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Specification

GENERAL DESCRIPTION

The Alitherm 400 HD window system described in this manual is suitable for both replacement windows for existing buildings, and for installation into new buildings.

The system incorporates top hung & side hung window types with internally beaded vent frames suitable for eurogroove multi-point locking.

The multi-point locking options allow for off-set handles suitable for LifeTime Homes standards.

Applications:

Windows:

- Fixed windows
- Side hung open out casements
- Top hung open out casements

Corner assembly of Alitherm 400 HD is crimping only.

PROFILE SPECIFICATION

The window frame are constructed of aluminium alloy extrusion to BS EN 755-9 and BS EN 12020, extruded from 6063 T6 alloy. The internal and external extrusions are separated with a polyamide thermal break.

The external aluminium alloy extrusion is pre-treated and finished either:-

- a) Anodised to BS 3987: 1987, grade AA25 to a natural self colour.
- b) Polyester powder organic coating to BS 6496. Dual colour is available.

GENERAL MANUFACTURING

Outer and vent frames are made by cutting the frame profiles with accurate 45° mitred ends using Tungsten Carbide Tipped Saw Blades, operating at approximately 3000 rpm.

The corners are joined using the Alitherm 400 HD crimping cleats to form a cold forged corner joint (made by deforming small slugs of metal into the groove of the corner cleat). Small joint sealant ACSIL04 to be used at ends of profile prior to crimping. General purpose sealant must NOT be used.

The ends of transoms and mullions are profiled to fit the frame and fixed using self-tapping screws with small joint sealant ACSIL04 applied prior to assembly. General purpose sealant must NOT be used.

On polyester powder coated finishes, great care should be taken to avoid getting gap sealer on visible surfaces and should be removed as soon as possible with a clean cloth.

Care should be exercised when using products not supplied by Smart Systems Ltd as no responsibility can be accepted.

Specification

WINDOW DRAINAGE

As with all dry glazed systems, it is recommended that the window system is adequately drained and ventilated. Refer to drainage details in manual, if in doubt ask The Technical Department.

In order to get maximum performance and weather resistance it is recommended that drips are used over all vents.

OUTER FRAME MANUFACTURING INFORMATION

The outer frame members are cut with 45° mitred ends to the overall size required, measured to the longest point of the metal.

Prior to corner crimping the centre line position of any transoms or mullions should be marked on the outer frame members. Where the transom/mullion runs right through, it should be marked out on both jambs or head and cill members in pairs to ensure accurate alignment of the sections.

Using the marked centre line, Drill the transom/mullion fixing holes using a 5mm dia. drill bit.

Corners are formed by coating the cut faces to be joined with ACSIL04 small gap sealant. Into the mitred corner insert the cleat glue and the required corner cleats and, where required, the aluminium corner chevrons. The two mitred ends are then brought together and crimped. The small gap sealer ensures a permanent joint and guards against the ingress of moisture and joint movement. After crimping the corner joint, special care should be taken to ensure any excess sealer is removed from painted surfaces.

Transoms or mullions are cut with square ends to the sizes calculated on the cutting formula sheets. The ends are then profiled to allow them to fit into the outer frame. Special tooling is available on request to profile the end of transom/mullion.

Prior to fixing of transoms and mullions smear the cut ends with ACSIL04 small gap sealant. After fixing, special care should be taken to ensure any excess is cleared from painted surfaces.

Please note: Do NOT use general purpose silicon for mitre & transom/mullion joints.

Specification

VENT

Corners are formed by coating the cut faces to be joined with ACIL04 small gap sealant. In the mitred corner insert the cleat glue and the required corner cleats and chevrons. The mitred ends are then brought together and crimped. The small gap sealer ensures a permanent joint and guards against the ingress of moisture and joint movement. Care should be taken to ensure any excess sealer is removed from the surfaces.

The cutting sizes produce vent frames with a cavity of 16-17mm.

When fixing, the friction stays into both the outer and vent frame, care should be taken to ensure that holes are located on 'V' grooves in the aluminium extrusions.

INTERNALLY BEADED ADAPTOR FRAME

The internally beaded adaptor frame members are cut with 45° mitred ends to the overall size required, measured to the longest point of metal. Care should be taken when measuring and cutting the frame members as only nominal clearance is required when the assembled frame is fixed in the outer frame.

Corners are formed by coating the cut faces to be joined with ACIL04 small gap sealant. Into the mitred corner insert the cleat glue and a corner cleat and the required corner chevrons. The small gap sealer ensures a permanent joint and guards against the ingress of moisture and joint movements. Care should be taken to ensure any excess sealer is removed from painted surfaces.

GLAZING

All beads are cut to suit the glazing aperture on the fully assembled window for glazing either at factory or on site as required.

EXTERNALLY BEADED GLAZING

Glazing beads are fitted to openings by cutting the horizontal beads square to head and cill of each vent and fixed light area. Vertical beads are cut at 90° both ends. Insert bottom beads and two setting blocks to ensure glass will be centralized in vertical dimension of opening (glazing blocks must be full width of cavity to fully support glass or sealed unit), then insert top bead followed by side beads. Finish glazing by insertion of internal gaskets all round. Please note, PAS24 requires Securi-Clips for external glazing. Contact GT Windows Ltd www.gtwindowproducts.co.uk

INTERNALLY BEADED GLAZING

Glazing beads are fitted to openings by cutting the horizontal beads square to head and cill of each vent and fixed light area. Vertical beads are cut square at both ends. Insert bottom beads and two setting blocks to ensure glass will be centralized in vertical dimension of opening (glazing blocks must be full width of cavity to fully support glass or sealed unit), then insert top bead followed by side beads. Finish glazing by insertion of internal gaskets all round.

Specification

Alitherm 400 HD Window Weather Performance (BS6375-1)

BS EN 1026: 2000 Air Permeability:	To be tested
BS EN 1027: 2000 Watertightness:	To be tested
BS EN 12211: 2000 Resistance to Wind Load:	To be tested

Alitherm 400 HD Window Security (PAS 24)

To be tested.

Alitherm 400 HD Window U Values

Please refer to the Smart Systems' Document L White Paper or contact the Technical Department.

Specification

Kitemark™ Certificate

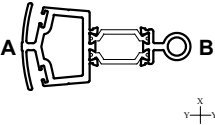
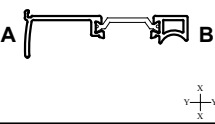
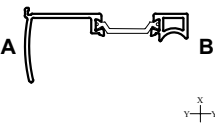
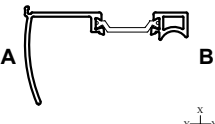
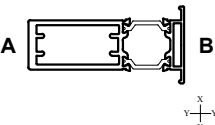
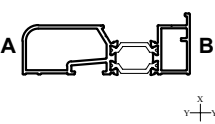
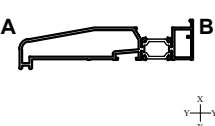
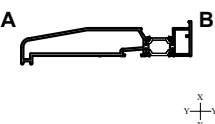
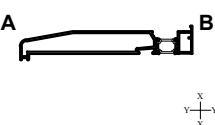
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**Hardware - Alitherm 400 HD Aluminium Alloy System
Casement Windows***

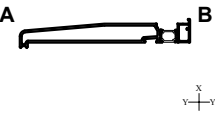
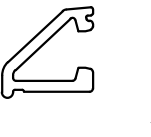
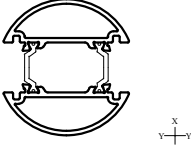
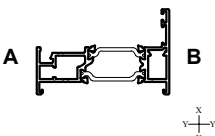
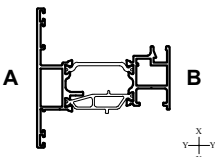
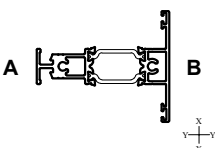
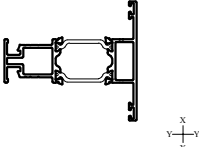
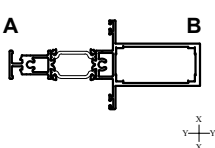
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Specification

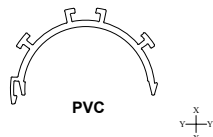
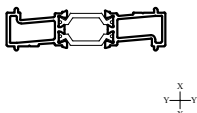
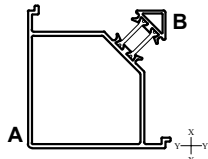
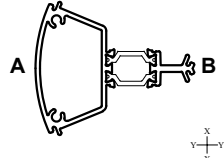
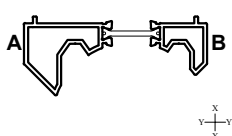
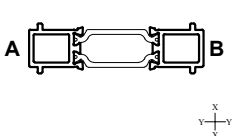
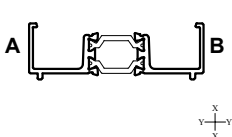
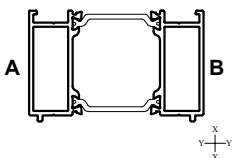
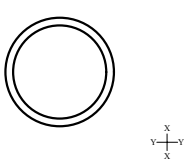
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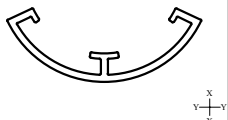
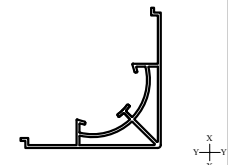
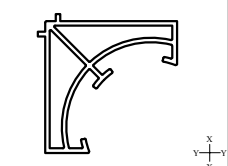
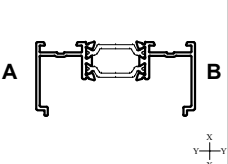
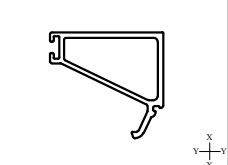
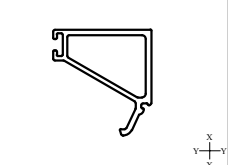
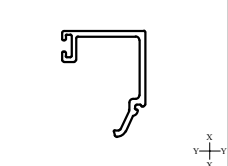
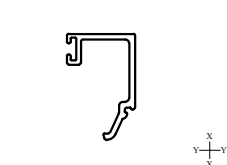
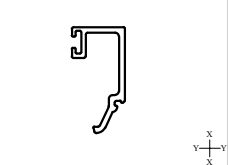
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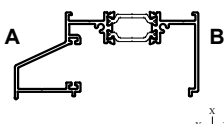
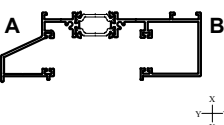
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UN3042		A21	288	111	31.2 --- 8.9	9.5 --- 4.3	6.5	1	✓	✓	✓	✓	✓
UN3080		A29	-	-	4.69 --- 4.69	2.47 --- 2.47	6.5	1	✓				
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PROFILES : TECHNICAL INFORMATION

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PROFILES : TECHNICAL INFORMATION

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PROFILES : TECHNICAL INFORMATION

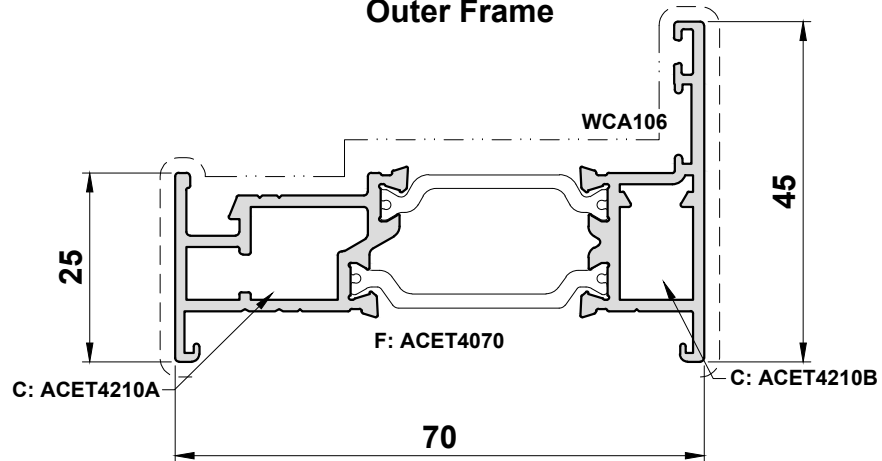
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Primary Visible Side

Secondary Visible Side

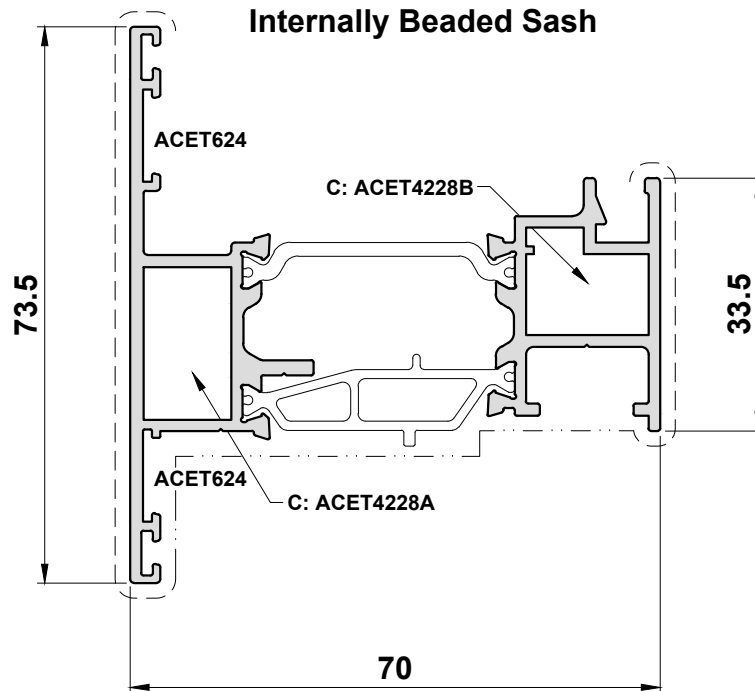
ETC4210

Outer Frame



ETC4229

Internally Beaded Sash

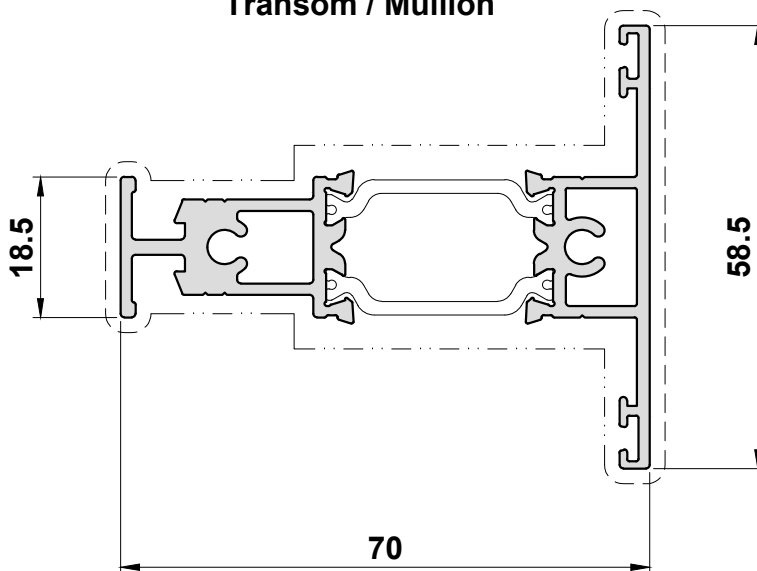


Scale 1:1

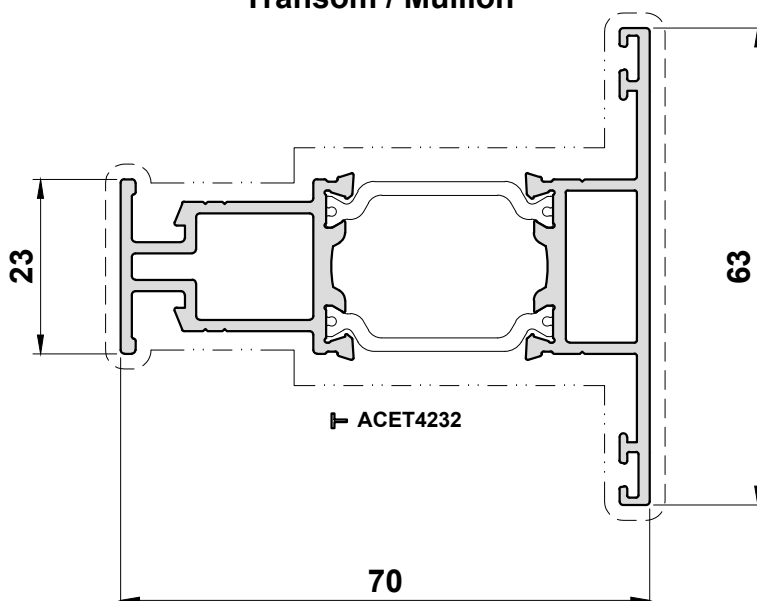
Primary Visible Side

Secondary Visible Side

ETC4230
Transom / Mullion



ETC4232
Transom / Mullion



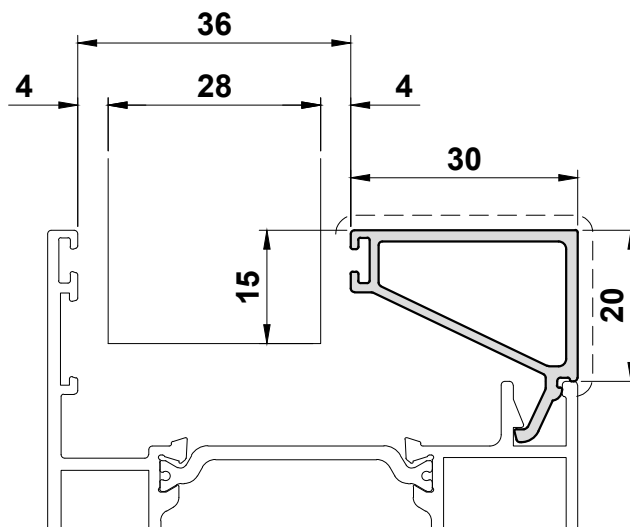
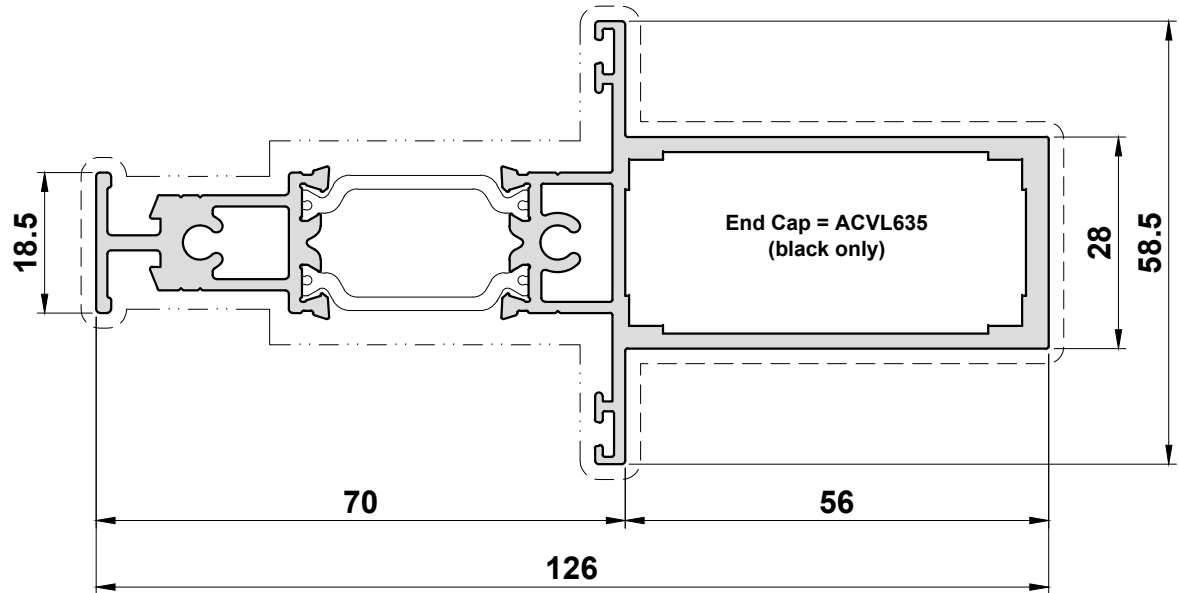
Scale 1:1

Primary Visible Side

Secondary Visible Side

ETC4236

Reinforced Transom / Mullion

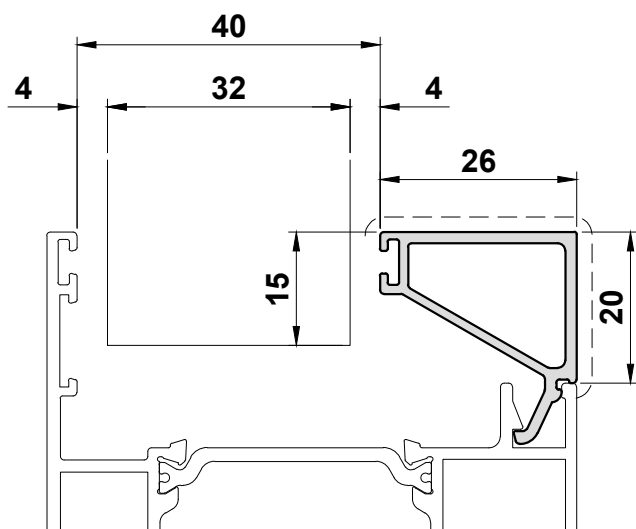


UN3400
30mm x 20mm
Tap In Bead

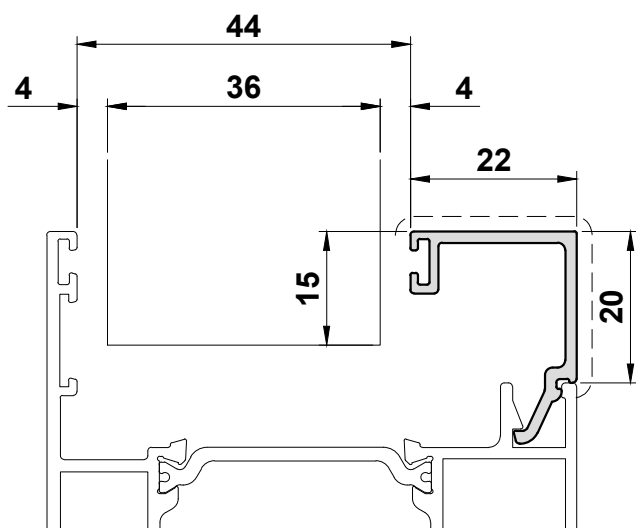
Scale 1:1

Primary Visible Side

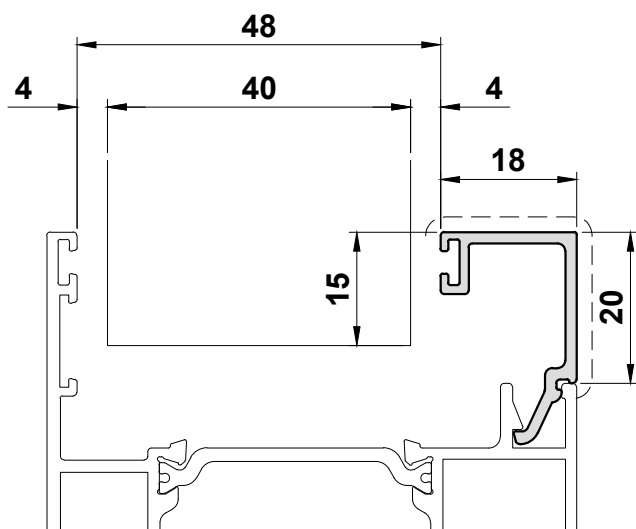
Secondary Visible Side



UN3401
26mm x 20mm
Tap In Bead



UN3402
22mm x 20mm
Tap In Bead

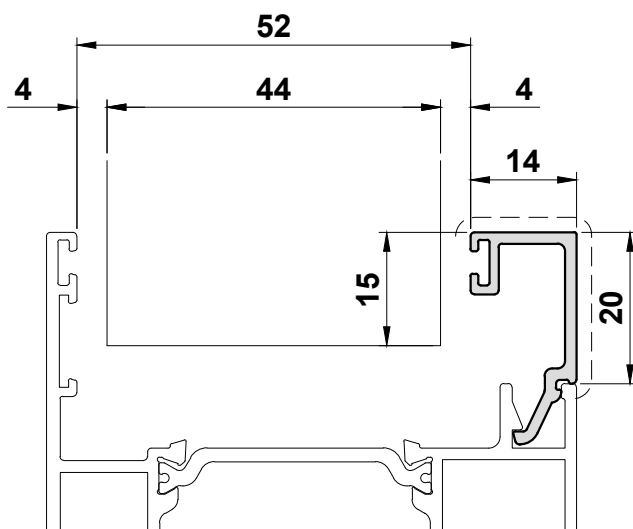


UN3403
18mm x 20mm
Tap In Bead

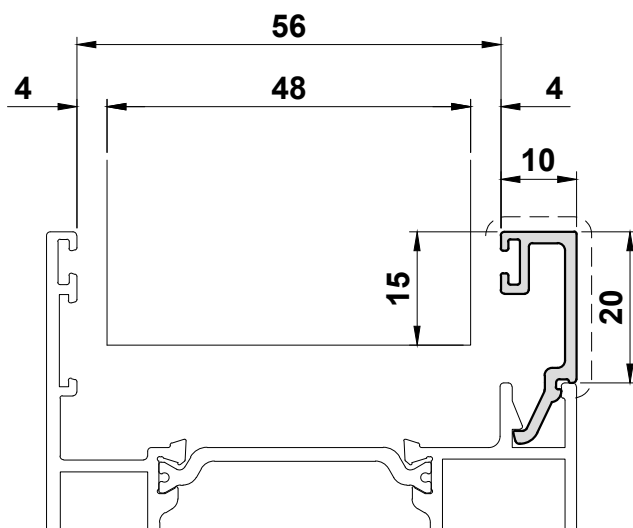
Scale 1:1

Primary Visible Side

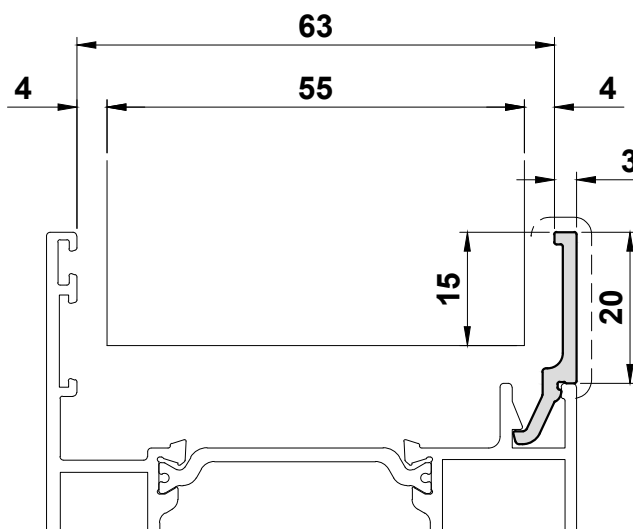
Secondary Visible Side



UN3404
14mm x 20mm
Tap In Bead



UN3405
10mm x 20mm
Tap In Bead



VG964
3mm x 20mm
Tap In Bead

Scale 1:1

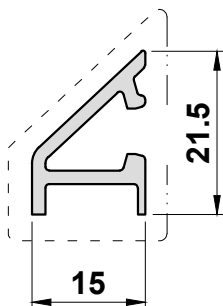
Primary Visible Side

Secondary Visible Side

VL72

Drip / Weather Bar

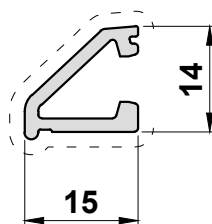
End Caps: ACVL059
Rivets: ACVL061



ETC572

Drip / Weather Bar

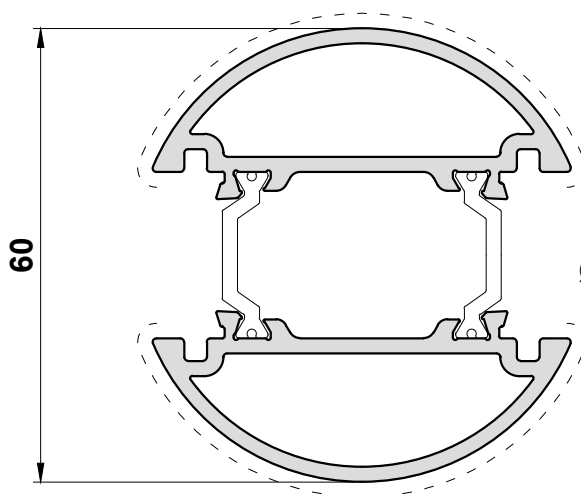
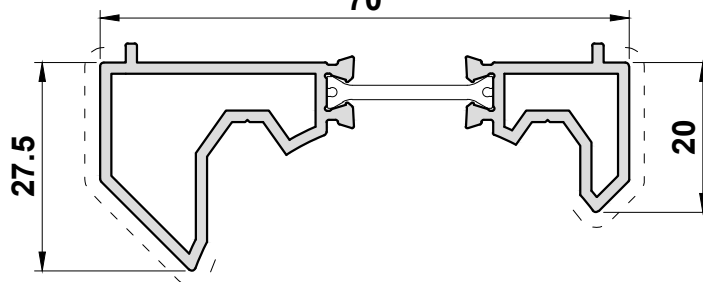
End Caps: ACVL059
Rivets: ACVL061



UN3012

Bay Pole Adaptor

70



ETC869

Ø60mm Bay Pole

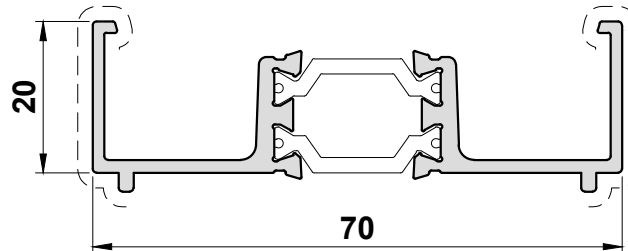
Scale 1:1

Primary Visible Side

Secondary Visible Side

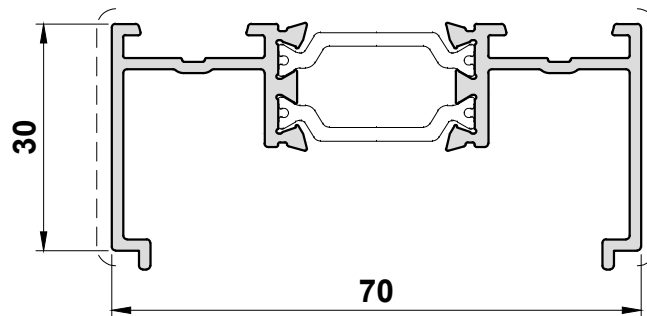
UN3020

70mm x 20mm Frame Extension



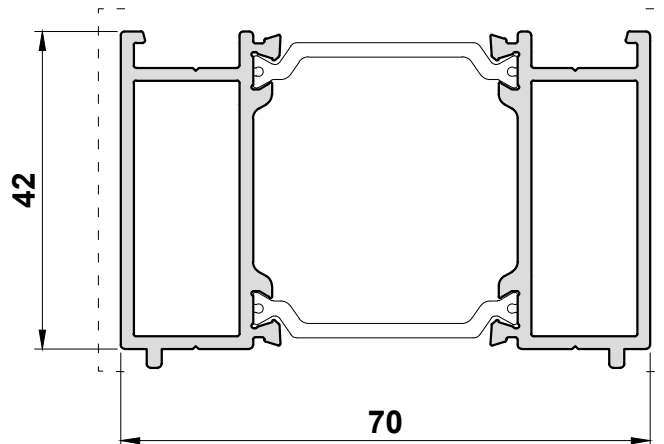
UN3370

30 x 70mm Head Extension



UN3042

42 x 70mm Head Extension

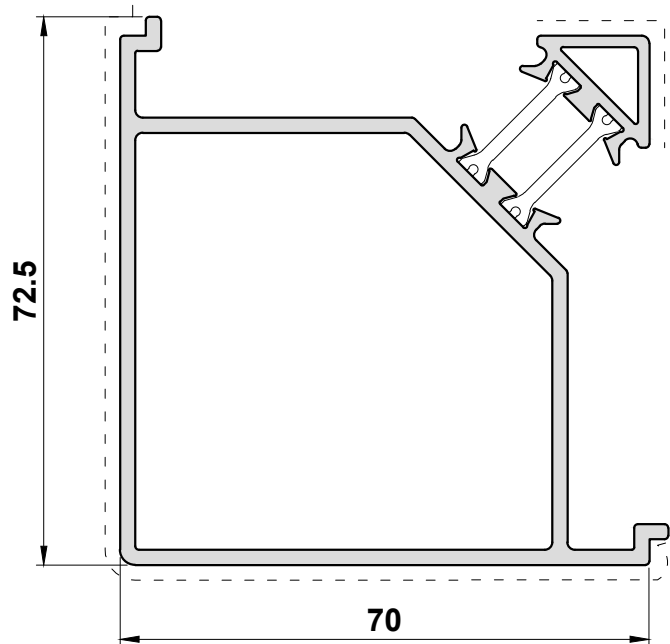


Scale 1:1

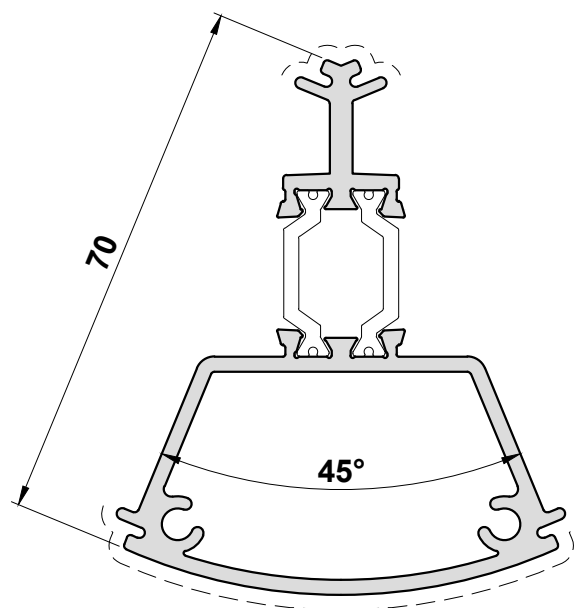
Primary Visible Side

Secondary Visible Side

UN3010
90° Corner Post



UN3011
135° Bay Pole

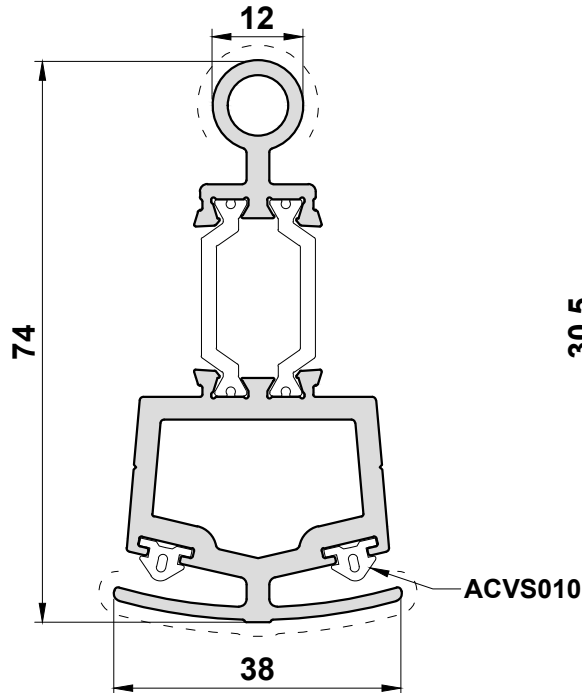


Scale 1:1

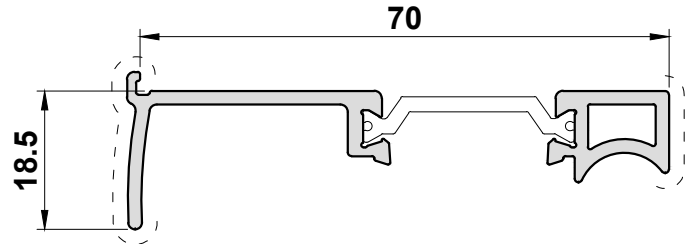
Primary Visible Side

Secondary Visible Side

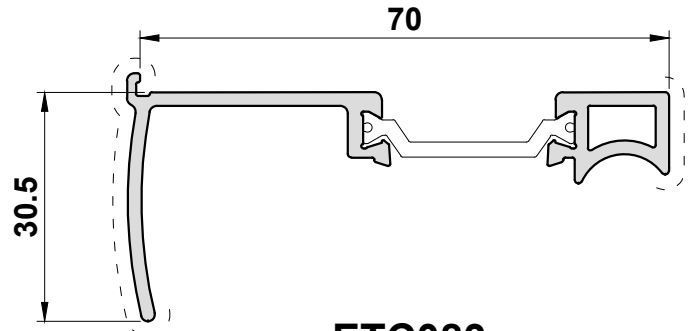
ETC080
Bay Pole



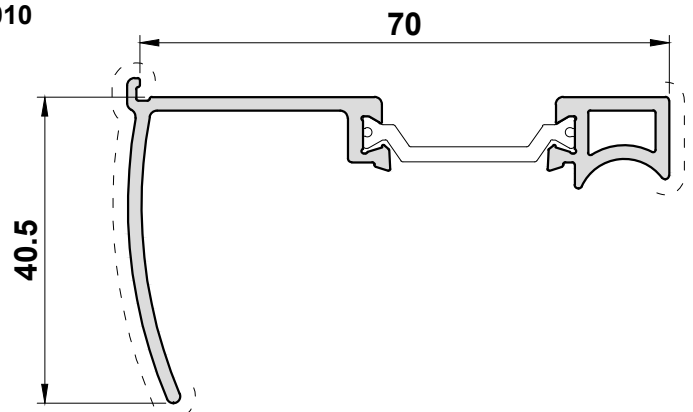
ETC081
169° - 150°
Bay Pole Adaptor



ETC082
149° - 130°
Bay Pole Adaptor



ETC083
129° - 115°
Bay Pole Adaptor



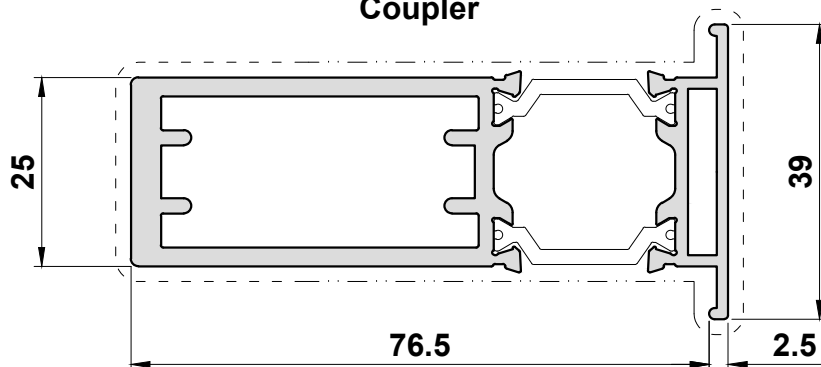
Scale 1:1

Primary Visible Side

Secondary Visible Side

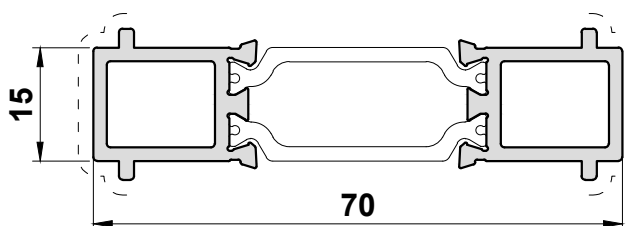
ETC357

Coupler



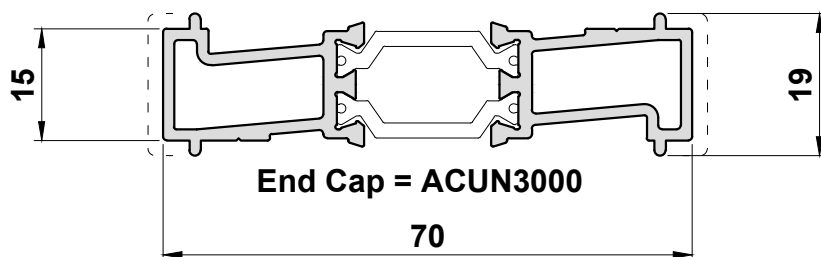
UN3015

70mm x 15mm Coupler



UN3000

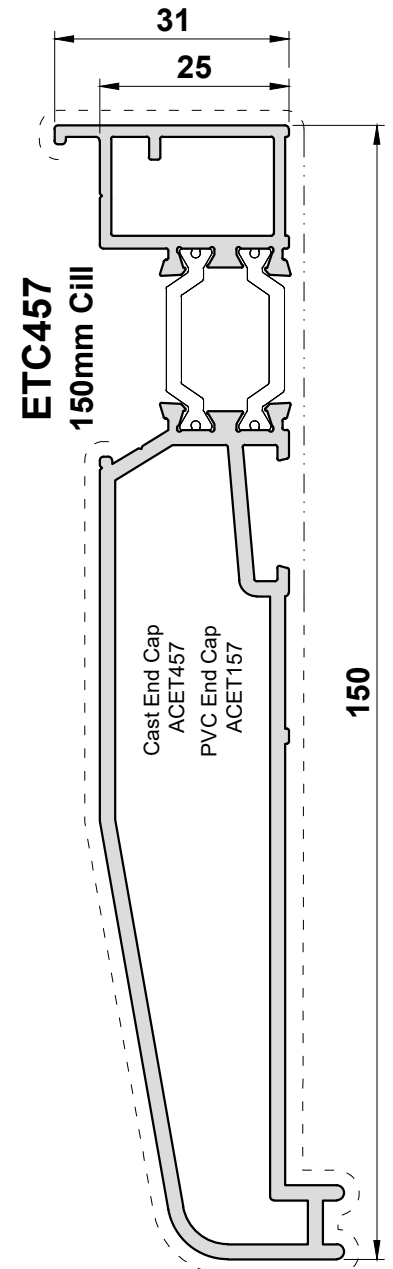
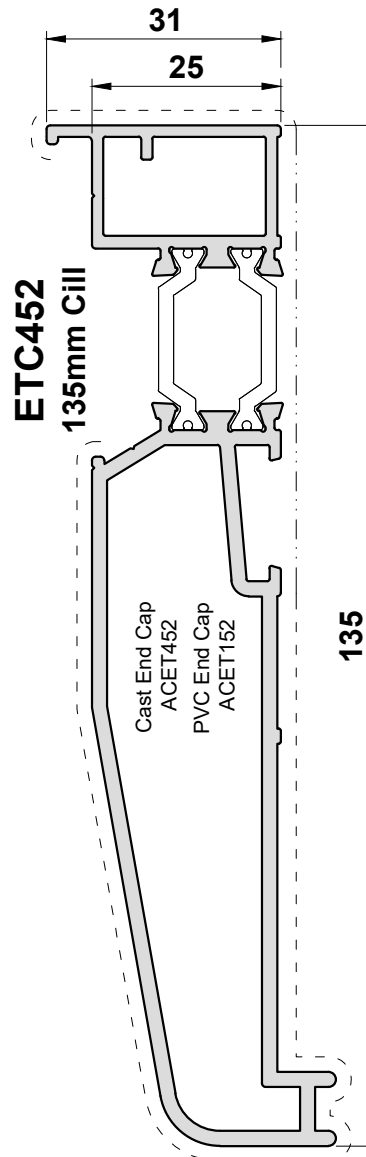
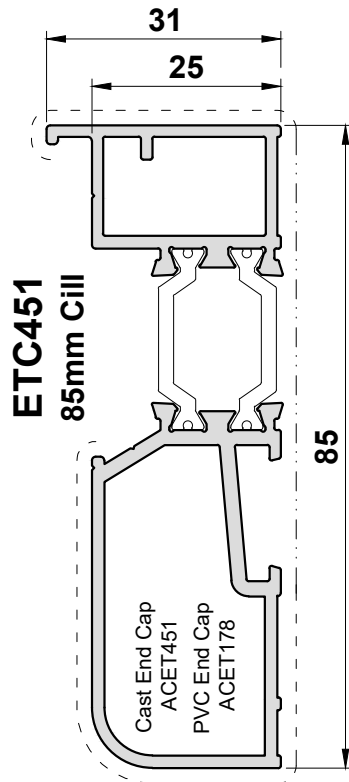
Flush Horizontal Coupler



Scale 1:1

Primary Visible Side

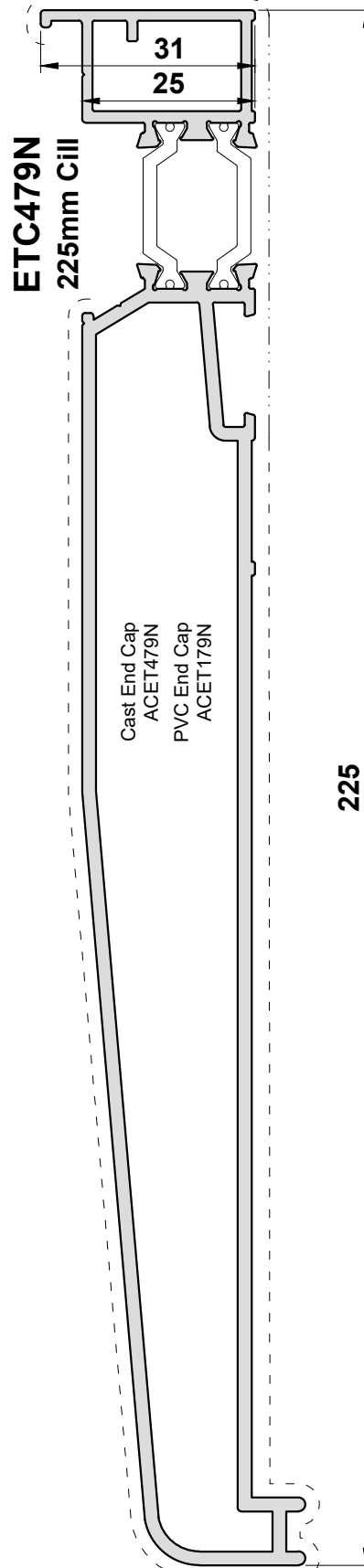
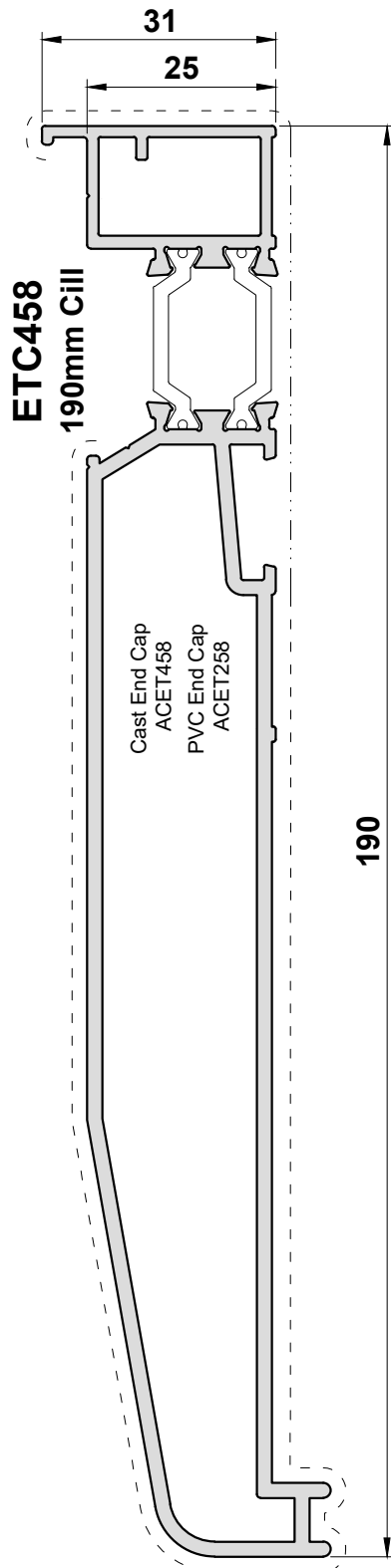
Secondary Visible Side



