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Updates

DATE	PAGE	DESCRIPTION
JUNE 2024	ALL PAGES	SPLIT MANUAL
AUGUST 2025	Various Pages	Heritage Door
	Various Pages	Foam Insert To ETD447
	E20 & E77	Surfaced Fixed Closure
	E23 & E83	Electric Strike
	E76, E86 & E87	Panic Exit Device
	E22 & E82	Single Door Shootbolt Detail
	E42 & E115	Glazing Packer Placement
JULY 2026	Section A	ETD4304 & ETD4305 Slim Mid-Rails and UN3270 & UN3577 head extensions added.
	Section B	ACSM025 Handle, ACUL421 & ACUL422 Split Spindle Locks added.
	Section E	ACDV737 Bottom Shootbolt location dimensions added.

Specification

GENERAL DESCRIPTION

The Alitherm 400 Door system described in this manual is suitable for domestic or commercial applications as replacement doors for existing buildings, and for installation into new buildings.

The Alitherm 400 Door provides the option of mechanical joints using punch tooling on outer frame and sash.

Stepped & Flush designs are available as:

- Single Open In Doors
- Double Open In Doors
- Single Open Out Doors
- Double Open Out Doors

Alitherm 400 door features Quick-Glaze Beads with integrated gasket, providing a fast and efficient glazing process. Non-integrated gasket options are also available.

PROFILE SPECIFICATION

The door frames are constructed of aluminium alloy extrusion to BS EN 755-9 and BS EN 12020, extruded to 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.

Specification

GENERAL MANUFACTURING

Outer and sash 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 outer frame corner and sash joints can be made using mechanically fixed corner cleats by punching the corners using the relevant punch tooling shown in section E of this manual. The ends of transoms and mullions are profiled to fit the frame and fixed using self-tapping screws with a small joint sealant.

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.

Important Note: All exposed aluminium should be coated using ACSIL014 or painted to match the frame.

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

Size Limitations

Door Type	Min Leaf Width (mm)	Max Leaf Width (mm)	Max Leaf Height (mm)	Overall Width (mm)	Overall Height (mm)
Single Door Open In	600	1100	2400	1164	2464
Double Door Open In	600	1100	2400	2276	2464
Single Door Open Out	600	1100	2400	1164	2464
Double Door Open Out	600	1100	2400	2276	2464

Important Notes:

1. Max leaf weight 130kg
2. Size limitations are based on current profiles using full frame

RECOMMENDED HERITAGE DOOR LIMITATIONS

Door Sashes:

Maximum Width: 1100mm

Minimum Width: 600mm

Maximum Height: 2100mm

Minimum Height: 1000mm (leaving 3 locking points)

Maximum Weight: 60kg

For advice on door sizes outside of the recommended design limitations, please contact the Technical Department at Smart Systems Ltd Tel: 01934 876100

Specification

DOOR DRAINAGE

As with all dry glazed systems, it is recommended that the door 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 above all open-out door leaves and at the bottom of all open-in doors. It is also recommended to use at the bottom of open-out doors where the low ramp threshold are used.

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 assembly the centre line position of any transoms/mullions or mid-rail 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 either drilling or punching, the corners ready for the cleat machine screws. Then, coating the cut faces to be joined with ACSIL04. Into the mitred corner insert the ACSIL013 and the required corner cleats. The two mitred ends are then brought together and screwed. ACSIL04 ensures a permanent joint and guards against the ingress of moisture and joint movement. After screwing the corner joint, special care should be taken to ensure any excess ACSIL04 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. After fixing, special care should be taken to ensure any excess is cleared from painted surfaces.

Specification

SASH

Corners are formed by either drilling or punching, the corners ready for the cleat machine screws. Then, coating the cut faces to be joined with ACSIL04. Into the mitred corner insert the ACSIL013 and the required corner cleats. The two mitred ends are then brought together and screwed. ACSIL04 ensures a permanent joint and guards against the ingress of moisture and joint movement. After screwing the corner joint, special care should be taken to ensure any excess ACSIL04 is removed from painted surfaces

Or the mitred ends can 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.

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 a suitable small gap sealer. Into the mitred corner insert the ACSIL013 and a corner cleat and the required corner chevrons. ACSIL04 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.

Alitherm 400 Door Weather Performance (BS6375-1)

Low thresholds have not been weather tested as they are unlikely to exceed UK exposure category 800 X shown below:

See pages A08 & A09.

Alitherm 400 Door Security (PAS 24)

Alitherm 400 door standard parts are able to achieve PAS24 requirement.

Alitherm 400 Door U Values

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

Specification

GLAZING

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

INTERNALLY BEADED GLAZING

Glazing beads are fitted to openings by cutting the horizontal beads square to head and cill of each sash and reverse adaptor 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

Kitemark™ Certificate

Aluminium Alloy Residential Door System (Slam lock/Key wind/Lift lever)

BS 6375:2016 / PAS 24:2016 - General and enhanced security performance requirements for door assemblies.

Profiles:

Outer Frame: ETD402, 404, 410, 412, 490, 491, 492, 493, 495, 496, 497, 499
Sash: ETD4202, 4203, 4204, 4205, 422, 424, 446, 448
Mid-rail: ETD430, 4301, 4302, 432

Hardware:

Locking: ACUL272, ACUL273, ACUL280, ACUL281, ACUL282, ACUL283, ACUL360, ACUL361, ACUL362, ACUL363, ACUL263, ACUL374, ACUL375, ACUL377, ACUL378, ACUL380, ACUL381, ACUL382, ACUL383, ACUL390, ACDV737, ACDV738, ACDV742, ACDV744, ACPD884, ACPD846, ACPD847, ACPD848, ACPD849
Hinges: ACUL250, ACUL260
Hinge Protectors: ACET252 (not required for PAS24)
Handle: All handles listed in manual
Cylinder: ACCY3560NKS3, ACCY6035NKS3, ACCY3560NKTTS3, ACCY6035NKTTS3

Size Limitations And Performance Characteristics

Door Type	Leaf Width (mm) - Maximum	Leaf Height (mm) - Maximum	Air Permeability Classification	Watertightness Classification	Resistance To Wind Classification	Exposure Category As Given In Table 1 Of BS6375-1:2009
Double Leaf Open In Full Frame	1100	2400	Class 2 Air	Class 3A Water	C3	1200
Double Leaf Open Out Full Frame	1100	2400	Class 2 Air	Class 9A Water	A3	1200
Double Leaf Open In Low Rebate Threshold	1100	2400	Class 3 Air	Class 3A Water	A3	1200
Double Leaf Open Out Low Rebate Threshold	1100	2400	Class 2 Air	Class 4A Water	C3	1200

Specification

Kitemark™ Certificate

Aluminium Alloy Residential Door System (Lift Lever with cams)

BS 6375:2016 / PAS 24:2016 - General and enhanced security performance requirements for door assemblies.

Profiles:

Outer Frame: ETD402, 404, 410, 412, 490, 491, 492, 493, 495, 496, 497, 499
Sash: ETD4202, 4203, 4204, 4205, 422, 424, 445, 447
Mid-rail: ETD430, 4301, 4302, 432

Hardware:

Locking: ACUL267, ACUL268, ACUL276, ACUL277, ACUL278, ACUL279
Hinges: ACUL250, ACUL260
Hinge Protectors: ACET252 (not required for PAS24)
Handle: All handles listed in manual
Cylinder: ACCY3560NKS3, ACCY6035NKS3, ACCY3560NKTTS3, ACCY6035NKTTS3

Size Limitations And Performance Characteristics

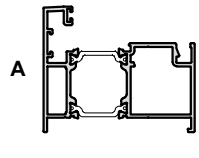
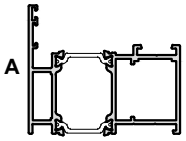
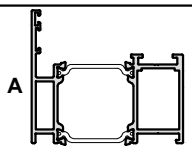
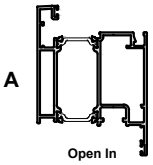
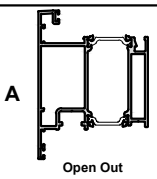
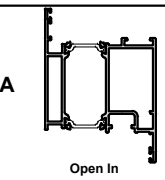
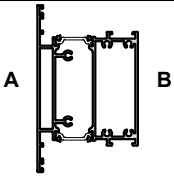
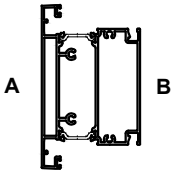
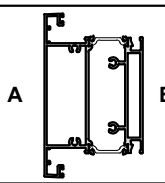
Door Type	Leaf Width (mm) - Maximum	Leaf Height (mm) - Maximum	Air Permeability Classification	Watertightness Classification	Resistance To Wind Classification	Exposure Category As Given In Table 1 Of BS6375-1:2009
Double Leaf Open In Full Frame	1100	2400	Class 4 Air	Class 3A Water	C3	AB2400
Double Leaf Open Out Full Frame	1100	2400	Class 4 Air	Class E 1050 Water	C3	AE2400
Double Leaf Open In Low Rebate Threshold	NOT TESTED					
Double Leaf Open Out Low Rebate Threshold						

Alitherm 400 Stepped Door

ISSUED: JULY 2026

Alitherm 400 Stepped Door

PROFILES : TECHNICAL INFORMATION

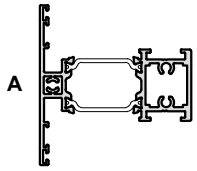
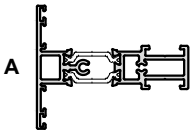
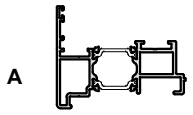
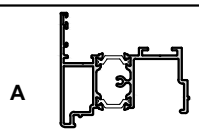
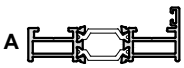
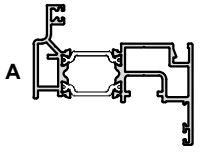
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ETD402		A20	435	144.8	34.66 ---- 8.75	12.59 ---- 4.75	6.5	1	✓	✓	✓	✓	✓
ETD404		A20	420	105.4	34.65 ---- 9.05	12.26 ---- 5.22	6.5	1	✓	✓	✓	✓	✓
ETD410	 Open In Shown Reverse For Open Out	A19	404	114.2	36.73 ---- 9.77	12.14 ---- 5.04	6.5	1	✓	✓	✓	✓	✓
ETD4204	 Open In	A21	589	174.6	52.01 ---- 14.41	43.33 ---- 9.59	6.5	1	✓	✓	✓	✓	✓
ETD4205	 Open Out	A21	581	173.6	50.53 ---- 13.06	42.55 ---- 9.41	6.5	1	✓	✓	✓	✓	✓
ETD424	 Open In	A22	559	163.7	50.15 ---- 14.17	37.54 ---- 7.82	6.5	1	✓	✓	✓	✓	✓
ETD430		A28	711	203.7	63.34 ---- 16.20	81.07 ---- 14.00	6.5	1	✓	✓	✓	✓	✓
ETD4301		A26	765	218.7	61.58 ---- 15.24	100.49 ---- 17.33	6.5	1	✓	✓	✓	✓	✓
ETD4302		A27	779	218.7	65.13 ---- 18.45	99.66 ---- 17.18	6.5	1	✓	✓	✓	✓	✓

A = Outside
B = Inside

MF = Mill Finish
SA = Silver Anodised
KL = Basic Colour
HP = Special Colour
M = Dual Colour

Alitherm 400 Stepped Door

PROFILES : TECHNICAL INFORMATION

Number	Picture	Page	Perim. mm	Mec. mm	Ix(cm4) wx(cm3)	Iy(cm4) wy(cm3)	Length	Pack pr.	MF	SA	KL	HP	M
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ETD433		A29	402	89.8	29.52 ---- 7.17	4.96 ---- 1.75	6.5	1	✓	✓	✓	✓	✓
ETD447	 Open In Shown Reverse for Open Out	A25	419	100.2	35.85 — 8.28	8.67 — 3.5	6.5	1	✓	✓	✓	✓	✓
ETD448	 Open In Shown Reverse for Open Out	A25	526	125.5	51.81 — 10.34	13.04 — 4.43	6.5	1	✓	✓	✓	✓	✓
ETD490		A23	335	64.7	44.19 — 8.28	1.45 — 1.56	6.5	1	✓	✓			
ETD492		A23	282	41.2	18.63 — 5.05	0.98 — 1.05	6.5	1	✓	✓			
ETD495		A24	295	78	33.27 — 7.36	1.06 — 1.29	6.5	1	✓	✓			
ETD496	 Open In Shown Reverse for Open Out	A24	282	26.2	10.64 — 3.07	0.92 — 1.07	6.5	1	✓	✓	✓	✓	✓
ETD4220		A30	413	104	34.82 — 9.46	8.85 — 3.11	6.5	1	✓	✓	✓	✓	✓

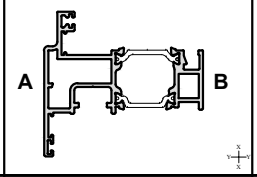
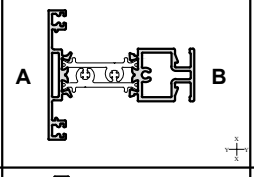
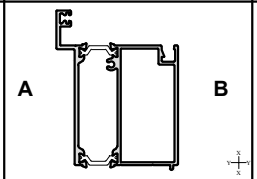
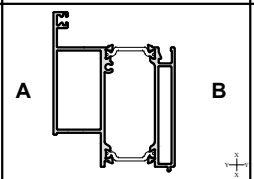
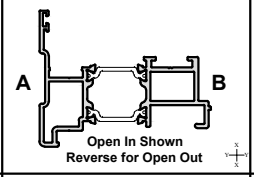
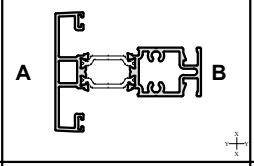
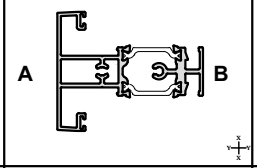
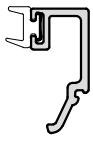
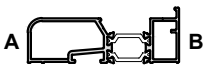
A = Outside
B = Inside

MF = Mill Finish
SA = Silver Anodised
KL = Basic Colour
HP = Special Colour
M = Dual Colour

ISSUED: JULY 2026

Alitherm 400 Stepped Door

PROFILES : TECHNICAL INFORMATION

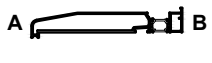
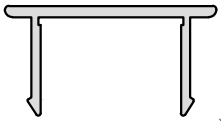
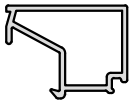
Number	Picture	Page	Perim. mm	Mec. mm	Ix(cm4) wx(cm3)	Iy(cm4) wy(cm3)	Length	Pack pr.	MF	SA	KL	HP	M
ETD4221		A30	430	108	34.83 — 9.12	10.38 — 3.52	6.5	1	✓	✓	✓	✓	✓
ETD4230		A31	379	100	24.76 — 6.71	6.83 — 2.40	6.5	1	✓	✓	✓	✓	✓
ETD4238		A33	505	165	28.99 — 8.92	38.08 — 9.54	6.5	1	✓	✓	✓	✓	✓
ETD4239		A33	491	139	38.18 — 11.20	43.85 — 11.13	6.5	1	✓	✓	✓	✓	✓
ETD4247		A31	411	104	35.11 — 8.30	9.77 — 4.02	6.5	1	✓	✓	✓	✓	✓
ETD4304		A32	434	107	30.95 — 7.89	8.80 — 3.09	6.5	1	✓	✓	✓	✓	✓
ETD4305		A32	491	107	30.35 — 7.51	8.41 — 2.95	6.5	1	✓	✓	✓	✓	✓
ETC4179G ETC4179		A34	104	29	- ---- -	- ---- -	6.5	1	✓	✓	✓	✓	
ETC451		A41	271	180	32.44 — 7.29	3.46 — 2.79	6.5	1	✓	✓	✓	✓	✓

A = Outside
B = Inside

MF = Mill Finish
SA = Silver Anodised
KL = Basic Colour
HP = Special Colour
M = Dual Colour

Alitherm 400 Stepped Door

PROFILES : TECHNICAL INFORMATION

Number	Picture	Page	Perim. mm	Mec. mm	Ix(cm4) wx(cm3)	Iy(cm4) wy(cm3)	Length	Pack pr.	MF	SA	KL	HP	M
ETC452		A41	414	382	122.46 — 18.03	6.01 — 3.34	6.5	1	✓	✓	✓	✓	✓
ETC457		A41	444	412	163.27 — 21.60	6.79 — 3.73	6.5	1	✓	✓	✓	✓	✓
ETC458		A42	524	492	313.62 — 32.63	8.87 — 4.79	6.5	1	✓	✓	✓	✓	✓
ETC479N		A42	594	559	501.64 — 44.04	9.72 — 5.34	6.5	1	✓	✓	✓	✓	✓
ETC572		A22	82	40	- ---- -	- ---- -	6.5	1	✓	✓	✓	✓	✓
EUD03		A24	113	39	- ----- -	- ----- -	4	1	✓	✓			
PCX47		A22	43.4	---	- — -	- — -	6.5	1					
SR014		A40	110.4	31.7	- — -	- — -	7	1	✓	✓	✓	✓	
UL062		A36	115	49	- — -	- — -	6.5	1	✓	✓	✓	✓	

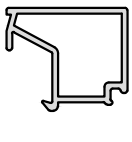
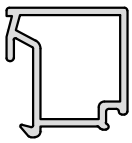
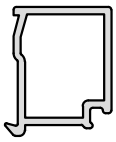
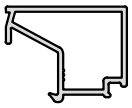
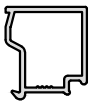
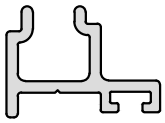
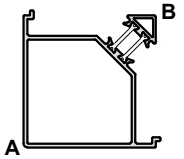
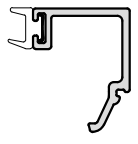
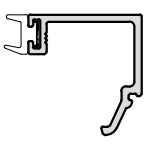
A = Outside
B = Inside

MF = Mill Finish
SA = Silver Anodised
KL = Basic Colour
HP = Special Colour
M = Dual Colour

ISSUED: JULY 2026

Alitherm 400 Stepped Door

PROFILES : TECHNICAL INFORMATION

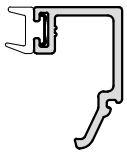
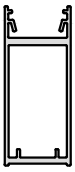
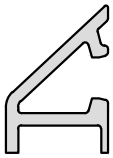
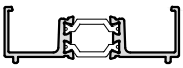
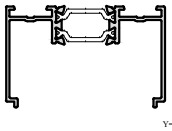
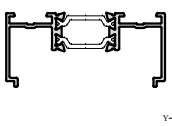
Number	Picture	Page	Perim. mm	Mec. mm	Ix(cm4) wx(cm3)	Iy(cm4) wy(cm3)	Length	Pack pr.	MF	SA	KL	HP	M
UL067		A36	110	46	- — -	- — -	6.5	1	✓	✓	✓	✓	
UL068		A36	101	40	- — -	- — -	6.5	1	✓	✓	✓	✓	
UL069		A36	87	48	- — -	- — -	6.5	1	✓	✓	✓	✓	
UL078		A36	120	51.9	- ---- -	- ---- -	6.5	1	✓	✓	✓	✓	
UL079		A36	96	43	- ---- -	- ---- -	6.5	1	✓	✓	✓	✓	
UL297		A23	106	12	- — -	- — -	6.5	1	✓	✓	✓	✓	
UN3010		A39	369	226	41.4 — 10.7	40 — 11.6	6.5	1	✓	✓	✓	✓	✓
UN3160G UN3160		A34	120	39	- ---- -	- ---- -	6.5	1	✓	✓	✓	✓	
UN3162NG UN3162N		A34	105	41	- ---- -	- ---- -	6.5	1	✓	✓	✓	✓	

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Alitherm 400 Stepped Door

PROFILES : TECHNICAL INFORMATION

Number	Picture	Page	Perim. mm	Mec. mm	Ix(cm4) wx(cm3)	Iy(cm4) wy(cm3)	Length	Pack pr.	MF	SA	KL	HP	M
UN3164G UN3164		A35	112	33	- ---- -	- ---- -	6.5	1	✓	✓	✓	✓	
UN3166		A35	98	43	- -- -	- -- -	6.5	1	✓	✓	✓	✓	
UN3168		A35	65	23	- -- -	- -- -	6.5	1	✓	✓	✓	✓	
UN514		A40	282.7	157.1	35.14 -- 8.74	8.86 -- 5.47	6.5	1	✓	✓	✓	✓	
VL72		A22	99.5	30.6	- -- -	- -- -	6.5	1	✓	✓	✓	✓	
UN3015		A39	214.5	56	18.1 --- 5.2	1 --- 1	6.5	1	✓	✓	✓	✓	✓
UN3020		A37	281.6	70.4	14.8 --- 4.2	0.9 --- 1	6.5	1	✓	✓	✓	✓	✓
UN3270		A37	407	85	23.39 --- 6.68	5.8 --- 1.83	6.5	1	✓	✓	✓	✓	✓
UN3370		A37	360	61	18.4 --- 5.26	2.15 --- 1.97	6.5	1	✓	✓	✓	✓	✓

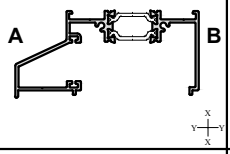
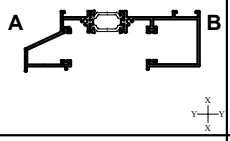
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KL = Basic Colour
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ISSUED: JULY 2026

Alitherm 400 Stepped Door

PROFILES : TECHNICAL INFORMATION

Number	Picture	Page	Perim. mm	Mec. mm	Ix(cm4) wx(cm3)	Iy(cm4) wy(cm3)	Length	Pack pr.	MF	SA	KL	HP	M
UN3570		A38	545	140	47.47 --- 9.53	9.26 --- 4.87	6.5	1	✓	✓	✓	✓	✓
UN3577		A38	751	178	117.89 --- 17.11	15.81 --- 8.83	6.5	1	✓	✓	✓	✓	✓

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Alitherm 400 Stepped Door

PROFILES : TECHNICAL INFORMATION

Number	Picture	Page	Perim. mm	Mec. mm	Ix(cm4) wx(cm3)	Iy(cm4) wy(cm3)	Length	Pack pr.	MF	SA	KL	HP	M

A = Outside
B = Inside

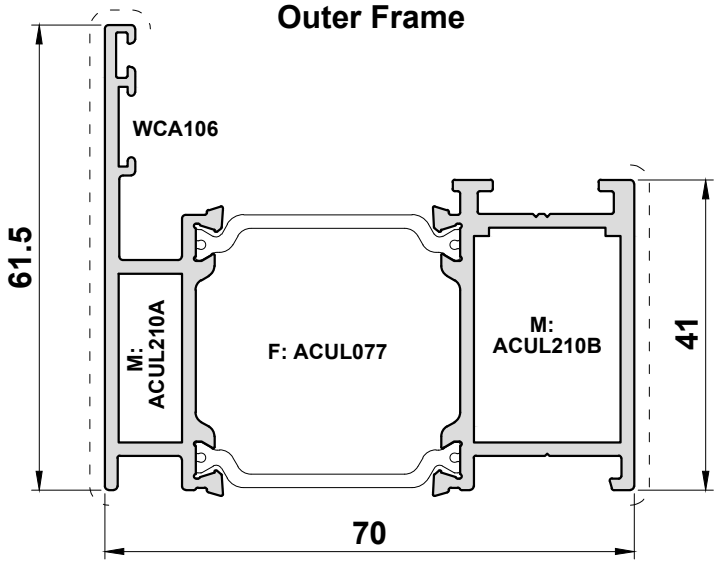
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SA = Silver Anodised
KL = Basic Colour
HP = Special Colour
M = Dual Colour

ISSUED: JULY 2026

Primary Visible Side - - - - - - - - - - - - - - - - - - Secondary Visible Side — · — — · — — · — — · — — · —

ETD410

Outer Frame

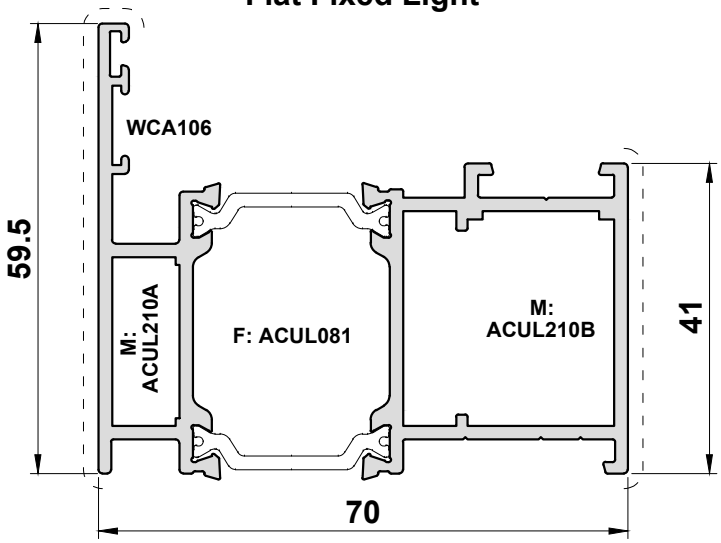


Scale 1:1

Primary Visible Side - - - - - - - - - - - - - - - - - - Secondary Visible Side — · — · — · — · — · — · —

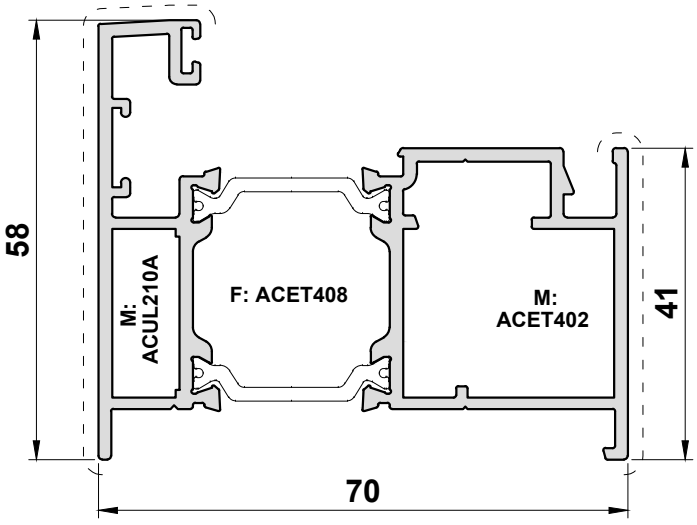
ETD404

Flat Fixed Light



ETD402

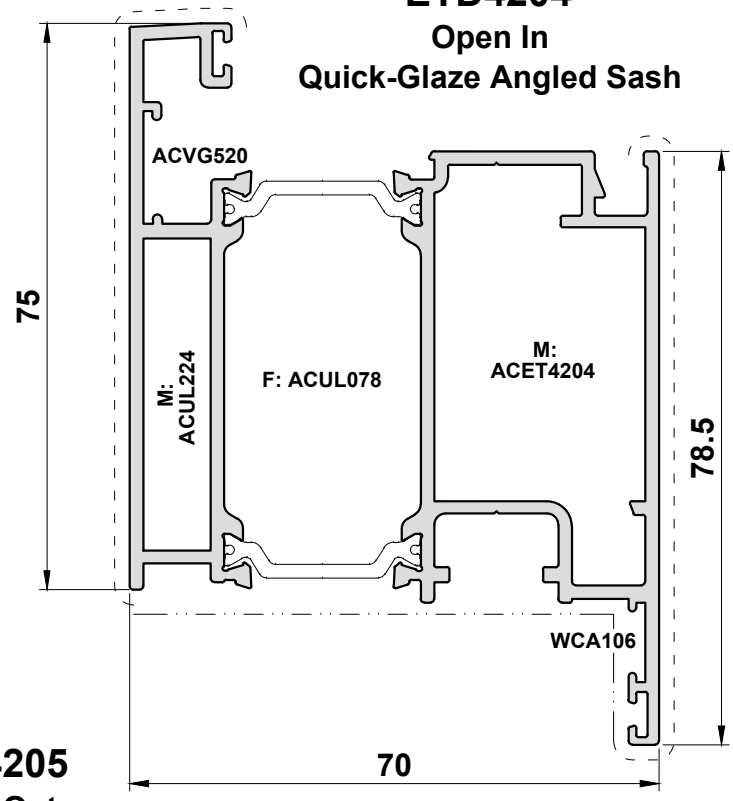
Quick-Glaze Angled Fixed Light



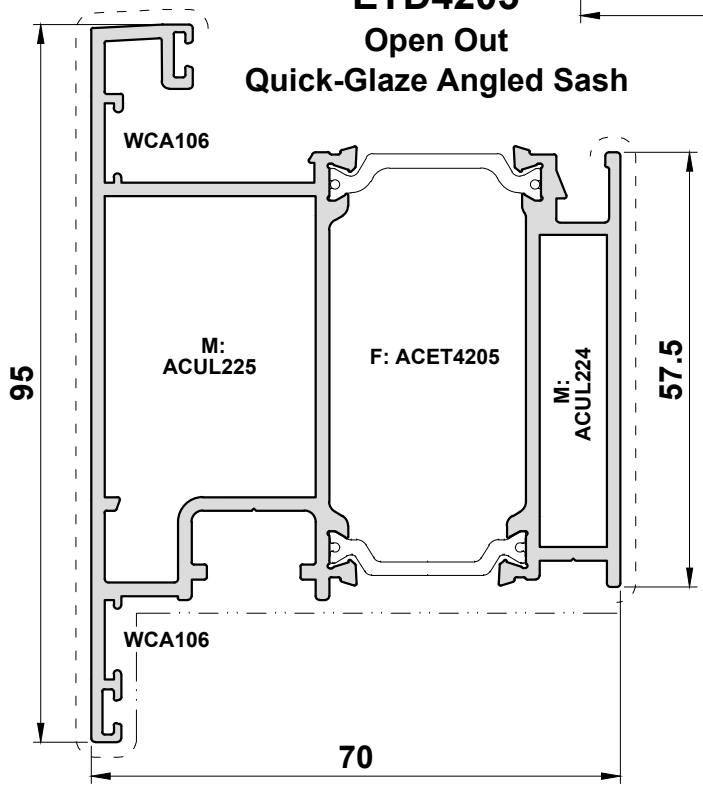
Scale 1:1

Primary Visible Side - - - - - - - - - - - - - - - - - - Secondary Visible Side —·—·—·—·—·—·—·—

ETD4204
Open In
Quick-Glaze Angled Sash



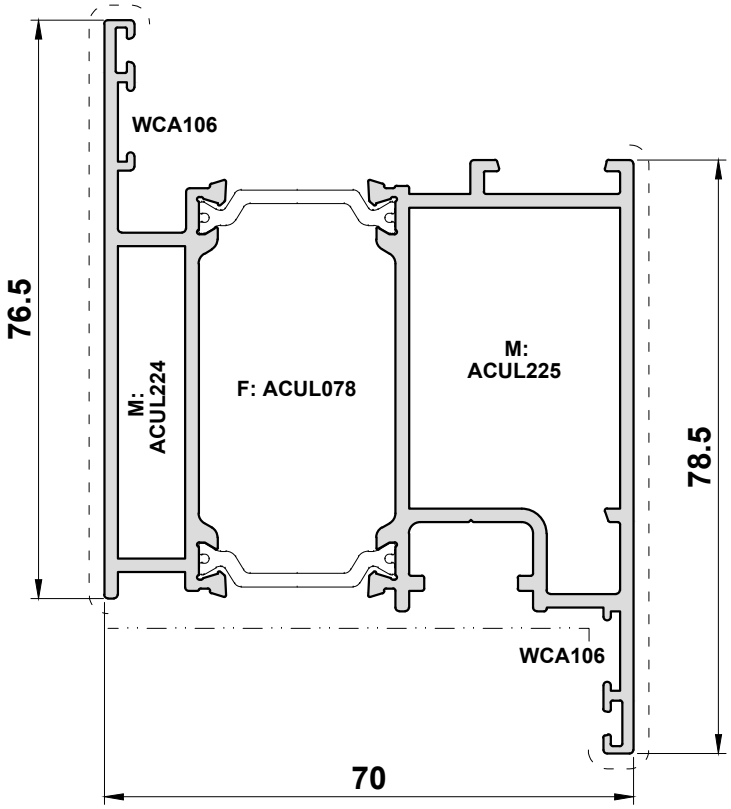
ETD4205
Open Out
Quick-Glaze Angled Sash



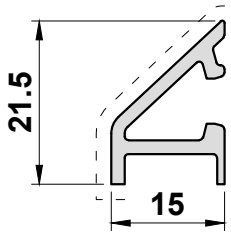
Scale 1:1

Primary Visible Side - - - - - - - - - - - - - - - - - Secondary Visible Side — · — · — · — · — · — · —

ETD424
Open In Flat Sash

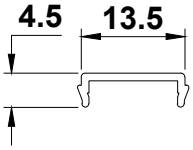


VL72
Weather Drip

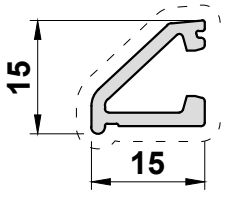


End Cap: ACVL059
Rivet: ACVL061

PCX47
PVC Infill



ETC572
Weather Drip



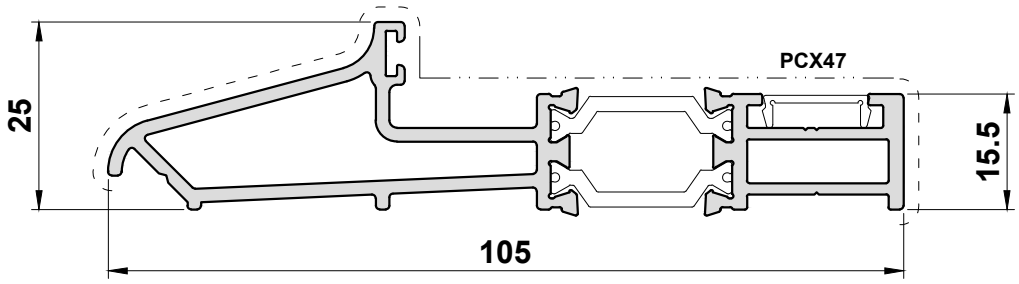
End Cap: ACET572
Rivet: ACVL061

Scale 1:1

Primary Visible Side - - - - - - - - - - - - - - - - - - Secondary Visible Side —·—·—·—·—·—·—·—

ETD490

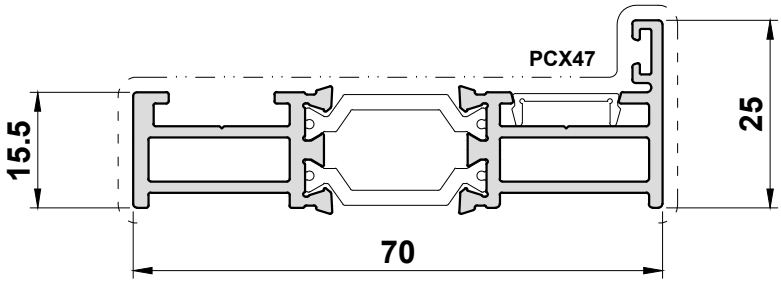
Open In Low Threshold



End Cap: ACET4190

ETD492

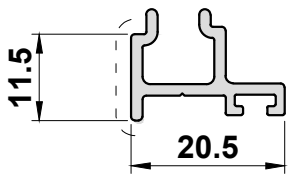
Open Out Low Threshold



End Cap: ACET4192

UL297

Low Threshold Adaptor



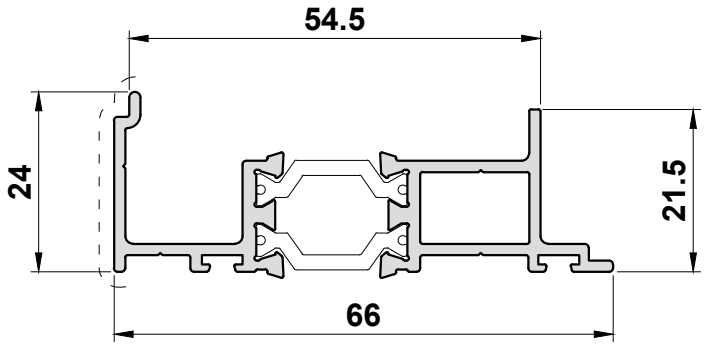
End Cap: ACET4197

Scale 1:1

Primary Visible Side - - - - - - - - - - - - - - - - - - Secondary Visible Side — · — · — · — · — · — · —

ETD496

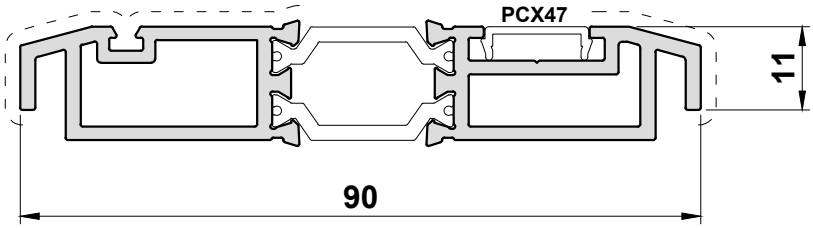
Door Threshold Ramp Adaptor



End Cap: ACET4196

ETD495

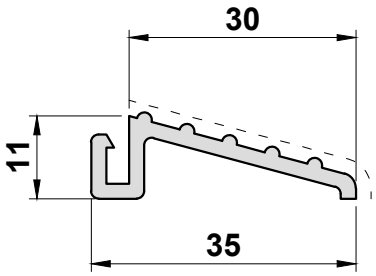
Door Threshold Ramp



End Cap: ACET4195

EUD03

Ramp

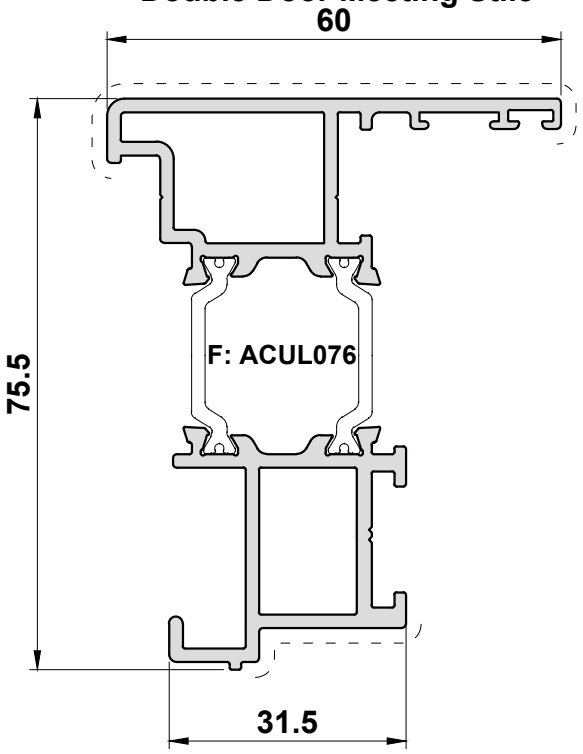


Scale 1:1

Primary Visible Side - - - - - - - - - - - - - - - - - - Secondary Visible Side — · — · — · — · — · — · —

ETD447

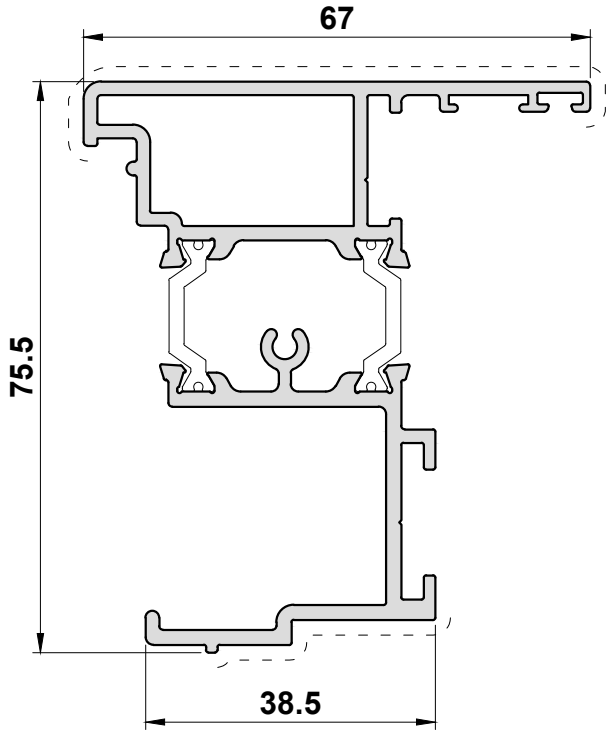
Double Door Meeting Stile



End Cap: ACET4142
ACET4146 /
ACET4147

ETD448

Double Door Meeting Stile



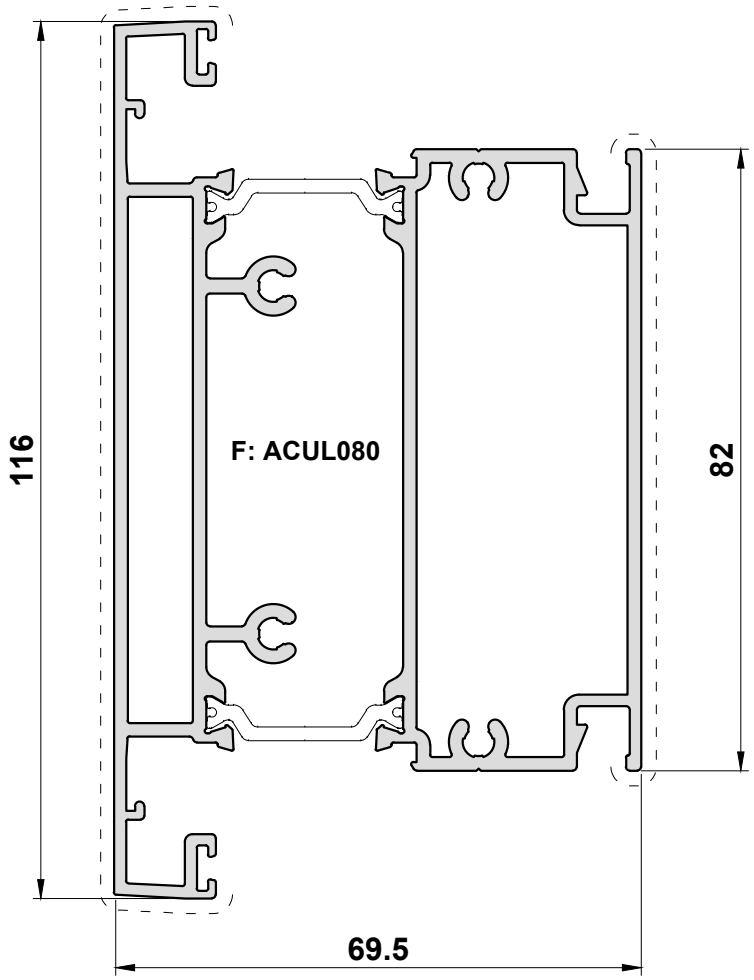
End Cap: ACET4143
ACET4145 /
ACET4148

Scale 1:1

Primary Visible Side - - - - - - - - - - - - - - - - - - Secondary Visible Side — · — · — · — · — · — · —

ETD4301

Open In
Quick-Glaze Angled Midrail



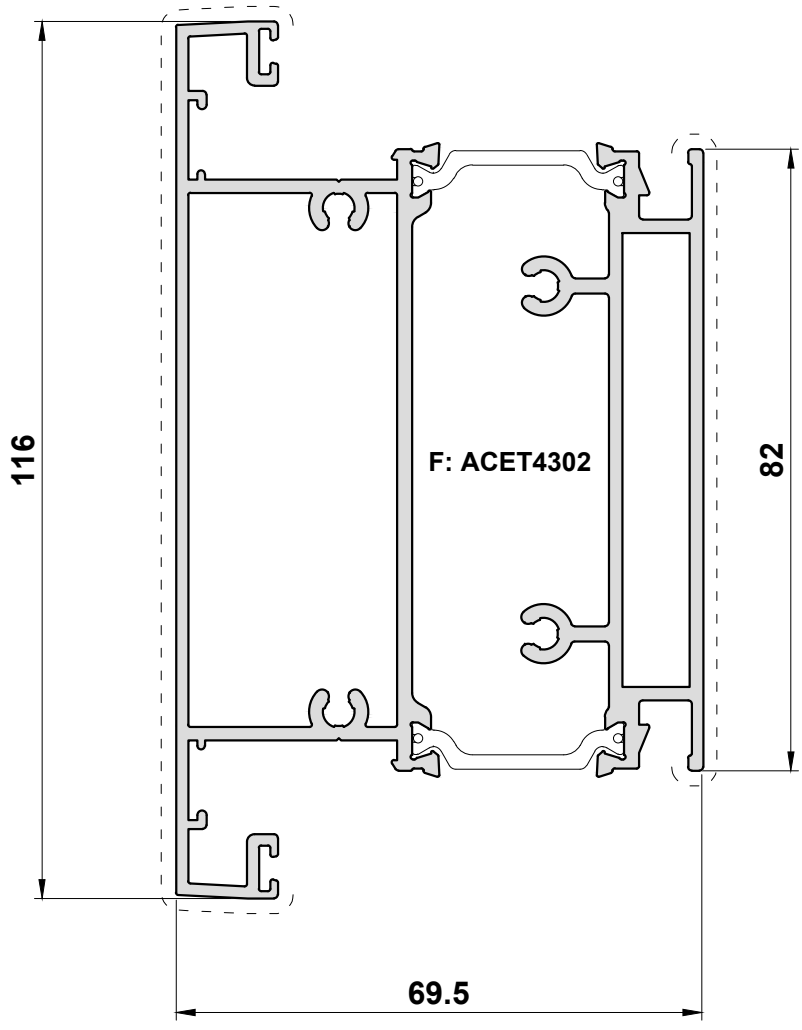
Scale 1:1

Primary Visible Side - - - - - - - - - - - - - - - - - - Secondary Visible Side — · — · — · — · — · —

ETD4302

Open Out

Quick-Glaze Angled Midrail

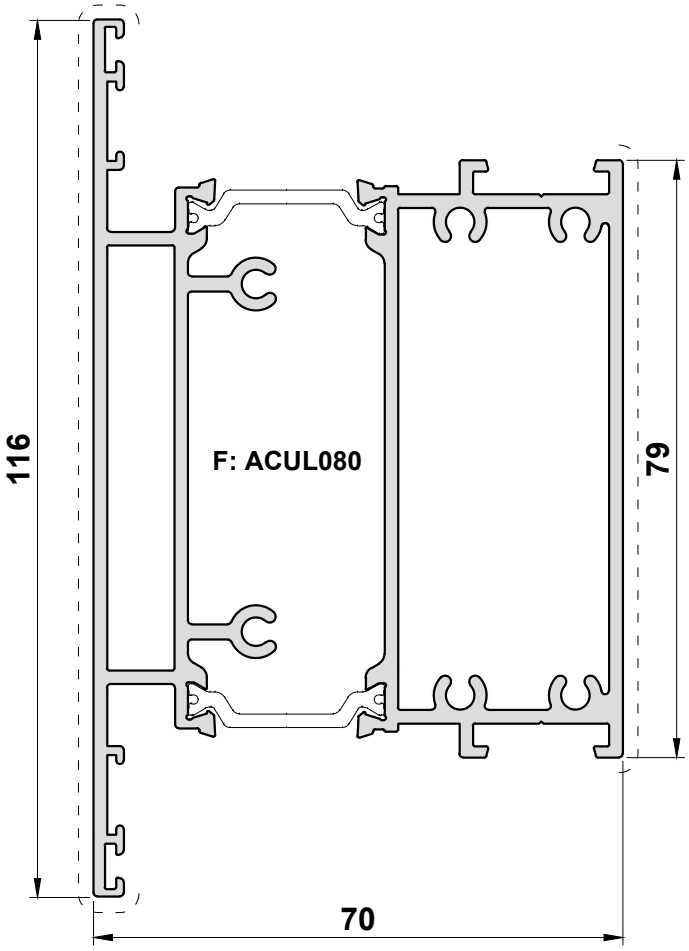


Scale 1:1

Primary Visible Side - - - - - - - - - - - - - - - - - - Secondary Visible Side — · — · — · — · — · — · —

ETD430

Flat Midrail

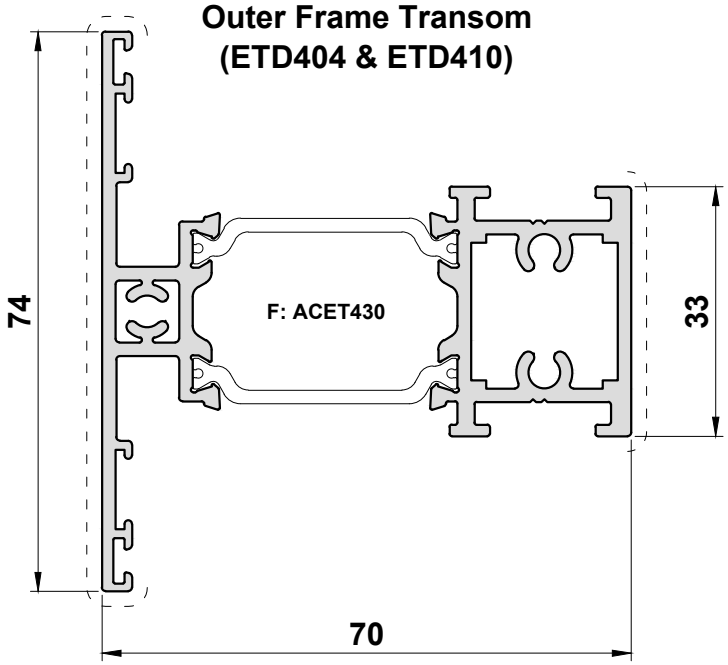


Scale 1:1

Primary Visible Side - - - - - - - - - - - - - - - - - - Secondary Visible Side — · — — · — — · — — · — —

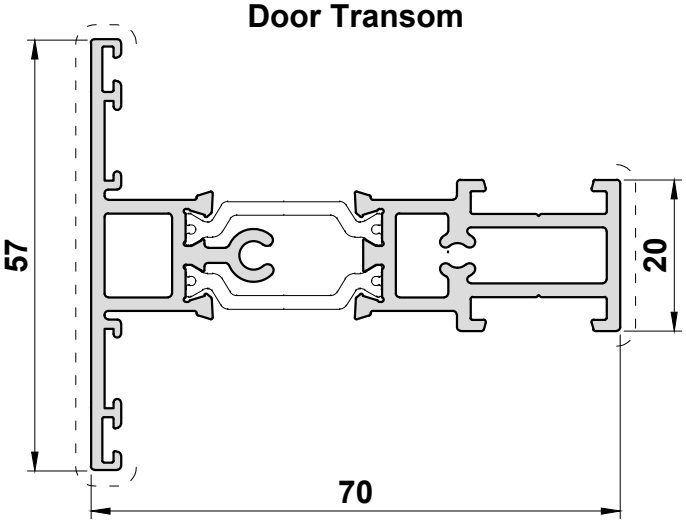
ETD432

Outer Frame Transom
(ETD404 & ETD410)



ETD433

Door Transom



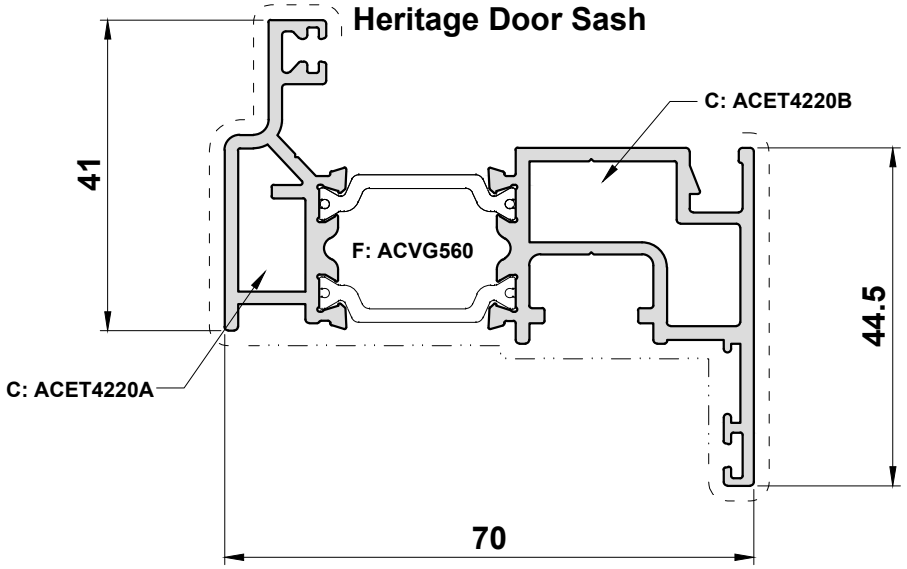
Scale 1:1

Primary Visible Side - - - - - - - - - - - - - - - - - - Secondary Visible Side —·—·—·—·—·—·—·—

ETD4220

Open In

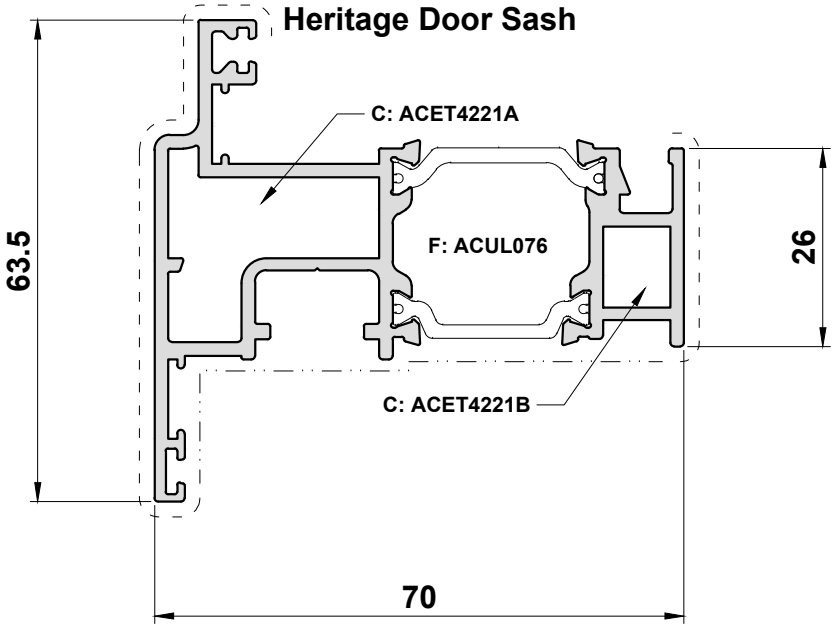
Heritage Door Sash



ETD4221

Open Out

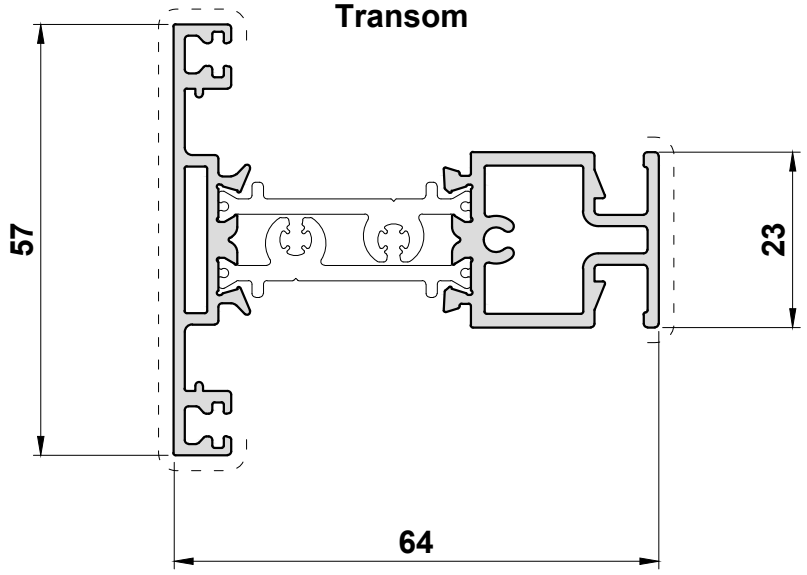
Heritage Door Sash



Scale 1:1

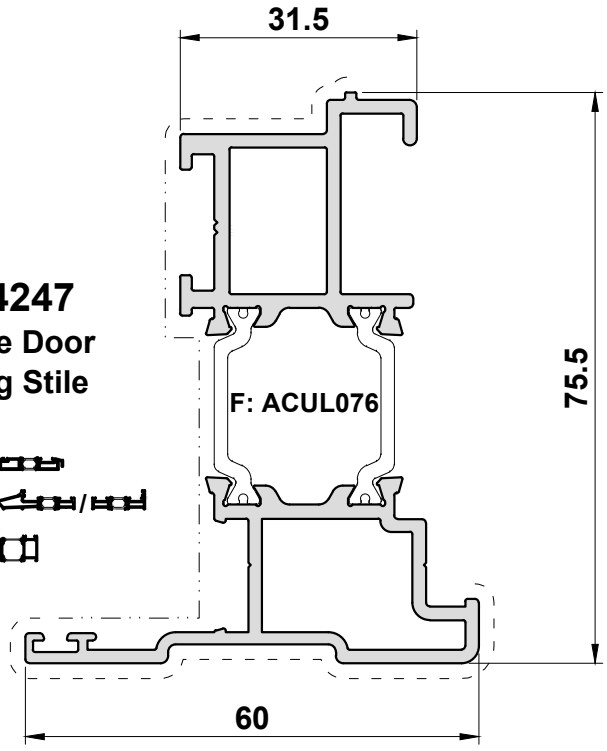
Primary Visible Side - - - - - - - - - - - - - - - - - - Secondary Visible Side — · — · — · — · — · — · —

ETD4230
Heritage Door Transom



ETD4247
Heritage Door Meeting Stile

End Cap: ACET4242
ACET4246
ACET4247

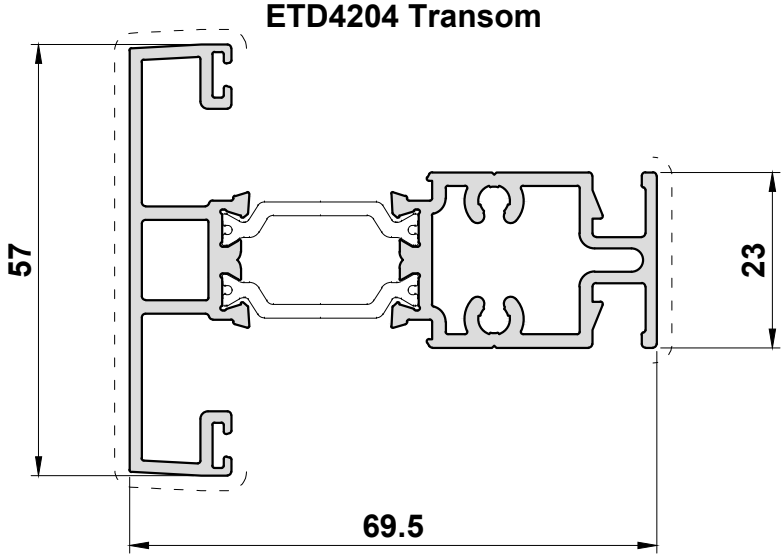


Scale 1:1

Primary Visible Side - - - - - - - - - - - - - - - - - - Secondary Visible Side — · — — · — — · — — · — — · —

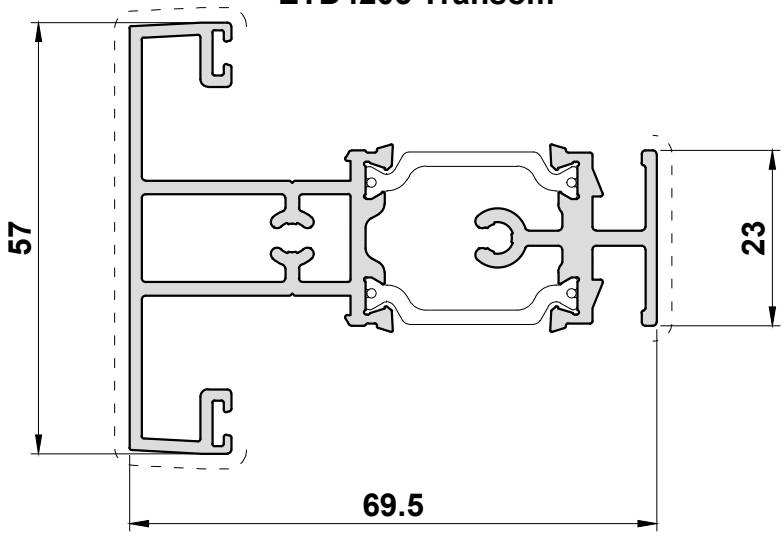
ETD4304

ETD4204 Transom



ETD4305

ETD4205 Transom



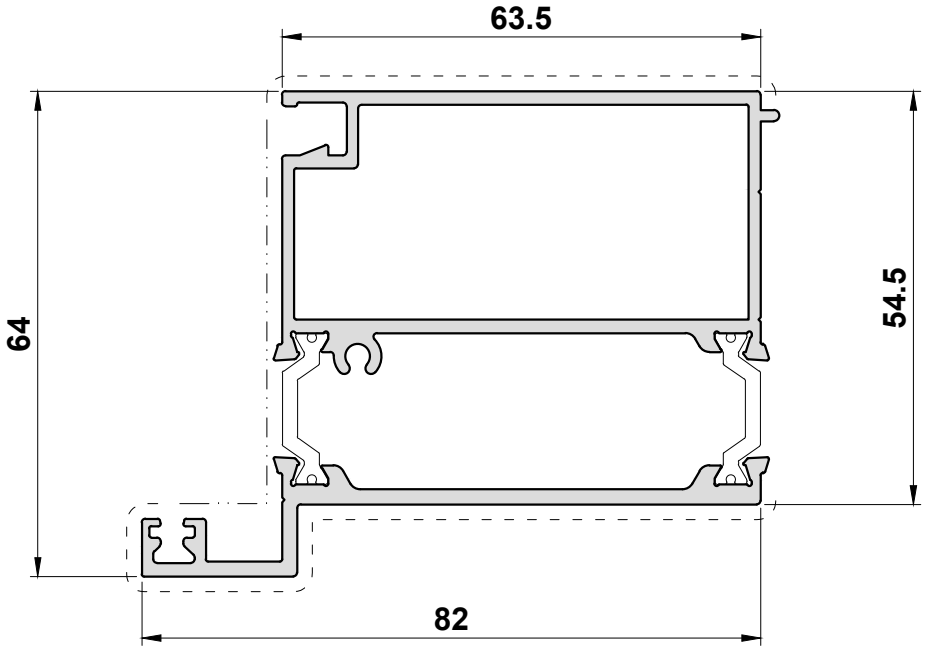
Scale 1:1

Primary Visible Side - - - - - - - - - - - - - - - - - - Secondary Visible Side —·—·—·—·—·—·—·—

ETD4238

Open In

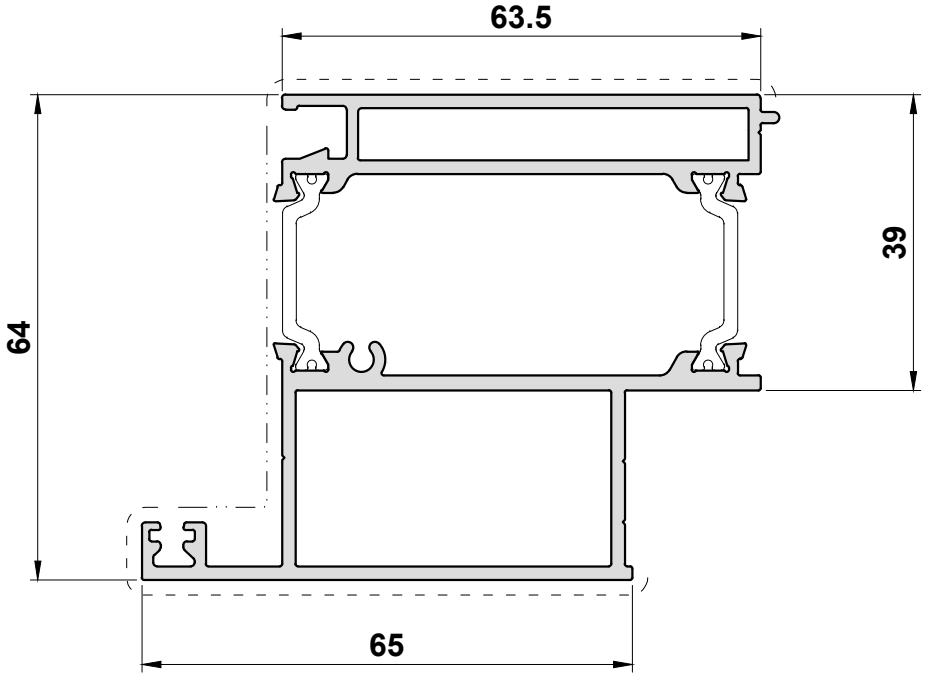
Heritage Door Lock Box



ETD4239

Open Out

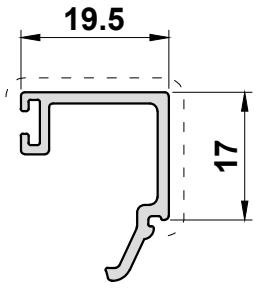
Heritage Door Lock Box



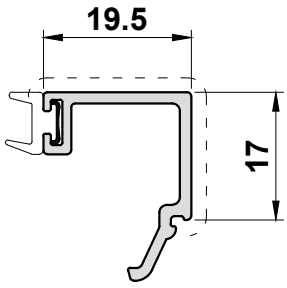
Scale 1:1

Primary Visible Side - - - - - - - - - - - - - - - - - - Secondary Visible Side —·—·—·—·—·—·—·—

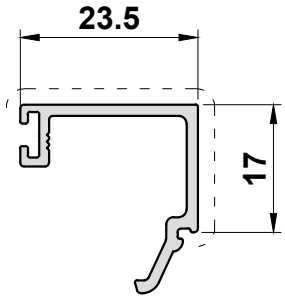
UN3160
28mm Square Bead



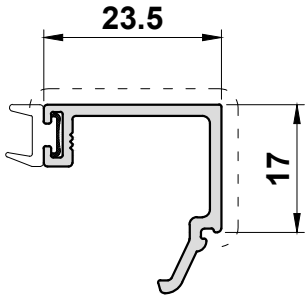
UN3160G
28mm Square Bead with Gasket



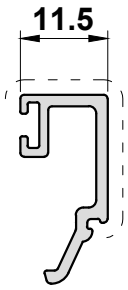
UN3162N
23.5mm Bead



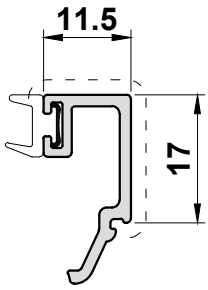
UN3162NG
23.5mm Bead with Gasket



ETC4179
11.5mm Bead



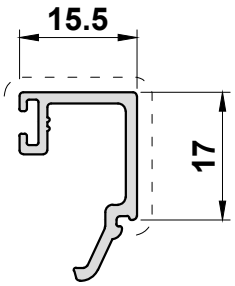
ETC4179G
11.5mm Bead with Gasket



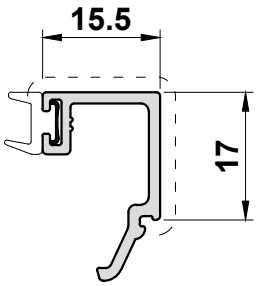
Scale 1:1

Primary Visible Side - - - - - - - - - - - - - - - - - - Secondary Visible Side —·—·—·—·—·—·—·—

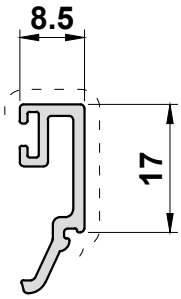
UN3164
15mm Bead



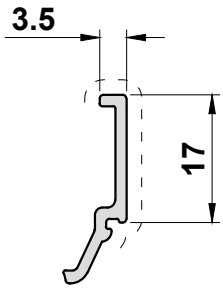
UN3164
15mm Bead with Gasket



UN3166
8.5mm Bead



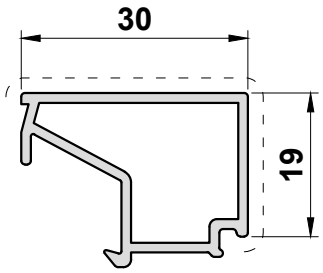
UN3168
3.5mm Bead



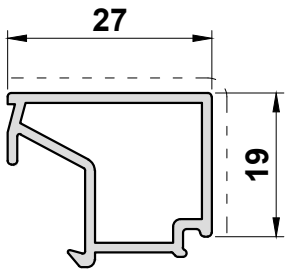
Scale 1:1

Primary Visible Side - - - - - - - - - - - - - - - - - - Secondary Visible Side — · — · — · — · — · — · —

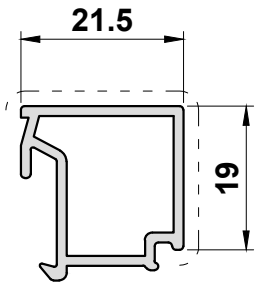
UL062
Glazing Bead



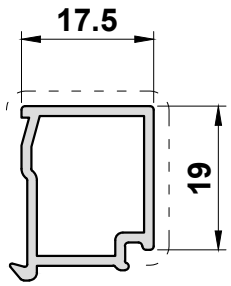
UL067
Glazing Bead



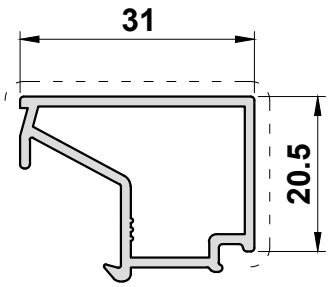
UL068
Glazing Bead



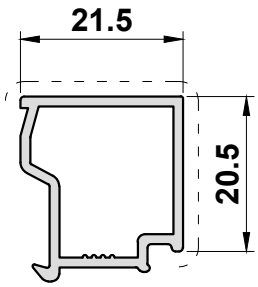
UL069
Glazing Bead



UL078
Glazing Bead



UL079
Glazing Bead

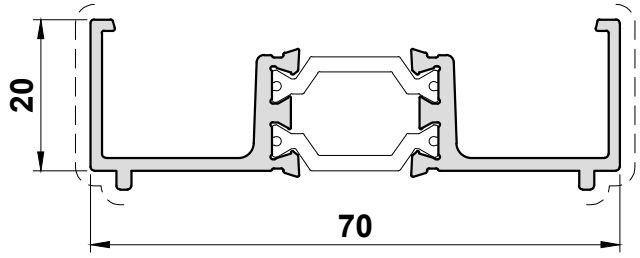


Scale 1:1

Primary Visible Side - - - - - - - - - - - - - - - - - - Secondary Visible Side — · — — · — — · — — · — — · —

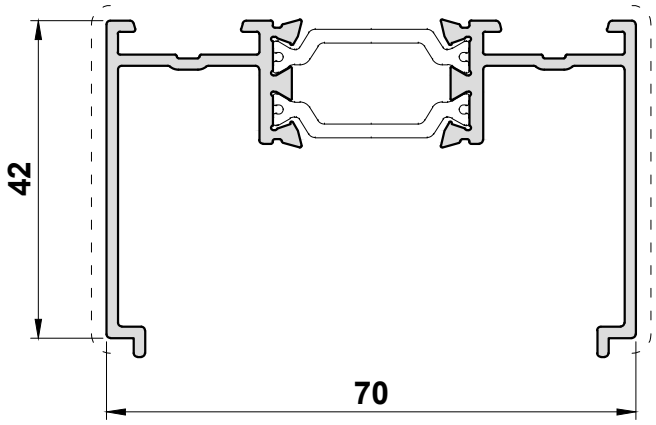
UN3020

70mm x 20mm Frame Extension



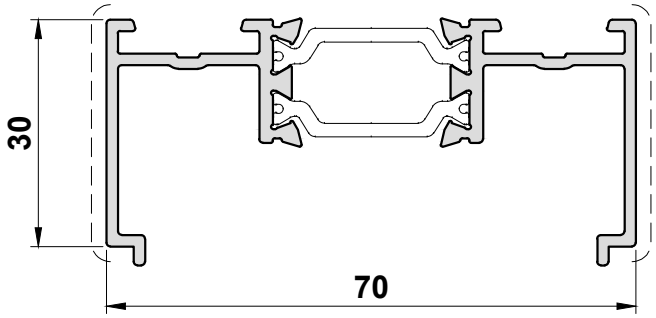
UN3270

70 x 42mm Head Extension



UN3370

30 x 70mm Head Extension

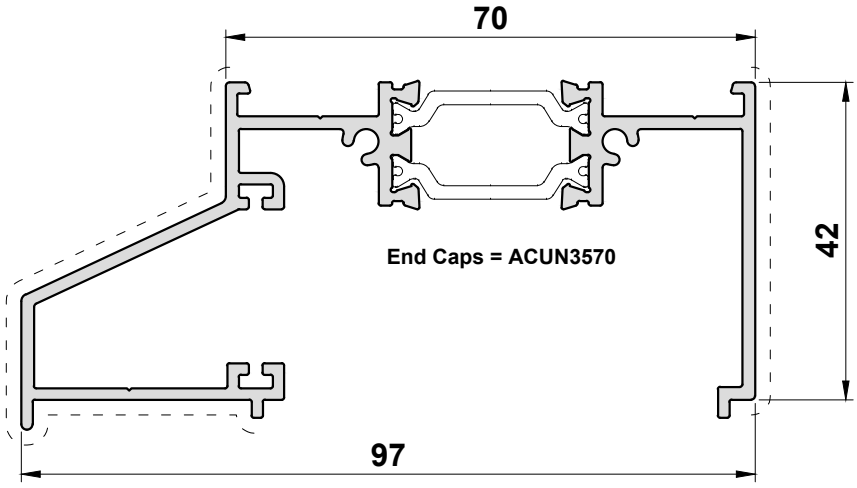


Scale 1:1

Primary Visible Side - - - - - - - - - - - - - - - - - - Secondary Visible Side — · — · — · — · — · — · —

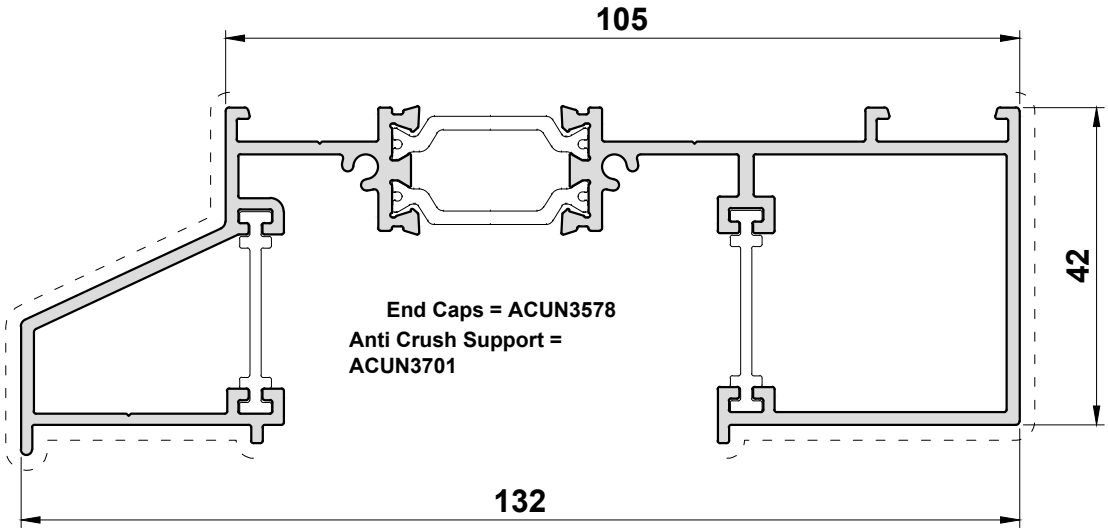
UN3570

70 x 42mm Hooded Head Extension



UN3577

70 x 42mm Hooded Head Extension

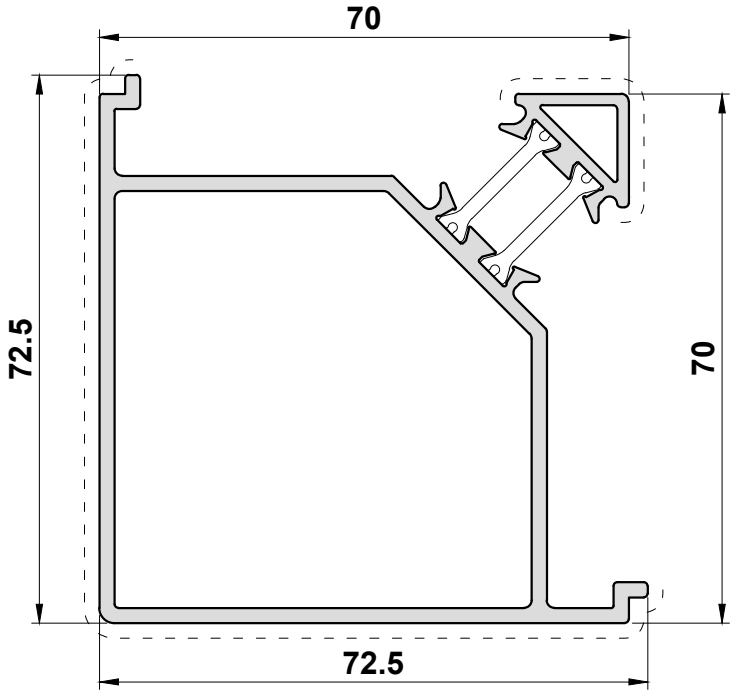


Scale 1:1

Primary Visible Side - - - - - - - - - - - - - - - - - - Secondary Visible Side — · — — · — — · — — · — — · —

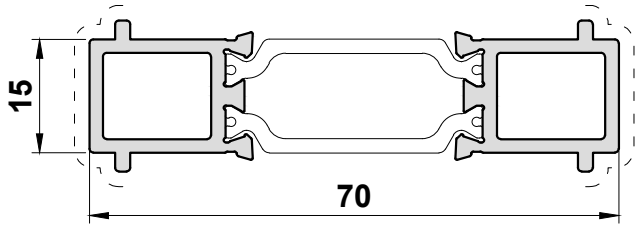
UN3010

90° Corner Post



UN3015

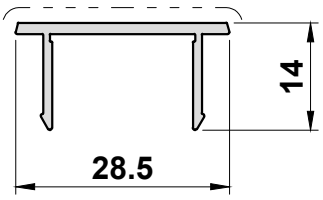
70mm x 15mm Coupler



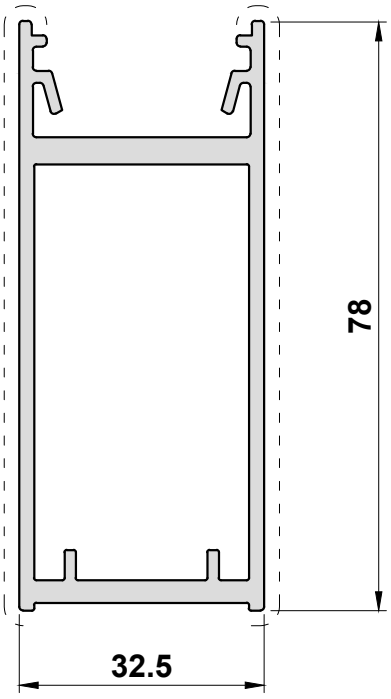
Scale 1:1

Primary Visible Side - - - - - - - - - - - - - - - - - Secondary Visible Side — · — · — · — · — · — · —

SR014
Cover Cap for UN514



UN514
Re-Inforcement for ETD455



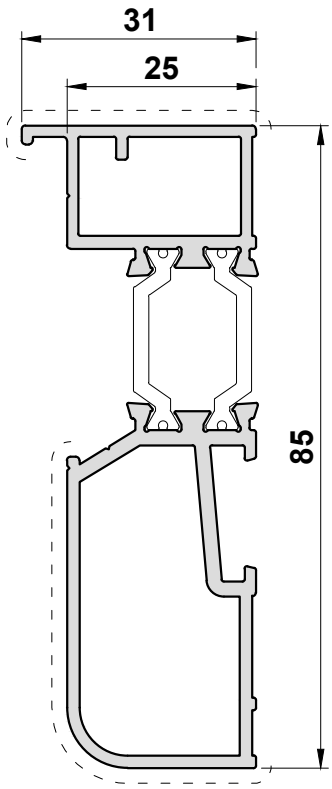
Scale 1:1

Alitherm 400 Stepped Door

PROFILE : SCALED PROFILE DRAWINGS

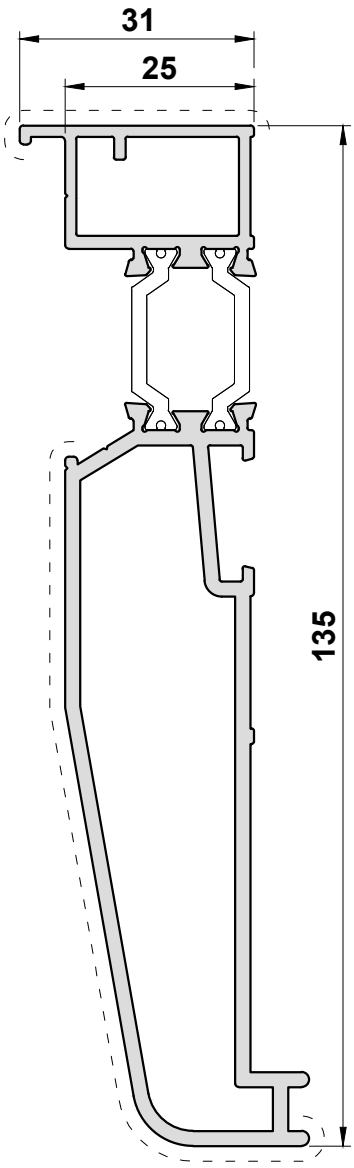
Primary Visible Side – – – – – – – – – – – – – – – – **Secondary Visible Side** — · — · — · — · — · — · —

ETC451
85mm Cill



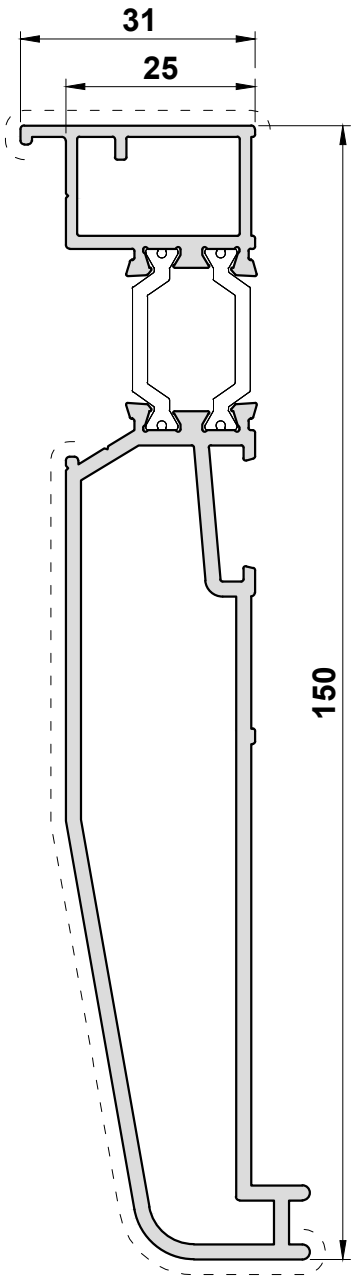
Cast End Cap: ACET451
PVC End Cap: ACET178

ETC452
135mm Cill



Cast End Cap: ACET452
PVC End Cap: ACET152

ETC457
150mm Cill



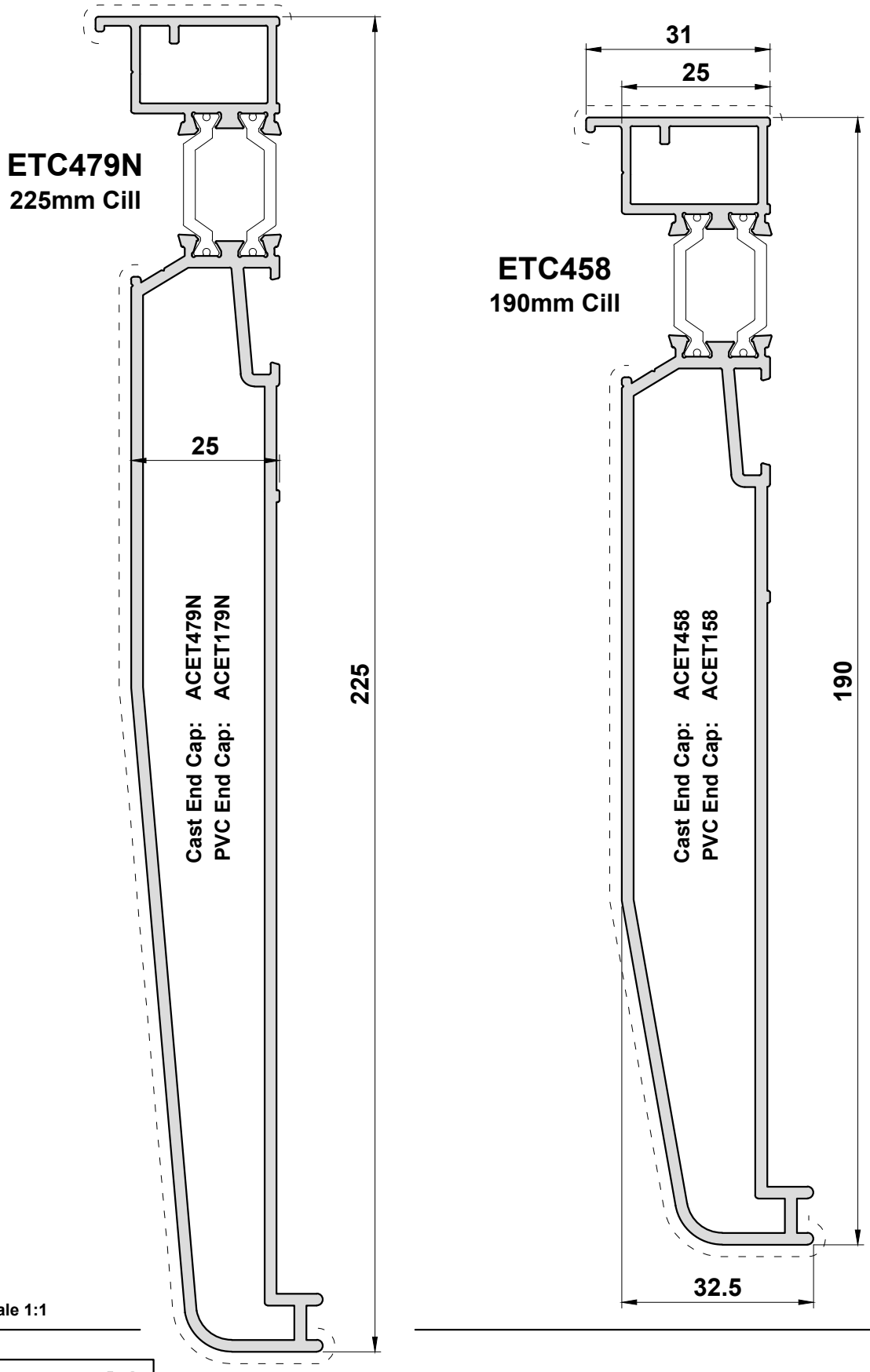
Cast End Cap: ACET457
PVC End Cap: ACET157

Scale 1:1

Alitherm 400 Stepped Door

PROFILE : SCALED PROFILE DRAWINGS

Primary Visible Side - - - - - - - - - - - - - - - - - - **Secondary Visible Side** — · — · — · — · — · — · —



Scale 1:1

ISSUED: JULY 2026

Section B

Accessories

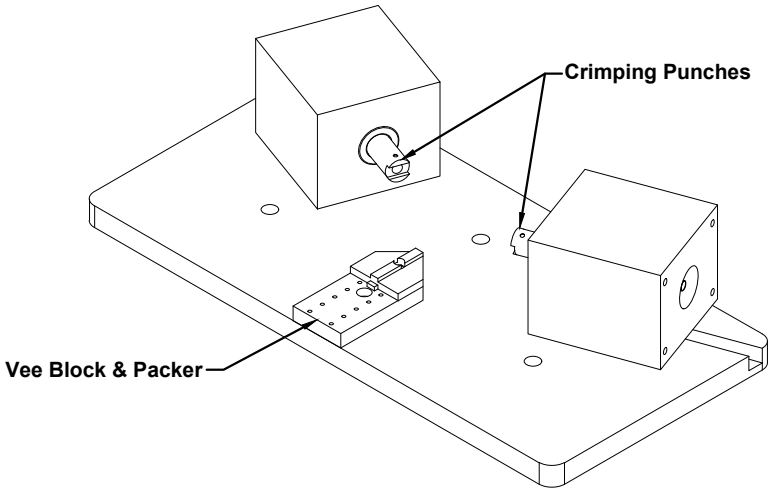
Photos & Drawings

Corner Joint - Crimping

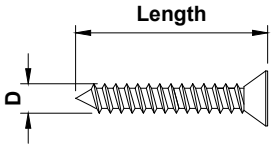
	Profile	Crimping Punches	Vee Block	Nylon Support	Packer
Outerframe	ETD4220	ACET4920P	ACUN3950 ACUN3957	ACUN3952	ACET4381 ACET4382
Sash	ETD4221	ACET4920P	ACUN3964	ACUN3952	ACET4380 ACET4384

PNEUMATIC CRIMPER
ACCR200N

MANUAL CRIMPER
ACCR300



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
ACUN3544	No.7	X	3/4"	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
ACUN3577	No.10	X	3/4"	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

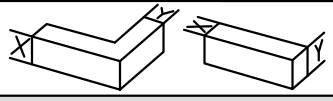


T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm

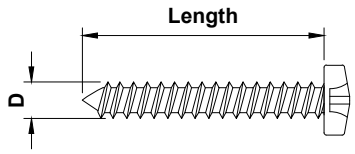


Screw (Grub)

MF = Mill Finish
SA = Silver Anodised
KL = Basic Colour
HP = Special Colour
SSC = Smooth Satin Chrome
SMC = Smokey Chrome
PC = Polished Chrome
WP = White
BL = Black



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

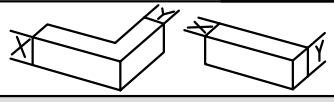


T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm

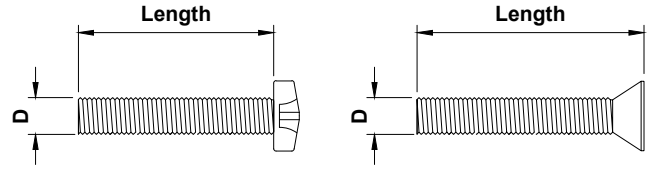


Screw (Grub)

MF	= Mill Finish	WP	= White
SA	= Silver Anodised	BL	= Black
KL	= Basic Colour		
HP	= Special Colour		
SSC	= Smooth Satin Chrome		
SMC	= Smokey Chrome		
PC	= Polished Chrome		



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

Part Number	Thread	X	Length	Description	Box Qty.
ACUN3581	M5	X	12	Pan Head Pozi Machine Screw	100
ACUN3819	M6	X	75	Pan Head Pozi Machine Screw	100

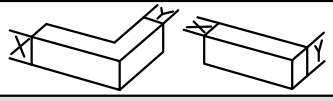


T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm



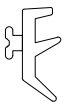
Screw (Grub)

MF	= Mill Finish	WP	= White
SA	= Silver Anodised	BL	= Black
KL	= Basic Colour		
HP	= Special Colour		
SSC	= Smooth Satin Chrome		
SMC	= Smokey Chrome		
PC	= Polished Chrome		



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		ACET843
			200m
			BL
	3mm		ACET842
			200m
			BL
	4mm		ACET841
			200m
			BL
	4mm		ACET835
			200m
			BL

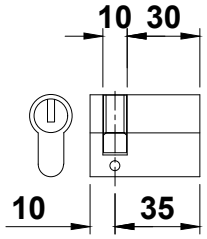
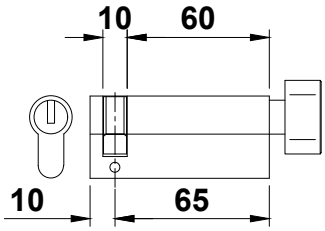
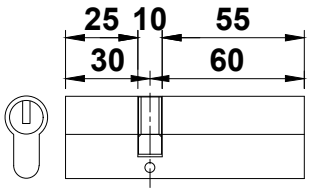
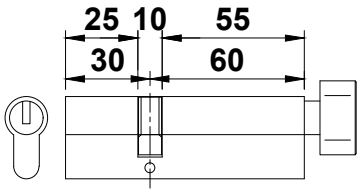
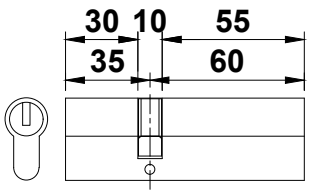
Thickness	Drawing 1:1	Part number
		Coil length
		Available Colours

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
	6mm		ACVG340
			200m
			BL
	6mm		ACVG340N
			100m
			BL
Low Line	4mm - 3mm		ACW20038
			50m
			BL
	5mm - 4mm		ACET848
			200m
			BL

Alitherm 400 Stepped Door

ACCESSORIES : PHOTOS & DRAWINGS

Image	Part Code	Pack	Unit	Application	Colour	
	**ACCY0035** **35mm Euro Profile Half Cylinder** **Supplied with 3 Keys**	**1**	**Each**		MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
	**ACCY0065TTS1** **65mm 1 Star Euro Profile Half Cylinder** **Supplied with 3 Keys**	**1**	**Each**	**Open Out**	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
	**ACCY3060S1** **30/60 1 Star Euro Profile Cylinder** **Supplied with 3 Keys**	**1**	**Each**	**Open Out**	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
	**ACCY3060TTS1** **30/60 1 Star Euro Profile Cylinder** **Supplied with 3 Keys**	**1**	**Each**	**Open Out**	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
	**ACCY3560NKS3** **35/60 TS007 3 Star Euro Profile Cylinder** **Supplied with 3 Keys**	**1**	**Each**	**Open Out**	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	

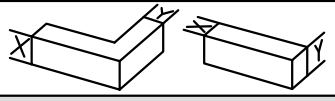


T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm

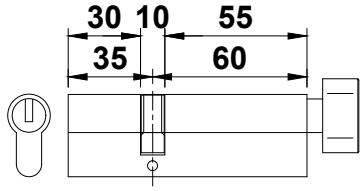
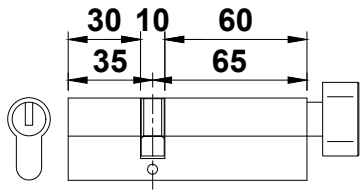
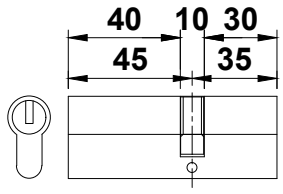
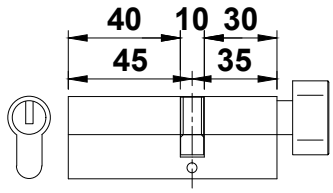
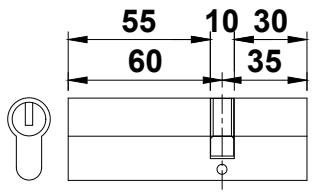


Screw (Grub)

MF = Mill Finish
SA = Silver Anodised
KL = Basic Colour
HP = Special Colour
SSC = Smooth Satin Chrome
SMC = Smokey Chrome
PC = Polished Chrome
WP = White
BL = Black



ISSUED: JULY 2026

Image	Part Code	Pack	Unit	Application	Colour	
	**ACCY3560NKTTS3** 35/60 TS007 3 Star Euro Profile Cylinder Supplied with 3 Keys	1	Each	Open Out	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
	**ACCY3565TTS1** 35/65 1 Star Euro Profile Cylinder Supplied with 3 Keys	1	Each	Open Out	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
	**ACCY4535S1** 45/35 1 Star Euro Profile Cylinder Supplied with 3 Keys	1	Each	Open In	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
	**ACCY4535TTS1** 45/35 1 Star Euro Profile Cylinder Supplied with 3 Keys	1	Each	Open In	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
	**ACCY6035NKS3** 35/60 TS007 3 Star Euro Profile Cylinder Supplied with 3 Keys	1	Each	Open In	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	

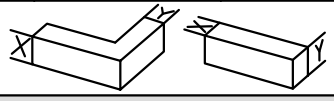


T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm



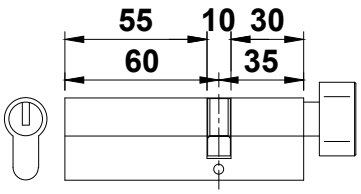
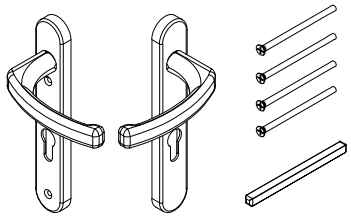
Screw (Grub)

MF = Mill Finish
SA = Silver Anodised
KL = Basic Colour
HP = Special Colour
SSC = Smooth Satin Chrome
SMC = Smokey Chrome
PC = Polished Chrome
WP = White
BL = Black



Alitherm 400 Stepped Door

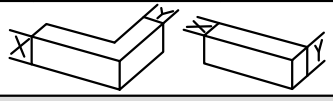
ACCESSORIES : PHOTOS & DRAWINGS

Image	Part Code	Pack	Unit	Application	Colour	
	**ACCY6035NKTTS3** **60/35 TS007 3 Star Euro Profile Cylinder** **Supplied with 3 Keys**	**1**	**Each**	**Open In**	MF SA KL HP SSC SMC WP BL PC	✓
	**ACDV251** **Lever/Lever Handle**	**1**	**Pair**		MF SA KL HP SSC SMC WP BL PC	 ✓ ✓ ✓ ✓ ✓
	**ACDV737** **Bottom Shoot Bolt**	**1**	**Each**	**ACUL276** **ACUL277** **ACUL278**	MF SA KL HP SSC SMC WP BL PC	✓
	**ACDV738** **Top Shoot Bolt**	**1**	**Each**	**ACUL276** **ACUL277** **ACUL278**	MF SA KL HP SSC SMC WP BL PC	✓
	**ACDV742** **200mm Extension for ACDV738**	**1**	**Each**	**ACUL276** **ACUL277** **ACUL278** **ACDV737** **ACDV738**	MF SA KL HP SSC SMC WP BL PC	✓


T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm

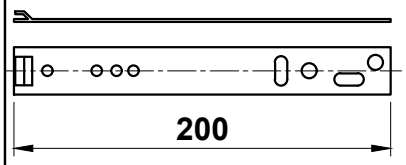
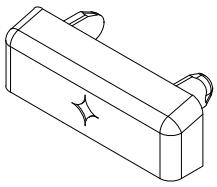

Screw (Grub)

MF	**= Mill Finish**	**W**	**= White**
SA	**= Silver Anodised**	**Z**	**= Black**
KL	**= Basic Colour**		
HP	**= Special Colour**		
SSC	**= Smooth Satin Chrome**		
SMC	**= Smokey Chrome**		
PC	**= Polished Chrome**		



Alitherm 400 Stepped Door

ACCESSORIES : PHOTOS & DRAWINGS

Image	Part Code	Pack	Unit	Application	Colour
	**ACDV744** **400mm Extension for ACDV738**	**1**	**Each**	**ACUL276** **ACUL277** **ACUL278** **ACDV737** **ACDV738**	MF ✓ SA KL HP SSC SMC WP BL PC
	**ACDV746** **600mm Extension for ACDV738**	**1**	**Each**	**ACUL276** **ACUL277** **ACUL278** **ACDV737** **ACDV738**	MF ✓ SA KL HP SSC SMC WP BL PC
	**ACET130** **Galvanised Steel Fixing Strap** **200mm x 25mm x 1.5mm**	**100**	**Pack**	**ETD410**	MF ✓ SA KL HP SSC SMC WP BL PC
	**ACET131** **PVC Drainage Cap** **For Colour match Drainage caps use - ACET432**	**100**	**Pack**		MF SA KL HP SSC SMC WP ✓ BL ✓ PC
	**ACET149** **Slimline Restrictor**	**1**	**Each**		MF ✓ SA KL HP SSC SMC WP BL PC

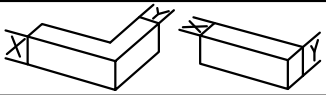


T-BARS
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ACVG66=3.0mm
ACVL150=4.0mm



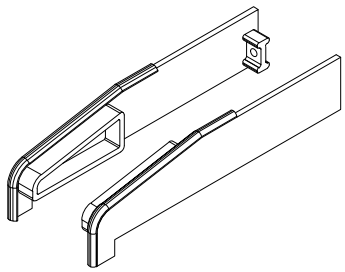
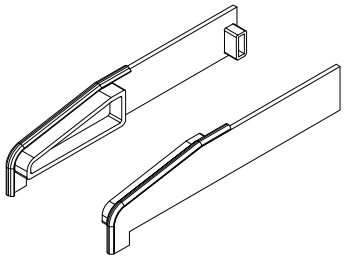
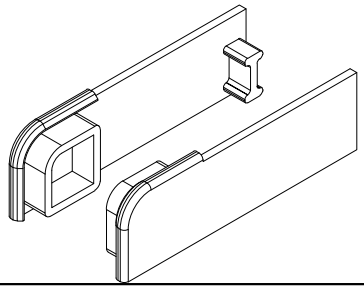
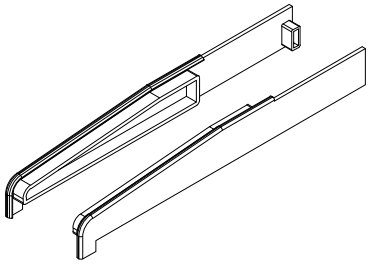
Screw (Grub)

MF	**= Mill Finish**	**W**	**= White**
SA	**= Silver Anodised**	**Z**	**= Black**
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SMC	**= Smokey Chrome**		
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Alitherm 400 Stepped Door

ACCESSORIES : PHOTOS & DRAWINGS

Image	Part Code	Pack	Unit	Application	Colour	
	**ACET152** **PVC Cill End Caps**	**10**	**Pair**	**ETC452**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	✓
					BL	✓
					PC	
	**ACET157** **PVC Cill End Caps**	**10**	**Pair**	**ETC457**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	✓
					BL	✓
					PC	
	**ACET178** **PVC Cill End Caps**	**10**	**Pair**	**ETC451**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	✓
					BL	✓
					PC	
	**ACET179** **PVC Cill End Caps**	**10**	**Pair**	**ETC479**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	✓
					BL	✓
					PC	
	**ACET234** **Threshold Gasket**	**50**	**m**		MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	✓
					PC	

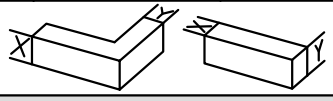


T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm



Screw (Grub)

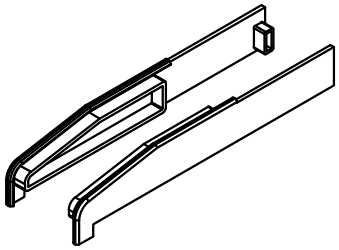
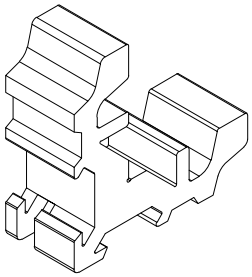
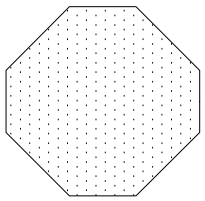
MF = Mill Finish
SA = Silver Anodised
KL = Basic Colour
HP = Special Colour
SSC = Smooth Satin Chrome
SMC = Smokey Chrome
PC = Polished Chrome
W = White
Z = Black



ISSUED: JULY 2026

Alitherm 400 Stepped Door

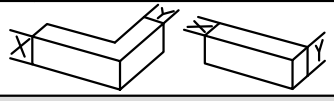
ACCESSORIES : PHOTOS & DRAWINGS

Image	Part Code	Pack	Unit	Application	Colour	
	**ACET252** **Hinge Protector Kit**	**1**	**kit**		MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
	**ACET258** **PVC Cill End Cap**	**10**	**Pair**	**ETC458**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	✓
					BL	✓
					PC	
	**ACET402** **Mechanical Cleat**	**24**	**Pack**	**ETD402**	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
	**ACET408** **Infill Foam**	**1**	**Each**	**ETD402**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	✓
					PC	
	**ACET4133** **Bridge Packer**	**10**	**Pack**	**ETD432**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	✓
					PC	



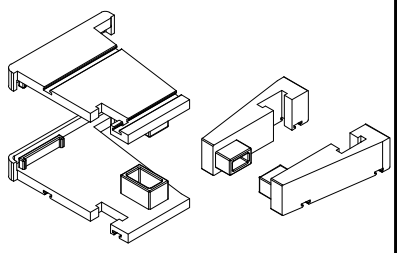
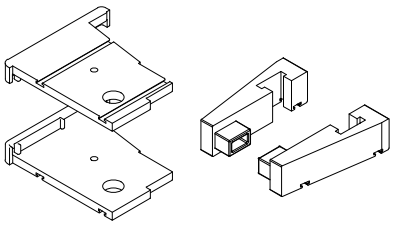
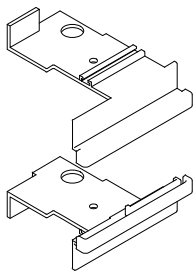
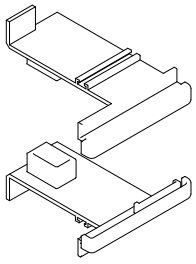
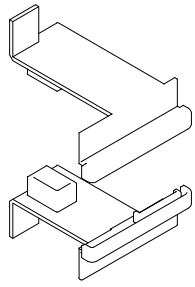


MF = Mill Finish
SA = Silver Anodised
KL = Basic Colour
HP = Special Colour
SSC = Smooth Satin Chrome
SMC = Smokey Chrome
PC = Polished Chrome
WP = White
BL = Black



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ACCESSORIES : PHOTOS & DRAWINGS

Image	Part Code	Pack	Unit	Application	Colour	
	**ACET4142** **End Cap Kit**	**1**	**kit**	**ETD447** **ETD495** **ETD496**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	✓
					BL	✓
					PC	
	**ACET4143** **End Cap Kit**	**1**	**kit**	**ETD448** **ETD495** **ETD496**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	✓
					BL	✓
					PC	
	**ACET4145** **End Cap**	**10**	**Pairs**	**ETD448** **ETD490** **ETD492**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	✓
					BL	✓
					PC	
	**ACET4146** **End Cap**	**10**	**Pairs**	**ETD447** **ETD490** **ETD492**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	✓
					BL	✓
					PC	
	**ACET4147** **End Cap**	**10**	**Pairs**	**ETD447** **ETD410**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	✓
					BL	✓
					PC	

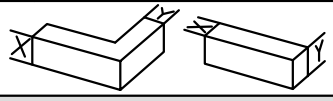


T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm

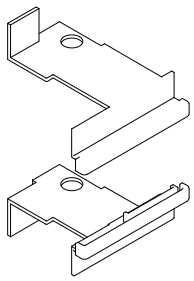
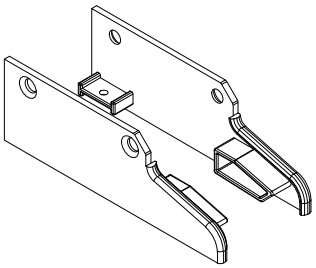
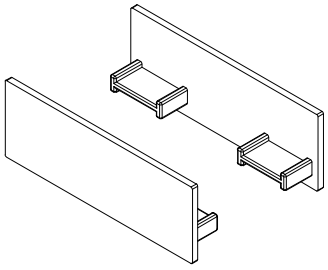
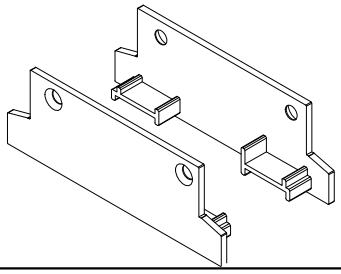
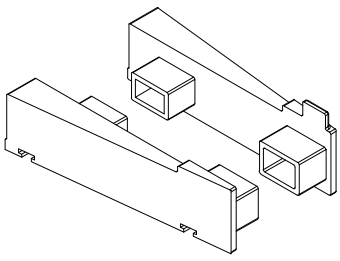


Screw (Grub)

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Image	Part Code	Pack	Unit	Application	Colour	
	**ACET4148** **End Cap**	**10**	**Pairs**	**ETD448** **ETD410**	MF SA KL HP SSC SMC WP BL PC	 ✓ ✓
	**ACET4190** **ETD490 End Cap**	**1**	**Pair**	**ETD490**	MF SA KL HP SSC SMC WP BL PC	✓ ✓ ✓ ✓ ✓
	**ACET4192** **ETD492 End Cap**	**10**	**Pairs**	**ETD492**	MF SA KL HP SSC SMC WP BL PC	 ✓ ✓
	**ACET4195** **ETD495 End Cap**	**10**	**Pairs**	**ETD495**	MF SA KL HP SSC SMC WP BL PC	 ✓ ✓
	**ACET4196** **ETD496 End Cap**	**10**	**Pairs**	**ETD496**	MF SA KL HP SSC SMC WP BL PC	 ✓ ✓

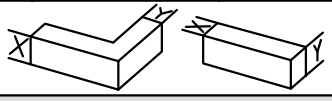


T-BARS
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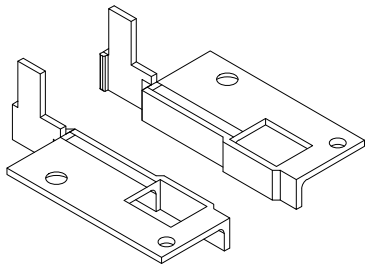
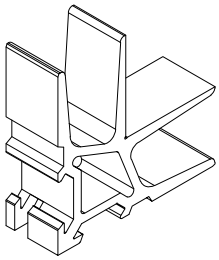
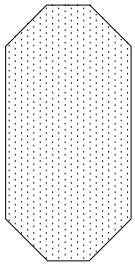
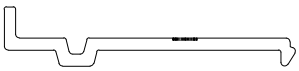
Screw (Grub)

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ACCESSORIES : PHOTOS & DRAWINGS

Image	Part Code	Pack	Unit	Application	Colour	
	**ACET4197** **End Cap for UL297**	**1**	**Pair**	**UL297**	MF SA KL HP SSC SMC WP BL PC	 ✓ ✓
	**ACET4204** **Mechanical Cleat**	**24**	**Pack**	**ETD4204**	MF SA KL HP SSC SMC WP BL PC	✓
	**ACET4205** **Infill Foam**	**1**	**Each**	**ETD4205**	MF SA KL HP SSC SMC WP BL PC	 ✓
	**ACET4206** **Bridge Packer**	**10**	**Pack**	**ETD402** **ETD4204** **ETD4301**	MF SA KL HP SSC SMC WP BL PC	 ✓
	**ACET4207** **Bridge Packer**	**10**	**Pack**	**ETD4205** **ETD4302**	MF SA KL HP SSC SMC WP BL PC	 ✓

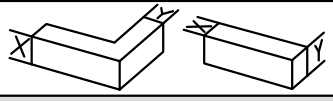


T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm



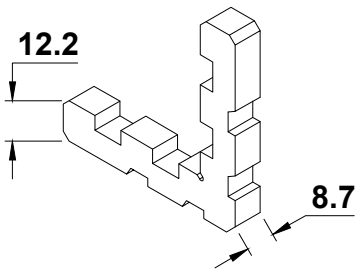
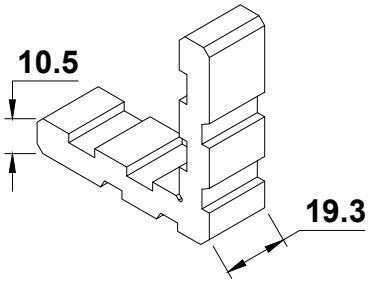
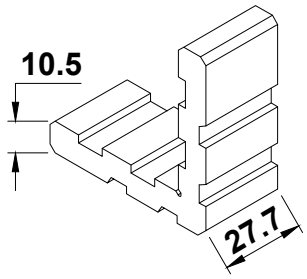
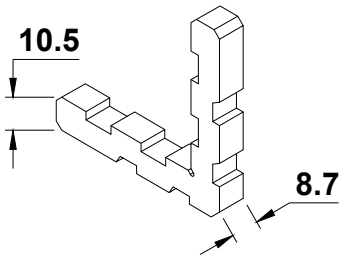
Screw (Grub)

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ACCESSORIES : PHOTOS & DRAWINGS

Image	Part Code	Pack	Unit	Application	Colour
	**ACET4220A** **Crimping Cleat**	**24**	**Pack**	**ETD4220**	MF ✓ SA KL HP SSC SMC WP BL PC
	**ACET4220B** **Crimping Cleat**	**24**	**Pack**	**ETD4220**	MF ✓ SA KL HP SSC SMC WP BL PC
	**ACET4221A** **Crimping Cleat**	**24**	**Pack**	**ETD4221**	MF ✓ SA KL HP SSC SMC WP BL PC
	**ACET4221B** **Crimping Cleat**	**24**	**Pack**	**ETD4221**	MF ✓ SA KL HP SSC SMC WP BL PC
	**ACET4222** **Bridge Packer**	**12**	**Pack**	**ETD4220**	MF SA KL HP SSC SMC WP BL ✓ PC

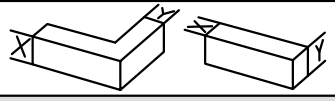


T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm



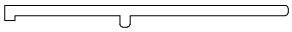
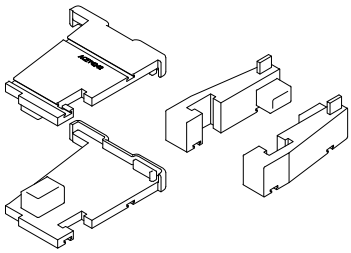
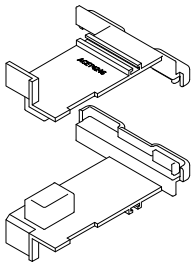
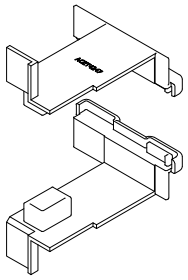
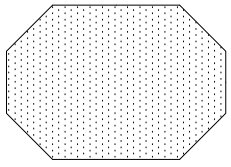
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ACCESSORIES : PHOTOS & DRAWINGS

Image	Part Code	Pack	Unit	Application	Colour	
	**ACET4224** **Bridge Packer**	**12**	**Pack**	**ETD4221**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	✓
					PC	
	**ACET4242** **End Cap Kit**	**1**	**kit**	**ETD4247** **ETD495** **ETD496**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	✓
					BL	✓
					PC	
	**ACET4246** **End Cap**	**10**	**Pairs**	**ETD4247** **ETD490** **ETD492**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	✓
					BL	✓
					PC	
	**ACET4247** **End Cap**	**10**	**Pairs**	**ETD4247** **ETD410**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	✓
					BL	✓
					PC	
	**ACET430** **Infill Foam**	**1**	**Each**	**ETD432**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	✓
					PC	

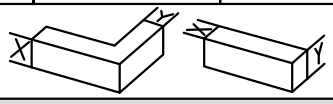


T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm



Screw (Grub)

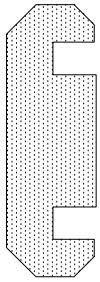
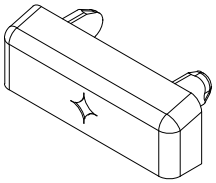
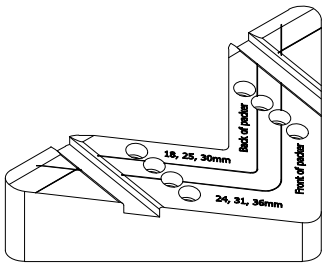
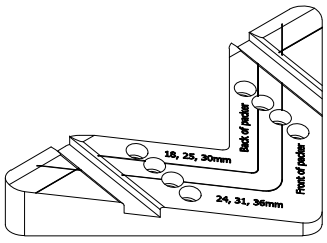
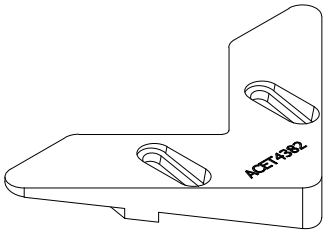
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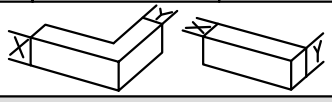
ACCESSORIES : PHOTOS & DRAWINGS

