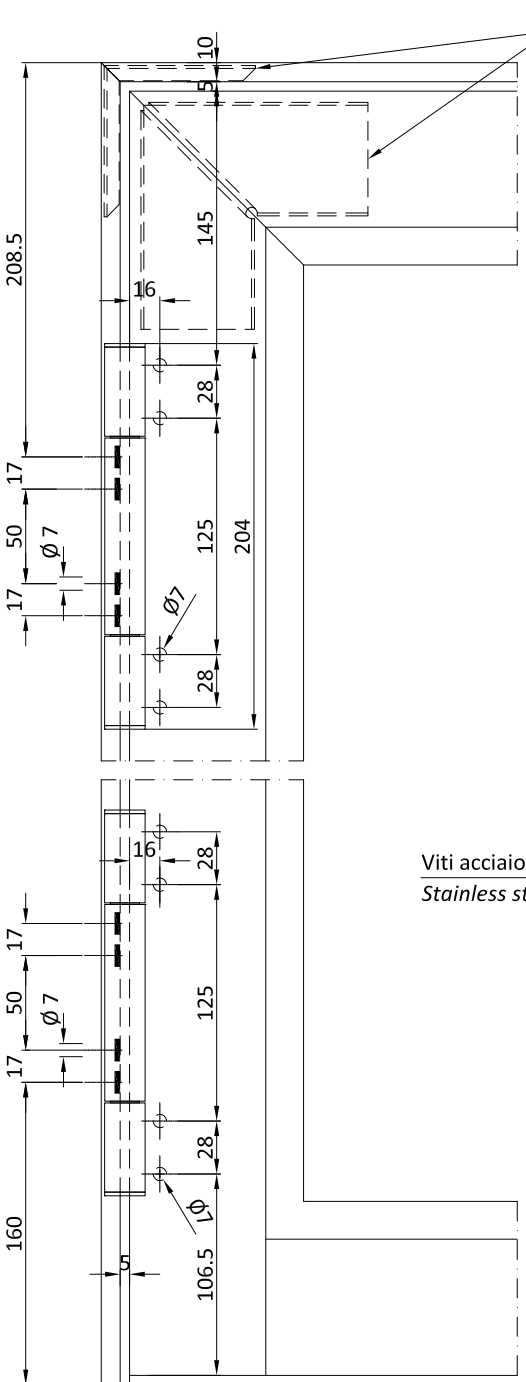
Spina inox Ø 6 x 10 da inserire dopo la regolazione dell'anta
Stainless steel pin Ø 6 x 10 to insert after regulating the leaf

- La lavorazione può essere effettuata anche in posizioni intermedie dell'altezza della porta.
- La lavorazione SX è speculare alla DX.
- La lavorazione è valida anche per le aperture esterne.
- Tooling can also be carried out in intermediate positions.
- Tooling is the same on the right and on the left.
- Tooling can be done also on external openings.



Peso max. per anta 250 kg
Max. weight for leaf: 250 kg

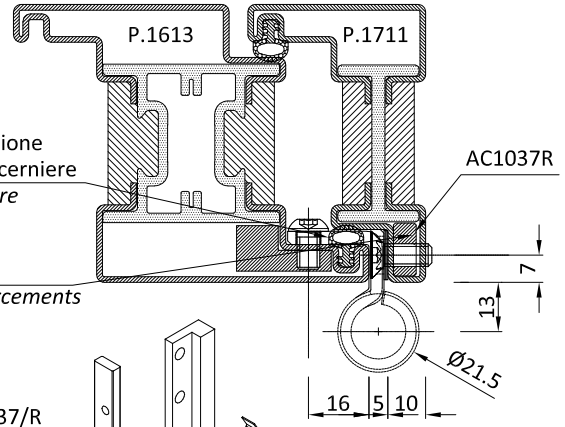
* Cerniera aggiuntiva per peso anta > di 250 kg - peso max 300 kg
Additional hinge for weight of leaf > di 250 kg - max 300 kg



Squadrette angolo
Corner plates

GE1001TT - tagliare la guarnizione dove interseca le cerniere
GE1001TT - cut the gasket where the hinges cross

Rinforzi interni
Internal reinforcements



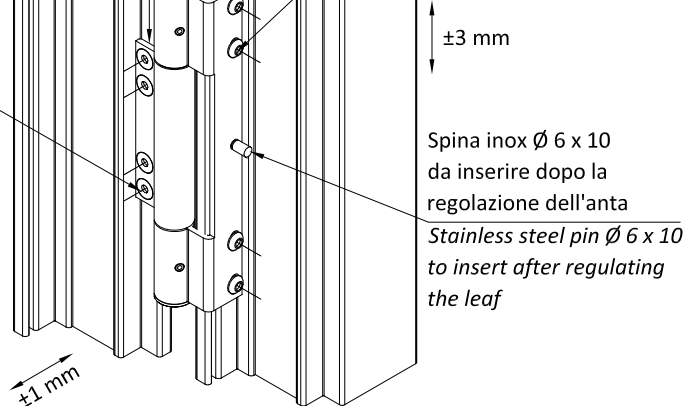
AC1037/R

Distanziale di regolazione
Regulating spacer

Rinforzi interni
Internal reinforcements

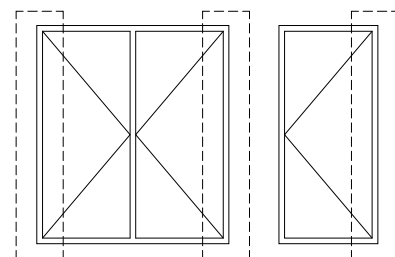
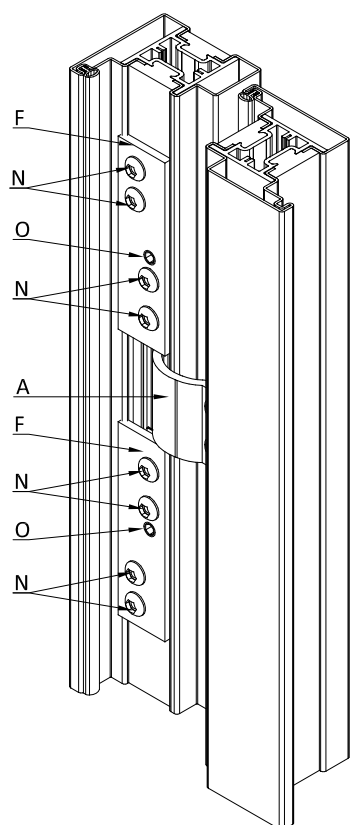
Vite acciaio inox testa a bottone M6 x 10
Stainless steel button head screws M6 x 10

Vite acciaio inox TSPEI M6 x 16
Stainless steel screws TSPEI M6 x 16



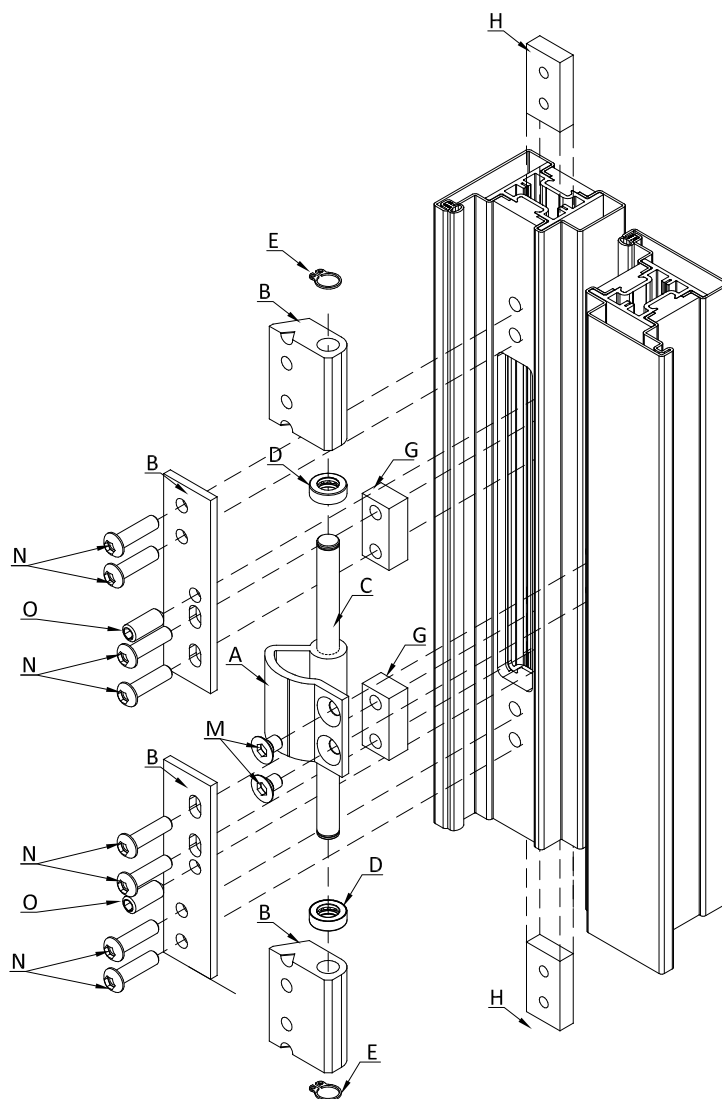
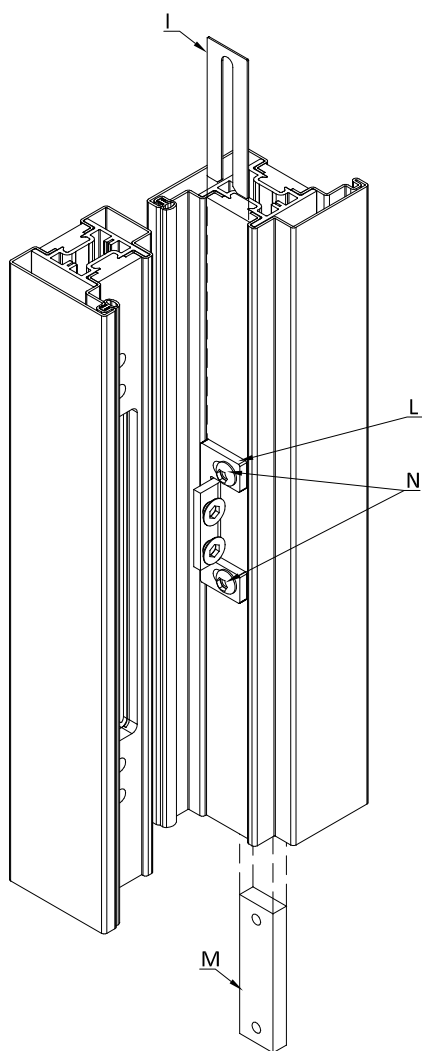
Spina inox Ø 6 x 10 da inserire dopo la regolazione dell'anta
Stainless steel pin Ø 6 x 10 to insert after regulating the leaf

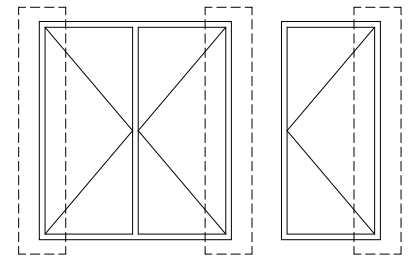
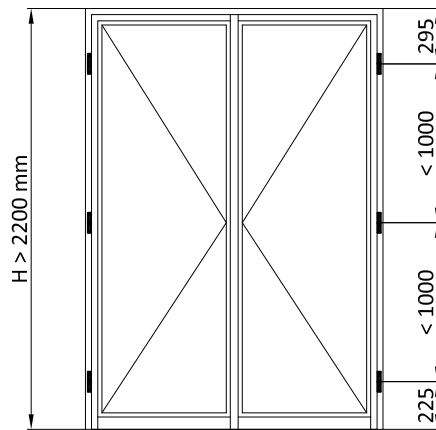
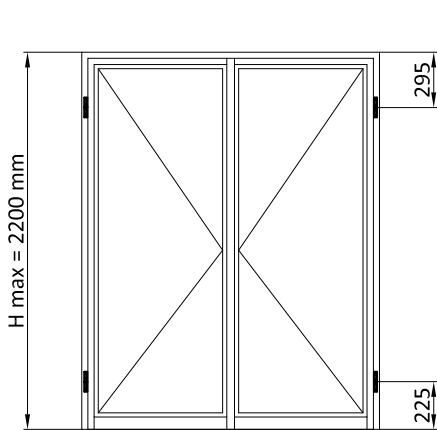
- La lavorazione può essere effettuata anche in posizioni intermedie dell'altezza della porta.
- La lavorazione SX è speculare alla DX.
- La lavorazione è valida anche per le aperture esterne.
- Tooling can also be carried out in intermediate positions.
- Tooling is the same on the right and on the left.
- Tooling can be done also on external openings.



- A) Corpo cerniera A
- B) Corpo cerniera B
- C) Perno
- D) Cuscinetto
- E) Seger
- F) Piastra
- G) Contro-piastra A
- H) Contro-piastra B
- I) Spessore
- L) Staffa di fissaggio
- M) Contropiastra C
- N) n°2 x Vite TPEI M8x12 mm
- O) n°10 x Vite TPEI M8x30 mm
- P) Grano M10x25 mm punta conica

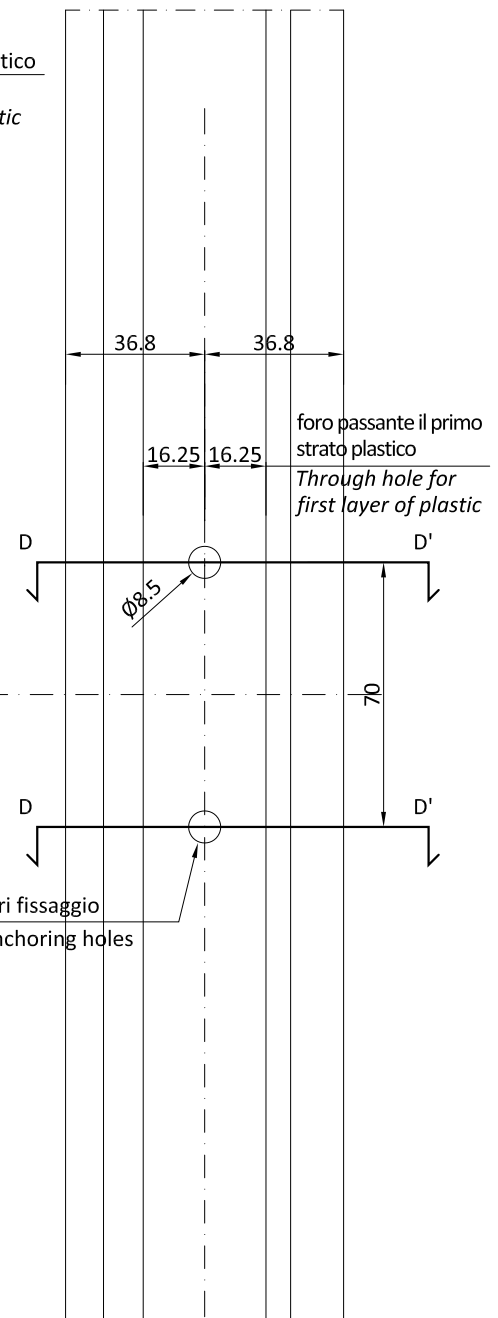
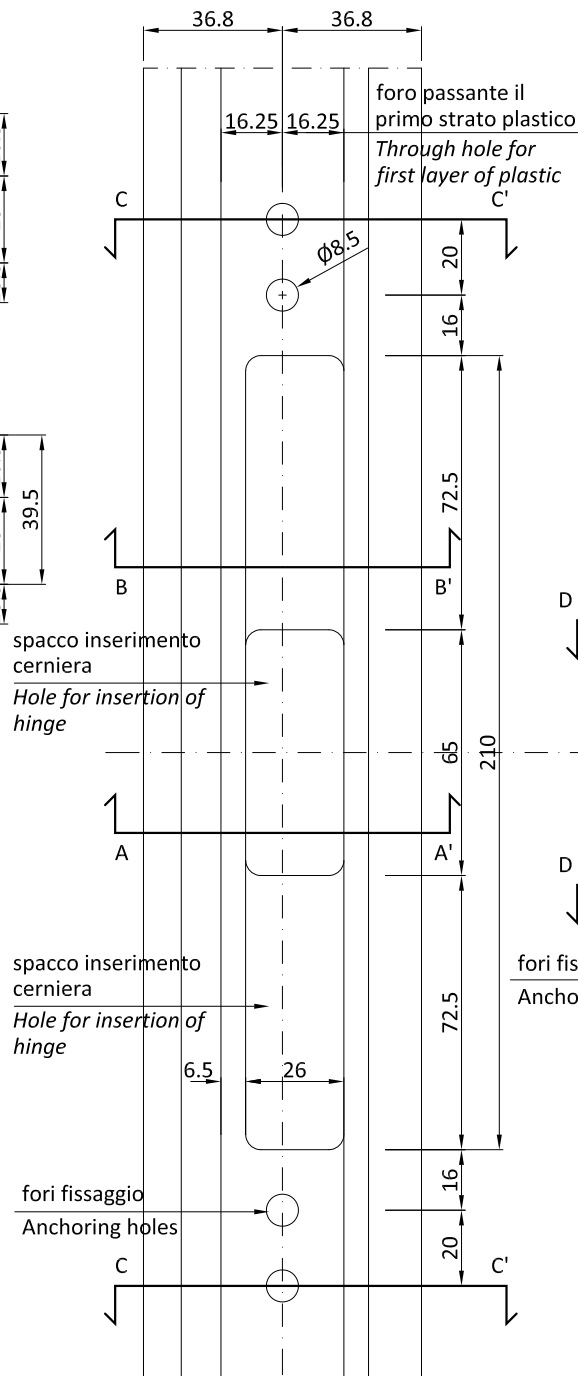
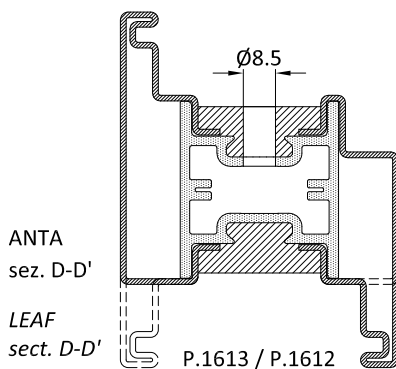
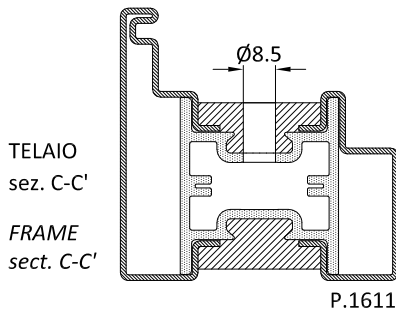
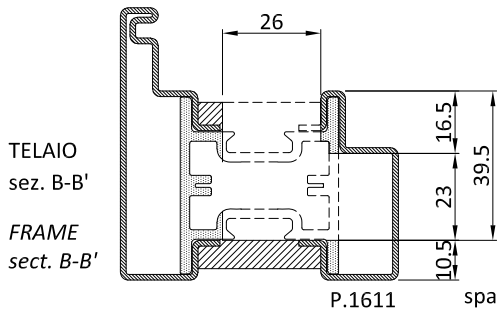
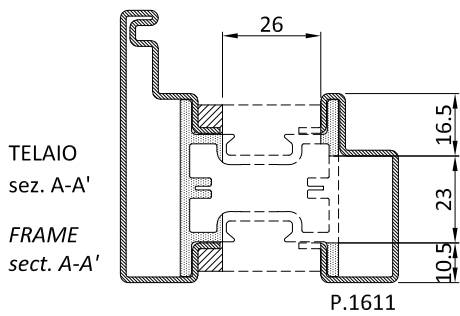
- A) Body hinge A
- B) Body hinge B
- C) Pin
- D) Bearing
- E) Seger
- F) Plate
- G) Retainer plate A
- H) Retainer plate B
- I) Shim
- L) Anchoring bracket
- M) Counter-plate C
- N) n° 2 x Screws TPEI M8x12 mm
- O) n°10 x Screws TPEI M8x30 mm
- P) Dowel M10x25 mm cone point

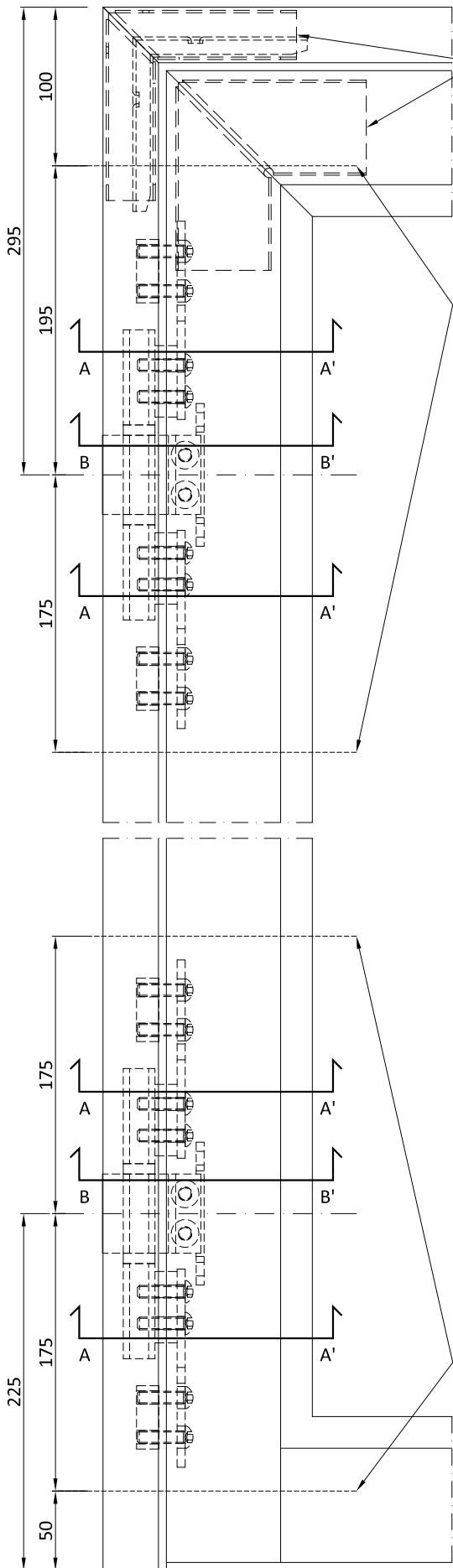




Peso max. per anta 180 kg
Massima apertura 96°
Max. weight for leaf: 180 kg
Maximum opening 96°

Lavorazione eseguibile con fresa AT1068
Tooling possible with milling cutter AT1068

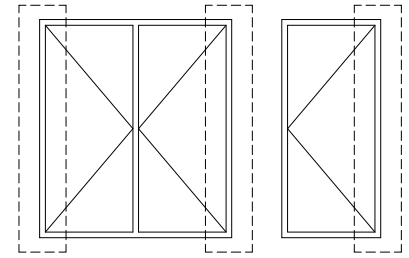




Squadrette angolo
Corner plates

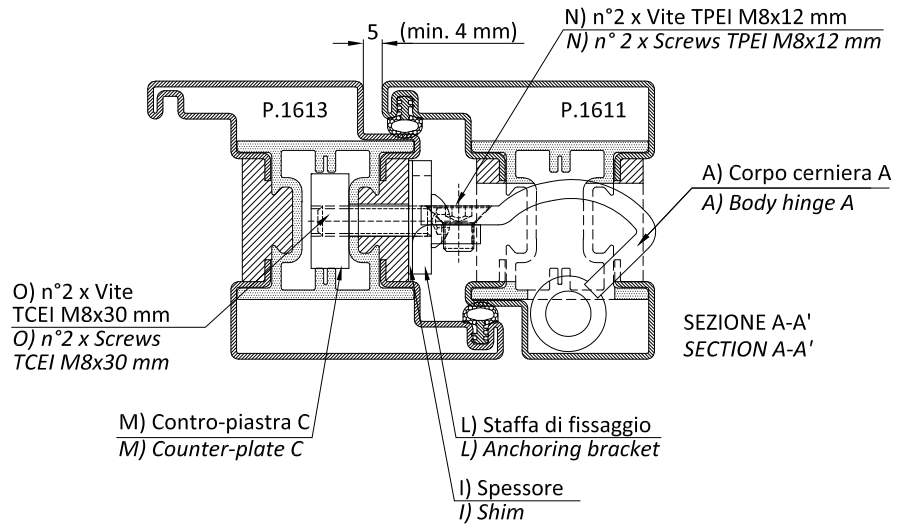
Fissaggio a muro
Anchoring to the wall

Fissaggio a muro
Anchoring to the wall



Peso max. per anta 180 kg
Massima apertura 96°
Max. weight for leaf: 180 kg
Maximum opening 96°

Lavorazione eseguibile con fresa AT1068
Tooling possible with milling cutter AT1068

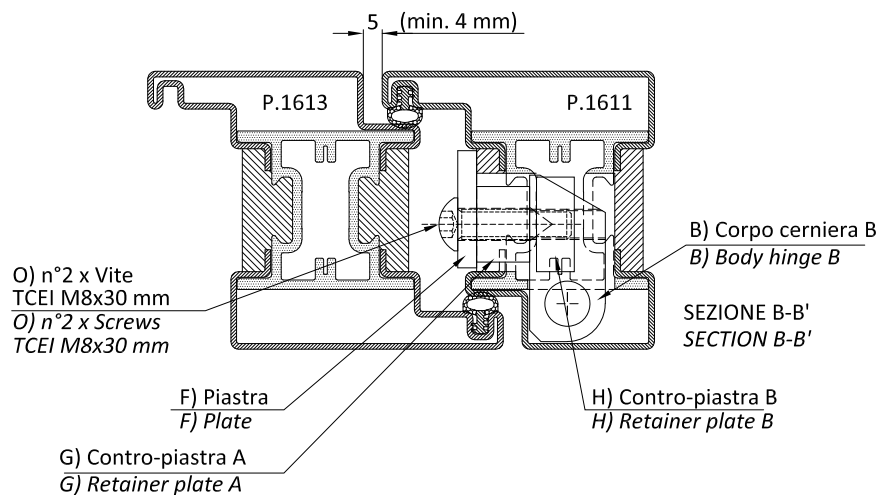


O) n°2 x Vite
TCEI M8x30 mm
O) n°2 x Screws
TCEI M8x30 mm

M) Contro-piastra C
M) Counter-plate C

L) Staffa di fissaggio
L) Anchoring bracket
I) Spessore
I) Shim

SEZIONE A-A'
SECTION A-A'

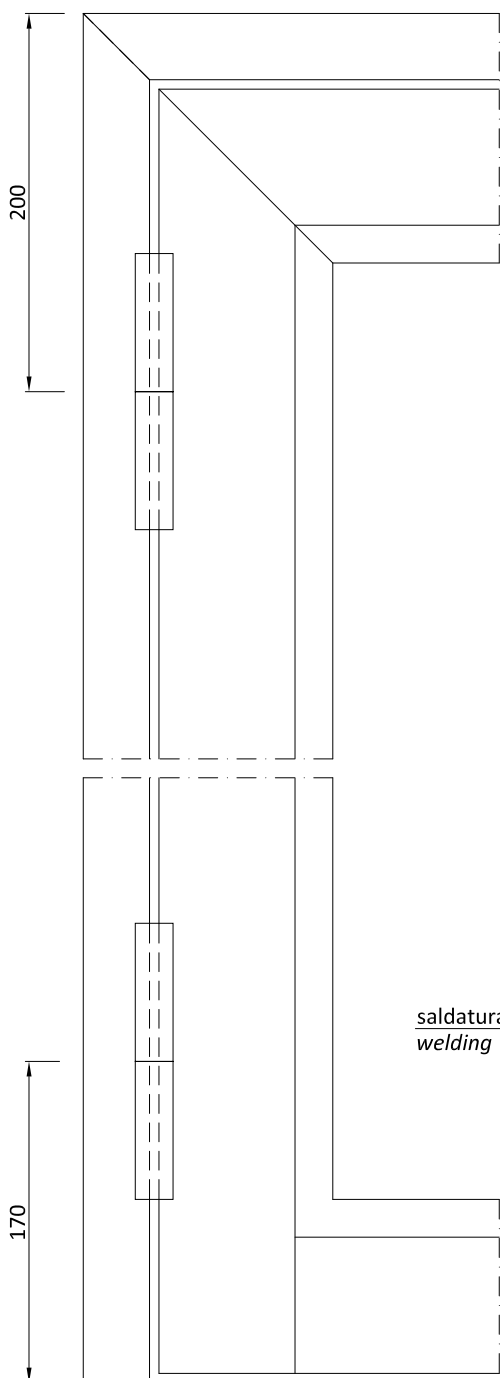
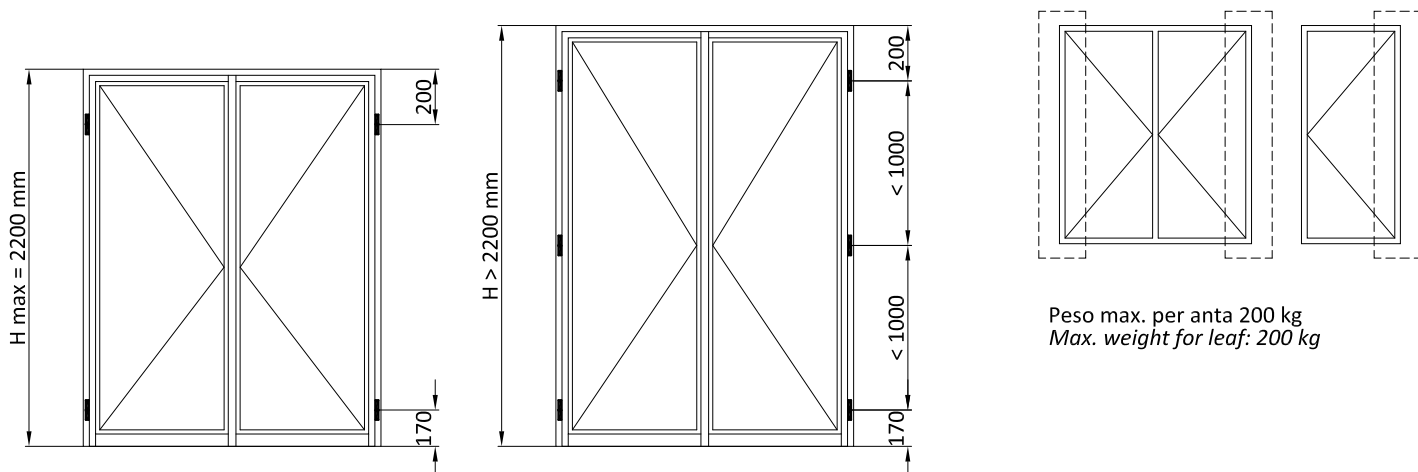


O) n°2 x Vite
TCEI M8x30 mm
O) n°2 x Screws
TCEI M8x30 mm

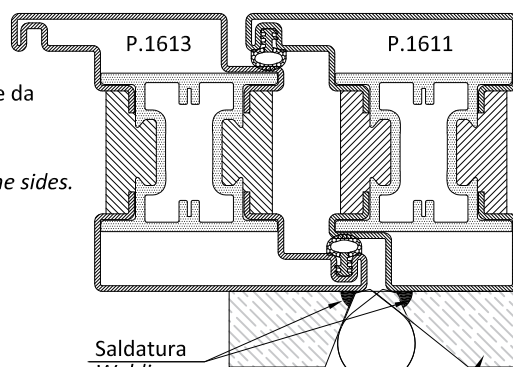
F) Piastra
F) Plate
G) Contro-piastra A
G) Retainer plate A

SEZIONE B-B'
SECTION B-B'

- La lavorazione può essere effettuata anche in posizioni intermedie dell'altezza della porta.
- La lavorazione SX è speculare alla DX.
- La lavorazione è valida anche per le aperture esterne.
- Tooling can also be carried out in intermediate positions.
- Tooling is the same on the right and on the left.
- Tooling can be done also on external openings.

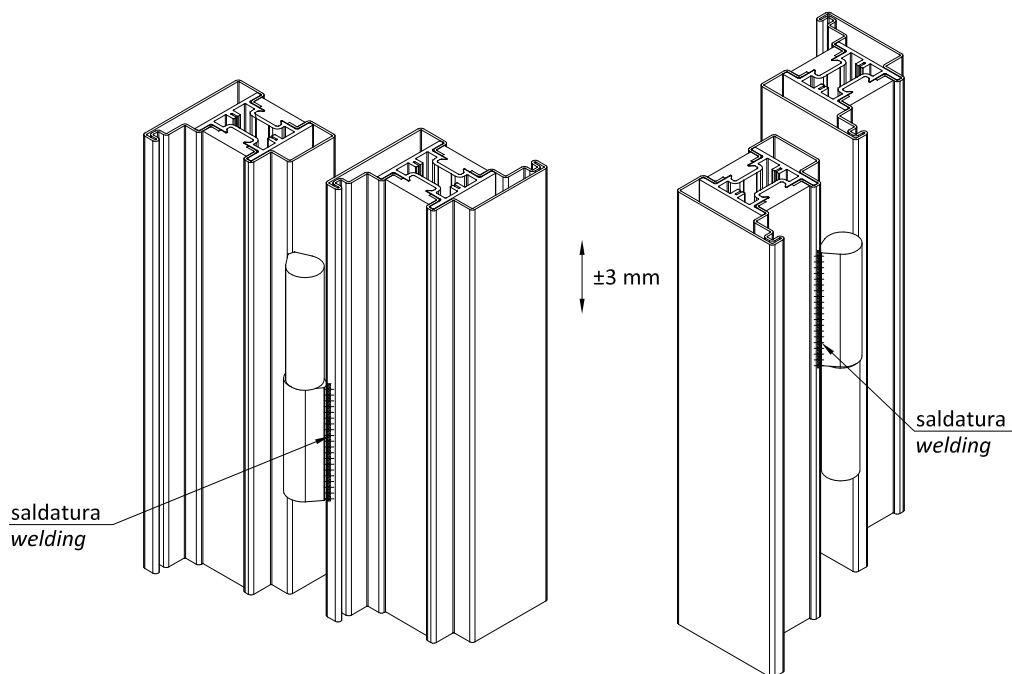


Posizionare le cerniere come da disegno saldandole sui alti.
Position the hinges as in the drawing, welding them on the sides.

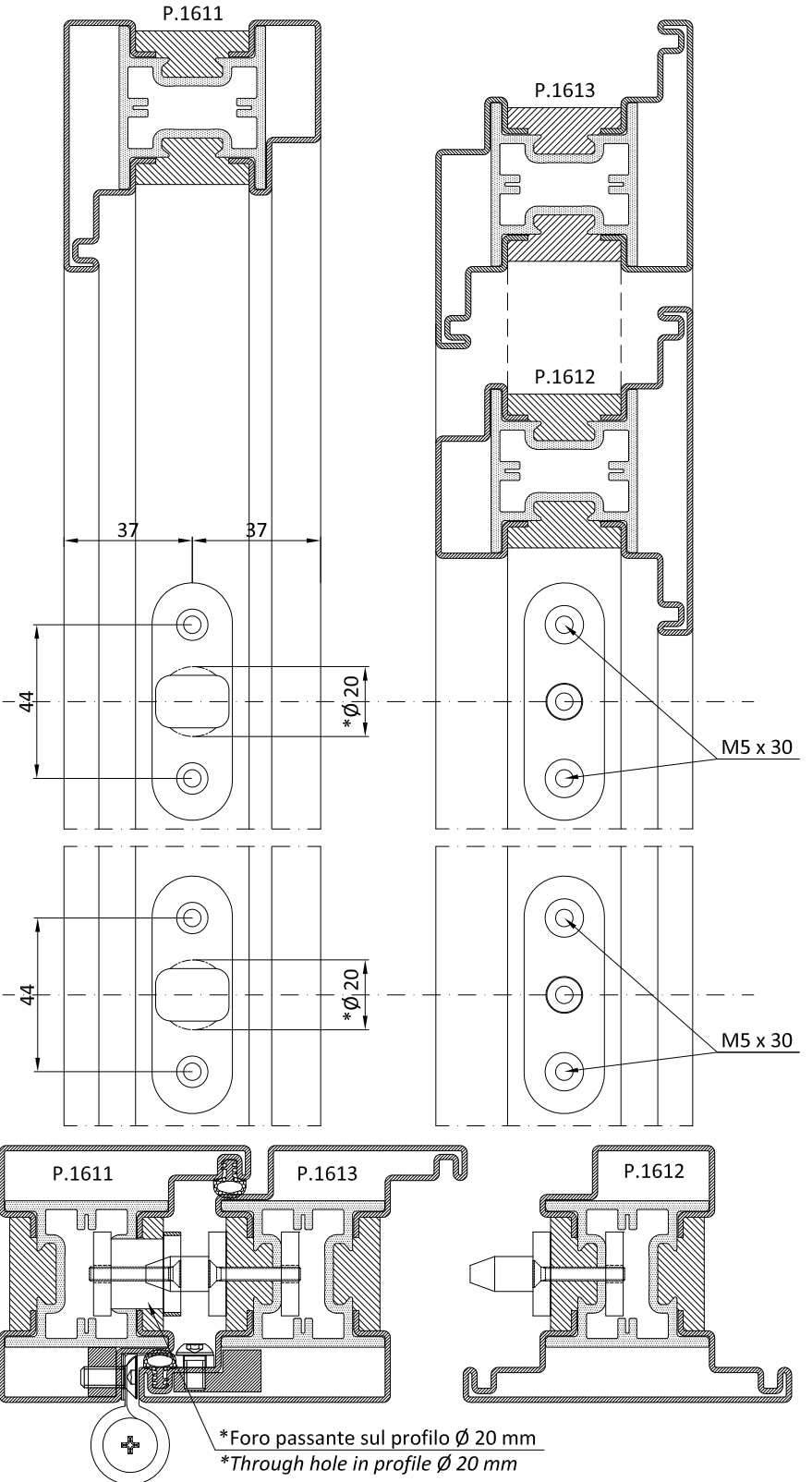
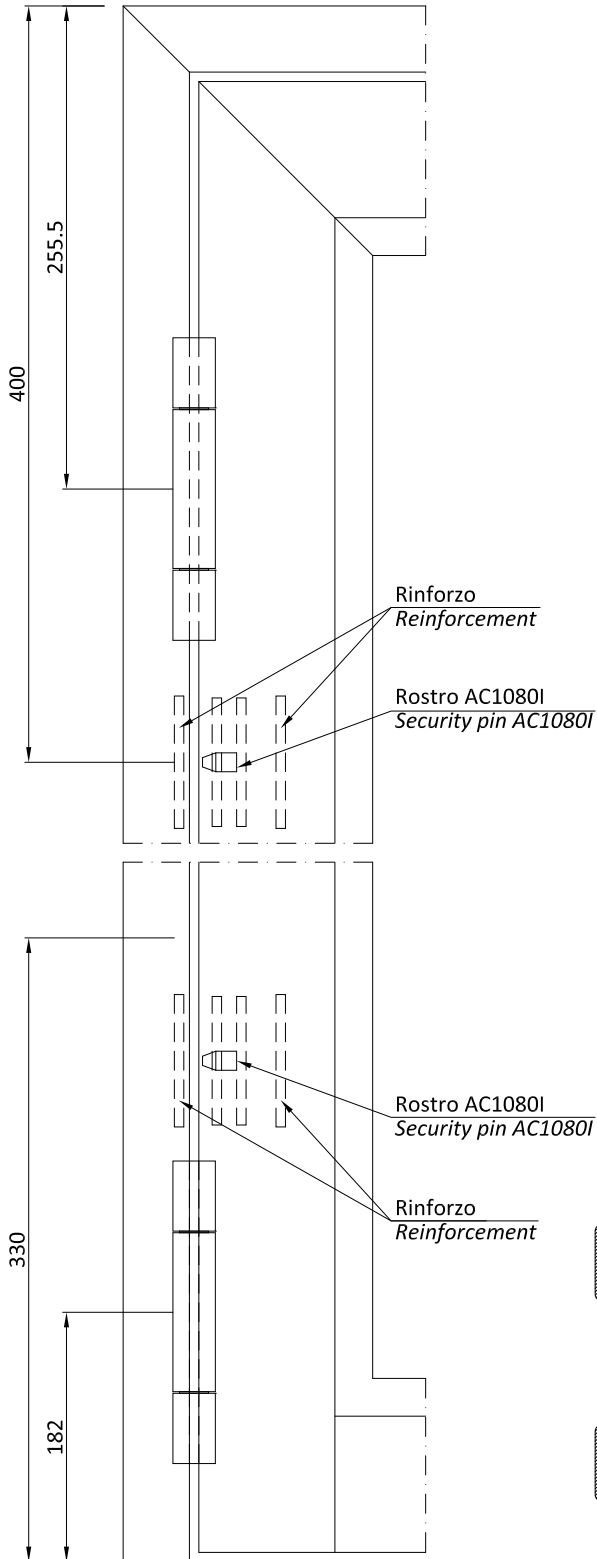
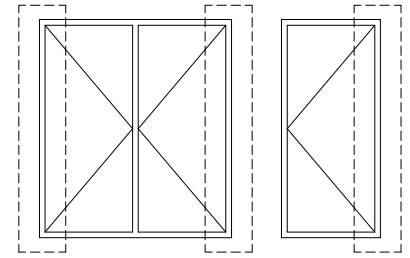
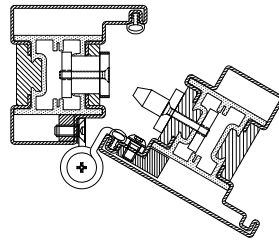
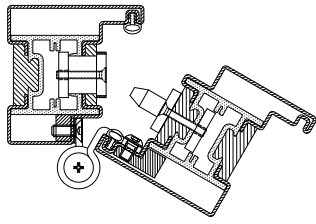


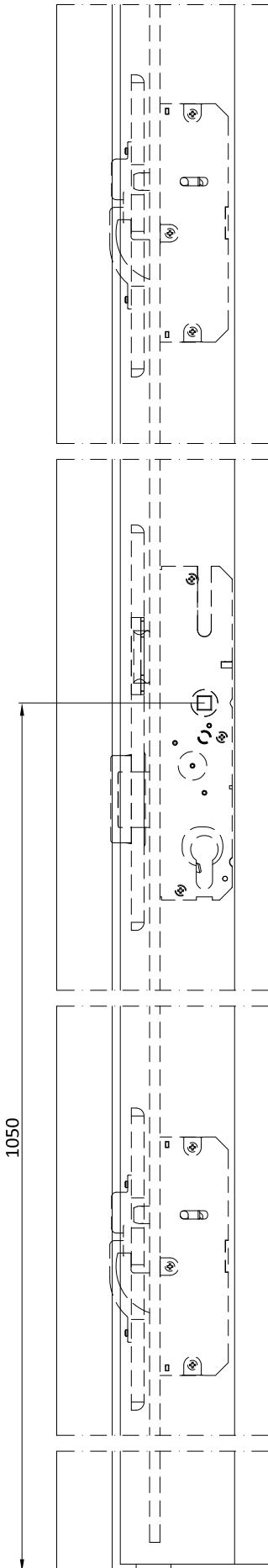
Saldatura
Welding

AT6023 maschera di posizionamento
AT6023 positioning jig



- La lavorazione può essere effettuata anche in posizioni intermedie dell'altezza della porta.
- La lavorazione SX è speculare alla DX.
- La lavorazione è valida anche per le aperture esterne.
- Tooling can be carried out also in intermediate positions regarding the height of the door.
- Tooling on left is the same as that on the right.
- Tooling can be done also on external openings.



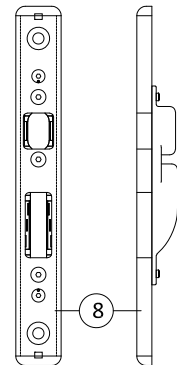
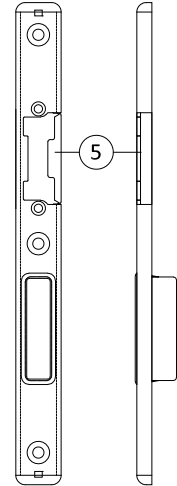
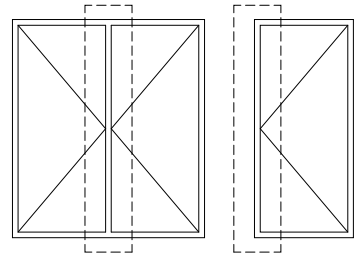
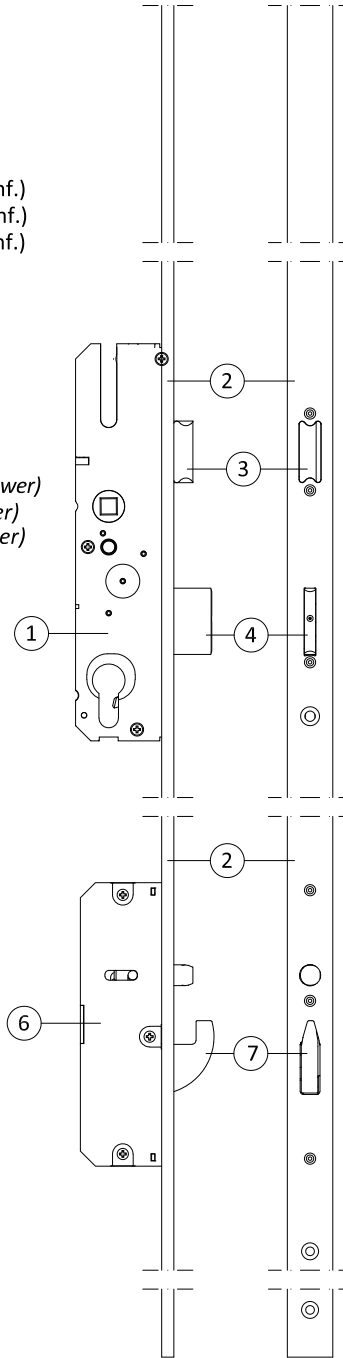


AC1065W D/S _ AC1066W D/S

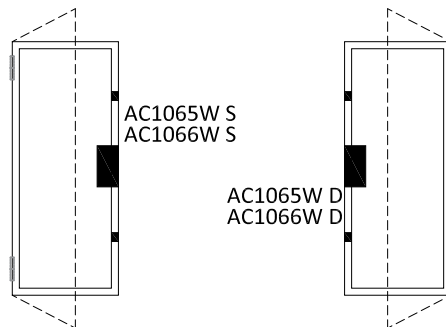
- 1) Serratura
- 2) Frontalino
- 3) Scrocco
- 4) Catenaccio
- 5) Incontro per serratura
- 6) Deviatori (n°2 pezzi sup + inf.)
- 7) Catenaccio (n°2 pezzi sup + inf.)
- 8) Incontro (n°2 pezzi sup + inf.)