Scale 1:1

Primary Visible Side

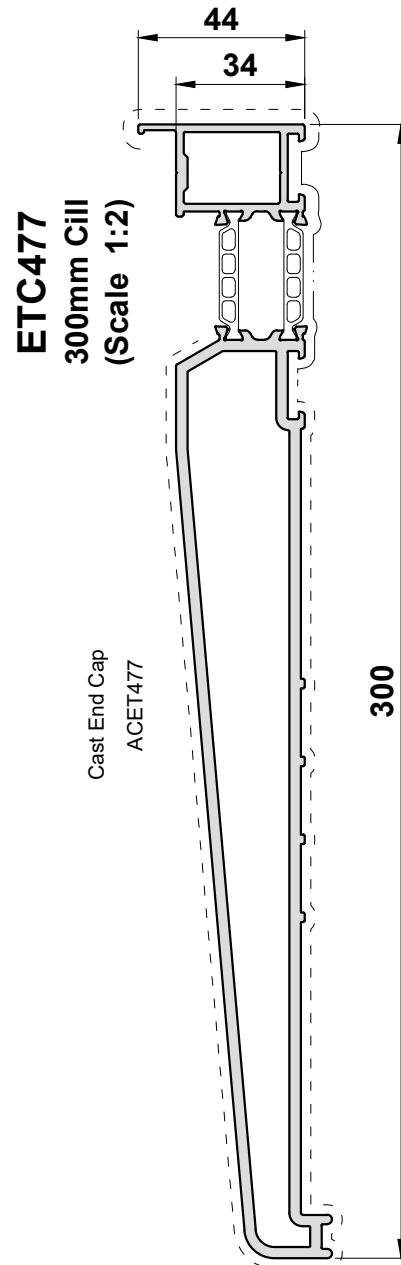
Secondary Visible Side



Scale 1:1

Primary Visible Side

Secondary Visible Side



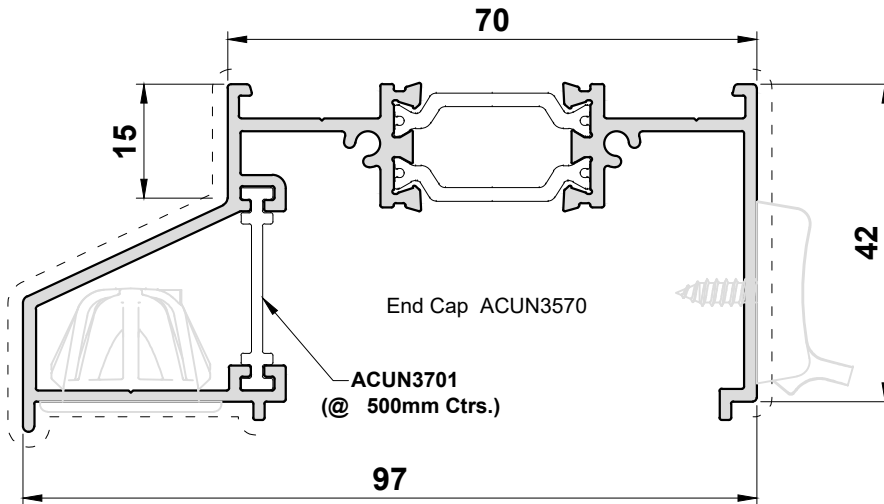
Scale 1:2

Primary Visible Side

Secondary Visible Side

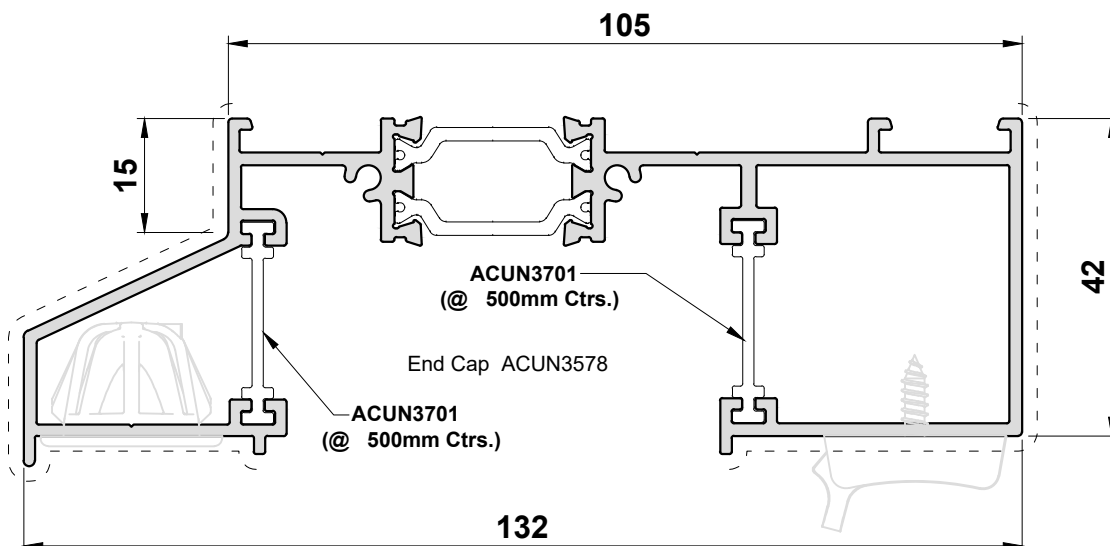
UN3570

42mm Hooded Head Extension For 70mm Sections



UN3577

42mm Hooded Wide Head Extension For 70mm Sections



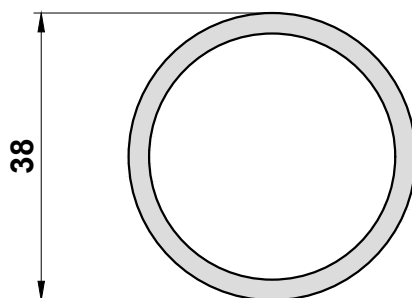
Scale 1:1

Primary Visible Side

Secondary Visible Side

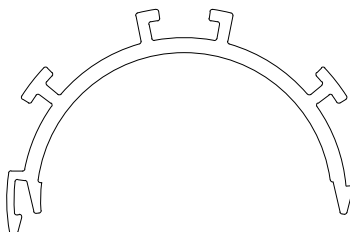
UN3080

Bay Pole



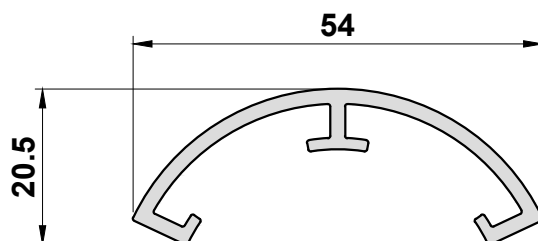
PCX55

PVC Isolator for UN3080



UN3081

Round Bay Pole Cover for UN3080



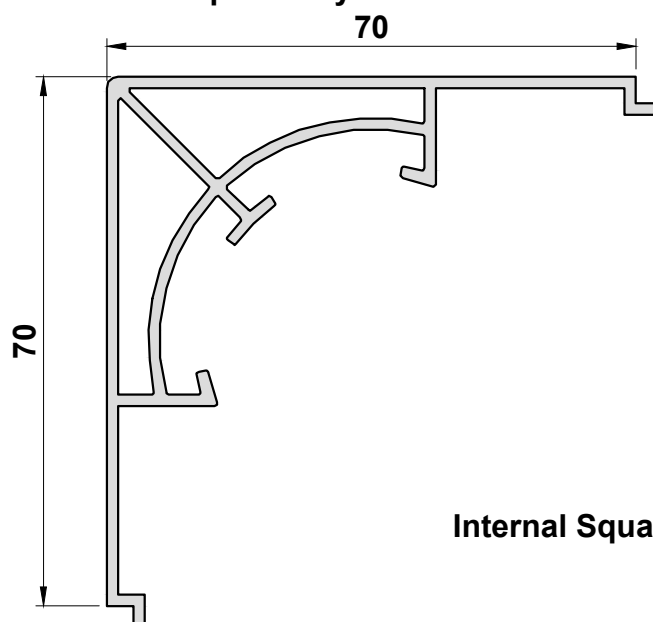
Scale 1:1

Primary Visible Side

Secondary Visible Side

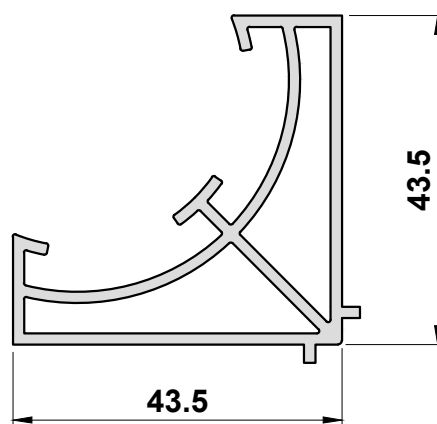
UN3082

External Square Bay Pole Cover for UN3080



UN3083

Internal Square Bay Pole Cover for UN3080

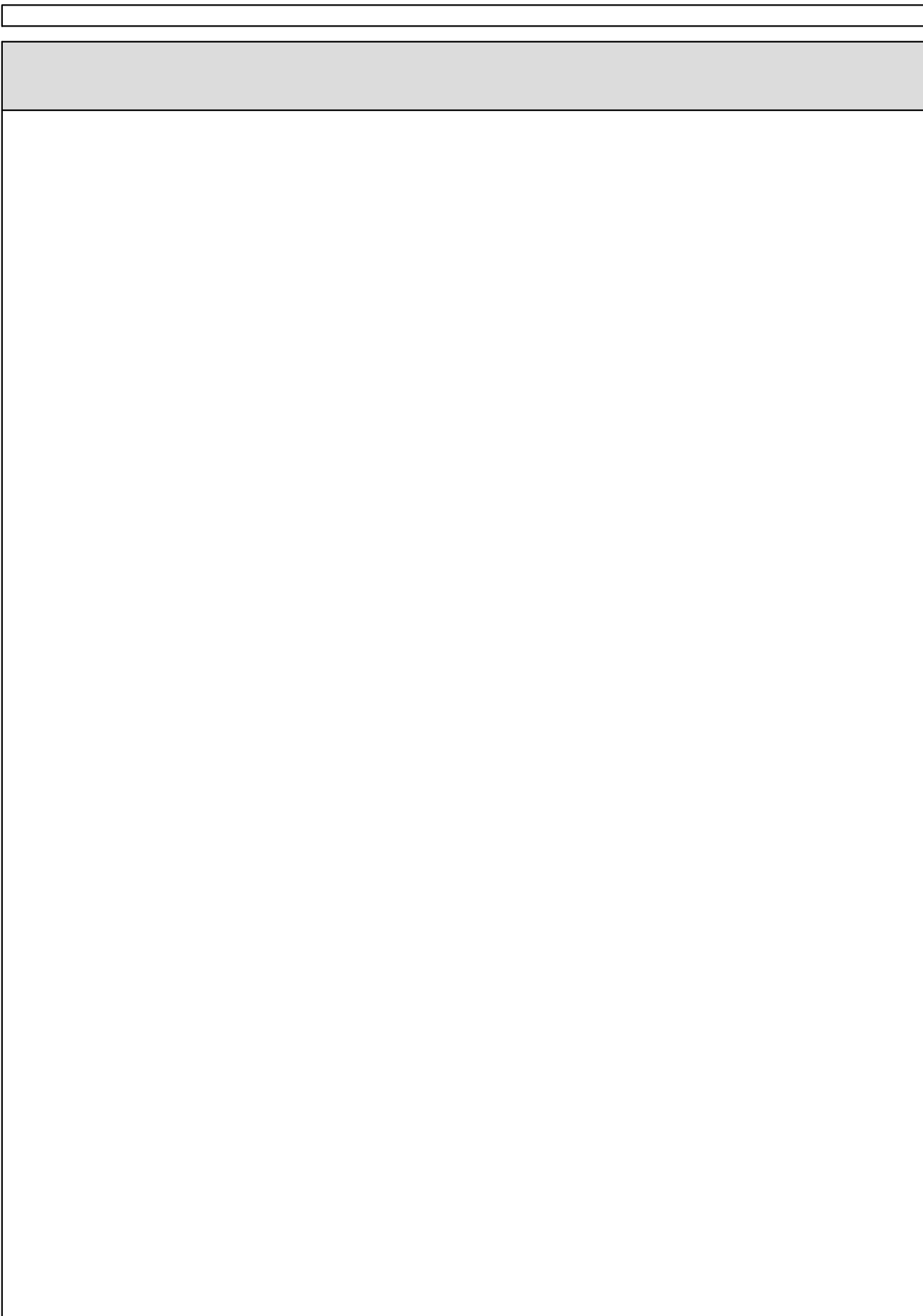


Scale 1:1

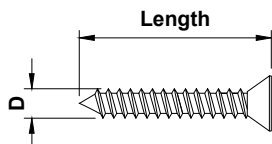
Section B

Accessories

Photos & Drawings



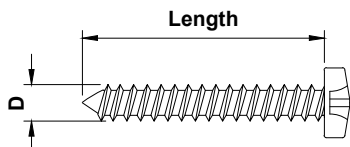
Countersunk Screws



Gauge	'D' (mm)
No.6	3.5
No.7	3.8
No.8	4
No.10	5
No.12	6

Part Number	Gauge	X	Length	Description	Box Qty.
ACUN3530	No.6	X	5/8"	Countersunk Pozi Self Tapper S/S	100
MUA025SSZ	No.6	X	1"	Countersunk Pozi Self Tapper S/S	100
ACET067	No.7	X	1/2"	Countersunk Pozi Self Tapper S/S	100
ACET060	No.7	X	1"	Countersunk Pozi Self Tapper S/S	100
ACET066	No.7	X	1 1/2"	Countersunk Pozi Self Tapper S/S	100
MUA067SSZ	No.7	X	2"	Countersunk Pozi Self Tapper S/S	100
ACUN3544	No.7	X	3/4"	Countersunk Pozi Self Tapper S/S	100
ACET064	No.8	X	5/8"	Countersunk Pozi Self Tapper S/S	100
ACUN3512	No.8	X	1 1/4"	Countersunk Pozi Self Tapper S/S	100
ACUN3513	No.8	X	1 3/4"	Countersunk Pozi Self Tapper S/S	100
ACET072	No.8	X	2 1/2"	Countersunk Pozi Self Tapper S/S	100
ACET490	4.3mm	X	16mm	Countersunk PH2 Polyamide Screw	1000
ACET290	4.3mm	X	20mm	Countersunk PH2 Polyamide Screw	100
ACET390	4.3mm	X	25mm	Countersunk PH2 Polyamide Screw	200
ACET190	4.3mm	X	45mm	Countersunk PH2 Polyamide Screw	1000
ACVS062	4.3mm	X	65mm	Countersunk PH2 Polyamide Screw	1000
ACET048	No.10	X	3/8"	Countersunk Pozi Self Tapper S/S	100
ACIM062	No.10	X	1 1/4"	Countersunk Pozi Self Tapper S/S	100
ACET062	No.10	X	2"	Countersunk Pozi Self Tapper S/S	100
ACET076	No.10	X	2 1/2"	Countersunk Pozi Self Tapper S/S	100

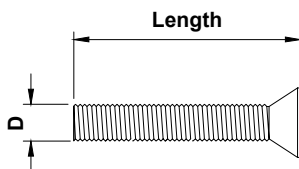
Pan Head Screws



Gauge	'D' (mm)
No.6	3.5
No.7	3.8
No.8	4
No.10	5
No.12	6

Part Number	Gauge	X	Length	Description	Box Qty.
ACET068	No.8	X	3/8"	Pozi Flange AB	100
ACET063	No.8	X	1/2"	Pan Head Self Tapper	100
ACET070	No.8	X	1/2"	Pozi Flange Self Tapper S/S	100
ACUN3535	No.8	X	5/8"	Pan Head Pozi S/S	100
ACET099	No.8	X	3/4"	Pozi Flange Self Tapper S/S	100
ACDR050	4.8mm	X	32mm	Pan Head Pozi S/S	200
PUA028	No.10	X	1"	Pan Head Pozi S/S	100
ACDR052	No.10	X	2"	Pan Head Self Tapper S/S	200
ACET079	No.10	X	2 1/2"	Pan Head Pozi S/S	100
ACW20160	No.12	X	1"	Flange Head Self Tapper S/S	100
ACMC109	6.3mm	X	38mm	DIN7981 - Pan Head Self Tapper	200

Machine Screws



Thread	'D' (mm) Nominal
M4	4
M5	5
M6	6
M8	8
M10	10

Part Number	Thread	X	Length	Description	Box Qty.
ACET122	M4	X	10	CSK Pozi Machine Screw	100
ACET123	M4	X	20	CSK Pozi Machine Screw	100
ACDV264	M4	X	35	CSK Pozi Machine Screw	100
ACSG071	M4	X	40	CSK Pozi Machine Screw	100
ACDV266	M4	X	45	CSK Pozi Machine Screw	100
ACDV262	M4	X	50	CSK Pozi Machine Screw	100
ACDV265	M4	X	60	CSK Pozi Machine Screw	100
ACDR051	M5	X	10	CSK Pozi Machine Screw	100
ACET069	M5	X	12	CSK Pozi Machine Screw	100
HEA132	M5	X	16	CSK Pozi Machine Screw	100
WCA134	M5	X	20	CSK Pozi Machine Screw	100
WCA143	M5	X	25	CSK Pozi Machine Screw	50
ACVS061	M5	X	40	CSK Pozi Machine Screw	100
ACET133	M5	X	50	CSK Pozi Machine Screw	100
ACET220	M5	X	60	CSK Pozi Machine Screw	100
ACET238	M5	X	70	CSK Pozi Machine Screw	100
ACMX861	M5	X	80	DIN965 - CSK Machine Screw	10
ACMX862	M5	X	90	DIN965 - CSK Machine Screw	10
ACUN3503	M6	X	10	CSK Socket Machine Screw	24
ACUN3501	M6	X	13	CSK Flange Socket Machine Screw	48
ACMX852	M6	X	16	DIN965 - CSK Machine Screw	10
HEA390	M6	X	16	CSK Socket Machine Screw	32
ACET235	M6	X	60	CSK Pozi Machine Screw	100
ACET237	M6	X	70	CSK Pozi Machine Screw	100

Glazing Gaskets

Retaining Gasket

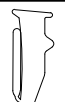
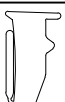
Commonly known as an E Gasket.
Retaining gaskets create a seal between the Glass and the Aluminium Profile.

High Line	2mm		ACVG231
			200m
			BL
	3mm		ACVG31
			200m
			BL
	4mm		ACVG131
			100m
			BL
Low Line	2mm		ACET844
			200m
			BL
	3mm		ACET842
			200m
			BL
	4mm		ACET841
			200m
			BL
	4mm		ACET835
			200m
			BL

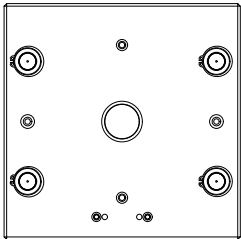
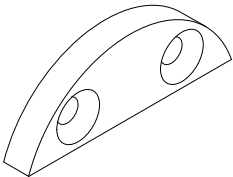
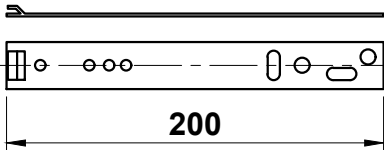
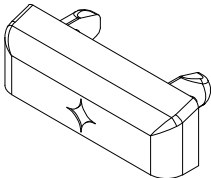
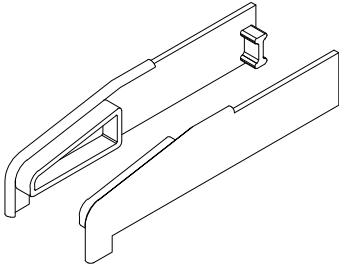
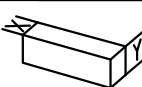
Thickness	Drawing 1:1	Part number
		Coil length
		Available Colours

Wedge Gasket

Wedge Gaskets help to hold the bead in place by providing tension between the bead and the glazing unit.

High Line	3mm		ACVG32
			100m
			BL
	3mm		ACVG32N
			100m
			BL
	4mm		ACVG33
			100m
			BL
	4mm		ACVG33N
			100m
			BL
	5mm		ACVG34
			100m
			BL
	5mm		ACVG34N
			100m
			BL
Low Line	6mm		ACVG340
			200m
			BL
	6mm		ACVG340N
			100m
			BL
	4mm - 3mm		ACW20038
			50m
			BL
	5mm - 4mm		ACET848
			200m
			BL

ACCESSORIES : PHOTOS & DRAWINGS

Image	Part Code	Pack	Unit	Application	Colour	
	ACDV916 Bead Punch Tool	1	each		MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
	ACET041 Cill Nose Bracket	1	Each	ETC451 ETC452 ETC457 ETC458 ETC477 ETC479	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
	ACET130 Galvanised Steel Fixing Strap 200mm x 25mm x 1.5mm	100	Pack	ETC4210	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
	ACET131 Drainage Cover Cap For colour matched drainage caps, please order ACET432	100	Pack	ETC4210 ETC4229 UN3000	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	✓
					Z	✓
					PC	
	ACET152 Cill End Cap	10	Pair	ETC452	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	✓
					Z	✓
					PC	
 T-BARS ACVG65=2.5mm ACVG66=3.0mm ACVL150=4.0mm	 Screw (Grub)	MF = Mill Finish SA = Silver Anodised KL = Basic Colour HP = Special Colour SSC = Smooth Satin Chrome SMC = Smokey Chrome PC = Polished Chrome		W = White Z = Black	 	

ACCESSORIES : PHOTOS & DRAWINGS

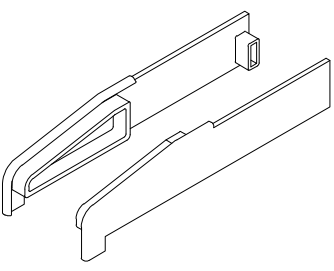
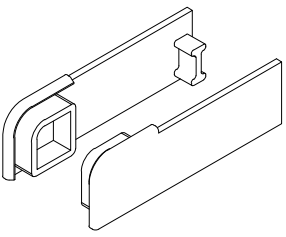
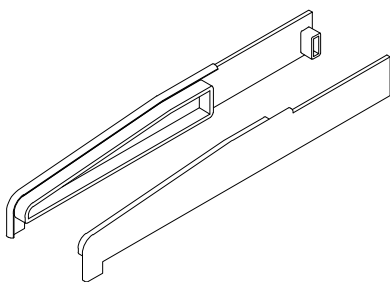
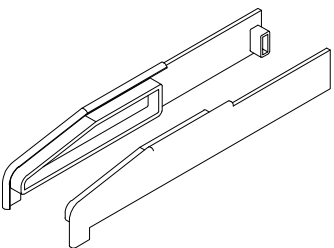
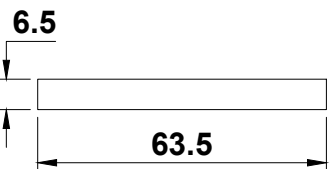
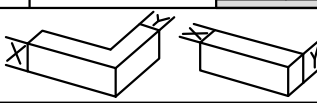
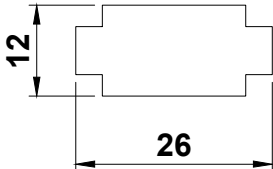
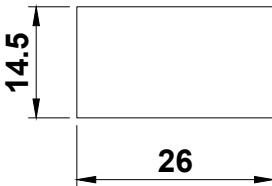
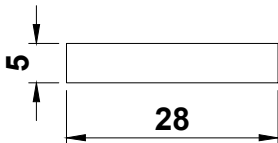
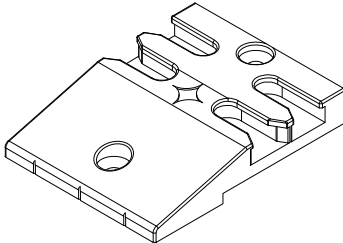
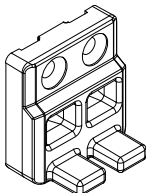
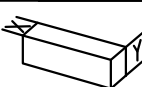
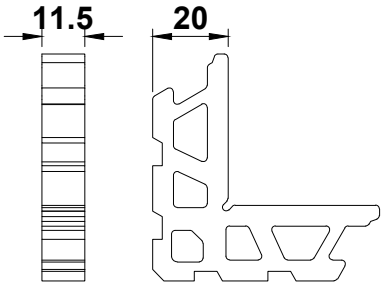
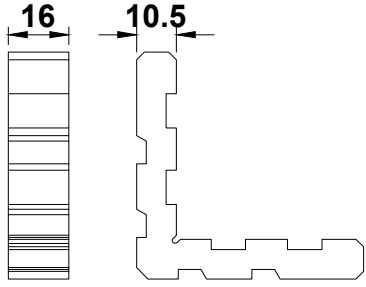
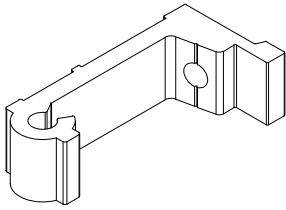
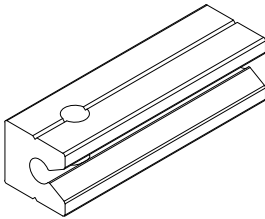
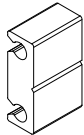
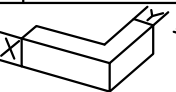
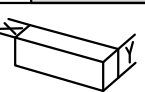
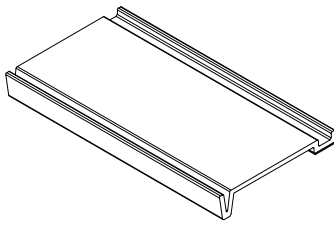
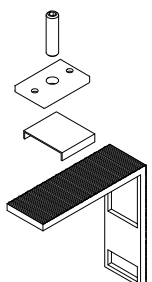
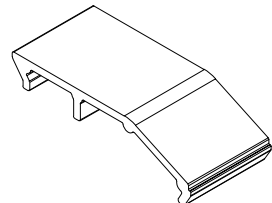
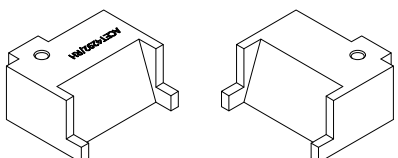
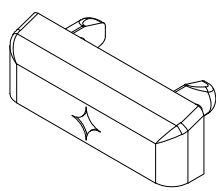
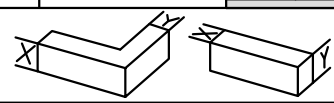
Image	Part Code	Pack	Unit	Application	Colour
	ACET157 Cill End Cap	10	Pair	ETC457	MF
					SA
					KL
					HP
					SSC
					SMC
					W
					Z
					PC
	ACET178 Cill End Cap	10	Pair	ETC451	MF
					SA
					KL
					HP
					SSC
					SMC
					W
					Z
					PC
	ACET179N Cill End Cap	10	Pair	ETC479N	MF
					SA
					KL
					HP
					SSC
					SMC
					W
					Z
					PC
	ACET258 Cill End Cap	10	Pair	ETC458	MF
					SA
					KL
					HP
					SSC
					SMC
					W
					Z
					PC
	ACET4070 Foam Length = 1250mm	1	Each	ETC4210	MF
					SA
					KL
					HP
					SSC
					SMC
					W
					Z
					PC
 T-BARS ACVG65=2.5mm ACVG66=3.0mm ACVL150=4.0mm	 Screw (Grub)	MF = Mill Finish SA = Silver Anodised KL = Basic Colour HP = Special Colour SSC = Smooth Satin Chrome SMC = Smokey Chrome PC = Polished Chrome	W = White Z = Black		

Image	Part Code	Pack	Unit	Application	Colour
	ACET4071 Foam Length = 1250mm	1	Each	ETC4229	MF
					SA
					KL
					HP
					SSC
					SMC
					W
					Z
					PC
	ACET4081 Foam Length = 1250mm	1	Each	ETC4229	MF
					SA
					KL
					HP
					SSC
					SMC
					W
					Z
					PC
	ACET4082 Foam Length = 1250mm	1	Each	ETC4210	MF
					SA
					KL
					HP
					SSC
					SMC
					W
					Z
					PC
	ACET4218 Mushroom Keep	1	Each		MF
					SA
					KL
					HP
					SSC
					SMC
					W
					Z
					PC
	ACET4219 Shootbolt Keep	1	Each		MF
					SA
					KL
					HP
					SSC
					SMC
					W
					Z
					PC
 T-BARS ACVG65=2.5mm ACVG66=3.0mm ACVL150=4.0mm	 Screw (Grub)	MF = Mill Finish SA = Silver Anodised KL = Basic Colour HP = Special Colour SSC = Smooth Satin Chrome SMC = Smokey Chrome PC = Polished Chrome	W = White Z = Black	 	

ACCESSORIES : PHOTOS & DRAWINGS

Image	Part Code	Pack	Unit	Application	Colour
	ACET4228A Crimping Cleat	24	Pack	ETC4229	MF ☒
					SA ☐
					KL ☐
					HP ☐
					SSC ☐
					SMC ☐
					W ☐
					Z ☐
					PC ☐
	ACET4228B Crimping Cleat	24	Pack	ETC4229	MF ☒
					SA ☐
					KL ☐
					HP ☐
					SSC ☐
					SMC ☐
					W ☐
					Z ☐
					PC ☐
	ACET4232 Cruciform Bracket	10	Pack	ETC4232	MF ☒
					SA ☐
					KL ☐
					HP ☐
					SSC ☐
					SMC ☐
					W ☐
					Z ☐
					PC ☐
	ACET4233 Transom Bracket	10	Pack	ETC4232	MF ☒
					SA ☐
					KL ☐
					HP ☐
					SSC ☐
					SMC ☐
					W ☐
					Z ☐
					PC ☐
	ACET4234 Anti-Twist Block	10	Pack	ETC4232	MF ☒
					SA ☐
					KL ☐
					HP ☐
					SSC ☐
					SMC ☐
					W ☐
					Z ☐
					PC ☐
 T-BARS ACVG65=2.5mm ACVG66=3.0mm ACVL150=4.0mm	 Screw (Grub)	MF = Mill Finish SA = Silver Anodised KL = Basic Colour HP = Special Colour SSC = Smooth Satin Chrome SMC = Smokey Chrome PC = Polished Chrome	W = White Z = Black	 	

ACCESSORIES : PHOTOS & DRAWINGS

Image	Part Code	Pack	Unit	Application	Colour	
	ACET4258 Bridge Packer	12	Pack	ETC4229	MF	☒
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
	ACET4280 Glass Adjuster Kit Kit Includes: 1 x Adjusting Screw 1 x Threaded Block 1 x Steel Cover 1 x ABS Corner	1	Kit	ETC4229	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	☒
					PC	
	ACET4285 Run Up Block	100	Pack	ETC4229	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	☒
					PC	
	ACET4292 Punches	1	Each	ETC4210	MF	☒
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
	ACET432 Drainage Cover Cap (Colour Match)	8	Pack	ETC4210 ETC4229 UN3000	MF	
					SA	
					KL	☒
					HP	☒
					SSC	
					SMC	
					W	☒
					Z	☒
					PC	
 T-BARS ACVG65=2.5mm ACVG66=3.0mm ACVL150=4.0mm	 Screw (Grub)	MF = Mill Finish SA = Silver Anodised KL = Basic Colour HP = Special Colour SSC = Smooth Satin Chrome SMC = Smokey Chrome PC = Polished Chrome		W = White Z = Black		

ACCESSORIES : PHOTOS & DRAWINGS

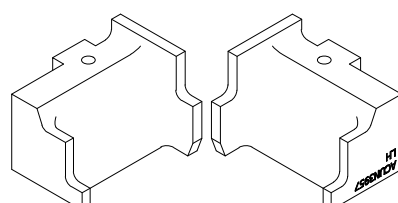
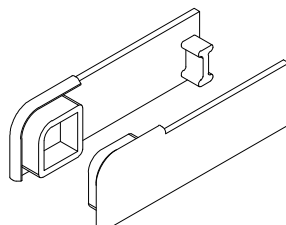
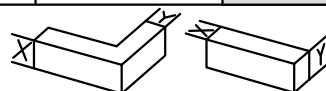
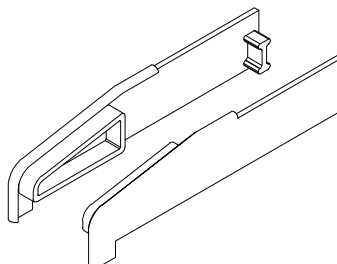
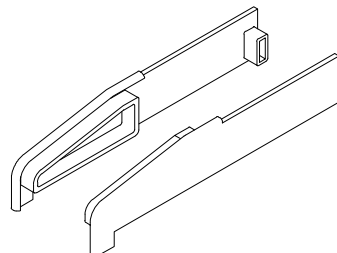
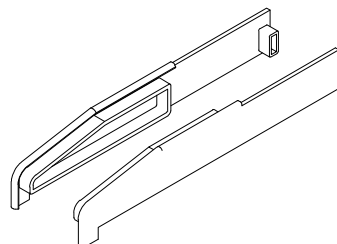
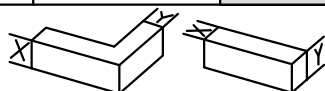
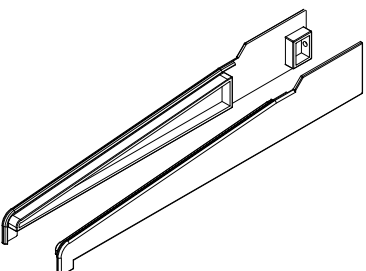
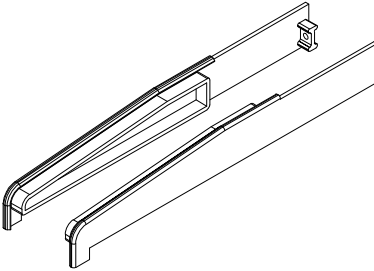
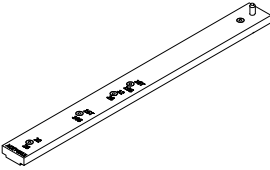
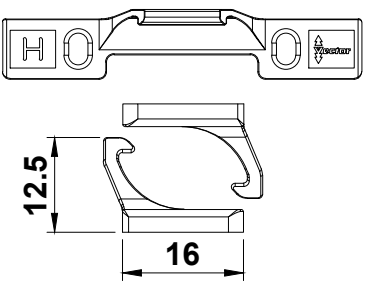
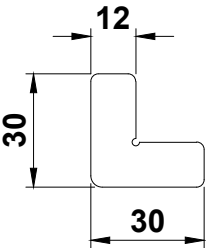
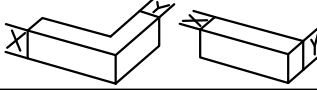
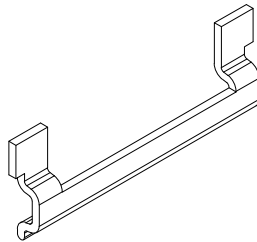
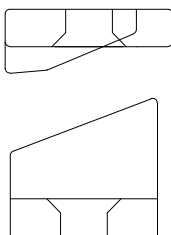
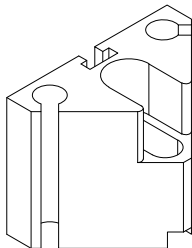
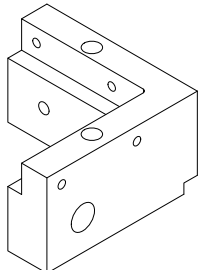
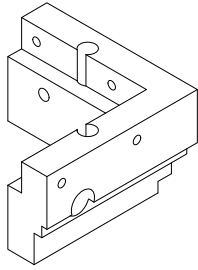
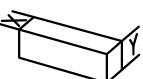
Image	Part Code	Pack	Unit	Application	Colour
	ACET4380 8mm Crimping Support	1	Each	ACET4383	MF ☒
					SA ☐
					KL ☐
					HP ☐
					SSC ☐
					SMC ☐
					W ☐
					Z ☐
					PC ☐
	ACET4381 10mm Crimping Support	1	Each	ACET4383	MF ☒
					SA ☐
					KL ☐
					HP ☐
					SSC ☐
					SMC ☐
					W ☐
					Z ☐
					PC ☐
	ACET4383 22.5mm Crimping Support	1	Each	ACET4380 ACET4381 ETC4210 ETC4229	MF ☒
					SA ☐
					KL ☐
					HP ☐
					SSC ☐
					SMC ☐
					W ☐
					Z ☐
					PC ☐
	ACET4399 Punches	1	Each	ETC4229	MF ☐
					SA ☐
					KL ☐
					HP ☐
					SSC ☐
					SMC ☐
					W ☐
					Z ☐
					PC ☐
	ACET451 Cill End Cap	1	Pair	ETC451	MF ☒
					SA ☐
					KL ☒
					HP ☒
					SSC ☐
					SMC ☐
					W ☒
					Z ☒
					PC ☐
 T-BARS ACVG65=2.5mm ACVG66=3.0mm ACVL150=4.0mm	 Screw (Grub)	MF = Mill Finish SA = Silver Anodised KL = Basic Colour HP = Special Colour SSC = Smooth Satin Chrome SMC = Smokey Chrome PC = Polished Chrome	W = White Z = Black		

Image	Part Code	Pack	Unit	Application	Colour	
	ACET452 Cill End Cap	1	Pair	ETC452	MF	✓
					SA	
					KL	✓
					HP	✓
					SSC	
					SMC	
					W	✓
					Z	✓
					PC	
	ACET457 Cill End Cap	1	Pair	ETC457	MF	✓
					SA	
					KL	✓
					HP	✓
					SSC	
					SMC	
					W	✓
					Z	✓
					PC	
	ACET458 Cill End Cap	1	Pair	ETC458	MF	✓
					SA	
					KL	✓
					HP	✓
					SSC	
					SMC	
					W	✓
					Z	✓
					PC	
	ACET461 Inline Espag Handle with 15mm Spindle	1	Each	ACET4211 to ACET4215 ACET4271 to ACET4277	MF	
					SA	
					KL	✓
					HP	✓
					SSC	✓
					SMC	✓
					W	✓
					Z	✓
					PC	✓
	ACET466 L/R Cranked Espag Handle with 15mm Spindle	1	Each	ACET4211 to ACET4215 ACET4271 to ACET4277	MF	
					SA	
					KL	✓
					HP	✓
					SSC	✓
					SMC	✓
					W	✓
					Z	✓
					PC	✓
 T-BARS ACVG65=2.5mm ACVG66=3.0mm ACVL150=4.0mm  Screw (Grub)	MF = Mill Finish SA = Silver Anodised KL = Basic Colour HP = Special Colour SSC = Smooth Satin Chrome SMC = Smokey Chrome PC = Polished Chrome		W = White Z = Black			

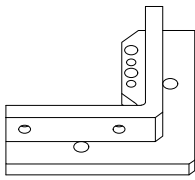
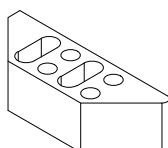
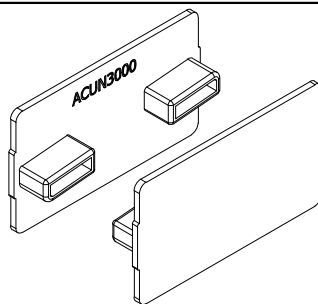
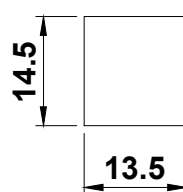
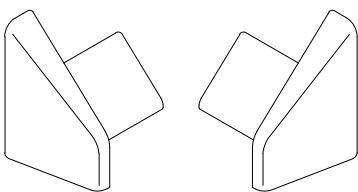
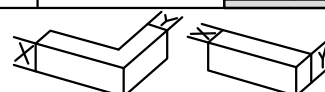
ACCESSORIES : PHOTOS & DRAWINGS

Image	Part Code	Pack	Unit	Application	Colour	
	ACET477 Cill End Cap	1	Pair	ETC477	MF	✓
					SA	
					KL	✓
					HP	✓
					SSC	
					SMC	
					W	✓
					Z	✓
					PC	
	ACET479N Cill End Cap	1	Pair	ETC479N	MF	✓
					SA	
					KL	✓
					HP	✓
					SSC	
					SMC	
					W	✓
					Z	✓
					PC	
	ACET4915 Sterling Stay Drill Jig	1	Pair	ETC4229	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
	ACET516 16mm Cavity Hinge Protector 4 Per Set (2 pairs)	50	Sets	ETC4229	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
	ACET624 Stainless Steel Chevron	100	Pack	ETC4229	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
 T-BARS ACVG65=2.5mm ACVG66=3.0mm ACVL150=4.0mm	 Screw (Grub)	MF = Mill Finish SA = Silver Anodised KL = Basic Colour HP = Special Colour SSC = Smooth Satin Chrome SMC = Smokey Chrome PC = Polished Chrome		W = White Z = Black		

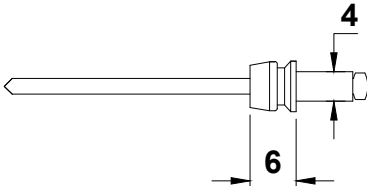
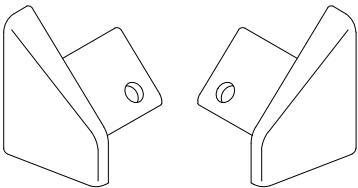
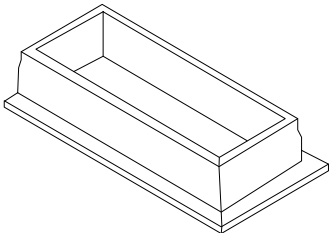
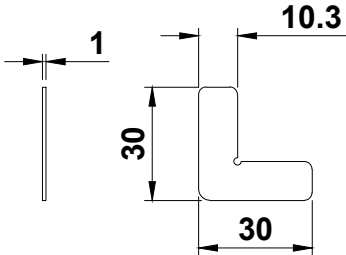
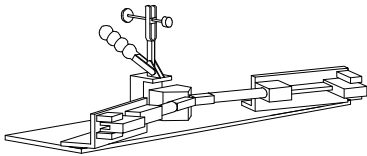
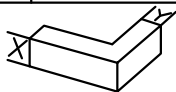
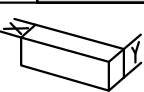
ACCESSORIES : PHOTOS & DRAWINGS

Image	Part Code	Pack	Unit	Application	Colour	
	ACET625 Anti-Twist Clip	100	Pack		MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
	ACET652 Pull-In Blocks	50	Pack	ETC4229	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	✓
					Z	✓
					PC	
	ACUN3950 Adjustable Vee Block	1	Each	ETC4210 ETC4229	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
	ACUN3951 Faceplate	1	Each	ETC4210	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
	ACUN3954 Faceplate	1	Each	ETC4229	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
 T-BARS ACVG65=2.5mm ACVG66=3.0mm ACVL150=4.0mm	 Screw (Grub)	MF = Mill Finish SA = Silver Anodised KL = Basic Colour HP = Special Colour SSC = Smooth Satin Chrome SMC = Smokey Chrome PC = Polished Chrome		W = White Z = Black	 	

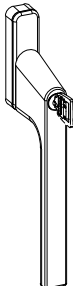
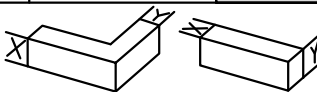
ACCESSORIES : PHOTOS & DRAWINGS

Image	Part Code	Pack	Unit	Application	Colour	
	ACUN3955 Packer	1	Each	ETC4210 ETC4229	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
	ACUN3956 Packer	1	Each	ETC4210 ETC4229	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
	ACUN3000 End Caps for UN3000	10	Pairs	UN3000	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	✓
					PC	
	ACVG560 Foam	1	Each	ETC4210 ETC4230	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	✓
					PC	
	ACVL059 End Cap	1	Pair	VL72	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	✓
					Z	✓
					PC	
 T-BARS ACVG65=2.5mm ACVG66=3.0mm ACVL150=4.0mm	 Screw (Grub)	MF = Mill Finish SA = Silver Anodised KL = Basic Colour HP = Special Colour SSC = Smooth Satin Chrome SMC = Smokey Chrome PC = Polished Chrome		W = White Z = Black		

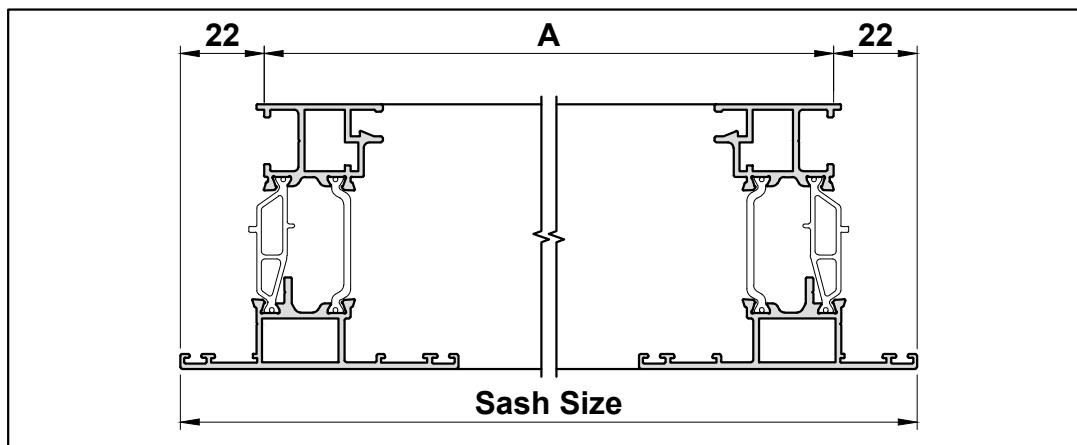
ACCESSORIES : PHOTOS & DRAWINGS

Image	Part Code	Pack	Unit	Application	Colour
	ACVL061 Rivet	100	Pack	VL72	MF ☒
					SA ☐
					KL ☐
					HP ☐
					SSC ☐
					SMC ☐
					W ☐
					Z ☐
					PC ☐
	ACVL072 Cast End Cap	1	Pair	VL72	MF ☒
					SA ☐
					KL ☒
					HP ☒
					SSC ☐
					SMC ☐
					W ☒
					Z ☒
					PC ☐
	ACVL635 PVC End Cap	1	each	ETC4236	MF ☐
					SA ☐
					KL ☐
					HP ☐
					SSC ☐
					SMC ☐
					W ☐
					Z ☒
					PC ☐
	WCA106 Stainless Steel Chevron	100	Pack	ETC4210	MF ☒
					SA ☐
					KL ☐
					HP ☐
					SSC ☐
					SMC ☐
					W ☐
					Z ☐
					PC ☐
	WUT024HSZA Manual Crimper Note: Vee Blocks & Punches are Sold Separately	1	Each		MF ☐
					SA ☐
					KL ☐
					HP ☐
					SSC ☐
					SMC ☐
					W ☐
					Z ☐
					PC ☐
 T-BARS ACVG65=2.5mm ACVG66=3.0mm ACVL150=4.0mm	 Screw (Grub)	MF = Mill Finish SA = Silver Anodised KL = Basic Colour HP = Special Colour SSC = Smooth Satin Chrome SMC = Smokey Chrome PC = Polished Chrome	W = White Z = Black	 	

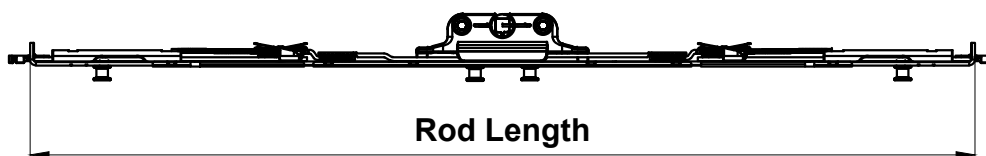
ACCESSORIES : PHOTOS & DRAWINGS

Image	Part Code	Pack	Unit	Application	Colour		
	ACSZ5033 Locking Espagnolette Handle Silver Anodised	1	Each		MF		
					SA	✓	
					KL		
					HP		
					SSC		
					SMC		
					W		
					Z		
					PC		
	ACSZ5034 Non-Locking Espagnolette Handle Silver Anodised	1	Each		MF		
					SA	✓	
					KL		
					HP		
					SSC		
					SMC		
					W		
					Z		
					PC		
					MF		
					SA		
					KL		
					HP		
					SSC		
					SMC		
					W		
					Z		
					PC		
					MF		
					SA		
					KL		
					HP		
					SSC		
					SMC		
					W		
					Z		
					PC		
 T-BARS ACVG65=2.5mm ACVG66=3.0mm ACVL150=4.0mm  Screw (Grub)	MF = Mill Finish SA = Silver Anodised KL = Basic Colour HP = Special Colour SSC = Smooth Satin Chrome SMC = Smokey Chrome PC = Polished Chrome					W = White Z = Black	

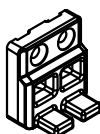
Telescopic Locking



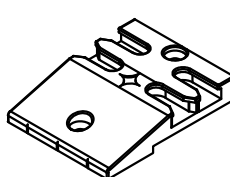
Part Code	Rod Length (mm)	Number of Keeps	Sash Rebate Size ('A')	
			Minimum	Maximum
ACET4211	500-576	3 x ACET4218 2 x ACET4219	540	616
ACET4212	577-728		617	768
ACET4213	729-1032		769	1072
ACET4214	1033-1336		1073	1376
ACET4215	1337-1640		1377	1680



ACET4219

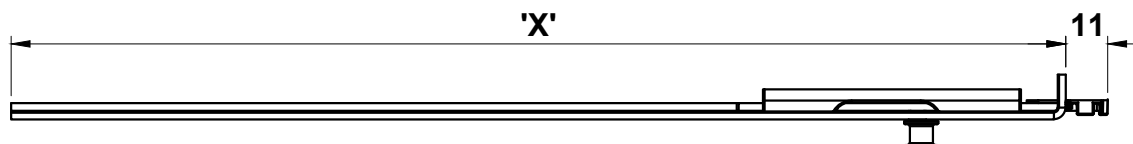
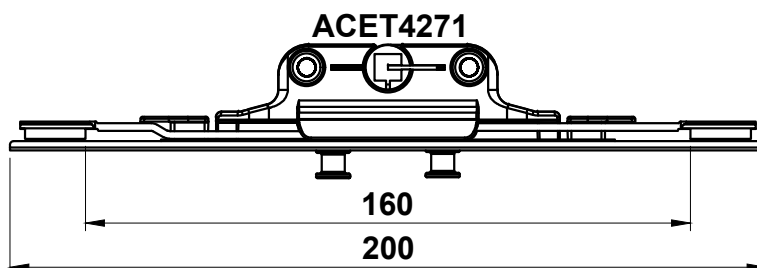


ACET4218



Croppable Locking

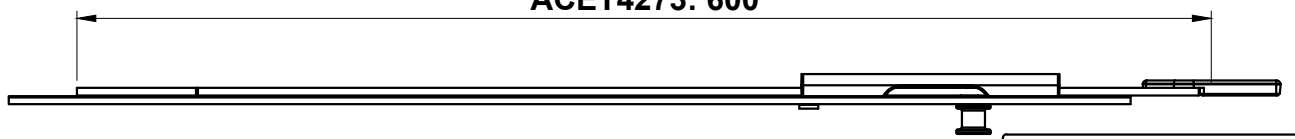
Basic locking Kit: ACET4271				
Locking Rod Part Codes	Dimension X	Number of Keeps	Sash Size	
			Minimum (mm)	Maximum (mm)
ACET4274	125.5	1 x ACET4218 2 x ACET4219	320	410
ACET4275	279	3 x ACET4218 2 x ACET4219	411	720
ACET4276	512		721	1185
ACET4277	748		1186	1655



Extension Rods

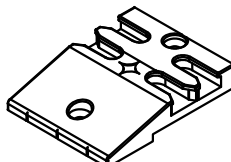
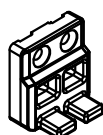
ACET4272: 300

ACET4273: 600



ACET4219

ACET4218

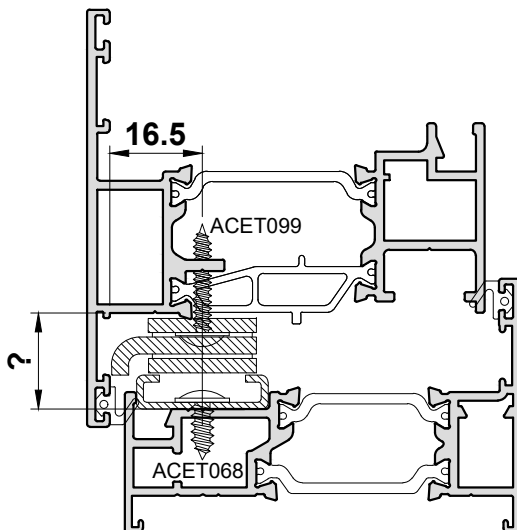


Notes:

- Sash locking can be further offset by 300mm with ACET4272, or by 600mm using ACET4273. Both require an additional ACET4218 keep per locking extension
- The sizes shown are based on a central handle position.
- Handles may be fitted off-centre if required.