Image	Part Code	Pack	Unit	Application	Colour	
	**ACET4302** **Infill Foam**	**1**	**Each**	**ETD4302**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	✓
					PC	
	**ACET432** **Colour Match Drainage Cover Cap**	**8**	**Pack**		MF	
					SA	✓
					KL	✓
					HP	
					SSC	
					SMC	✓
					WP	✓
					BL	
					PC	
	**ACET4380** **Adjustable Packer**	**1**	**Each**	**ETD4221**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
	**ACET4381** **Adjustable Packer**	**1**	**Each**	**ETD4220**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
	**ACET4382** **Adjustable Packer**	**1**	**Each**	**ETD4220**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	


T-BARS
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ACVL150=4.0mm

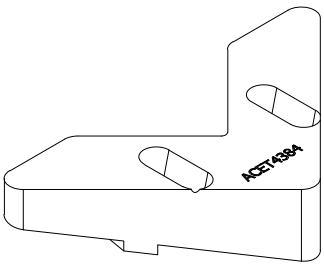
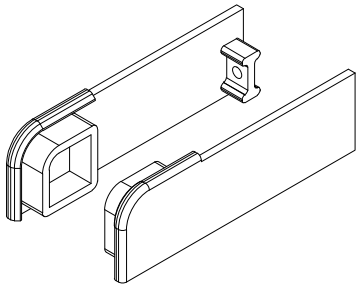
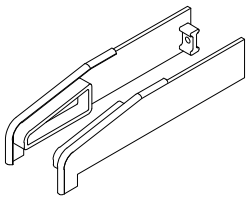
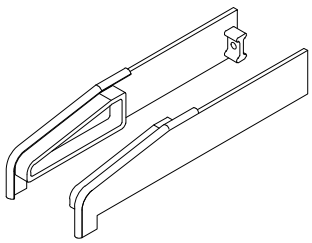
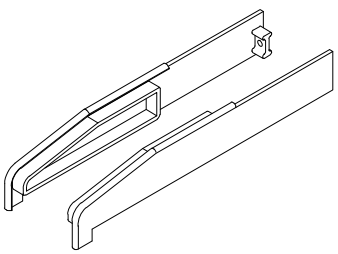

Screw (Grub)

MF = Mill Finish
SA = Silver Anodised
KL = Basic Colour
HP = Special Colour
SSC = Smooth Satin Chrome
SMC = Smokey Chrome
PC = Polished Chrome
WP = White
BL = Black



Alitherm 400 Stepped Door

ACCESSORIES : PHOTOS & DRAWINGS

Image	Part Code	Pack	Unit	Application	Colour	
	**ACET4384** **Adjustable Packer**	**1**	**Each**	**ETD4221**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
	**ACET451** **Cast Cill End Caps** **(Pair)**	**1**	**Pair**	**ETC451**	MF	✓
					SA	
					KL	✓
					HP	✓
					SSC	
					SMC	
					WP	✓
					BL	✓
					PC	
	**ACET452** **Cast Cill End Caps** **(Pair)**	**1**	**Pair**	**ETC452**	MF	✓
					SA	
					KL	✓
					HP	✓
					SSC	
					SMC	
					WP	✓
					BL	✓
					PC	
	**ACET457** **Cast Cill End Caps** **(Pair)**	**1**	**Pair**	**ETC457**	MF	✓
					SA	
					KL	✓
					HP	✓
					SSC	
					SMC	
					WP	✓
					BL	✓
					PC	
	**ACET458** **Cast Cill End Caps** **(Pair)**	**1**	**Pair**	**ETC458**	MF	✓
					SA	
					KL	✓
					HP	✓
					SSC	
					SMC	
					WP	✓
					BL	✓
					PC	

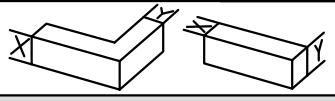


T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm



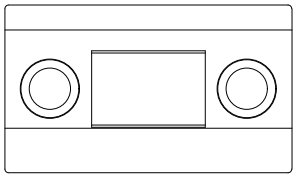
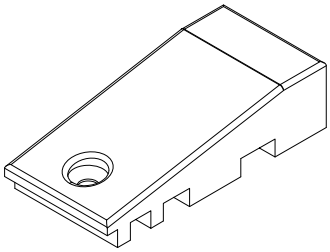
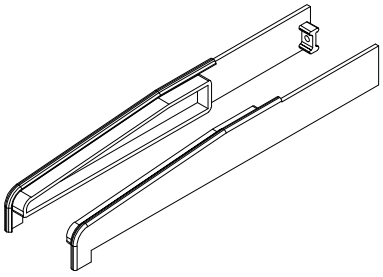
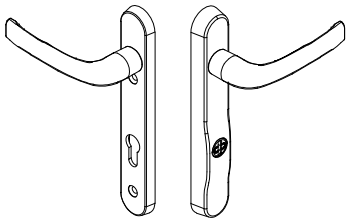
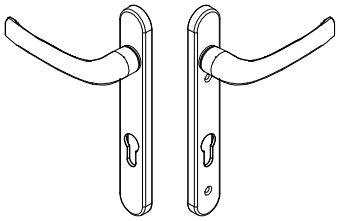
Screw (Grub)

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SSC = Smooth Satin Chrome
SMC = Smokey Chrome
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Alitherm 400 Stepped Door

ACCESSORIES : PHOTOS & DRAWINGS

Image	Part Code	Pack	Unit	Application	Colour	
	**ACET468** **Single Door Keep**	**1**	**Each**	**ETD410**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
	**ACET475** **Run Up Blocks**	**2**	**Pack**	**ETD410**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	✓
					BL	✓
					PC	
	**ACET479N** **Cast Cill End Caps** **(Pair)**	**1**	**Pair**	**ETC479**	MF	✓
					SA	
					KL	✓
					HP	✓
					SSC	
					SMC	
					WP	✓
					BL	✓
					PC	
	**ACET480** **PAS 24** **Lever / Lever Handle**	**1**	**Pair**		MF	
					SA	
					KL	✓
					HP	
					SSC	
					SMC	
					WP	✓
					BL	✓
					PC	✓
	**ACET484** **Standard** **Lever / Lever Handle**	**1**	**Pair**		MF	
					SA	
					KL	✓
					HP	
					SSC	
					SMC	
					WP	✓
					BL	✓
					PC	✓

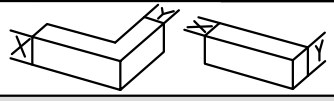


T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm



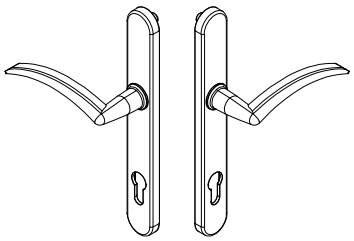
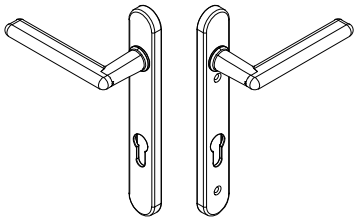
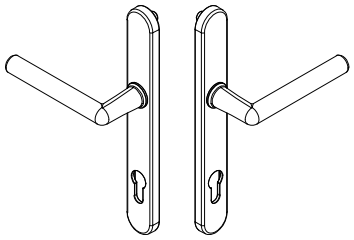
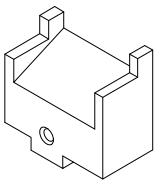
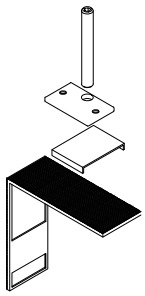
Screw (Grub)

MF	**= Mill Finish**	**WP**	**= White**
SA	**= Silver Anodised**	**BL**	**= Black**
KL	**= Basic Colour**		
HP	**= Special Colour**		
SSC	**= Smooth Satin Chrome**		
SMC	**= Smokey Chrome**		
PC	**= Polished Chrome**		



Alitherm 400 Stepped Door

ACCESSORIES : PHOTOS & DRAWINGS

Image	Part Code	Pack	Unit	Application	Colour	
	**ACET486** **Swept** **Lever / Lever Handle**	**1**	**Pair**		MF	
					SA	
					KL	✓
					HP	
					SSC	
					SMC	
					WP	✓
					BL	✓
					PC	✓
	**ACET487** **Oval** **Lever / Lever Handle**	**1**	**Pair**		MF	
					SA	
					KL	✓
					HP	
					SSC	
					SMC	
					WP	✓
					BL	✓
					PC	
	**ACET488** **Round** **Lever / Lever Handle**	**1**	**Pair**		MF	
					SA	
					KL	✓
					HP	
					SSC	
					SMC	
					WP	✓
					BL	✓
					PC	✓
	**ACET4920P** **Punches**	**1**	**Pair**	**ETD4220** **ETD4221**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
	**ACET496** **Glass Adjustment Kit**	**1**	**kit**	**ETD4204** **ETD4205** **ETD424** **(Not For Heritage)**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	

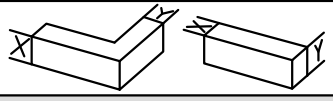


T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm



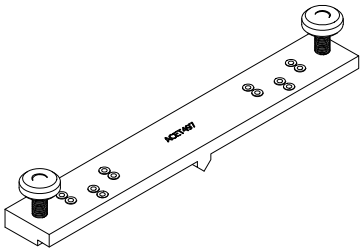
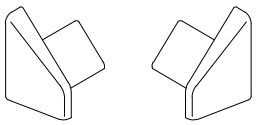
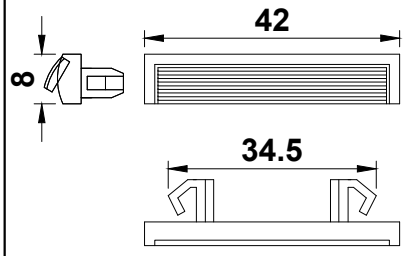
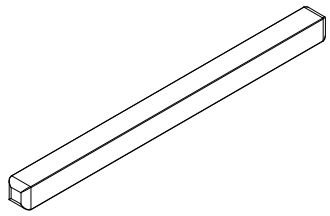
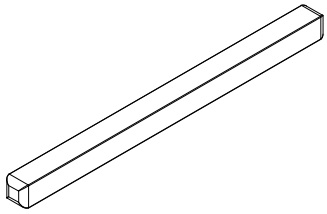
Screw (Grub)

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Alitherm 400 Stepped Door

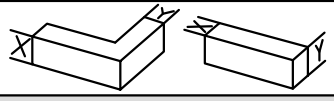
ACCESSORIES : PHOTOS & DRAWINGS

Image	Part Code	Pack	Unit	Application	Colour	
	**ACET497** **Drill Jig**	**1**	**Each**	**ACET496** **ETD4204** **ETD4205** **ETD424**	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
	**ACET572** **End Cap**	**100**	**Pack**	**ETC572**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	✓
					BL	✓
					PC	
	**ACGSL045** **Drainage Cap**	**100**	**Pack**		MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	✓
					BL	✓
					PC	
	**ACMX008** **60mm Spindle**	**1**	**Each**		MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
	**ACMX409** **150mm Spindle**	**1**	**Each**		MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	✓



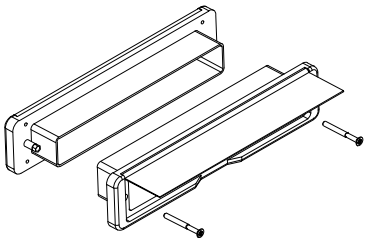
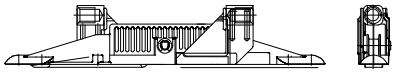
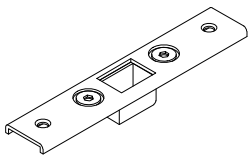
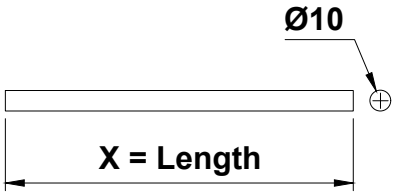
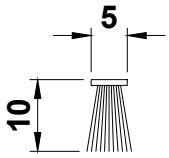


MF	**= Mill Finish**	**WP**	**= White**
SA	**= Silver Anodised**	**BL**	**= Black**
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HP	**= Special Colour**		
SSC	**= Smooth Satin Chrome**		
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Alitherm 400 Stepped Door

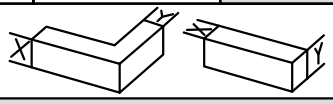
ACCESSORIES : PHOTOS & DRAWINGS

Image	Part Code	Pack	Unit	Application	Colour	
	**ACPD6051** **Nu Mail Letter Box** **(Also Available In Gold & Graphite)**	**1**	**Each**	**ETD430** **ETD4301** **ETD4302**	MF SA KL HP SSC SMC WP BL PC	 ✓ ✓ ✓
	**ACPD844** **35mm Backset Shootbolt Adaptor**	**1**	**Each**	**All Locks Excluding ACUL267 ACUL268 ACUL276 ACUL277 ACUL278**	MF SA KL HP SSC SMC WP BL PC	✓
	**ACPD845** **Shootbolt Keep**	**1**	**Each**		MF SA KL HP SSC SMC WP BL PC	
	**ACPD8XX** **10mm Dia Galvanised Rod** **ACPD846: X = 1000mm** **ACPD847: X = 1250mm** **ACPD848: X = 1500mm** **ACPD849: X = 2000mm**	**1**	**Each**	**ACPD844**	MF SA KL HP SSC SMC WP BL PC	✓
	**ACSH038N** **5 x 10mm Woolpile (Grey)**	**225**	**m**		MF SA KL HP SSC SMC WP BL PC	


T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm


Screw (Grub)

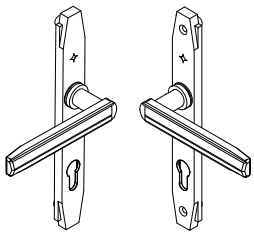
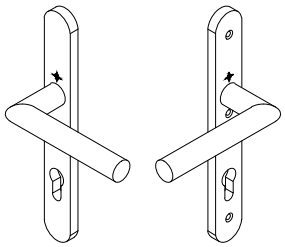
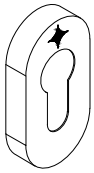
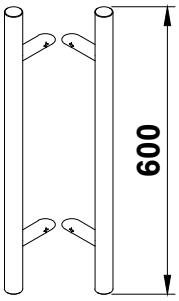
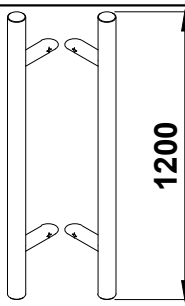
MF	**= Mill Finish**	**WP**	**= White**
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ISSUED: JULY 2026

Alitherm 400 Stepped Door

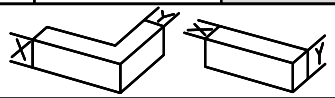
ACCESSORIES : PHOTOS & DRAWINGS

Image	Part Code	Pack	Unit	Application	Colour	
	**ACSM001N** **Art Deco Lever/Lever Door Handle**	**1**	**Pair**		MF SA KL HP SSC SMC WP BL PC	✓ ✓ ✓
	**ACSM013** **Stainless Steel Lever Handle on Oval Backplate (Not Handed)**	**1**	**Pair**		MF SA KL HP SSC SMC WP BL PC	
	**ACSM015SS** **Stainless Steel Oval Escutcheon** **Kit Contains:** **1 x External Cover Plate** **1 x Internal Fixing Plate** **4 x Screws**	**1**	**Each**	**ACSM020SS** **ACSM021SS** **ACSM040SS**	MF SA KL HP SSC SMC WP BL PC	
	**ACSM020SS** **600mm Stainless Steel Tubular Handle (Pair)** **Back to back fixing kit included.**	**1**	**Each**	**ACSM015SS**	MF SA KL HP SSC SMC WP BL PC	
	**ACSM021SS** **1200mm Stainless Steel Tubular Handle (Pair)** **Back to back fixing kit included.**	**1**	**Each**	**ACSM015SS**	MF SA KL HP SSC SMC WP BL PC	



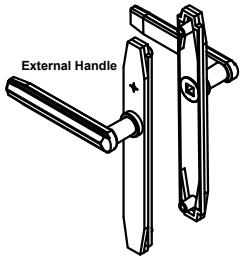
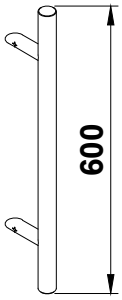
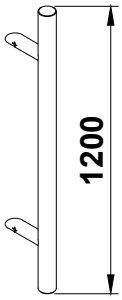
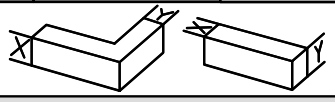


MF = Mill Finish
SA = Silver Anodised
KL = Basic Colour
HP = Special Colour
SSC = Smooth Satin Chrome
SMC = Smokey Chrome
PC = Polished Chrome
WP = White
BL = Black

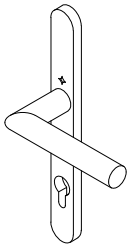
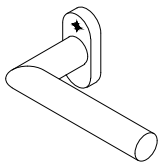
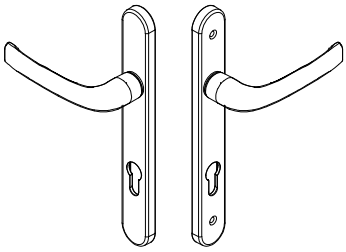
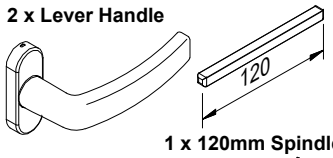
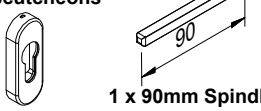
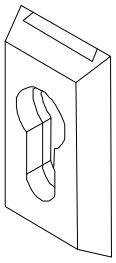


Alitherm 400 Stepped Door

ACCESSORIES : PHOTOS & DRAWINGS

Image	Part Code	Pack	Unit	Application	Colour
 (Left Shown)	**ACSM025L/R** **Art Deco Dummy Door Handles** **No Cylinder** **Handles are Fixed in Position**	**1**	**pair**	**ACSM001N**	MF SA KL HP SSC SMC WP ✓ BL ✓ PC
	**ACSM030** **Secret Single Fixing Kit for ACISM20SS & ACISM21SS**	**1**	**Each**	**ACSM020SS ACSM021SS ACSM037 ACSM038**	MF SA KL HP SSC SMC WP BL PC
	**ACSM031** **Back to Back Fixing Kit for ACISM20SS & ACISM21SS**	**1**	**Each**	**ACSM020SS ACSM021SS**	MF SA KL HP SSC SMC WP BL PC
	**ACSM037SS** **600mm Stainless Steel Tubular Handle (Single)**	**1**	**Each**	**ACSM015SS ACSM032**	MF SA KL HP SSC SMC WP BL PC
	**ACSM038SS** **1200mm Stainless Steel Tubular Handle (Single)**	**1**	**Each**	**ACSM015SS ACSM032**	MF SA KL HP SSC SMC WP BL PC
 T-BARS ACVG65=2.5mm ACVG66=3.0mm ACVL150=4.0mm  Screw (Grub)	**MF = Mill Finish** **WP = White** **SA = Silver Anodised** **BL = Black** **KL = Basic Colour** **HP = Special Colour** **SSC = Smooth Satin Chrome** **SMC = Smokey Chrome** **PC = Polished Chrome**				

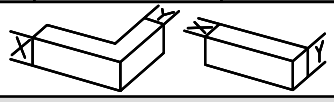
ISSUED: JULY 2026

Image	Part Code	Pack	Unit	Application	Colour	
	**ACSM058SS** **Stainless Steel Lever Handle on Long Backplate (Not Handed)** **Fixings and Spindle Sold Separately**	**1**	**Pair**	**ACSM015SS ACMX409 ACMX008 ACUN3509 WCA134**	MF SA KL HP SSC SMC WP BL PC	
	**ACSM059SS** **Stainless Steel Lever Handle on Oval Backplate (Not Handed)** **Fixings and Spindle Sold Separately**	**1**	**Each**	**ACSM015SS ACMX409 ACMX008 ACUN3509 WCA134**	MF SA KL HP SSC SMC WP BL PC	
	**ACSM060** **Heritage Lever/Lever Handle**	**1**	**Pair**	**ACW20465 ACW20466**	MF SA KL HP SSC SMC WP BL PC	 ✓ ✓
2 x Lever Handle  **1 x 120mm Spindle** **2 x Escutcheons**  **1 x 90mm Spindle**	**ACSM095** **Suitable With Lift Lever**	**1**	**set**		MF SA KL HP SSC SMC WP BL PC	
	**ACSZ400** **Safety Lock Plate** **Door Handle - External**	**1**	**Each**		MF SA KL HP SSC SMC WP BL PC	 ✓ ✓ ✓ ✓ ✓



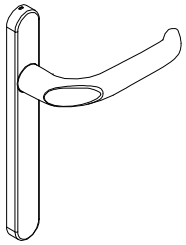
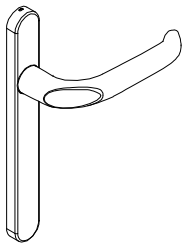
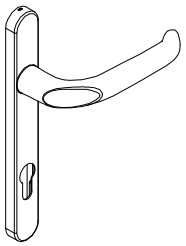
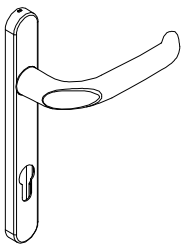
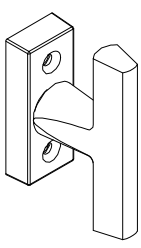


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HP = Special Colour
SSC = Smooth Satin Chrome
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Alitherm 400 Stepped Door

ACCESSORIES : PHOTOS & DRAWINGS

Image	Part Code	Pack	Unit	Application	Colour	
	**ACSZ800** **External Lever Handle Without Cylinder**	**1**	**Each**	**ACSZ801** **ACSZ803** **ACSZ830**	MF	
					SA	✓
					KL	✓
					HP	✓
					SSC	
					SMC	
					WP	
					BL	✓
					PC	✓
	**ACSZ801** **Internal Lever Handle Without Cylinder**	**1**	**Each**	**ACSZ800** **ACSZ803**	MF	
					SA	✓
					KL	✓
					HP	✓
					SSC	
					SMC	
					WP	
					BL	✓
					PC	✓
	**ACSZ802** **External Handle With Cylinder**	**1**	**Each**	**ACSZ800** **ACSZ803**	MF	
					SA	✓
					KL	✓
					HP	✓
					SSC	
					SMC	
					WP	
					BL	✓
					PC	✓
	**ACSZ803** **Internal Handle With Cylinder**	**1**	**Each**	**ACSZ55*** **ACSZ801** **ACSZ803** **ACMX309**	MF	
					SA	✓
					KL	✓
					HP	✓
					SSC	
					SMC	
					WP	
					BL	✓
					PC	✓
	**ACSZ827** **Internal 'T' Door Handle With Short Backplate**	**1**	**Each**		MF	
					SA	✓
					KL	✓
					HP	✓
					SSC	
					SMC	
					WP	
					BL	✓
					PC	✓

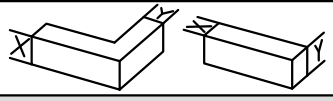


T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm



Screw (Grub)

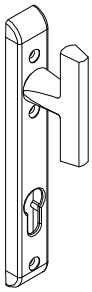
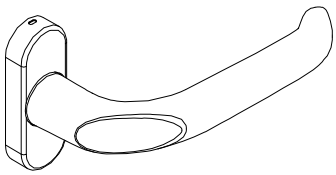
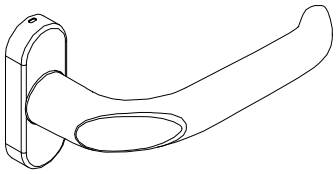
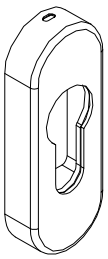
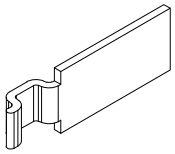
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WP = White
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ISSUED: JULY 2026

Alitherm 400 Stepped Door

ACCESSORIES : PHOTOS & DRAWINGS

Image	Part Code	Pack	Unit	Application	Colour	
	**ACSZ830** **Internal 'T' Door Handle With Long Backplate**	**1**	**Each**		MF	
					SA	✓
					KL	✓
					HP	✓
					SSC	
					SMC	
					WP	
					BL	✓
					PC	✓
	**ACSZ836** **Internal Door Handle With Short Backplate**	**1**	**Each**		MF	
					SA	✓
					KL	✓
					HP	✓
					SSC	
					SMC	
					WP	
					BL	✓
					PC	✓
	**ACSZ837** **External Door Handle With Short Backplate**	**1**	**Each**		MF	
					SA	✓
					KL	✓
					HP	✓
					SSC	
					SMC	
					WP	
					BL	✓
					PC	✓
	**ACSZ839** **Escutcheon (Cylinder Cover)**	**1**	**Each**		MF	
					SA	✓
					KL	✓
					HP	✓
					SSC	
					SMC	
					WP	
					BL	✓
					PC	✓
	**ACUL025** **Anti-Twist Clip**	**100**	**Pack**		MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	

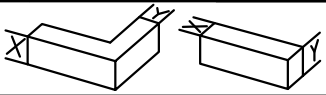


T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm



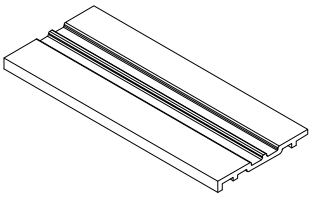
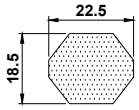
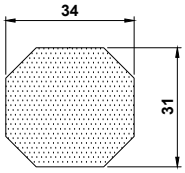
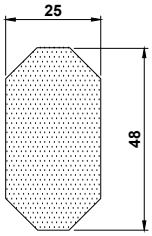
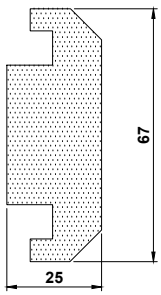
Screw (Grub)

MF	**= Mill Finish**	**WP**	**= White**
SA	**= Silver Anodised**	**BL**	**= Black**
KL	**= Basic Colour**		
HP	**= Special Colour**		
SSC	**= Smooth Satin Chrome**		
SMC	**= Smokey Chrome**		
PC	**= Polished Chrome**		



Alitherm 400 Stepped Door

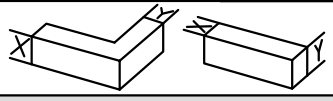
ACCESSORIES : PHOTOS & DRAWINGS

Image	Part Code	Pack	Unit	Application	Colour	
	**ACUL065** **42mm Bridge Packer**	**12**	**Pack**	**ETD404** **ETD424** **ETD430**	MF SA KL HP SSC SMC WP BL PC	 ✓
	**ACUL076** **Infill Foam**	**1**	**Each**	**ETD447** **ETD4221** **ETD4247**	MF SA KL HP SSC SMC WP BL PC	 ✓
	**ACUL077** **Infill Foam**	**1**	**Each**	**ETD410**	MF SA KL HP SSC SMC WP BL PC	 ✓
	**ACUL078** **Infill Foam**	**1**	**Each**	**ETD4204** **ETD424**	MF SA KL HP SSC SMC WP BL PC	 ✓
	**ACUL080** **Infill Foam**	**1**	**Each**	**ETD430** **ETD4301**	MF SA KL HP SSC SMC WP BL PC	 ✓


T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm


Screw (Grub)

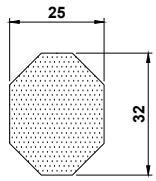
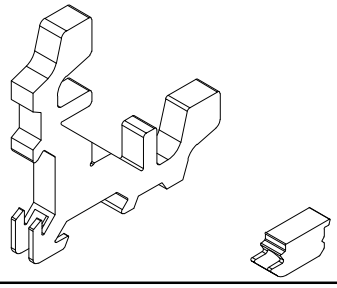
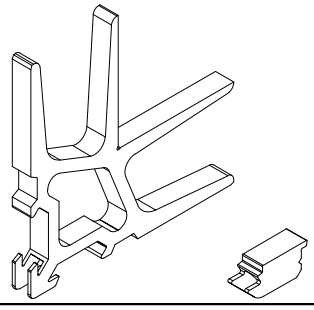
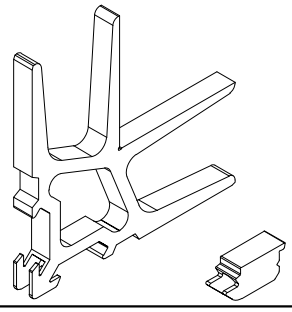
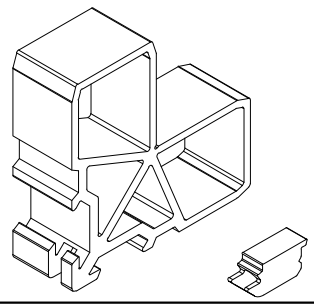
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ISSUED: JULY 2026

Alitherm 400 Stepped Door

ACCESSORIES : PHOTOS & DRAWINGS

Image	Part Code	Pack	Unit	Application	Colour	
	**ACUL081** **Infill Foam**	**1**	**Each**	**ETD404**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	✓
					PC	
	**ACUL210A** **Mechanical Cleat**	**24**	**Pack**	**ETD402** **ETD410**	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
	**ACUL210B** **Mechanical Cleat**	**24**	**Pack**	**ETD410**	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
	**ACUL224** **Mechanical Cleat**	**24**	**Pack**	**ETD4204** **ETD4205** **ETD424**	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
	**ACUL225** **Mechanical Cleat**	**24**	**Pack**	**ETD4205** **ETD424**	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	

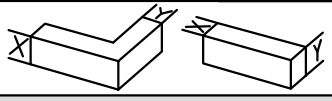


T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm



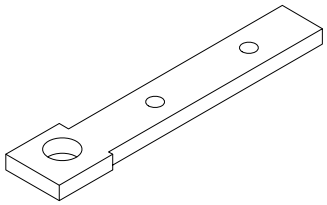
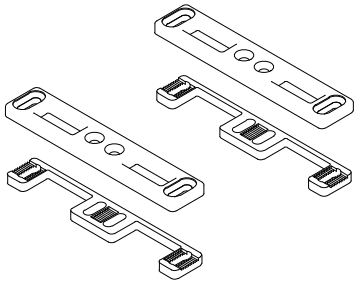
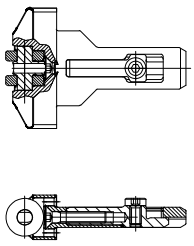
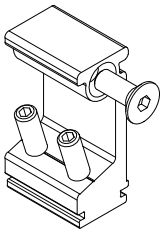
Screw (Grub)

MF = Mill Finish
SA = Silver Anodised
KL = Basic Colour
HP = Special Colour
SSC = Smooth Satin Chrome
SMC = Smokey Chrome
PC = Polished Chrome
WP = White
BL = Black



Alitherm 400 Stepped Door

ACCESSORIES : PHOTOS & DRAWINGS

Image	Part Code	Pack	Unit	Application	Colour
	**ACUL242** **Aluminium Finger Bolt Guide**	**1**	**Each**	**ACPD846** **ACPD847** **ACPD848**	MF ✓ SA KL HP SSC SMC WP BL PC
	**ACUL250** **Door Hinge**	**1**	**Each**	**ETD410** **ETD4204** **ETD4205** **ETD424**	MF ✓ SA KL HP SSC SMC WP BL PC
	**ACUL279** **Double Door Keep Kit** **Kit contains:** **2 x Keeps** **2 x Base Plates**	**1**	**Kit**	**ACDV737** **ACDV738** **ETD410** **ETD490** **ETD492** **ETD497**	MF ✓ SA KL HP SSC SMC WP BL PC
	**ACUL291** **Roller Latch**	**1**	**Each**	**ACUL282** **ACUL283** **ACUL362** **ACUL363** **ACUL382** **ACUL383**	MF ✓ SA KL HP SSC SMC WP BL PC
	**ACUL295** **Low Threshold Bracket**	**1**	**Pair**	**ETD490** **ETD492** **ETD495**	MF ✓ SA KL HP SSC SMC WP BL PC

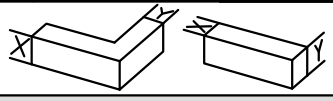


T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm

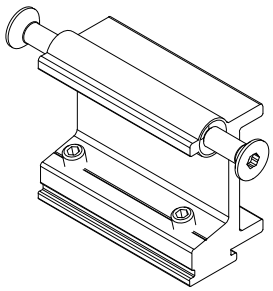


Screw (Grub)

MF = Mill Finish
SA = Silver Anodised
KL = Basic Colour
HP = Special Colour
SSC = Smooth Satin Chrome
SMC = Smokey Chrome
PC = Polished Chrome
WP = White
BL = Black



ISSUED: JULY 2026

Image	Part Code	Pack	Unit	Application	Colour	
	**ACUL299** **Transom/Mullion Bracket**	**10**	**Pack**	**ETD430**	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
					MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
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					SA	
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					HP	
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					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
					MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					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
WP = White
BL = Black

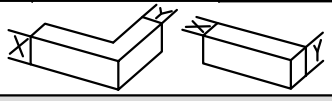
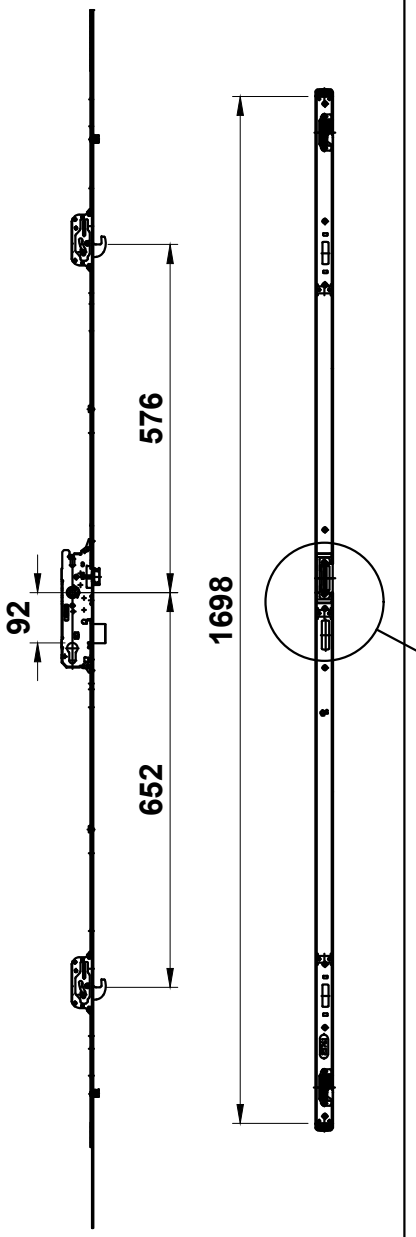
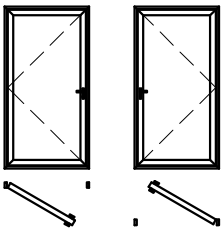
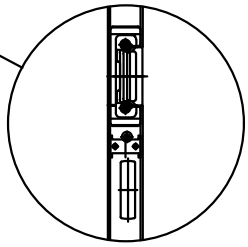
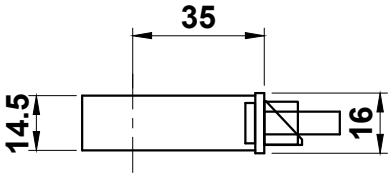


Image	Part Code	Pack	Unit	Application	Colour
	**ACUL267** **Lift Lever Handle Lock with Left Hand Keep** **Kit includes:** • **1 x Lift Lever Handle Lock** • **1 x Left Hand Full Height Keep** **Viewed Externally**  **Left Hand Open Out** **Right Hand Open In**  	**1**	**Pack**	**ACDV251** **ACDV737** **ACDV738** **ACET480** **ACET484** **ACET486** **ACET487** **ACSM015SS** **ACSM040SS**	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**	**WP**	**= White**
SA	**= Silver Anodised**	**BL**	**= Black**
KL	**= Basic Colour**		
HP	**= Special Colour**		
SSC	**= Smooth Satin Chrome**		
SMC	**= Smokey Chrome**		
PC	**= Polished Chrome**		

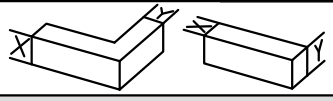
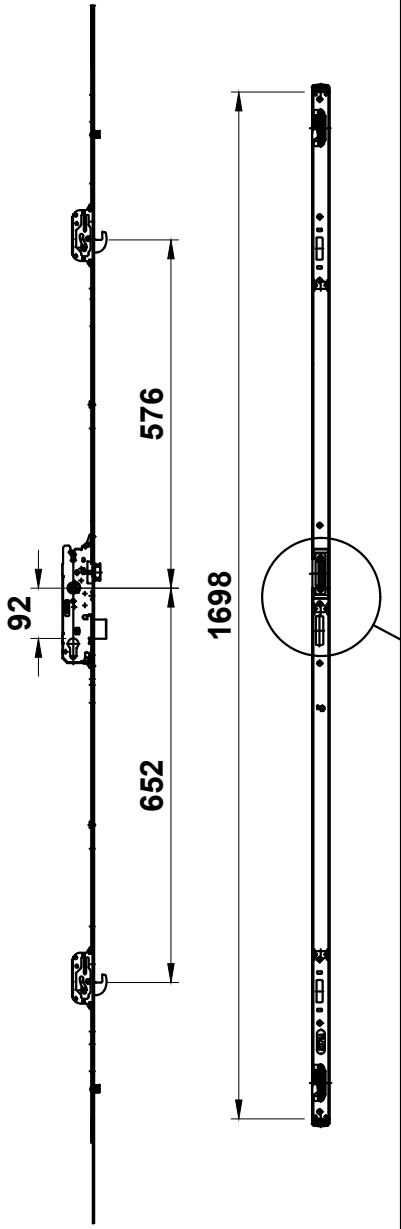
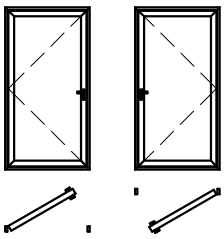
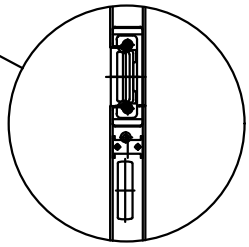
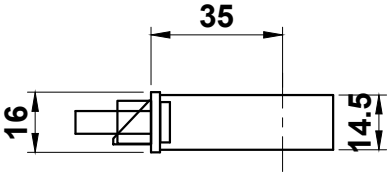
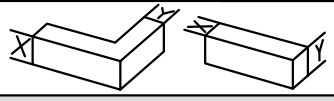


Image	Part Code	Pack	Unit	Application	Colour
	**ACUL268** **Lift Lever Handle Lock with Right Hand Keep** **Kit includes:** • **1 x Lift Lever Handle Lock** • **1 x Right Hand Full Height Keep** **Viewed Externally**  **Left Hand Open In** **Right Hand Open Out**  	1	Pack	**ACDV251** **ACDV737** **ACDV738** **ACET480** **ACET484** **ACET486** **ACET487** **ACSM015SS** **ACSM040SS**	MF ✓ SA KL HP SSC SMC W Z PC


T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm

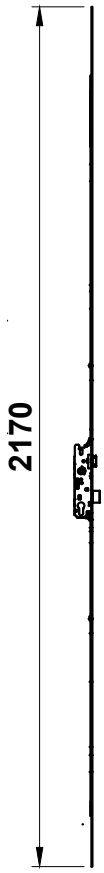

Screw (Grub)

MF	**= Mill Finish**	**WP**	**= White**
SA	**= Silver Anodised**	**BL**	**= Black**
KL	**= Basic Colour**		
HP	**= Special Colour**		
SSC	**= Smooth Satin Chrome**		
SMC	**= Smokey Chrome**		
PC	**= Polished Chrome**		



Alitherm 400 Stepped Door

ACCESSORIES : PHOTOS & DRAWINGS

Image	Part Code	Pack	Unit	Application	Colour	
	**ACUL276** **Secondary Door Lock**	**1**	**Pack**	**ACDV251** **ACDV737** **ACDV738** **ACET480** **ACET484** **ACET486** **ACET487** **ACSM015SS** **ACSM040SS** **ACUL279**	MF SA KL HP SSC SMC WP BL PC	✓
					MF SA KL HP SSC SMC WP BL PC	
					MF SA KL HP SSC SMC WP BL PC	

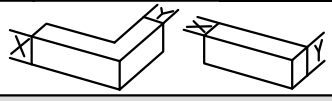


T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm

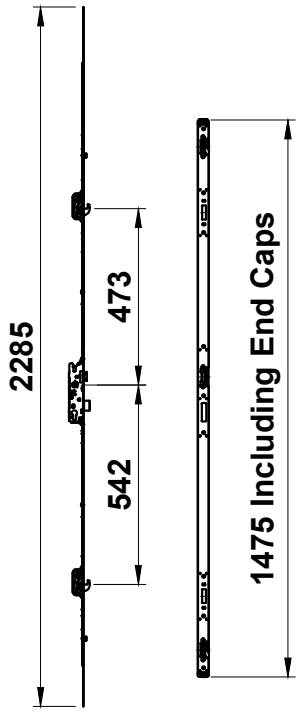
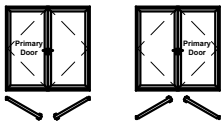
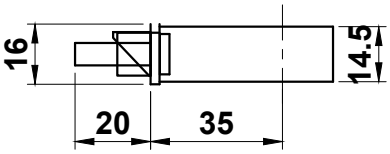
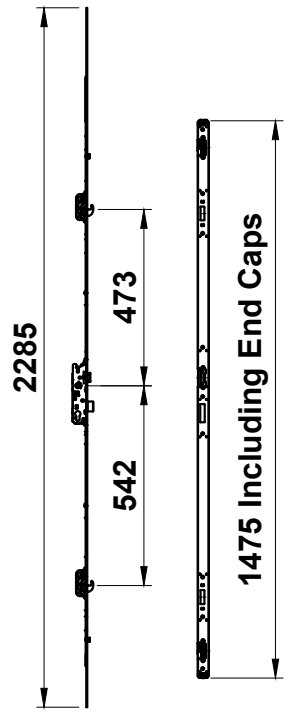
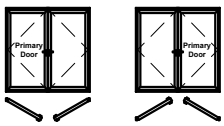
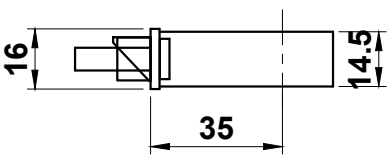


Screw (Grub)

MF	**= Mill Finish**	**WP**	**= White**
SA	**= Silver Anodised**	**BL**	**= Black**
KL	**= Basic Colour**		
HP	**= Special Colour**		
SSC	**= Smooth Satin Chrome**		
SMC	**= Smokey Chrome**		
PC	**= Polished Chrome**		



ISSUED: JULY 2026

Image	Part Code	Pack	Unit	Application	Colour
	**ACUL277** **Lift Lever Primary Double Door Lock Left Hand Keep** **Kit includes:** • 1 x Primary Double Door Lock • 1 x Left Hand Full Height Keep **Viewed Externally**  	1	Pack	ACDV251 ACDV737 ACDV738 ACET480 ACET484 ACET486 ACET487 ACSM015SS ACSM040SS ACUL276	MF ✓ SA KL HP SSC SMC W Z PC
	**ACUL278** **Lift Lever Primary Double Door Lock Right Hand Keep** **Kit includes:** • 1 x Primary Double Door Lock • 1 x Right Hand Full Height Keep **Viewed Externally**  	1	Pack	ACDV251 ACDV737 ACDV738 ACET480 ACET484 ACET486 ACET487 ACSM015SS ACSM040SS ACUL276	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	WP	= White
SA	= Silver Anodised	BL	= Black
KL	= Basic Colour		
HP	= Special Colour		
SSC	= Smooth Satin Chrome		
SMC	= Smokey Chrome		
PC	= Polished Chrome		

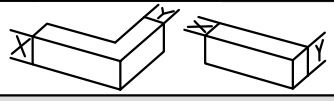
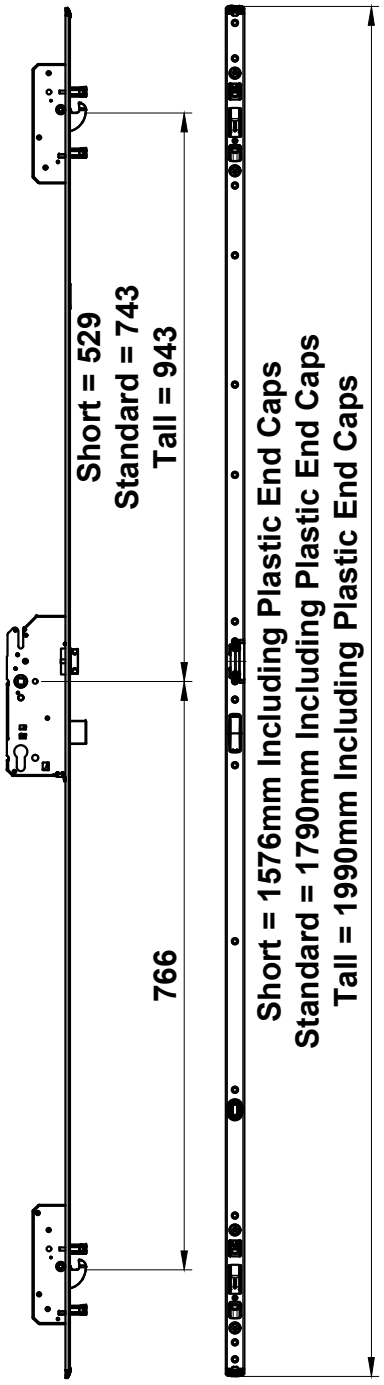
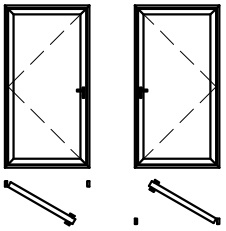


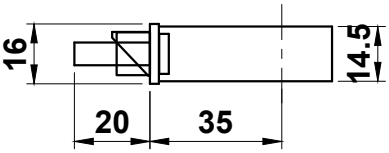
Image	Part Code	Pack	Unit	Application	Colour
	Slam Lock **Left Hand Keep** **ACUL360** **Short** **Kit includes:** • **1 x Short Slam Multi Point Lock** • **1 x Short Left Hand full height keep** • **2 x Release Magnets** **ACUL280** **Standard** **Kit includes:** • **1 x Slam Multi Point Lock** • **1 x Left Hand full height Keep** • **2 x Release Magnets** **ACUL380** **Tall** **Kit includes:** • **1 x Tall Slam Multi Point Lock** • **1 x Tall Left Hand full height keep** • **2 x Release Magnets**	**1**	**Pack**	**ACSM015SS** **ACSM020SS** **ACSM021SS**	MF ✓ SA KL HP SSC SMC W Z PC



Viewed Externally



Left Hand Open Out **Right Hand Open In**




T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm


Screw (Grub)

MF	**= Mill Finish**	**WP**	**= White**
SA	**= Silver Anodised**	**BL**	**= Black**
KL	**= Basic Colour**		
HP	**= Special Colour**		
SSC	**= Smooth Satin Chrome**		
SMC	**= Smokey Chrome**		
PC	**= Polished Chrome**		

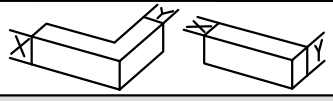
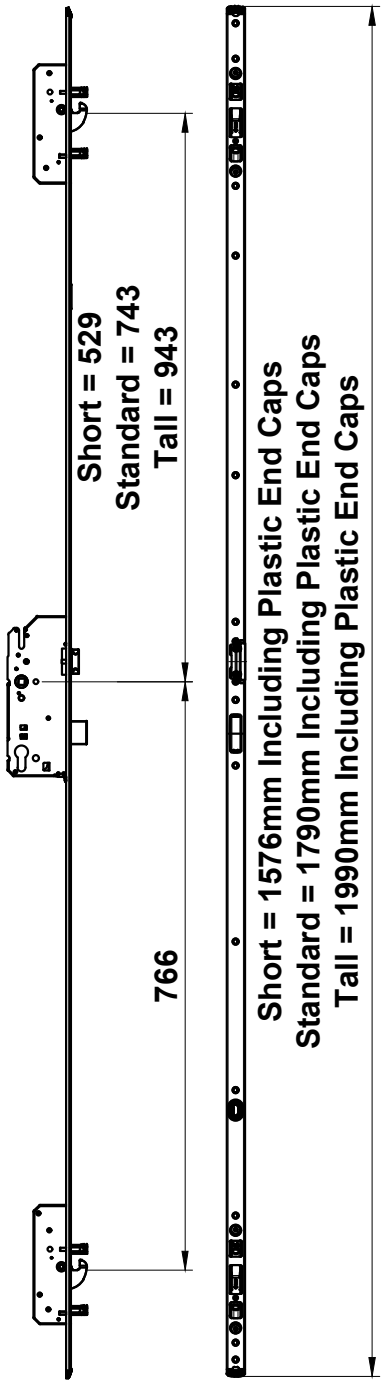
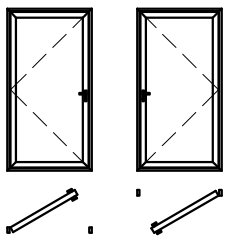
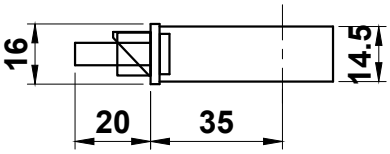


Image	Part Code	Pack	Unit	Application	Colour
	**Slam Lock** **Right Hand Keep** **ACUL361** **Short** **Kit includes:** • **1 x Short Slam Multi Point Lock** • **1 x Short Right Hand full height keep** • **2 x Release Magnets** **ACUL281** **Standard** **Kit includes:** • **1 x Slam Multi Point Lock** • **1 x Right Hand full height Keep** • **2 x Release Magnets** **ACUL381** **Tall** **Kit includes:** • **1 x Tall Slam Multi Point Lock** • **1 x Tall Right Hand full height keep** • **2 x Release Magnets** **Viewed Externally**  **Left Hand Open In** **Right Hand Open Out** 	1	Pack	ACSM015SS ACSM020SS ACSM021SS	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**	**WP**	**= White**
SA	**= Silver Anodised**	**BL**	**= Black**
KL	**= Basic Colour**		
HP	**= Special Colour**		
SSC	**= Smooth Satin Chrome**		
SMC	**= Smokey Chrome**		
PC	**= Polished Chrome**		

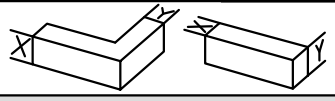
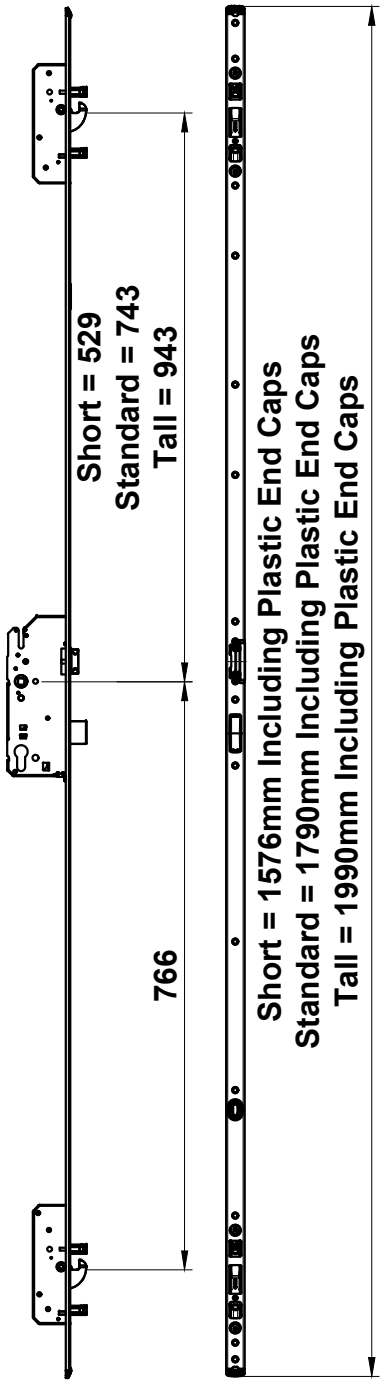
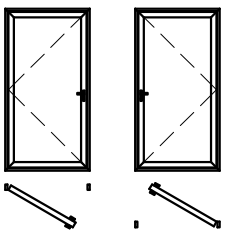
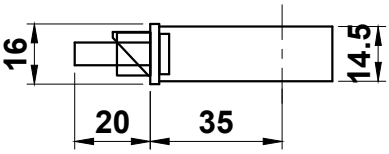


Image	Part Code	Pack	Unit	Application	Colour
	**Key Wind** **Left Hand Keep** **ACUL362** **Short** **Kit includes:** • **1 x Short key wind multi point lock** • **1 x Short Left Hand full height keep** **ACUL282** **Standard** **Kit includes:** • **1 x Keywind Multi Point Lock** • **1 x Left Hand full height Keep** **ACUL382** **Tall** **Kit includes:** • **1 x Tall key wind multi point lock** • **1 x Tall Left Hand full height keep**	1	Pack	ACDV251 ACDV737 ACDV738 ACET480 ACET484 ACET486 ACET487 ACSM015SS ACSM040SS	MF ✓ SA KL HP SSC SMC W Z PC

Viewed Externally



Left Hand Open Out **Right Hand Open In**





T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm



Screw (Grub)

MF	**= Mill Finish**	**WP**	**= White**
SA	**= Silver Anodised**	**BL**	**= Black**
KL	**= Basic Colour**		
HP	**= Special Colour**		
SSC	**= Smooth Satin Chrome**		
SMC	**= Smokey Chrome**		
PC	**= Polished Chrome**		

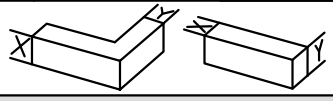
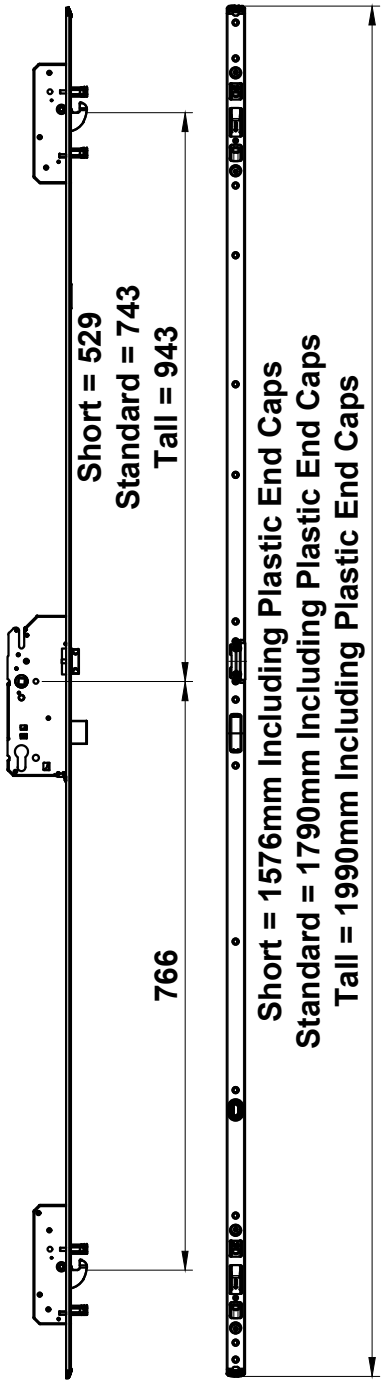
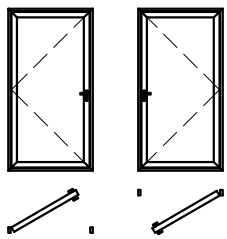
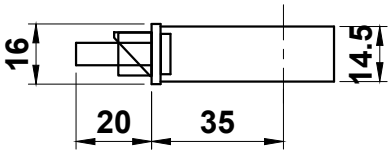


Image	Part Code	Pack	Unit	Application	Colour
	**Key Wind Right Hand Keep** **ACUL363** **Short** **Kit includes:** • **1 x Short key wind multi point lock** • **1 x Short Right Hand full height keep** **ACUL283** **Standard** **Kit includes:** • **1 x Lift Lever Multi Point Lock** • **1 x Right Hand full height Keep** **ACUL383** **Tall** **Kit includes:** • **1 x Tall key wind multi point lock** • **1 x Tall Right Hand full height keep** **Viewed Externally**  **Left Hand Open In** **Right Hand Open Out** 	**1**	**Pack**	**ACDV251** **ACDV737** **ACDV738** **ACET480** **ACET484** **ACET486** **ACET487** **ACSM015SS** **ACSM040SS**	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**	**WP**	**= White**
SA	**= Silver Anodised**	**BL**	**= Black**
KL	**= Basic Colour**		
HP	**= Special Colour**		
SSC	**= Smooth Satin Chrome**		
SMC	**= Smokey Chrome**		
PC	**= Polished Chrome**		

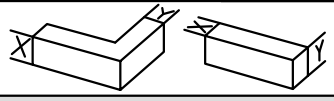
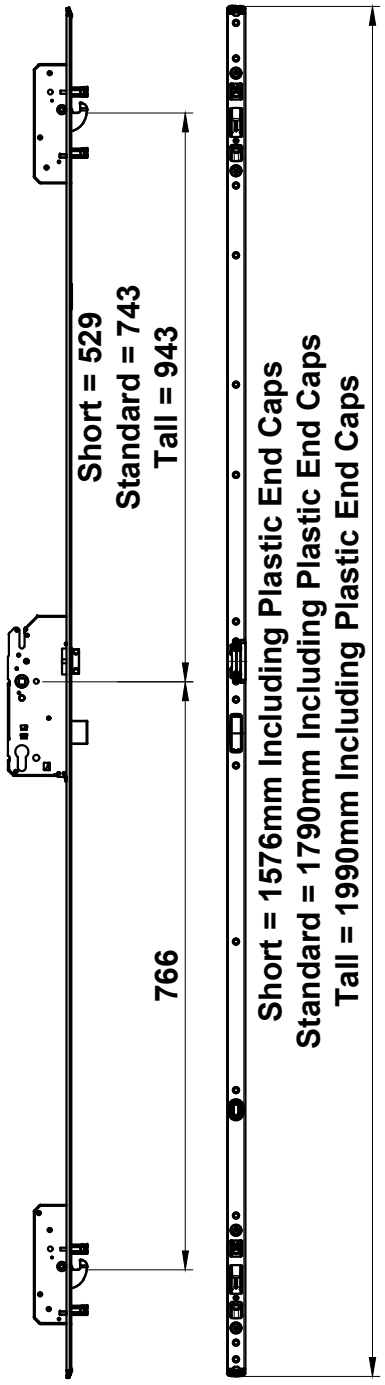
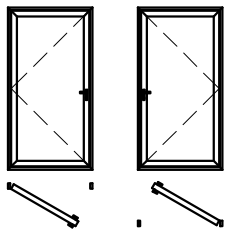
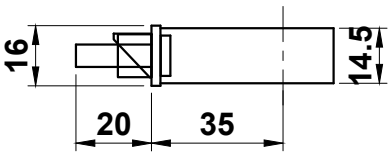


Image	Part Code	Pack	Unit	Application	Colour
	**Lift Lever** **Left Hand Keep** **ACUL377** **Short** **Kit includes:** • **1 x Lift Lever Lock** • **1 x Left Hand Full Height Keep** **ACUL272** **Standard** **Kit includes:** • **1 x Lift Lever Lock** • **1 x Left Hand Full Height Keep** **ACUL374** **Tall** **Kit includes:** • **1 x Lift Lever Lock** • **1 x Left Hand Full Height Keep**	**1**	**Pack**	**ACDV251** **ACET480** **ACET484** **ACET486** **ACET487**	MF ✓ SA KL HP SSC SMC W Z PC

Viewed Externally



Left Hand Open Out **Right Hand Open In**





T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm



Screw (Grub)

MF	**= Mill Finish**	**WP**	**= White**
SA	**= Silver Anodised**	**BL**	**= Black**
KL	**= Basic Colour**		
HP	**= Special Colour**		
SSC	**= Smooth Satin Chrome**		
SMC	**= Smokey Chrome**		
PC	**= Polished Chrome**		

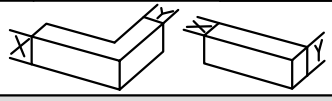
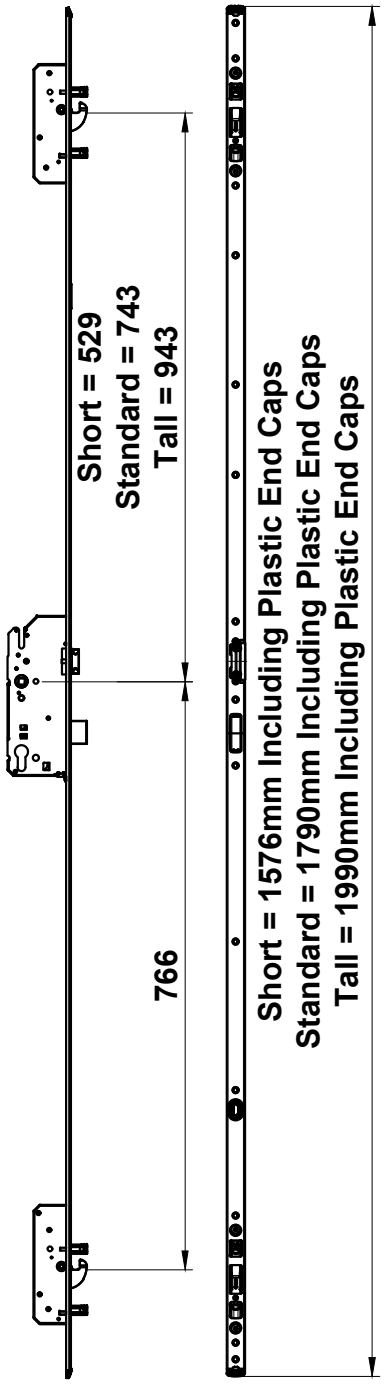
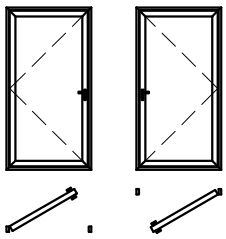
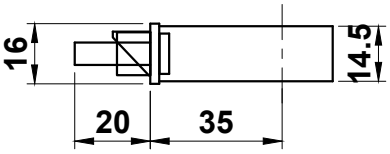


Image	Part Code	Pack	Unit	Application	Colour
	**Lift Lever** **Right Hand Keep** **ACUL378** **Short** **Kit includes:** • 1 x Lift Lever Lock • 1 x Right Hand Full Height Keep **ACUL273** **Standard** **Kit includes:** • 1 x Lift Lever Lock • 1 x Right Hand Full Height Keep **ACUL375** **Tall** **Kit includes:** • 1 x Lift Lever Lock • 1 x Right Hand Full Height Keep **Viewed Externally**  **Left Hand Open In** **Right Hand Open Out** 	1	Pack	**ACDV251** **ACET480** **ACET484** **ACET486** **ACET487** **ACUL276**	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	WP	= White
SA	= Silver Anodised	BL	= Black
KL	= Basic Colour		
HP	= Special Colour		
SSC	= Smooth Satin Chrome		
SMC	= Smokey Chrome		
PC	= Polished Chrome		

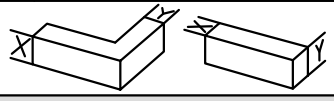
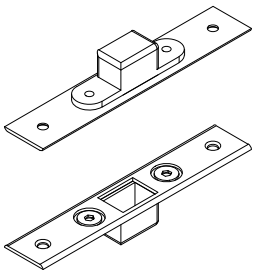
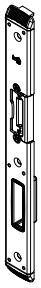


Image	Part Code	Pack	Unit	Application	Colour	
	**ACUL390** **Finger Bolt Flat Keep**	1	Pair	All Locks Excluding ACUL276 ACUL277 ACUL278	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
	**ACUL416** **Center Keep**	1	Each	ACUL460 ETD410	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
	**ACUL417** **Center Keep**	1	Each	ACUL460 ETD410	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
					MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
					MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	



T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm



Screw (Grub)

MF	**= Mill Finish**	**WP**	**= White**
SA	**= Silver Anodised**	**BL**	**= Black**
KL	**= Basic Colour**		
HP	**= Special Colour**		
SSC	**= Smooth Satin Chrome**		
SMC	**= Smokey Chrome**		
PC	**= Polished Chrome**		

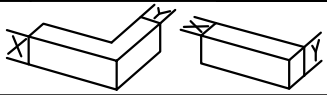
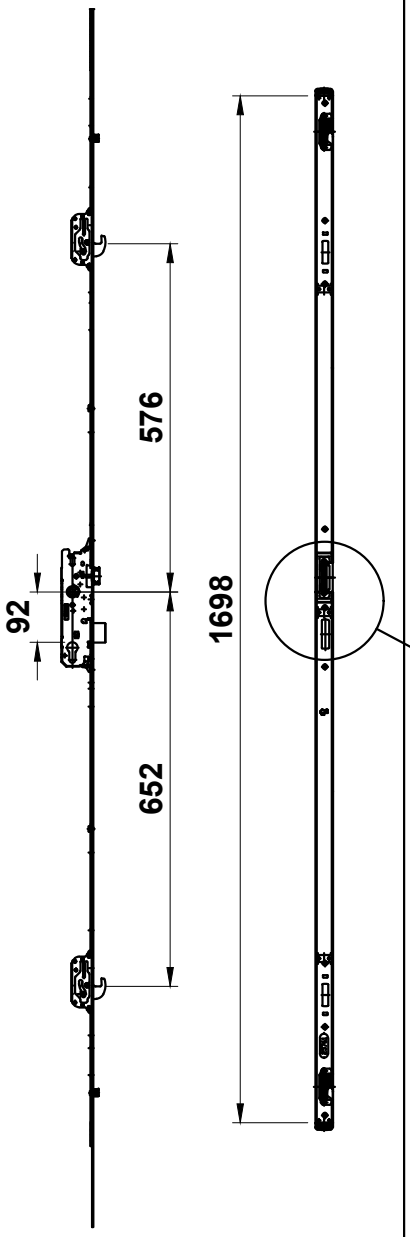
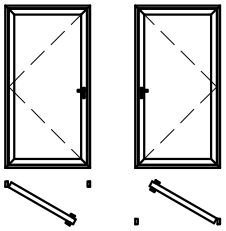
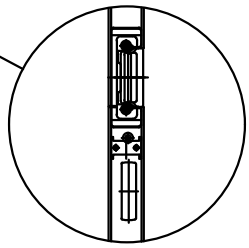
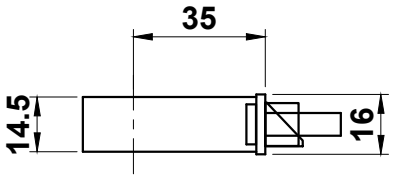


Image	Part Code	Pack	Unit	Application	Colour
	**ACUL421** **Split Spinde Lift Lever Handle Lock with Left Hand Keep** **Kit includes:** • **1 x Split Spindle Lift Lever Handle Lock** • **1 x Left Hand Full Height Keep** • **1 x Split Spindle** **Viewed Externally**  **Left Hand Open Out** **Right Hand Open In**  	1	Pack	**ACDV251** **ACDV737** **ACDV738** **ACET480** **ACET484** **ACET486** **ACET487** **ACSM015SS** **ACSM040SS**	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**	**WP**	**= White**
SA	**= Silver Anodised**	**BL**	**= Black**
KL	**= Basic Colour**		
HP	**= Special Colour**		
SSC	**= Smooth Satin Chrome**		
SMC	**= Smokey Chrome**		
PC	**= Polished Chrome**		

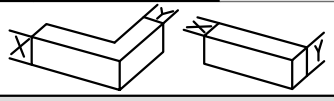
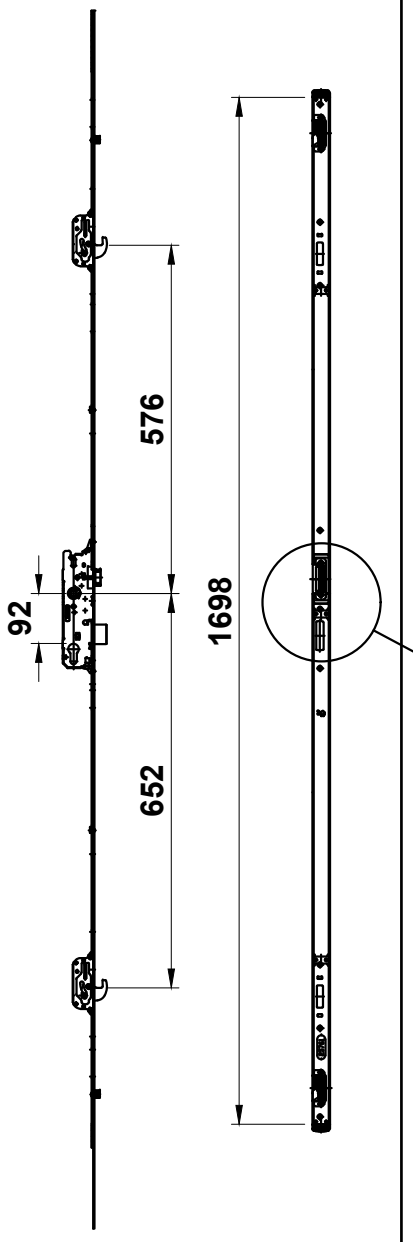
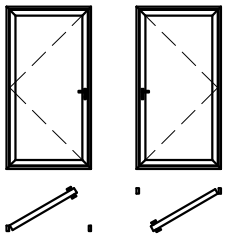
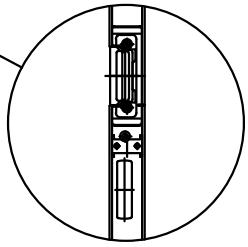
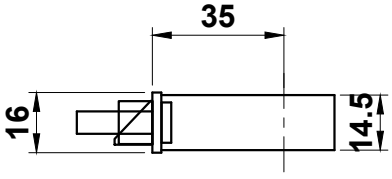


Image	Part Code	Pack	Unit	Application	Colour
	**ACUL422** **Split Spindle Lift Lever Handle Lock with Right Hand Keep** **Kit includes:** • **1 x Split Spindle Lift Lever Handle Lock** • **1 x Right Hand Full Height Keep** • **1 x Split Spindle** **Viewed Externally**  **Left Hand Open In** **Right Hand Open Out**  	1	Pack	ACDV251 ACDV737 ACDV738 ACET480 ACET484 ACET486 ACET487 ACSM015SS ACSM040SS	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**	**WP**	**= White**
SA	**= Silver Anodised**	**BL**	**= Black**
KL	**= Basic Colour**		
HP	**= Special Colour**		
SSC	**= Smooth Satin Chrome**		
SMC	**= Smokey Chrome**		
PC	**= Polished Chrome**		

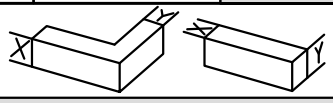
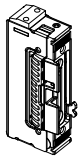
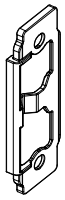
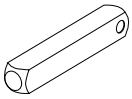
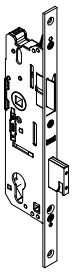
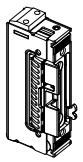


Image	Part Code	Pack	Unit	Application	Colour	
	**ACUL466** **12V DC Fail Secure Electric Strike**	**1**	**Each**	**ACUL283 ACUL363 ACUL383 ACUL416 ACUL417 ACUL467 ETD410**	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
	**ACUL467** **Latch Slide For Electric Strike**	**1**	**Each**	**ACUL465 ACUL466**	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
	**ACUL469** **9 x 60mm Spindle For ACUL473 Panic Bar**	**1**	**Each**		MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
	**ACUL460** **Single Point Lock**	**1**	**Each**	**ETD424 ETD4204 ETD4205**	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
	**ACUL465** **12V DC Fail Safe Electric Strike**	**1**	**Each**	**ACUL283 ACUL363 ACUL383 ACUL416 ACUL417 ACUL467 ETD410**	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	



T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm



Screw (Grub)

MF	**= Mill Finish**	**WP**	**= White**
SA	**= Silver Anodised**	**BL**	**= Black**
KL	**= Basic Colour**		
HP	**= Special Colour**		
SSC	**= Smooth Satin Chrome**		
SMC	**= Smokey Chrome**		
PC	**= Polished Chrome**		

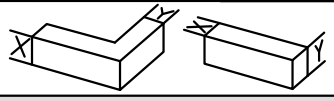
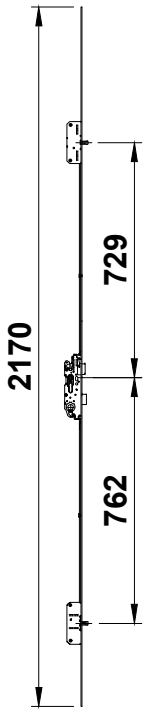
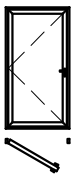
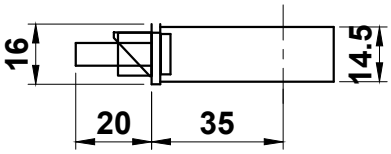
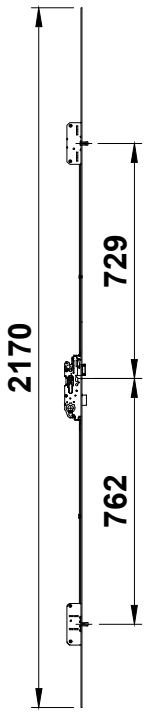
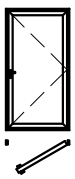
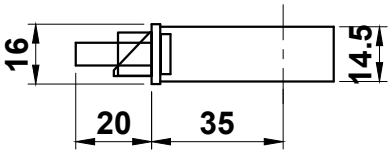


Image	Part Code	Pack	Unit	Application	Colour
	**ACUL470** **Panic Bar Multipoint Lock** **Only compatible with free movement cam cylinder** **Viewed Externally**  **Left Hand Open Out** 	1	Pack	**ACUL417** **ACUL472** **ACUL473** **ACUL474** **ACUL475** **ACUL476** **ACUL477**	MF ✓ SA KL HP SSC SMC W Z PC
	**ACUL471** **Panic Bar Multipoint Lock** **Only compatible with free movement cam cylinder** **Viewed Externally**  **Right Hand Open Out** 	1	Each	**ACUL416** **ACUL472** **ACUL473** **ACUL474** **ACUL475** **ACUL476** **ACUL477**	MF ✓ SA KL HP SSC SMC W Z PC

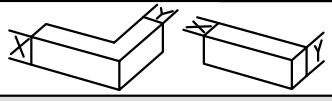


T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm



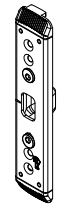
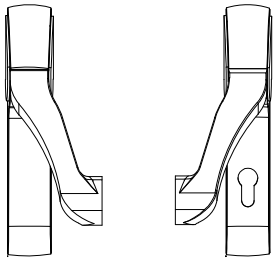
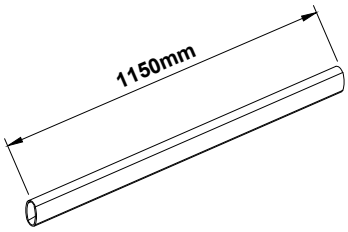
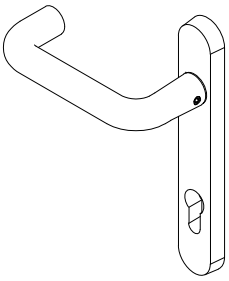
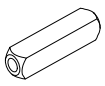
Screw (Grub)

MF	**= Mill Finish**	**WP**	**= White**
SA	**= Silver Anodised**	**BL**	**= Black**
KL	**= Basic Colour**		
HP	**= Special Colour**		
SSC	**= Smooth Satin Chrome**		
SMC	**= Smokey Chrome**		
PC	**= Polished Chrome**		



Alitherm 400 Stepped Door

ACCESSORIES : PHOTOS & DRAWINGS

Image	Part Code	Pack	Unit	Application	Colour	
	**ACUL472** **Door Keep**	**1**	**Each**	**ACUL470** **ACUL471** **ETD410**	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
	**ACUL473** **Panic Bar Arms** **(Black PVC)**	**1**	**set**	**ACUL470** **ACUL471** **ETD4205**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	✓
					PC	
	**ACUL474** **Green Panic Bar**	**1**	**Each**	**ACUL473**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
	**ACUL475** **Silver External Lever Handle** **for ACUL473** **Panic Bar**	**1**	**Each**	**ACUL470** **ACUL471** **ETD4205**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
	**ACUL476** **External Panic Bar Split Spindle** **- 9 x 39mm**	**1**	**Each**	**ACUL470** **ACUL471** **ETD4205**	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	

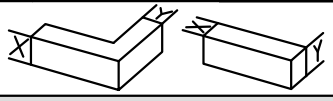


T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm



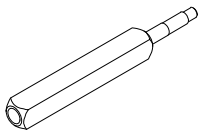
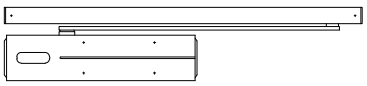
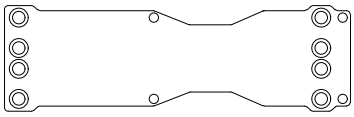
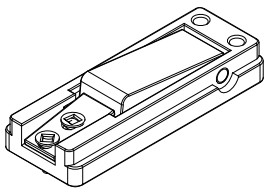
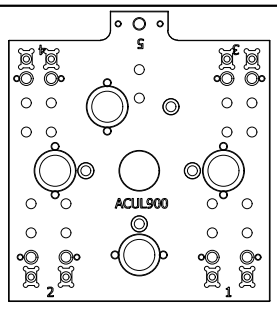
Screw (Grub)

MF	**= Mill Finish**	**WP**	**= White**
SA	**= Silver Anodised**	**BL**	**= Black**
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SSC	**= Smooth Satin Chrome**		
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PC	**= Polished Chrome**		



Alitherm 400 Stepped Door

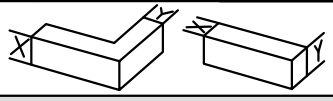
ACCESSORIES : PHOTOS & DRAWINGS

Image	Part Code	Pack	Unit	Application	Colour	
	**ACUL477** **Internal Panic Bar Split Spindle - 9 x 67mm**	**1**	**Each**	**ACUL470 ACUL471 ETD4205**	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
	**ACUL478** **Surface Fixed Closer (Silver)**	**1**	**Each**		MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
	**ACUL479** **Mounting Plate For Surface Fixed Closer**	**1**	**Each**	**ACUL478**	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
	**ACUL480** **Hold Open Device For Surface Fixed Closer**	**1**	**Each**	**ACUL478**	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
	**ACUL900** **Punch Tool**	**1**	**Each**	**ETD402 ETD404 ETD410 ETD4204 ETD4205 ETD424**	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	



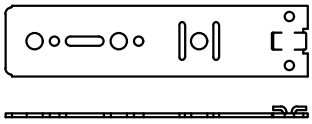
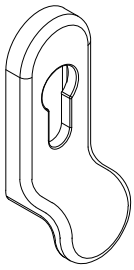
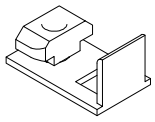


MF	**= Mill Finish**	**WP**	**= White**
SA	**= Silver Anodised**	**BL**	**= Black**
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Alitherm 400 Stepped Door

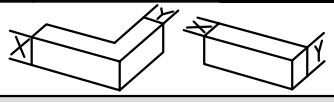
ACCESSORIES : PHOTOS & DRAWINGS

Image	Part Code	Pack	Unit	Application	Colour	
	**ACUL950** **Drill Jig for Hinges**	**1**	**Each**	**ACUL250 ETD410 ETD424 ETD4204 ETD4205**	MF SA KL HP SSC SMC WP BL PC	
	**ACUN23X** **Screw Fixing Lug B x 38mm x 2mm** **ACUN230: B = 160mm ACUN232: B = 240mm ACUN233: B = 280mm**	**100**	**Pack**	**ETC451 ETC452 ETC457 ETC458 ETC478 ETC479 ETD410 ETD412**	MF SA KL HP SSC SMC WP BL PC	✓
	**ACUN3035** **Door Gasket**	**100**	**m**		MF SA KL HP SSC SMC WP BL PC	 ✓
	**ACUN3143** **Cylinder Pull S/S** **Fixings:- 2 No. ACET064**	**1**	**Each**		MF SA KL HP SSC SMC WP BL PC	
	**ACUN3400** **Shootbolt End Guide For ACDV737/8**	**1**	**Each**		MF SA KL HP SSC SMC WP BL PC	✓



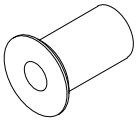
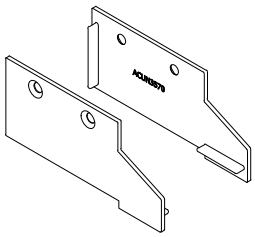
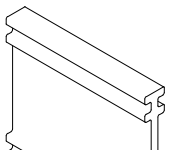


MF = Mill Finish
SA = Silver Anodised
KL = Basic Colour
HP = Special Colour
SSC = Smooth Satin Chrome
SMC = Smokey Chrome
PC = Polished Chrome
WP = White
BL = Black



Alitherm 400 Stepped Door

ACCESSORIES : PHOTOS & DRAWINGS

Image	Part Code	Pack	Unit	Application	Colour	
	**ACUN3499** **M5 Shakeproof Washer**	**100**	**Pack**		MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
	**ACUN3500** **M6 Shakeproof Washer**	**100**	**Pack**		MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
	**ACUN3509** **M5 Rivnut**	**20**	**Pack**		MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
	**ACUN3570** **UN3570 End Caps**	**1**	**Pair**		MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	✓
					BL	✓
					PC	
	**ACUN3701** **Anti-Crush Support**	**25**	**Pack**		MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	✓
					PC	

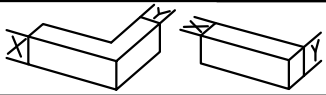


T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm



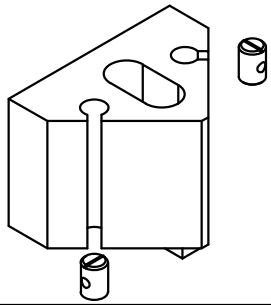
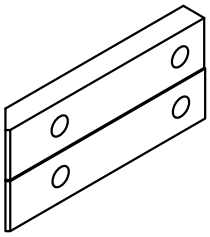
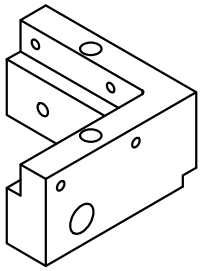
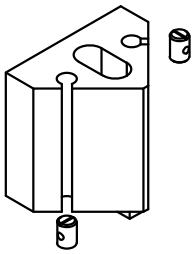
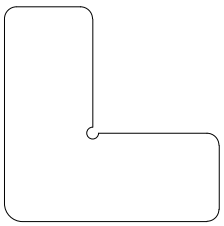
Screw (Grub)

MF	**= Mill Finish**	**WP**	**= White**
SA	**= Silver Anodised**	**BL**	**= Black**
KL	**= Basic Colour**		
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Alitherm 400 Stepped Door

ACCESSORIES : PHOTOS & DRAWINGS

Image	Part Code	Pack	Unit	Application	Colour	
	**ACET3950** **Vee Block**	**1**	**Each**	**ETD4220**	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
	**ACET3952** **Nylon Packer**	**1**	**Each**	**ETD4220** **ETD4221**	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
	**ACET3957** **Vee Block**	**1**	**Each**	**ETD4220**	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
	**ACET3964** **Vee Block**	**1**	**Each**	**ETD4221**	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
	**ACVG520** **Stainless Steel Chevron**	**100**	**Pack**	**ETD4204**	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	

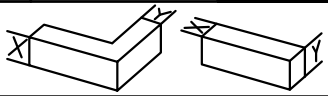


T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm



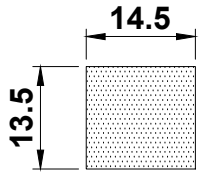
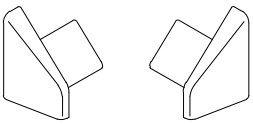
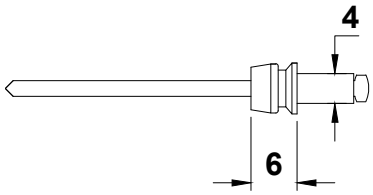
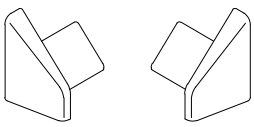
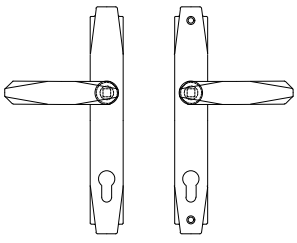
Screw (Grub)

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Alitherm 400 Stepped Door

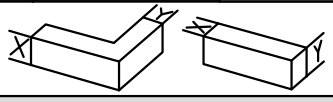
ACCESSORIES : PHOTOS & DRAWINGS

Image	Part Code	Pack	Unit	Application	Colour	
	**ACVG560** **Infill Foam**	**1**	**Each**	**ETD4220**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	✓
					PC	
	**ACVL059** **End Caps**	**1**	**Pair**	**VL72**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	✓
					BL	✓
					PC	
	**ACVL061** **Rivet to secure VL72**	**100**	**Pack**	**VL72**	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
	**ACVL072** **Cast End Caps**	**1**	**Pair**	**VL72**	MF	✓
					SA	
					KL	✓
					HP	✓
					SSC	
					SMC	
					WP	✓
					BL	✓
					PC	
	**ACW20062** **Art Deco Lever / Lever Handle Includes Cylinder Cut Out** **Available in Antique Brass and Satin Nickel Plate**	**1**	**Pair**	**ACW20465** **ACW20466**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	


T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm

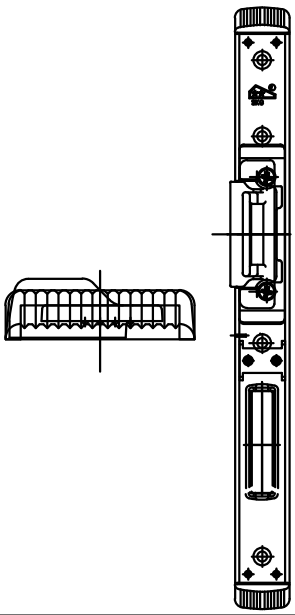
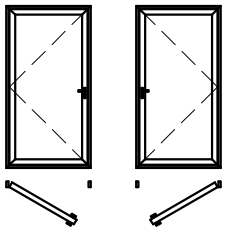
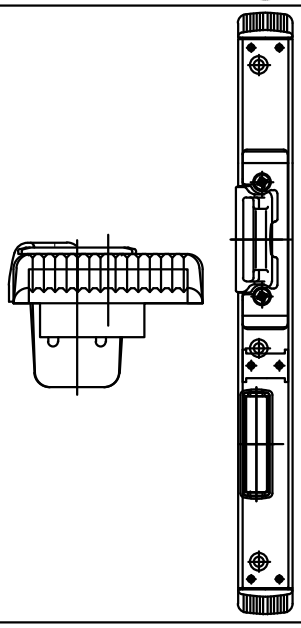
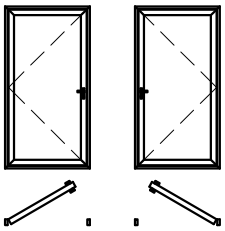
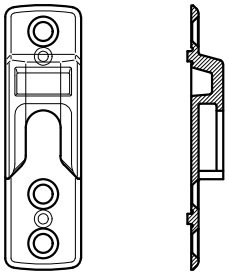

Screw (Grub)

MF = Mill Finish **WP = White**
SA = Silver Anodised **BL = Black**
KL = Basic Colour
HP = Special Colour
SSC = Smooth Satin Chrome
SMC = Smokey Chrome
PC = Polished Chrome



Alitherm 400 Stepped Door

ACCESSORIES : PHOTOS & DRAWINGS

Image	Part Code	Pack	Unit	Application	Colour
	**ACW20066 L/R** **Open Out Centre Keep** **Viewed Externally**  **Left Hand Open Out** **Right Hand Open Out**	1	Each	ACW20465	MF ✓ SA KL HP SSC SMC WP BL PC
	**ACW20166 L/R** **Open In Centre Keep** **Viewed Externally**  **Right Hand Open In** **Left Hand Open In**	1	Each	ACW20465	MF ✓ SA KL HP SSC SMC WP BL PC
	**ACW20367** **Rollers Keep**	1	Each	ACW20465	MF ✓ SA KL HP SSC SMC WP BL PC



T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm



Screw (Grub)

MF	**= Mill Finish**	**WP**	**= White**
SA	**= Silver Anodised**	**BL**	**= Black**
KL	**= Basic Colour**		
HP	**= Special Colour**		
SSC	**= Smooth Satin Chrome**		
SMC	**= Smokey Chrome**		
PC	**= Polished Chrome**		

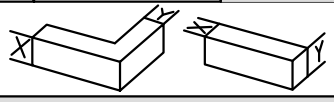
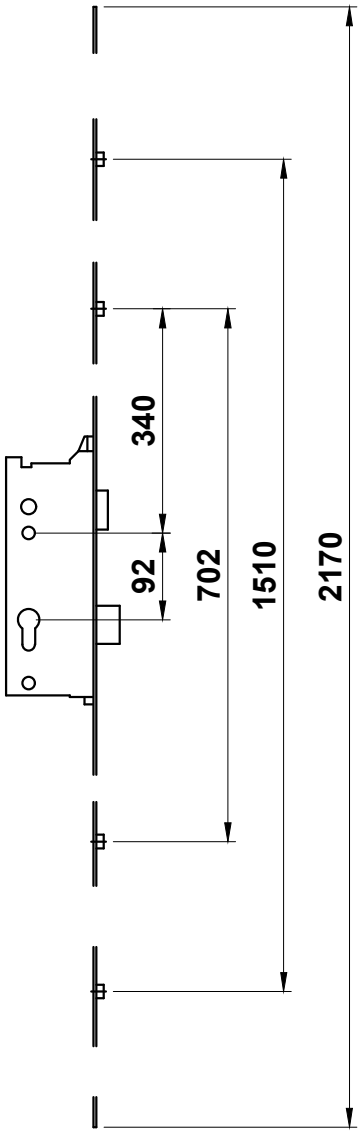
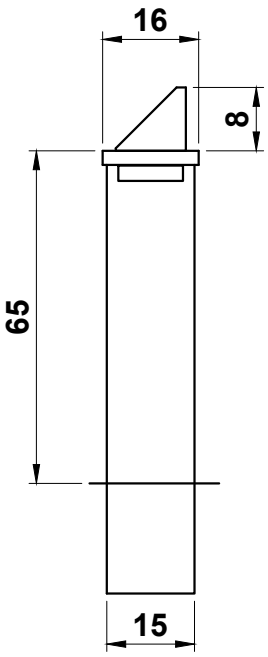
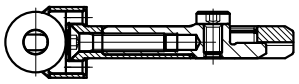


Image	Part Code	Pack	Unit	Application	Colour
	**ACW20465** **Euro Cylinder Profile** **Open In & Out** **Primary Lock** **65mm Set Back** 	1	Each	ACW20466 ETD4220 ETD4221	MF ✓ SA KL HP SSC SMC W Z PC
	**ACPD690** **Roller Latch**	1	Each	W20465	MF ✓ SA KL HP SSC SMC WP BL PC



T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm



Screw (Grub)

MF	= Mill Finish	WP	= White
SA	= Silver Anodised	BL	= Black
KL	= Basic Colour		
HP	= Special Colour		
SSC	= Smooth Satin Chrome		
SMC	= Smokey Chrome		
PC	= Polished Chrome		

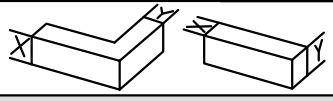
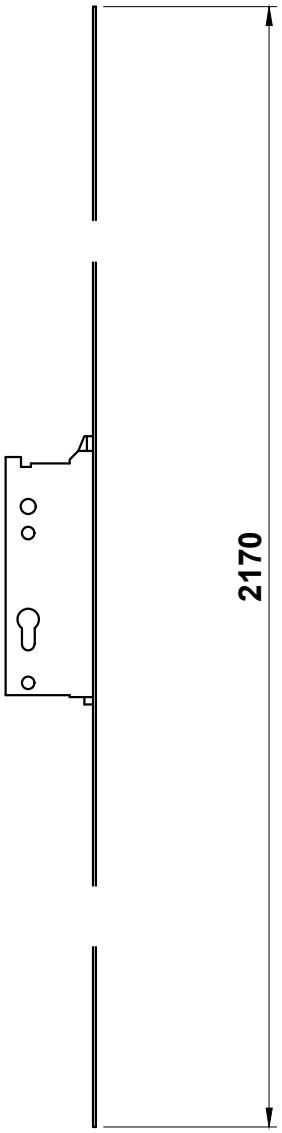
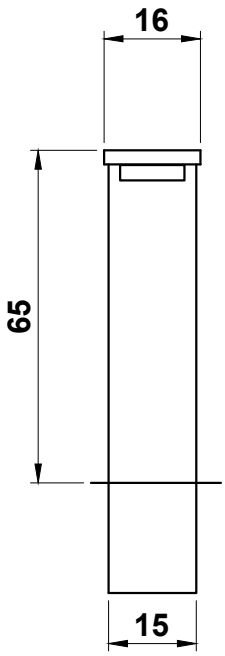
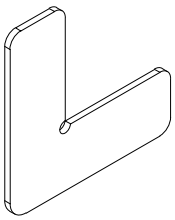


Image	Part Code	Pack	Unit	Application	Colour
	**ACW20466** **Euro Cylinder Profile** **Open In & Out** **Secondary Lock** **65mm Set Back** 	**1**	**Each**	**ACW20465** **ETD4220** **ETD4221**	MF ✓ SA KL HP SSC SMC W Z PC
	**WCA106SSZ** **Stainless Steel Chevrons**	**50**	**Pack**	**ETD402** **ETD4204** **ETD4205** **ETD424**	MF ✓ SA KL HP SSC SMC WP BL PC

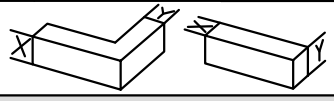


T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm



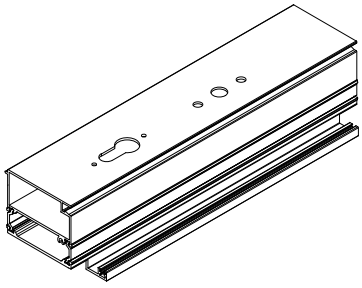
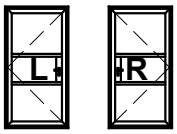
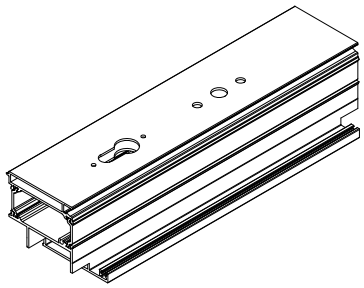
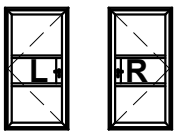
Screw (Grub)

MF	**= Mill Finish**	**WP**	**= White**
SA	**= Silver Anodised**	**BL**	**= Black**
KL	**= Basic Colour**		
HP	**= Special Colour**		
SSC	**= Smooth Satin Chrome**		
SMC	**= Smokey Chrome**		
PC	**= Polished Chrome**		



Alitherm 400 Stepped Door

ACCESSORIES : PHOTOS & DRAWINGS

Image	Part Code	Pack	Unit	Application	Colour	
	**ACW4238 L/R** **285mm Pre Prepared Lock Casing - Open In** 	**1**	**Each**		MF SA KL HP SSC SMC WP BL PC	✓ ✓ ✓ ✓ ✓
	**ACW4239 L/R** **285mm Pre Prepared Lock Casing - Open Out** 	**1**	**Each**		MF SA KL HP SSC SMC WP BL PC	✓ ✓ ✓ ✓ ✓
					MF SA KL HP SSC SMC WP BL PC	
					MF SA KL HP SSC SMC WP BL PC	
					MF SA KL HP SSC SMC WP BL PC	

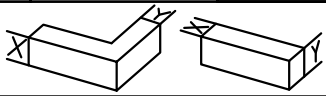


T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm



Screw (Grub)

MF = Mill Finish
SA = Silver Anodised
KL = Basic Colour
HP = Special Colour
SSC = Smooth Satin Chrome
SMC = Smokey Chrome
PC = Polished Chrome
WP = White
BL = Black



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Alitherm 400 Stepped Door

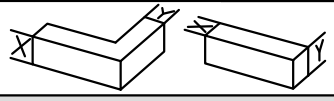
STANDARD ACCESSORIES

Image	Part Code	Pack	Unit	Application	Colour	
	**ACMX09700** **Alu. Polish**	**1**	**each**		MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
	**ACMX09761** **Maxi Gloss**	**1**	**each**		MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
	**ACMX09762** **Alu. Bright**	**1**	**each**		MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
	**ACMX09763** **Teflon Spray**	**1**	**each**		MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
	**ACMX09764** **Maxi Clean**	**1**	**each**		MF	
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					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	





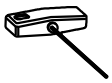
MF = Mill Finish
SA = Silver Anodised
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SSC = Smooth Satin Chrome
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PC = Polished Chrome
WP = White
BL = Black



Alitherm 400 Stepped Door

STANDARD ACCESSORIES

Image	Part Code	Pack	Unit	Application	Colour
	**ACMX09765** **Glue Cleaner** **De-grease and silicone remover (1 Litre).**	**1**	**each**		MF SA KL HP SSC SMC WP BL PC
	**ACMX09770** **Roll & Wrap 100mm**	**1**	**each**		MF SA KL HP SSC SMC WP BL PC
	**ACMX09775** **Grip Handwrap**	**1**	**each**		MF SA KL HP SSC SMC WP BL PC
	**ACMX09801** **Protective Tape 50mm**	**1**	**each**		MF SA KL HP SSC SMC WP BL PC
	**ACMX09802** **Protective Tape 70mm**	**1**	**each**		MF SA KL HP SSC SMC WP BL PC

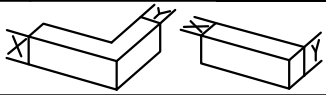


T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm



Screw (Grub)

MF	**= Mill Finish**	**WP**	**= White**
SA	**= Silver Anodised**	**BL**	**= Black**
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PC	**= Polished Chrome**		



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Alitherm 400 Stepped Door

STANDARD ACCESSORIES

Image	Part Code	Pack	Unit	Application	Colour	
	**ACMX09803** **Protective Tape 100mm**	**1**	**each**		MF SA KL HP SSC SMC WP BL PC	
	**ACMX09830** **Rubber Sealant**	**1**	**each**		MF SA KL HP SSC SMC WP BL 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 WP ✓ BL ✓ PC	
	**ACSIL08** **Silicon Gun**	**1**	**each**		MF SA KL HP SSC SMC WP BL PC	
	**ACSIL013** **Glue for Mitre**	**1**	**each**		MF SA KL HP SSC SMC WP BL PC	

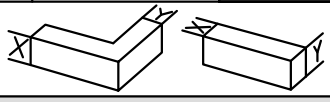


T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm



Screw (Grub)

MF	= Mill Finish	WP	= White
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PC	= Polished Chrome		



Alitherm 400 Stepped Door

STANDARD ACCESSORIES

Image	Part Code	Pack	Unit	Application	Colour	
	**ACSIL014** **Anti-Corrosion Coating**	**1**	**each**		MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
	**ACUN3900** **Gasket Roller**	**1**	**each**		MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
					MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					WP	
					BL	
					PC	
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					SA	
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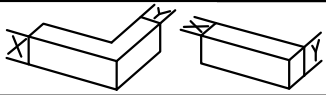


T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm



Screw (Grub)

MF	**= Mill Finish**	**WP**	**= White**
SA	**= Silver Anodised**	**BL**	**= Black**
KL	**= Basic Colour**		
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SSC	**= Smooth Satin Chrome**		
SMC	**= Smokey Chrome**		
PC	**= Polished Chrome**		



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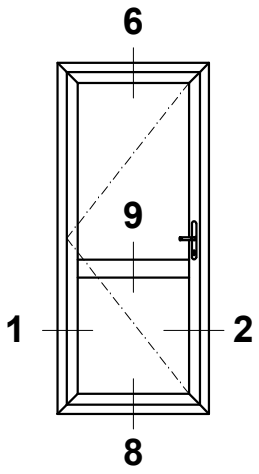
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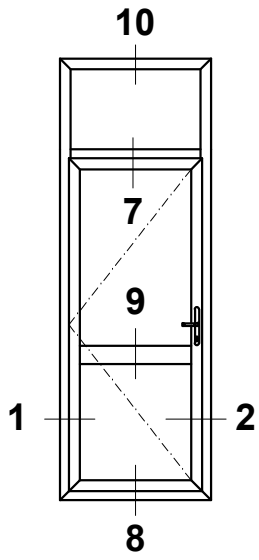
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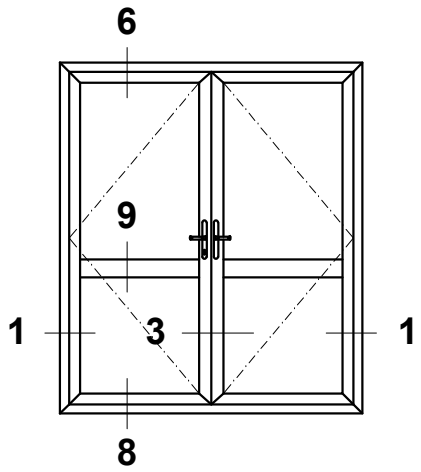
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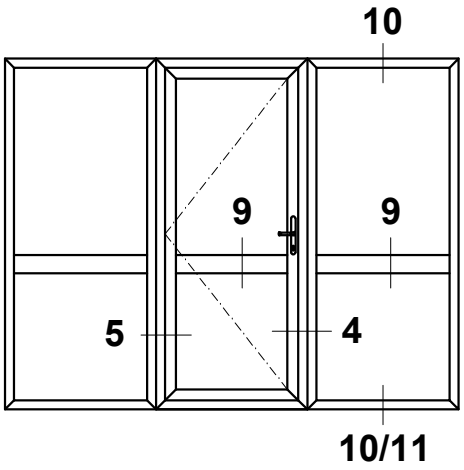
Alitherm 400 Stepped Door

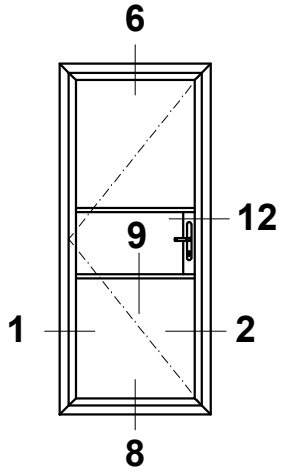
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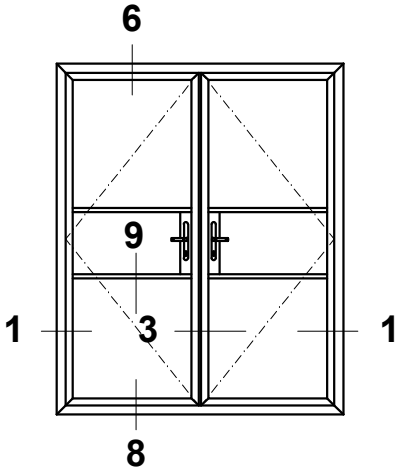






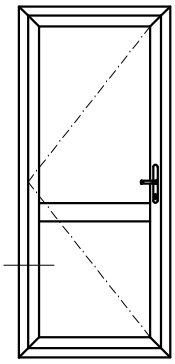


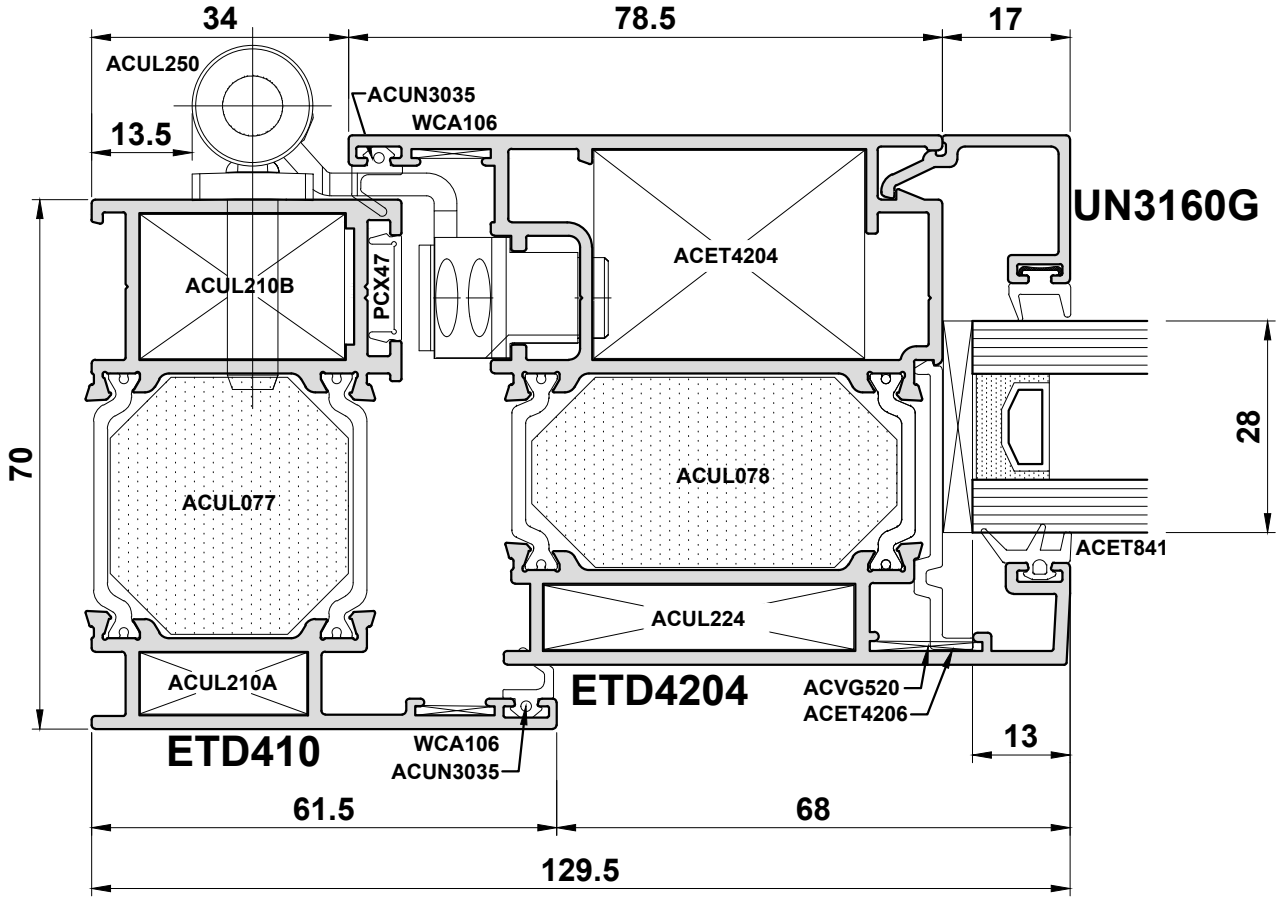




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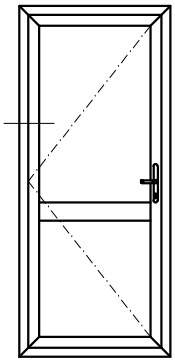
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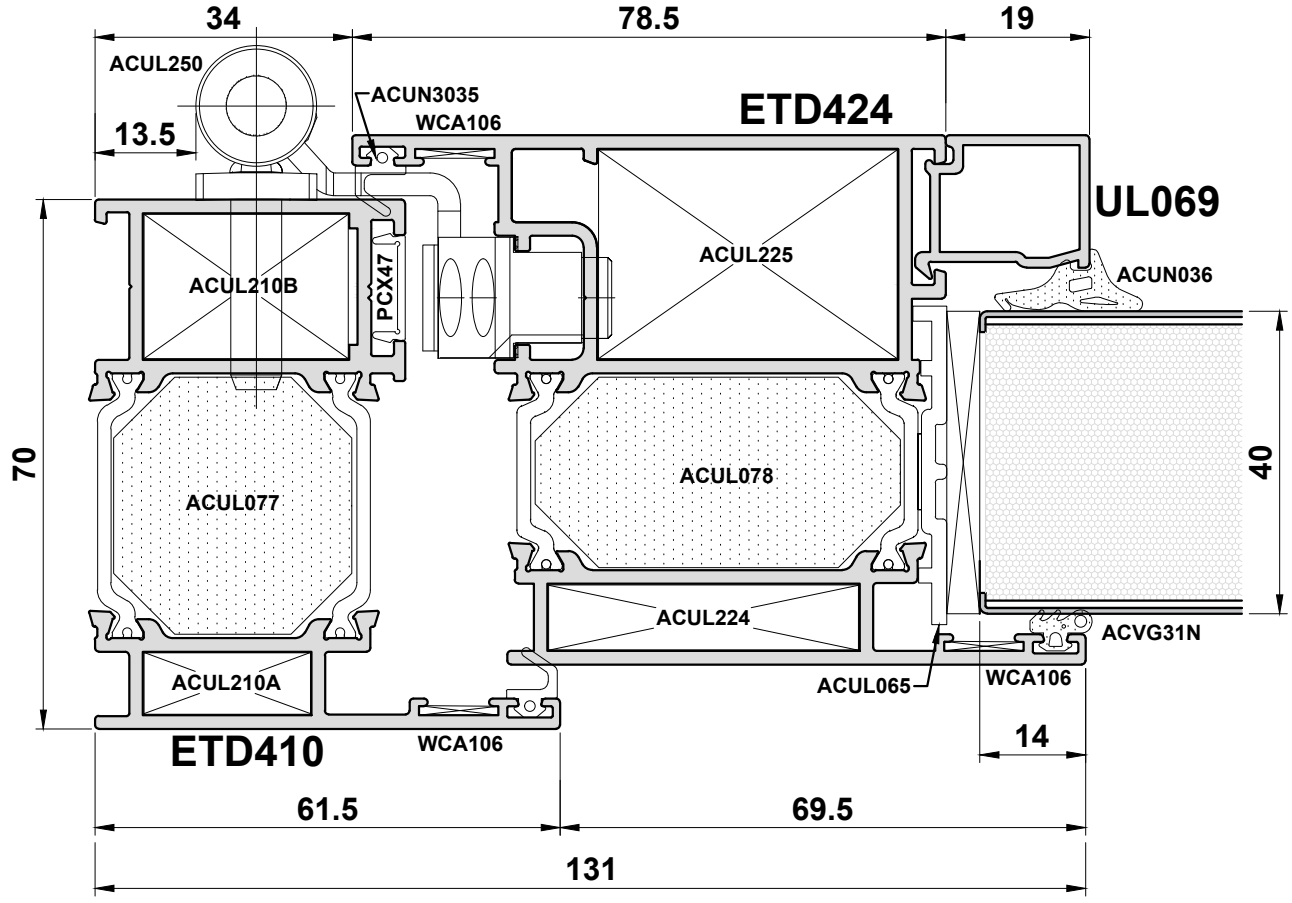




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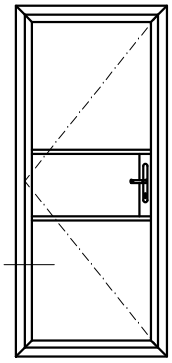
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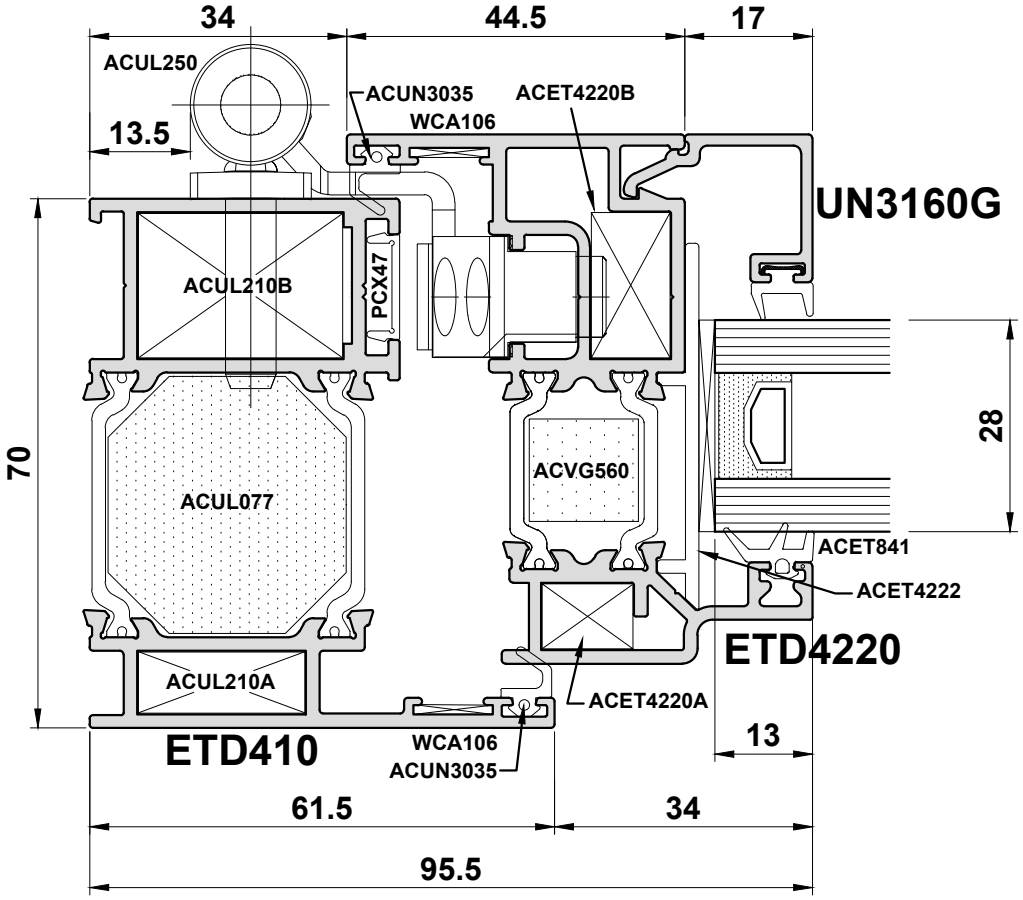