AC1065W D/S _ AC1066W D/S

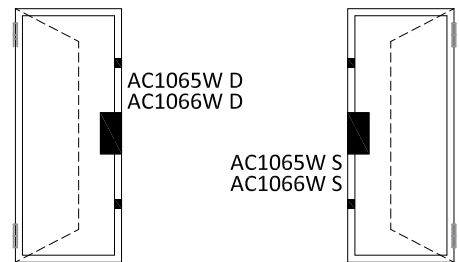
- 1) Lock
- 2) Front plate
- 3) Spring latch
- 4) Bolt
- 5) Strike plate
- 6) Diverters (n° 2 items upper + lower)
- 7) Bolt (n° 2 items upper + lower)
- 8) Plate (n° 2 items upper + lower)



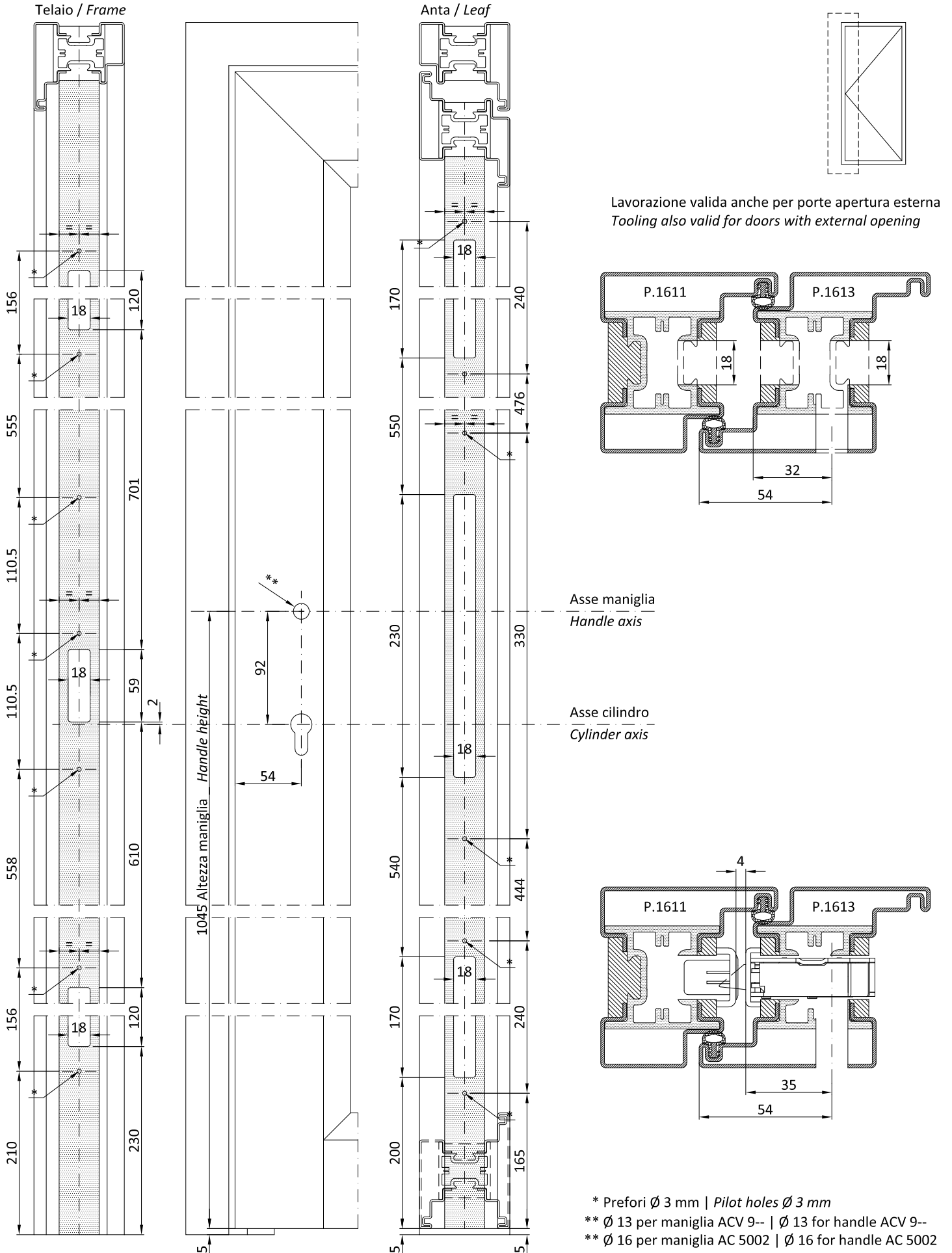
SCHEMA UTILIZZO SERRATURE
DIAGRAM FOR THE USE OF LOCKS

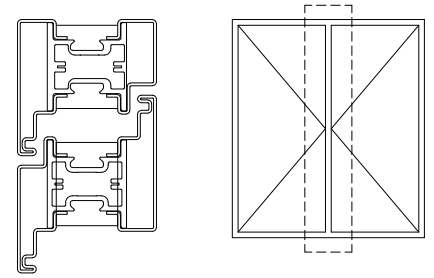
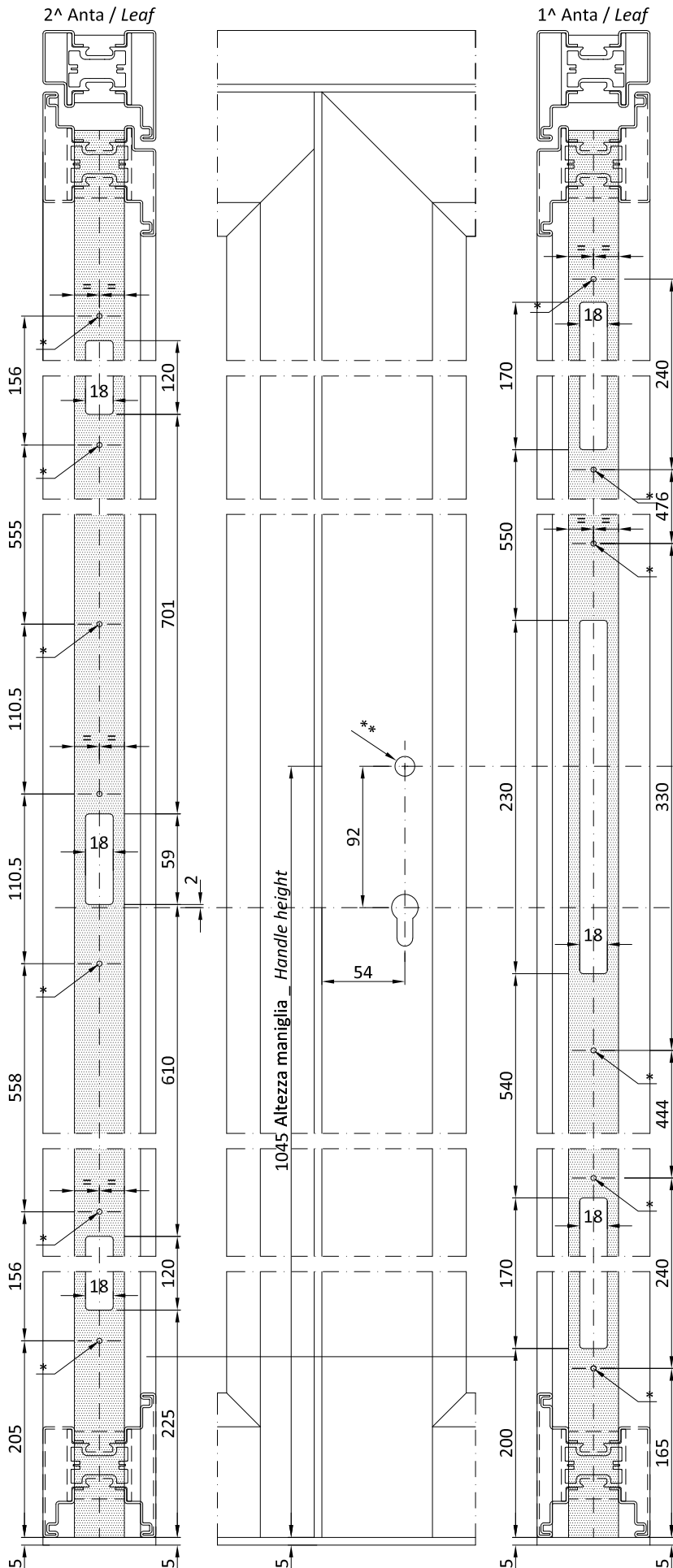


APERTURA INTERNA _ VISTA INTERNA
INWARDS OPENING _ INTERIOR ELEVATION

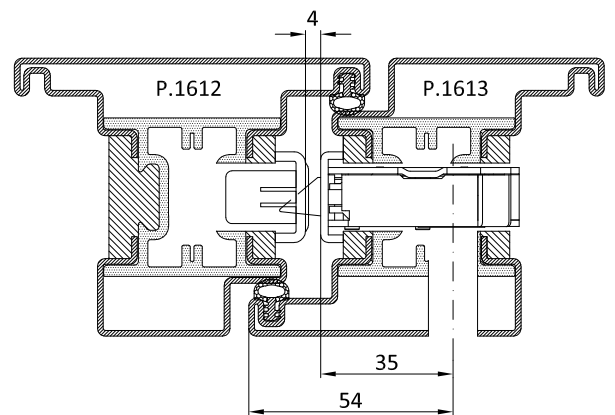
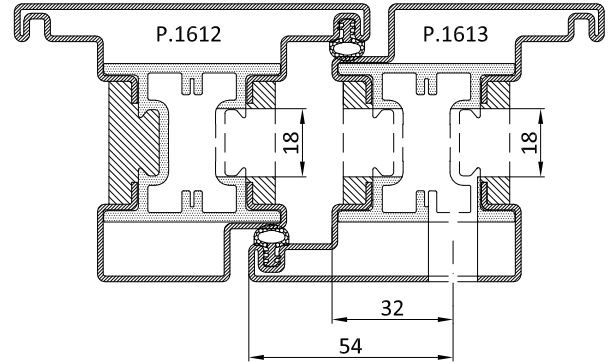


APERTURA ESTERNA _ VISTA INTERNA
OUTWARDS OPENING _ INTERIOR ELEVATION

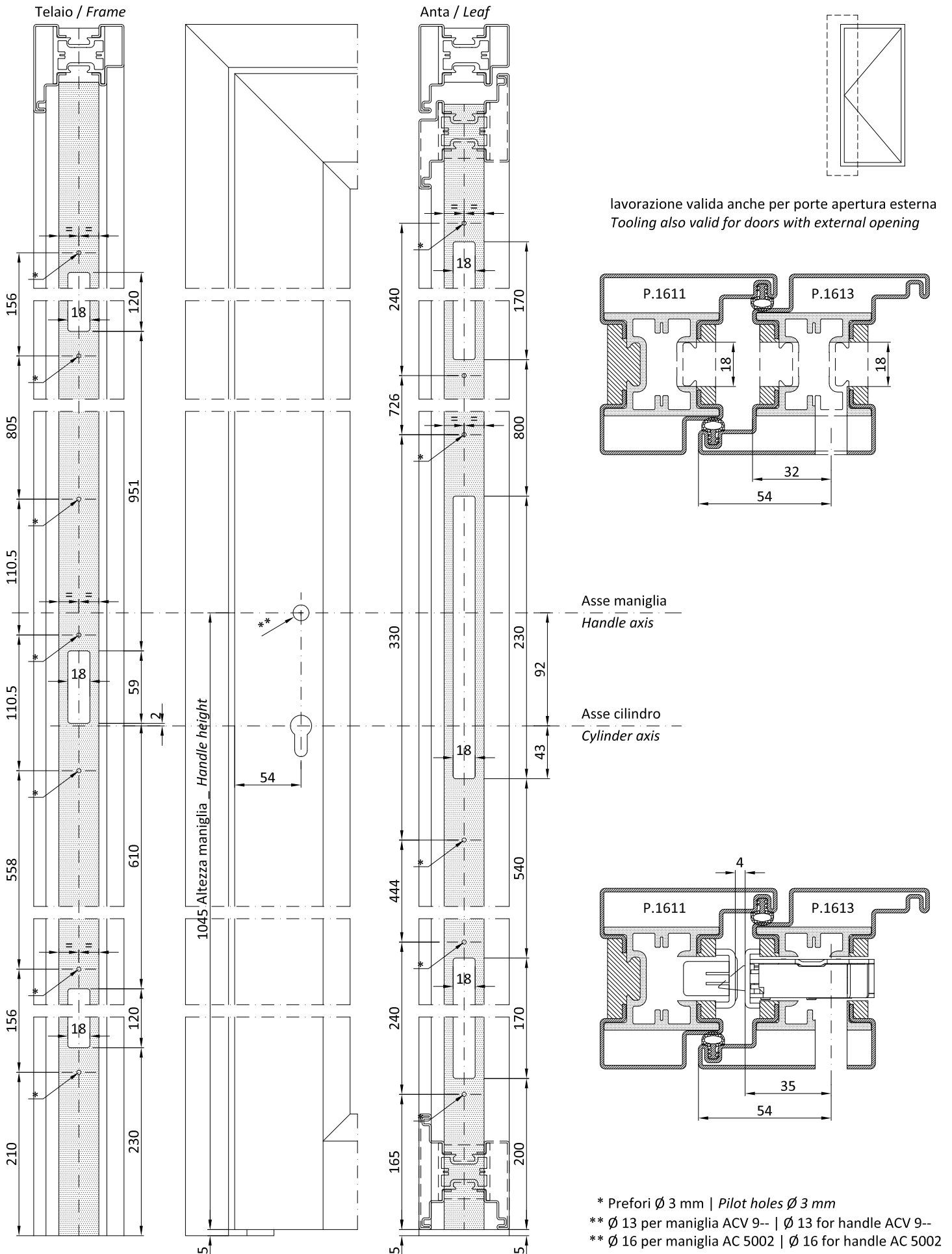


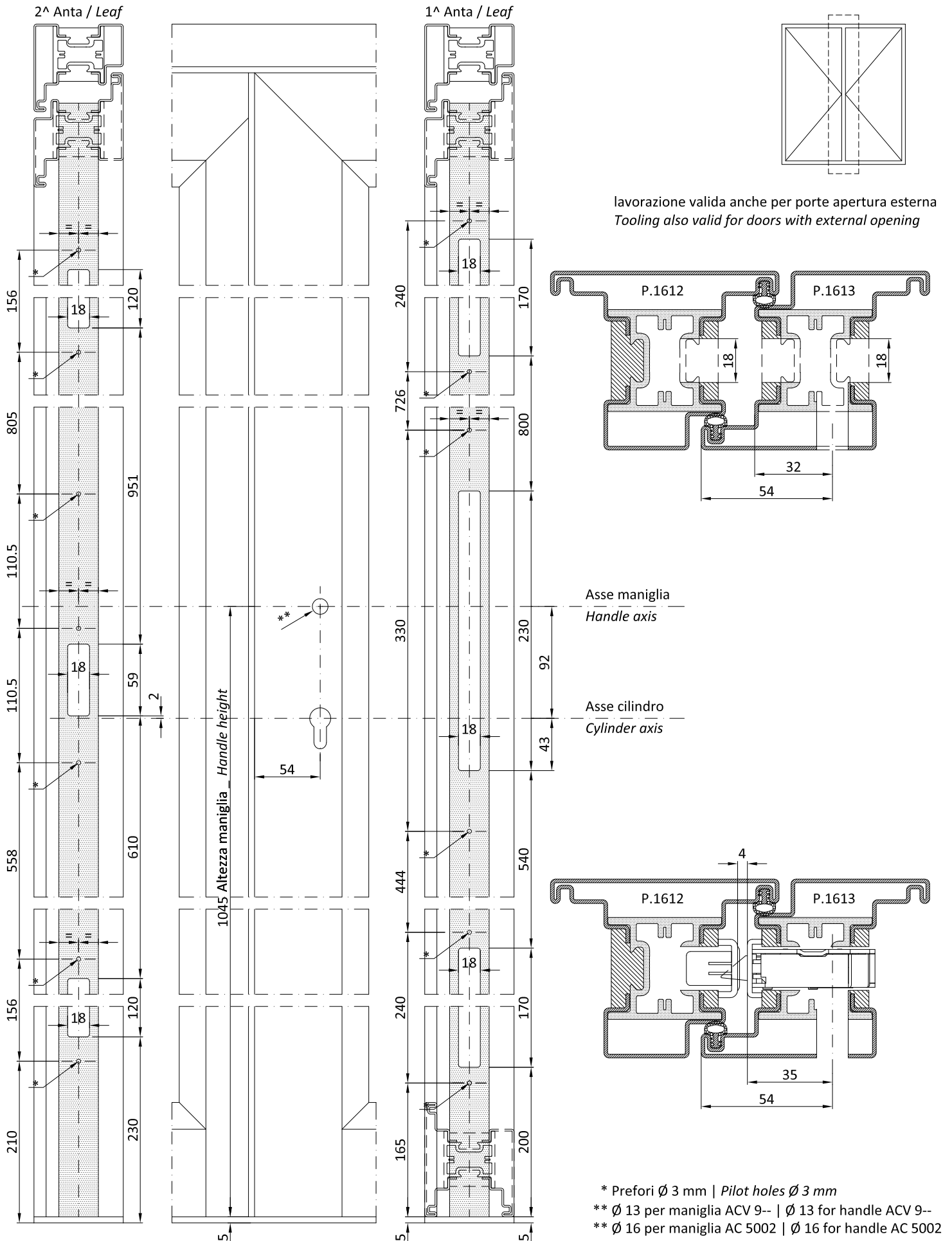


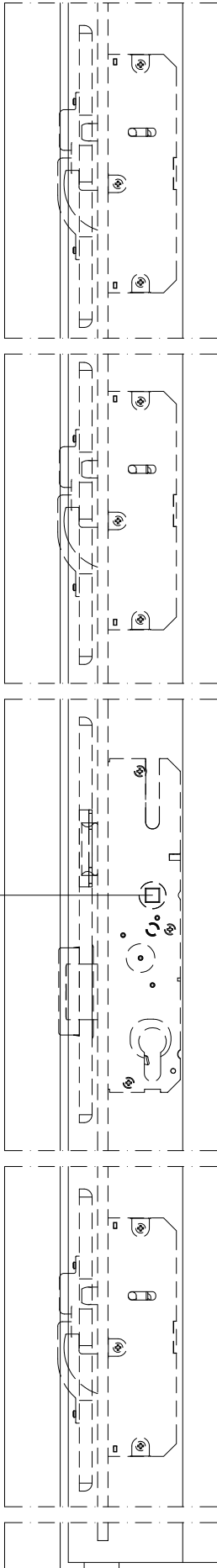
Lavorazione valida anche per porte apertura esterna
Tooling also valid for doors with external opening



- * Prefori Ø 3 mm | Pilot holes Ø 3 mm
- ** Ø 13 per maniglia ACV 9-- | Ø 13 for handle ACV 9--
- ** Ø 16 per maniglia AC 5002 | Ø 16 for handle AC 5002







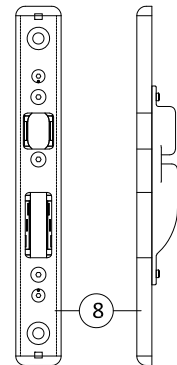
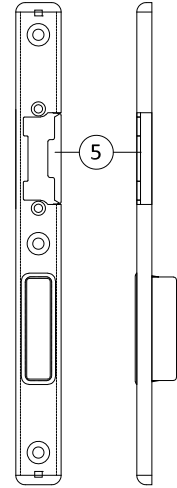
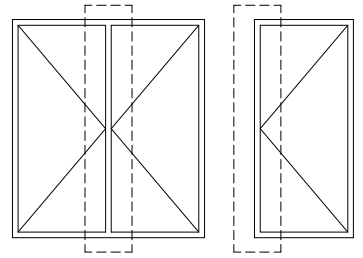
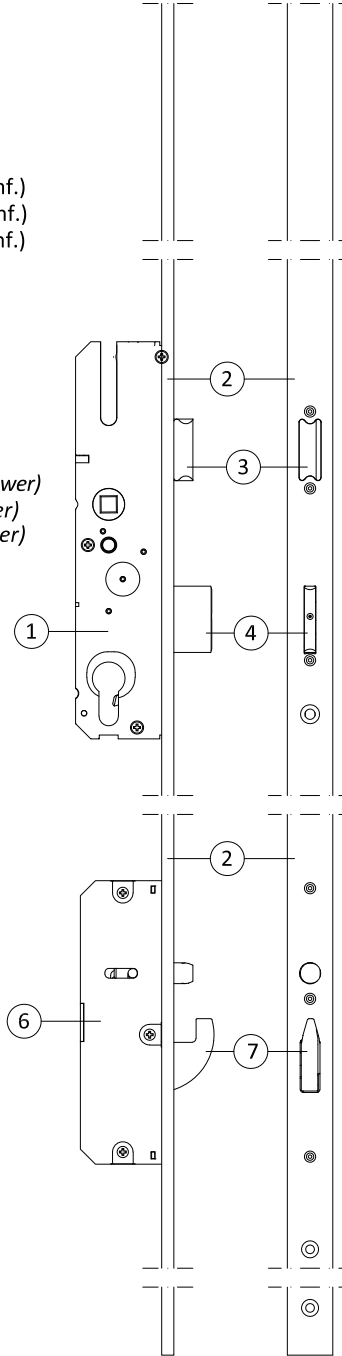
1050

AC1067W D/S

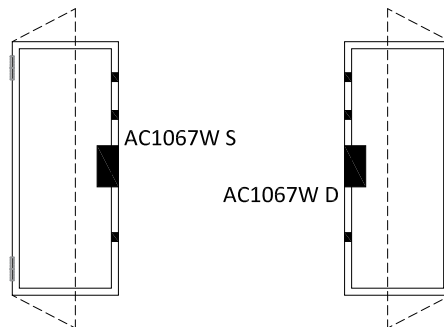
- 1) Serratura
- 2) Frontalino
- 3) Scrocco
- 4) Catenaccio
- 5) Incontro per serratura
- 6) Deviatori (n°3 pezzi sup + inf.)
- 7) Catenaccio (n°3 pezzi sup + inf.)
- 8) Incontro (n°3 pezzi sup + inf.)

AC1067W D/S

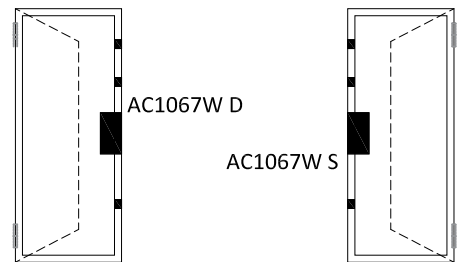
- 1) Lock
- 2) Front plate
- 3) Spring latch
- 4) Bolt
- 5) Strike plate
- 6) Diverters (n° 3 items upper + lower)
- 7) Bolt (n° 3 items upper + lower)
- 8) Plate (n° 3 items upper + lower)



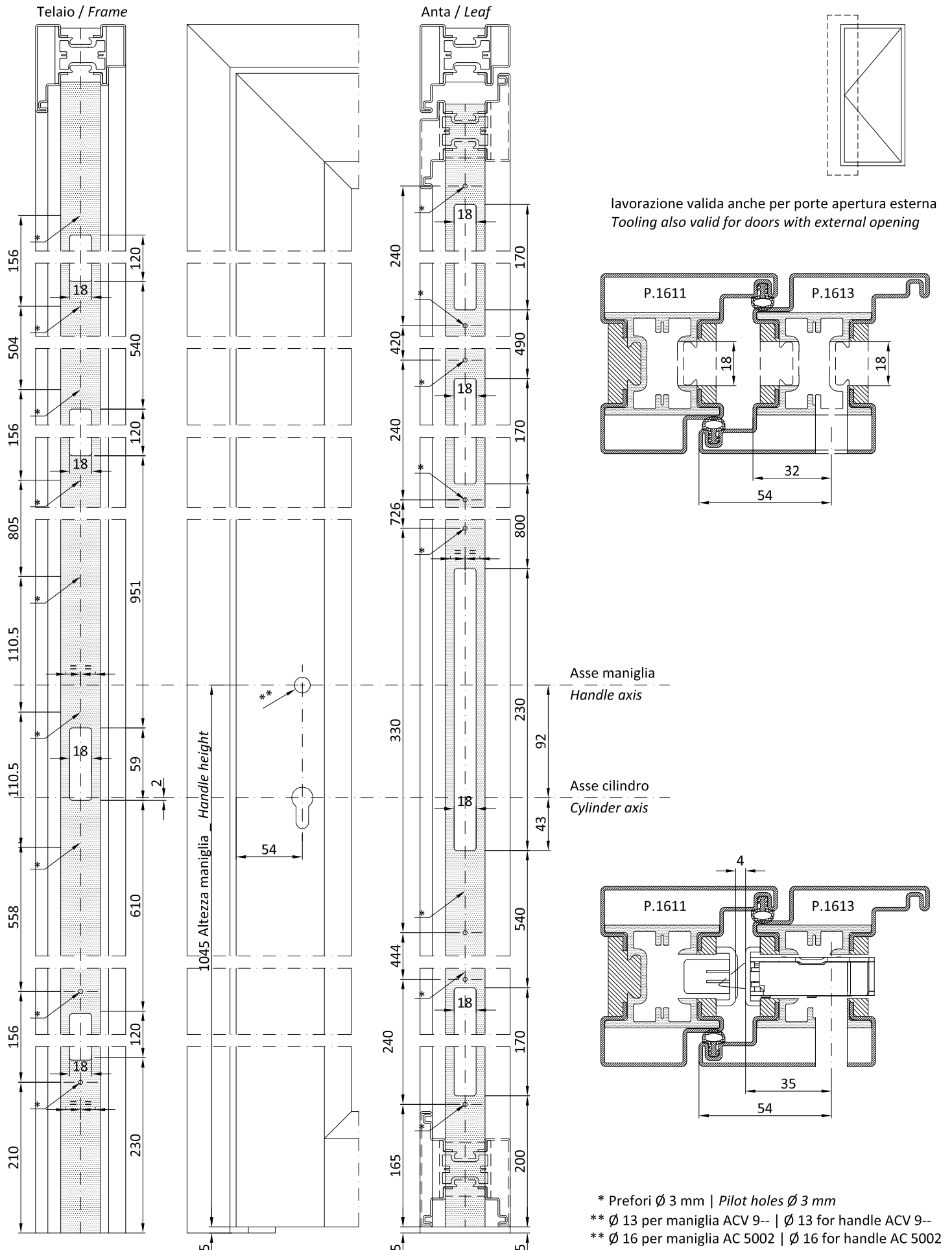
SCHEMA UTILIZZO SERRATURE
DIAGRAM FOR THE USE OF LOCKS

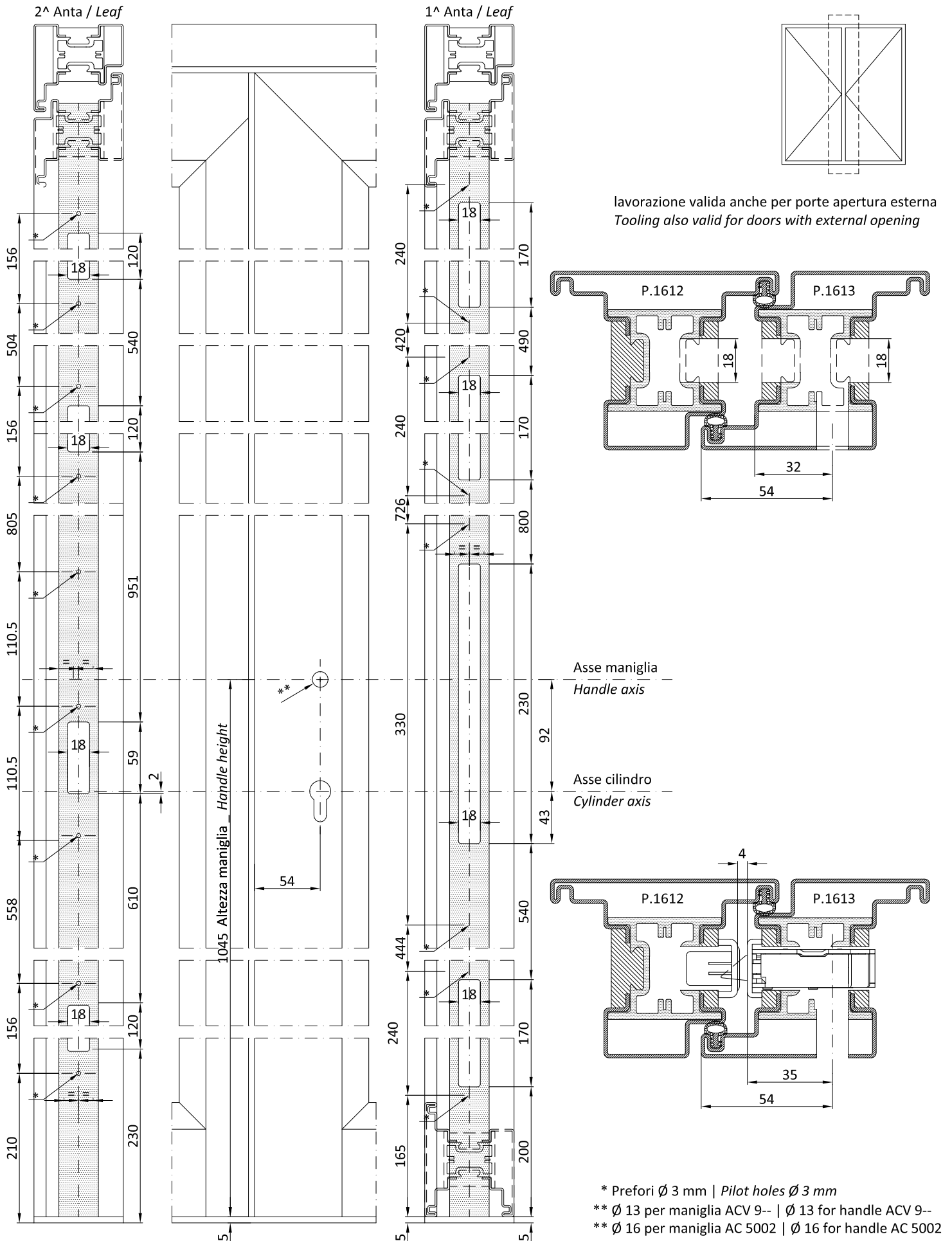


APERTURA INTERNA _ VISTA INTERNA
INWARDS OPENING _ INTERIOR ELEVATION

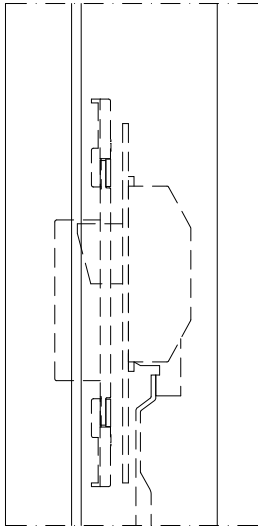


APERTURA ESTERNA _ VISTA INTERNA
OUTWARDS OPENING _ INTERIOR ELEVATION



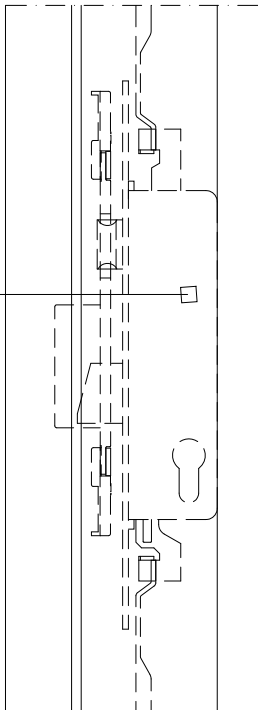
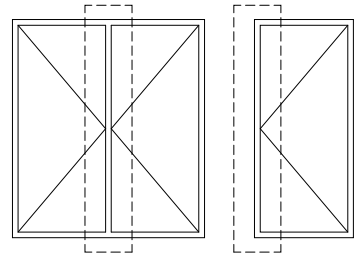


* Prefori Ø 3 mm | Pilot holes Ø 3 mm
 ** Ø 13 per maniglia ACV 9-- | Ø 13 for handle ACV 9--
 ** Ø 16 per maniglia AC 5002 | Ø 16 for handle AC 5002



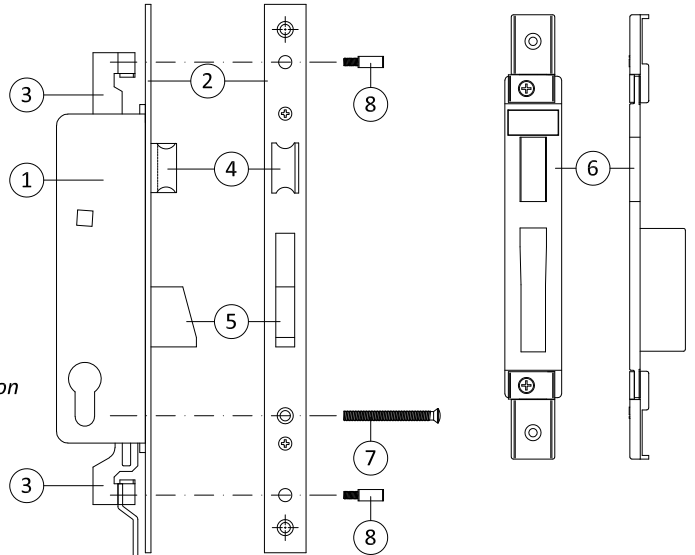
AC1070

- 1) Serratura
- 2) Frontalino
- 3) Riduttore di collegamento
- 4) Scrocco
- 5) Catenaccio
- 6) Incontro per serratura
- 7) Vite inox TS M5x50
- 8) Perno fissaggio asta



AC1075

- 9) Deviatori (n°2 pezzi sup + inf.)
- 10) Frontalino (n°2 pezzi sup + inf.)
- 11) Catenaccio (n°2 pezzi sup + inf.)
- 12) Aste inox (n°2 pezzi sup + inf.)
- 13) Incontro (n°2 pezzi sup + inf.)

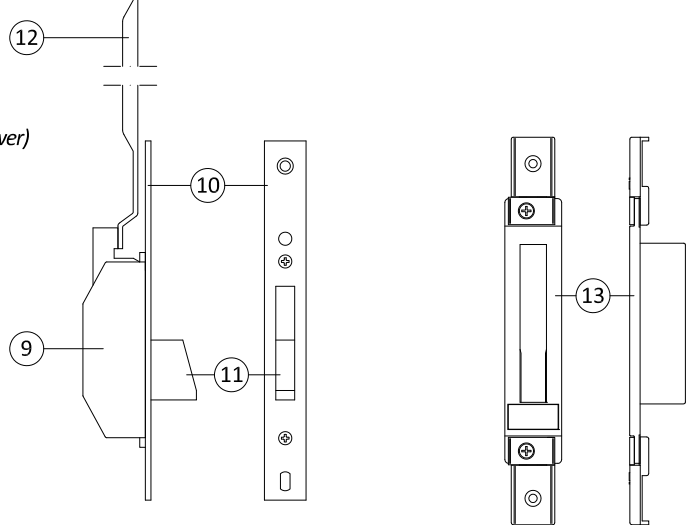


AC1070

- 1) Lock
- 2) Front plate
- 3) Reduction unit/adaptor for connection
- 4) Spring latch
- 5) Bolt
- 6) Strike plate
- 7) Stainless steel screws TS M5x50
- 8) Pin for anchoring the rod

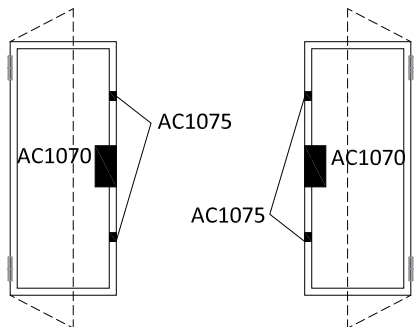
AC1075

- 9) Diverters (n° 2 items upper + lower)
- 10) Apron lining (n° 2 items upper + lower)
- 11) Bolt (n° 2 items upper + lower)
- 12) Stainless steel rods (n° 2 items upper + lower)
- 13) Plate (n° 2 items upper + lower)

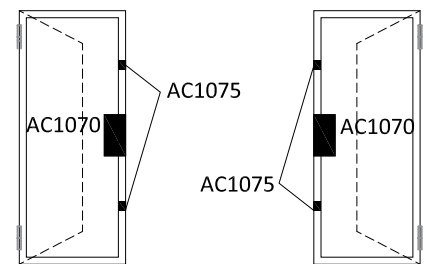


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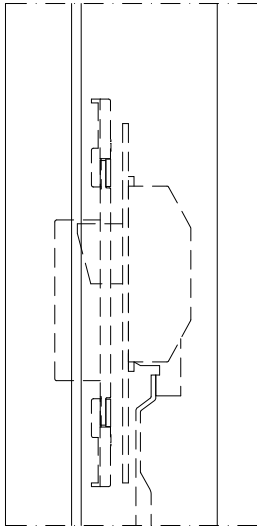
SCHEMA UTILIZZO SERRATURE E TERZE CHIUSURE
DIAGRAM FOR THE USE OF LOCKS AND THIRD LOCKS



APERTURA INTERNA _ VISTA INTERNA
INWARDS OPENING _ INTERIOR ELEVATION

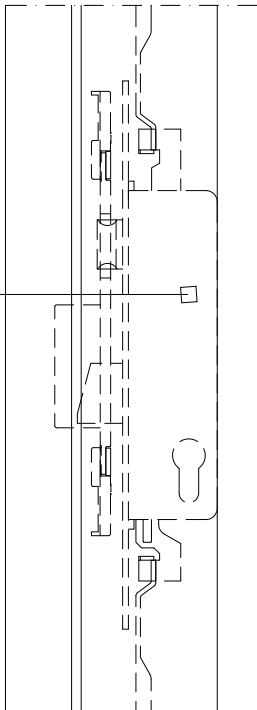
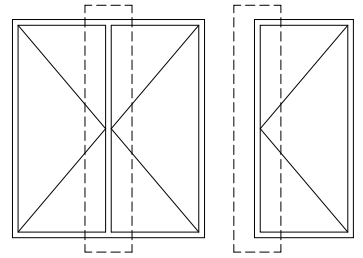


APERTURA ESTERNA _ VISTA INTERNA
OUTWARDS OPENING _ INTERIOR ELEVATION



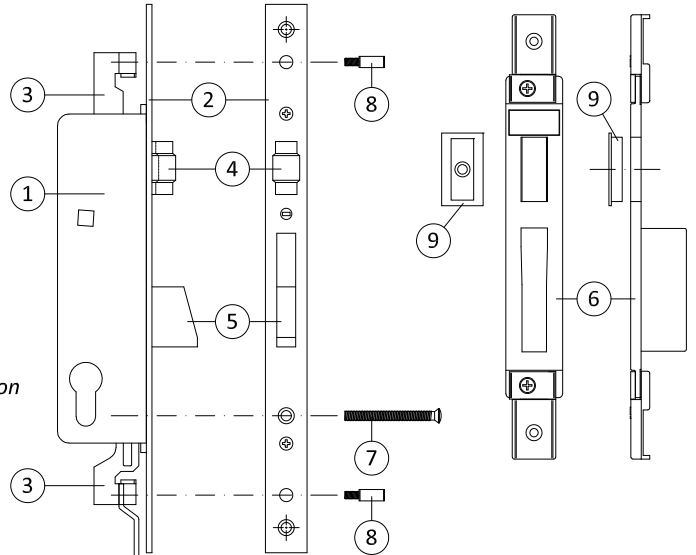
AC1071

- 1) Serratura
- 2) Frontalino
- 3) Riduttore di collegamento
- 4) Rullo
- 5) Catenaccio
- 6) Incontro per serratura
- 7) Vaschetta per rullo
- 8) Vite inox TS M5x50
- 9) Perno fissaggio asta



AC1075

- 10) Deviatori (n°2 pezzi sup + inf.)
- 11) Frontalino (n°2 pezzi sup + inf.)
- 12) Catenaccio (n°2 pezzi sup + inf.)
- 13) Aste inox (n°2 pezzi sup + inf.)
- 14) Incontro (n°2 pezzi sup + inf.)

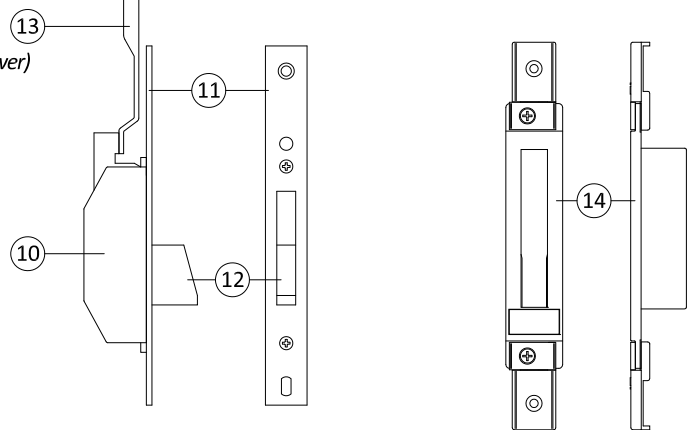


AC1071

- 1) Lock
- 2) Front plate
- 3) Reduction unit/adaptor for connection
- 4) Roller
- 5) Bolt
- 6) Strike plate
- 7) Compartment for roller
- 8) Stainless steel screws TS M5x50
- 9) Pin for anchoring the rod

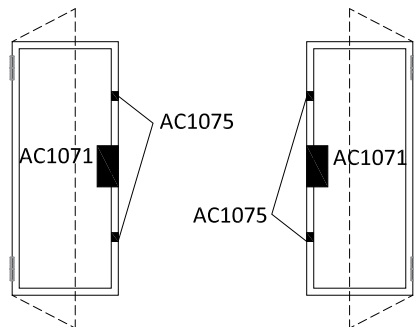
AC1075

- 10) Diverters (n° 2 items upper + lower)
- 11) Apron lining (n° 2 items upper + lower)
- 11) Bolt (n° 2 items upper + lower)
- 13) Stainless steel rods (n° 2 items upper + lower)
- 14) Plate (n° 2 items upper + lower)

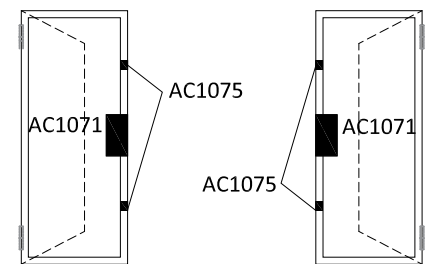


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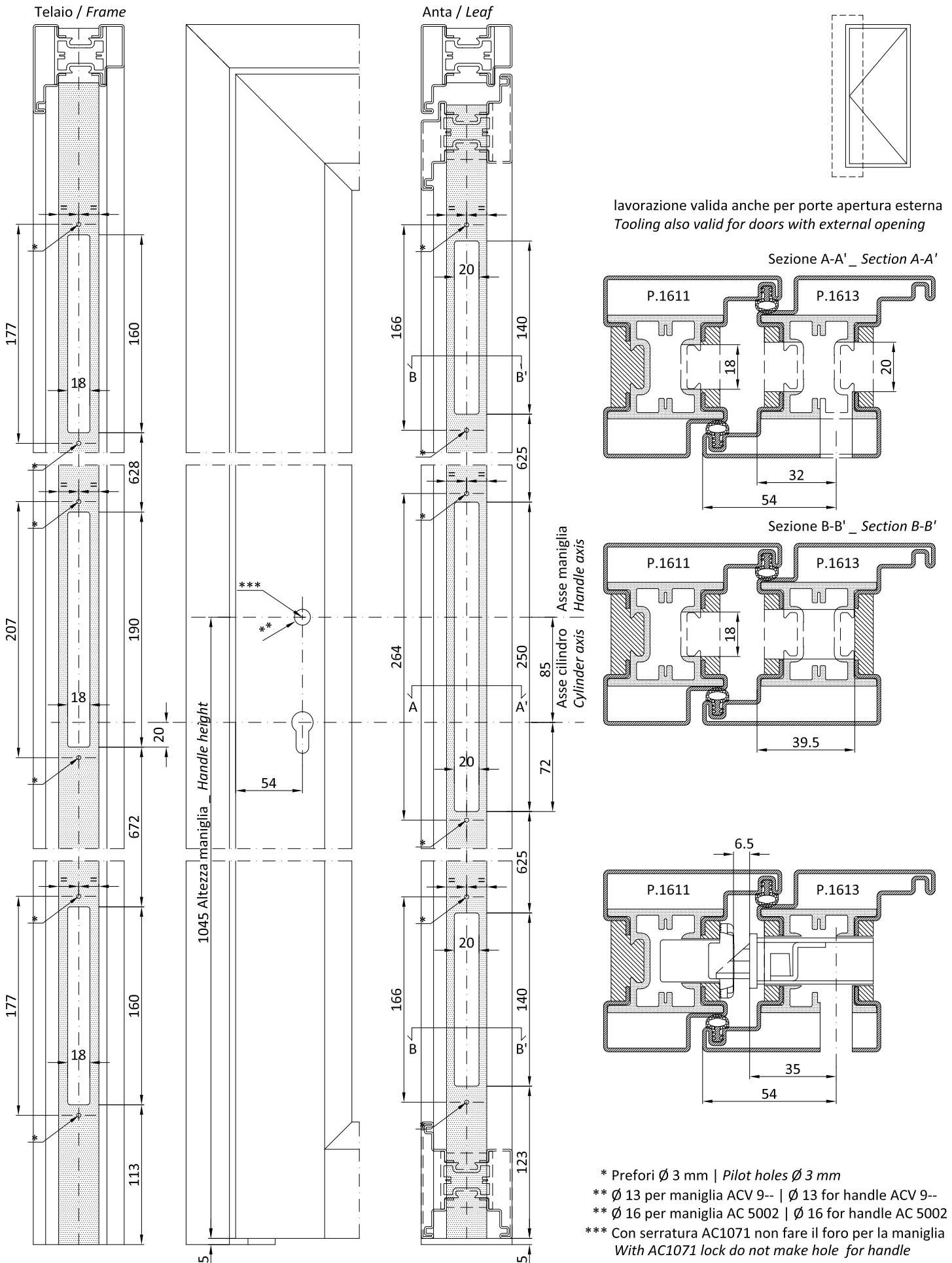
SCHEMA UTILIZZO SERRATURE E TERZE CHIUSURE
DIAGRAM FOR THE USE OF LOCKS AND THIRD LOCKS

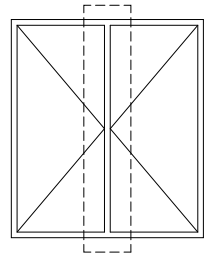
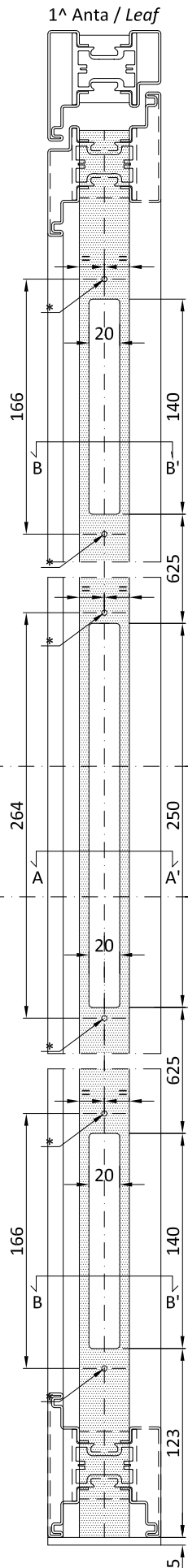
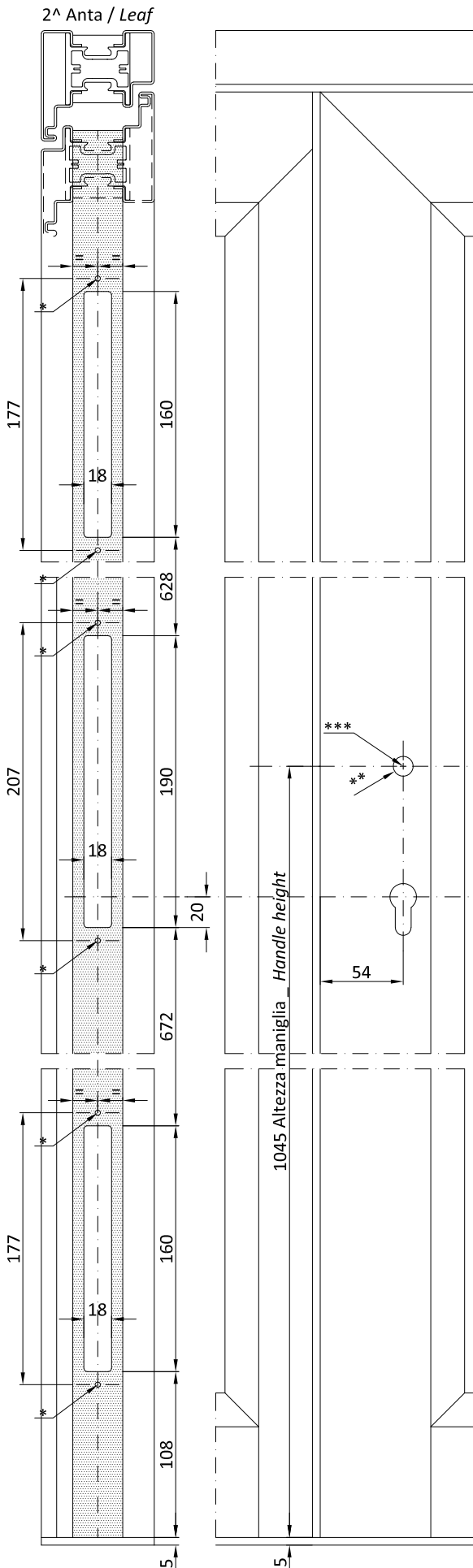


APERTURA INTERNA _ VISTA INTERNA
INWARDS OPENING _ INTERIOR ELEVATION

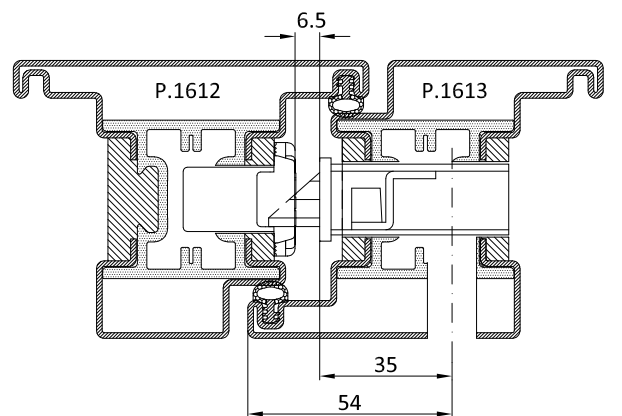
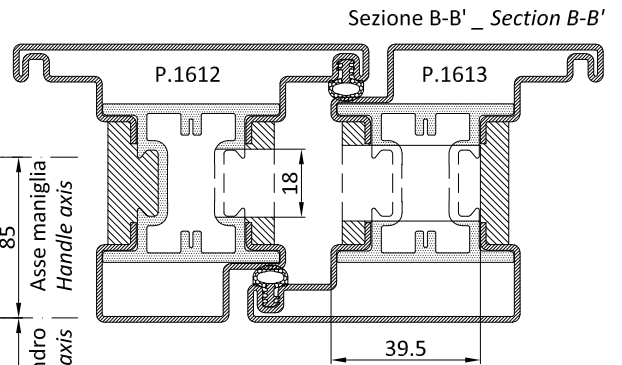
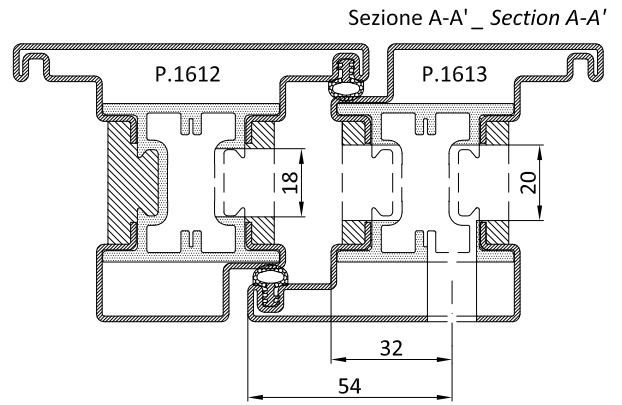


APERTURA ESTERNA _ VISTA INTERNA
OUTWARDS OPENING _ INTERIOR ELEVATION

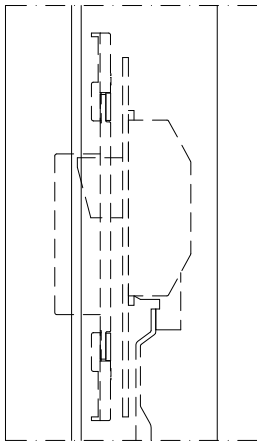




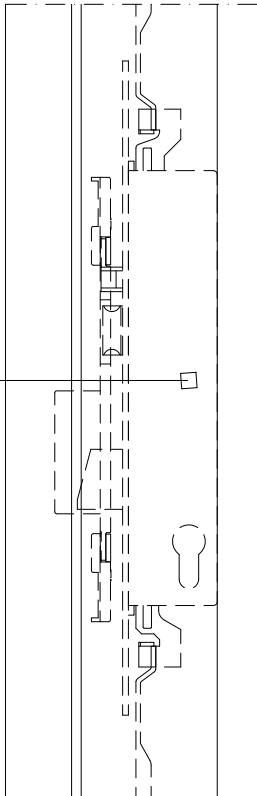
lavorazione valida anche per porte apertura esterna
Tooling also valid for doors with external opening



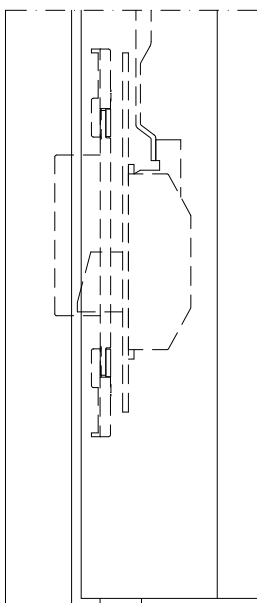
- * Prefori Ø 3 mm | Pilot holes Ø 3 mm
- ** Ø 13 per maniglia ACV 9-- | Ø 13 for handle ACV 9--
- ** Ø 16 per maniglia AC 5002 | Ø 16 for handle AC 5002
- *** Con serratura AC1071 non fare il foro per la maniglia
With AC1071 lock do not make hole for handle



- AC1072
- 1) Serratura
 - 2) Frontalino
 - 3) Riduttore di collegamento
 - 4) Scrocco
 - 5) Catenaccio
 - 6) Incontro per serratura
 - 7) Vite inox TS M5x50
 - 8) Perno fissaggio asta

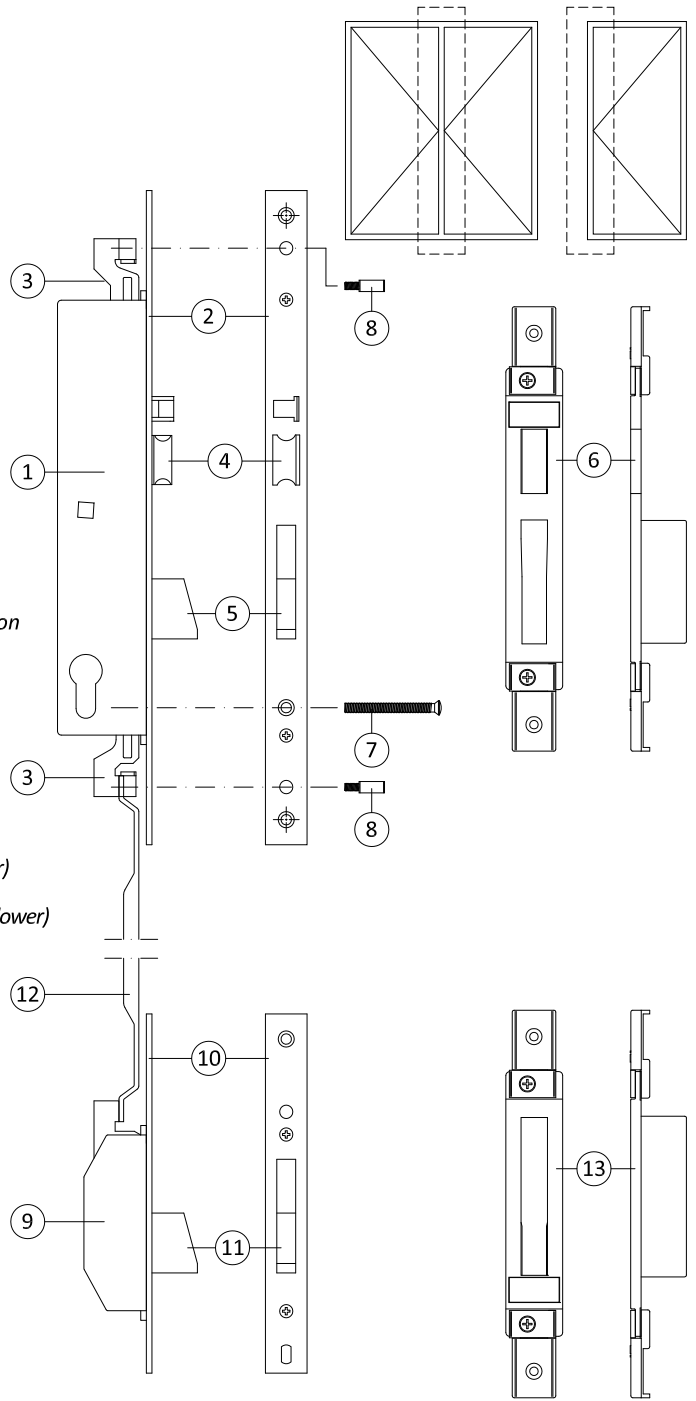


- AC1075
- 9) Deviatori (n°2 pezzi sup + inf.)
 - 10) Frontalino (n°2 pezzi sup + inf.)
 - 11) Catenaccio (n°2 pezzi sup + inf.)
 - 12) Aste inox (n°2 pezzi sup + inf.)
 - 13) Incontro (n°2 pezzi sup + inf.)