Friction Hinge Stays - For Open Out Casement

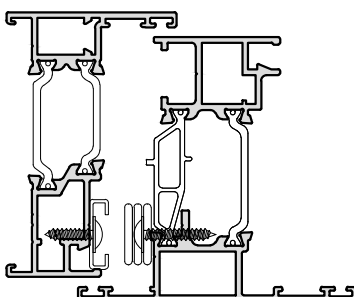
Heavy Duty (Sterling) Stays (Use drill jig ACET4915)



Hinge Code Top Hung	Hinge Length (mm)	Max Vent Weight (kg)	Min Vent Height (mm)	Max Vent Height (mm)	Opening Angle (+/-2.5°)
ACINS10	262	40	315	640	50
ACINS12	313	50	640	800	50
ACINS16	415	65	800	1100	50
ACINS22	567	100	1090	1500	45
ACINS22W	567	100	1500	2000	20
ACINS26	680	180	2000	2500	20
Side Hung	Hinge Length (mm)	Max Vent Weight (kg)	Min Vent Width (mm)	Max Vent Width (mm)	Opening Angle (+/-2.5°)
ACINSSH10	262	38	327	660	85
ACINSSH16	415	55	450	838	60

Please Note:

1. Dimensions shown in table are sash sizes - not rebate sizes.
2. The minimum sash sizes for ACINS10 & ACINSSH10 can both be reduced to 281mm where cockspur handles are used.
3. Top hung height & side hung width sizes to be reduced by 2mm where size is 450mm or smaller.
4. Vents of 100kg must be fitted with ACINS09 cam adjustment devices, which are optional on lighter vents
5. Separate restrictors (ACINS30 & ACINS31) vent holding devices may be required to hold large vents in a selected ventilation position against variable wind pressure.



Friction Hinge Stays 16mm Stack (Standard)

Top Hung Windows

Top Hung	Type of Hinge / Stay	Max. Vent	Height	
		Weight (kgs)	Minimum	Maximum
ACETDHS08	Standard	12	200	350
ACETDHS10		16	275	400
ACETDHS12		20	350	550
ACETDHS16		21	500	780
ACETDHS20		26	700	1100
ACETDHS24		40	850	1300
ACETDTH24	Heavy Duty	50	850	1500
ACETDHS12R	Restricted	20	350	550
ACETDHS16R		21	500	780
ACETDHS20R		26	700	1100
ACETDHS24R		40	850	1300

Side Hung Windows

Side Hung	Type of Hinge / Stay	Max. Vent	Width	
		Weight (kgs)	Minimum	Maximum
ACETDHSSH12	Standard	22	320	600
ACETDHSSH16		24	420	700
ACETDHRSH12	Restricted	22	300	600
ACETDHRSH16		24	400	700
ACETME16	Egress	40	400	900
ACETDSH16	Heavy Duty	40	400	1000

Note1: Vent Height / Width is measured in mm.

Note2: Dimensions shown in table are sash sizes - not rebate sizes.

Note3: Top hung height and side hung width sizes to be reduced by 2mm where size is 450mm or smaller

Note4: Typical Dimensions based on Max. Size and Glass 30kg/metre

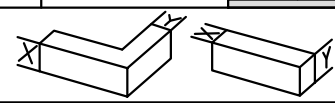
Image	Part Code	Pack	Unit	Application	Colour	
	ACMX09700 Alu. Polish	1	each		MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
	ACMX09761 Maxi Gloss	1	each		MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
	ACMX09762 Alu. Bright	1	each		MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
	ACMX09763 Teflon Spray	1	each		MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
	ACMX09764 Maxi Clean	1	each		MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
 T-BARS ACVG65=2.5mm ACVG66=3.0mm ACVL150=4.0mm	 Screw (Grub)	MF = Mill Finish SA = Silver Anodised KL = Basic Colour HP = Special Colour SSC = Smooth Satin Chrome SMC = Smokey Chrome PC = Polished Chrome		W = White Z = Black		

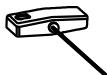
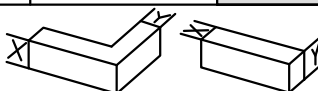
Image	Part Code	Pack	Unit	Application	Colour	
	ACMX09765 Alu. Cleaner	1	each		MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
	ACMX09770 Roll & Wrap 100mm	1	each		MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
	ACMX09775 Grip Handwrap	1	each		MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
	ACMX09801 Protective Tape 50mm	1	each		MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
	ACMX09802 Protective Tape 70mm	1	each		MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
 T-BARS ACVG65=2.5mm ACVG66=3.0mm ACVL150=4.0mm	 Screw (Grub)	MF = Mill Finish SA = Silver Anodised KL = Basic Colour HP = Special Colour SSC = Smooth Satin Chrome SMC = Smokey Chrome PC = Polished Chrome	W = White Z = Black			

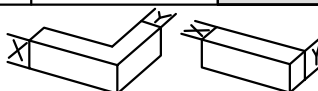
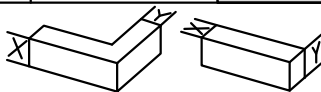
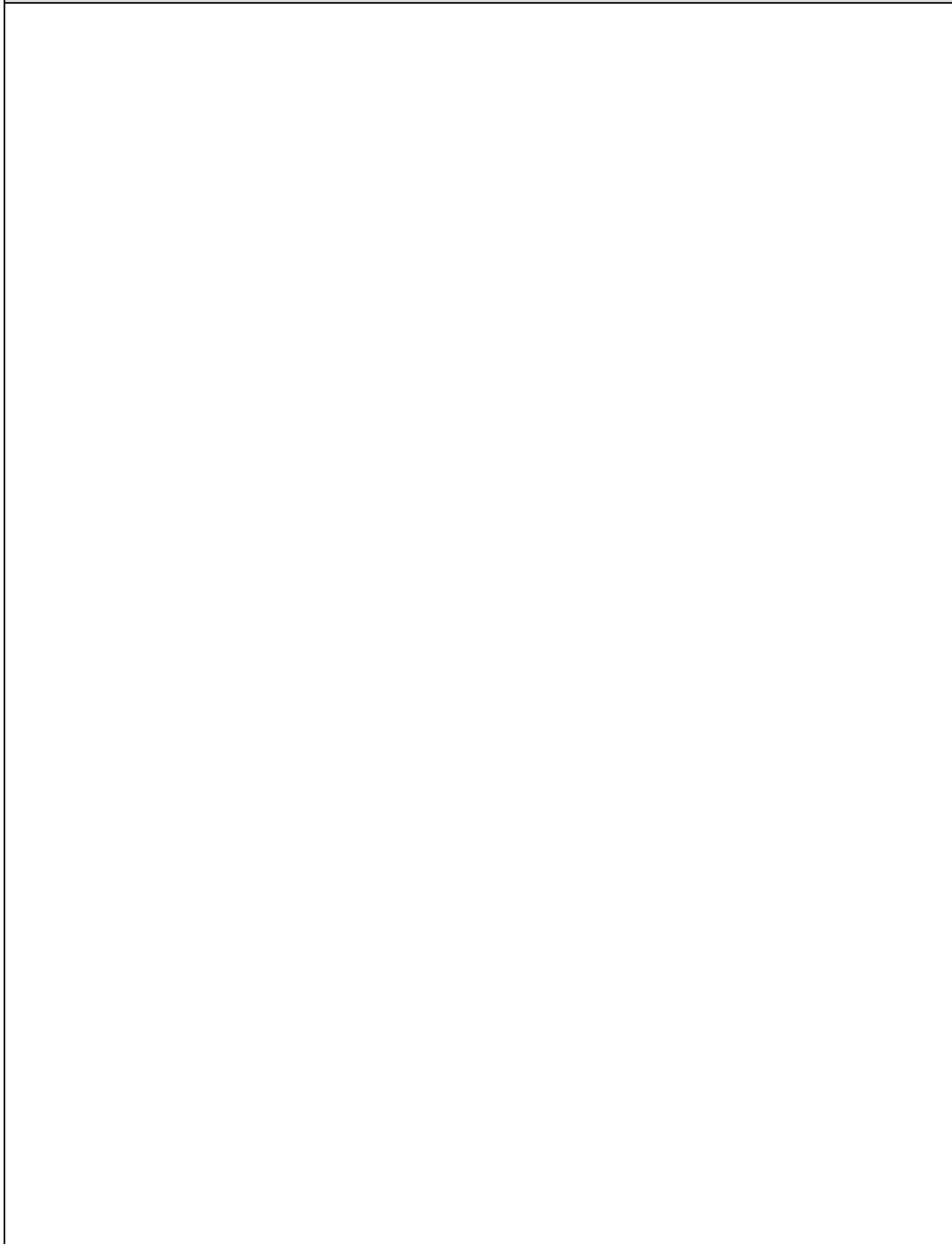
Image	Part Code	Pack	Unit	Application	Colour
	ACMX09803 Protective Tape 100mm	1	each		MF
					SA
					KL
					HP
					SSC
					SMC
					W
					Z
					PC
	ACMX09830 Rubber Sealant	1	each		MF
					SA
					KL
					HP
					SSC
					SMC
					W
					Z
					PC
	ACSIL04 Sealing Glue Order with suffix of KL colour (eg.ACSIL04KL005) or BL=Black/WP=White/ CL=Clear	1	each		MF
					SA
					KL
					HP
					SSC
					SMC
					W
					Z
					PC
	ACSIL08 Silicon Gun	1	each		MF
					SA
					KL
					HP
					SSC
					SMC
					W
					Z
					PC
	ACSIL013 Glue for Mitre	1	each		MF
					SA
					KL
					HP
					SSC
					SMC
					W
					Z
					PC
 T-BARS ACVG65=2.5mm ACVG66=3.0mm ACVL150=4.0mm	 Screw (Grub)	MF = Mill Finish SA = Silver Anodised KL = Basic Colour HP = Special Colour SSC = Smooth Satin Chrome SMC = Smokey Chrome PC = Polished Chrome	W = White Z = Black		

Image	Part Code	Pack	Unit	Application	Colour
	ACSIL014 Anti-Corrosion Coating	1	each		MF ☒
					SA ☐
					KL ☐
					HP ☐
					SSC ☐
					SMC ☐
					W ☐
					Z ☐
					PC ☐
	ACUN3900 Gasket Roller	1	each		MF ☐
					SA ☐
					KL ☐
					HP ☐
					SSC ☐
					SMC ☐
					W ☐
					Z ☐
					PC ☐
					MF ☐
					SA ☐
					KL ☐
					HP ☐
					SSC ☐
					SMC ☐
					W ☐
					Z ☐
					PC ☐
					MF ☐
					SA ☐
					KL ☐
					HP ☐
					SSC ☐
					SMC ☐
					W ☐
					Z ☐
					PC ☐
 T-BARS ACVG65=2.5mm ACVG66=3.0mm ACVL150=4.0mm  Screw (Grub)	MF = Mill Finish SA = Silver Anodised KL = Basic Colour HP = Special Colour SSC = Smooth Satin Chrome SMC = Smokey Chrome PC = Polished Chrome				MF ☐
					SA ☐
					KL ☐
					HP ☐
					SSC ☐
					SMC ☐
					W ☐
					Z ☐
					PC ☐
					

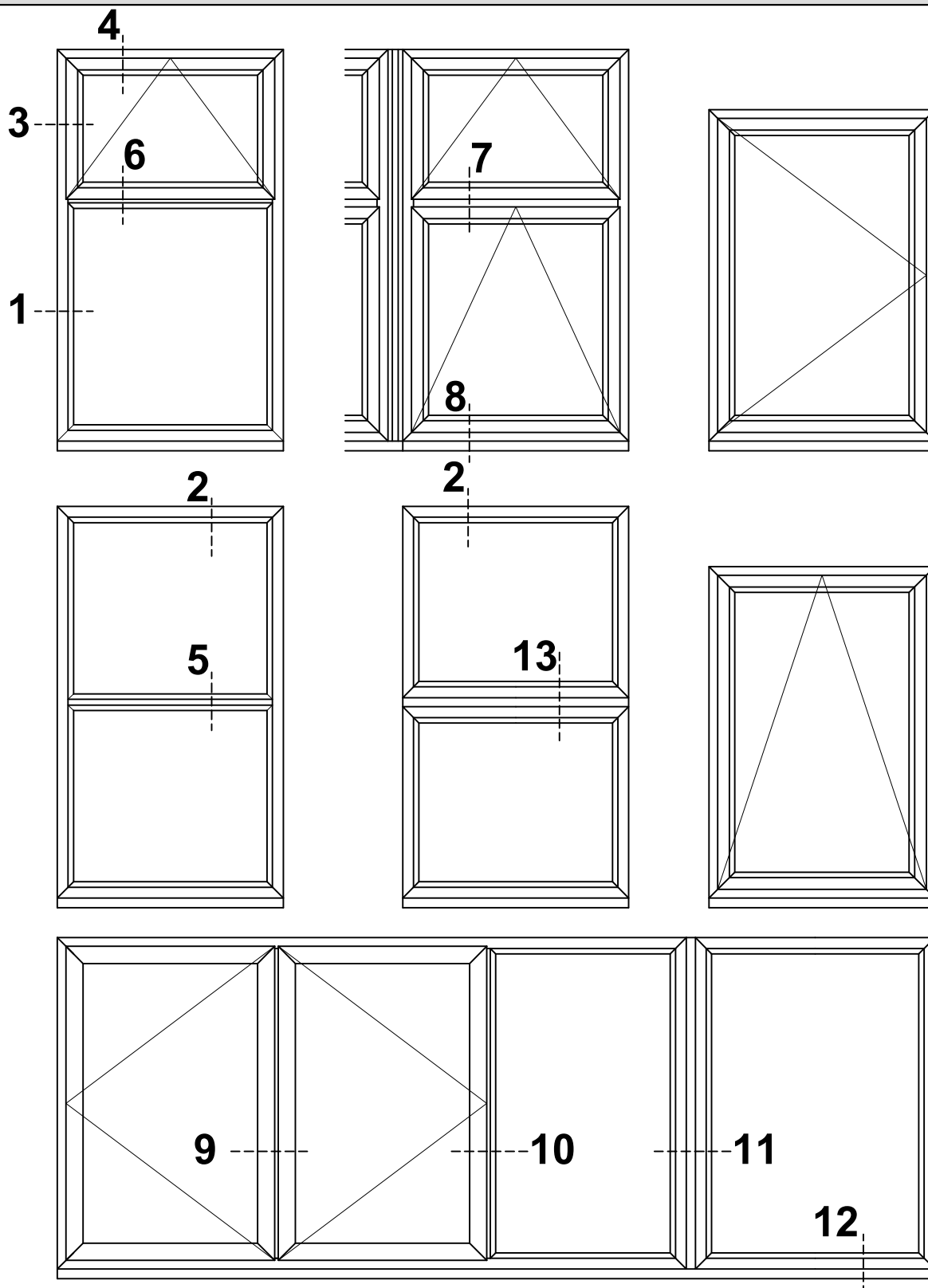
Section C

Sections

Scale Elevations

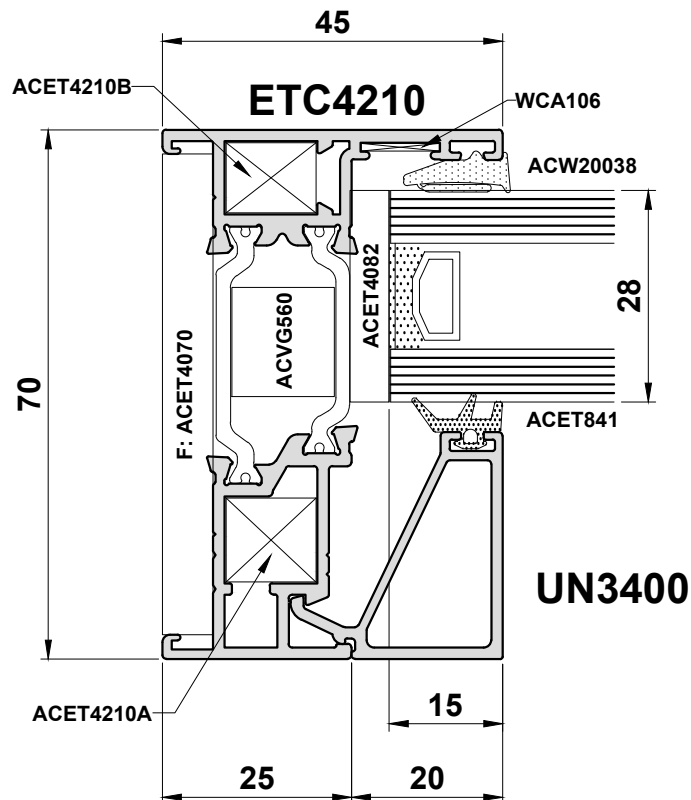
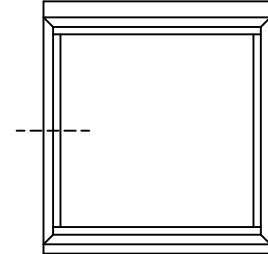


Standard Casement Details



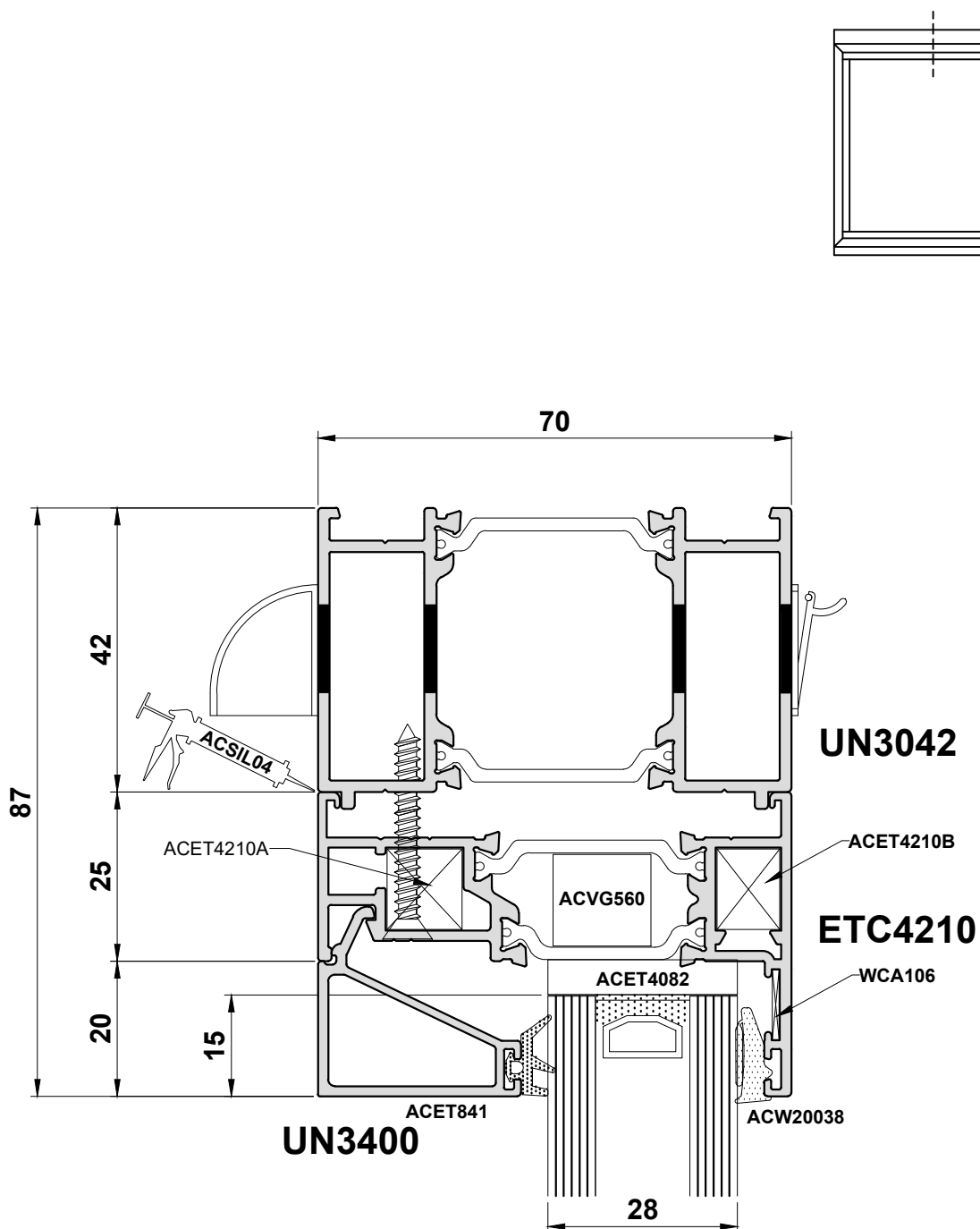
Do Not Scale From This Drawing

Detail 1



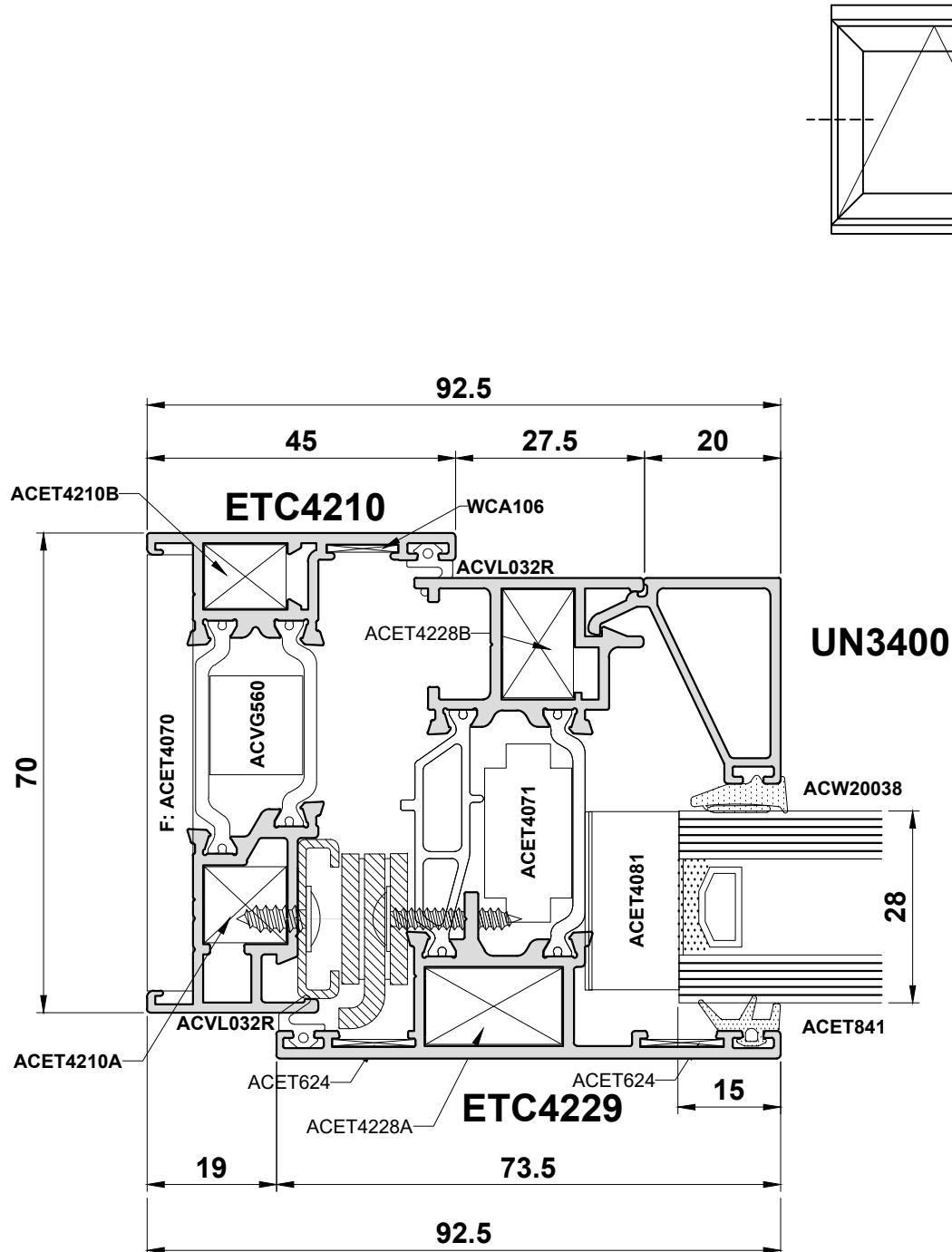
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Detail 2



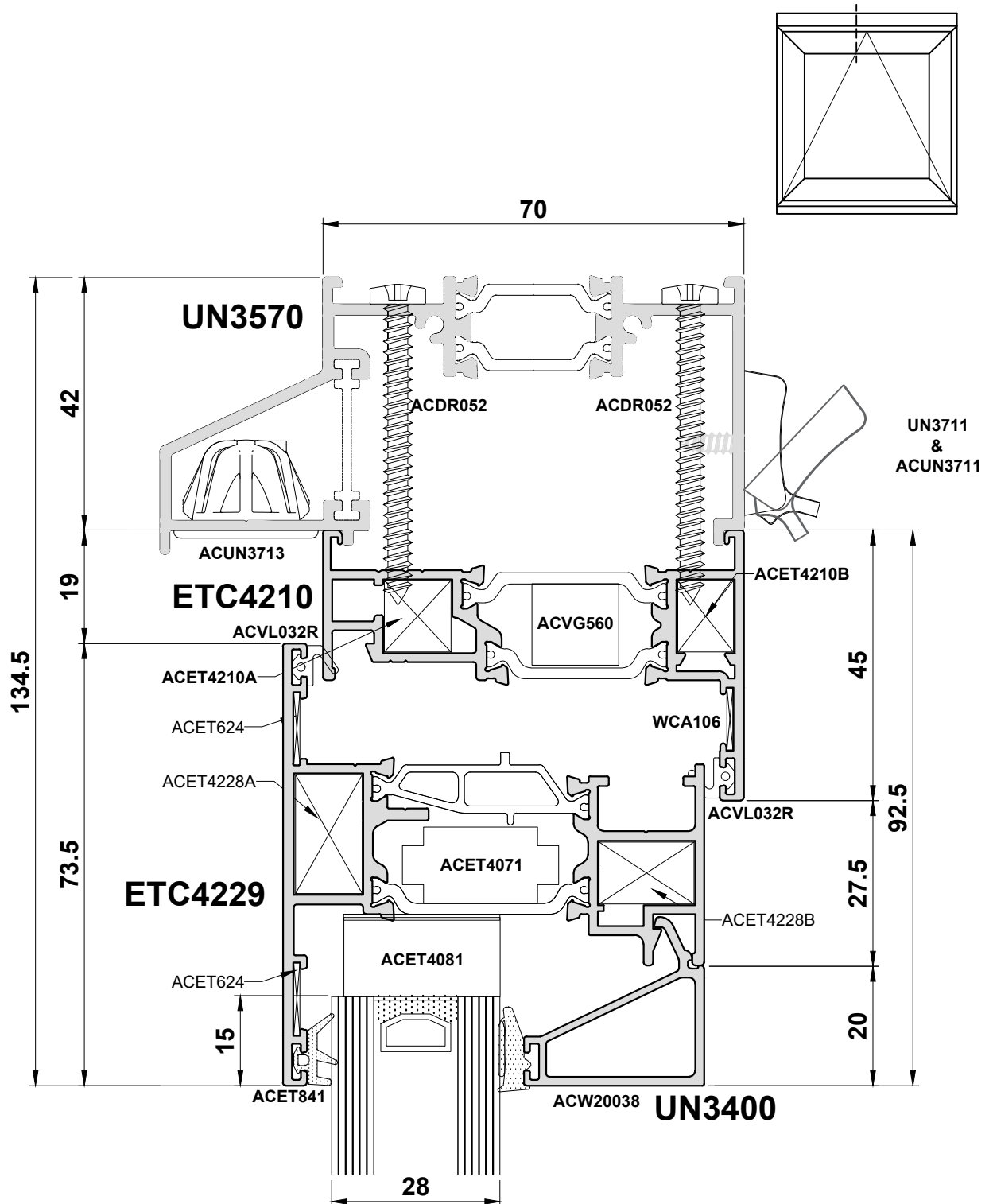
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Detail 3



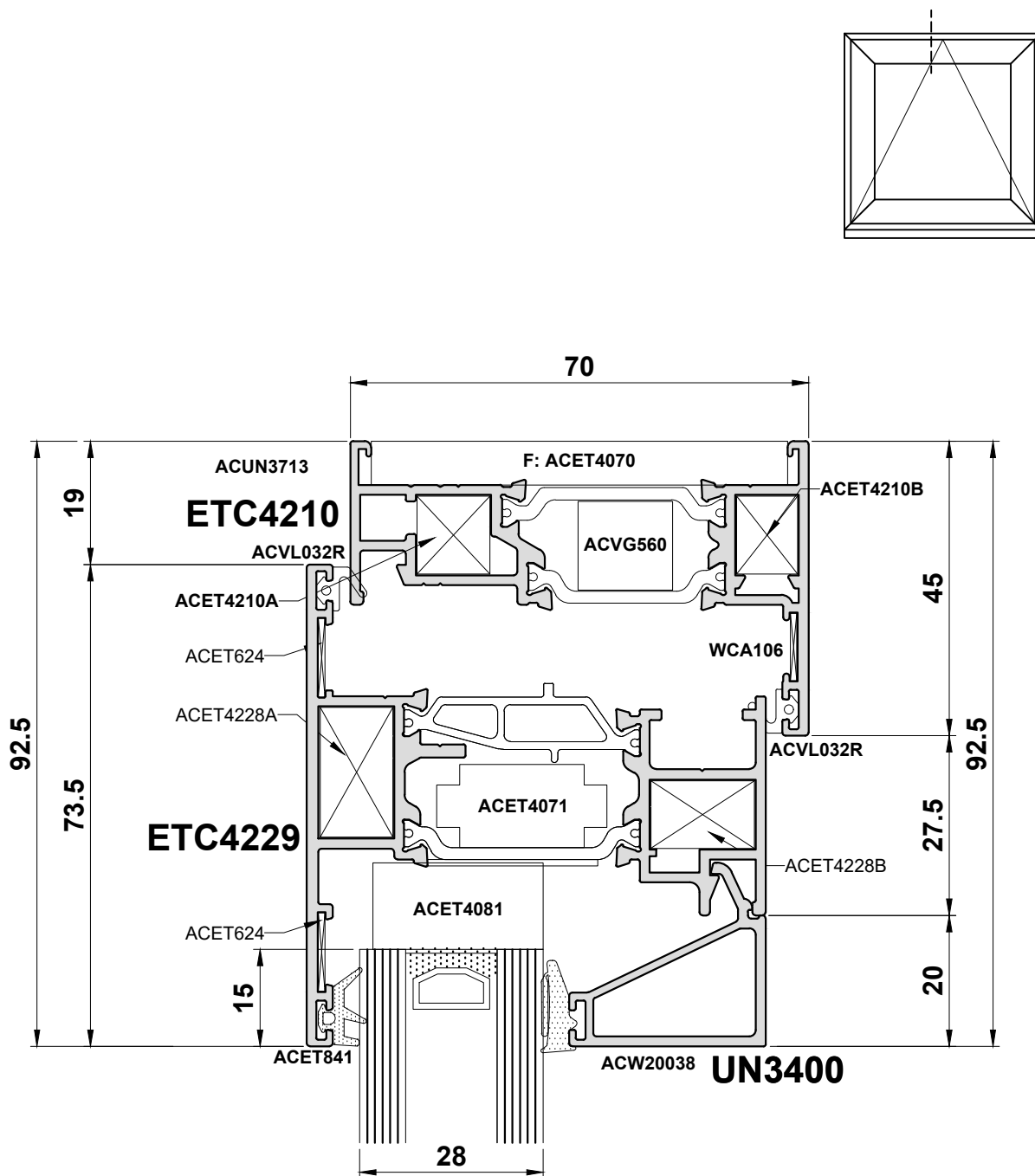
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Detail 4A



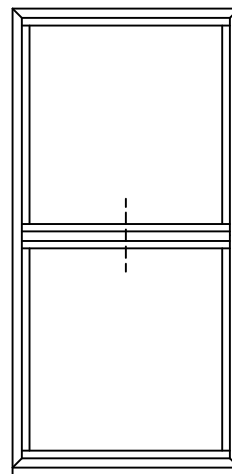
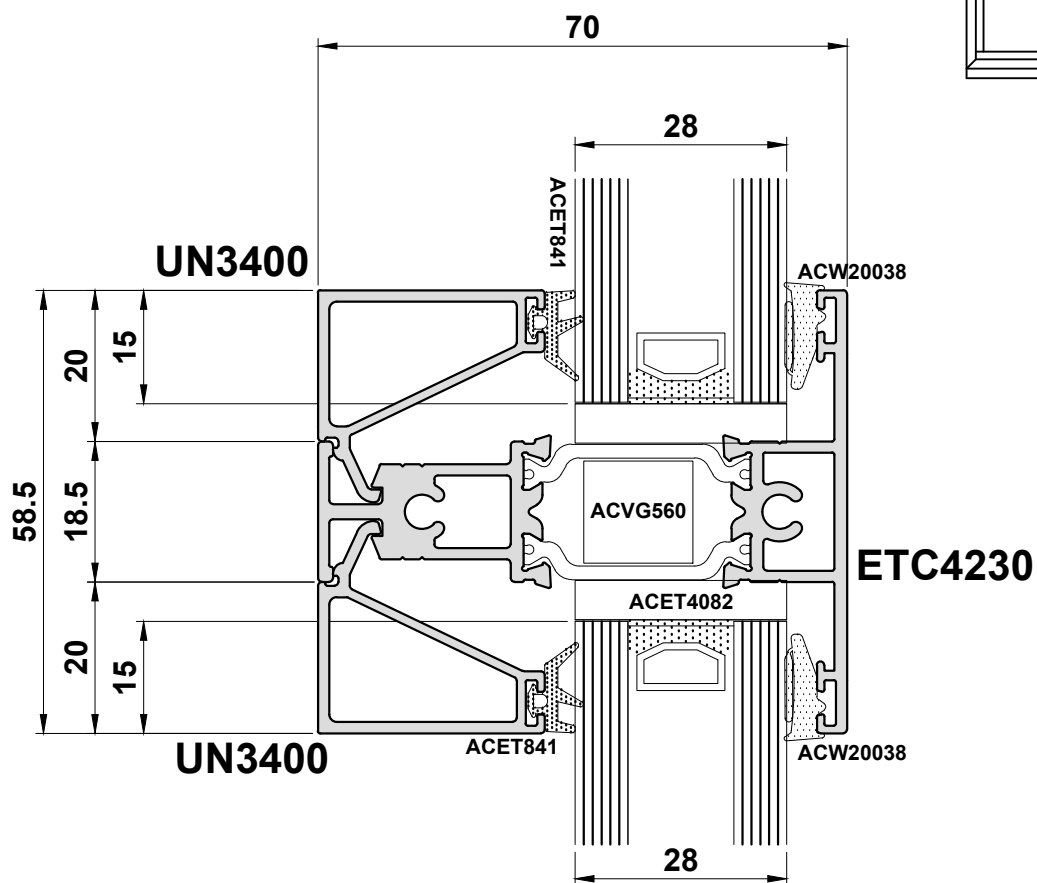
Do Not Scale From This Drawing

Detail 4B



Do Not Scale From This Drawing

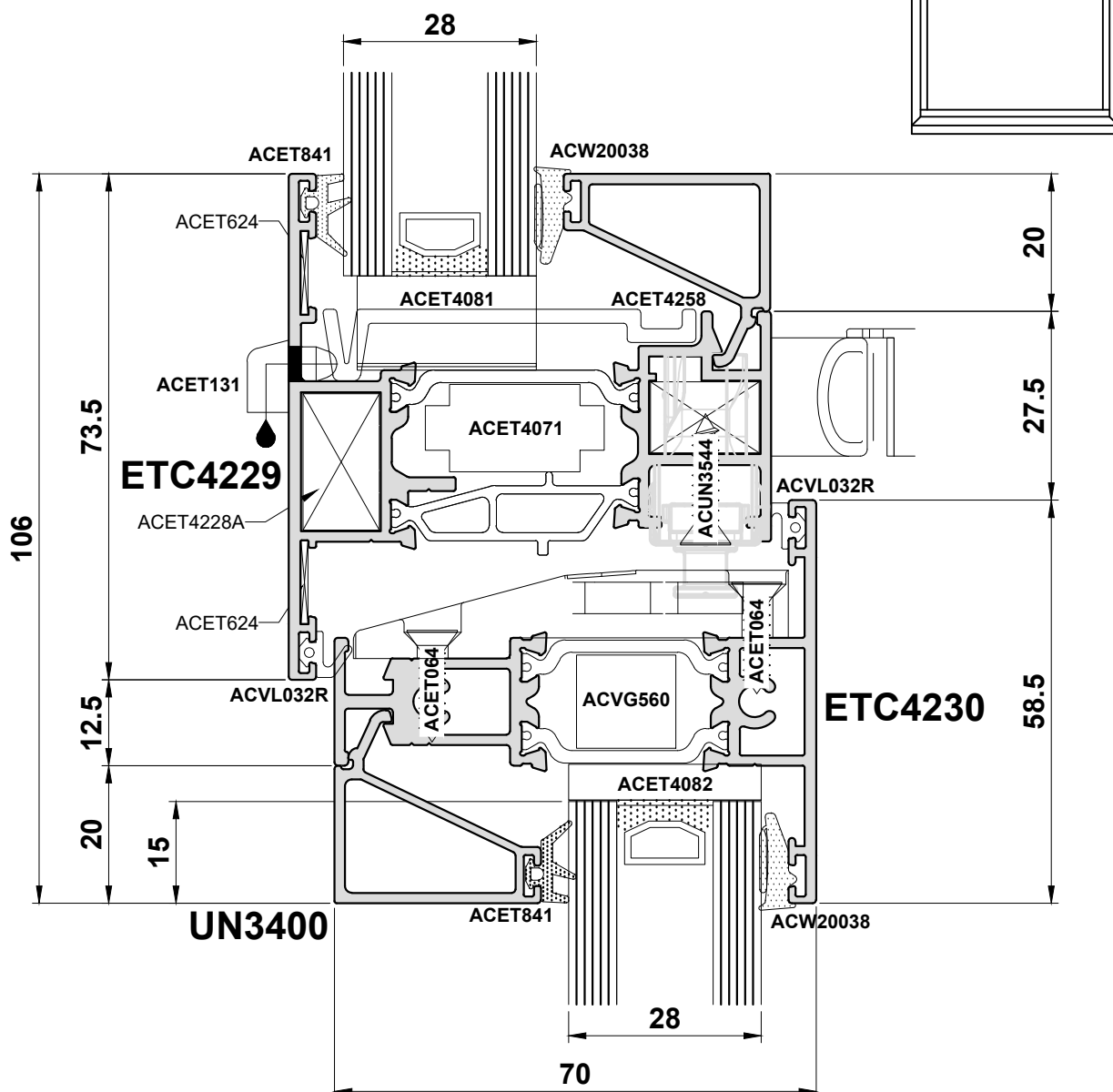
Detail 5



Note: Transoms will drain through the joint to the outerframe.

Do Not Scale From This Drawing

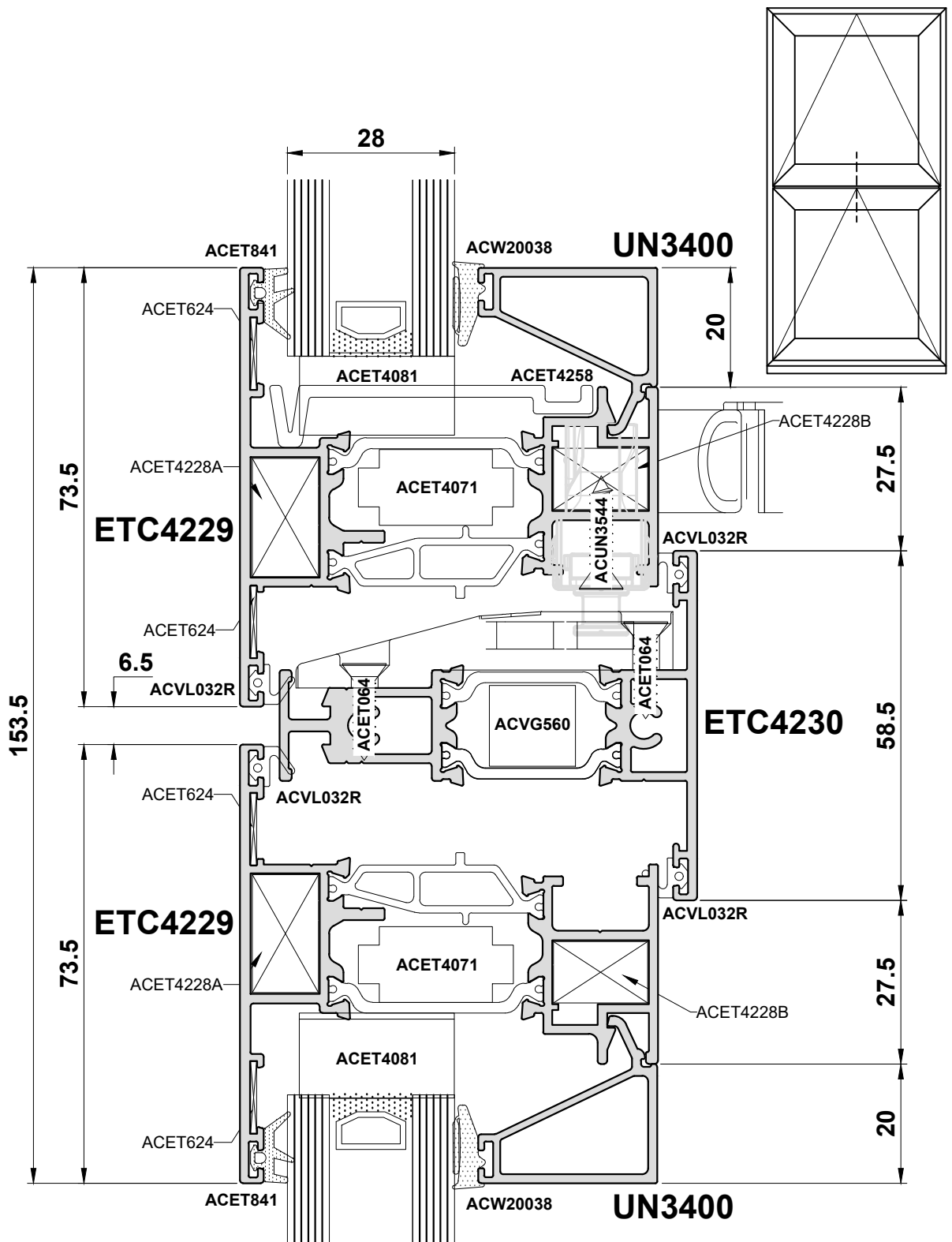
Detail 6



Note: Transoms will drain through the join to the outerframe.

Do Not Scale From This Drawing

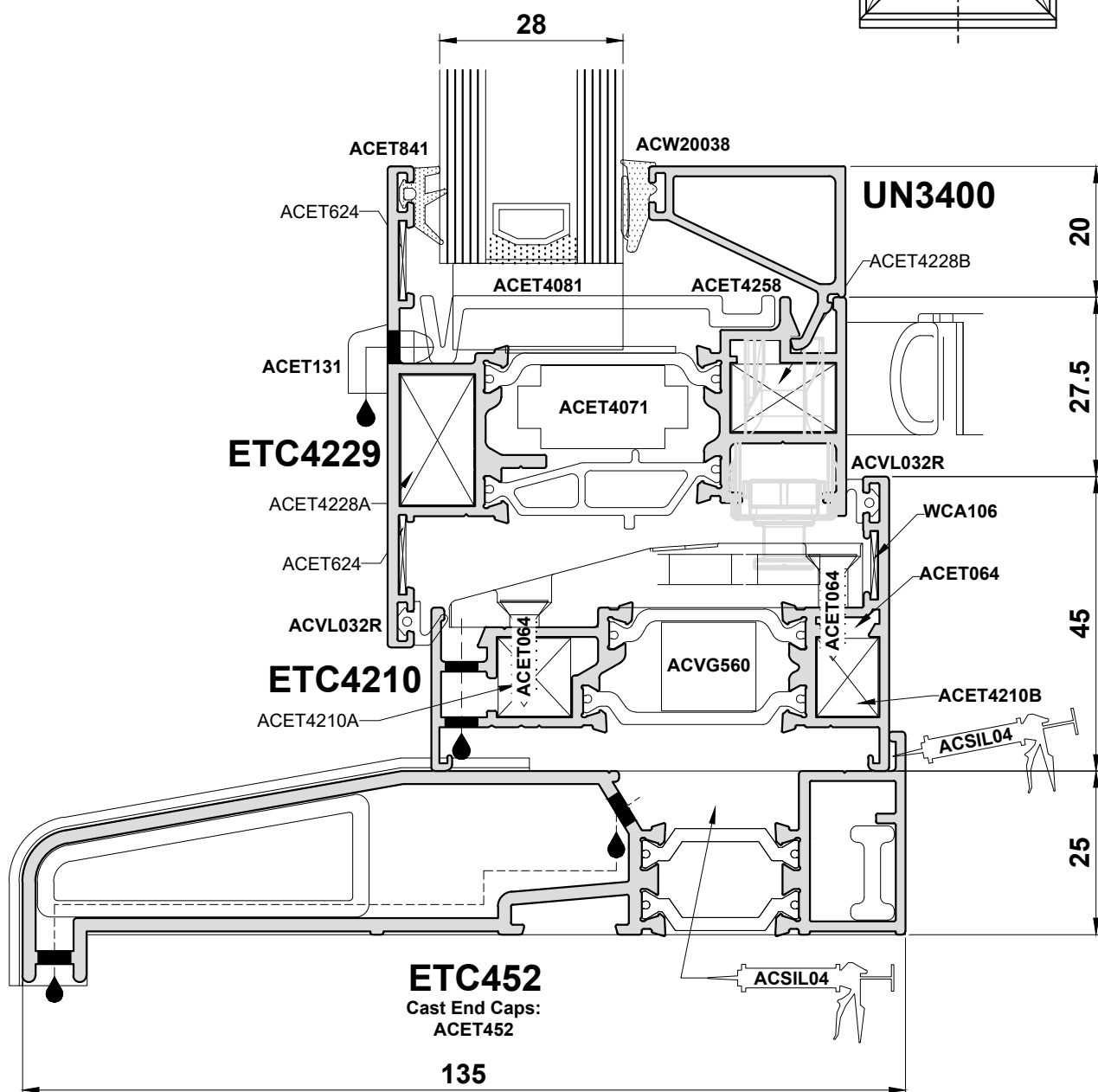
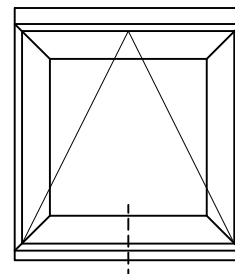
Detail 7



Note: Transoms will drain through the join to the outerframe.