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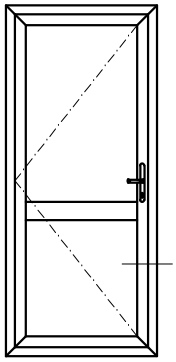
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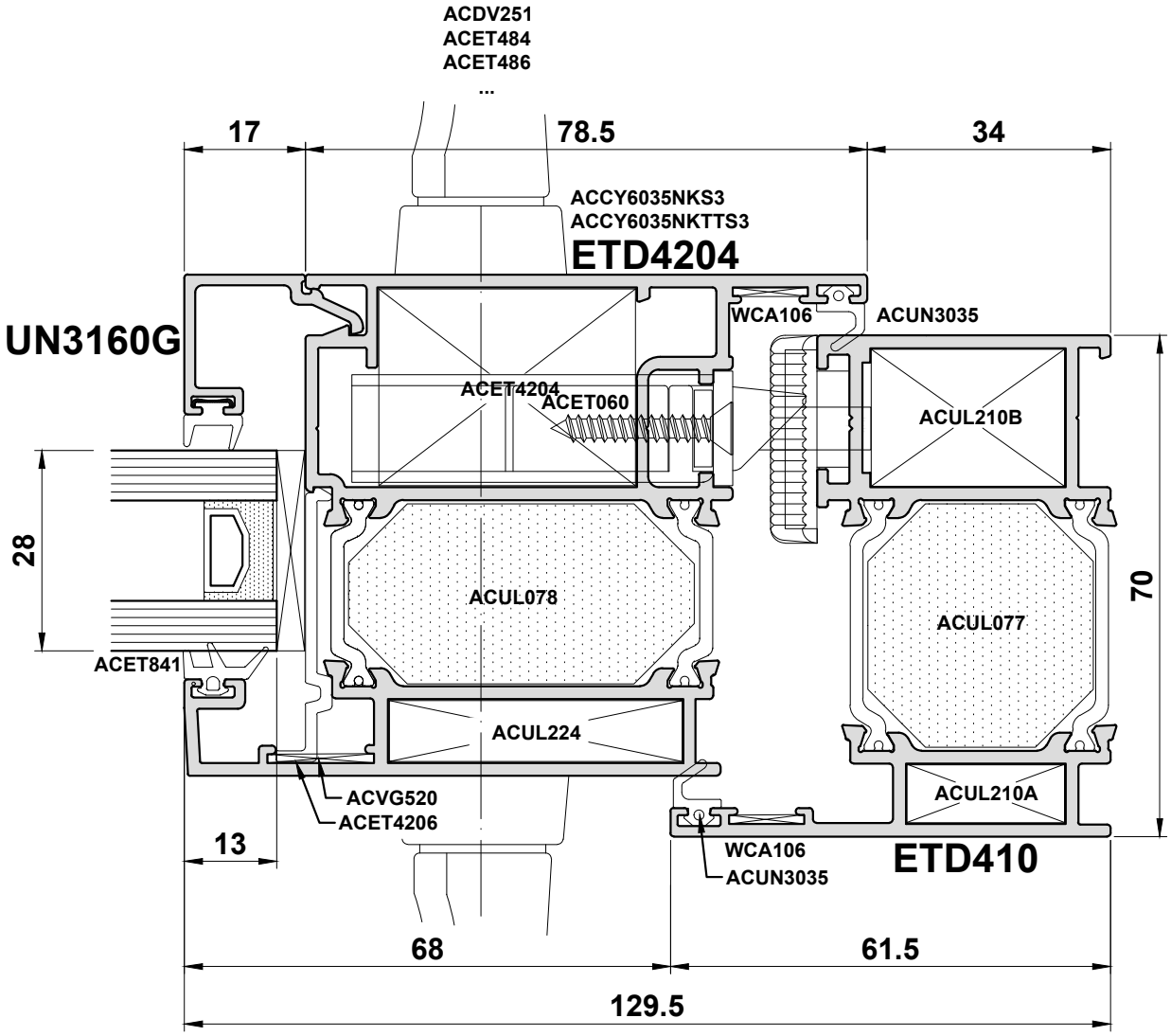




Do Not Scale From This Drawing

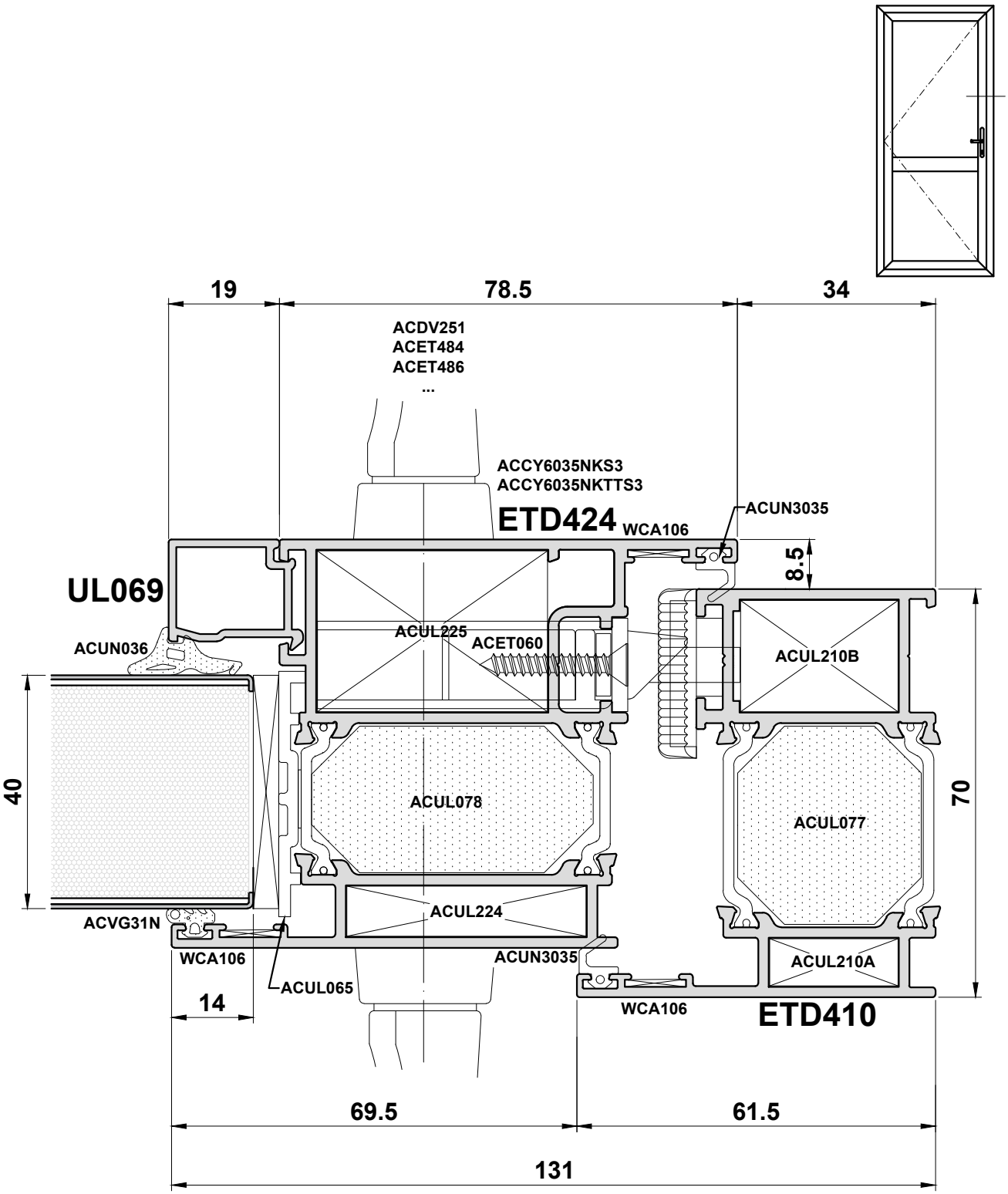
Open In - Detail 2A





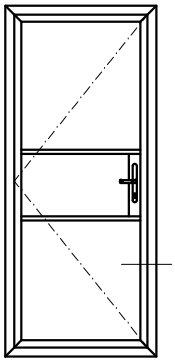
Do Not Scale From This Drawing

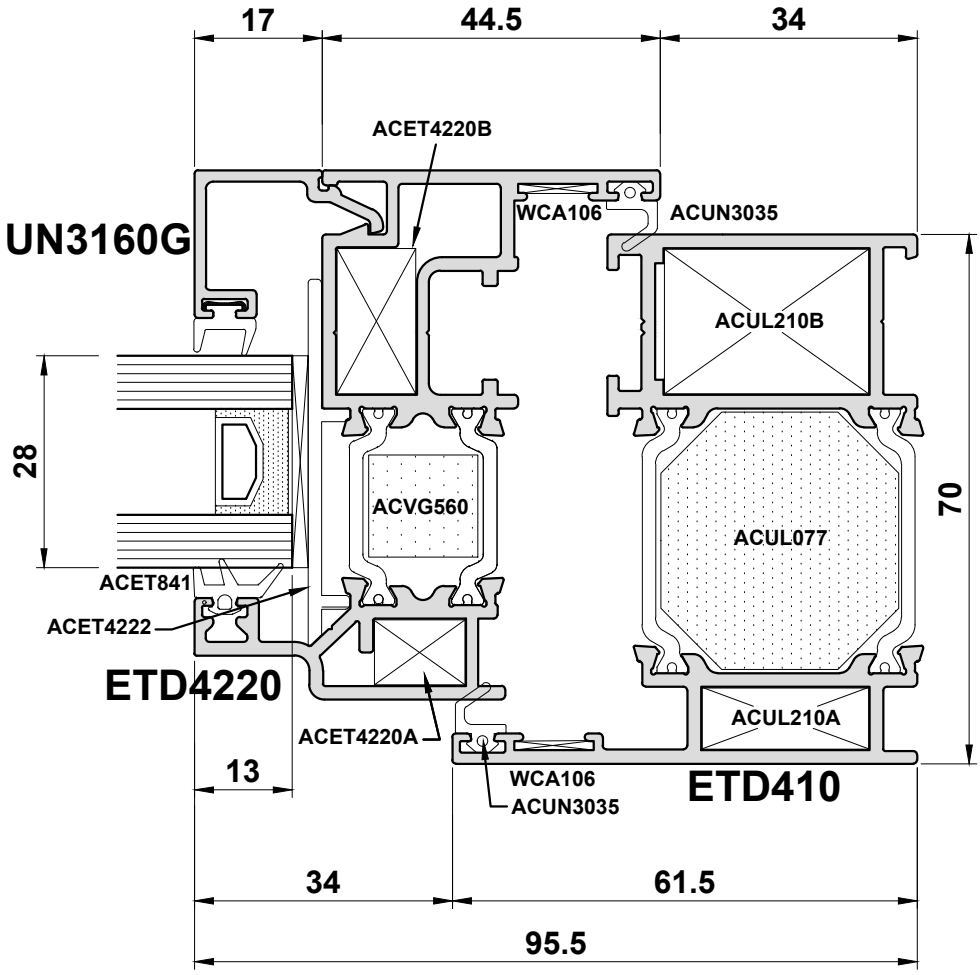
Open In - Detail 2B



Do Not Scale From This Drawing

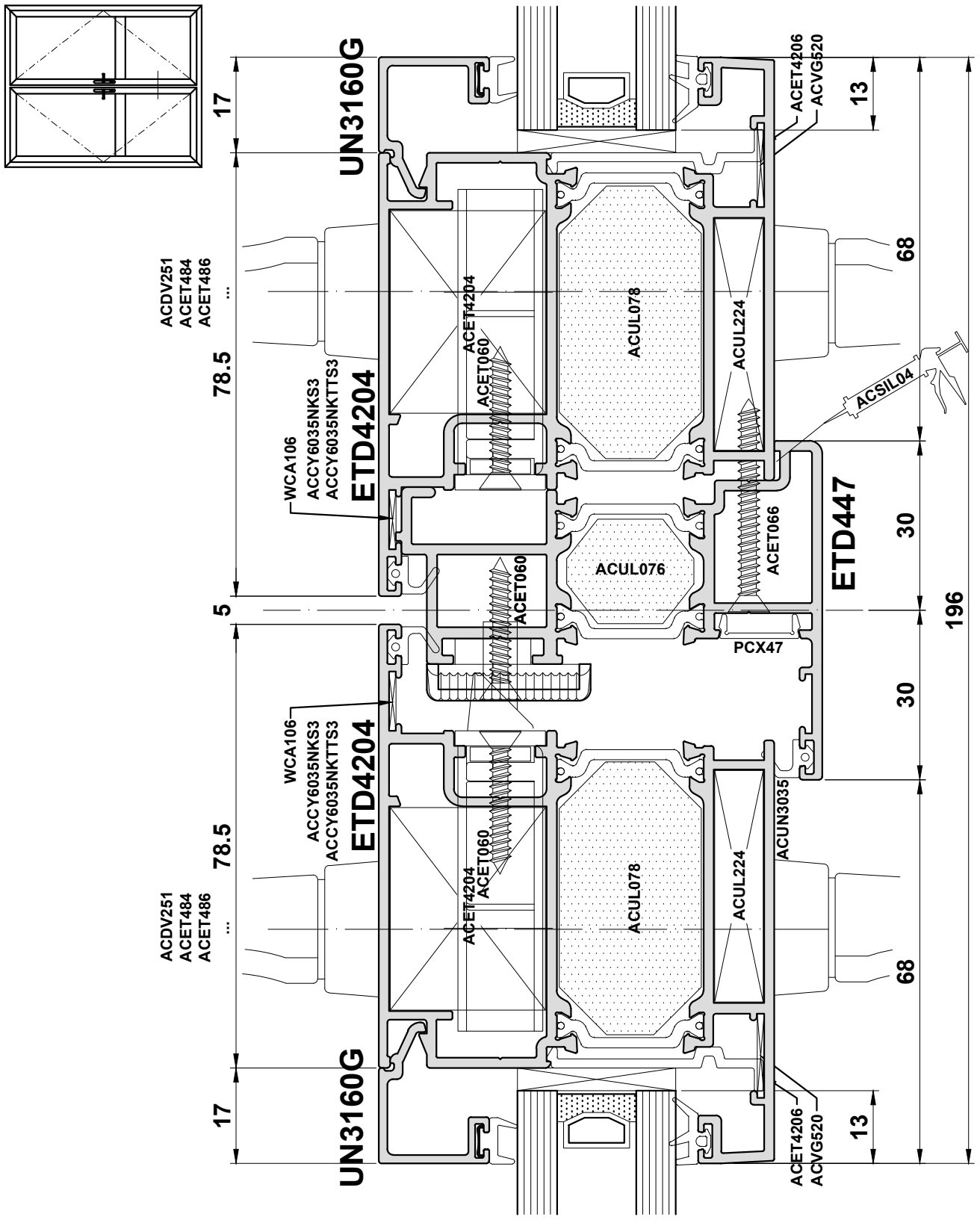
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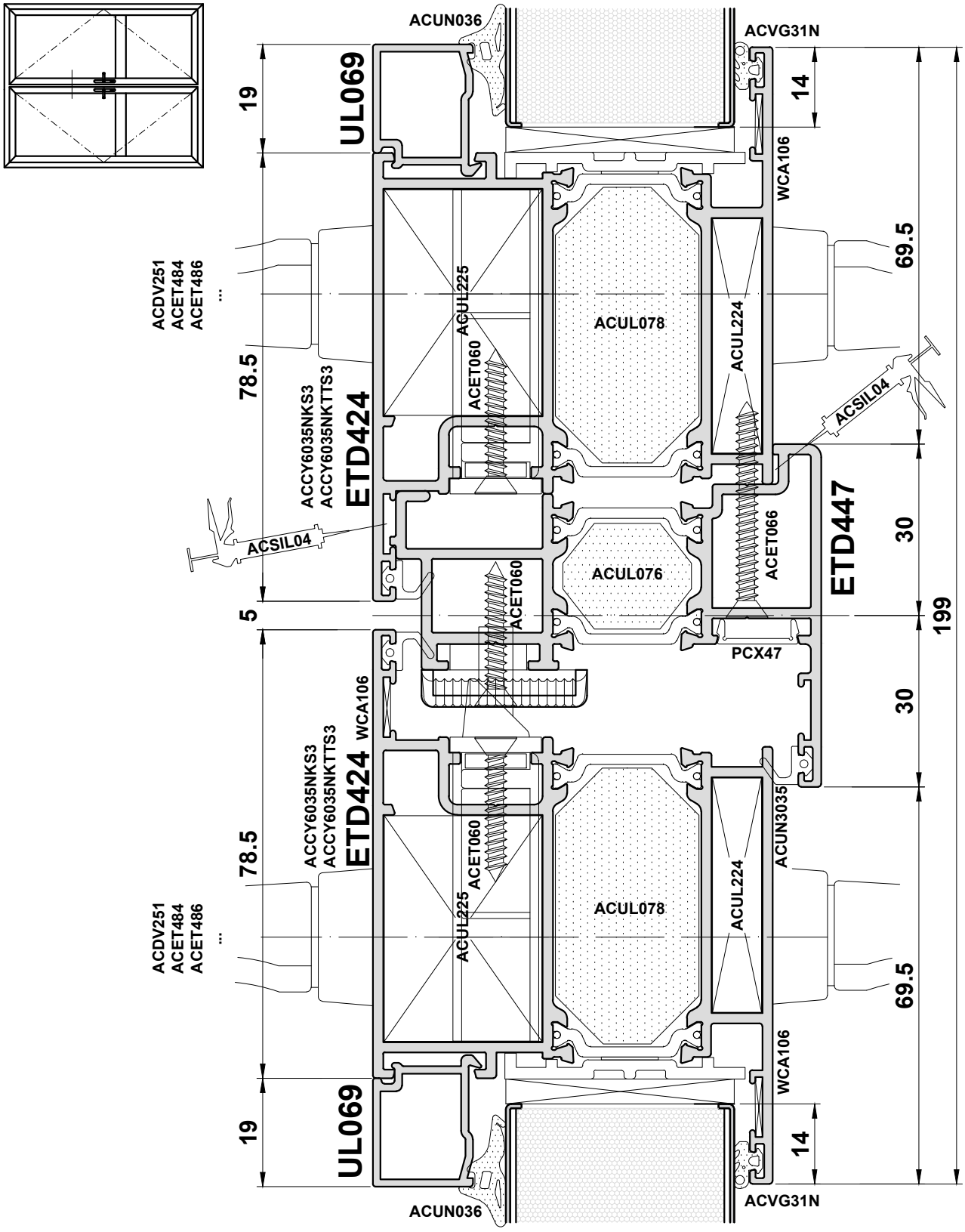
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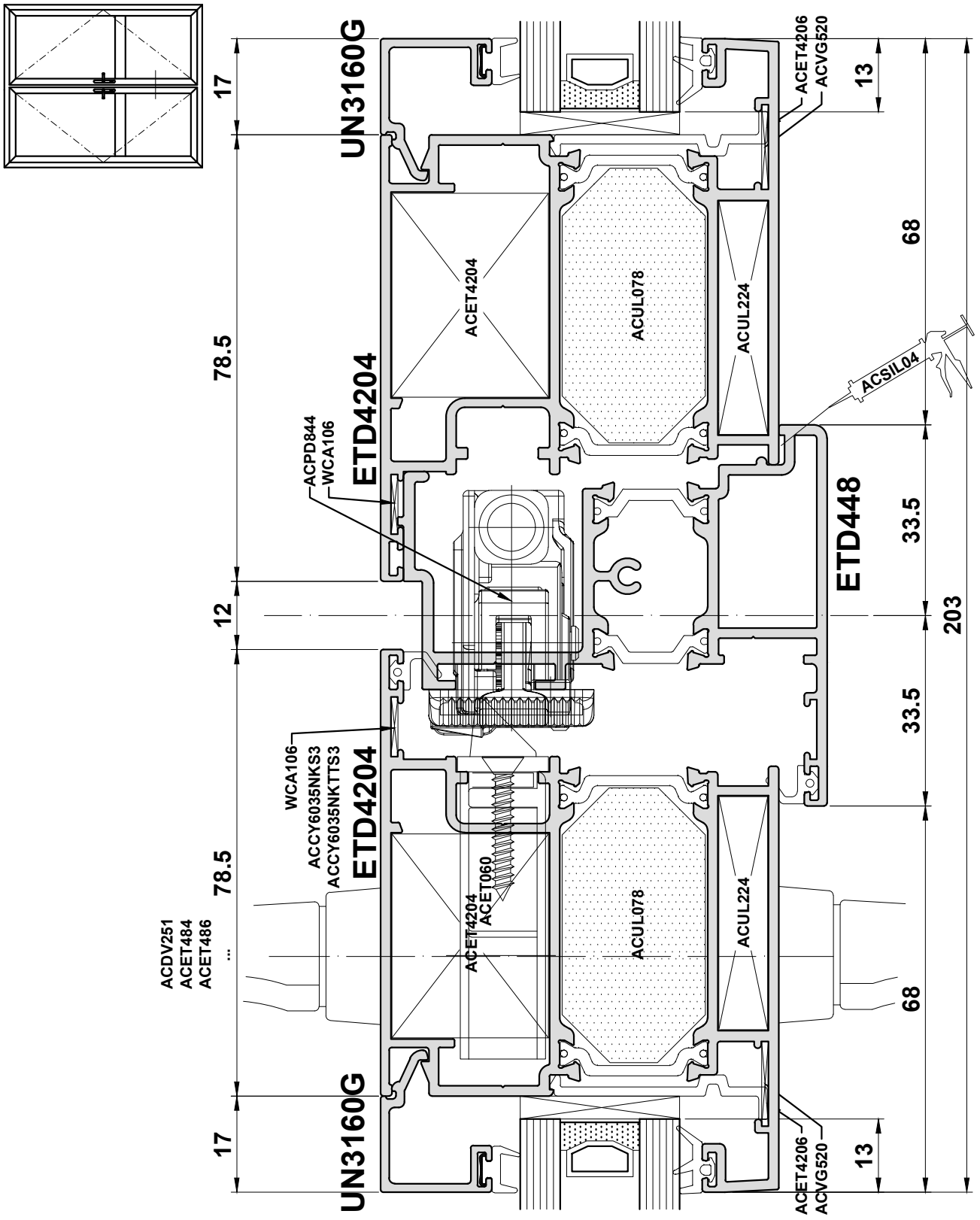
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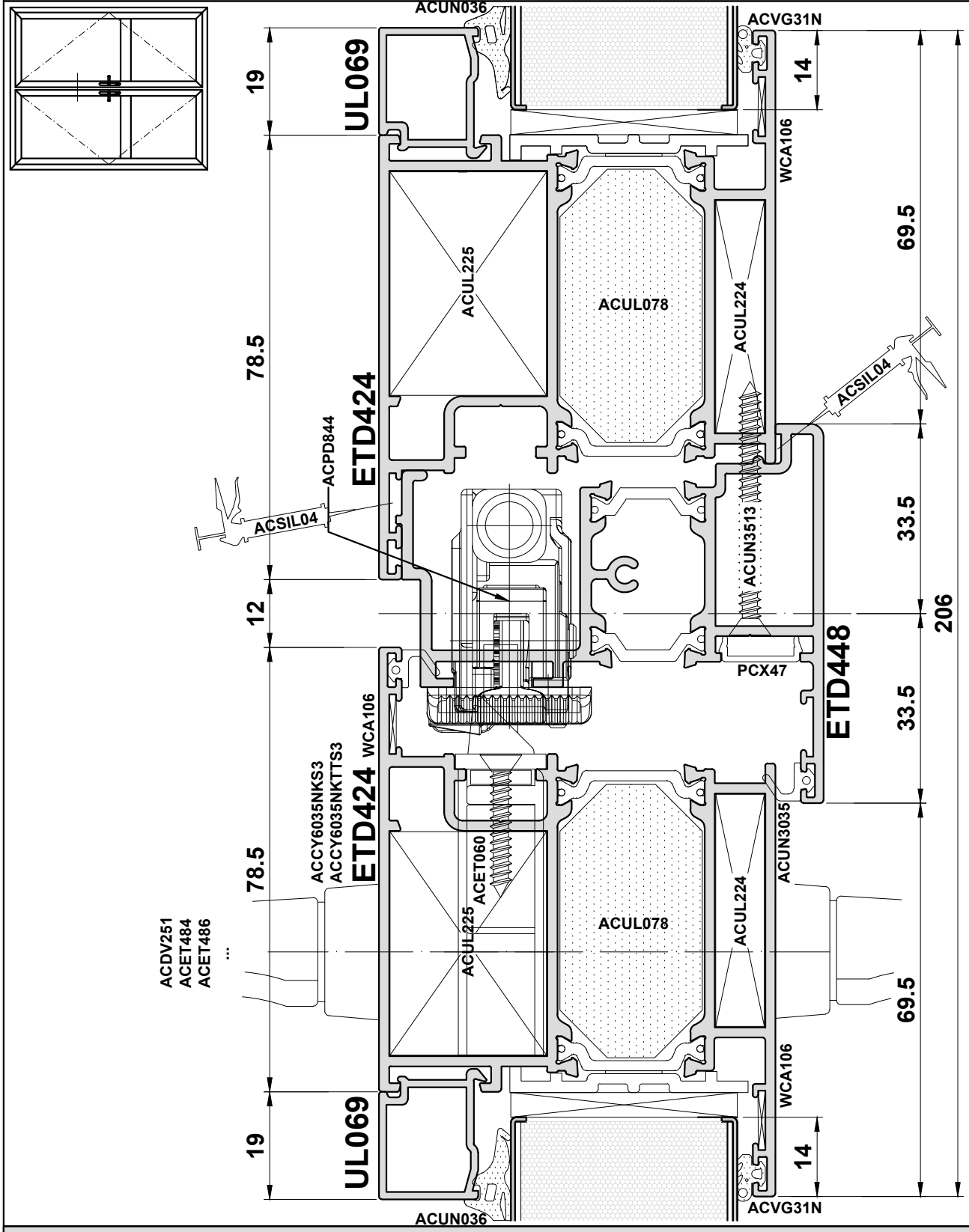
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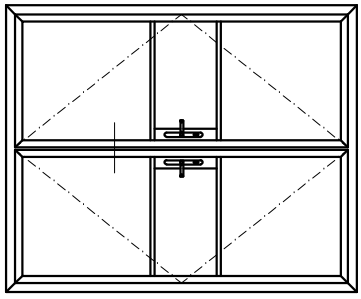
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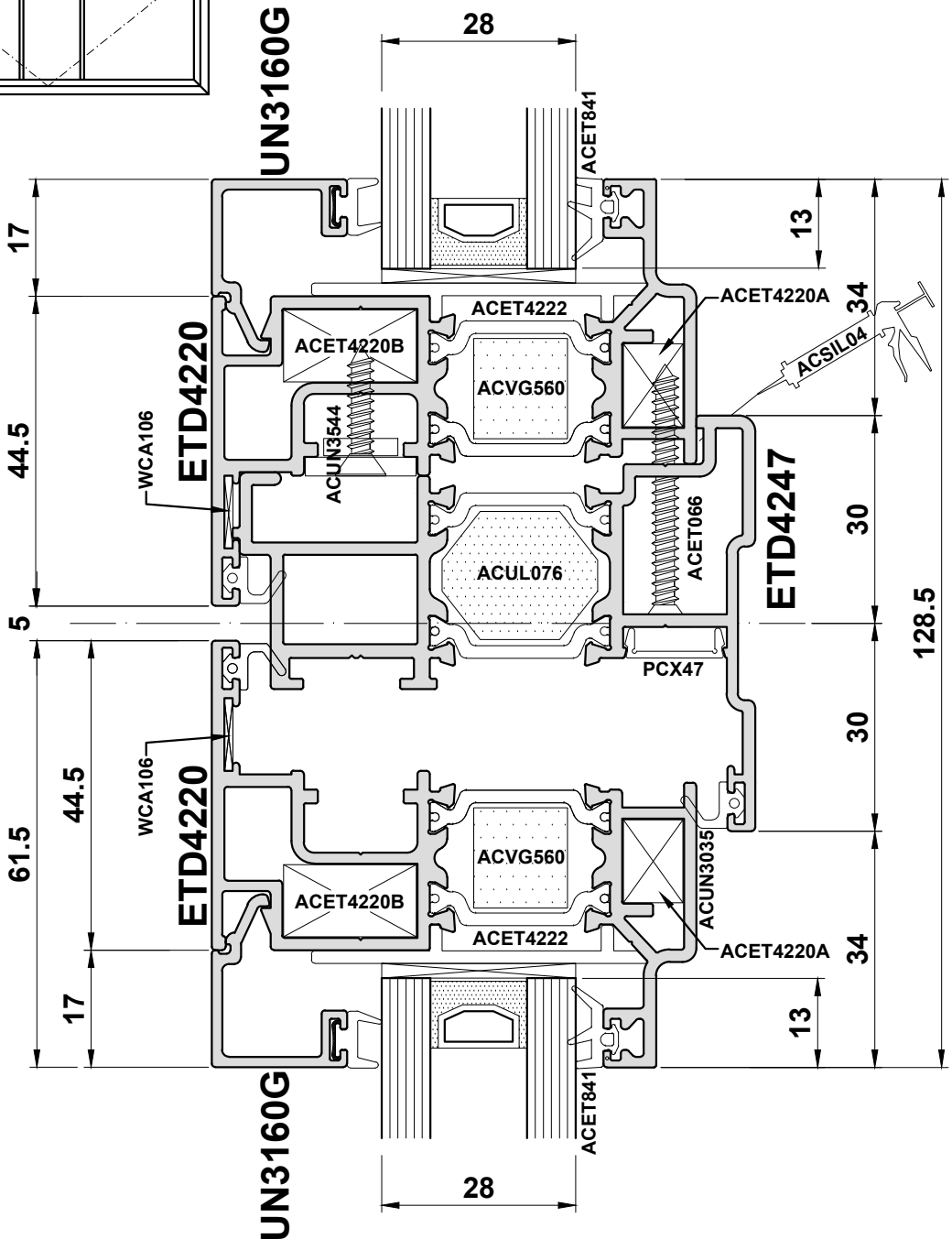


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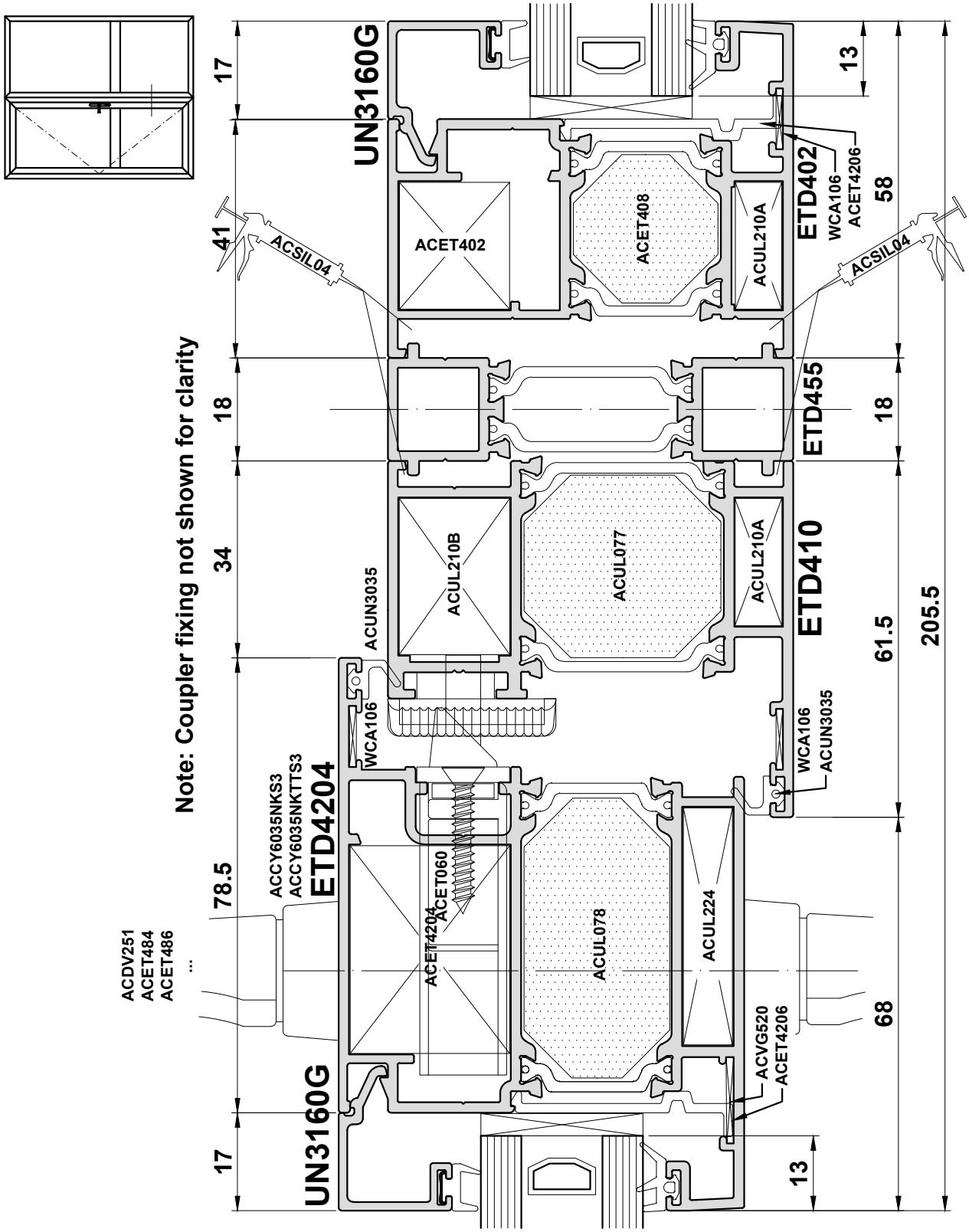


ONLY USE ACW20465 LOCK & ACW20466 SECONDARY LOCK FOR HERITAGE DOORS



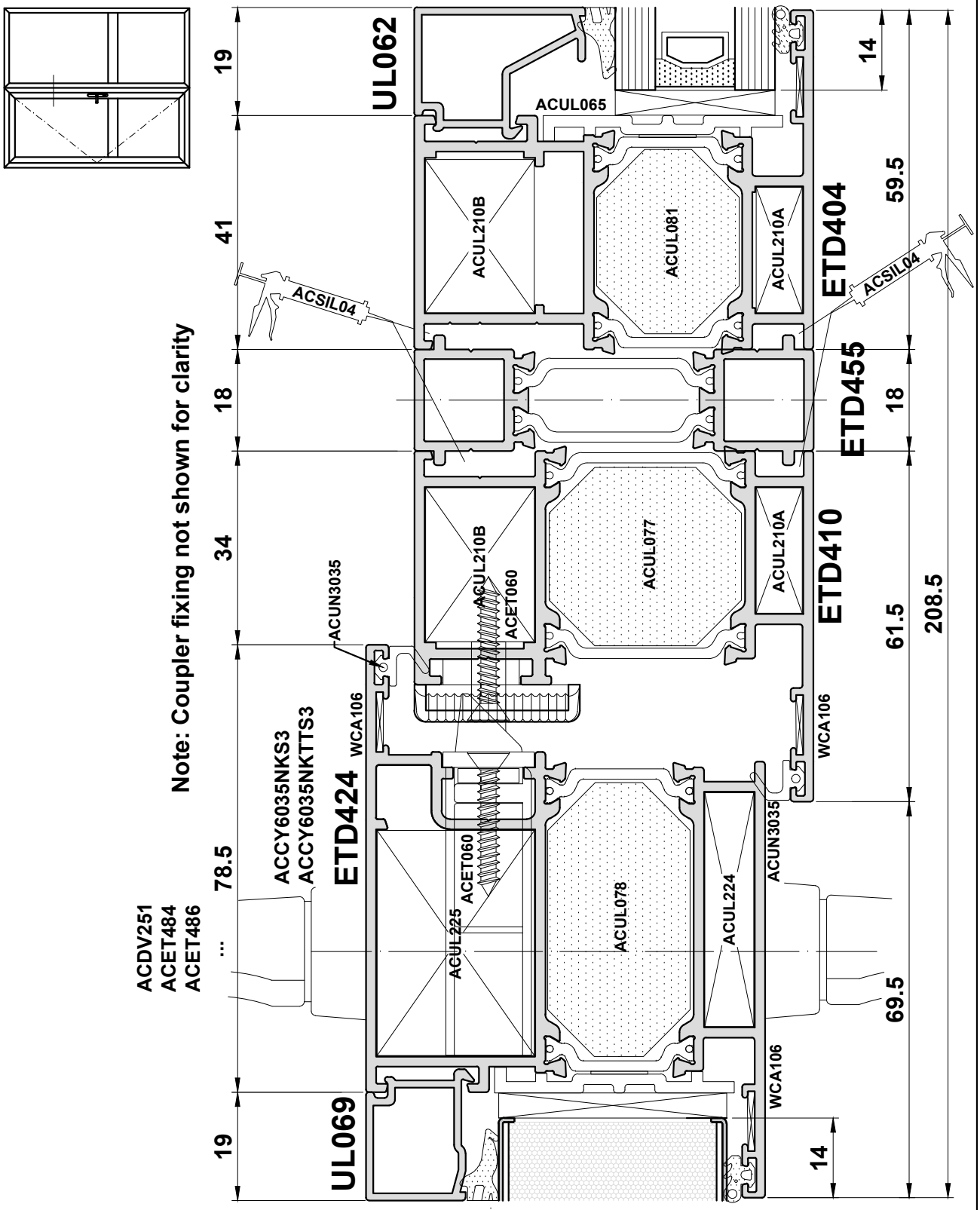
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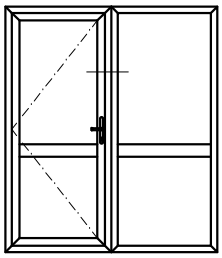
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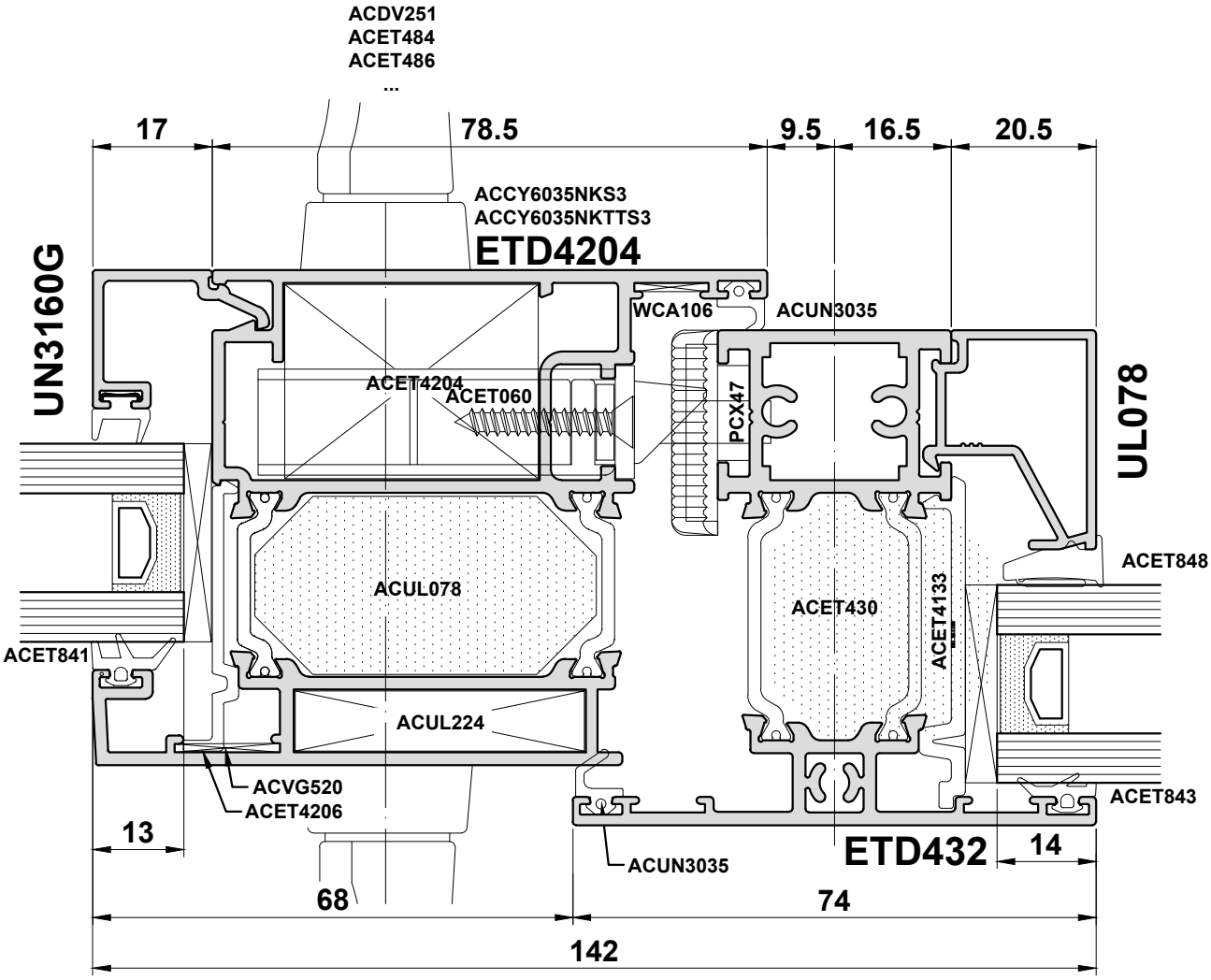
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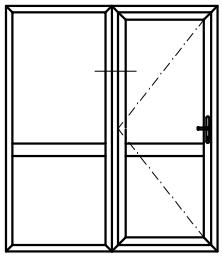
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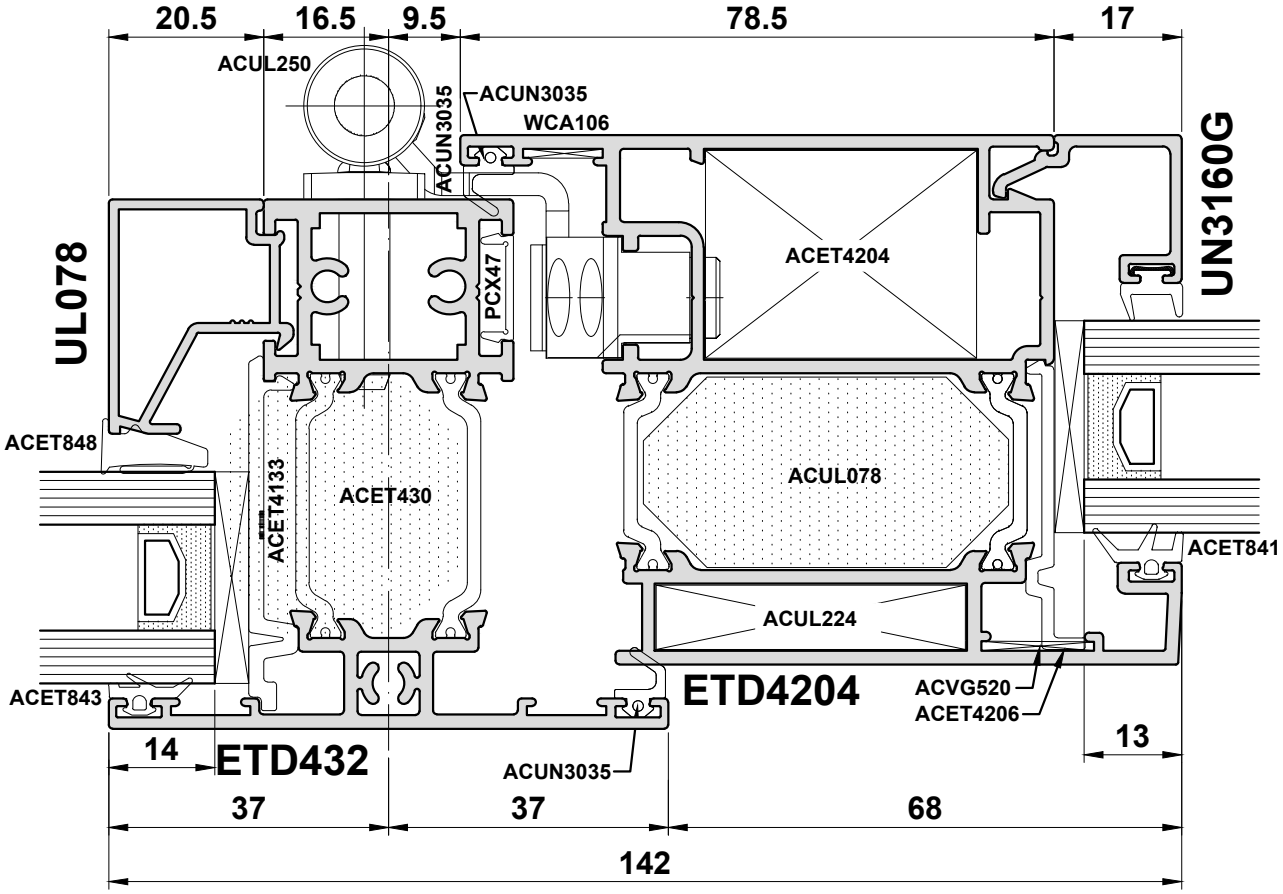




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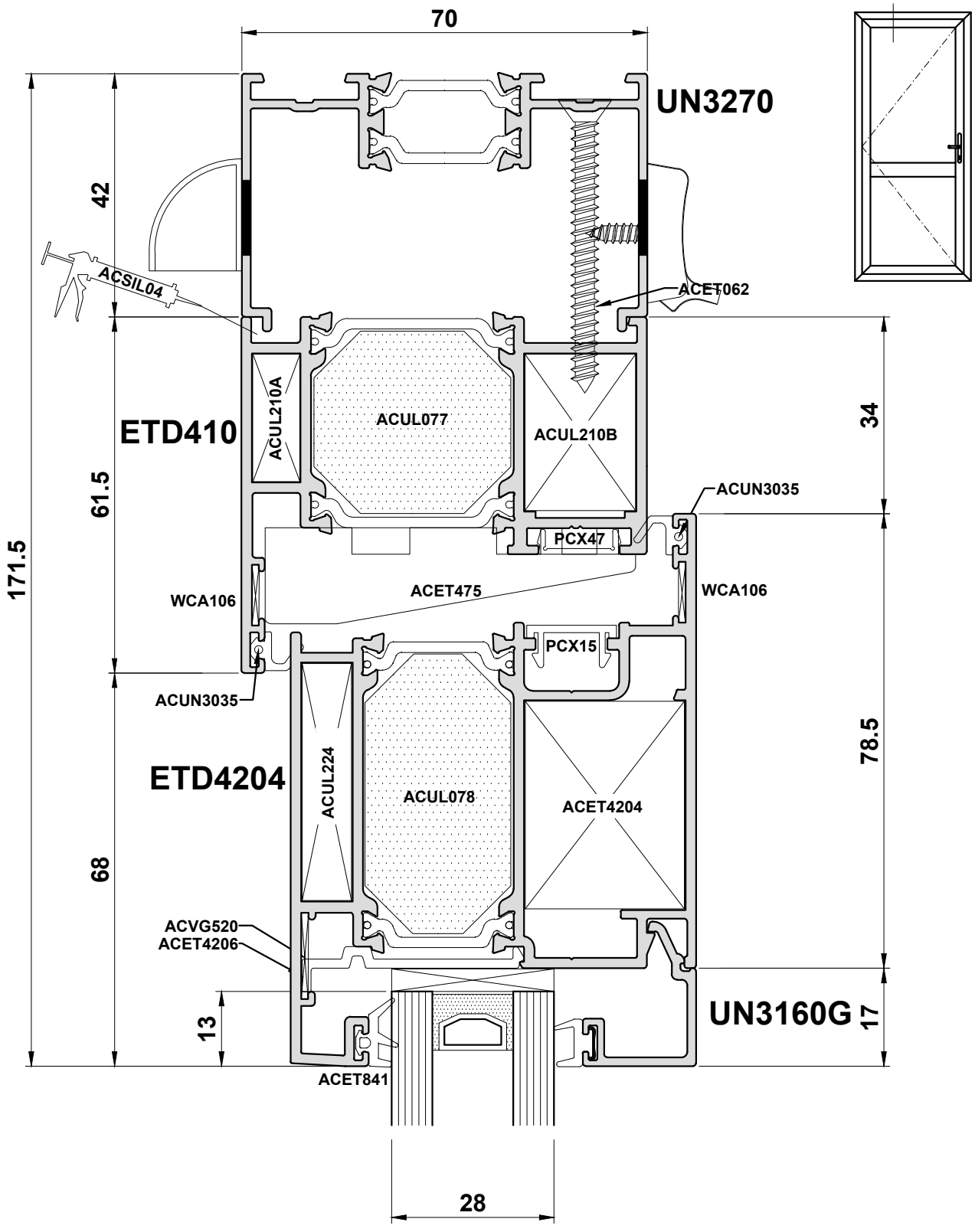
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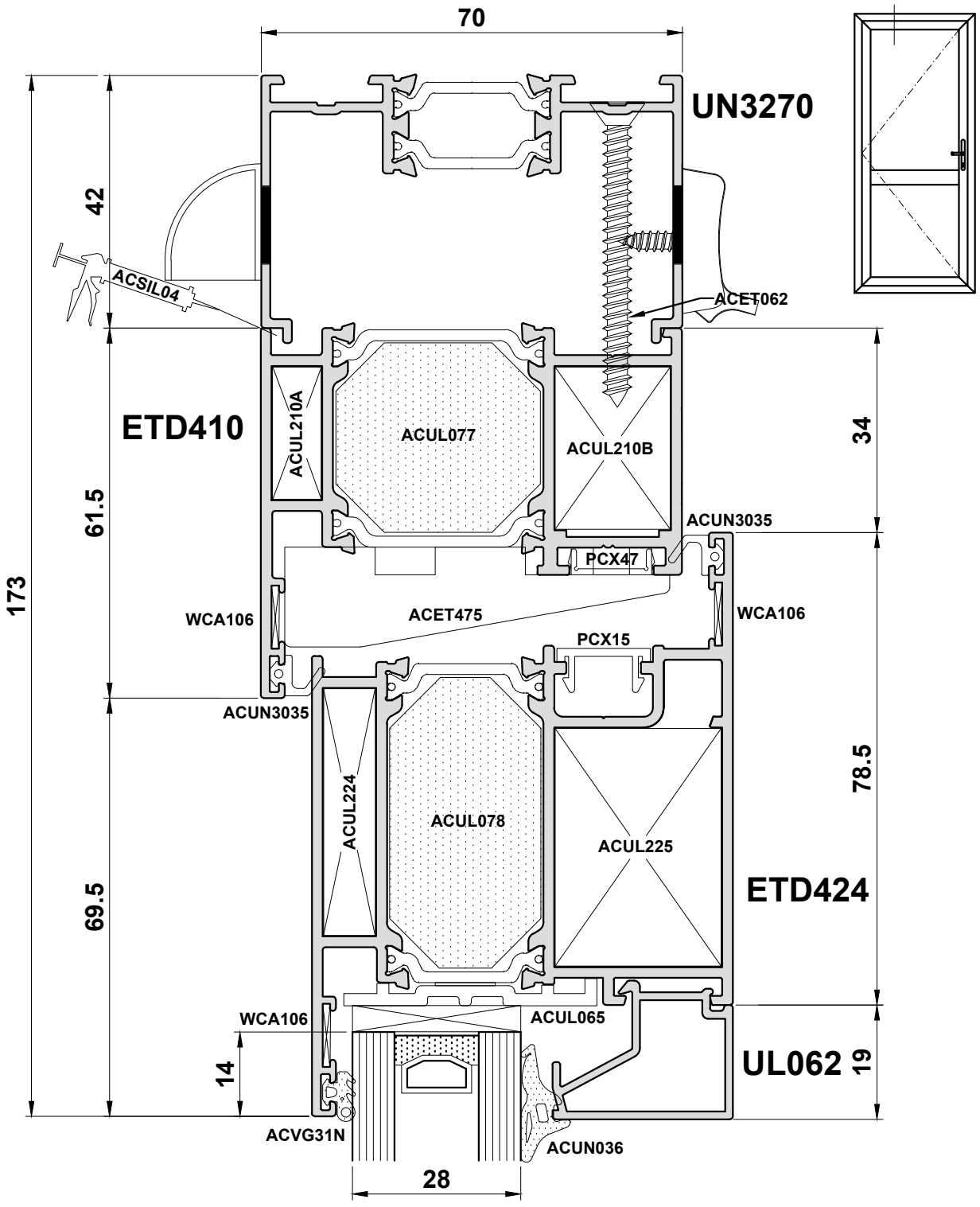
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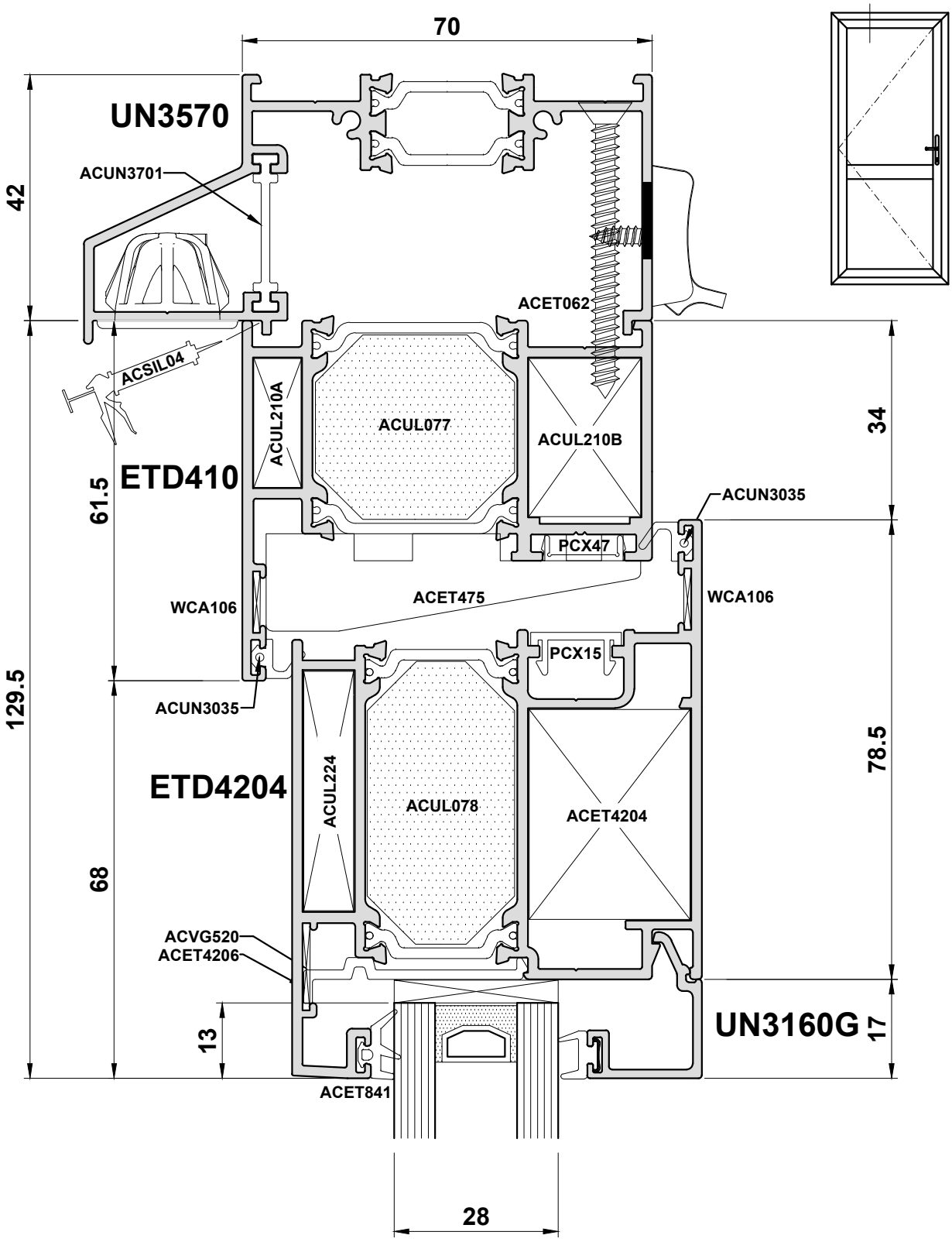
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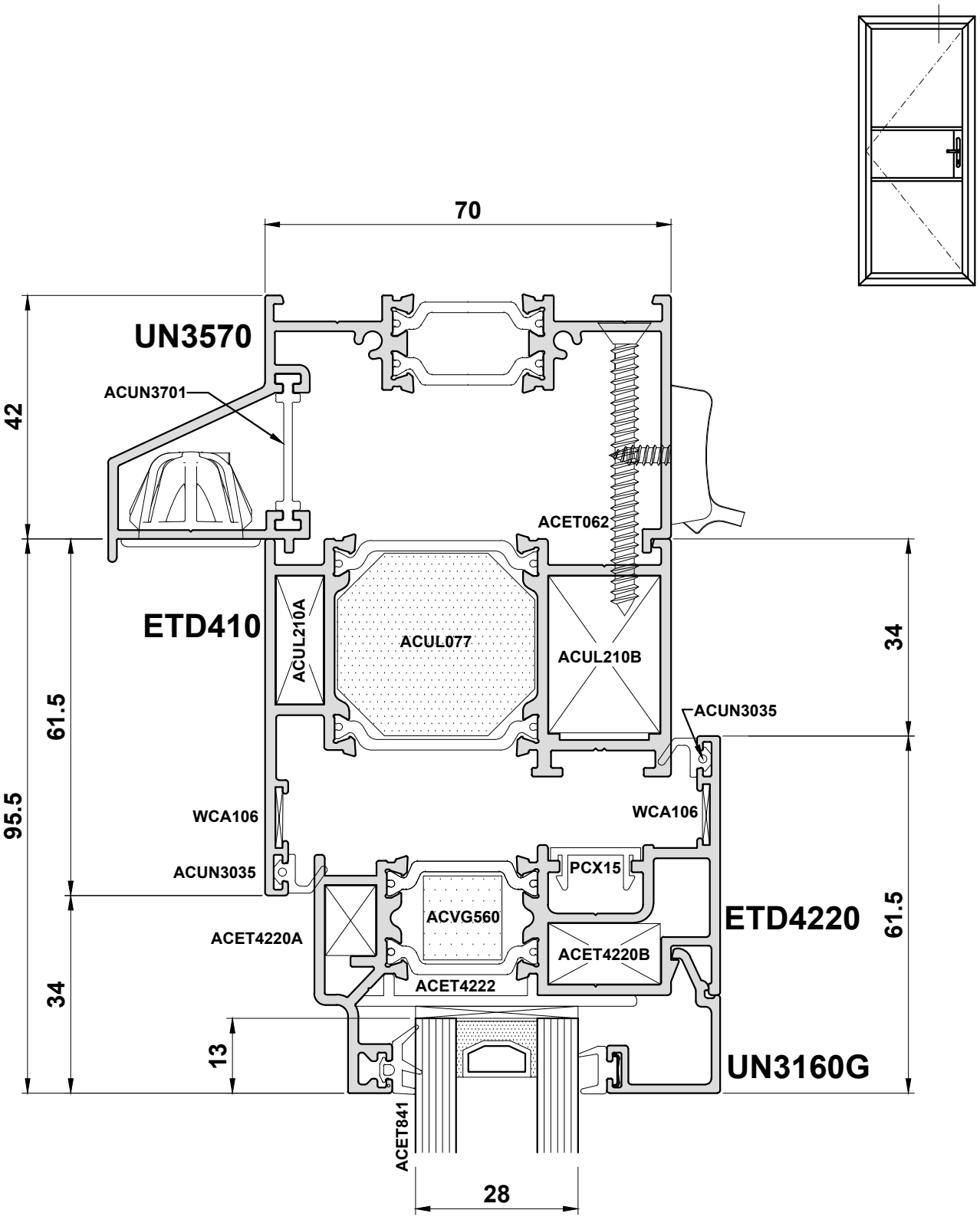
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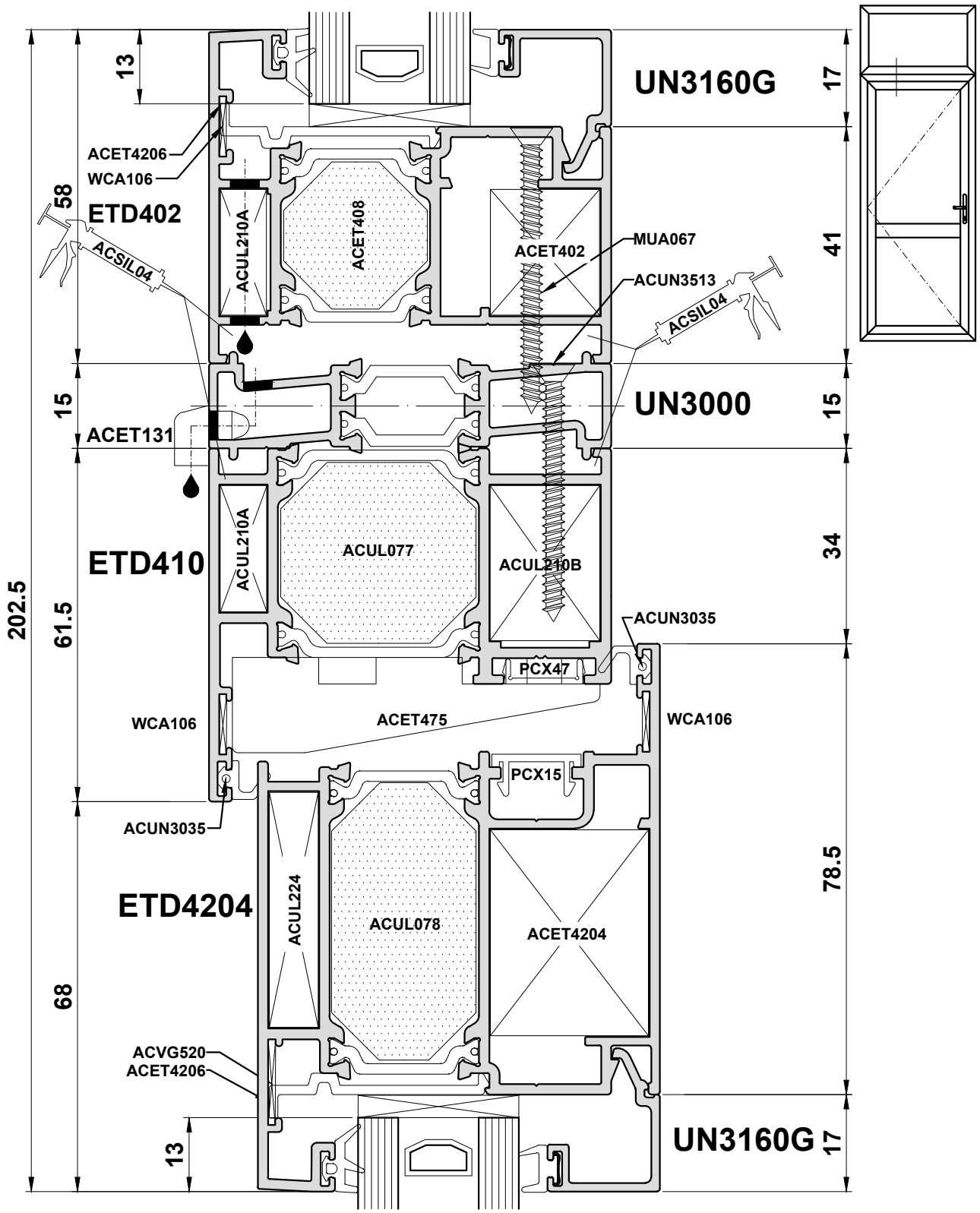
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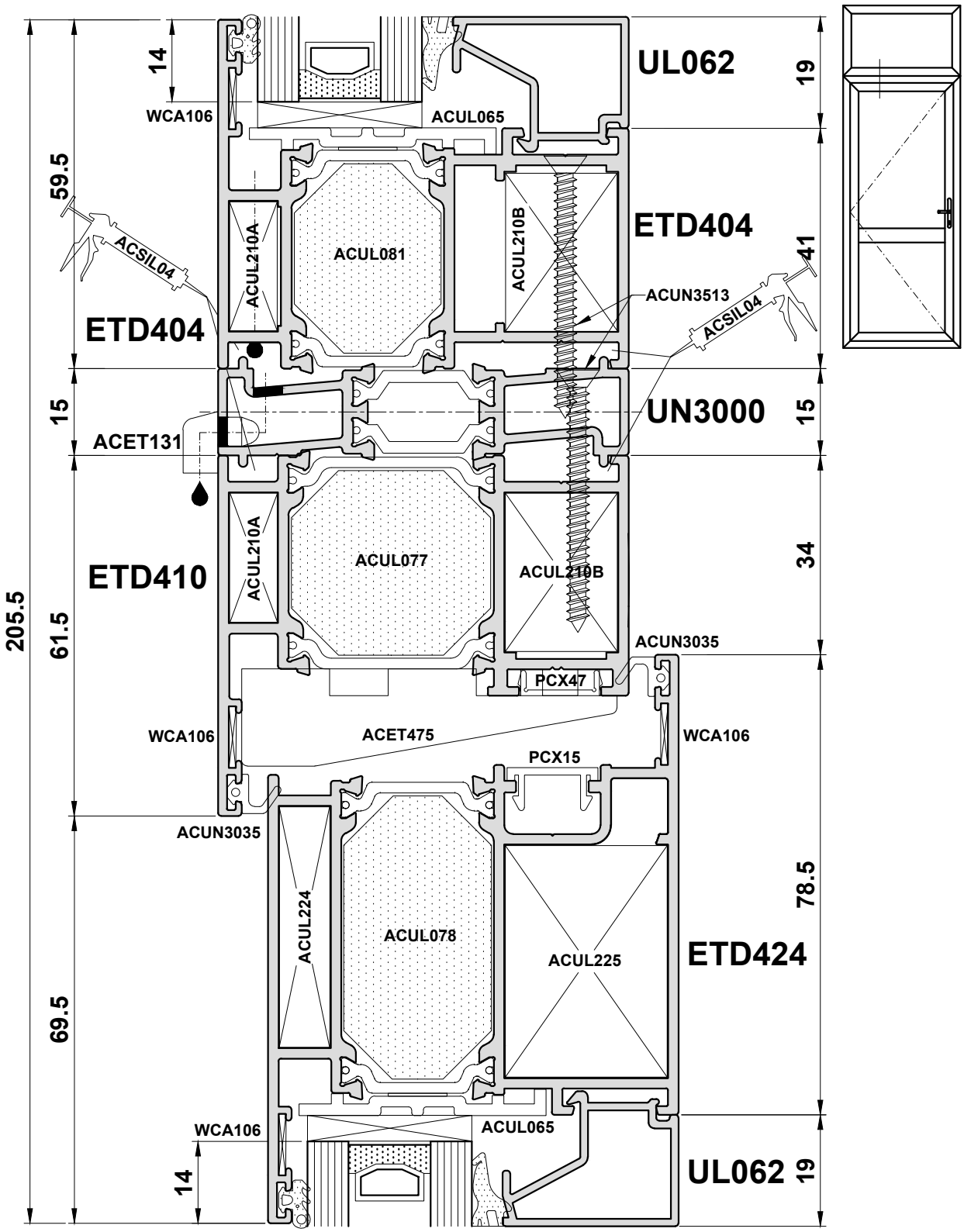
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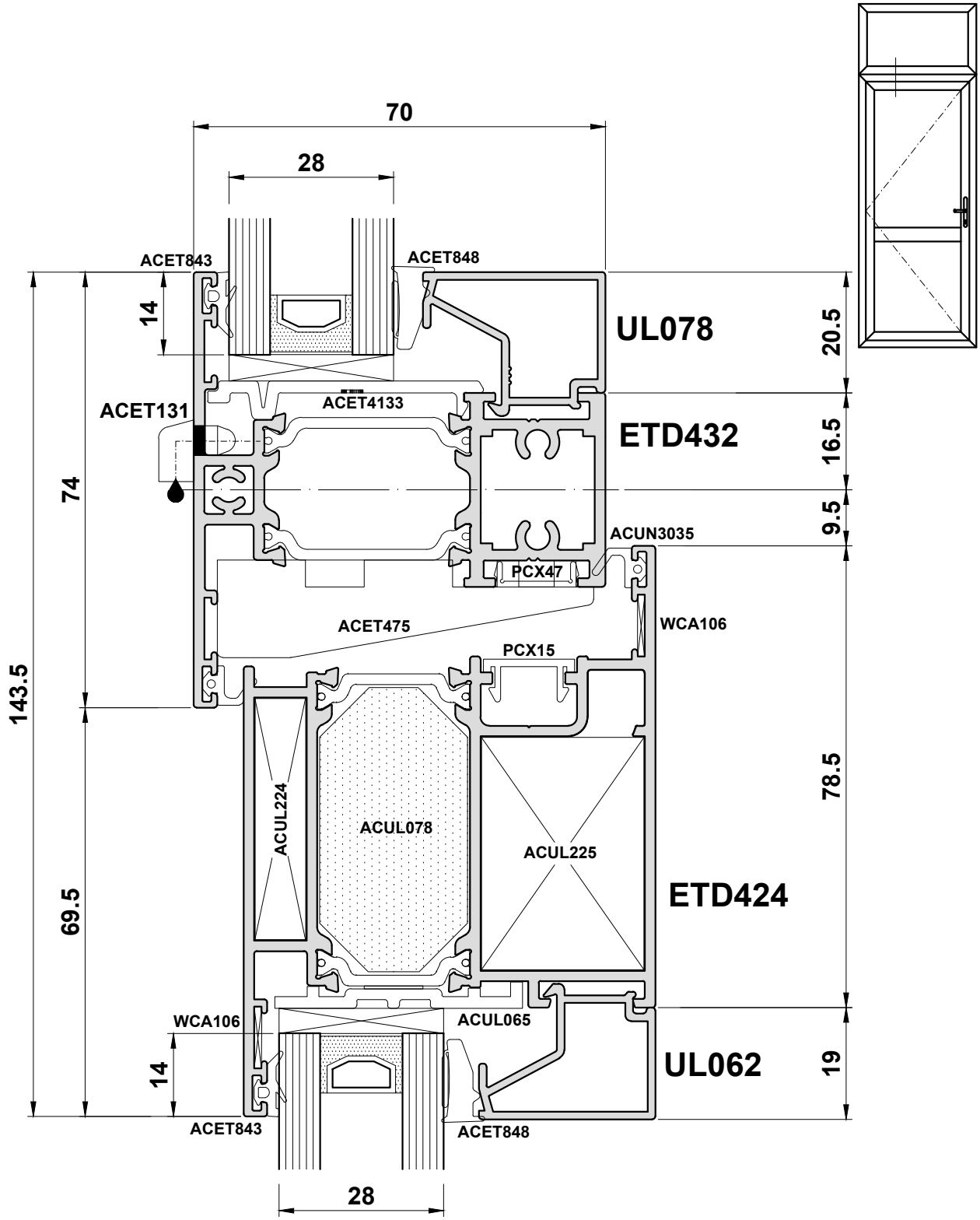
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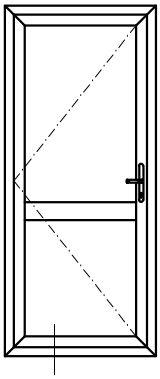
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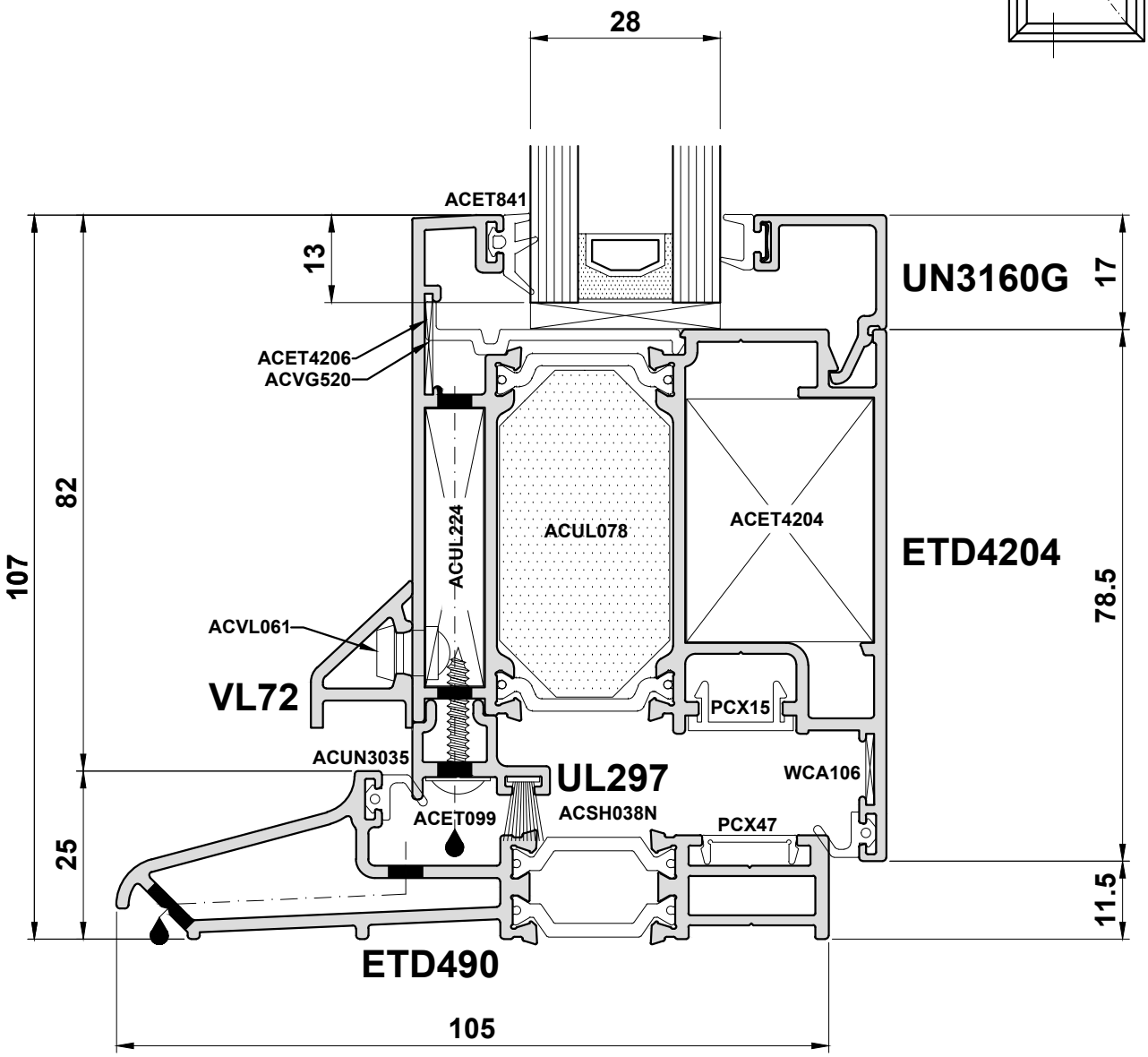
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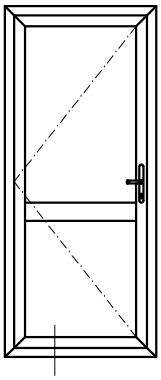
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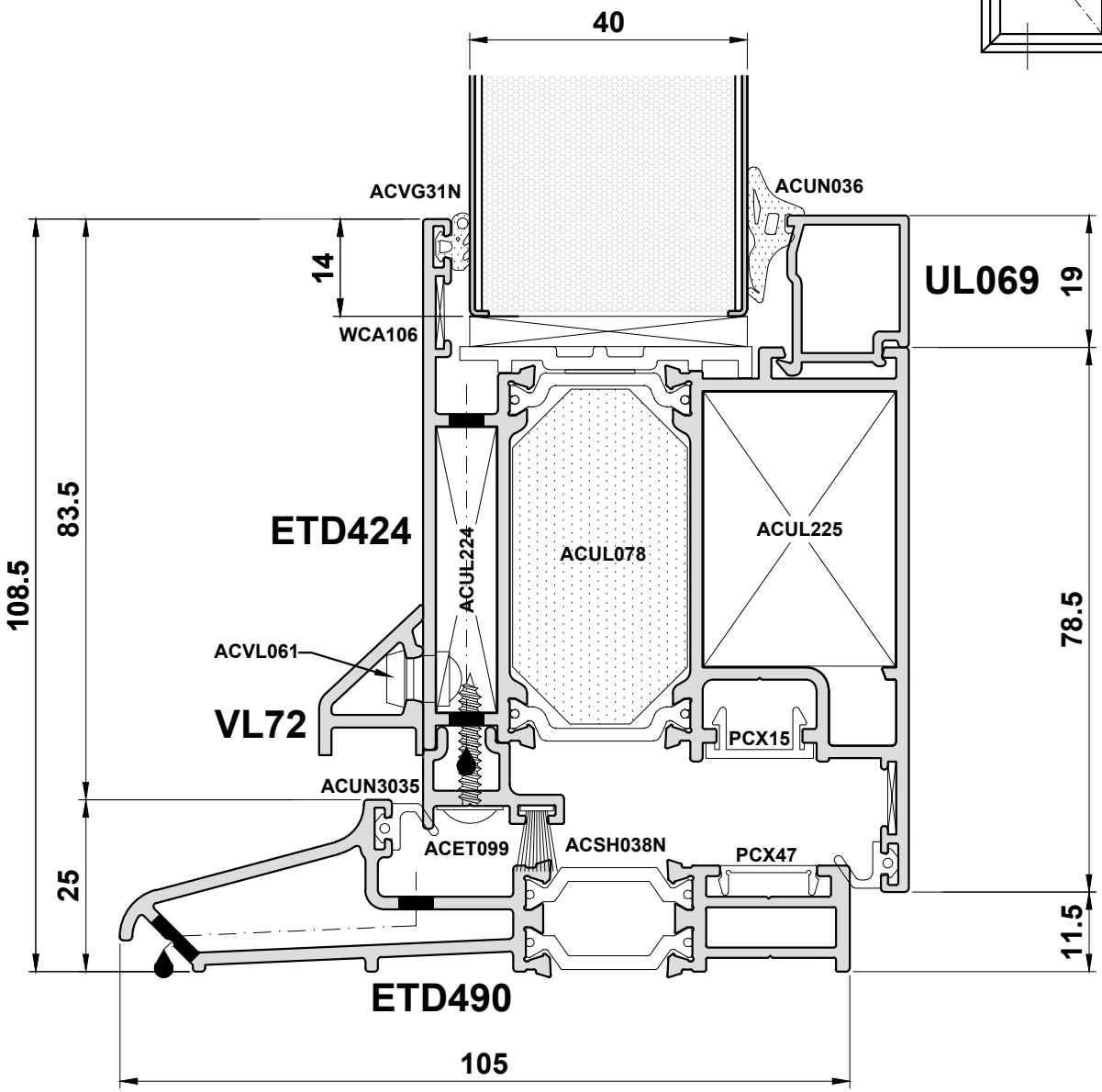




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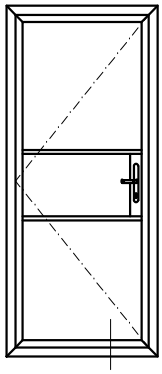
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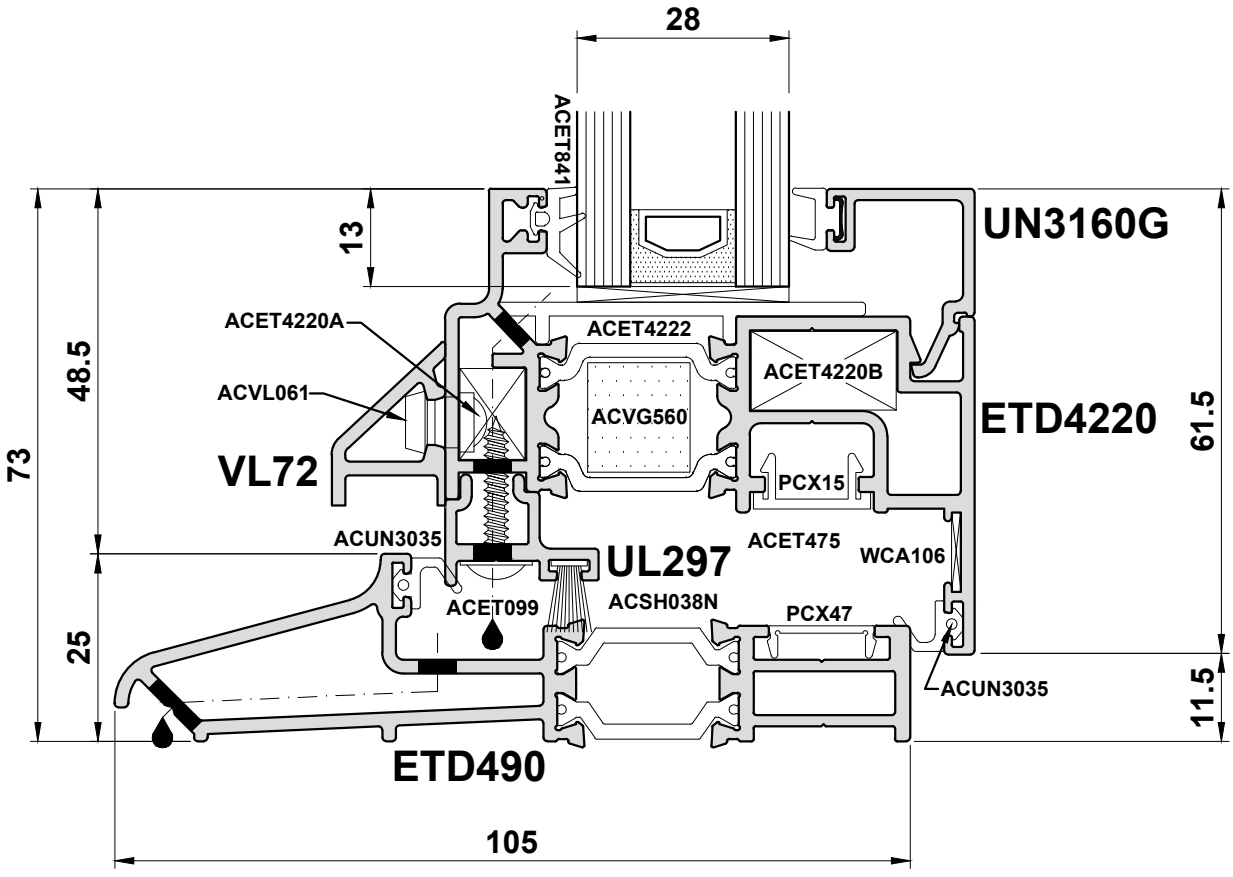




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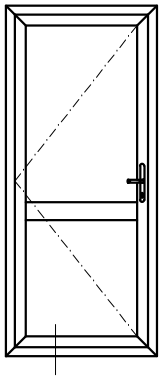
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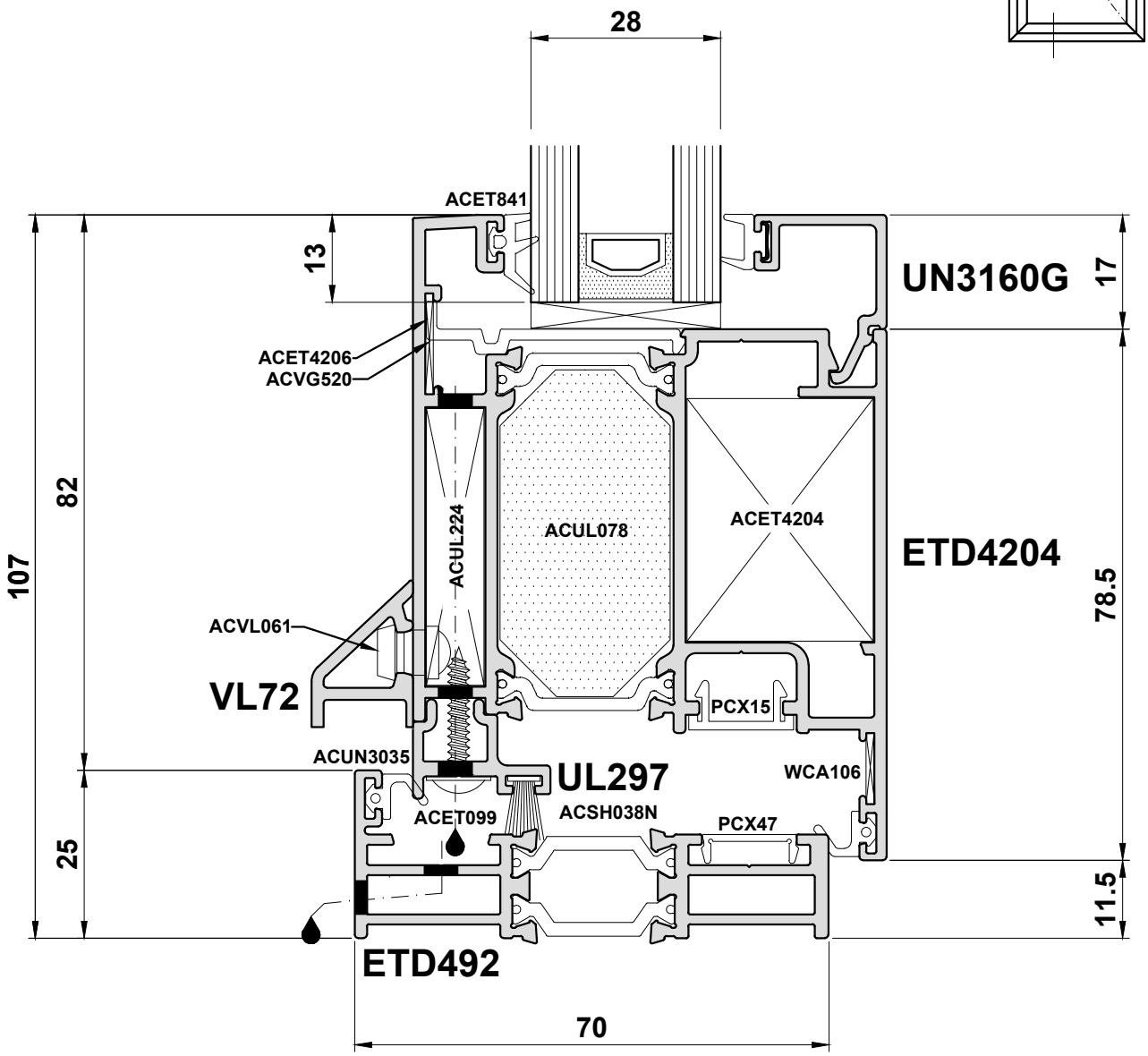




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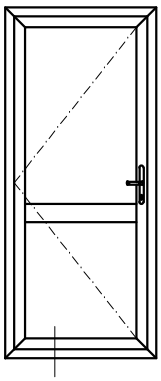
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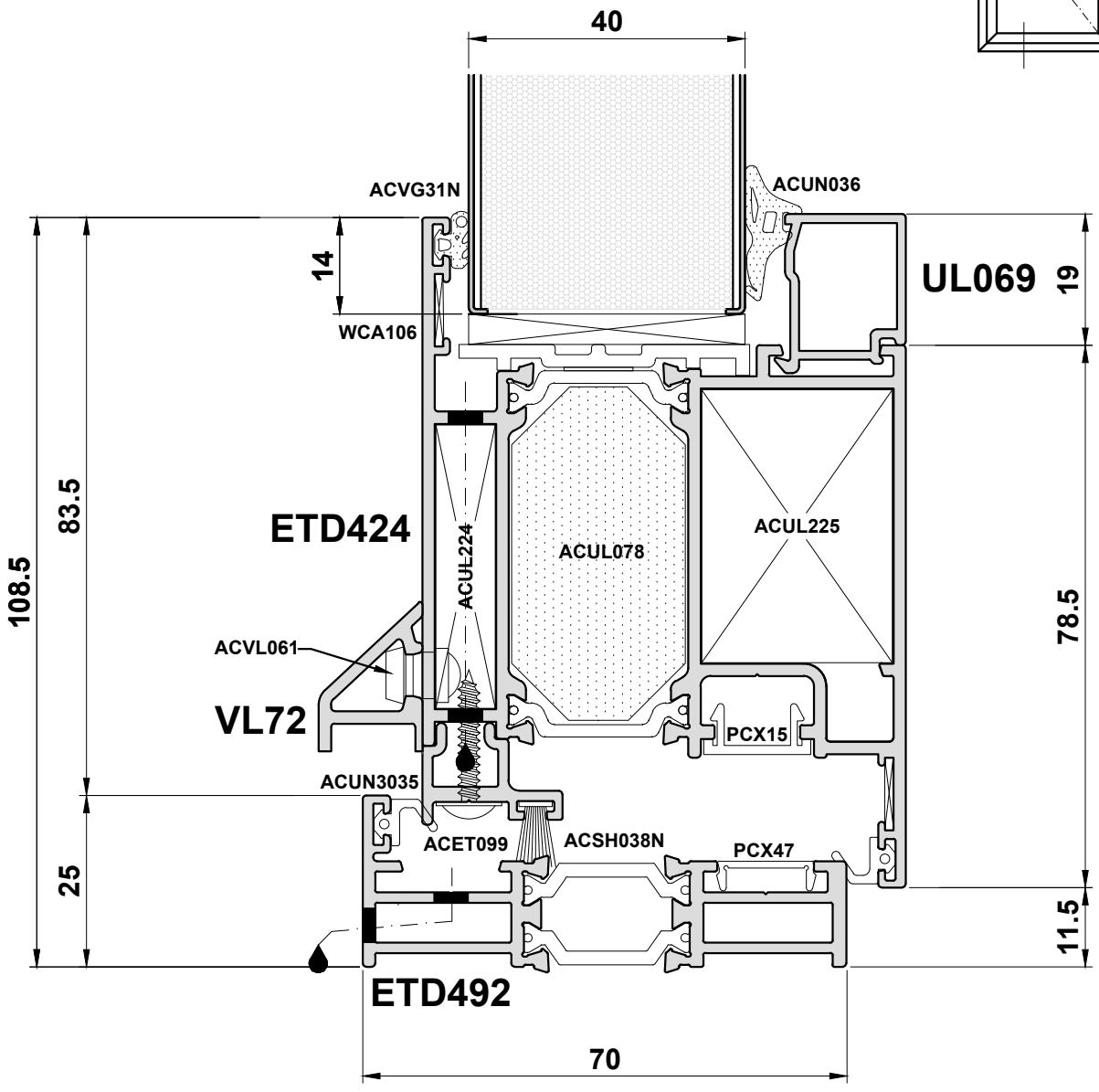




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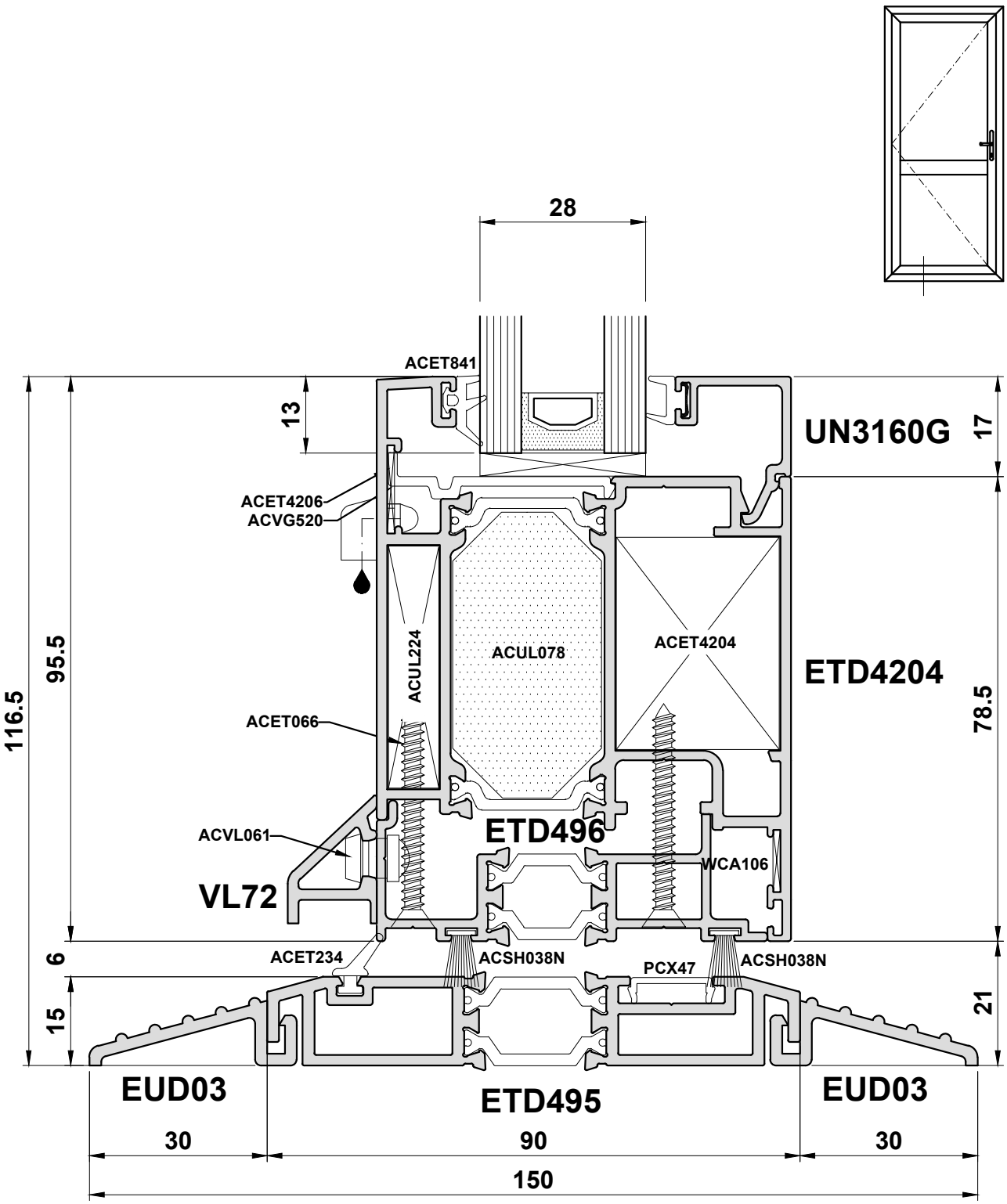
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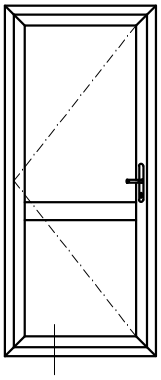
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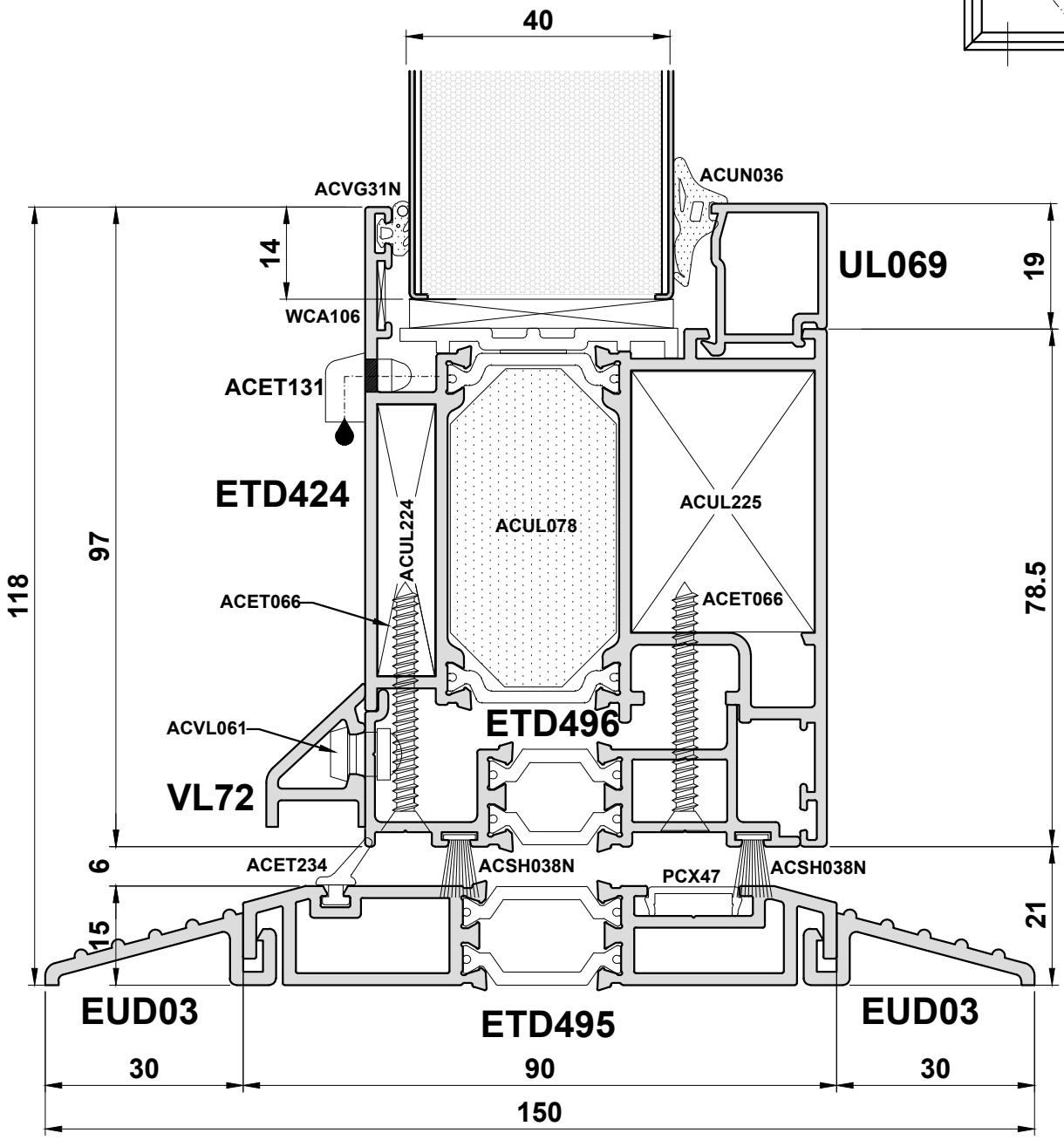
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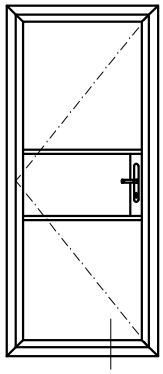
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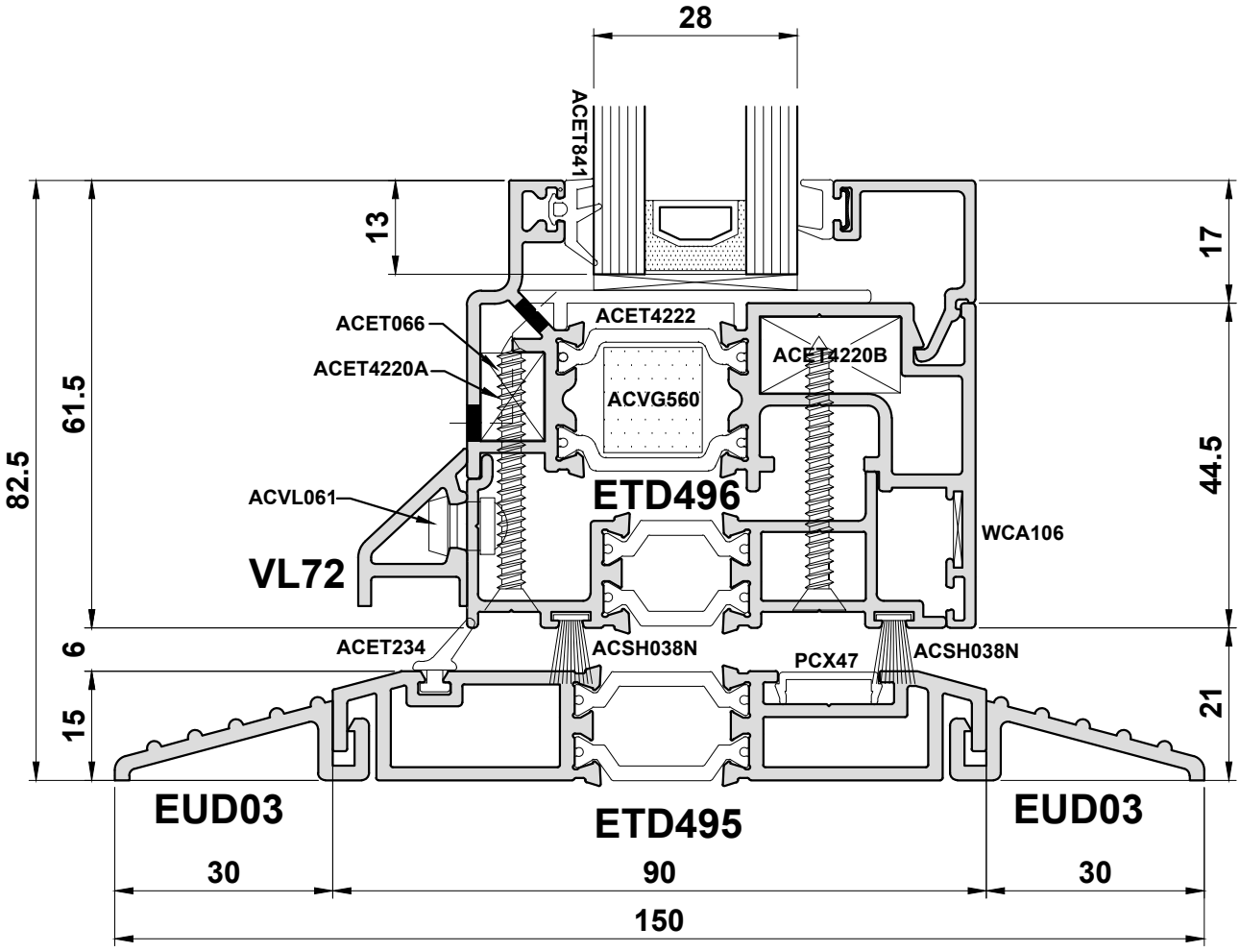




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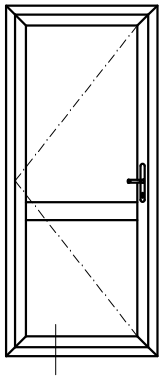
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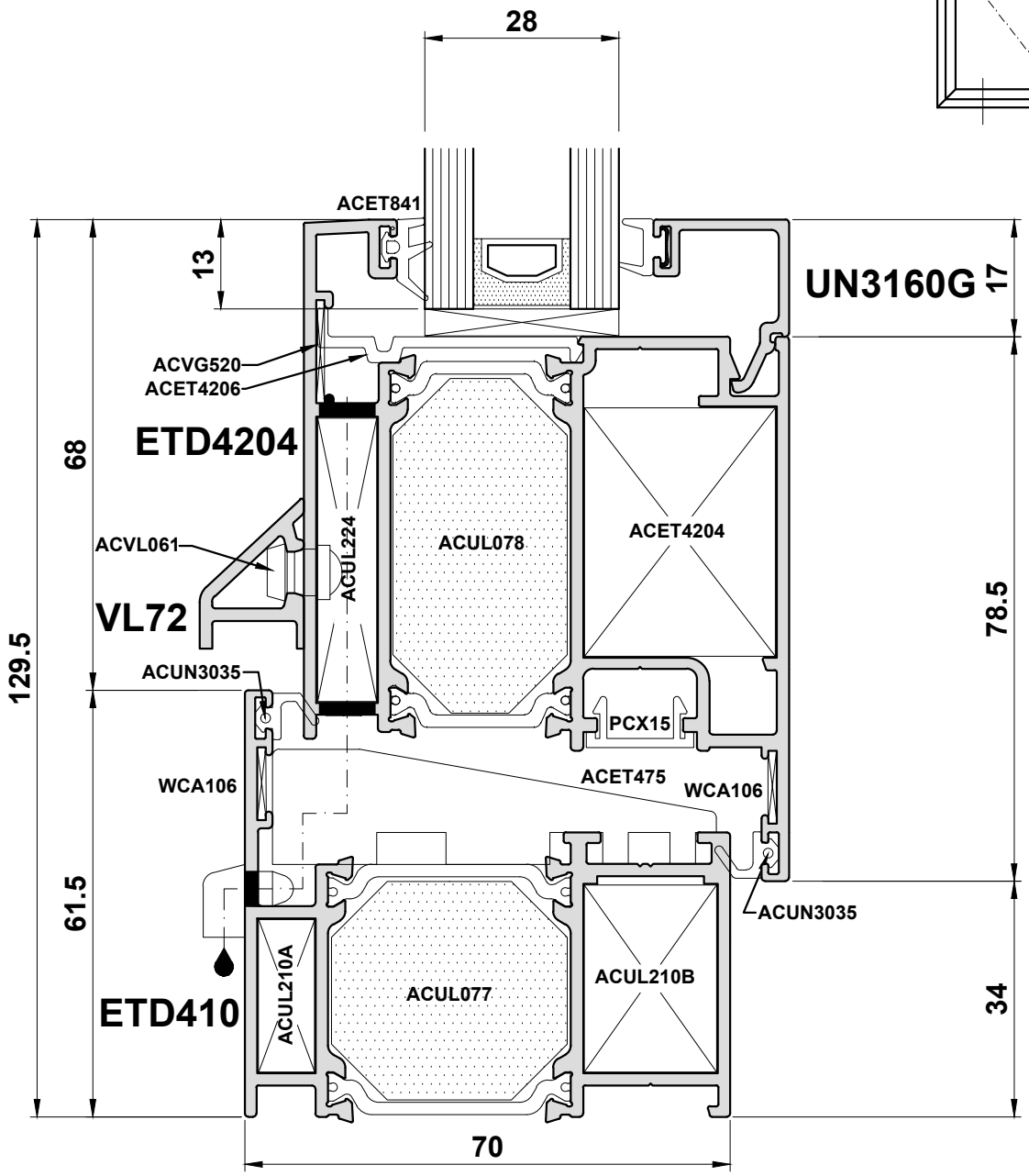




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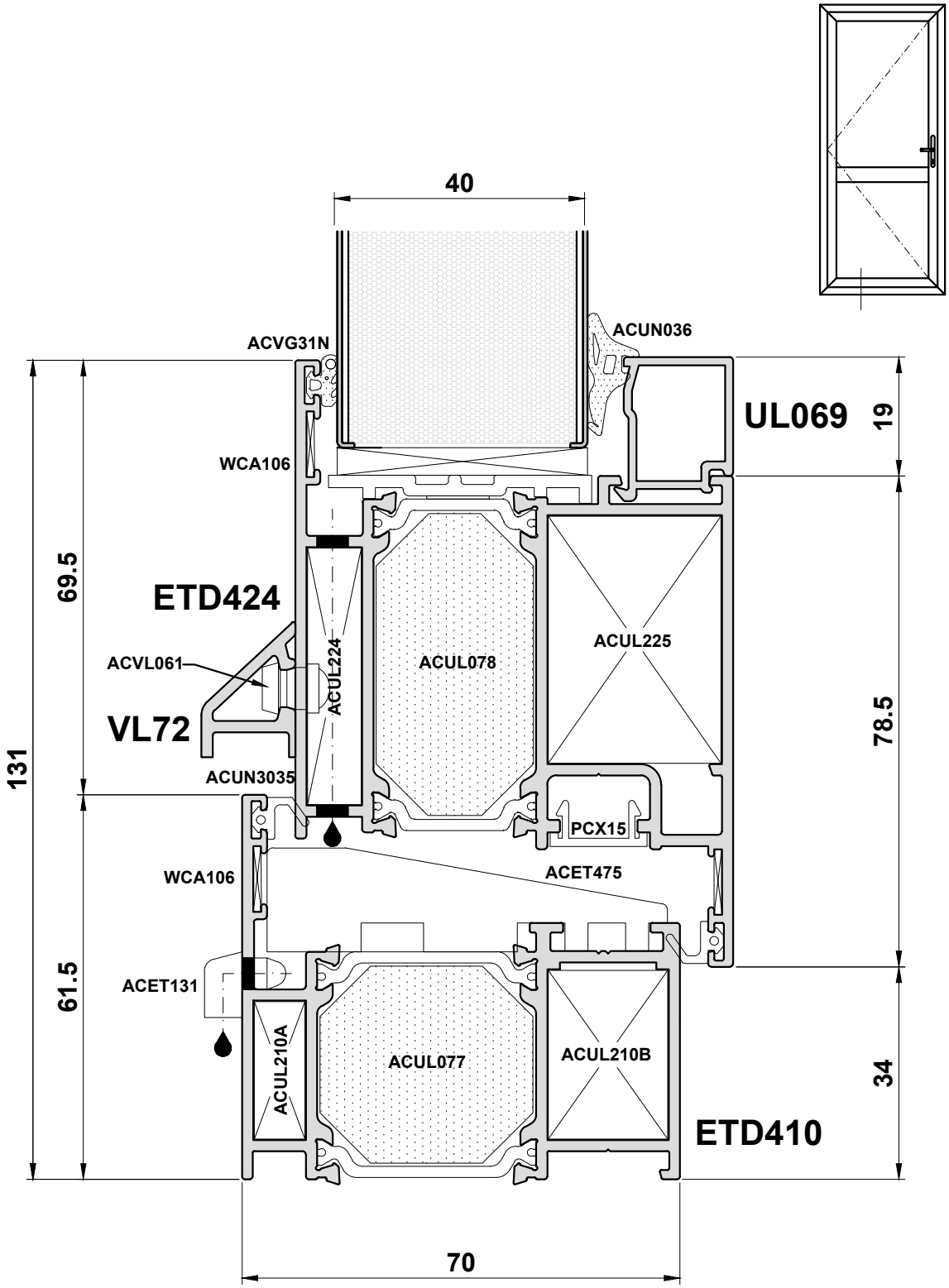
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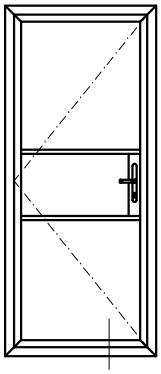
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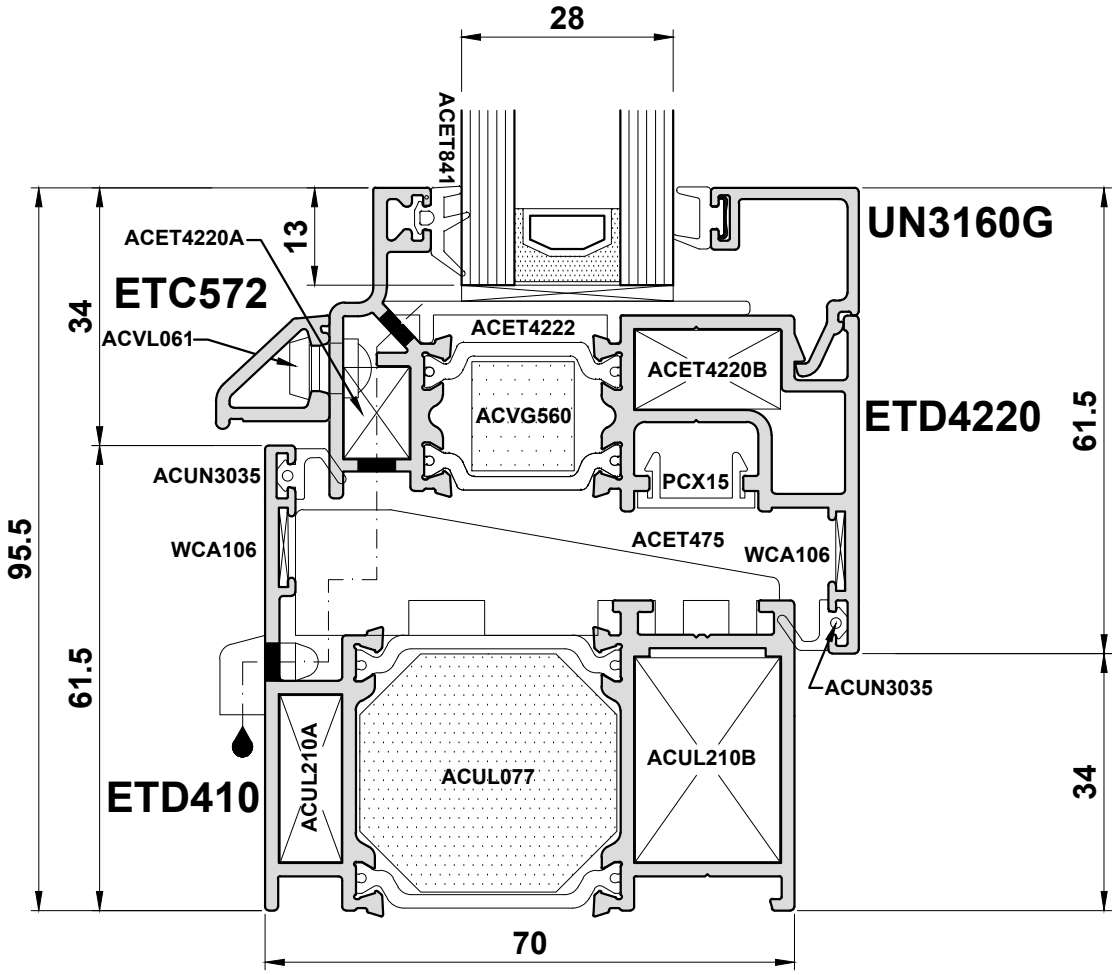
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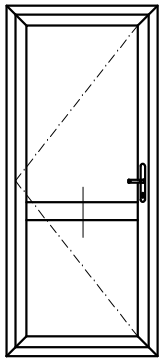
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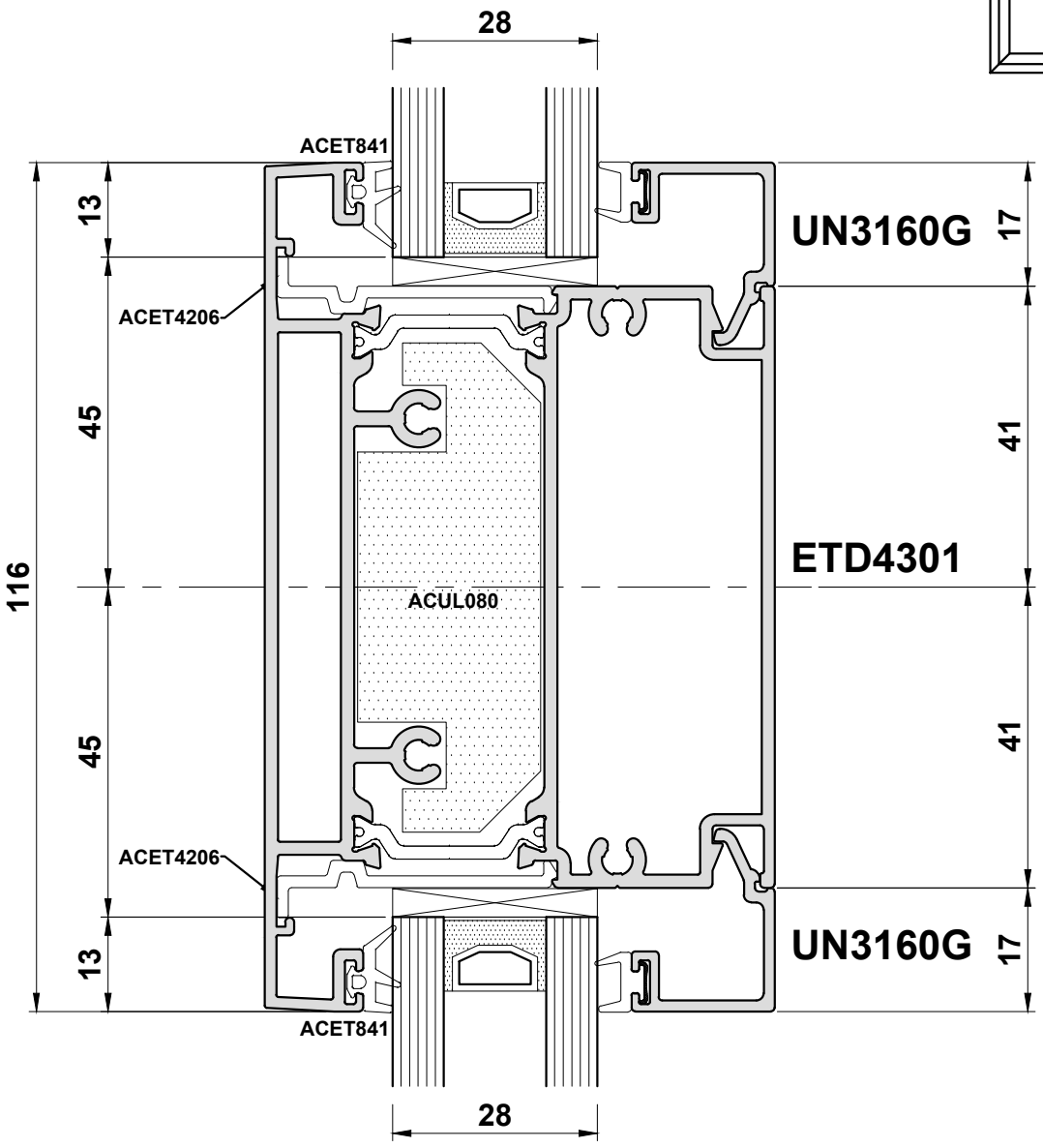