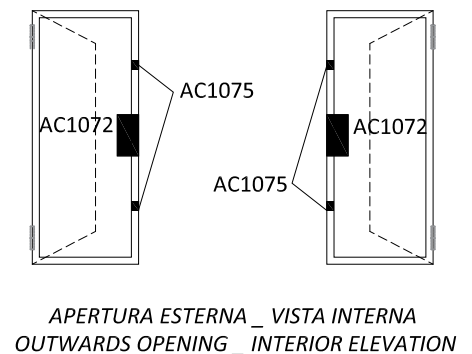
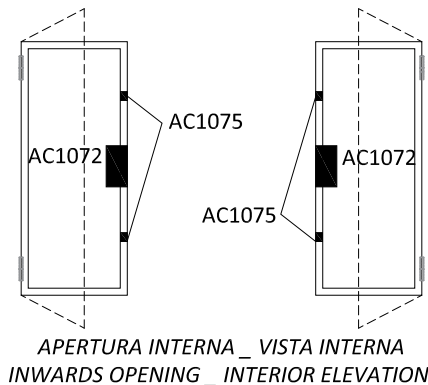
- AC1072
- 1) Lock
 - 2) Front plate
 - 3) Reduction unit/adaptor for connection
 - 4) Spring latch
 - 5) Bolt
 - 6) Strike plate
 - 7) Stainless steel screws TS M5x50
 - 8) Pin for anchoring the rod

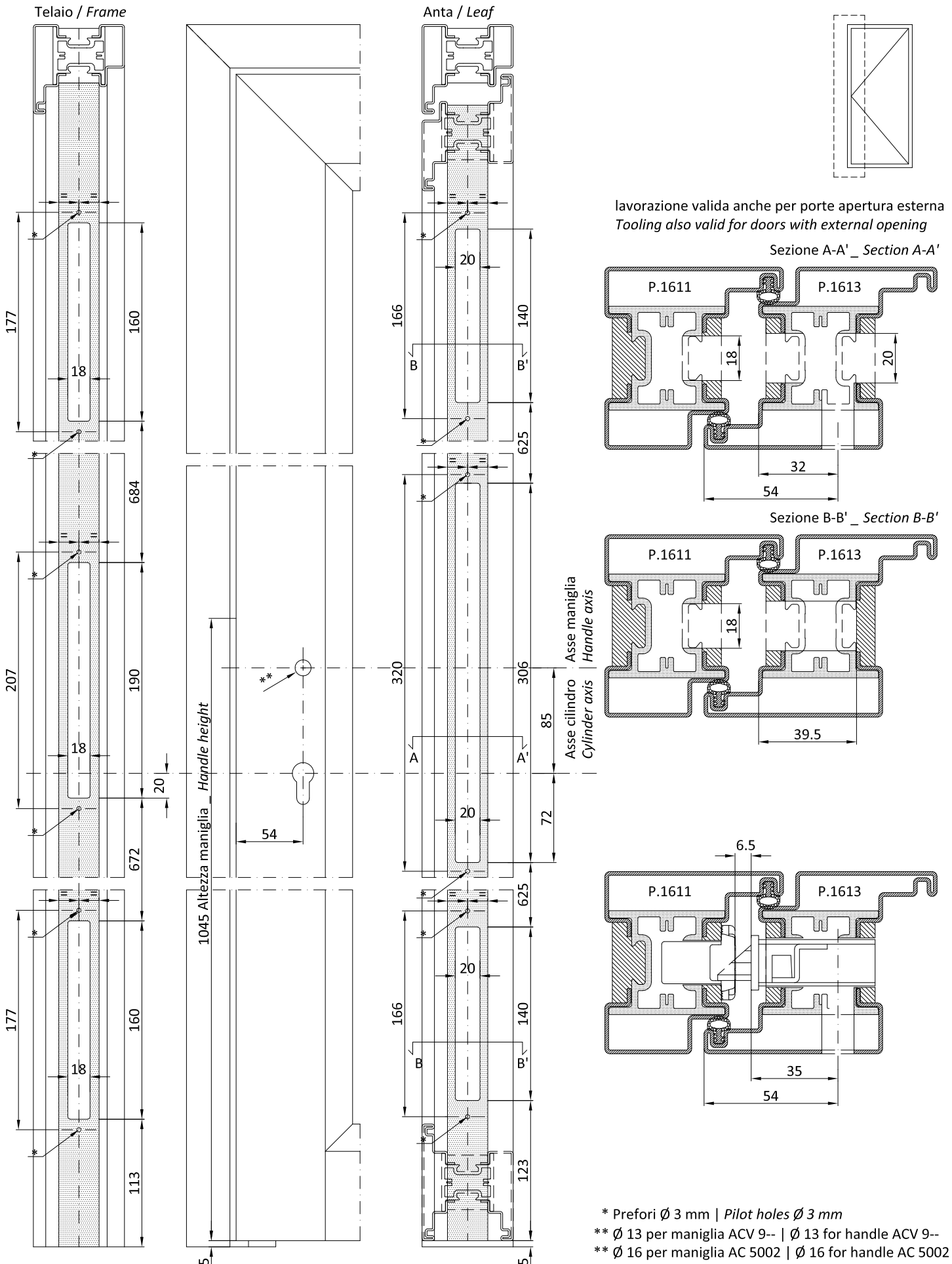
- AC1075
- 9) Diverters (n° 2 items upper + lower)
 - 10) Apron lining (n° 2 items upper + lower)
 - 11) Bolt (n° 2 items upper + lower)
 - 12) Stainless steel rods (n° 2 items upper + lower)
 - 13) Plate (no. 2 items upper + lower)



1050

SCHEMA UTILIZZO SERRATURE E TERZE CHIUSURE
DIAGRAM FOR THE USE OF LOCKS AND THIRD LOCKS





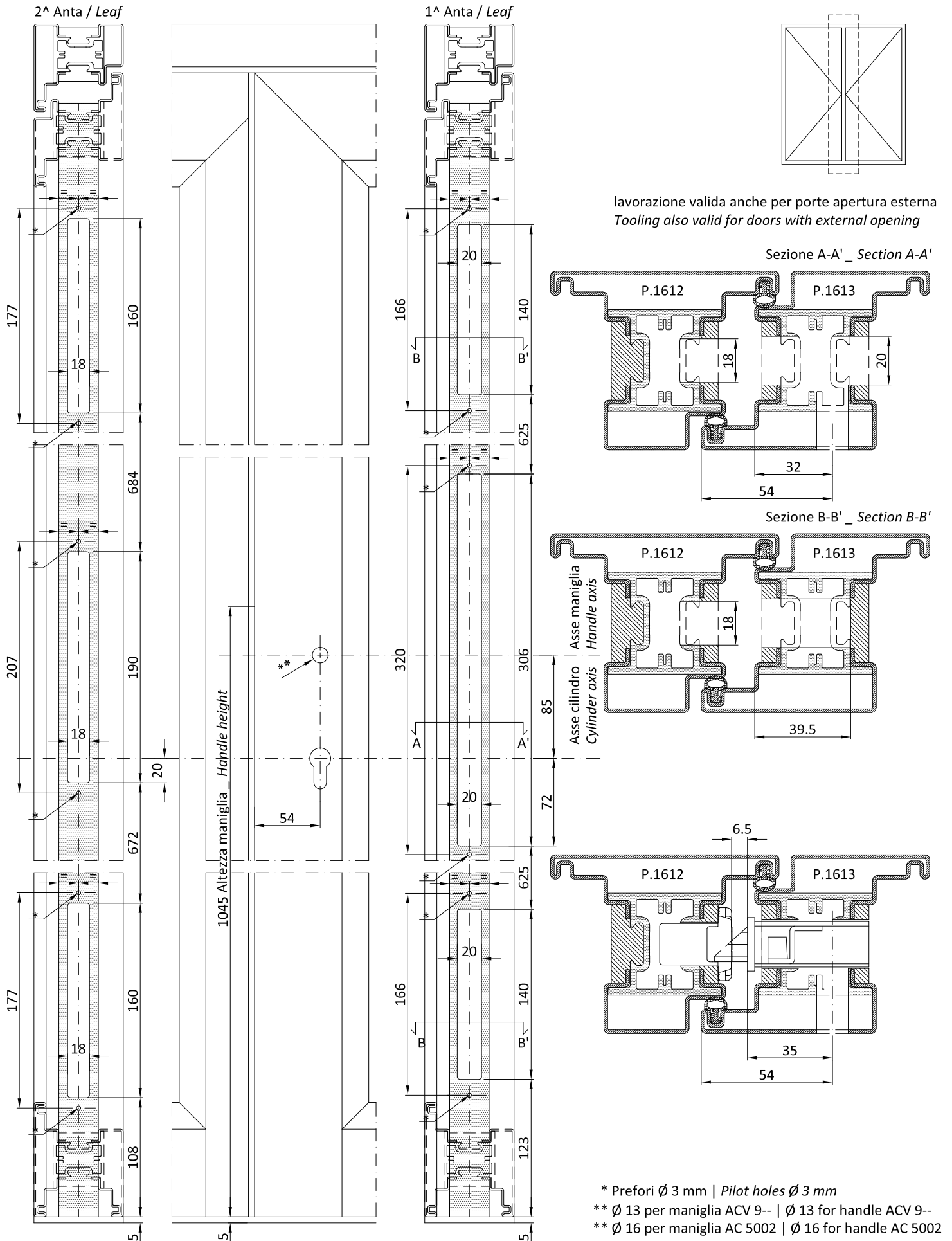
lavorazione valida anche per porte apertura esterna
Tooling also valid for doors with external opening

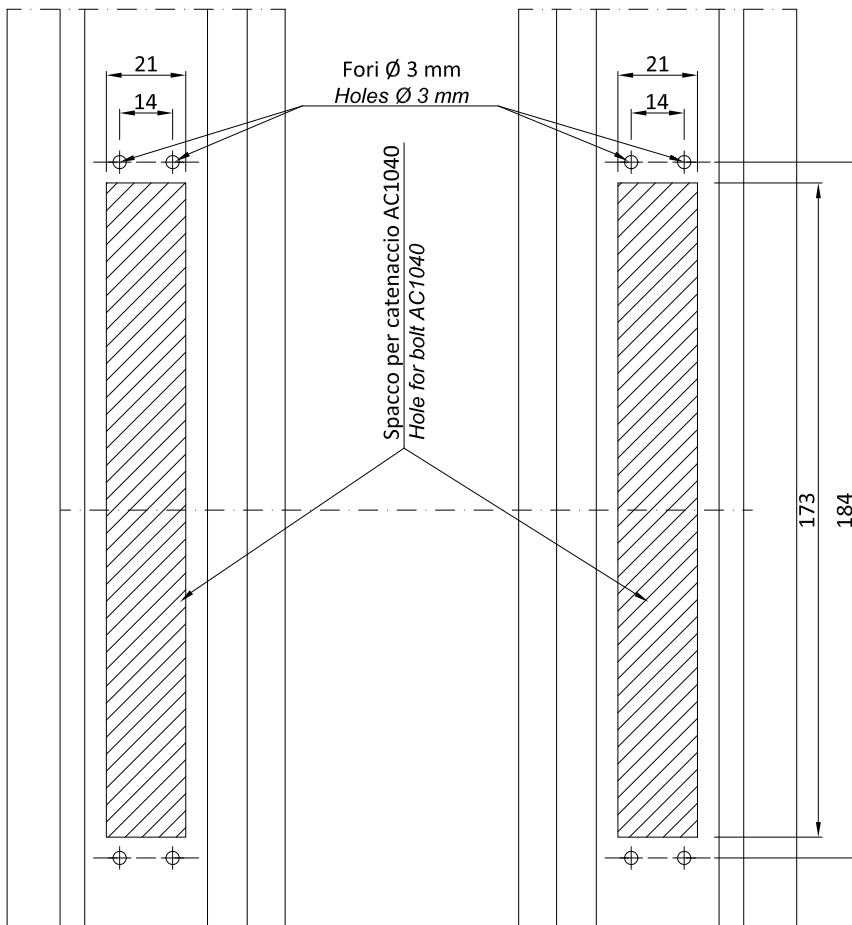
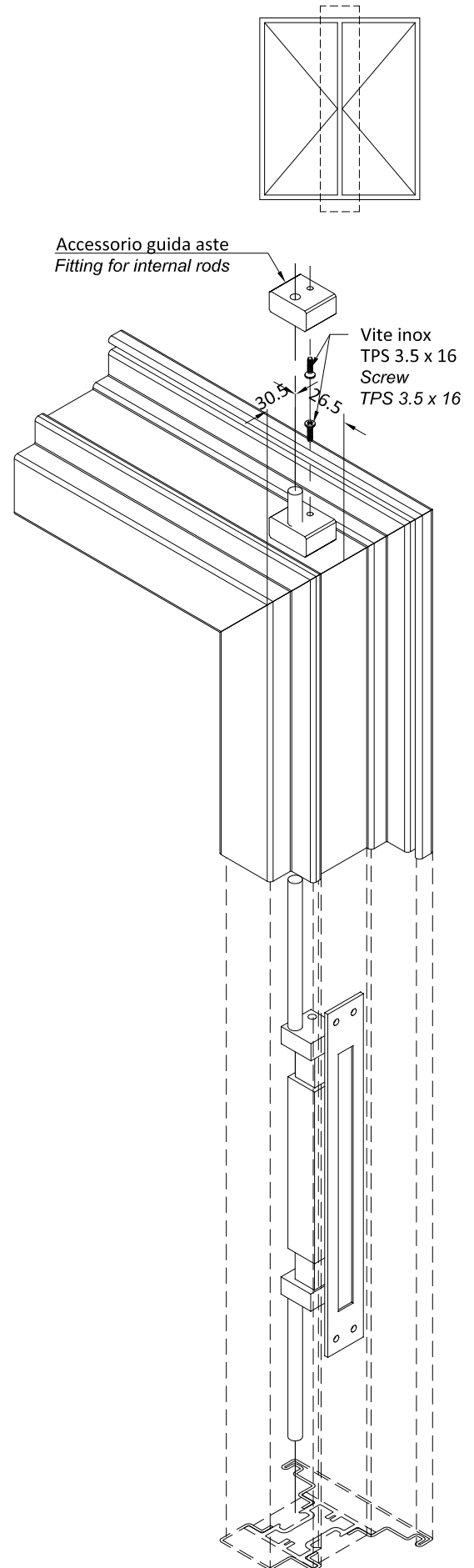
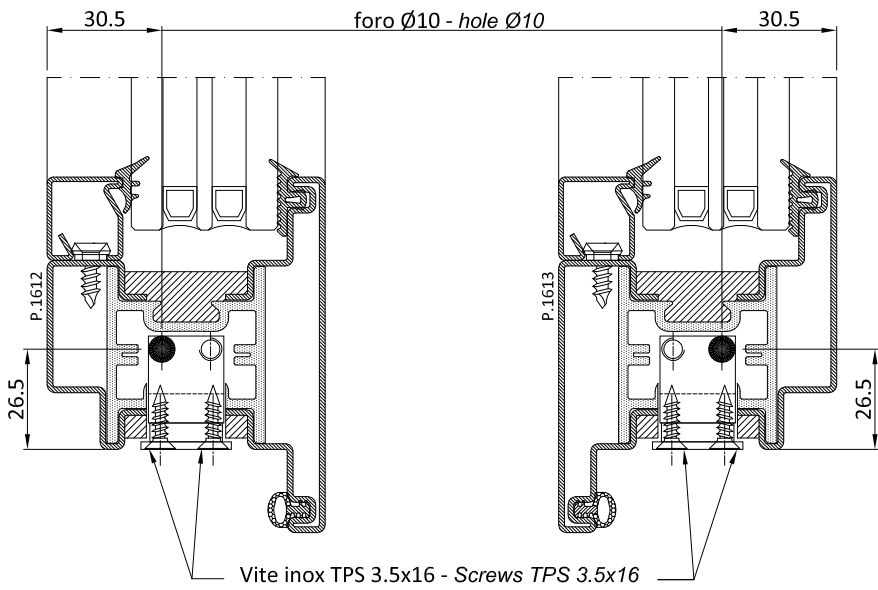
Sezione A-A' / Section A-A'

Sezione B-B' / Section B-B'

Asse maniglia / Handle axis
Asse cilindro / Cylinder axis

- * Prefori Ø 3 mm | Pilot holes Ø 3 mm
- ** Ø 13 per maniglia ACV 9-- | Ø 13 for handle ACV 9--
- ** Ø 16 per maniglia AC 5002 | Ø 16 for handle AC 5002



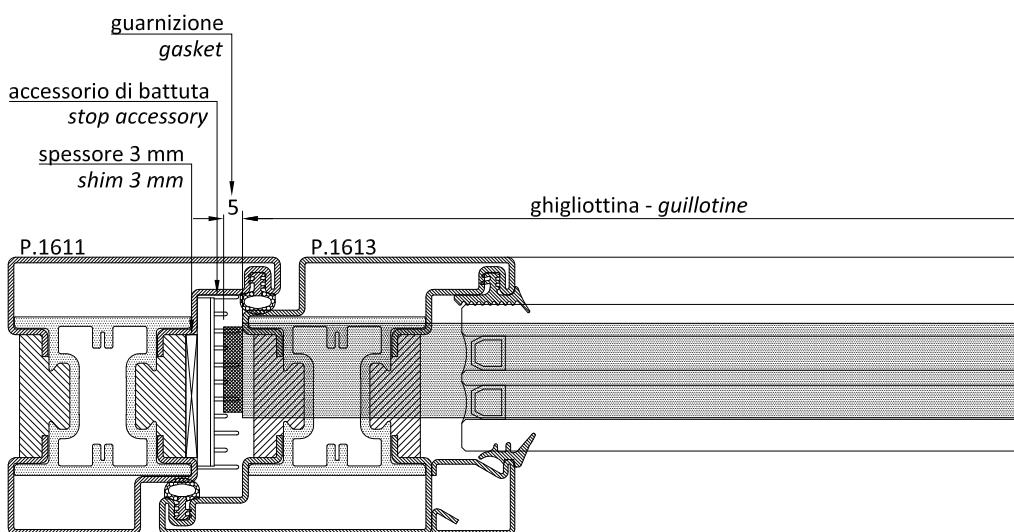
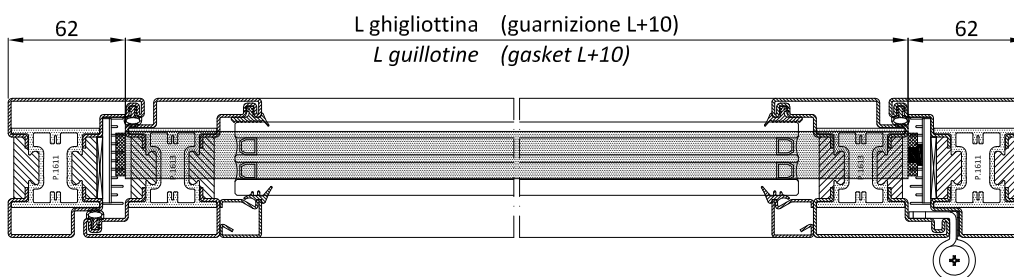
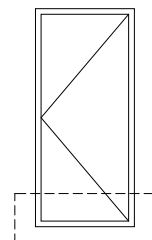


Aste Ø 7 mm L. mm 1500
Ø 7 mm L. mm 1500 rods

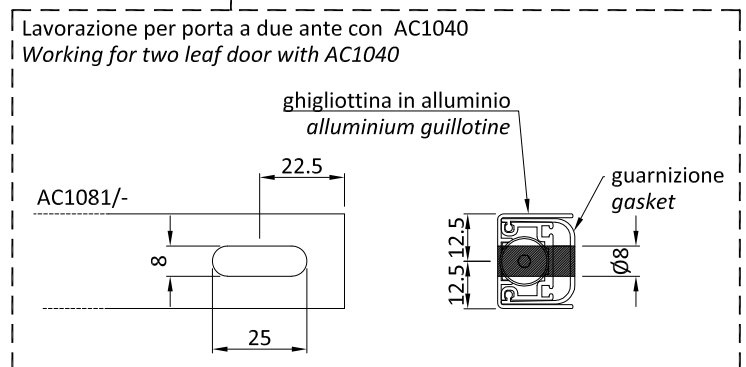
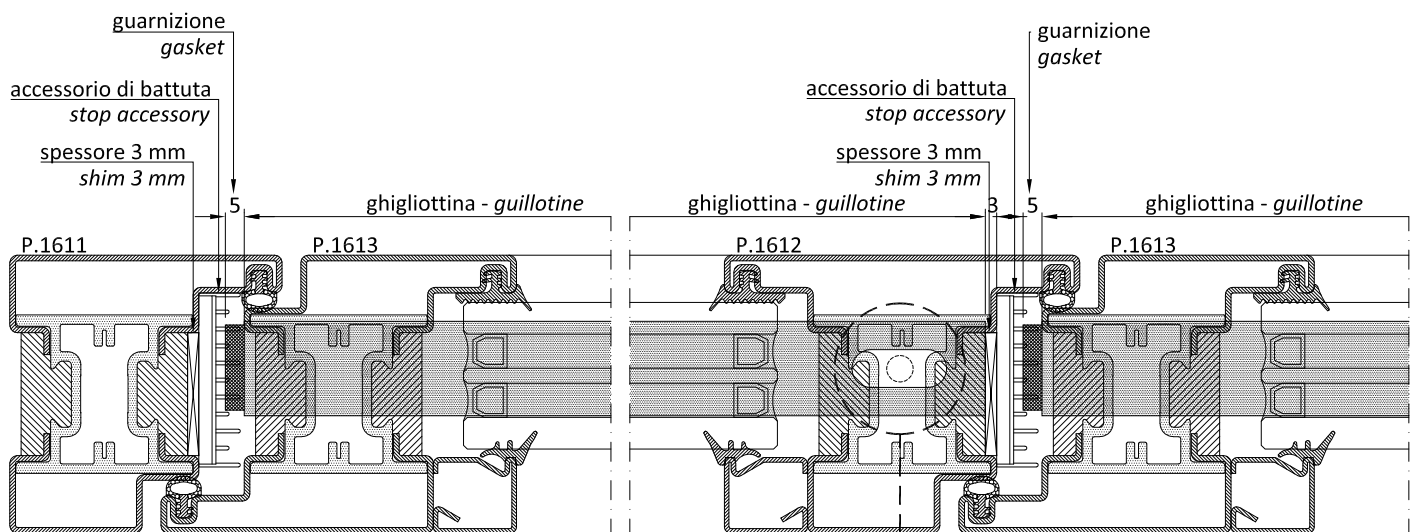
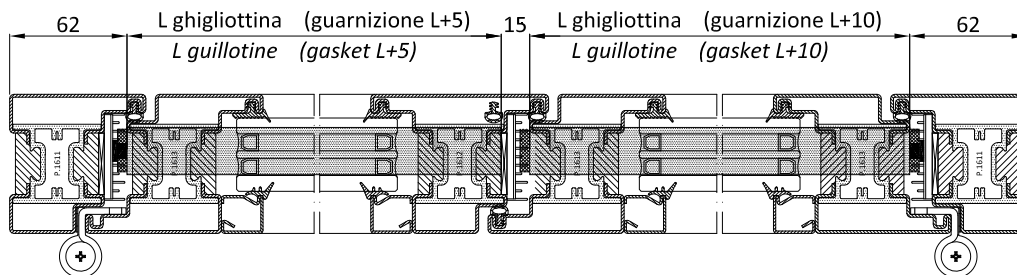
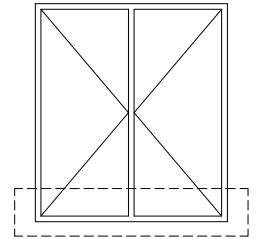


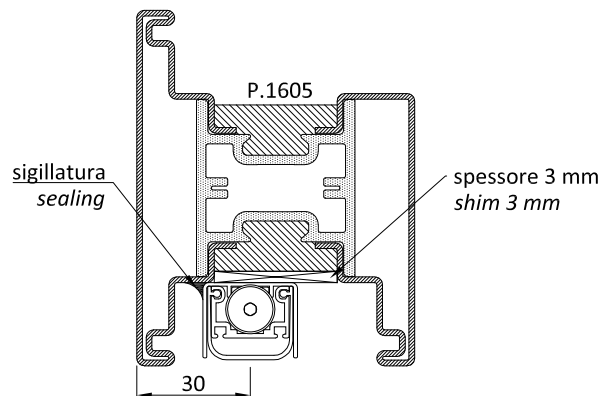
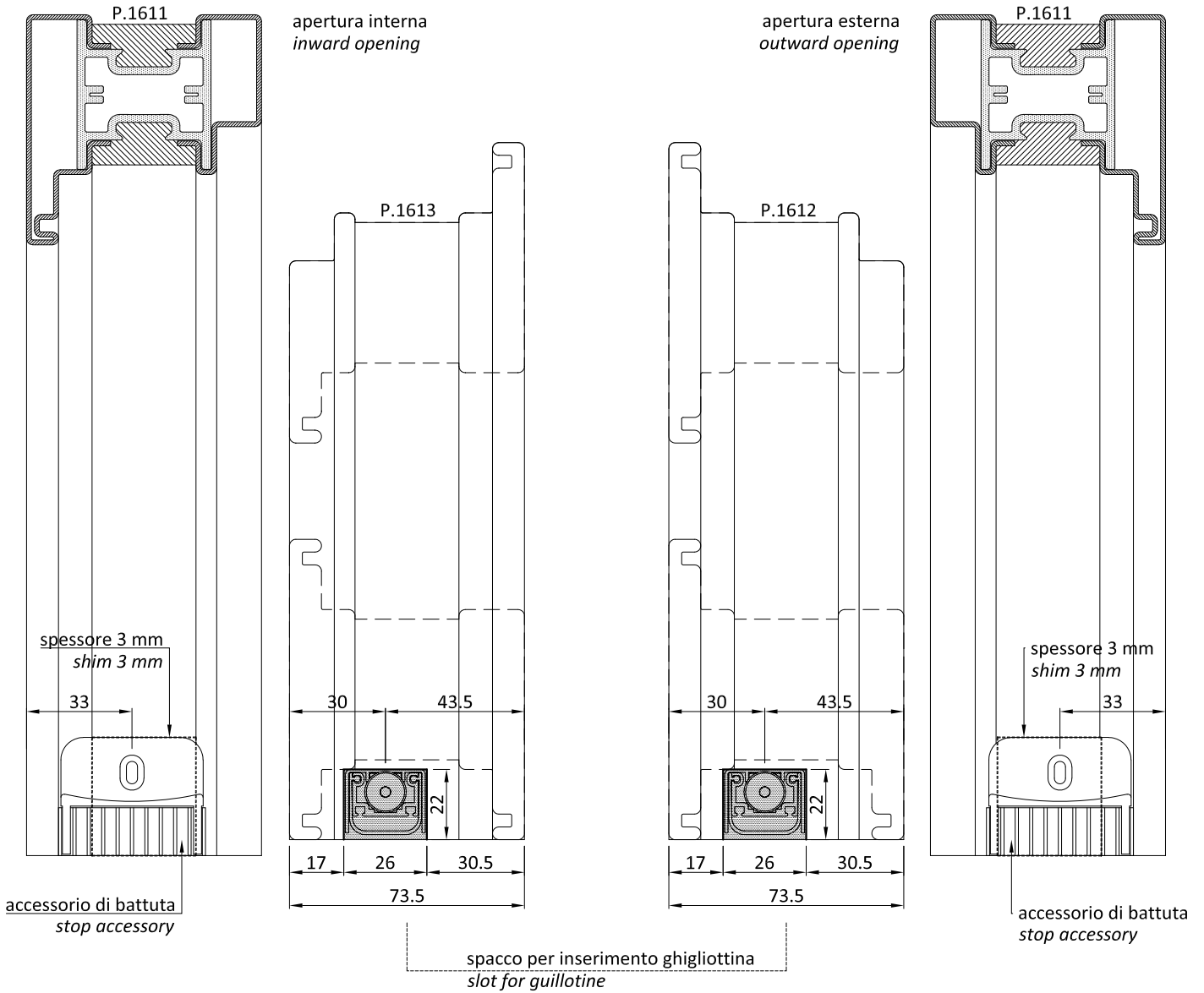
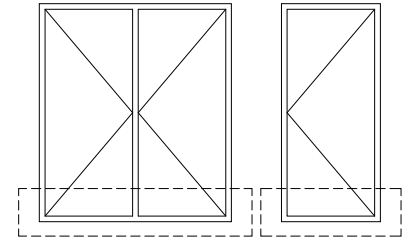
AC1040 catenaccio
AC1040 bolt

cod.	dimensioni dimensions [mm]
AC1081/A	615 → 730
AC1081/B	715 → 830
AC1081/C	815 → 930
AC1081/D	915 → 1030
AC1081/E	1015 → 1130
AC1081/F	1115 → 1230



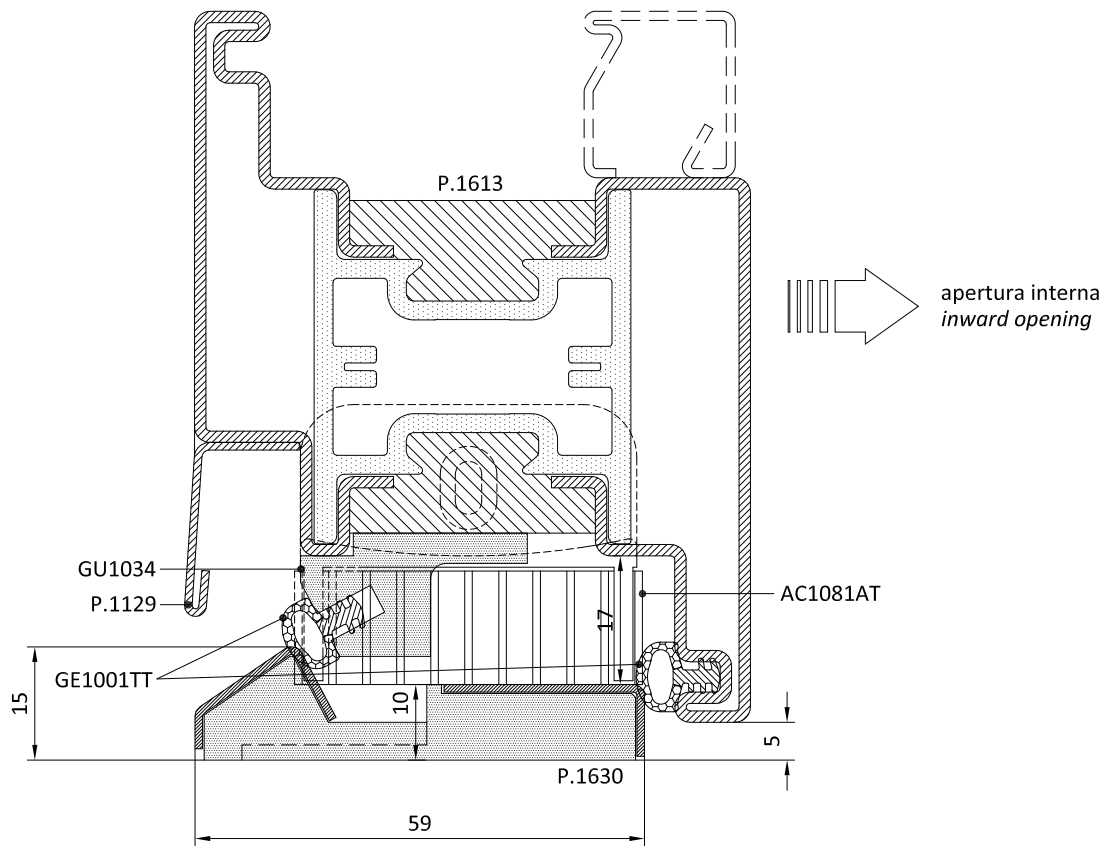
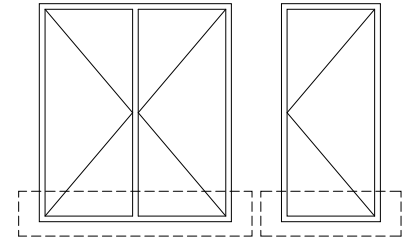
cod.	dimensioni dimensions [mm]
AC1081/A	615 → 730
AC1081/B	715 → 830
AC1081/C	815 → 930
AC1081/D	915 → 1030
AC1081/E	1015 → 1130
AC1081/F	1115 → 1230

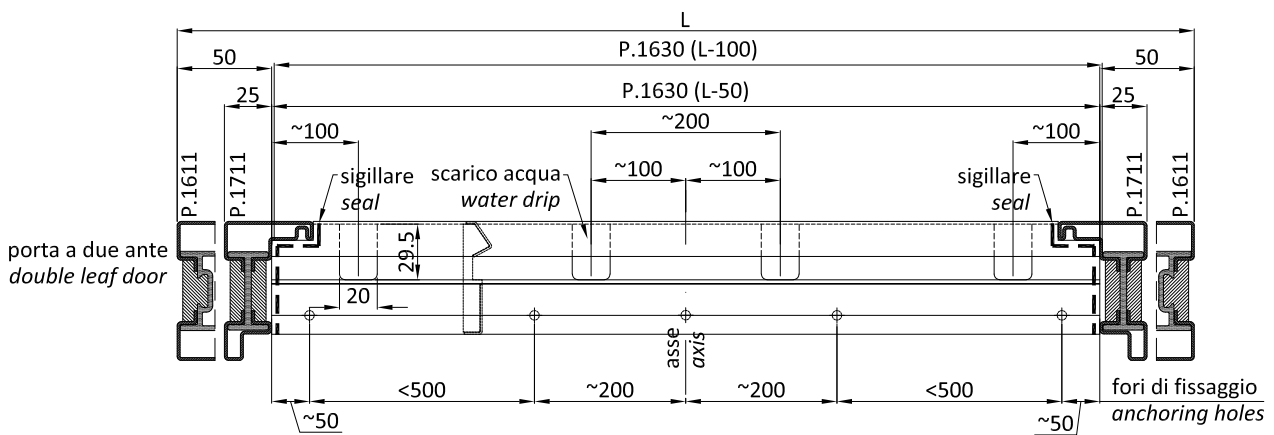
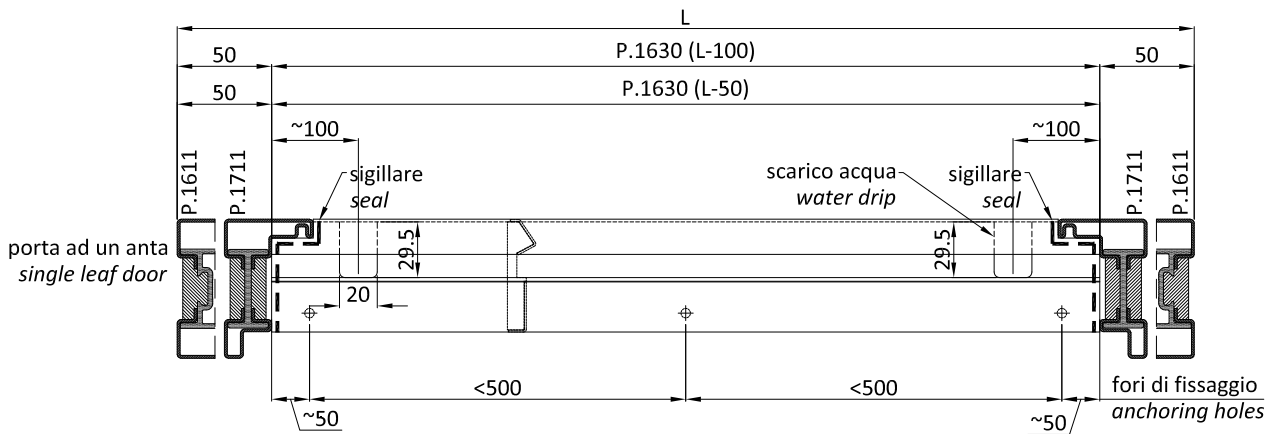
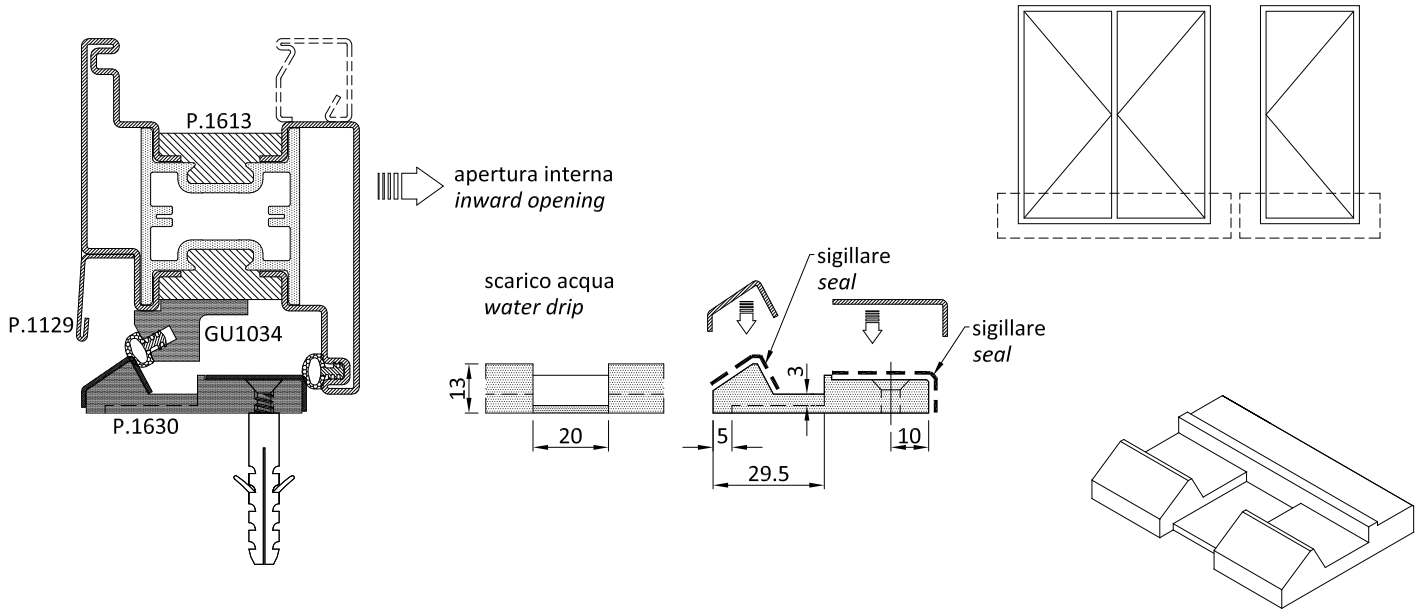


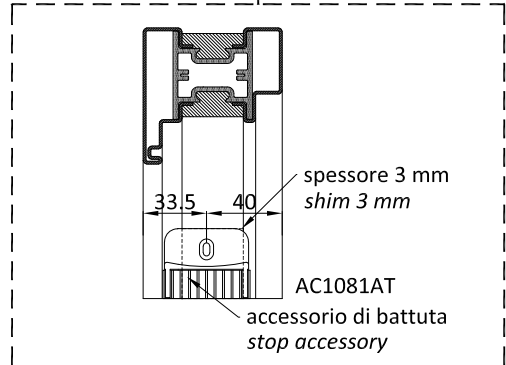
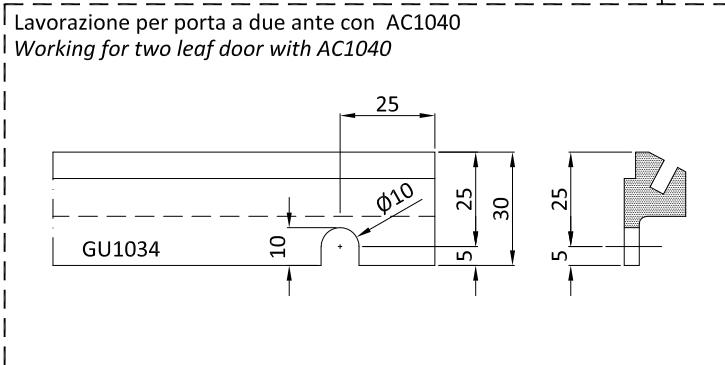
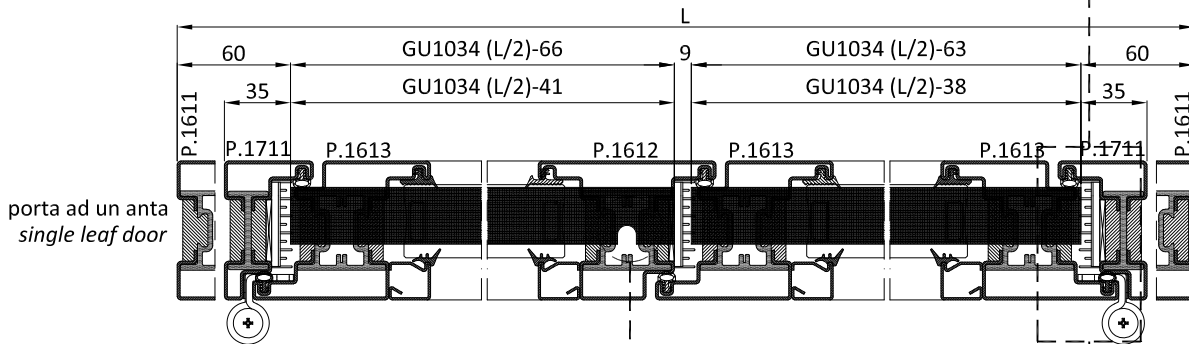
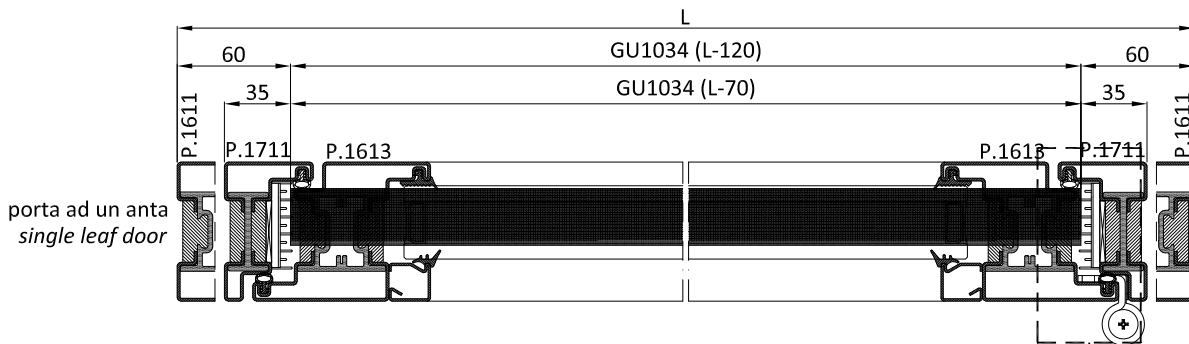
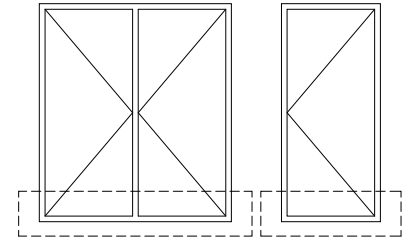
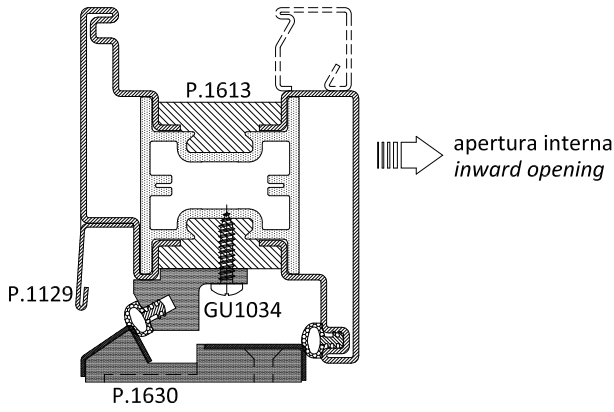


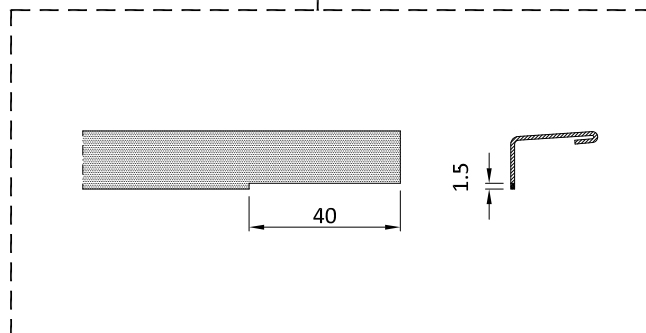
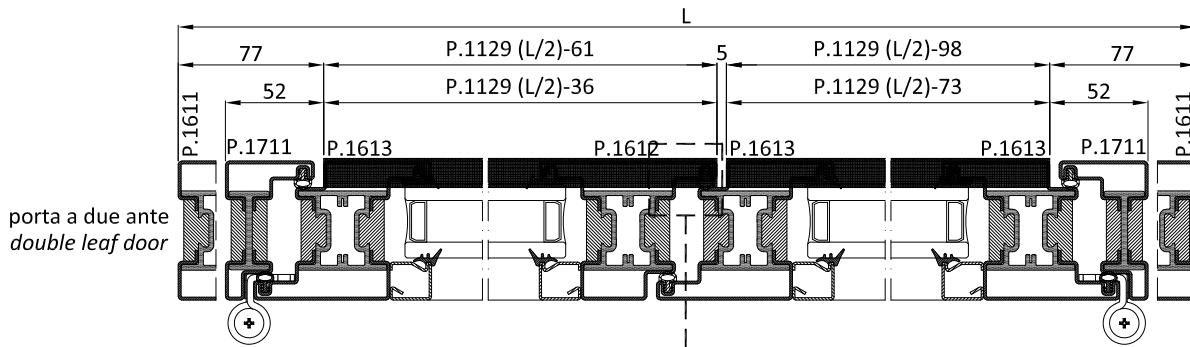
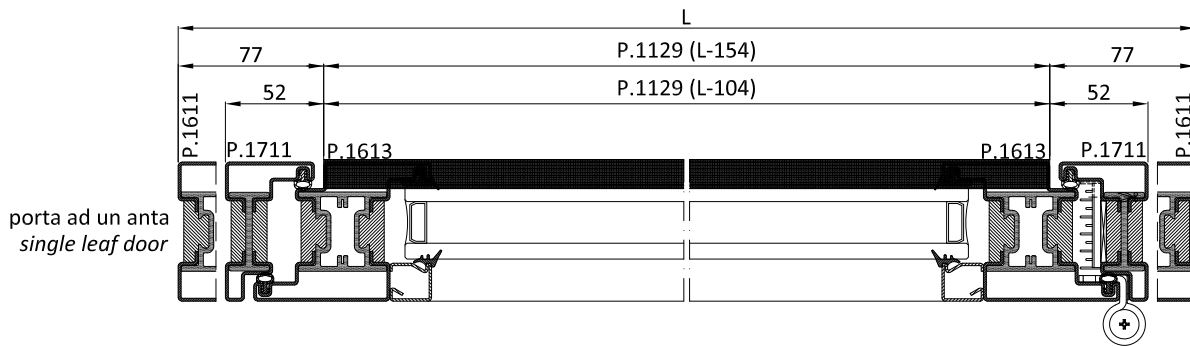
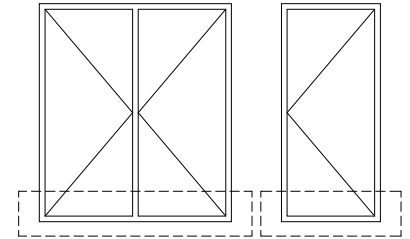
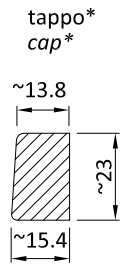
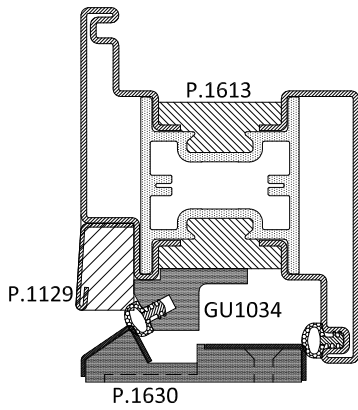
viti in dotazione
supplied screws