Do Not Scale From This Drawing

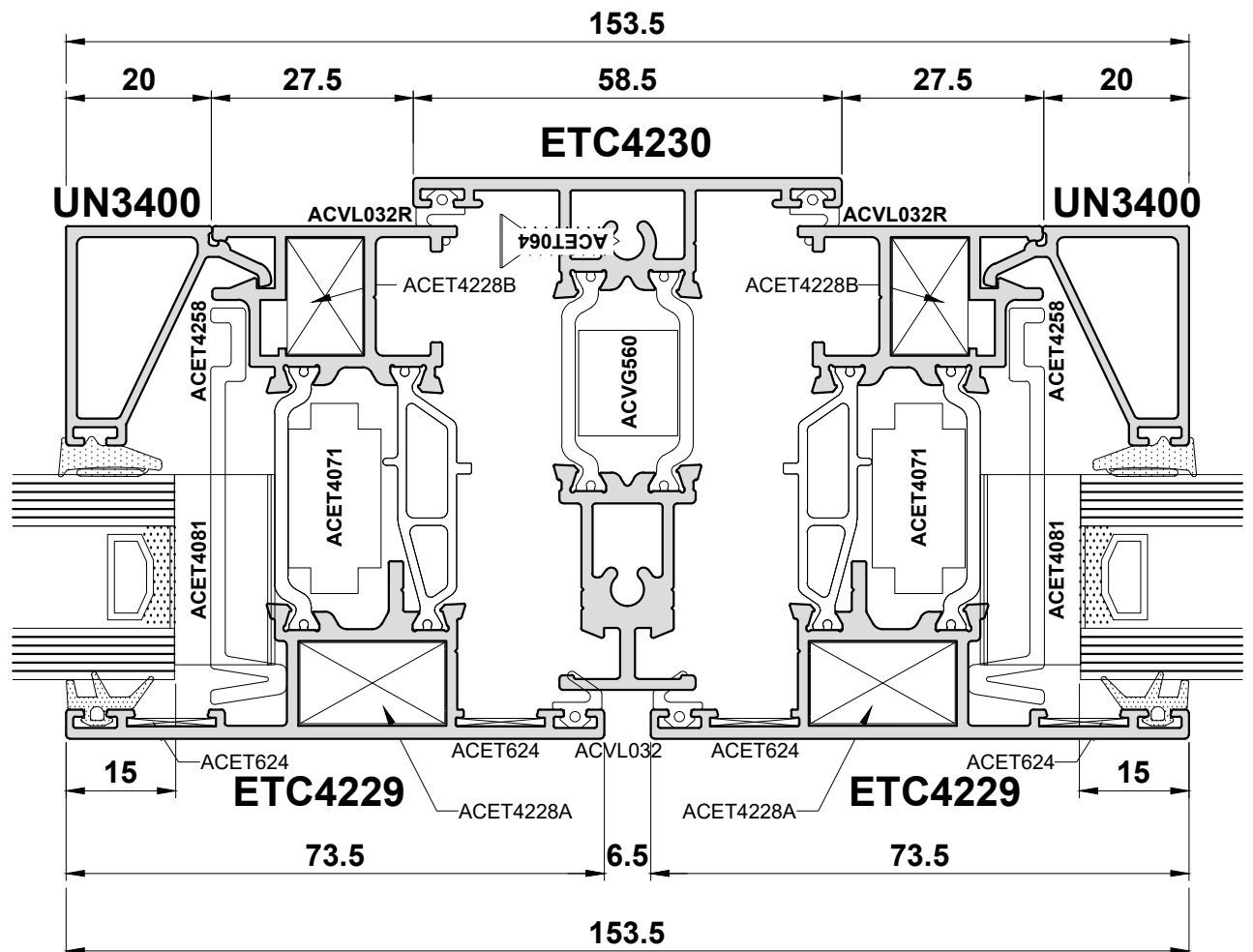
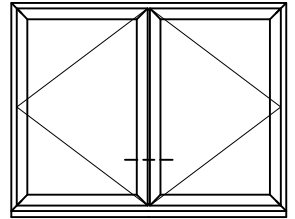
Detail 8



Cill end caps shall be sealed to cill to prevent water egress over edge

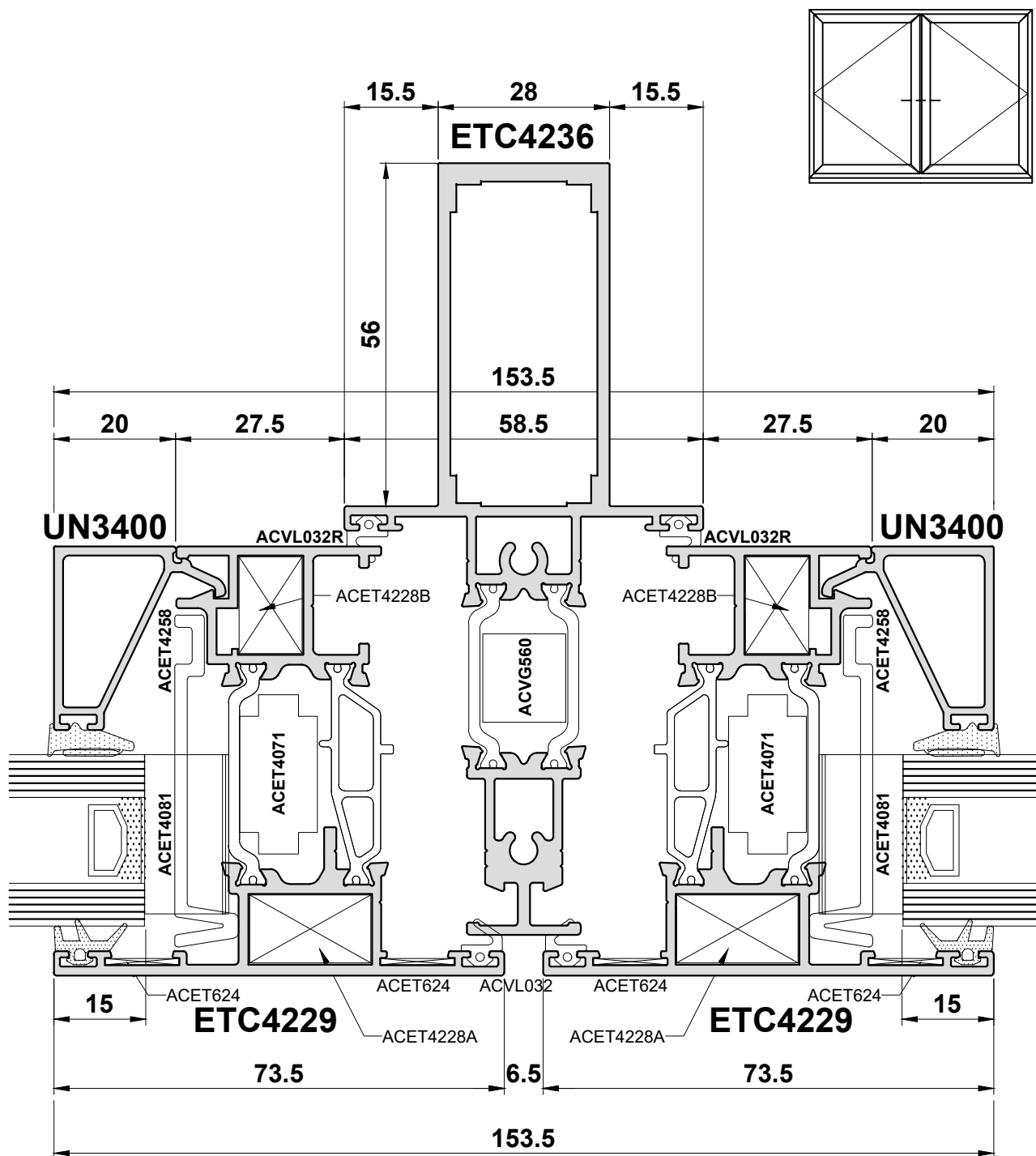
Do Not Scale From This Drawing

Detail 9A



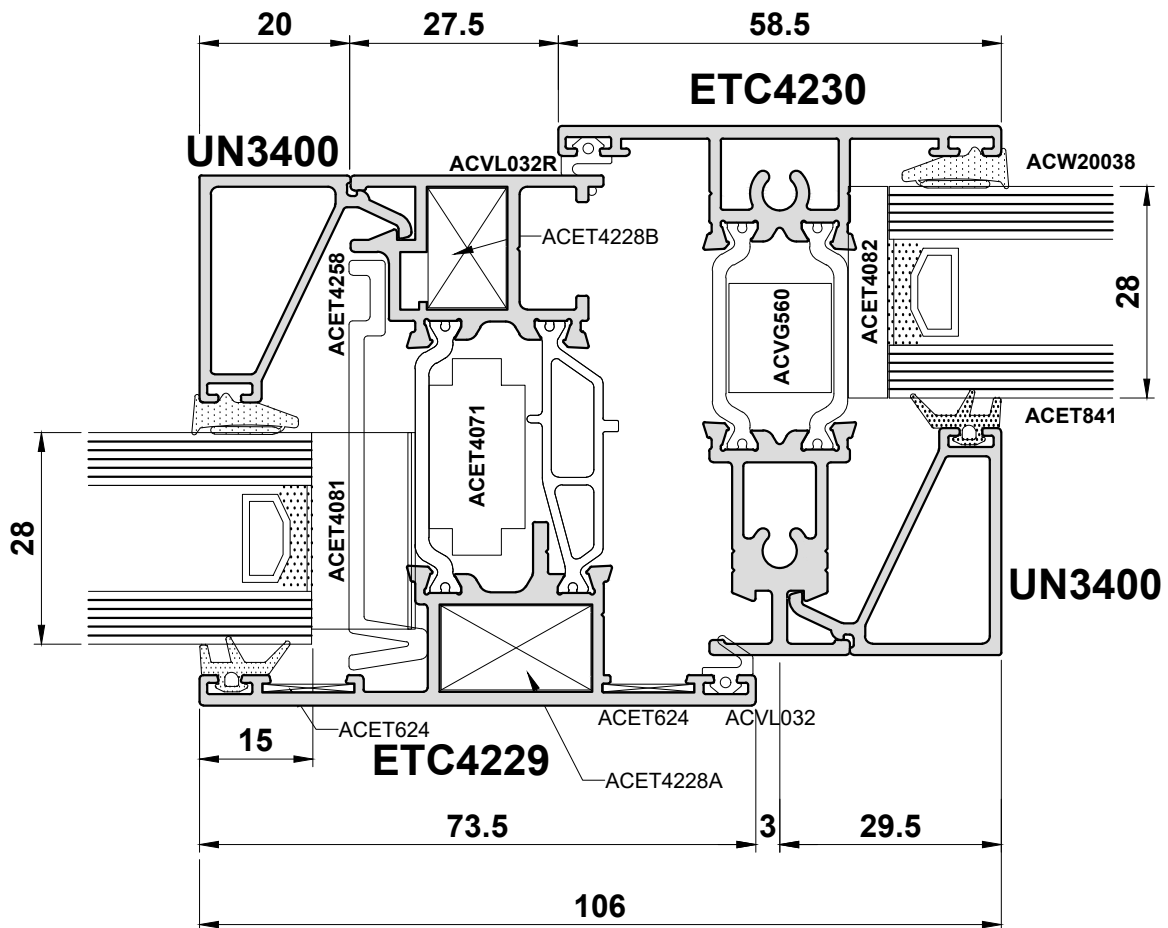
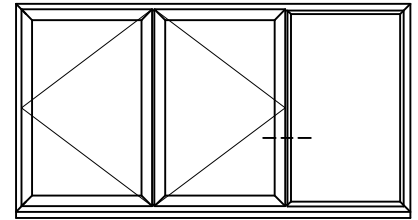
Do Not Scale From This Drawing

Detail 9B



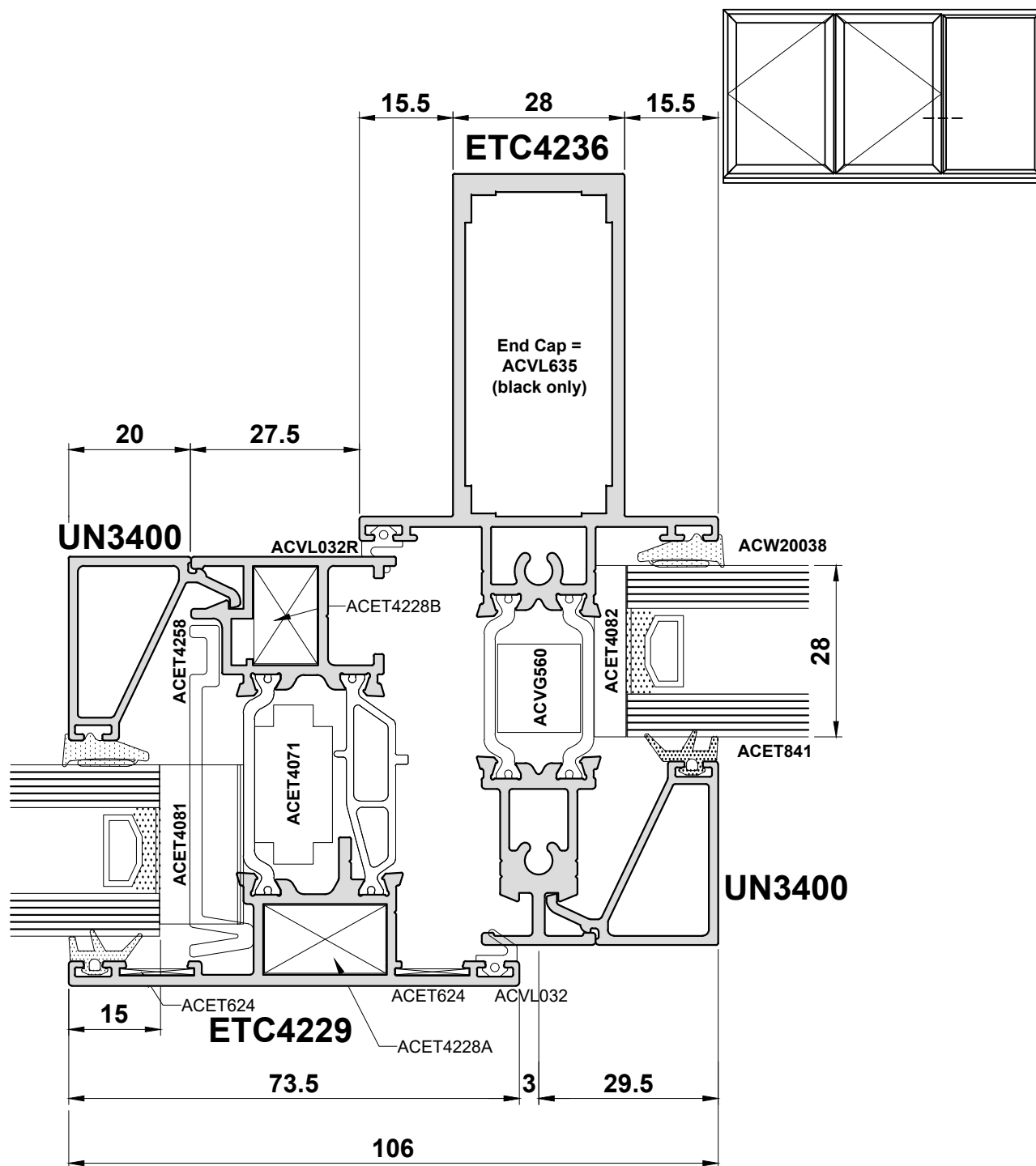
Do Not Scale From This Drawing

Detail 10A



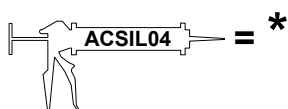
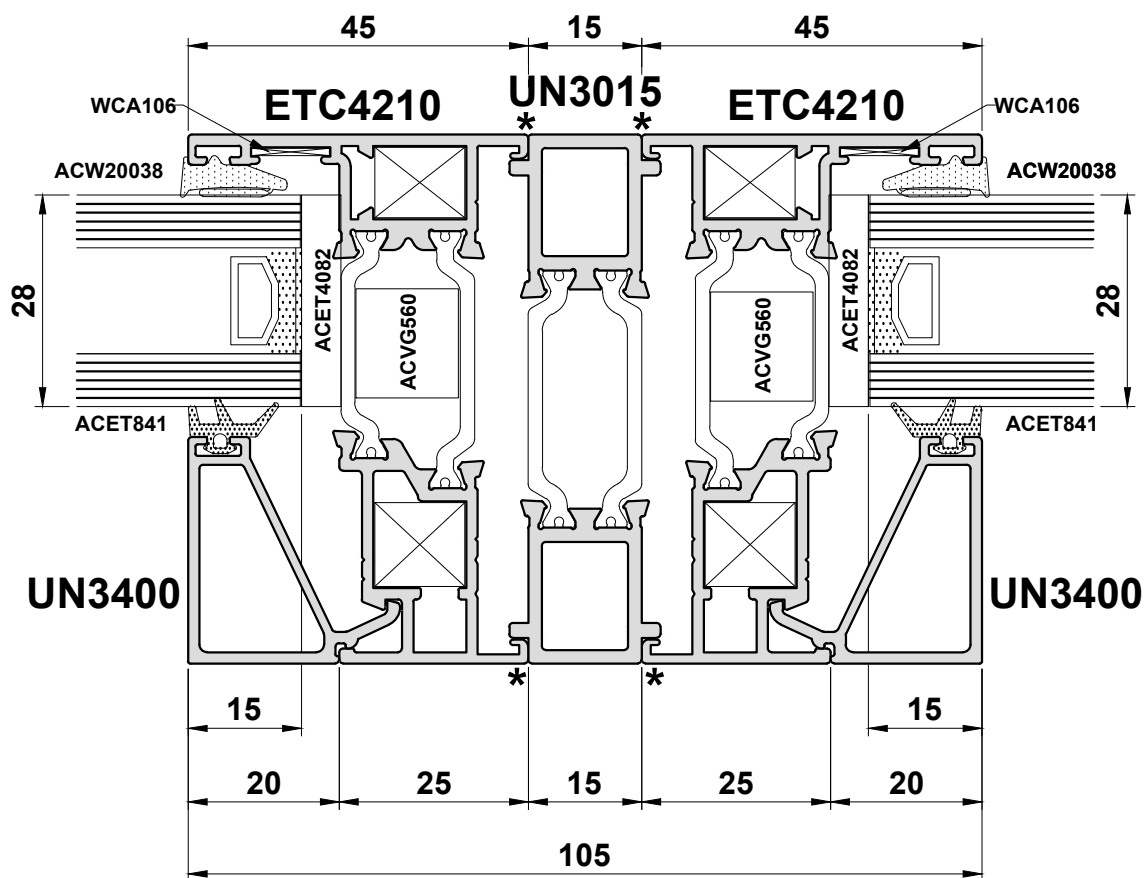
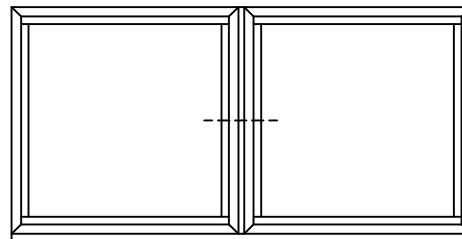
Do Not Scale From This Drawing

Detail 10B



Do Not Scale From This Drawing

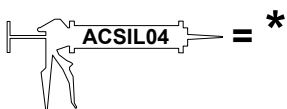
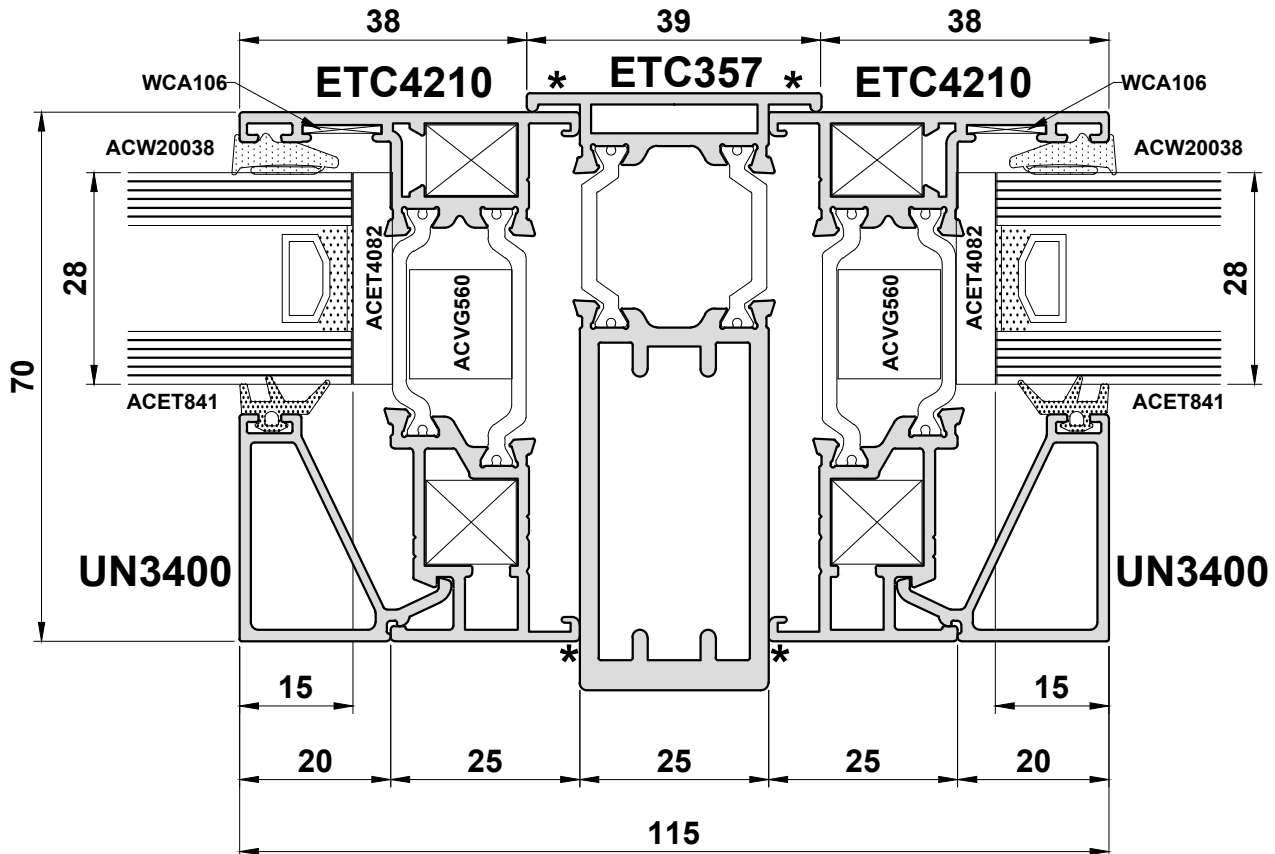
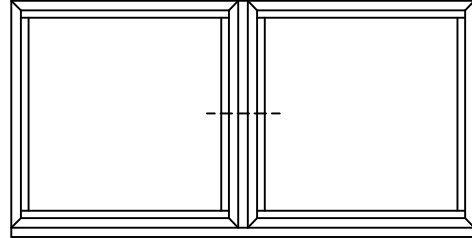
Detail 11A



Coupler fixing not shown for clarity

Do Not Scale From This Drawing

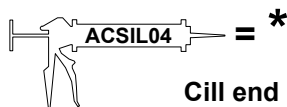
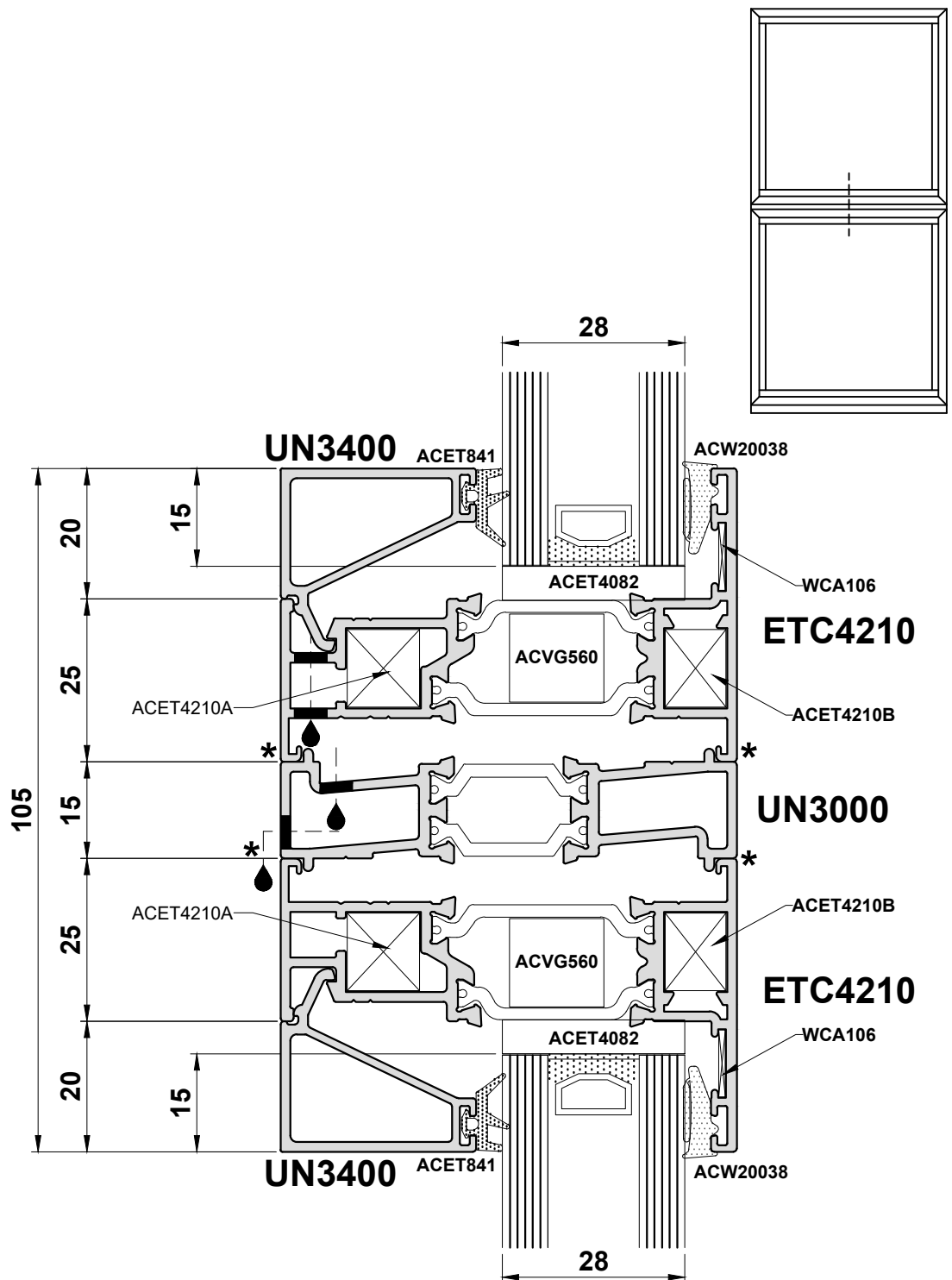
Detail 11B



Coupler fixing not shown for clarity

Do Not Scale From This Drawing

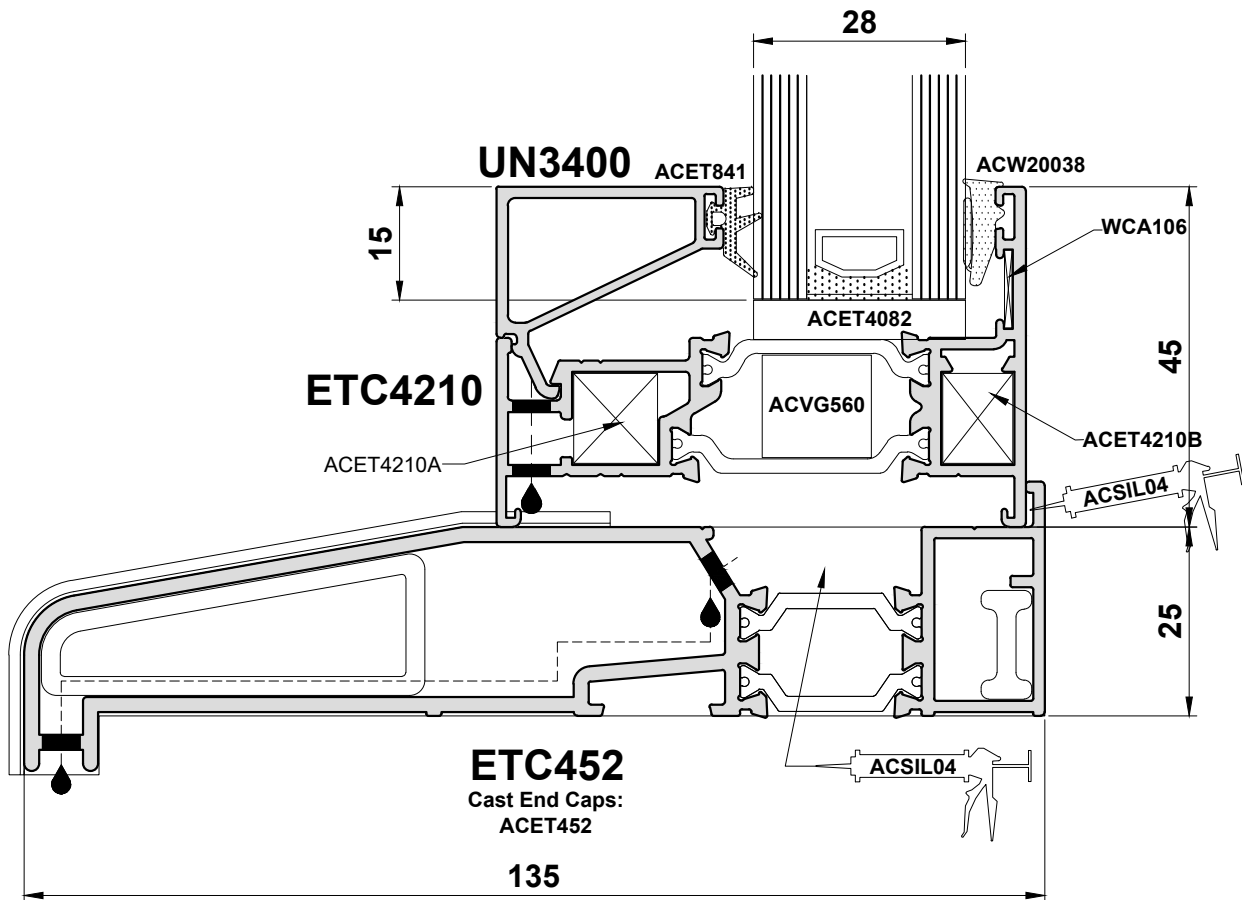
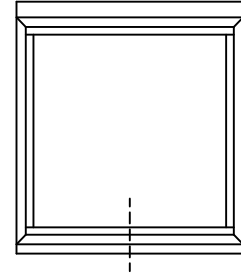
Detail 12



Coupler fixing not shown for clarity
Cill end caps should be sealed to cill to prevent water egress over edge

Do Not Scale From This Drawing

Detail 13

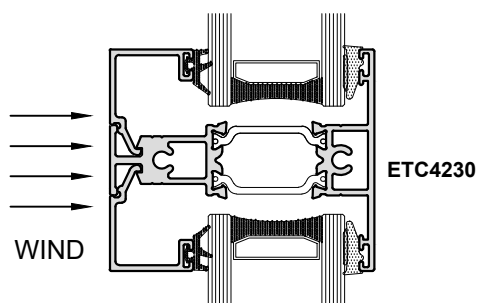


Do Not Scale From This Drawing

Section D

Statics

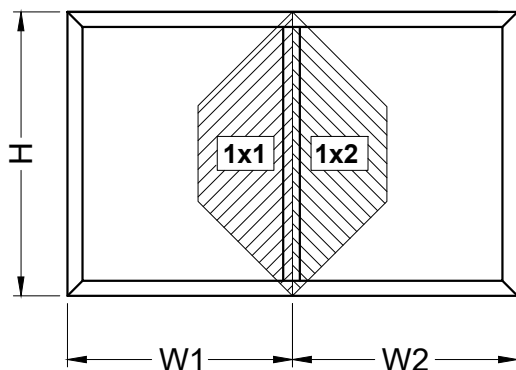
**For Wind Loading Limitations, Please Contact
The Technical Department - T: 01934 833100**



The position of the axes is an indication for the use and application of the moments of inertia (I_x and I_y) and the section modulus (W_x and W_y). We always choose the values of the axis perpendicular to the load to resist it.

- To resist the wind loads we use the values I_x and W_x .

EXAMPLE



$H = 175\text{cm}$

$W1 = 120\text{cm}$

$W2 = 100\text{cm}$

$P = 1250\text{ Pa}$ (wind pressure)

- 1) Determine I_{xx} value for the stiles (if required) using the Specification Wizard

$I_{xx} = 21.0\text{ cm}^4$

- 2) Determine suitability



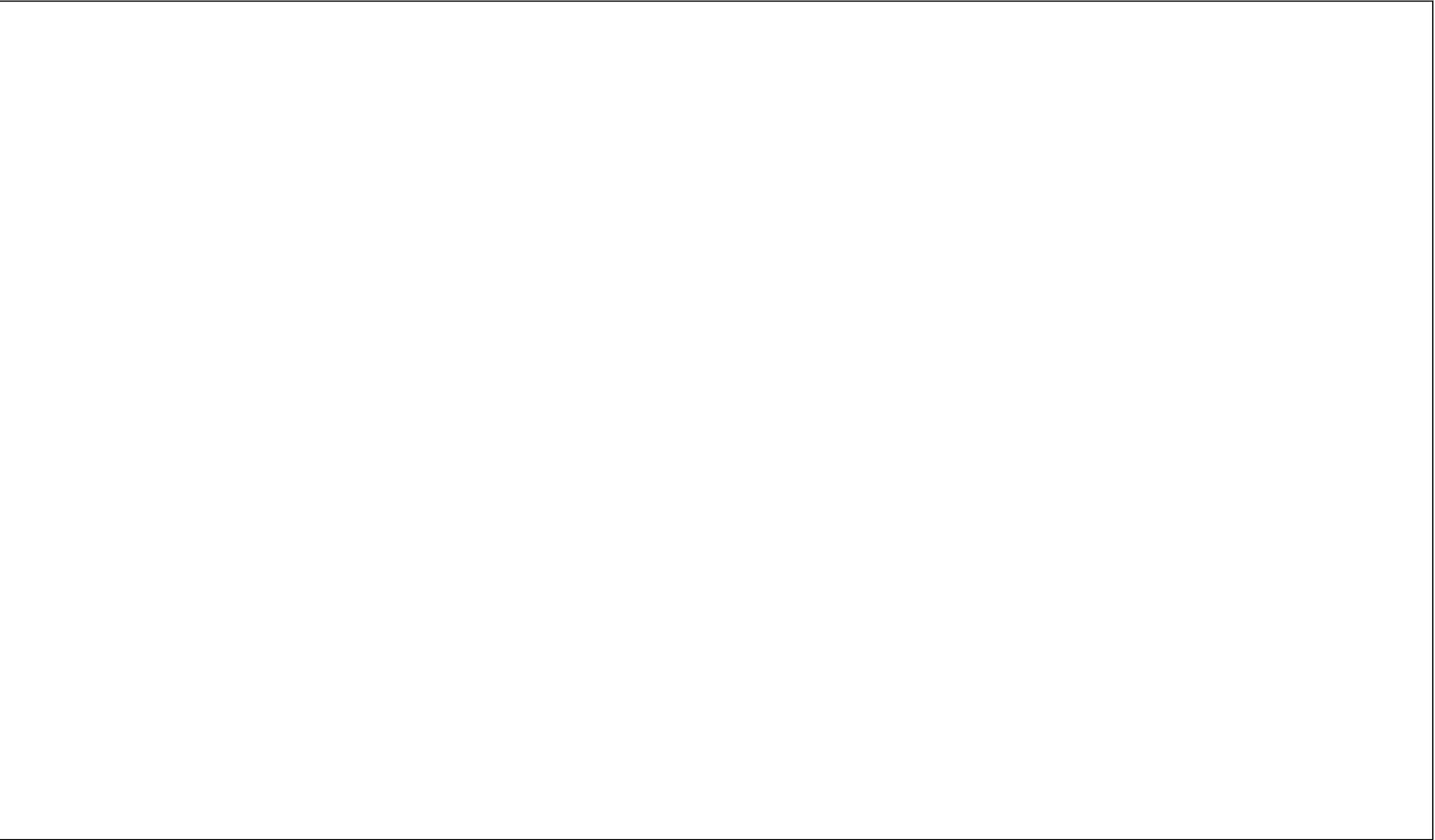
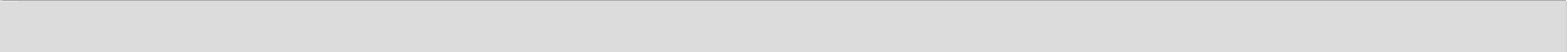
Number	Picture	$I_x(\text{cm}^4)$ $W_x(\text{cm}^3)$	$I_y(\text{cm}^4)$ $W_y(\text{cm}^3)$
ETC4230		28.81 — 7.17	4.75 — 1.62
ETC4236		115.69 — 17.22	9.23 — 3.15

Section E



Construction Drawings

Corner Joint Details.....	E03-E04
Drainage.....	E05
Cill Details.....	E06-E07
Friction Hinges & Accessories.....	E08-E09
Transom/Mullion Details.....	E10-E13
Locking Details.....	E14-E16
Glazing Information.....	E17-E20
Standard Bay Pole.....	E21-E22
Horizontal Coupler.....	E23
Fixing Straps.....	E24
Trickle Vent.....	E25
Jackable Bay Poles.....	E26-E29
ACDV916 Punch Tool.....	E30



Corner Joint Details

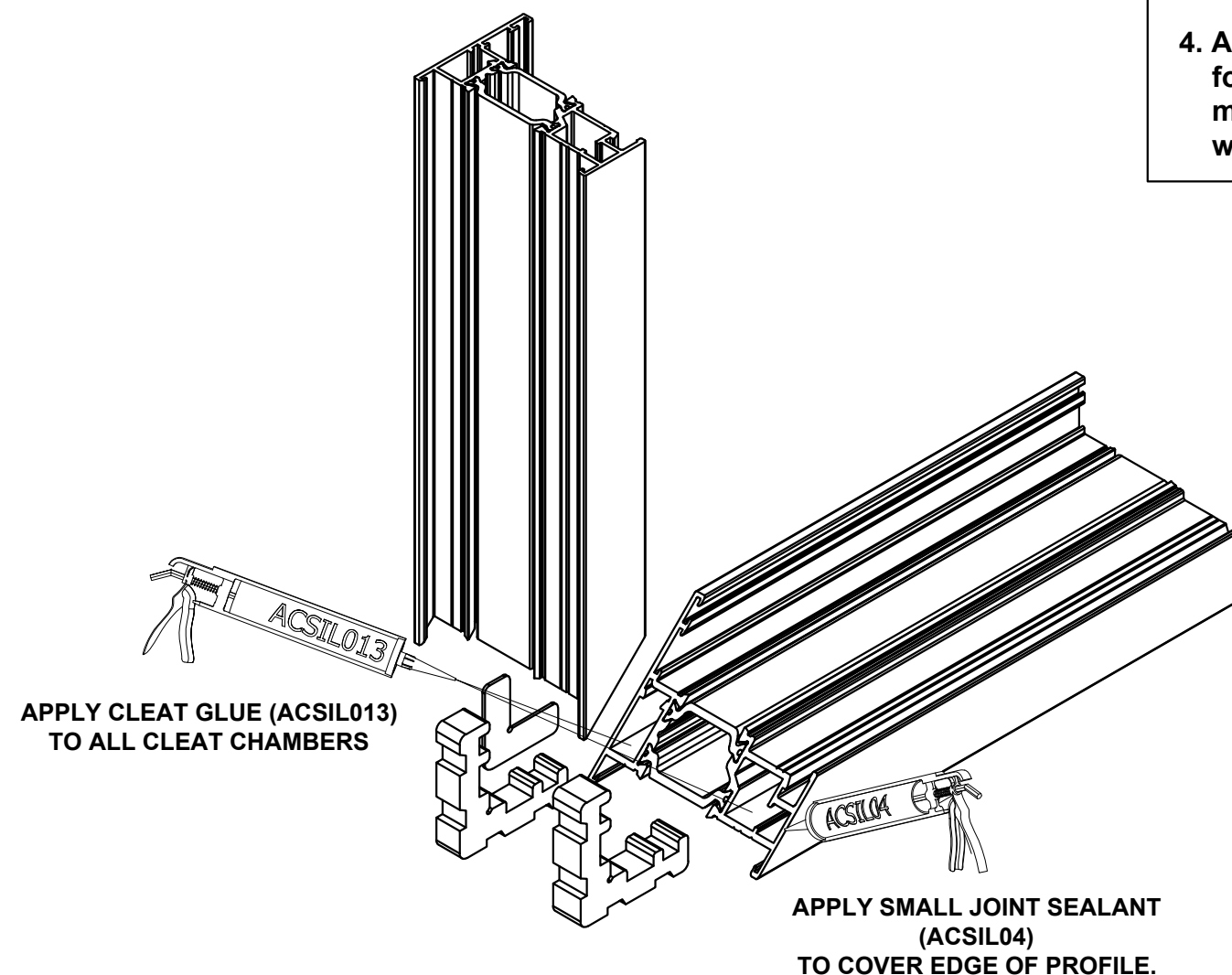
To ensure accurate corners, we recommend the use of support blocks (by others) whilst cutting. Do NOT clamp directly onto the polyamide.