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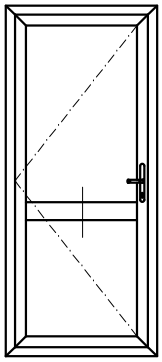
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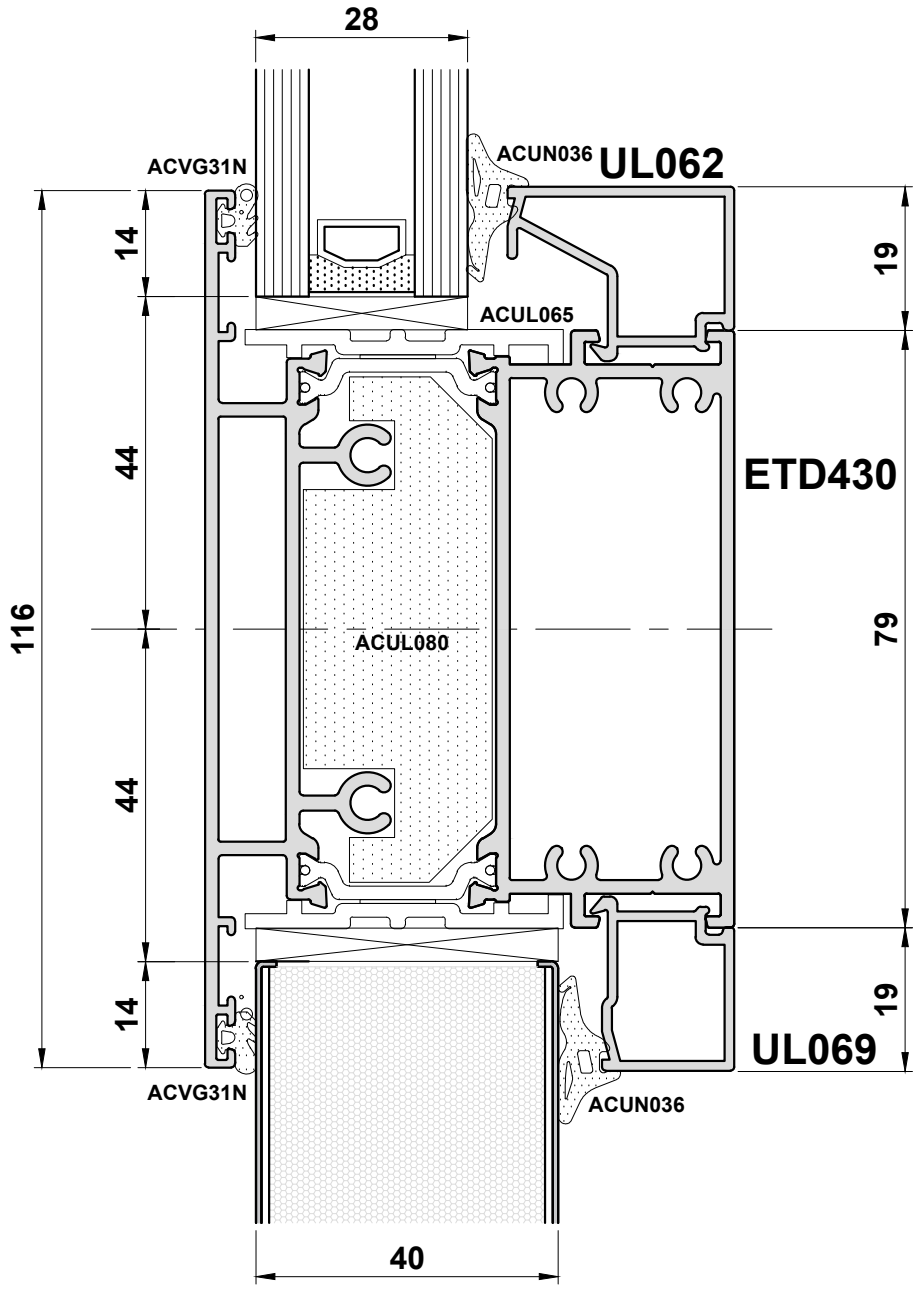




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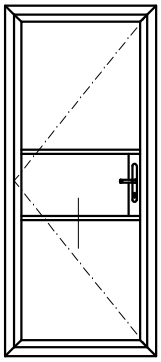
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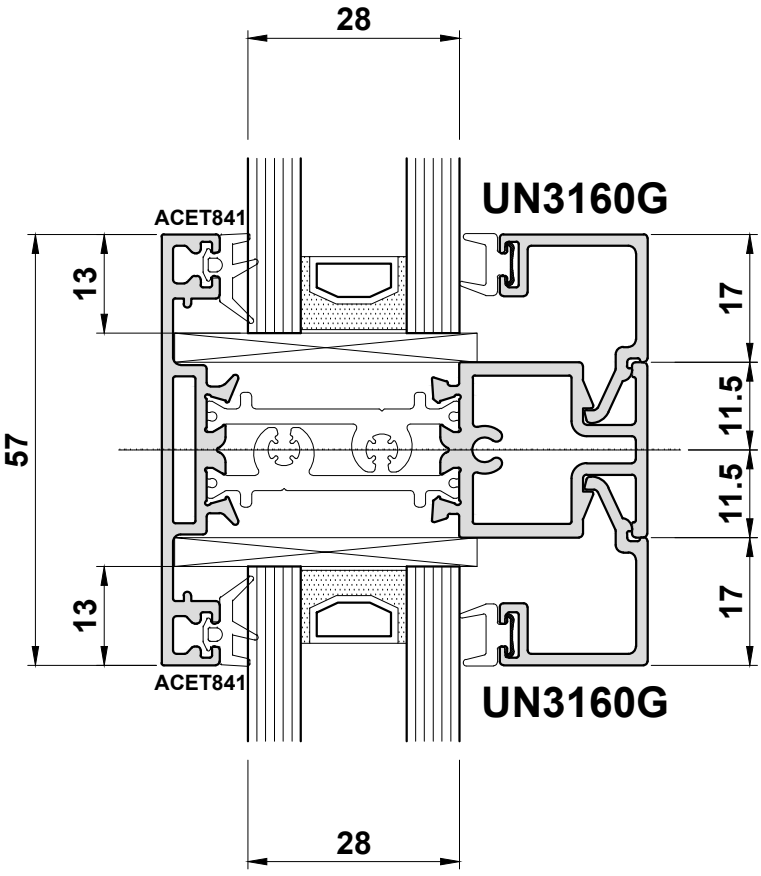




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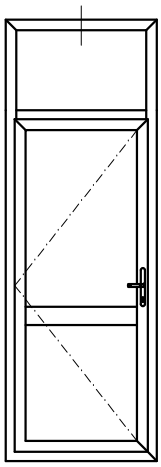
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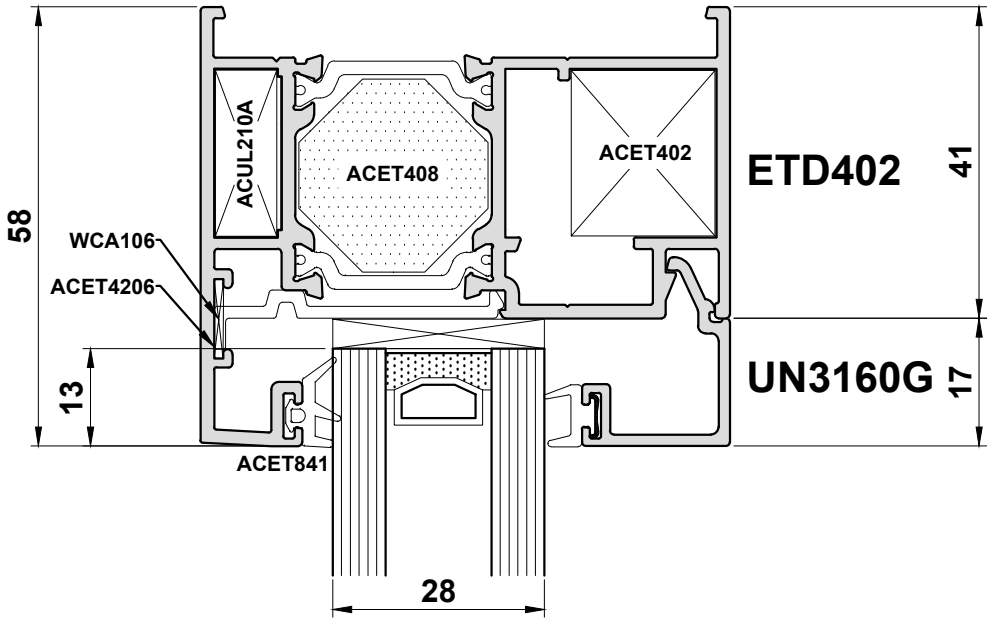




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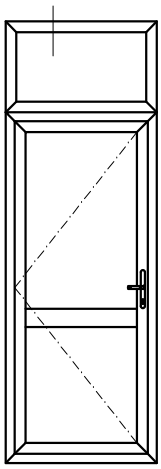
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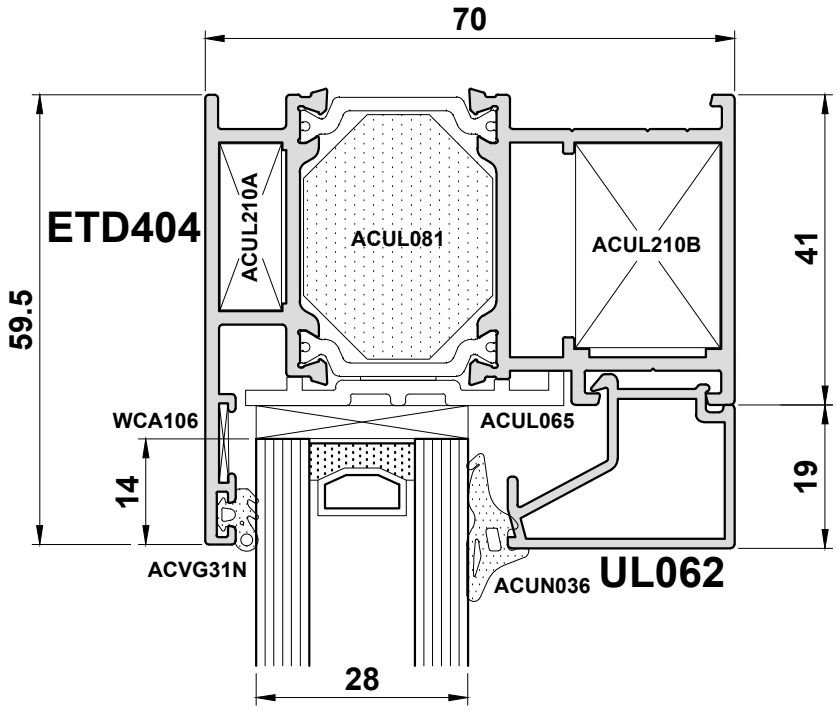




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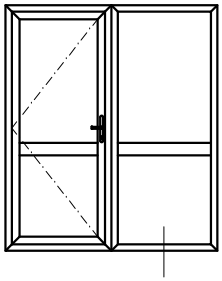
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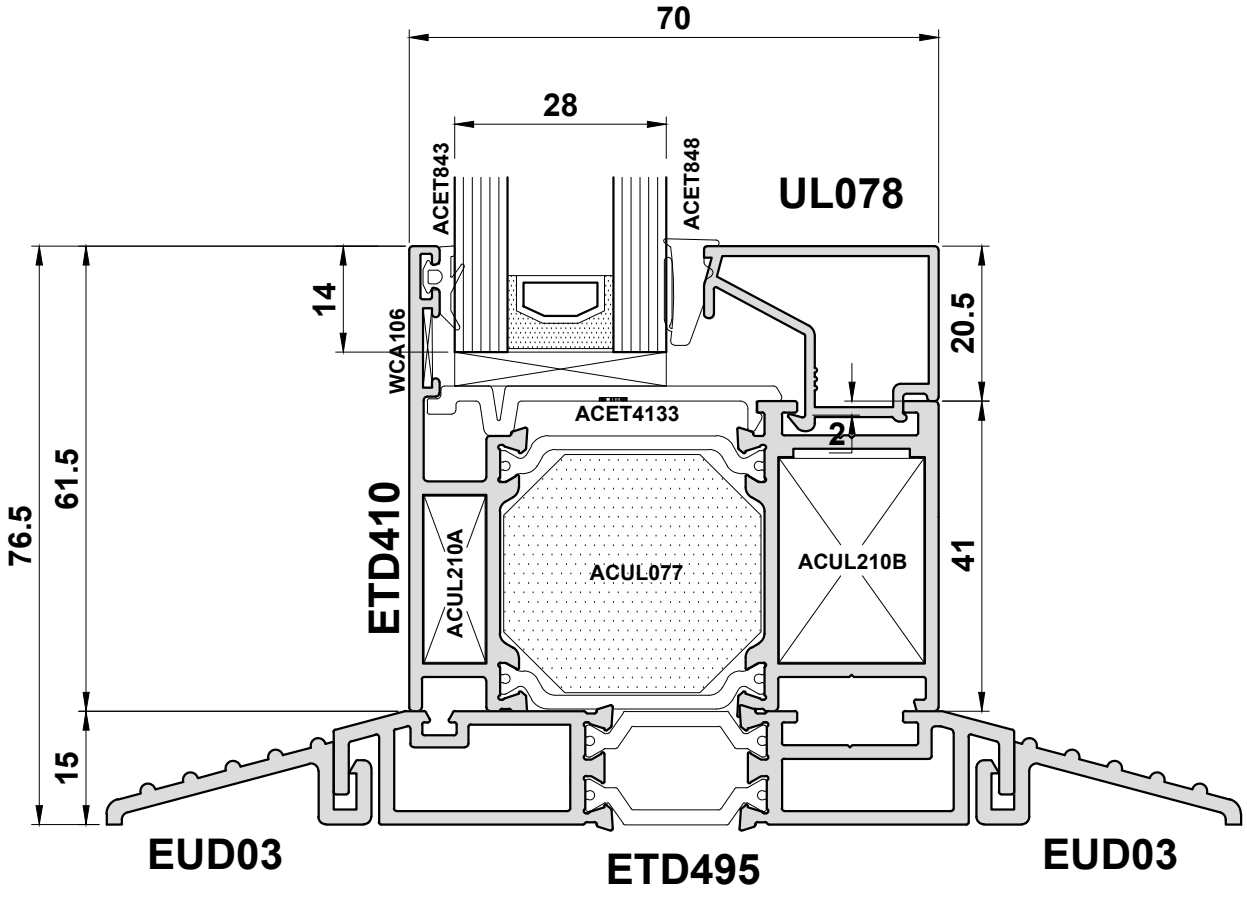




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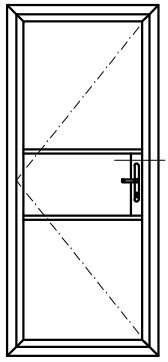
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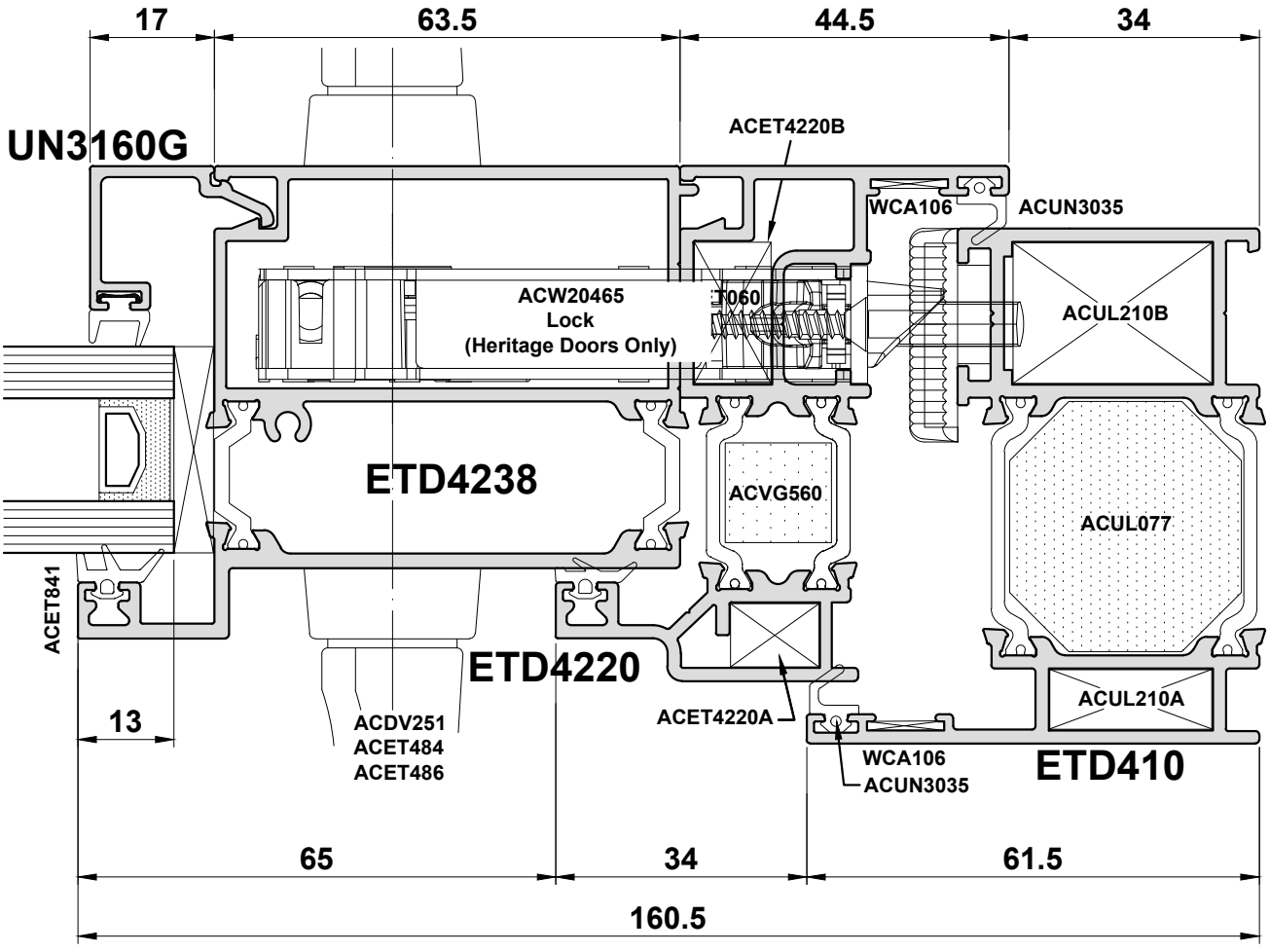




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Heritage Open In - Detail 12

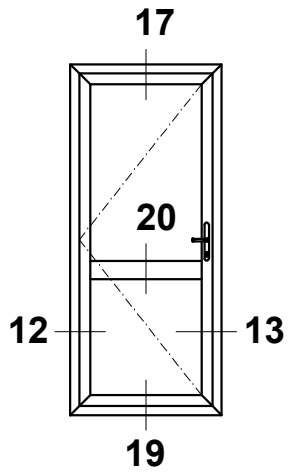


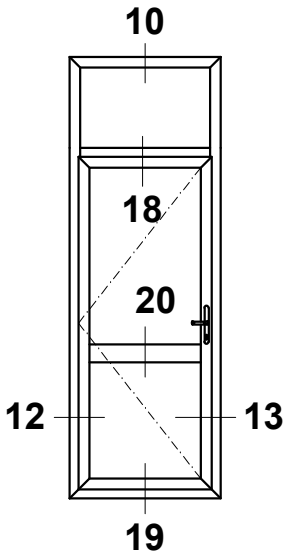


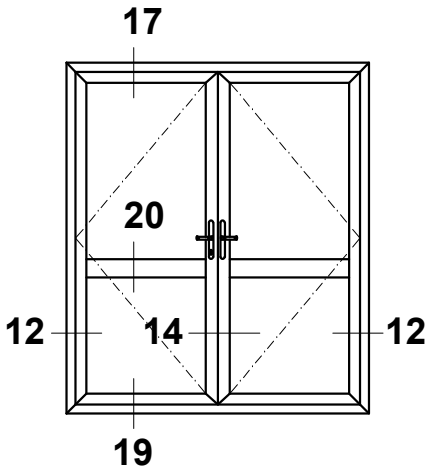
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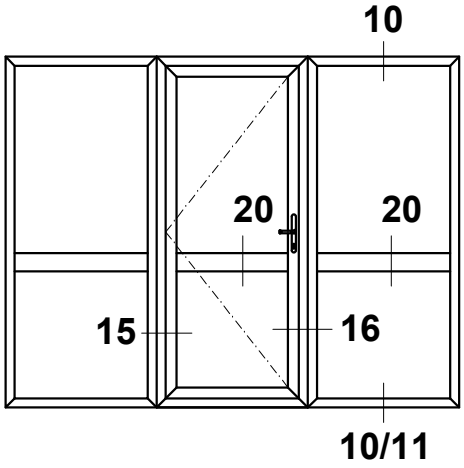
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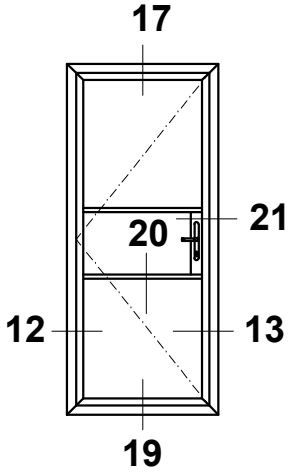
Open Out Quick-Glaze Bead - Elevations

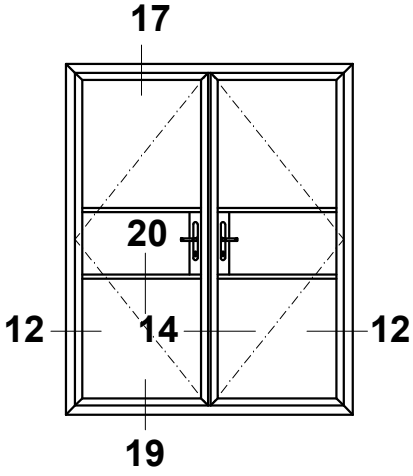






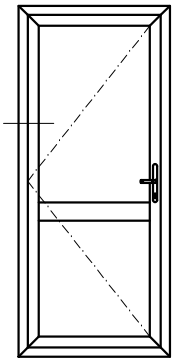


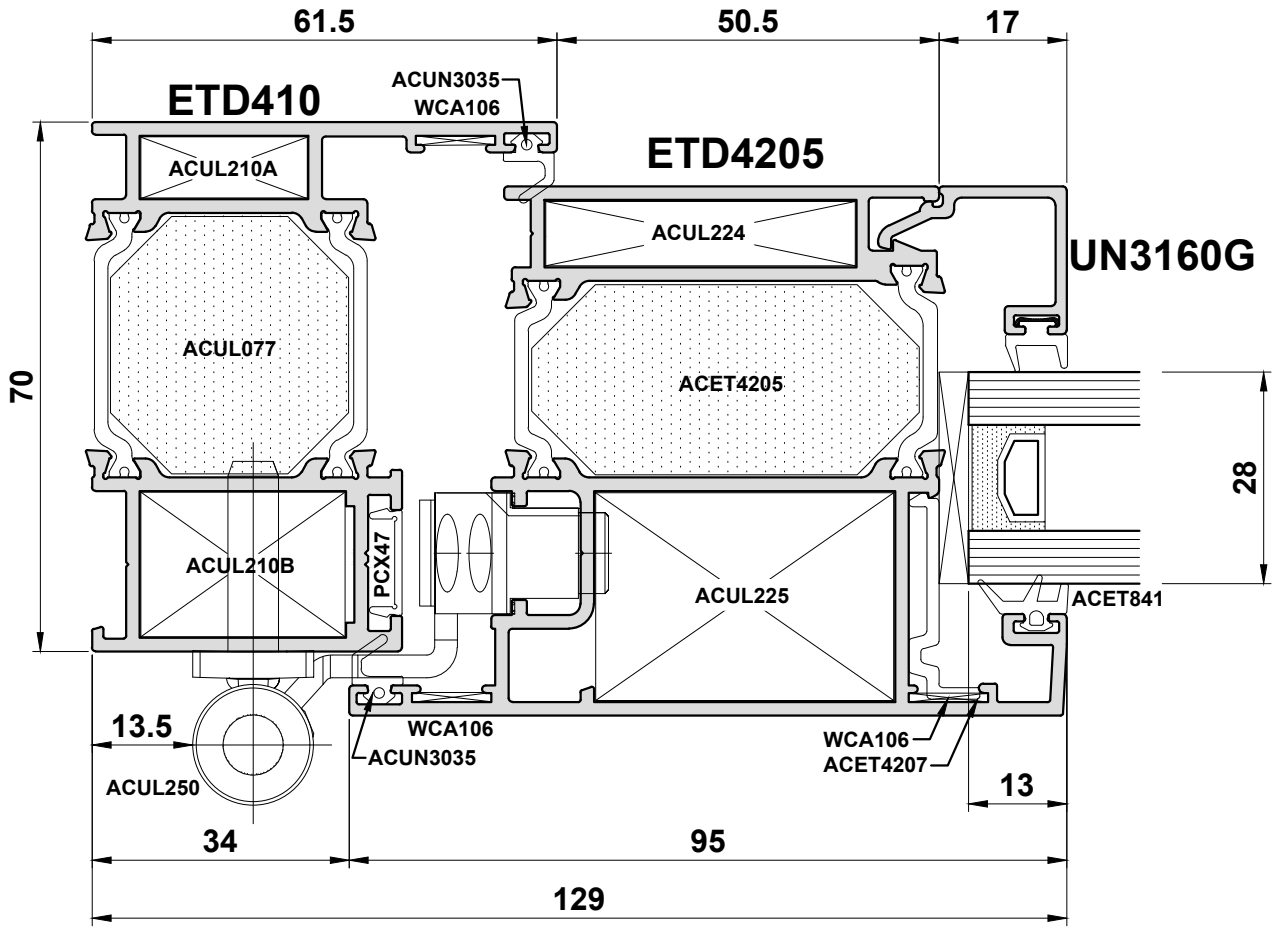




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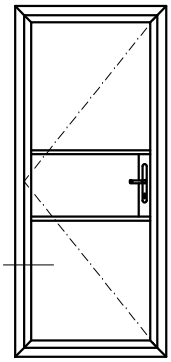
Open Out - Detail 12A

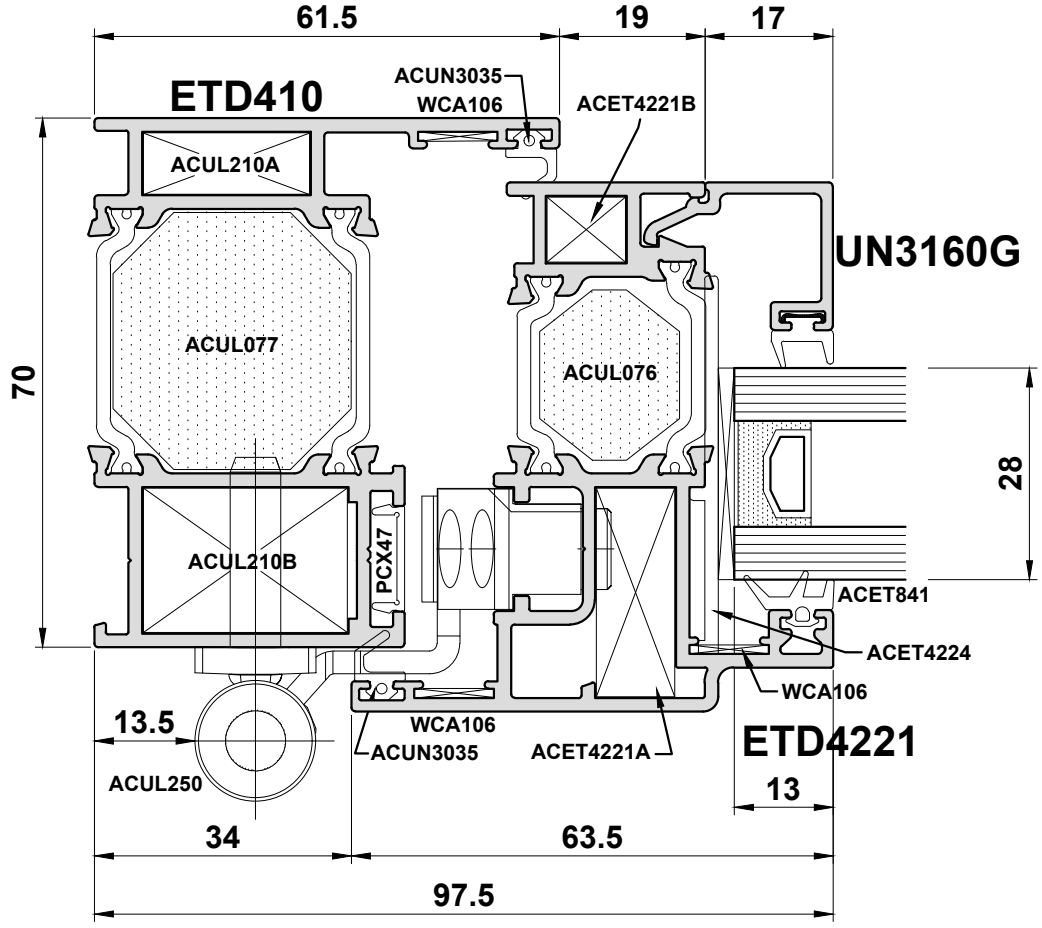




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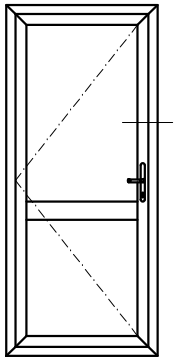
Open Out - Detail 12B

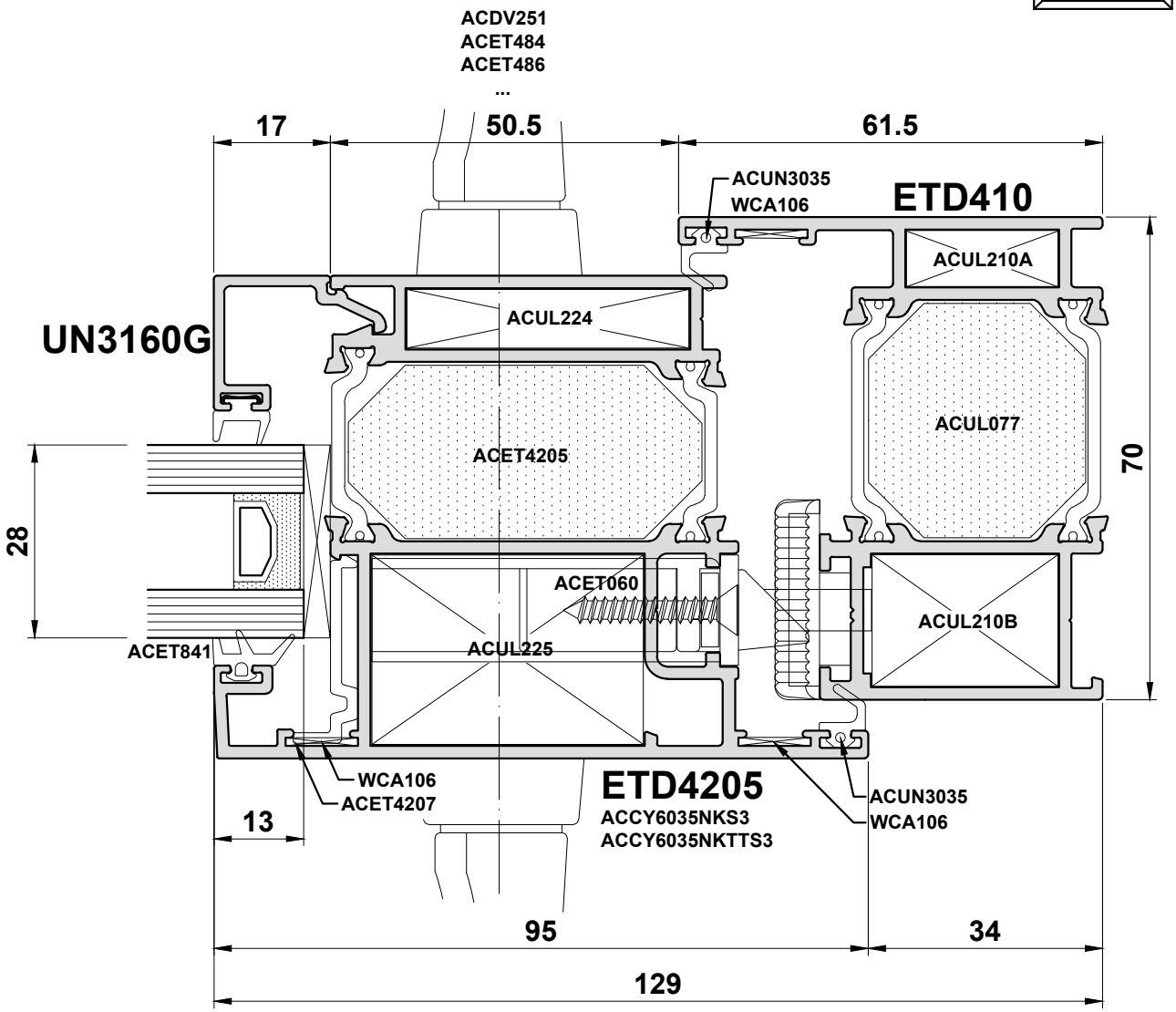




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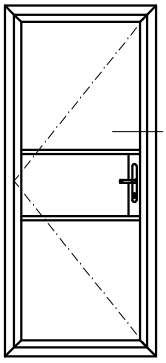
Open Out - Detail 13A

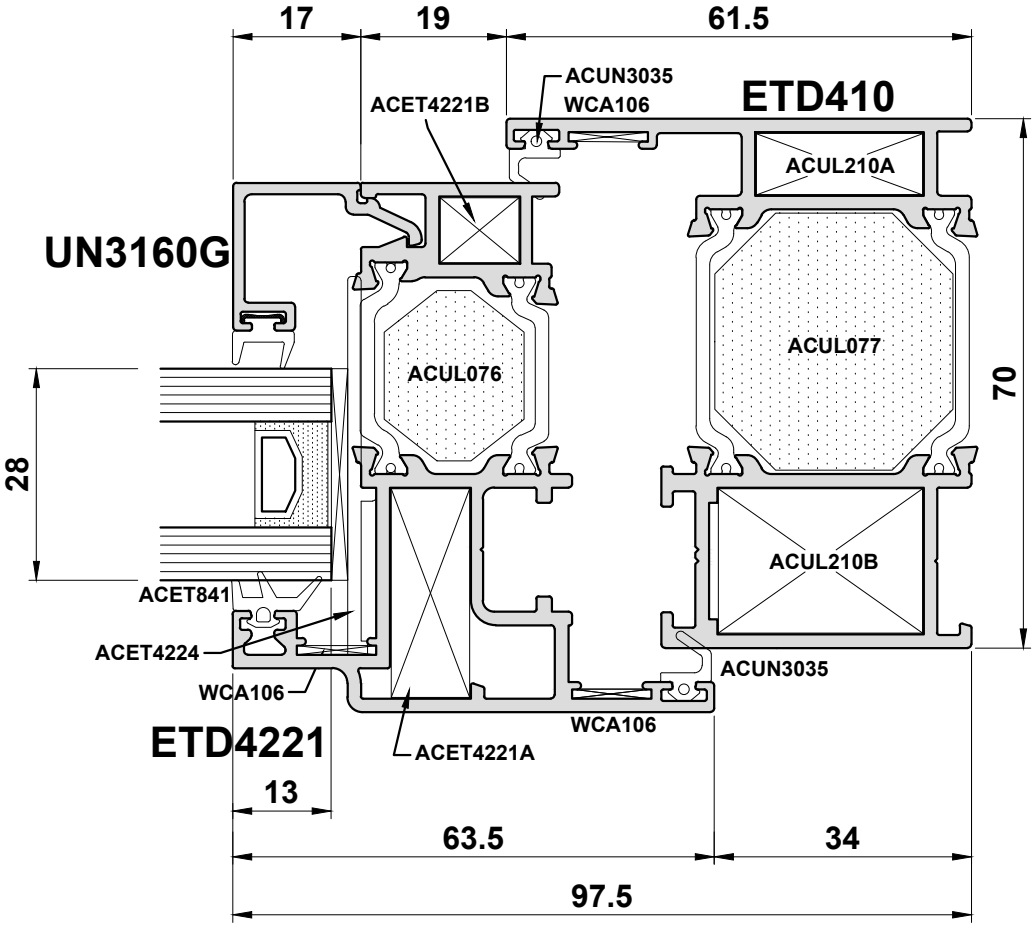




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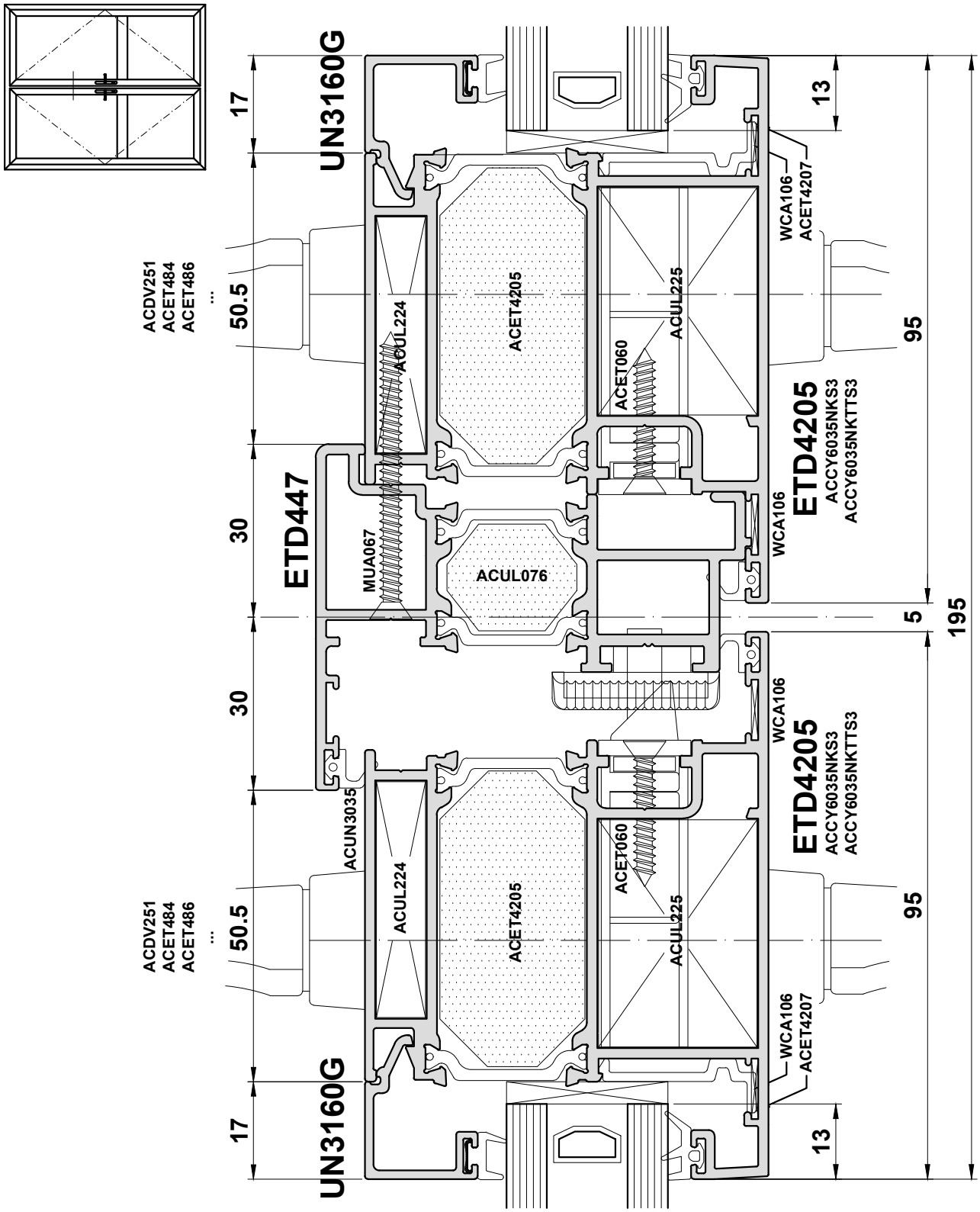
Open Out - Detail 13B





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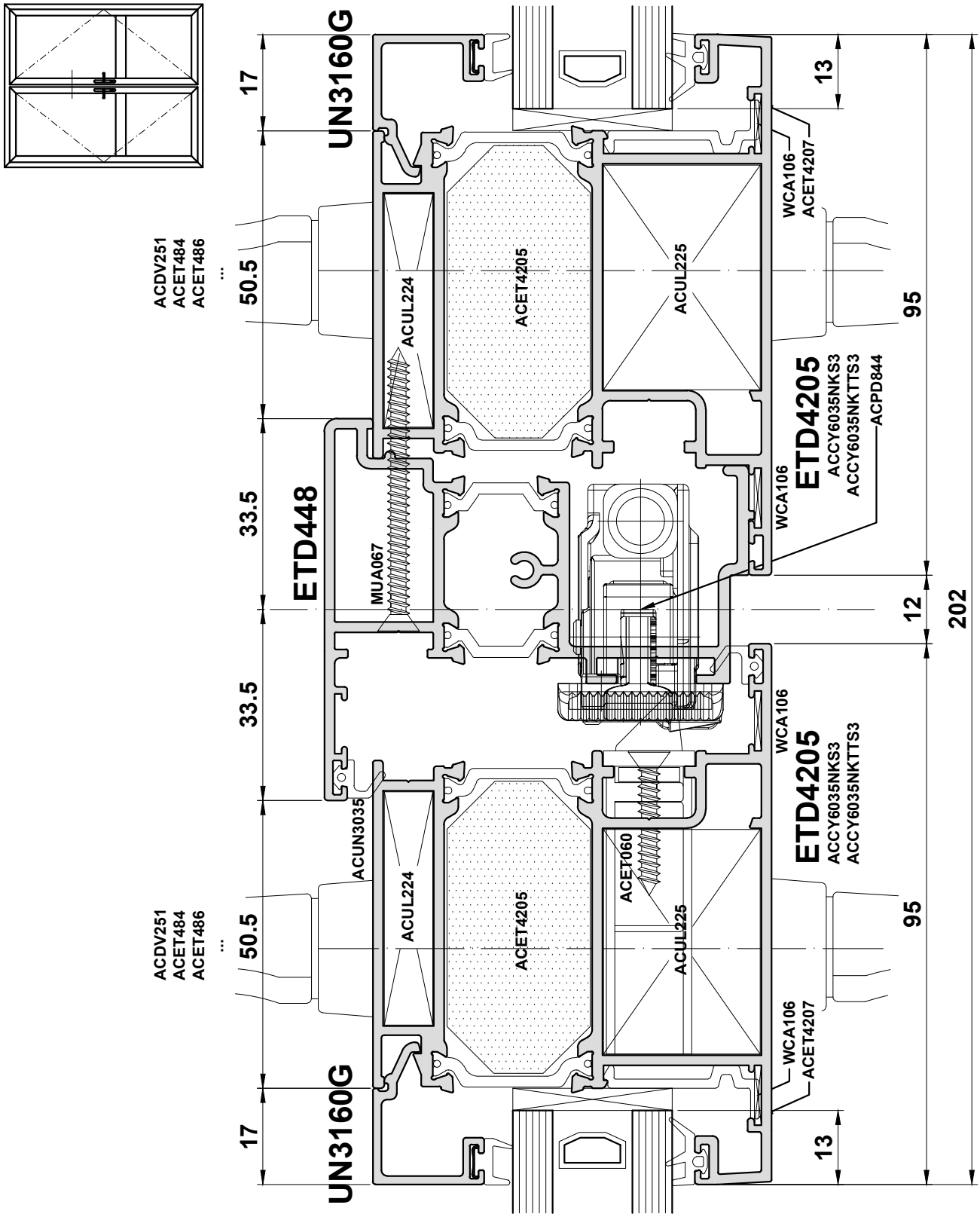
Open Out - Detail 14A



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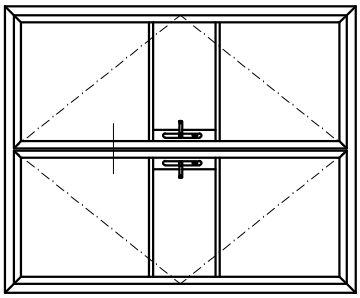
ISSUED: JULY 2026

Open Out - Detail 14B

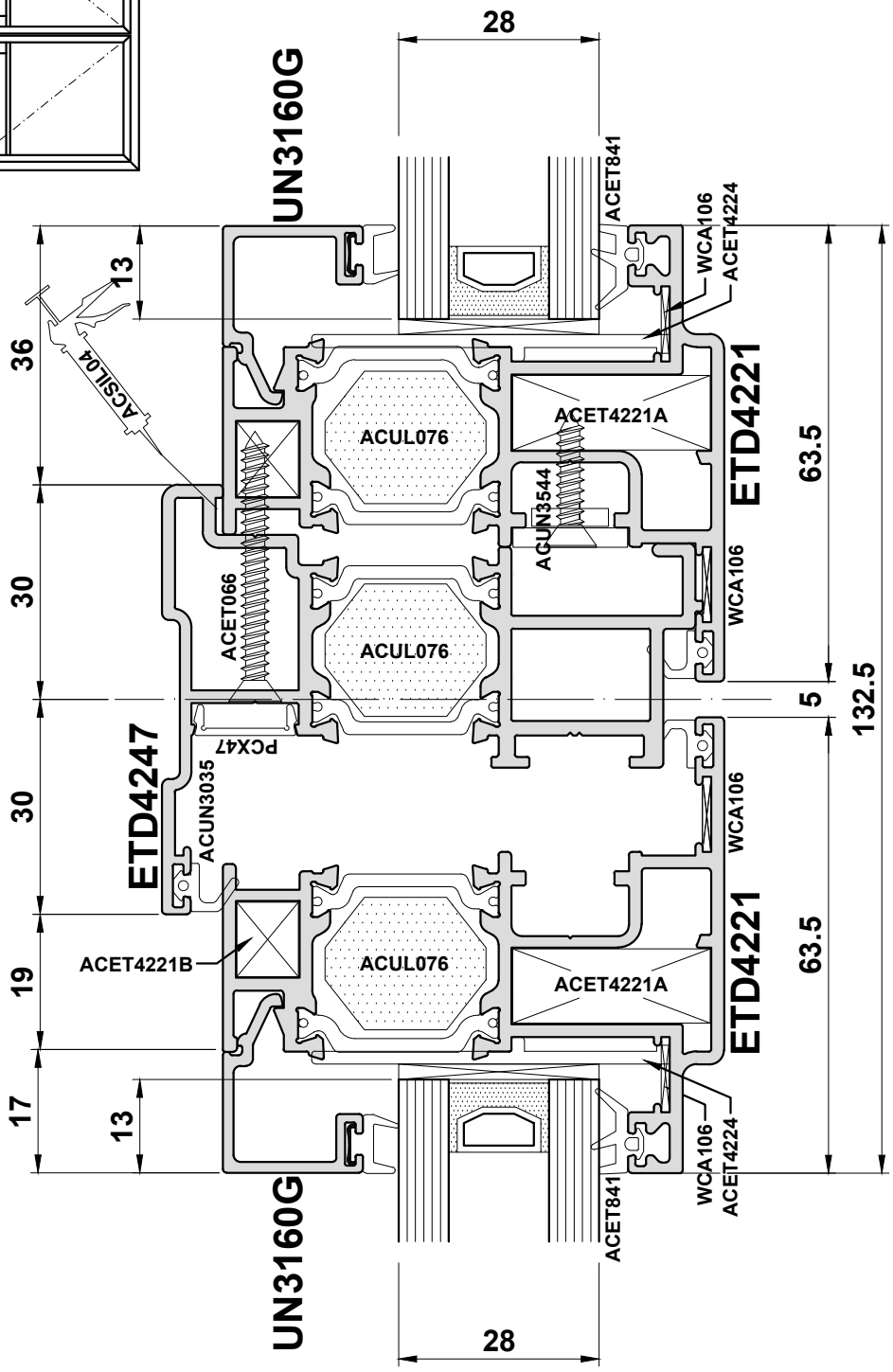


Do Not Scale From This Drawing

Open Out - Detail 14C

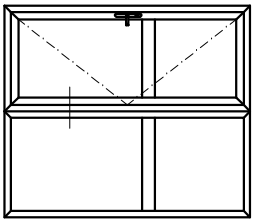


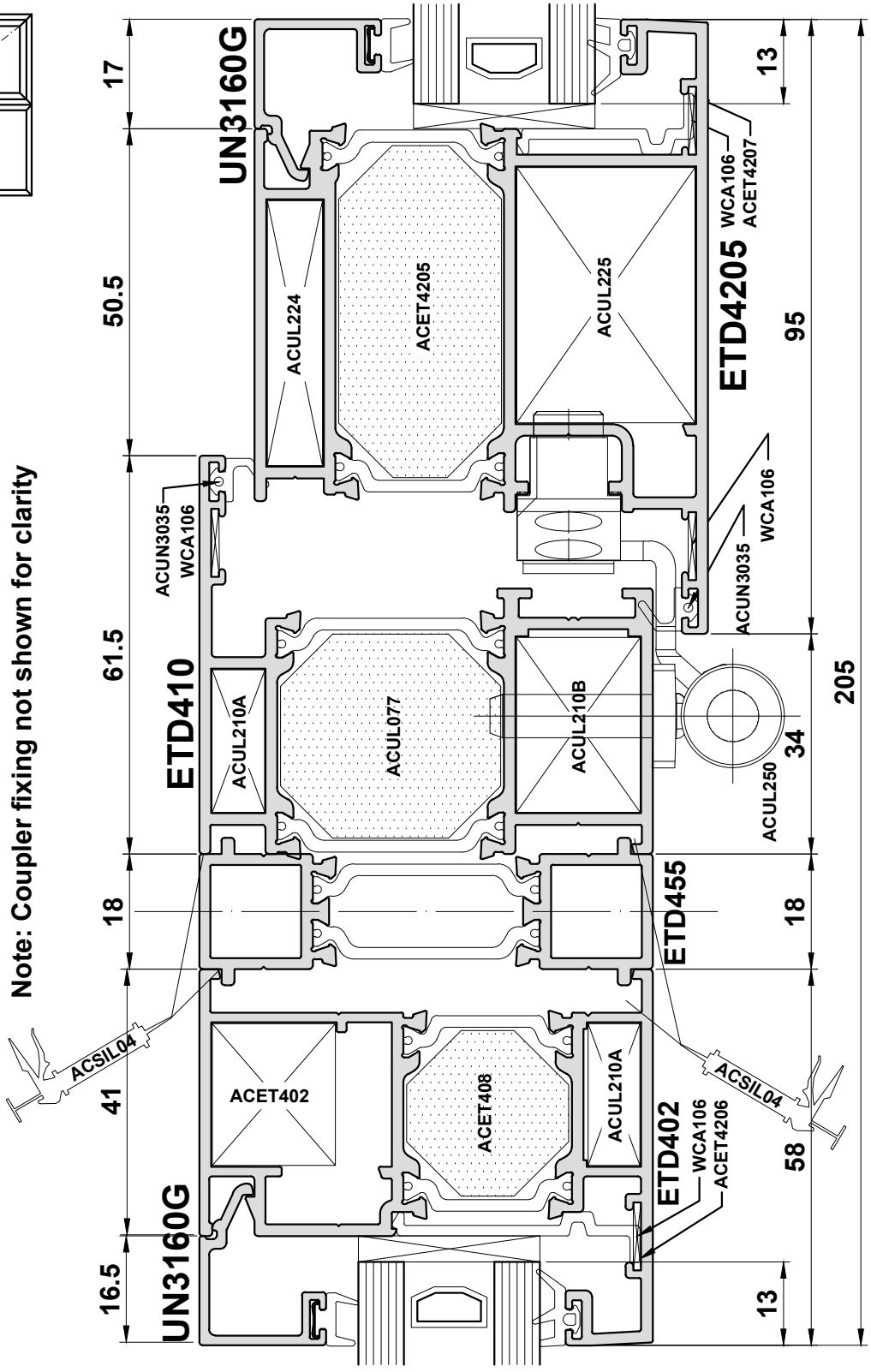
ONLY USE ACW20465 LOCK & ACW20466 SECONDARY LOCK FOR HERITAGE DOORS



Do Not Scale From This Drawing

Open Out - Detail 15

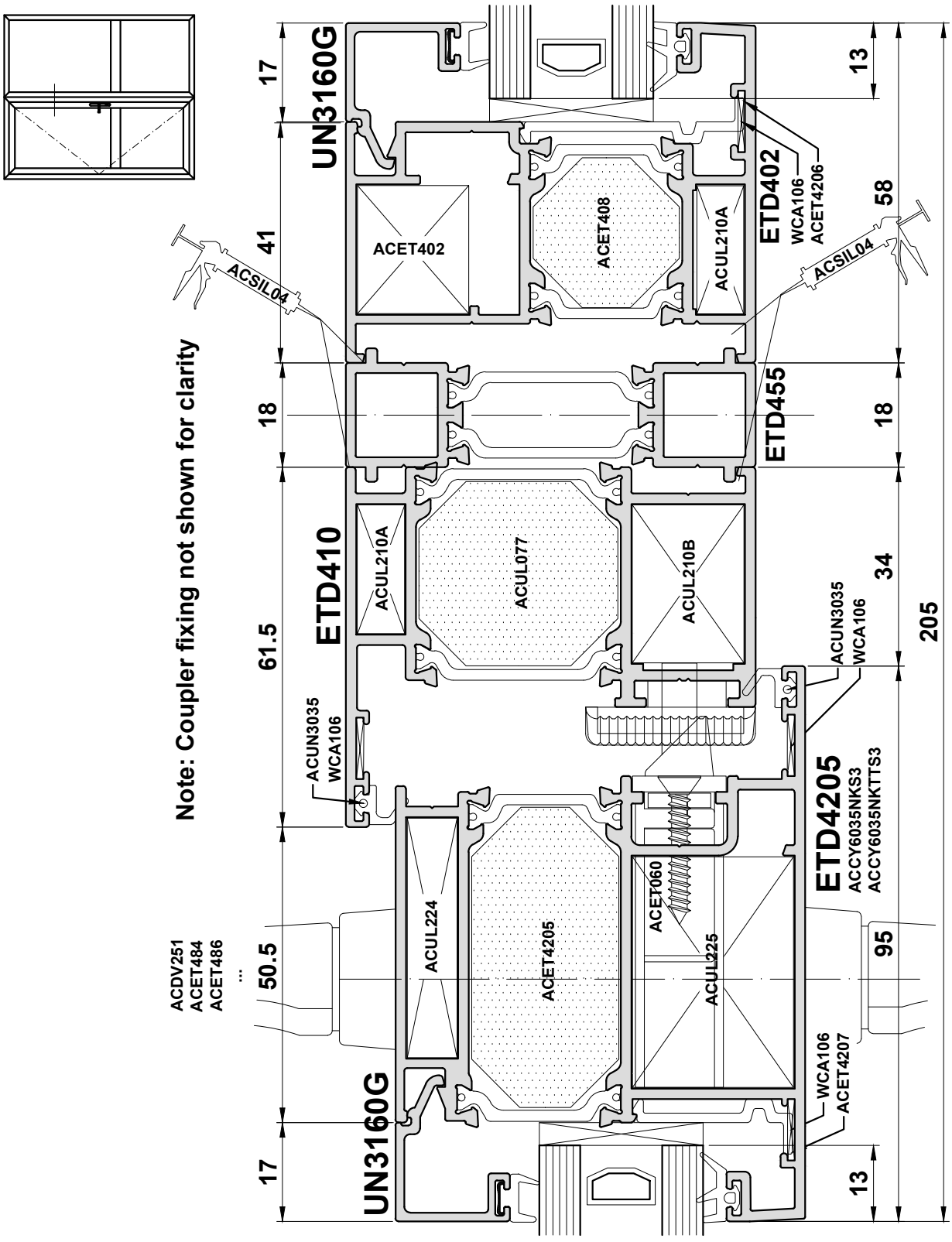




Note: Coupler fixing not shown for clarity

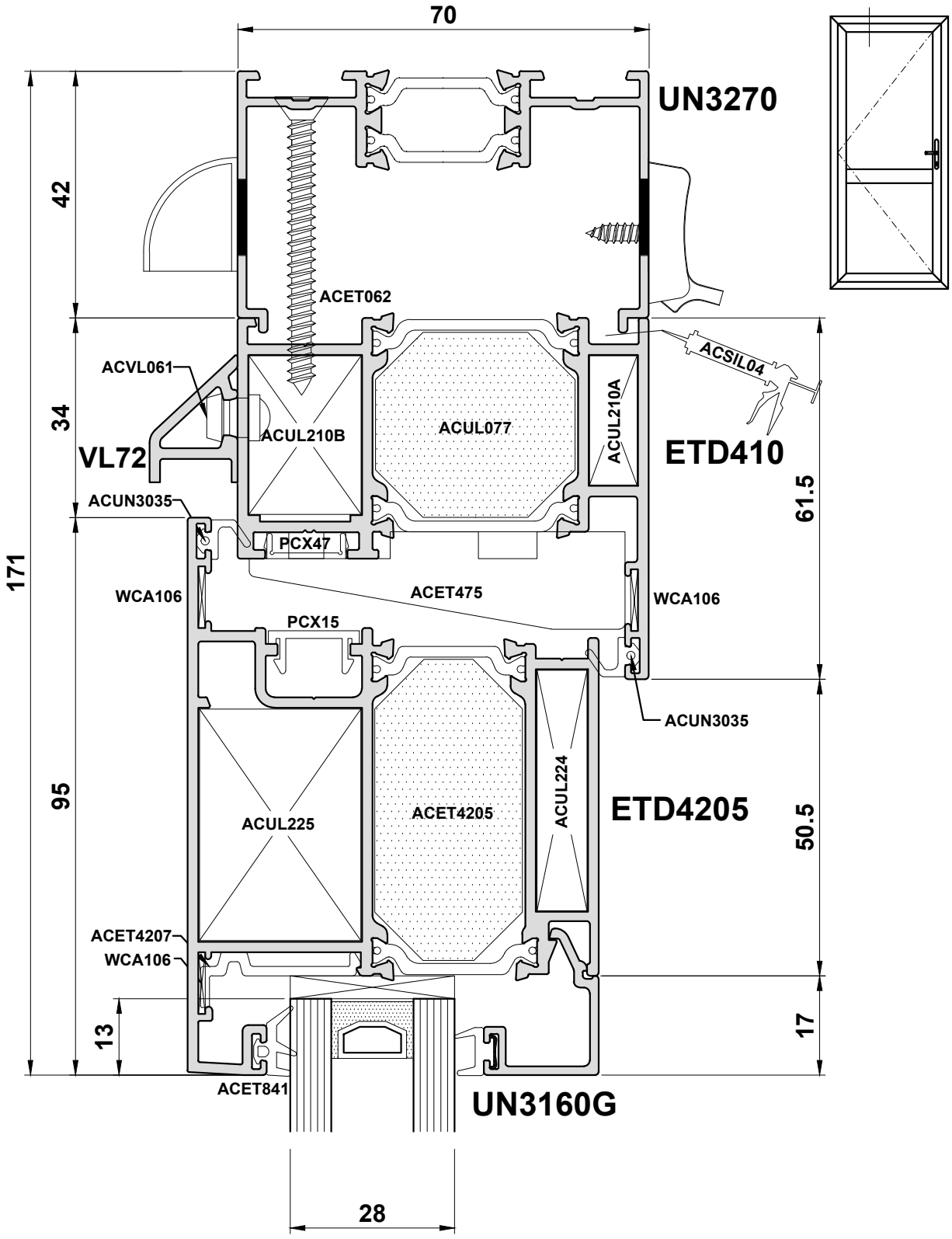
Do Not Scale From This Drawing

Open Out - Detail 16



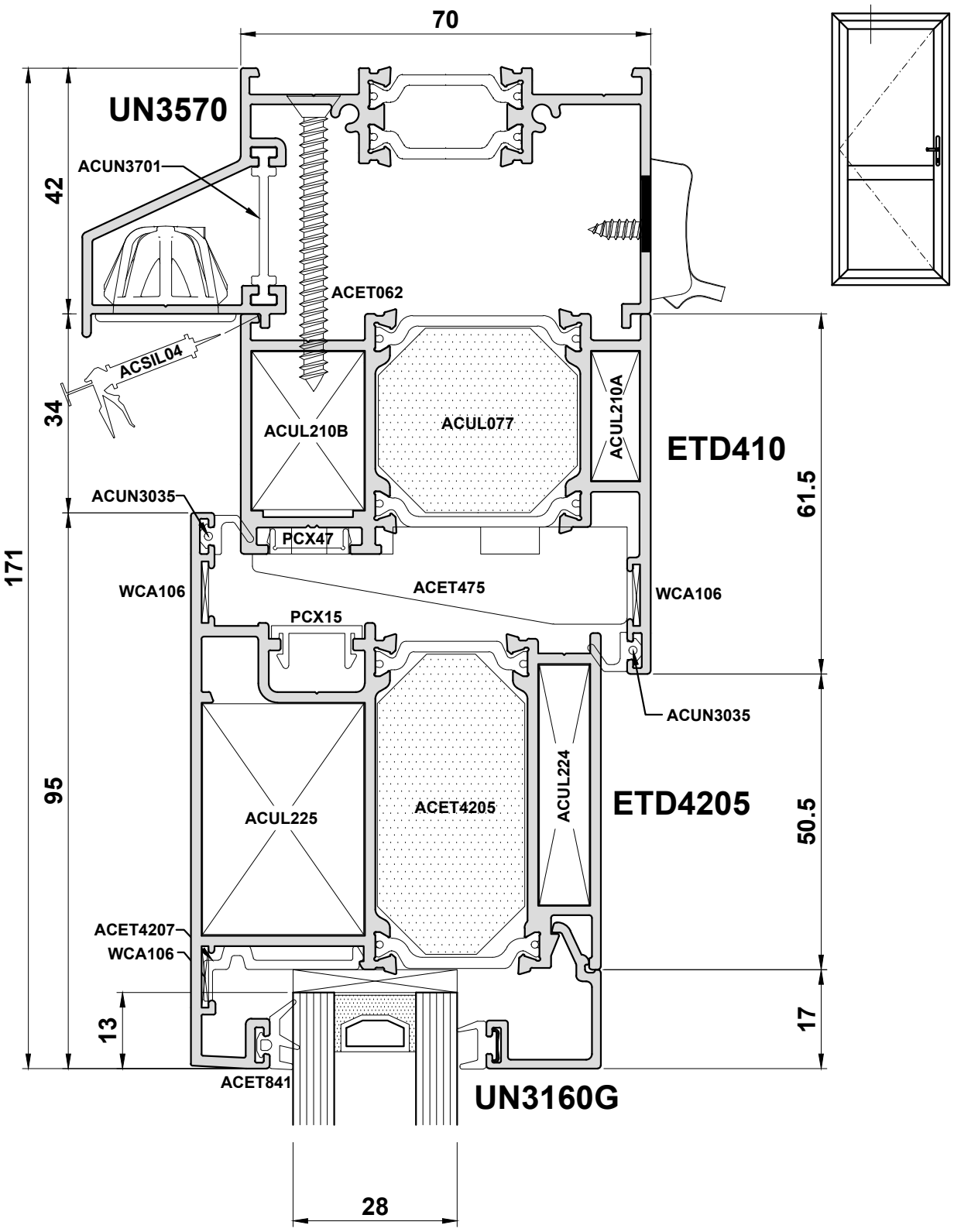
Do Not Scale From This Drawing

Open Out - Detail 17A



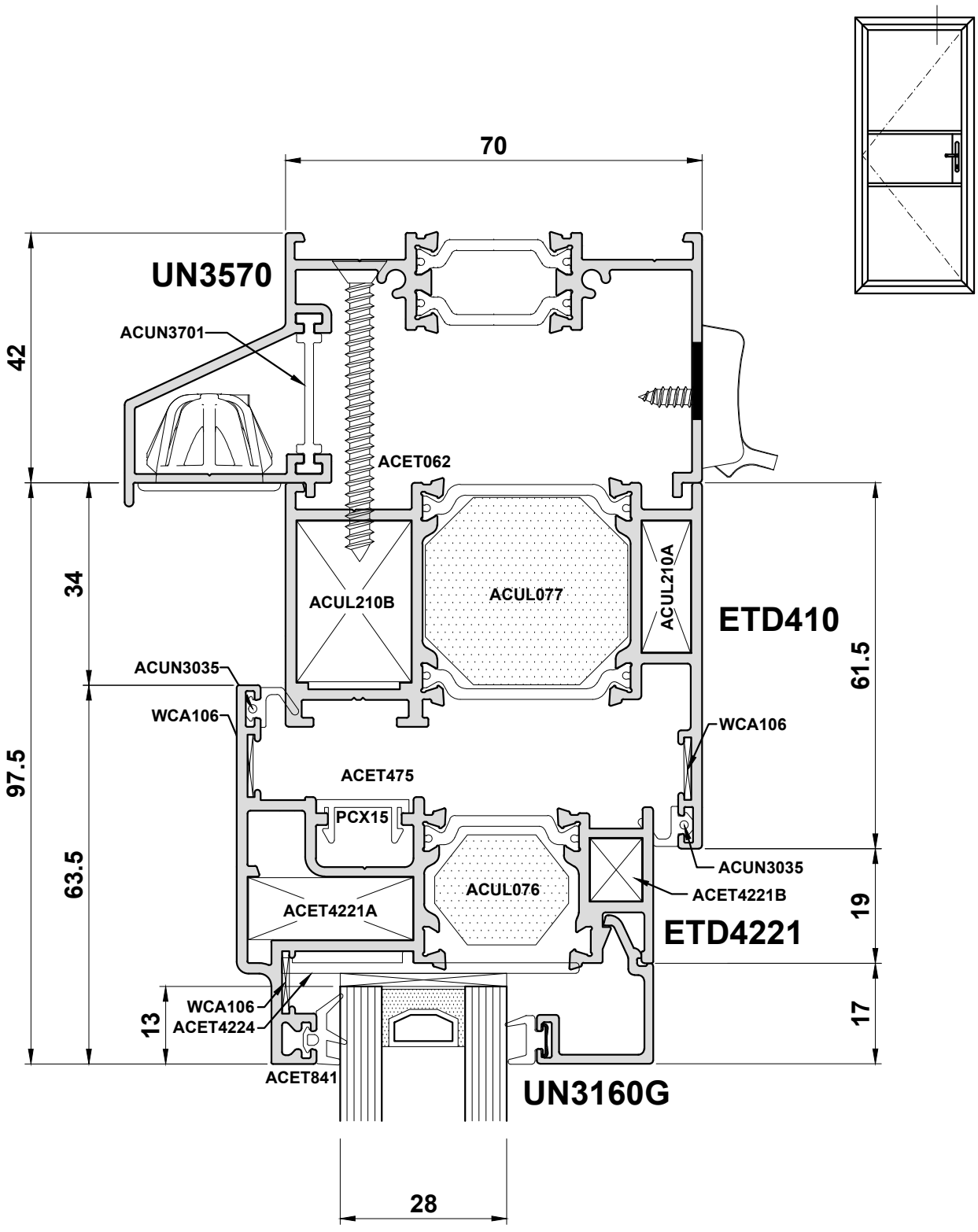
Do Not Scale From This Drawing

Open Out - Detail 17B



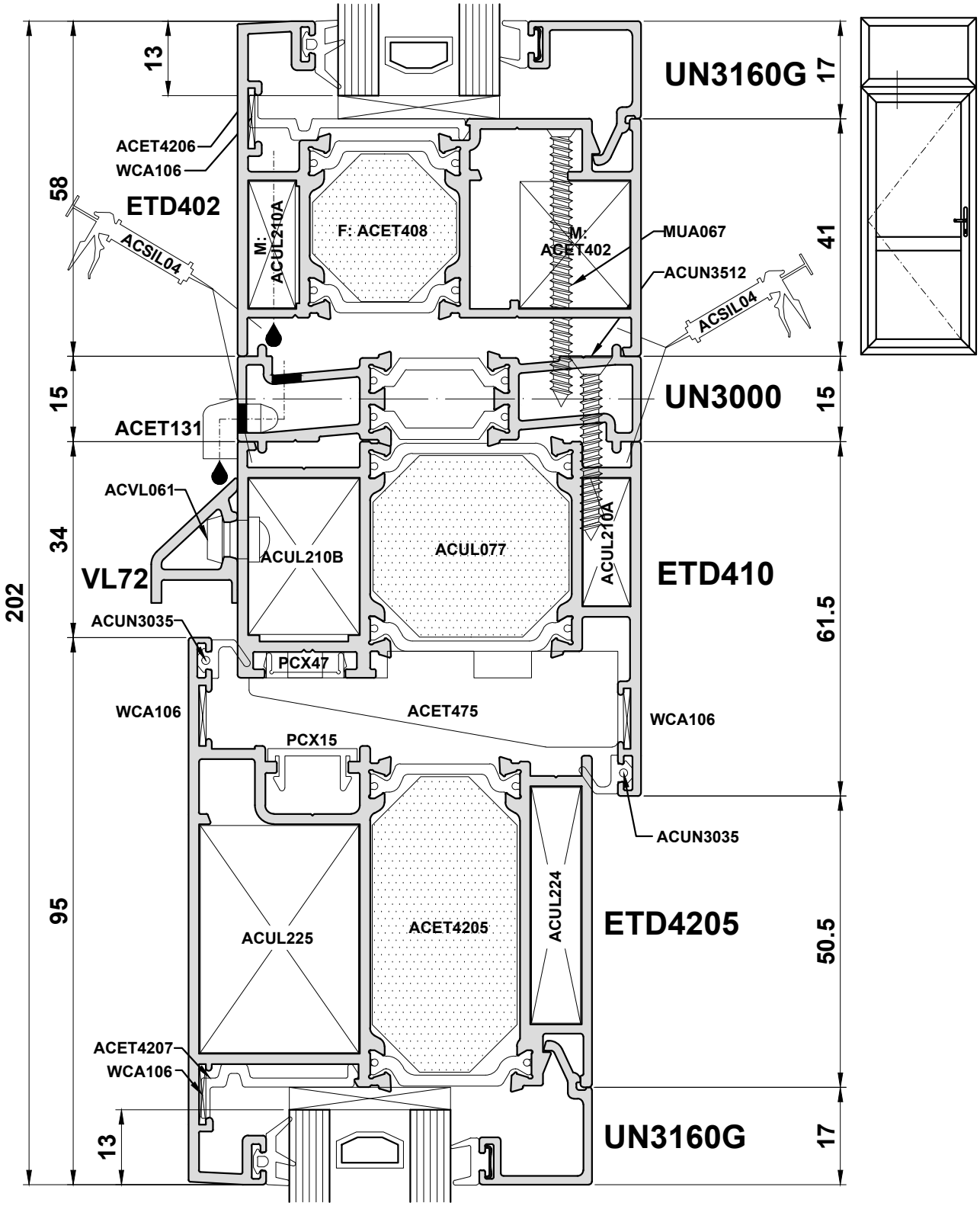
Do Not Scale From This Drawing

Open Out - Detail 17C



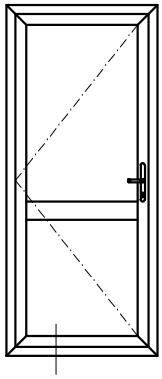
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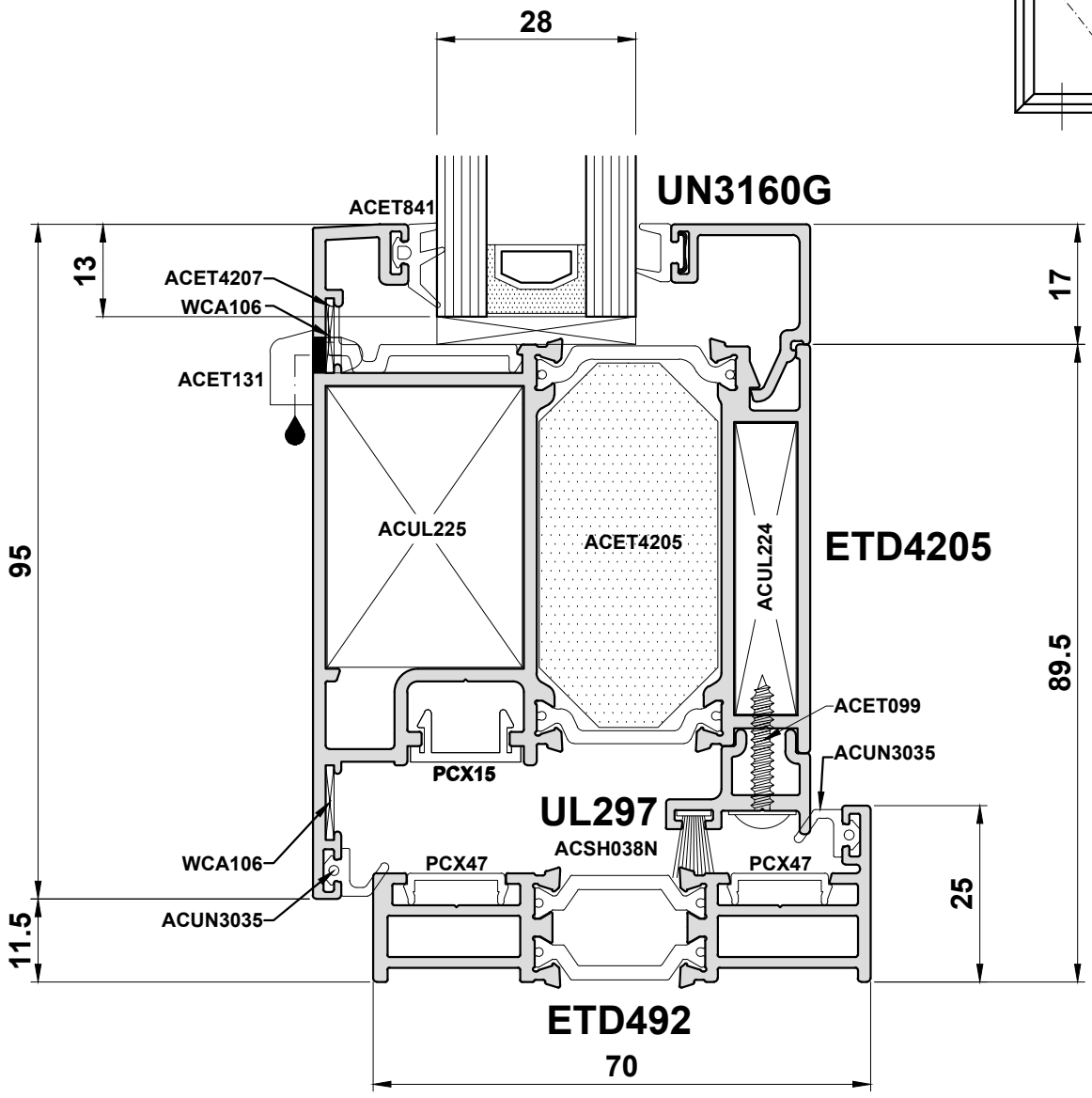
Open Out - Detail 18



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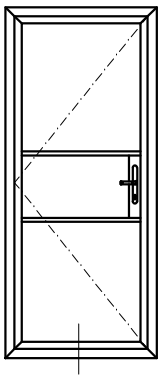
Open Out - Detail 19A

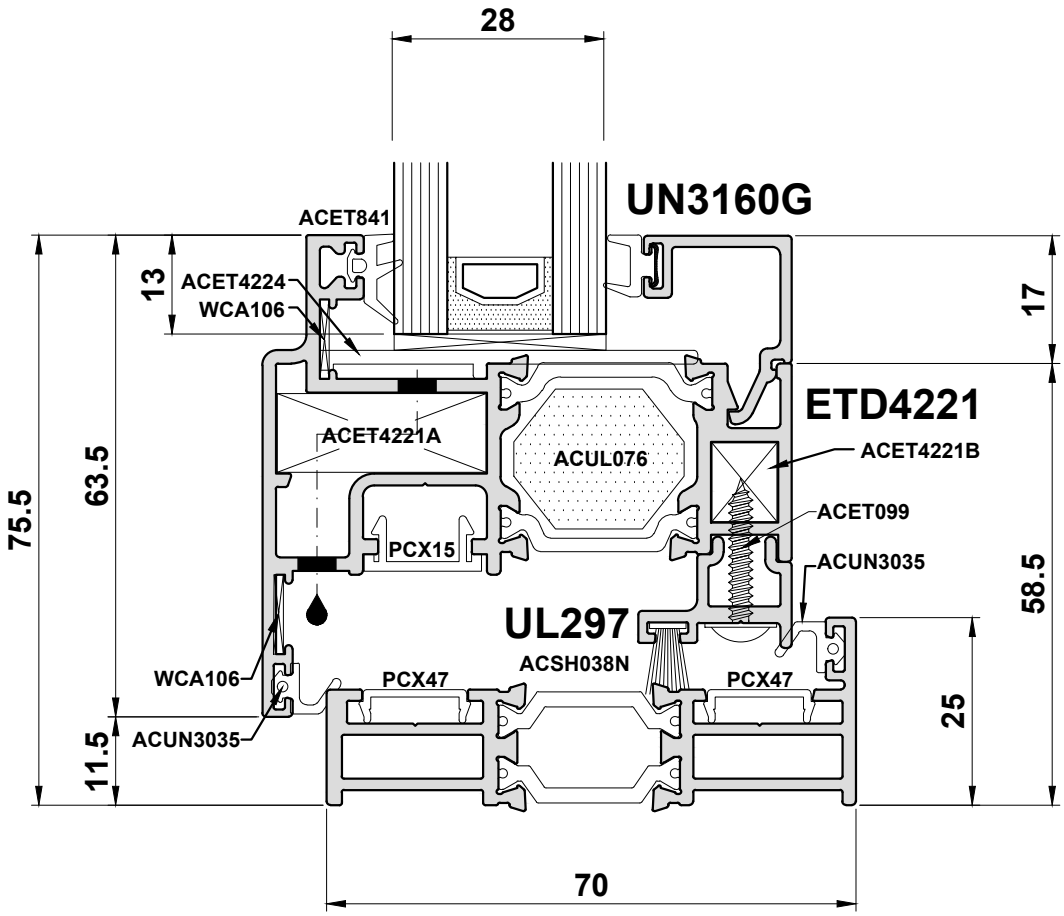




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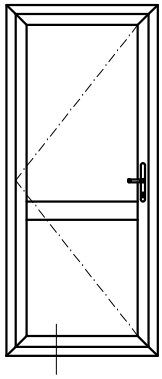
Open Out - Detail 19B

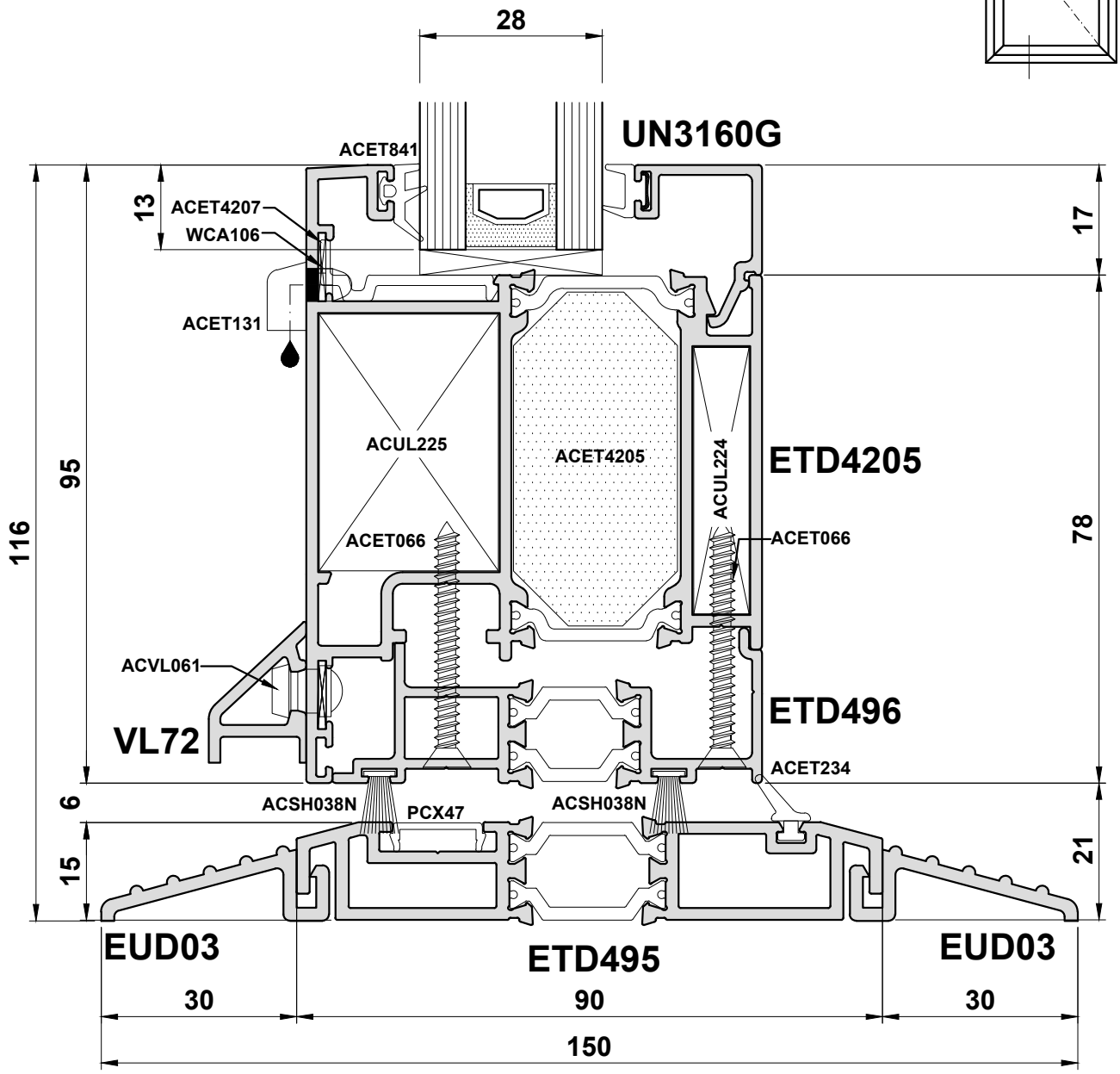




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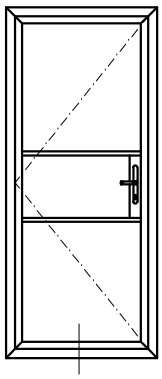
Open Out - Detail 19C

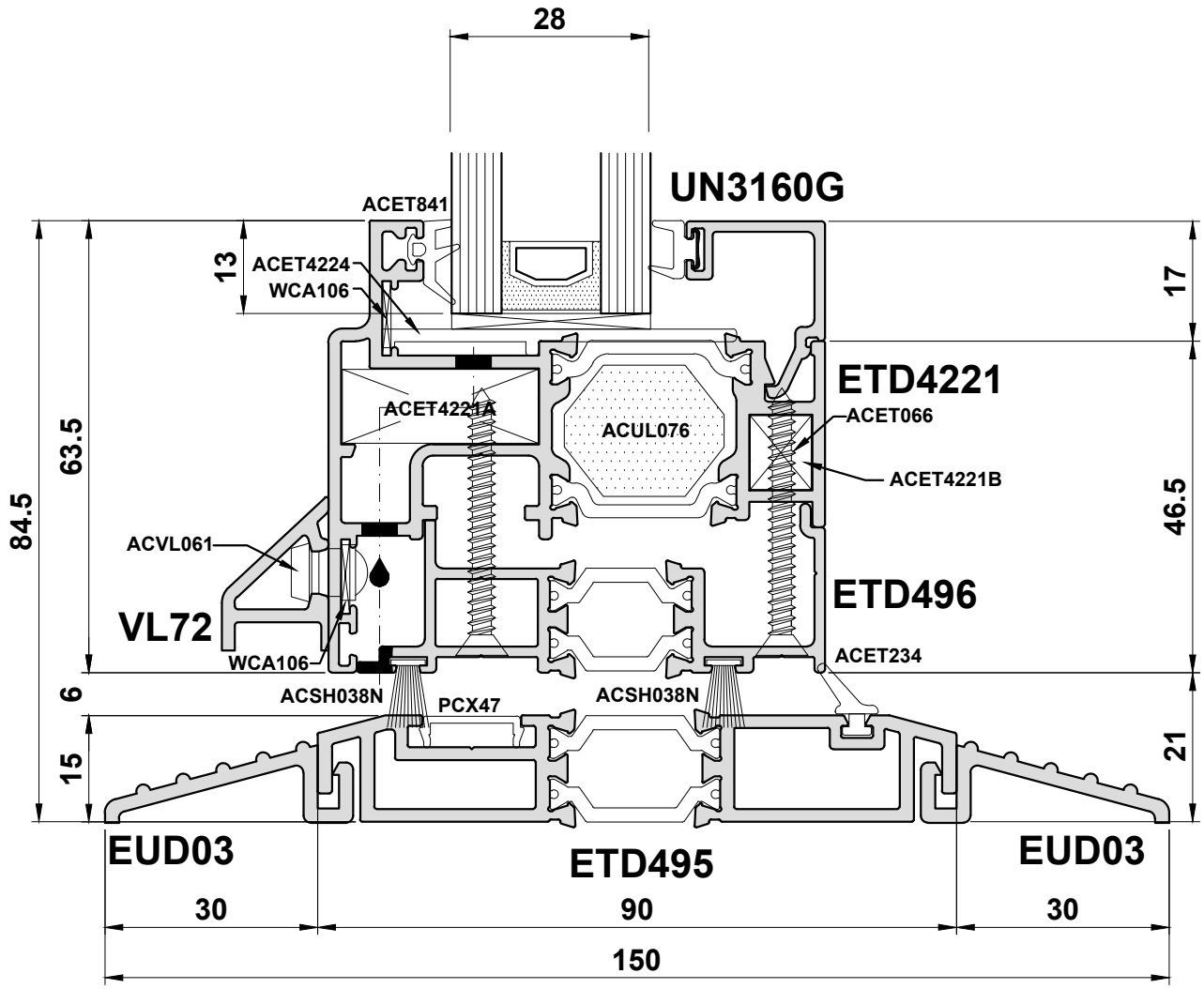




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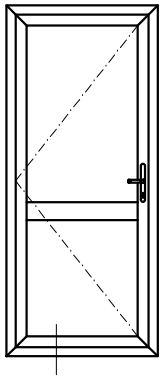
Open Out - Detail 19D

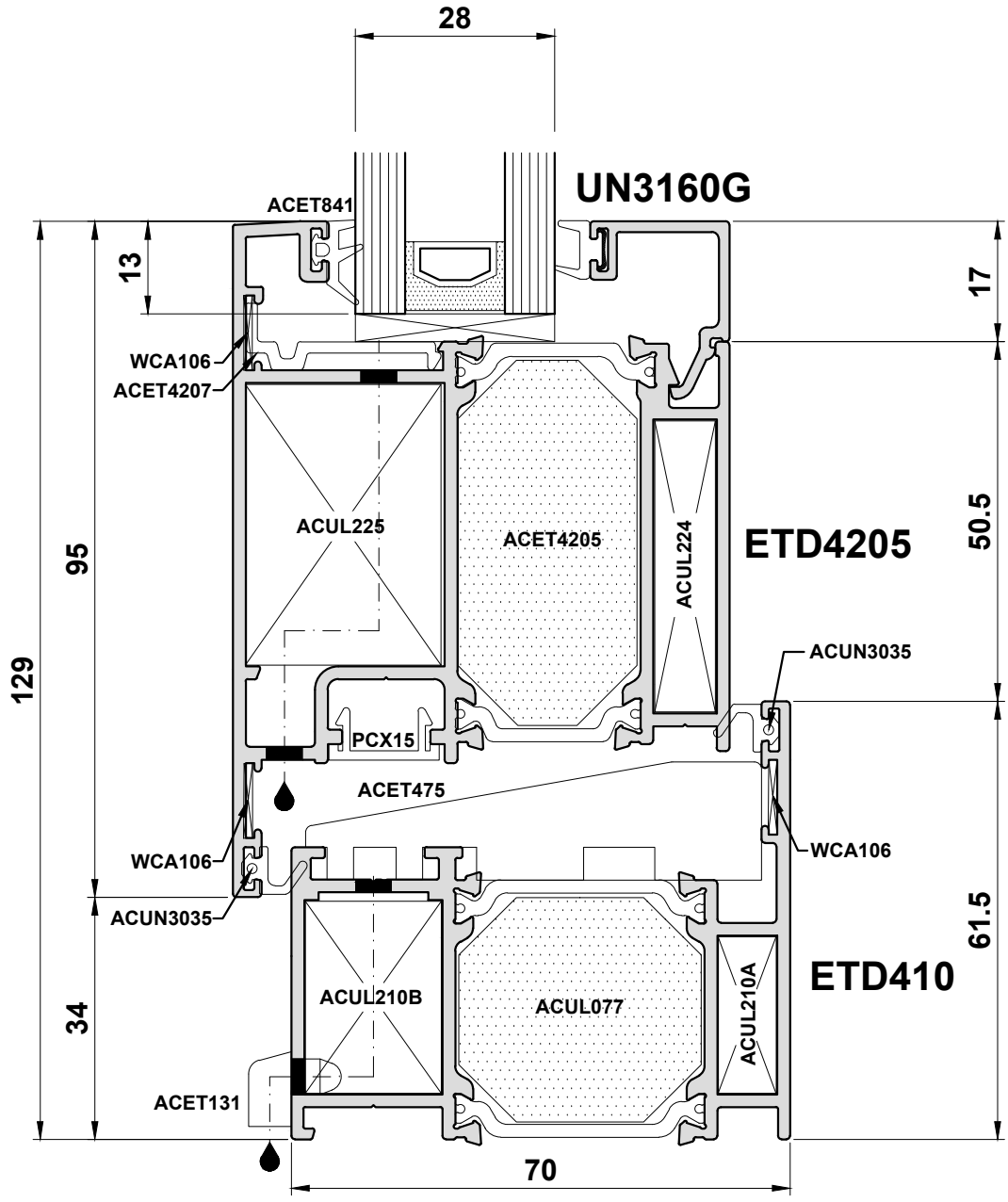




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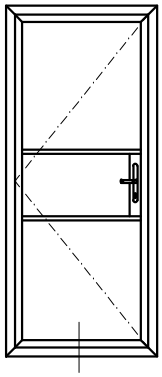
Open Out - Detail 19E

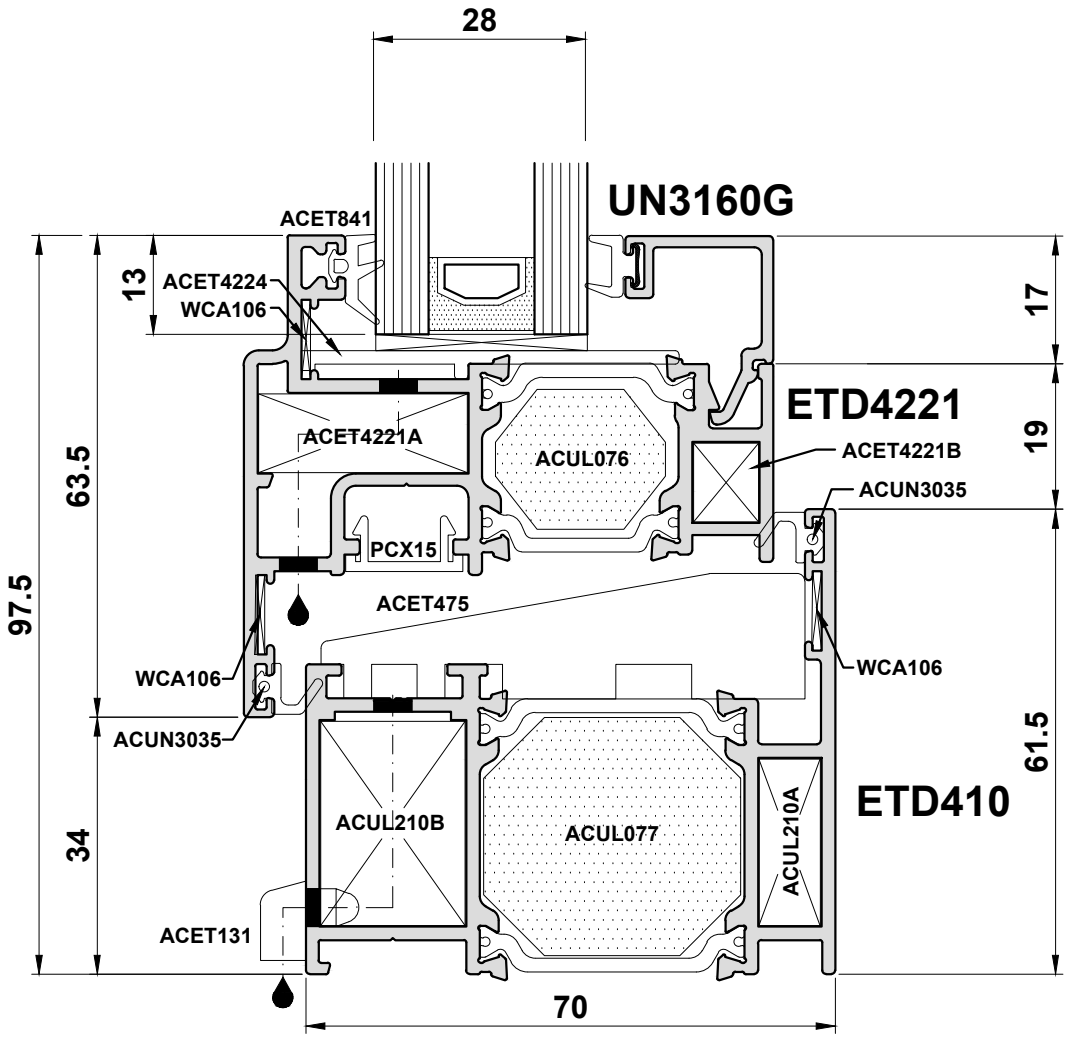




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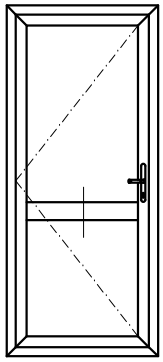
Open Out - Detail 19F

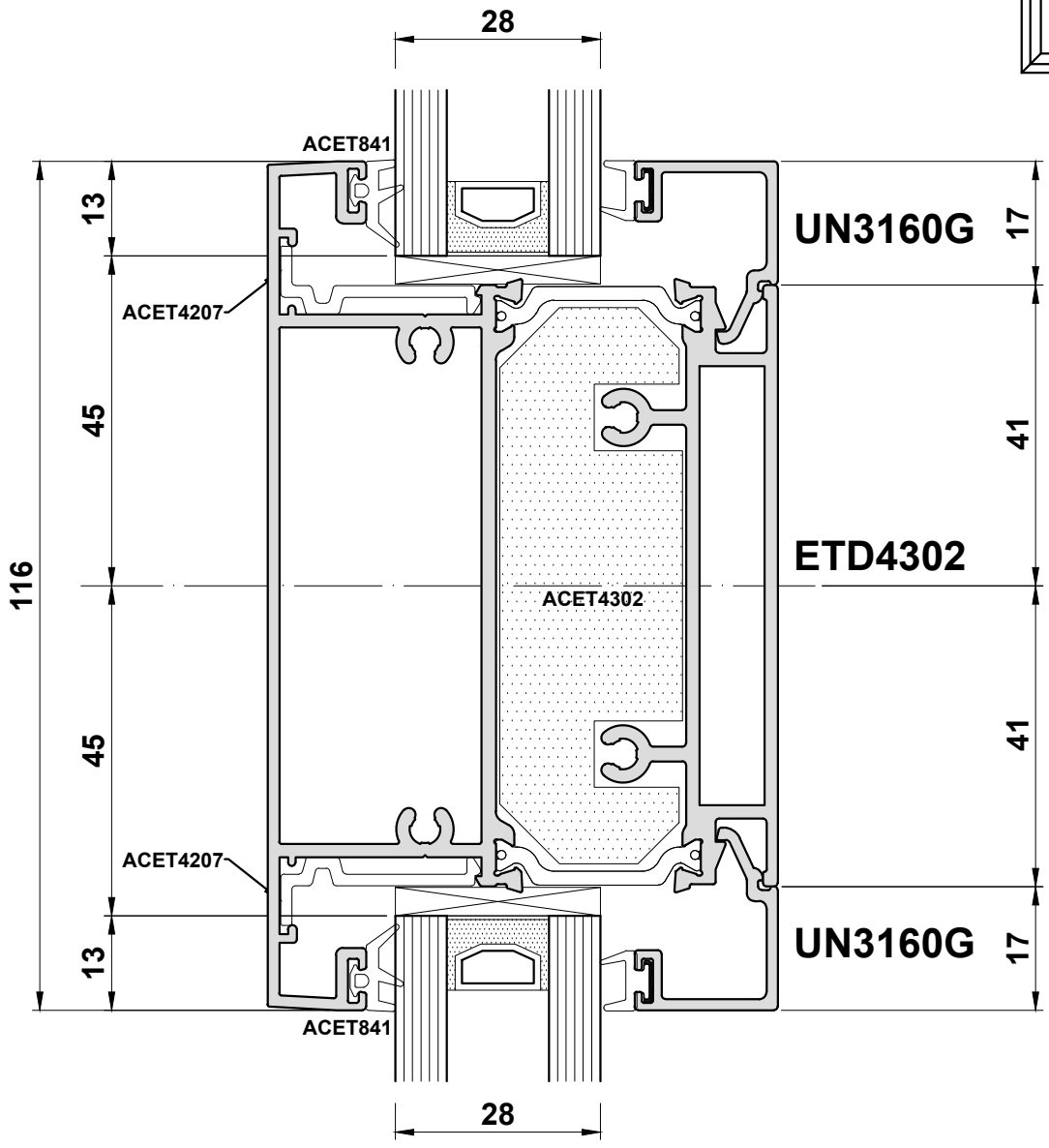




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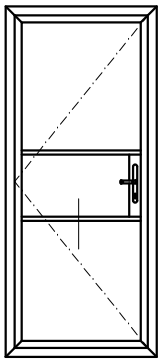
Open In - Detail 20A

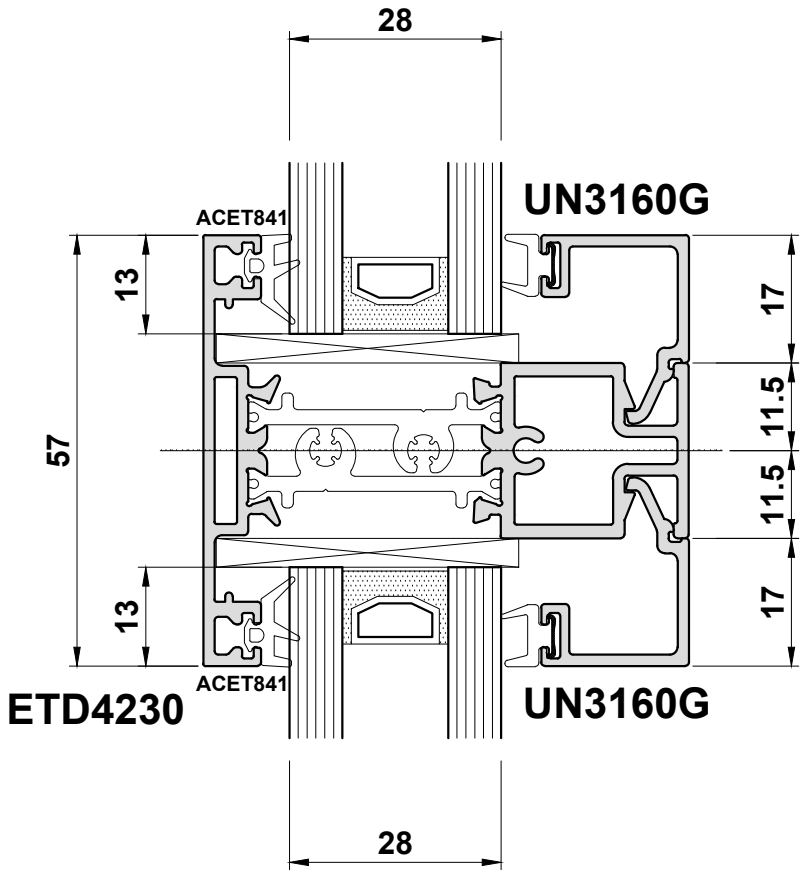




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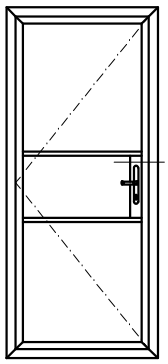
Open Out - Detail 20B

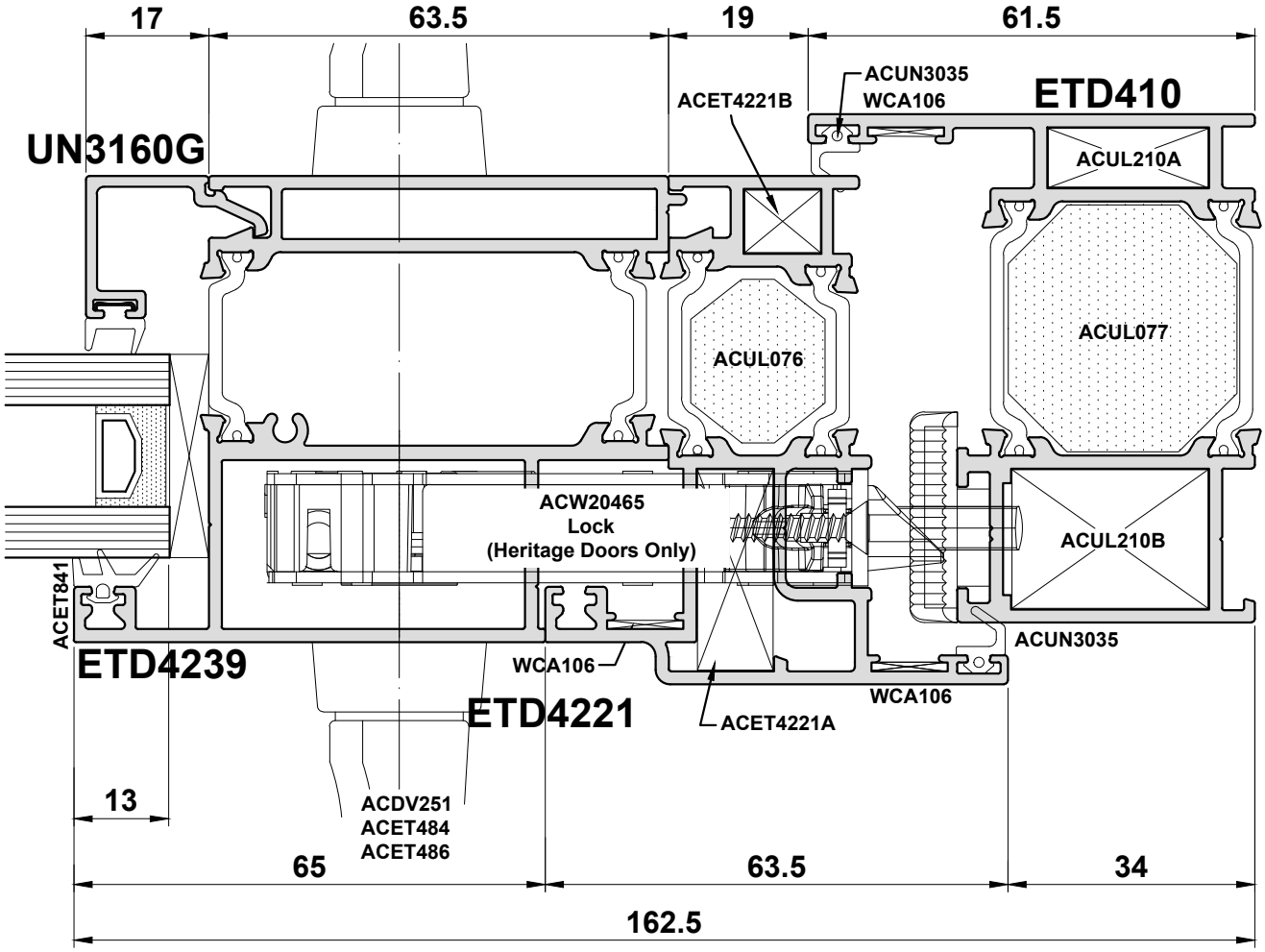




Do Not Scale From This Drawing

Open Out - Detail 21





Do Not Scale From This Drawing

Do Not Scale From This Drawing

Section D

Statics

Open Out & In

General Size Limitations are shown on Page A02.

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

Section E

E ` ETD

Construction Drawings - Open In

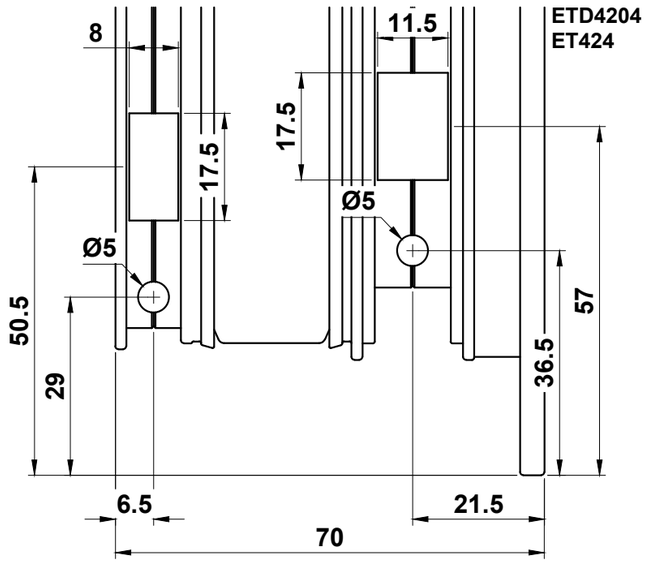
Corner Joint Detail..... E03
Corner Crimping..... E04
ACUL900 Punch Tool E05
Low Rebate Threshold Assembly..... E06
Low Ramp Threshold Assembly..... E07
Drainage..... E08 - E09
Sub Cill Drainage..... E10
Standard Bead Transom Assembly..... E11 - E12
Quick-Glaze Bead Transom Assembly..... E13
Panel Door Details..... E14
Door Locking Hardware Options..... E15
Lock Overview of Single and Double Doors..... E16
Heritage Single Door Hardware Options..... E17
Heritage Double Door Hardware Options..... E18
Hinge Preparation..... E19
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Single Door Lock Preparation..... E21
Single Door Shootbolt Detail..... E22
Electric Strike Details..... E23
Single Point Lock & Internal Lever Handle Prep E24
Stainless Steel Hardware..... E25
ACSM020 & ACSM021 Fitting Detail..... E26
Heritage Open In Door Lock Preparation..... E27
Heritage Open In Door Handle Preparations... E28
Heritage ACW20367 Door Keep Position Guide. E29
Heritage ACW20066 L/R Door Centre Keep Prep E30
Lift Lever Shootbolt Layout..... E31
Heritage Double Door L/Lever Shootbolt Layout E32
Heritage ACW20367 Floating Mullion Install..... E33
Lift Lever Full Frame Preparation..... E34 - E35
Lift Lever Low Rebate Preparation..... E36 - E37
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Fingerbolt Full Frame Preparation..... E41 - E42
Fingerbolt Low Rebate Preparation..... E43 - E44
Fingerbolt Low Ramp Preparation..... E45 - E46
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Heritage Fingerbolt Low Rebate Preparation..... E48
Heritage Fingerbolt Low Ramp Preparation..... E49
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Glazing Details..... E55
Quick-Glaze Bead..... E56 - E57
Glass Adjuster..... E58
Fixing Strap Detail..... E59
Example Layout..... E60
Restrictor Fitting..... E61
Trickle Vent..... E62

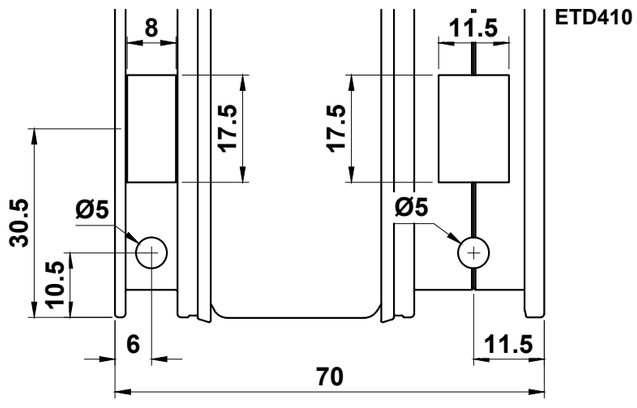
Section E

Construction Drawings - Open Out

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ACUL900 Punch Tool E67
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Low Ramp Threshold Assembly..... E69
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Electric Strike Details..... E83
Single Point Lock & Internal Lever Handle Prep E84
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Heritage Open Out Door Handle Preparations... E89
Heritage ACW20367 Door Keep Position Guide. E90
Heritage ACW20066 L/R Door Centre Keep Prep E91
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Heritage Double Door L/Lever Shootbolt Layout E93
Heritage ACW20367 Floating Mullion Install..... E94
Lift Lever Full Frame Preparation..... E95 - E96
Lift Lever Low Rebate Preparation..... E97 - E98
Lift Lever Low Ramp Preparation..... E99 - E100
ACUL267 & ACUL268 Lock Preparation..... E101
Fingerbolt Full Frame Preparation..... E102 - E103
Fingerbolt Low Rebate Preparation..... E104 - E105
Fingerbolt Low Ramp Preparation..... E106 - E107
Heritage Fingerbolt Full Frame Preparation..... E108
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Heritage Fingerbolt Low Ramp Preparation..... E110
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Glazing Chart..... E112 - E114
Glazing Details..... E115
Quick-Glaze Bead..... E116 - E117
Glass Adjuster..... E118
Fixing Strap Detail..... E119
Example Layout..... E120
Restrictor Fitting..... E121
Trickle Vent..... E122

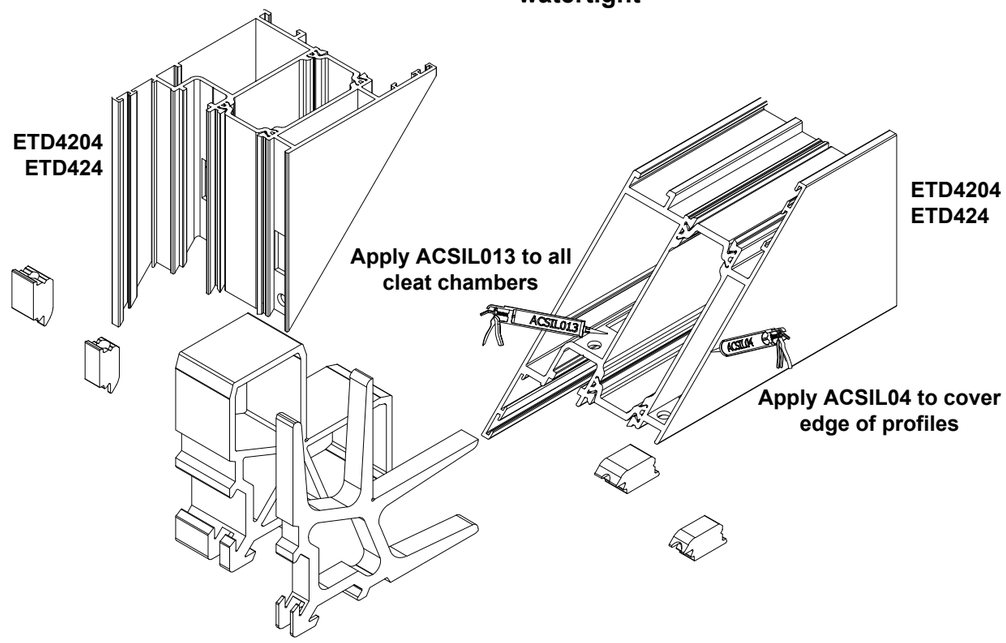
Corner Joint Details



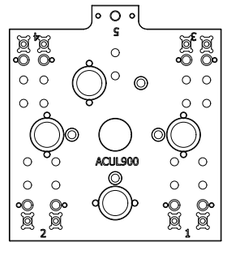


Notes

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



ACUL900



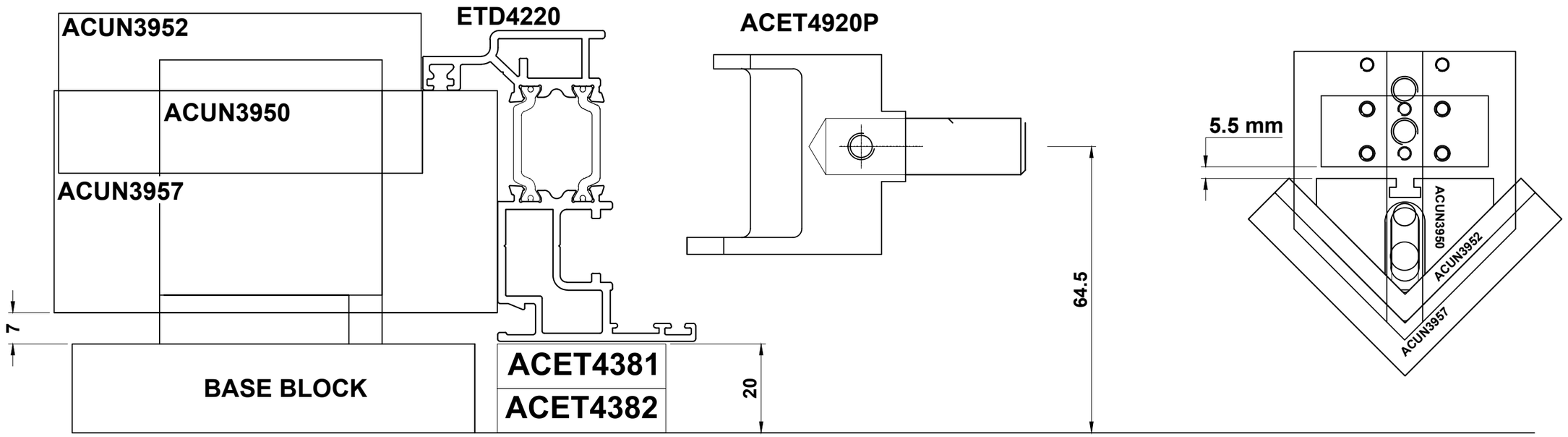
To ensure accurate corners, we recommend the use of support blocks (by others) whilst cutting.