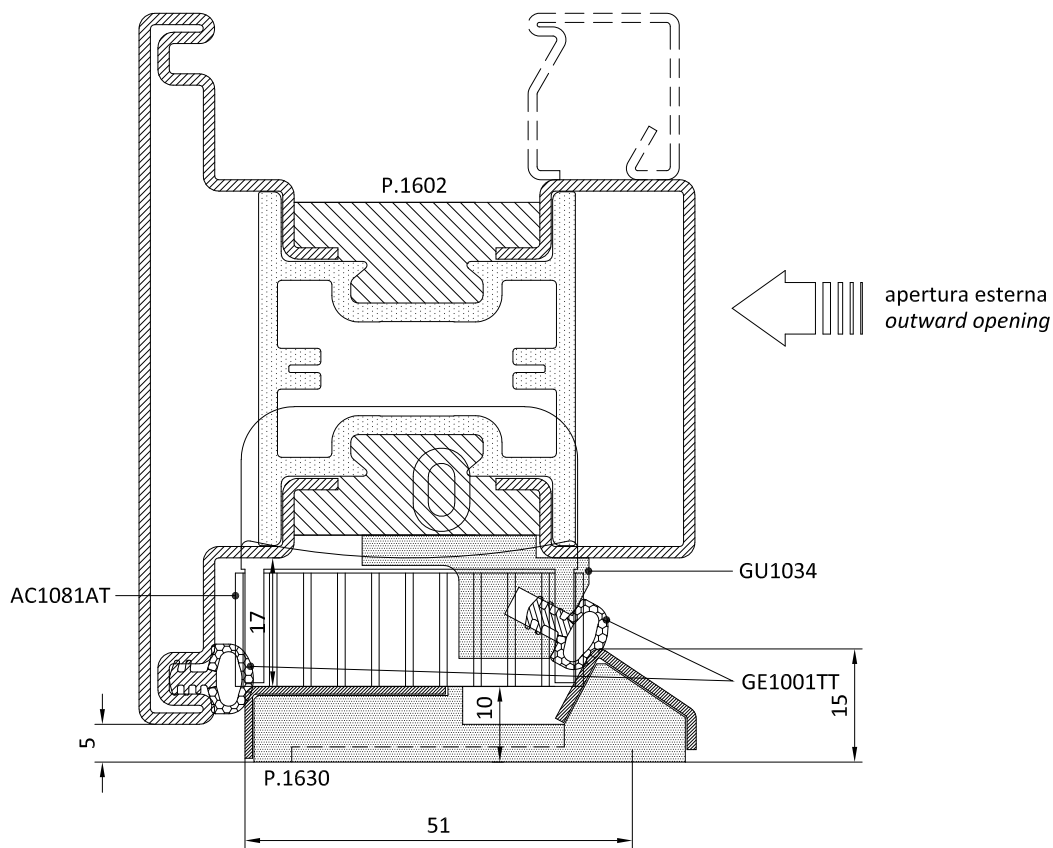
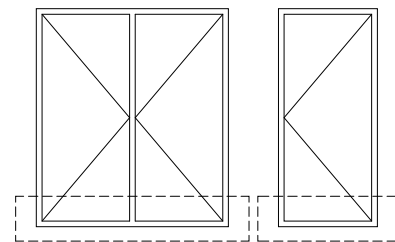


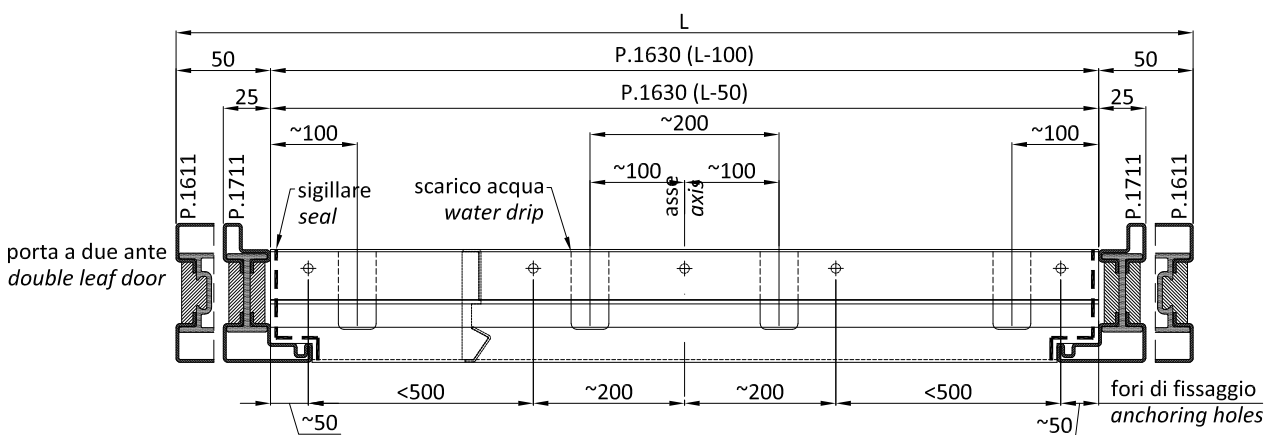
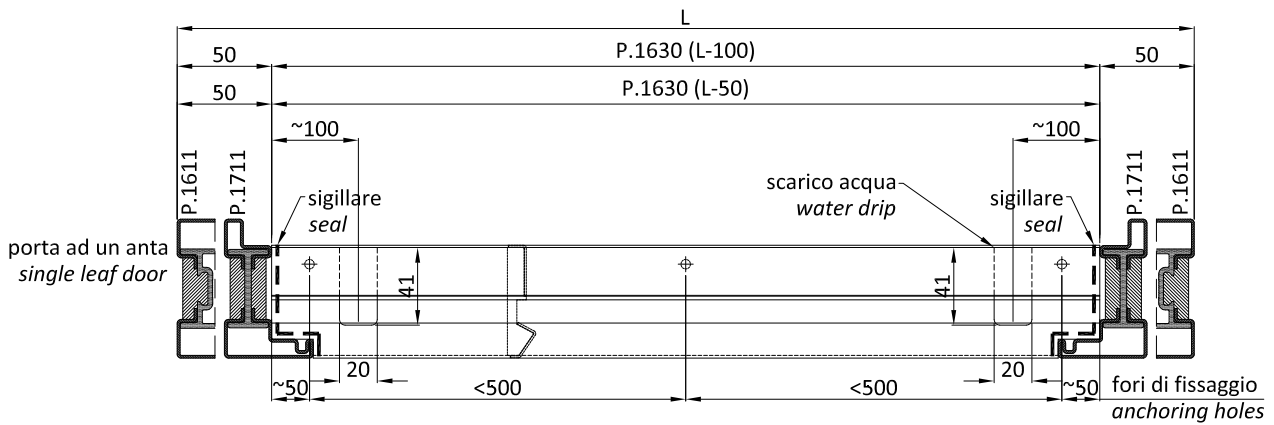
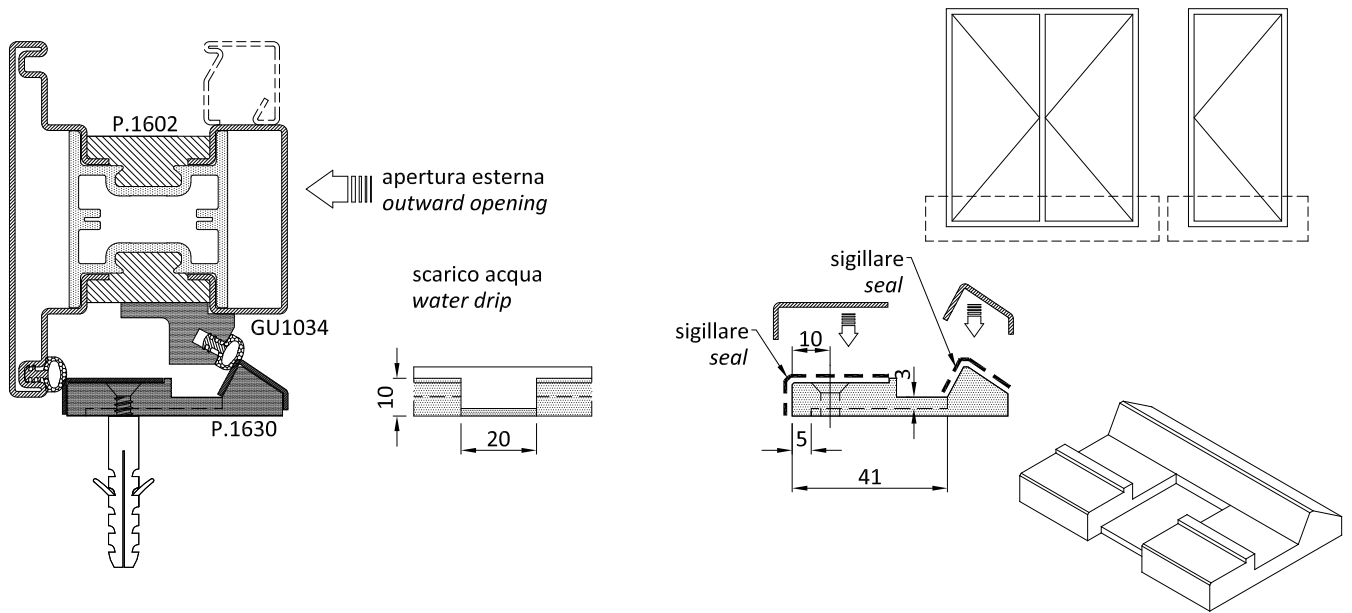


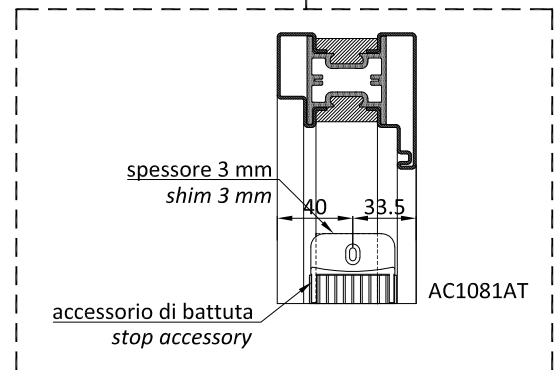
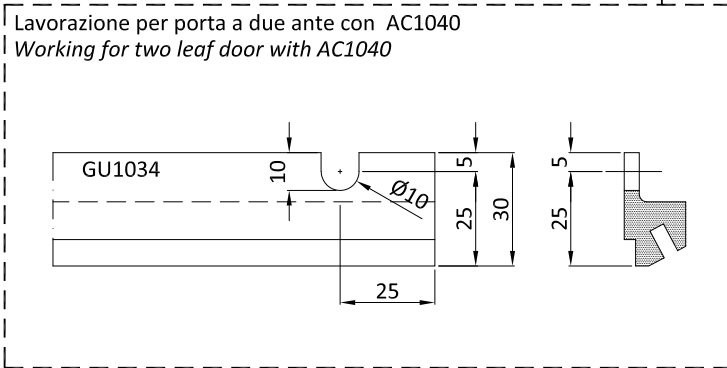
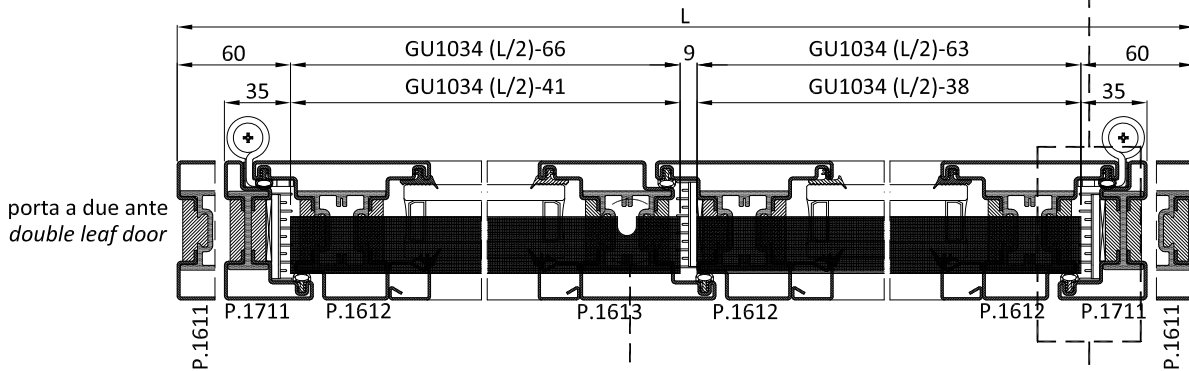
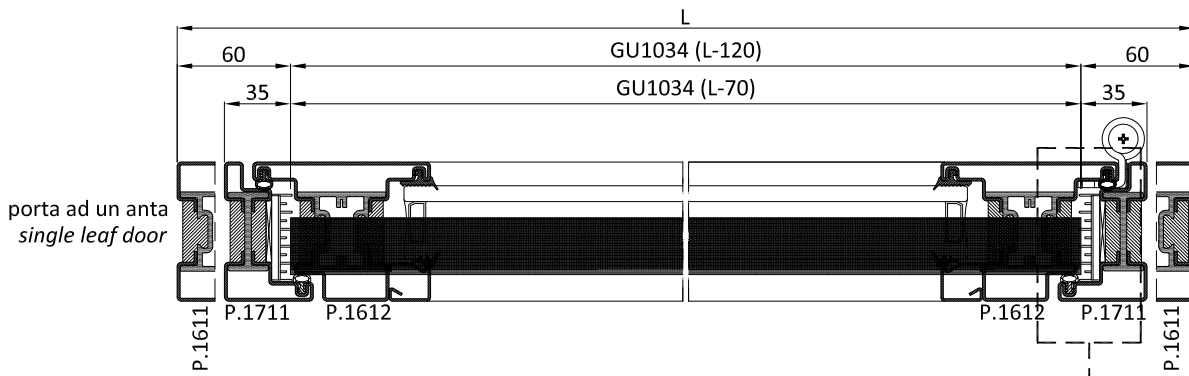
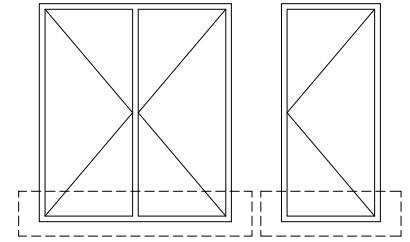
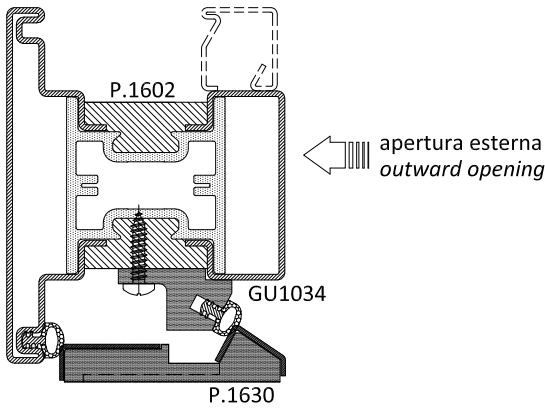


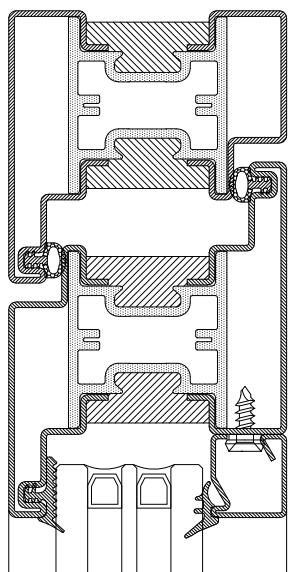
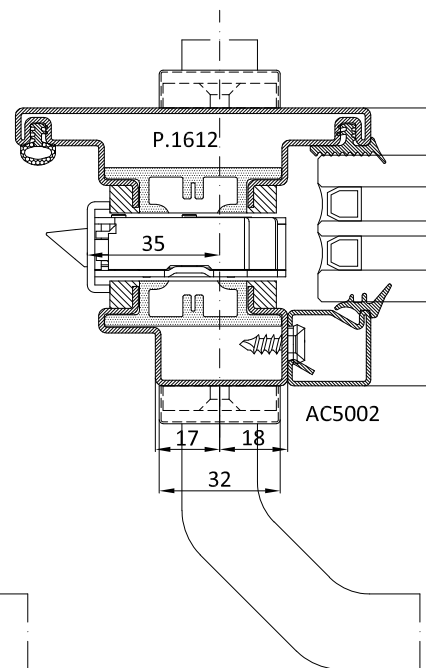
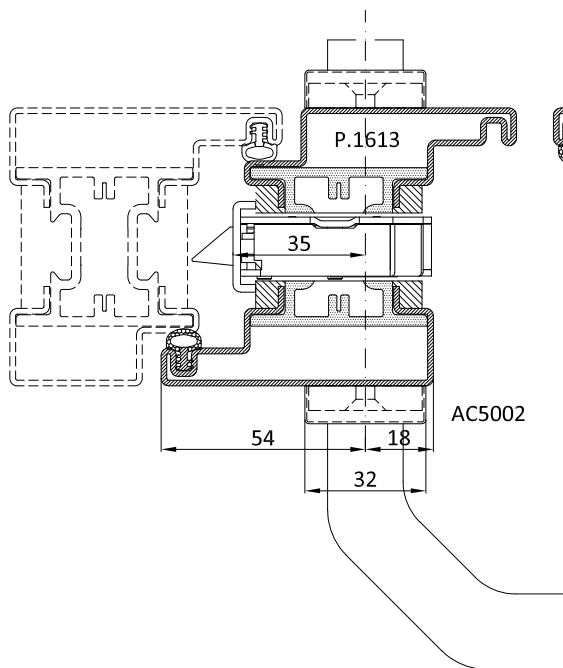
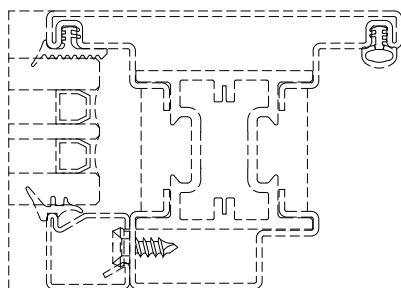
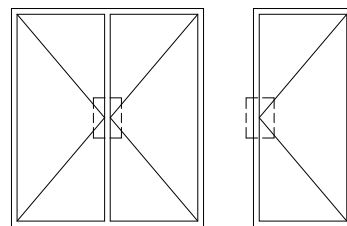


*non forniti
*not included







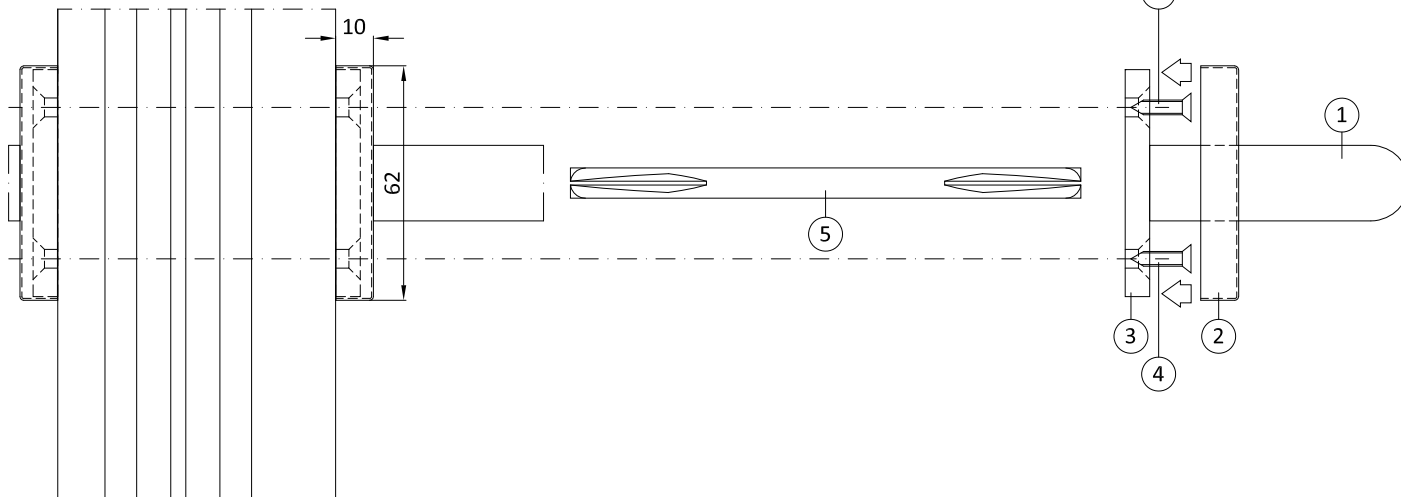


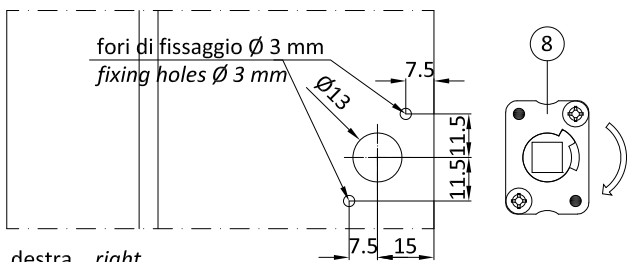
AC5002 :

- 1) Impugnatura
- 2) Rosetta
- 3) Corpo maniglia
- 4) Vite TPS 3.9x15.9
- 5) Quadro

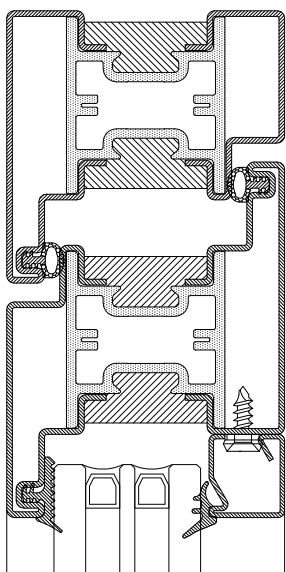
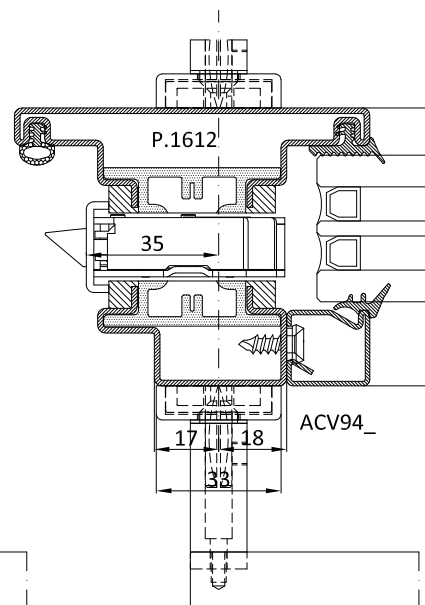
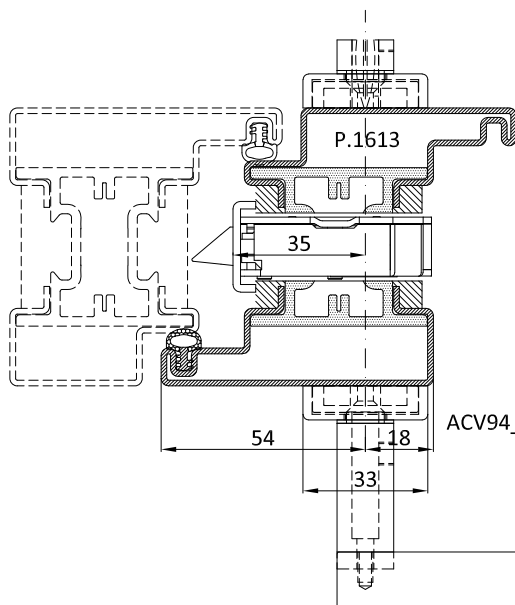
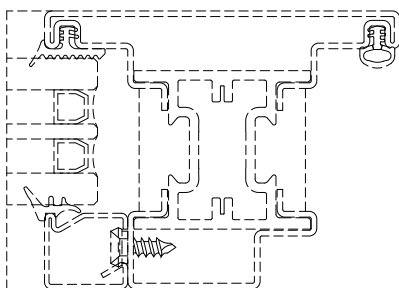
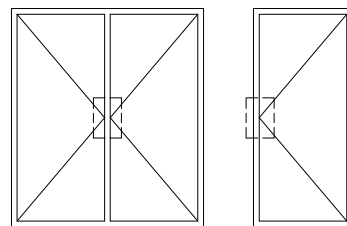
AC5002 :

- 1) Handle grip
- 2) Rose
- 3) Handle body
- 4) Countersunk head screws 3.9x15.9
- 5) Spindle bar





destra _right
Lavorazione speculare per anta SX
Same working for left hand

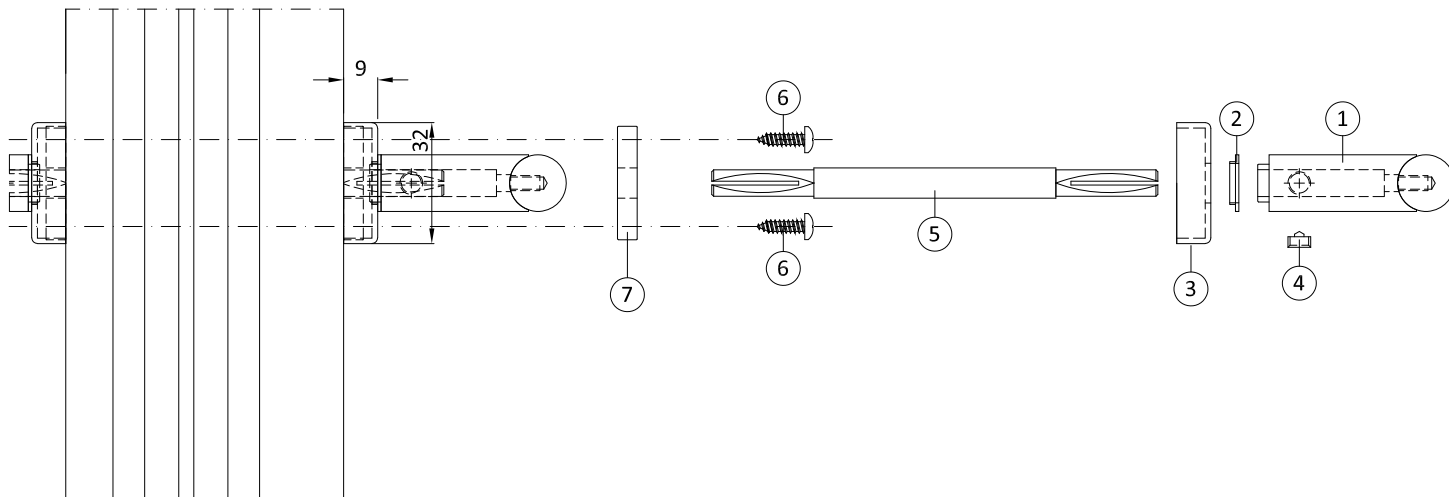


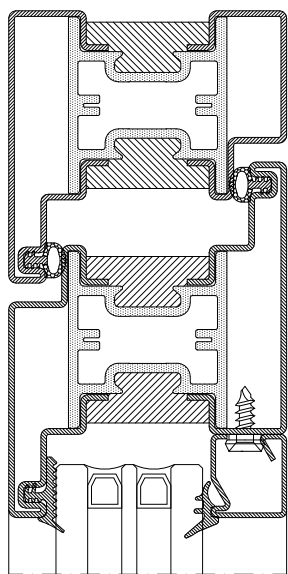
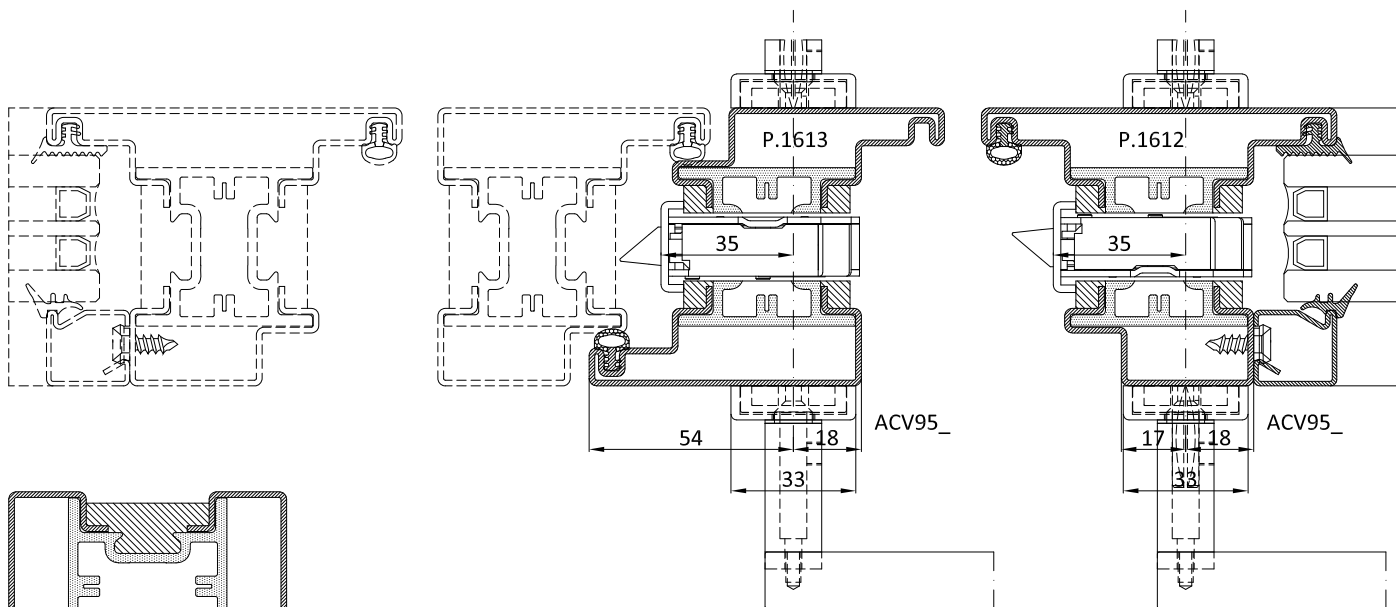
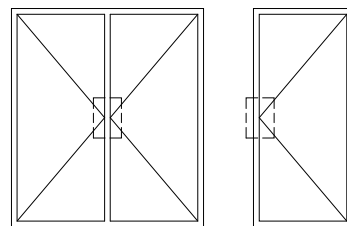
ACV94- :

- 1) Impugnatura
- 2) Rondella
- 3) Rosetta
- 4) Grano M6x6
- 5) Quadro
- 6) Vite TC 3.5x12.7
- 7) Molla

ACV94- :

- 1) Handle grip
- 2) Ring
- 3) Rose
- 4) Dowel M6x6
- 5) Spindle bar
- 6) Flat head screws 3.5x12.7
- 7) Spring



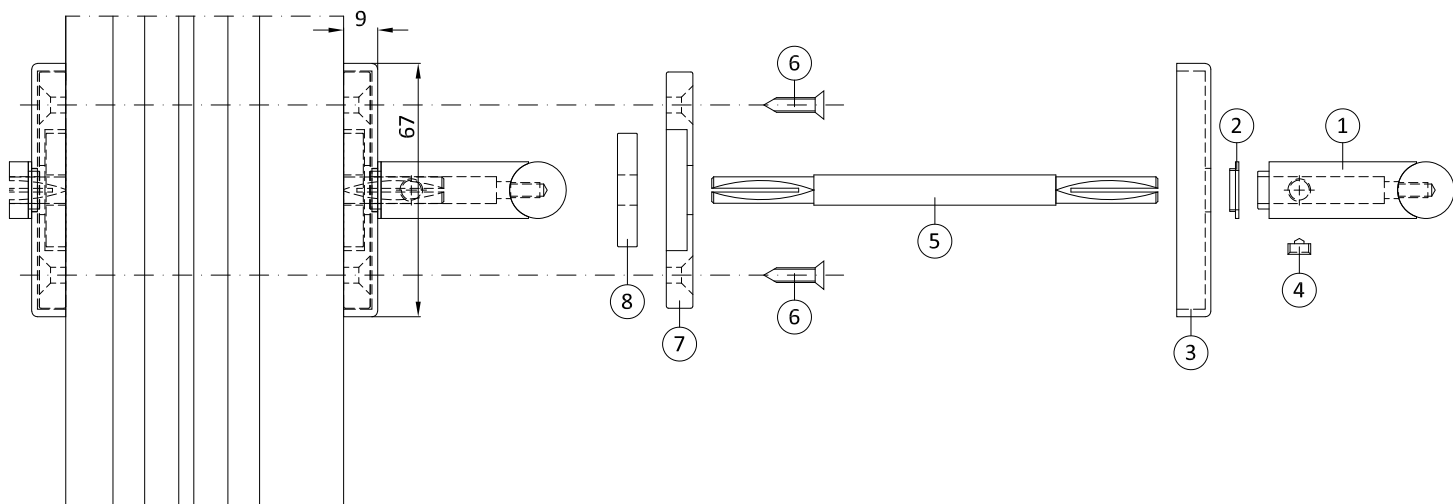


ACV95- :

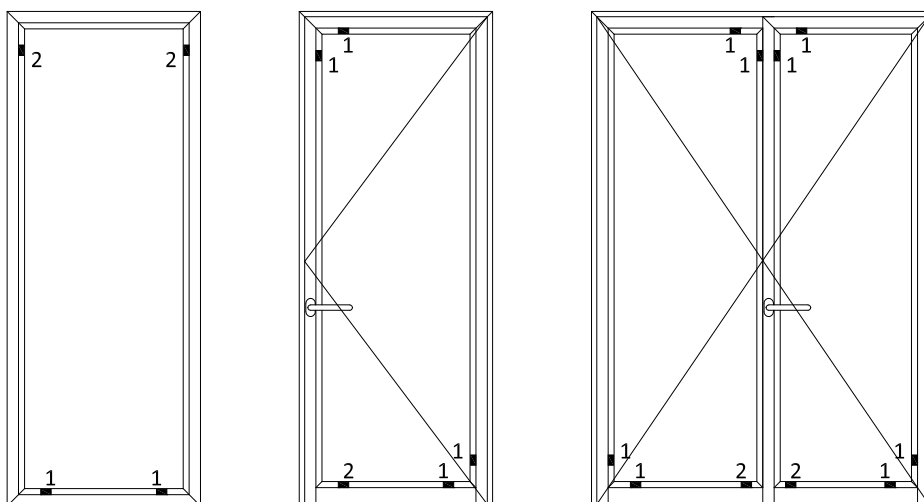
- 1) Impugnatura
- 2) Rondella
- 3) Rosetta
- 4) Grano M6x6
- 5) Quadro
- 6) Vite TPS 3.9x15.9
- 7) Adattatore per molla
- 8) Molla

ACV95- :

- 1) Handle grip
- 2) Ring
- 3) Rose
- 4) Dowel M6x6
- 5) Spindle bar
- 6) Countersunk head screws 3.9x15.9
- 7) Adapter for spring
- 8) Spring

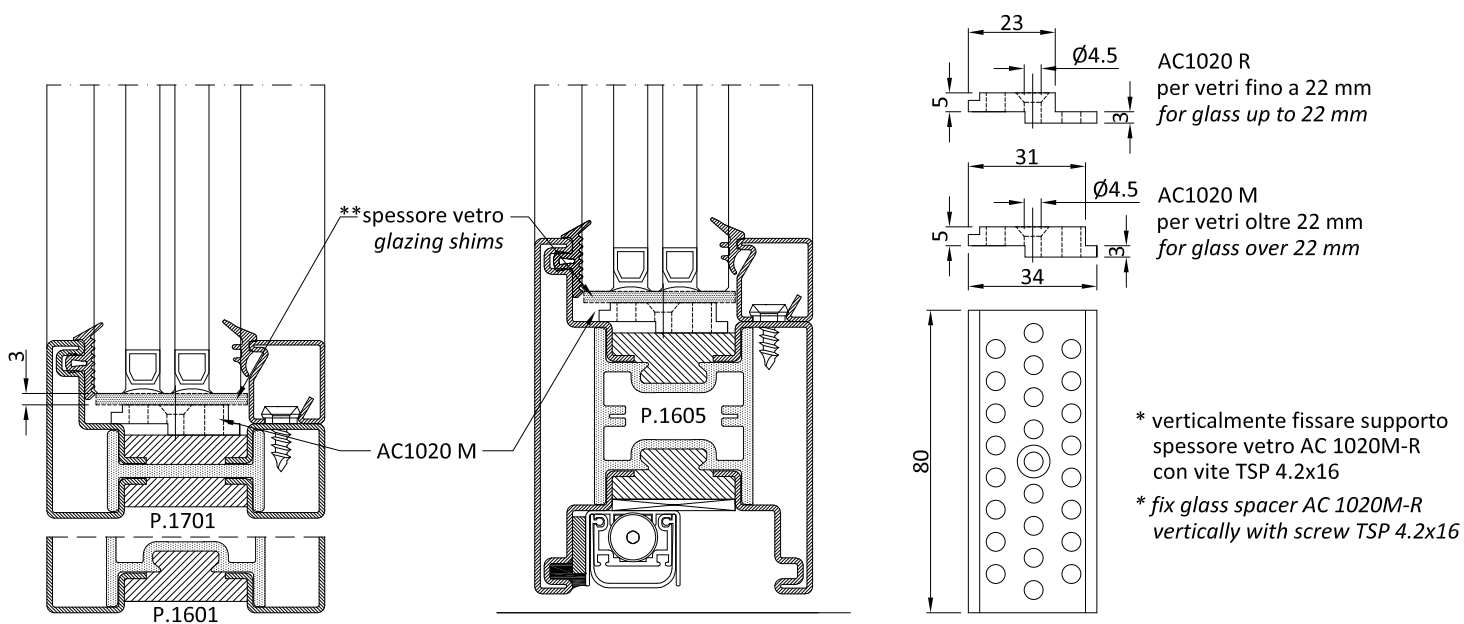


Porta | Door



1) spessore portante | carry shim

2) spessore distanziatore | compensation shim

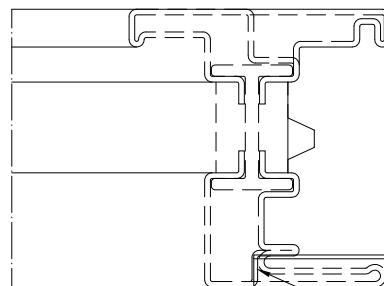
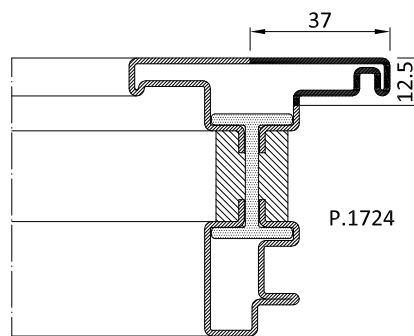
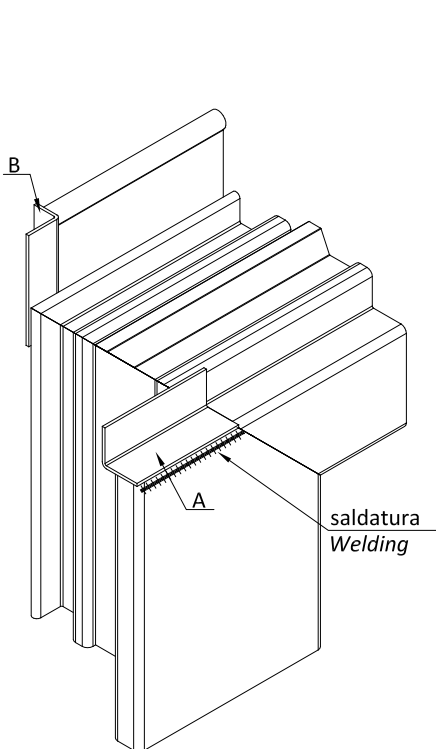
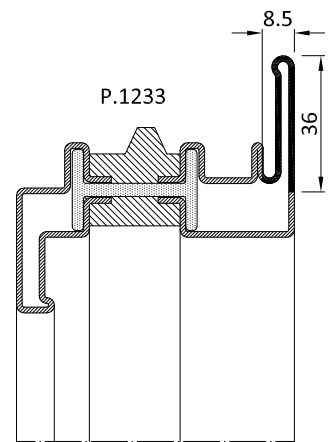
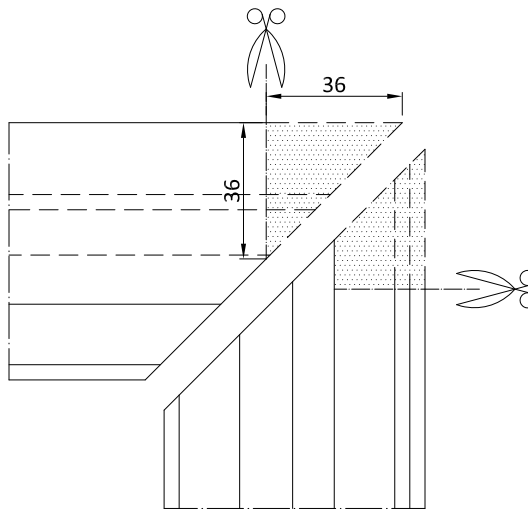
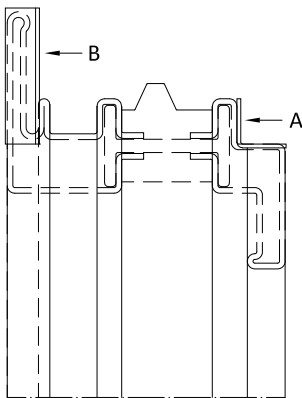
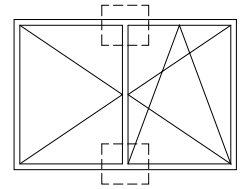
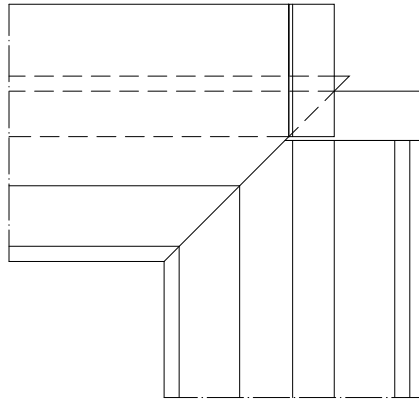
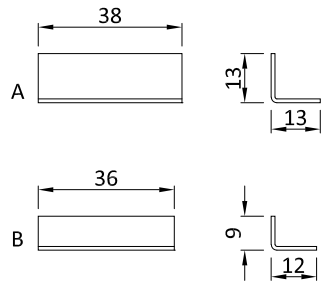


Note / Note

- La larghezza degli spessori è almeno pari o maggiore (+2 mm) dello spessore del vetro installato.
- La posizione degli spessori deve essere garantita dall'utilizzo di materiale adeguato che ne eviti lo spostamento.
- The shims' width is the same or greater (+2 mm) than the thickness of the glass installed.
- The position of the shims has to be ensured by using appropriate material that avoids creeping.

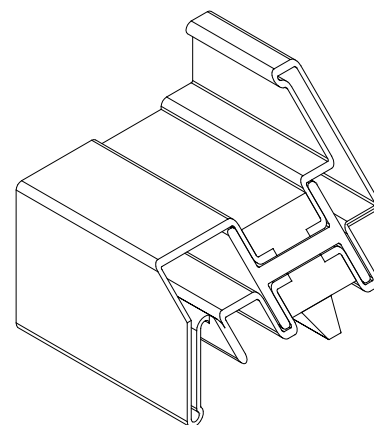
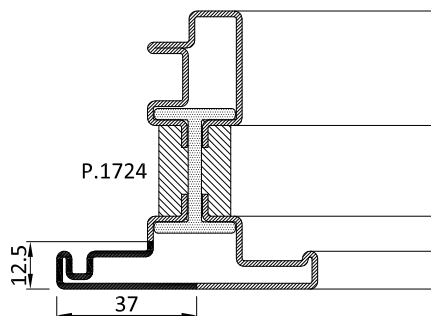
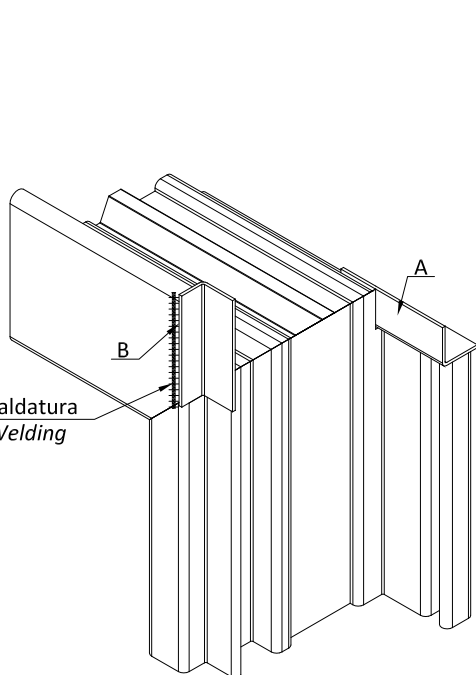
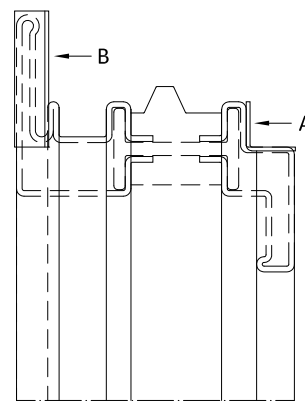
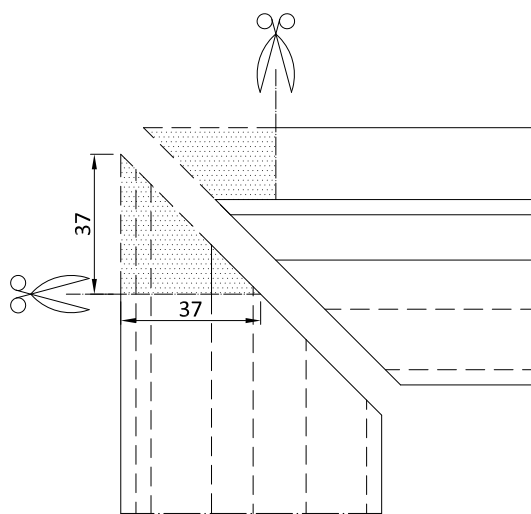
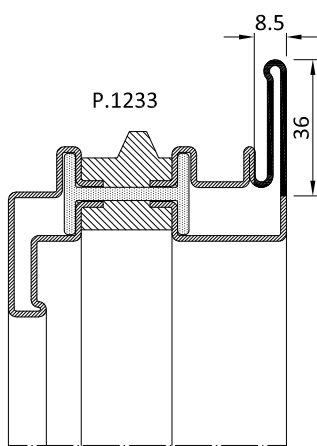
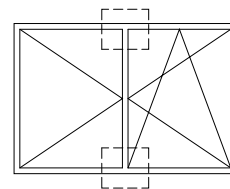
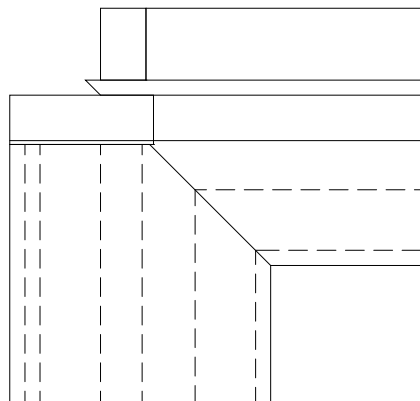
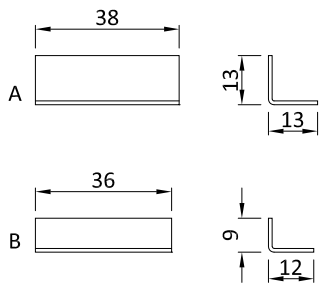
* vite TSP 4.2 x 16 mm non inclusa - screw TSP 4.2 x 16 mm not included





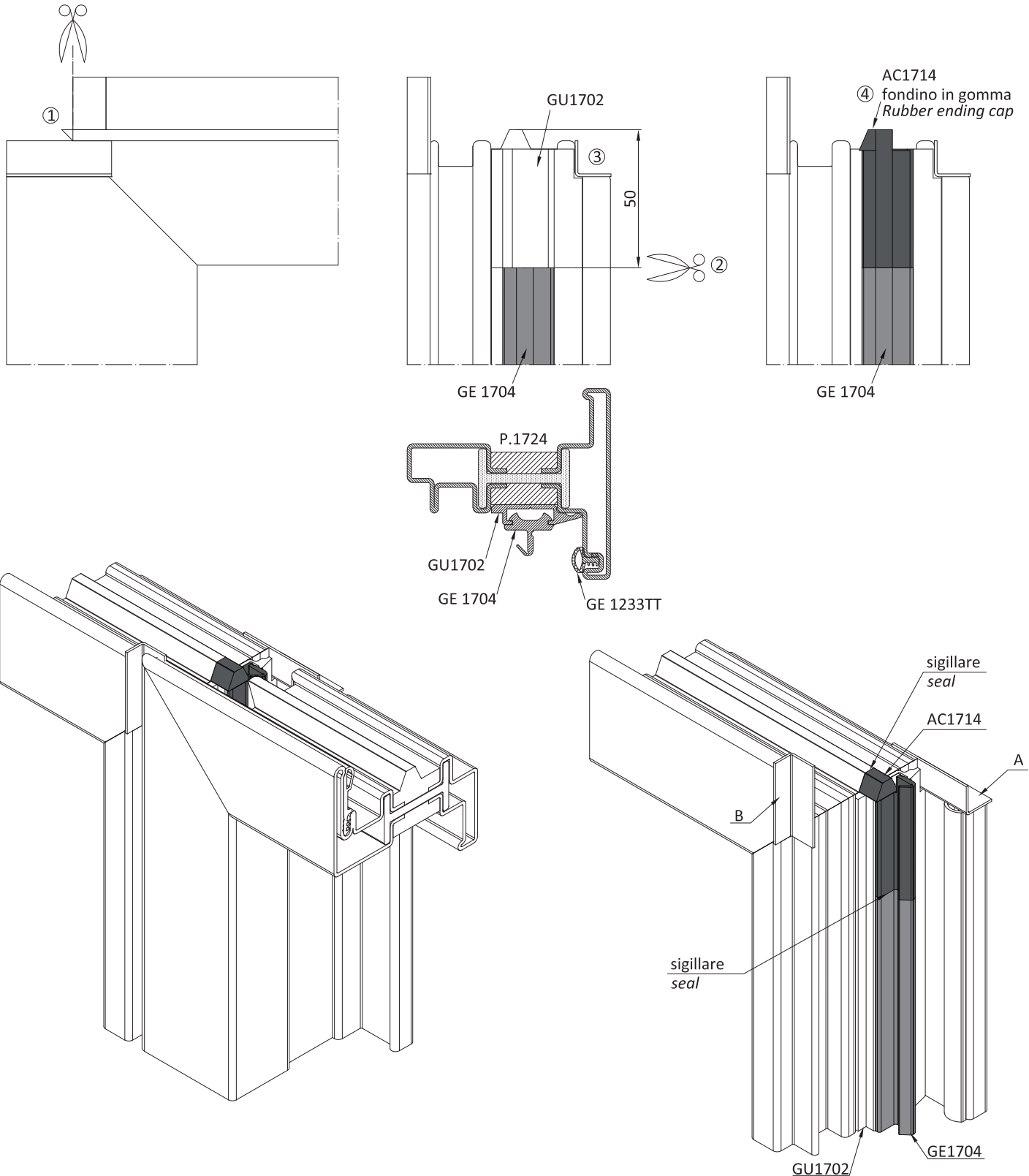
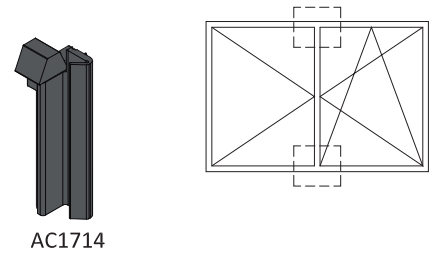
porzione da rifilare e saldare dopo
l'assieme dell'angolo
area to cut and weld after the corner joint

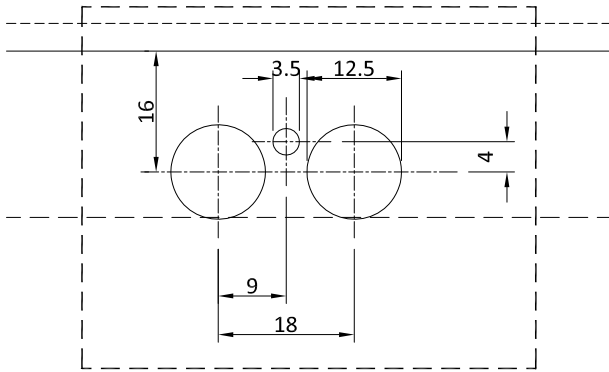
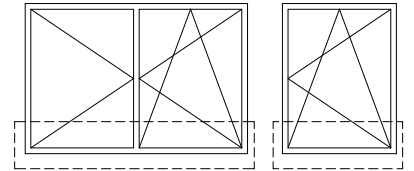
Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura.
Note: the ending caps for T-Z joint are furnished in larger dimensions and should be trimmed down after welding.