Notes

1. Degrease mitre sections
2. Cover mitred faces with ACSIL04
3. Apply ACSIL013 to cleat chambers
4. Apply ACSIL04 to any fractures formed by crimping to and to mechanical blocks to make watertight

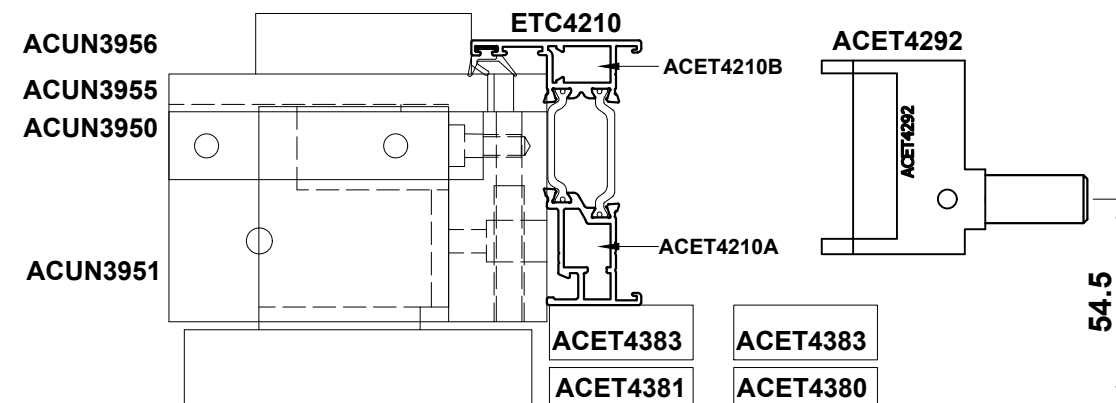
Table 1

KL Colour	Sealant Part Number
Black	ACSIL04BL
White	ACSIL04WP
Clear	ACSIL04CL
KL001	ACSIL04KL001
KL002	ACSIL04KL002
KL003	ACSIL04KL003
KL004	ACSIL04KL004
KL005	ACSIL04KL005
KL006	ACSIL04KL006
KL007	ACSIL04KL007
KL010	ACSIL04KL010
KL011	ACSIL04KL011
KL012	ACSIL04KL012
KL013	ACSIL04KL013

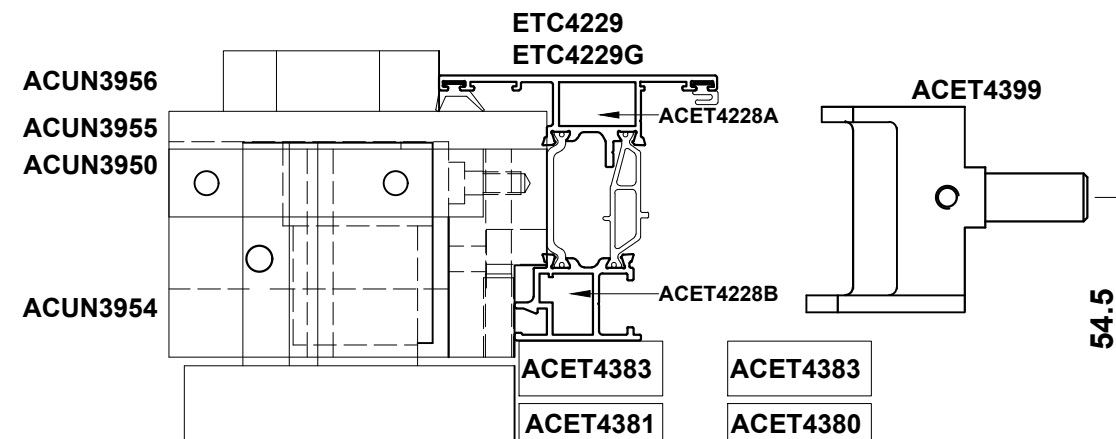


Do Not Scale From This Drawing

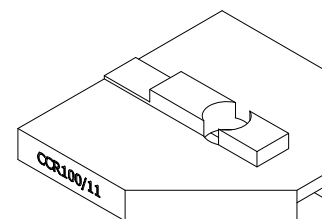
Corner Crimping



Hand crimper ACET4381 set 26.5mm
Power crimper ACET4380 set 36.5mm

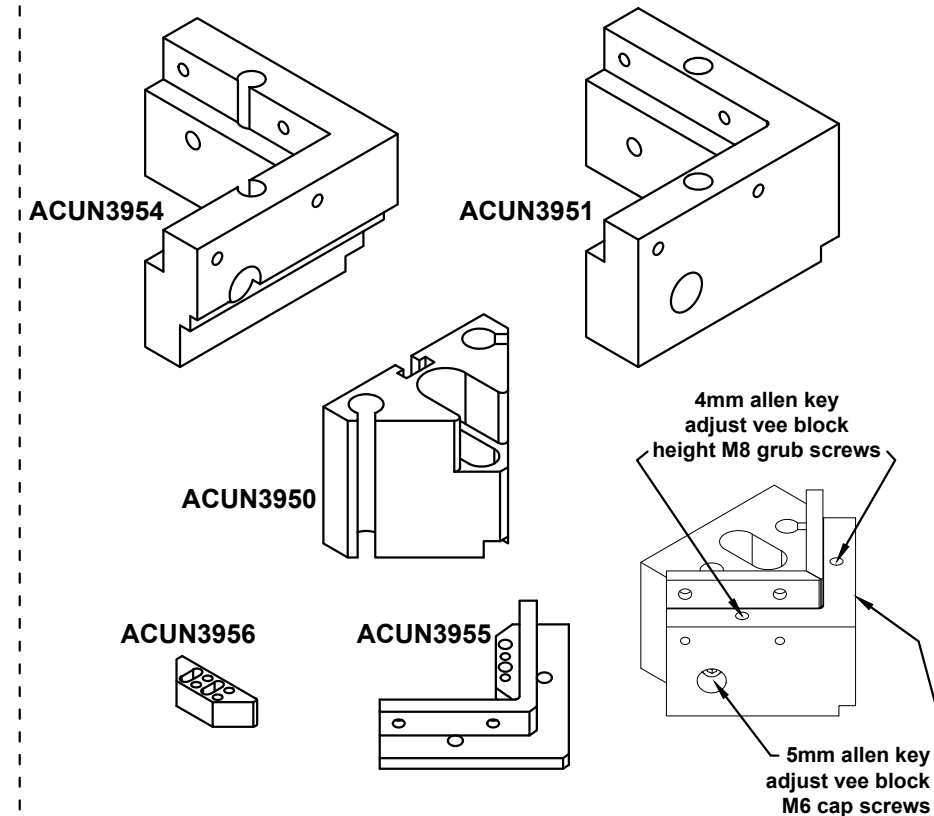


Hand crimper ACET4381 set 26.5mm
Power crimper ACET4380 set 36.5mm

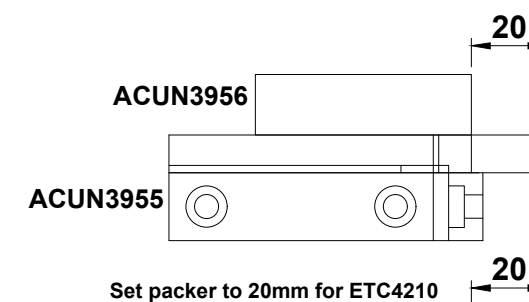
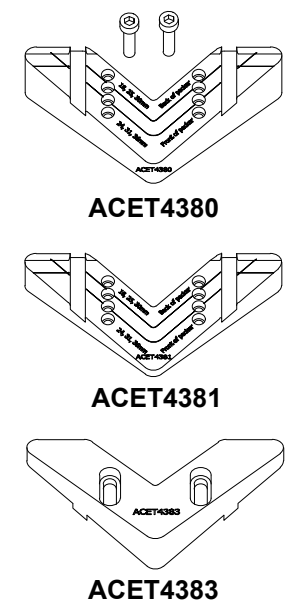


Power crimper use 10mm packer ACCR100/11

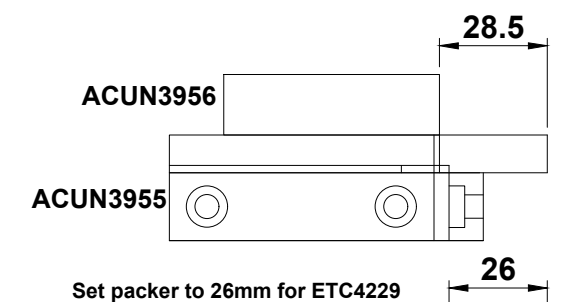
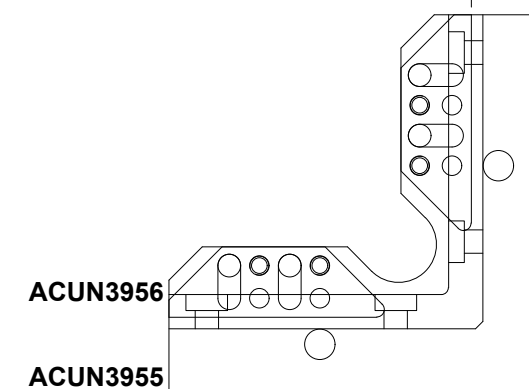
Adjustable Vee Block



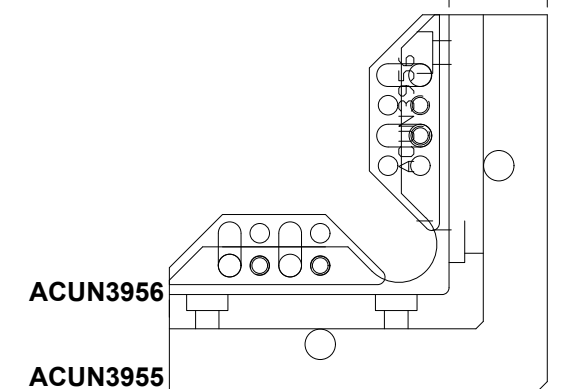
Section Packers



Set packer to 20mm for ETC4210

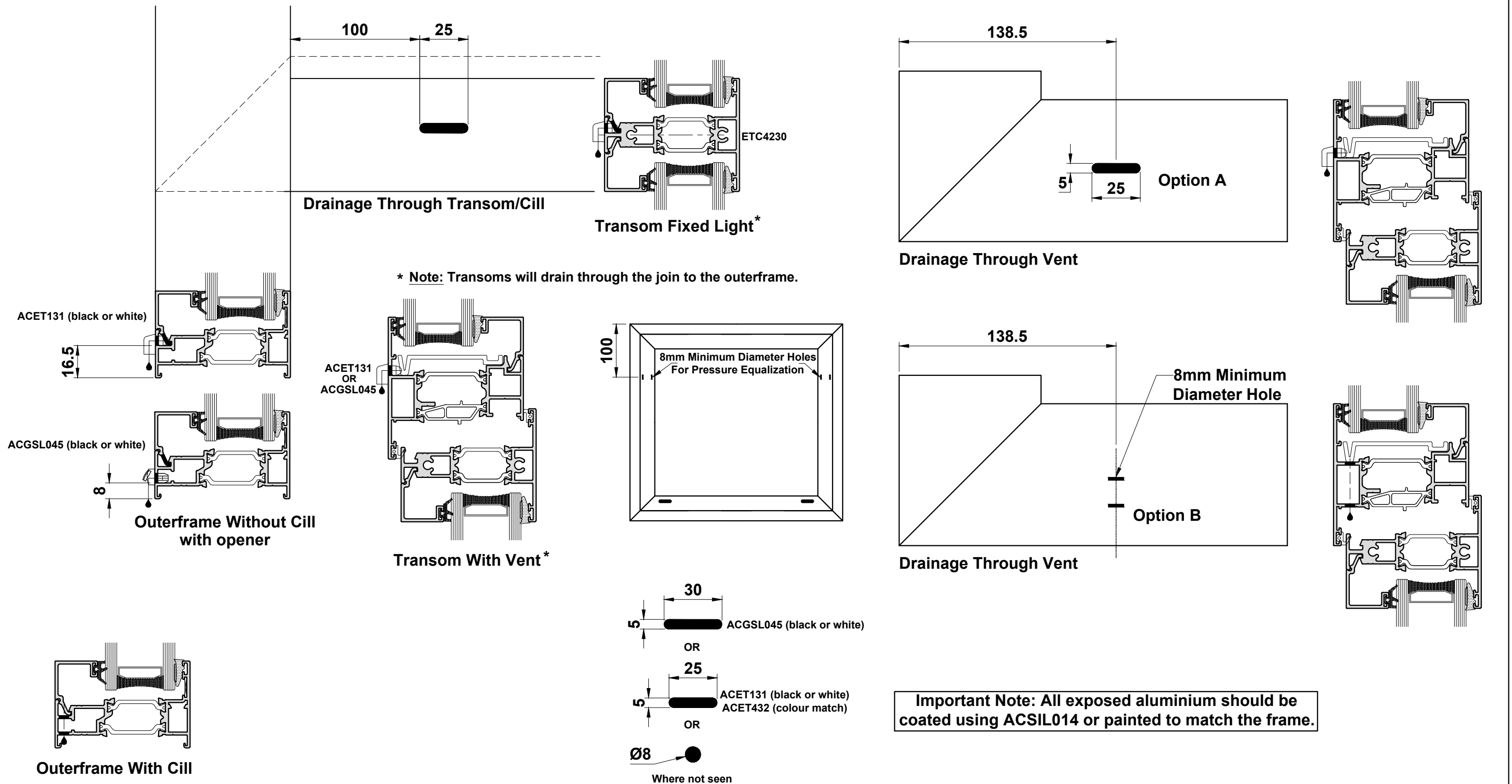


Set packer to 26mm for ETC4229



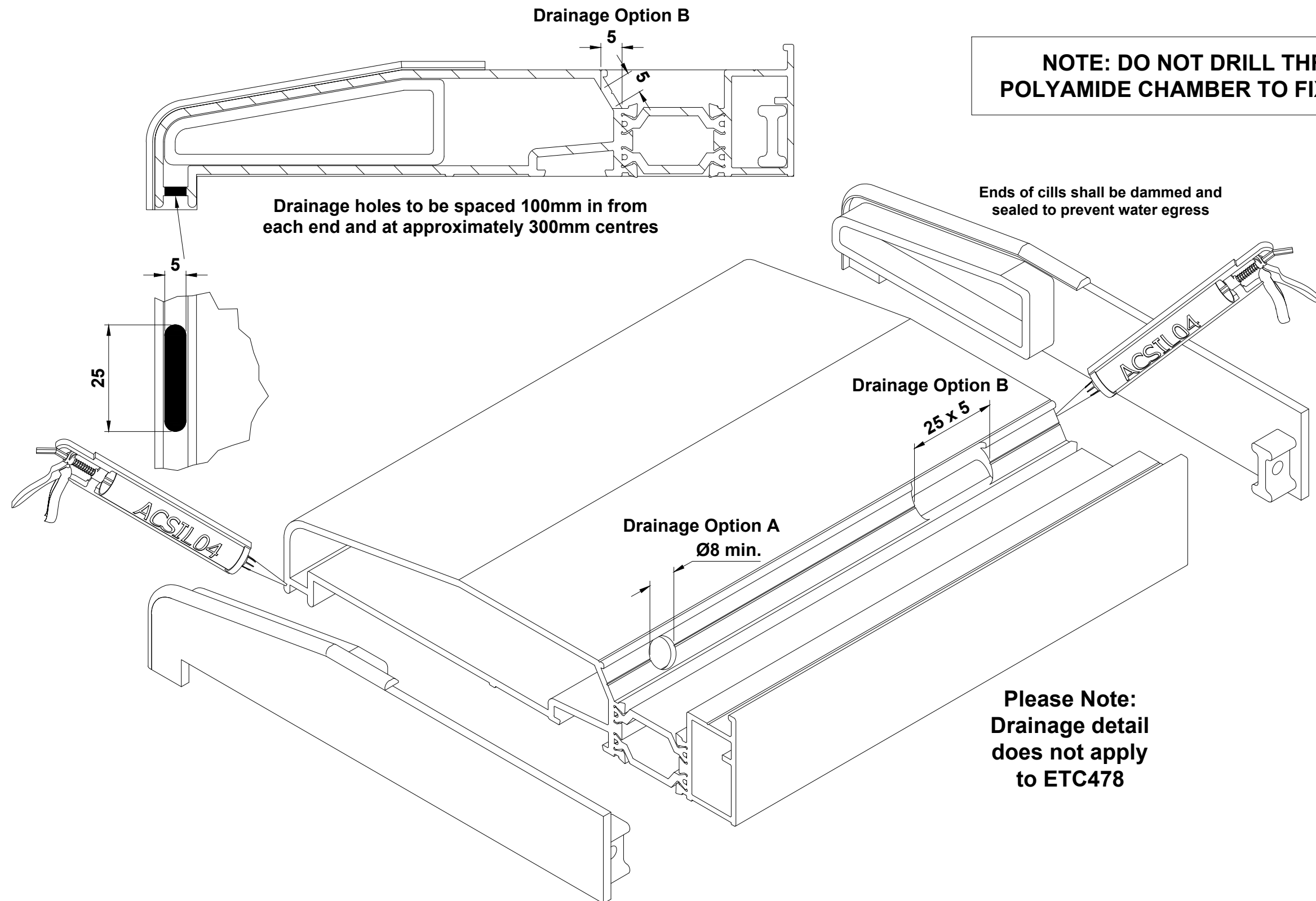
Do Not Scale From This Drawing

Drainage



Do Not Scale From This Drawing

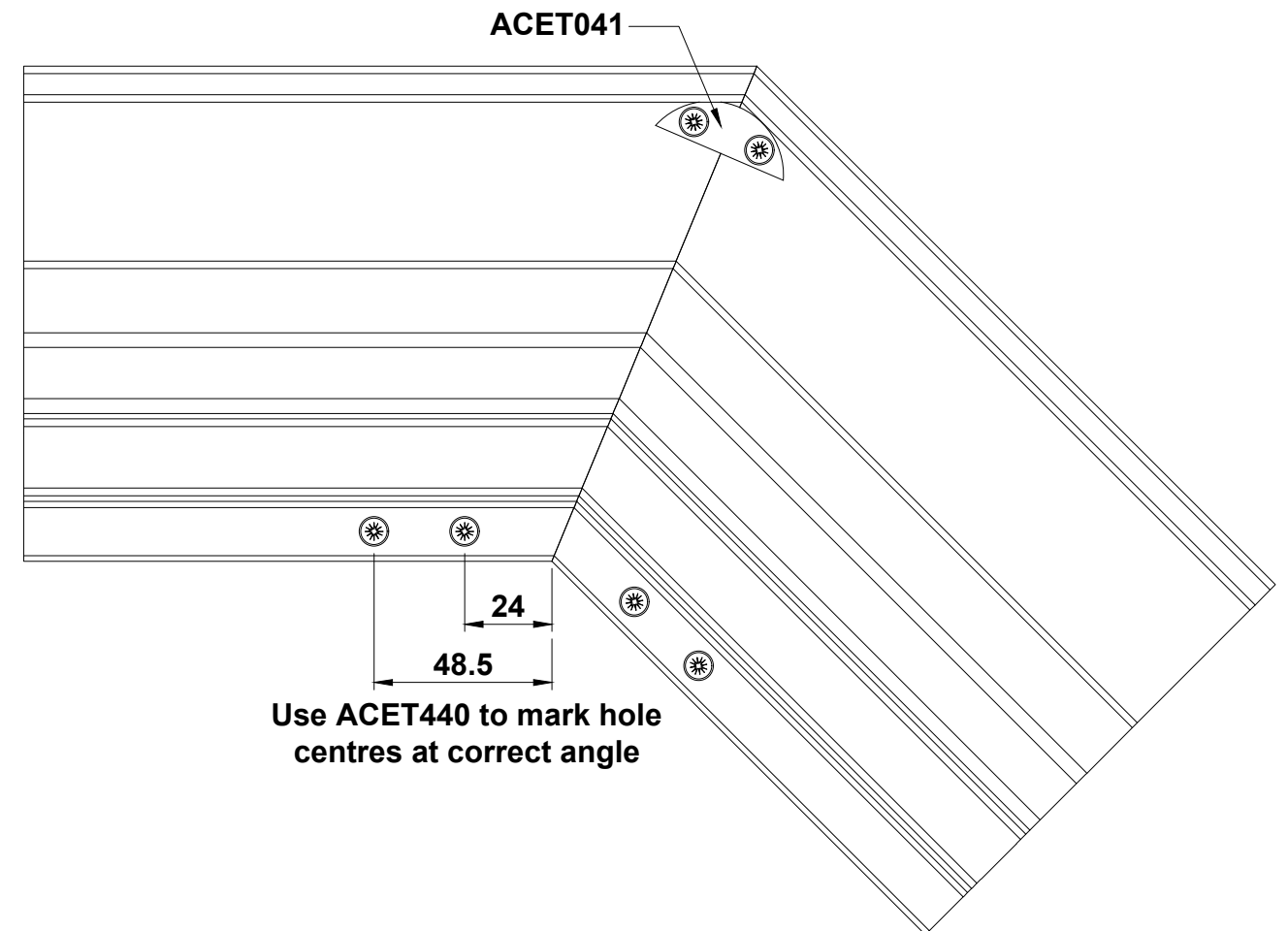
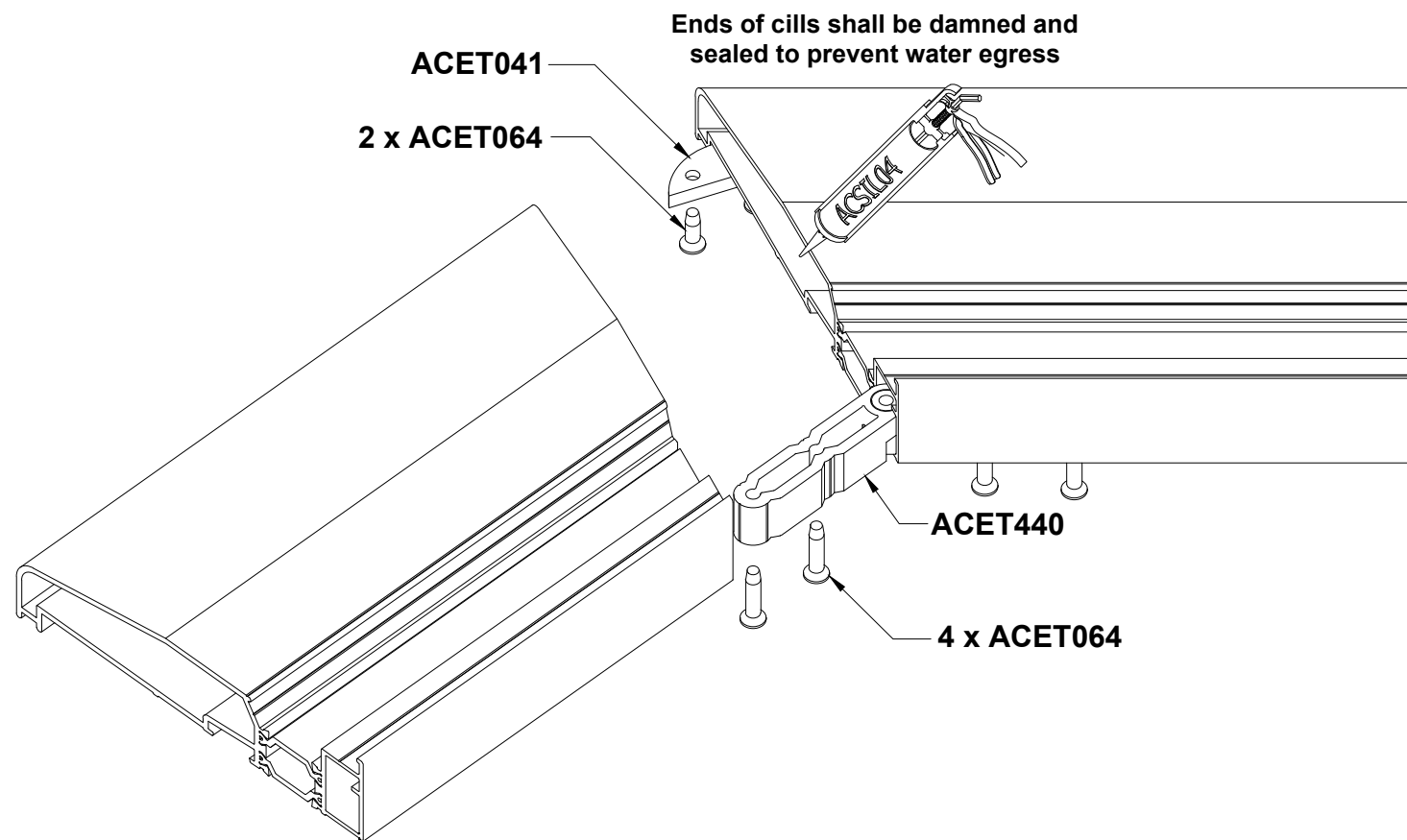
Sub Cill Drainage



Do Not Scale From This Drawing

Angled Sub Cill

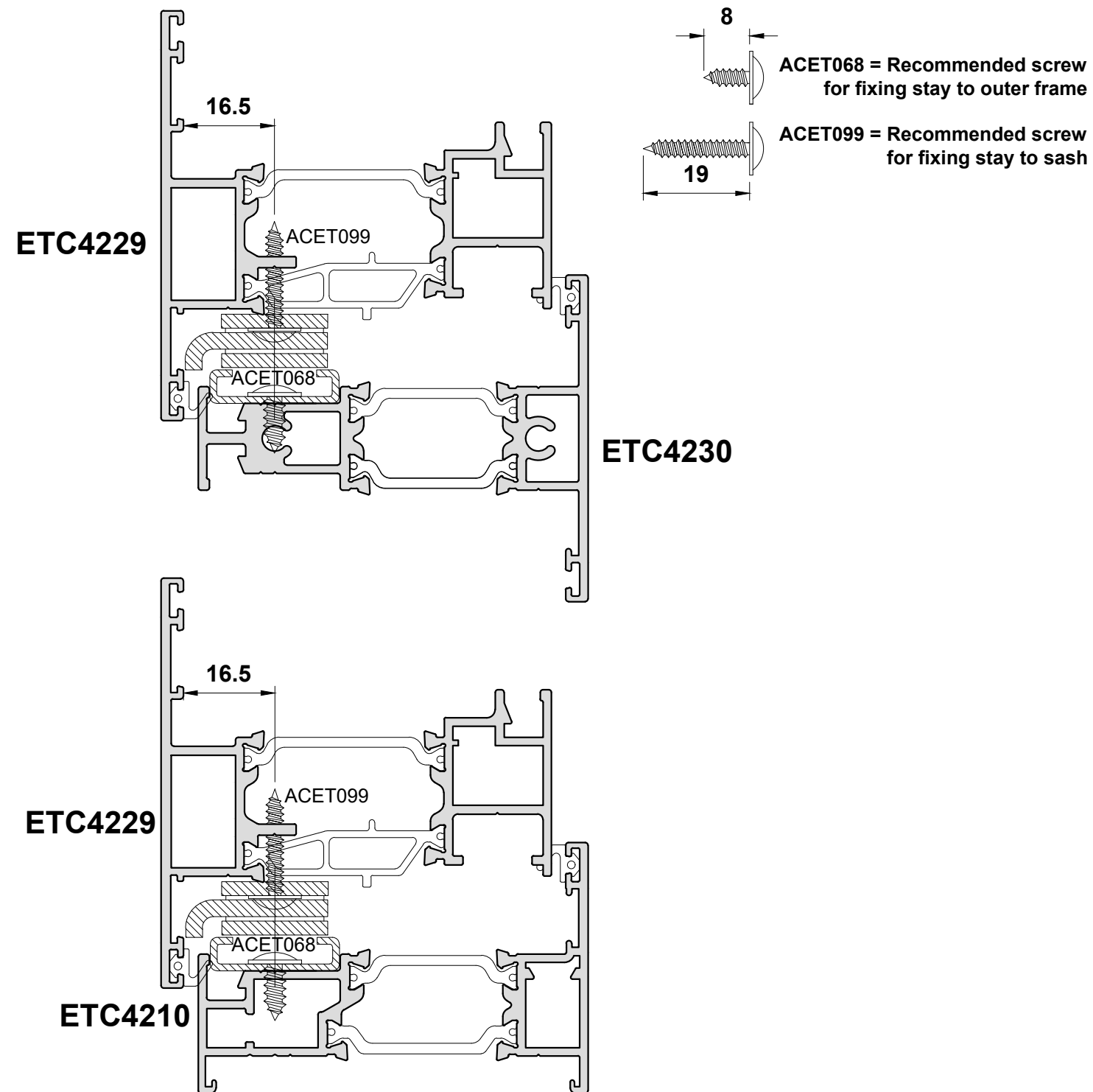
**NOTE: DO NOT DRILL THROUGH
POLYAMIDE CHAMBER TO FIX THE CILL**



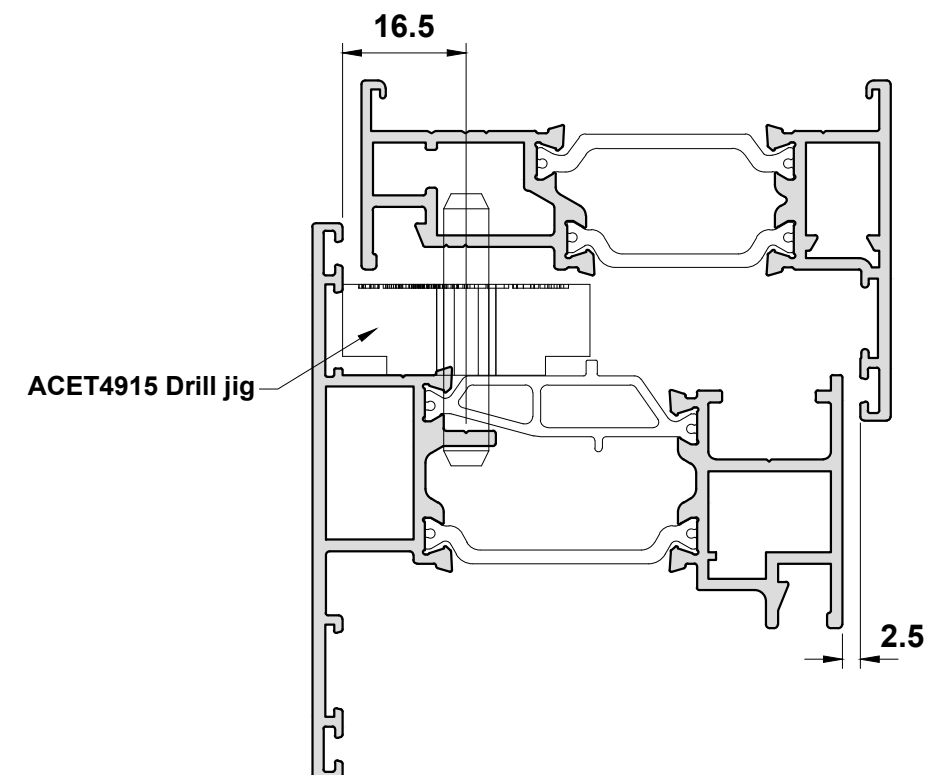
Do Not Scale From This Drawing

Friction Stay

Heavy Duty (Sterling) Stays

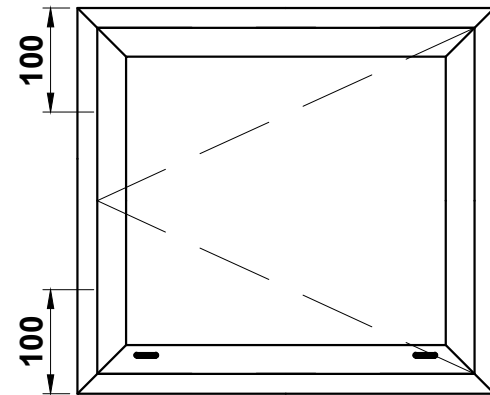


Hinge Code Top Hung	Hinge Length (mm)	Max Vent Weight (kg)	Min Vent Height (mm)	Max Vent Height (mm)	Opening Angle (+/-2.5°)
ACINS10	262	40	315	640	50
ACINS12	313	50	640	800	50
ACINS16	415	65	800	1100	50
ACINS22	567	100	1090	1500	45
ACINS22W	567	100	1500	2000	20
ACINS26	680	180	2000	2500	20
Side Hung	Hinge Length (mm)	Max Vent Weight (kg)	Min Vent Width (mm)	Max Vent Width (mm)	Opening Angle (+/-2.5°)
ACINSSH10	262	38	327	660	85
ACINSSH16	415	55	450	838	60



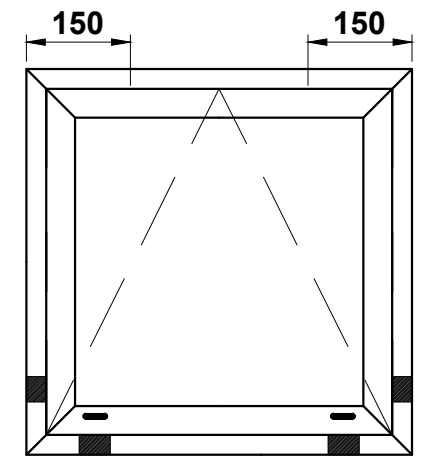
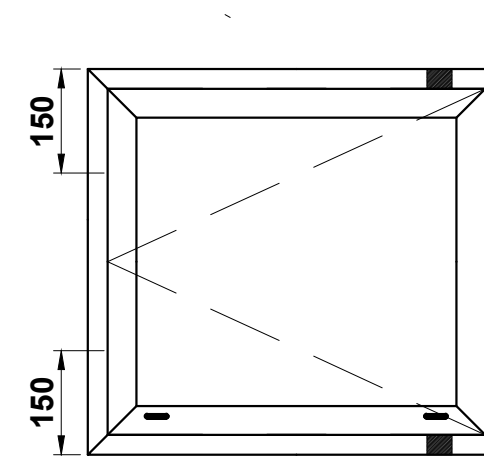
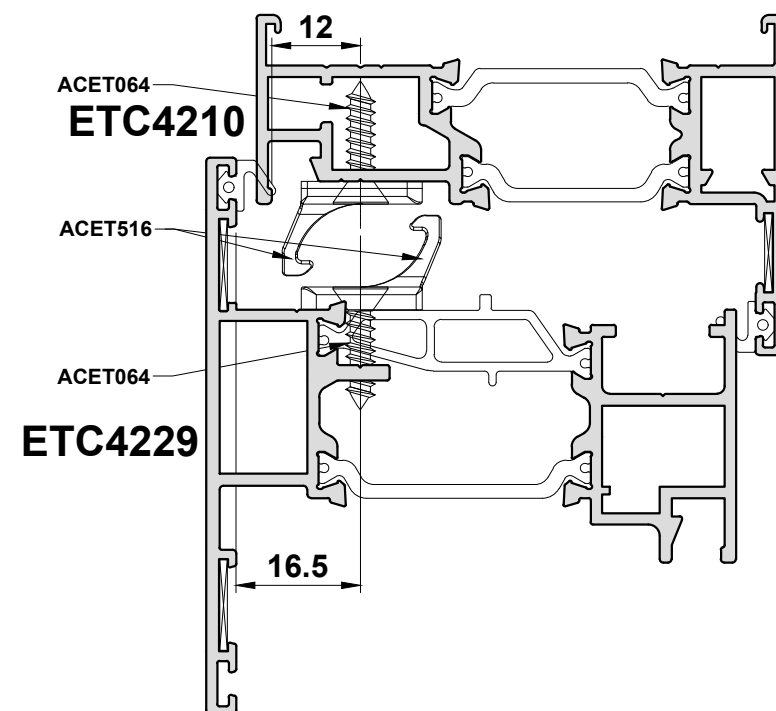
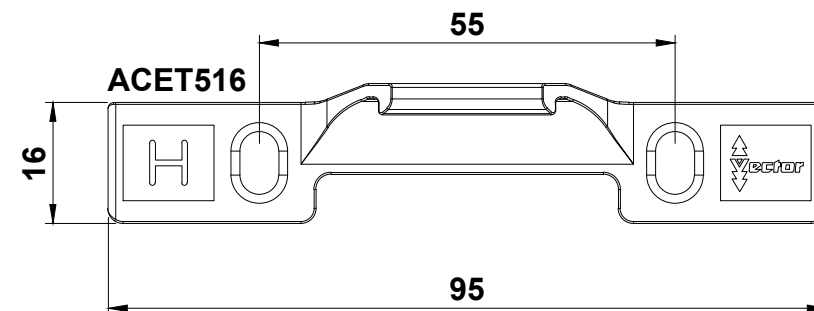
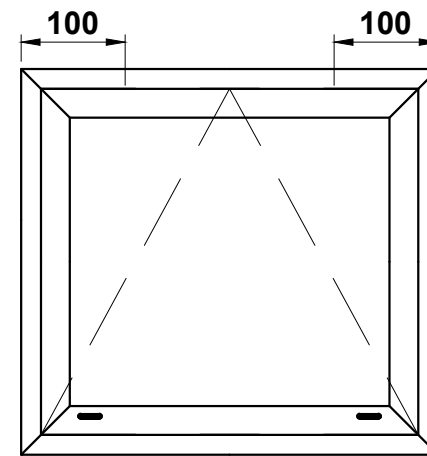
Do Not Scale From This Drawing

Friction Stay Accessories



Please Note:

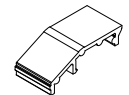
- 2 pairs per opening vent to be fitted to hinged side of window
- Each pair must be fitted with the hook centre within 100mm of each hinge



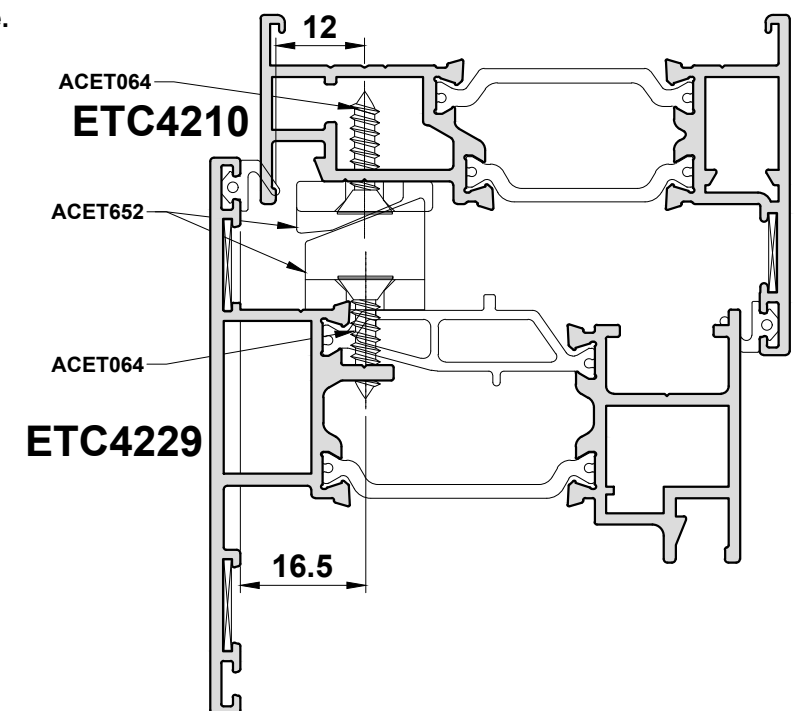
Please Note:

- 2 pairs per opening vent to be fitted to hinged side of window
- Each pair must be fitted with the wedge centre within 150mm of each hinge and in the centre of the window when sash height or width is greater than 800mm.
- When used with ACET516 and security takes priority, install ACET652 centre within 200mm of hinge.

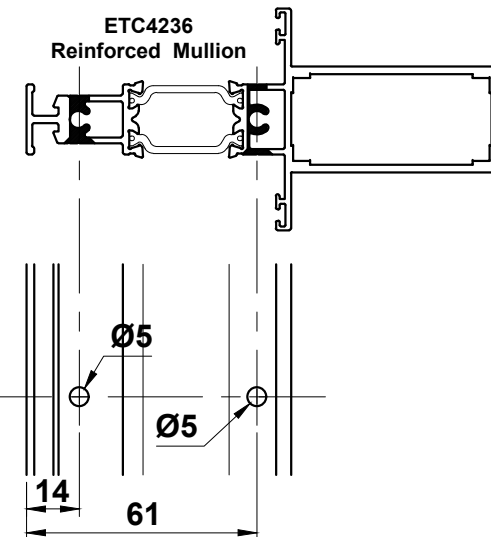
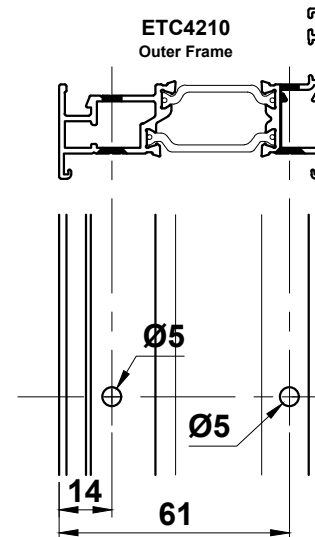
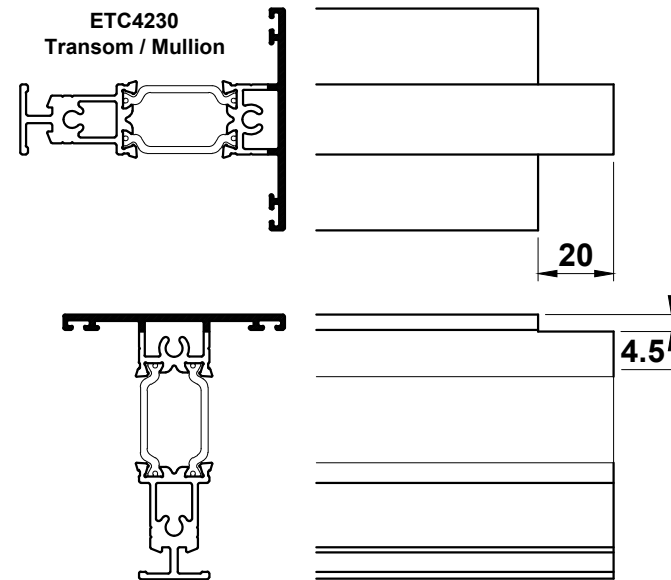
ACET4285



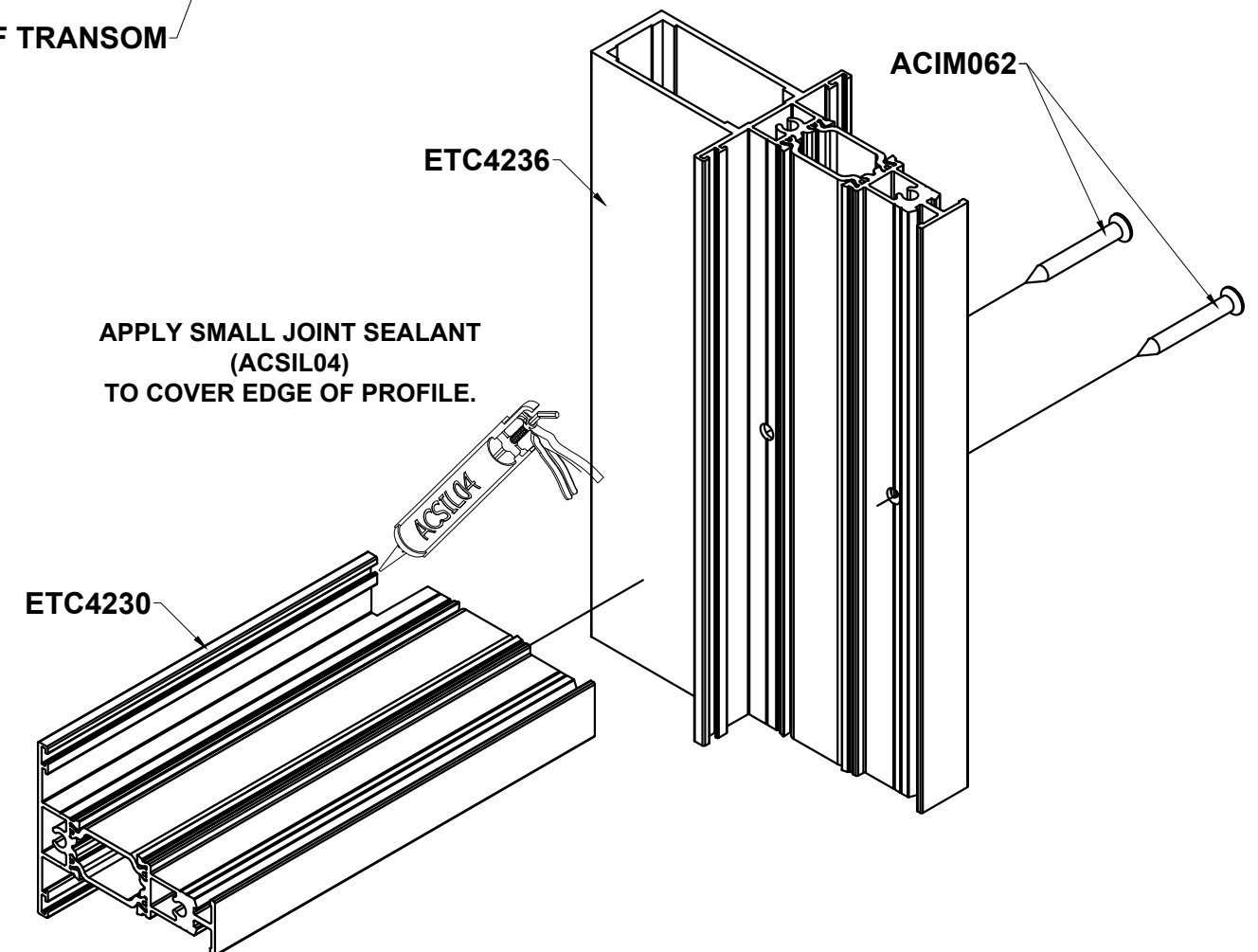
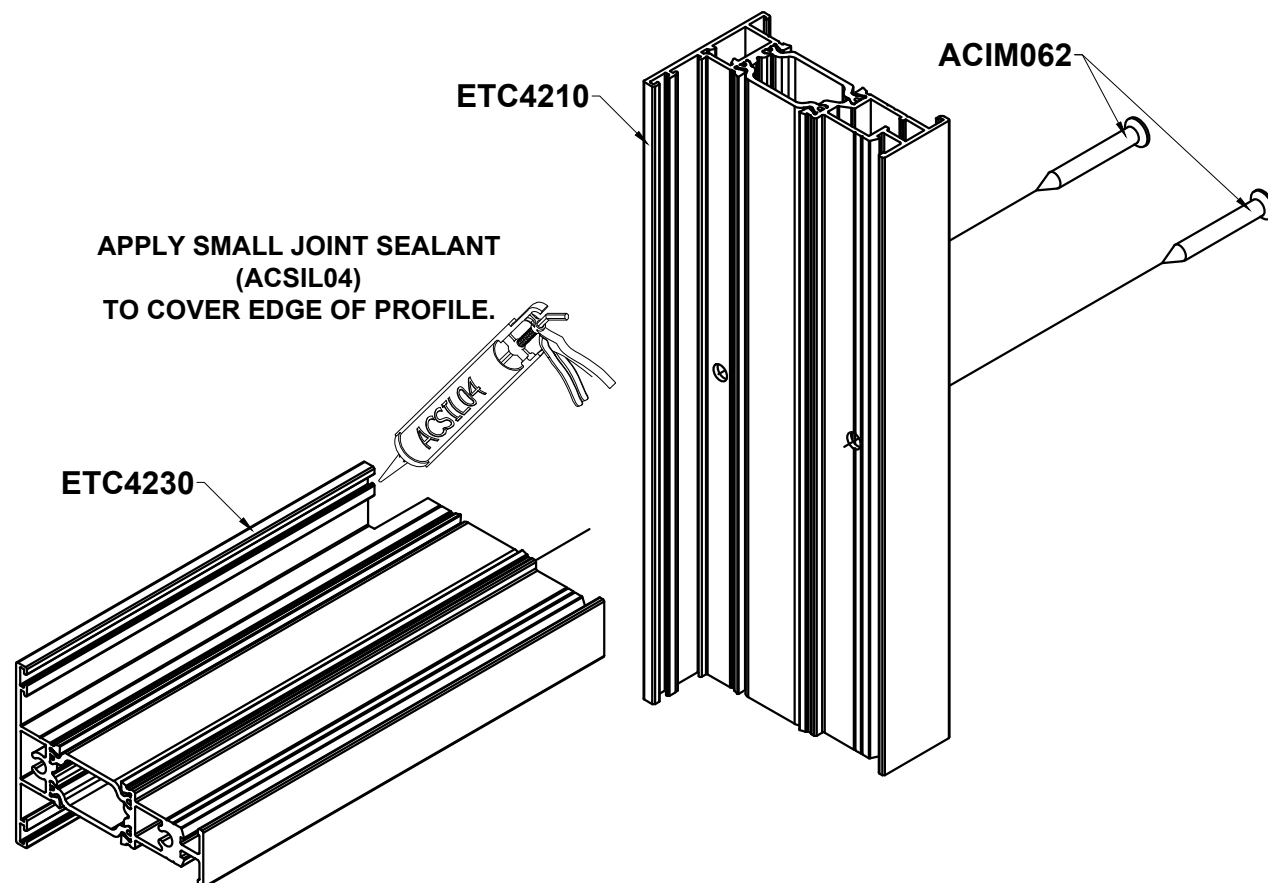
Please note that for fitting each sash, we recommend using 4 x ACET4285, as shown in the images above.