Do Not Scale From This Drawing

Corner Crimping

Manual Crimper = ACCR300

Pneumatic Crimper = ACCR200N

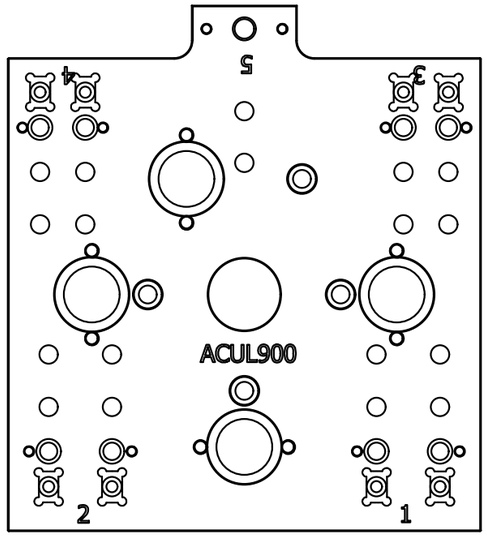


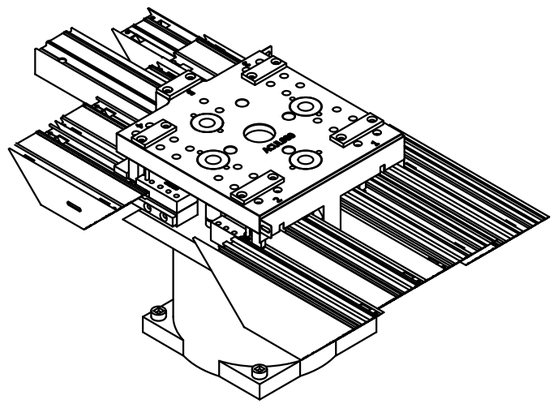
Please consult our Technical Department for support with alternative crimper models

Do Not Scale From This Drawing

Alitherm 400 Stepped Door

ACUL900 Punch Tool

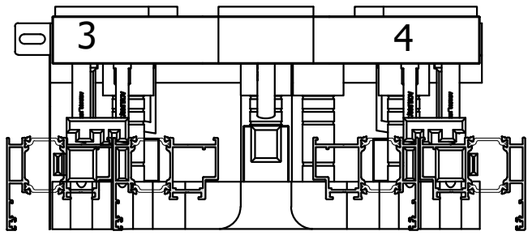


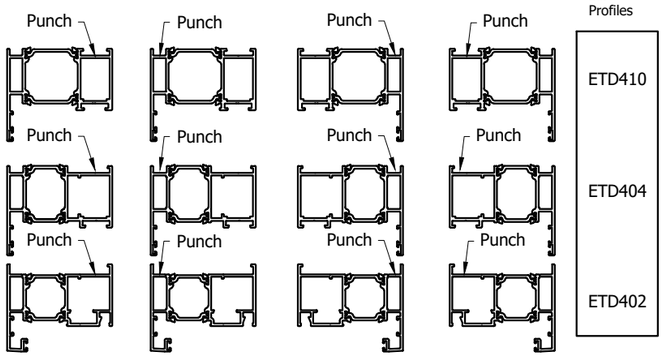


IMPORTANT NOTE:
Please do not overtighten retaining nut to punch tool base.

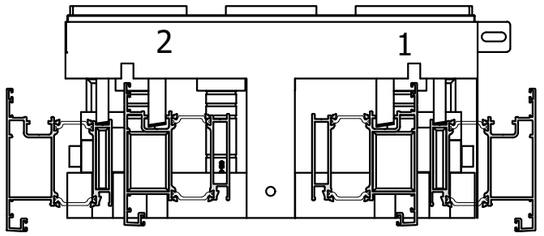
Use support stands for longer lengths of profiles.

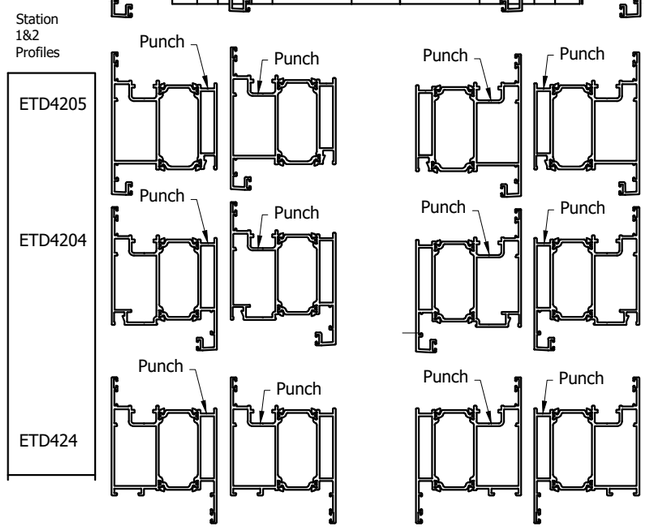
Station 3 & 4



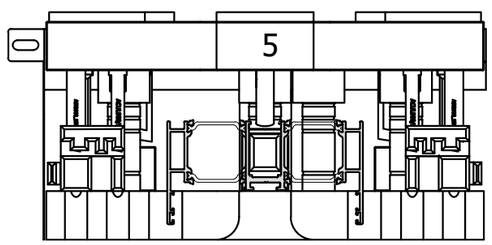


Station 1 & 2

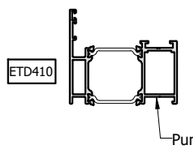


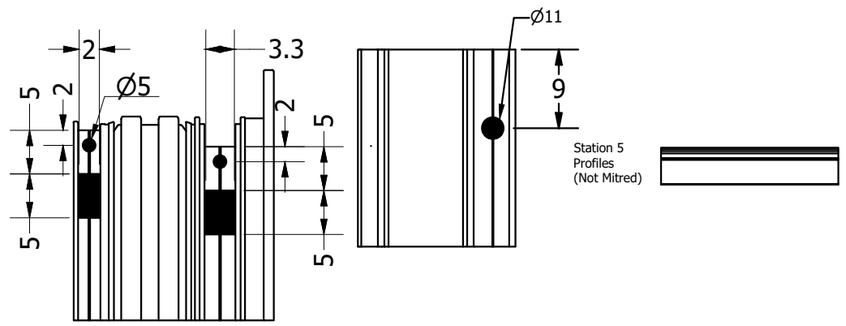


Station 5



Station 5 Profiles

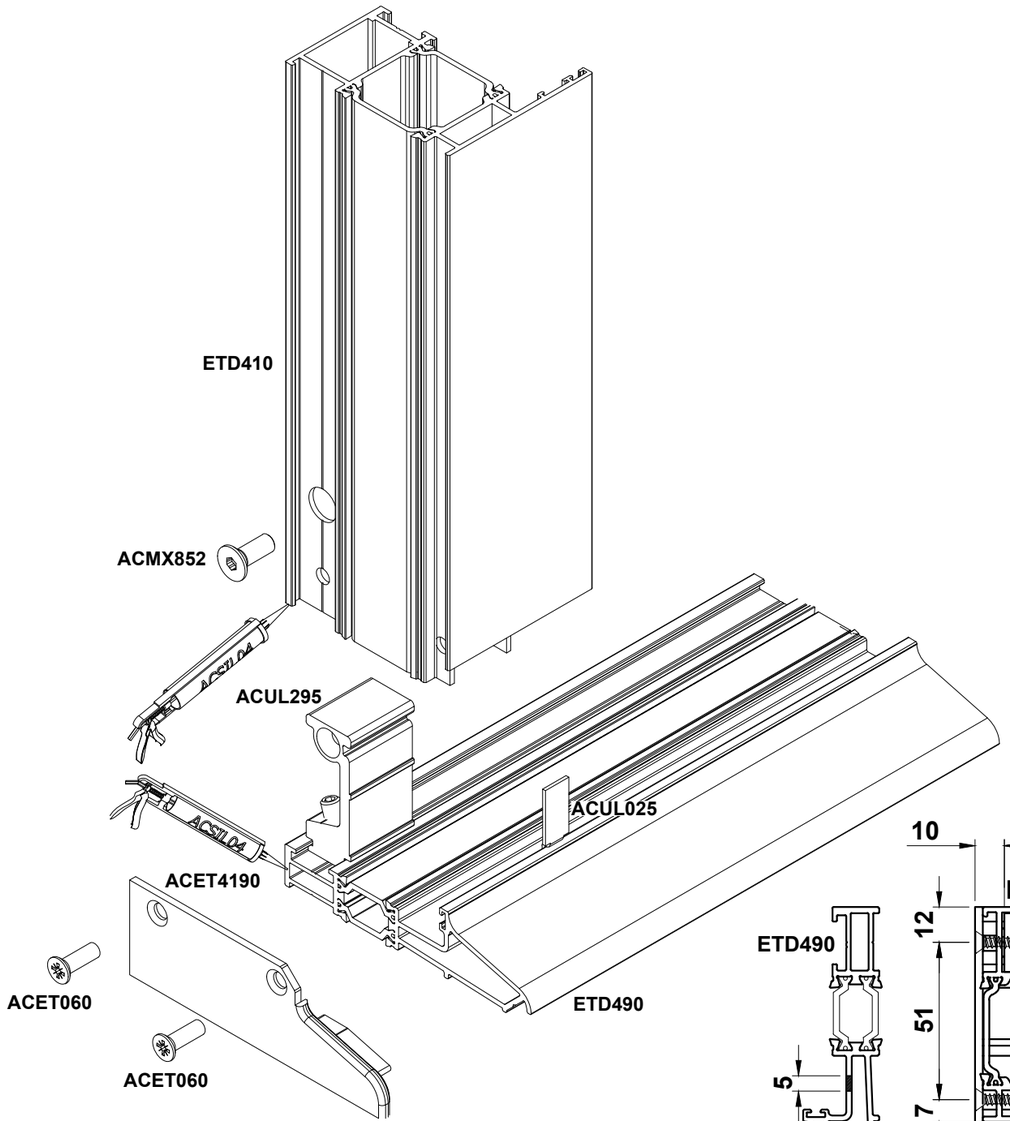


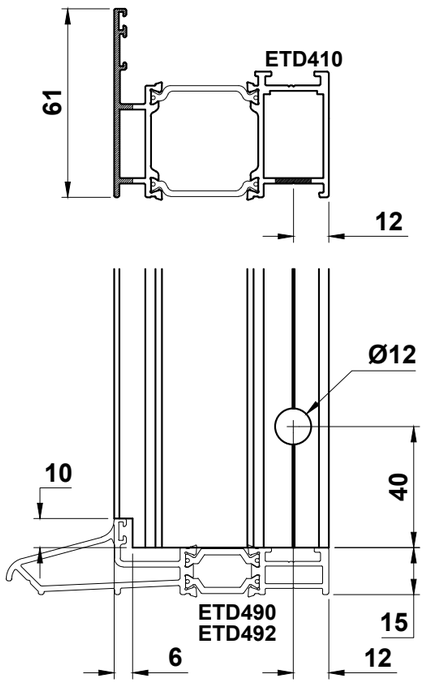


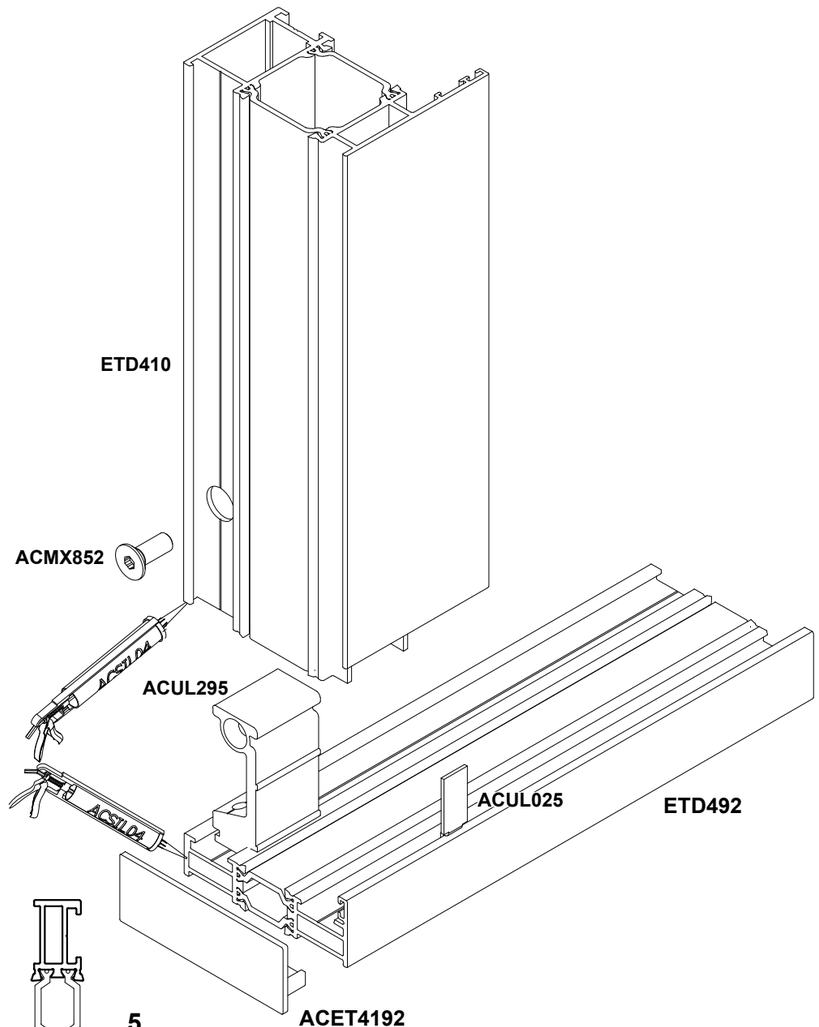
Do Not Scale From This Drawing

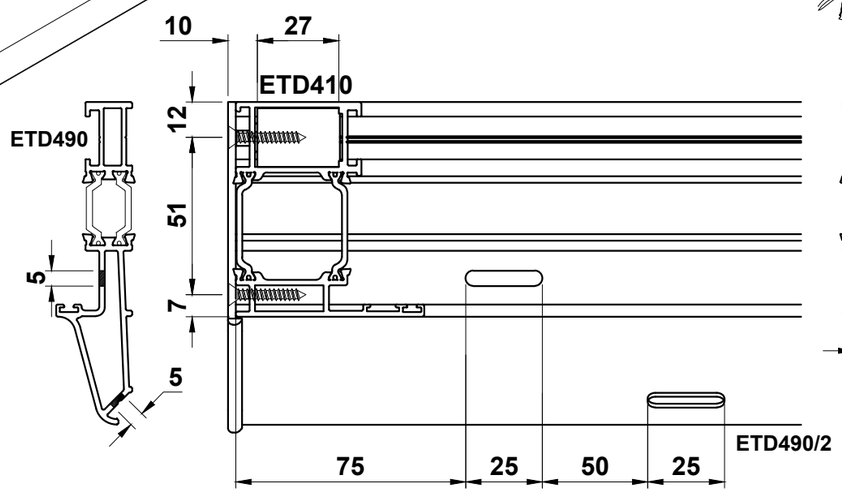
Alitherm 400 Stepped Door

Low Rebate Threshold Assembly





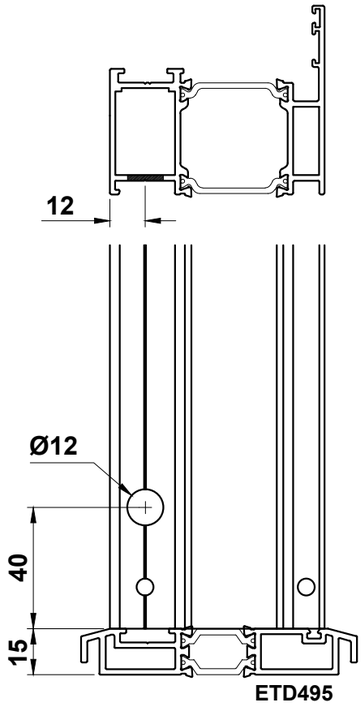


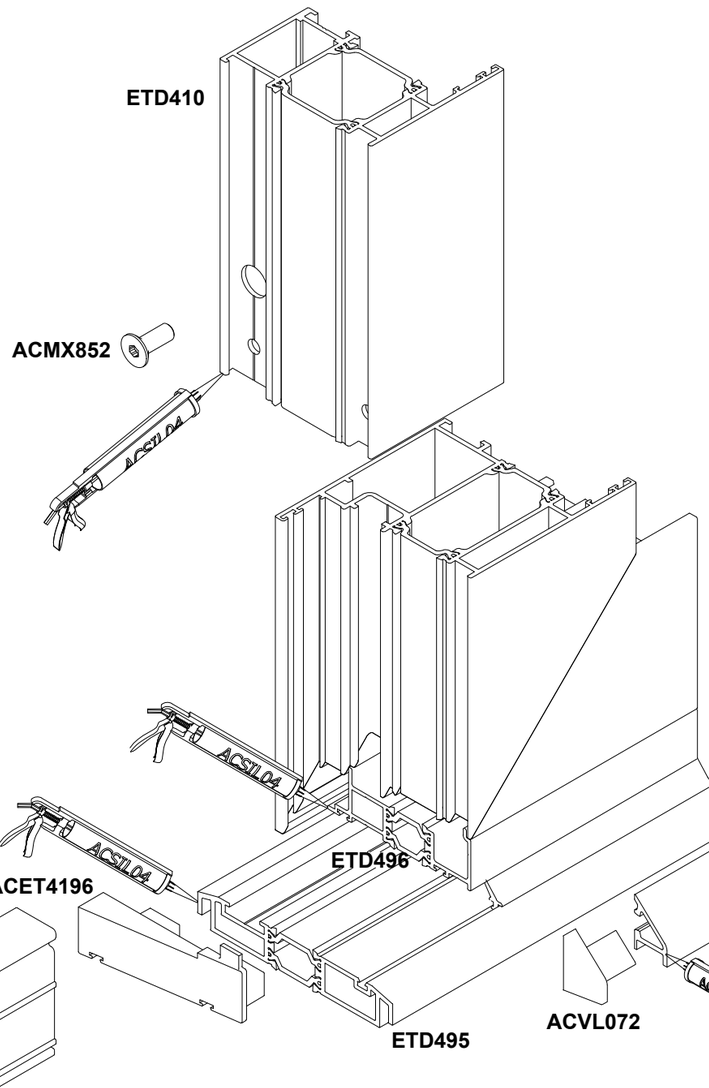


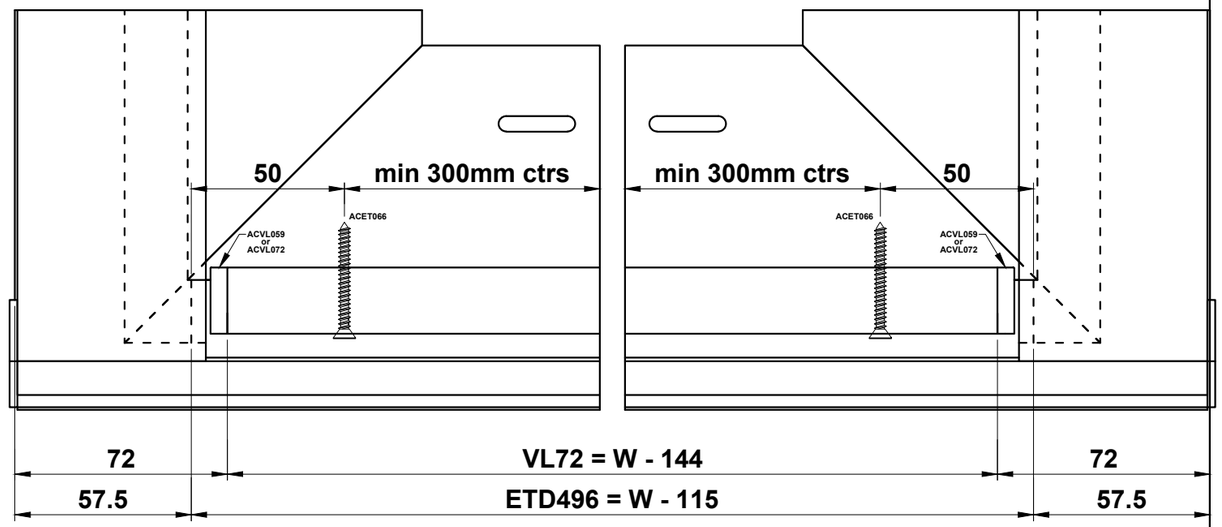
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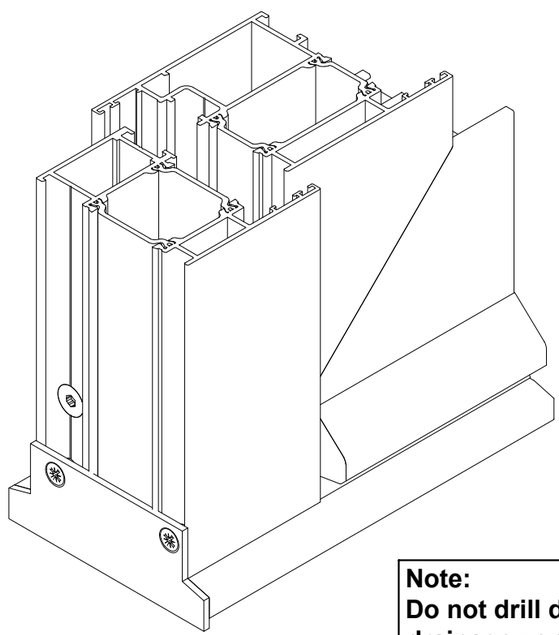
Alitherm 400 Stepped Door

Low Ramp Threshold Assembly









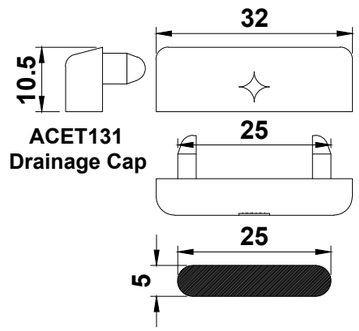
Important Note: All exposed aluminium should be coated using ACSIL014 or painted to match the frame.

Note:
Do not drill down through drainage zone for installation.

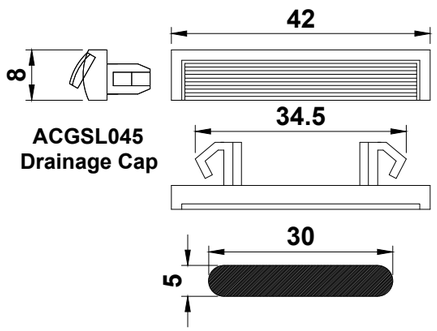
Do Not Scale From This Drawing

Drainage

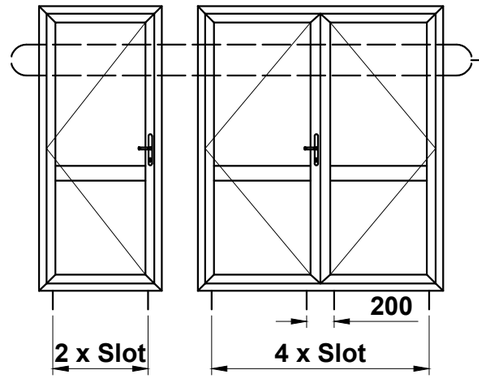
Important Note: All exposed aluminium should be coated using ACSIL014 or painted to match the frame.



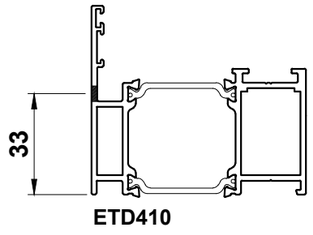
ACET131
Drainage Cap



ACGSL045
Drainage Cap

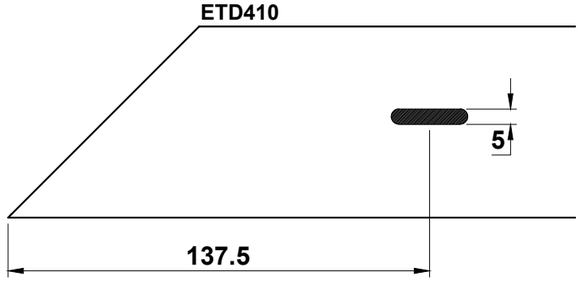


Pressure Equalization (Ø8mm Hole through polyamide)



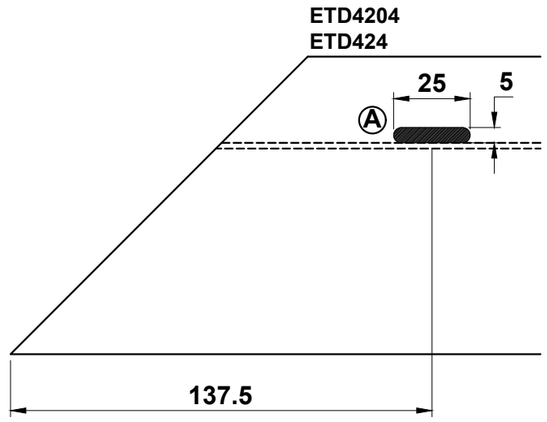
ETD410

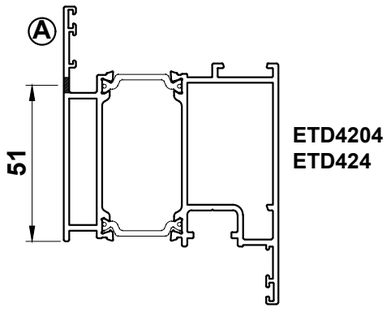
ETD410



ETD4204
ETD424

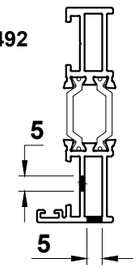
Option A



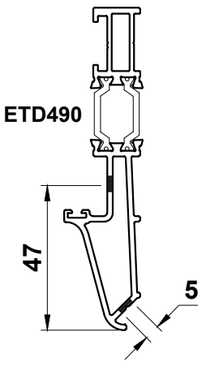


ETD4204
ETD424

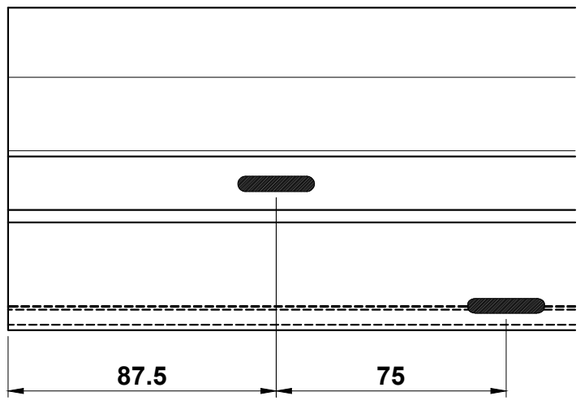
ETD492



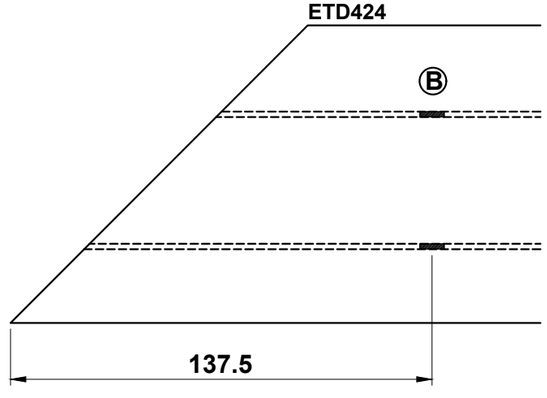
ETD490



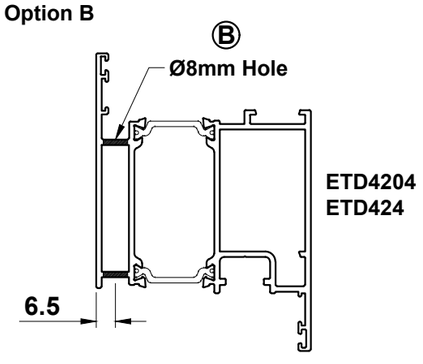
ETD490
ETD492



ETD4204
ETD424



Option B

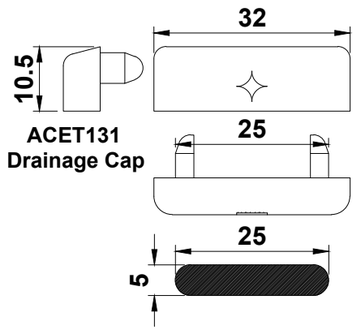


ETD4204
ETD424

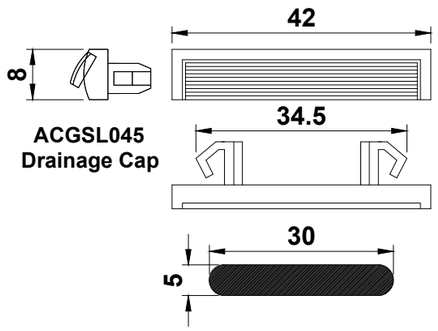
Do Not Scale From This Drawing

Drainage

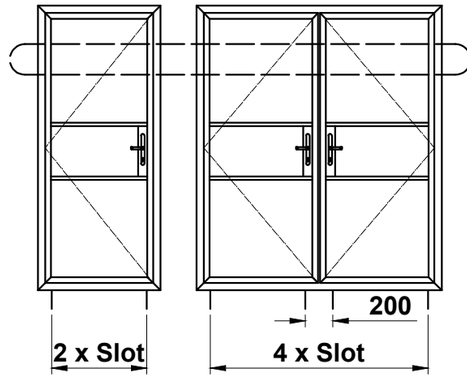
Important Note: All exposed aluminium should be coated using ACSIL014 or painted to match the frame.



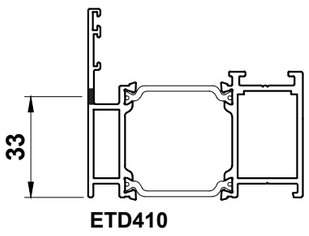
ACET131
Drainage Cap



ACGSL045
Drainage Cap

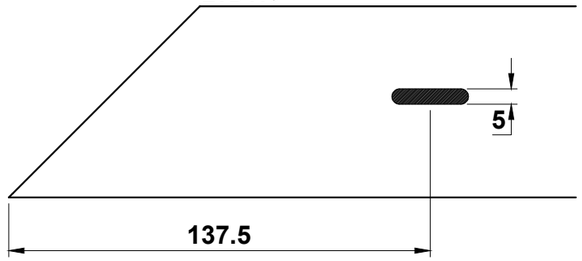


Pressure Equalization (Ø8mm Hole through polyamide)

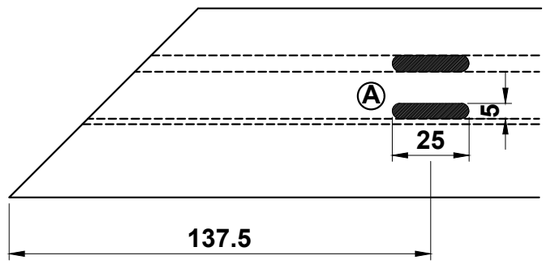


ETD410

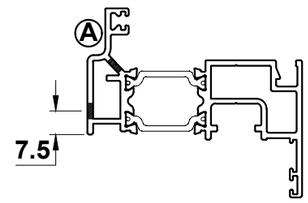
ETD410



ETD4220

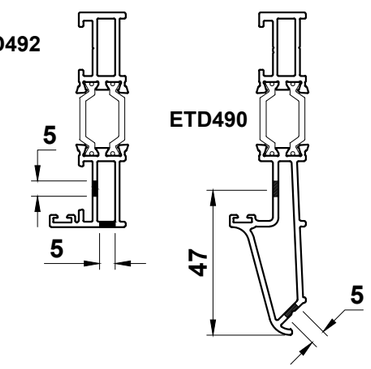


Option A

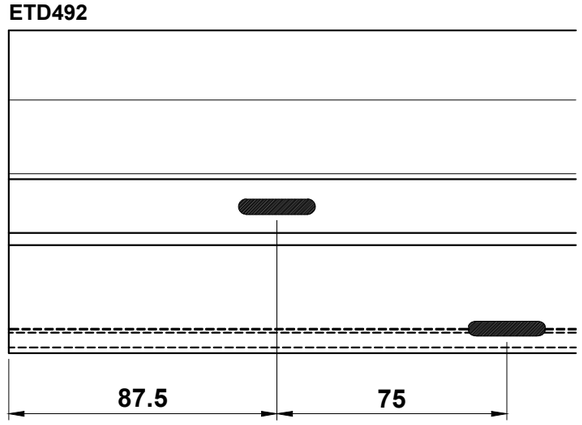


ETD4220

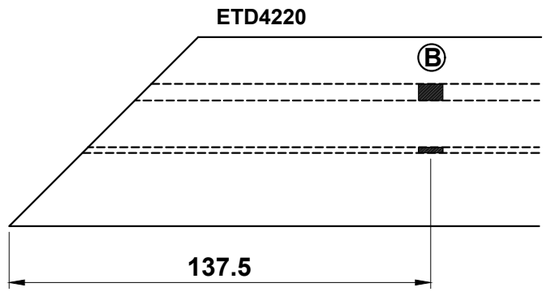
ETD492



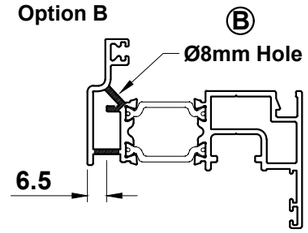
ETD490
ETD492



ETD4220



Option B



ETD4220

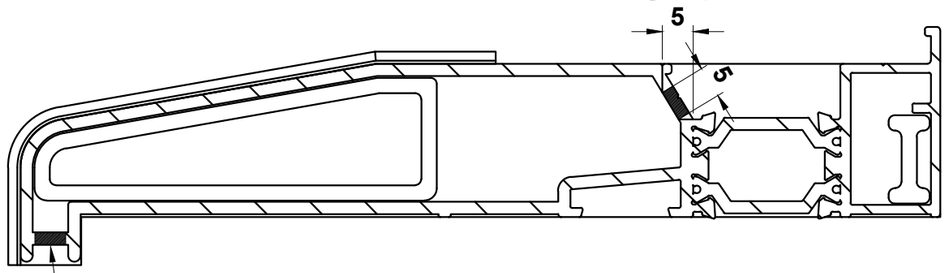
Do Not Scale From This Drawing

Alitherm 400 Stepped Door

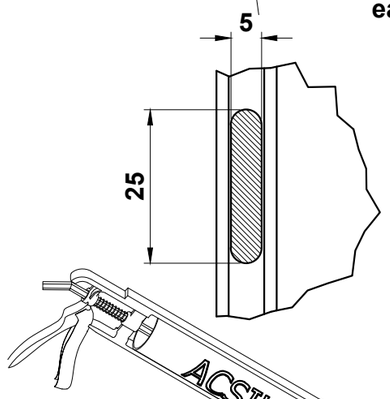
Sub Cill Drainage

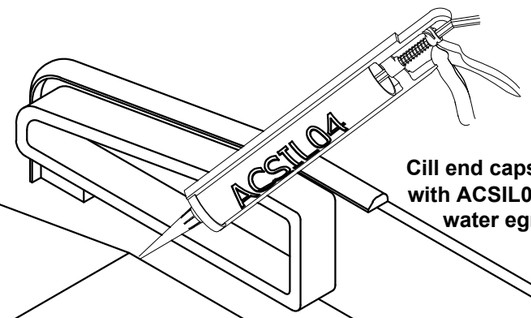
Important Note: All exposed aluminium should be coated using ACSIL014 or painted to match the frame.

Drainage Option B



Drainage holes to be spaced 100mm in from each end and at approximately 300mm centres



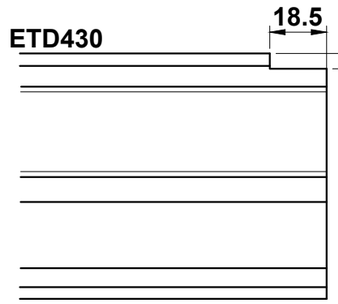


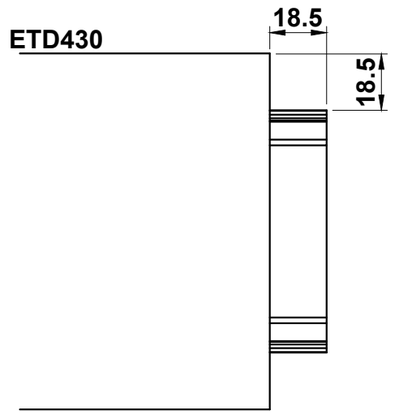
Cill end caps should be sealed with ACSIL04 to cill to prevent water egress over edge

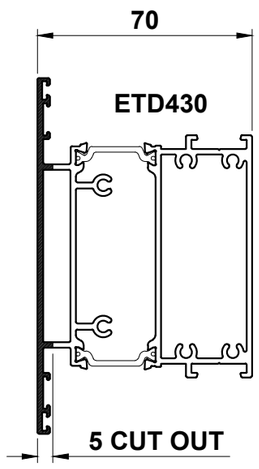
Drainage Option B

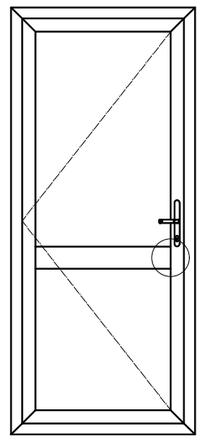
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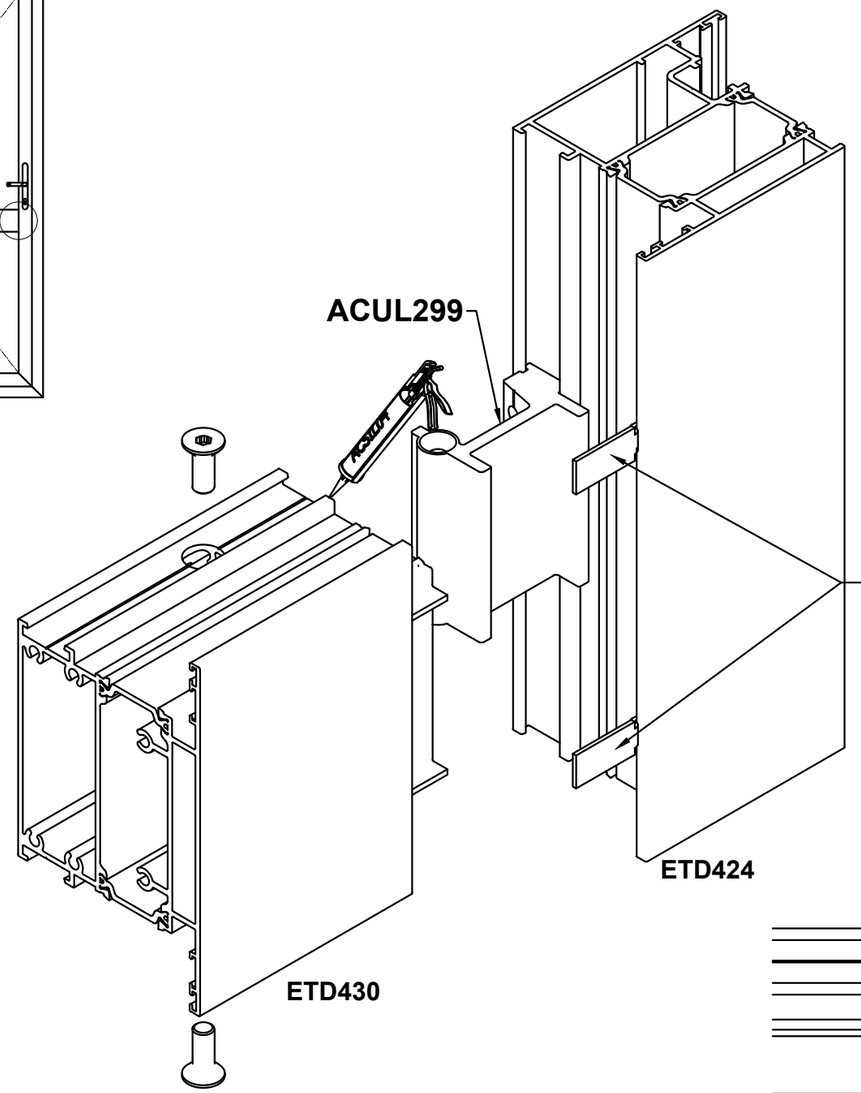
ETD430 & ETD424 Transom Assembly







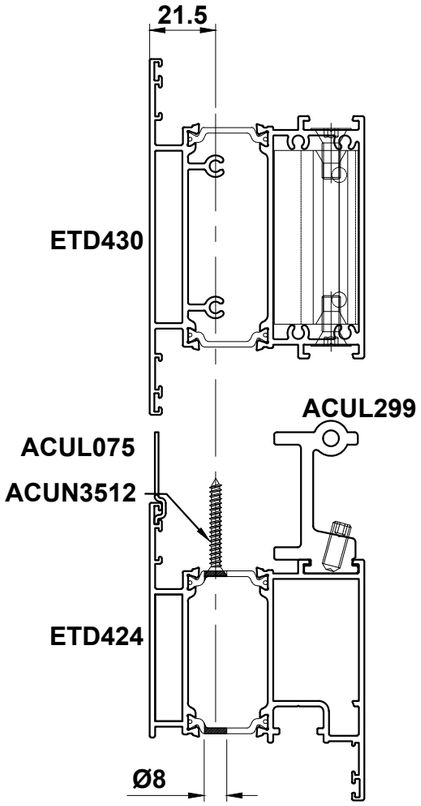






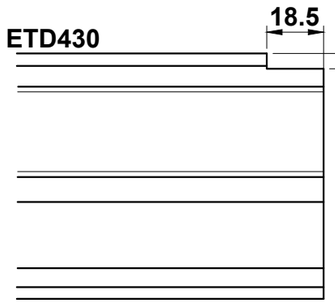


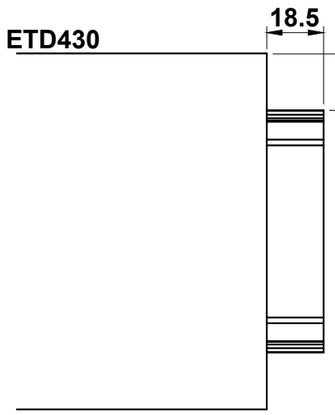
Note: 4 X ACUN3512 can be used to replace ACUL299.

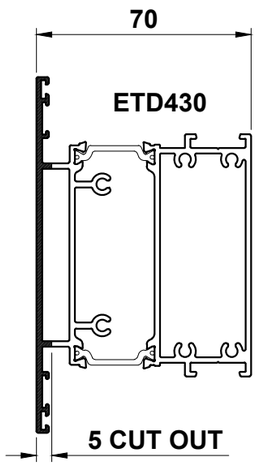


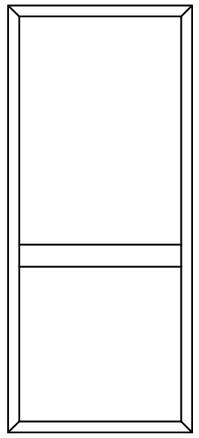
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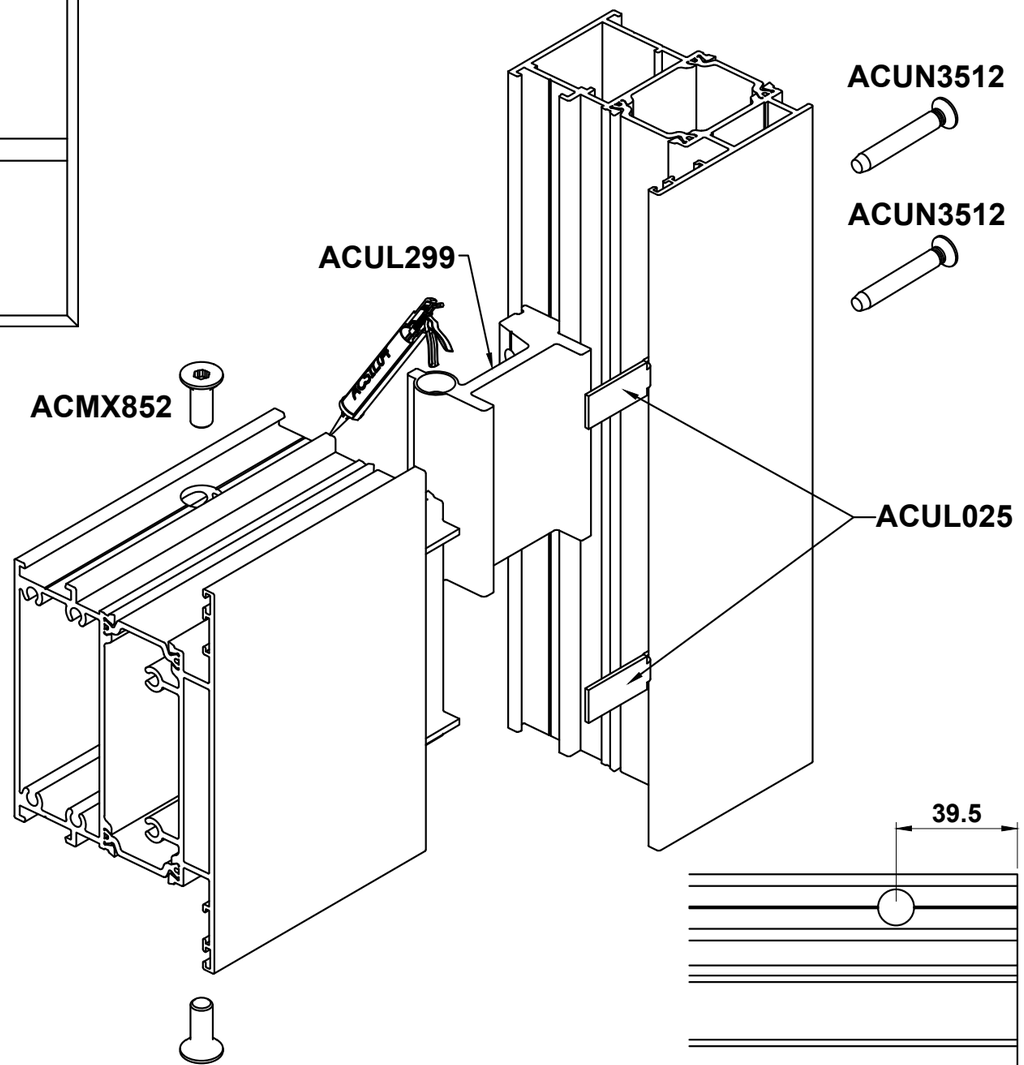
ETD430 & ETD404 Transom Assembly



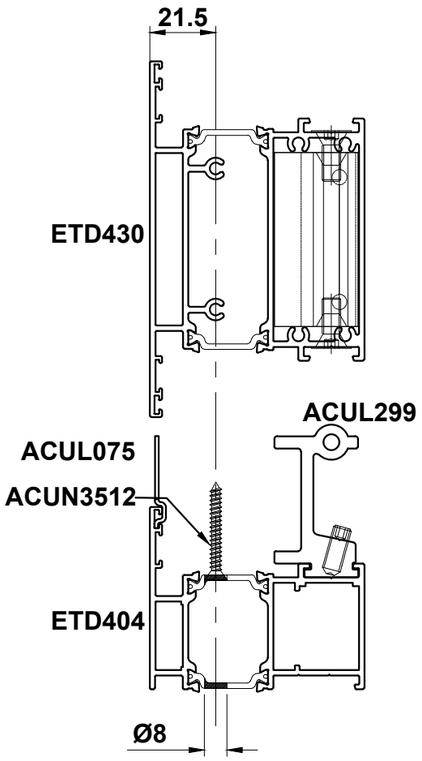






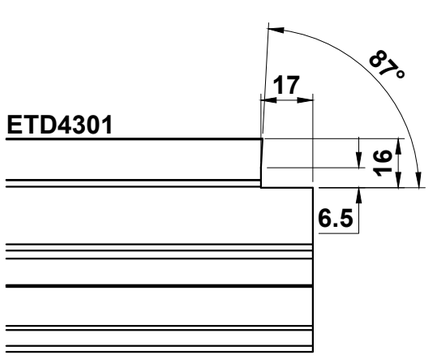


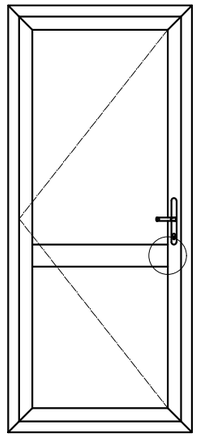
Note: 4 X ACUN3512 can be used to replace ACUL299.

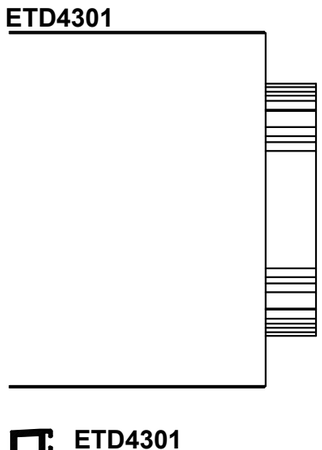


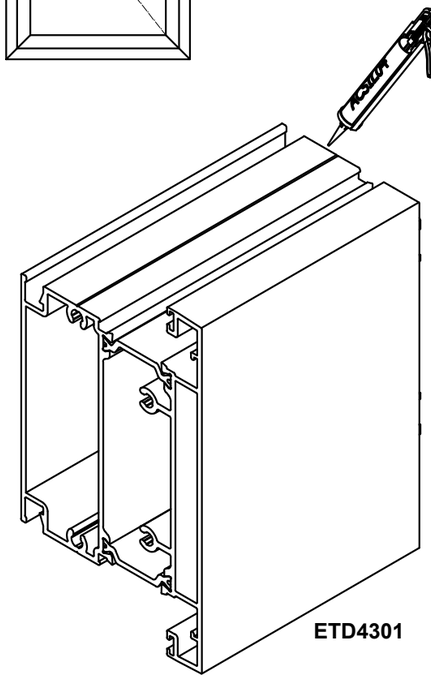
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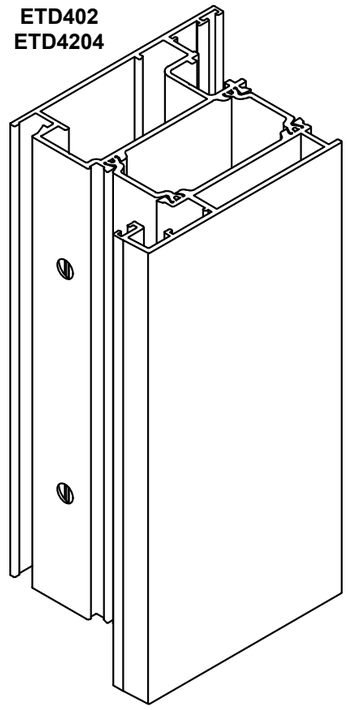
ETD4301 Transom Assembly



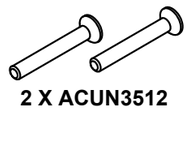


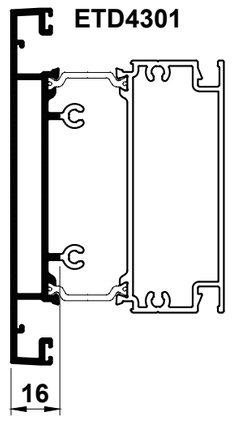


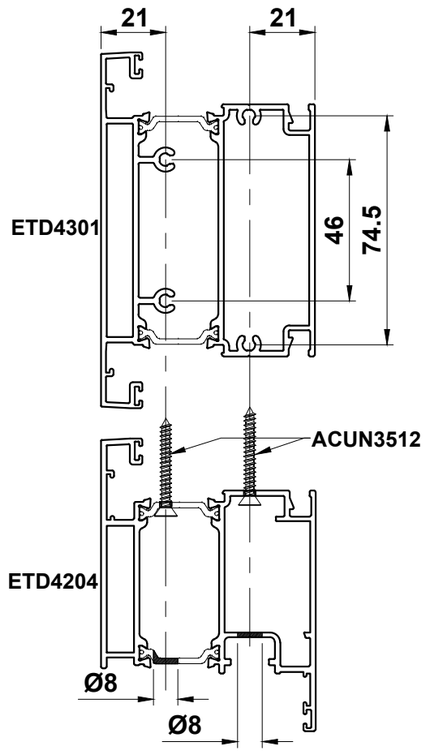


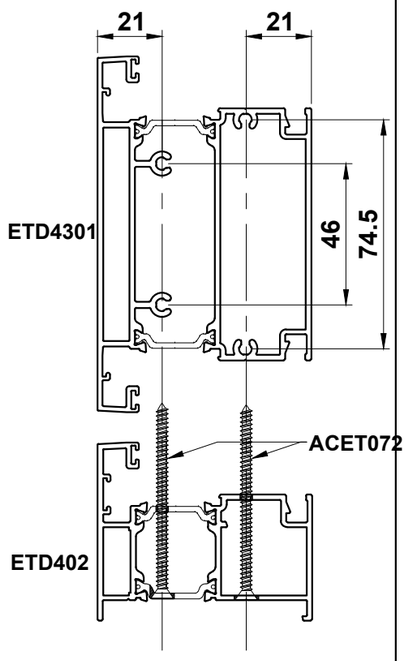










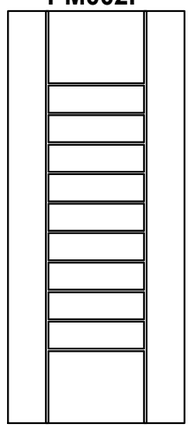


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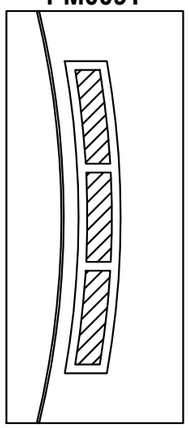
Panel Door Details

We offer a range of designs in panel doors from traditional Victorian, Georgian and Edwardian designs to contemporary chic. Here are just a select few we can offer:

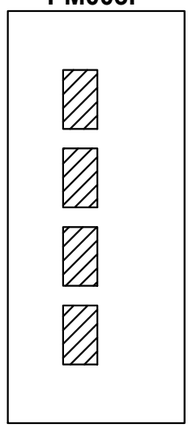
PM002P



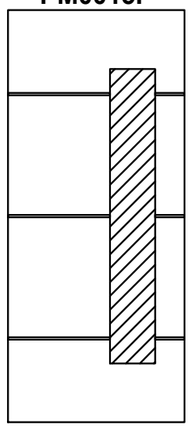
PM009T



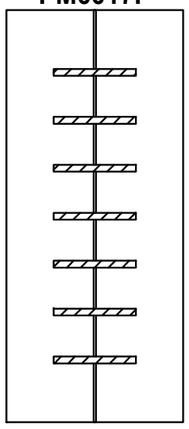
PM003P



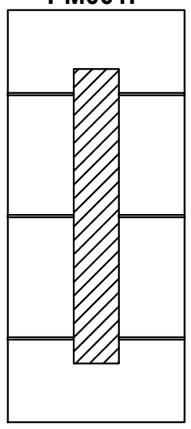
PM0015P



PM0017P



PM001P



For more information and panel designs please visit our website, www.smartsystems.co.uk or call our sales team on 01934 876100.

An overall U-value of 1.2 W/m²K may be achieved by specifying glaze-in panels. Below are the centre pane U-values and overall U-values of the examples shown:

40mm Panel Thickness

Panel Number	CP U-Value (W/m2K)	Door U-Value (W/m2K)
PM002P	0.8	1.2
PM009T	0.9	1.3
PM003P	0.9	1.3
PM0015P	0.9	1.3
PM0017P	0.9	1.3
PM001P	0.9	1.3

32mm Panel Thickness

Panel Number	CP U-Value (W/m2K)	Door U-Value (W/m2K)
PM002P	1.0	1.4
PM009T	1.1	1.4
PM003P	1.1	1.4
PM0015P	1.1	1.4
PM0017P	1.1	1.4
PM001P	1.1	1.4

28mm Panel Thickness

Panel Number	CP U-Value (W/m2K)	Door U-Value (W/m2K)
PM002P	1.1	1.4
PM009T	1.2	1.5
PM003P	1.2	1.5
PM0015P	1.2	1.5
PM0017P	1.2	1.5
PM001P	1.2	1.5

Do Not Scale From This Drawing

Door Locking & SZ Hardware Options

Slam Lock Guide (Internal Lever Handle Only)

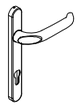
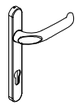
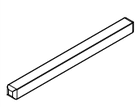
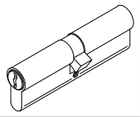
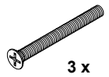
Overall Sash Height	Spindle Height (X)	Kit Part Number	
		Left Hand	Right Hand
2030-2230 (Standard)	1050	ACUL280	ACUL281
1820-2029 (Short)	1050	ACUL360	ACUL361
2231-2450 (Tall)	1050	ACUL380	ACUL381

Note: Height limits apply to all threshold options.

Key Operated Lock Guide

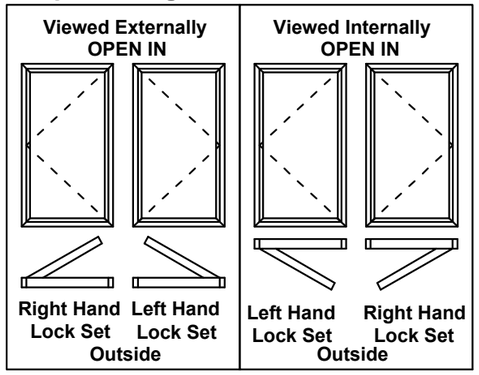
Overall Sash Height	Spindle Height (X)	Kit Part Number	
		Left Hand	Right Hand
2030-2230 (Standard)	1050	ACUL282	ACUL283
1820-2029 (Short)	1050	ACUL362	ACUL363
2231-2450 (Tall)	1050	ACUL382	ACUL383

Handle With Large Backplate Guide

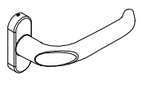
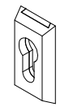
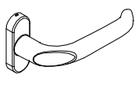
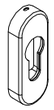
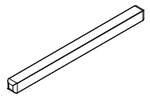
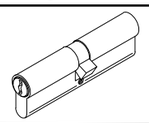
Ext. Handle	Int. Handle	Spindle	Cylinder	Screw	Screw	Rivnuts
				 3 x	 3 x	 3 x
ACSZ800	ACSZ801	ACMX409Sq. Spindle 150mm	--	ACMX861 M5 x 75mm	--	--
	ACSZ803		ACCY0035 Half Cylinder			
	ACSZ830 T					
ACSZ802	ACSZ803		ACCY6035S3 35/60 Cylinder		--	--
	ACSZ830 T					
ACSZ400 + 2 x ACVS061	ACSZ803	ACMX008 Sq. Spindle 60mm	ACCY6035S3 35/60 Cylinder	ACVS061 M5 x 40mm	--	--
	ACSZ830 T					
--	ACSZ803	ACMX008 Sq. Spindle 60mm	*ACCY6035S3 35/60 Cylinder	--	WCA134 M5 x 20mm	ACUN3509 M5
	ACSZ830 T					

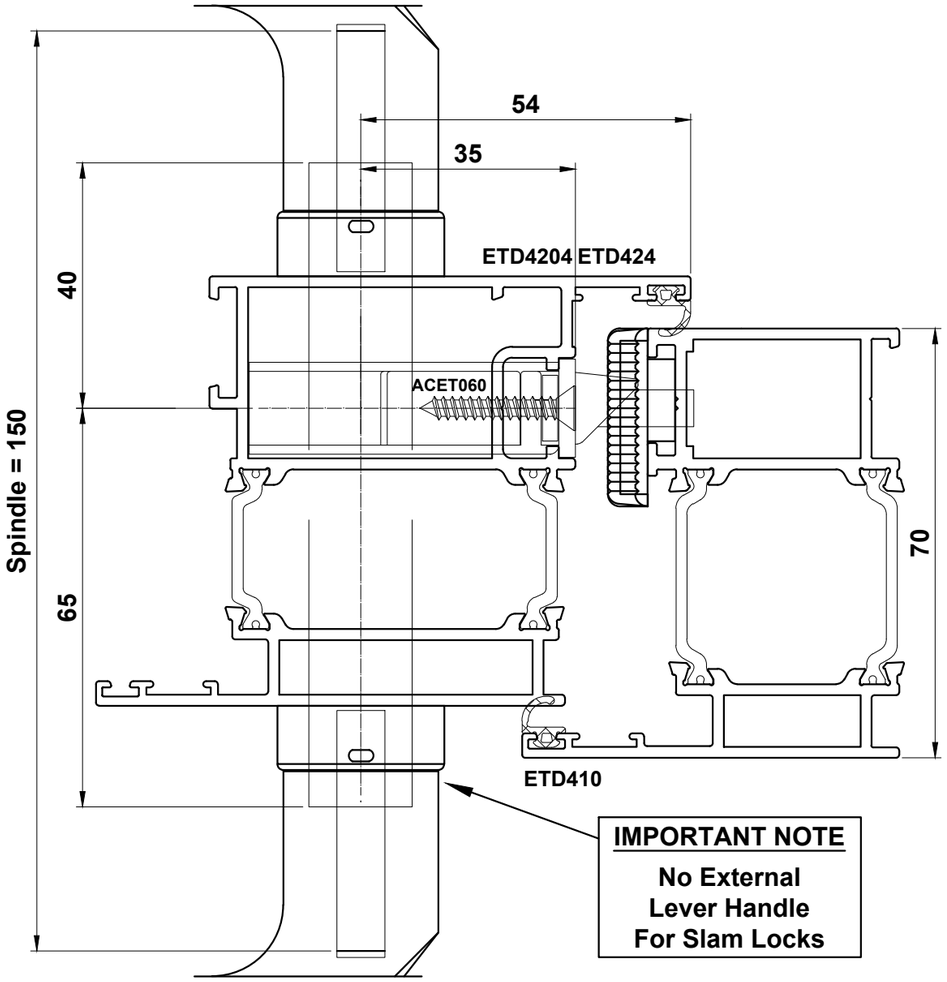
*Use with Ext. Ecutcheon

Keep Handing Guide



Handle with Small Backplate Guide

Ext. Handle	Ext. Escutcheon	Int. Handle	Int. Escutcheon	Spindle	Cylinder	Screw	Rivnuts
							
ACSZ837	ACSZ400	ACSZ836	ACSZ839	ACMX409Sq. Spindle 150mm	ACCY6035S3	WCA134 M5 x 20mm	ACUN3509 M5
					ACCY0035		
	ACSZ400			ACMX008 Sq. Spindle 60mm	ACCY6035S3	WCA134 M5 x 20mm	ACUN3509 M5
					ACCY0035		
ACSZ837	ACSZ400	ACSZ827 T		ACMX409Sq. Spindle 150mm	ACCY6035S3	WCA134 M5 x 20mm	ACUN3509 M5
					ACCY0035		



IMPORTANT NOTE
No External Lever Handle For Slam Locks

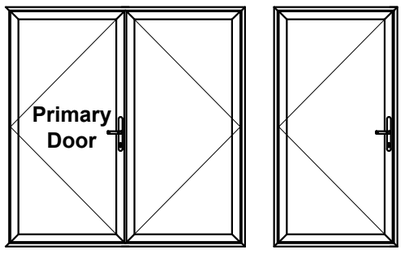
With Cylinder
Without Cylinder
T Handle With Cylinder
T Handle Without Cylinder

Note:
Please check kitemark for all suitable hardware to achieve PAS24.

Do Not Scale From This Drawing

Lock Overview of Single and Double Doors

Finger Bolt Locking Options



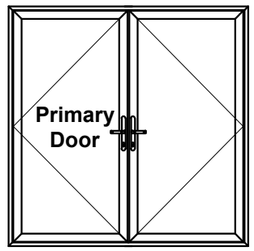
Single & Primary Door Lock Selection

Overall Sash Height	Lift Lever		Slam Lock **		Key Wind	
	Left	Right	Left	Right	Left	Right
2030-2230 (Standard)	ACUL272	ACUL273	ACUL280	ACUL281	ACUL282	ACUL283
1820-2029 (Short)	ACUL377	ACUL378	ACUL360	ACUL361	ACUL362	ACUL363
2231-2450* (Tall)	ACUL374	ACUL375	ACUL380	ACUL381	ACUL382	ACUL383

Secondary Door Accessory Selection

35mm Backset Shootbolt Adaptor	Bottom 10mm Dia Rod	Top 10mm Dia Rod		Keep	Shootbolt Guide
		Overall FRAME Size	Rod Part No.		
ACPD844 	ACPD846 (1000mm)	1820 - 1923	ACPD846 (1000mm)	ACUL390 (2 Required)	ACUL242 (2 Required)
		1923 - 2173	ACPD847 (1250mm)		
		2174 - 2423*	ACPD848 (1500mm)		
		*For doors above 2423mm, use ACPD849 (2000mm)			

Lift Lever Locking Options

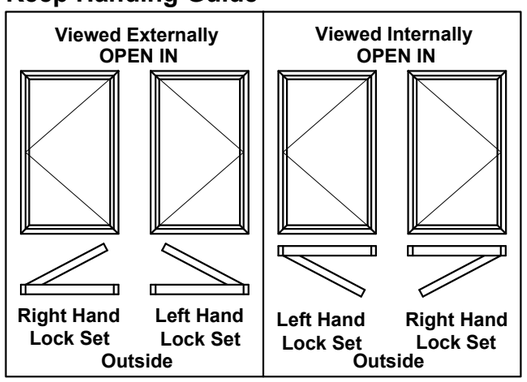


Double Handle Lift Lever Lock Option

Overall Sash Height	Primary Door Lift Lever		Secondary Door Lift Lever	Double Door Keep	Shootbolts	Shootbolt Extensions
	Left	Right				
1885-2450*	ACUL277	ACUL278	ACUL276	ACUL279	ACDV737 ACDV738	ACDV742 ACDV744

*Any doors above 2450mm are above the tested limit.
**Please see page E31 for shootbolt layout.

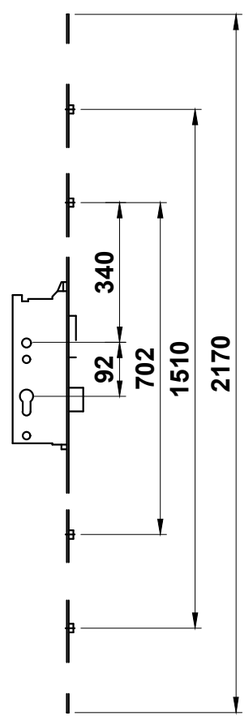
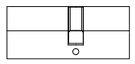
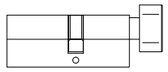
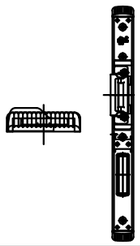
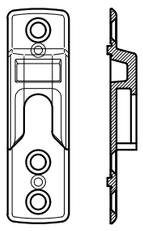
Keep Handing Guide

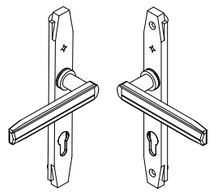
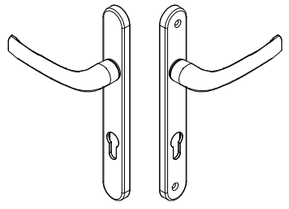
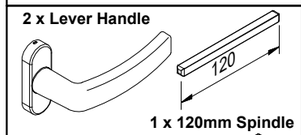
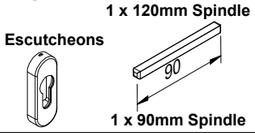
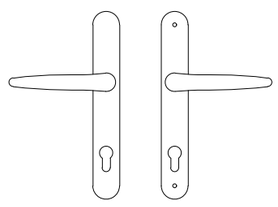
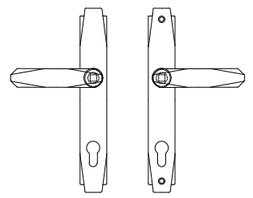


For ACUL267 & 268 Cam Lock Option Refer To Page E40

Do Not Scale From This Drawing

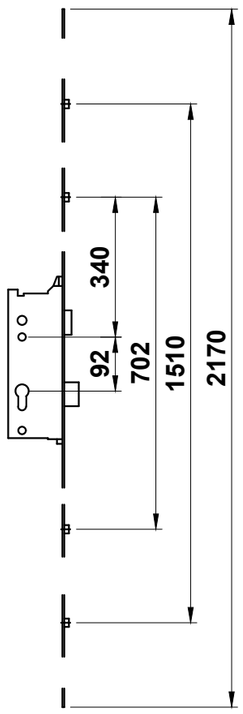
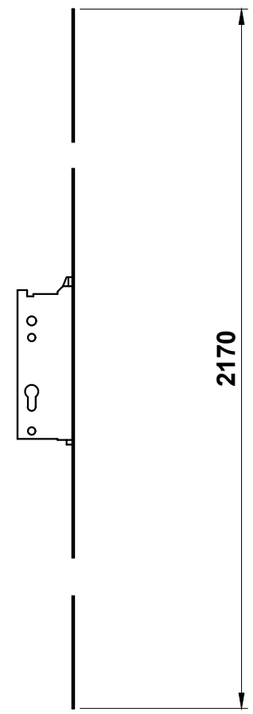
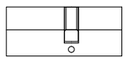
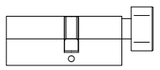
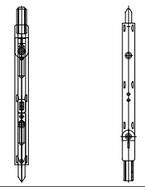
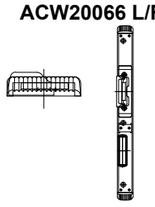
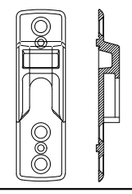
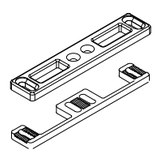
Heritage Single Door Hardware Options

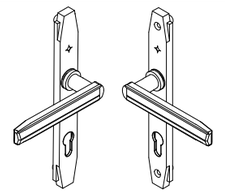
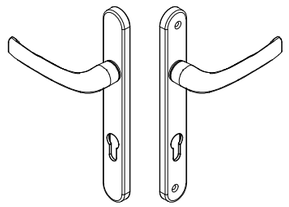
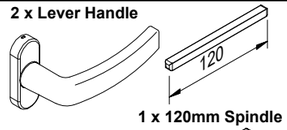
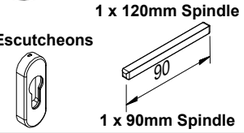
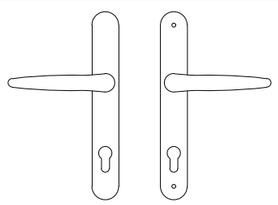
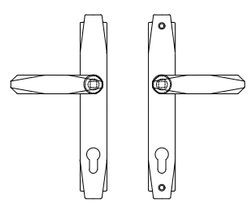
Lock	Accessories	Quantity
ACW20465 	ACCY4535S1 	1
	ACCY4535TTS1 	
	ACW20066 L/R 	1
	ACW20367 	4

Handles		Quantity
	**ACSM001N** Art Deco Lever/Lever Door Handle	1 Pair
	**ACSM060** Heritage Lever/Lever Handle	
2 x Lever Handle  1 x 120mm Spindle 2 x Escutcheons  1 x 90mm Spindle	**ACSM095** Suitable With Lift Lever Addtional Parts: HEA132 - M5 x 16mm ACUN3509 - M5 Rivnut	
	**ACW20261** Standard Lever/Lever Handle Fixing kit supplied	
	**ACW20062** Art Deco Lever / Lever Handle Available in Antique Brass and Satin Nickel Plate	

Do Not Scale From This Drawing

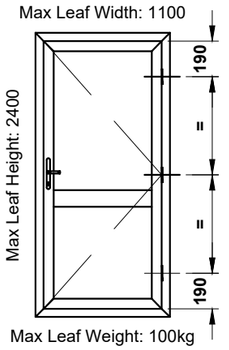
Heritage Double Door Hardware Options

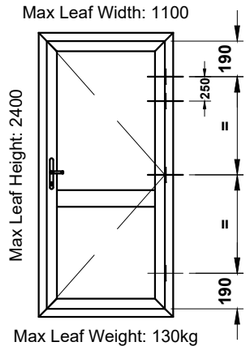
Lock		Accessories	Quantity
ACW20465 	ACW20466 	ACCY4535S1 	2
		ACCY4535TTS1 	
		ACDV737/ACDV738 	2 / 2
		ACW20066 L/R 	1
		ACW20367 	4
		ACUL279 	2

Handles		Quantity
	**ACSM001N** Art Deco Lever/Lever Door Handle	2 Pair
	**ACSM060** Heritage Lever/Lever Handle	
2 x Lever Handle  1 x 120mm Spindle 2 x Escutcheons  1 x 90mm Spindle	**ACSM095** Suitable With Lift Lever Addtional Parts: HEA132 - M5 x 16mm ACUN3509 - M5 Rivnut	
	**ACW20261** Standard Lever/Lever Handle Fixing kit supplied	
	**ACW20062** Art Deco Lever / Lever Handle Available in Antique Brass and Satin Nickel Plate	

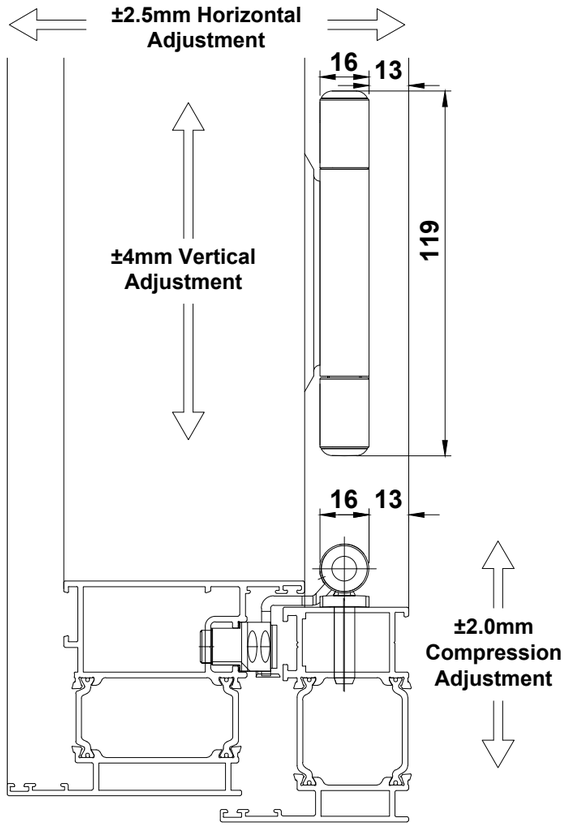
Do Not Scale From This Drawing

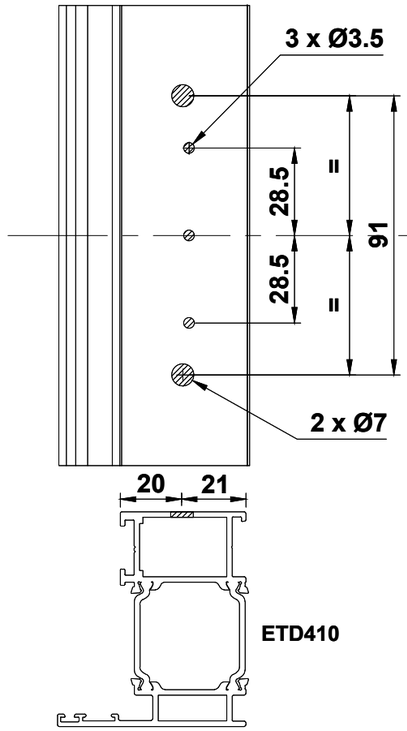
ACUL250 Hinge Preparation

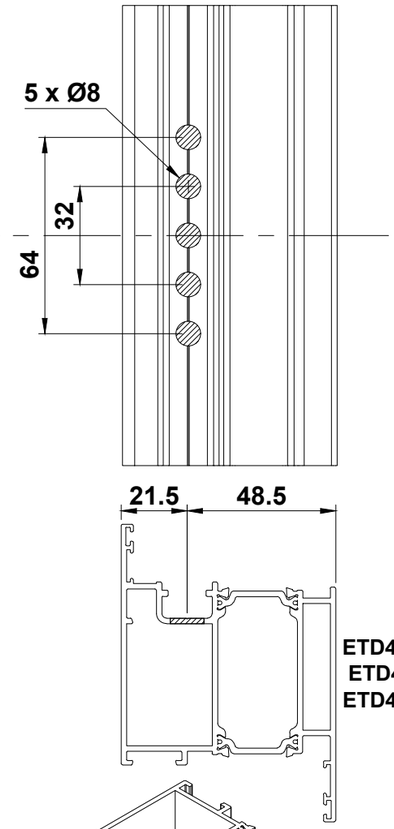


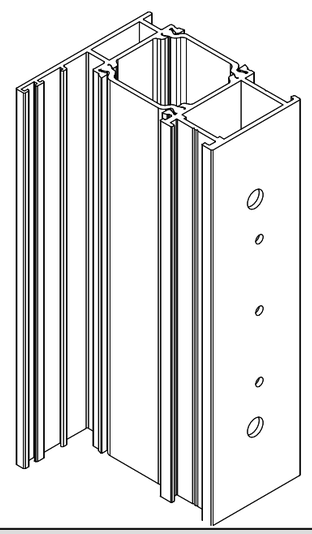


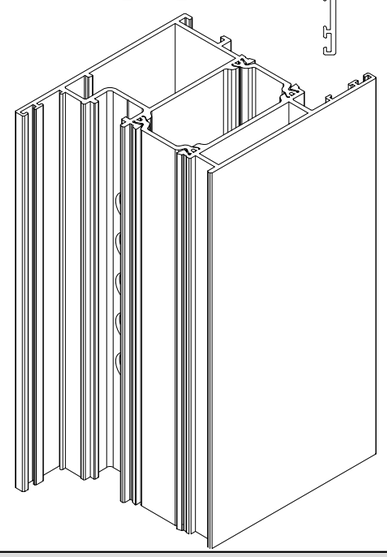
Surface Fixed Closers - Hinge Load Calculation	
Without Backcheck Increase door weight by 20%	**With Backcheck** Increase door weight by 75%
Example: (Glass Weight = 44kg) + 20% = 53kg	Example: (Glass Weight = 44kg) + 75% = 77kg









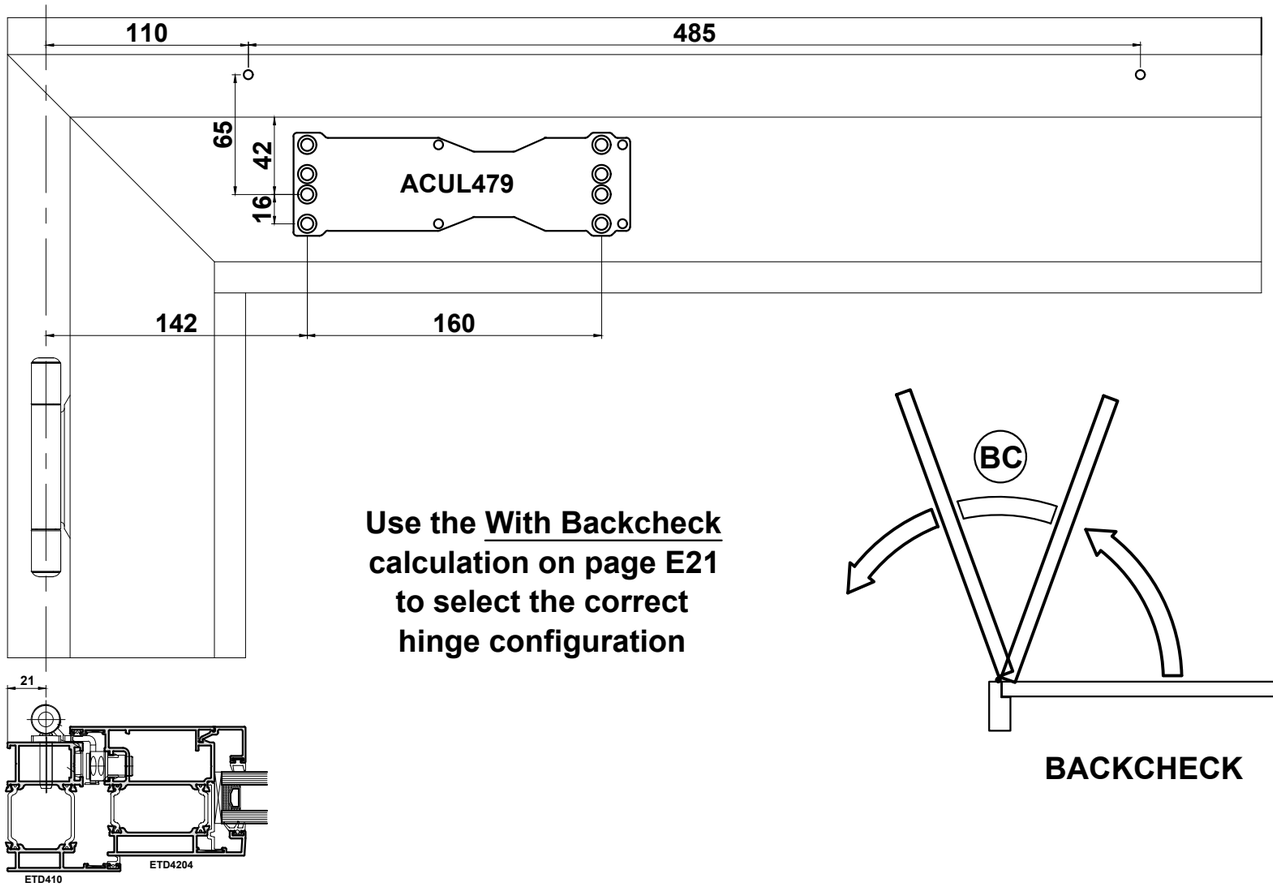


Fitting Instructions:
(Full instructions are supplied with each ACUL250 Hinge)

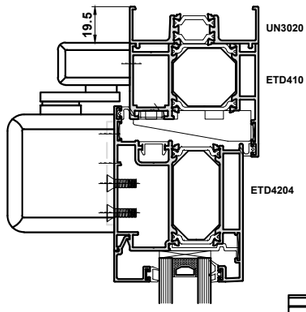
1. Align outer frame and sash in correct position
2. Clamp drill jig ACUL950 over the centre line of the hinge
3. Drill through all bushes marked '1' with a Ø7.2mm drill bit (supplied) and through all bushes marked '2' with a Ø3.5mm drill bit (not supplied)
4. Fasten the sash plate using ACIM062
5. Fasten the frame plate using ACUN3512 screws ensuring the grub screws are positioned towards the door sash
6. Drive in the central barrel until it lines up with the rings on the frame plate
7. Drive in pin 'B' to the top of the hinge and then drive in pin 'A' to the bottom of the hinge
8. Open the door and lightly tighten the security screws
9. Adjust hinge as required then insert caps and cover caps.

Do Not Scale From This Drawing

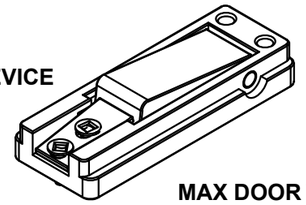
ACUL478 Surface Fixed Closer & Slide Arm - Open In



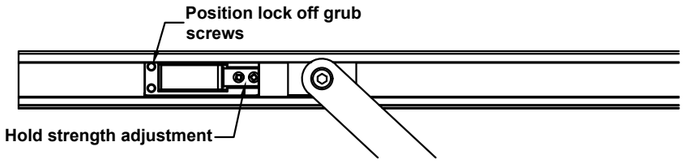
Use the With Backcheck calculation on page E21 to select the correct hinge configuration



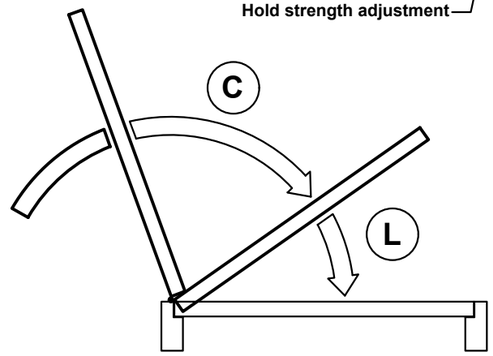
ACUL480
HOLD OPEN DEVICE



MAX DOOR WEIGHT 80KG



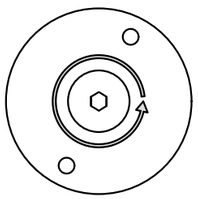
BACKCHECK

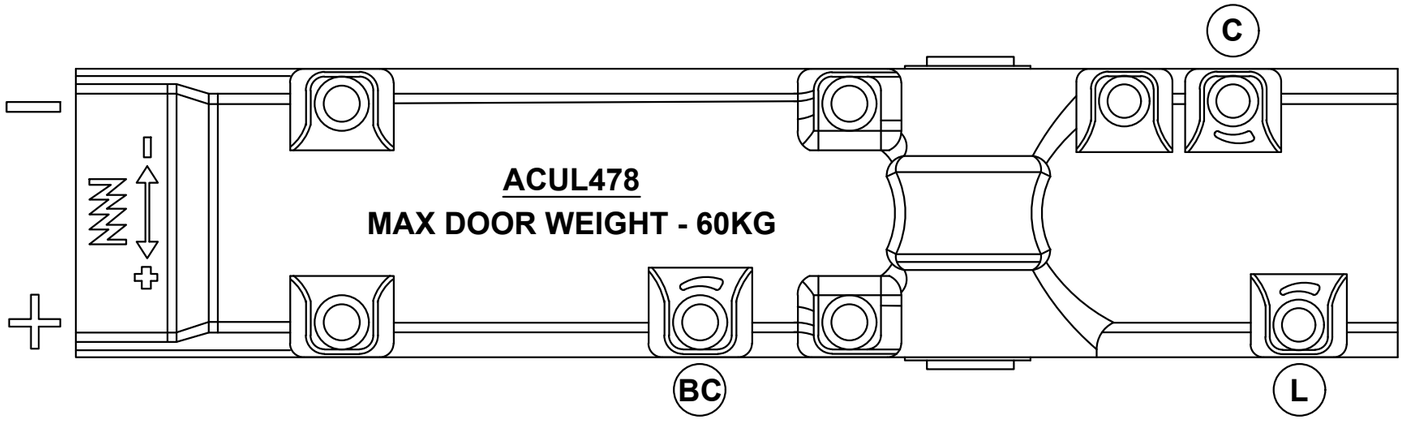


CLOSING SPEED

Size	Leaf Width	Full Turn
	Min	-7
EN1	< 750mm	-5
EN2	< 850mm	-3
EN3	< 950mm	0*
EN4	< 1100mm	+3

*** Factory Setting**



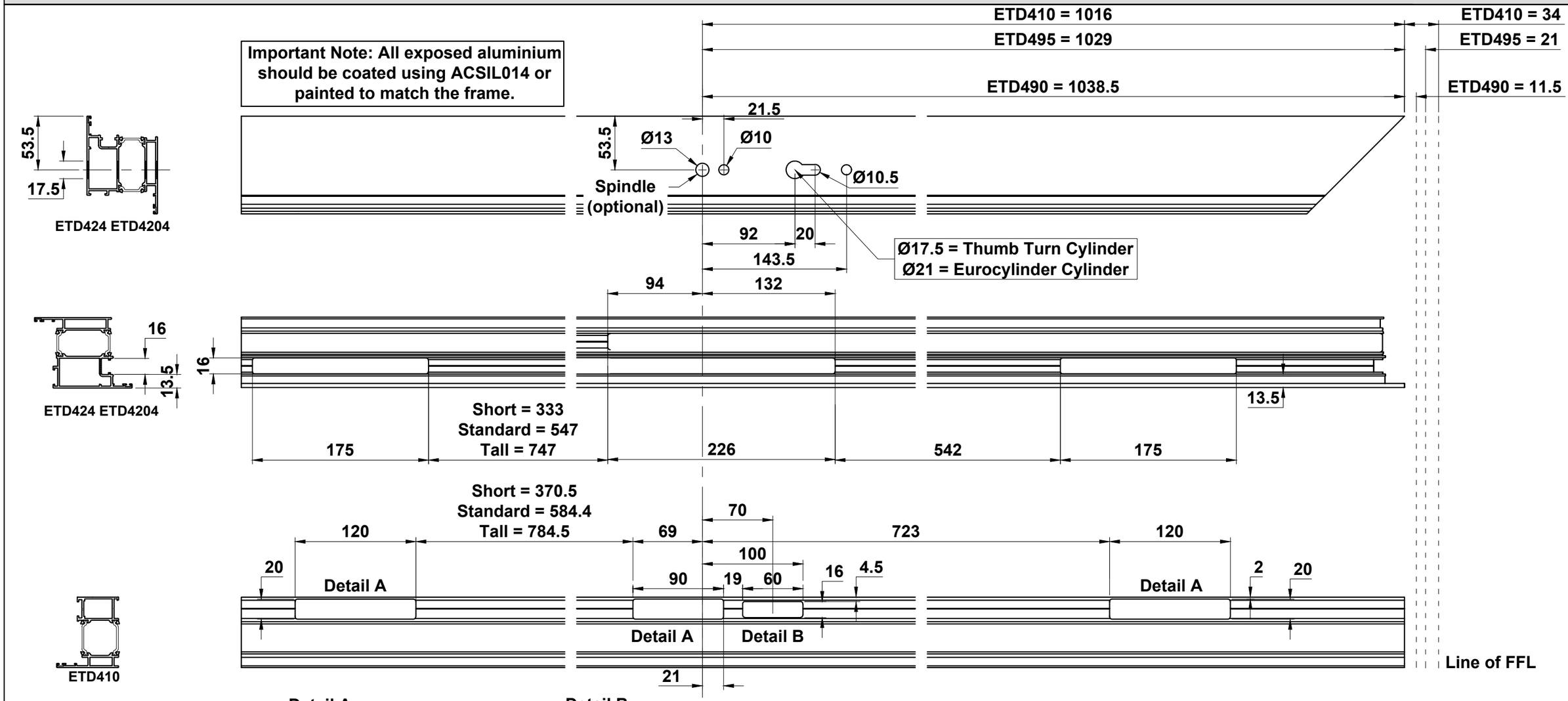


Please consult Technical Support for doors beyond these limitations.

Do Not Scale From This Drawing

Alitherm 400 Stepped Door

Single Door Lock Preparation



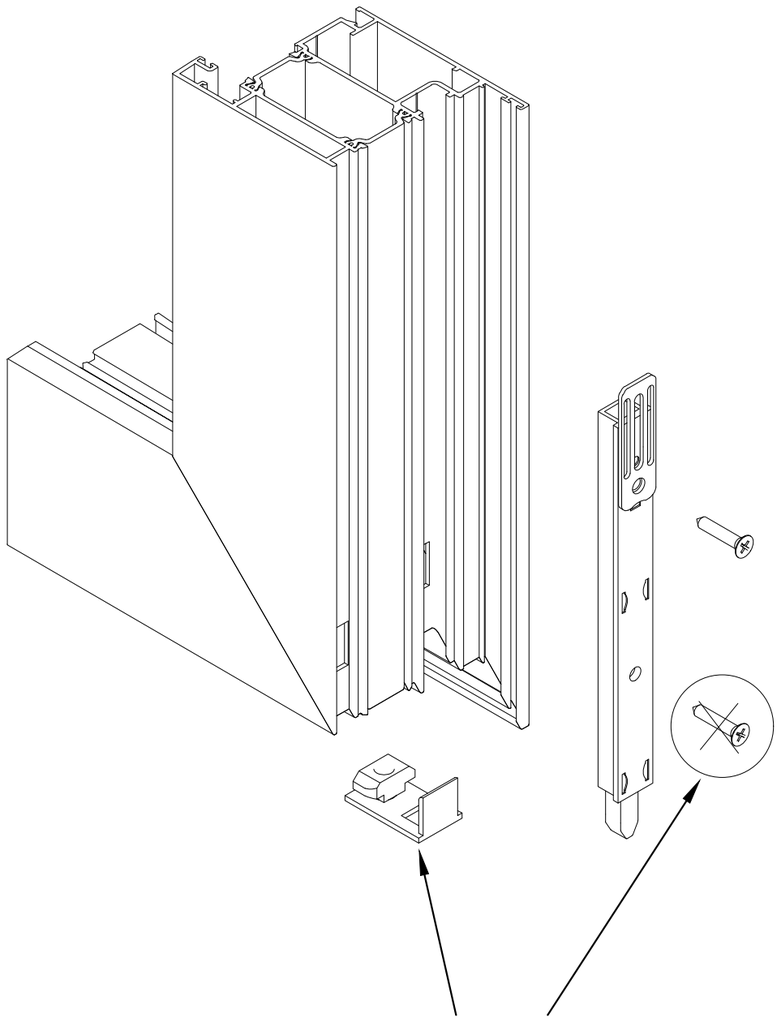
Lock Kits

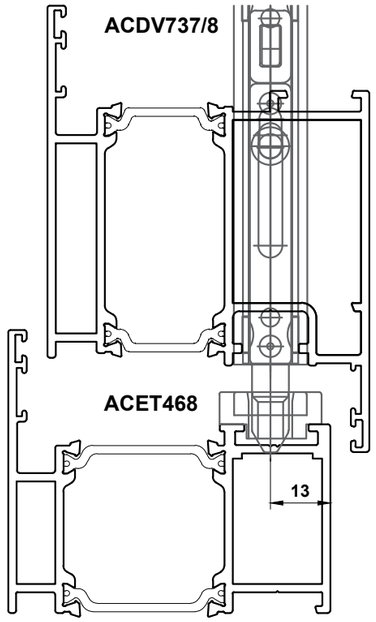
	Slam Lock		Key Wind		Lift Lever	
Height	Left Hand	Right Hand	Left Hand	Right Hand	Left Hand	Right Hand
Short	ACUL360	ACUL361	ACUL362	ACUL363	ACUL377	ACUL378
Standard	ACUL280	ACUL281	ACUL282	ACUL283	ACUL272	ACUL273
Tall	ACUL380	ACUL381	ACUL382	ACUL383	ACUL374	ACUL375

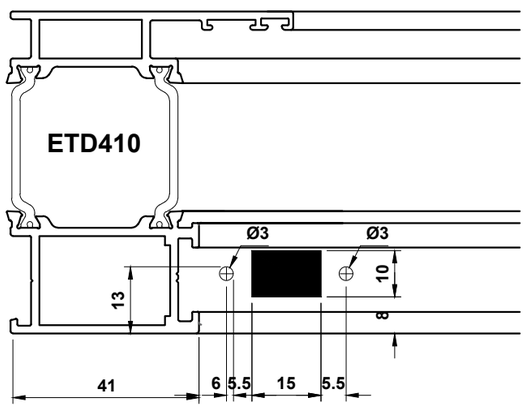
Do Not Scale From This Drawing

Alitherm 400 Stepped Door

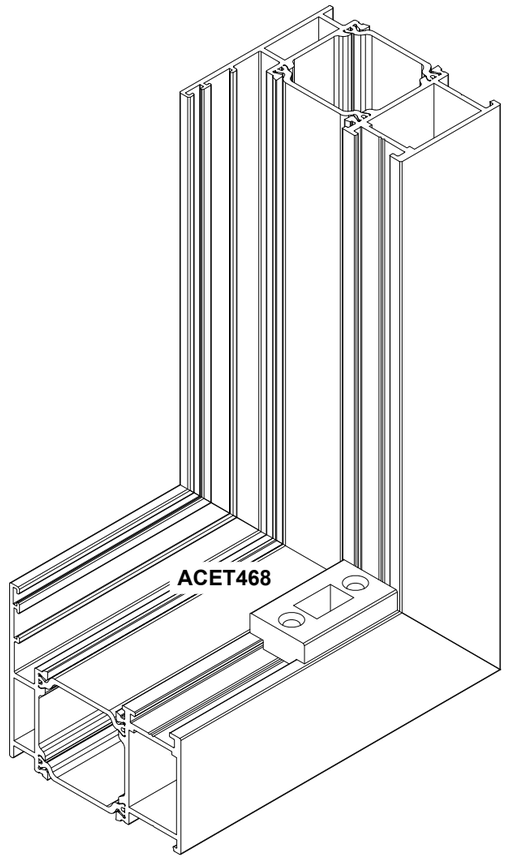
Single Door Shootbolt Detail

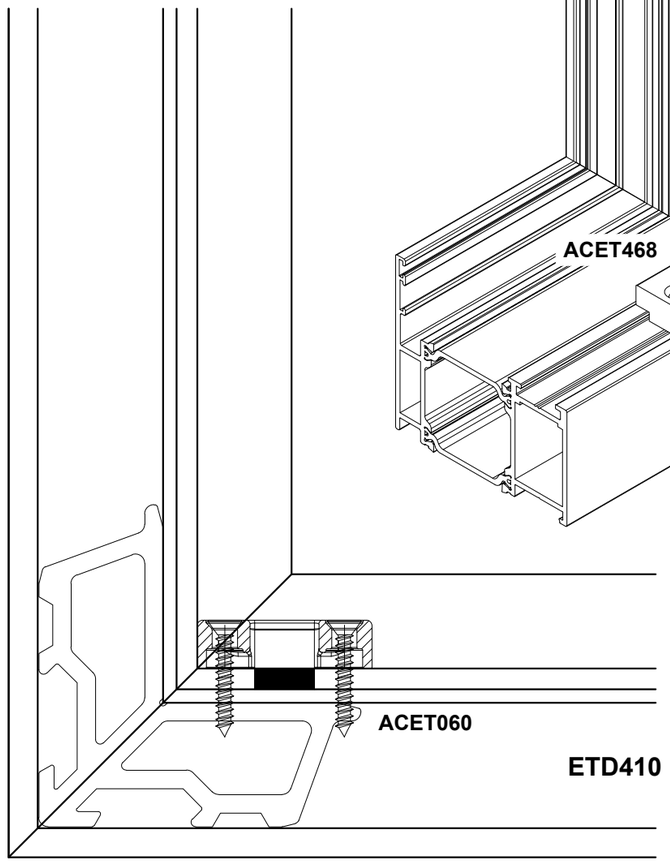






Doors above 2300mm high it is recommended to install shootbolts onto the multipoint lock

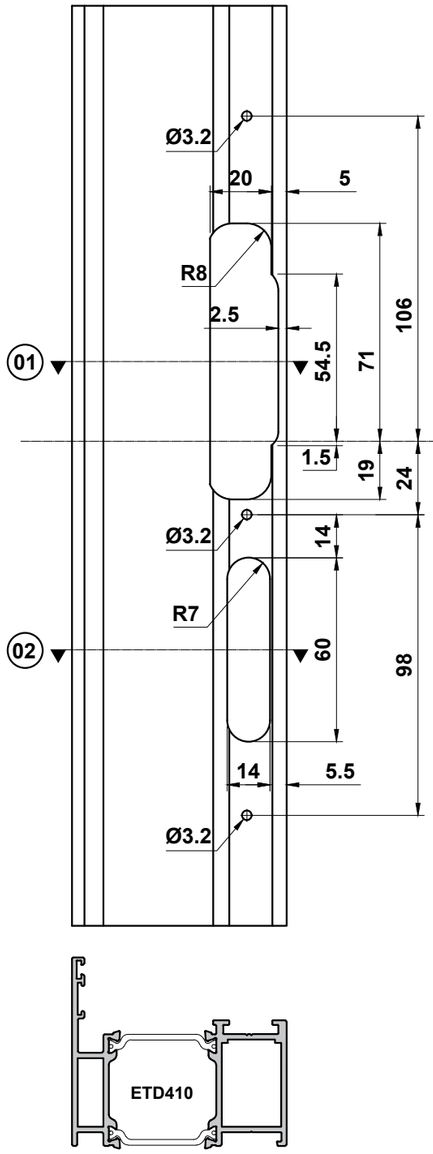


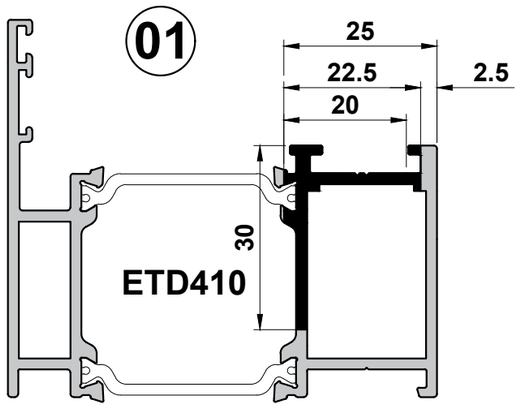


Do Not Scale From This Drawing

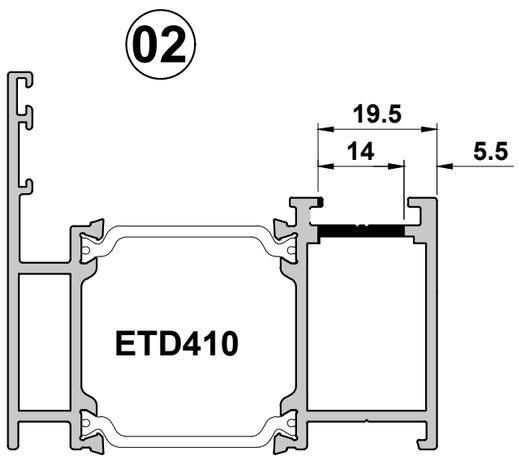
Open In Electric Strike Details

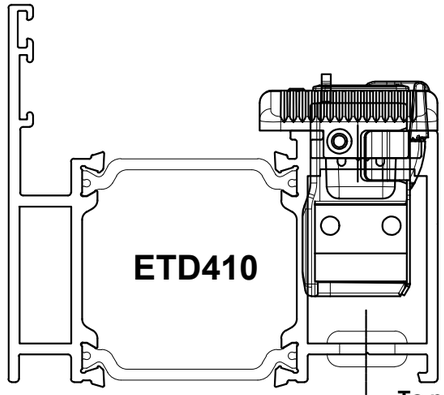
Centre Keep Cut Out





Ensure that the electric strike is powered only by a trained professional.

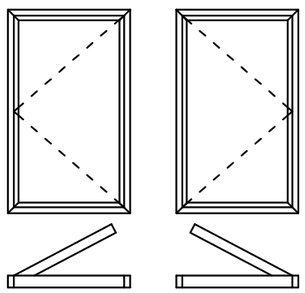




To prevent cutting the cable, a grommet must be installed at the exit point.

Keep Handing Guide

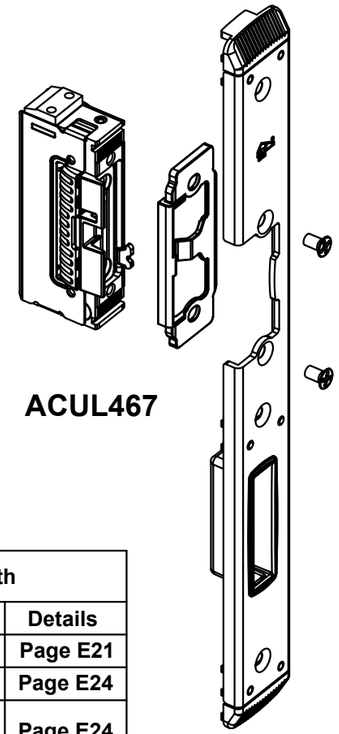
Viewed Externally



Left Hand Open In	Right Hand Open In
ACUL417	ACUL416

Max. Wire Size:	
Solid:	2.5mm²
Fine-Stranded (flexible):	1.5mm²
Fine-Stranded (with ferrule) :	1.5mm²

ACUL465 - 12V DC FAIL SAFE
ACUL466 - 12V DC FAIL SECURE



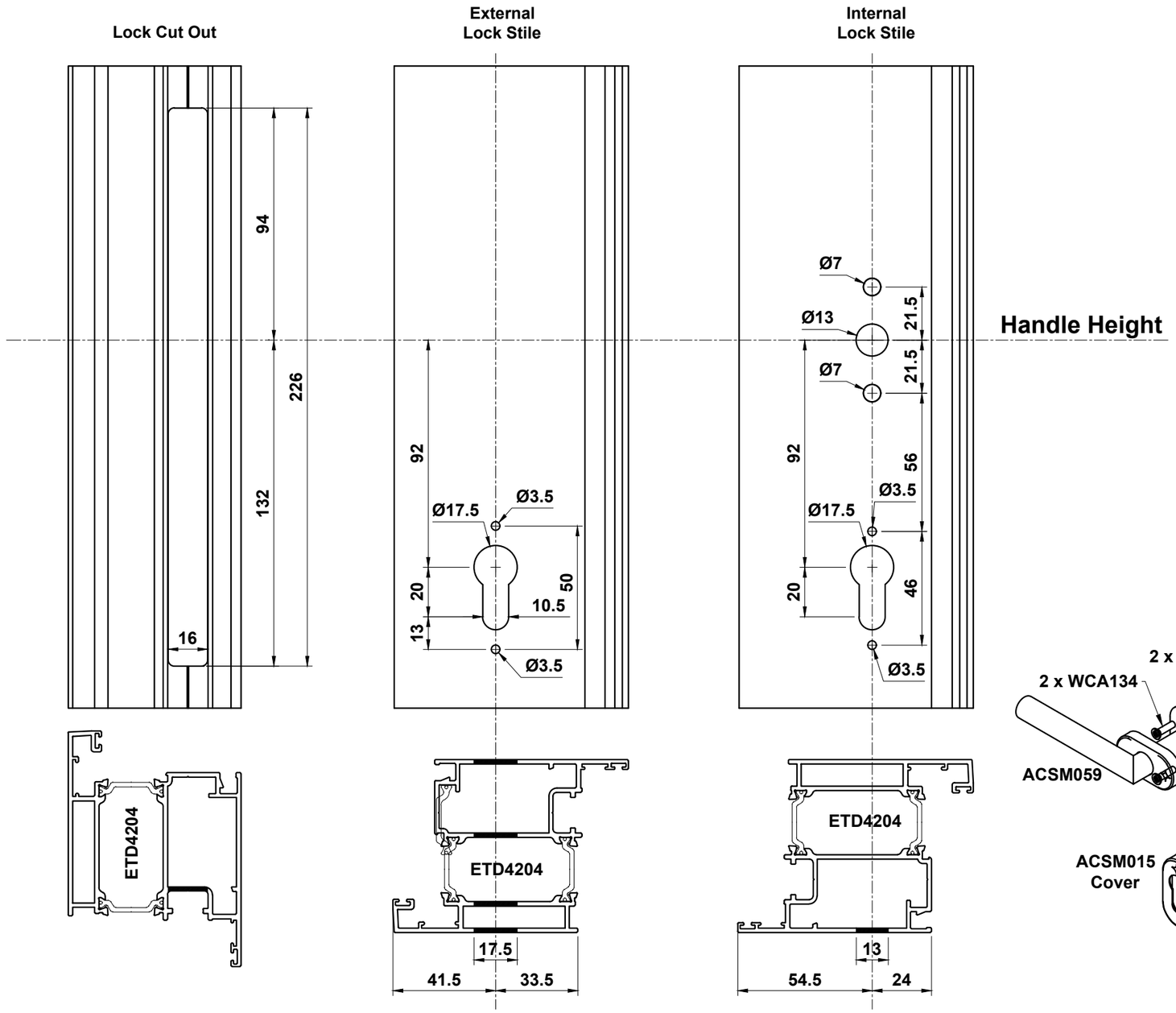
ACUL467

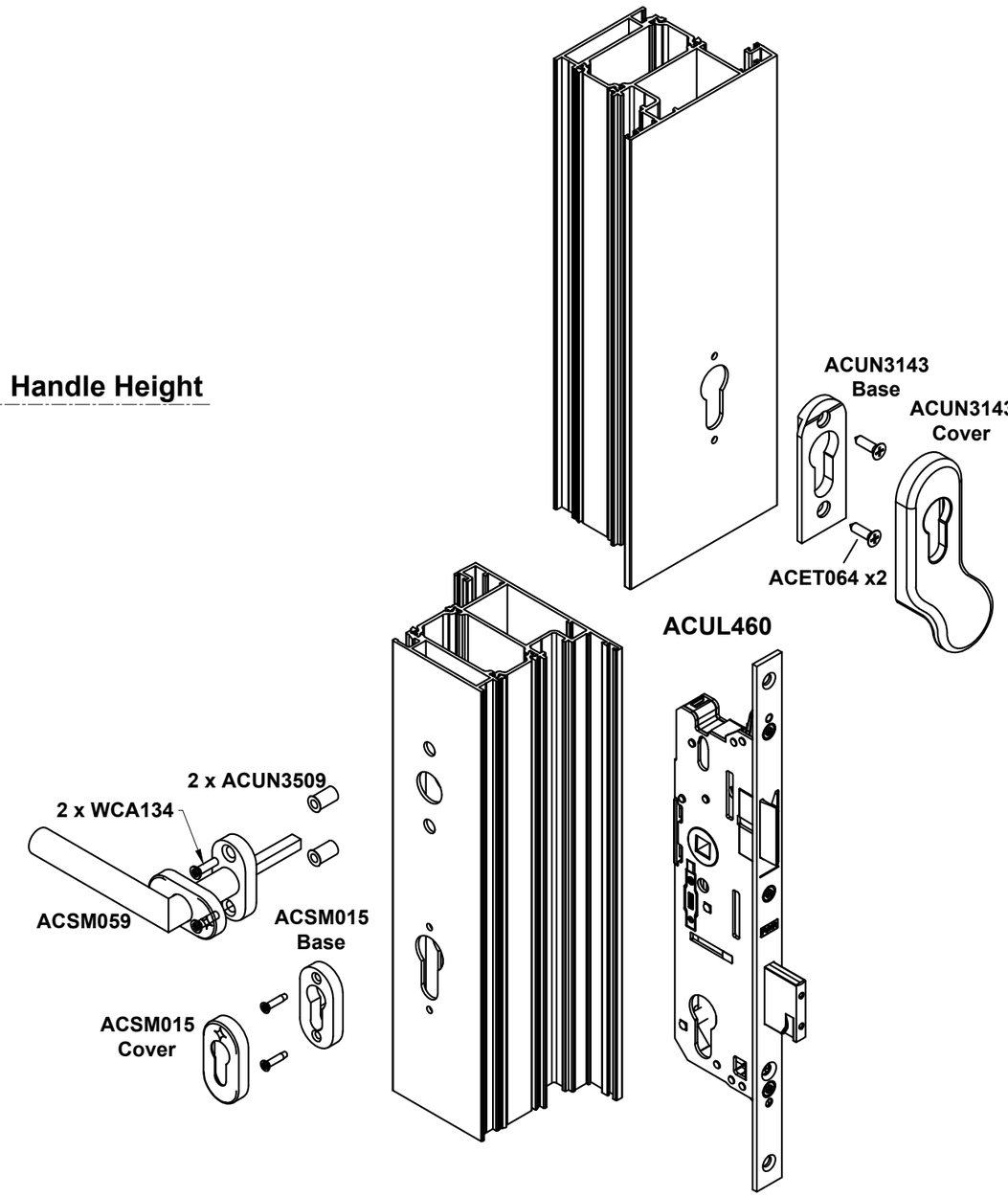
ACUL417

Can Be Used With		
Hardware	Type	Details
Lock	Key Wind	Page E21
Lock	Single Point	Page E24
Handle	Lever / Cylinder Pull	Page E24
Handle	Straight Pull Handle	Page E25

Do Not Scale From This Drawing

Single Point Lock & Internal Lever Handle Preparation

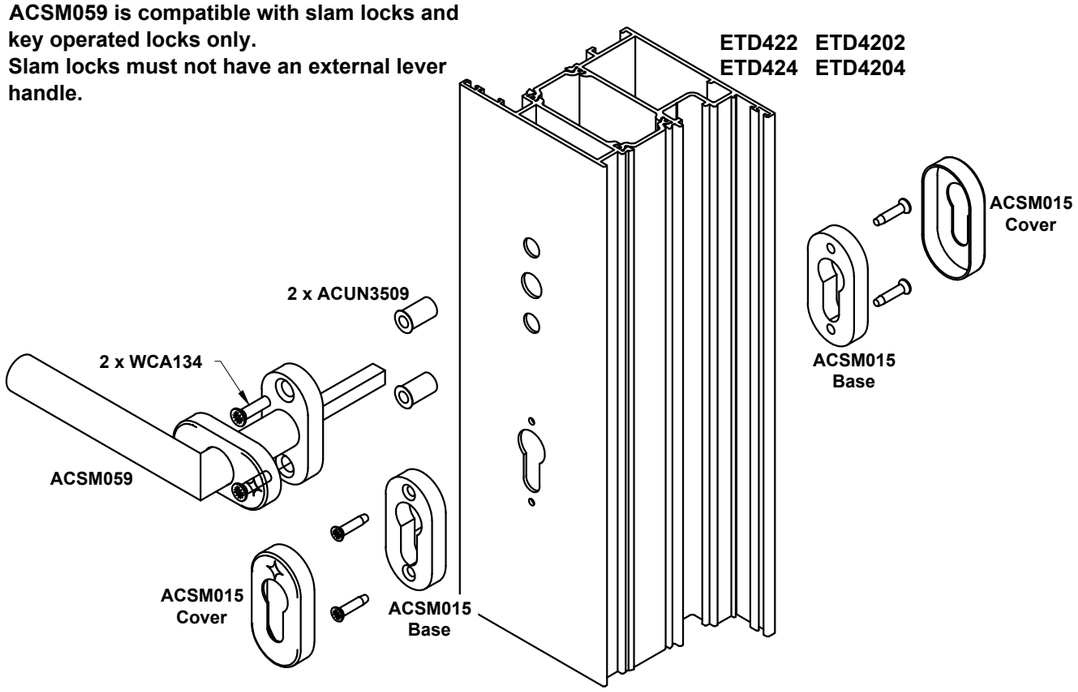


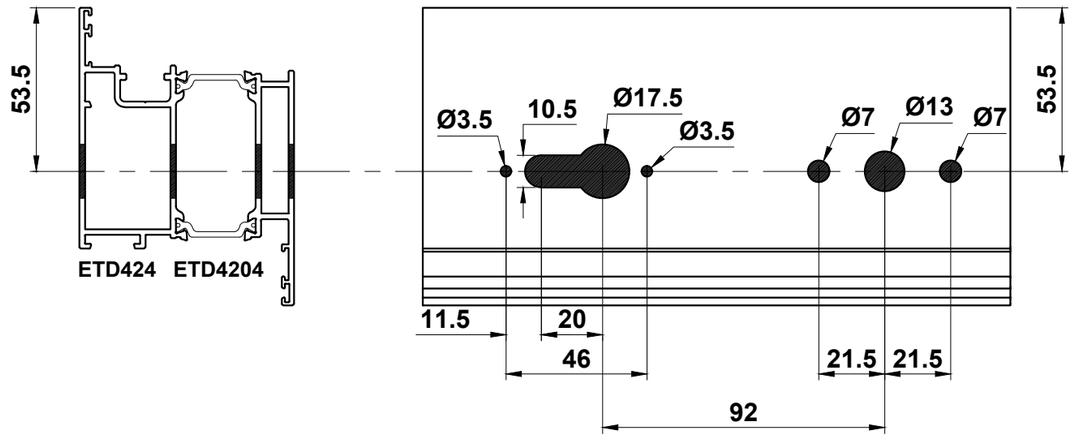


Do Not Scale From This Drawing

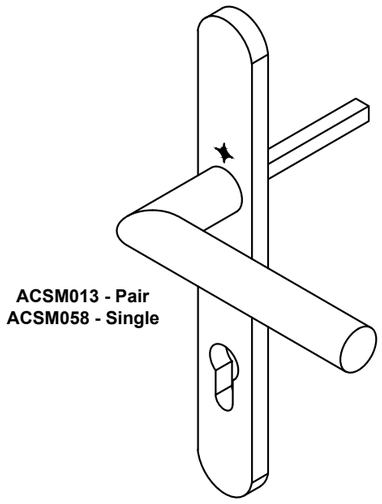
Stainless Steel Hardware - ACSM013, ACSM015, ACSM056 & ACSM059 Fitting Detail

Please Note:
ACSM059 is compatible with slam locks and key operated locks only.
Slam locks must not have an external lever handle.



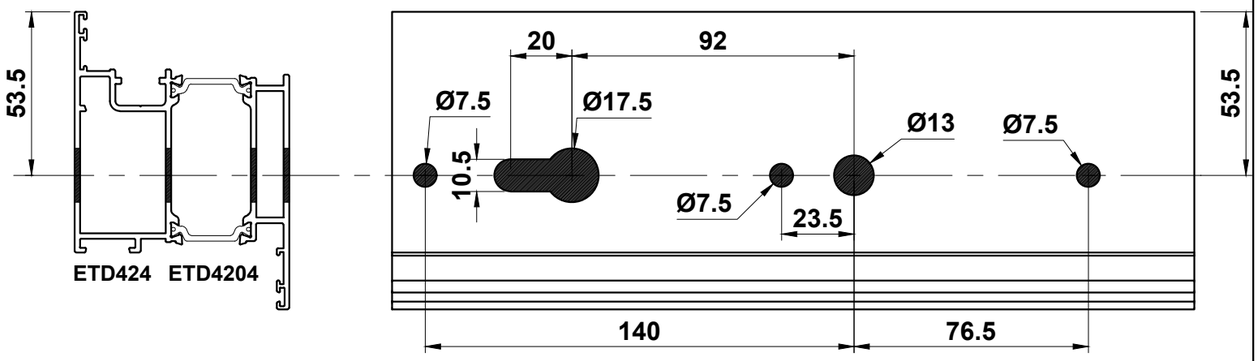


Please Note:
ACSM058 is compatible with all locks.
Slam locks must not have an external lever handle therefore require WCA134 & ACUN3509 for single side fixing and the spindle will need to be cut down.