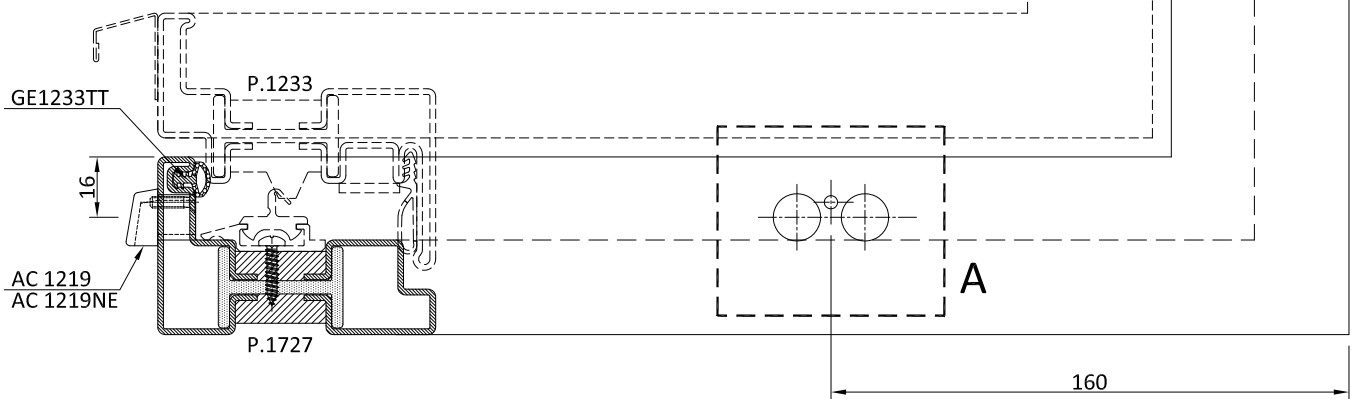
Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura.
Note: the ending caps for T-Z joint are furnished in larger dimensions and should be trimmed down after welding.

- 1) Asportare il poliammide.
- 1) *Remove the polyamide.*
- 2) Tagliare la guarnizione GE1704 a 50 mm. dal filo esterno del polliamide.
- 2) *Cut the gasket GE1702 at 50 mm from the end thread of polyamide.*
- 3) Asportare la parte dell'estruso GU1702 che interferisce con il fondino A.
- 3) *Remove the part of the extrudate GU1702 that interferes with the rubber ending cap A.*
- 4) Posizionare il fondino di gomma ed incollarlo alla guarnizione GE1701 a mezzo di colla ciano-acrilica.
- 4) *Position the rubber ending cap and stick it to the gasket GE1701 with cyano-acrylic glue*

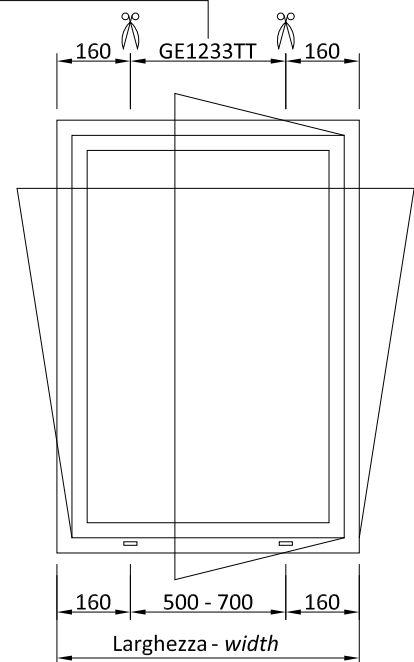
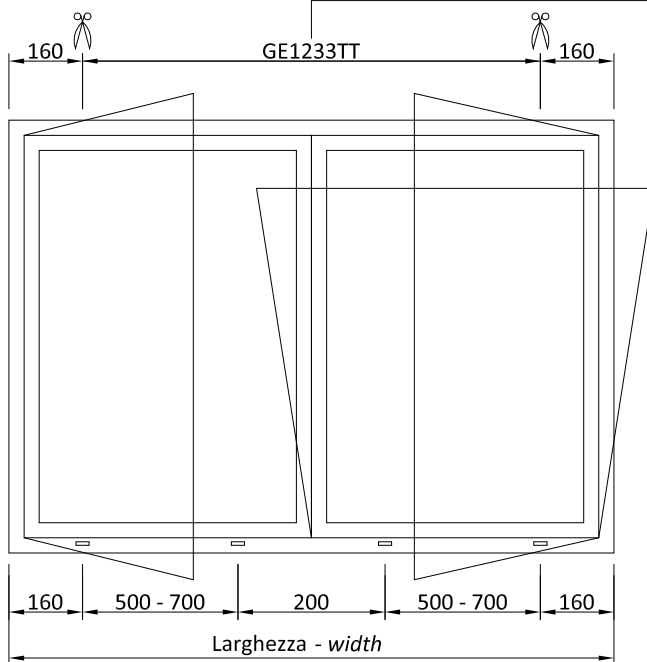




Particolare A - Detail "A"

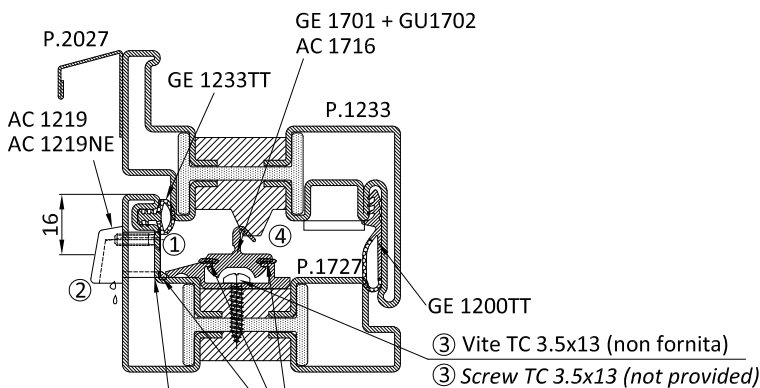
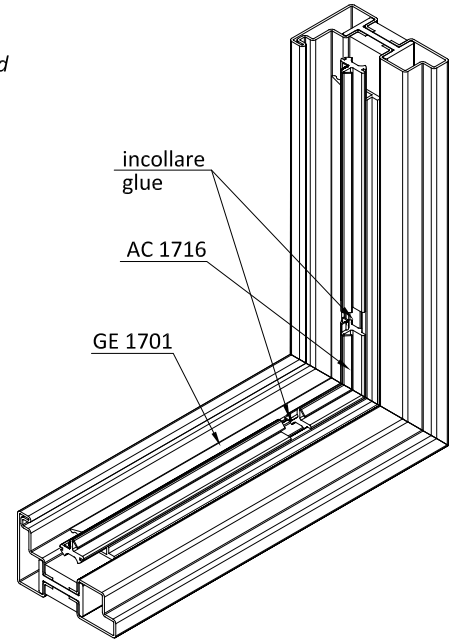
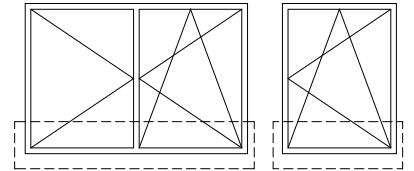


Tagliare la guarnizione per 20 mm | Cut the gasket to 20 mm



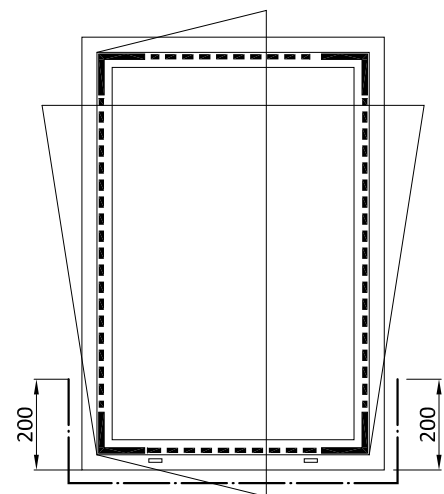
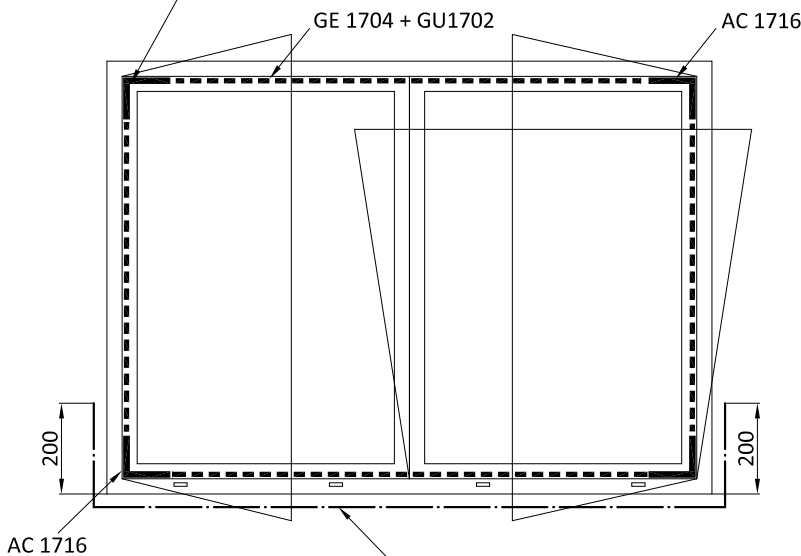
- 1) Eseguire i fori come da disegno .
- 2) Posizionare lo scarico acqua e sigillare fissare con viti in dotazione M3x12.
- 3) Posizionare il supporto della guarnizione di giunto GU1702 e fissarlo con viti TC 3.5x13 (non fornita).
- 4) Sigillare la guarnizione di giunto GE1701 con il supporto GU1702 per tutta lunghezza e per 200 mm in altezza sul telaio.
- 5) Posizionare la guarnizione di giunto centrale GE1701 e gli angoli vulcanizzati AC1716, incollare gli angoli alla guarnizione a mezzo di colla ciano-acrilica.

- 1) Drill the holes according to drawing .
- 2) Install the water drip accessory, seal and secure with the supplied M3x12 screw.
- 3) Position the support of the weather strip GU1702 and anchor it with the double-sided adhesive tape provided and screws TC 3.5x13 (not provided).
- 4) Seal the weather strip GE1701 with the support GU1702 for the whole length and for 200 mm vertically on the frame.
- 5) Install the central weather strip GE1701 and the vulcanised corners AC1716, glue the corners to the weather strip using cyanoacrylate glue.

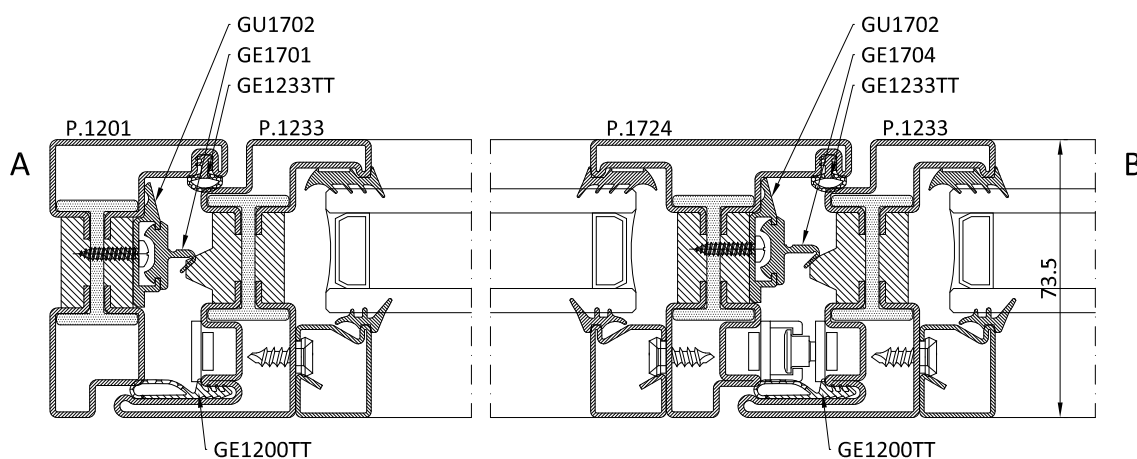
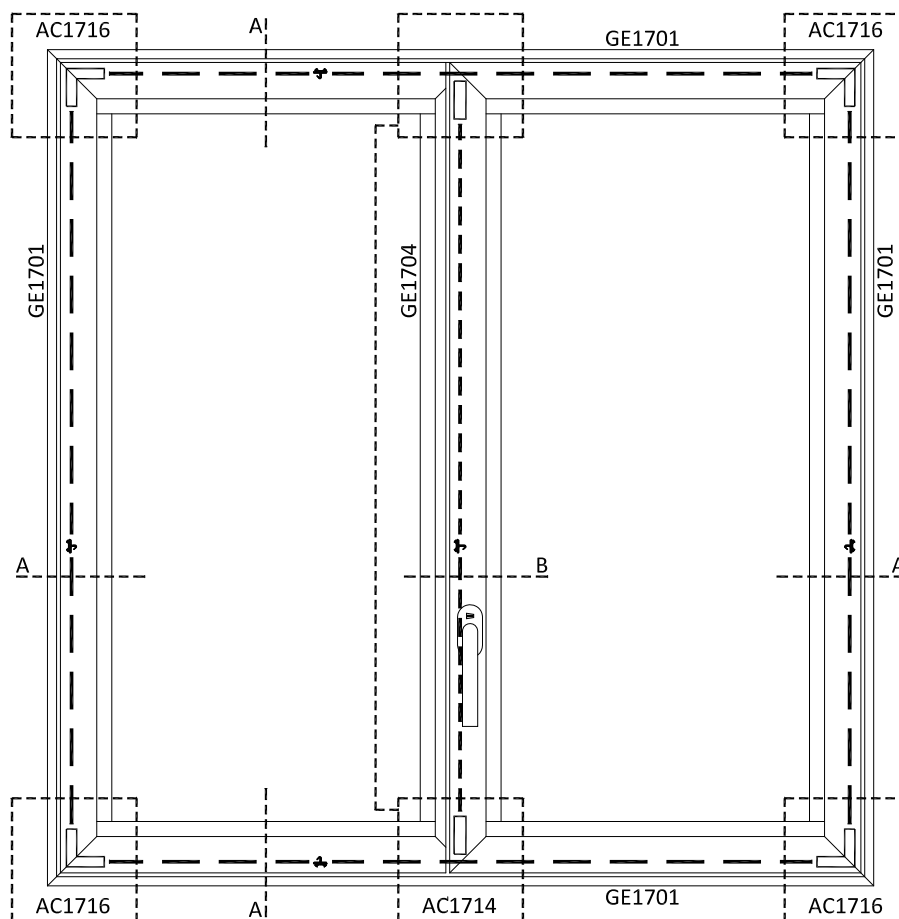
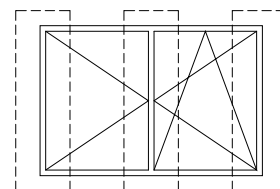


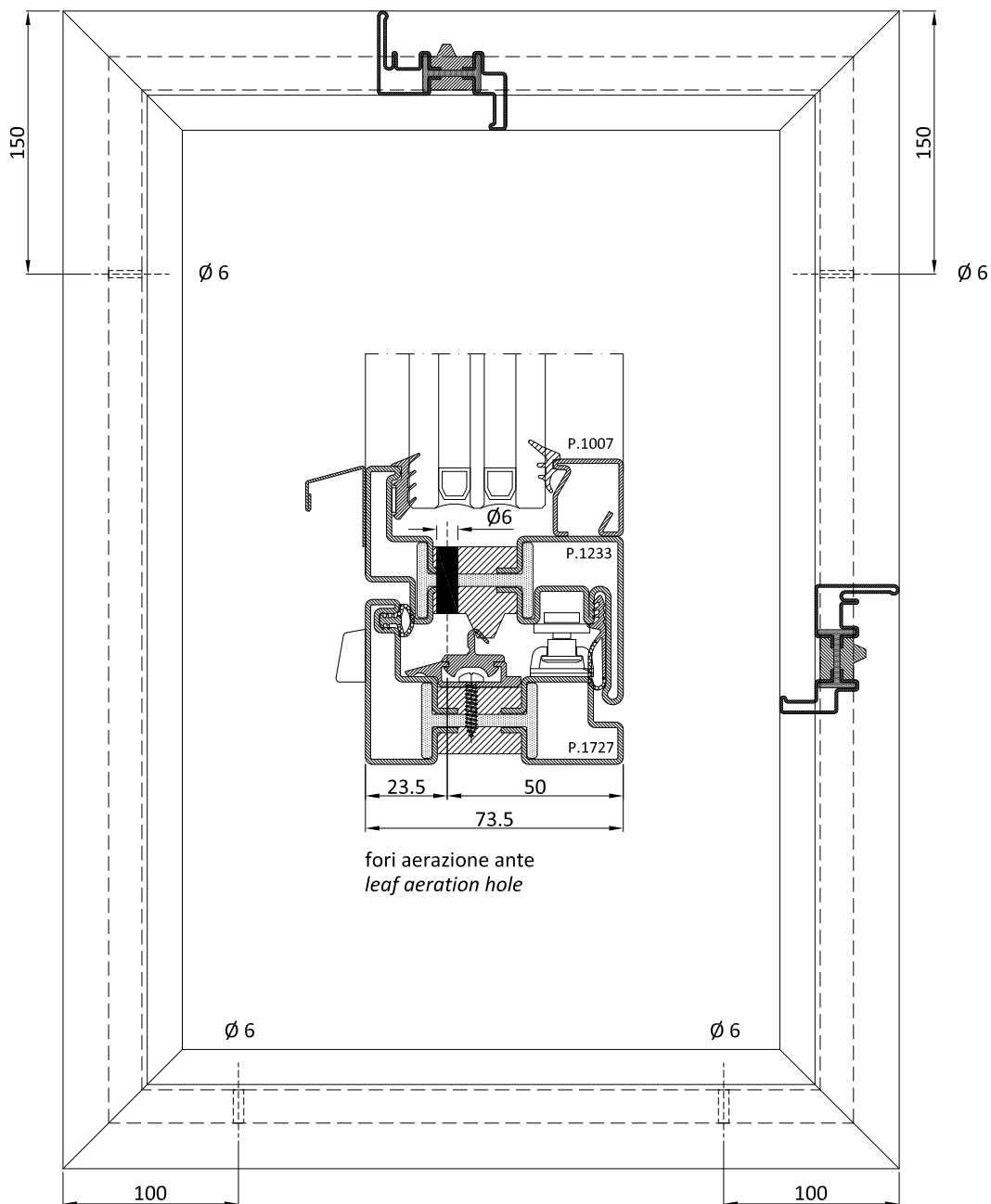
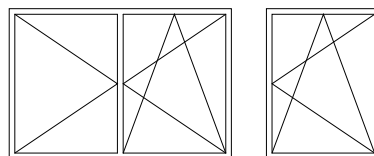
- ③ Vite TC 3.5x13 (non fornita)
③ Screw TC 3.5x13 (not provided)
- ④ sigillare per tutta la lunghezza la base inferiore e per 200 mm in altezza il telaio.
④ Seal the lower frame for its whole length and for 200 mm vertically.
- sigillare il perimetro dello scarico acqua
seal the perimeter of water drip

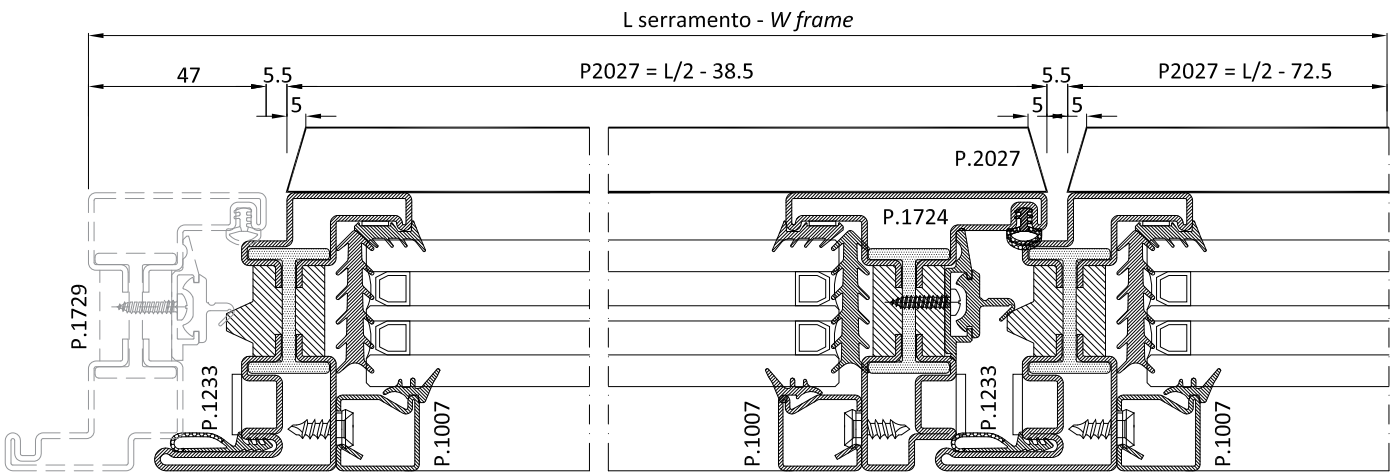
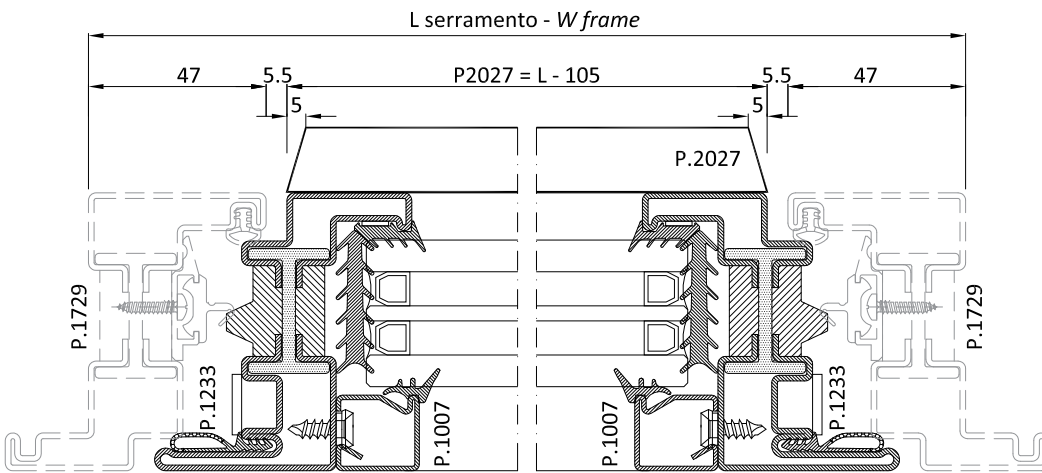
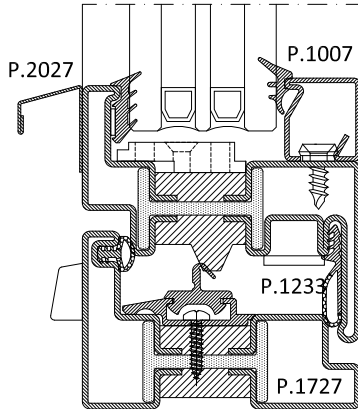
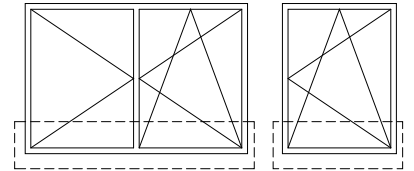
incollare gli angoli vulcanizzati AC1716 alla guarnizione con colla cianoacrilica
Glue the vulcanised corner AC1716 to the gasket using cyanoacrylate glue

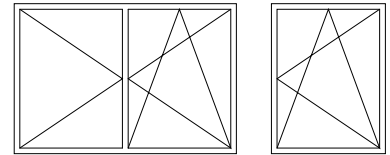


- ④ sigillare per tutta la lunghezza la base inferiore e per 200 mm in altezza il telaio.
④ Seal the lower frame for its whole length and for 200 mm vertically.



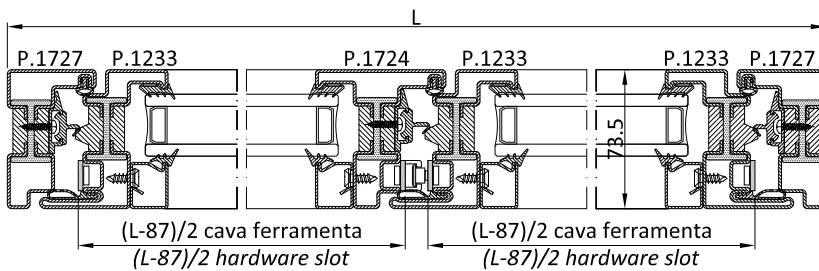
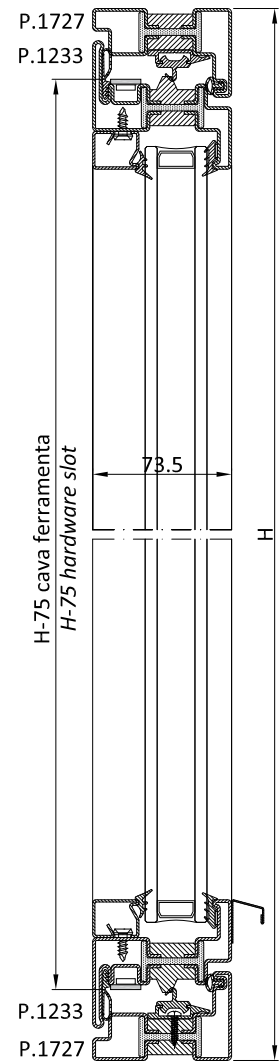
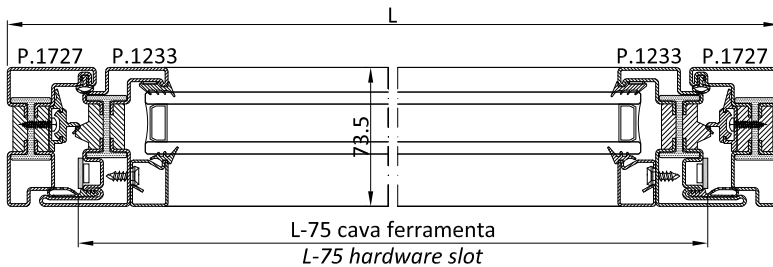


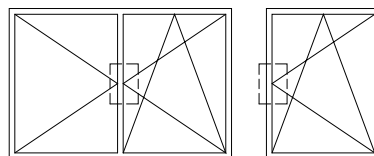




Standard		H altezza - Height								
		661 860	861 1000	1001 1200	1201 1400	1401 1600	1601 1800	1801 2000	2001 2200	2201 2400
L W larghezza width	601-800	A1	B1	C1	D1	E1	F1	G1	H1	I1
	801-1000	-	B2	C2	D2	E2	F2	G2	H2	I2
	1001-1200	-	-	C3	D3	E3	F3	G3	H3	I3
	1201-1400	-	-	-	D4	E4	-	-	-	-

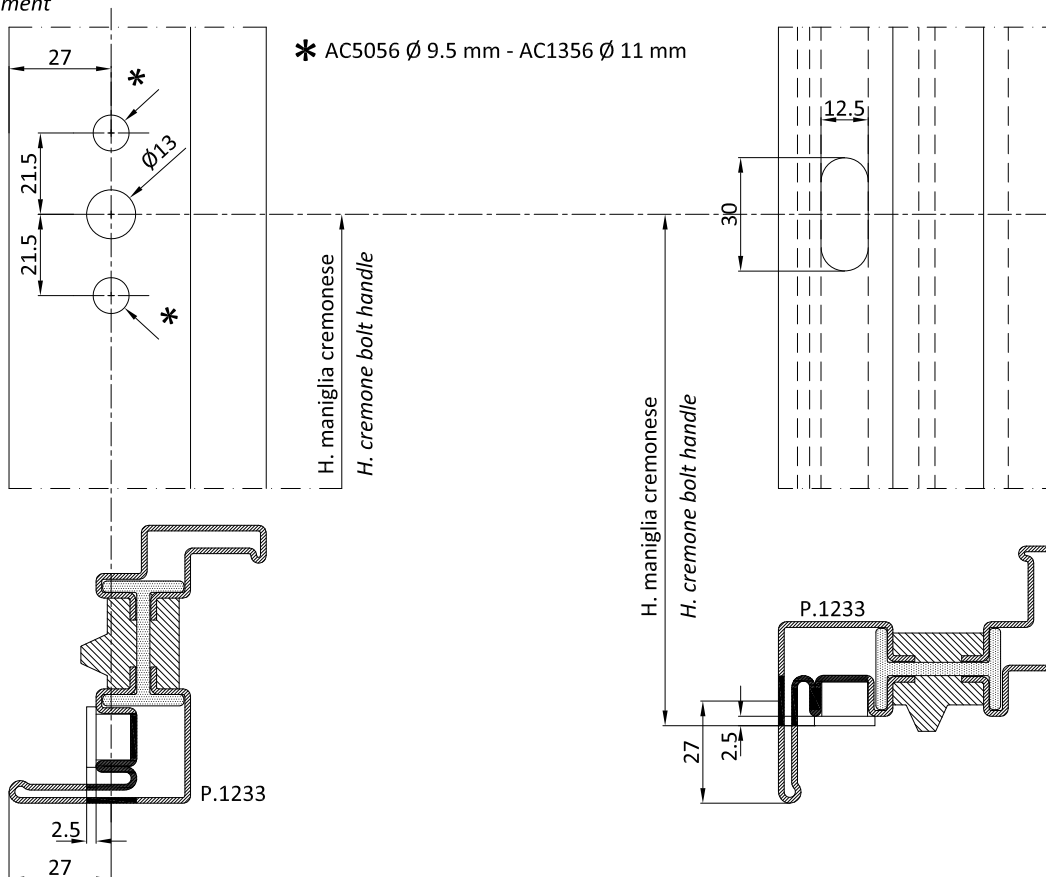
AGE281-2 130 kg Easy
AGE785-6 130 kg Easy





Fori per inserimento quadro comando e fissaggio maniglia / movimento DK
Holes for inserting control panel and anchoring of handle / TT (tilt and turn) movement

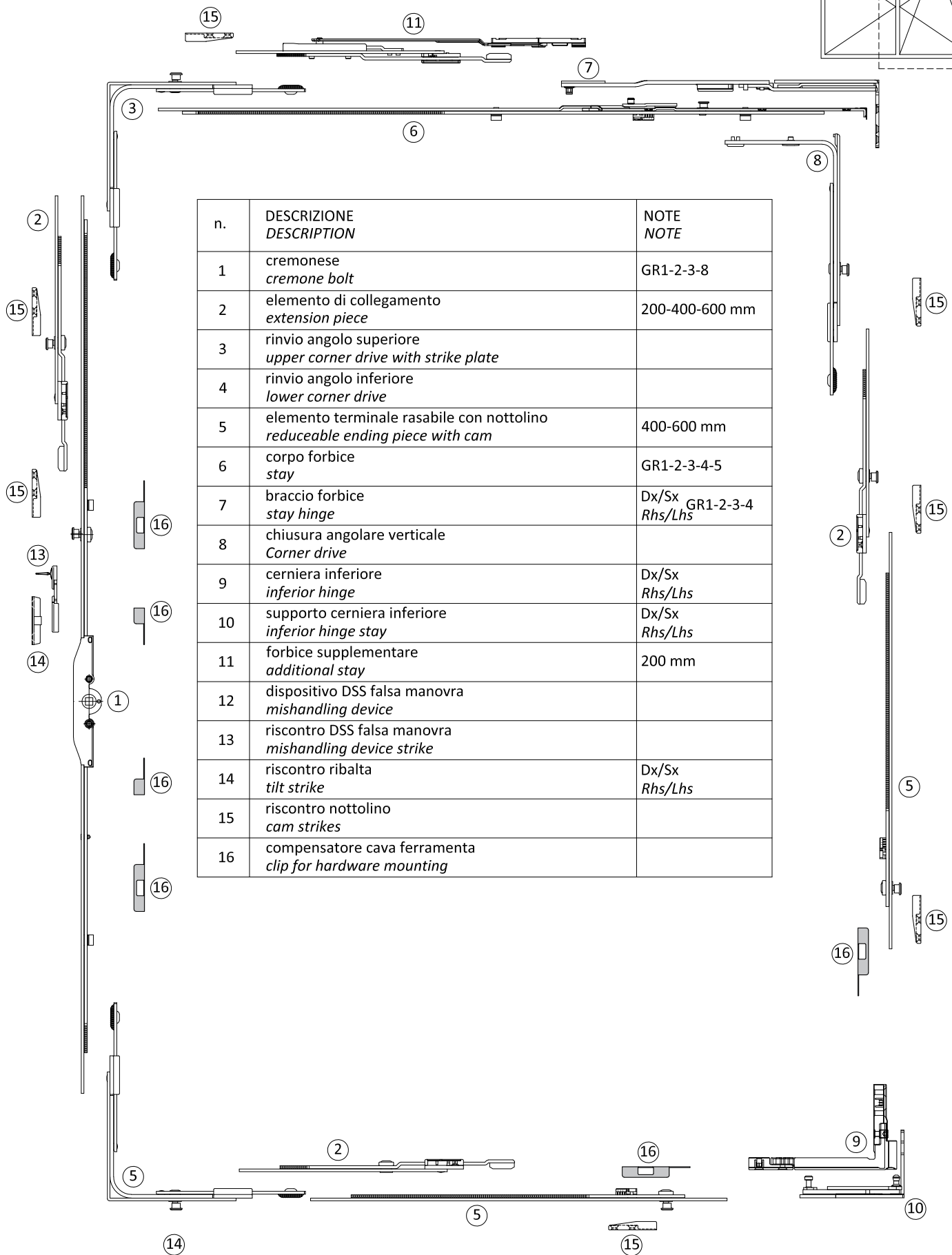
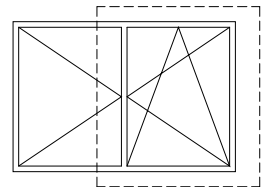
Asola per inserimento meccanismo cremonese
Slot for insertion of cremone mechanism



ALTEZZA MANIGLIA CREMONESE - CREMONE BOLT HANDLE HEIGHT		
Tipo Type	H cava ferramenta - H hardware slot std	H maniglia cremonese H cremone bolt handle
Finestre Windows	Y 370 → 520	H/2
	Z 521 → 660	H/2
	A 661 → 860	H/2
	B 861 → 1000	H/2
	C 1001 → 1200	500
	D 1201 → 1400	500
	E 1401 → 1600	500
Porte - finestre French Windows	F 1601 → 1800	500
	G 1801 → 2000	1050
	H 2001 → 2200	1050
	I 2201 → 2400	1050
	J 2401 → 2600	1050
	K 2601 → 2800	1050
L 2801 → 3000	1050	

STANDARD

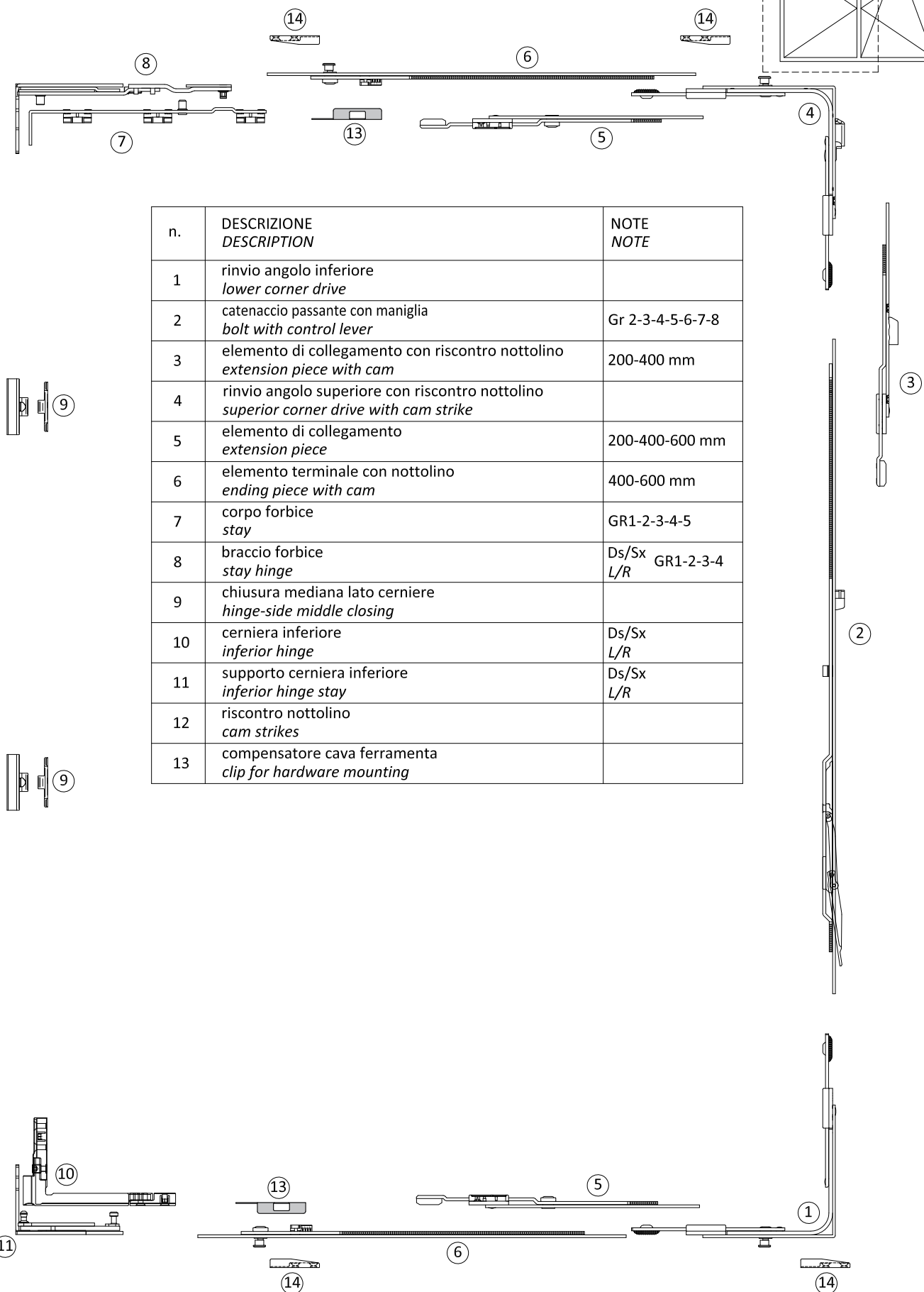
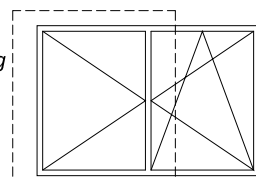
peso massimo anta 130 kg
maximum leaf weight 130 kg



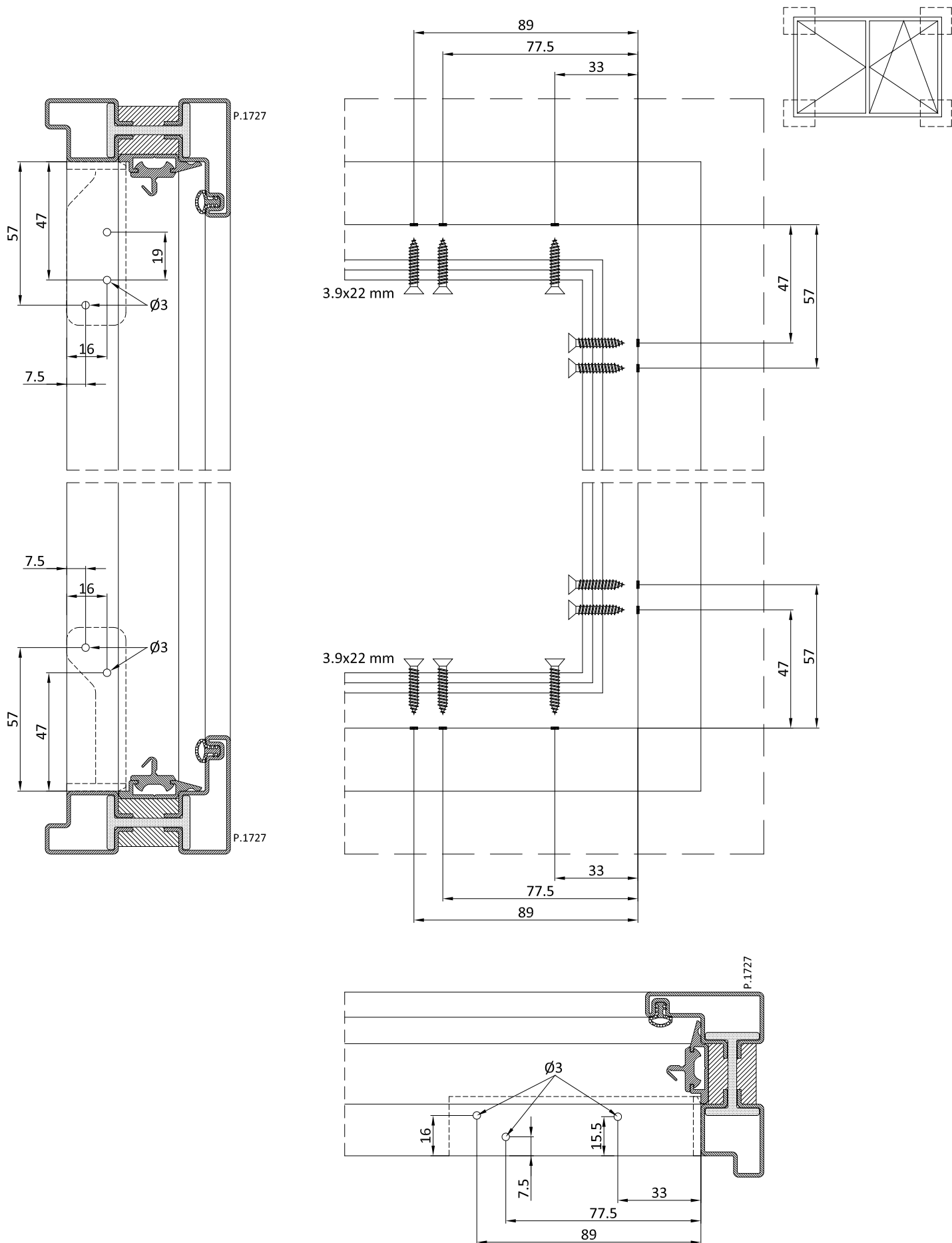
n.	DESCRIZIONE DESCRIPTION	NOTE NOTE
1	cremonese cremone bolt	GR1-2-3-8
2	elemento di collegamento extension piece	200-400-600 mm
3	rinvio angolo superiore upper corner drive with strike plate	
4	rinvio angolo inferiore lower corner drive	
5	elemento terminale rasabile con nottolino reduceable ending piece with cam	400-600 mm
6	corpo forbice stay	GR1-2-3-4-5
7	braccio forbice stay hinge	Dx/Sx GR1-2-3-4 Rhs/Lhs
8	chiusura angolare verticale Corner drive	
9	cerniera inferiore inferior hinge	Dx/Sx Rhs/Lhs
10	supporto cerniera inferiore inferior hinge stay	Dx/Sx Rhs/Lhs
11	forbice supplementare additional stay	200 mm
12	dispositivo DSS falsa manovra mishandling device	
13	riscontro DSS falsa manovra mishandling device strike	
14	riscontro ribalta tilt strike	Dx/Sx Rhs/Lhs
15	riscontro nottolino cam strikes	
16	compensatore cava ferramenta clip for hardware mounting	

STANDARD

peso massimo anta 130 kg
maximum leaf weight 130 kg

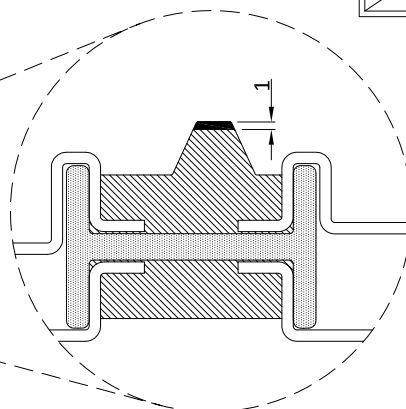
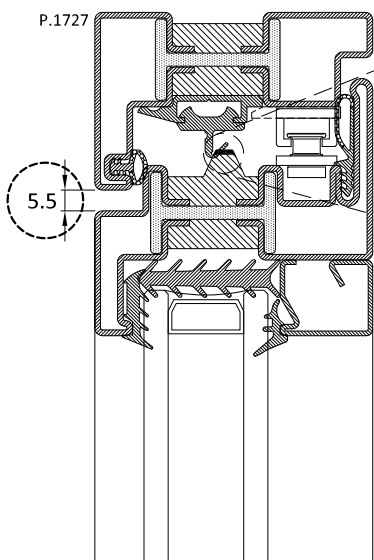
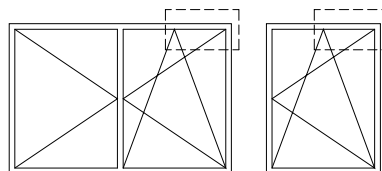


n.	DESCRIZIONE DESCRIPTION	NOTE NOTE
1	rinvio angolo inferiore lower corner drive	
2	catenaccio passante con maniglia bolt with control lever	Gr 2-3-4-5-6-7-8
3	elemento di collegamento con riscontro nottolino extension piece with cam	200-400 mm
4	rinvio angolo superiore con riscontro nottolino superior corner drive with cam strike	
5	elemento di collegamento extension piece	200-400-600 mm
6	elemento terminale con nottolino ending piece with cam	400-600 mm
7	corpo forbice stay	GR1-2-3-4-5
8	braccio forbice stay hinge	Ds/Sx L/R GR1-2-3-4
9	chiusura mediana lato cerniere hinge-side middle closing	
10	cerniera inferiore inferior hinge	Ds/Sx L/R
11	supporto cerniera inferiore inferior hinge stay	Ds/Sx L/R
12	riscontro nottolino cam strikes	
13	compensatore cava ferramenta clip for hardware mounting	