Transom Details

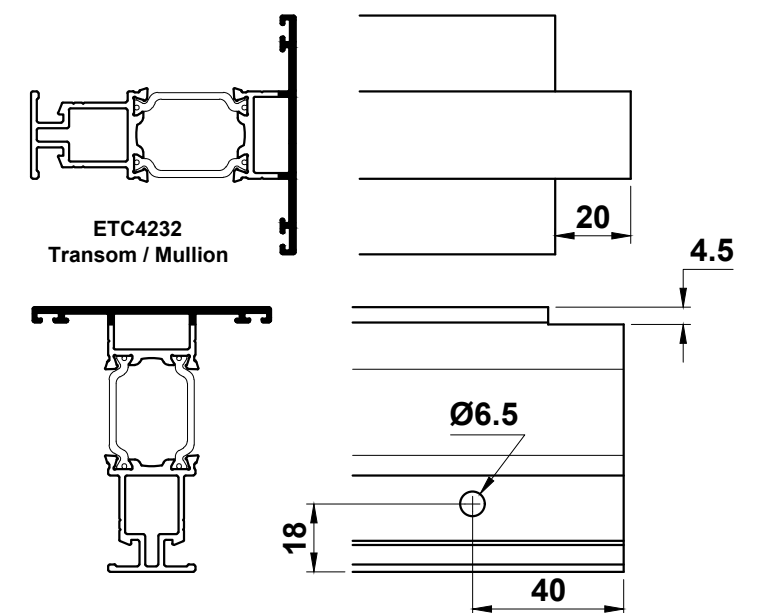
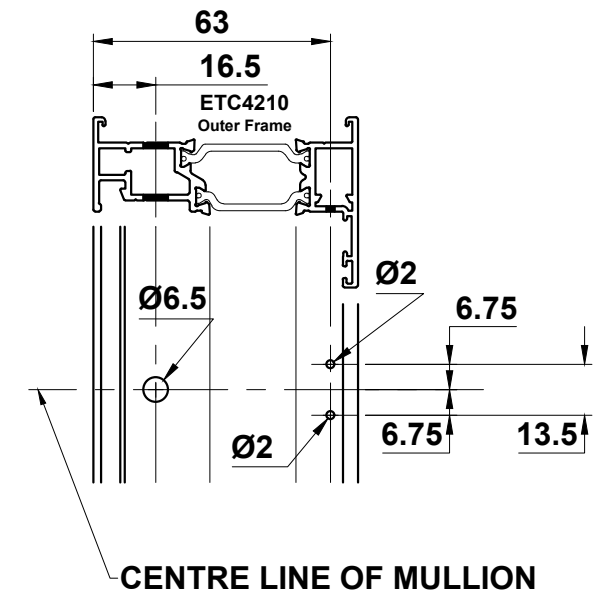
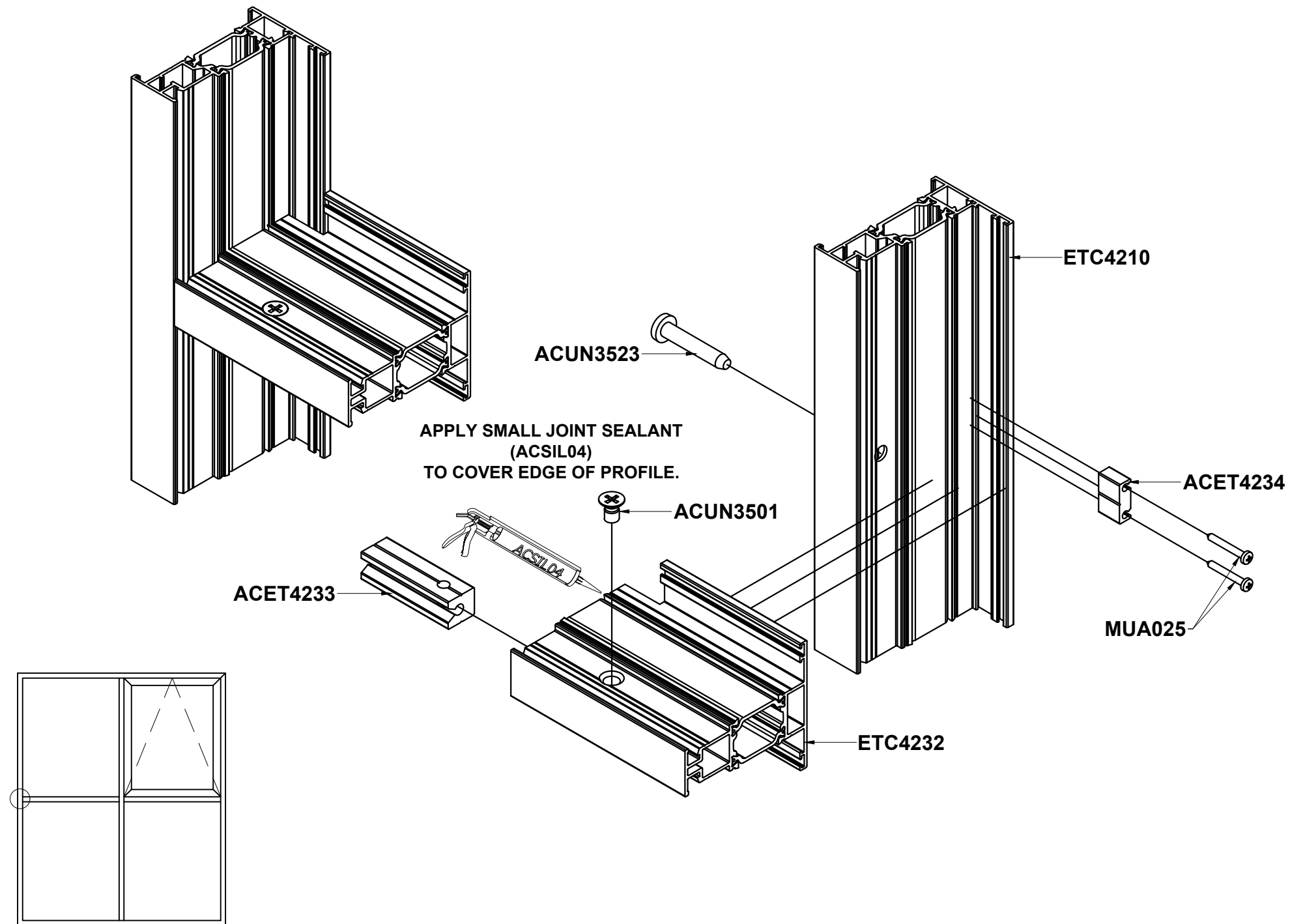


CENTRE LINE OF TRANSOM



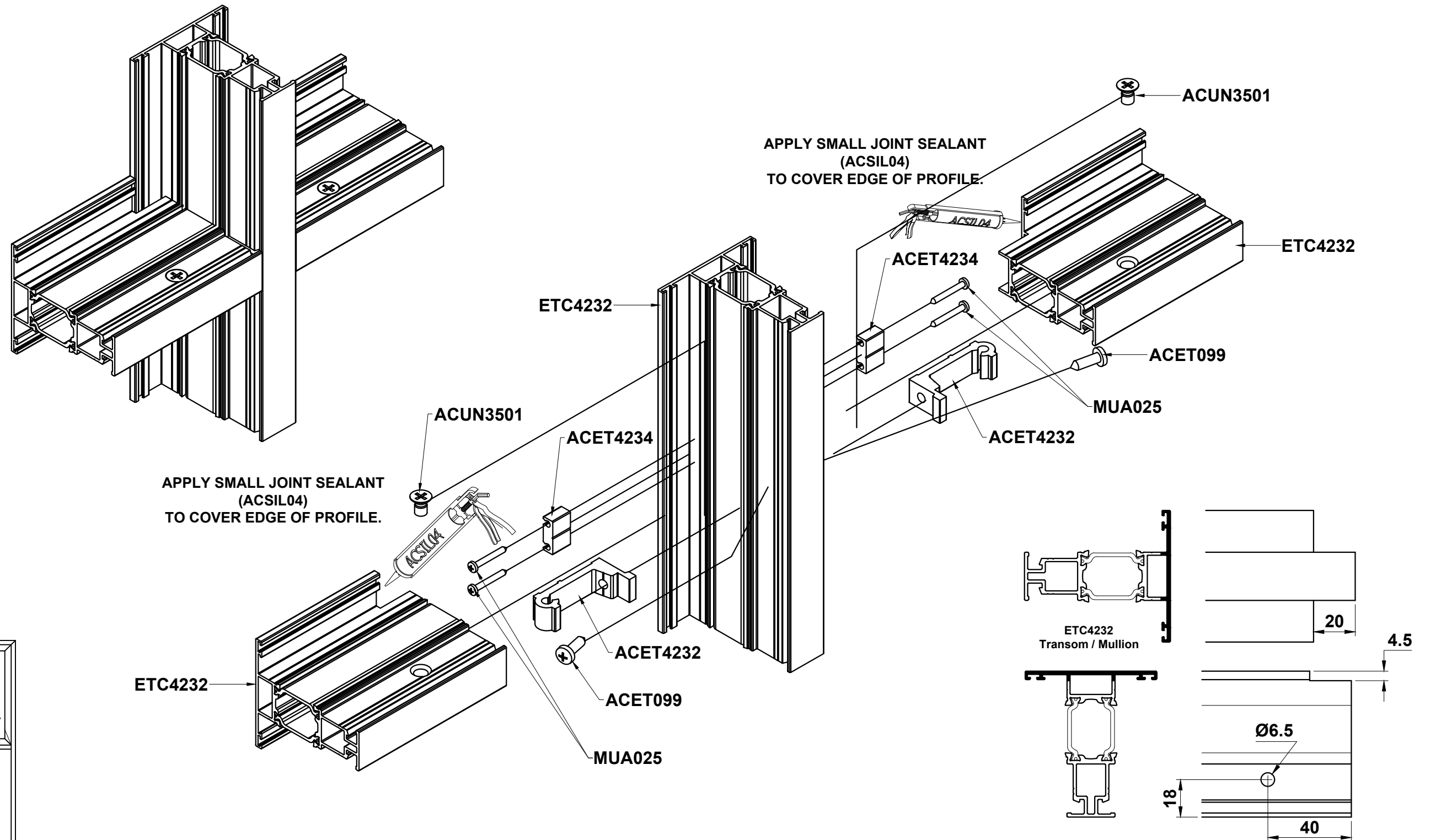
Do Not Scale From This Drawing

Transom Details



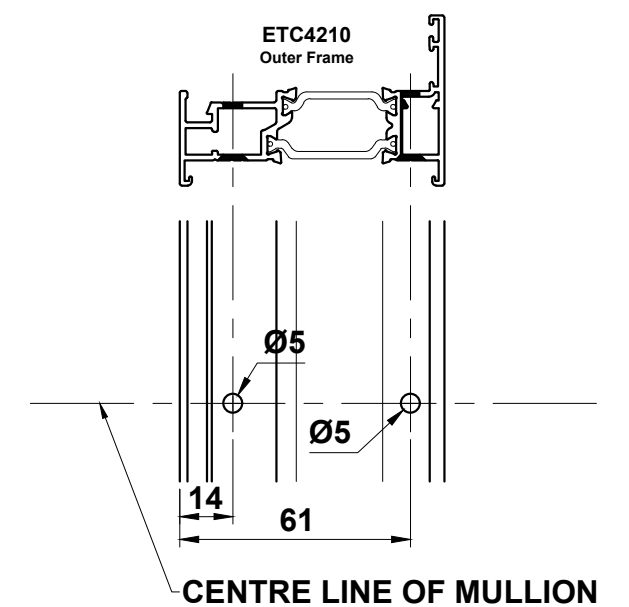
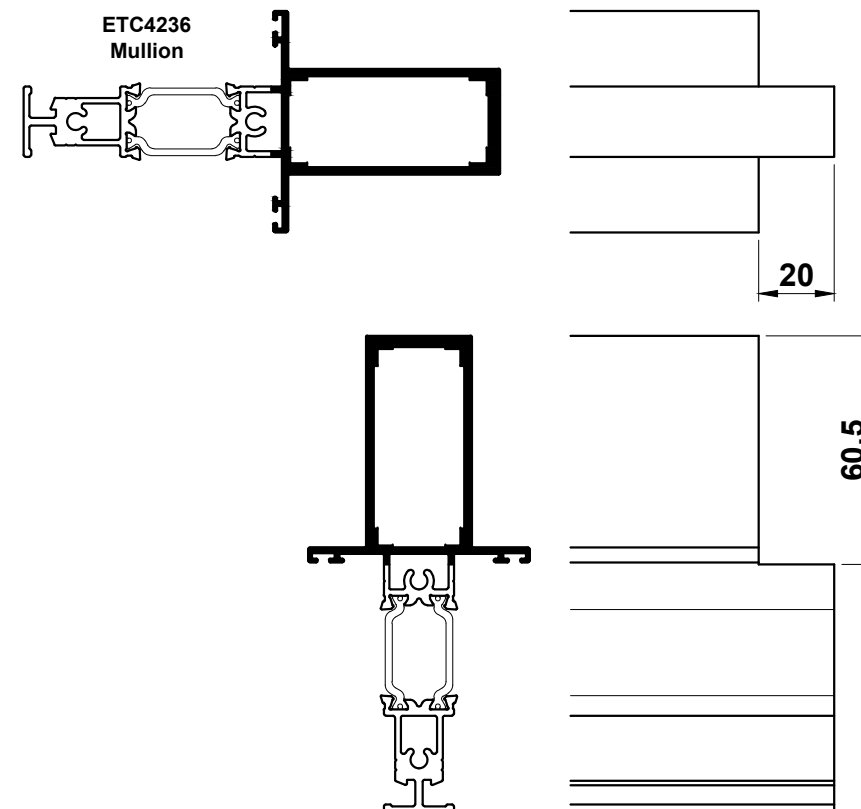
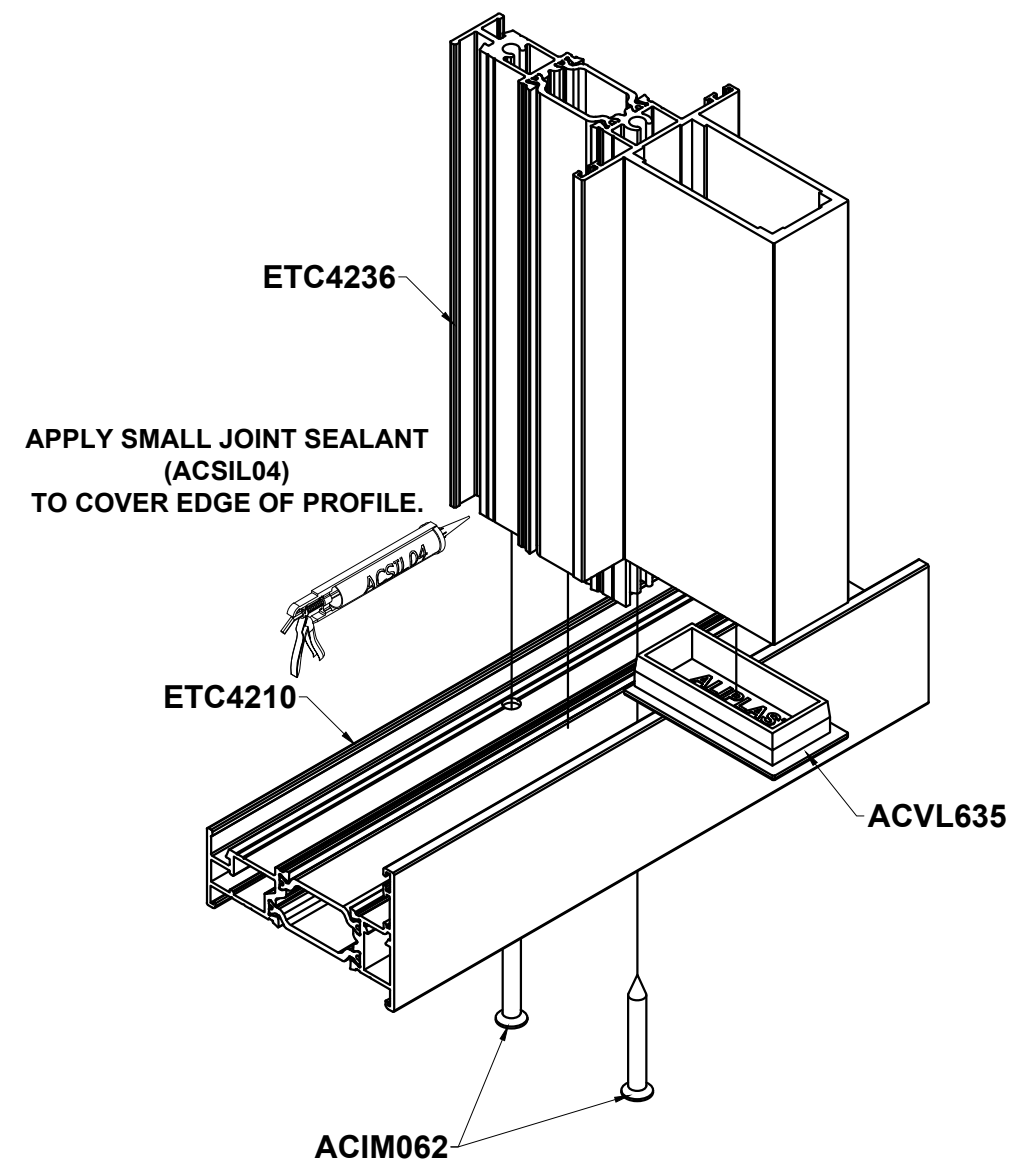
Do Not Scale From This Drawing

Crucifix Joint



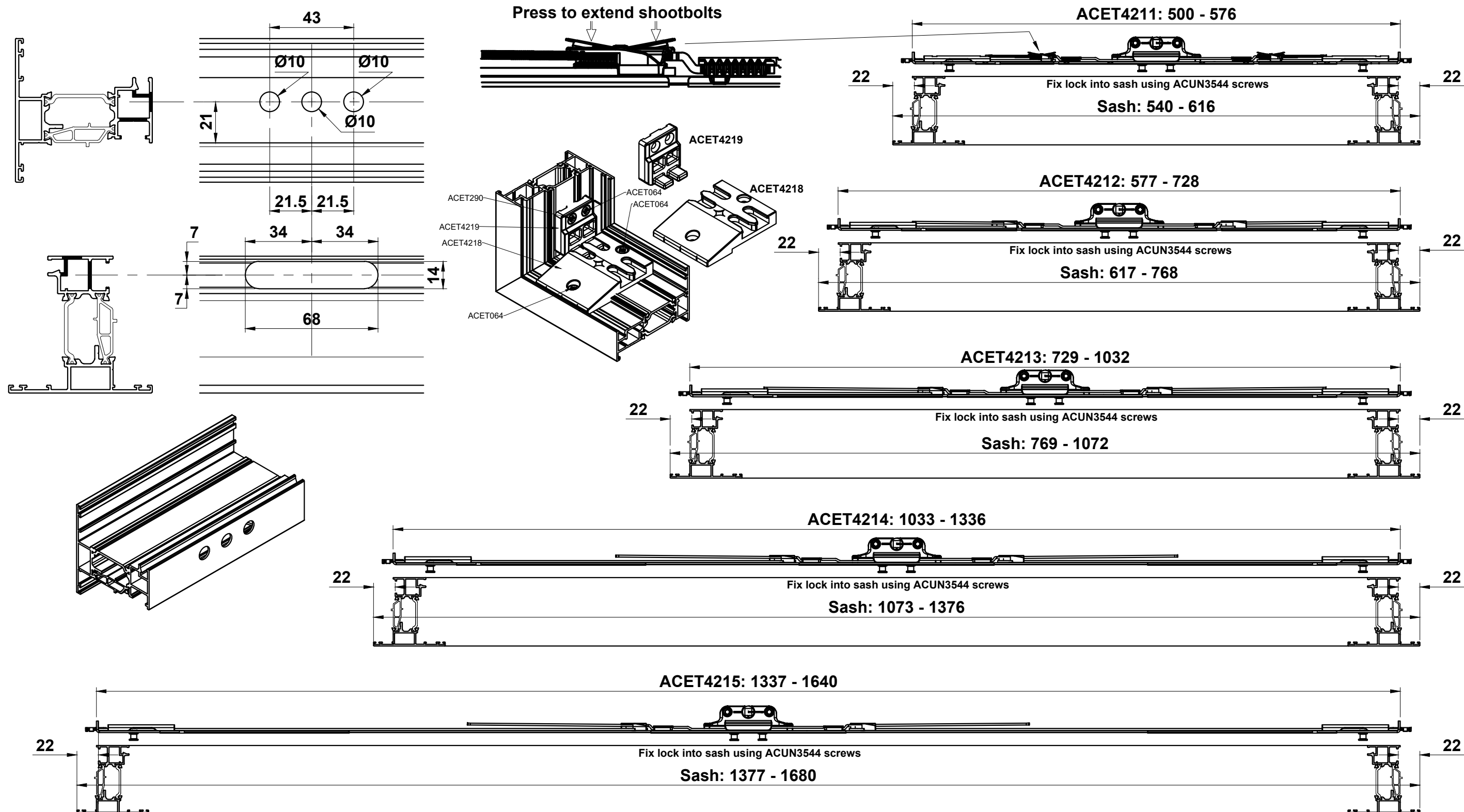
Do Not Scale From This Drawing

Mullion Details



Do Not Scale From This Drawing

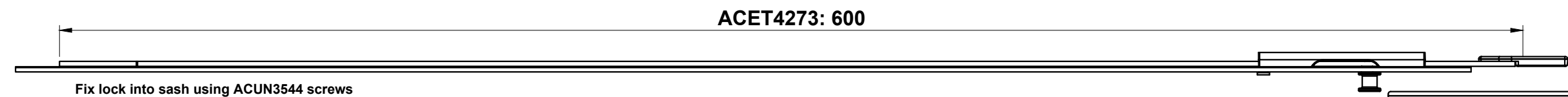
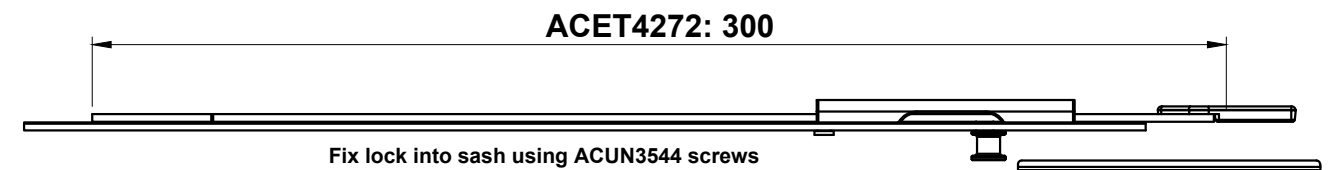
Telescopic Lock Details



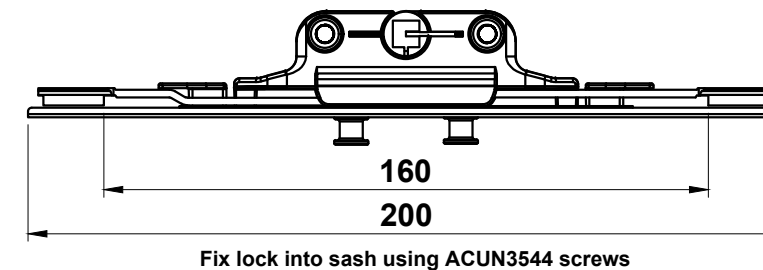
Do Not Scale From This Drawing

Croppable Lock Details

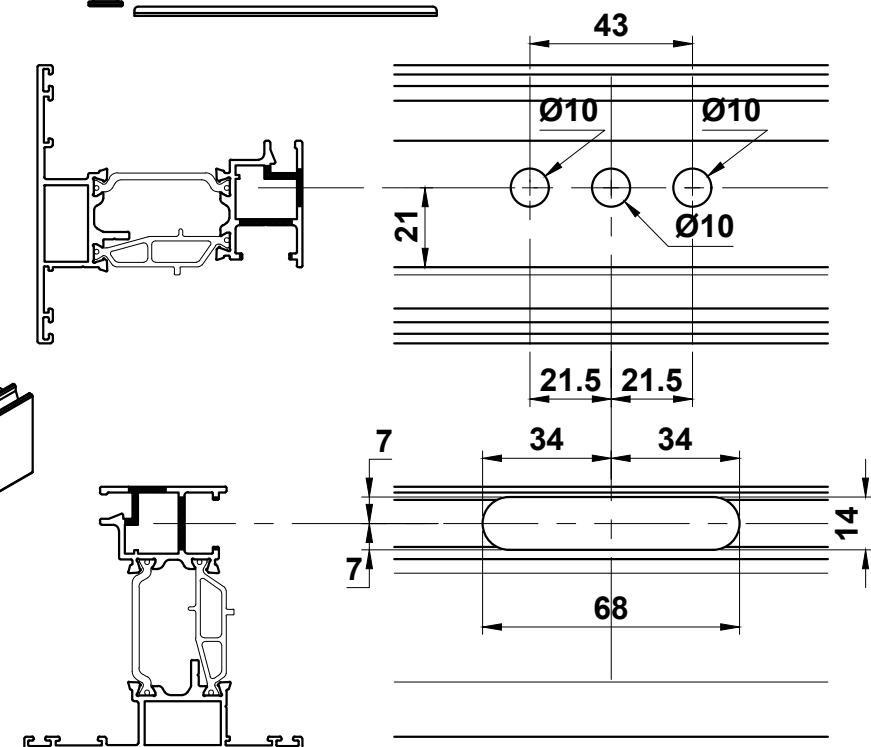
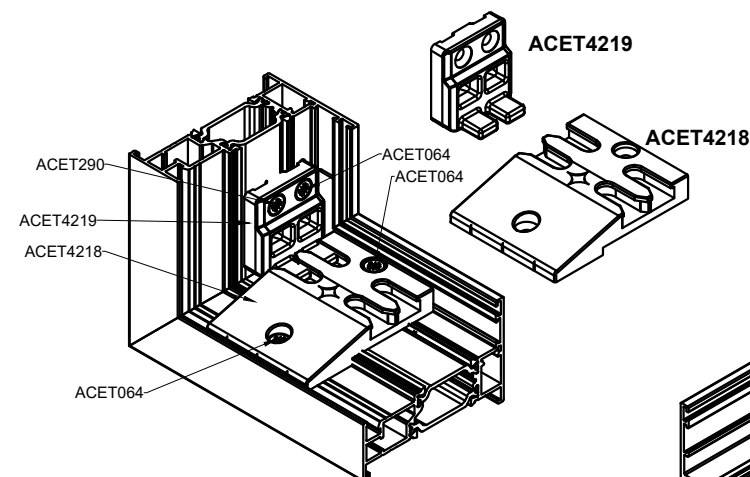
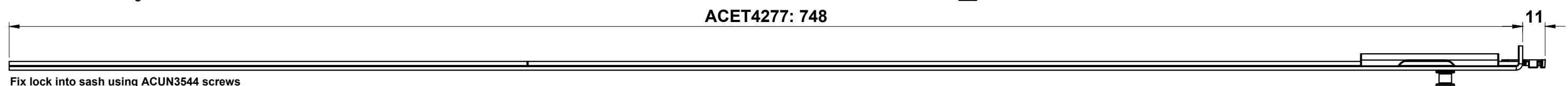
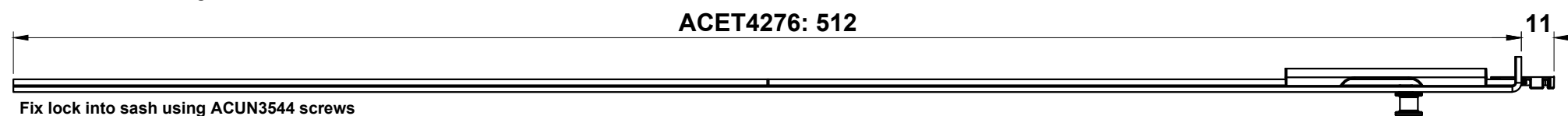
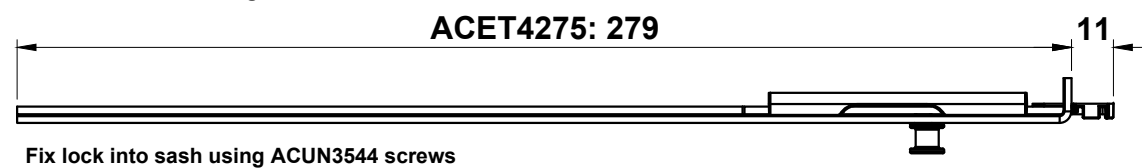
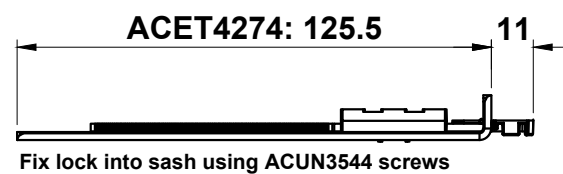
Extension rods with additional locking mushroom



ACET4271 Drive Gear

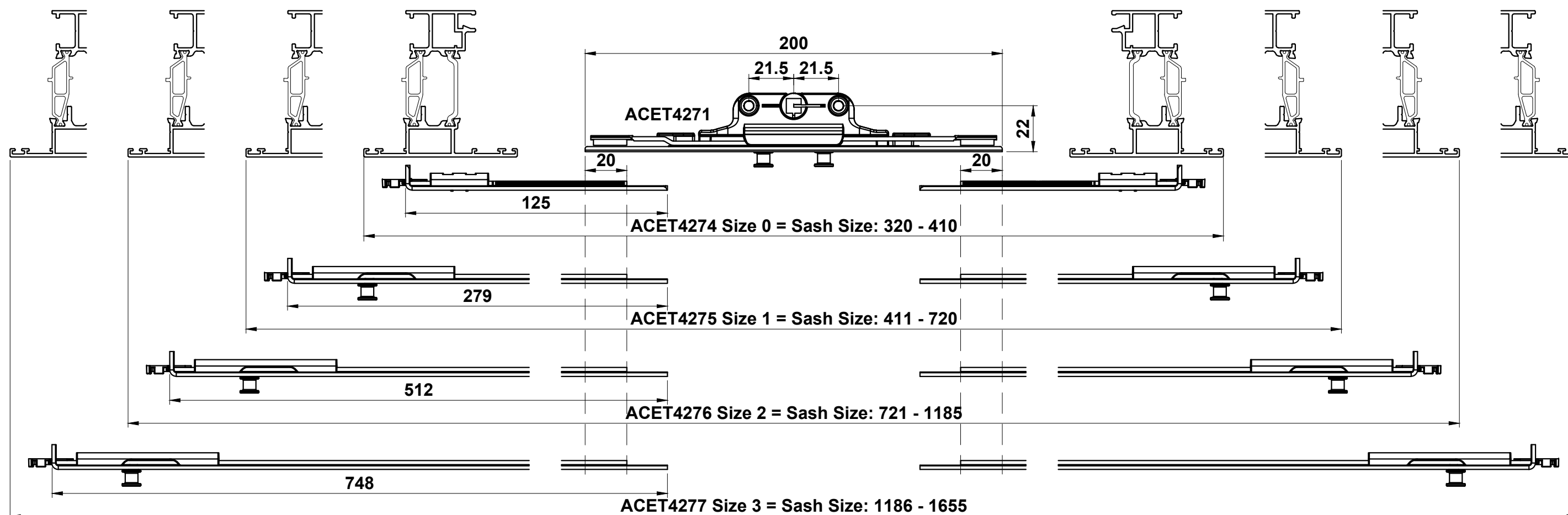


Locking rods



Do Not Scale From This Drawing

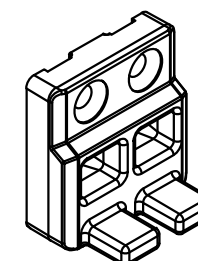
Croppable Lock Selection



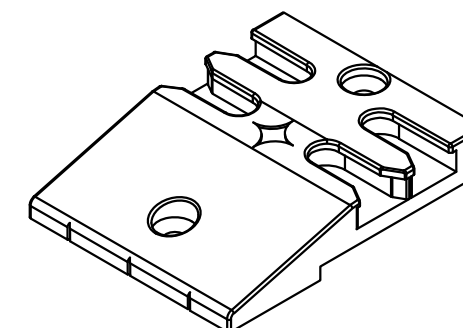
Notes:

- Sash sizes can be increased by 300mm with ACET4272, or by 600mm using ACET4273. Both require an additional ACET4218 keep per locking extension
- The sizes shown are based on a central handle position.
- Handles may be fitted off-centre if required.

ACET4219

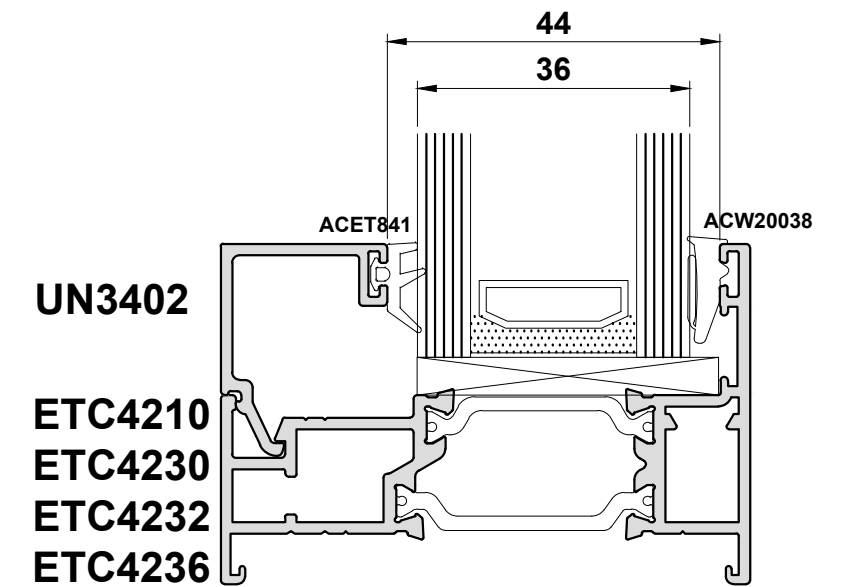
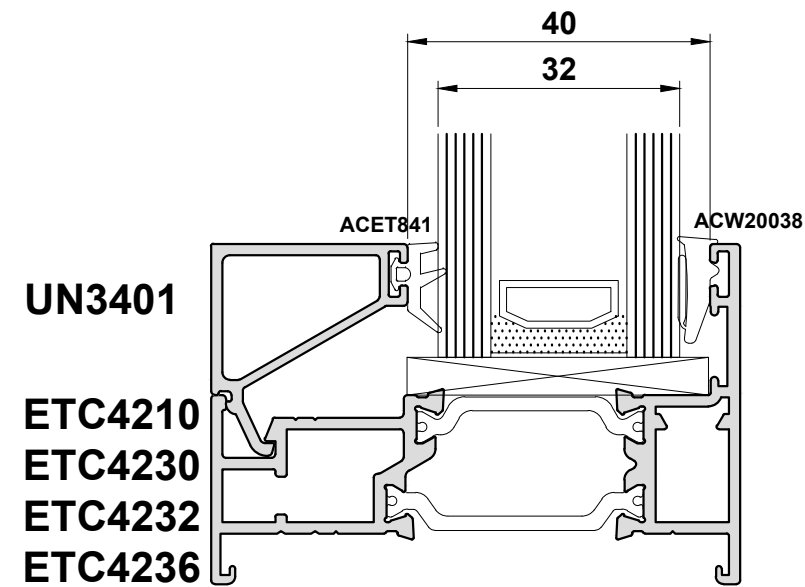
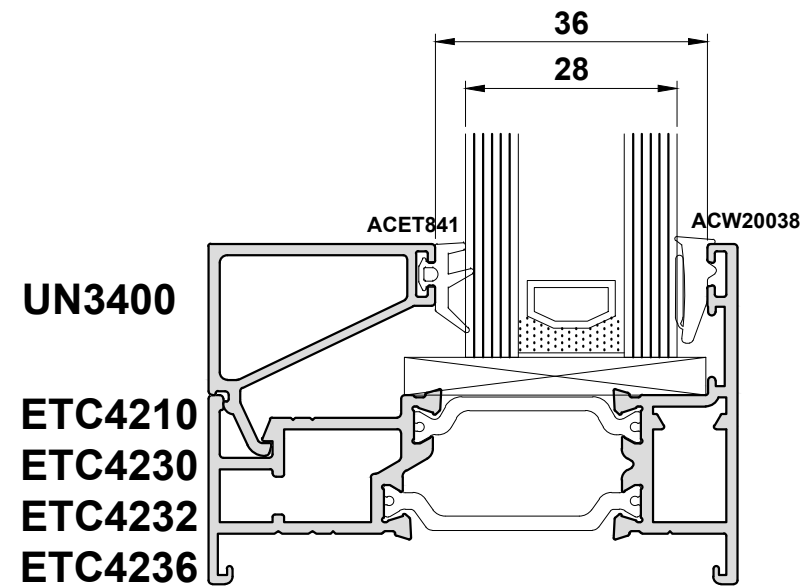


ACET4218



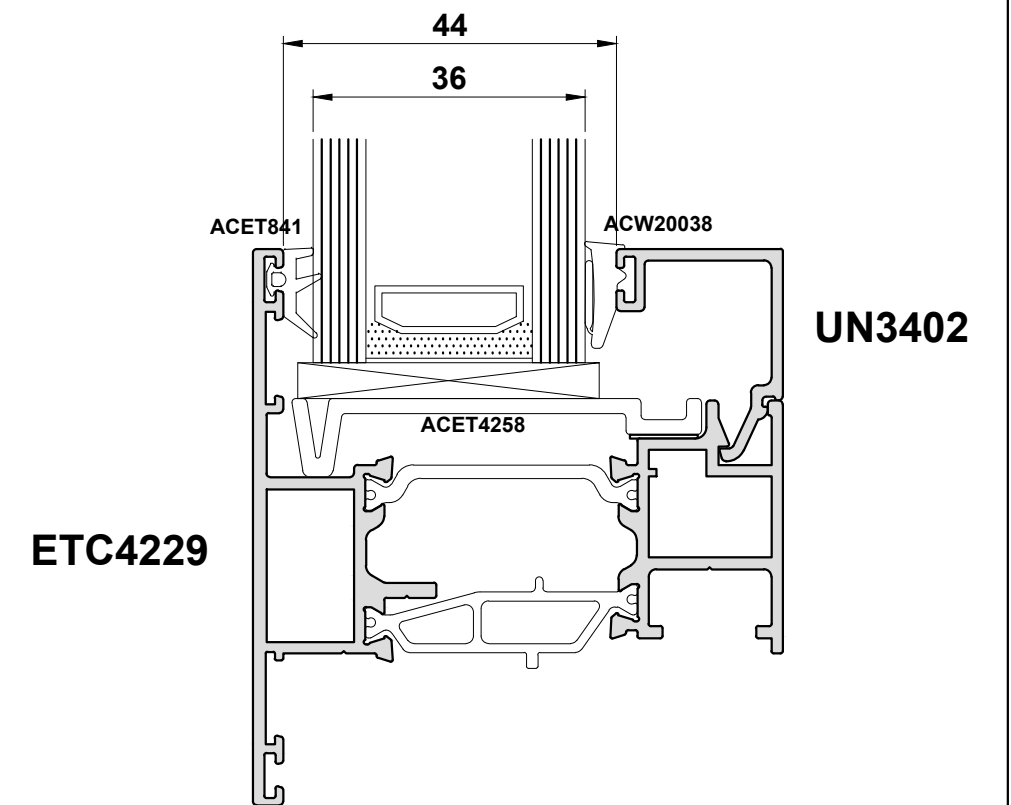
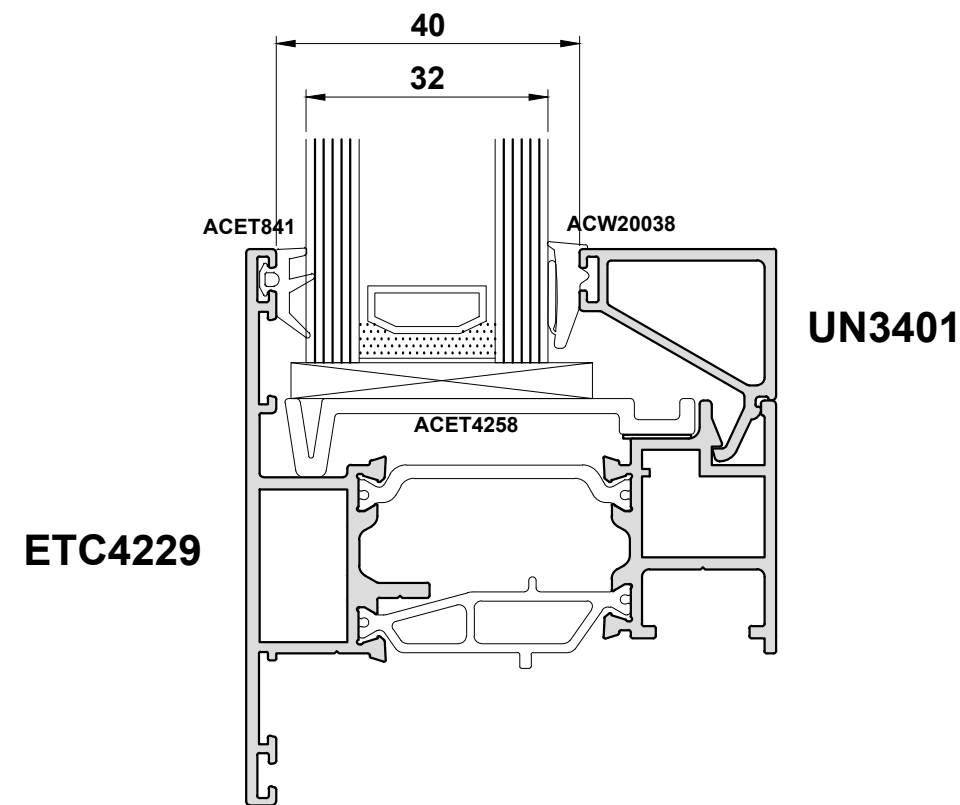
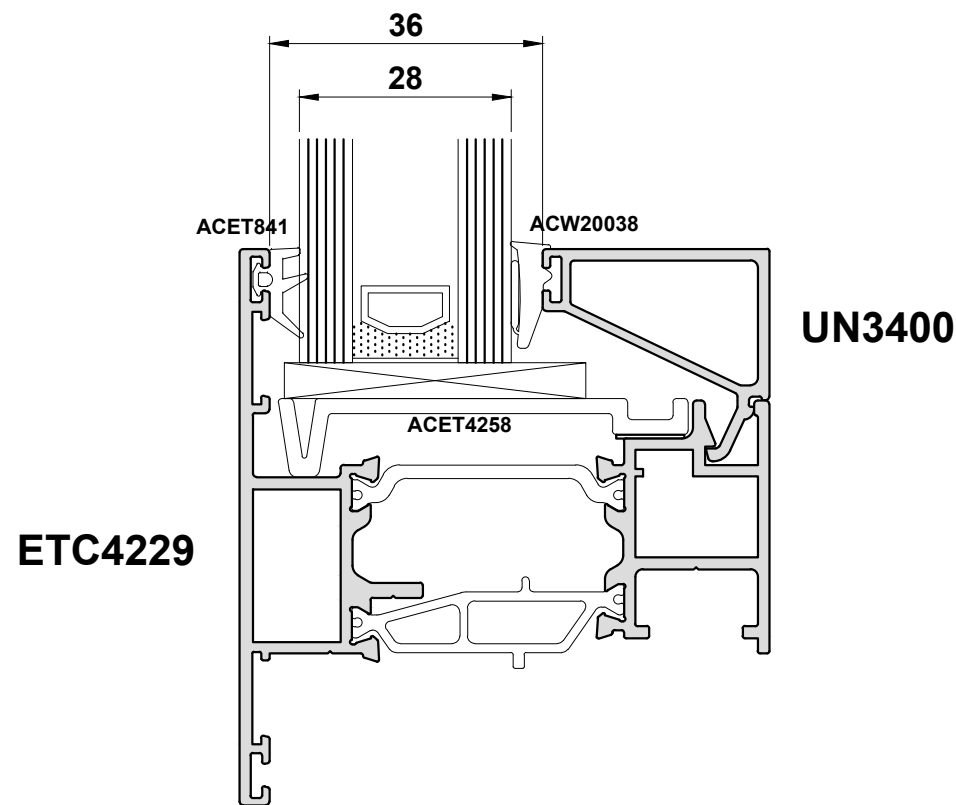
Do Not Scale From This Drawing

Glazing Details



Externally Glazed

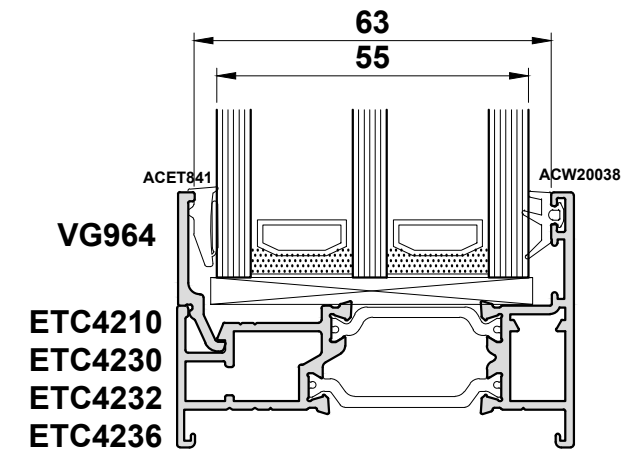
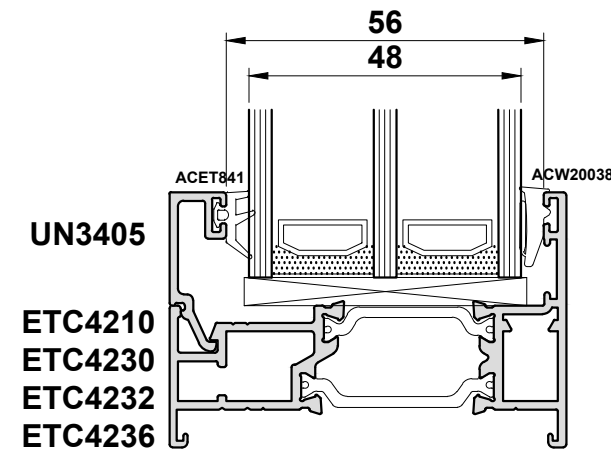
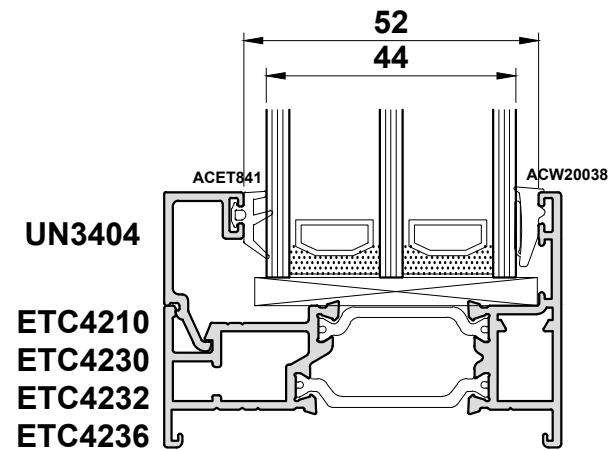
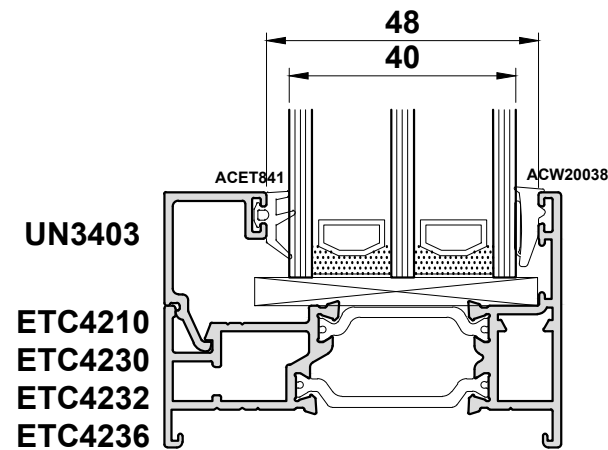
⚠ Please use GT Window Products glass clips for externally glazed profiles.



Internally Glazed

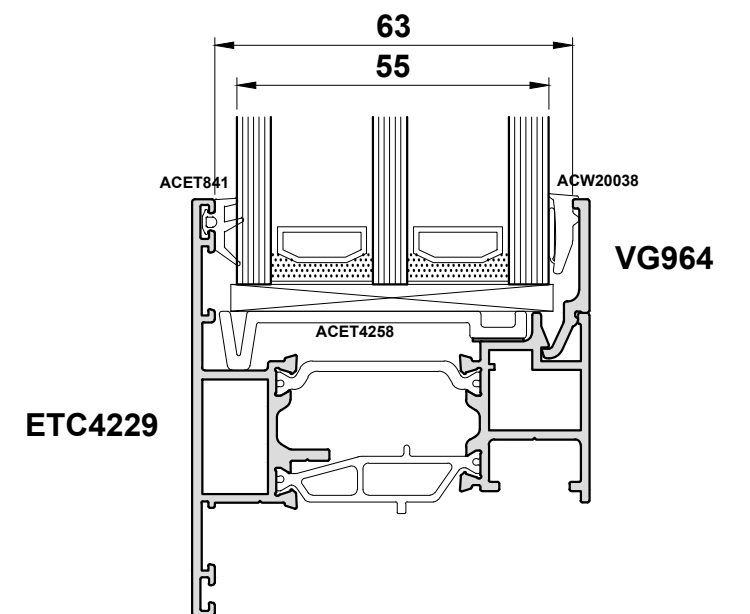
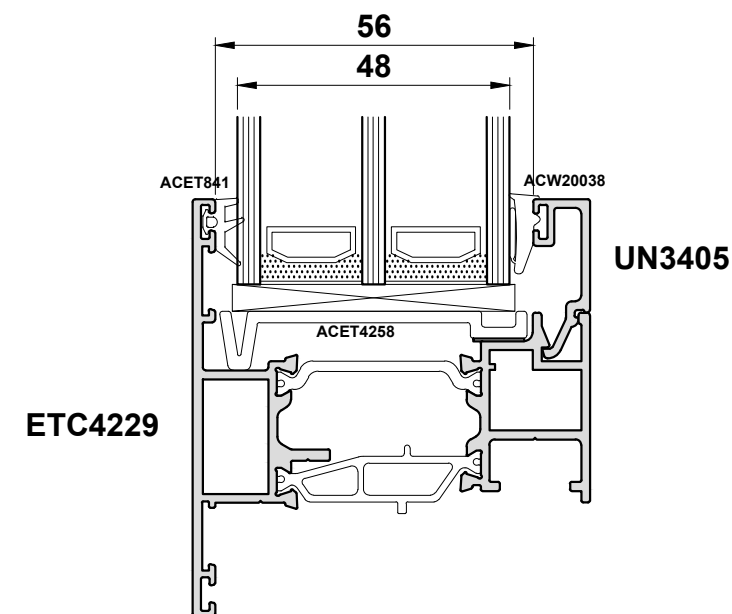
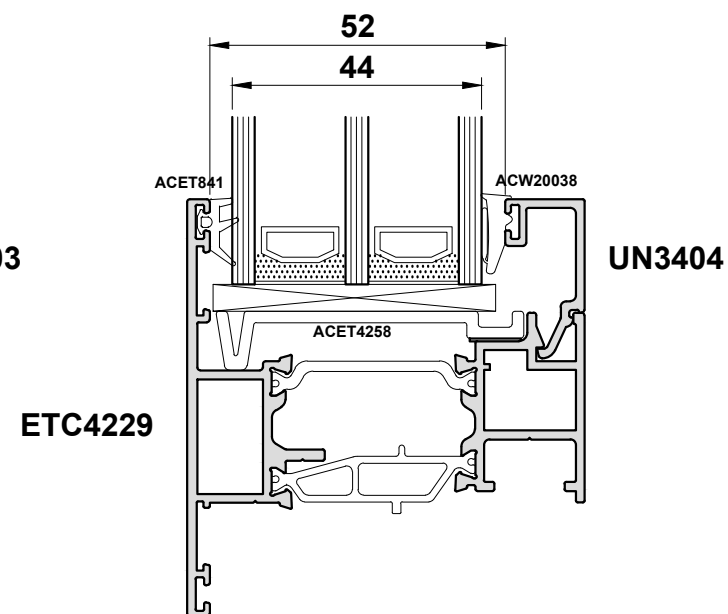
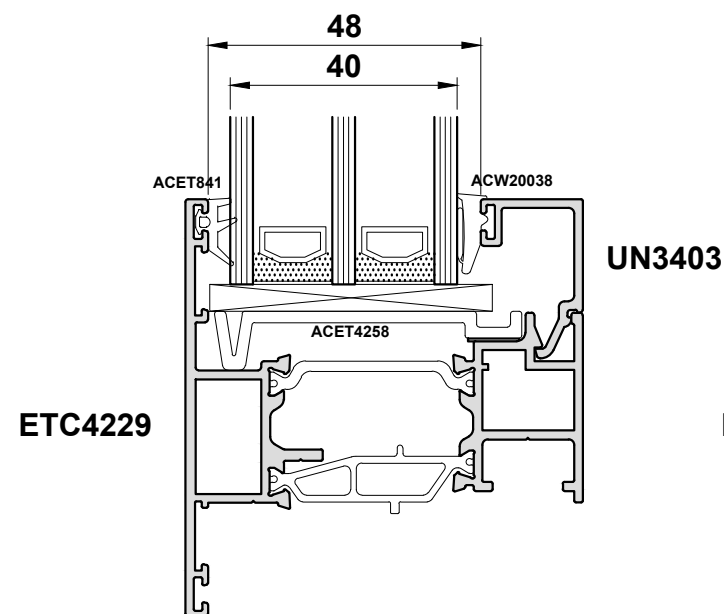
Do Not Scale From This Drawing

Glazing Details



Externally Glazed

 Please use GT Window Products glass clips for externally glazed profiles.