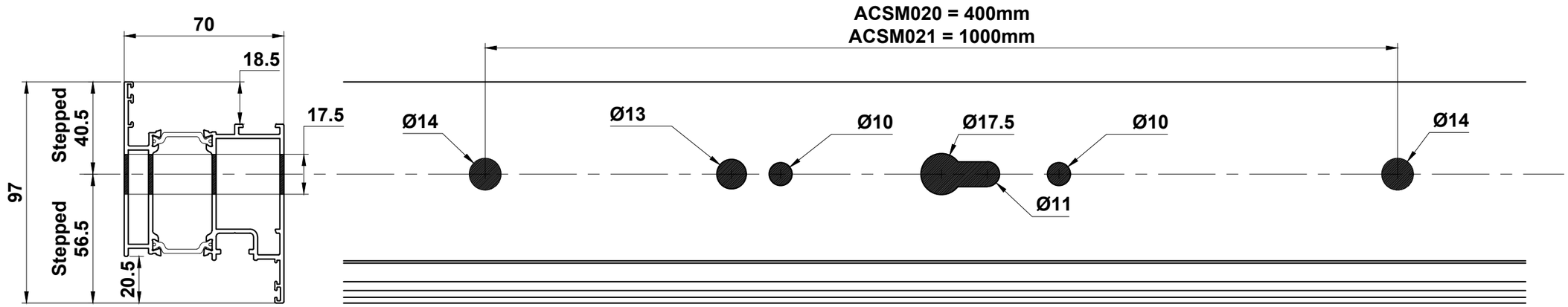
Important Note: All exposed aluminium should be coated using ACSIL014 or painted to match the frame.

Please Note:
ACSM013SS pack contains;
2 x Universal Backplate & Lever
2 x Cover Plate
2 x Bolt Receiver Sleeve
2 x 40mm M5 Machine Screws
2 X 60mm M5 Machine Screws
1 x 3mm Allen Key
1 x 170mm Spindle

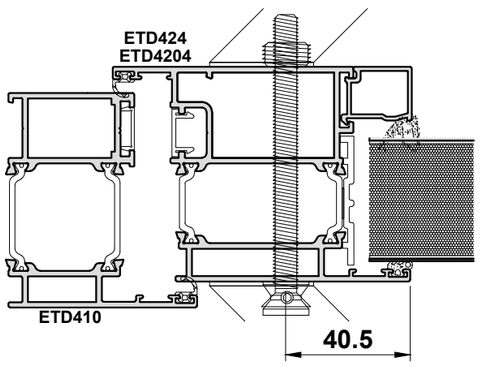


Do Not Scale From This Drawing

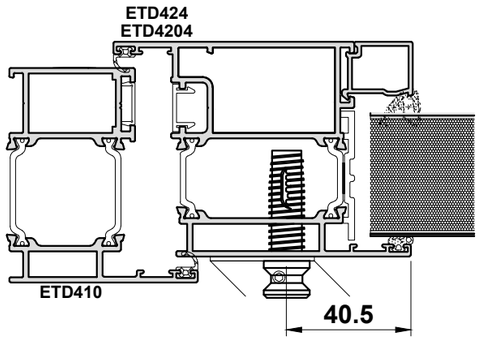
ACSM020 & ACSM021 Fitting Detail



Important Note: All exposed aluminium should be coated using ACSIL014 or painted to match the frame.



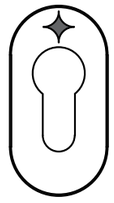
ACSM031 fixing kit is to be used when fixing two back to back handles. Screw will need to be cut down to size.

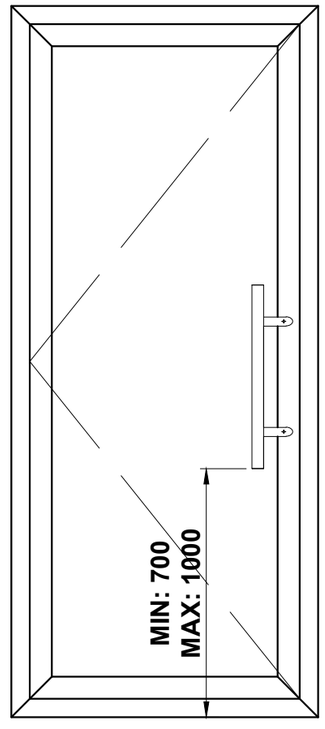


If a single handle is required, please use ACSM037 or ACSM038 single handle with ACSM030 Secret fixing.

We recommend to use ACSM015 escutcheon and position in-line with the handle fixings as shown in the above prep.

ACSM015



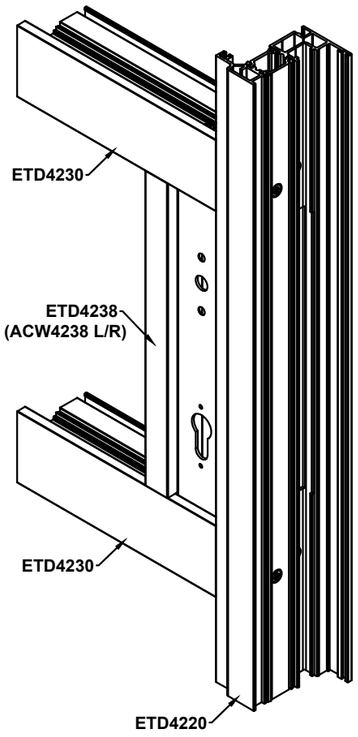


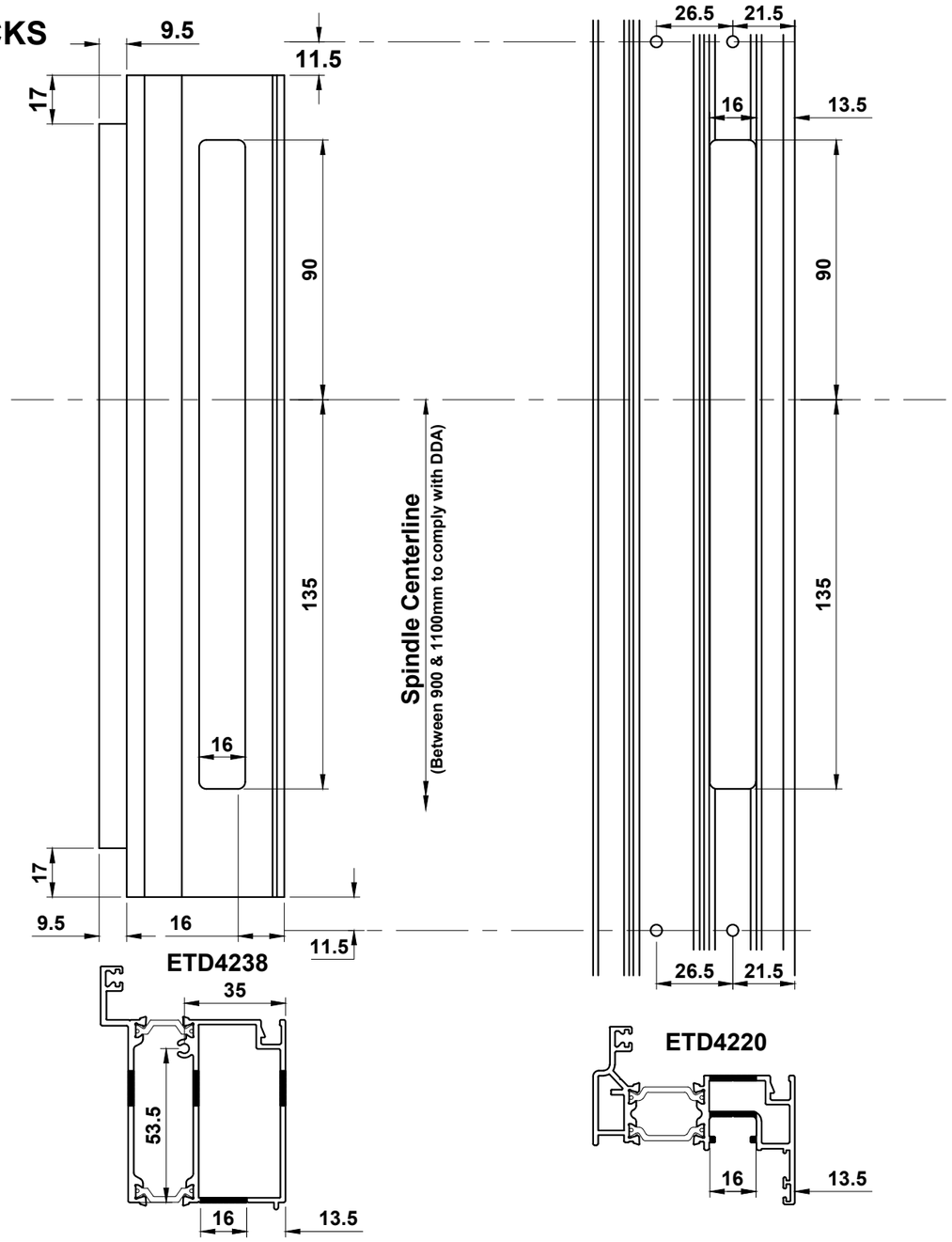
	Length (mm)	Single Handles	Fixing Kits
	600	ACSM037SS	ACSM030
	1200	ACSM038SS	
		Pair Handles	
	600	ACSM020SS	ACSM031
	1200	ACSM021SS	

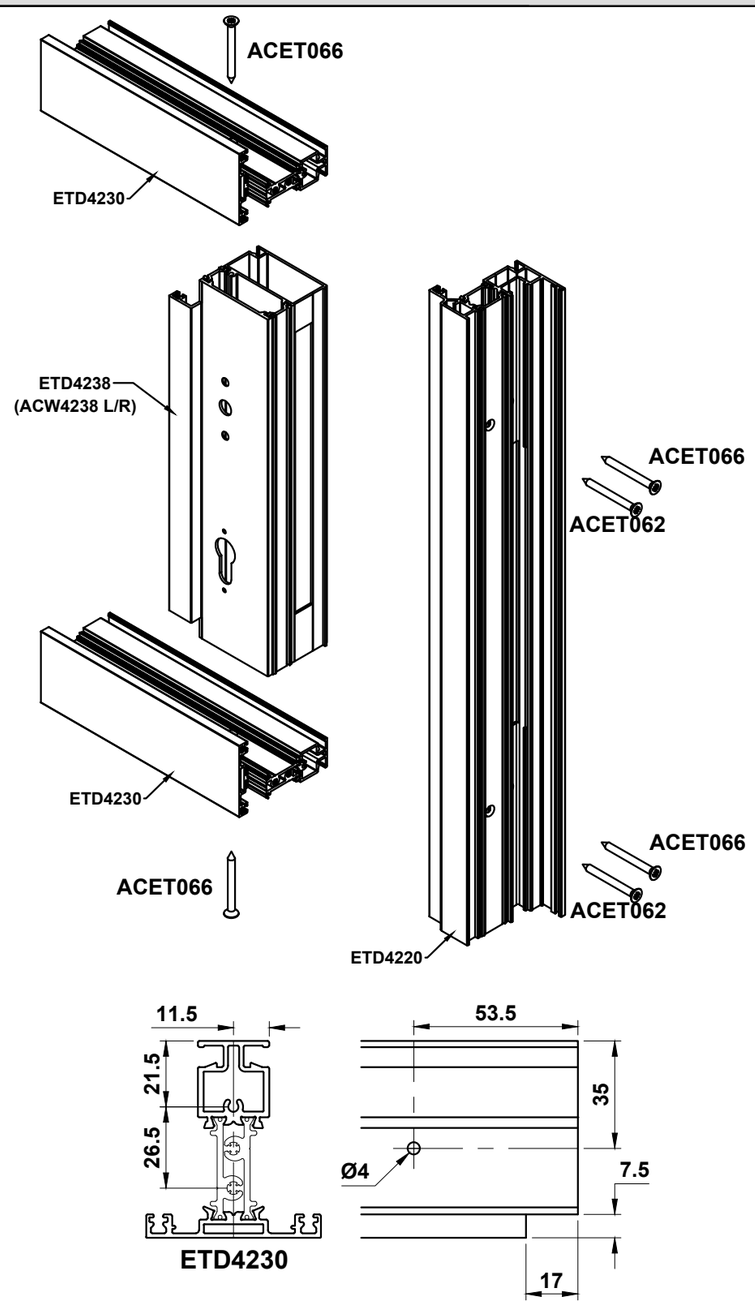
Do Not Scale From This Drawing

Heritage Open In Door Lock Preparation

FOR ACW20465 & ACW20466 LOCKS





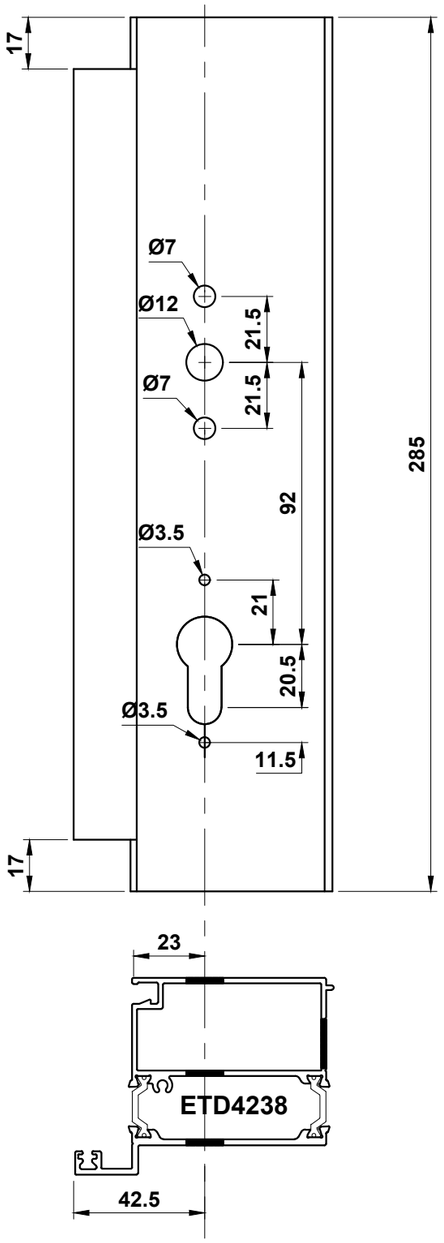


Do Not Scale From This Drawing

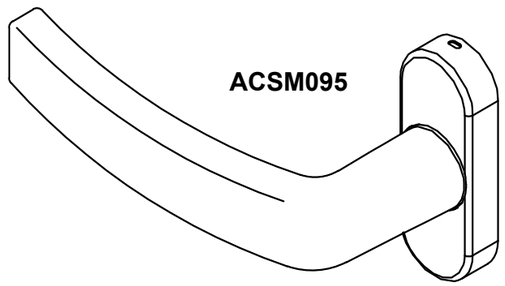
Alitherm 400 Stepped Door

Heritage Open In Door Handle Preparations

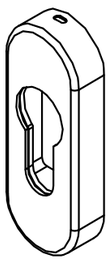
ACW4238L

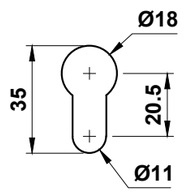


Lever Handle & Oval Rose

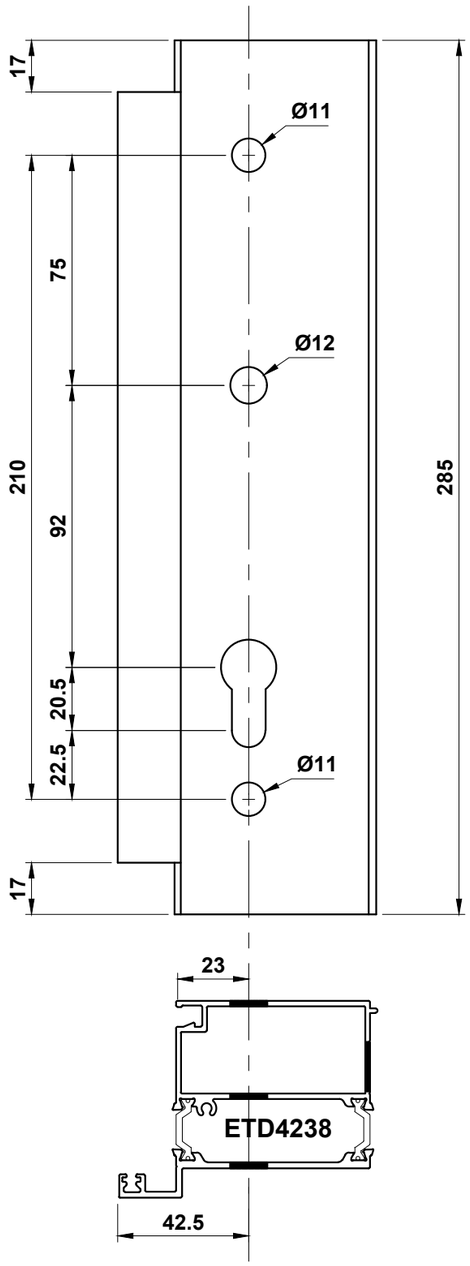


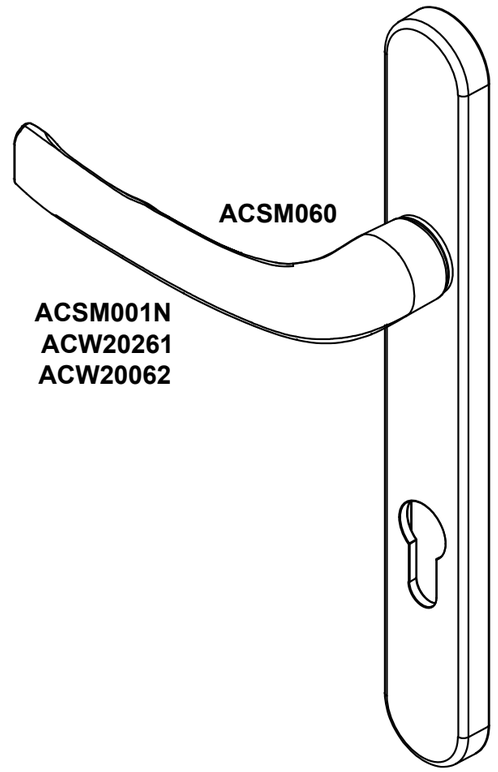
ACW4238L/R
Pre Prepared
Lock Casing

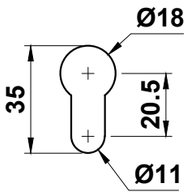




Long Escutcheon Handles

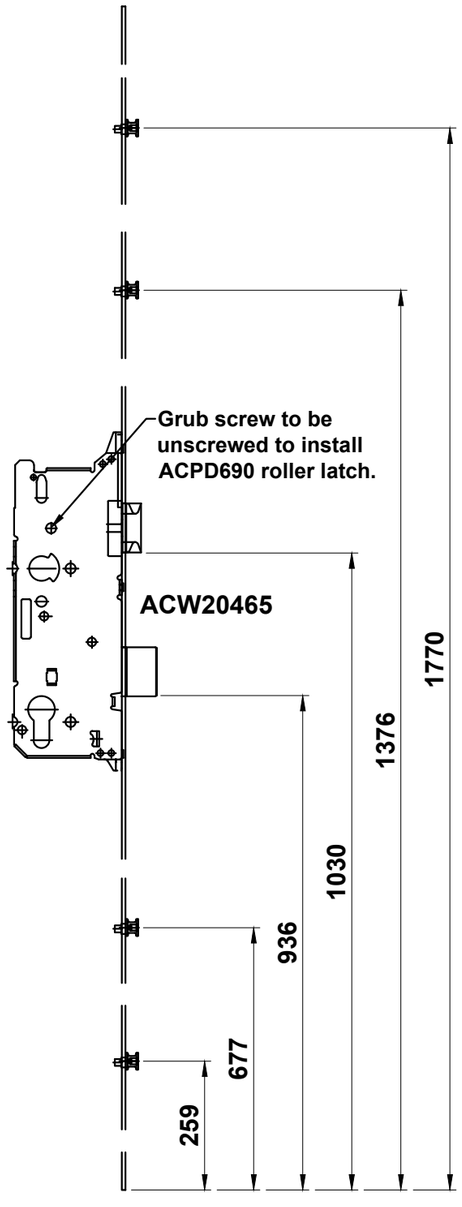




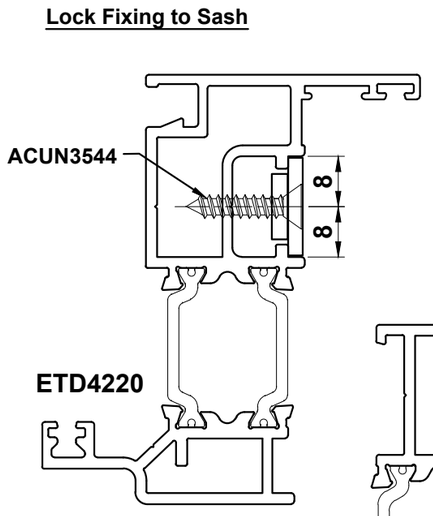


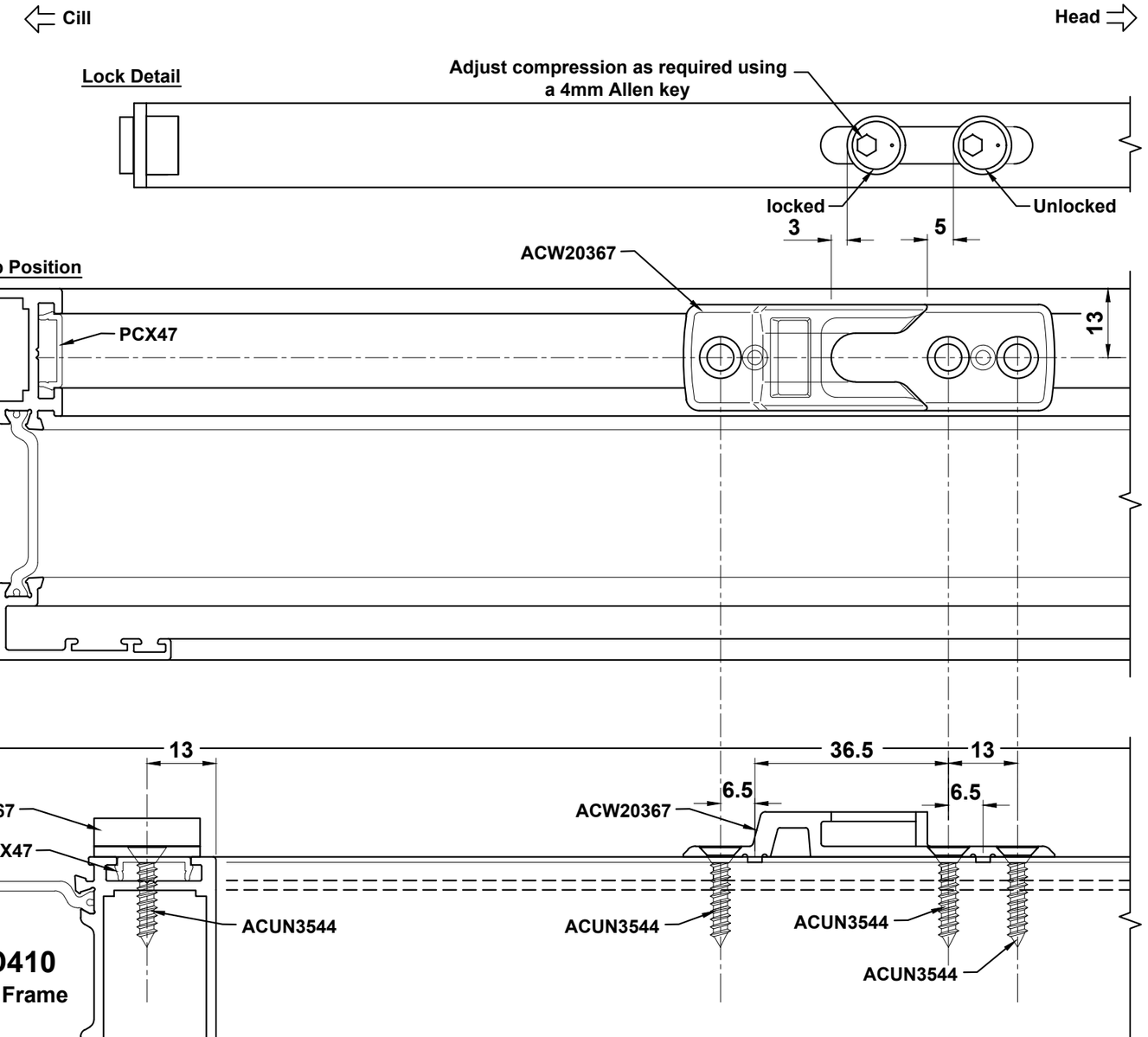
Do Not Scale From This Drawing

Heritage ACW20367 Door Keep Position Guide



Locking Positions (in unlocked position)

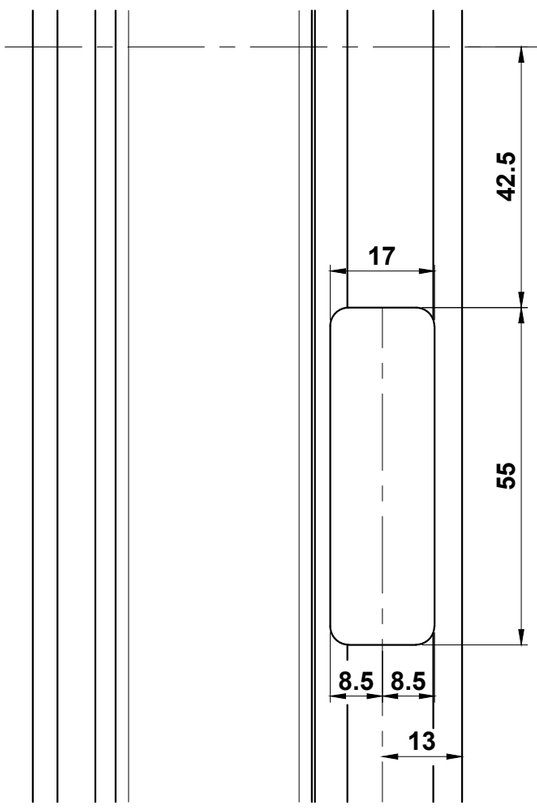


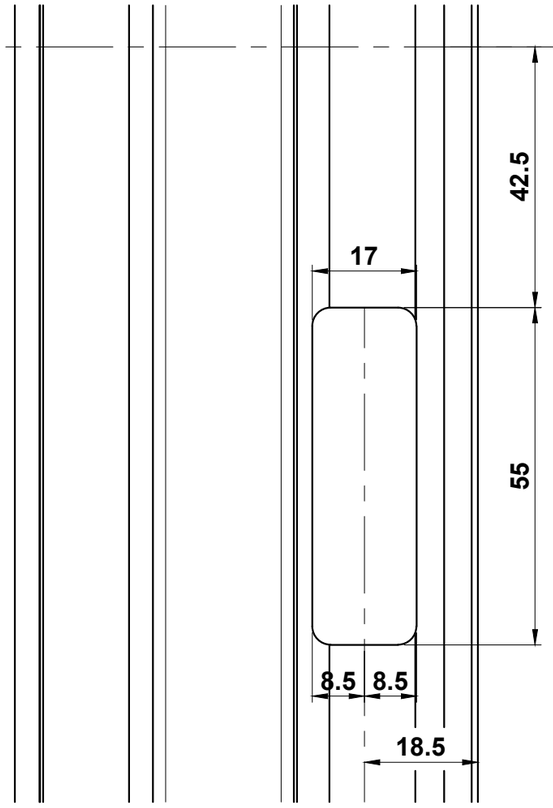


Do Not Scale From This Drawing

Heritage ACW20066 L/R Door Centre Keep Preparation

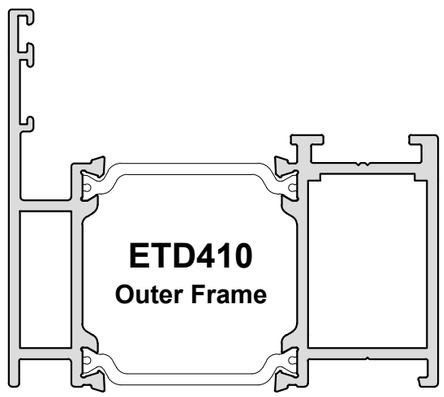
ACW20166 Open In Centre Keep



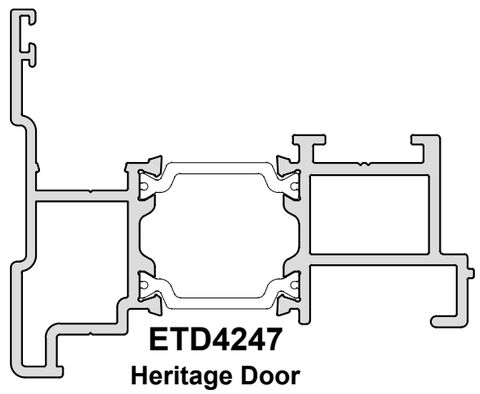


Spindle Centerline
(Between 900 & 1100mm to finish floor comply with DDA)

FINISH FLOOR LINE



ETD410
Outer Frame

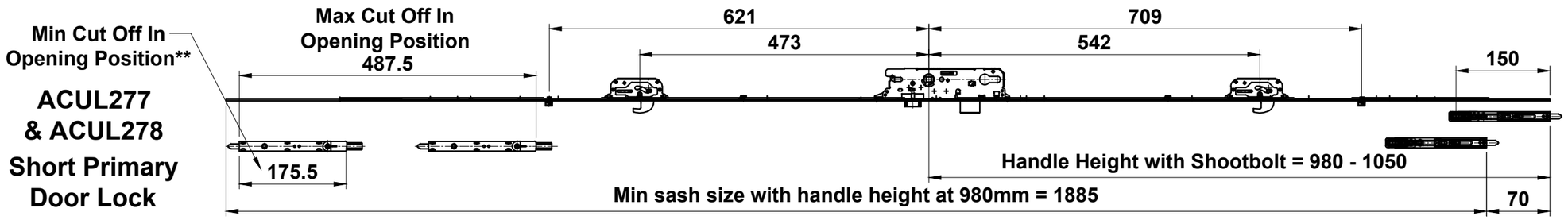


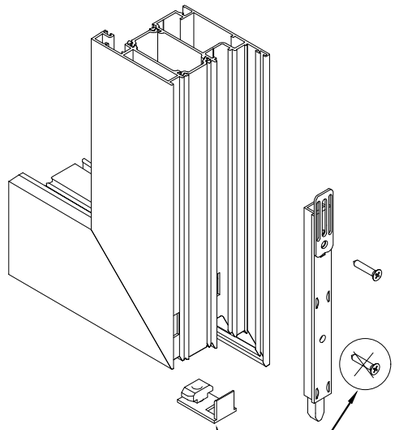
ETD4247
Heritage Door
Meeting Stile

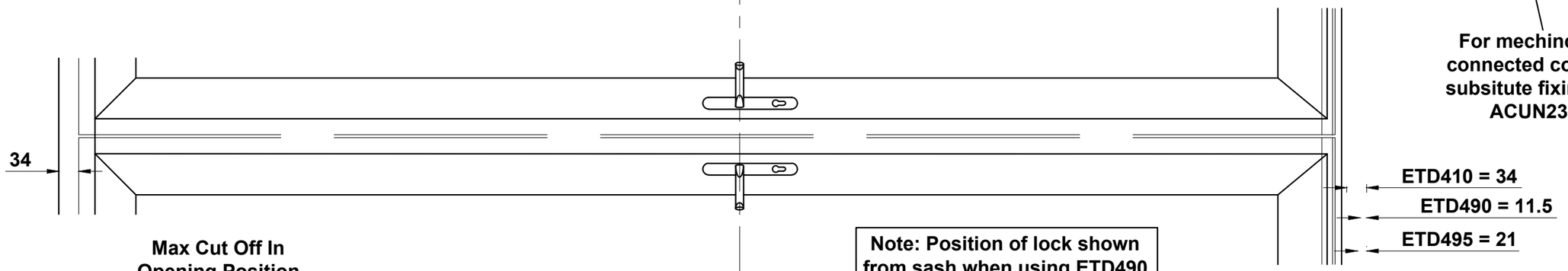
Do Not Scale From This Drawing

Double Door Lift Lever Shootbolt Layout

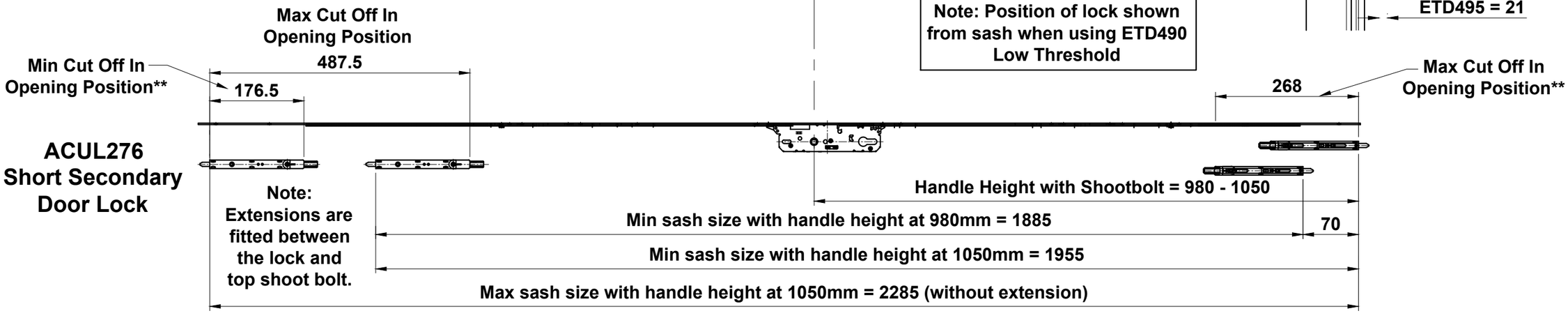
Note: ACDV742 & ACDV744 extensions may used with all locks







Note: Position of lock shown from sash when using ETD490 Low Threshold

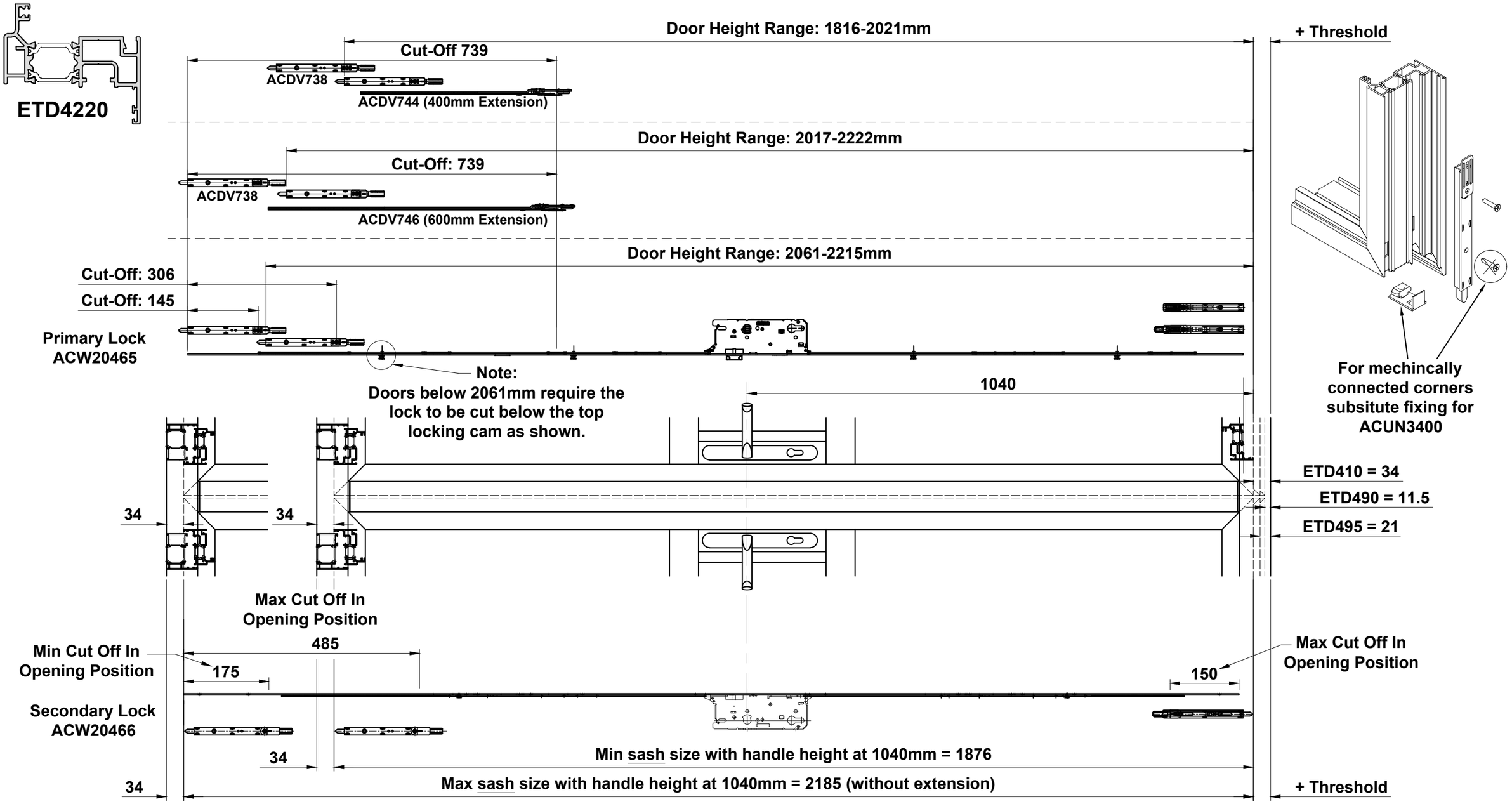


Note: Extensions are fitted between the lock and top shoot bolt.

*Maximum sash height is 2500mm. Sizes shown here only indicate sizes with ACDV744.

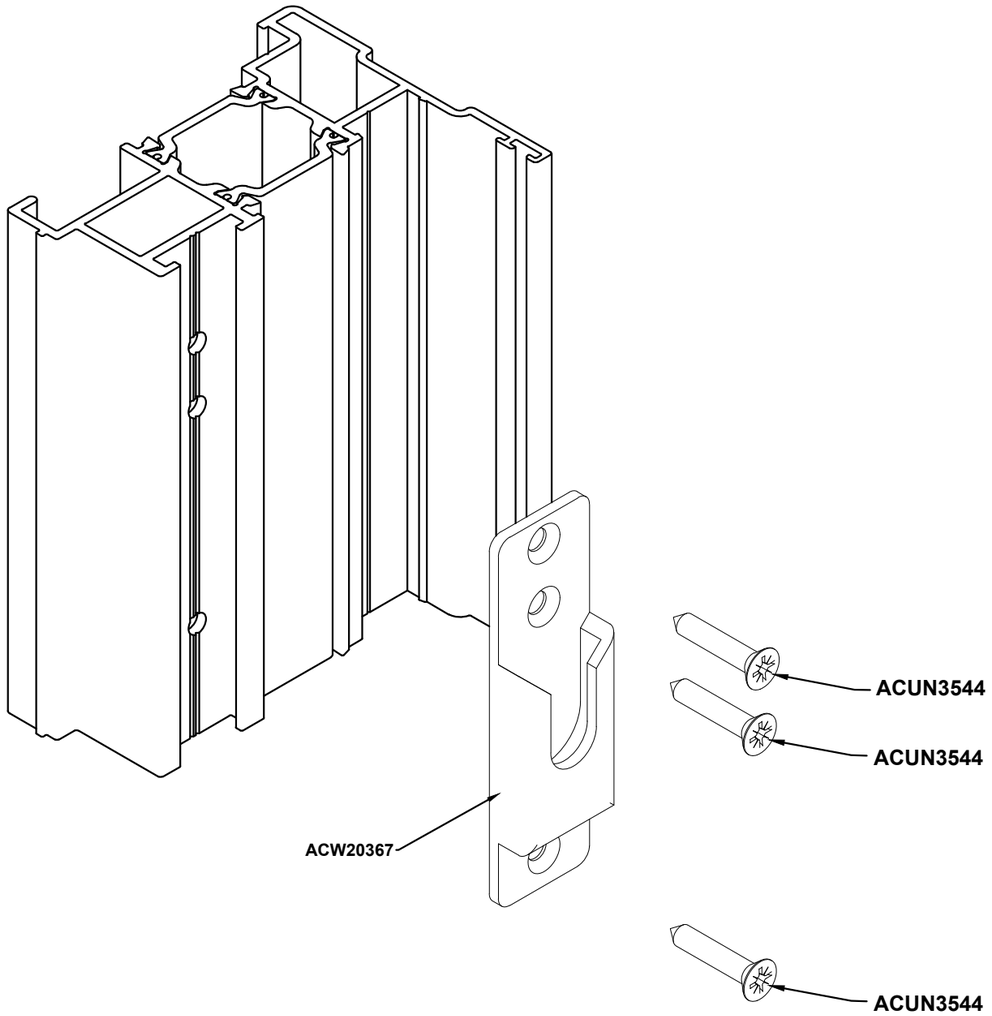
Do Not Scale From This Drawing

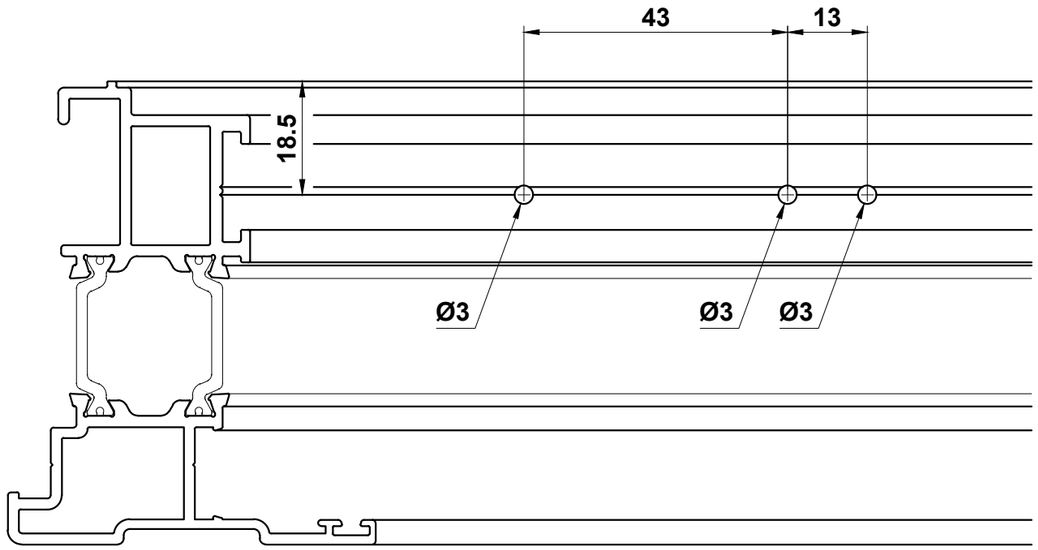
Heritage Double Door Lift Lever Shootbolt Layout

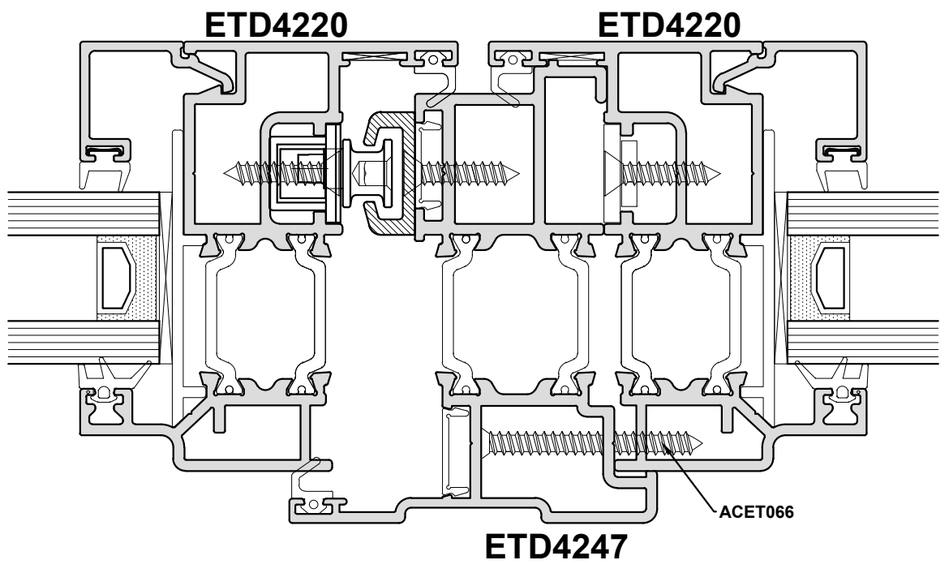


Do Not Scale From This Drawing

Heritage ACW20367 Floating Mullion Installation

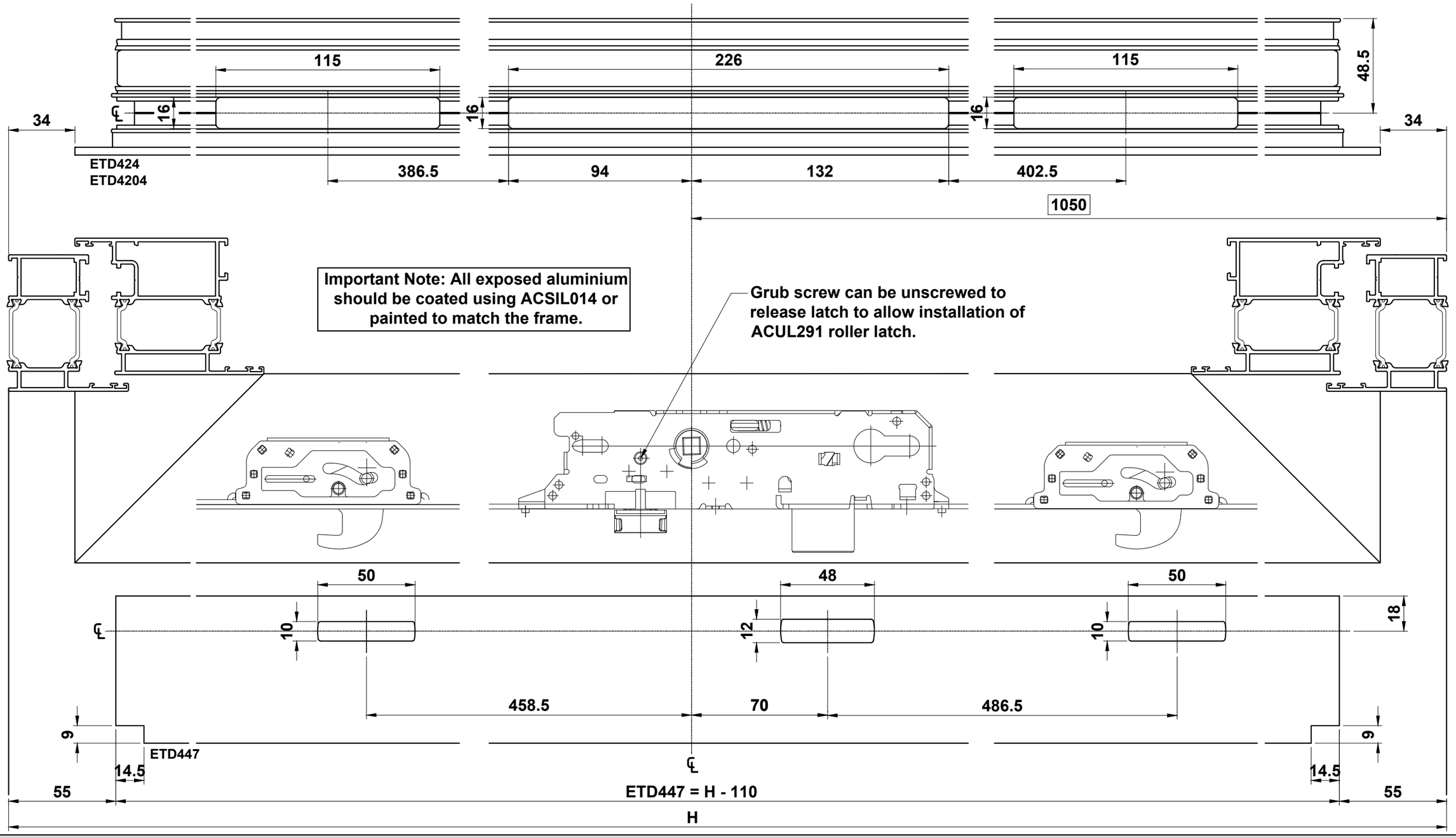






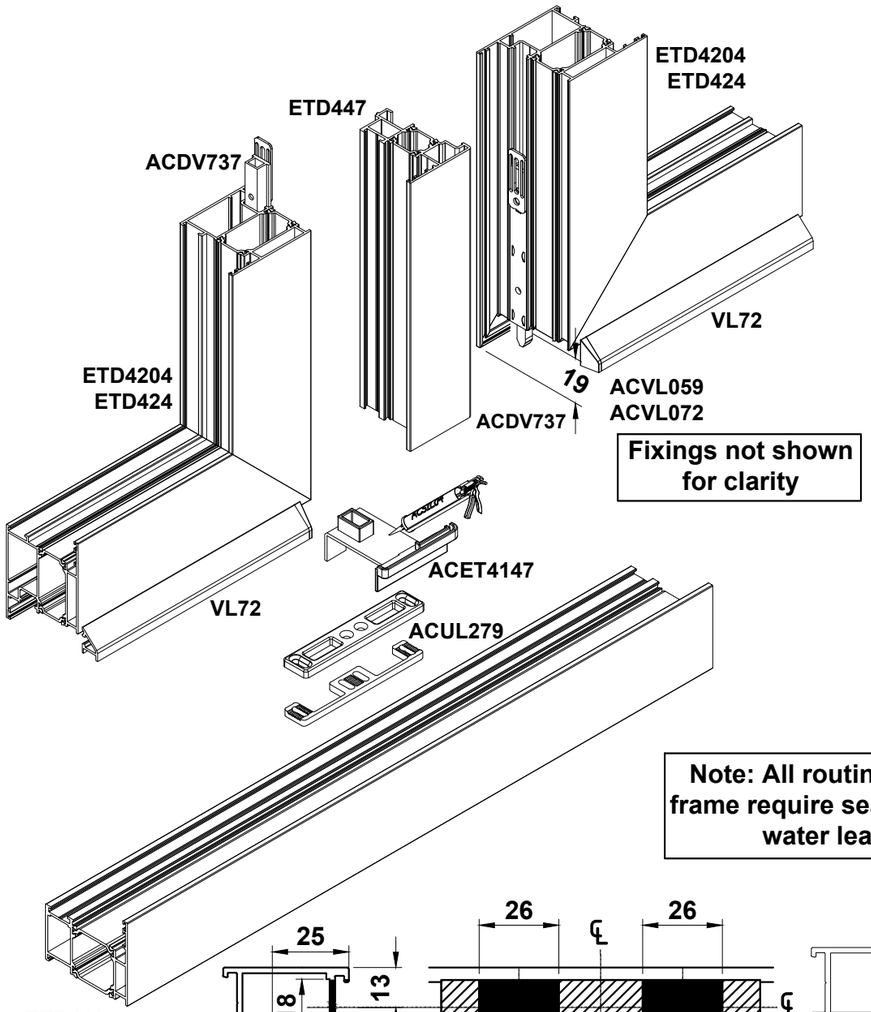
Do Not Scale From This Drawing

Double Door Lift Lever Lock Preparation for Full Frame



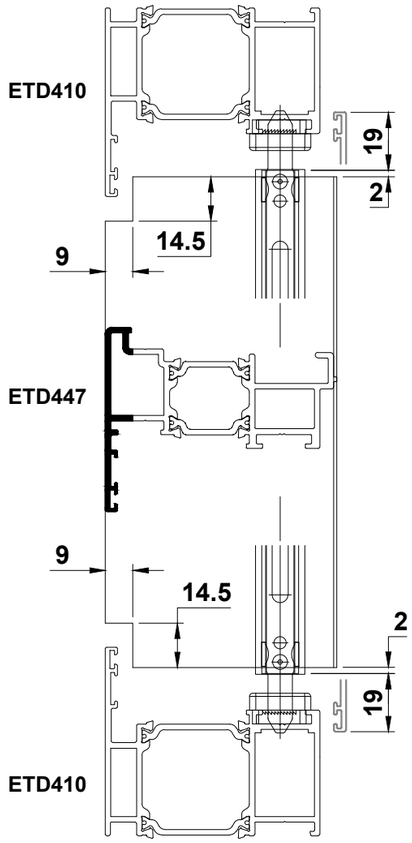
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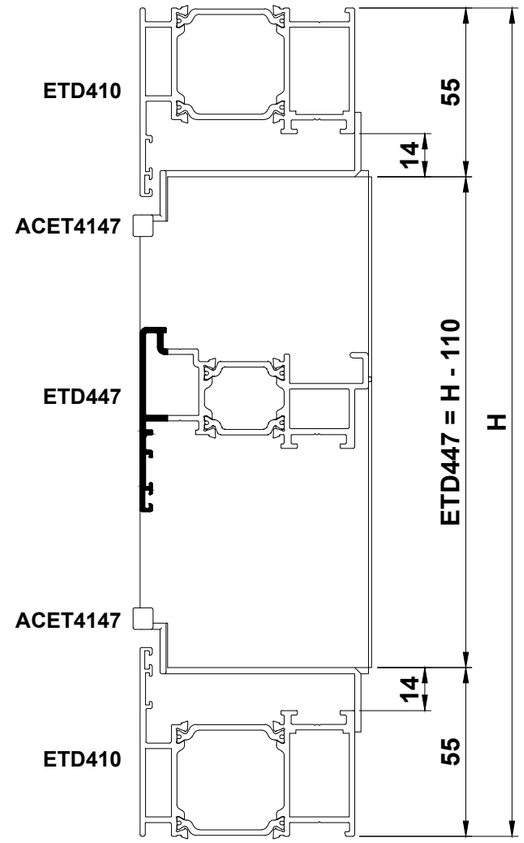
Double Door Lift Lever Meeting Stile Assembly for Full Frame

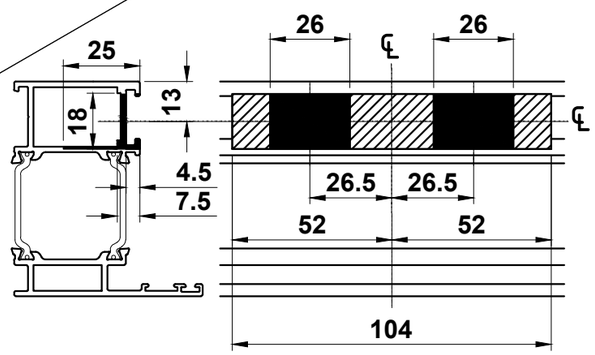


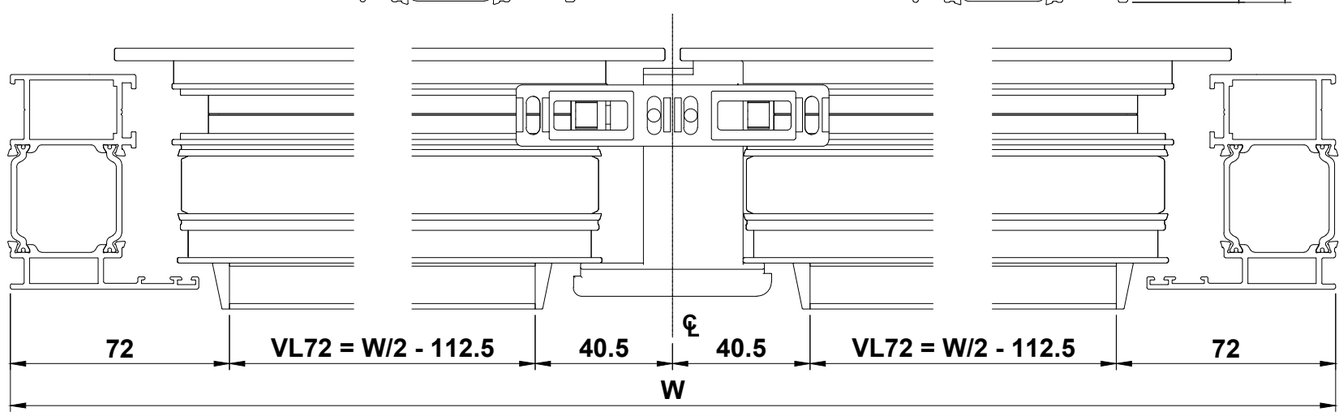
Fixings not shown for clarity

Note: All routing on outer frame require sealant to stop water leakage



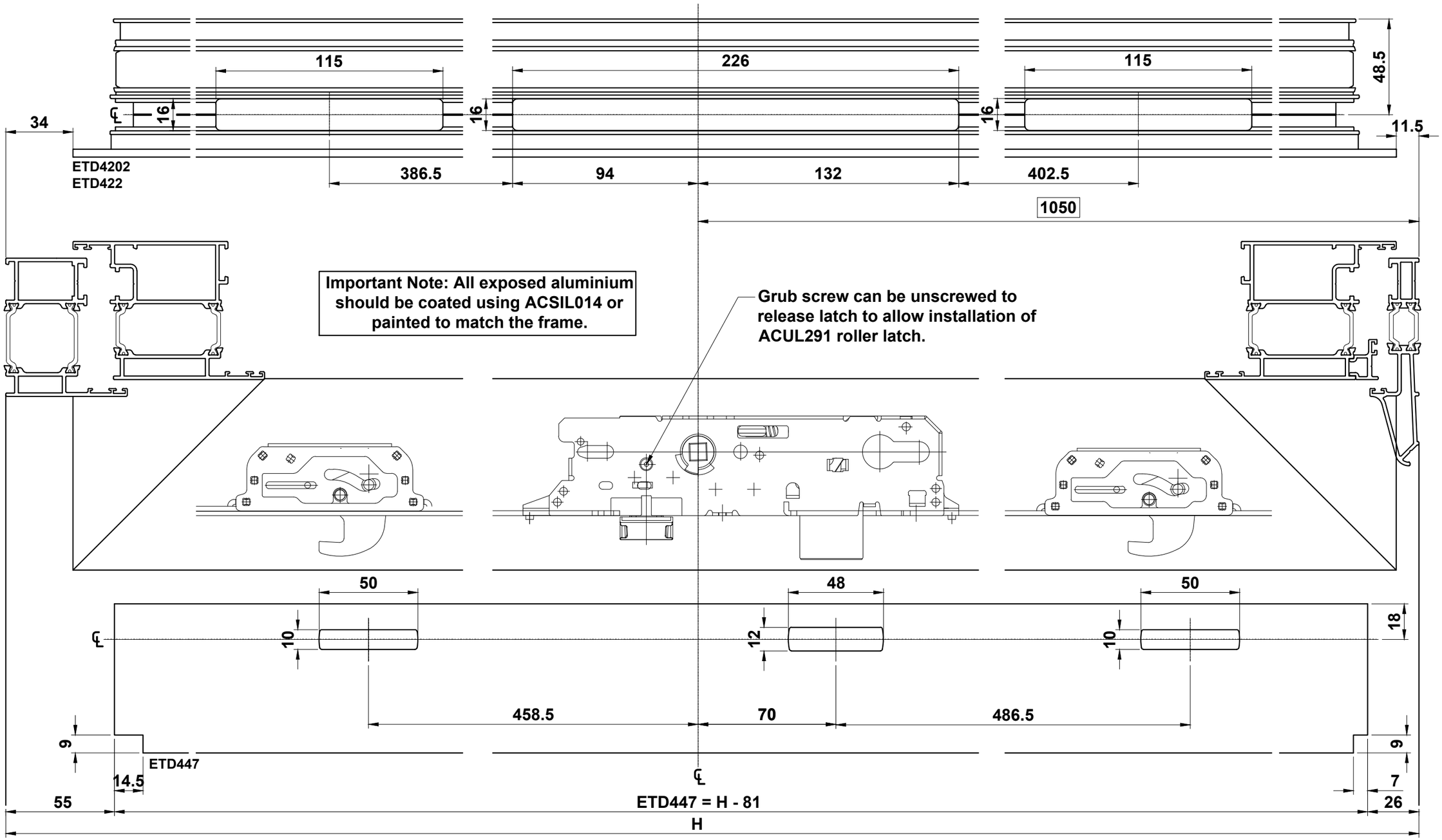






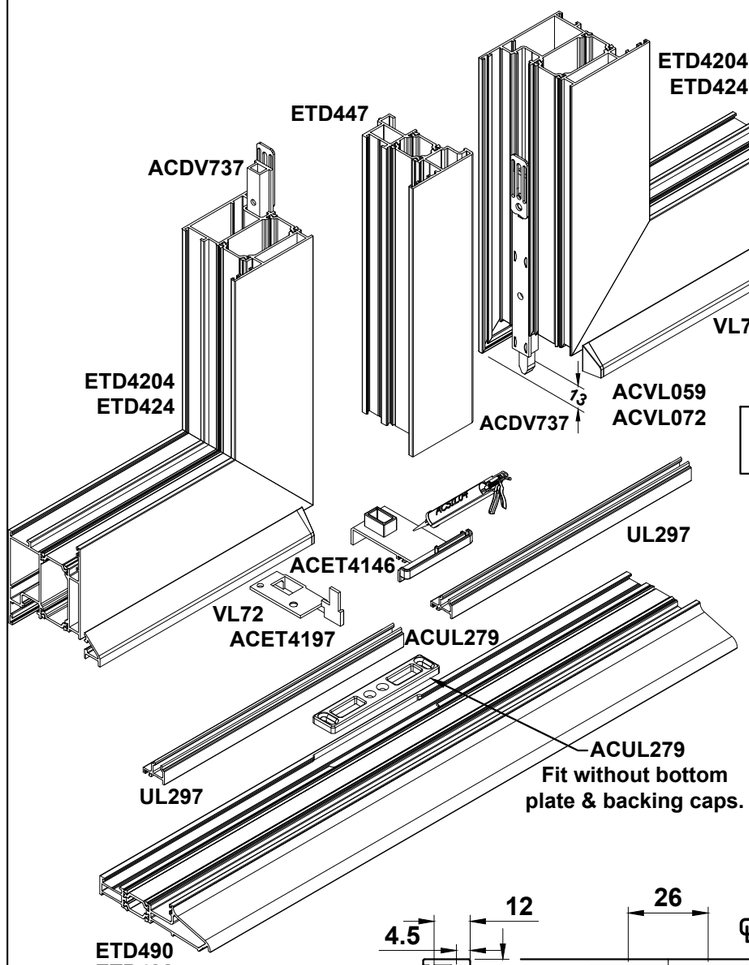
Do Not Scale From This Drawing

Double Door Lift Lever Lock Preparation for Low Rebate Threshold

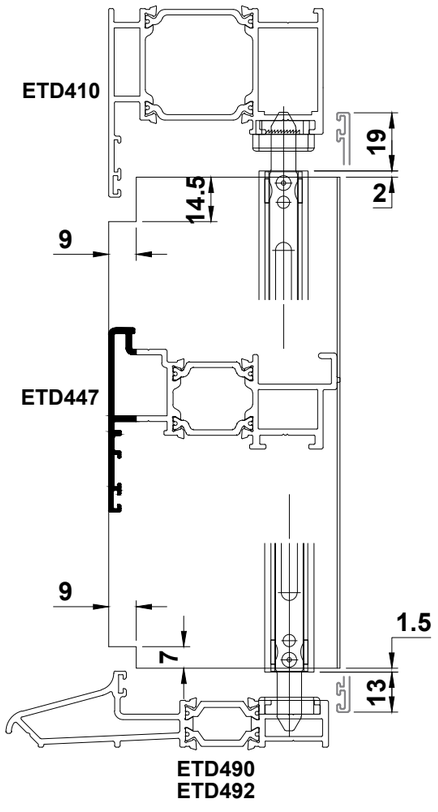


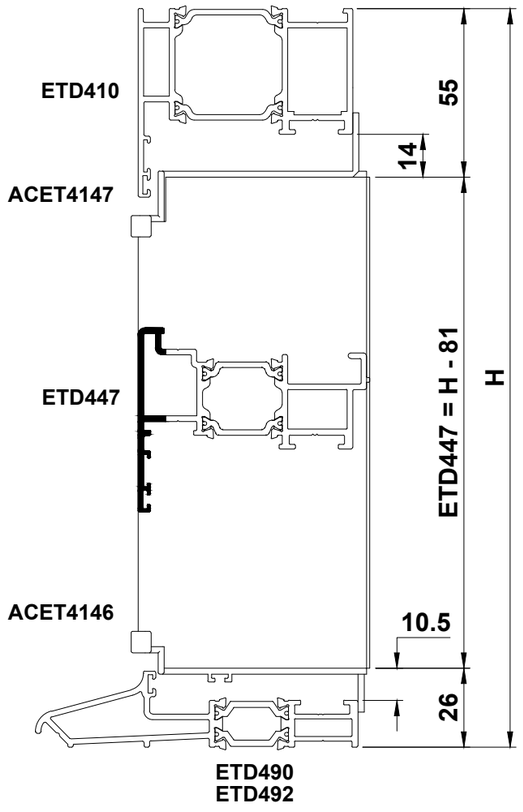
Do Not Scale From This Drawing

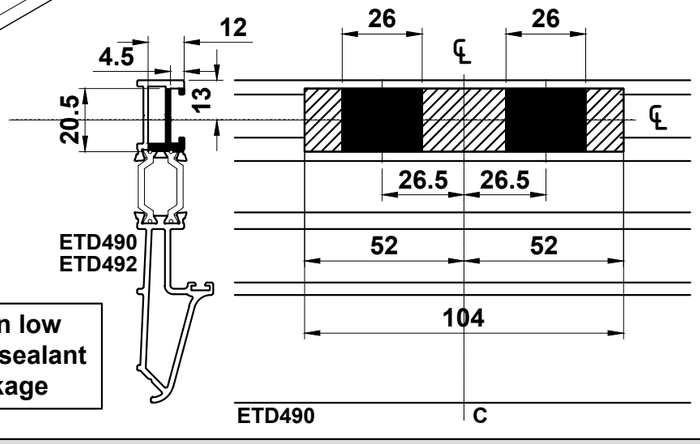
Double Door Lift Lever Meeting Stile Assembly for Low Rebate Threshold

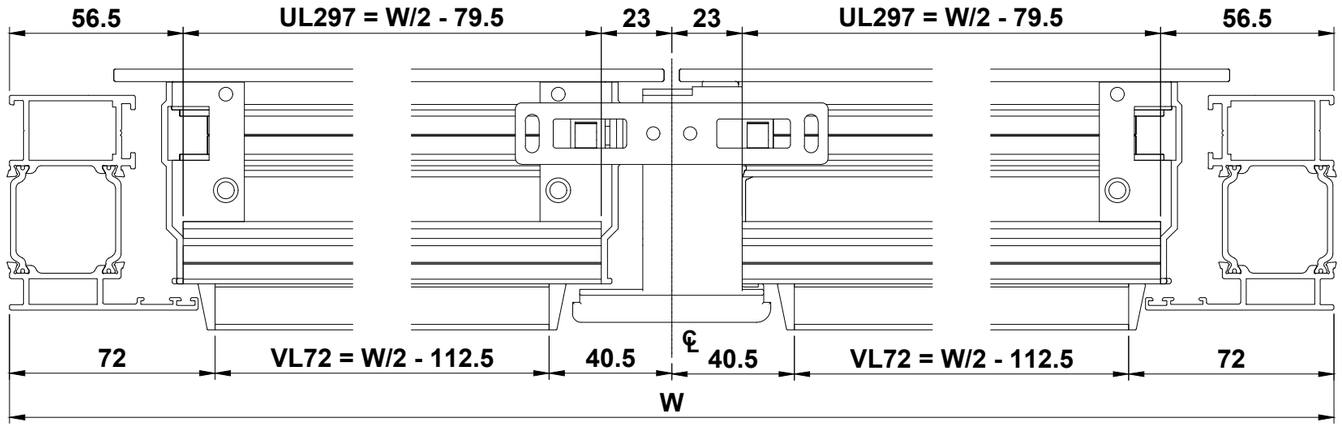


Fixings not shown for clarity





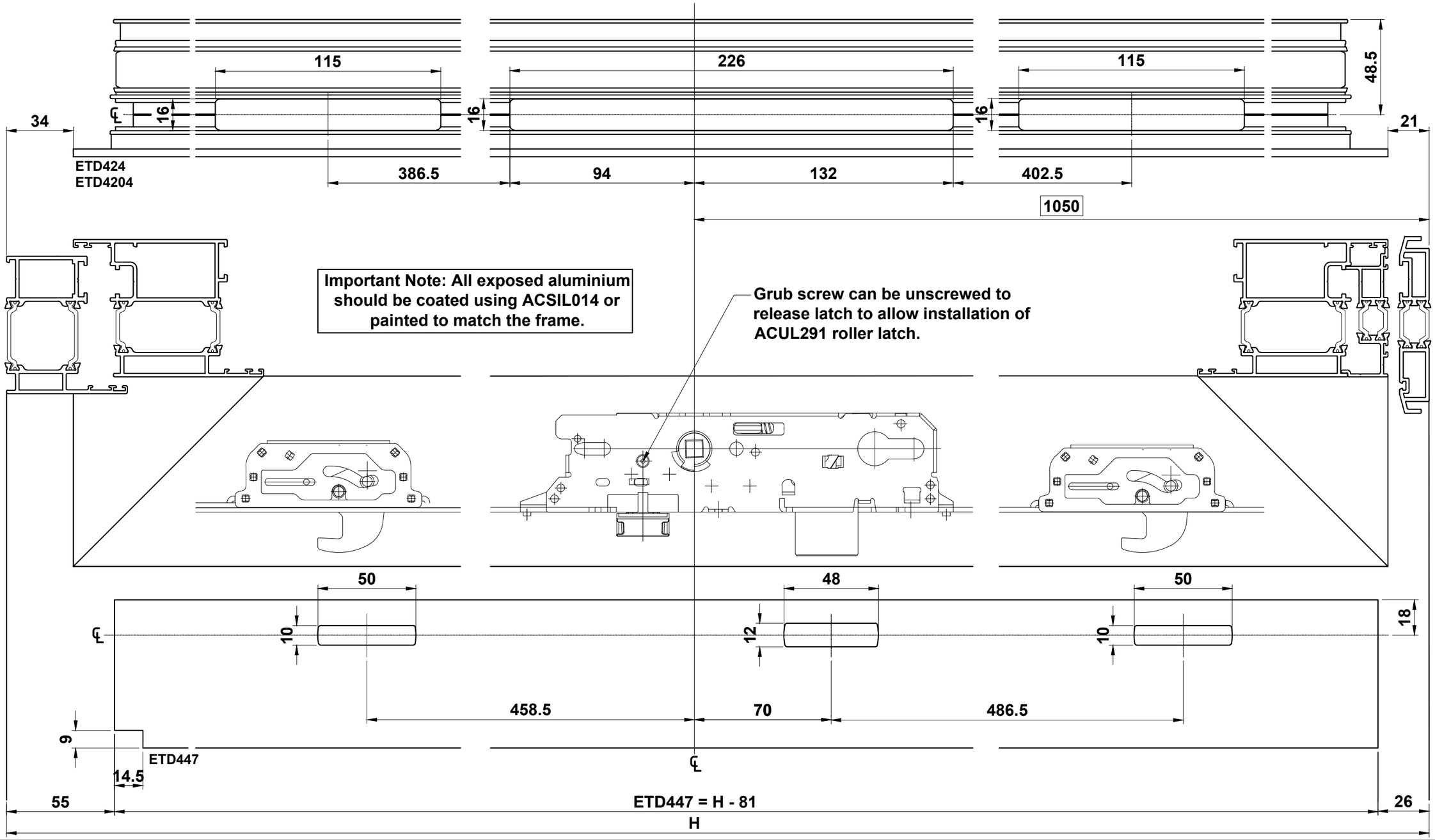




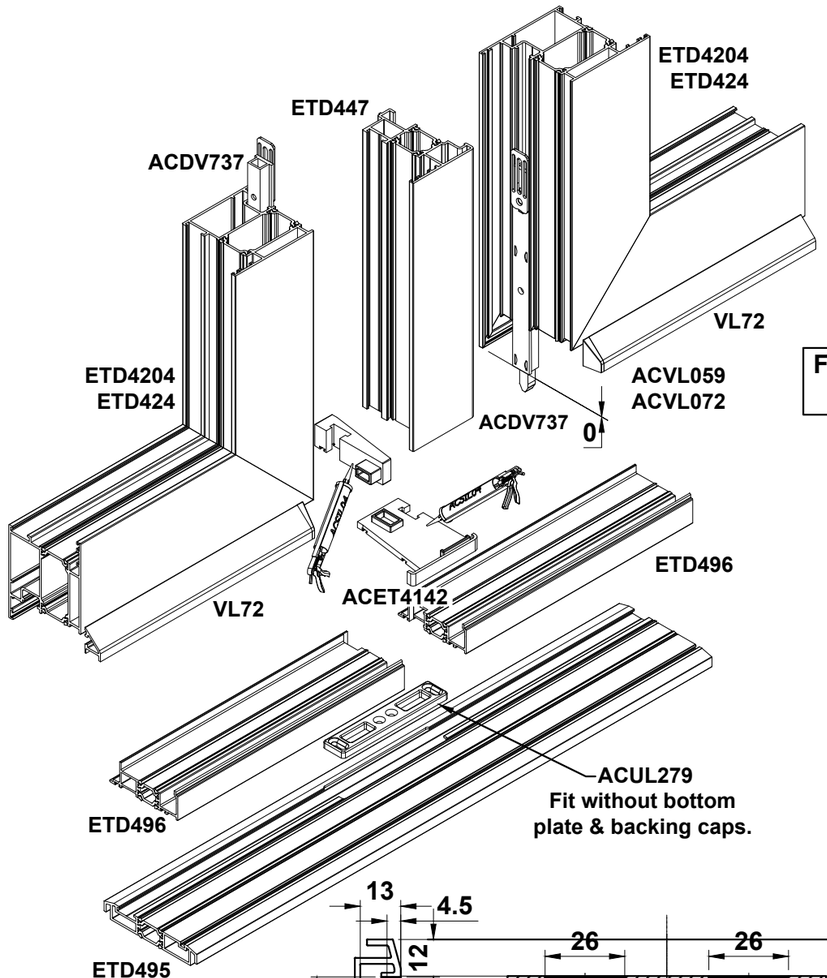
Note: All routing on low threshold to require sealant to stop water leakage

Do Not Scale From This Drawing

Double Door Lift Lever Lock Preparation for Low Ramp Threshold

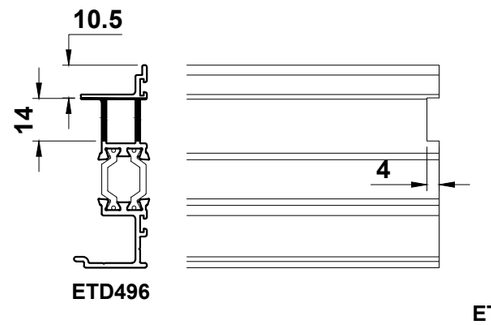


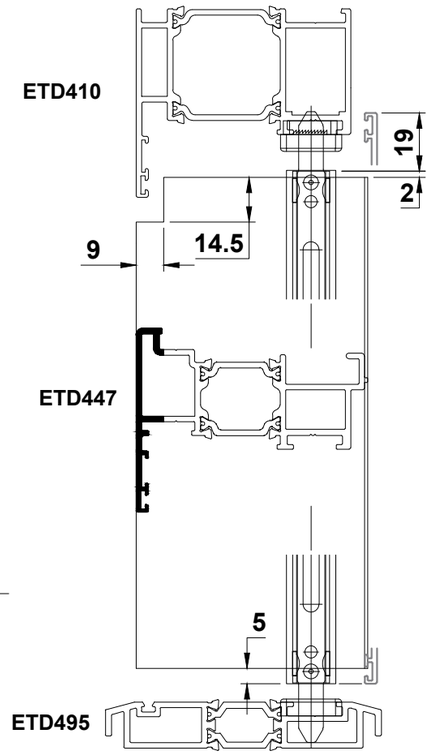
Double Door Lift Lever Meeting Stile Assembly for Low Ramp Threshold

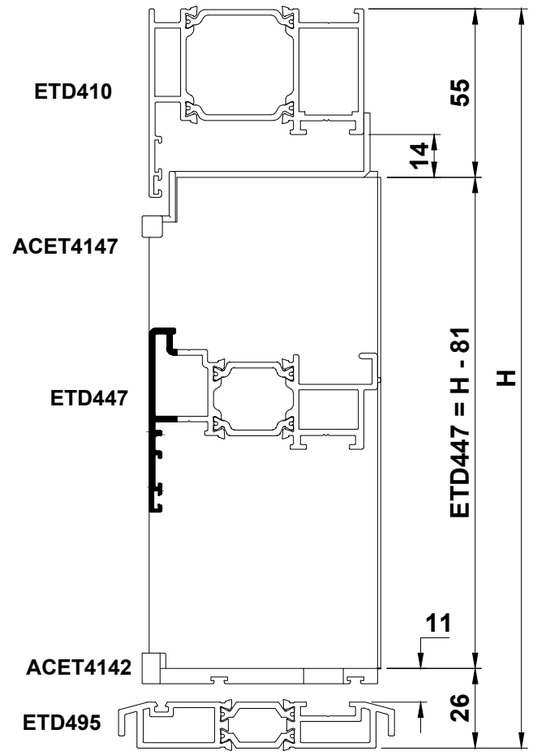


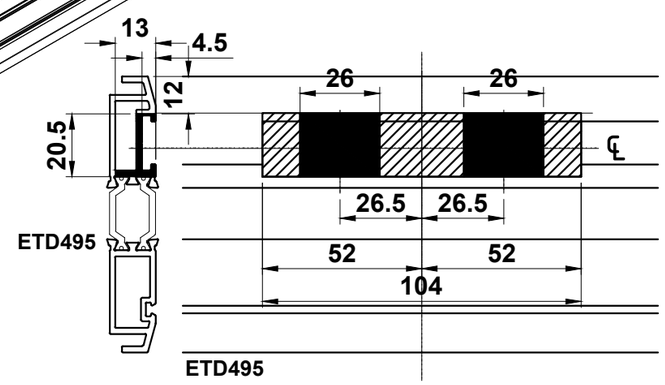
Note: All routing on low threshold require sealant to stop water leakage

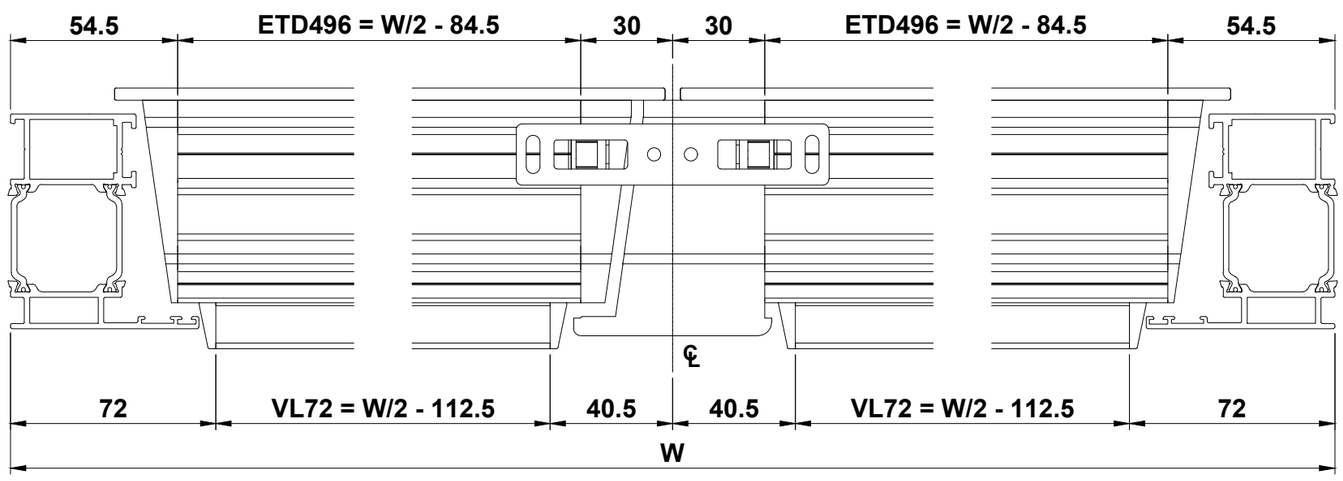
Fixings not shown for clarity



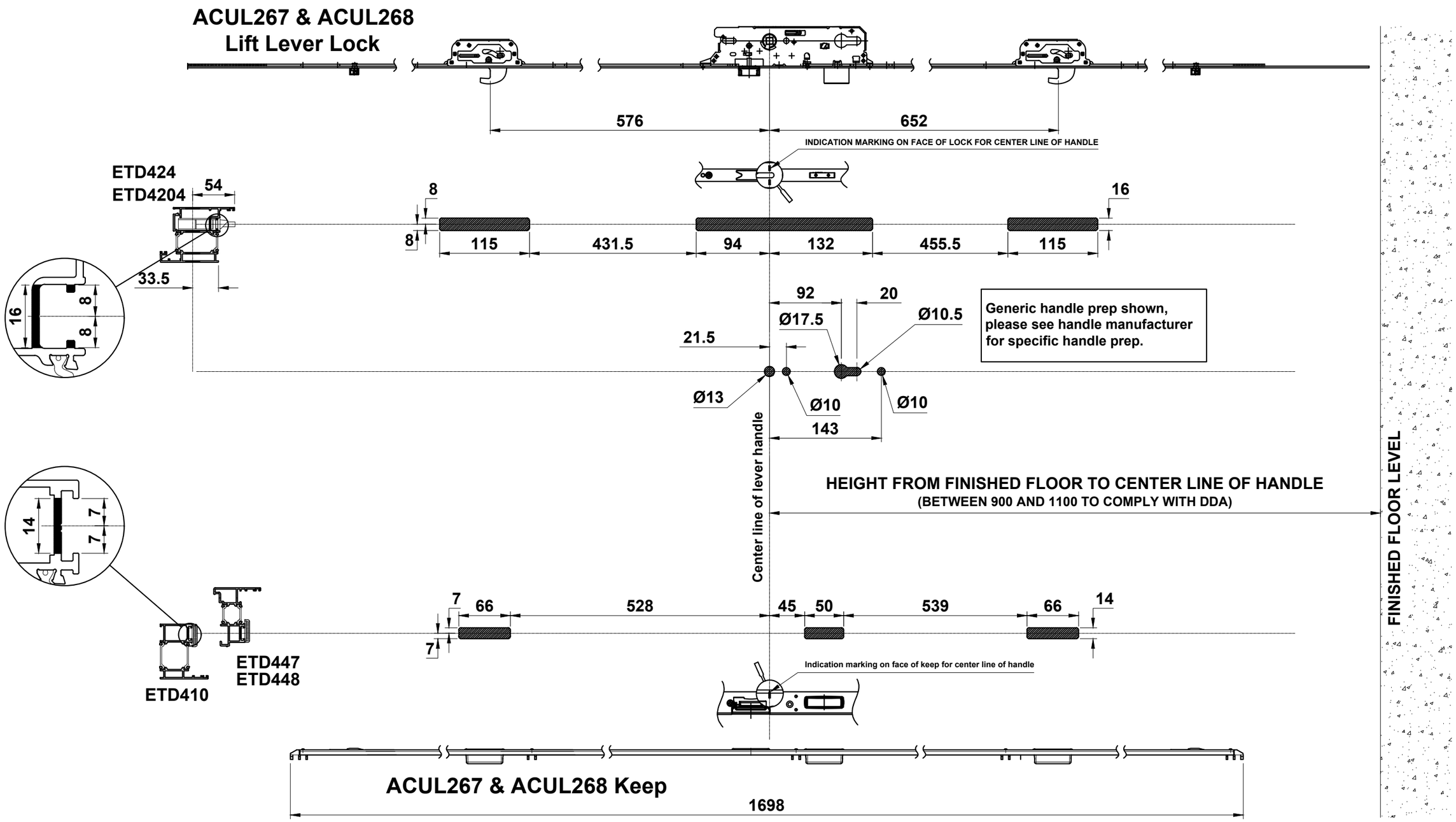






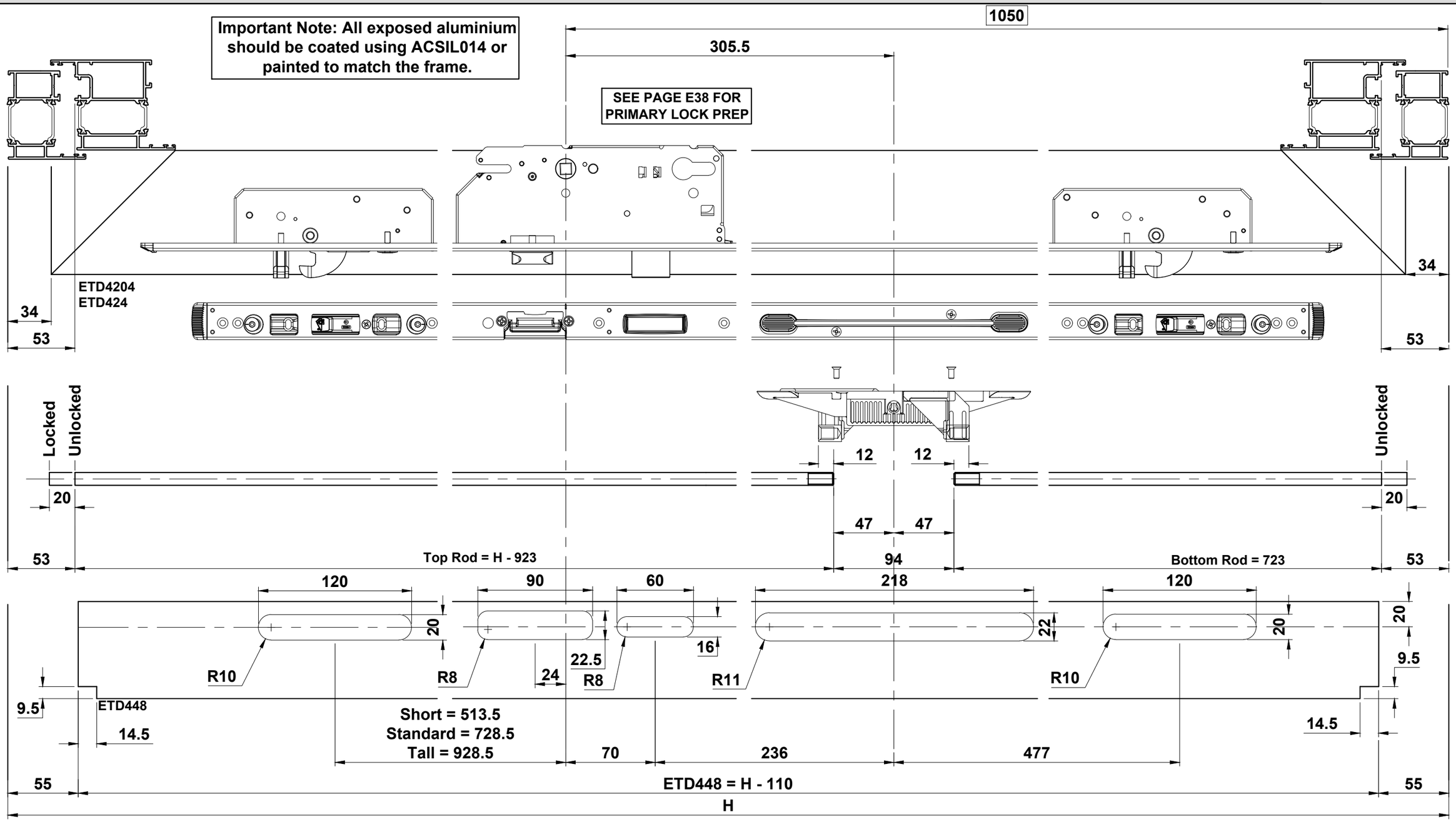


ACUL267 & ACUL268 Lift Lever Lock Preparation



Do Not Scale From This Drawing

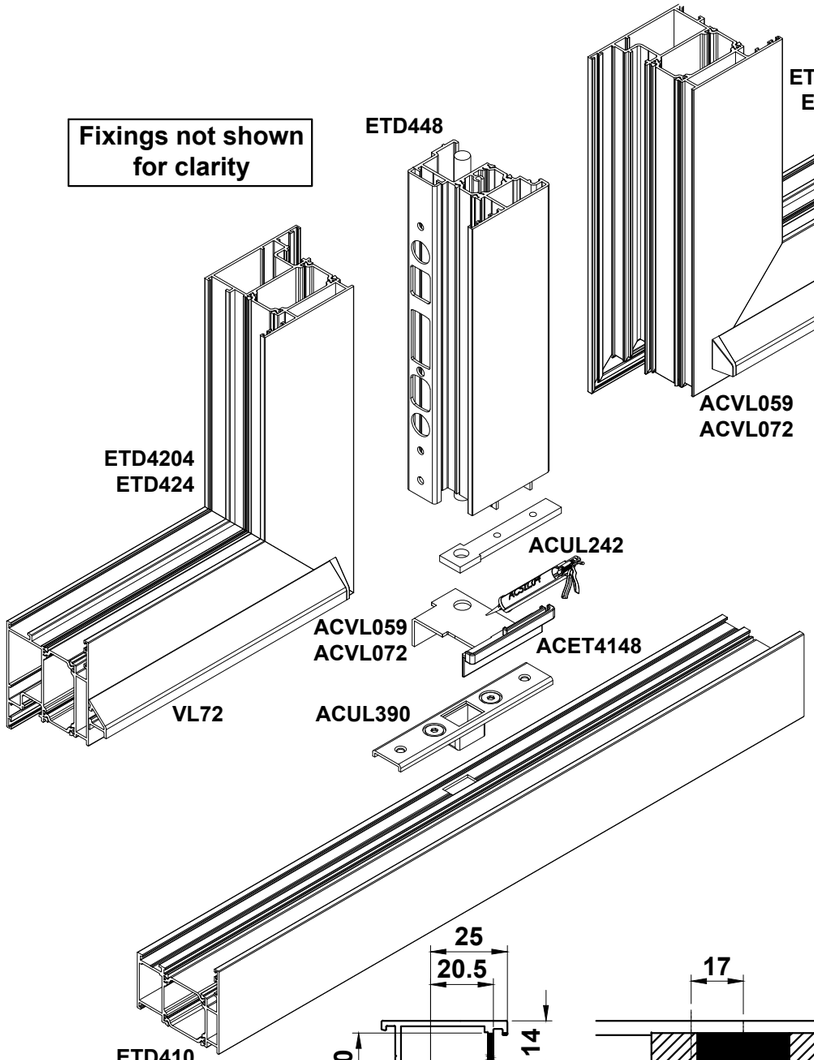
Double Door Finger Bolt Lock Preparation for Full Frame



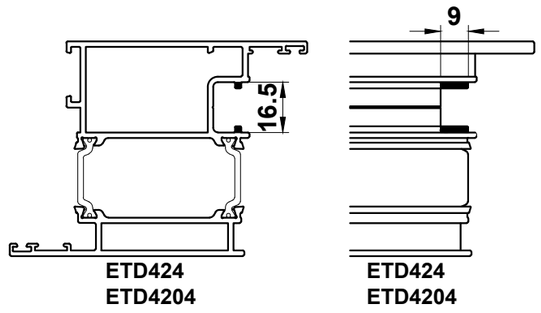
Do Not Scale From This Drawing

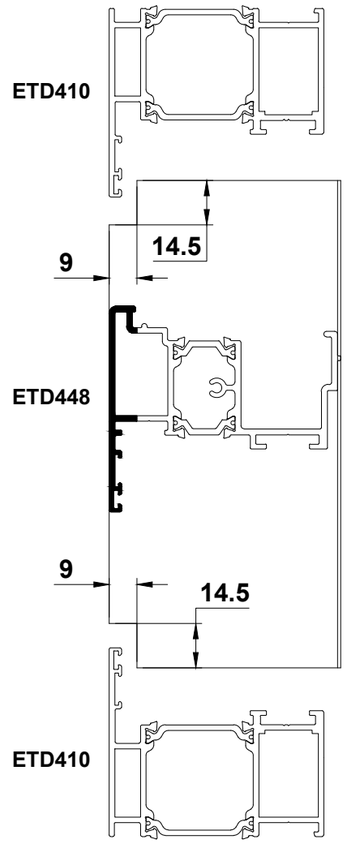
Double Door Finger Bolt Meeting Stile Assembly for Full Frame

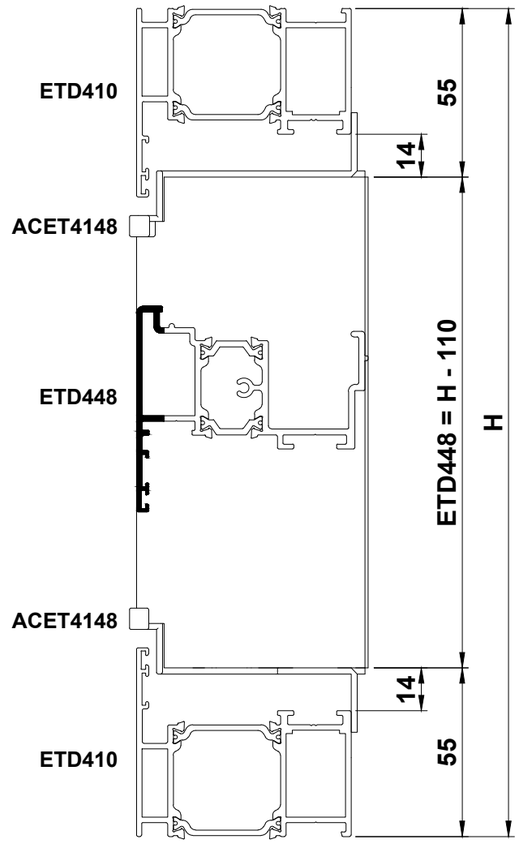
Fixings not shown for clarity



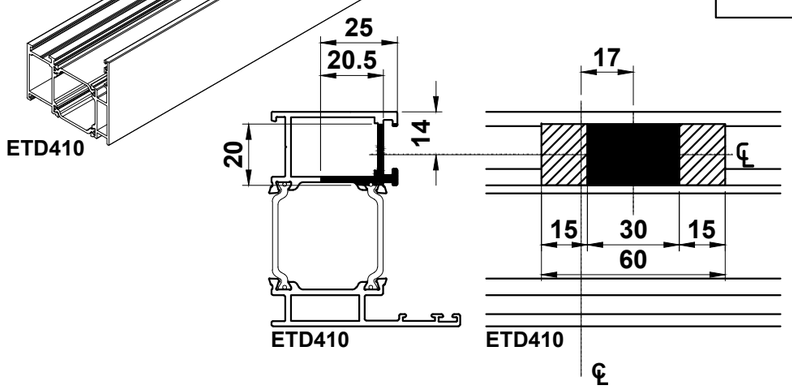
Sash to be notched to allow ACUL242 to fit into position

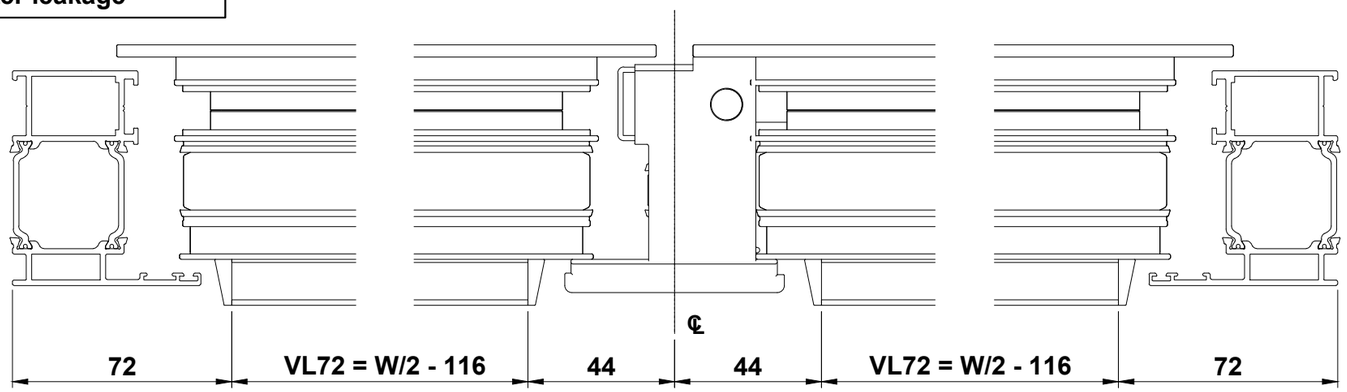






Note: All routing on outer frame require sealant to stop water leakage



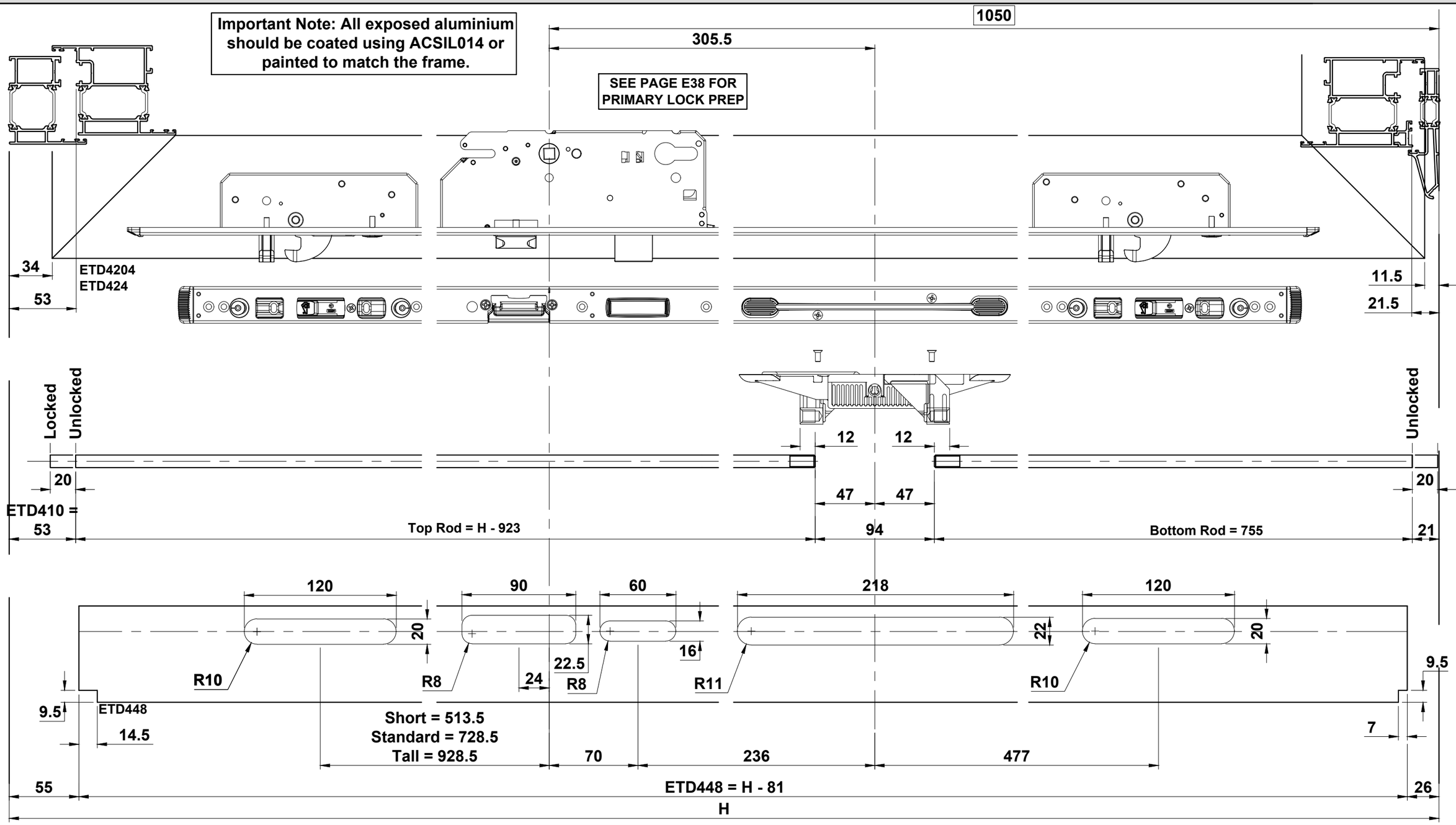


Do Not Scale From This Drawing

Double Door Finger Bolt Lock Preparation for Low Rebate Threshold

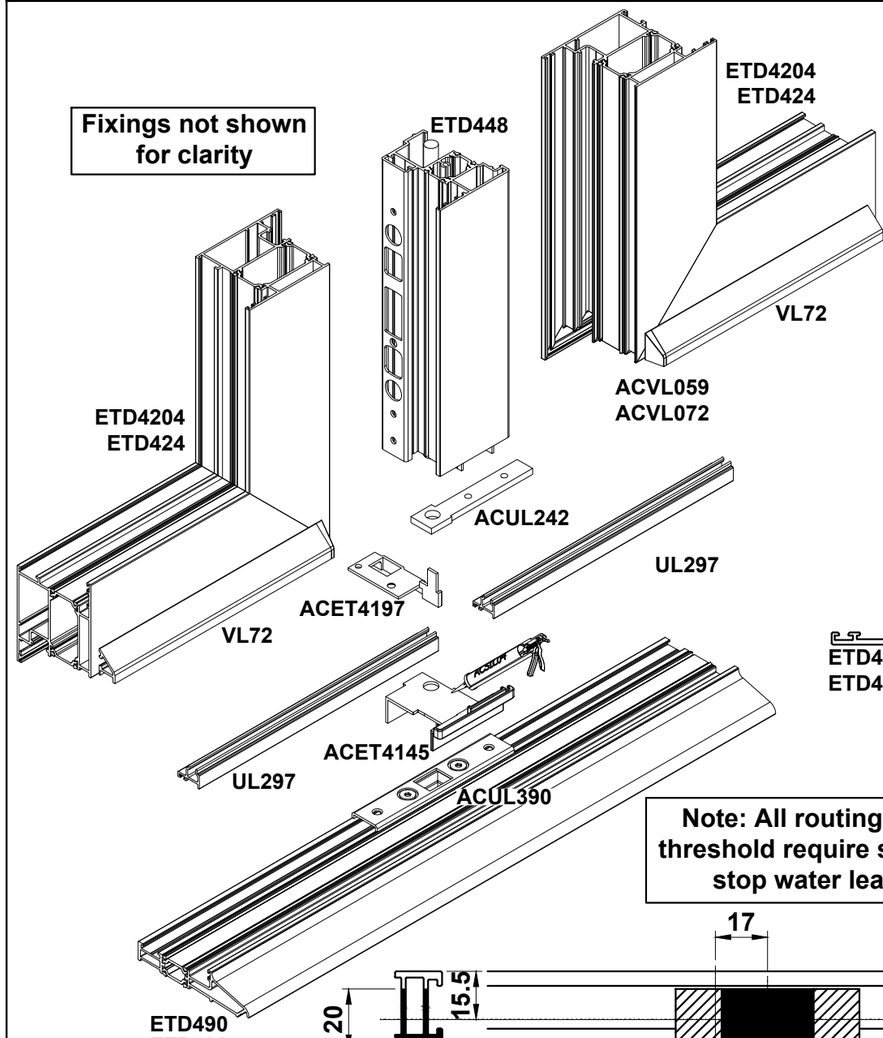
Important Note: All exposed aluminium should be coated using ACSIL014 or painted to match the frame.

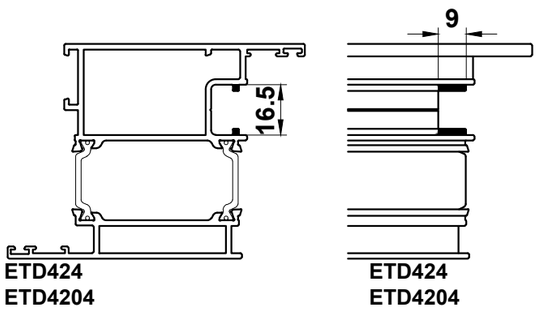
SEE PAGE E38 FOR PRIMARY LOCK PREP

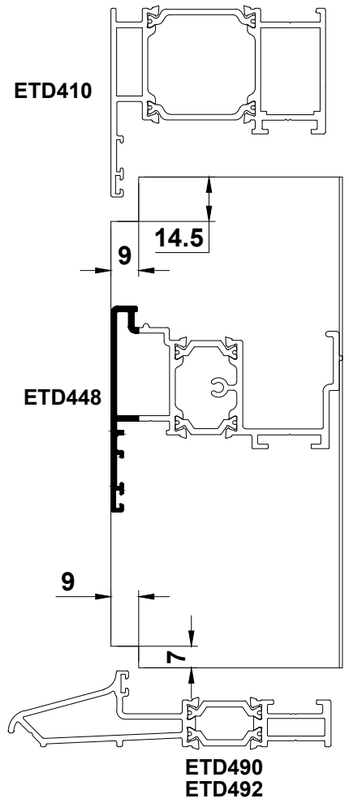


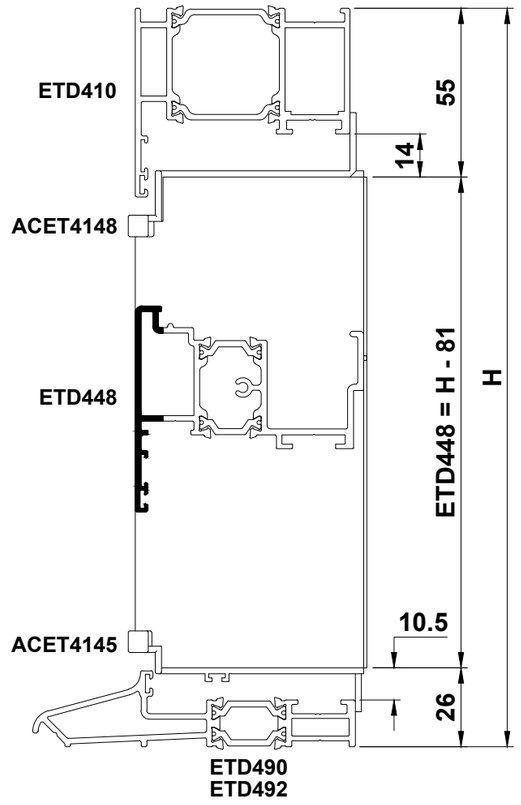
Alitherm 400 Stepped Door

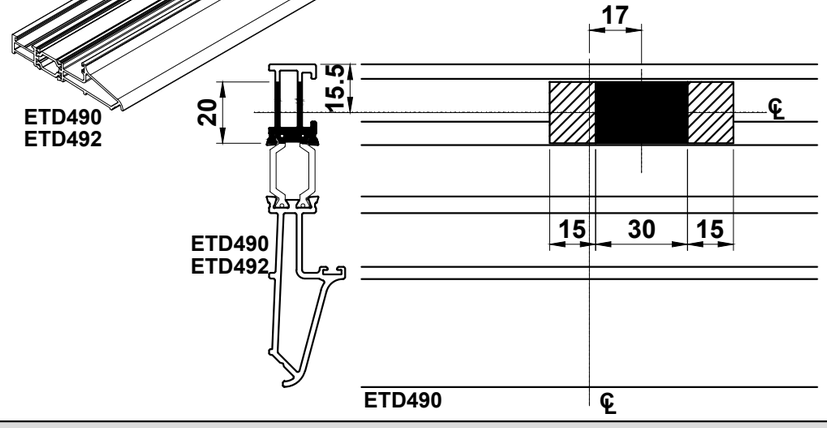
Double Door Finger Bolt Meeting Stile Assembly for Low Rebate Threshold

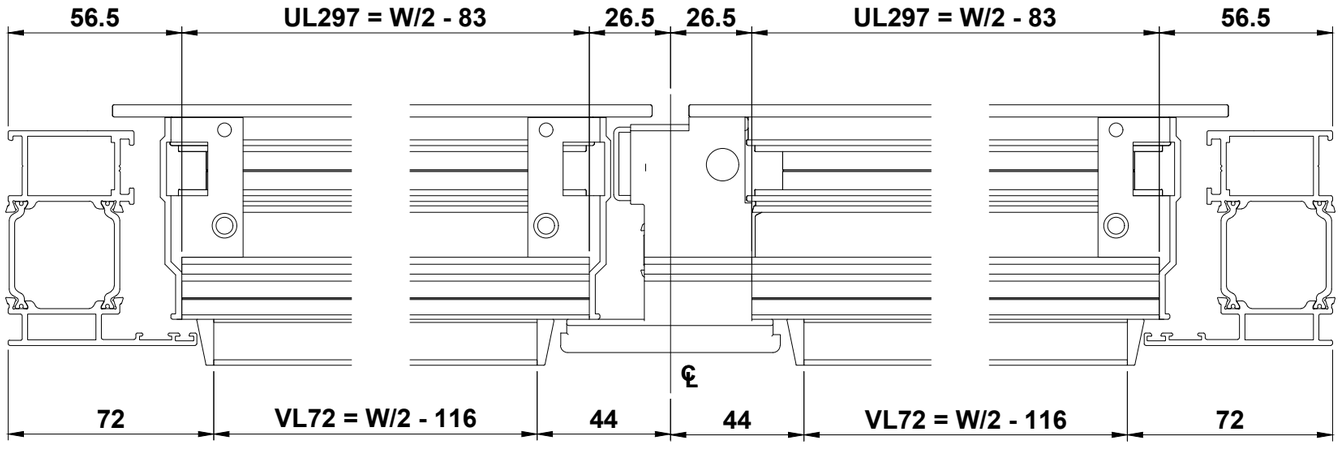








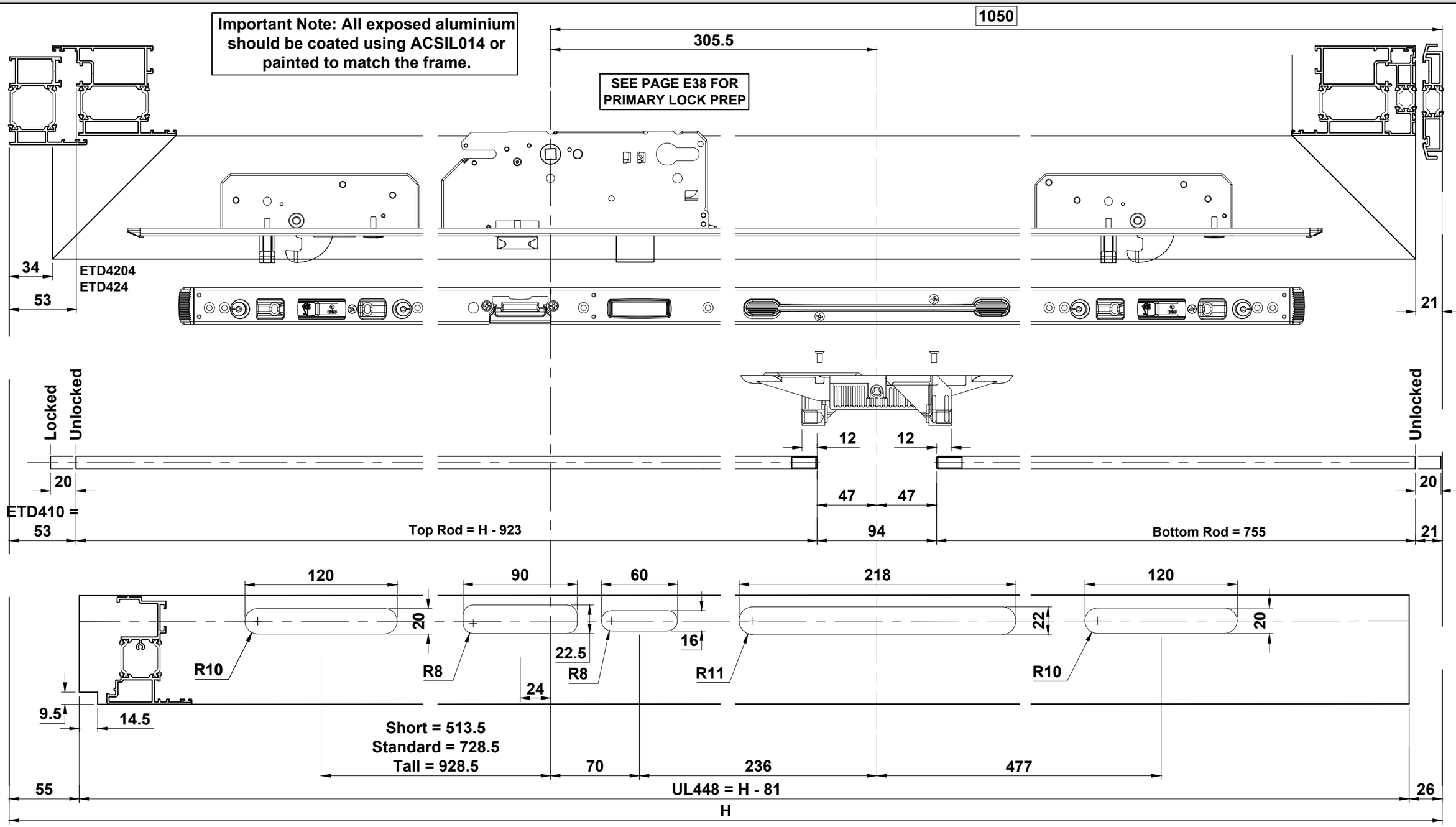




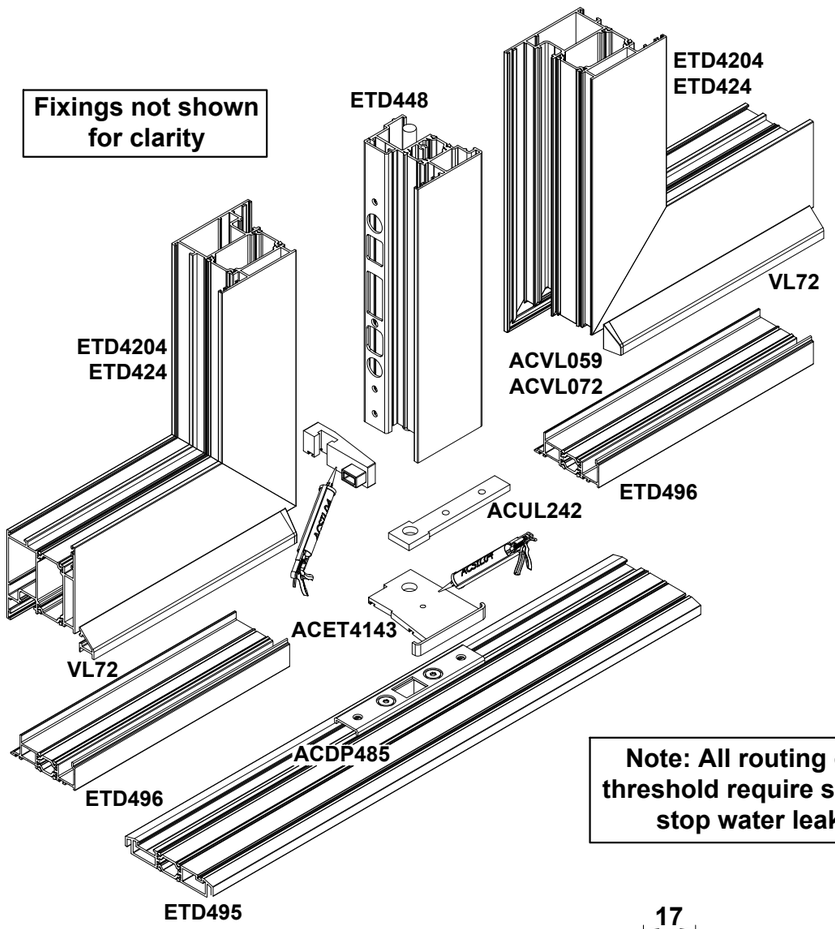
Do Not Scale From This Drawing

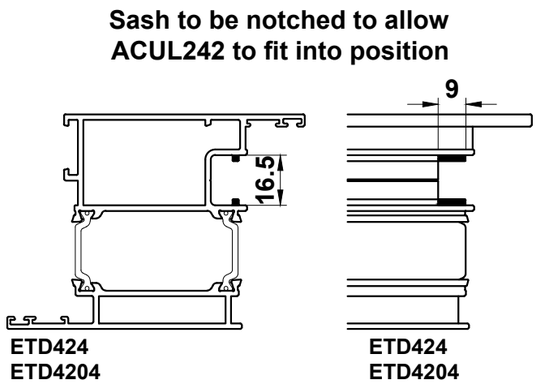
Double Door Finger Bolt Lock Preparation for Low Ramp Threshold

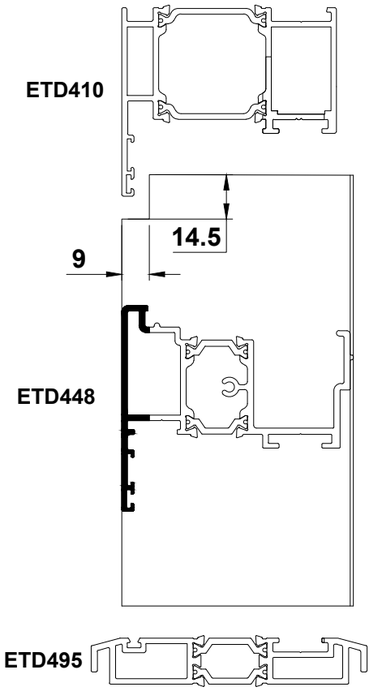
Important Note: All exposed aluminium should be coated using ACSIL014 or painted to match the frame.