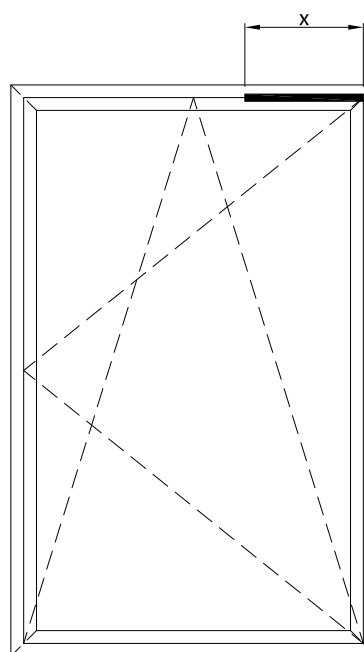
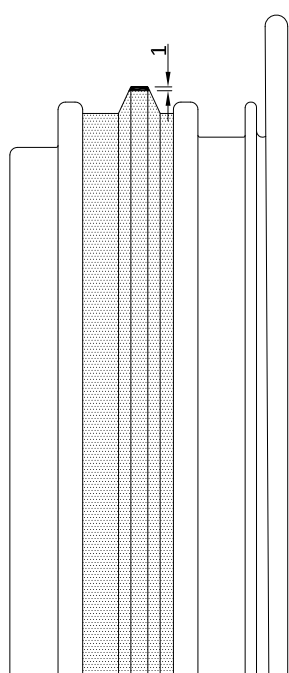
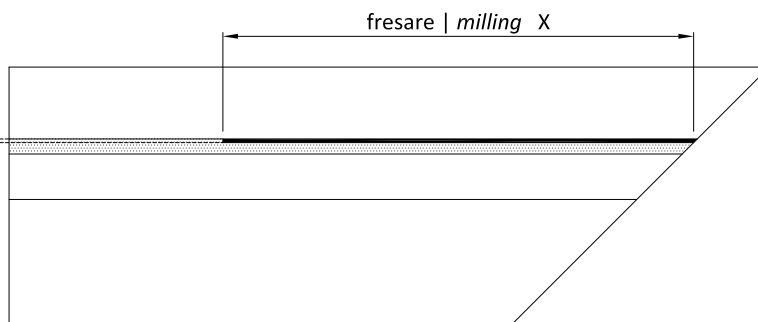
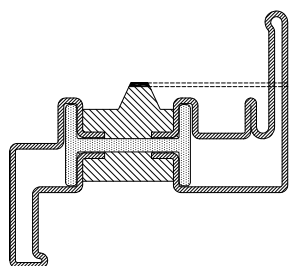


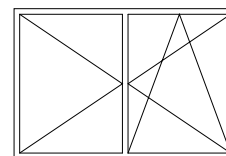
Fori eseguibili con maschera ATG281
Holes to be done with ATG281





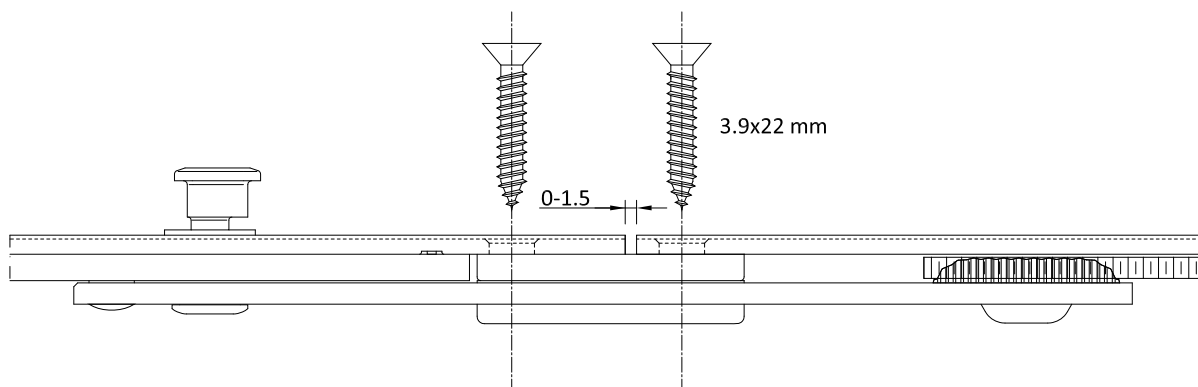
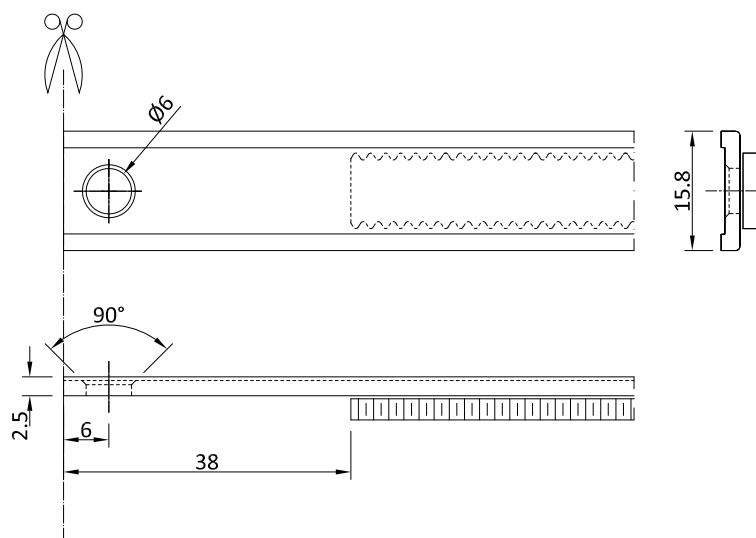
Larghezza cava ferramenta Width hardware slot [mm]	X [mm]
600 → 800	200
801 → 1400	280



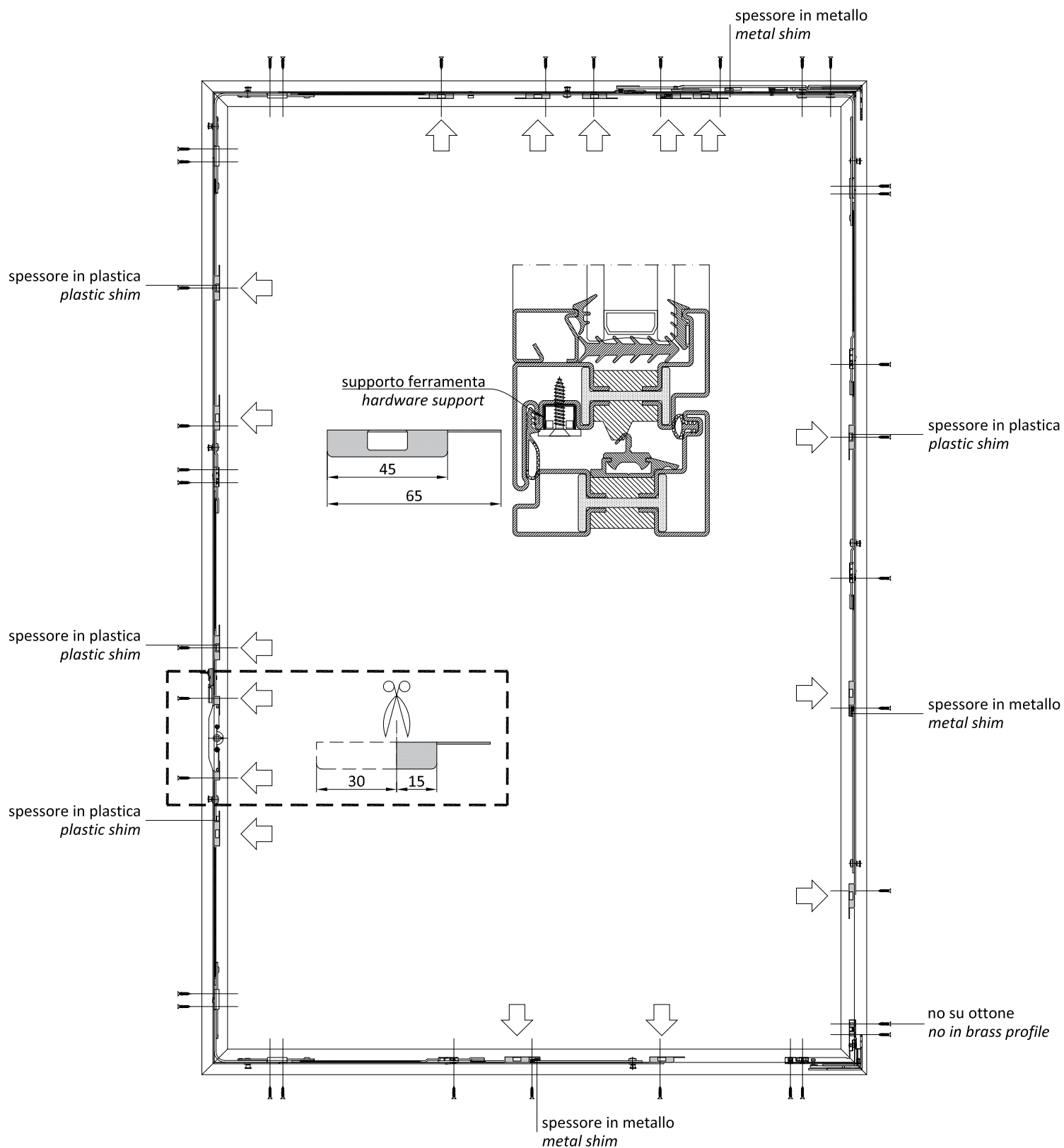
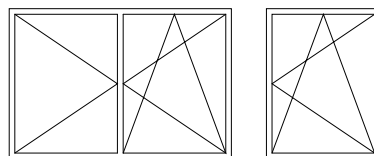


Lavorazione da eseguire sui componenti rasabili della ferramenta
Working on the cuttable pieces of the hardware

- 1 - Eseguire taglio della ferramenta sfalsato
- 2 - Eseguire foro e svasatura
- 1 - Cutting of the hardware
- 2 - Hole drilling and countersink

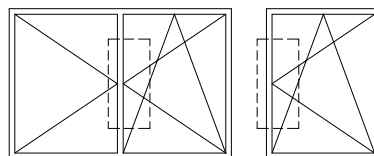


Lavorazione eseguibile con trancia ATG 311 o ATG 312
Tooling possible with punching machine ATG 311 or ATG 312

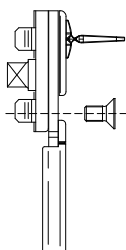


viti | screws TPS 3.9x22 mm



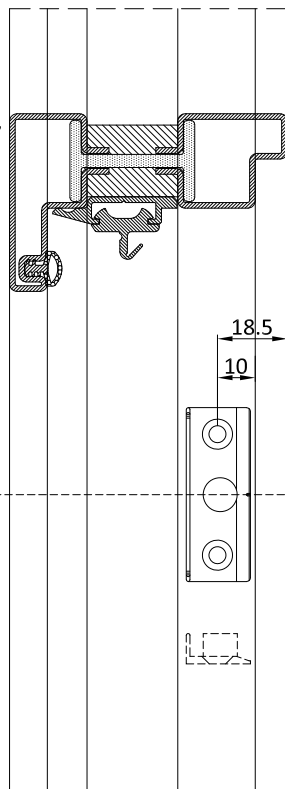


DSS

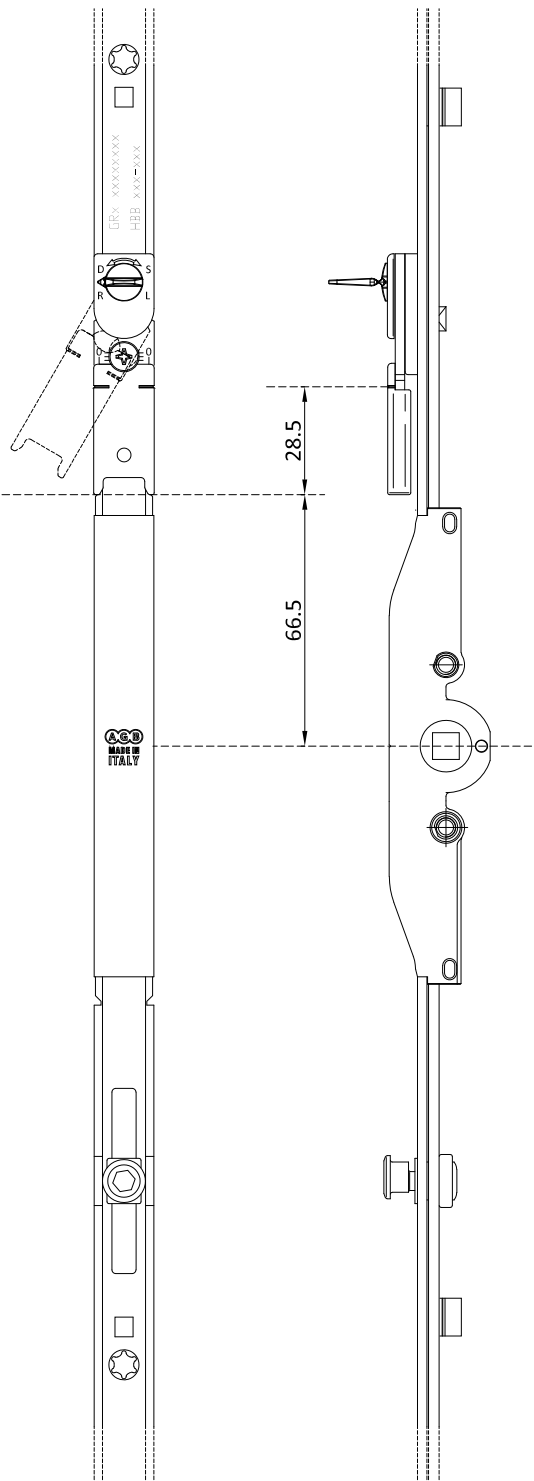
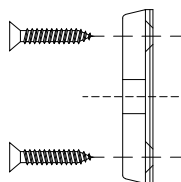


M4x8 mm

P.1727



3.9x22 mm

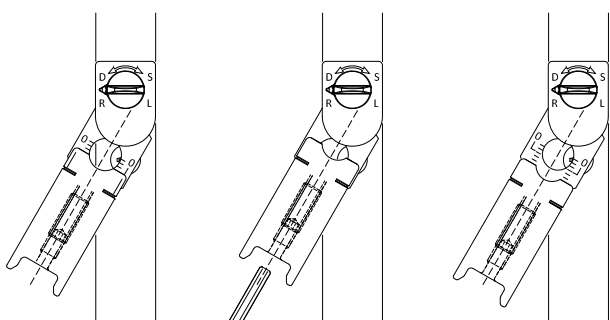


Regolazione
Adjustment

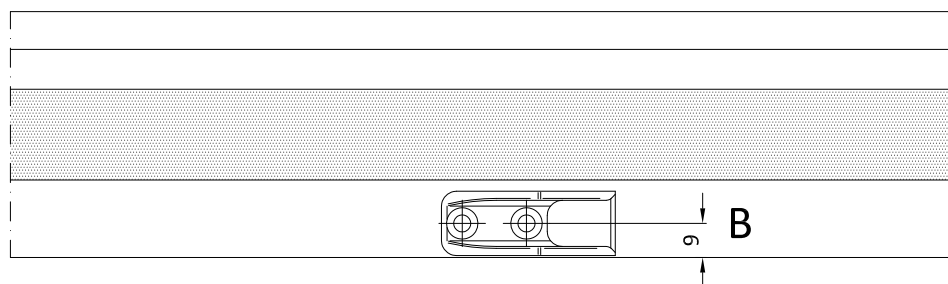
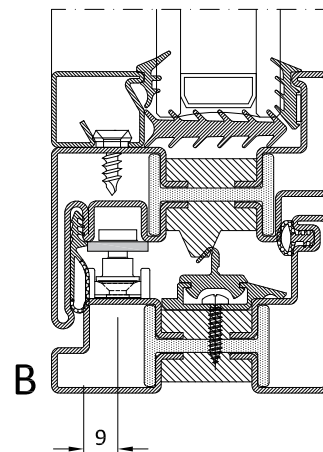
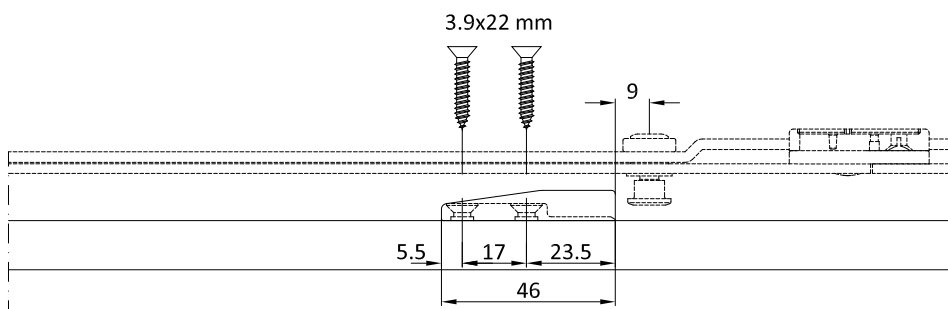
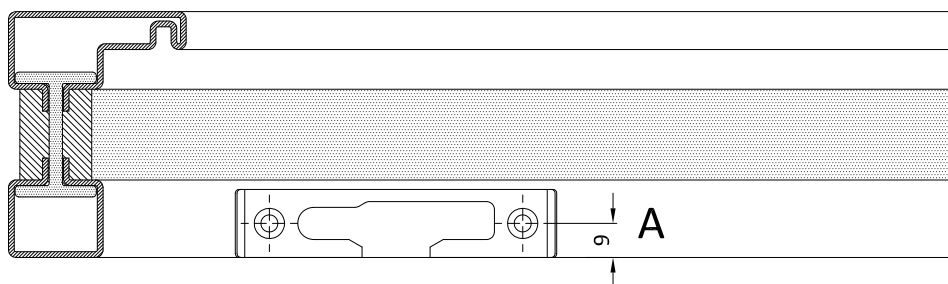
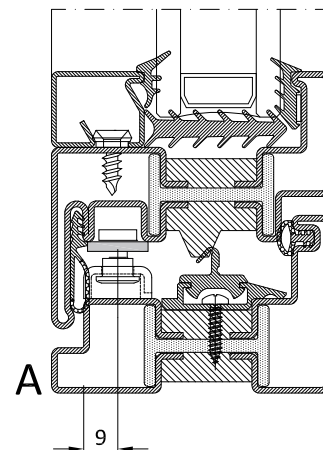
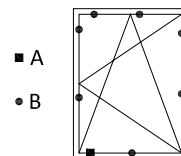
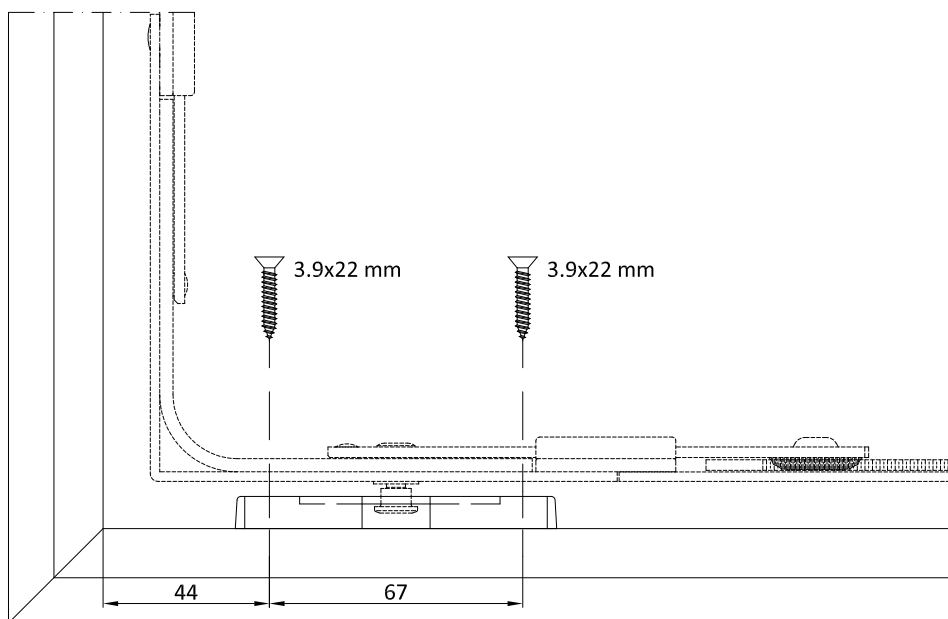
+3 mm

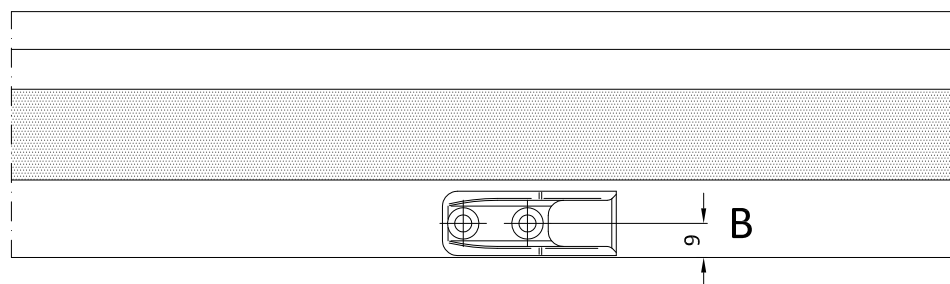
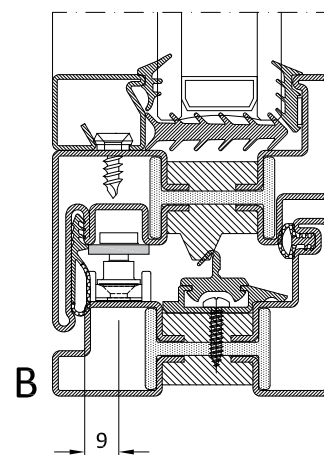
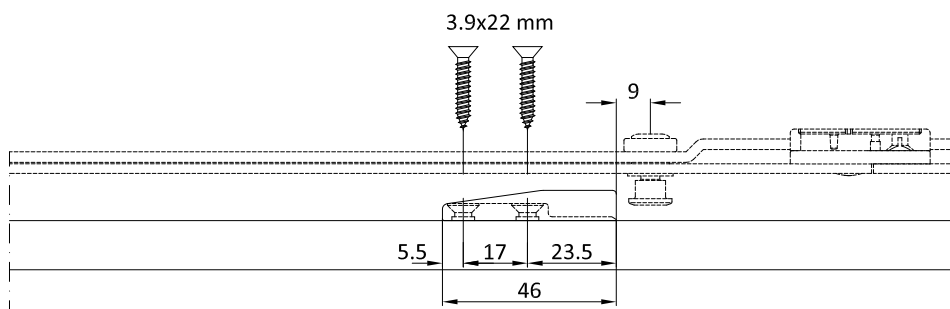
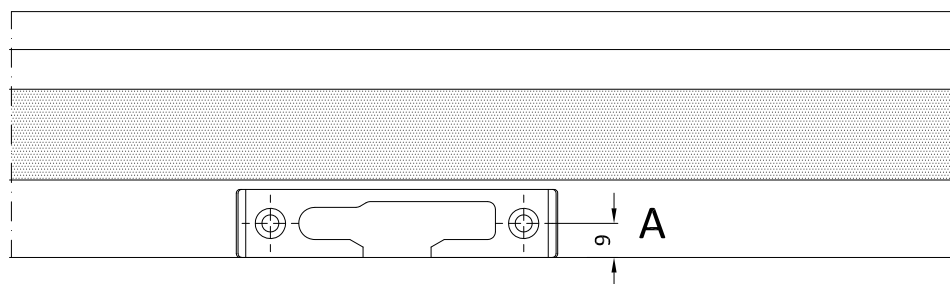
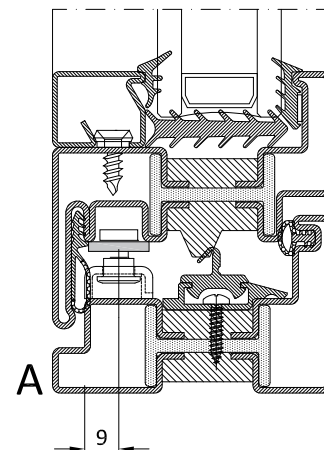
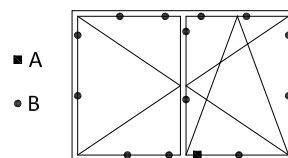
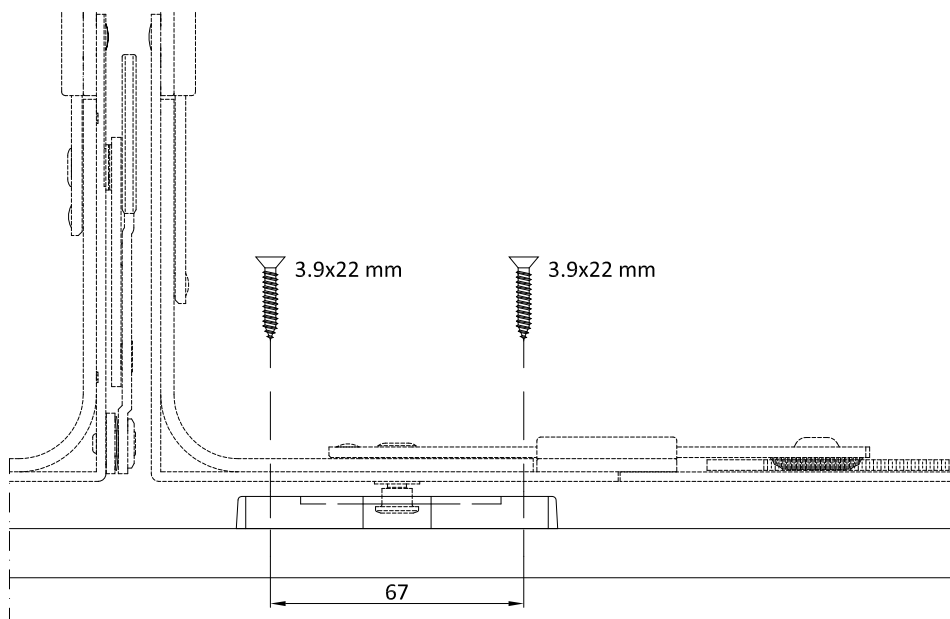
0 mm

-3 mm

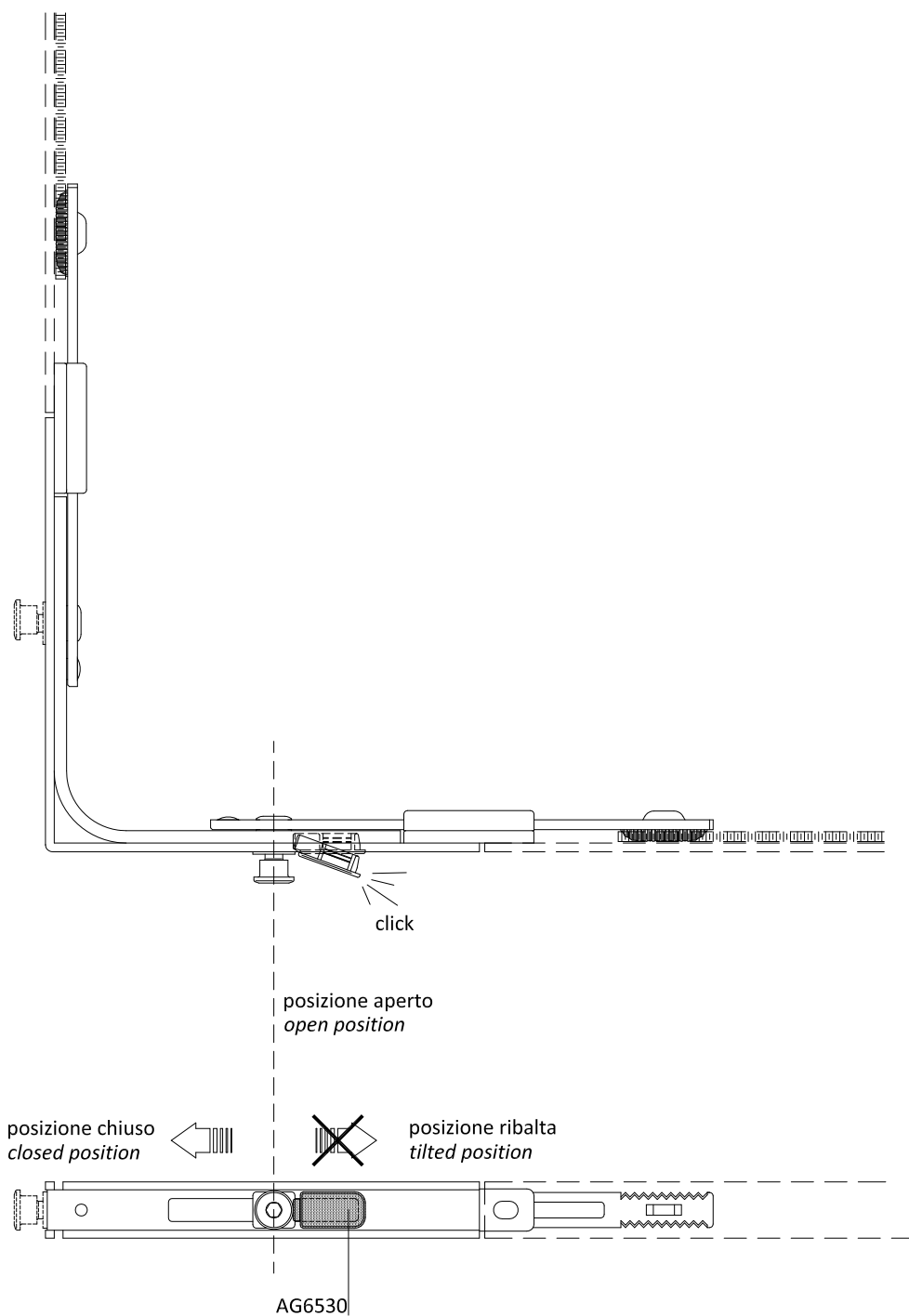
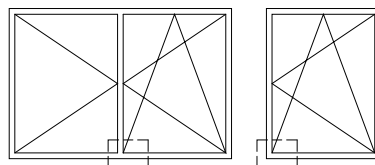
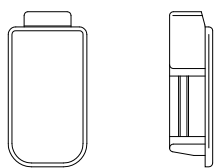


2.5 mm

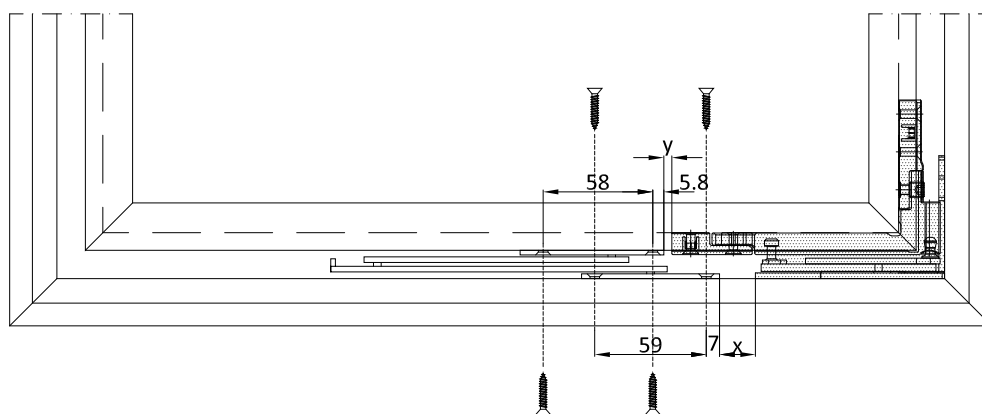
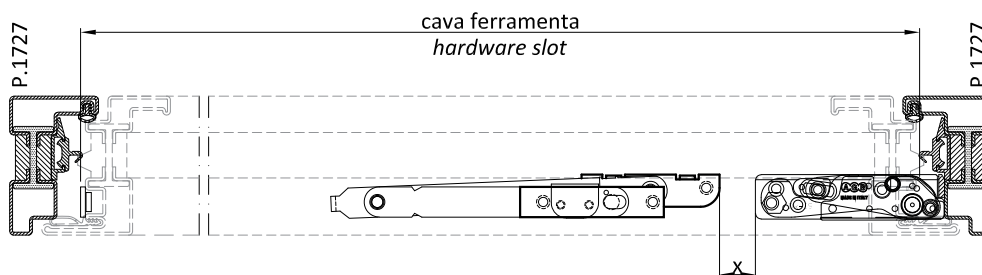
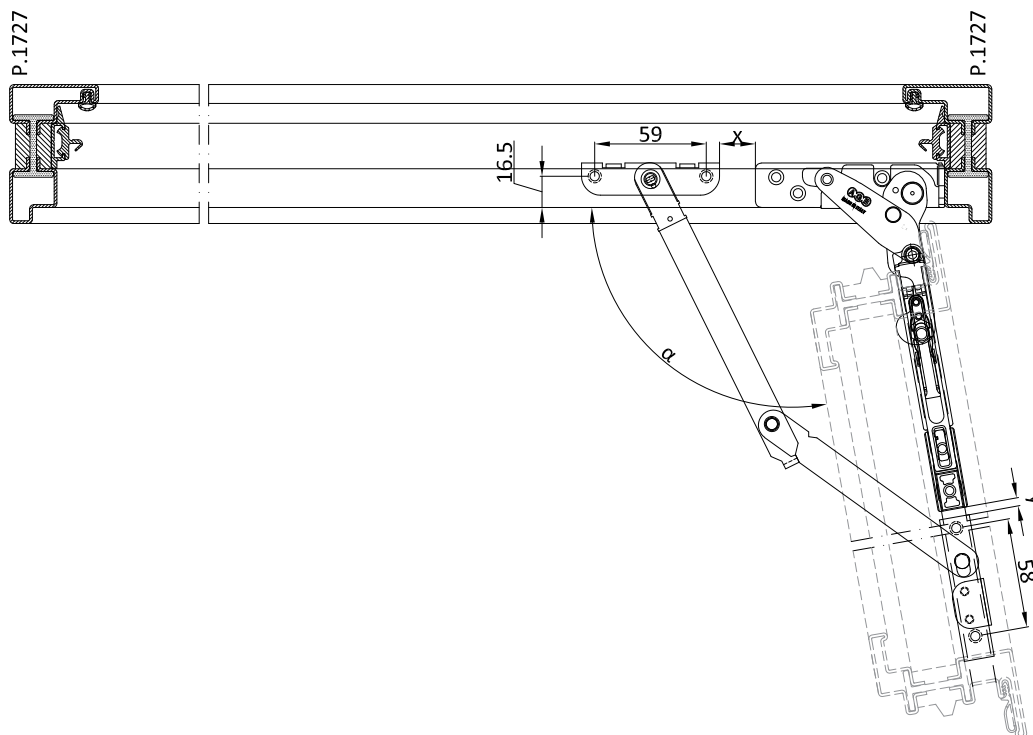
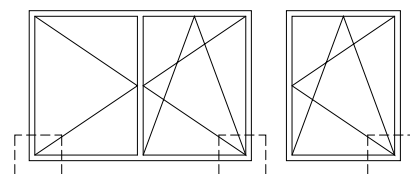




AG6530

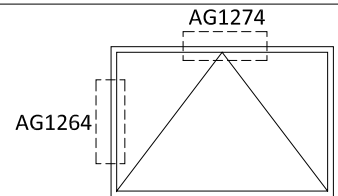


α	x [mm]	y [mm]	min. cava ferramenta hardware slot min. [mm]
90°	31	16.3	450
100°	19	4.3	450



non installabile su kit AG1281-2-5-6
not possible to install on kit AG1281-2-5-6





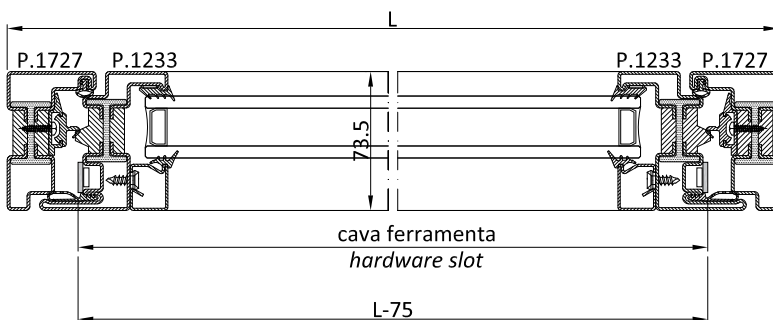
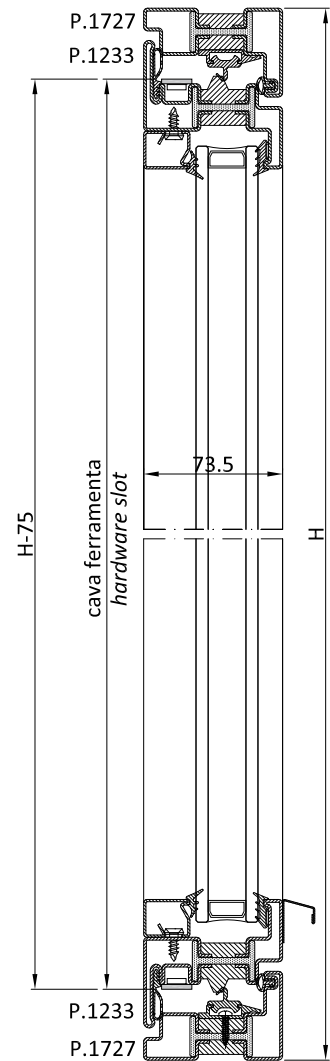
	AG1264	H altezza - Height			
		560 660	661 860	861 1200	1201 1600
L W larghezza width	600-910	A1	B1	C1	D1
	911-1110	A2	B2	C2	D2
	1111-1470	A3	B3	C3	D3
	1471-1860	A4	B4	C4	D4

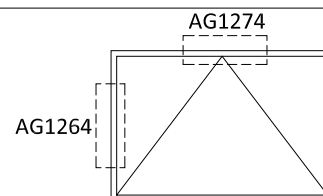
2 cerniere - peso massimo anta 70 kg
3 cerniere - peso massimo anta 100 kg

2 hinges - maximum leaf weight 70 kg
3 hinges - maximum leaf weight 100 kg

Specificare all'ordine misure cava ferramenta
Specify hardware slot size

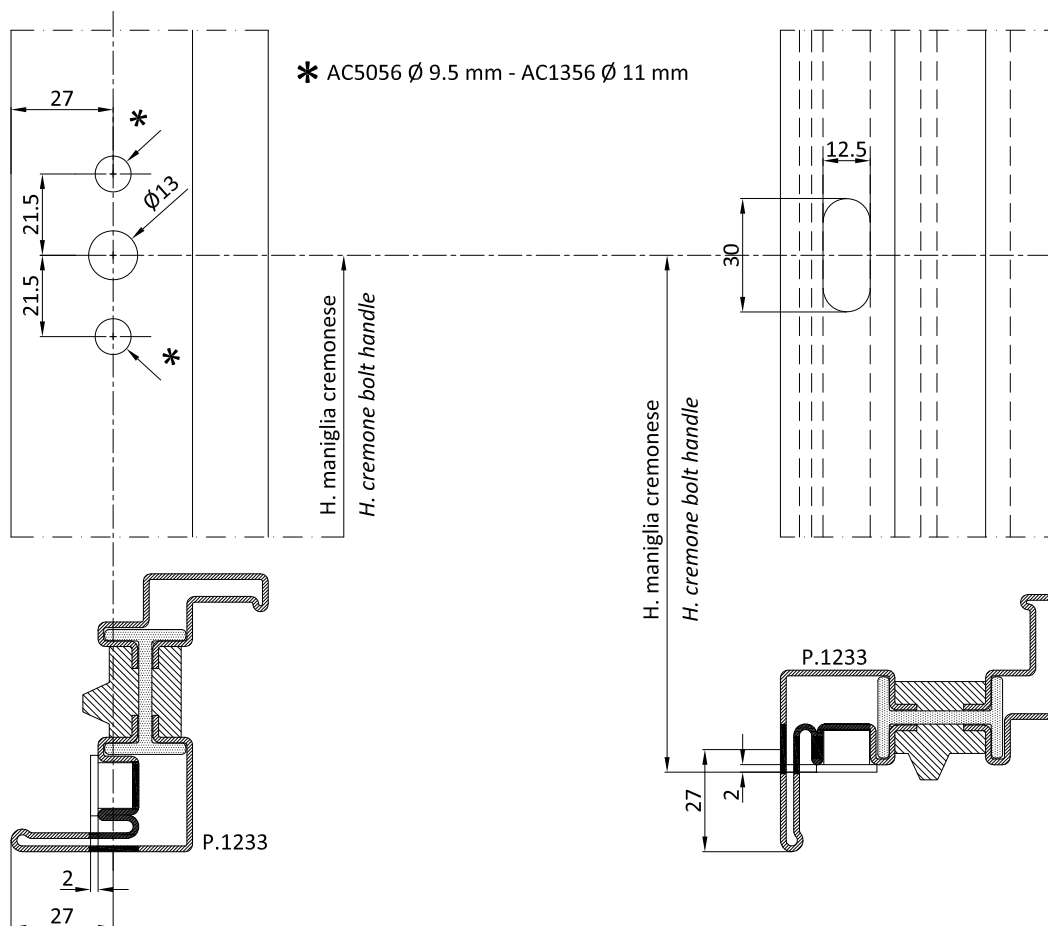
	AG1274	H altezza - Height			
		350 660	661 860	861 1200	1201 1400
L W larghezza width	560-660	A1	B1	C1	D1
	661-860	A2	B2	C2	D2
	861-1200	A3	B3	C3	D3
	1201-1600	A4	B4 </td <td>C4</td> <td>D4</td>	C4	D4





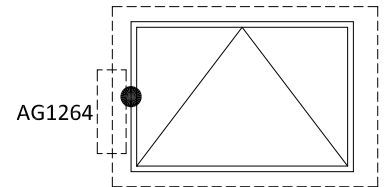
Fori per inserimento quadro comando e fissaggio maniglia / movimento DK
holes for inserting control panel and anchoring of handle / TT (tilt and turn) movement

Asola per inserimento meccanismo cremonese
Slot for insertion of cremone mechanism



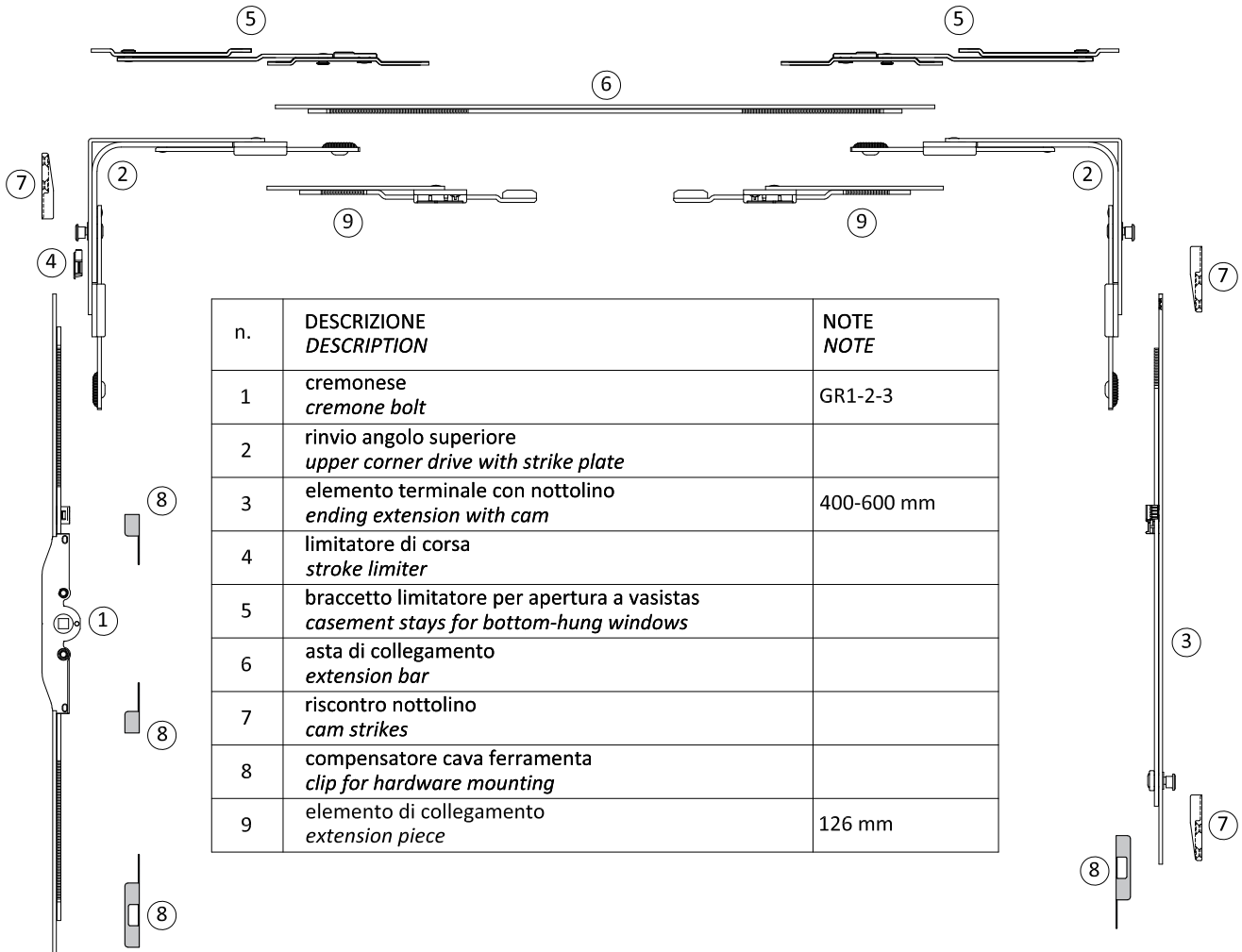
AG1264 ALTEZZA MANIGLIA CREMONESE - CREMONE BOLT HANDLE HEIGHT		
Tipo Type	cava ferramenta hardware slot	H maniglia cremonese H cremone bolt handle
Vasistas Bottom-hung	560 → 660	H/2
	661 → 860	H/2
	861 → 1200	H/2
	1201 → 1600	H/2

AG1274 ALTEZZA MANIGLIA CREMONESE - CREMONE BOLT HANDLE HEIGHT		
Tipo Type	cava ferramenta hardware slot	H maniglia cremonese H cremone bolt handle
Vasistas Bottom-hung	560 → 660	L/2
	661 → 860	L/2
	861 → 1200	L/2
	1201 → 1600	L/2

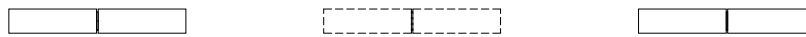


2 cerniere - peso massimo anta 70 kg
3 cerniere - peso massimo anta 100 kg

2 hinges - maximum leaf weight 70 kg
3 hinges - maximum leaf weight 100 kg



n.	DESCRIZIONE DESCRIPTION	NOTE NOTE
1	cremonese cremone bolt	GR1-2-3
2	rinvio angolo superiore upper corner drive with strike plate	
3	elemento terminale con nottolino ending extension with cam	400-600 mm
4	limitatore di corsa stroke limiter	
5	braccetto limitatore per apertura a vasistas casement stays for bottom-hung windows	
6	asta di collegamento extension bar	
7	riscontro nottolino cam strikes	
8	compensatore cava ferramenta clip for hardware mounting	
9	elemento di collegamento extension piece	126 mm

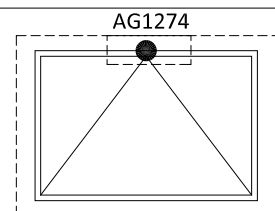


AC2632/C

cerniere non incluse nel kit
hinges not included in the kit

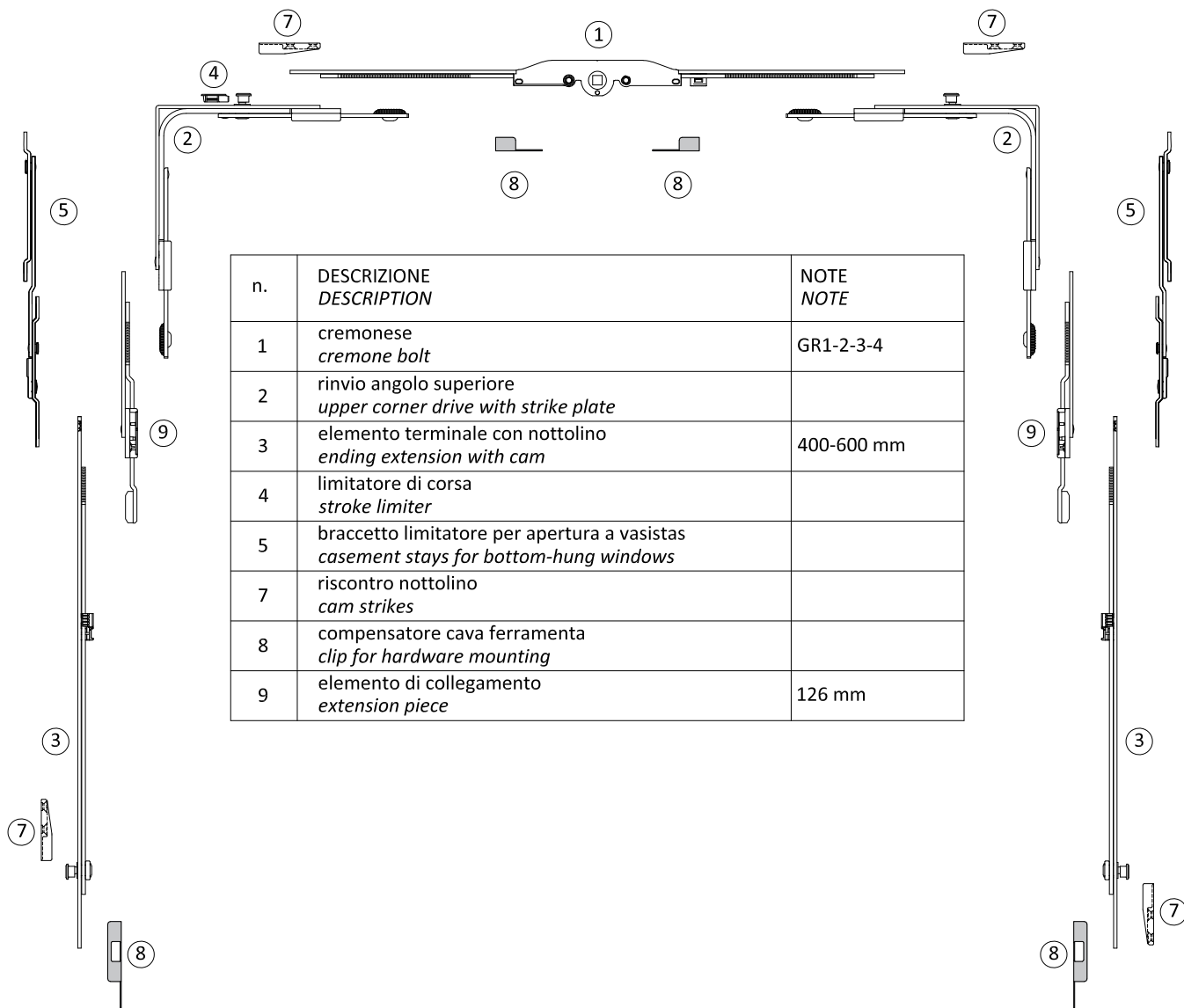
Specificare all'ordine misure cava ferramenta
Specify hardware slot size