Internally Glazed

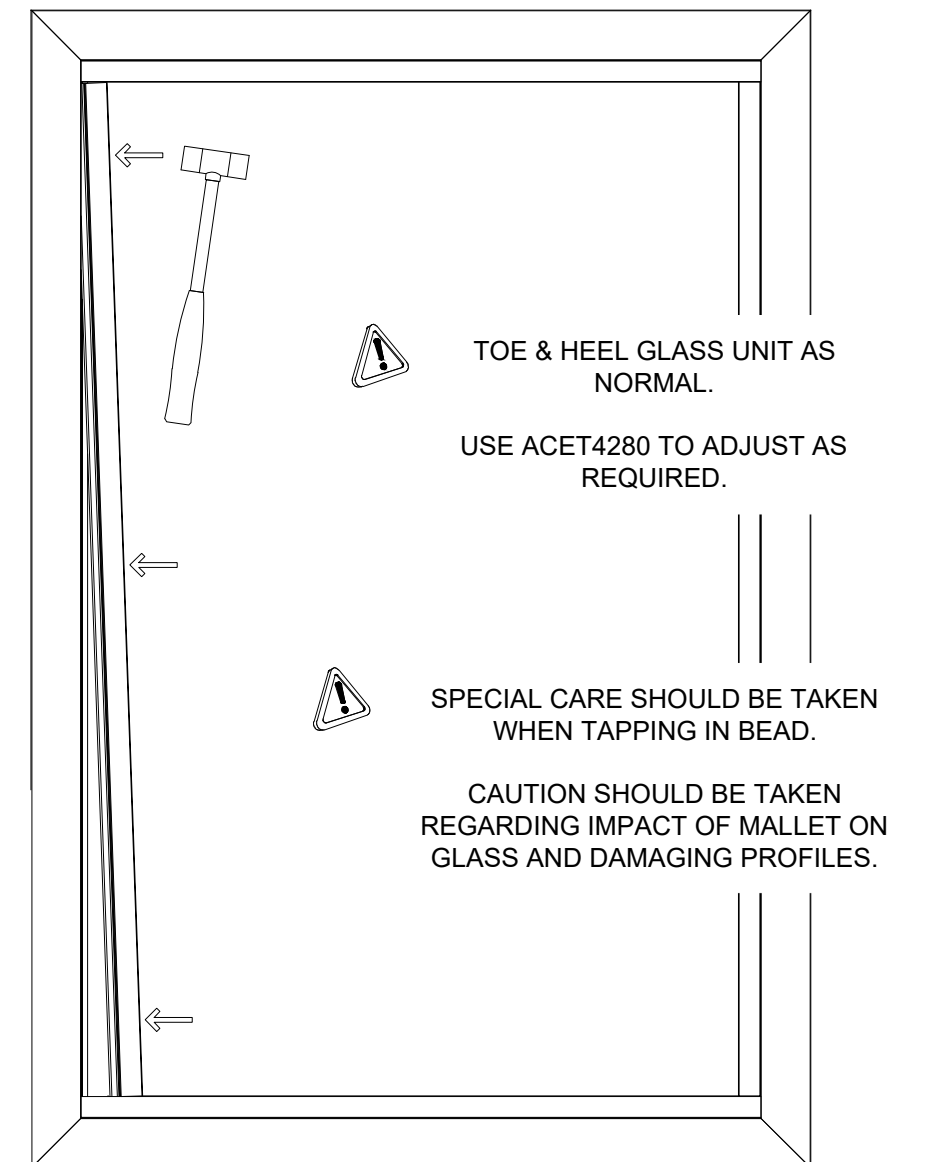
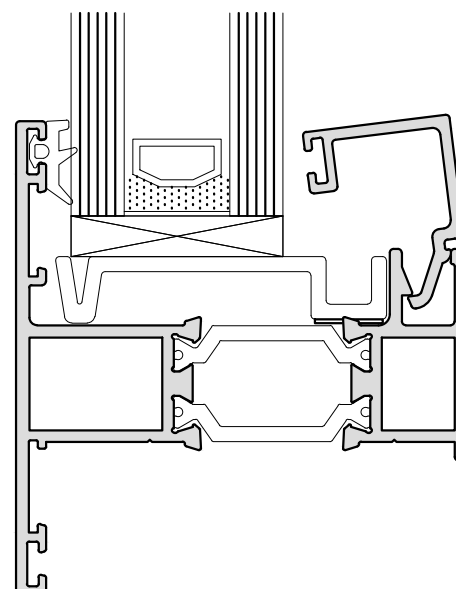
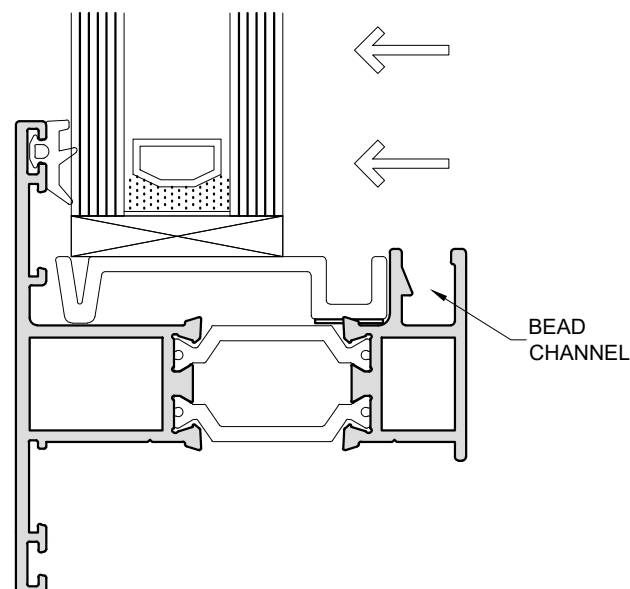
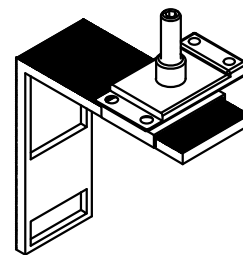
Do Not Scale From This Drawing

Bead Installation

QUICK-GLAZE BEAD INSTALLATION

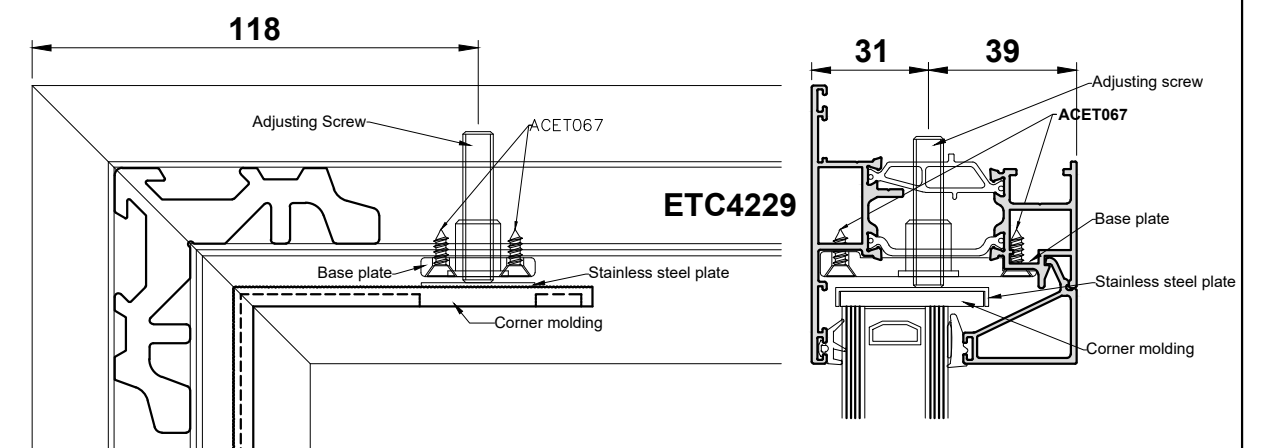
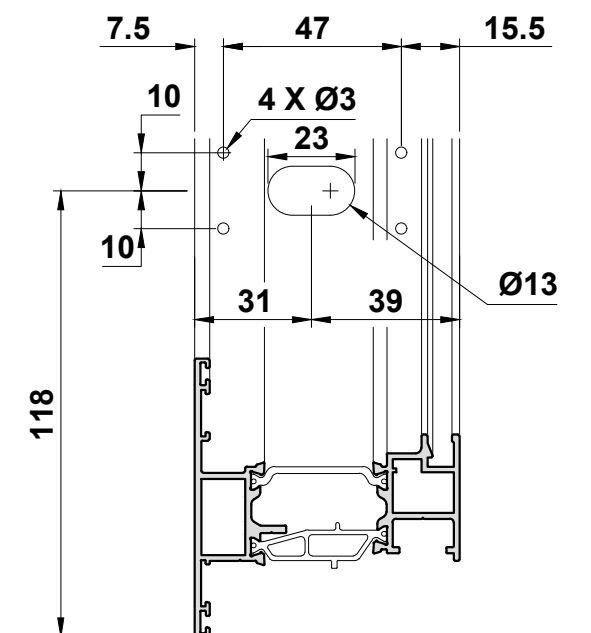
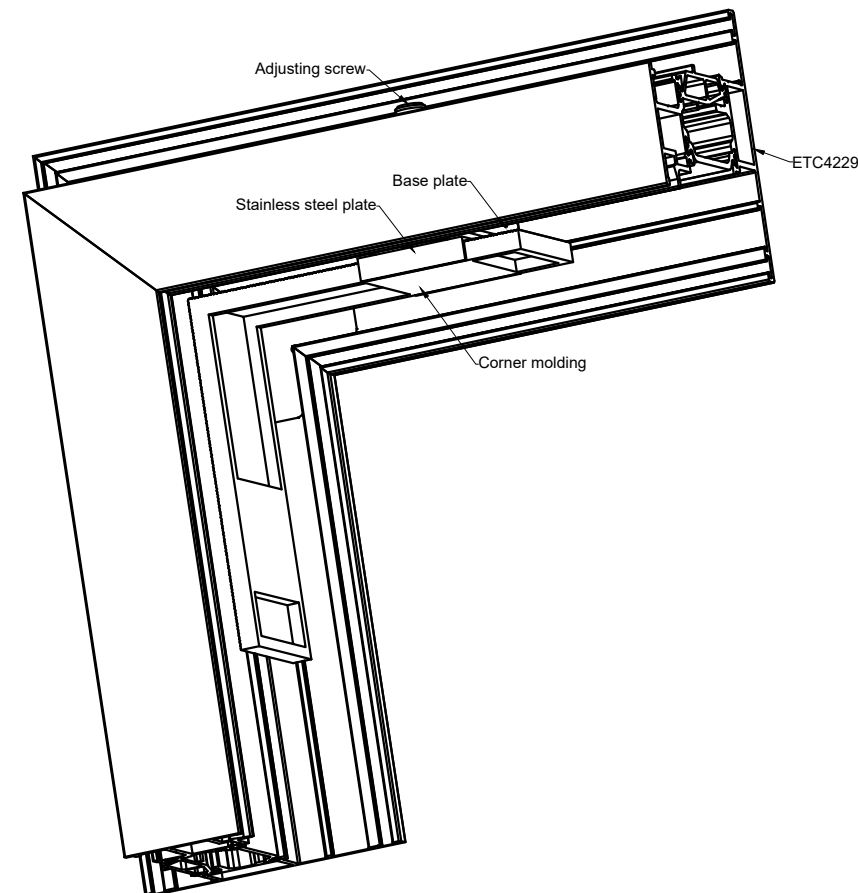
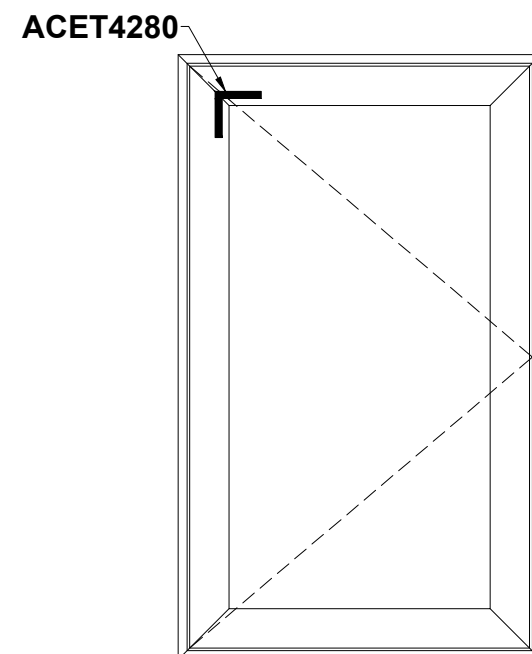
1. INSTALL GLASS UNIT, ENSURING IT HAS BEEN PUSHED FORWARD TO ENGAGE COMPRESSION OF E GASKET.
2. BEGINNING WITH HORIZONTAL BEADS, LOCATE BEAD IN CLIP CHANNEL OF SASH AS SHOWN. INTEGRATED GASKET MAY REST AGAINST GLASS UNIT.
3. APPLY FIRM PRESSURE TO THE BEAD TO HOLD IN POSITION. THIS MAY CAUSE THE BEAD TO FULLY LOCK INTO POSITION.
4. USING A NYLON MALLET, TAP BEAD INTO CHANNEL WORKING FROM ONE END TO THE OTHER. PLEASE TAKE CARE AT THIS STAGE TO AVOID DAMAGE TO BOTH THE GLAZING UNIT AND THE BEAD.
5. REPEAT STEPS 2 - 4 TO INSTALL VERTICAL BEADS.

WE STRONGLY RECOMMEND INSTALLING ACET4280 GLASS ADJUSTERS WHEN USING QUICK-GLAZE BEADS. THIS WILL REMOVE THE NEED TO REMOVE BEADS IN ORDER TO ADJUST GLASS POSITION.



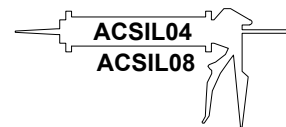
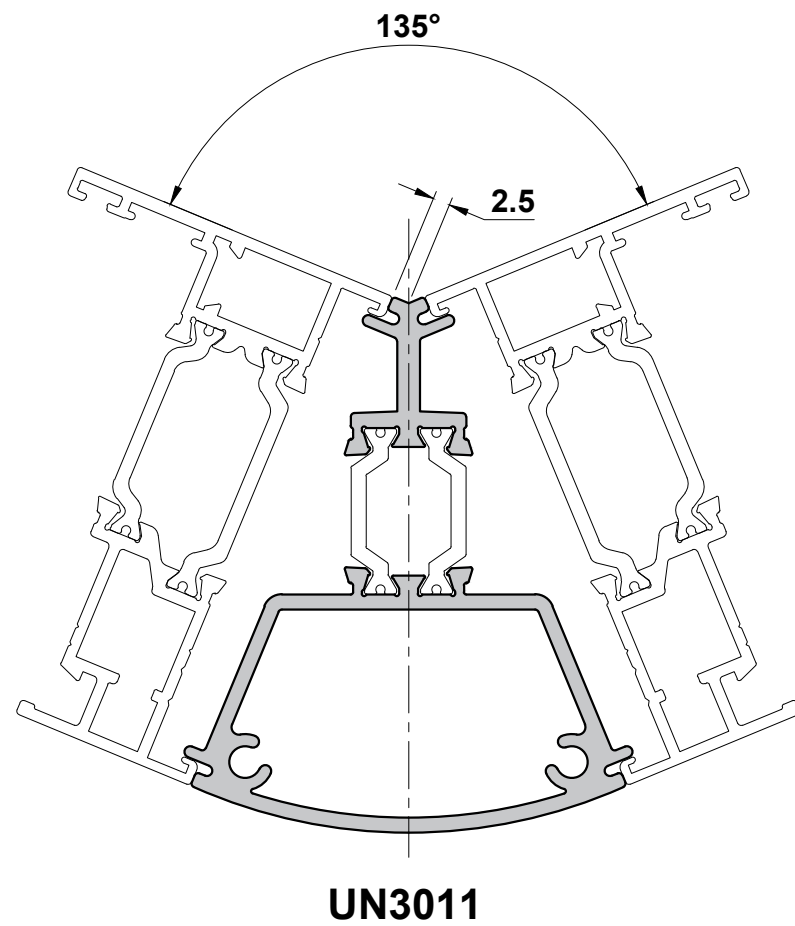
Exploded view diagram of the ABS assembly. The components are labeled as follows:

- Adjusting Screw
- ABS Base Plate with M8 threaded insert
- Stainless Steel Plate
- ABS Corner Molding

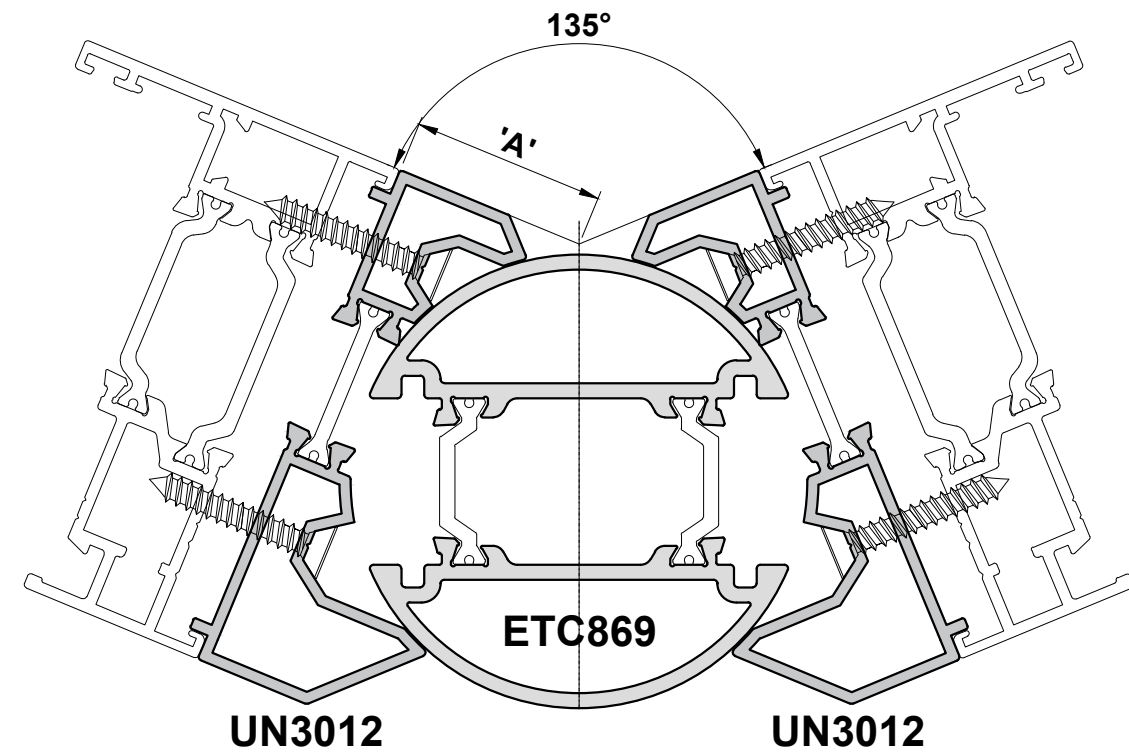


Do Not Scale From This Drawing

Bay Pole Options

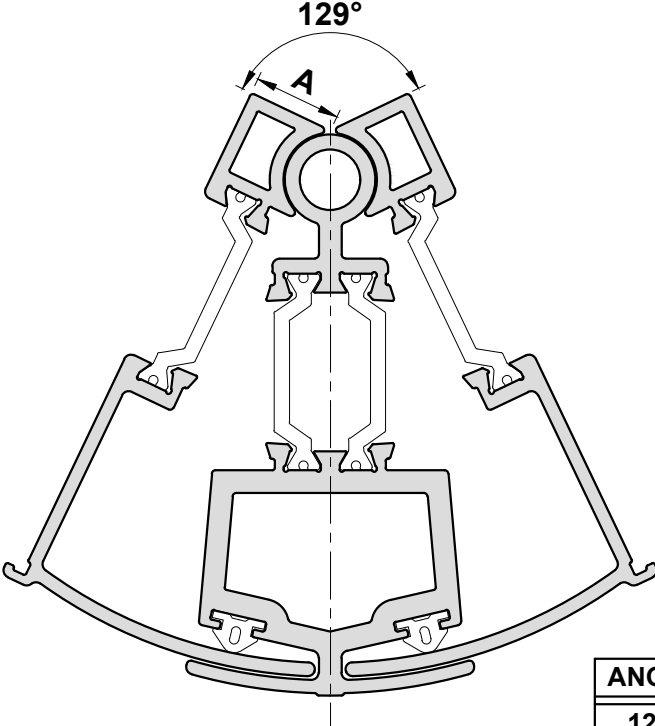
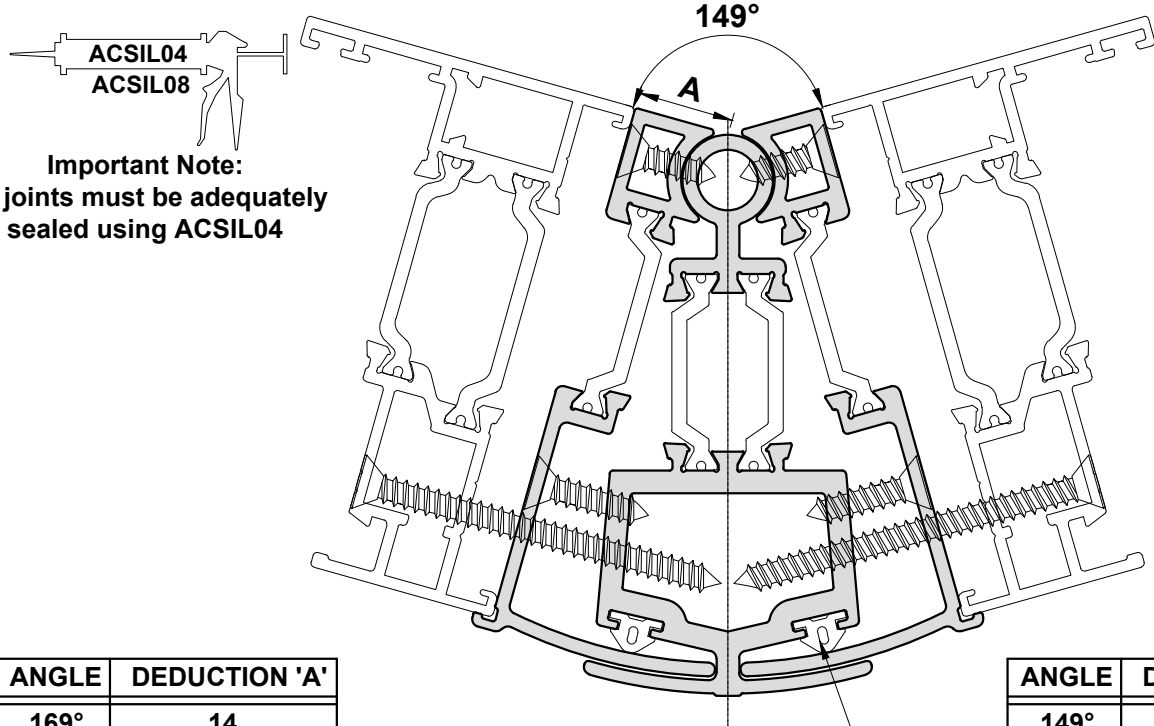
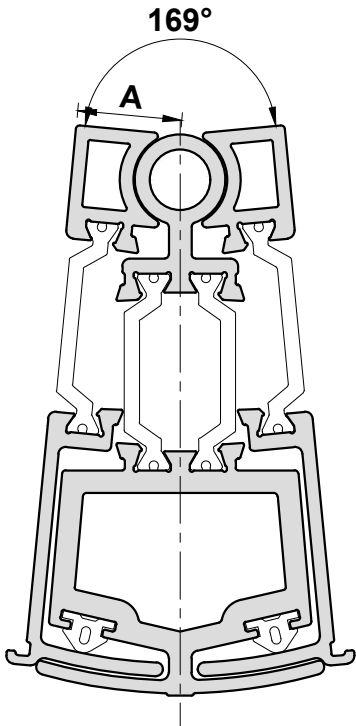


Important Note:
All joints must be adequately
sealed using ACSIL04



ANGLE	DEDUCTION 'A'
180°	37.5
175°	36
170°	35
165°	33.5
160°	32.5
155°	31
150°	30
145°	28.5
140°	27
135°	25.5
130°	24
125°	23
120°	21
115°	19.5
110°	18

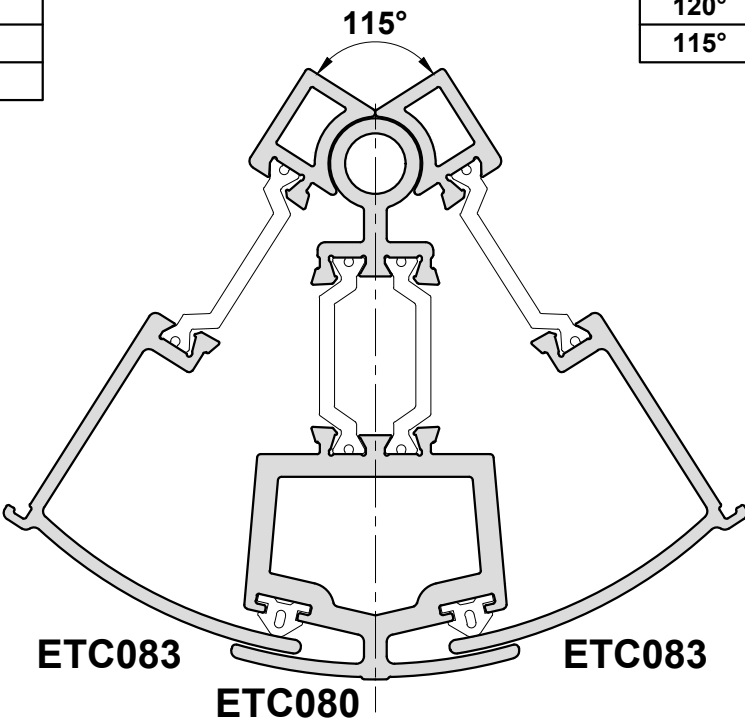
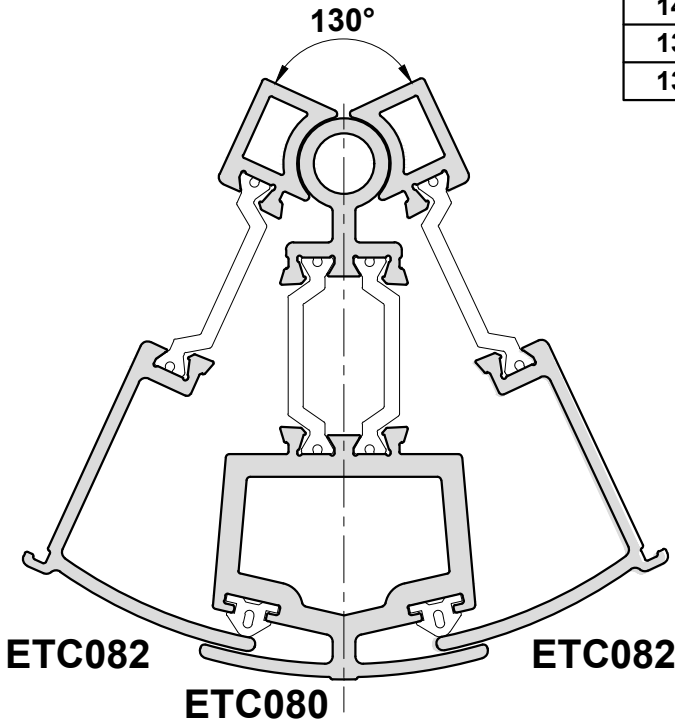
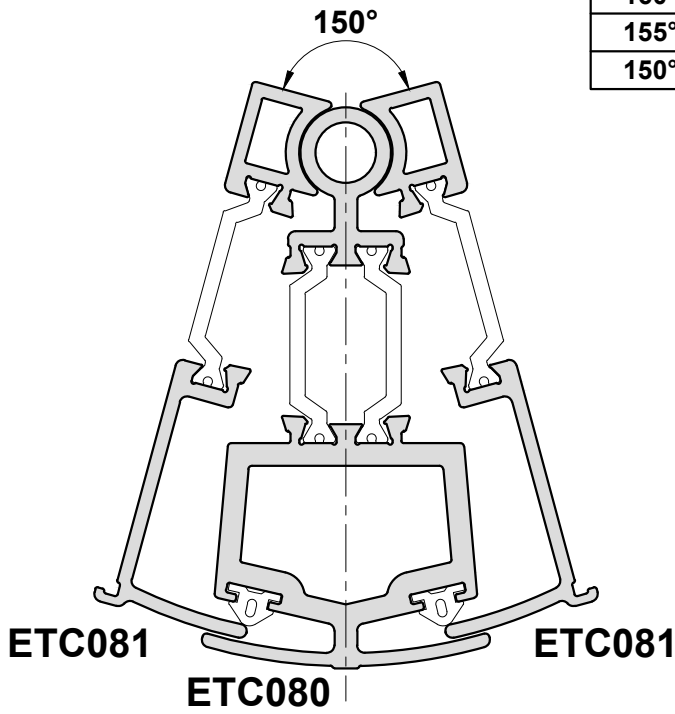
Bay Pole Options



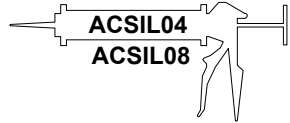
ANGLE	DEDUCTION 'A'
169°	14
165°	13.5
160°	13.6
155°	13
150°	13

ANGLE	DEDUCTION 'A'
149°	12.5
145°	12.5
140°	12
135°	12
130°	11.5

ANGLE	DEDUCTION 'A'
129°	11.5
125°	11.5
120°	11
115°	10.5



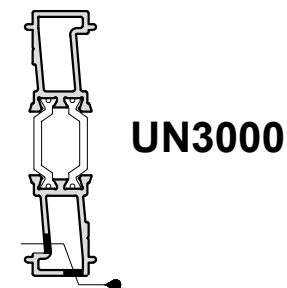
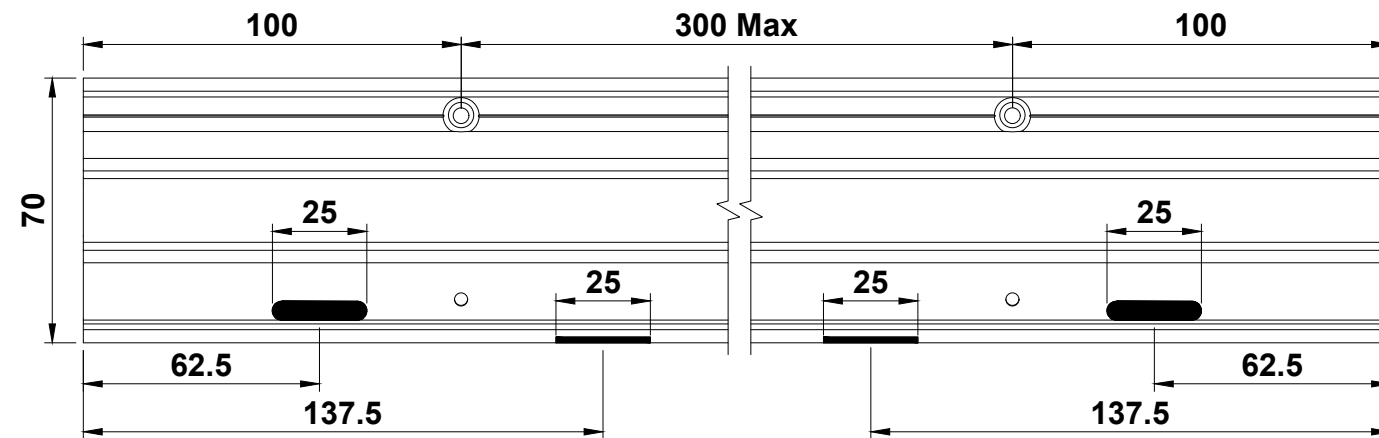
Important Note:
All joints must be adequately
sealed using ACSIL04



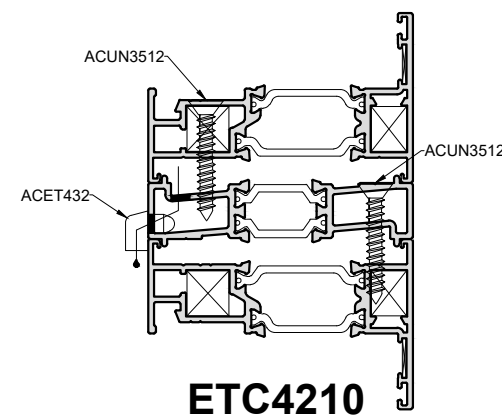
ACVS010

Do Not Scale From This Drawing

Horizontal Coupler Details



Important Note: Seal all joints to UN3000 using ACSIL04.

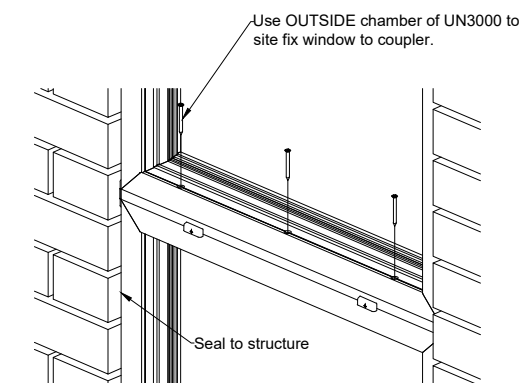
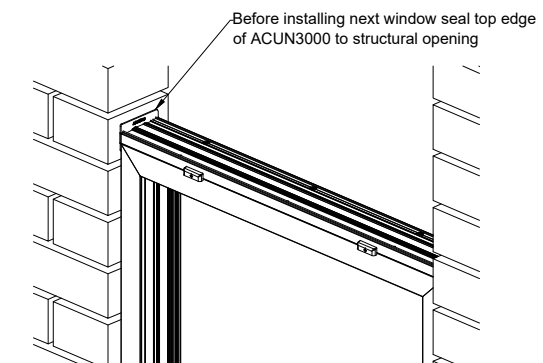
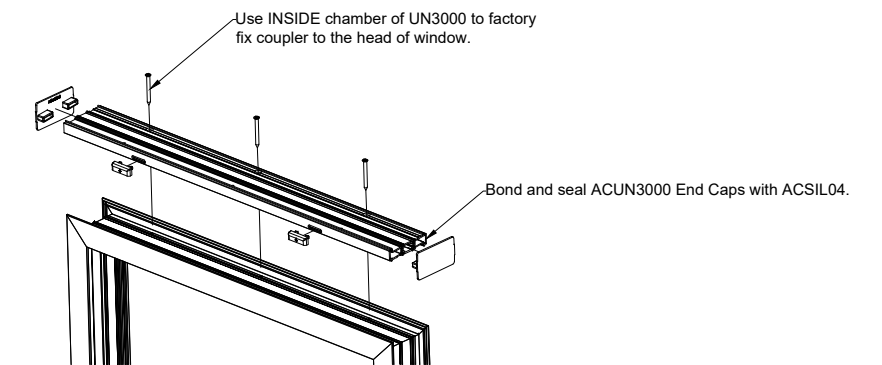


Important Note: Do not screw through drainage channel.



Zone Drainage of Jamb Cavity

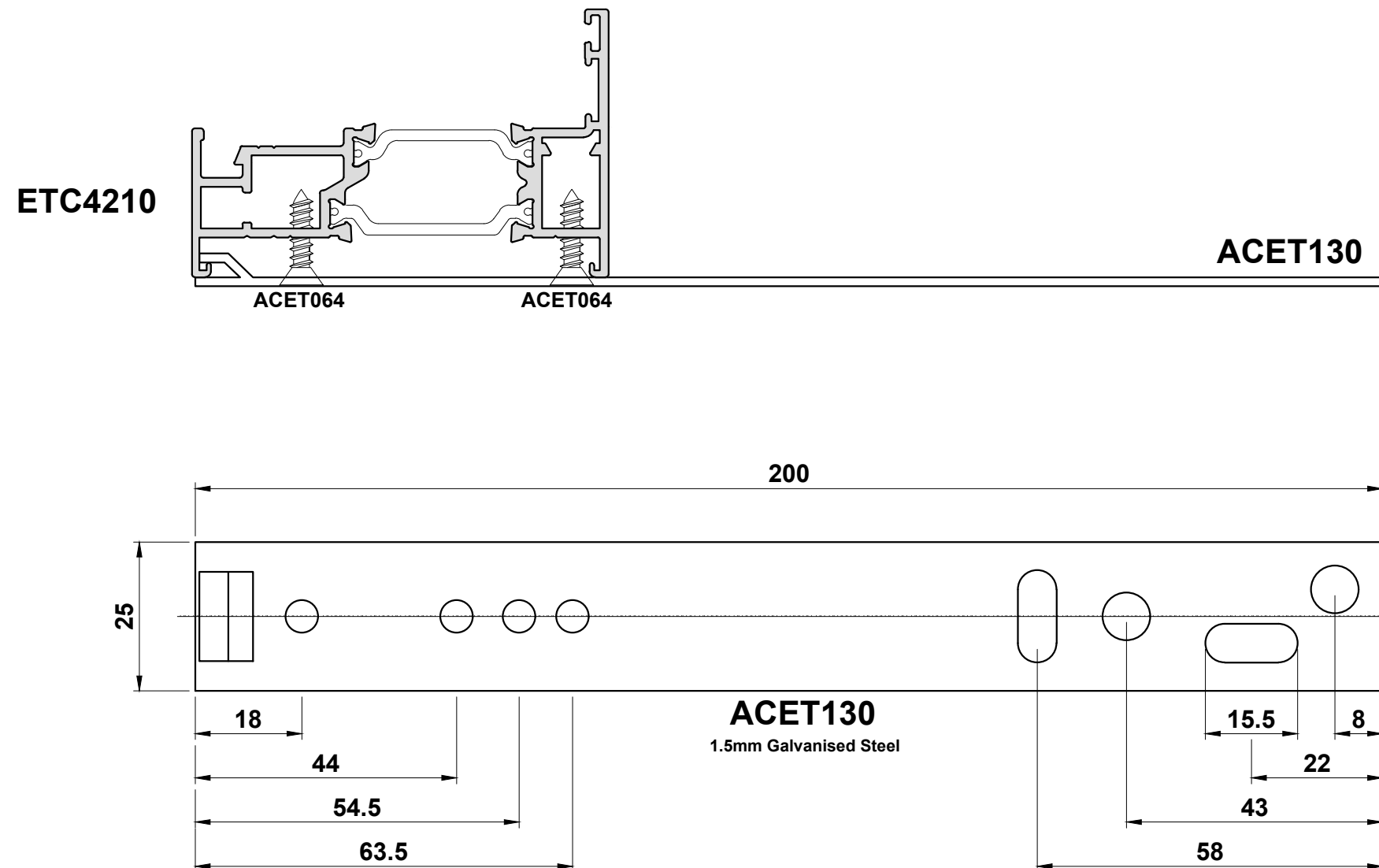
CWCT Built up wall guidance recommends drainage of Jamb Cavity



Fixing Strap Details

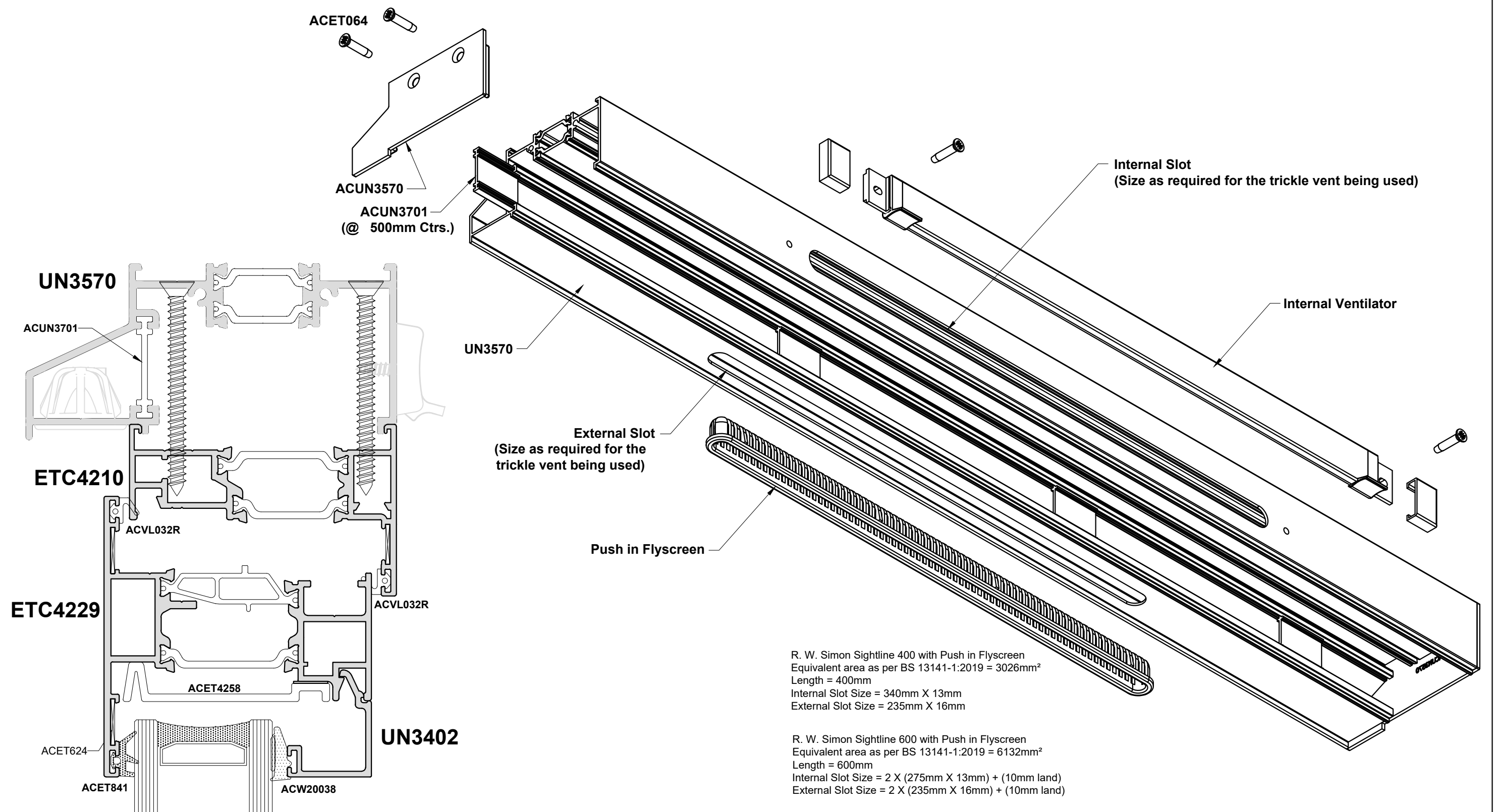
NOTE:

Fixing straps should be spaced a minimum of 150mm in from each end & at a maximum of 300mm apart.



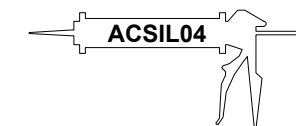
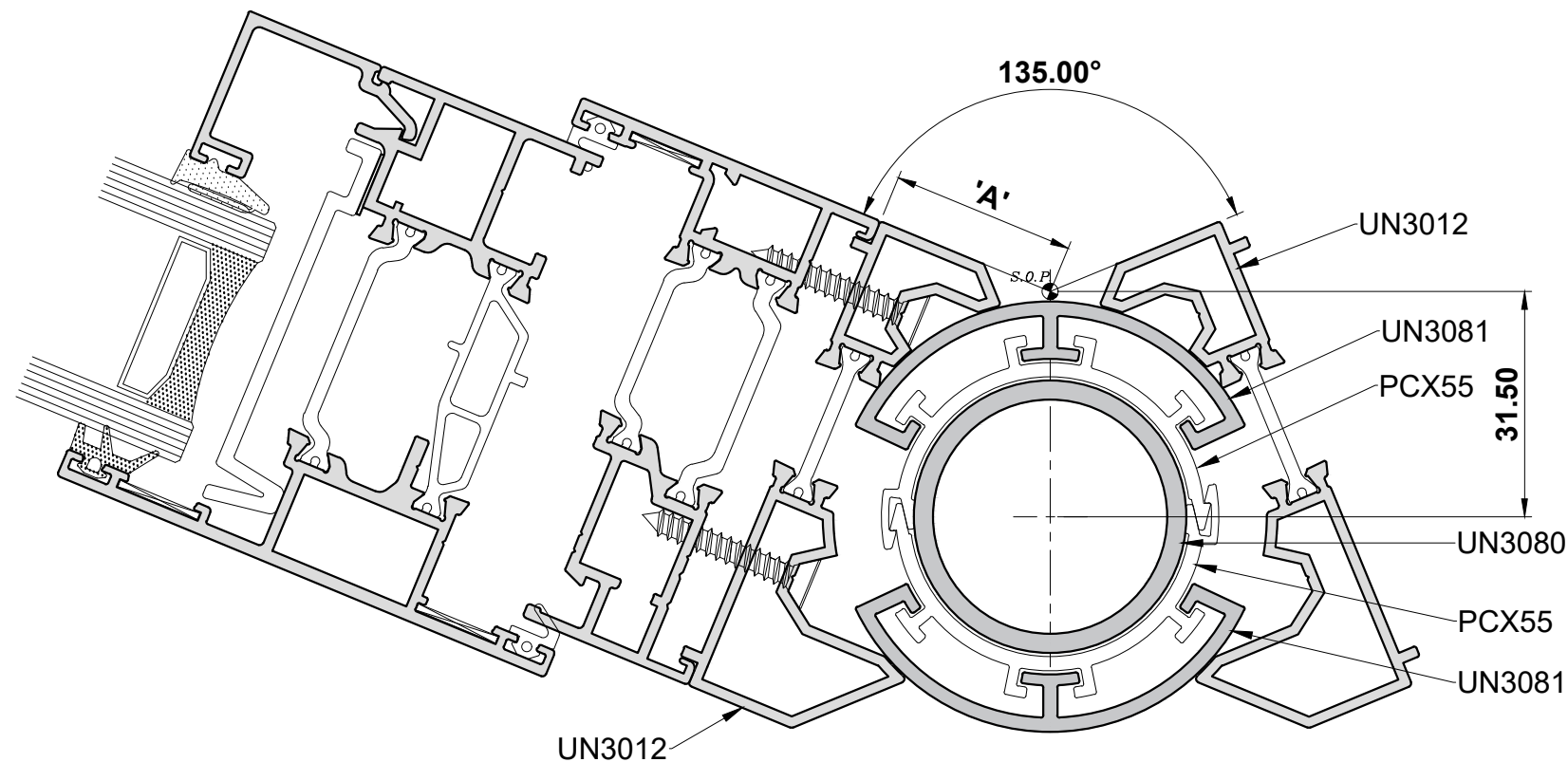
Do Not Scale From This Drawing

UN3570



Do Not Scale From This Drawing

Jackable Bay Pole



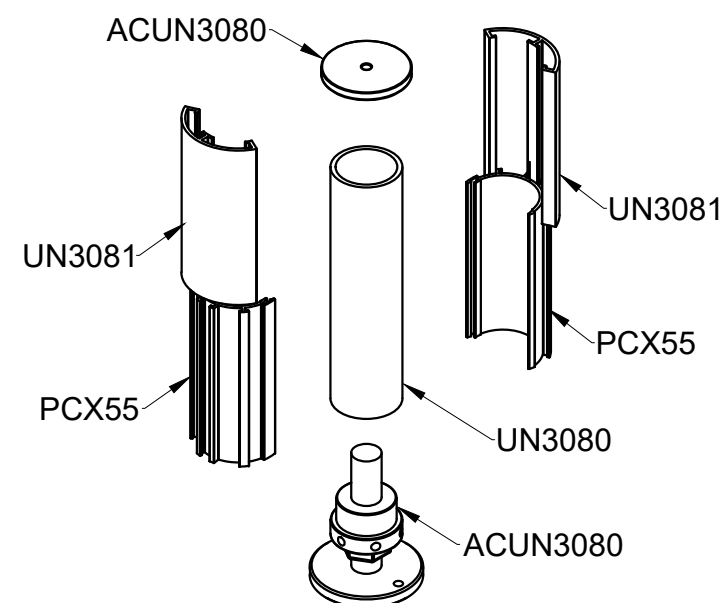
Important Note:
All joints must be adequately
sealed using ACSIL04

ANGLE	DEDUCTION 'A'
180°	37.5
175°	36
170°	35
165°	33.5
160°	32.5
155°	31
150°	30
145°	28.5
140°	27
135°	25.5
130°	24
125°	23
120°	21
115°	19.5
110°	18

Note: Installation to comply with relevant building regulations and British standards :-

- BS8213-4 Code of Practice for the survey and installation of window and external doorsets.
- Approved document A structure.
- Approved document C resistance to the passage of moisture.