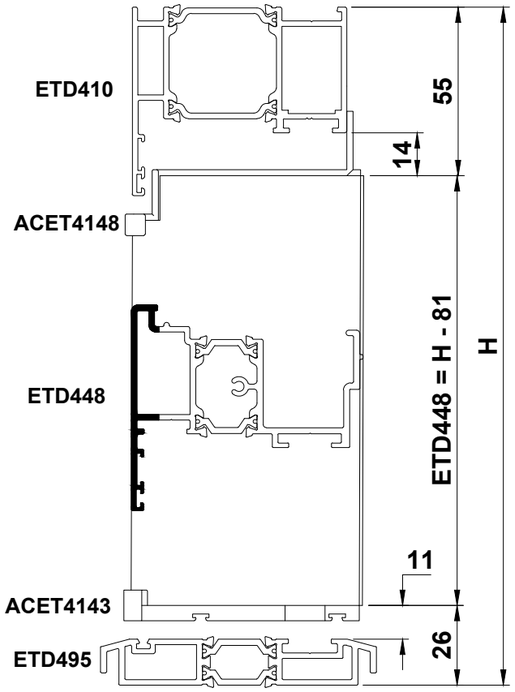


Double Door Lift Lever Meeting Stile Assembly for Low Rebate Threshold

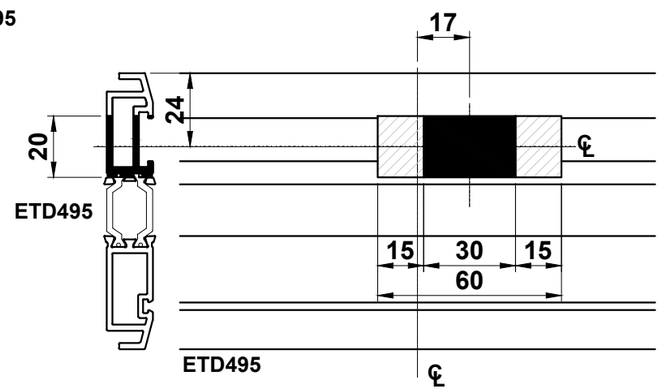


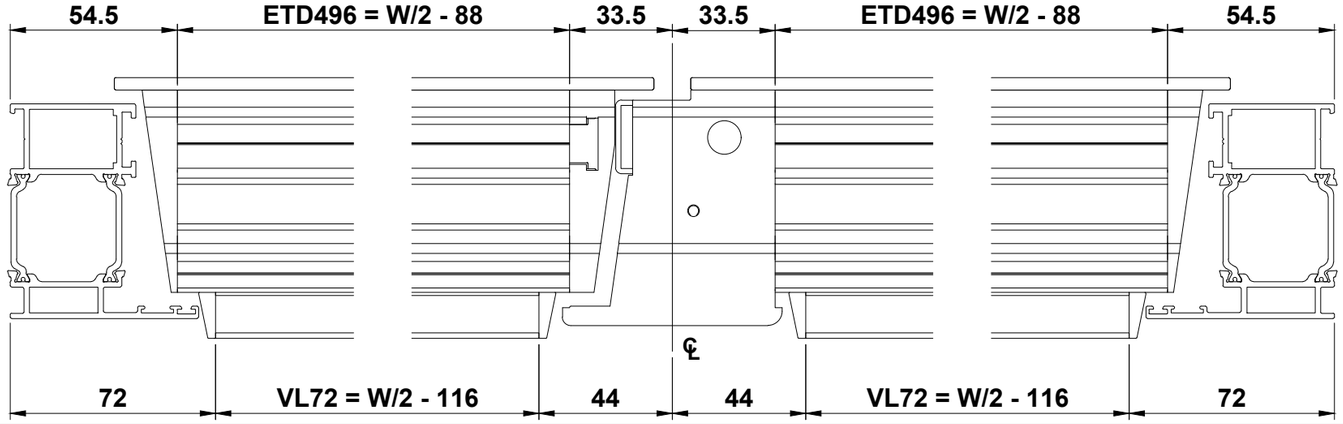






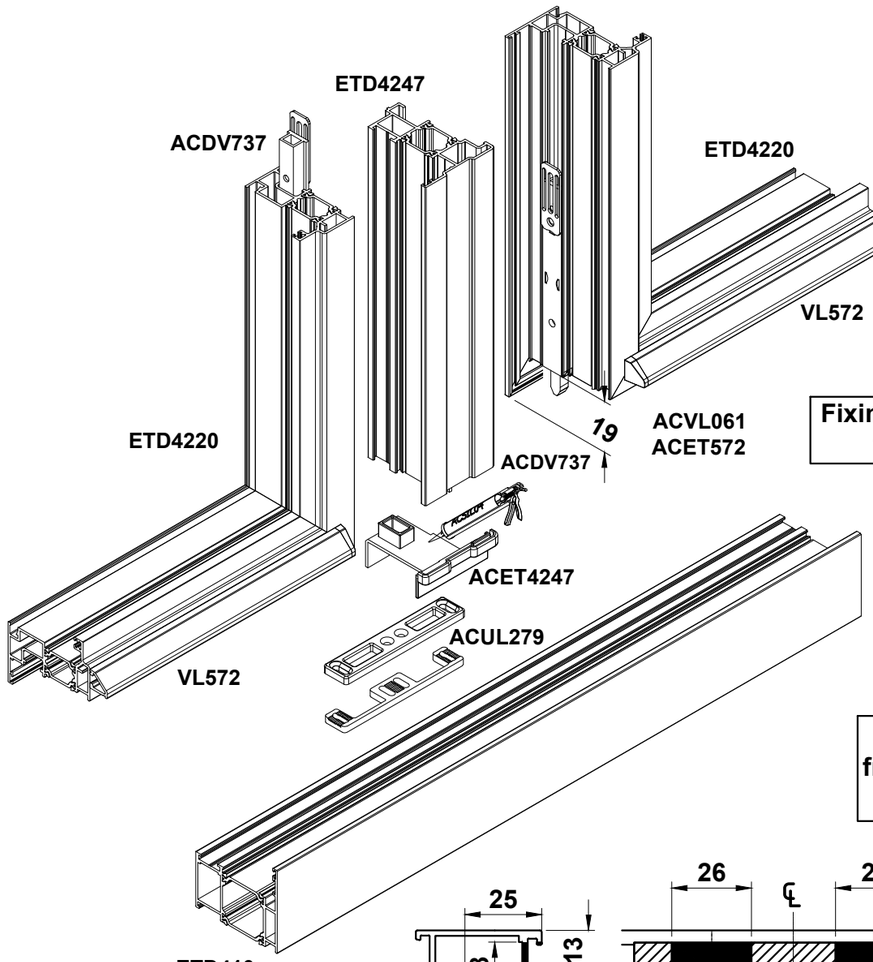
Note: All routing on low threshold require sealant to stop water leakage





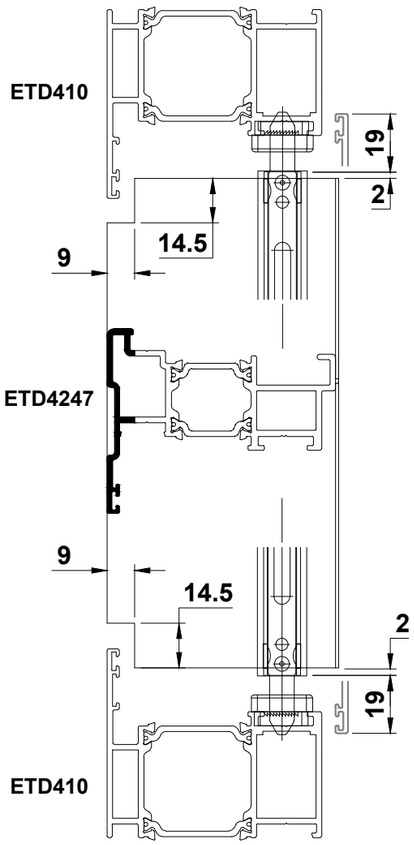
Do Not Scale From This Drawing

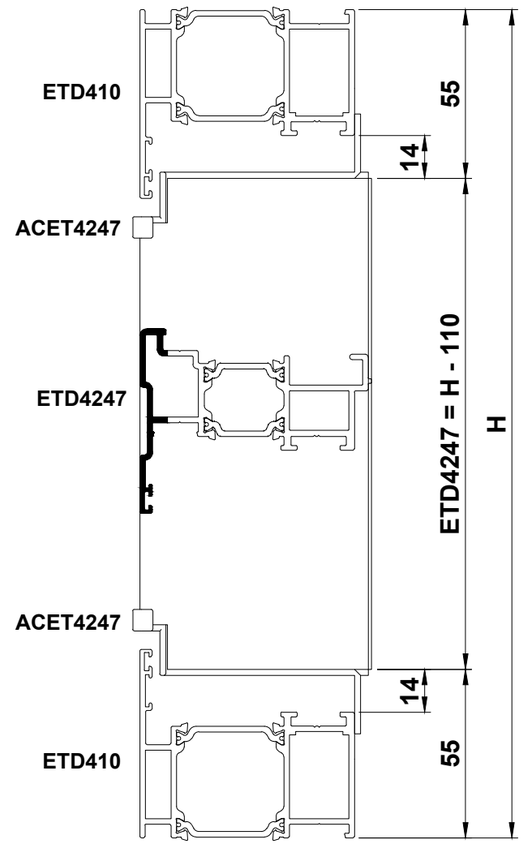
Heritage Double Door Lift Lever Meeting Stile Assembly for Full Frame

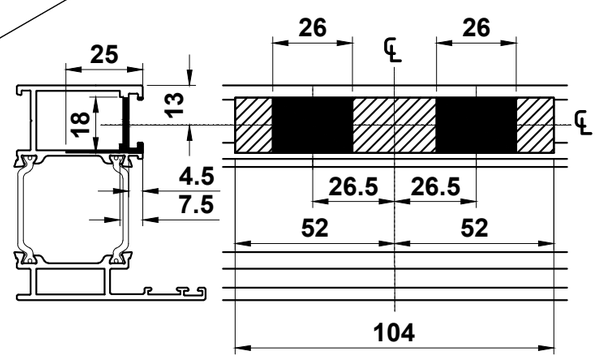


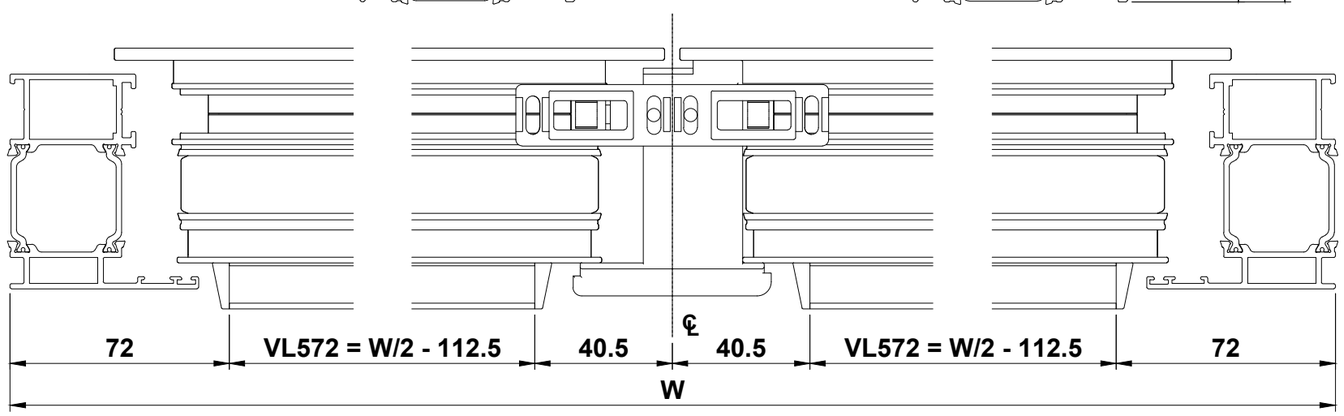
Fixings not shown for clarity

Note: All routing on outer frame require sealant to stop water leakage

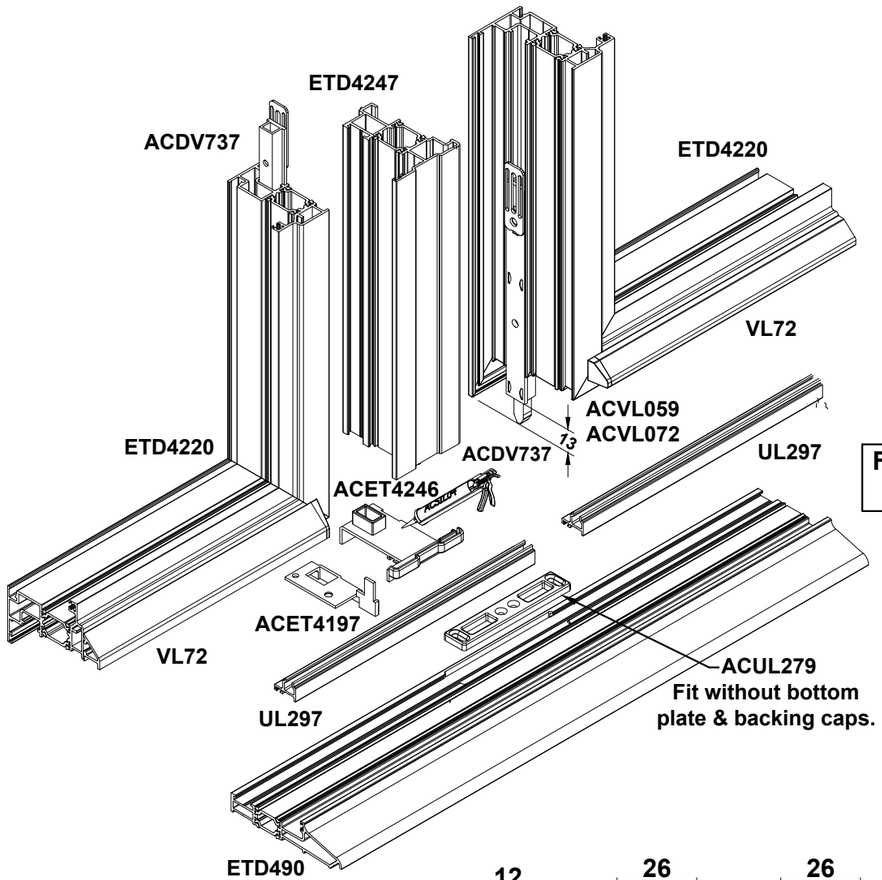




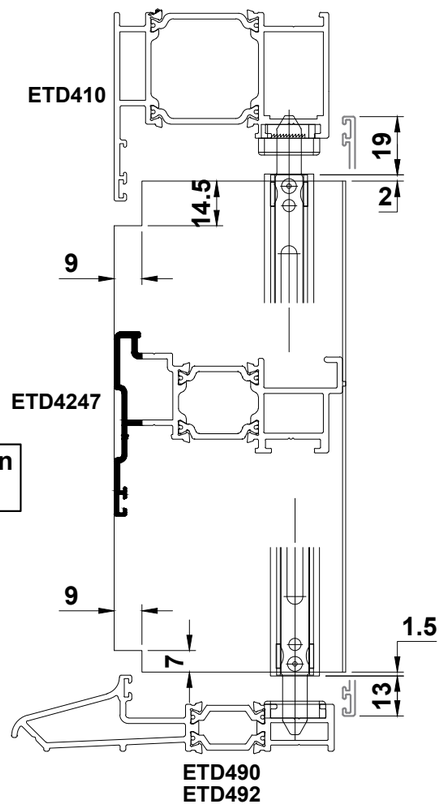


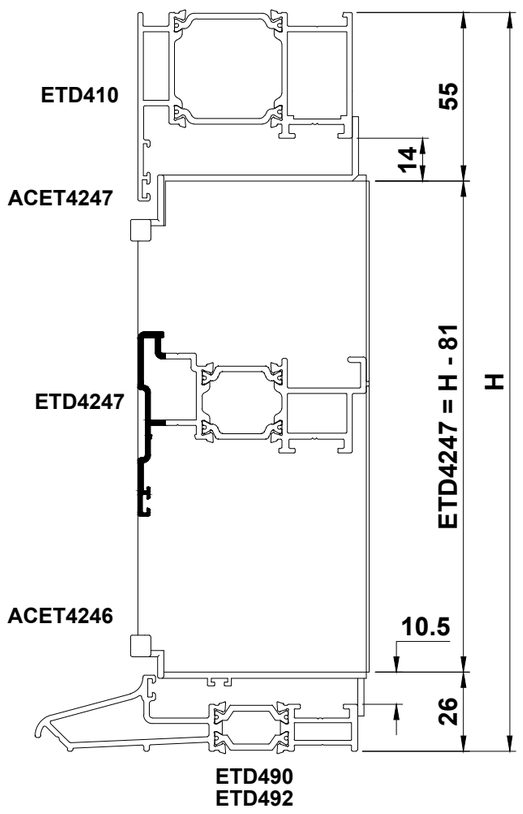


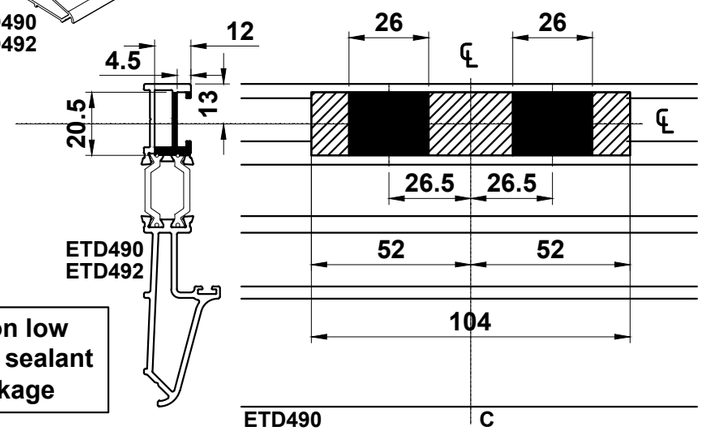
Heritage Double Door Lift Lever Meeting Stile Assembly for Low Rebate Threshold



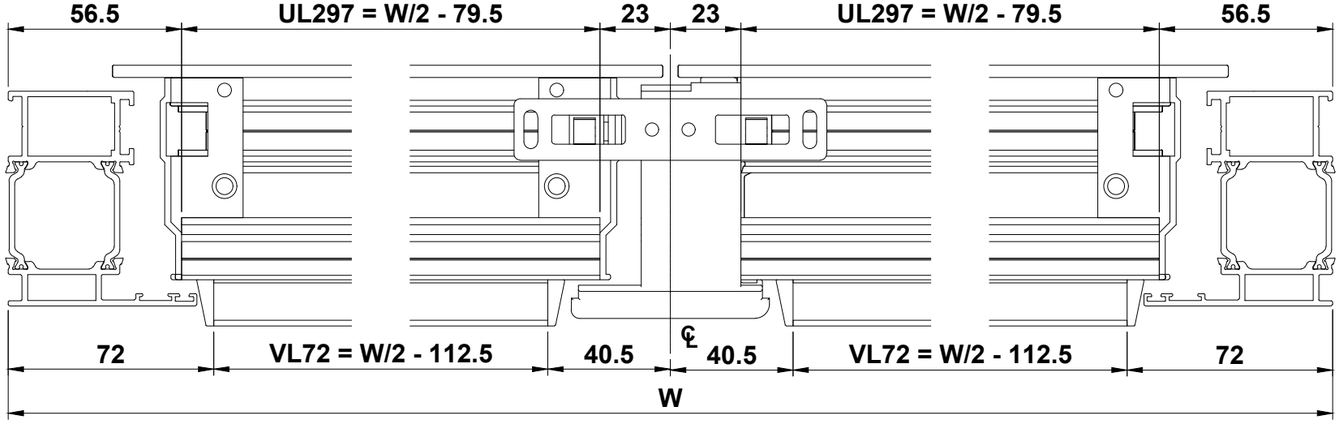
Fixings not shown for clarity





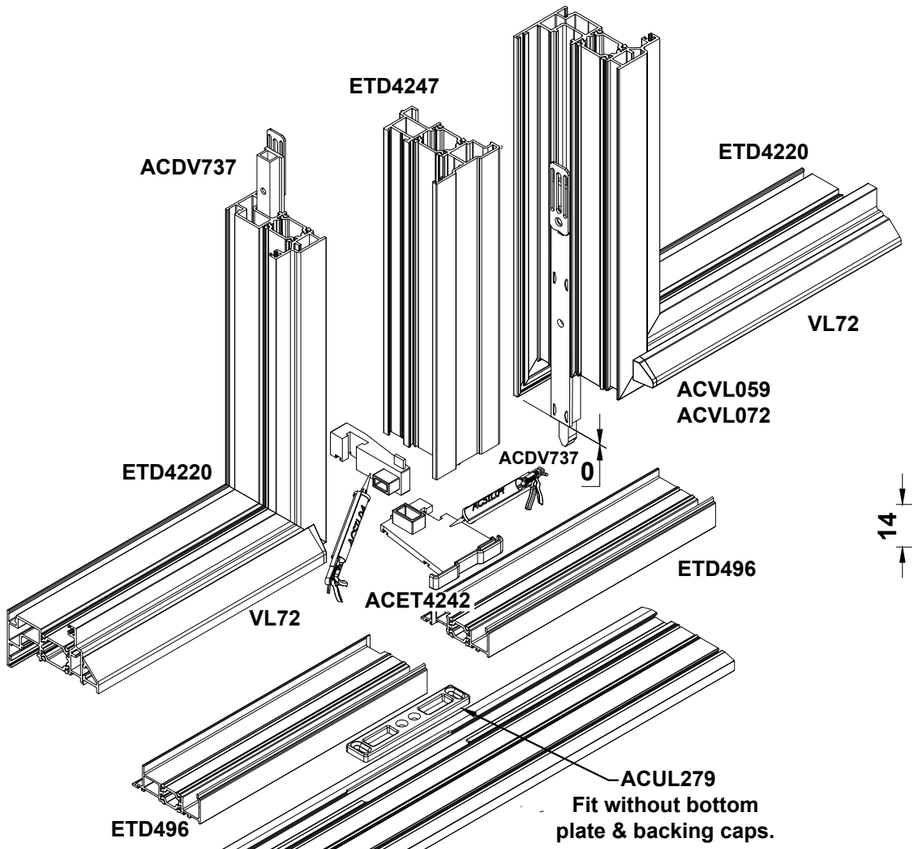


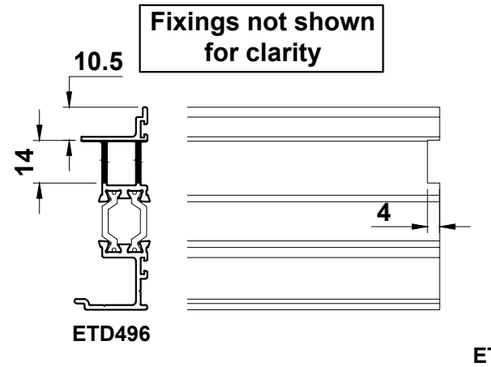
Note: All routing on low threshold to require sealant to stop water leakage

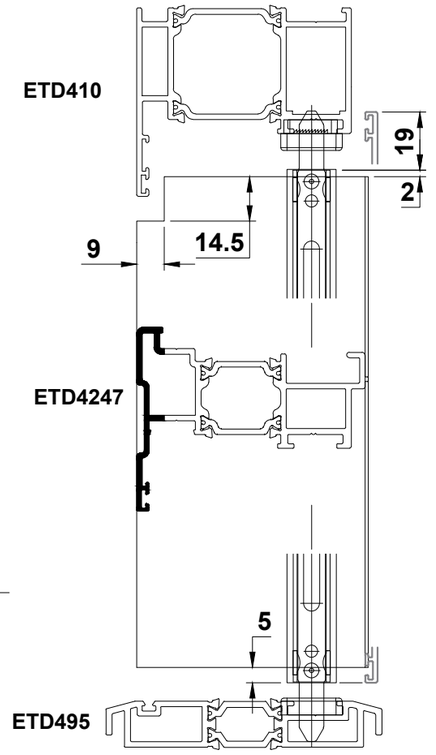


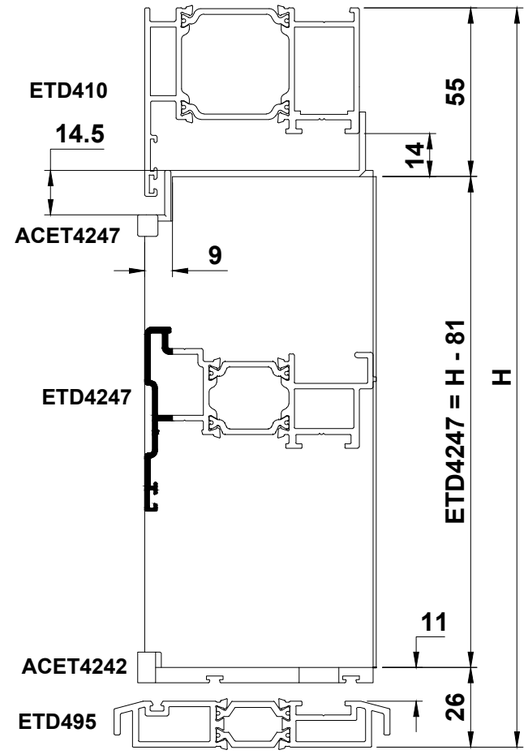
Do Not Scale From This Drawing

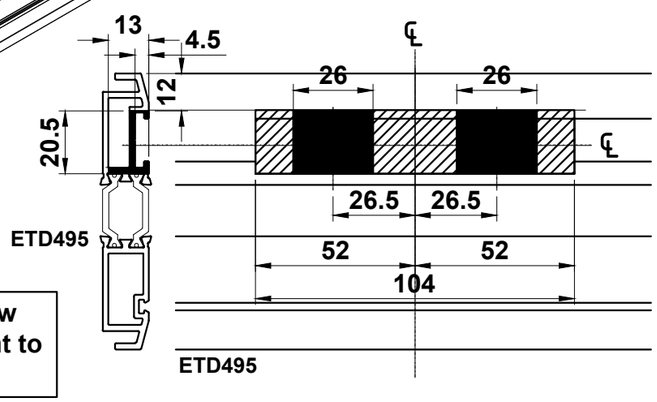
Heritage Double Door Lift Lever Meeting Stile Assembly for Low Ramp Threshold



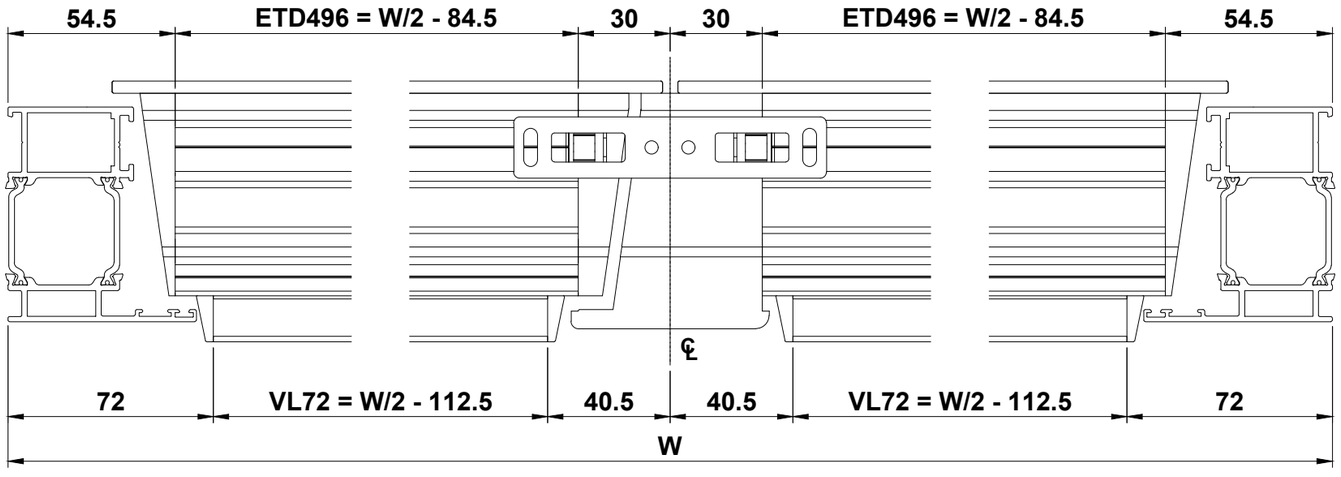








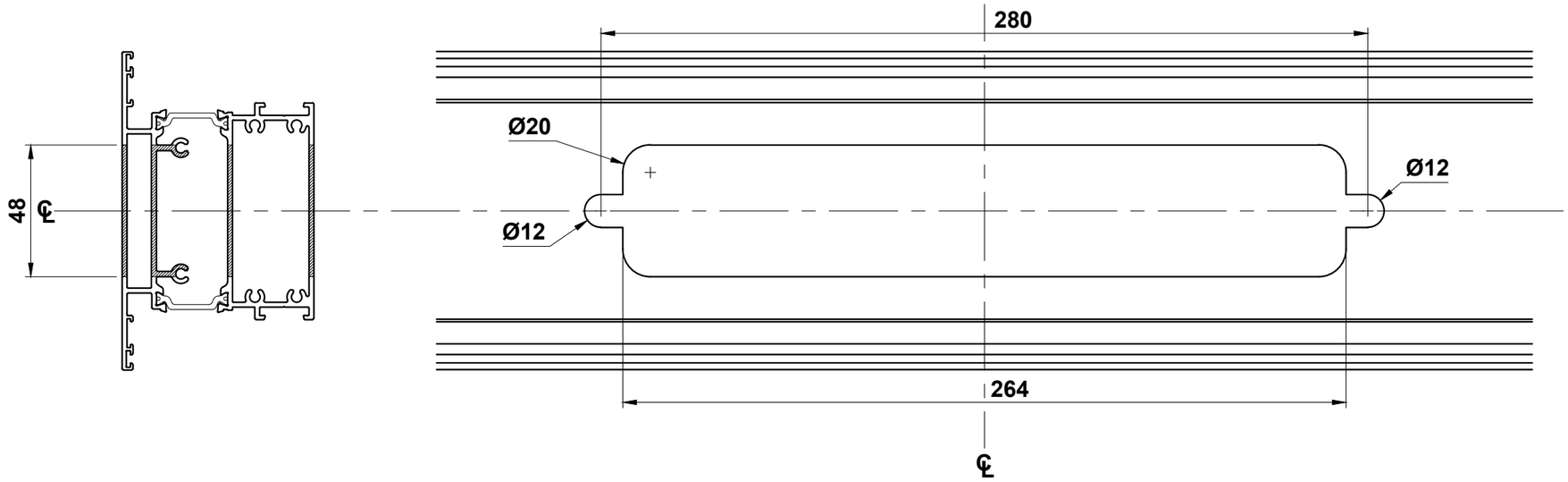
Note: All routing on low threshold require sealant to stop water leakage

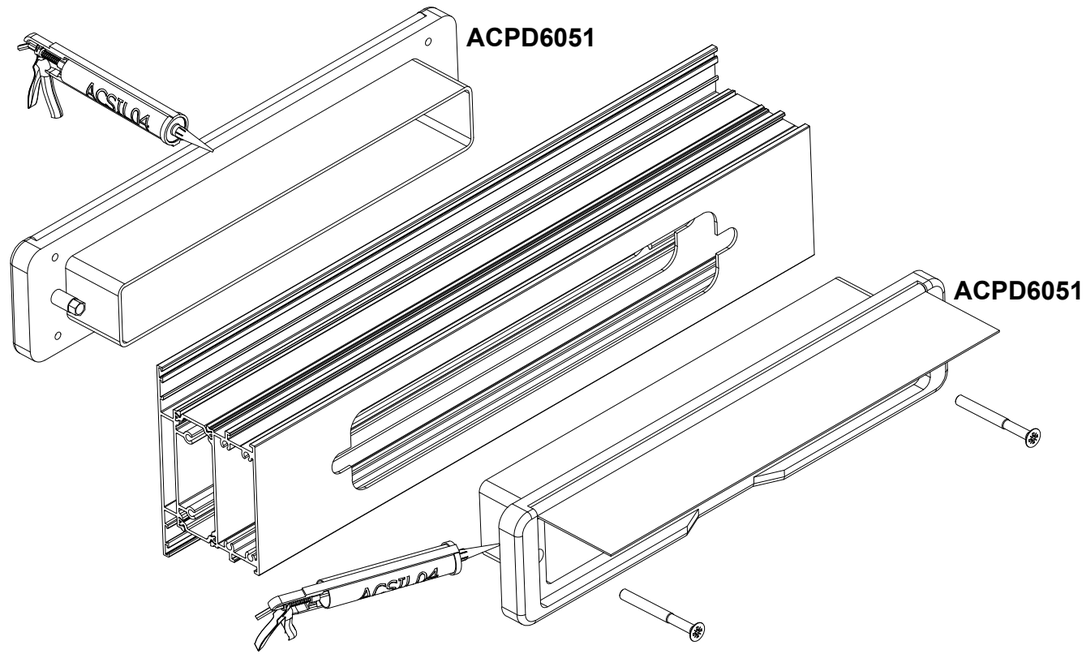


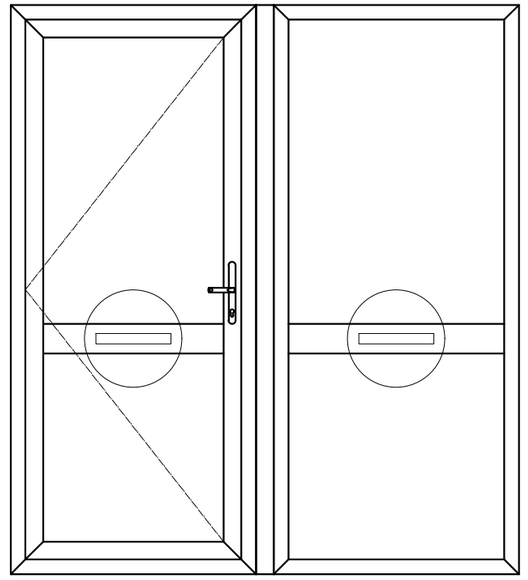
Do Not Scale From This Drawing

Alitherm 400 Stepped Door

Letter Plate Fitting







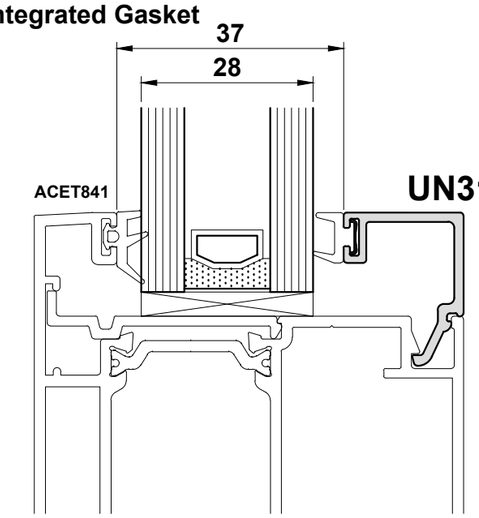
Do Not Scale From This Drawing

Alitherm 400 Stepped Door

Glazing Chart

28mm Glazing

Integrated Gasket

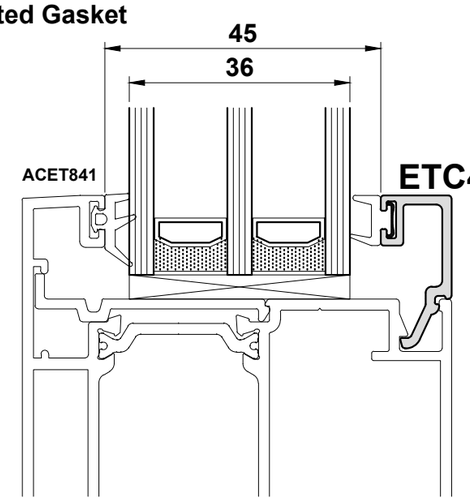


ETD402 ETD4204 ETD4203 ETD4301 ETD4305 ETD4220

Low Profile Gaskets		
Glazing Thickness	External Gasket	Internal Gasket
28	ACET841	-
29 (28.8)	ACET842	-

36mm Glazing

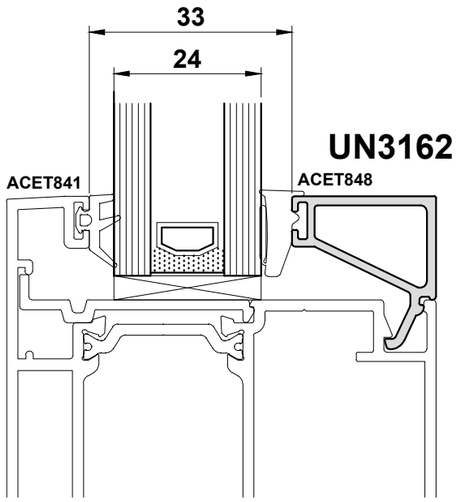
Integrated Gasket



ETD402 ETD4204 ETD4203 ETD4301 ETD4305 ETD4220

Low Profile Gaskets		
Glazing Thickness	External Gasket	Internal Gasket
36	ACET841	-
37	ACET842	-

24-26mm Glazing

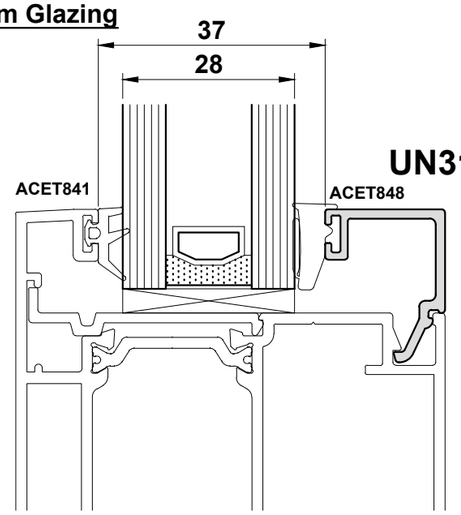


ETD402 ETD4204 ETD4203 ETD4301 ETD4305 ETD4220

Low Profile Gaskets		
Glazing Thickness	External Gasket	Internal Gasket
24	ACET841	ACET848
25	ACET842	ACET848
26	ACET843	ACET848

Standard Gaskets		
Glazing Thickness	External Gasket	Internal Gasket
24	ACVG31	ACUN036
25	ACVG231	ACUN036
26	ACVG231	ACUN036

28-30mm Glazing

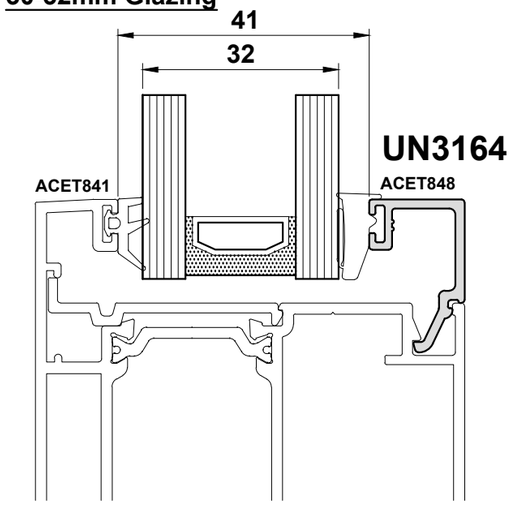


Low Profile Gaskets		
Glazing Thickness	External Gasket	Internal Gasket
28	ACET841	ACET848
29 (28.8)	ACET842	ACET848
30	ACET843	ACET848

Standard Gaskets		
Glazing Thickness	External Gasket	Internal Gasket
28	ACVG31	ACUN036
29 (28.8)	ACVG231	ACUN036
30	ACVG231	ACUN036

Glazing Chart

30-32mm Glazing

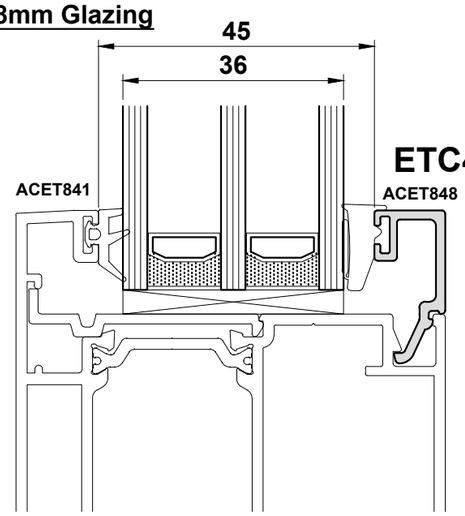


Low Profile Gaskets		
Glazing Thickness	External Gasket	Internal Gasket
30	ACET841	ACET848
31	ACET842	ACET848
32	ACET843	ACET848

Standard Gaskets		
Glazing Thickness	External Gasket	Internal Gasket
30	ACVG31	ACUN036
31	ACVG231	ACUN036
32	ACVG231	ACUN036

ETD402 ETD4204 ETD4203 ETD4301 ETD4305 ETD4220

36-38mm Glazing

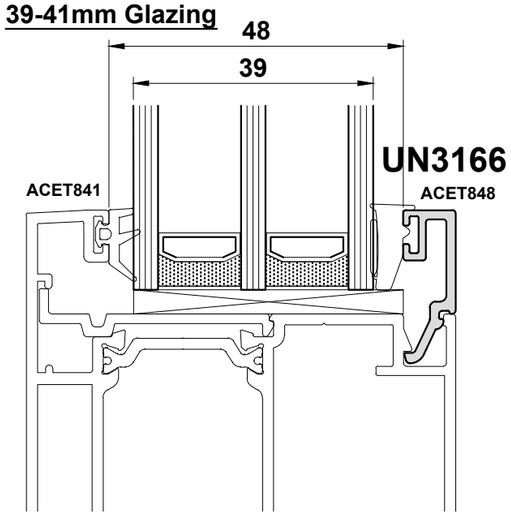


Low Profile Gaskets		
Glazing Thickness	External Gasket	Internal Gasket
36	ACET841	ACET848
37	ACET842	ACET848
38	ACET843	ACET848

Standard Gaskets		
Glazing Thickness	External Gasket	Internal Gasket
36	ACVG31	ACUN036
37	ACVG231	ACUN036
38	ACVG231	ACUN036

ETD402 ETD4204 ETD4203 ETD4301 ETD4305 ETD4220

39-41mm Glazing

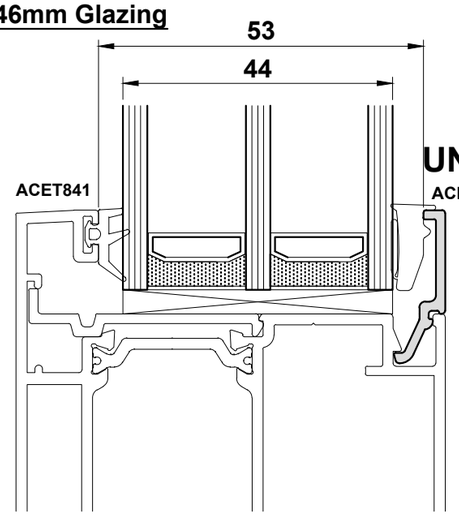


Low Profile Gaskets		
Glazing Thickness	External Gasket	Internal Gasket
39	ACET841	ACET848
40	ACET842	ACET848
41	ACET843	ACET848

Standard Gaskets		
Glazing Thickness	External Gasket	Internal Gasket
39	ACVG31	ACUN036
40	ACVG231	ACUN036
41	ACVG231	ACUN036

ETD402 ETD4204 ETD4203 ETD4301 ETD4305 ETD4220

44-46mm Glazing



Low Profile Gaskets		
Glazing Thickness	External Gasket	Internal Gasket
44	ACET841	ACET848
45	ACET842	ACET848
46	ACET843	ACET848

Standard Gaskets		
Glazing Thickness	External Gasket	Internal Gasket
44	ACVG31	ACUN036
45	ACVG231	ACUN036
46	ACVG231	ACUN036

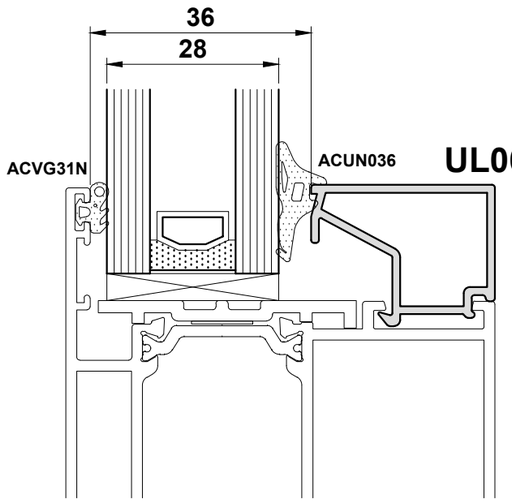
ETD402 ETD4204 ETD4203 ETD4301 ETD4305 ETD4220

Do Not Scale From This Drawing

Alitherm 400 Stepped Door

Glazing Chart

27-29mm Glazing

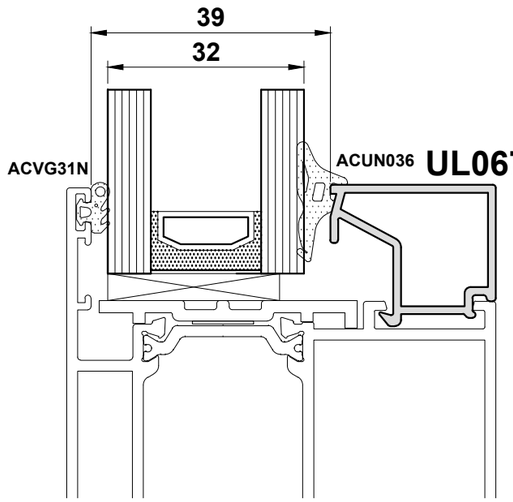


Low Profile Gaskets		
Glazing Thickness	External Gasket	Internal Gasket
27	ACET841	ACET848
28	ACET842	ACET848
29 (28.8)	ACET843	ACET848

Standard Gaskets		
Glazing Thickness	External Gasket	Internal Gasket
27	ACVG31N	ACUN036
28	ACVG231	ACUN036
29 (28.8)	ACVG231	ACUN036

ETD402 ETD4204 ETD4203 ETD4301 ETD4305 ETD4220

30-32mm Glazing

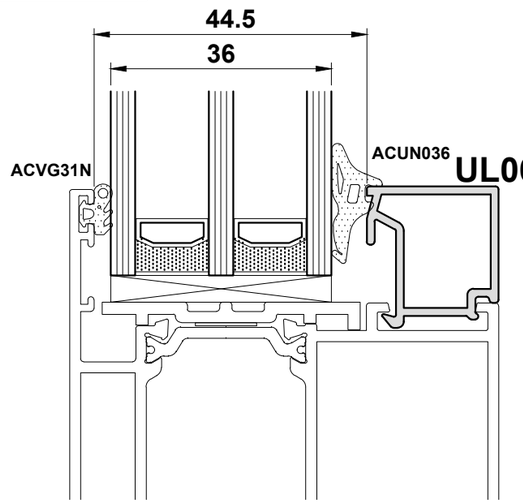


Low Profile Gaskets		
Glazing Thickness	External Gasket	Internal Gasket
30	ACET841	ACET848
31	ACET842	ACET848
32	ACET843	ACET848

Standard Gaskets		
Glazing Thickness	External Gasket	Internal Gasket
30	ACVG31N	ACUN036
31	ACVG231	ACUN036
32	ACVG231	ACUN036

ETD402 ETD4204 ETD4203 ETD4301 ETD4305 ETD4220

36mm Glazing

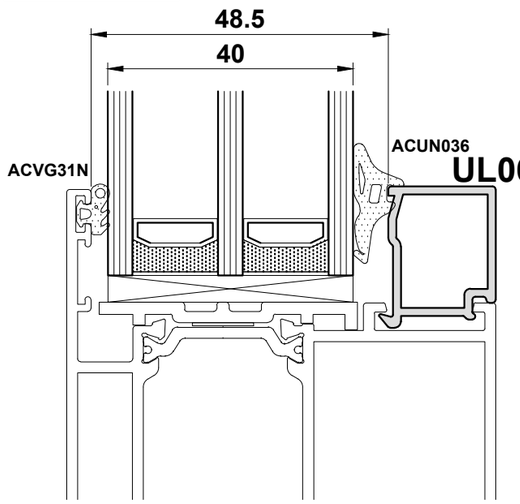


Low Profile Gaskets		
Glazing Thickness	External Gasket	Internal Gasket
35	ACET841	ACET848
36	ACET842	ACET848
37	ACET843	ACET848

Standard Gaskets		
Glazing Thickness	External Gasket	Internal Gasket
35	ACVG31N	ACUN036
36	ACVG231	ACUN036
37	ACVG231	ACUN036

ETD402 ETD4204 ETD4203 ETD4301 ETD4305 ETD4220

42mm Glazing



Low Profile Gaskets		
Glazing Thickness	External Gasket	Internal Gasket
39	ACET841	ACET848
40	ACET842	ACET848
41	ACET843	ACET848
42	ACET843	ACET848

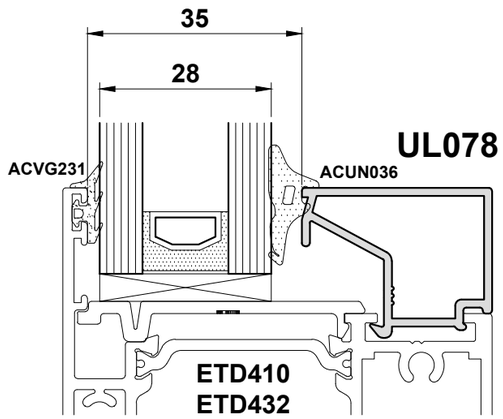
Standard Gaskets		
Glazing Thickness	External Gasket	Internal Gasket
39	ACVG31N	ACUN036
40	ACVG231	ACUN036
41	ACVG231	ACUN036
42	ACVG231	ACUN033

ETD402 ETD4204 ETD4203 ETD4301 ETD4305 ETD4220

Do Not Scale From This Drawing

Glazing Chart

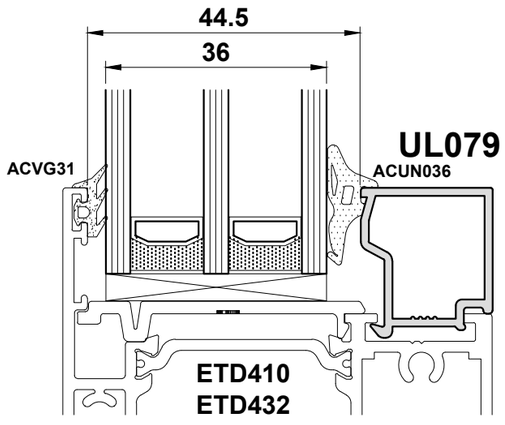
27-29mm Glazing



Low Profile Gaskets		
Glazing Thickness	External Gasket	Internal Gasket
27	ACET842	ACET848
28	ACET843	ACET848
29 (28.8)	ACET843	ACW20038

Standard Gaskets		
Glazing Thickness	External Gasket	Internal Gasket
27	ACVG231	ACUN036
28	ACVG231	ACUN036
29 (28.8)	ACVG231	ACUN033

36-38mm Glazing

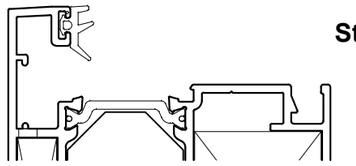


Low Profile Gaskets		
Glazing Thickness	External Gasket	Internal Gasket
36	ACET841	ACET848
37	ACET842	ACET848
38	ACET843	ACET848

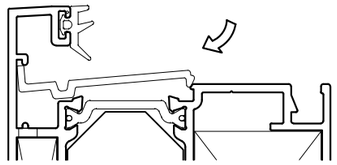
Standard Gaskets		
Glazing Thickness	External Gasket	Internal Gasket
36	ACVG31	ACUN036
37	ACVG231	ACUN036
38	ACVG231	ACUN036

Do Not Scale From This Drawing

Glazing Details

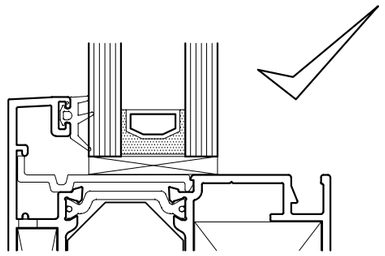


Step One. Install Captive Gasket
- Follow Gasket Configuration from pages E51 - E54

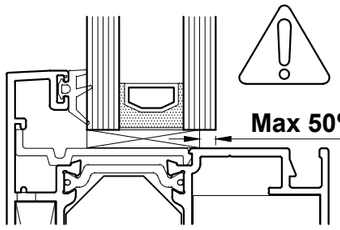


Step Two. Install Bridge Packer
- Follow Packer Placement diagrams

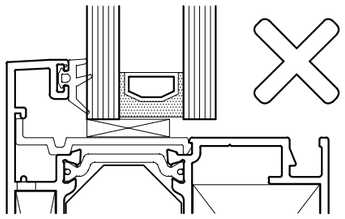
Step Three. Install Support Packer



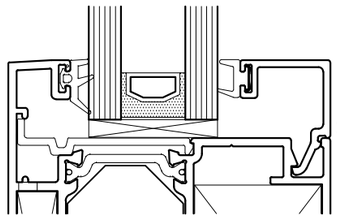
Ensure the packer supports both panes of glass



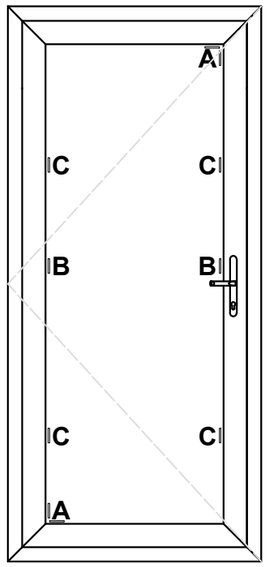
Minimium Packer Support Coverage 50%



Incorrect Support



Step Four. Install Glazing Beads
- Guidlines on Page E56



Door Packer Placement

Standard

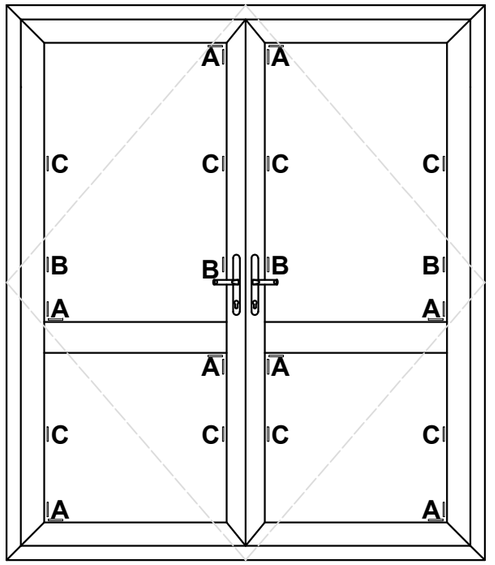
A Toe & Heel Packing Points

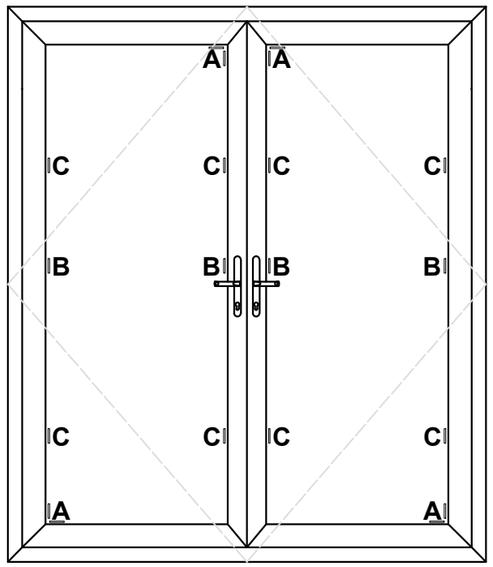
PAS24

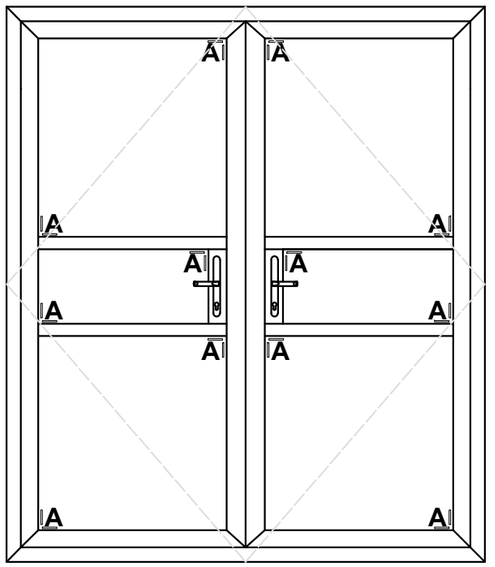
B Latch Packing Points

C Locking Packing Points

Note:- When packing around the locking/latch points. Pack adjescent on the hinge side.





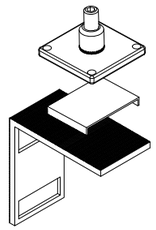


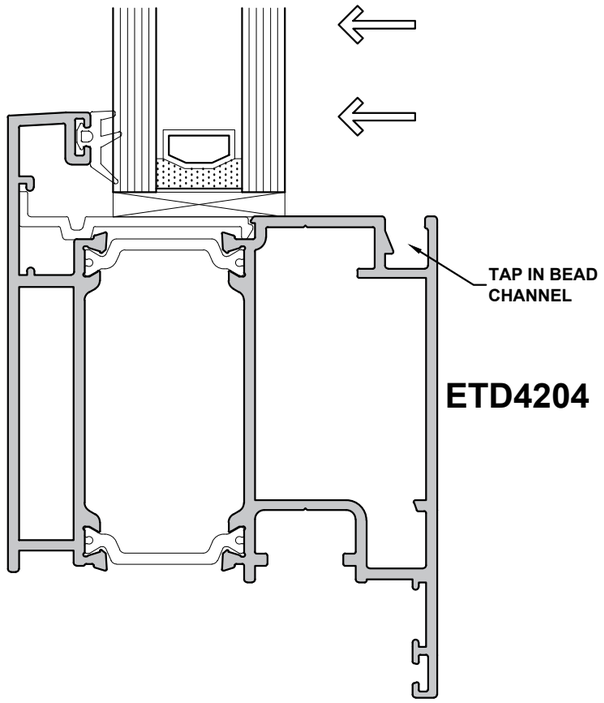
Quick-Glaze Bead Installation

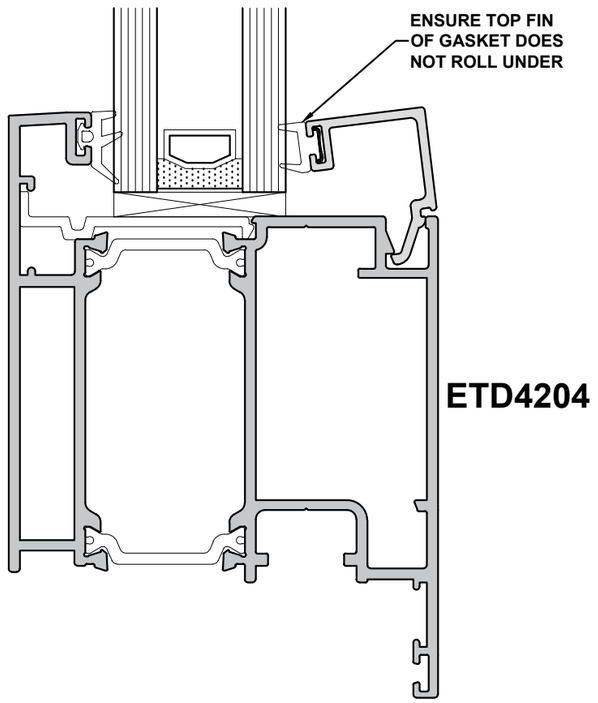
QUICK-GLAZE BEAD INSTALLATION

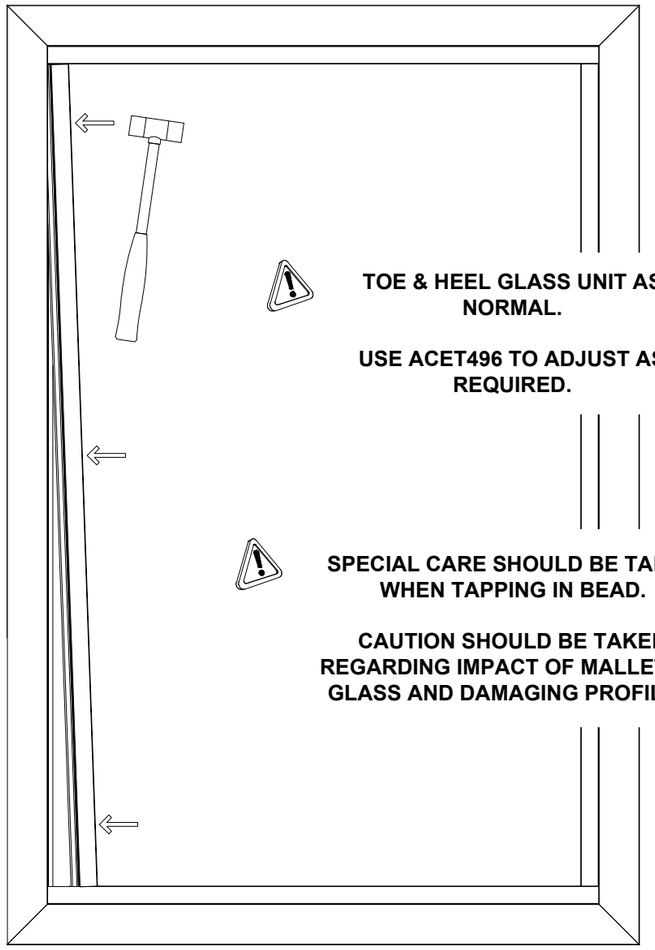
1. INSTALL GLASS UNIT, ENSURING IT HAS BEEN PUSHED FORWARD TO ENGAGE COMPRESSION OF E GASKET.
2. BEGINNING WITH HORIZONTAL BEADS, LOCATE BEAD IN CLIP CHANNEL OF SASH AS SHOWN. INTEGRATED GASKET MAY REST AGAINST GLASS UNIT.
3. APPLY FIRM PRESSURE TO THE BEAD TO HOLD IN POSITION. THIS MAY CAUSE THE BEAD 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 ACET496 GLASS ADJUSTERS WHEN USING QUICK-GLAZE BEADS. THIS WILL REMOVE THE NEED TO REMOVE BEADS IN ORDER TO ADJUST GLASS POSITION.









Do Not Scale From This Drawing

Quick-Glaze Bead Removal

KEEP INTEGRATED GASKET

QUICK-GLAZE BEAD REMOVAL

1. STARTING ON VERTICAL BEADS, APPLY PRESSURE TO BEAD IN DIRECTION SHOWN IN ORDER TO CREATE SMALL GAP BETWEEN SASH AND BEAD.
2. GENTLY INSERT DE-GLAZING TOOL TAKING PARTICULAR CARE AS NOT TO DAMAGE PAINT FINISH.
3. SLOWLY PRISE THE BEAD UP AND AWAY FROM THE SASH.
4. THE BEAD SHOULD NOW BE EASILY REMOVABLE FROM QUICK-GLAZE BEAD CHANNEL IN SASH

BEAD AND INTEGRATED GASKET CAN BE REUSED.

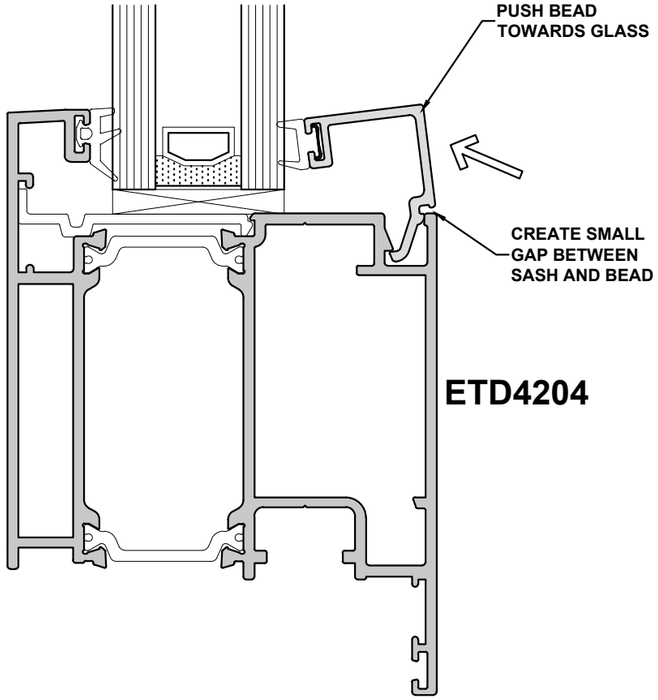
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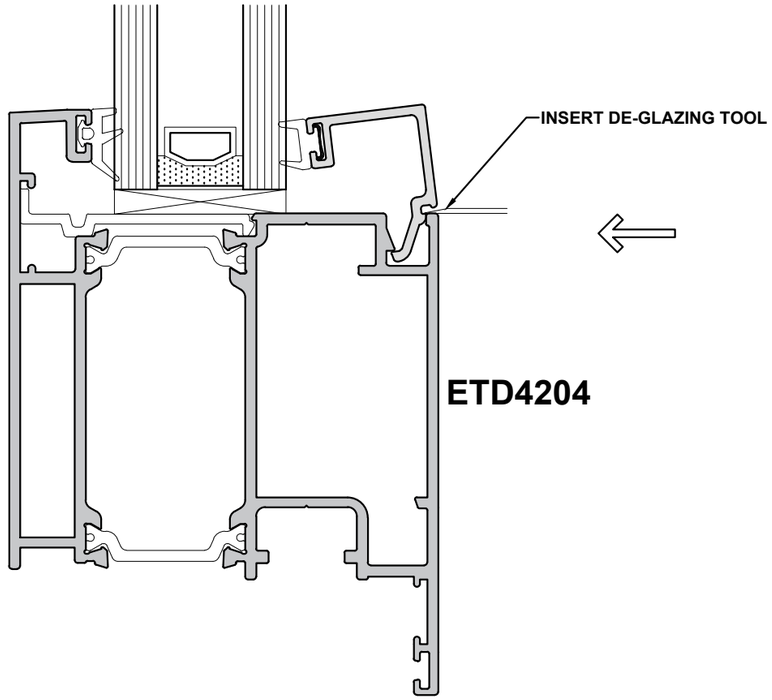
REPLACE INTEGRATED GASKET

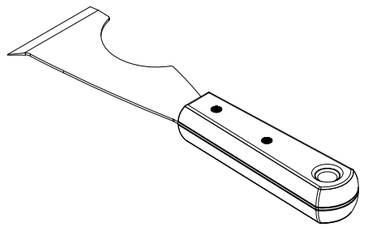
QUICK-GLAZE BEAD REMOVAL

1. USING SMALL FLAT HEADED SCREWDRIVER OR SIMILAR, WEDGE TIP BETWEEN CO EXTRUDED GASKET AND ALUMINIUM.
2. IN A LEVERING MOTION, PRISE THE GASKET AWAY FROM THE ALUMINIUM. PARTICULAR CARE SHOULD BE TAKEN NOT TO DAMAGE THE GLASS UNIT AND ALUMINIUM.
3. COMPLETE THIS AT SEVERAL LOCATIONS ALONG THE LENGTH OF THE BEAD.
4. REMOVE GASKET AND DISCARD. THIS GASKET CAN NO LONGER BE USED.
5. THE BEAD SHOULD NOW BE EASILY REMOVABLE FROM TAP IN BEAD CHANNEL IN SASH

PLEASE SEE GLAZING CHART FOR REPLACEMENT GASKET CODES.

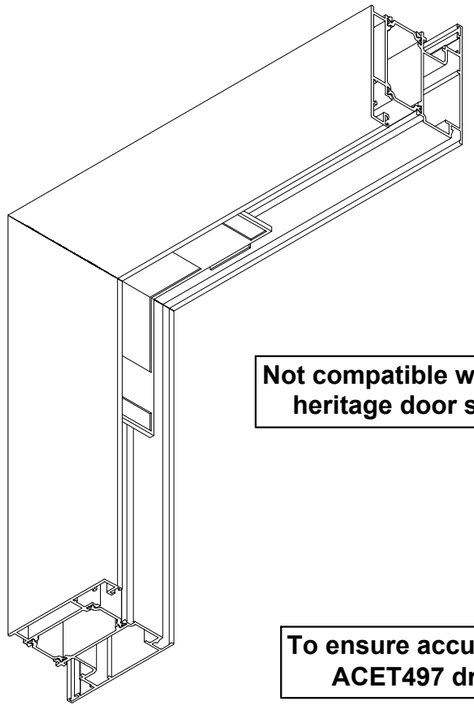




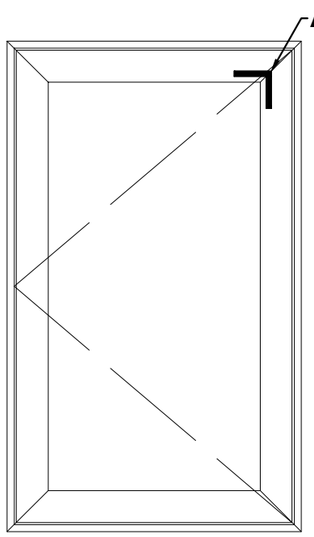


Alitherm 400 Stepped Door

ACET496 Glass Adjuster

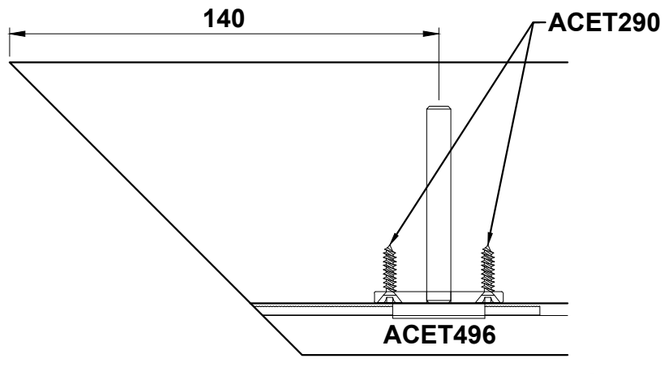


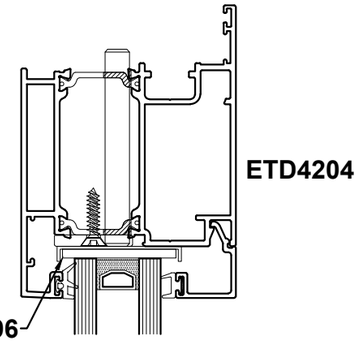
Not compatible with the heritage door sash



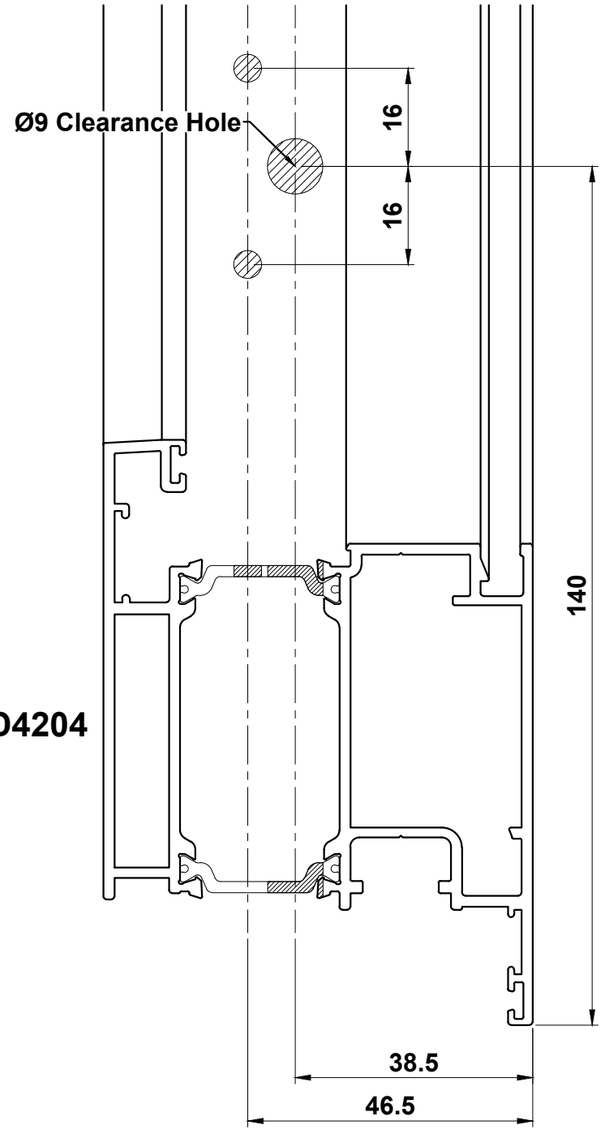
To ensure accuracy use ACET497 drill jig

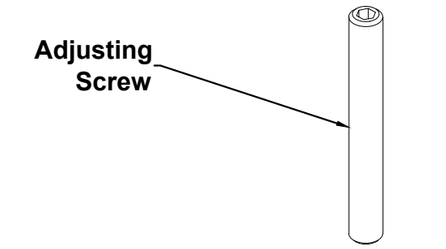
Note: Do not tighten the adjusting screw too tightly as it can lead to cracked glass.

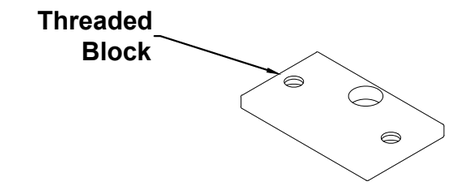


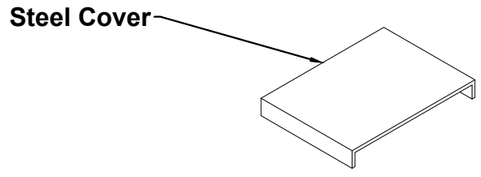


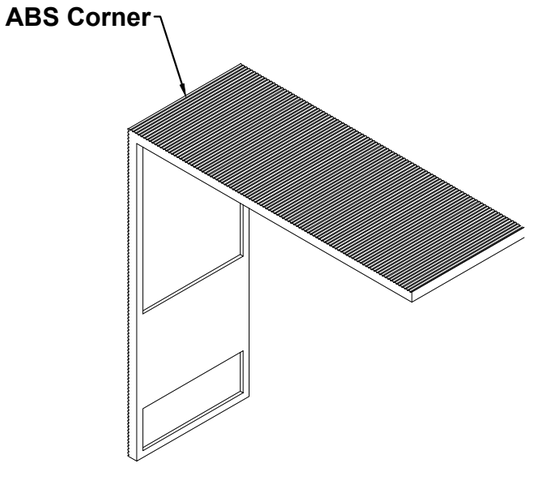
ETD4204







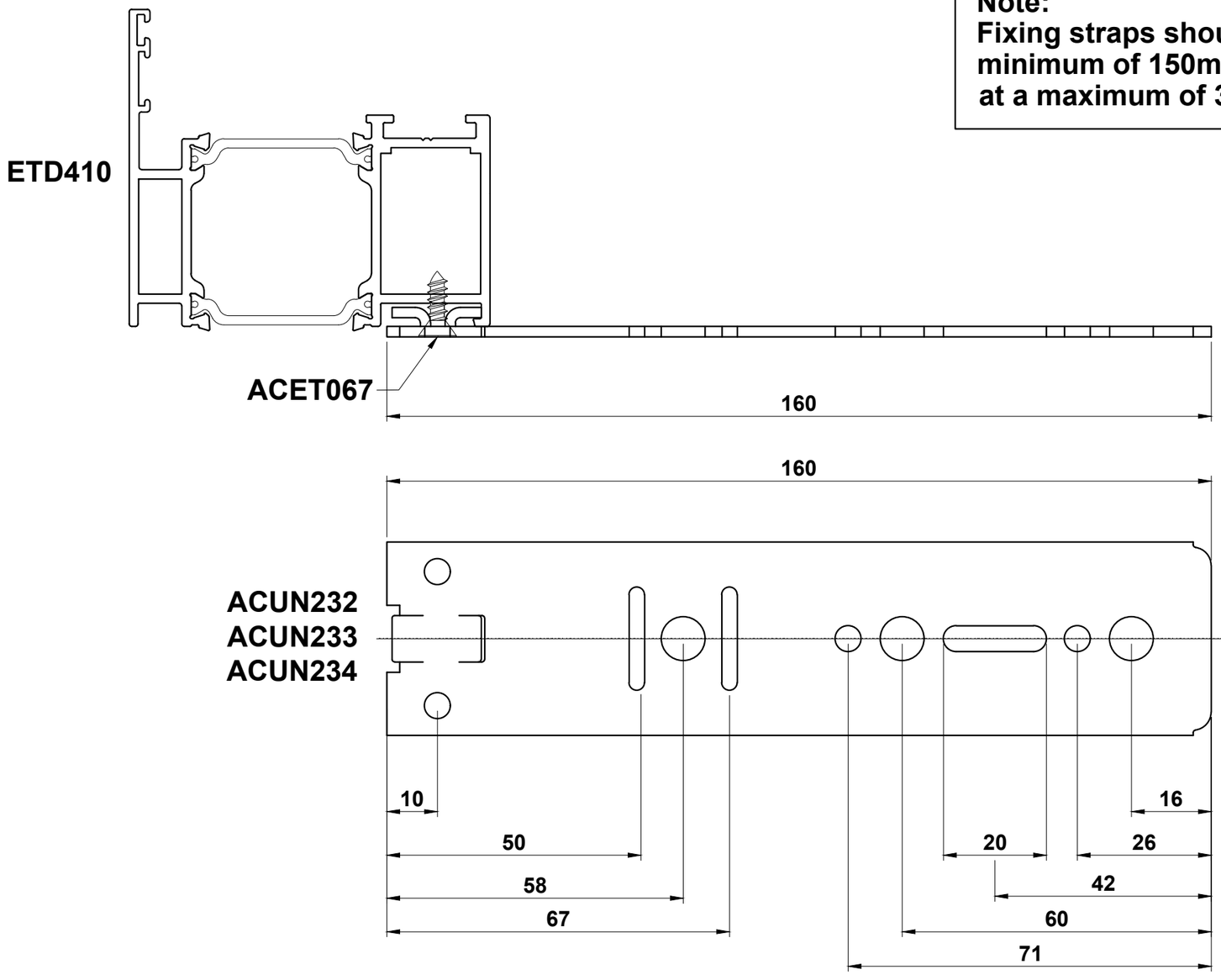




Do Not Scale From This Drawing

Fixing Strap Detail

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

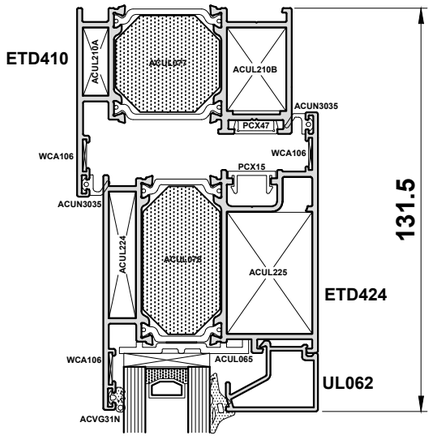


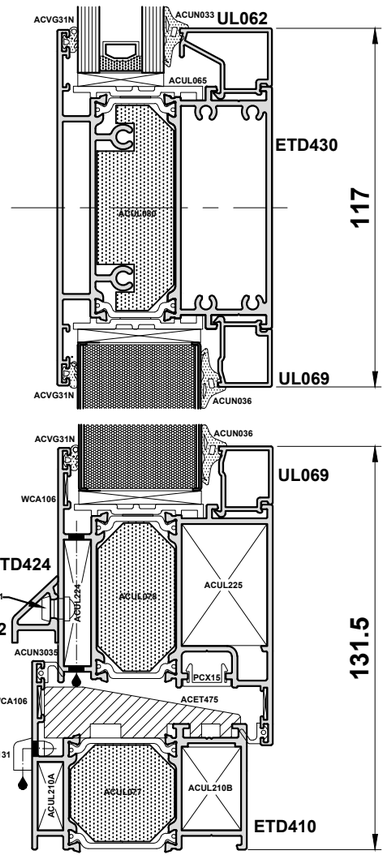
Do Not Scale From This Drawing

Alitherm 400 Stepped Door

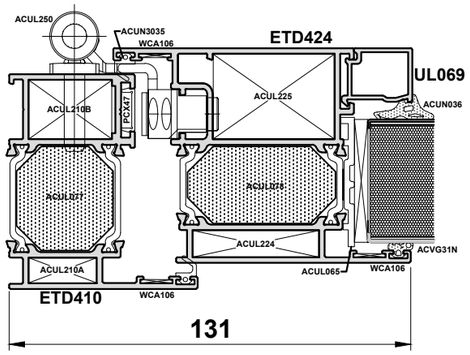
Example Layout

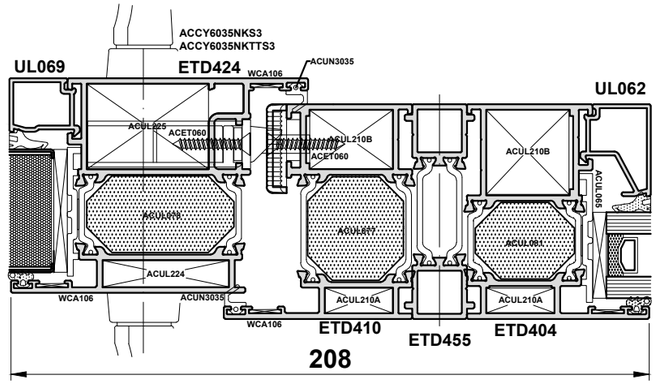
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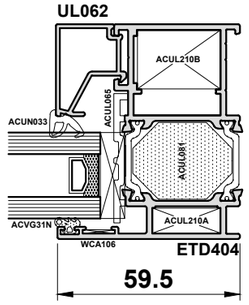


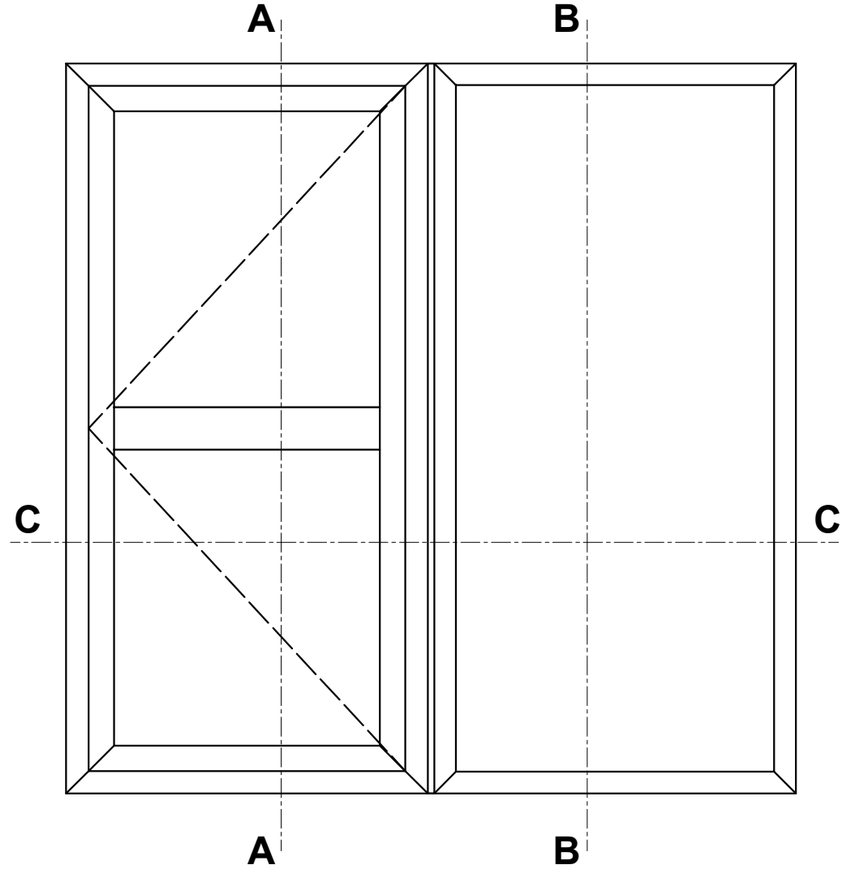


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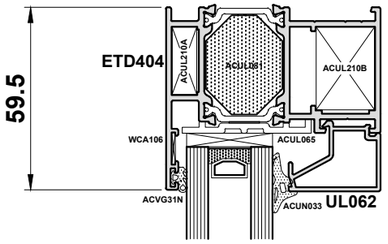


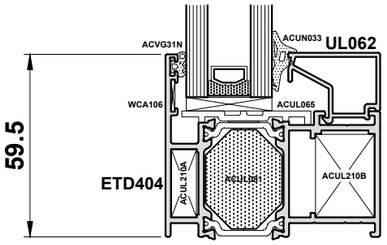






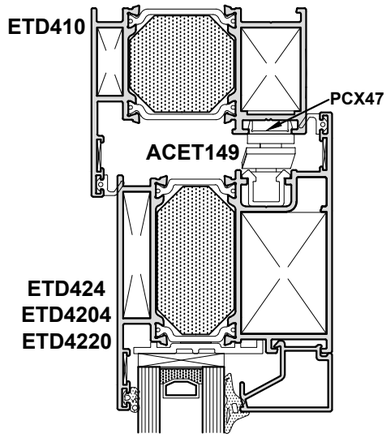
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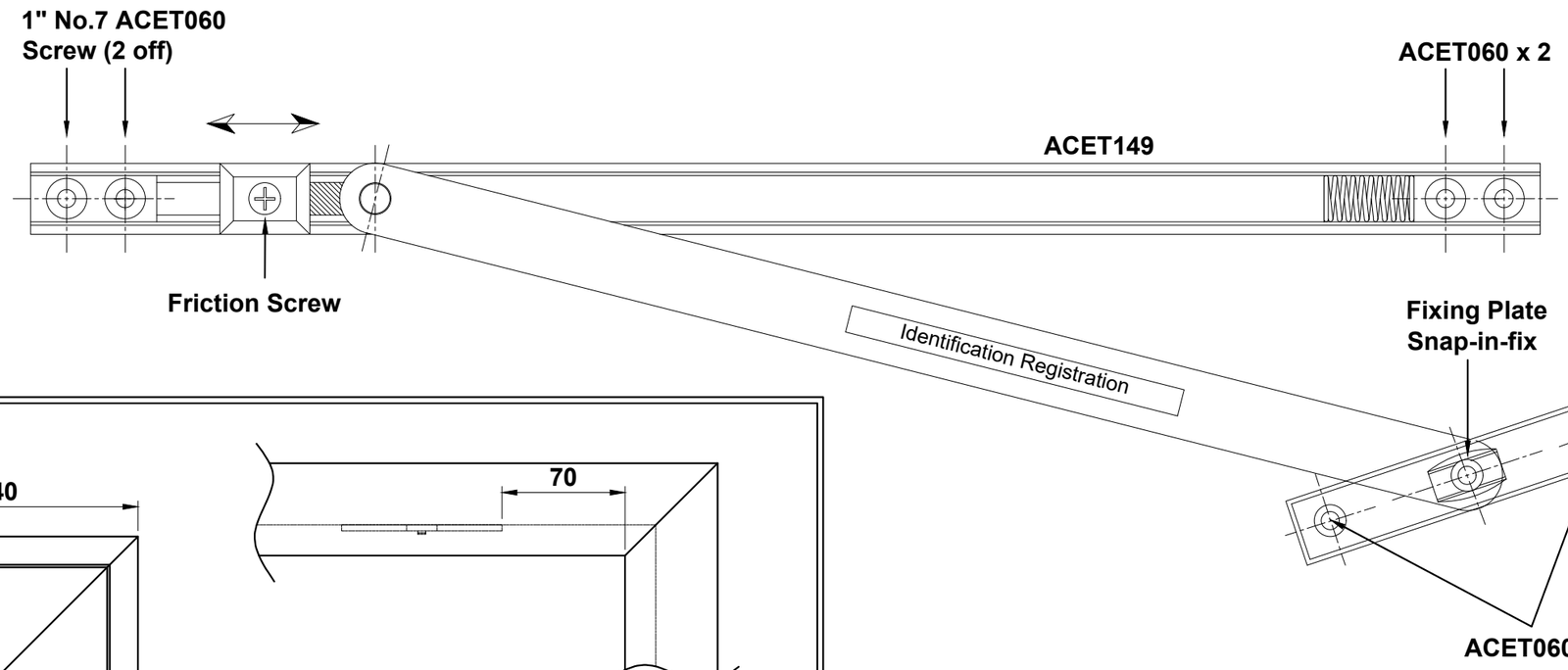
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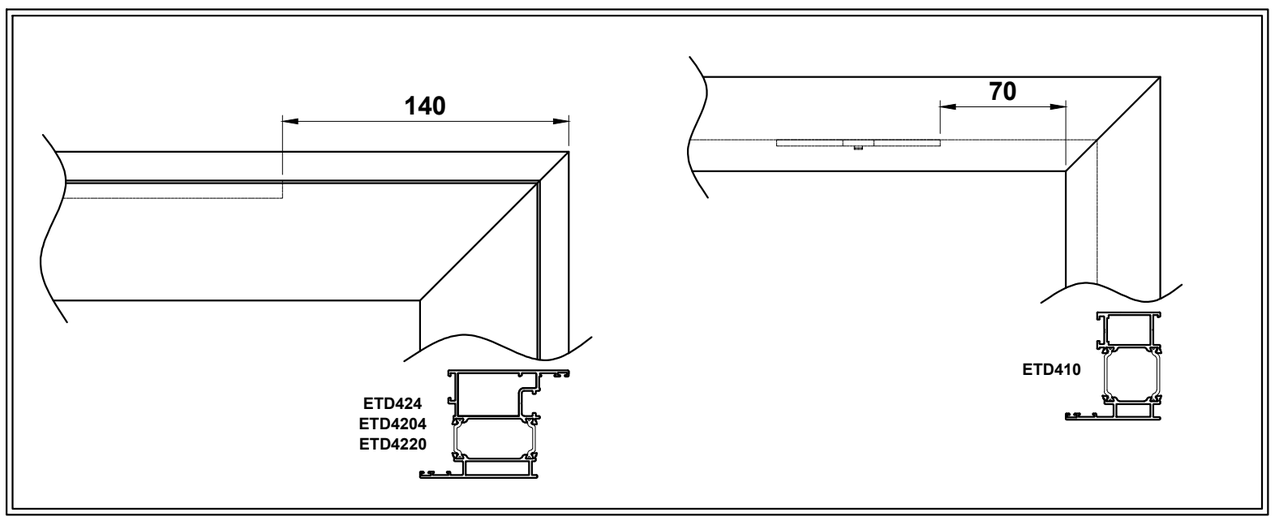
ACET149 Fitting Instructions



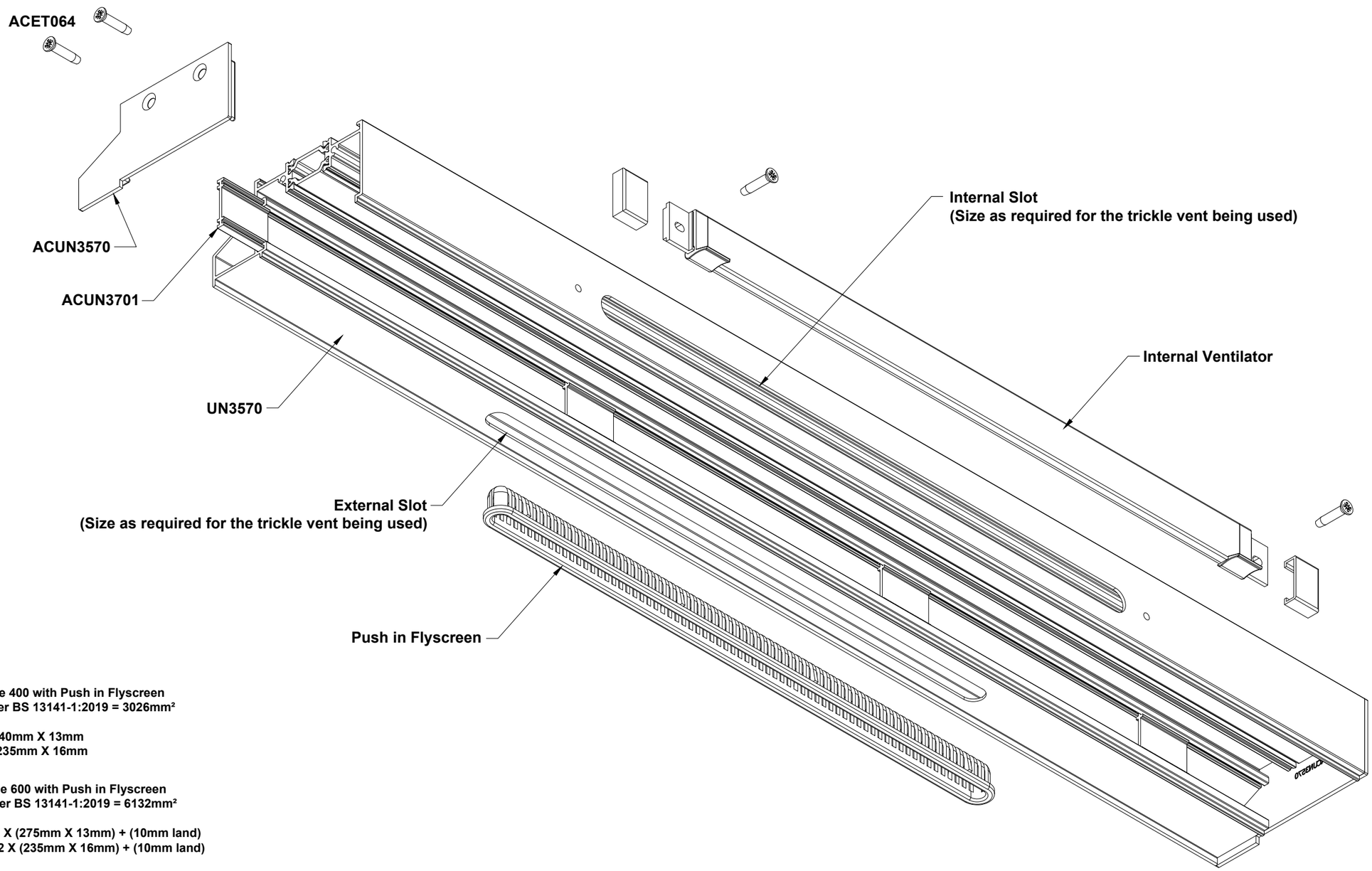
Ensure friction screw is loose
before fitting stay to door.
Adjust to required tension
once the stay is fixed in position.







Trickle Vent



R. W. Simon Sightline 400 with Push in Flyscreen
Equivalent area as per BS 13141-1:2019 = 3026mm²
Length = 400mm
Internal Slot Size = 340mm X 13mm
External Slot Size = 235mm X 16mm

R. W. Simon Sightline 600 with Push in Flyscreen
Equivalent area as per BS 13141-1:2019 = 6132mm²
Length = 600mm
Internal Slot Size = 2 X (275mm X 13mm) + (10mm land)
External Slot Size = 2 X (235mm X 16mm) + (10mm land)

Do Not Scale From This Drawing

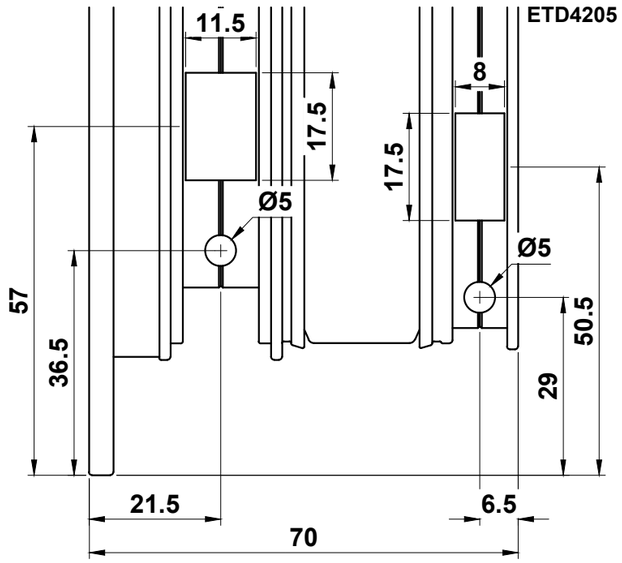
Section E

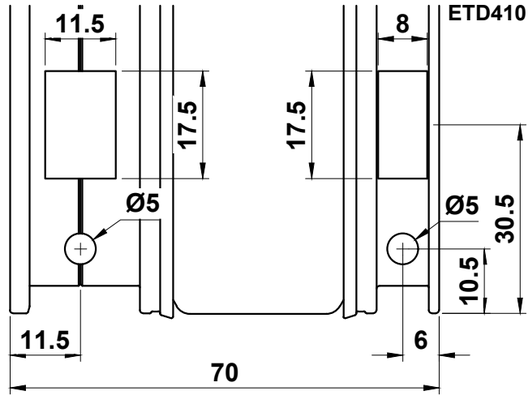
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Alitherm 400 Stepped Door

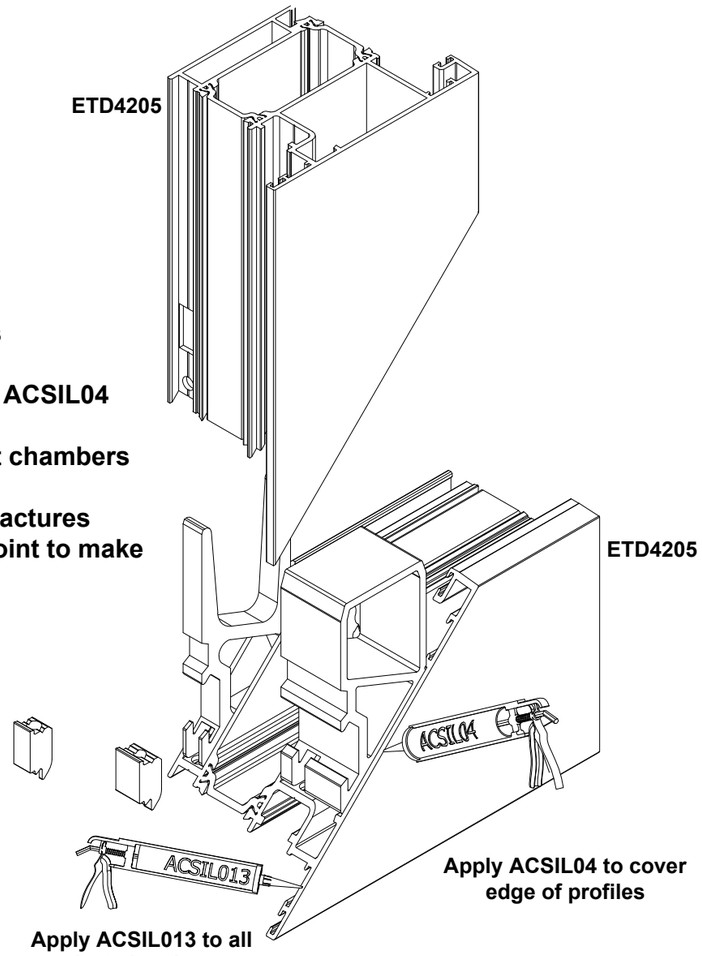
Corner Joint Details





Notes

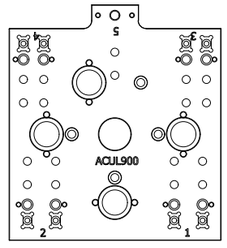
1. Degrease mitre sections
2. Cover mitred faces with ACSIL04
3. Apply ACSIL013 to cleat chambers
4. Apply ACSIL04 to any fractures formed by mechanical joint to make watertight



Apply ACSIL013 to all cleat chambers

Apply ACSIL04 to cover edge of profiles

ACUL900



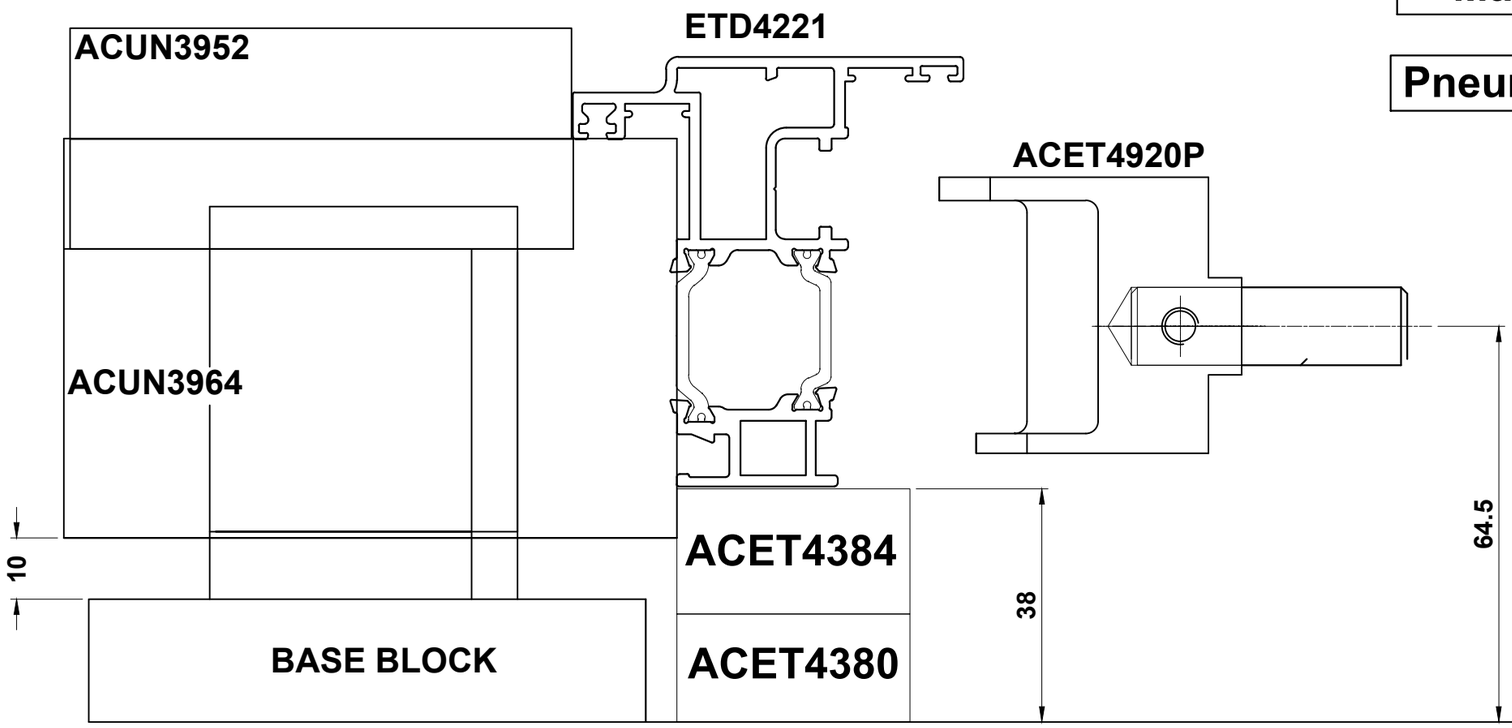
To ensure accurate corners, we recommend the use of support blocks (by others) whilst cutting.

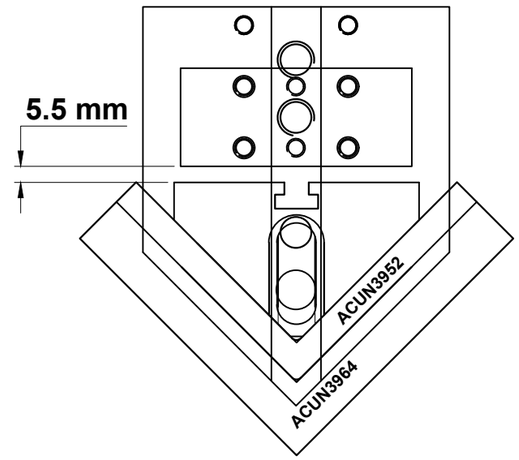
Do Not Scale From This Drawing

Corner Crimping

Manual Crimper = ACCR300

Pneumatic Crimper = ACCR200N



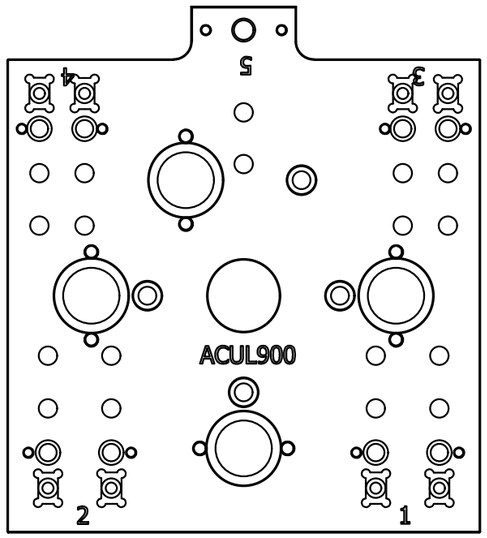


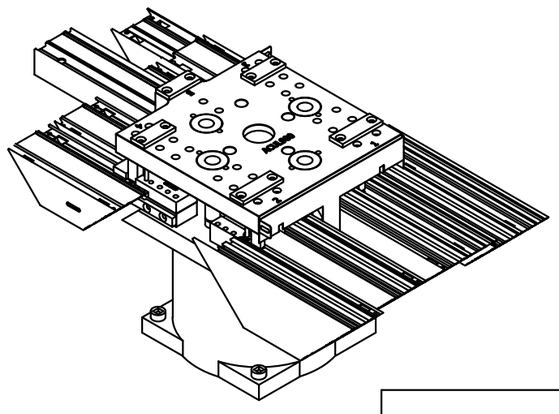
Please consult our Technical Department for support with alternative crimper models

Do Not Scale From This Drawing

Alitherm 400 Stepped Door

ACUL900 Punch Tool

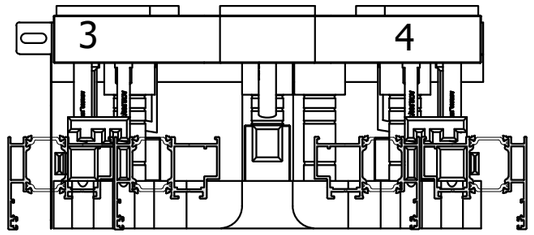


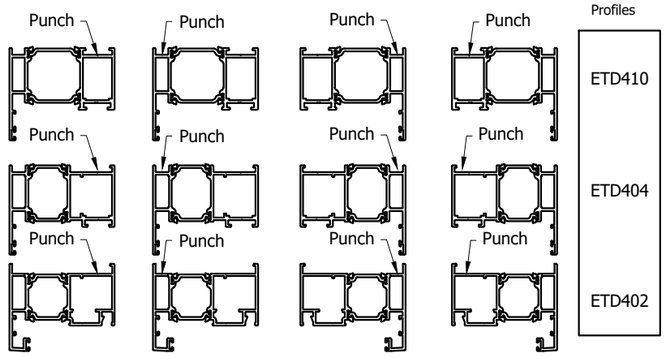


IMPORTANT NOTE:
Please do not overtighten retaining nut to punch tool base.

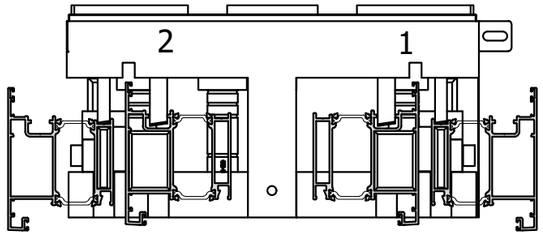
Use support stands for longer lengths of profiles.

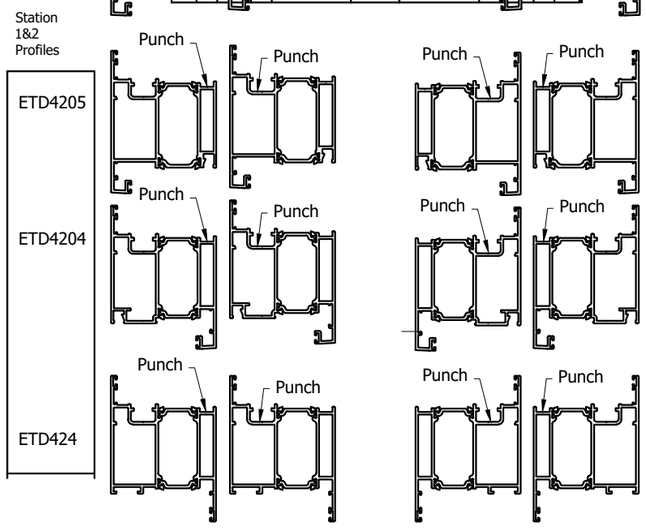
Station 3 & 4



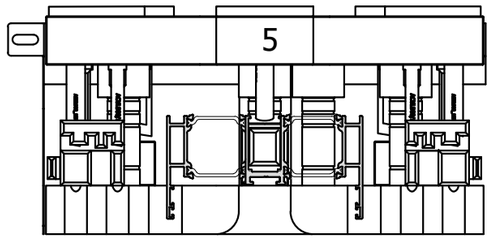


Station 1 & 2

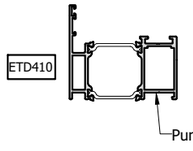


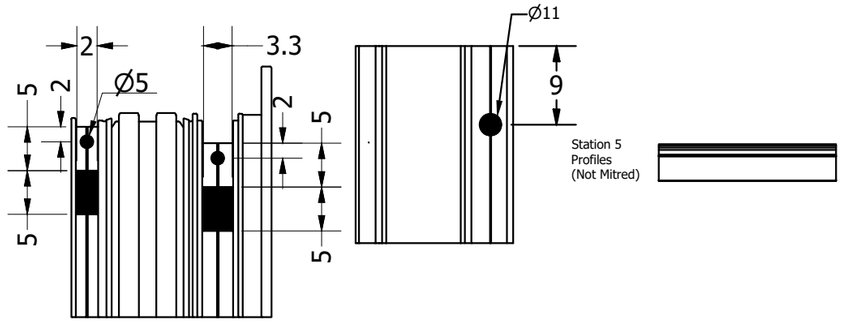


Station 5



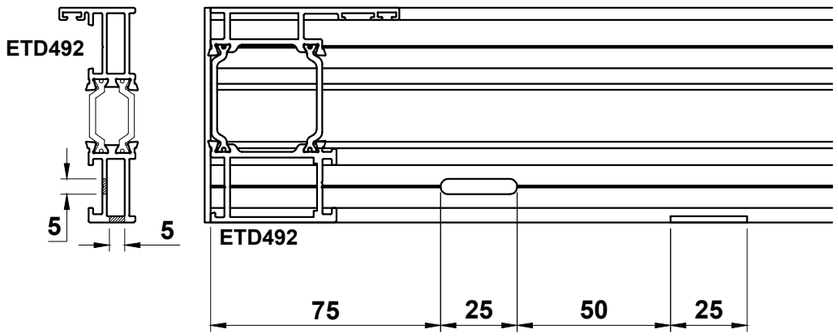
Station 5 Profiles

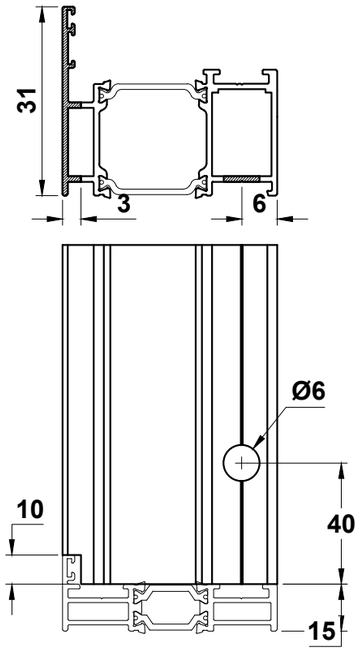


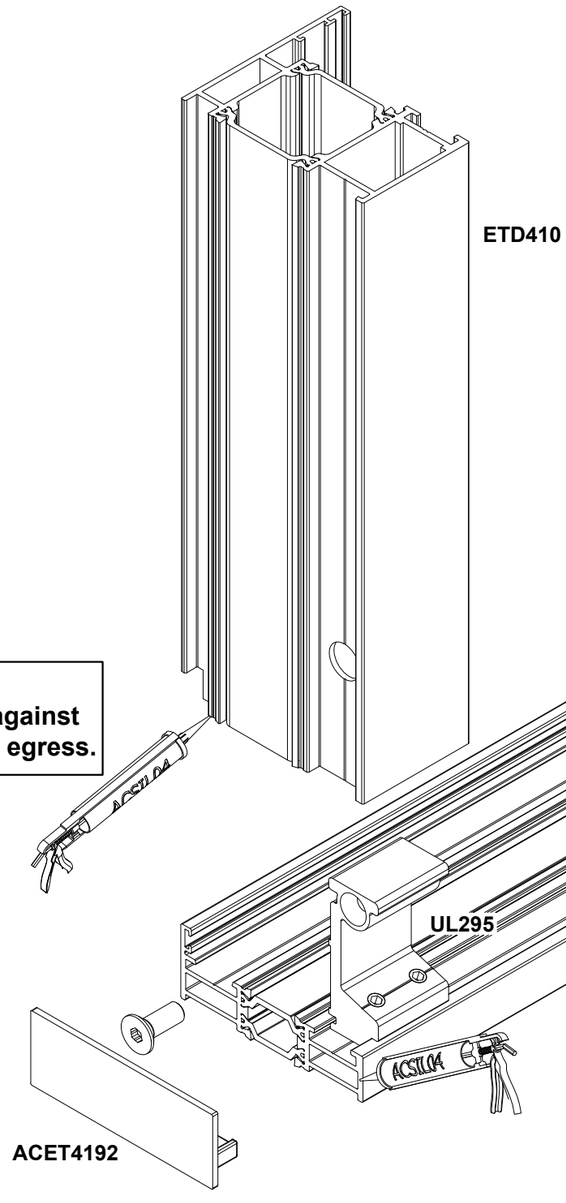


Do Not Scale From This Drawing

Low Rebate Threshold Assembly





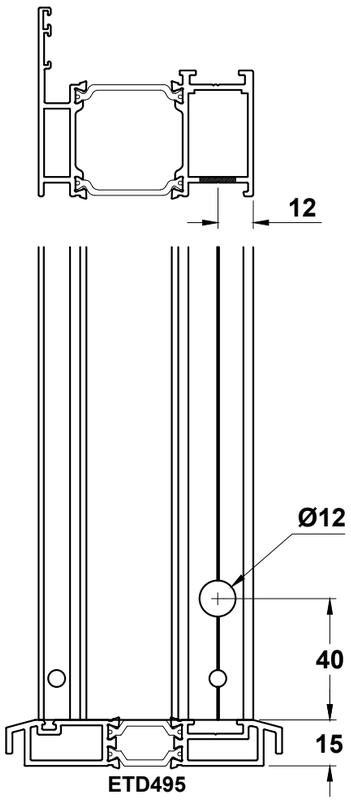


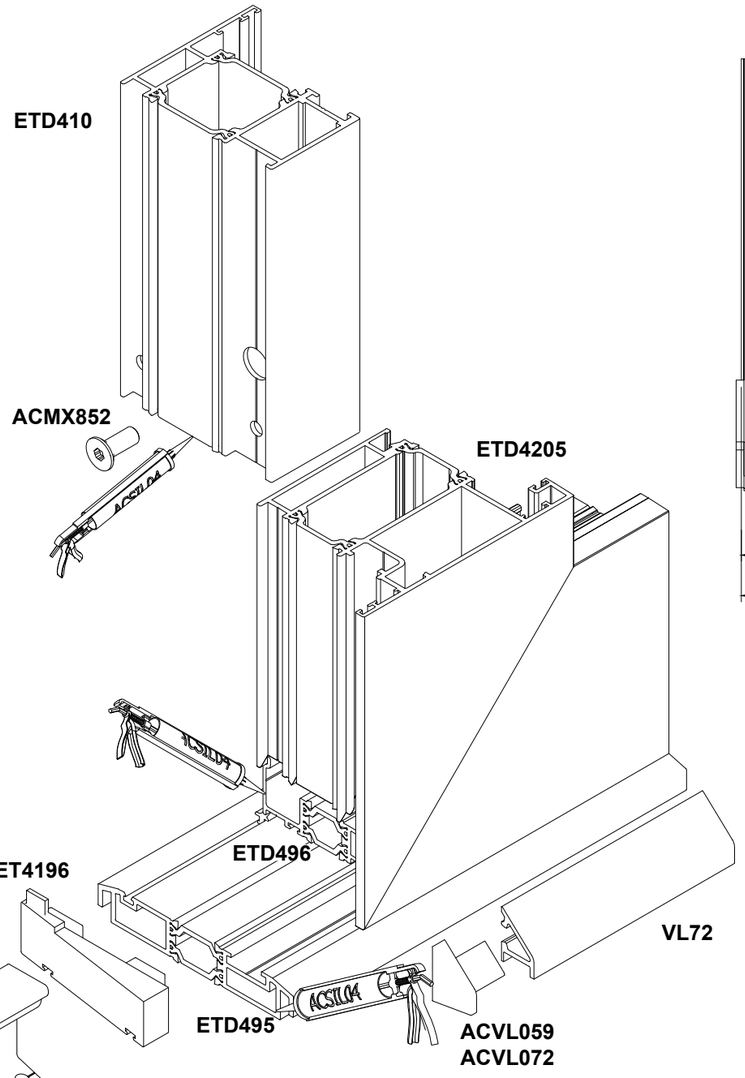
Important Note:
Ensure end cap is sealed against threshold to prevent water egress.