2 cerniere - peso massimo anta 70 kg
3 cerniere - peso massimo anta 100 kg

2 hinges - maximum leaf weight 70 kg
3 hinges - maximum leaf weight 100 kg



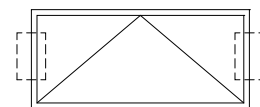
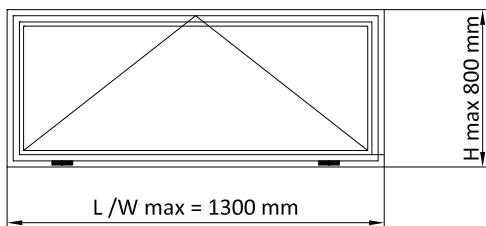
n.	DESCRIZIONE DESCRIPTION	NOTE NOTE
1	cremonese cremone bolt	GR1-2-3-4
2	rinvio angolo superiore upper corner drive with strike plate	
3	elemento terminale con nottolino ending extension with cam	400-600 mm
4	limitatore di corsa stroke limiter	
5	braccetto limitatore per apertura a vasistas casement stays for bottom-hung windows	
7	riscontro nottolino cam strikes	
8	compensatore cava ferramenta clip for hardware mounting	
9	elemento di collegamento extension piece	126 mm



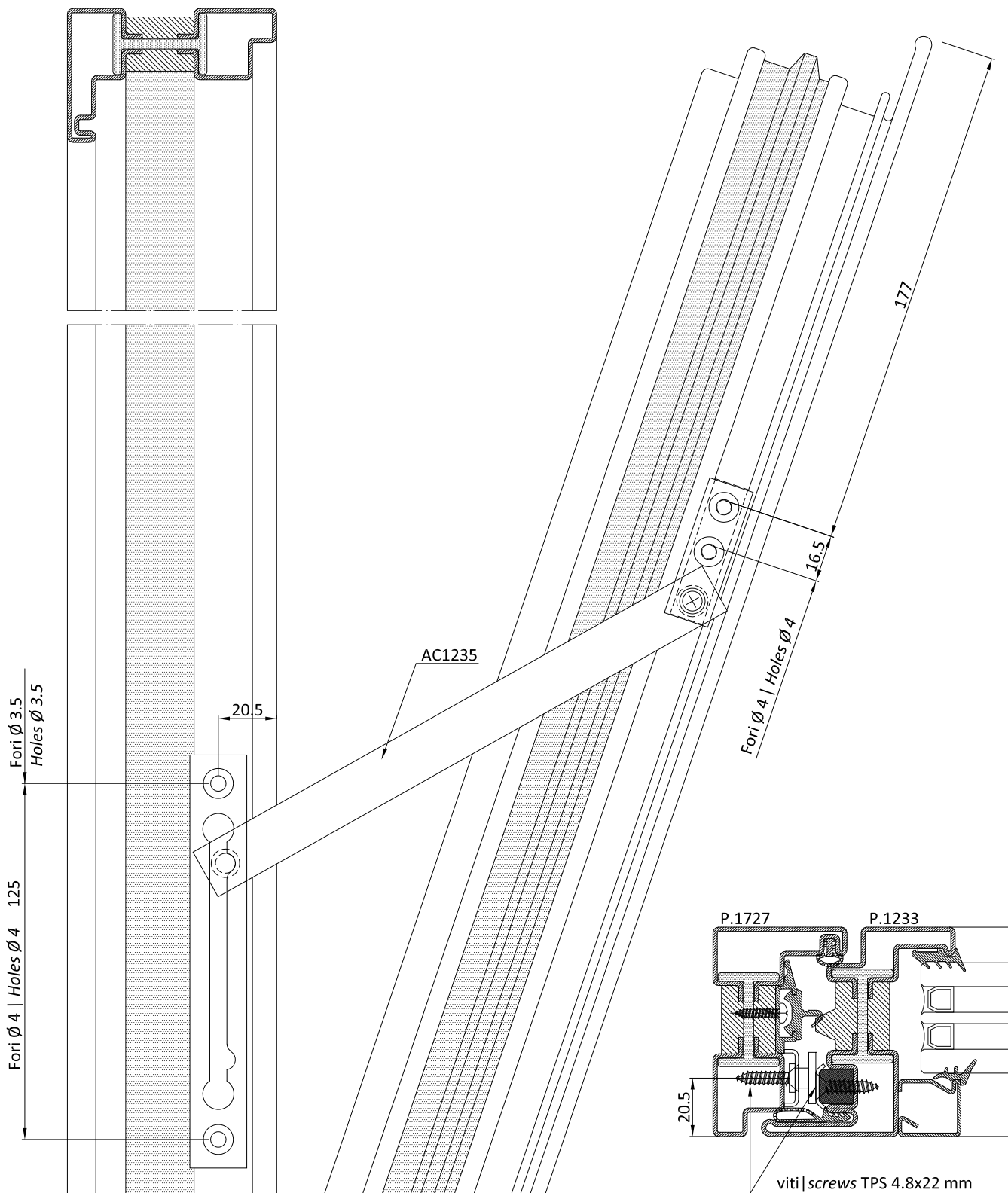
AC2632/C

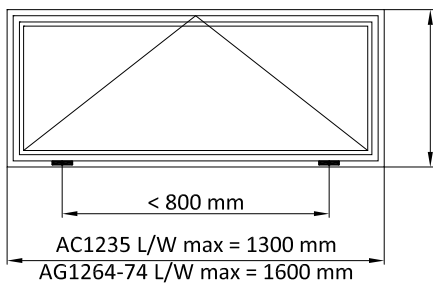
cerniere non incluse nel kit
hinges not included in the kit



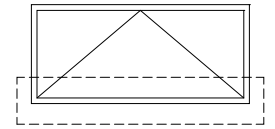


Peso max. per anta 70 kg
H min anta 300 mm
Max. weight for leaf: 70 kg
W min leaf 300 mm





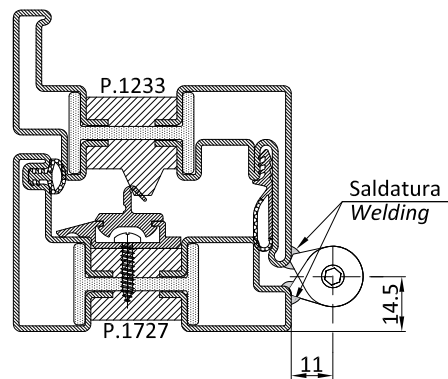
AC1235 H max = 800 mm
AG1264-74 H max = 1200 mm



AC1235
Peso max. per anta 70 kg
Max. weight for leaf: 70 kg

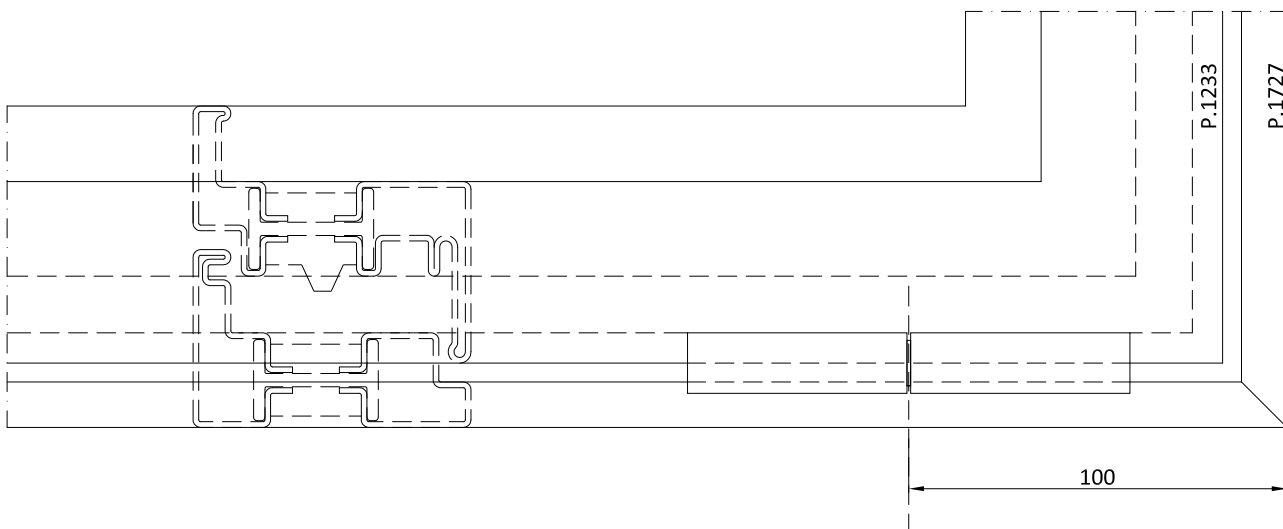
AG1264 - AG1274
2 cerniere
peso massimo anta 70 kg
3 cerniere
peso massimo anta 100 kg

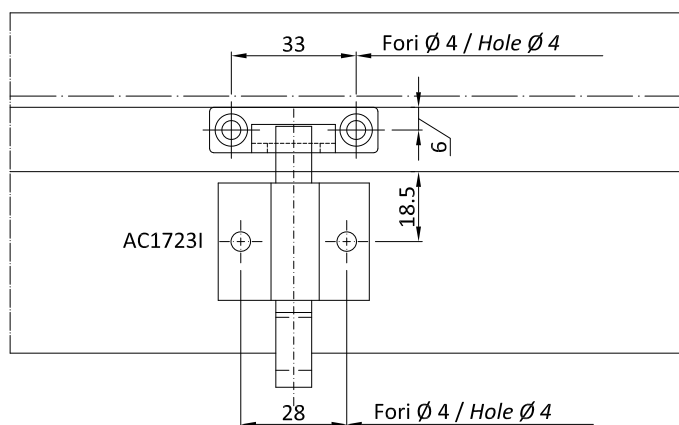
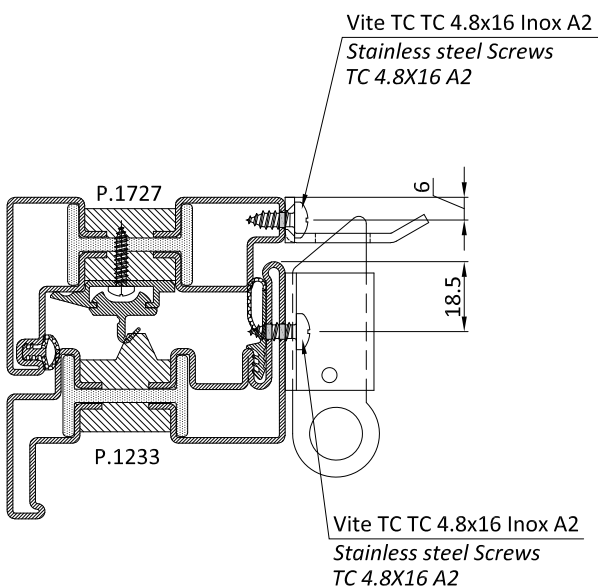
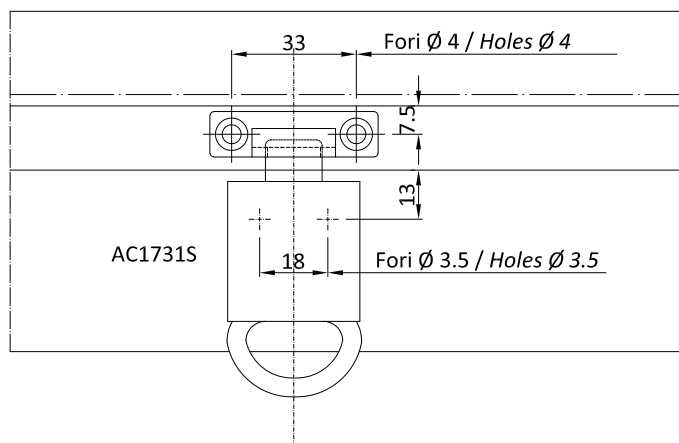
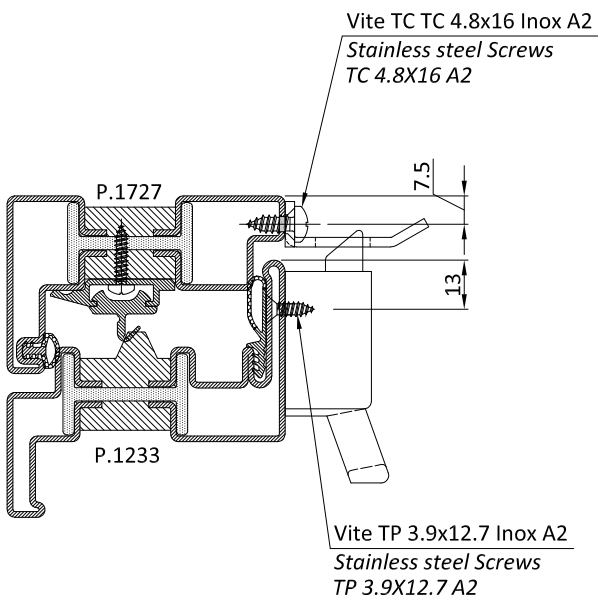
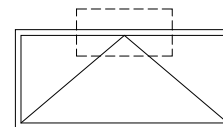
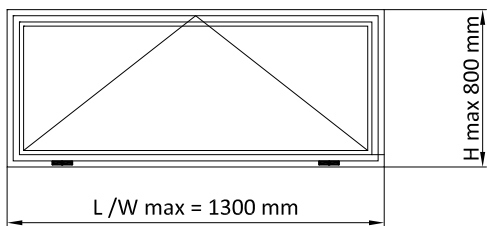
2 hinges
maximum leaf weight 70 kg
3 hinges
maximum leaf weight 100 kg

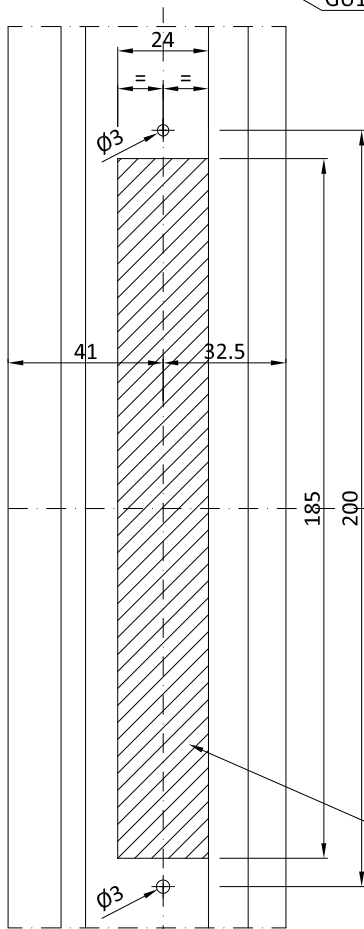
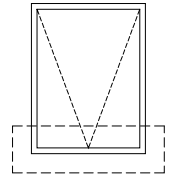
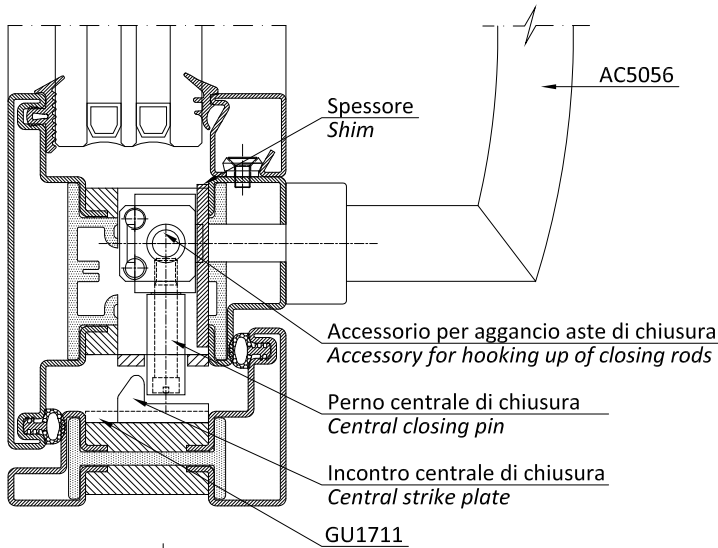


Posizionare le cerniere come da disegno saldandole sui lati.
Position the hinges as in the drawing, welding them on the sides.

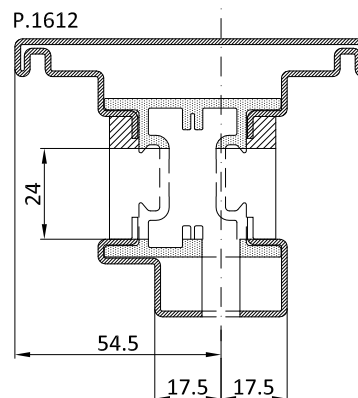
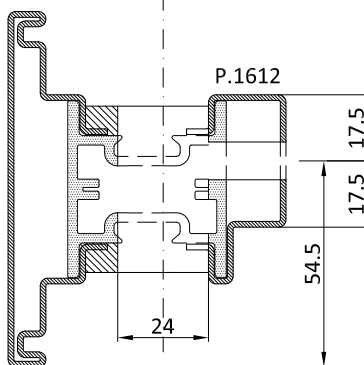
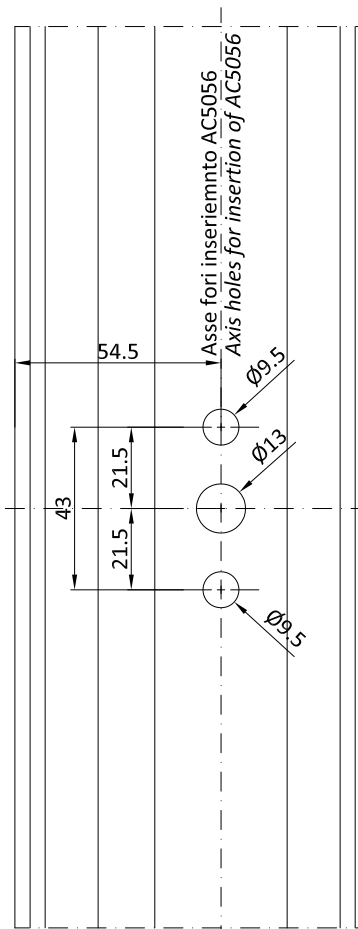
- La lavorazione può essere effettuata anche in posizioni intermedie alla larghezza del vasistas.
- La lavorazione SX è speculare alla DX.
- Tooling can be carried out also in intermediate positions regarding the width of the hopper or bottom-hung window.
- Tooling on left is the same as that on the right.

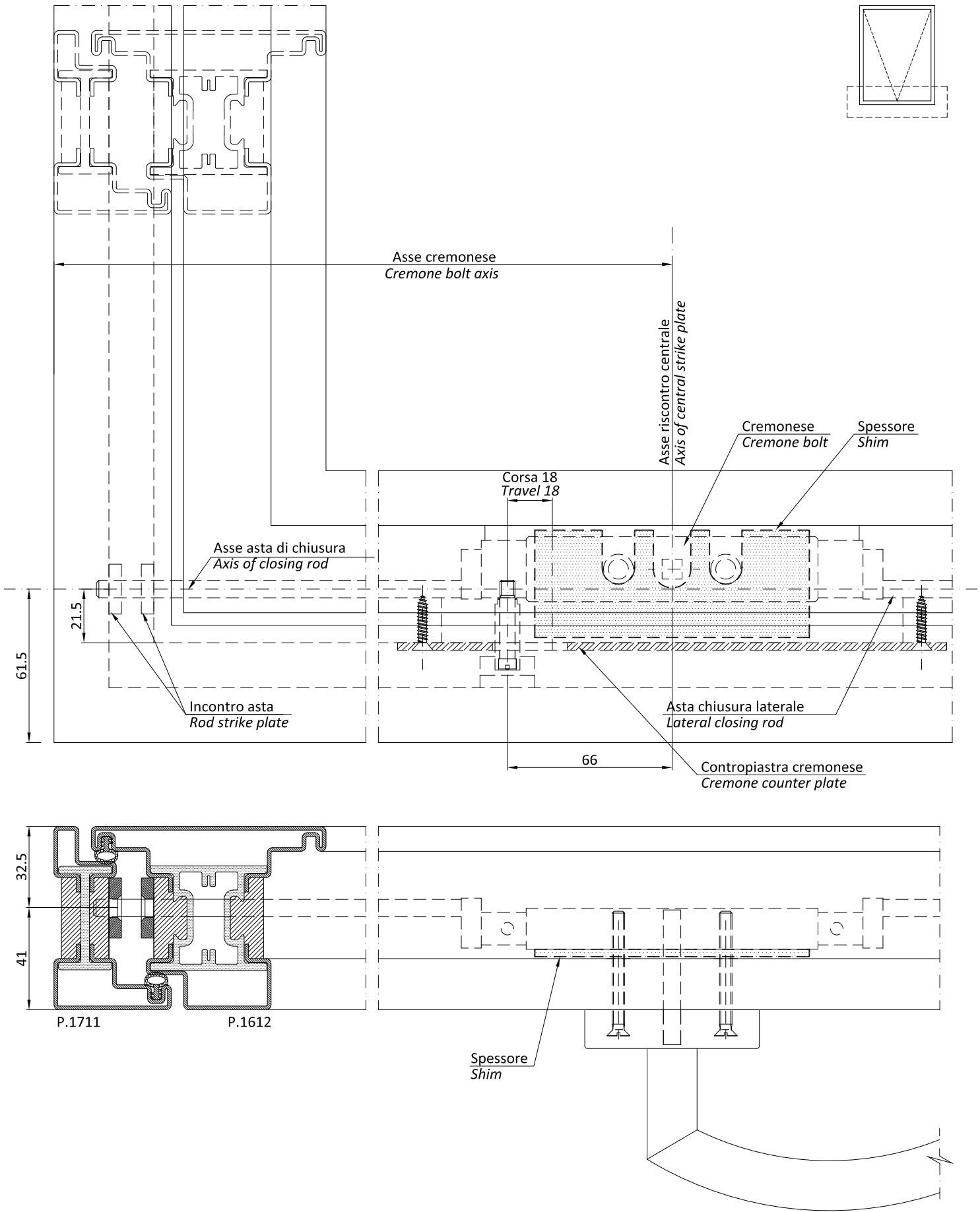




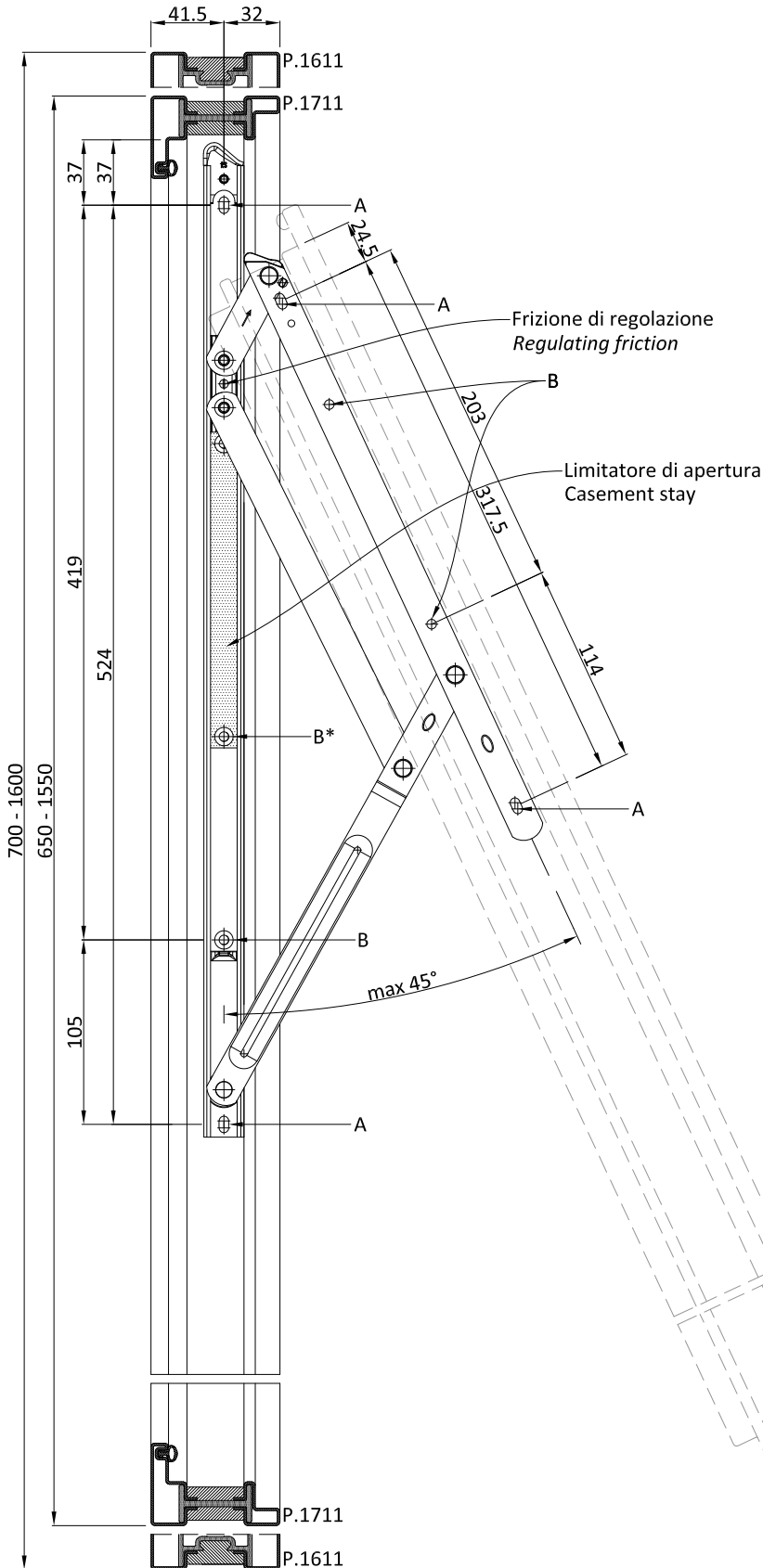
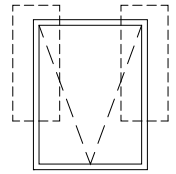


fresatura passante per inserimento cremonese
Through milling of interface connection for insertion of cremone bolt





Peso massimo anta 75 kg
Maximum vent weight 75 kg

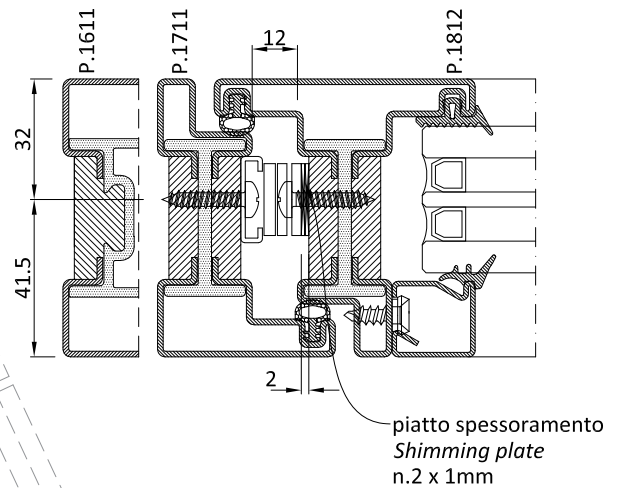


- Fissare i compassi in corrispondenza dei fori asolati A foro su profilo Ø 4 per viti TC 4.8x22 mm;
- Verificare il funzionamento dei compassi;
- Fissare l'apertura massima desiderata mediante il limitatore di apertura;
- Completare l'operazione di fissaggio nei rimanenti fori B.

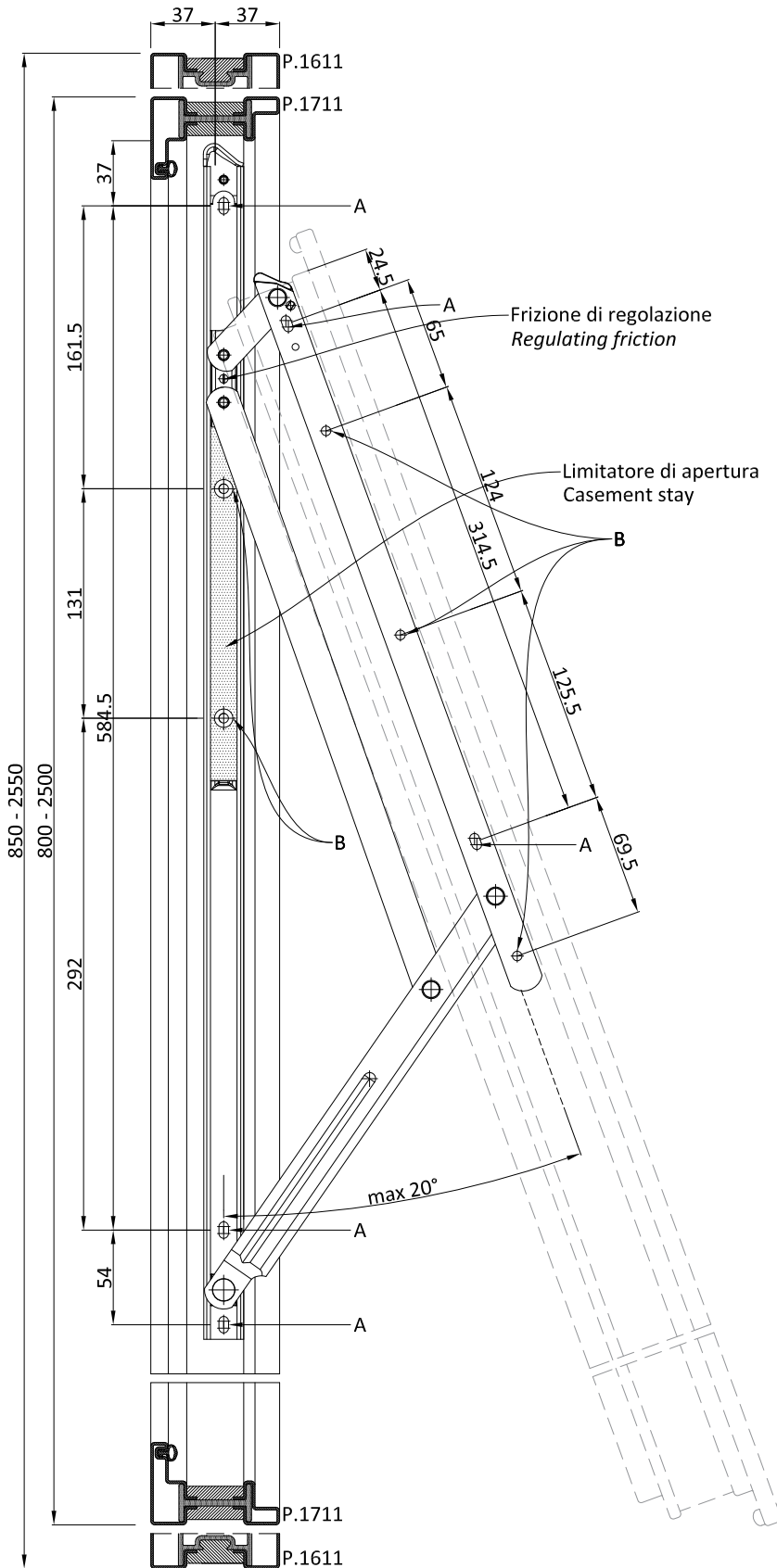
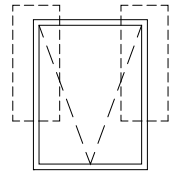
* posizione determinata dalla apertura massima desiderata - foro da eseguire in opera

- Fit the side arms into the slotted holes A - hole on profile Ø 4 for TC 4.8x22 mm screws;
- Check the side arms move properly;
- Set the desired maximum opening using the casement stay;
- Complete the anchoring operation in the remaining B holes.

* Position determined by the maximum opening desired - hole to be made during installation



Peso massimo anta 120 kg
Maximum vent weight 120 kg

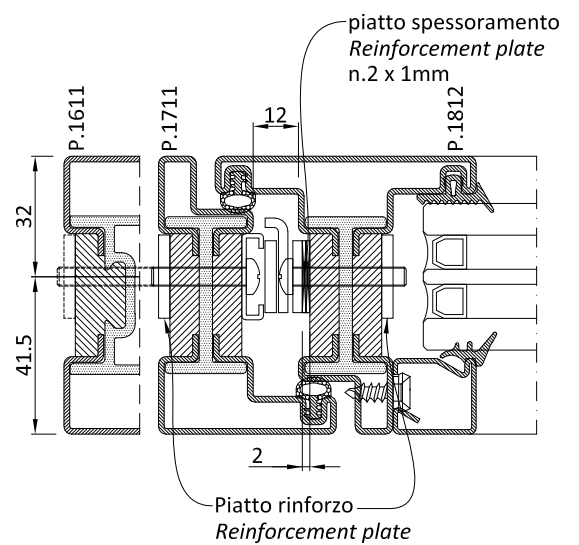


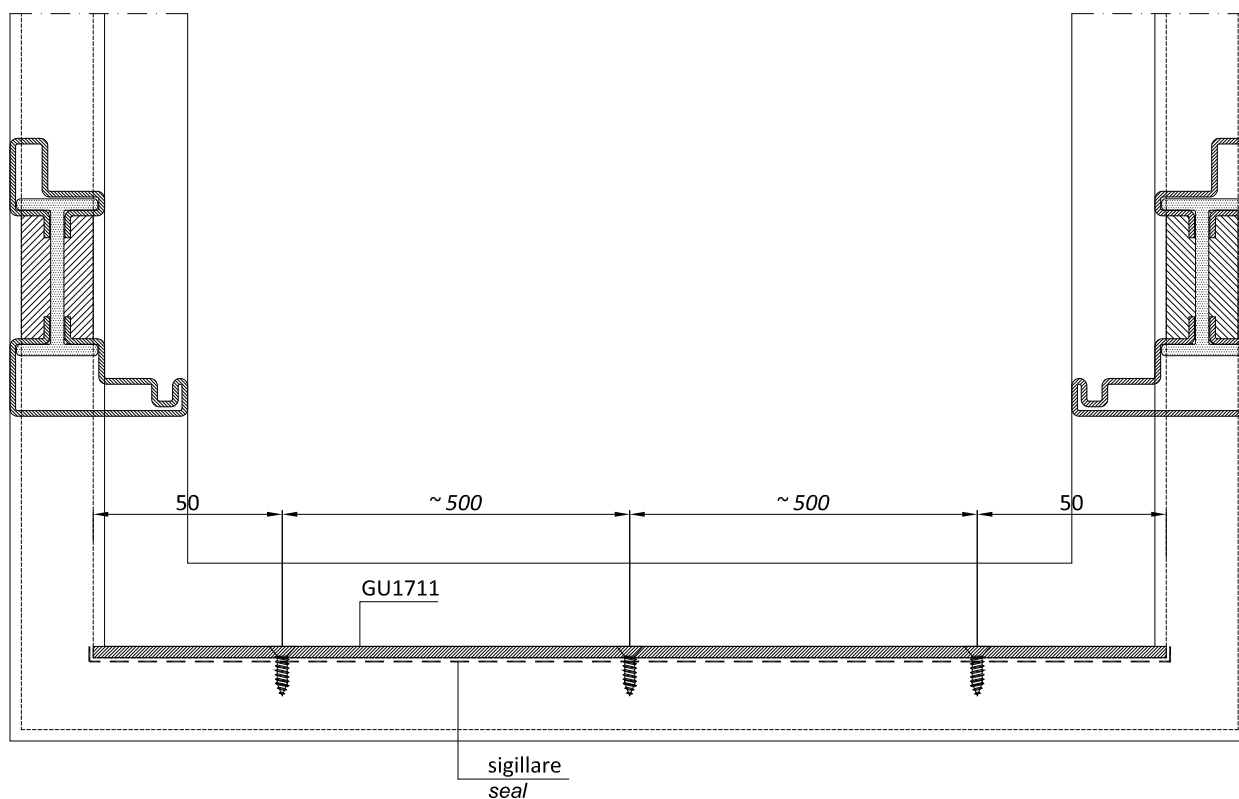
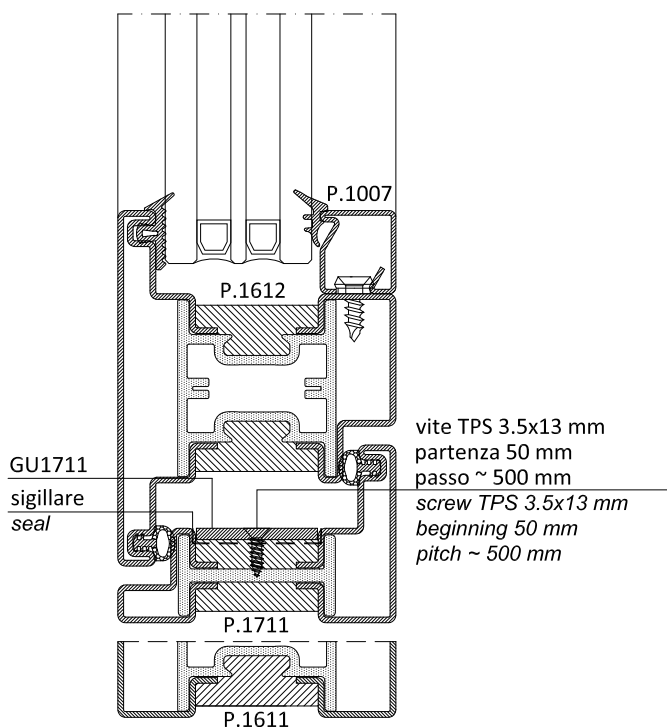
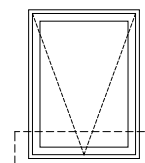
- Fissare i compassi in corrispondenza dei fori asolati A foro su profilo Ø 4 per viti TC 4.8x22 mm;
- Verificare il funzionamento dei compassi;
- Fissare l'apertura massima desiderata mediante il limitatore di apertura;
- Completare l'operazione di fissaggio nei rimanenti fori B.

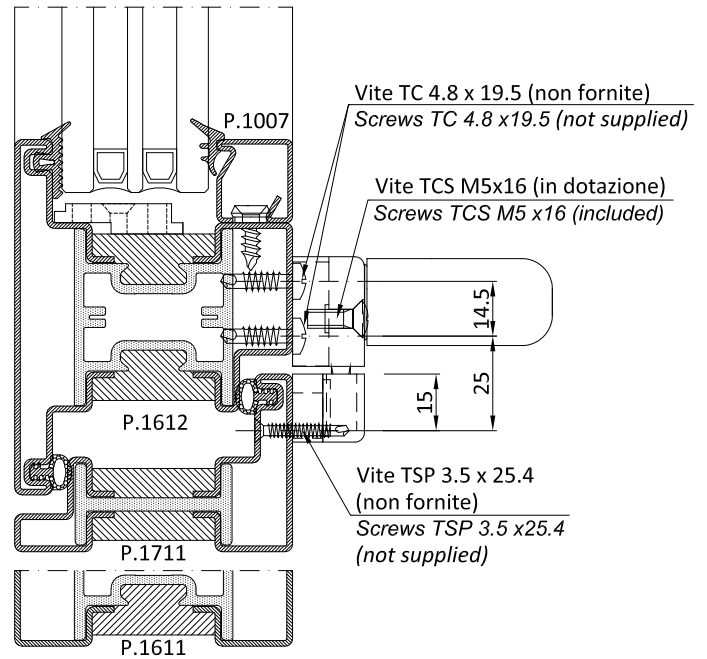
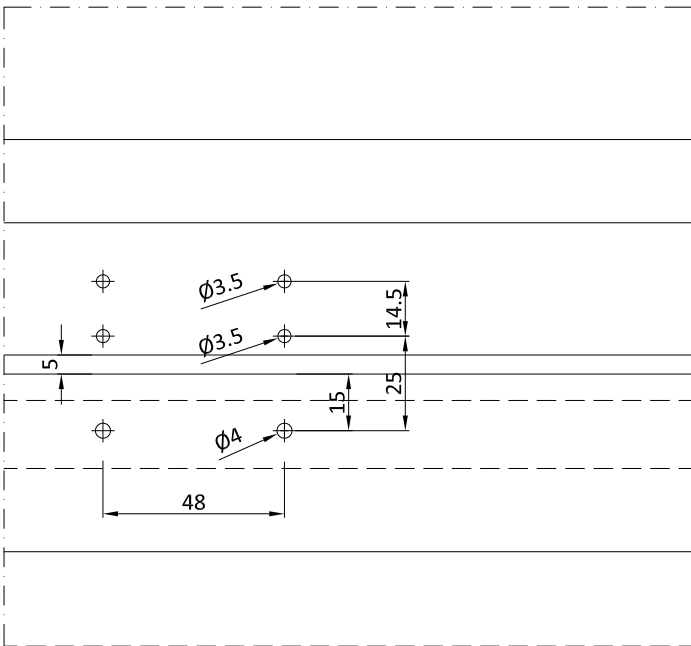
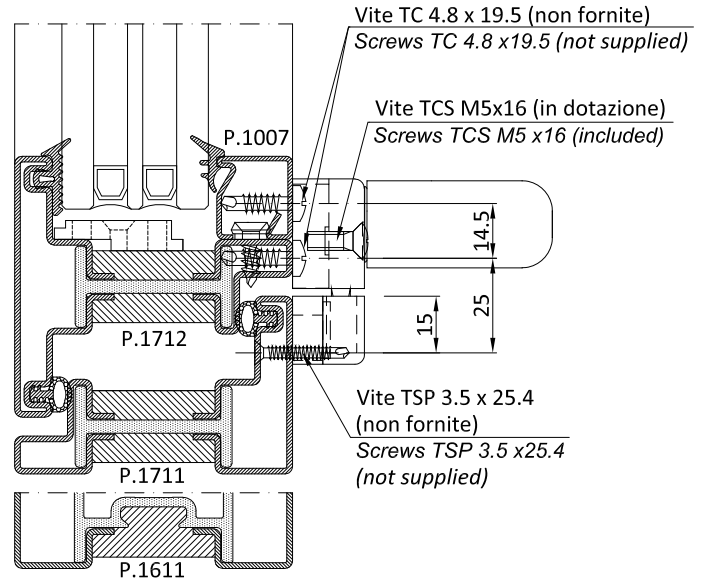
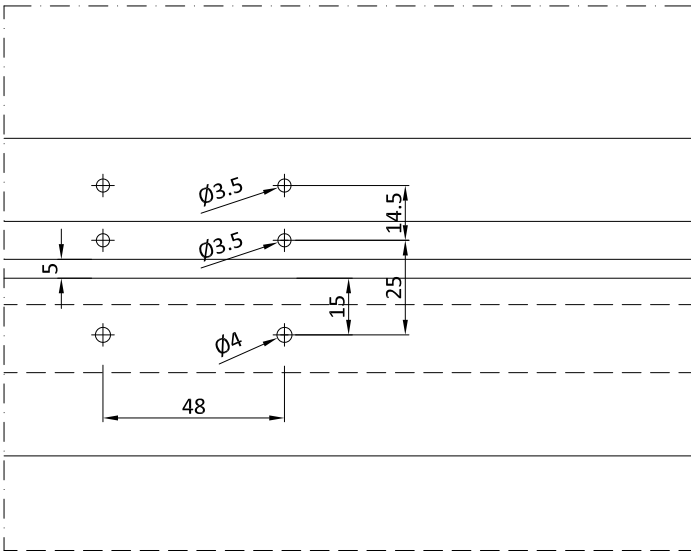
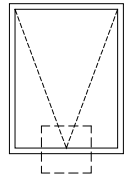
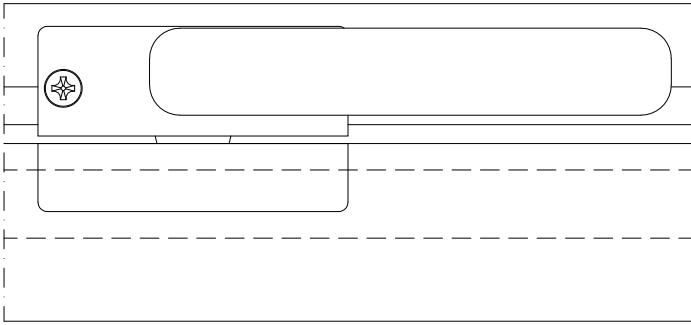
* posizione determinata dalla apertura massima desiderata - foro da eseguire in opera

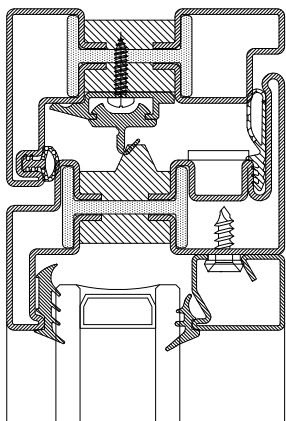
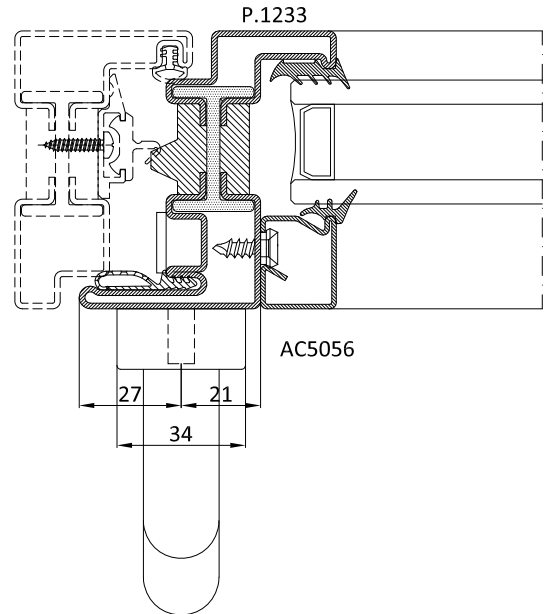
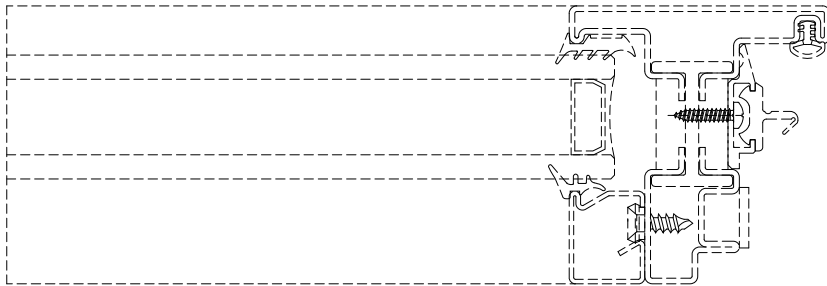
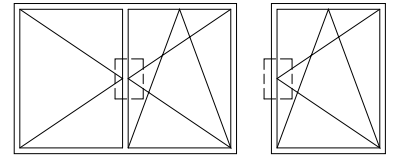
- Fit the side arms into the slotted holes A - hole on profile Ø 4 for TC 4.8x22 mm screws;
- Check the side arms move properly;
- Set the desired maximum opening using the casement stay;
- Complete the anchoring operation in the remaining B holes.