Height (mm)	Load Bearing
1000	Capped at 2 Tonnes
1250	1.5 Tonnes
1500	1.1 Tonnes
1750	0.8 Tonnes
2000	0.6 Tonnes
2250	0.5 Tonnes
2500	0.4 Tonnes

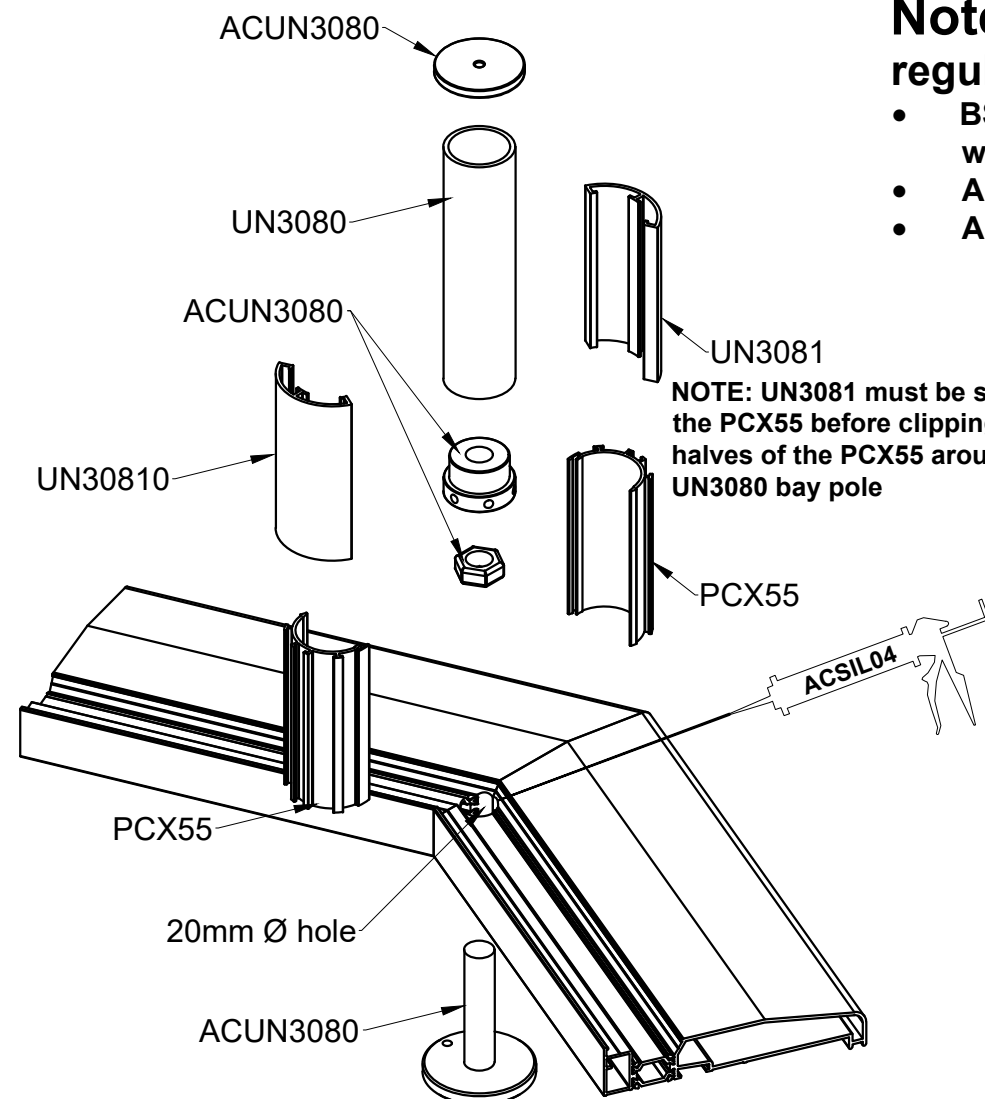


Do Not Scale From This Drawing

Jackable Bay Pole

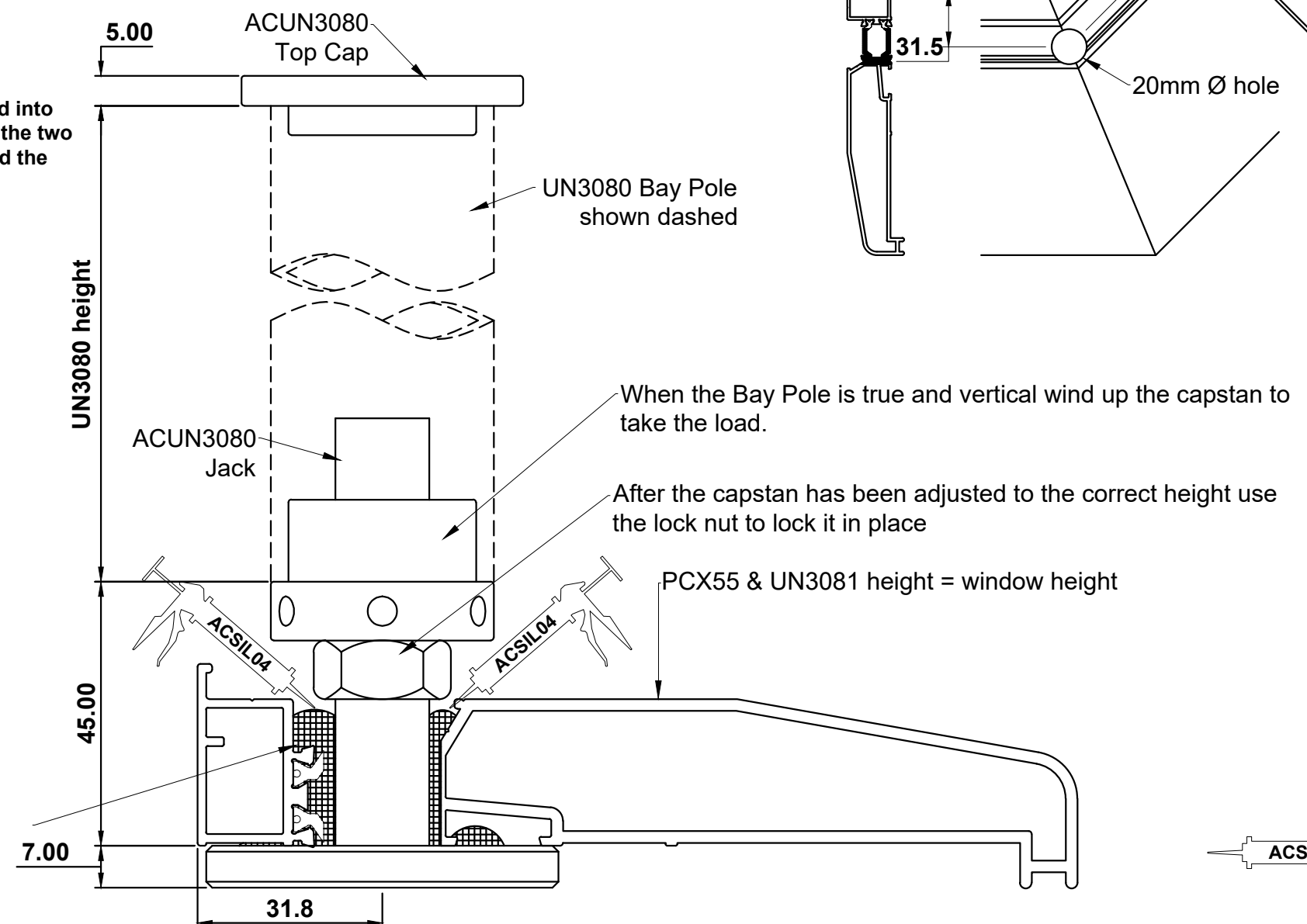
Note: Installation to comply with relevant building regulations and British standards :-

- BS8213-4 Code of Practice for the survey and installation of window and external doorsets.
- Approved document A structure.
- Approved document C resistance to the passage of moisture.

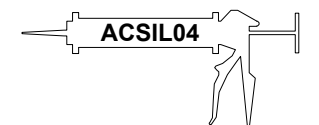


Fully seal between the jack and sub cill with ACSIL04 so that water is not able to track through the 20mm hole.

When the cill does not form a complete water barrier then damp proof course should be used.
See approved document C section 5.9



Remove old mortar under the jack so that the 60mm base rests on a sound and level surface. When required use spreader plate under the jack and above the top cap.



Important Note:
All joints must be adequately sealed using ACSIL04

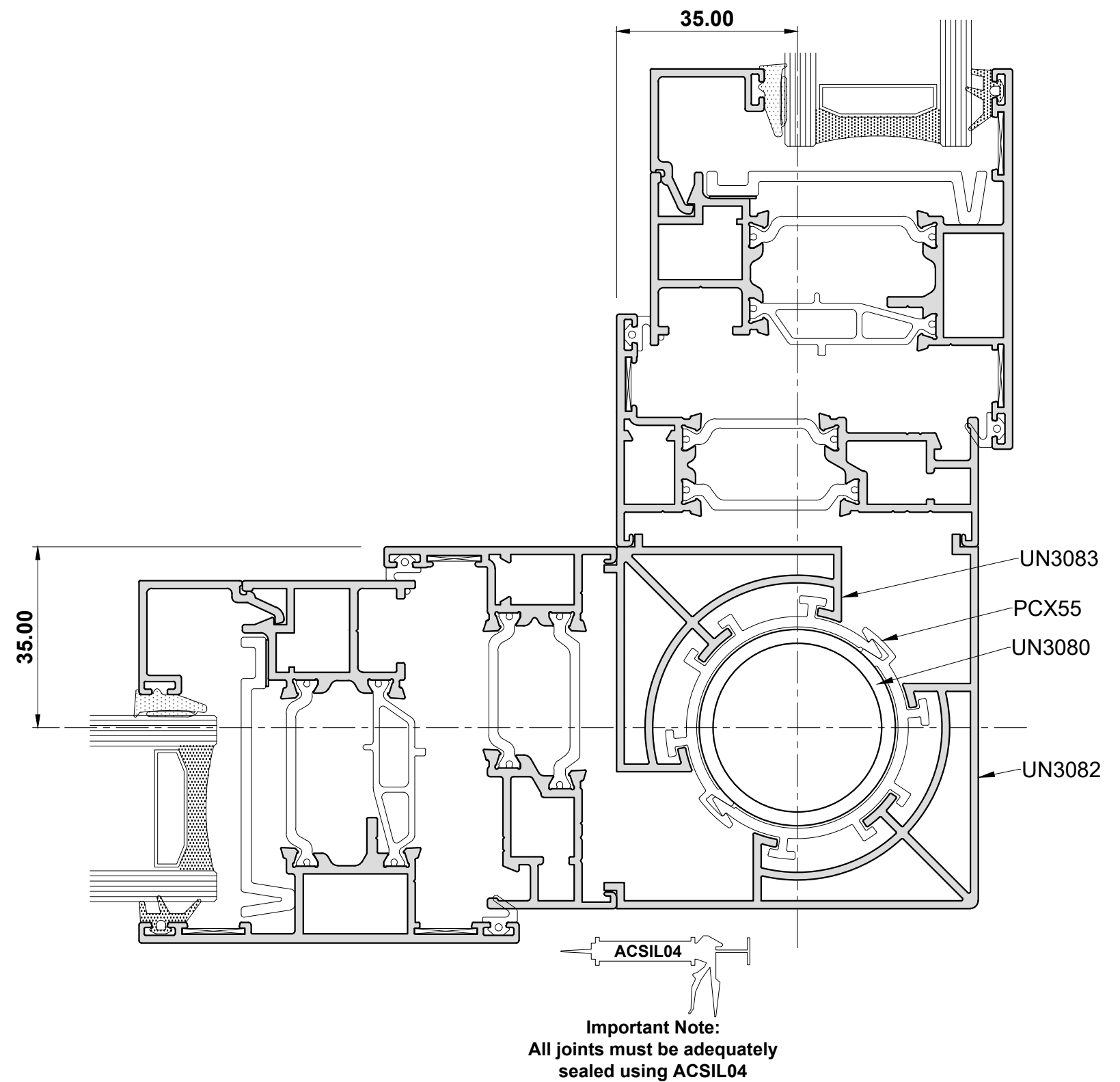
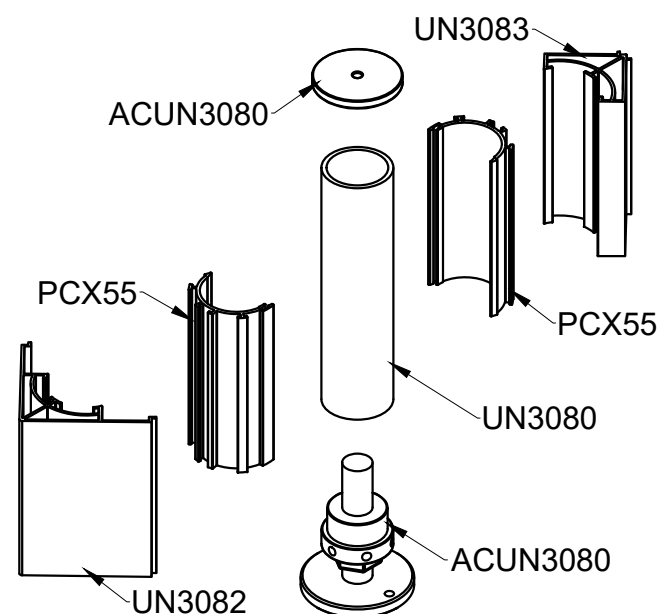
Do Not Scale From This Drawing

90° Bay Pole

Note: Installation to comply with relevant building regulations and British standards :-

- BS8213-4 Code of Practice for the survey and installation of window and external doorsets.
- Approved document A structure.
- Approved document C resistance to the passage of moisture.

Height (mm)	Load Bearing
1000	Capped at 2 Tonnes
1250	1.5 Tonnes
1500	1.1 Tonnes
1750	0.8 Tonnes
2000	0.6 Tonnes
2250	0.5 Tonnes
2500	0.4 Tonnes

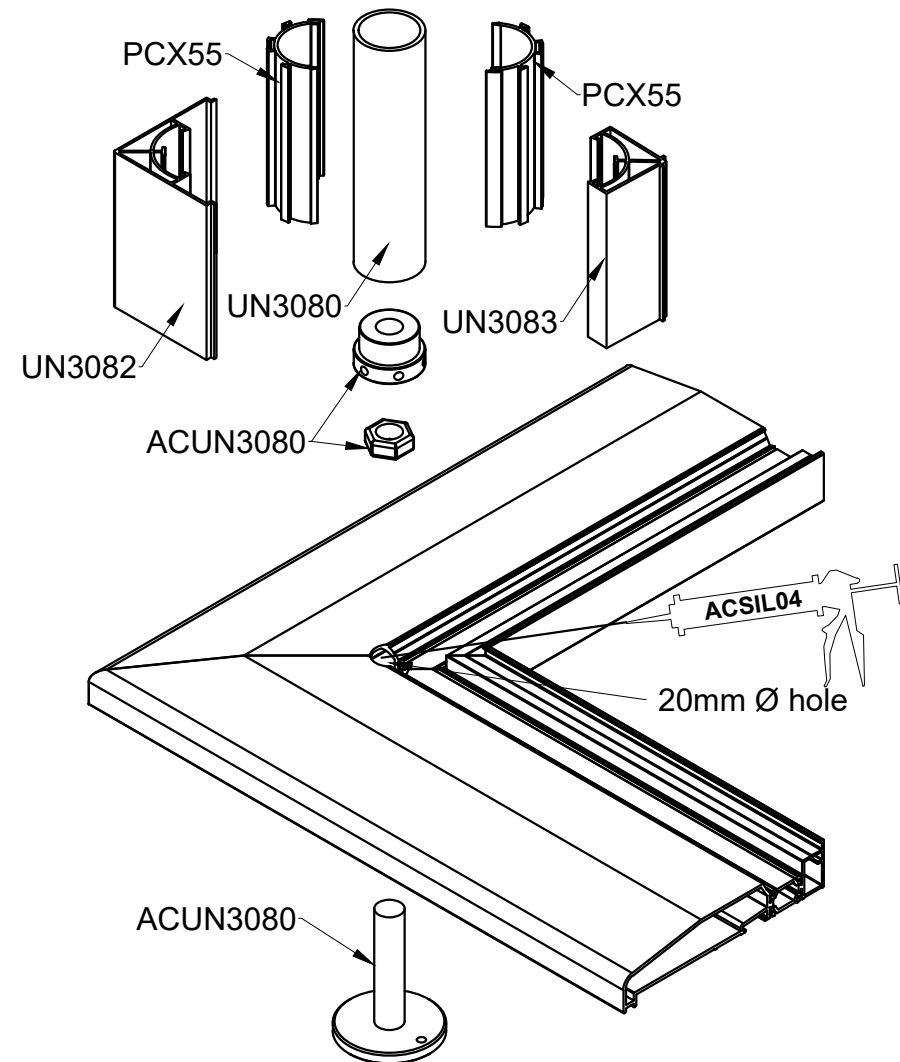


Do Not Scale From This Drawing

90° Bay Pole

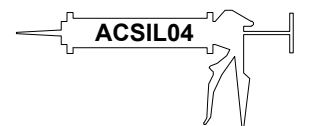
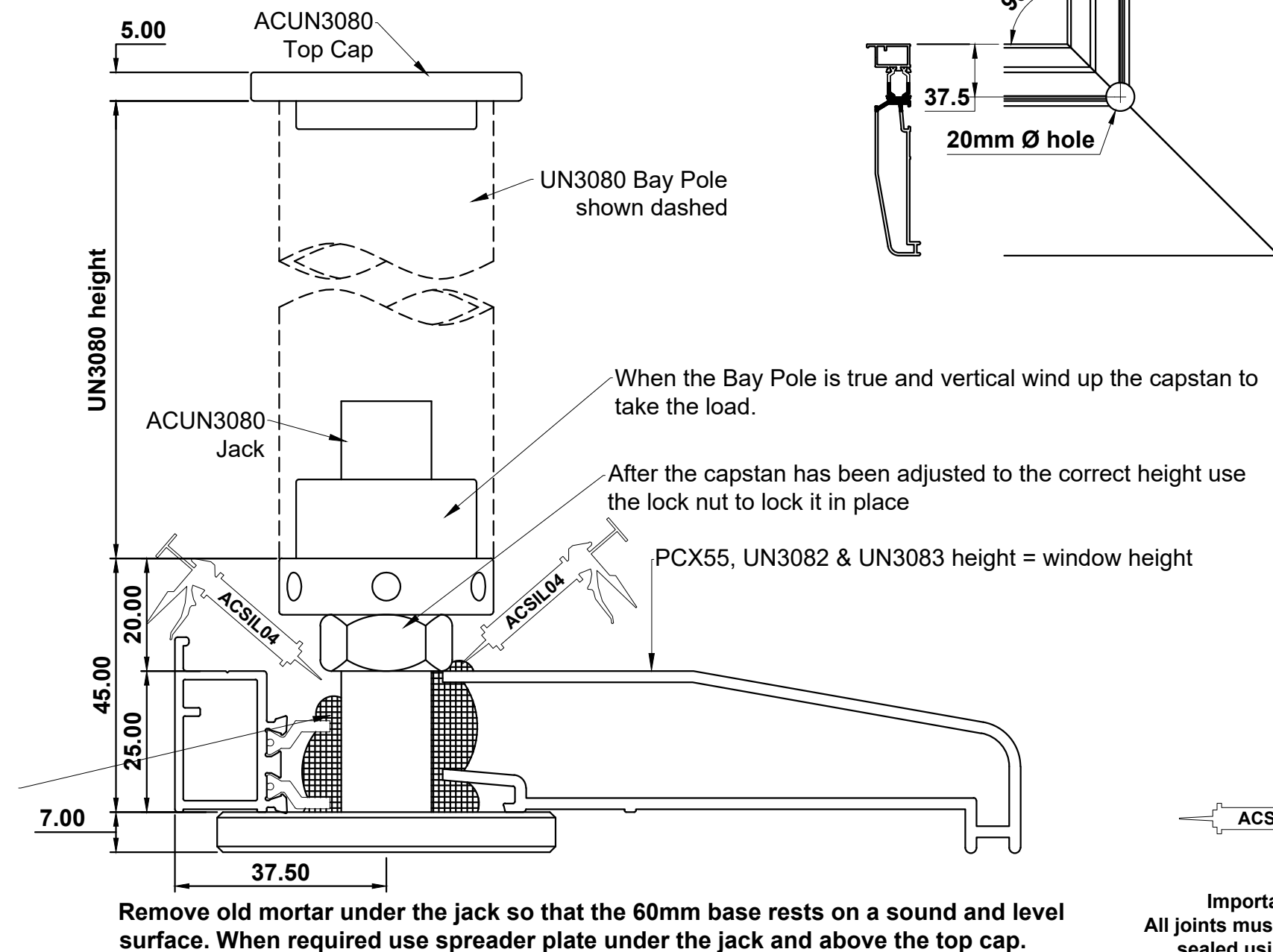
Note: Installation to comply with relevant building regulations and British standards :-

- BS8213-4 Code of Practice for the survey and installation of window and external doorsets.
- Approved document A structure.
- Approved document C resistance to the passage of moisture.



Fully seal between the jack and sub cill with ACSIL04 so that water is not able to track through the 20mm hole.

When the cill does not form a complete water barrier then damp proof course should be used.
See approved document C section 5.9

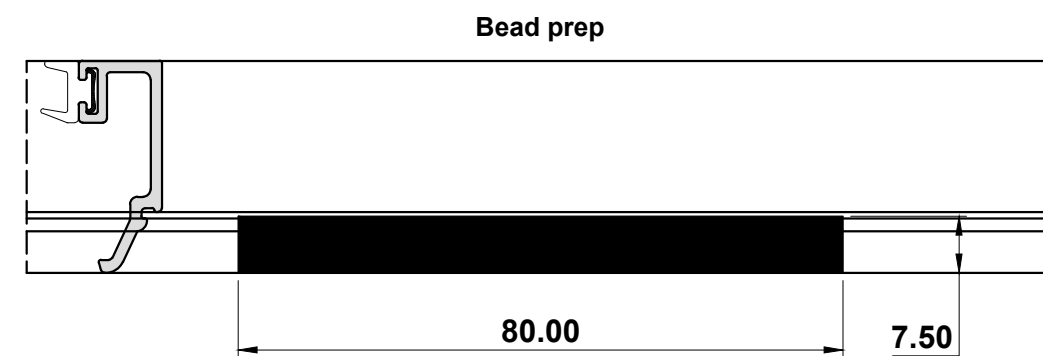
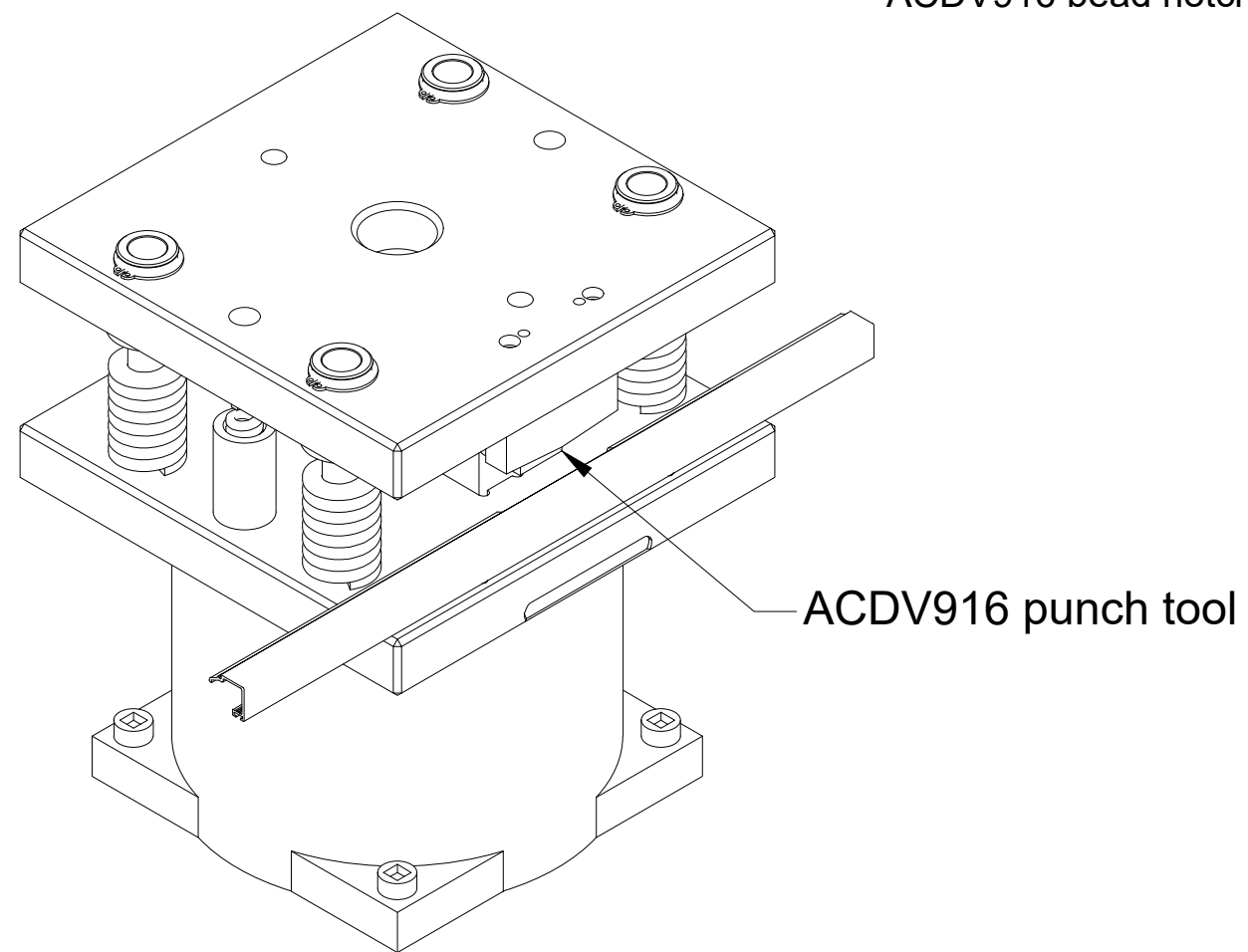


Important Note:
All joints must be adequately sealed using ACSIL04

Do Not Scale From This Drawing

ACDV916 Punch Tool

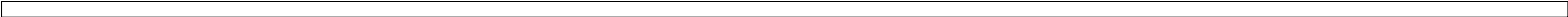
ACDV916 bead notching punch tool.



Please contact Technical Department for further information.

*After machining, all exposed aluminium should be coated using ACSIL014 or painted to match frame.
(Consider all following sheets where machining occurs)

Do Not Scale From This Drawing



Section F

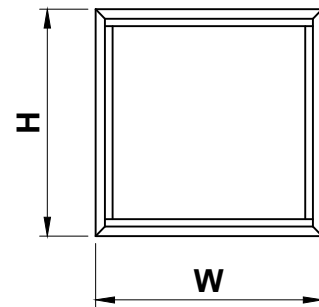


Sawing Tables

F03-08

Section F

Cutting Information



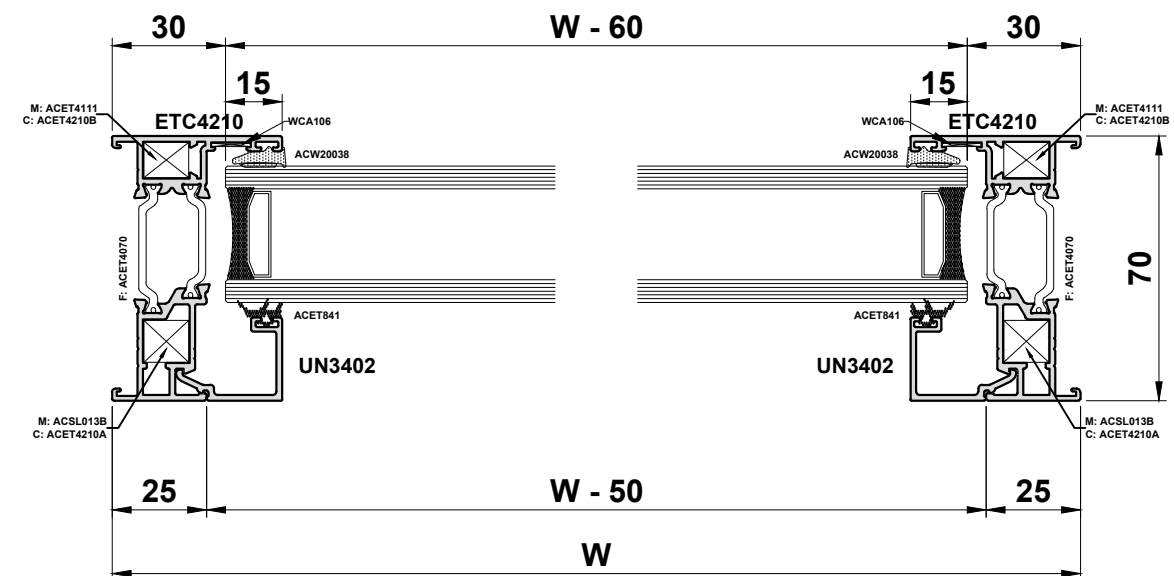
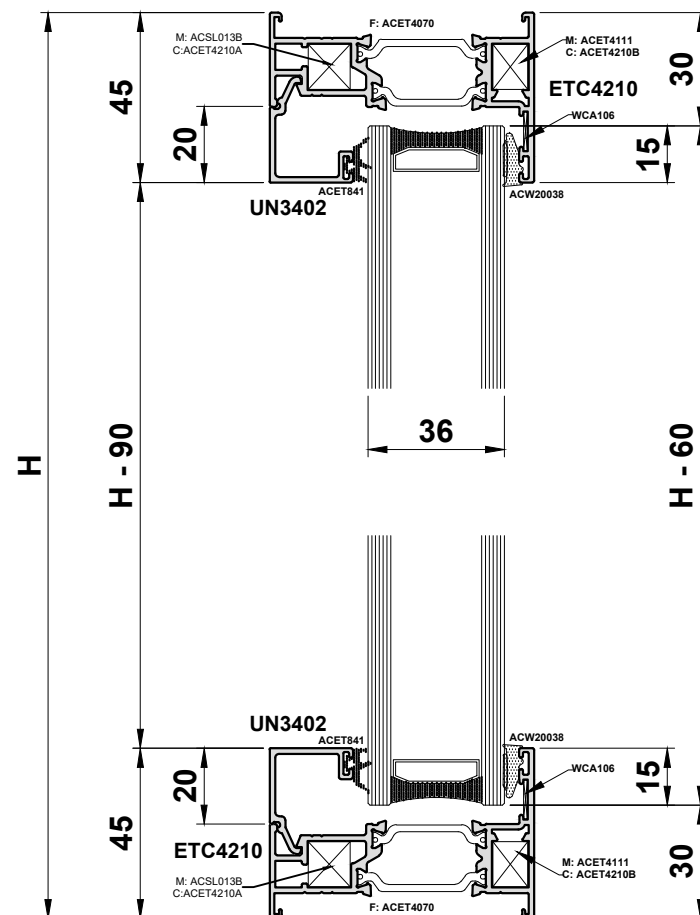
GLASS
W - 60 X H - 60

PROFILES

ETC4210	2		W
ETC4210	2		H
BEAD	2		W - 50
BEAD	2		H - 90

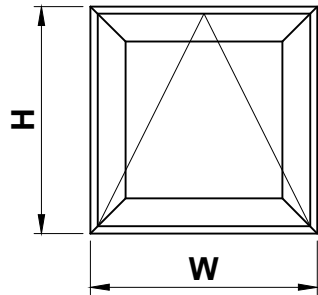
ACCESSORIES

ACET4210A	4	Cleat - Outerframe
ACET4210B	4	Cleat - Outerframe
WCA106	4	Chevron - Outerframe
ACET841	2 (W+H)	E Gasket
ACW20038	2 (W+H)	Wedge Gasket
ACVG560	2 (W+H)-20	Polyamide Foam
ACET4070	2 (W+H)	Cavity Foam
ACET4082	2 (W+H)-50	Glazing Perimeter Foam



Do Not Scale From This Drawing

Cutting Information



GLASS
W - 155 X H - 155

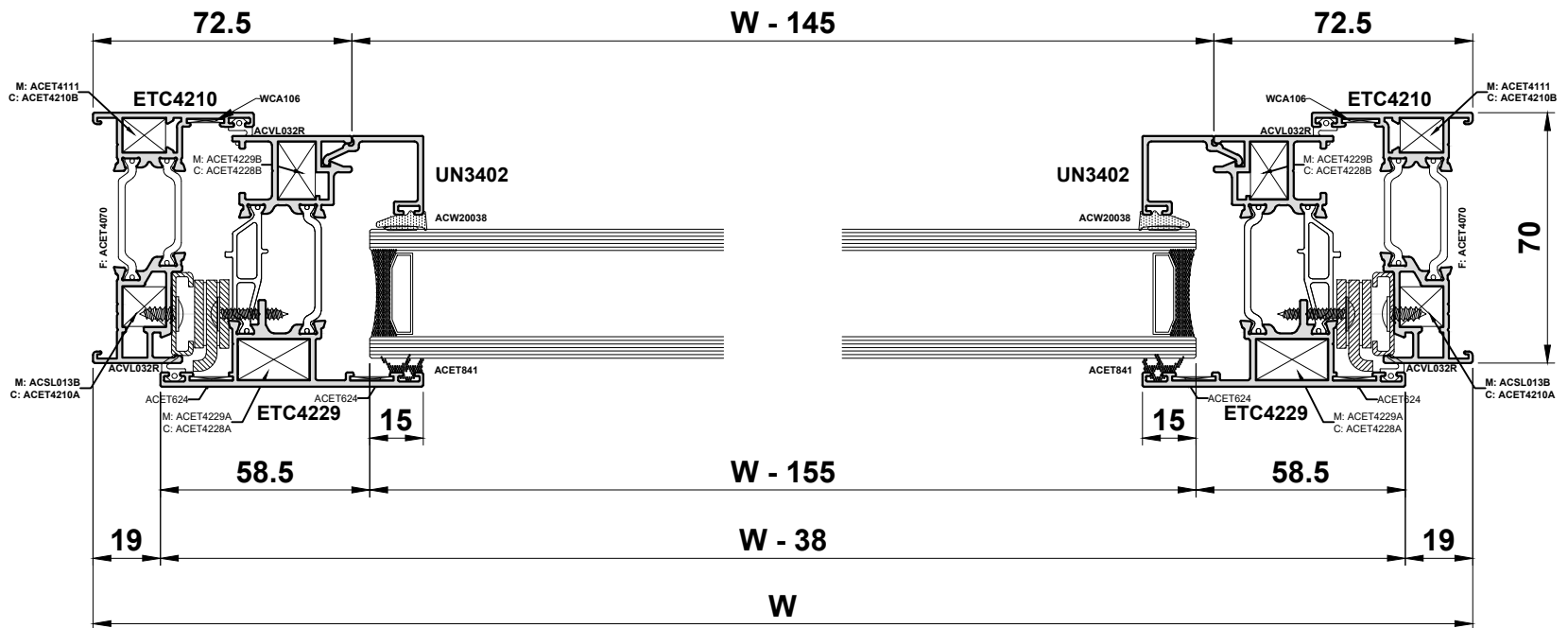
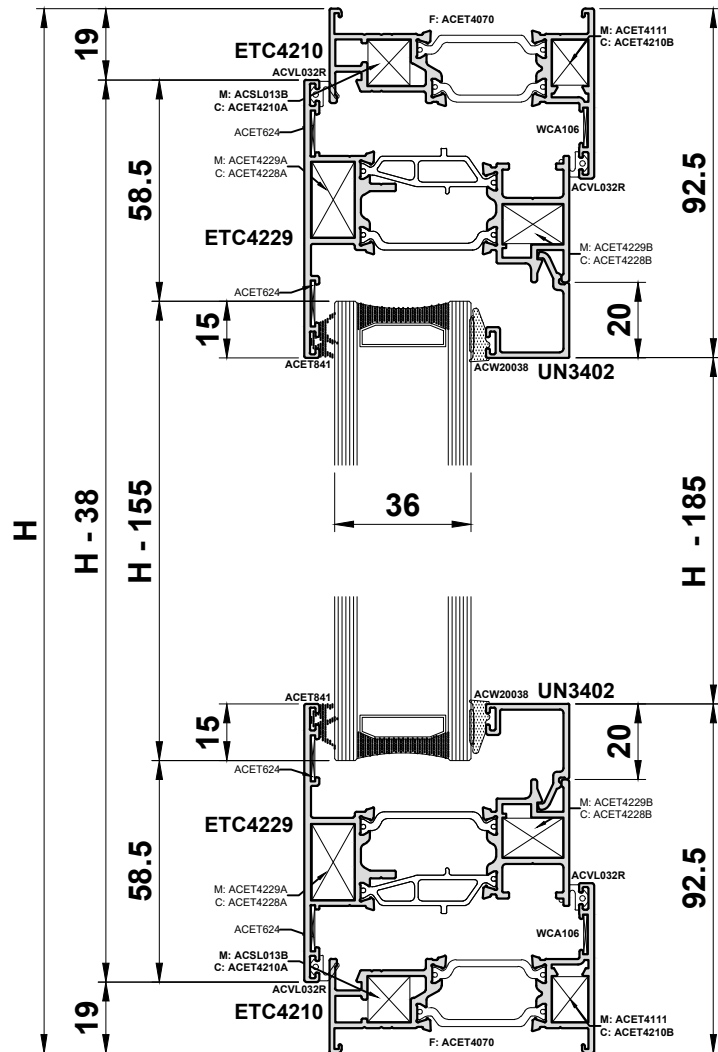
PROFILES

ETC4210	2		W
ETC4210	2		H
ETC4229	2		W - 38
ETC4229	2		H - 38
BEAD	2		W - 145
BEAD	2		H - 185

ACCESSORIES

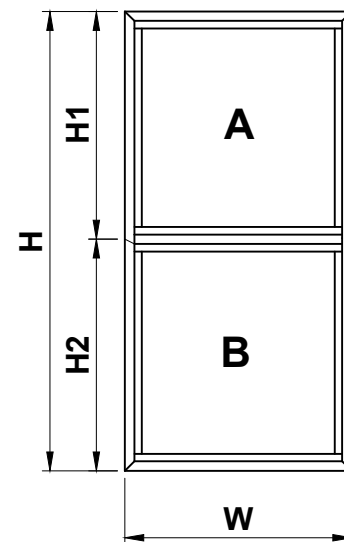
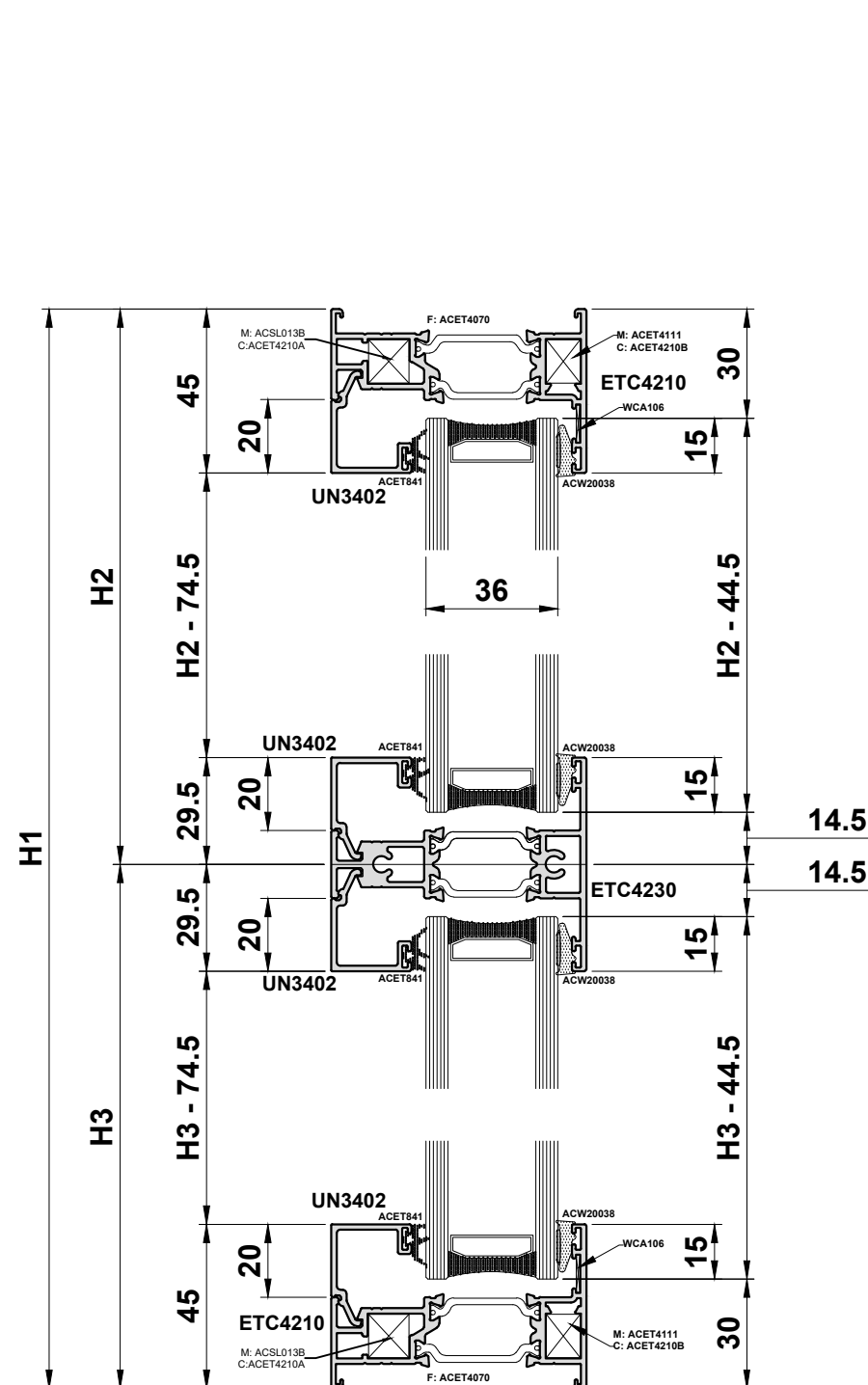
ACET4210A	4	Cleat - Outerframe
ACET4210B	4	Cleat - Outerframe
WCA106	4	Chevron - Outerframe
ACET4228A	4	Cleat - Sash
ACET4228B	4	Cleat - Sash
ACET624	8	Chevron - Sash
ACVL032R	4 (W+H)	Flipper Seal
ACET841	2 (W+H)	E Gasket
ACW20038	2 (W+H)	Wedge Gasket
ACVG560	2 (W+H)-20	Polyamide Foam
ACET4070	2 (W+H)	Cavity Foam
ACET4071	2 (W+H)-95	Sash Polyamide Foam
ACET4081	2 (W+H)-130	Glazing Perimeter Foam

Note: Friction Hinges, Locking & Handles not shown.
Please select preferred options from Section B.



Do Not Scale From This Drawing

Cutting Information



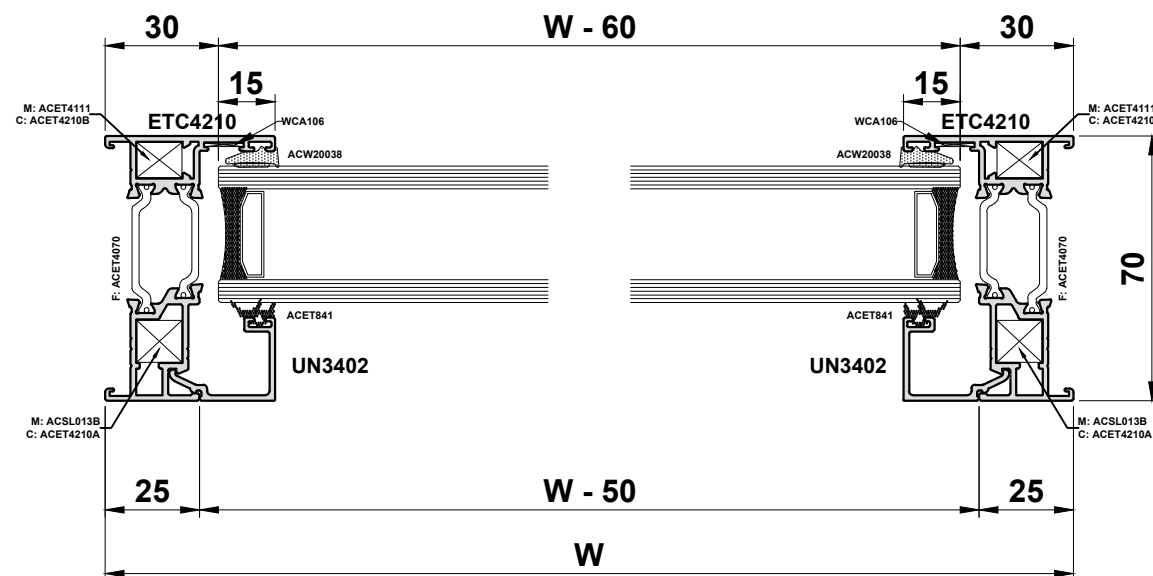
GLASS	
A	W - 60 X H2 - 44.5
B	W - 60 X H3 - 44.5

PROFILES

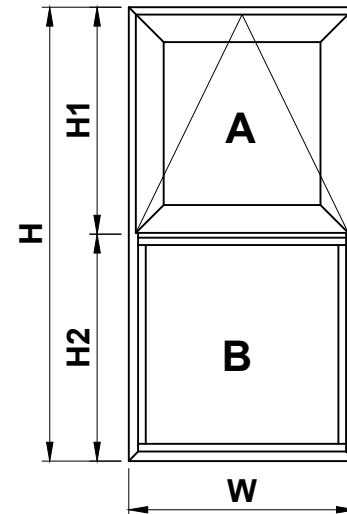
ETC4210	2		W
ETC4210	2		H
ETC4230	1		W - 50
BEAD	4		W - 50
BEAD	2		H2 - 74.5
BEAD	2		H3 - 74.5

ACCESSORIES

ACET4210A	4	Cleat - Outerframe
ACET4210B	4	Cleat - Outerframe
WCA106	4	Chevron - Outerframe
ACIM062	4	Transom Screws
ACET841	2 (W+H)	E Gasket
ACW20038	2 (W+H)	Wedge Gasket
ACVG560	2 (W+H)-20	Polyamide Foam
ACVG560	2 W-50	Transom Polyamide Foam
ACET4070	2 (W+H)	Cavity Foam
ACET4071	2 (W+H)-95	Sash Polyamide Foam
ACET4081	2 (W+H)-130	Glazing Perimeter Foam



Do Not Scale From This Drawing



GLASS	
A	W - 155 X H2 - 139
B	W - 60 X H3 - 44.5

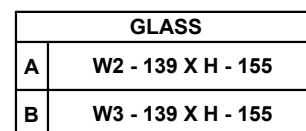
ETC4210	2			W
ETC4210	2			H
ETC4229	2			W - 38
ETC4229	2			H2 - 22
ETC4230	1			W - 50
BEAD	2			W - 145
BEAD	2			H2 - 169
BEAD	2			W - 50
BEAD	2			H3 - 74.5

ACET4210A	4	Cleat - Outerframe
ACET4210B	4	Cleat - Outerframe
WCA106	4	Chevron - Outerframe
ACIM062	4	Transom Screws
ACET4228A	4	Cleat - Sash
ACET4228B	4	Cleat - Sash
ACET624	8	Chevron - Sash
ACET841	2 (W+H)	E Gasket
ACW20038	2 (W+H)	Wedge Gasket
ACVG560	2 (W+H)-20	Polyamide Foam
ACVG560	2 W-50	Transom Polyamide Foam
ACET4070	2 (W+H)	Cavity Foam
ACET4071	2 (W+H)-95	Sash Polyamide Foam
ACET4081	2 (W+H)-130	Glazing Perimeter Foam

[illegible]

PAGE F06

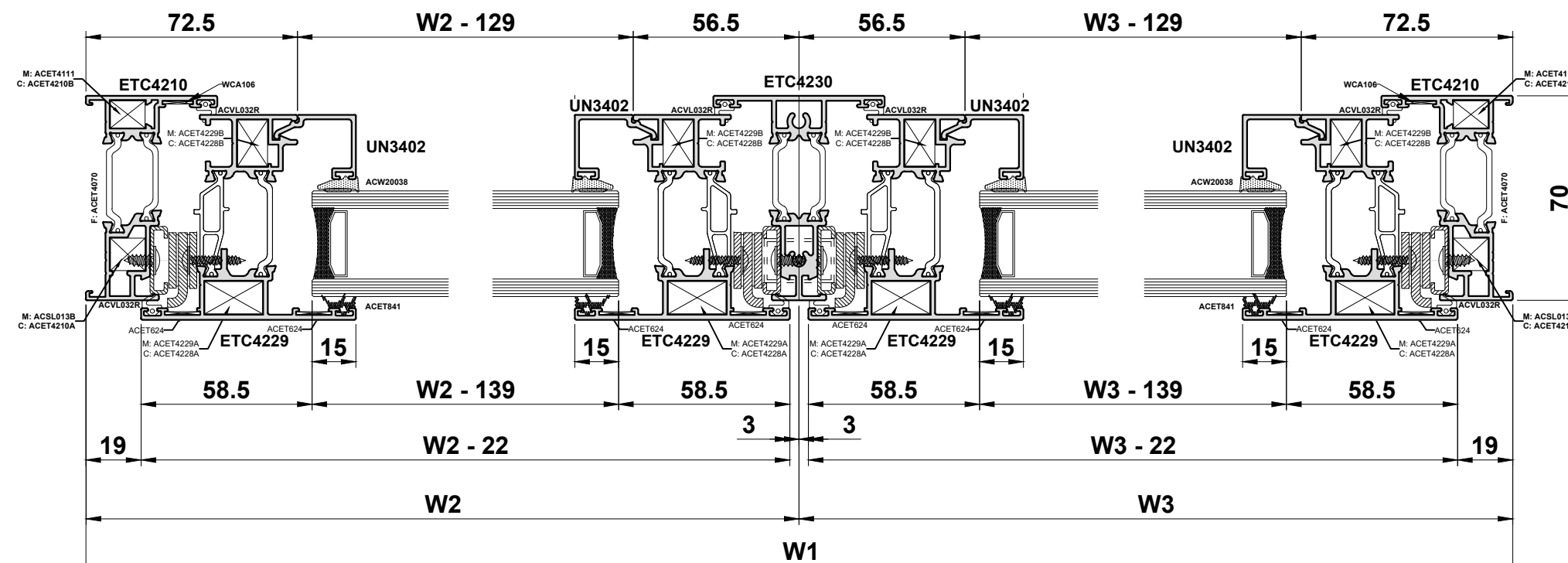
Cutting Information



ETC4210	2			W
ETC4210	2			H
ETC4229	2			W2 - 22
ETC4229	2			W3 - 22
ETC4229	4			H - 38
ETC4230	1			H - 50
UN3402	2			W2 - 129
UN3402	2			W3 - 129
UN3402	4			H - 185

ACET4210A	4	Cleat - Outerframe
ACET4210B	4	Cleat - Outerframe
WCA106	4	Chevron - Outerframe
ACET4228A	8	Cleat - Sash
ACET4228B	8	Cleat - Sash
ACET624	16	Chevron - Sash
ACVL032R	(4W) + (8H)	Flipper Seal
ACET841	(2W) + (4H)	E Gasket
ACW20038	(2W) + (4H)	Wedge Gasket
ACVG560	2 (W+H)-20	Polyamide Foam
ACVG560	2 W-50	Mullion Polyamide Foam
ACET4070	2 (W+H)	Cavity Foam
ACET4071	2 (W+H)-95	Sash Polyamide Foam
ACET4081	2 (W+H)-130	Glazing Perimeter Foam

Note: Friction Hinges, Locking & Handles not shown.
Please select preferred options from Section B.



Do Not Scale From This Drawing

Cutting Information

Do Not Scale From This Drawing