* Position determined by the maximum opening desired - hole to be made during installation







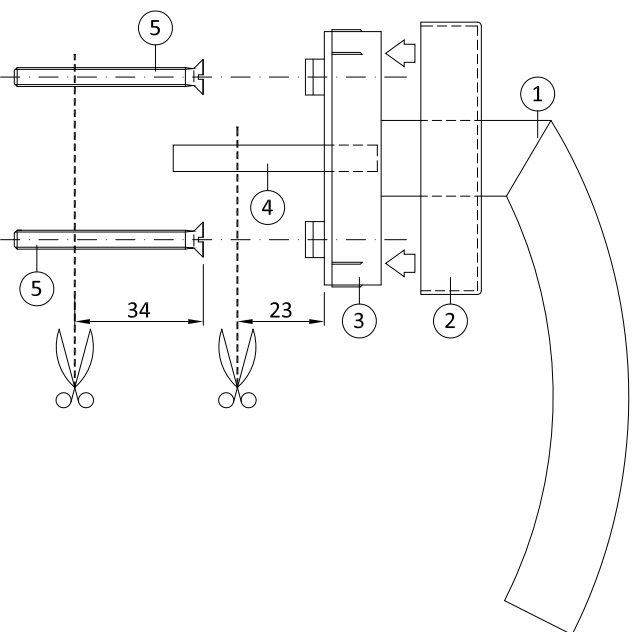
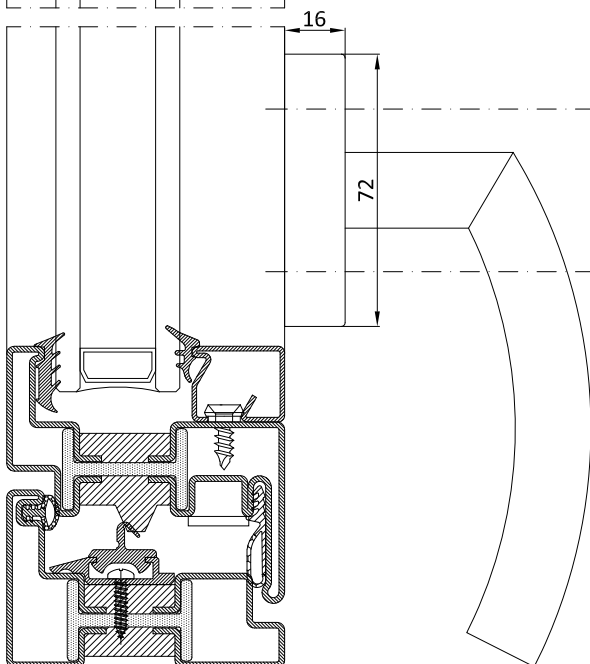


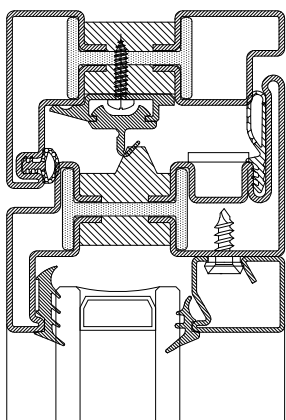
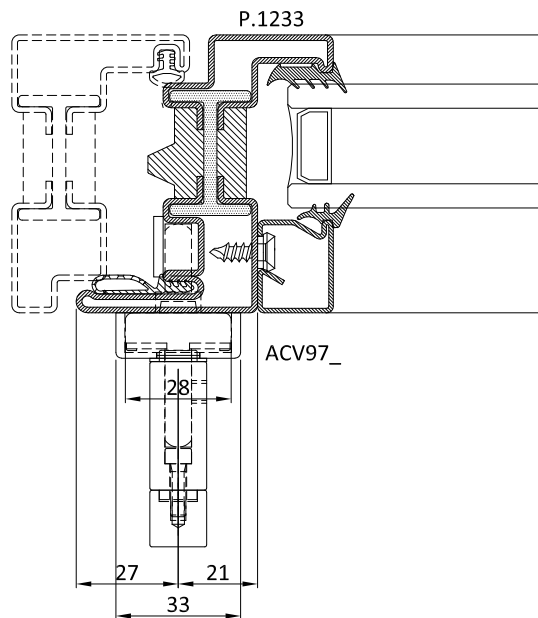
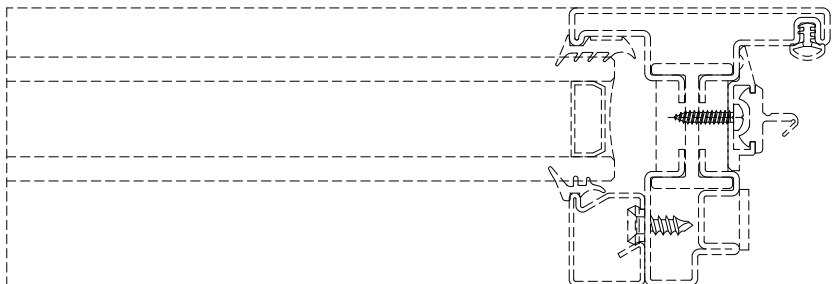
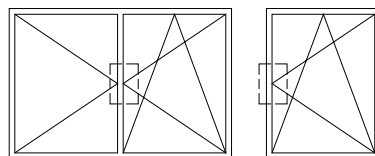
AC5056 :

- 1) Impugnatura
- 2) Rosetta
- 3) Corpo maniglia
- 4) Quadro
- 5) Vite TP M5x50 (non fornite)

AC5056 :

- 1) Handle grip
- 2) Rose
- 3) Handle body
- 4) Spindle bar
- 5) Flat head screws M5x50 (not supplied)



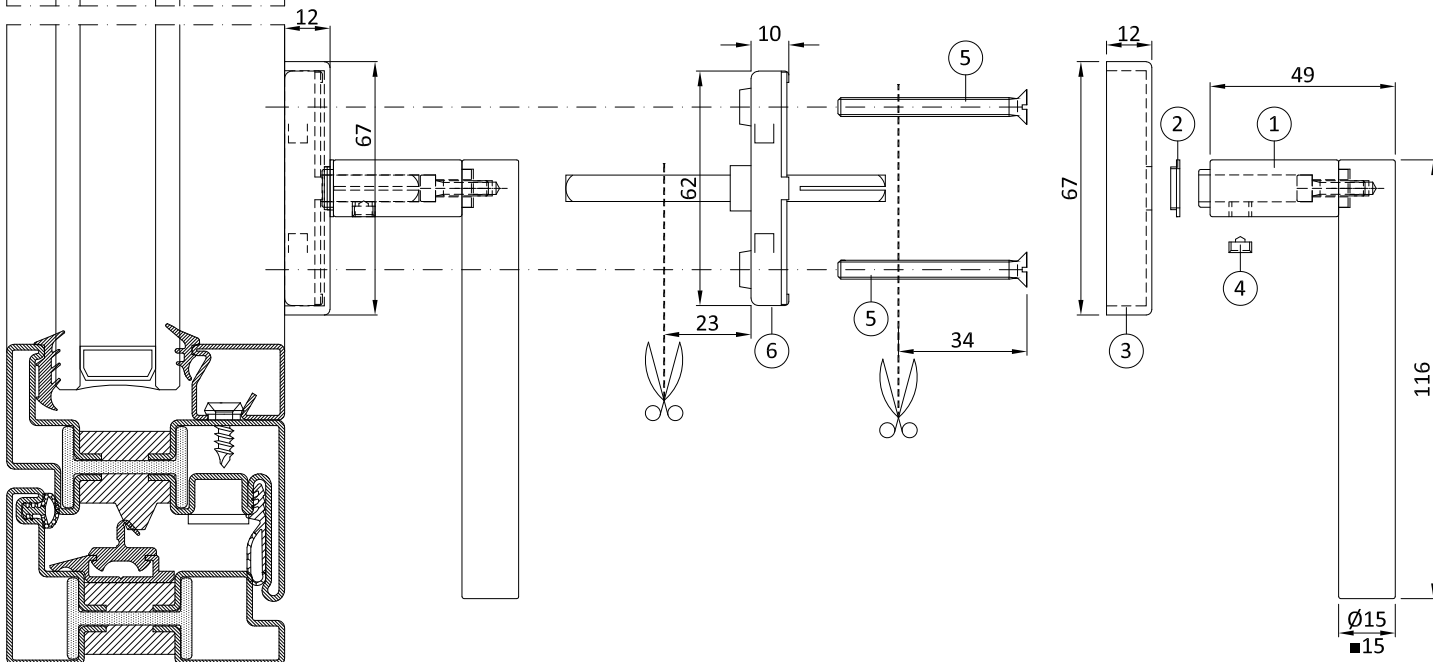


ACV97- :

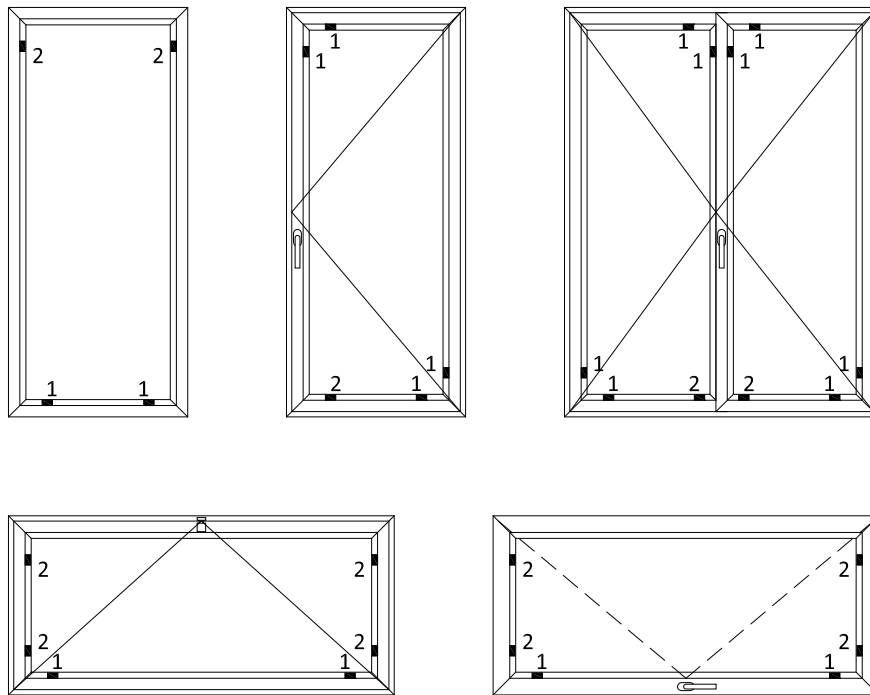
- 1) Impugnatura
- 2) Rondella
- 3) Rosetta
- 4) Grano M6x6
- 5) Vite TP M5x50 (non fornite)
- 6) AC1356 Movimento DK

ACV97- :

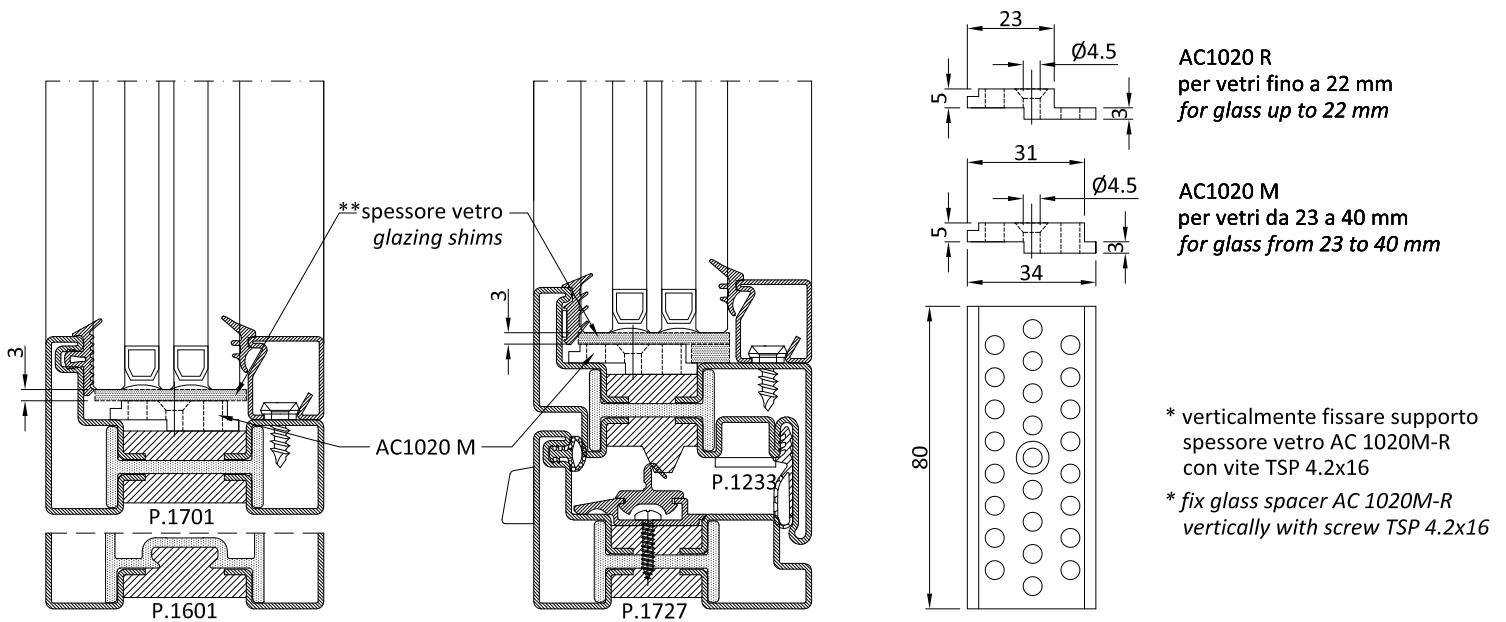
- 1) Handle grip
- 2) Ring
- 3) Rose
- 4) Dowel M6x6
- 5) Flat head screws M5x50 (not supplied)
- 6) Tilt-turn movement AC1356



Finestra | Window



- 1) spessore portante | carry shim
- 2) spessore distanziatore | compensation shim



AC1020 R
per vetri fino a 22 mm
for glass up to 22 mm

AC1020 M
per vetri da 23 a 40 mm
for glass from 23 to 40 mm

* verticalmente fissare supporto spessore vetro AC 1020M-R con vite TSP 4.2x16

* fix glass spacer AC 1020M-R vertically with screw TSP 4.2x16

Note / Note

- La larghezza degli spessori è almeno pari o maggiore (+2 mm) dello spessore del vetro installato.
- La posizione degli spessori deve essere garantita dall'utilizzo di materiale adeguato che ne eviti lo spostamento.
- The shims' width is the same or greater (+2 mm) than the thickness of the glass installed.
- The position of the shims has to be ensured by using appropriate material that avoids creeping.

* vite TSP 4.2 x 16 mm non inclusa - screw TSP 4.2 x 16 mm not included

** spessori vetro non inclusi - glass thickness not included



Generalità

I sistemi progettati e sviluppati dalla Secco Sistemi sono idonei per la fabbricazione di un'ampia gamma serramenti, vetrate e facciate in metallo. I sistemi sono rivolti ad aziende esperte e professionali nel campo della lavorazione dei metalli e della costruzione di serramenti e facciate, che sono a conoscenza delle normative di riferimento, delle direttive e delle specifiche tecniche del fornitore del sistema, nonché delle fondamentali regole dell'arte per la produzione e installazione di questi manufatti. Tutta la documentazione tecnica fornita costituisce un riferimento per i tecnici qualificati delle aziende al fine di indicare le modalità per la costruzione dei prodotti. In ogni caso i tecnici qualificati devono analizzare criticamente le indicazioni riportate per verificarne la loro adeguatezza per ogni singola commessa in relazione ai carichi, agli stress previsti e alle condizioni di messa in opera, essendo impossibile riportare in questa documentazione tutte le varianti riscontrabili nei progetti reali.

Tolleranze

EBE 75 prevede l'accoppiamento tra i telai esterni e le ante apribili con distanza di 12 mm su porte e 15 mm su finestre. Per garantire il corretto funzionamento degli accessori e delle guarnizioni le lavorazioni devono essere eseguite con particolare attenzione e precisione: si consiglia di mantenere la tolleranza per la dimensione degli elementi apribili compresa tra +0/-2 mm e la tolleranza per il sormonto degli stessi compresa tra +0/+1 mm.

Taglio/Lavorazioni

I profili EBE 75 in acciaio zincato, acciaio inox e corten possono essere tagliati con le normali troncatrici a disco utilizzate per i tubolari in acciaio, mentre per il taglio dei profili in ottone possono anche essere utilizzate troncatrici per le serie di alluminio. Vista la loro particolare dimensione e forma si consiglia di utilizzare le ganasce di taglio previste dal sistema per assicurare una perfetta stabilità dei profili durante il taglio. La verifica del taglio, sia per la sezione inclinata a 45° che per la sezione verticale a 90°, dovrebbe garantire una tolleranza compresa tra -1°/+1°. Tutte le lavorazioni devono essere eseguite con il rispetto della seguente nota tecnica ed eventuali modifiche concordate con l'ufficio tecnico Secco Sistemi.

Saldatura

I profili EBE 75 possono essere saldati con i tradizionali sistemi di saldatura (MIG/MAG, TIG), con un idoneo sistema di lubrificazione/refrigerazione e utilizzando le istruzioni presenti nella presente nota tecnica ed evitando di saldare in prossimità della giunzione a taglio termico. L'eventuale riscaldamento del poliuretano libera sostanze gassose a base di aldeidi e CO: per tale ragione si consiglia di saldare con gli appositi DPI previsti e in zone con sufficiente areazione e in presenza di sistema per l'evacuazione dei fumi. I profili in corten devono essere saldati con apposito filo in corten mentre per i profili in ottone si può utilizzare un filo CuSi3. Si raccomanda di saldare in profondità e senza lasciare fori e porosità le aree in contatto, di lisciare e pulire adeguatamente la superficie saldata per garantire una corretta resistenza strutturale all'angolo e permettere una successiva verniciatura senza imperfezioni estetiche visibili (pori e ondulazioni).

Verniciatura/Brunitura

I profili EBE 75 sono stati progettati per essere verniciati a polveri in forni con temperature di 180°C per 25 minuti. La zona a taglio termico in poliuretano non è in grado di accogliere con sufficiente adesione le polveri poliesteri e perciò si consiglia di ricoprire tali zone, nelle sole parti destinate ad essere in vista, con apposite pellicole adesive idonee al passaggio in forno.

I telai prima della verniciatura o della brunitura devono essere forati come da istruzioni presenti in questa nota tecnica per permettere la fuoriuscita dei liquidi utilizzati durante il pretrattamento delle superfici. All'uscita del forno di polimerizzazione della polvere i telai vanno rimossi accuratamente e adagiati in posizione piana sino al loro completo raffreddamento.

Si consiglia di seguire il ciclo di pretrattamenti e verniciatura presente nella documentazione Secco Sistemi.

Vetrage

Il sistema di fissaggio del vetro prevede l'utilizzo di fermavetri agganciati all'interno tramite clips o boccole interne e mandati in pressione con l'incastro dell'apposita guarnizione interna; all'esterno è previsto l'utilizzo di una guarnizione perimetrale continua giuntata e sigillata in un angolo superiore o di una guarnizione butilica di fondo giunto e un cordolo di silicone applicato secondo le prescrizioni tecniche del fornitore del prodotto. Per il corretto funzionamento del sistema si suggerisce di verificare la perfetta compressione delle guarnizioni interne del fermavetro.

Installazione

La corretta installazione deve garantire il mantenimento delle performance dichiarate nella marcatura CE e testate in laboratorio. Si consiglia di progettare un corretto numero di fissaggi in relazione al tipo di controtelaio/muratura esistente e alle dimensioni degli elementi da installare. Al termine dell'installazione si verifichi il corretto funzionamento del serramento (facilità di apertura/chiusura, stabilità dell'anta aperta a riposo, etc.), il rispetto delle fughe e del sormonto tra ante apribili e telai fissi, il regolare posizionamento delle guarnizioni e delle sigillature, il drenaggio del giunto aperto e la mancanza di difetti estetici sulle superfici dei telai e del vetro.

General information

The systems designed and developed by Secco Sistemi are suitable for the manufacturing of a wide range of doors, windows and shutters, as well as faces or facades in metal. The systems are designed for professional and expert companies in the metal-working sector and that of construction of doors, windows, shutters and facades. These companies are well aware of the specific regulations and the directions and technical specifications of the system supplier, and also the fundamental rules of the art of manufacturing and installing these products. All the technical documentation provided furnishes a source of reference for the qualified technicians of the companies, giving indications as to how the products should be constructed. These qualified experts must critically analyse the indications to verify their adequacy for each single order in terms of load, stress and conditions of installation, particularly as this documentation cannot provide for all the different variations that may be found in projects.

Tolerance

EBE 75 is made by coupling external frames with the opening leaves with a distance of 12 mm on doors and 15 mm on windows. To ensure the correct functioning of hardware and gaskets, tooling must be performed with great care and precision. It is advised to keep the tolerance between $+0/-1$ mm for opening elements and between $+0/+0.5$ mm for their overlapping area.

Cut / Processing

EBE 75 profiles in galvanized steel, stainless steel and corten steel can be cut with normal saws, like those used for steel pipes. EBE 75 profiles in brass can be cut with saws used for aluminium. Given their dimension and size, it is recommended to use the cutting jaws advised to ensure perfect stability during the cutting procedure. In order to verify the correctness of the cut, the tolerance of both the 45° and the 90° sections must be between $-1^\circ/+1^\circ$. All Tooling must be performed in line with this technical note and any variations agreed with Secco Sistemi's Technical Department.

Welding

EBE 75 profiles can be welded with the traditional systems (MIG/MAG, TIG), with an appropriate lubricating/cooling system and according to the instructions as per this technical note. Avoid welding near the thermal break joint. Heating any polyurethane items releases gaseous substances containing aldehydes and CO. For this reason it is recommended to weld with the special Personal Protective Equipment suggested and in areas with sufficient ventilation and fume-disposing systems. The corten profiles must be welded with special corten wire, while for profiles in brass a CuSi3 wire can be used. It is recommended to weld in depth, to avoid leaving any holes or porosity on the surfaces and to smooth and clean the welded surface thoroughly. This is to guarantee a proper structural resistance at the corner and to allow for later painting without any visible imperfections (pores and ripples).

Painting/Burnishing

EBE 75 profiles have been designed to be painted with the powder coating technique in industrial ovens at temperatures of 180°C for 25 minutes. The thermal break area is not designed to absorb polyester powders and therefore it's advised to cover the visible areas with appropriate industrial-oven-resistant adhesive films (SA1024 and SA1033). Holes must be drilled in the frames (as per instructions in these technical specifications) before painting or burnishing in order to allow drainage of any liquid used as a pre-treatment of the surfaces. Once out of the oven, the frames must be accurately removed and laid in a horizontal position until complete cooled.

It is advised to follow pre-treatment and painting cycles as outlined in the Secco Sistemi documentation.

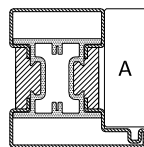
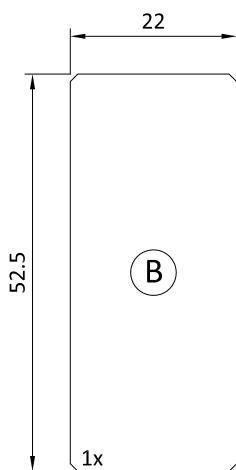
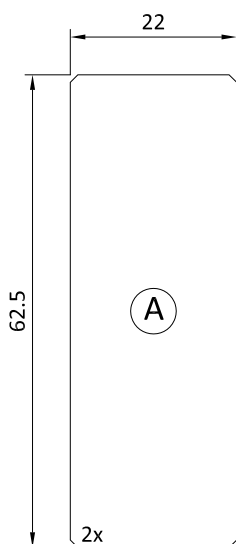
Glass application

Glass needs to be secured internally and externally. Internally, glazing beads must be used together with clips or bushings and then secured by pressure with the appropriate gasket; externally a continuous perimetrical gasket should be applied, jointed and sealed in a top corner or a butyl seal and a thread of silicone that must be applied according to the product supplier's technical specifications. In order to ensure the correct functioning of the system, it is recommended to verify the proper pressurization of the internal glazing bead gaskets.

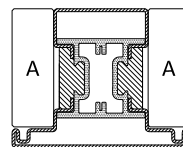
Installation

Proper installation must guarantee that the performances declared in the EC marking and verified in the lab will remain constant. It is advised to arrange a correct series of set ups with reference to the existing type of subframe/brickwork and to the dimensions of the elements to install. Once installation is completed, the proper functioning of the window/door (easiness of opening/closing, stability of the open leaf, etc.), should be tested as well as the correctness of joints and overlapping areas between opening leaves and fixed frames, the proper positioning of gaskets and seals, the drainage of frames with weep system and the absence of any aesthetic defects on the frame and glass surfaces.

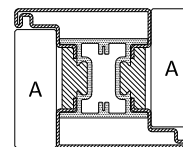
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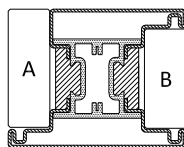
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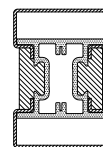
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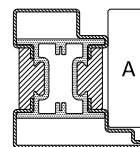
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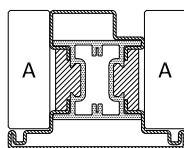
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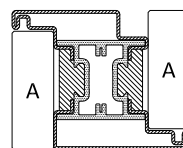
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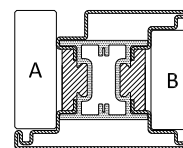
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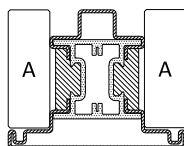
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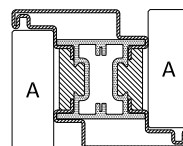
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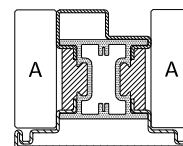
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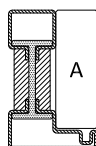
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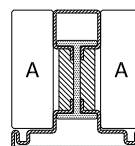
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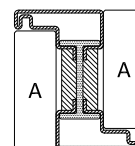
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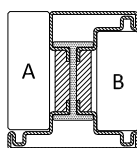
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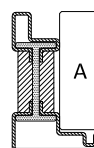
P.1702



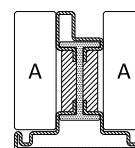
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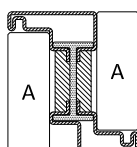
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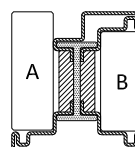
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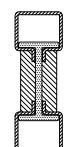
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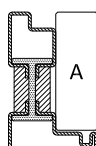
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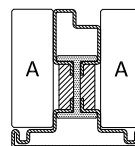
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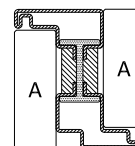
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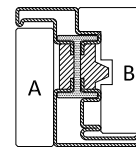
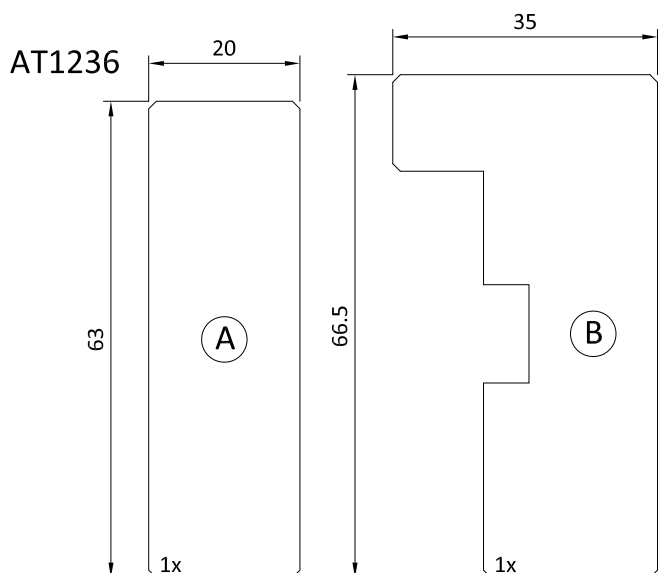
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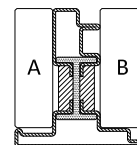
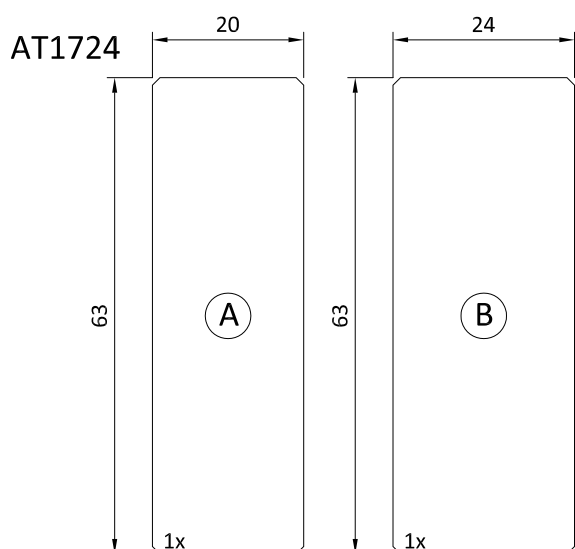
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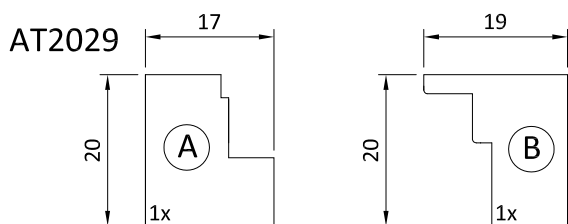
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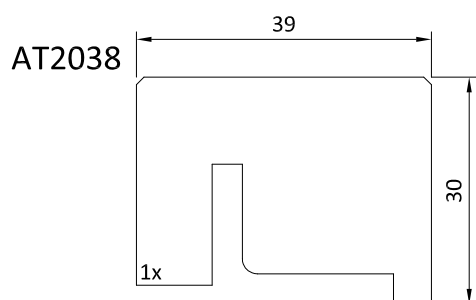
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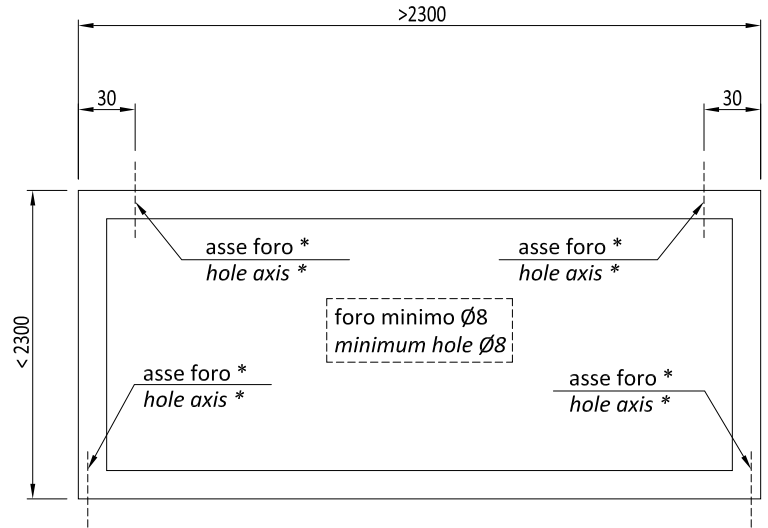
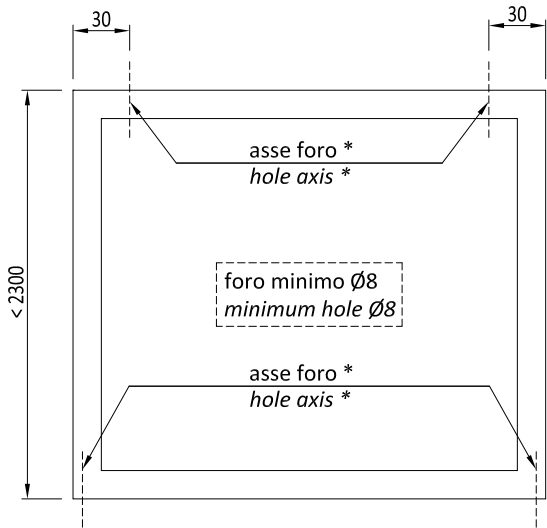
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P.2038



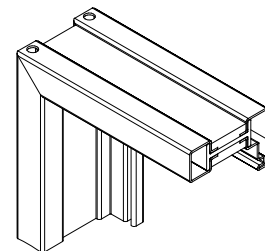
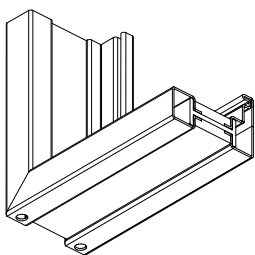
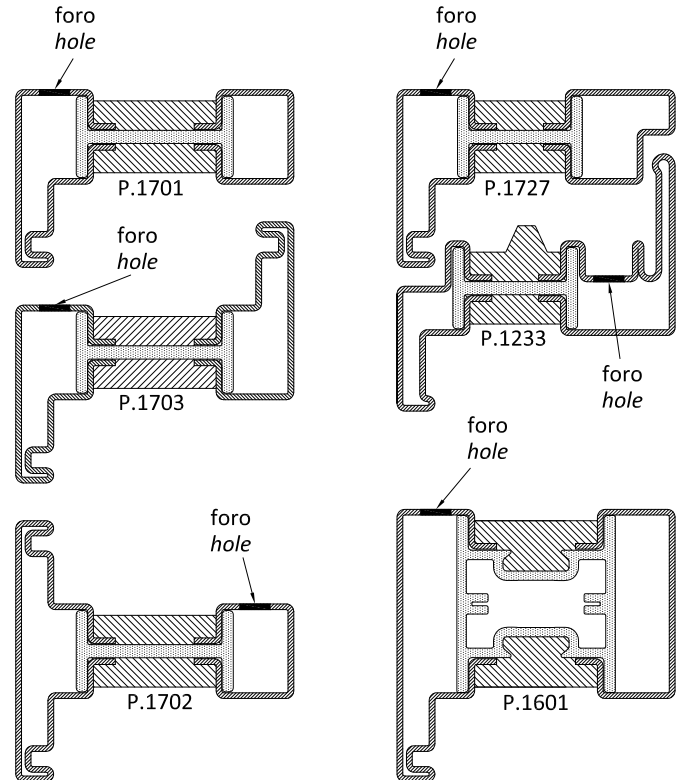
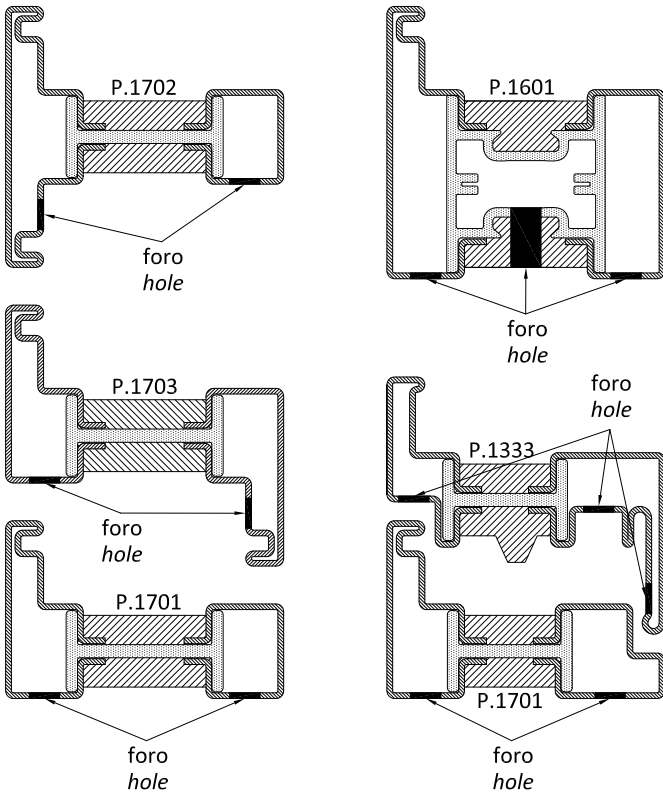
* forare alla massima estremità
* to be drilled on the extremity

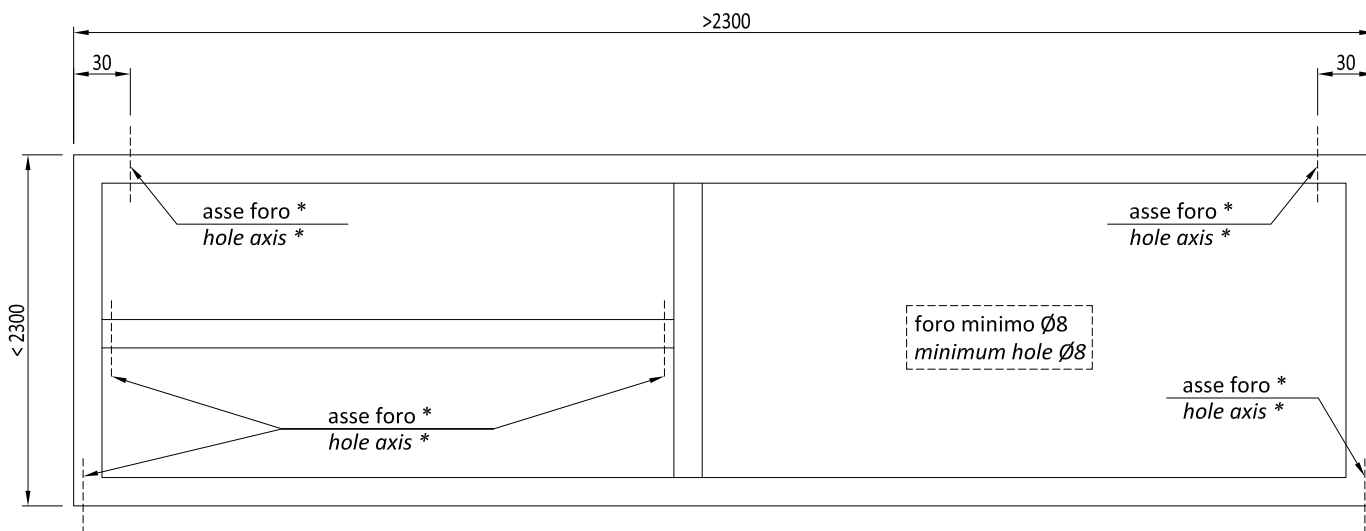
N.B. dimensioni orientamento telai indicative - da verificare con l'impianto di verniciatura/brunitura scelto

N.B. frame dimensions are indicative - they have to be checked with the powder painting / burnishing plant

FORATURA LATO INFERIORE PER SCOLO LIQUIDI
DRILLING BOTTOM FRAME FOR LIQUID DRAINAGE

FORATURA LATO SUPERIORE PER APPENDERE
DRILLING UPPER FRAME FOR FRAME HANGING



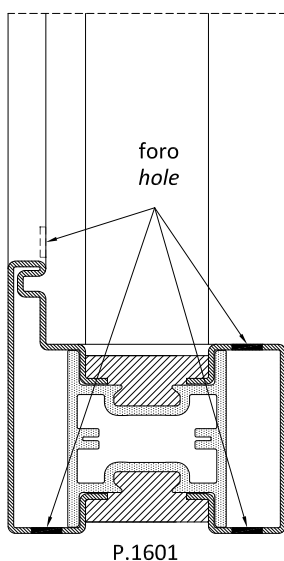
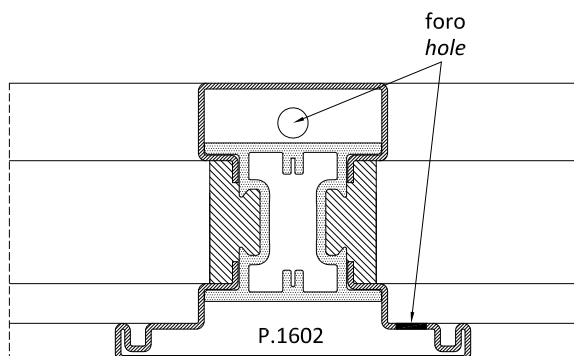


* forare alla massima estremità
* to be drilled on the extremity

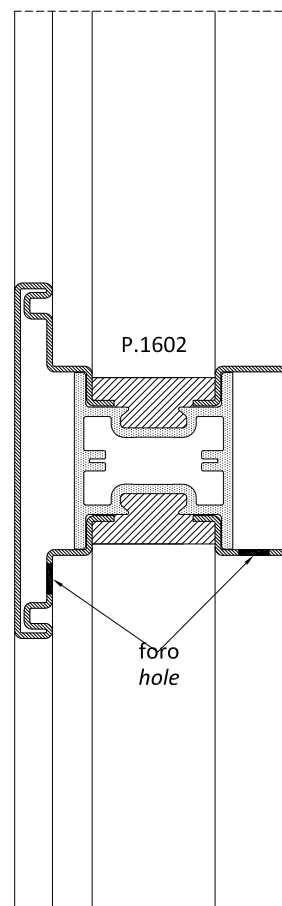
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N.B. frame dimensions are indicative - they have to be checked with the powder painting / burnishing plant

FORATURA MONTANTI
DRILLING MULLION



FORATURA TRAVERSI
DRILLING TRANSOM



Troncatricecaratteristiche minime della macchina

- Potenza: 1.8 – 2.5 kW;
- Possibilità di taglio a 45° nei due sensi e a 90°;
- Velocità di taglio ideali: 15-30 giri/min per acciaio inox;
60-90 giri/min per acciaio zincato e corten,
90 giri/min o superiori per bronzo (OT/67);
- Capacità di taglio: 150 x 80 mm a 90°;
100 mm taglio a 45°.

caratteristiche della lama

- Lama da 350 mm con spessore 2.5 mm;
- N° denti: - 300 per tagli a 45°;
- 350 per tagli a 90°;
- Materiale: HSS (verificare materiali di commercio con finiture che migliorano la durata delle lame).

NB: è possibile tagliare la lega OT/67 con le stesse macchine dell'alluminio.

Pantografocaratteristiche minime della macchina

- Mandrino con velocità regolabile 2000-11000 giri/min (per un corretta lavorazione su acciaio inox è necessario operare a n° ridotto di giri < 4000);
- Struttura in ghisa adatta al taglio acciaio;
- Testata pesante per limitare le vibrazioni;
- Chiusura del profilo da lavorare con morse.

caratteristiche minime delle frese

- Materiale: HSS (verificare materiali di commercio con finiture che migliorano la durata delle frese);
- Frese a 4 denti;
- Frese con diametro 5 mm per le lavorazioni di scasso.

Foraturemontaggio componenti di chiusura e movimentazione sui profilati in acciaio inox

- Forare con punte da trapano HSS del diametro indicato sulla corrispondente tavola tecnica;
- Maschiare il foro con vite autofilettante zincocromata avente diametro corrispondente alla vite inox fornita nel kit con l'articolo da montare;
- Posizionamento e fissaggio definitivo dell'articolo con le viti inox in dotazione.

fresatura di cave e asole sui profili inox

- Adoperare macchine (pantografi o fresatrici) adeguate alle lavorazioni dell'acciaio;
- Regolazione del numero di giri max (3000 giri/1');
- Impiego di frese di diametro massimo di 8mm a 4 pale in acciaio HSS;
- Abbondare con la lubrificazione, concentrata sull'utensile;
- Ridurre l'avanzamento fino ad accertare un taglio il più regolare possibile;
- È normale un'usura accelerata dell'utensile.

CutterMinimum requirements for the use of the machine

- Power: 1.8 – 2.5 kW;
- Possibility of cutting at 45° in both directions and at 90°;
- Ideal cutting speed: 15-30 rmp for stainless steel;
60-90 rmp for galvanised and corten steel;
90 rmp or higher for bronze (OT/67);
- Cutting capability: 150 x 80 mm at 90°;
100 mm cut at 45°.

Blade specifications

- 350 mm blade with a 2.5 mm thickness;
- Number of teeth: 300 for 45° cut;
350 for 90° cut;
- Material: HSS (please verify availability of longer lasting material on the market).

Note: OT/67 alloy can be cut with machines made for aluminum.

PhantographMinimum requirements for the use of the machine

- Mandrel with a 2000-11000 rmp adjustable speed (for a proper stainless steel processing a slower speed is required i.e.<4000 rpm);
- Machine should be made of cast iron suitable for steel cutting;
- Heavy head in order to limit vibrations;
- Secure the profile to be processed in jaws.

Minimum requirements for the use of a milling machine

- Material: HSS (please verify availability of longer lasting material on the market);
- Use a 4-tooth milling machine;
- Use a milling machine with a 5-mm diameter for groove processing.

DrillingHow to mount closing and moving components on a stainless steel profile

- Use a HSS drill. The diameter of the drill is indicated in the technical note;
- Thread the hole with self-threading zinc-plated screws with the same diameter as the stainless steel screw provided with the kit;
- Position and secure the item with the stainless steel screws provided.

Milling slots and loops in the profiles

- Use machines designed for steel processing (pantographs or milling machines);
- Max rpm setting (3000 rpm);
- Use milling machines with a diameter no bigger than 8 mm and with 4 HSS steel blades;
- Exceed with lubrication, mainly on the machine;
- Processed slowly until the milling is as clean as possible;
- Expect a fast wearing of the machine.

1. Controllo materiale in arrivo / *Incoming equipment Control*

Verifica visiva dell'intergrità delle barre con attenzione a: / *Profiles wholeness visual control paying attention to:*

- Strisci profondi / *Deep scratches* verifica visiva / *visual control*
- Botte e avvallamenti sulla superficie / *Bumps and dips on surface* verifica visiva / *visual control*
- Rettilineità barre / *Profiles straightness tolerance* 0,002 x L
- Svergolamento / *Profiles twist tolerance* 1° x m

2. Taglio barre e controllo barre / *Cut and Control of profiles*

- Misura lunghezza / *Length measurement* ±0.5 mm
- Verifica 45° / *45° Control* ± 1°
- Verifica 90° / *90° Control* ± 1°

MATERIALI**ACCIAIO INOX****Materiale**

Profilati ricavati da nastro di lamiera di acciaio inox laminato a freddo pre-trattato industrialmente per garantire la massima qualità e uniformità.

Caratteristiche fisiche

AISI 316L Marino (X2 CrNiMo 17-12-2)

Norme di riferimento

EN 10088-2; EU 114

Trattamenti superficiali

Finitura satinata: ottenuta su nastro AISI 304 con finitura superficiale 2B con successiva satinatura con abrasivi a grana 240-280.

Finitura lucida: ottenuta su nastro AISI 316L (marino) con finitura superficiale 2R, riflettività 53% e successiva lucidatura a specchio.

Finitura Scotch Brite: ottenuta su nastro AISI 316L (marino) con finitura superficiale 2B con successiva spazzolatura Scotch Brite.

ACCIAIO COR-TEN**Materiale**

Profilati ottenuti da nastro in acciaio altoresistenziale, autopassivante (che un tempo veniva commercializzato con il nome Cor-Ten) tale da formare, se esposto all'aria, uno strato di ossido uniforme e stabile che, ricoprendo la lamiera, ne arresta la corrosione atmosferica.

Caratteristiche fisiche

Fe 510 X (C max % 0,12; Si % 0,25-0,75; Mn % 0,20-0,50; P % 0,07-0,15; Cu % 0,25-0,55; Cr % 0,30-1,25; Ni max % 0,65)

Norme di riferimento

EN 10149

Trattamenti superficiali

Dopo la profilatura il materiale viene immerso in speciali bagni ossidanti tali da accelerare la formazione dello strato protettivo. Raggiunta la tonalità desiderata della superficie si procede ad una ceratura di stabilizzazione del materiale.

ACCIAIO ZINCATO VERNICIATO**Materiale**

Profilati ottenuti da nastro in lamiera di acciaio zincato a caldo sistema Sendzimir finitura skinpassata

Caratteristiche fisiche

FeP02 GZ 200 (copertura di zinco pari a 200gr/m² per faccia)

Norme di riferimento

UNI EN 10142/3/7; EURONORM 143

Trattamenti superficiali per la verniciatura

La preparazione del supporto zincato si effettua tramite i processi di sgrassaggio, decapaggio e lavaggio in acqua. Segue l'applicazione di uno strato di zinco per fosfatazione seguito da lavaggi in acqua demineralizzata. Infine applicazione della mano a finire con polveri poliestere cotte in forno a 180 °C per 25 minuti.

LEGA DI RAME OT67**Materiale**

Profilati ottenuti da nastro di Lega di Rame OT67 laminato a freddo rincrudito allo stato grezzo.

Caratteristiche fisiche

Cu Zn 33 CW 506L (OT 67, 67% rame)

Norme di riferimento

EN 1652:1999

Trattamenti superficiali

Finitura brunita: dopo la profilatura viene eseguita una ricottura di distensione, quindi la pulitura meccanica con abrasivo e la successiva brunitura per immersione con liquido brunitore; il profilo viene poi lavato e asciugato ed infine protetto mediante trattamento con olio di vaselina.

Finitura lucida: dopo la profilatura viene eseguita una ricottura di distensione e successivamente la lucidatura a specchio.

MATERIALS**STAINLESS STEEL****Materials**

Sections processed out of the cold-rolled coils, industrially pre-treated for utmost quality and uniformity.

Physical features

AISI 316L Marino (X2 CrNiMo 17-12-2)

Norms of reference

EN 10088-2; EU 114

Surface treatment

Satined: obtained on AISI 304 coil 2B pre-finish with post-treatment by means of abrasive 240-280 in grain size.

Polished: obtained on AISI 316L (marine) coil pre-finish with 2R surface finish, 53% reflectivity, and mirror post-polish.

Scotch Brite: obtained on AISI 316L (marine) coil 2B pre-finish with Scotch-Brite post-scrubbing.

CORTEN STEEL**Materials**

Sections processed out of highly resistant self-oxidising steel coils – once traded under the name Cor-Ten. If exposed to the open air, it produces a uniform protective layer that reduces weather corrosion.

Physical features

Fe 510 X (C max % 0,12; Si % 0,25-0,75; Mn % 0,20-0,50; P % 0,07-0,15; Cu % 0,25-0,55; Cr % 0,30-1,25; Ni max % 0,65)

Norms of reference

EN 10149

Surface treatment

After forming, sections are plunged into a special oxydising bath to catalyze formation of the protective coating. Once the desired tone obtained, sections are stabilized by a wax coating.

GALVANIZED AND PAINTED STEEL**Materials**

Sections processed out of hot galvanized steel coils, band "Sendzimir, skinpassed finishing.

Physical features

FeP02 GZ 200 (with zinc coating of 200 gr/sq x m on both faces)

Norms of reference

UNI EN 10142/3/7; EURONORM 143

Pre-painted surface treatment

The preparation of a galvanised surface is made through several processes: degreasing, pickling and washing. A coating of zinc is then applied through a phosphatising process followed by rinses in demineralised water. A final coat is then applied with polyester powders baked at 180 °C for 25 minutes.

COPPER ALLOY OT67**Materials**

Sections processed out of copper alloy coils, industrially cold-rolled.

Physical features

Cu Zn 33 CW 506L (OT 67, 67% copper e 33% zinc)

Norms of reference

EN 1652:1999

Surface treatment

Burnished finish: after forming, the product is submitted to stress relieving, then to mechanical cleaning with abrasive products and ultimately to burnishing by plunging into a burnishing solution. It is then washed and dried and protected with a vaseline coating.

Glossy finish: after forming, the product is submitted to stress relieving and then mirror-like polished.

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METALFORM

MASTERS OF METAL

UNITED KINGDOM

METALFORM

NORWAYMETAL LTD

53 Chelsea Manor Street

London, SW3 5RZ

SALES@METALFORM.UK

+44 20 81298814

GERMANY

METALFORM GMBH

Carl-Zeiss-Ring 15A

85737 Ismaning

SALES@METALFORMGROUP.DE

+49 17663630406

NORWAY

METALFORM AS

Brochmannsveien 2

1950 Rømskog

SALG@METALFORM.NO

+47 401 62 446

METALFORMGROUP

SALES@METALFORMGROUP.COM