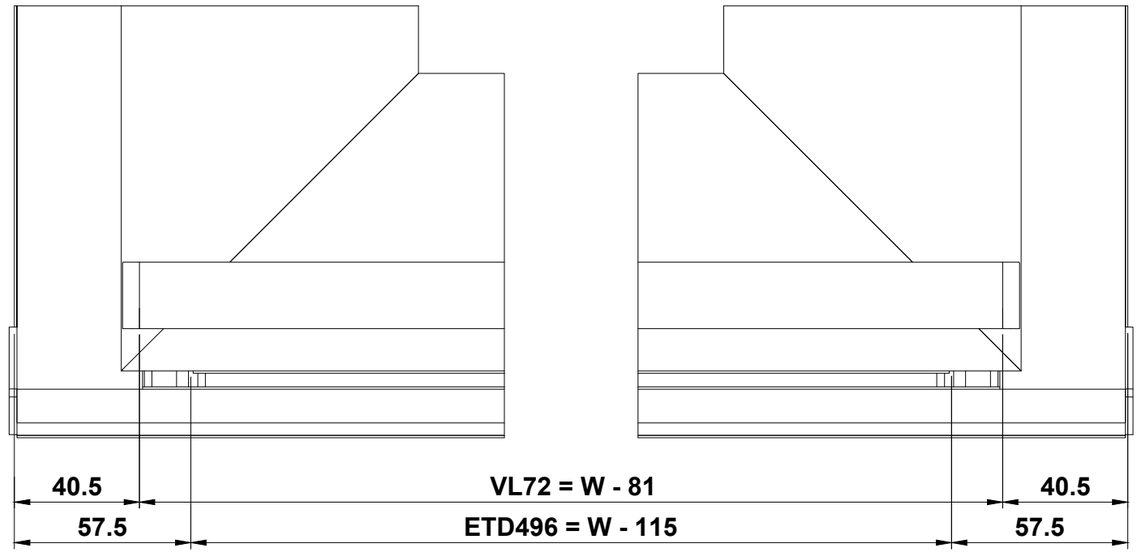
Note:
Do not drill down through drainage zone for installation.

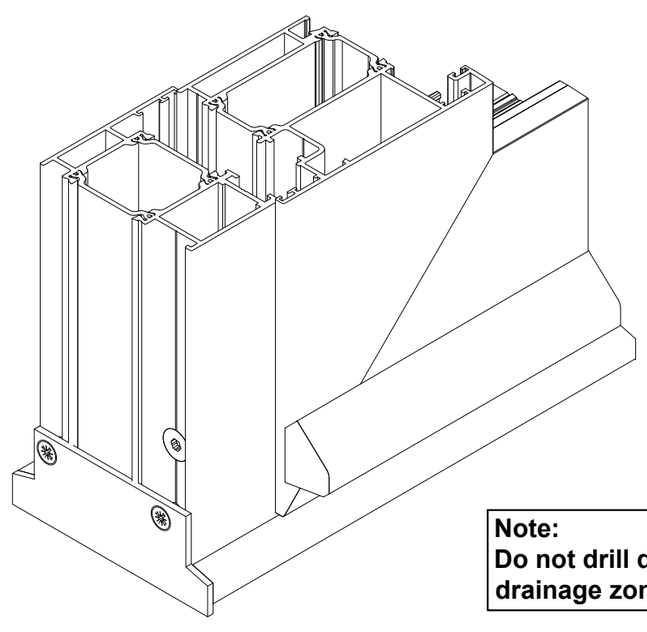
Do Not Scale From This Drawing

Low Ramp Threshold Assembly









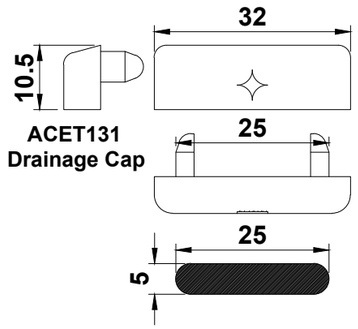
Note:
Do not drill down through drainage zone for installation.

Do Not Scale From This Drawing

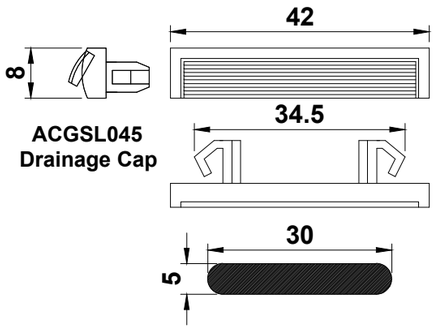
Alitherm 400 Stepped Door

Drainage

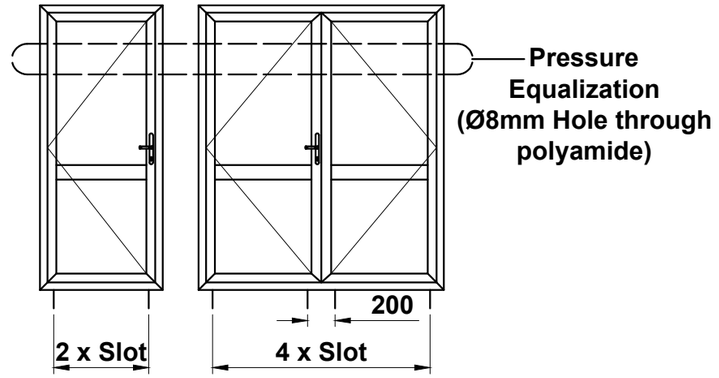
Important Note: All exposed aluminium should be coated using ACSIL014 or painted to match the frame.

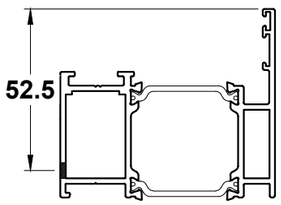


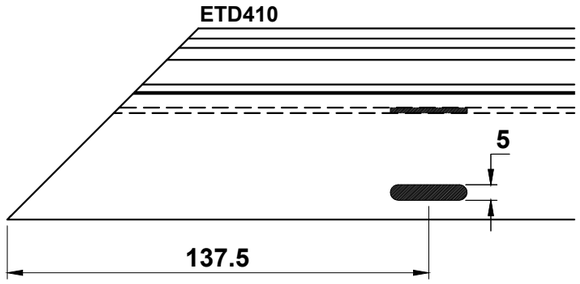
ACET131
Drainage Cap

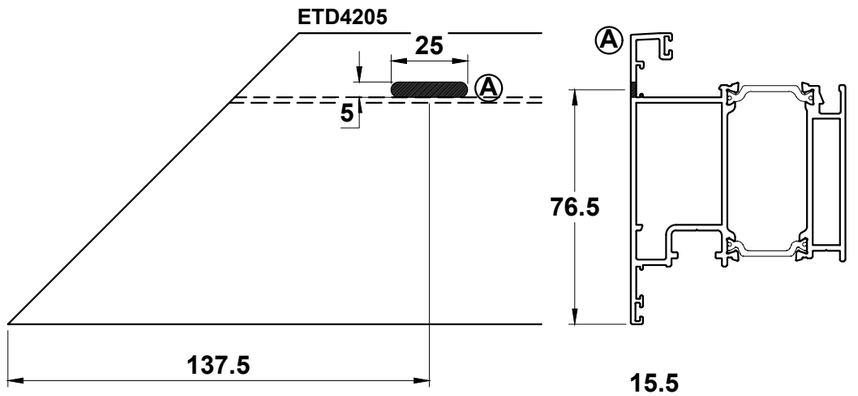


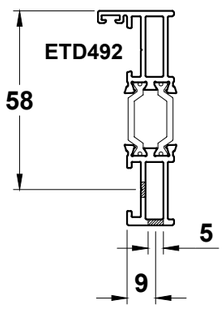
ACGSL045
Drainage Cap

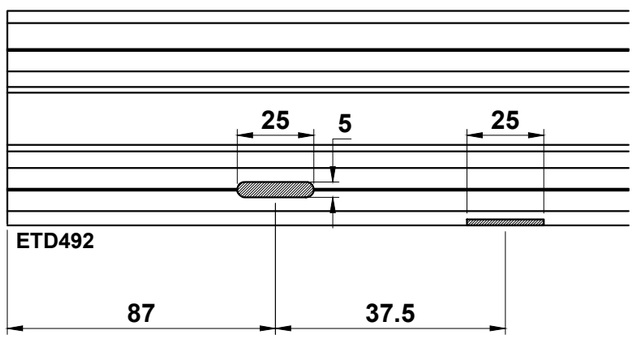


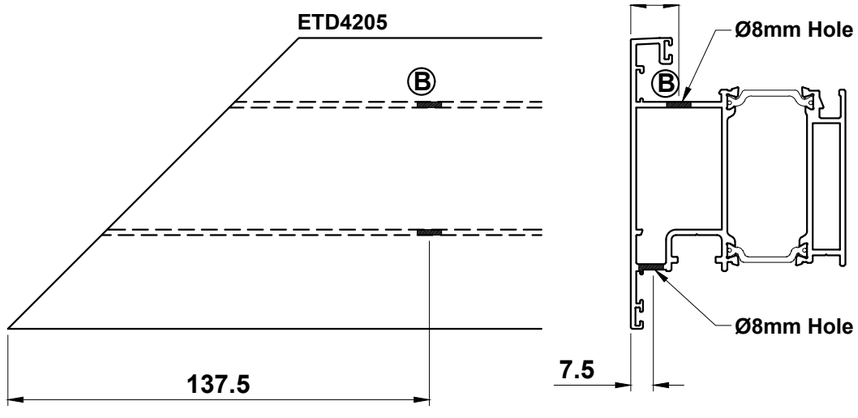








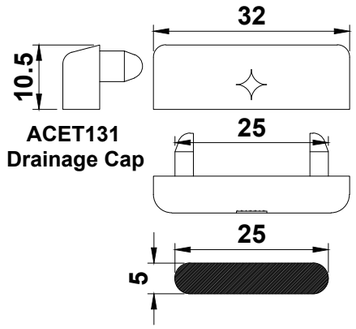




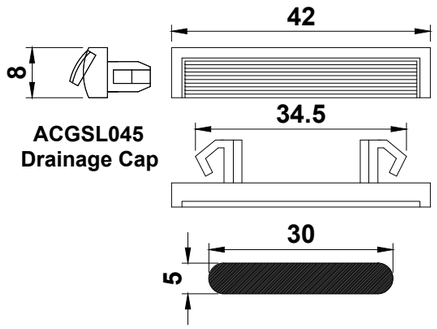
Do Not Scale From This Drawing

Drainage

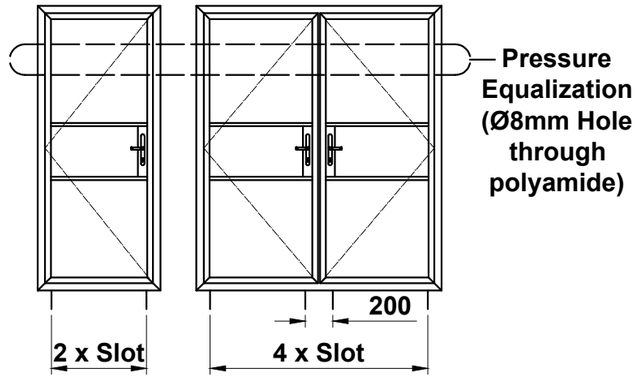
Important Note: All exposed aluminium should be coated using ACSIL014 or painted to match the frame.

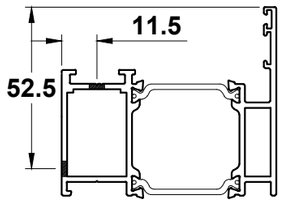


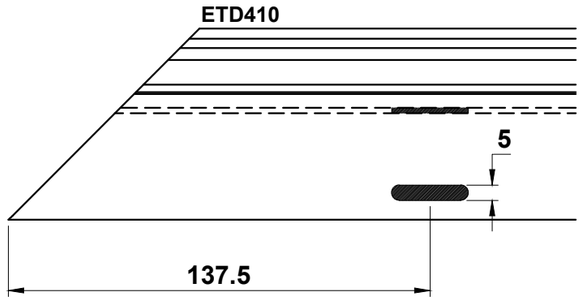
ACET131
Drainage Cap



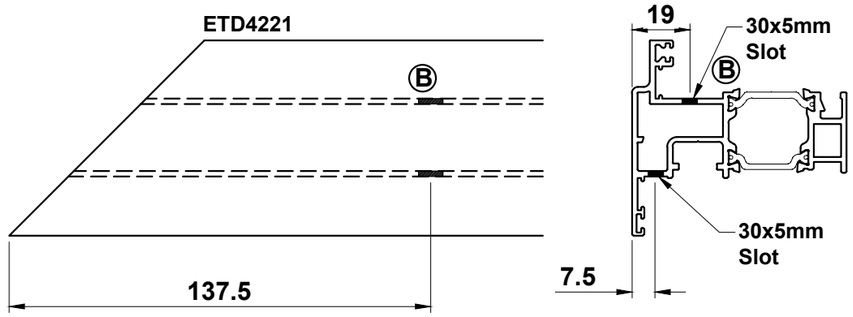
ACGSL045
Drainage Cap

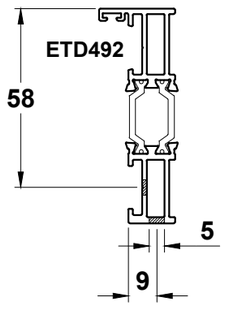


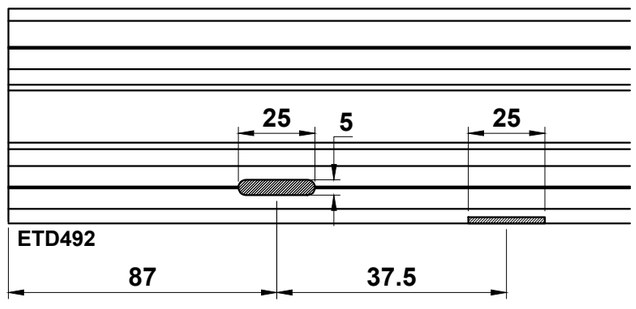




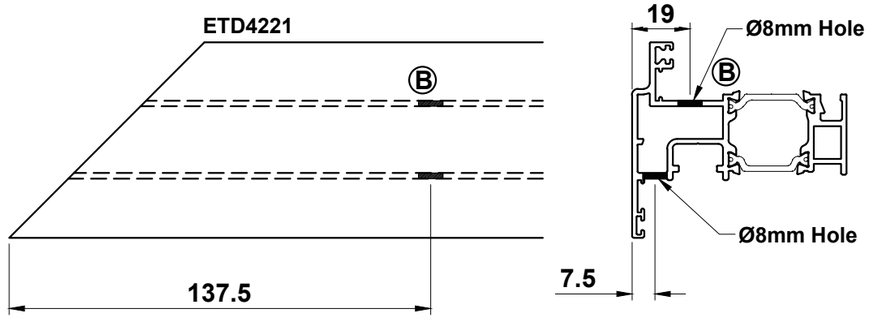
Option A







Option B

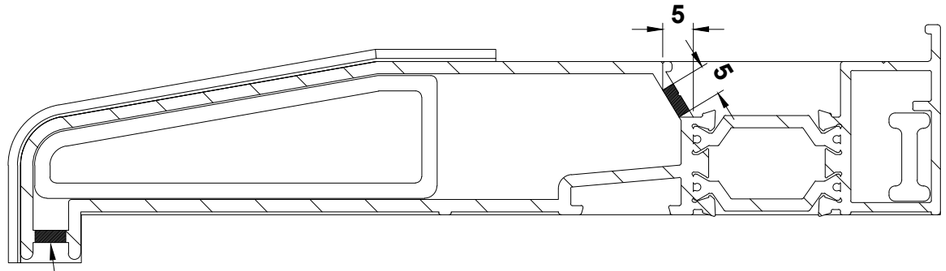


Do Not Scale From This Drawing

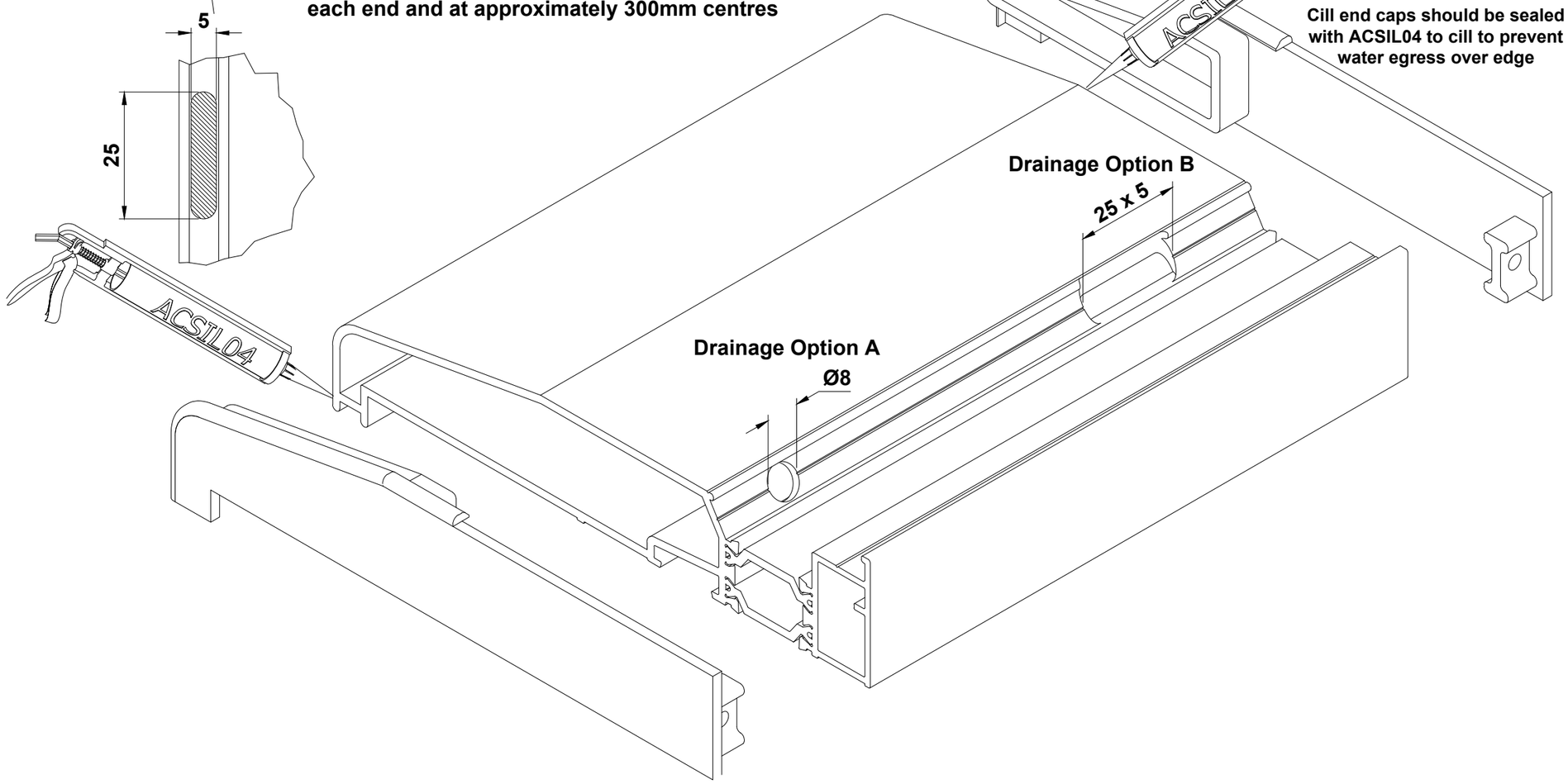
Sub Cill Drainage

Important Note: All exposed aluminium should be coated using ACSIL014 or painted to match the frame.

Drainage Option B



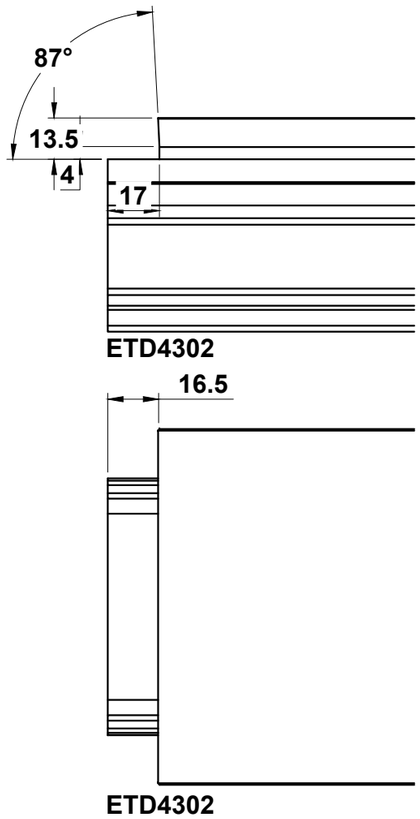
Drainage holes to be spaced 100mm in from each end and at approximately 300mm centres

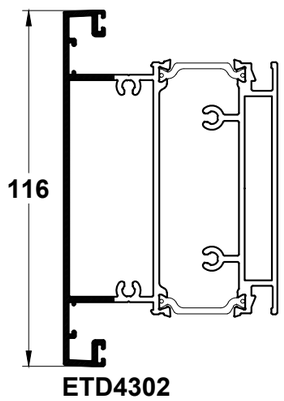


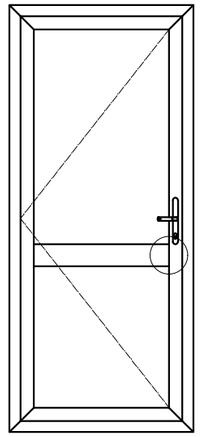
Cill end caps should be sealed with ACSIL04 to cill to prevent water egress over edge

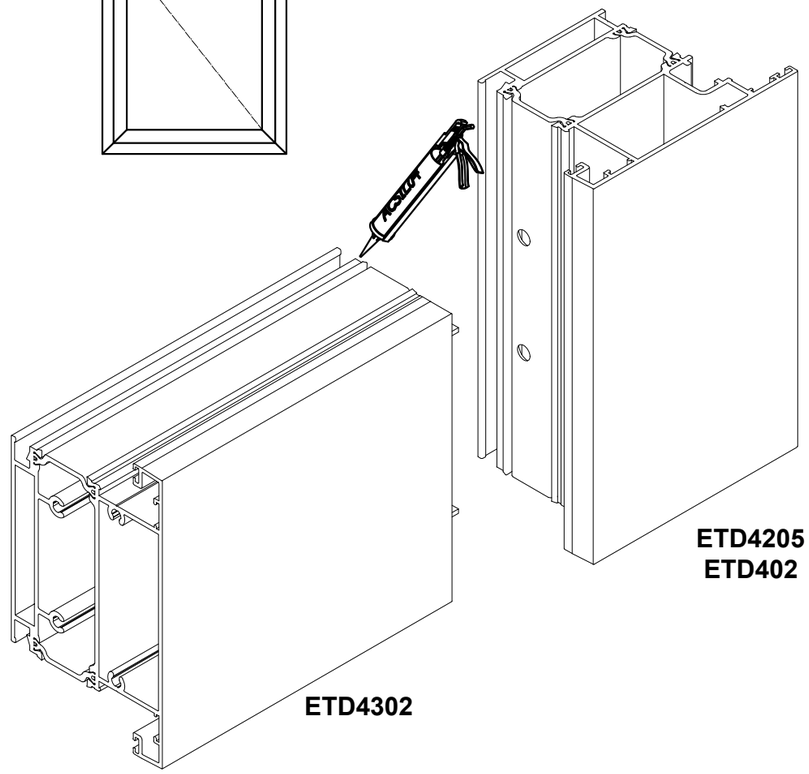
Do Not Scale From This Drawing

ETD4302 Midrail Assembly

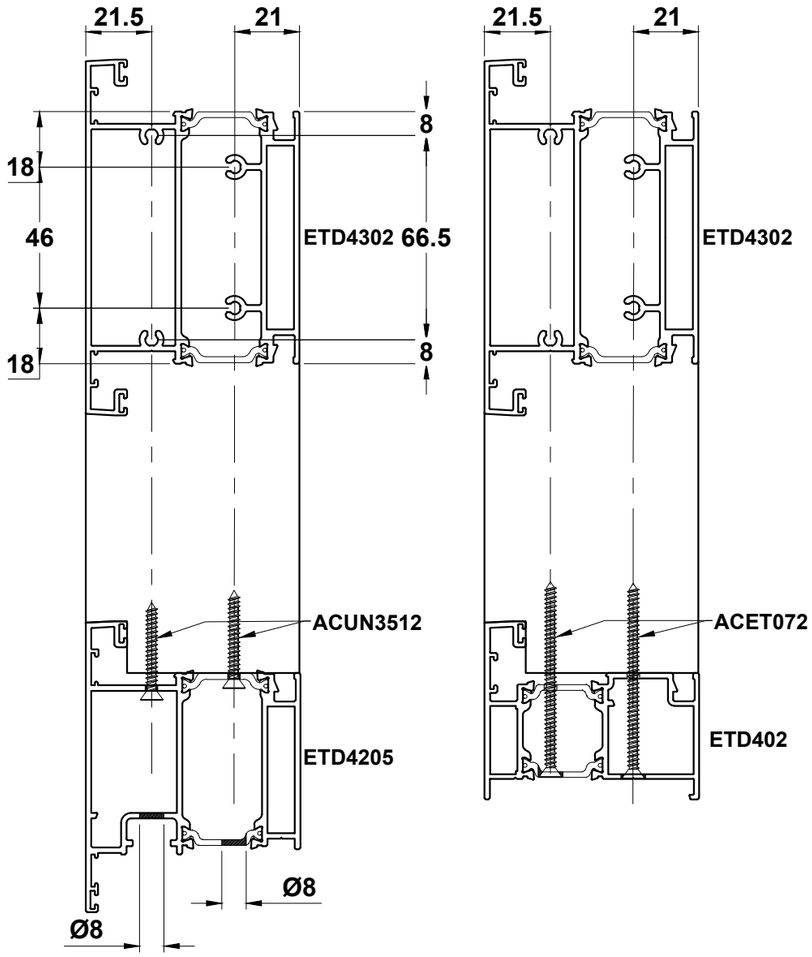












Do Not Scale From This Drawing

Door Locking & SZ Hardware Options

Slam Lock Guide (Internal Lever Handle Only)

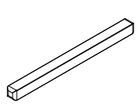
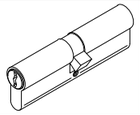
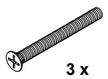
Overall Sash Height	Spindle Height (X)	Kit Part Number	
		Left Hand	Right Hand
2030-2230 (Standard)	1050	ACUL280	ACUL281
1820-2029 (Short)	1050	ACUL360	ACUL361
2231-2450 (Tall)	1050	ACUL380	ACUL381

Note: Height limits apply to all threshold options.

Key Operated Lock Guide

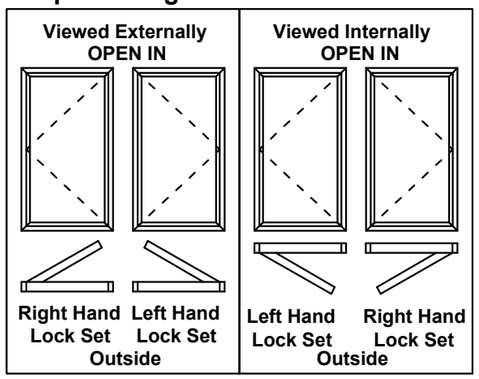
Overall Sash Height	Spindle Height (X)	Kit Part Number	
		Left Hand	Right Hand
2030-2230 (Standard)	1050	ACUL282	ACUL283
1820-2029 (Short)	1050	ACUL362	ACUL363
2231-2450 (Tall)	1050	ACUL382	ACUL383

Handle With Large Backplate Guide

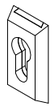
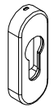
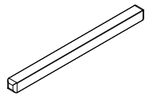
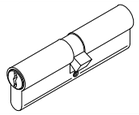
Ext. Handle	Int. Handle	Spindle	Cylinder	Screw	Screw	Rivnuts
				 3 x	 3 x	 3 x
ACSZ800	ACSZ801	ACMX409Sq. Spindle 150mm	--	ACMX861 M5 x 75mm	--	--
	ACSZ803		ACCY0060 Half Cylinder			
	ACSZ830 T					
ACSZ802	ACSZ803		ACCY6035S3 35/60 Cylinder		--	--
	ACSZ830 T					
ACSZ400 + 2 x ACVS061	ACSZ803	ACMX008 Sq. Spindle 60mm	ACCY6035S3 35/60 Cylinder	ACVS061 M5 x 40mm	--	--
	ACSZ830 T					
--	ACSZ803	ACMX008 Sq. Spindle 60mm	*ACCY6035S3 35/60 Cylinder	--	WCA134 M5 x 20mm	ACUN3509 M5
	ACSZ830 T					

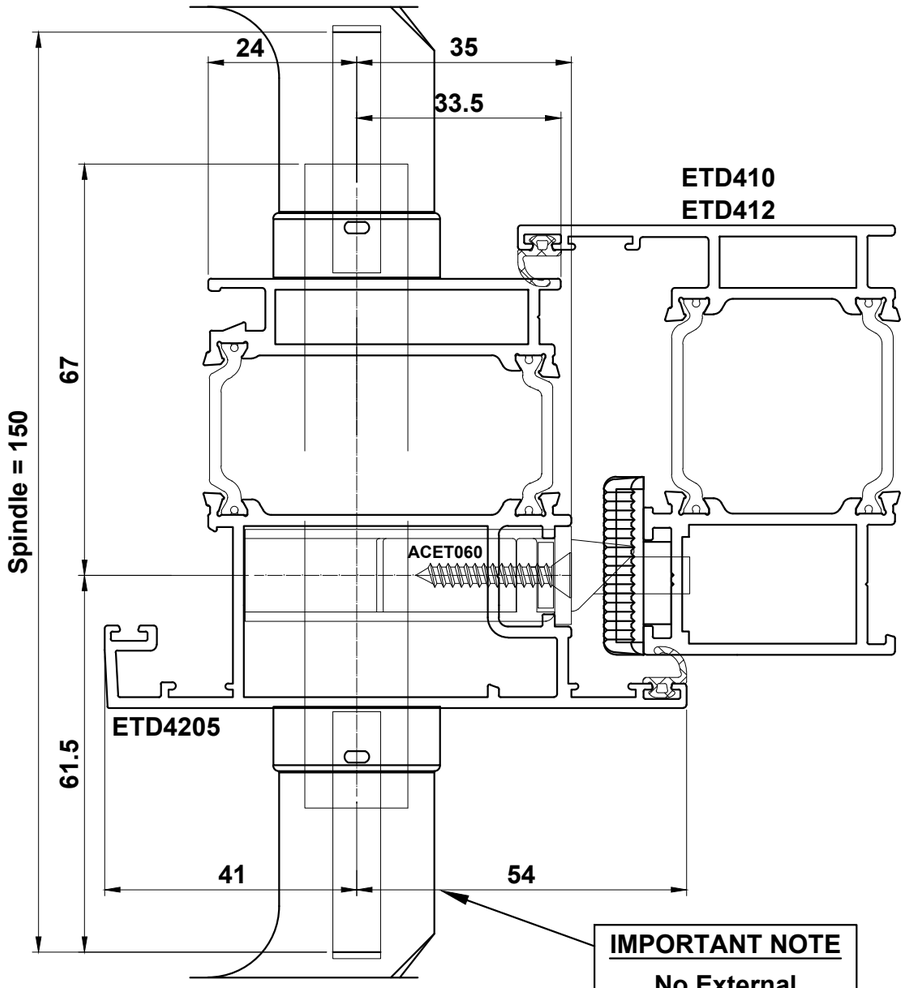
*Use with Ext. Ecutcheon

Keep Handing Guide



Handle with Small Backplate Guide

Ext. Handle	Ext. Escutcheon	Int. Handle	Int. Escutcheon	Spindle	Cylinder	Screw	Rivnuts
							
ACSZ837	ACSZ400	ACSZ836	ACSZ839	ACMX409Sq. Spindle 150mm	ACCY3560S3	WCA134 M5 x 20mm	ACUN3509 M5
					ACCY0060		
	ACSZ400			ACMX008 Sq. Spindle 60mm	ACCY3560S3	WCA134 M5 x 20mm	ACUN3509 M5
					ACCY0060		
ACSZ837	ACSZ400	ACSZ827 T		ACMX409Sq. Spindle 150mm	ACCY3560S3	WCA134 M5 x 20mm	ACUN3509 M5
					ACCY0060		



IMPORTANT NOTE
No External Lever Handle For Slam Locks

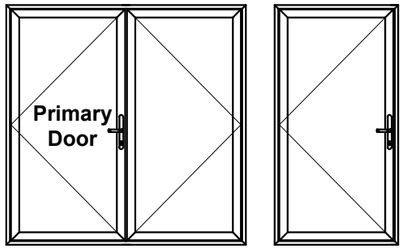
With Cylinder
Without Cylinder
T Handle With Cylinder
T Handle Without Cylinder

Note:
Please check kitemark for all suitable hardware to achieve PAS24.

Do Not Scale From This Drawing

Lock Overview of Single and Double Doors

Finger Bolt Locking Options



Single & Primary Door Lock Selection

Overall Sash Height	Lift Lever		Slam Lock **		Key Wind	
	Left	Right	Left	Right	Left	Right
2030-2230 (Standard)	ACUL272	ACUL273	ACUL280	ACUL281	ACUL282	ACUL283
1820-2029 (Short)	ACUL377	ACUL378	ACUL360	ACUL361	ACUL362	ACUL363
2231-2450* (Tall)	ACUL374	ACUL375	ACUL380	ACUL381	ACUL382	ACUL383

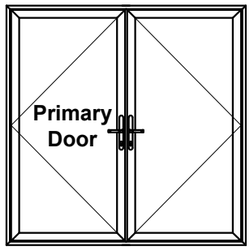
*Any doors above 2450mm are above the tested limit.
** No lever handles installed externally.

Secondary Door Accessory Selection

35mm Backset Shootbolt Adaptor	Bottom 10mm Dia Rod	Top 10mm Dia Rod		Keep	Shootbolt Guide
		Overall Size	Rod Part No.		
ACPD844 	ACPD846 (1000mm)	1820 - 1923	ACPD846 (1000mm)	ACUL390 (2 Required)	ACUL242 (2 Required)
		1923 - 2173	ACPD847 (1250mm)		
		2174 - 2323	ACPD848 (1500mm)		
		2323 - 2423*	ACPD848 (1500mm)		

*For doors above 2423mm, use ACPD849 (2000mm)

Lift Lever Locking Options

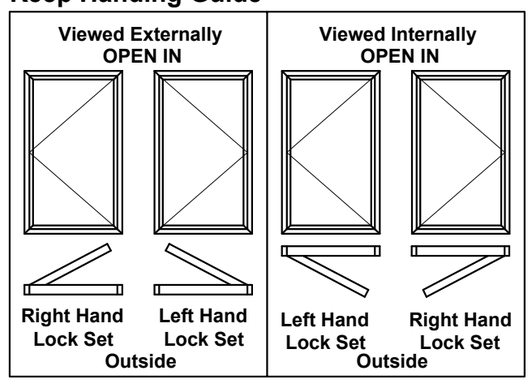


Double Handle Lift Lever Lock Option

Overall Sash Height	Primary Door Lift Lever		Secondary Door Lift Lever	Double Door Keep	Shootbolts	Shootbolt Extensions
	Left	Right				
1885-2450*	ACUL277	ACUL278	ACUL276	ACUL279	ACDV737 ACDV738	ACDV742 ACDV744

*Any doors above 2450mm are above the tested limit.
**Please see page E92 for shootbolt layout.

Keep Handing Guide

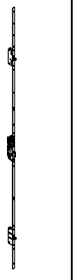


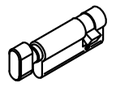
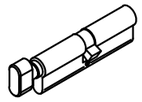
For ACUL267 & 268 Cam Lock Option Refer To Page E101

Do Not Scale From This Drawing

Panic Bar Hardware Overview

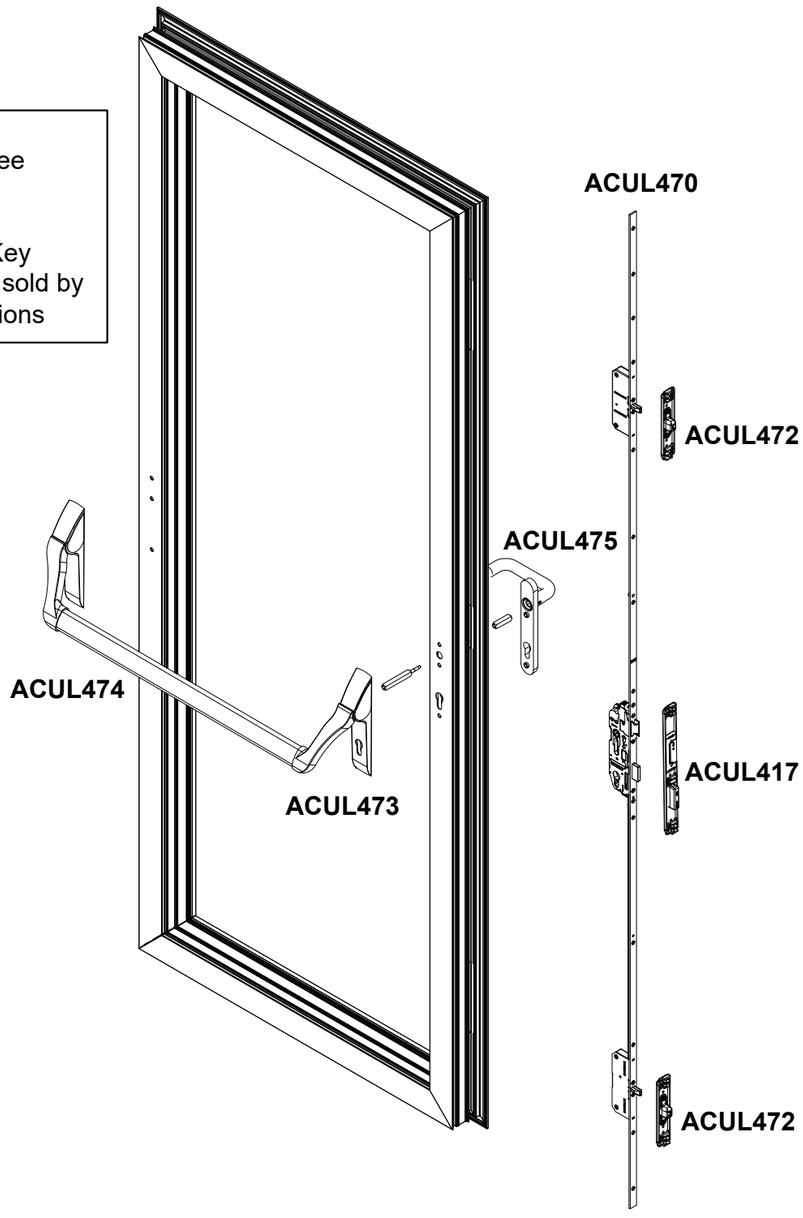
Viewed Externally	Lock	Keep
Right Hand Open Out	1x  ACUL470	1x  ACUL417

Viewed Externally	Lock	Keep
Left Hand Open Out	1x  ACUL471	1x  ACUL416

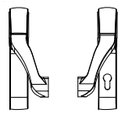
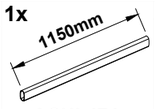
Internal Only	Ext. Access
1x 	1x 
ACCY0065TTS1 Thumbturn Half Cylinder	ACCY3565TTS1 Thumbturn 35/65 Cylinder

Important:
Cylinders require free movement cam

If you require Key/Key cylinders these are sold by CES Security Solutions



Panic Bar Fittings:

Panic Bar	Fixings	Keep	Int. Spindle
1x  ACUL473	6x  ACUN3581 M5 x 12mm	2x  ACUL472	1x  ACUL469 9 x 60mm SPINDLE
1x 1150mm  ACUL474	6x  ACUN3499 M5 Washer		
	6x  ACUN3509 M5 Rivnut		

Panic Bar Only Exit:
The door is secured by engaging the deadbolt through two full rotations of the key. Egress is always possible from the interior via the panic bar, which overrides the deadbolt & latch.

Key Entry:
To enable key-operated access from the exterior, specify the use of escutcheon model ACSZ839 with a external access cylinder.

External Handle Fittings:

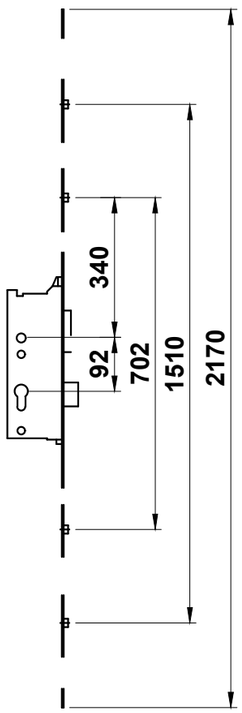
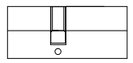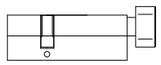
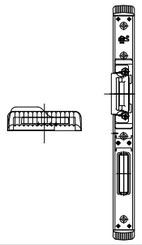
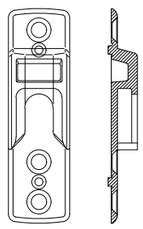
Handle	Fixings	Int. Spindle	Ext. Spindle
1x  ACUL475	2 x  ACUN3819 M6 x 75mm	1x  ACUL477 9 x 67mm	1x  ACUL476 9 x 39mm
	2 x  ACUN3500 M6 Washer		

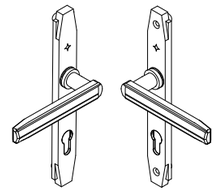
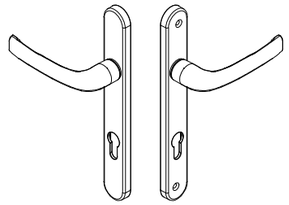
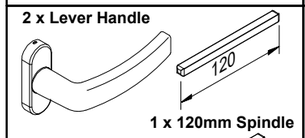
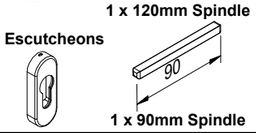
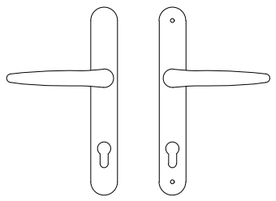
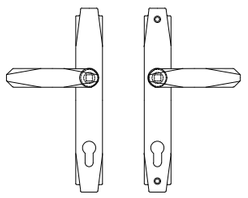
Panic Bar With External Handle:
The external handle is activated by turning the cylinder key to the unlocked position or by engaging the panic bar.
Once activated, external access is maintained via the lever handle until the door is manually secured by rotating the cylinder key twice.

Application: Allows building occupants to exit while simultaneously permitting external access for emergency responders when the door is unlocked.

Do Not Scale From This Drawing

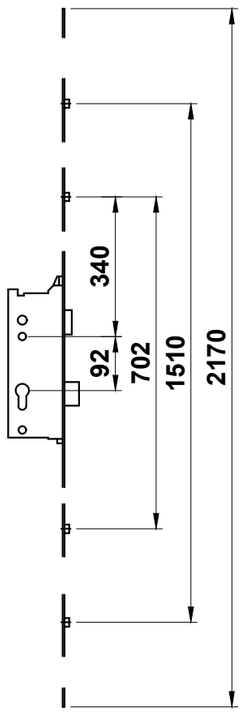
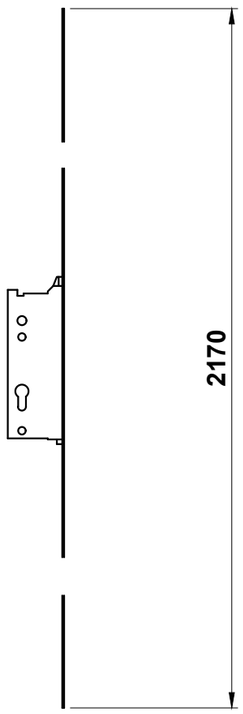
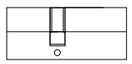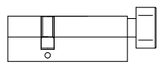
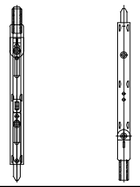
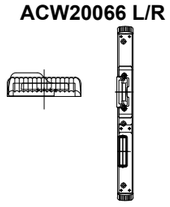
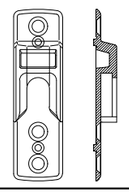
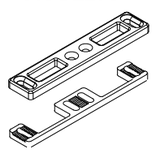
Heritage Single Door Hardware Options

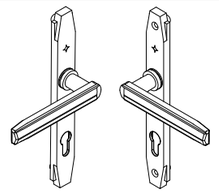
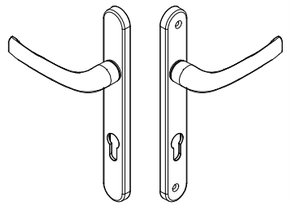
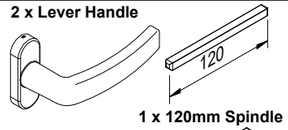
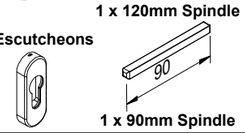
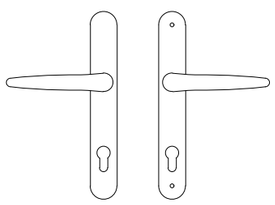
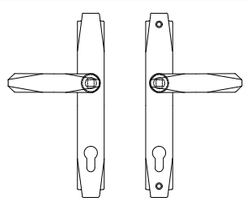
Lock	Accessories	Quantity
ACW20465 	ACCY3060S1 	1
	ACCY3060TTS1 	
	ACW20066 L/R 	1
	ACW20367 	4

Handles		Quantity
	**ACSM001N** Art Deco Lever/Lever Door Handle	1 Pair
	**ACSM060** Heritage Lever/Lever Handle	
2 x Lever Handle  1 x 120mm Spindle 2 x Escutcheons  1 x 90mm Spindle	**ACSM095** Suitable With Lift Lever Addtional Parts: HEA132 - M5 x 16mm ACUN3509 - M5 Rivnut	
	**ACW20261** Standard Lever/Lever Handle Fixing kit supplied	
	**ACW20062** Art Deco Lever / Lever Handle Available in Antique Brass and Satin Nickel Plate	

Do Not Scale From This Drawing

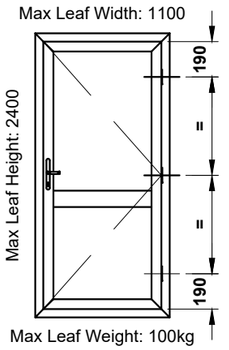
Heritage Double Door Hardware Options

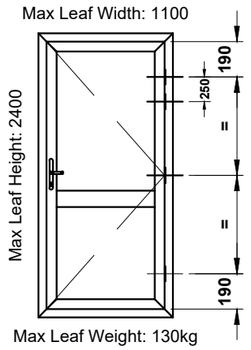
Lock		Accessories	Quantity
ACW20465 	ACW20466 	ACCY3060S1 	2
		ACCY3060TTS1 	
		ACDV737/ACDV738 	2 / 2
		ACW20066 L/R 	1
		ACW20367 	4
		ACUL279 	2

Handles		Quantity
	**ACSM001N** Art Deco Lever/Lever Door Handle	2 Pair
	**ACSM060** Heritage Lever/Lever Handle	
2 x Lever Handle  1 x 120mm Spindle 2 x Escutcheons  1 x 90mm Spindle	**ACSM095** Suitable With Lift Lever Addtional Parts: HEA132 - M5 x 16mm ACUN3509 - M5 Rivnut	
	**ACW20261** Standard Lever/Lever Handle Fixing kit supplied	
	**ACW20062** Art Deco Lever / Lever Handle Available in Antique Brass and Satin Nickel Plate	

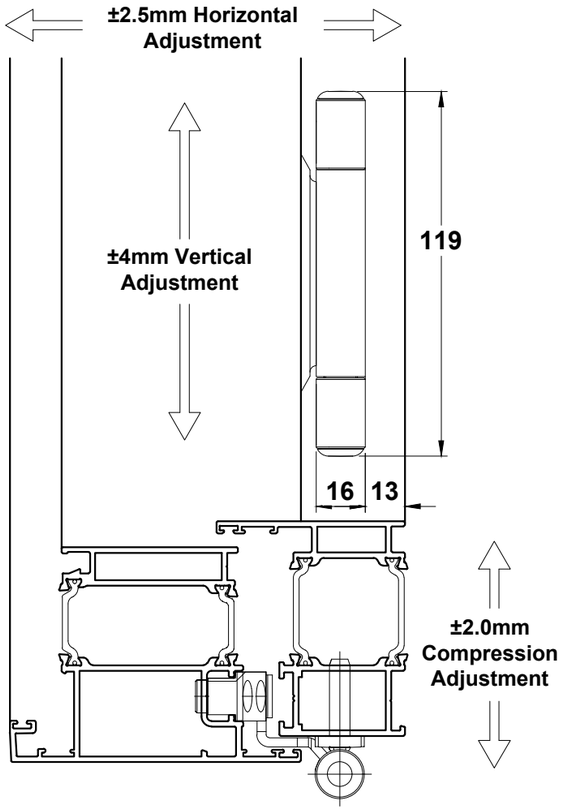
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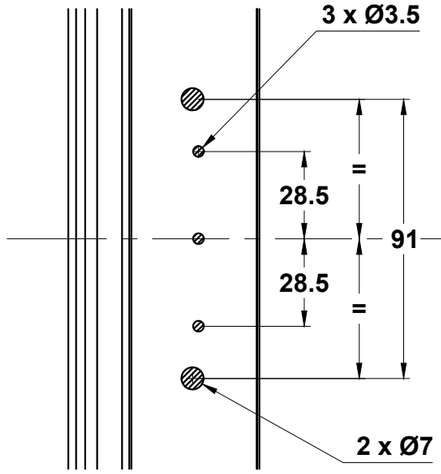
ACUL250 Hinge Preparation

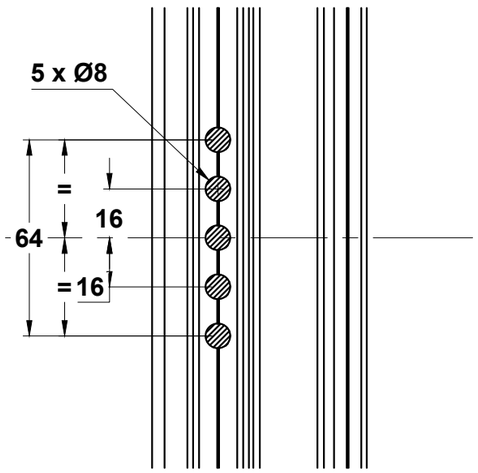


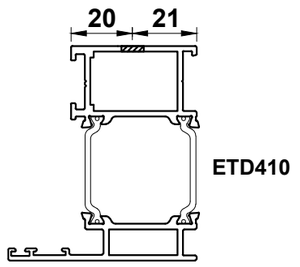


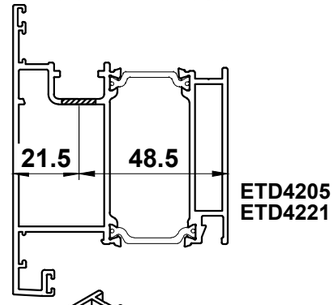
Surface Fixed Closers - Hinge Load Calculation	
Without Backcheck Increase door weight by 20%	**With Backcheck** Increase door weight by 75%
Example: (Glass Weight = 44kg) + 20% = 53kg	Example: (Glass Weight = 44kg) + 75% = 77kg

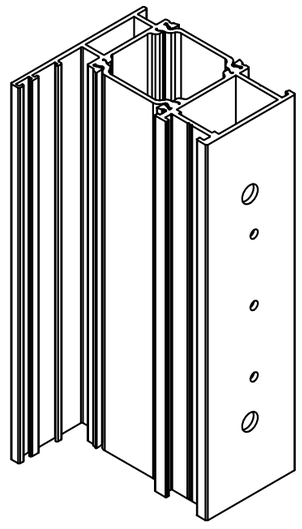


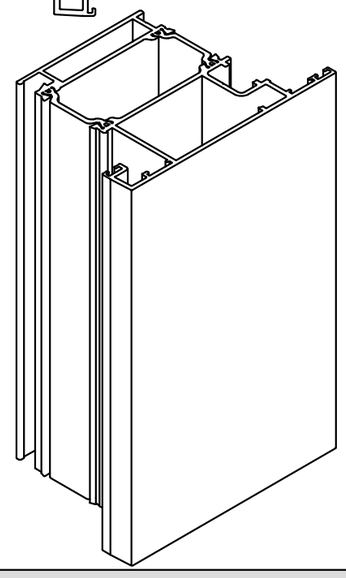










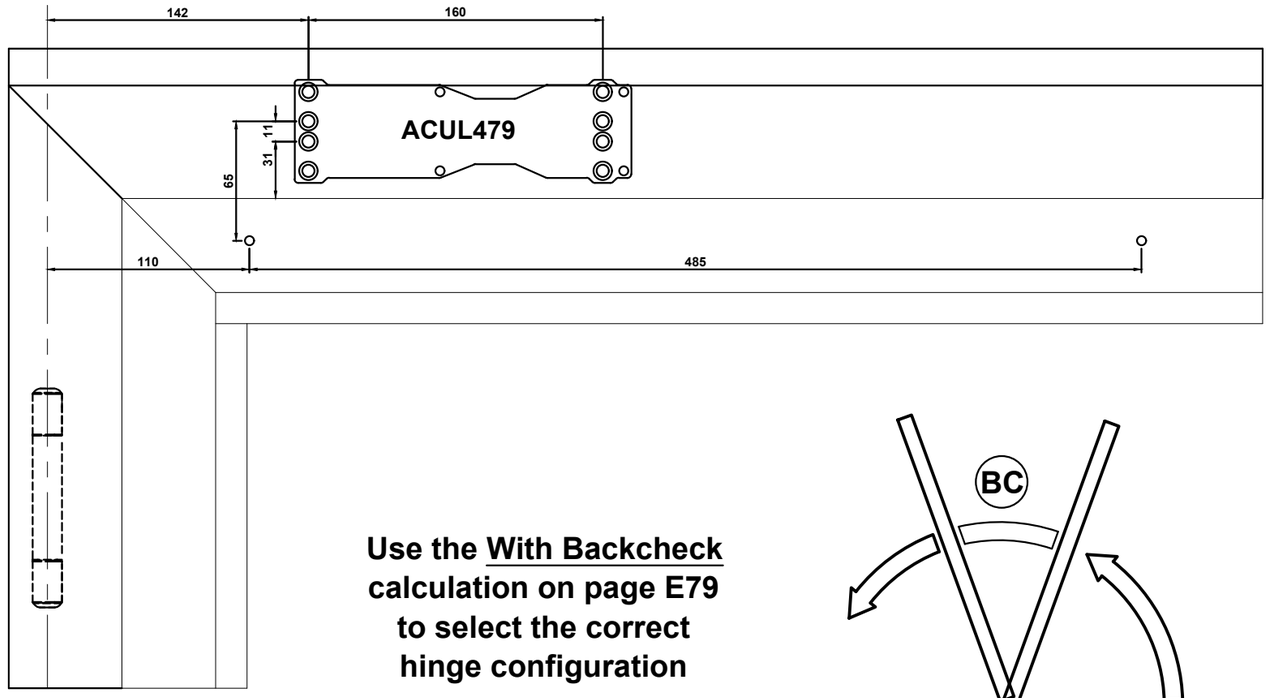


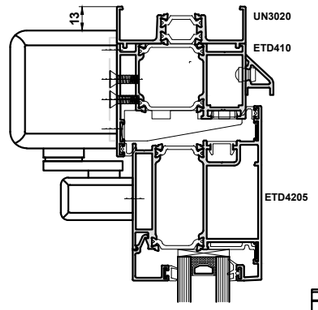
Fitting Instructions:
(Full instructions are supplied with each ACUL250 Hinge)

1. Align outer frame and sash in correct position
2. Clamp drill jig ACUL950 over the centre line of the hinge
3. Drill through all bushes marked '1' with a Ø7.2mm drill bit (supplied) and through all bushes marked '2' with a Ø3.5mm drill bit (not supplied)
4. Fasten the sash plate using ACIM062
5. Fasten the frame plate using ACUN3512 screws ensuring the grub screws are positioned towards the door sash
6. Drive in the central barrel until it lines up with the rings on the frame plate
7. Drive in pin 'B' to the top of the hinge and then drive in pin 'A' to the bottom of the hinge
8. Open the door and lightly tighten the security screws
9. Adjust hinge as required then insert caps and cover caps.

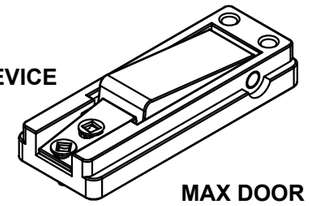
Do Not Scale From This Drawing

ACUL478 Surface Fixed Closer & Slide Arm - Open Out

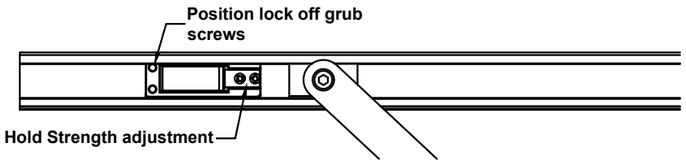




ACUL480
HOLD OPEN DEVICE

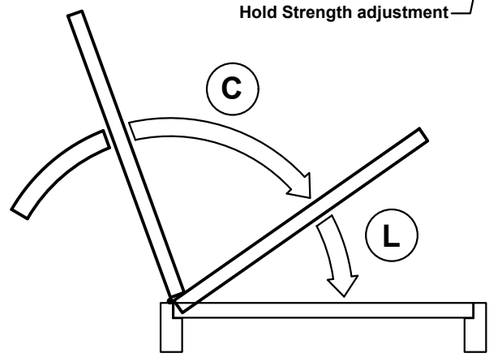


MAX DOOR WEIGHT 80KG



Use the <u>With Backcheck</u> calculation on page E79 to select the correct hinge configuration

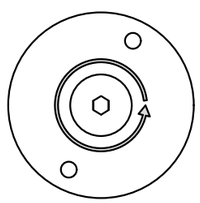
BACKCHECK

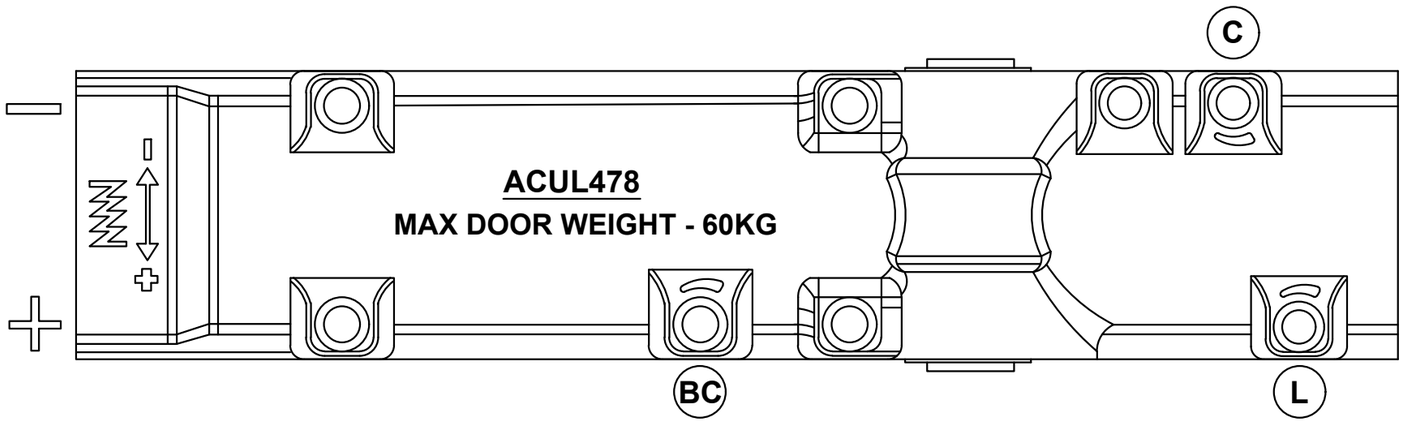


CLOSING SPEED

Size	Leaf Width	Full Turn
	Min	-7
EN1	< 750mm	-5
EN2	< 850mm	-3
EN3	< 950mm	0*
EN4	< 1100mm	+3

* Factory Setting

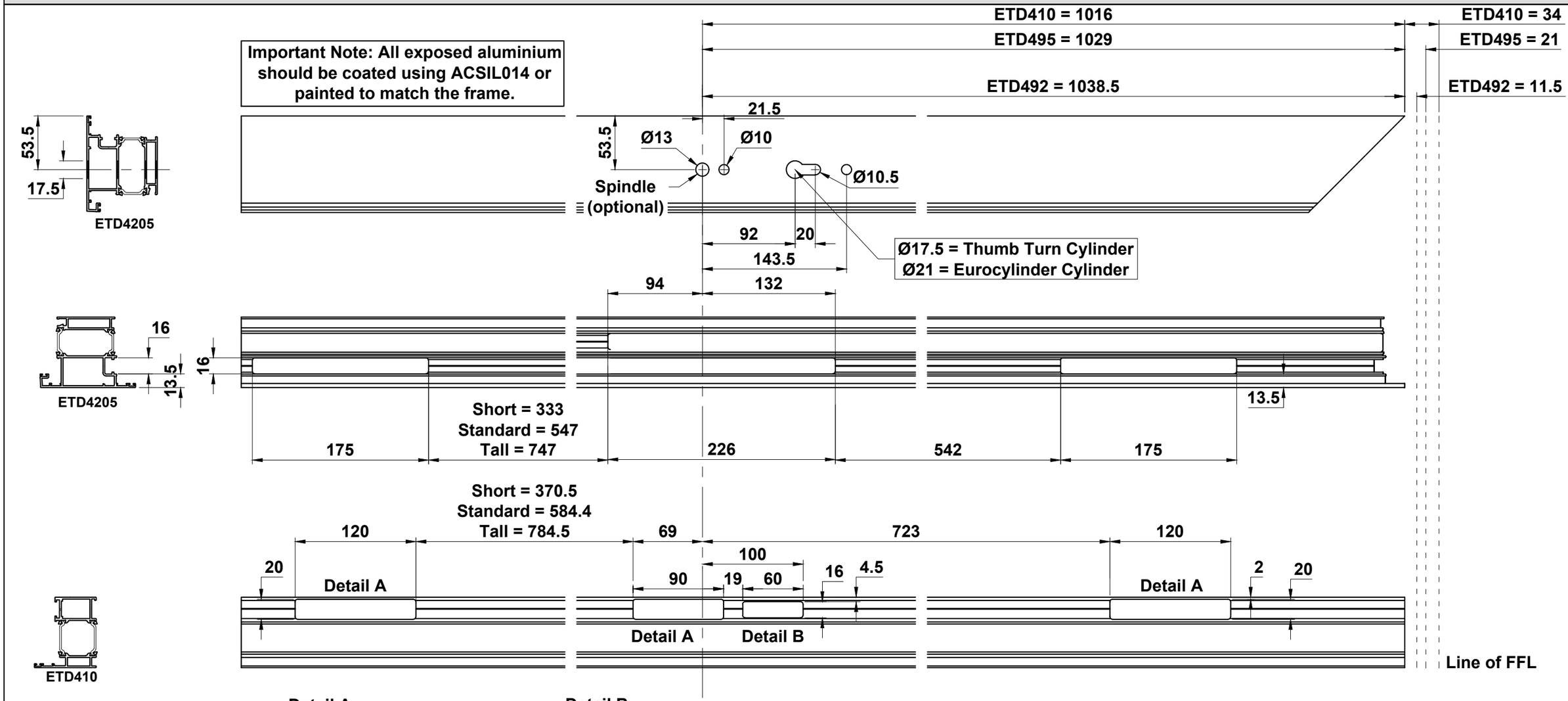




Please consult Technical Support for doors beyond these limitations.

Do Not Scale From This Drawing

Single Door Lock Preparation



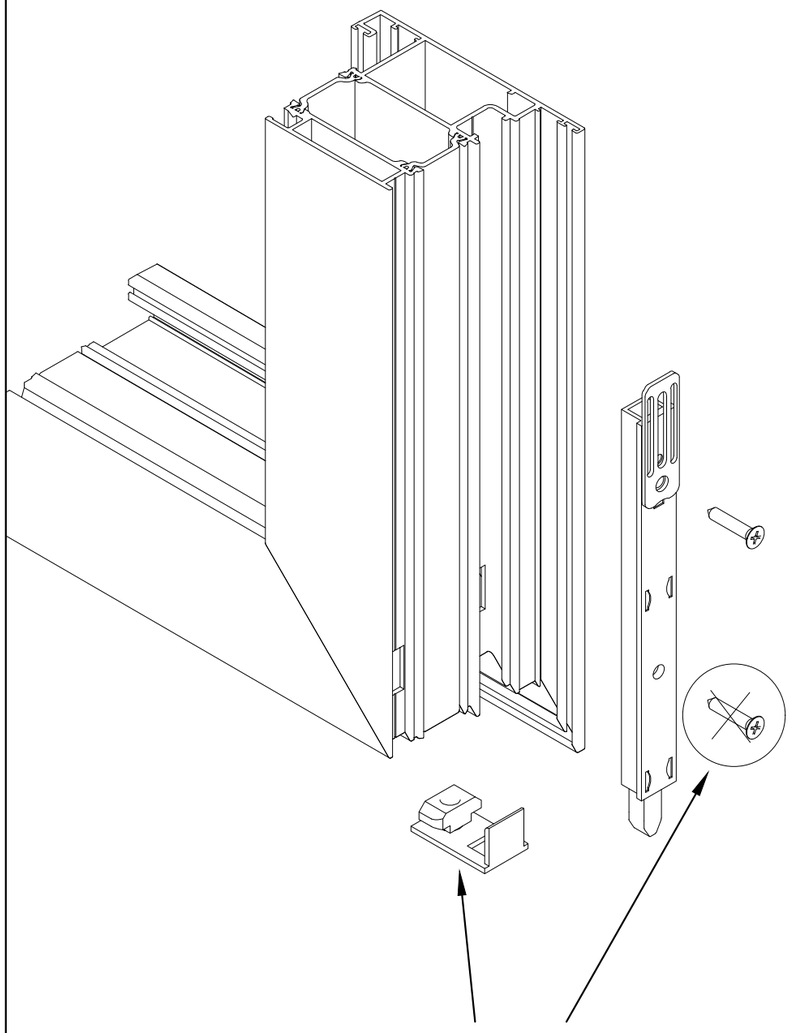
Lock Kits

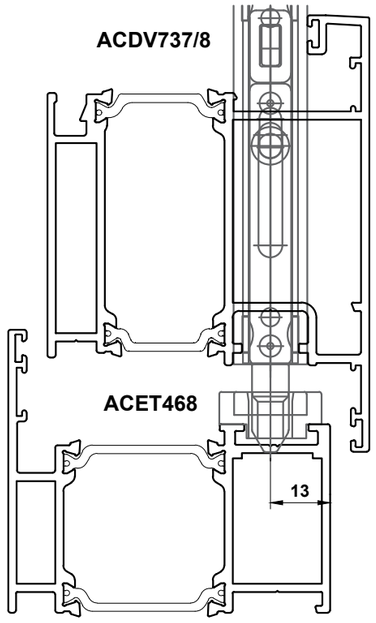
	Slam Lock		Key Wind		Lift Lever	
Height	Left Hand	Right Hand	Left Hand	Right Hand	Left Hand	Right Hand
Short	ACUL360	ACUL361	ACUL362	ACUL363	ACUL377	ACUL378
Standard	ACUL280	ACUL281	ACUL282	ACUL283	ACUL272	ACUL273
Tall	ACUL380	ACUL381	ACUL382	ACUL383	ACUL374	ACUL375

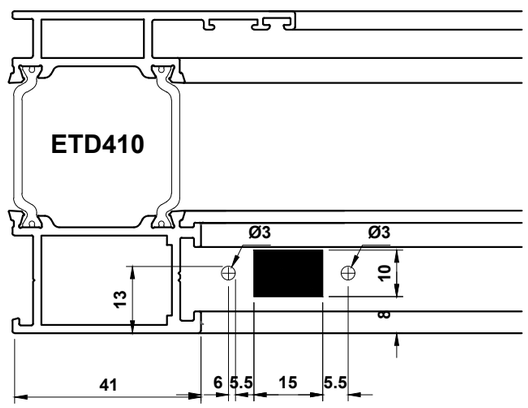
Do Not Scale From This Drawing

Alitherm 400 Stepped Door

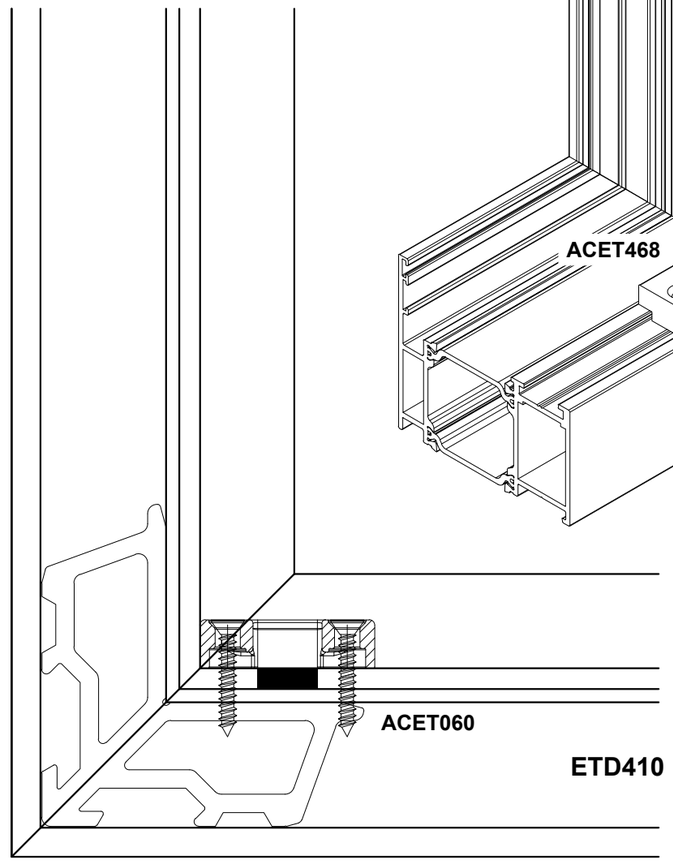
Single Door Shootbolt Detail

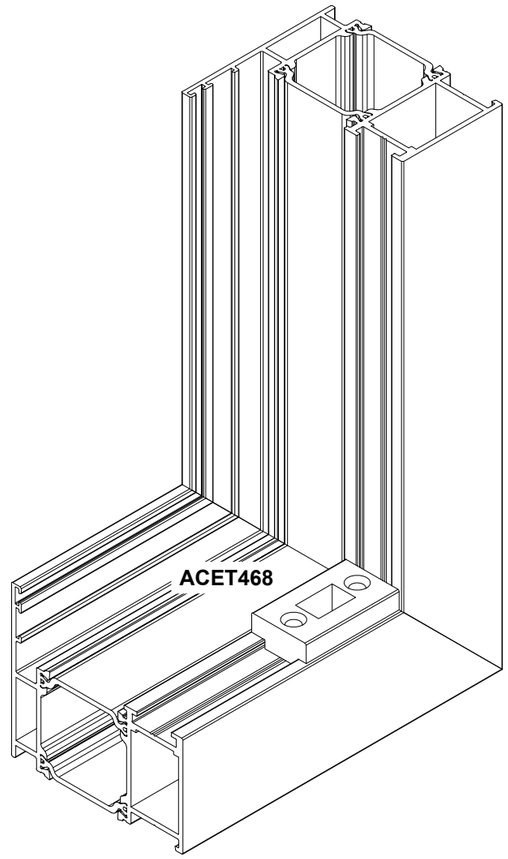






Doors above 2300mm high it is recommended to install shootbolts onto the multipoint lock

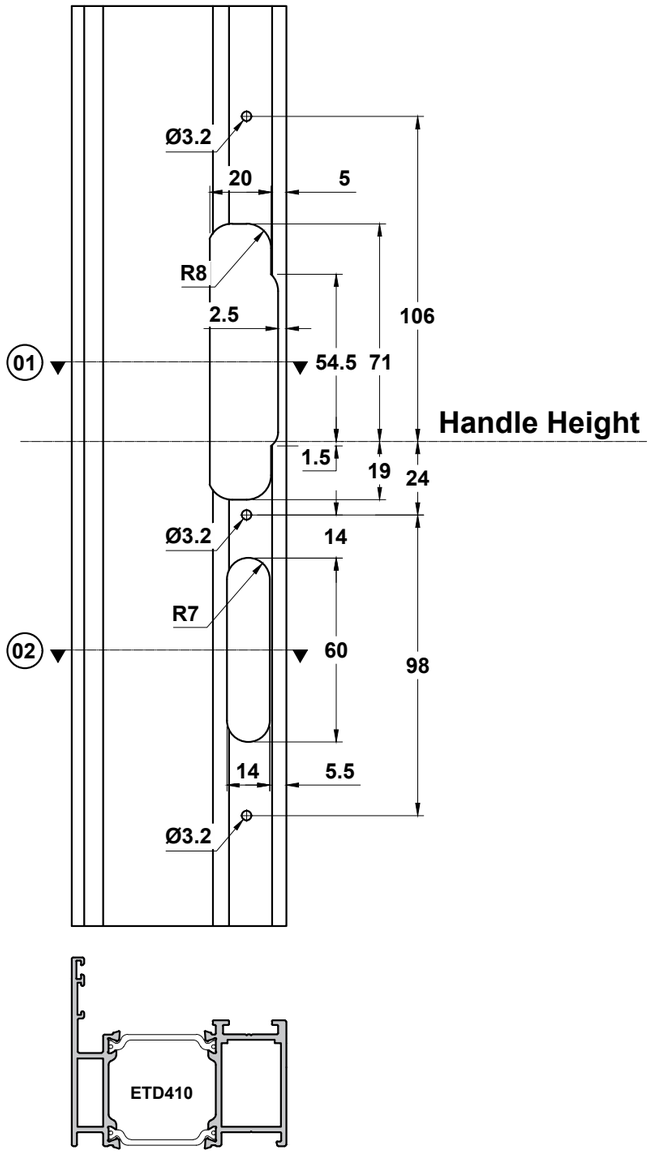


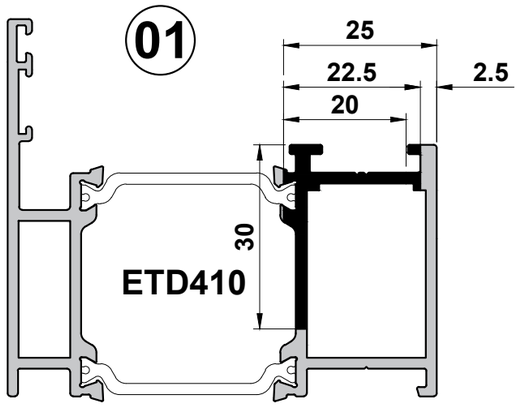


Do Not Scale From This Drawing

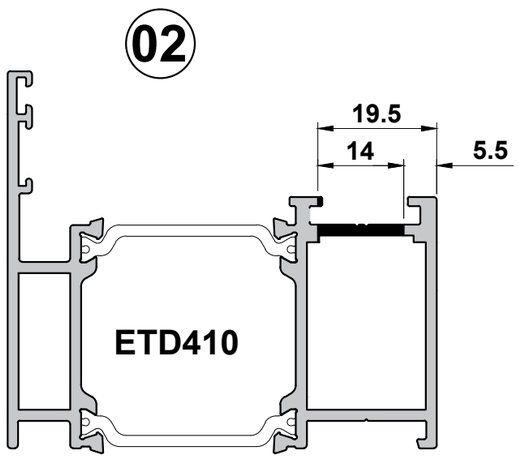
Open Out Electric Strike Details

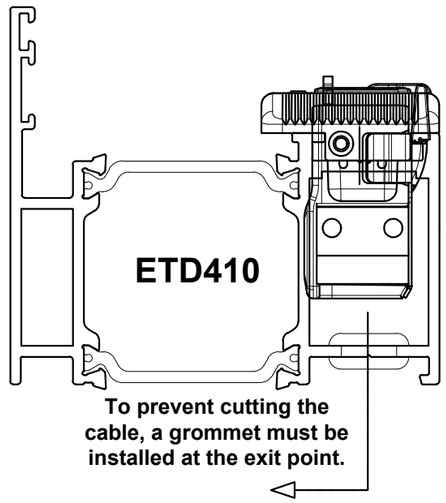
Centre Keep Cut Out





Ensure that the electric strike is powered only by a trained professional.



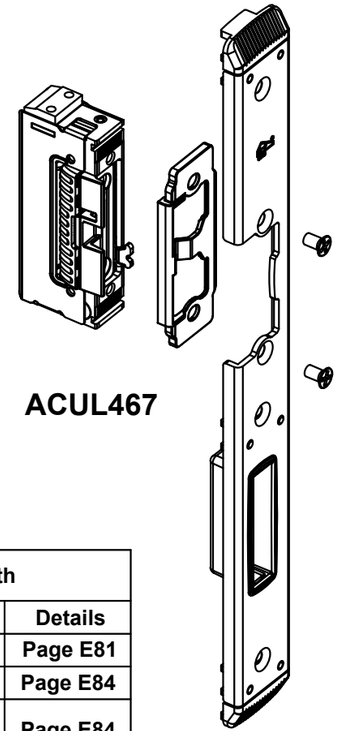


To prevent cutting the cable, a grommet must be installed at the exit point.

Max. Wire Size:

Solid:	2.5mm²
Fine-Stranded (flexible):	1.5mm²
Fine-Stranded (with ferrule) :	1.5mm²

ACUL465 - 12V DC FAIL SAFE
ACUL466 - 12V DC FAIL SECURE

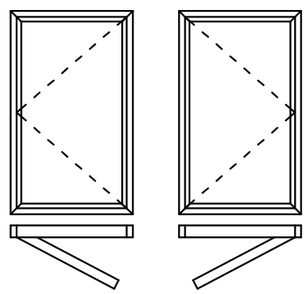


ACUL467

ACUL417

Keep Handing Guide

Viewed Externally

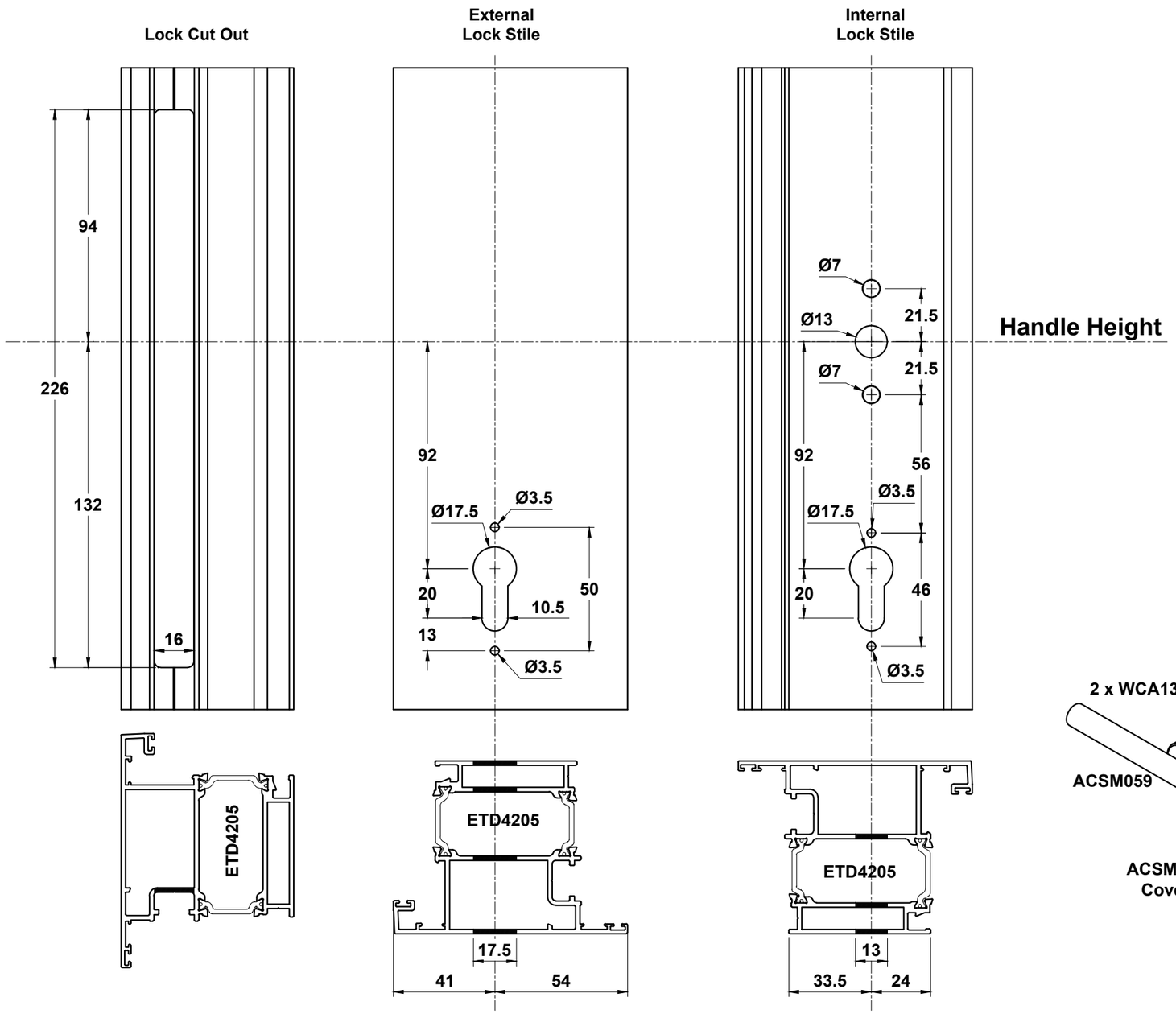


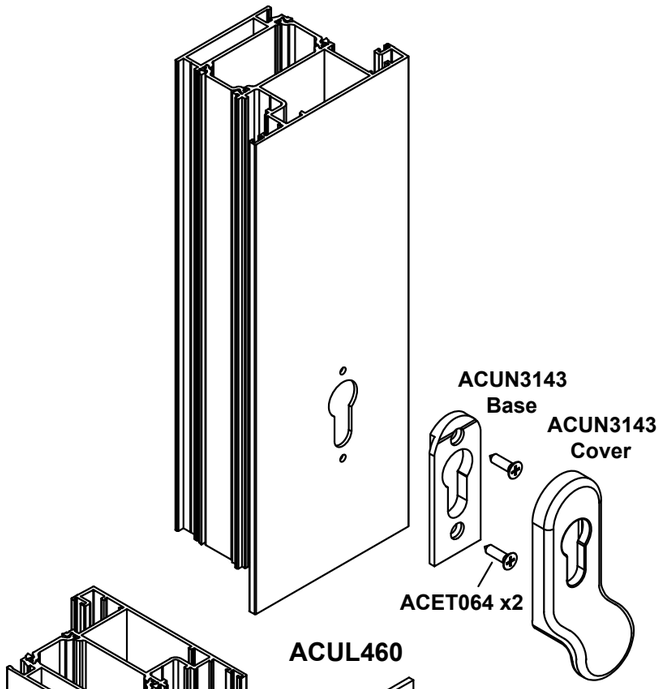
Left Hand Open Out	Right Hand Open Out
ACUL416	ACUL417

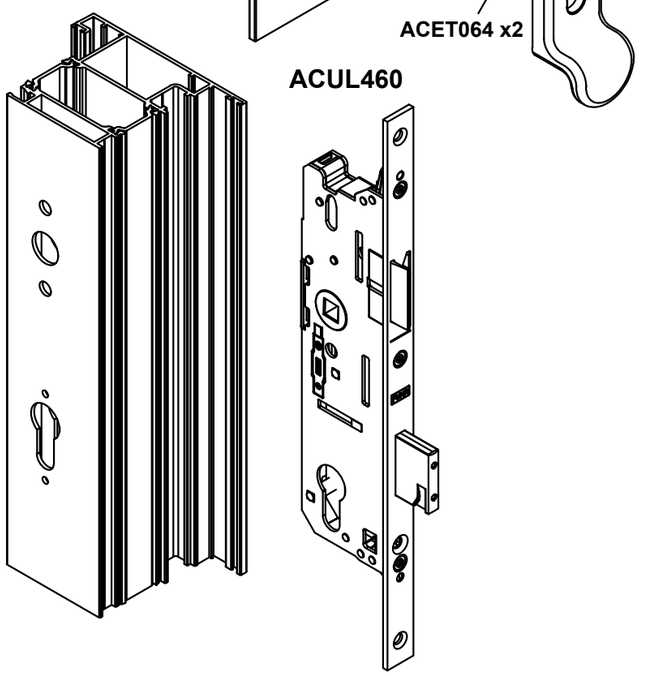
Can Be Used With		
Hardware	Type	Details
Lock	Key Wind	Page E81
Lock	Single Point	Page E84
Handle	Lever / Cylinder Pull	Page E84
Handle	Straight Pull Handle	Page E26

Do Not Scale From This Drawing

Single Point Lock & Internal Lever Handle Preparation





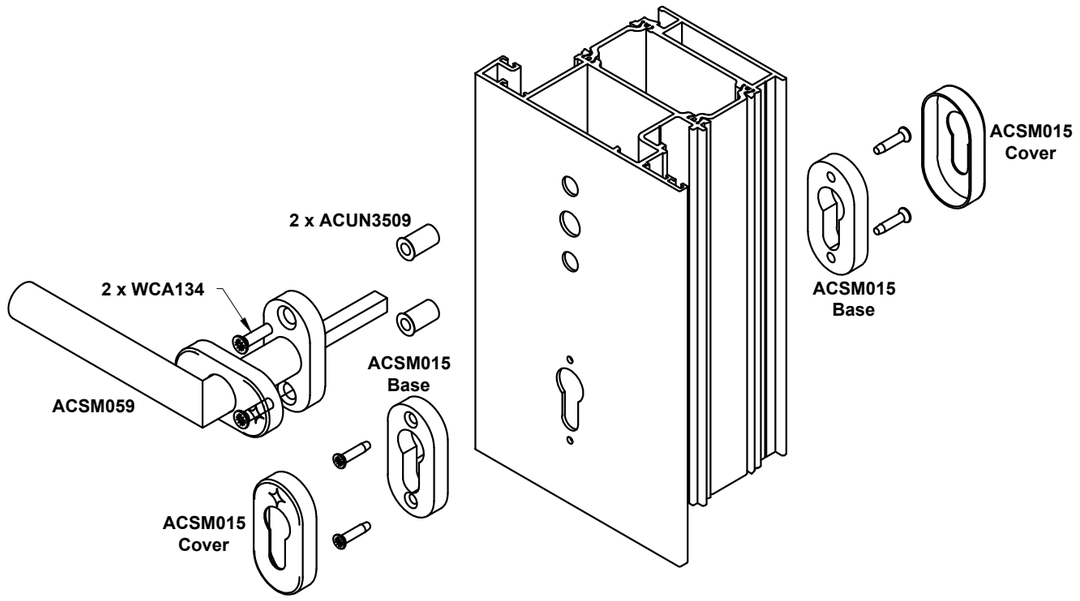


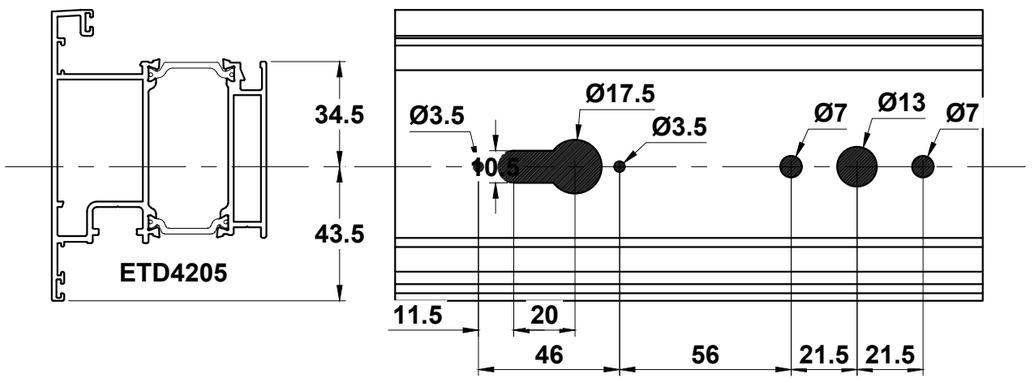
Do Not Scale From This Drawing

Stainless Steel Hardware - ACSM013, ACSM015, ACSM058 & ACSM059 Fitting Detail

Please Note:

ACSM059 is compatible with slam locks and key operated locks only.
Slam locks must not have an external lever handle.

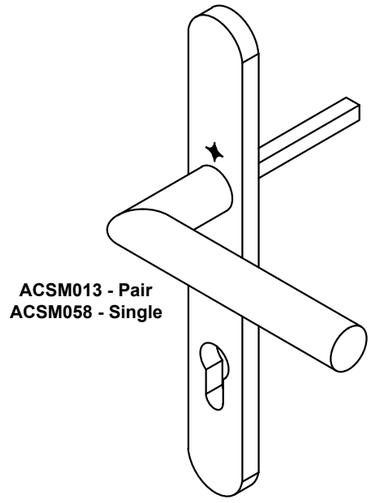




Please Note:

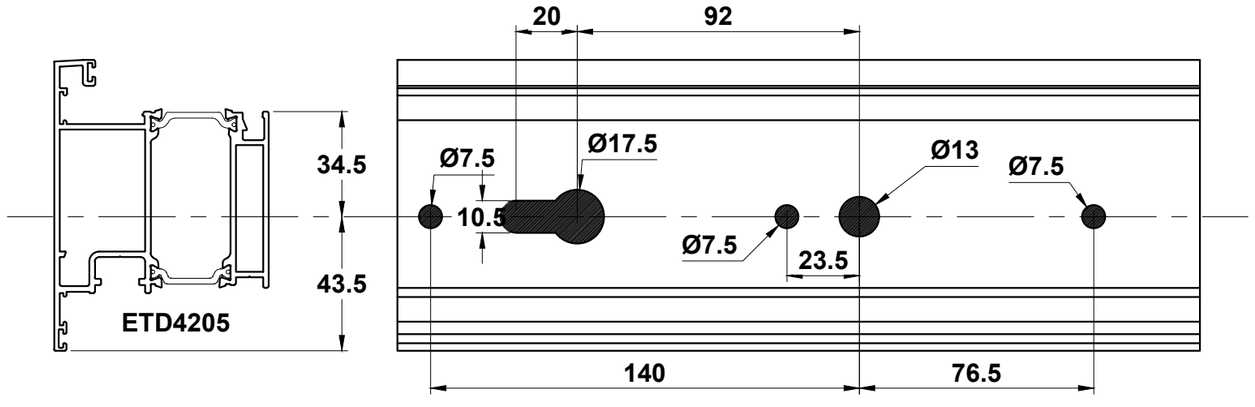
ACSM058 is compatible with all locks.
Slam locks must not have an external lever handle therefore require WCA134 & ACUN3509 for single side fixing and the spindle will need to be cut down.

Important Note: All exposed aluminium should be coated using ACSIL014 or painted to match the frame.



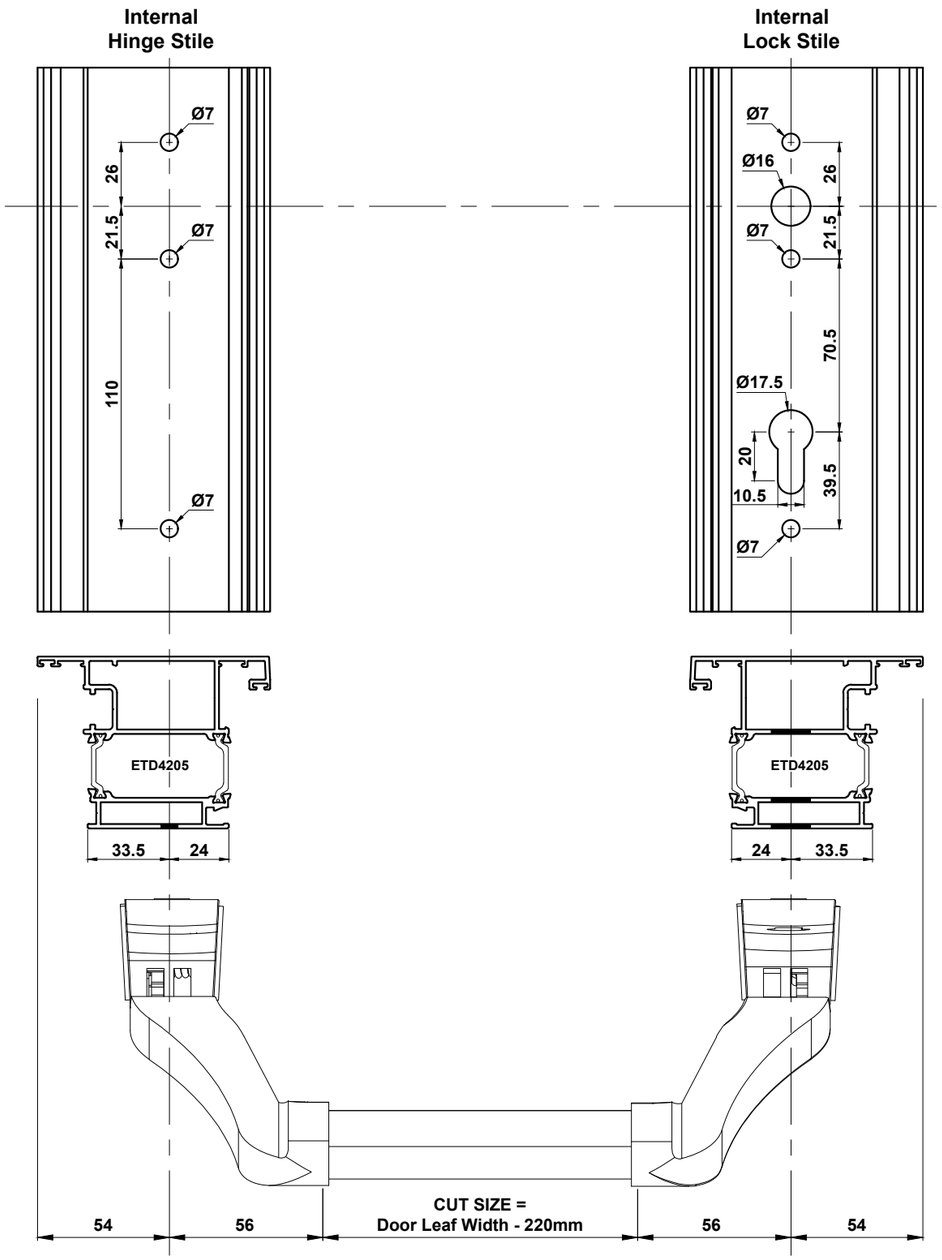
Please Note:

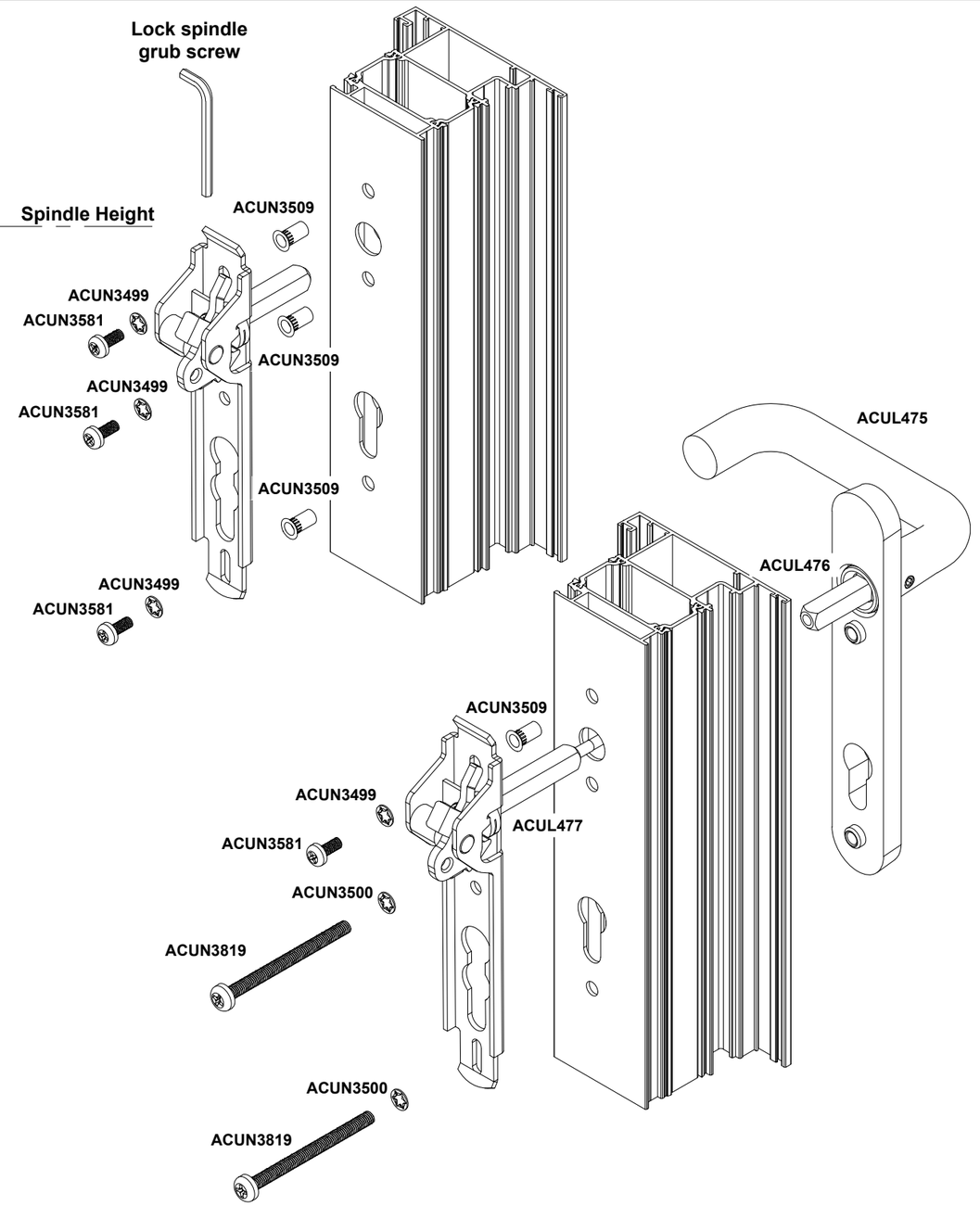
ACSM013SS pack contains;
2 x Universal Backplate & Lever
2 x Cover Plate
2 x Bolt Receiver Sleeve
2 x 40mm M5 Machine Screws
2 X 60mm M5 Machine Screws
1 x 3mm Allen Key
1 x 170mm Spindle



Do Not Scale From This Drawing

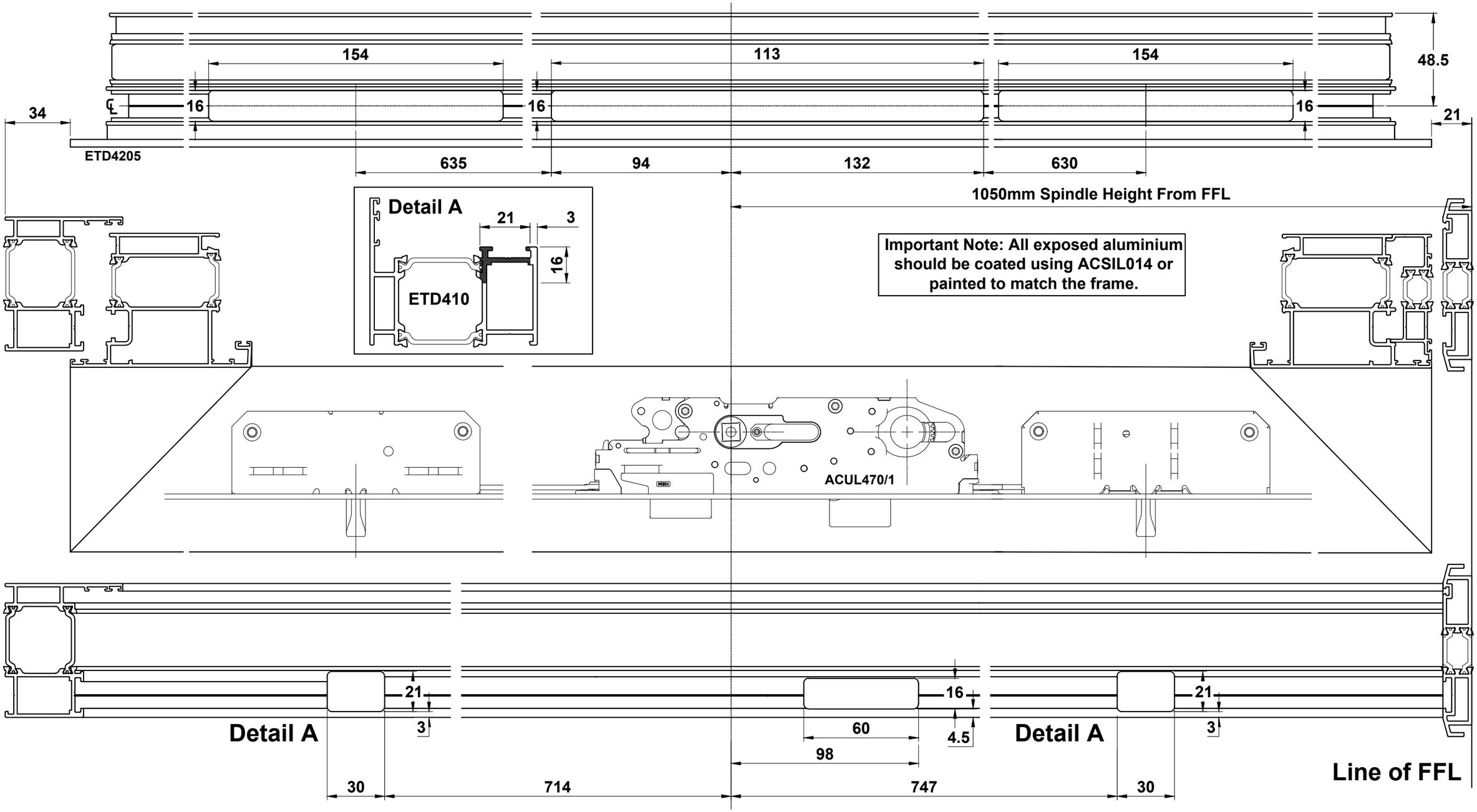
Panic Bar Preparation





Do Not Scale From This Drawing

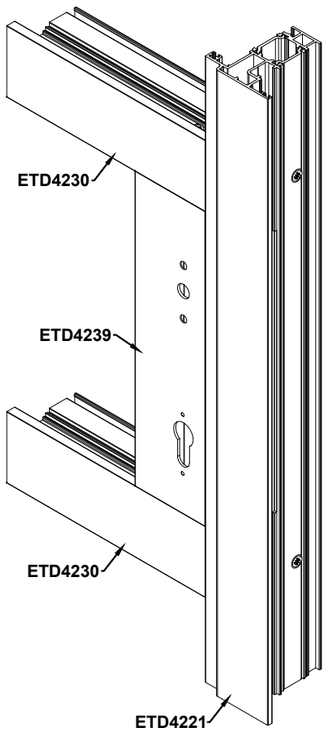
Panic Lock Preparation for Low Ramp Threshold

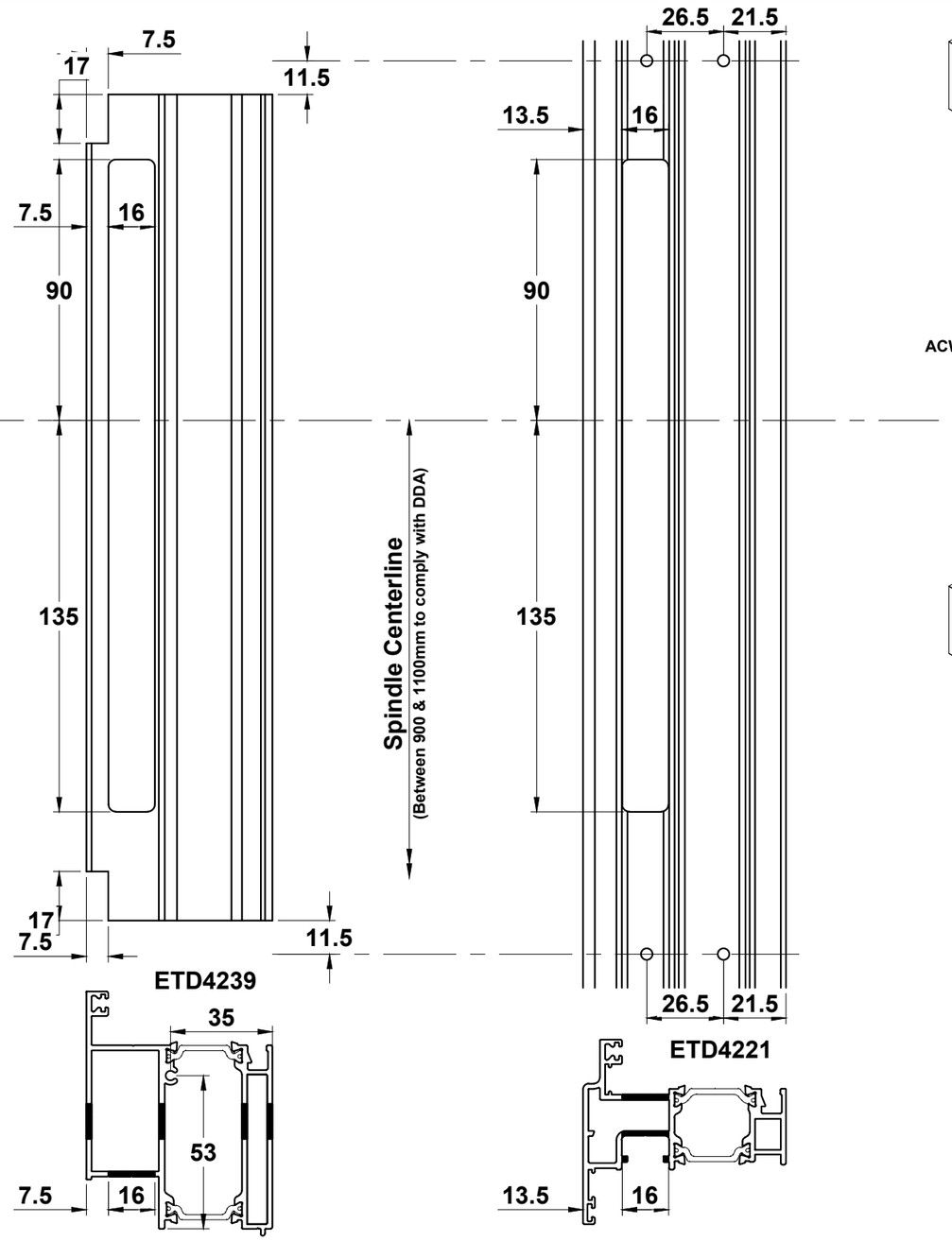


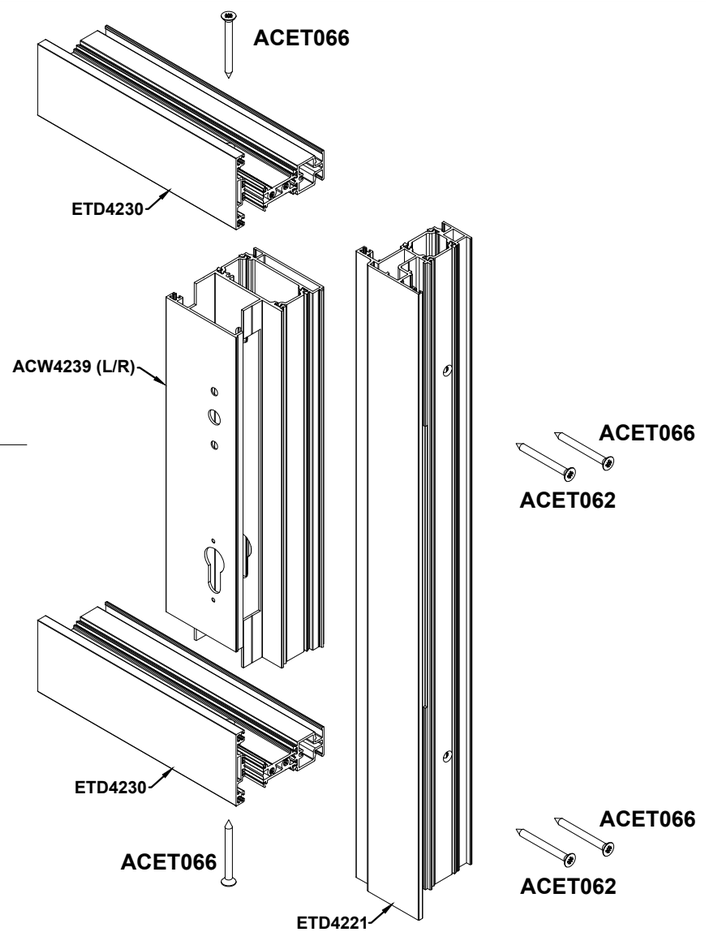
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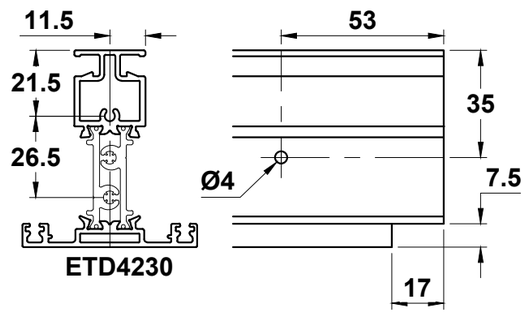
Heritage Open Out Door Lock Preparation

FOR ACW20465 & ACW20466 LOCKS



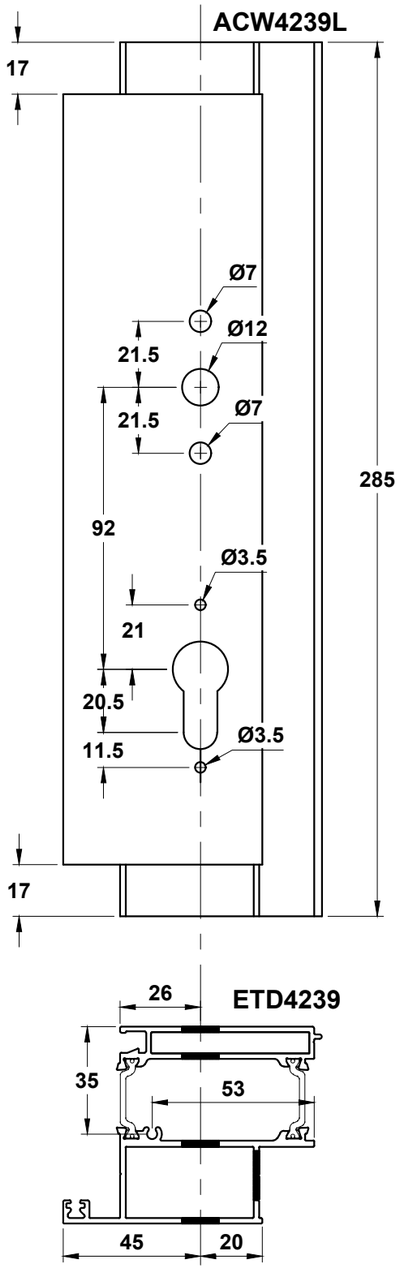




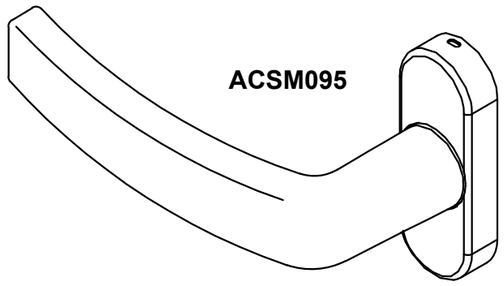


Do Not Scale From This Drawing

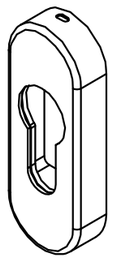
Heritage Open Out Door Handle Preparations

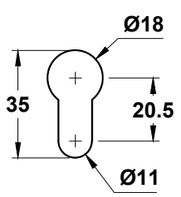


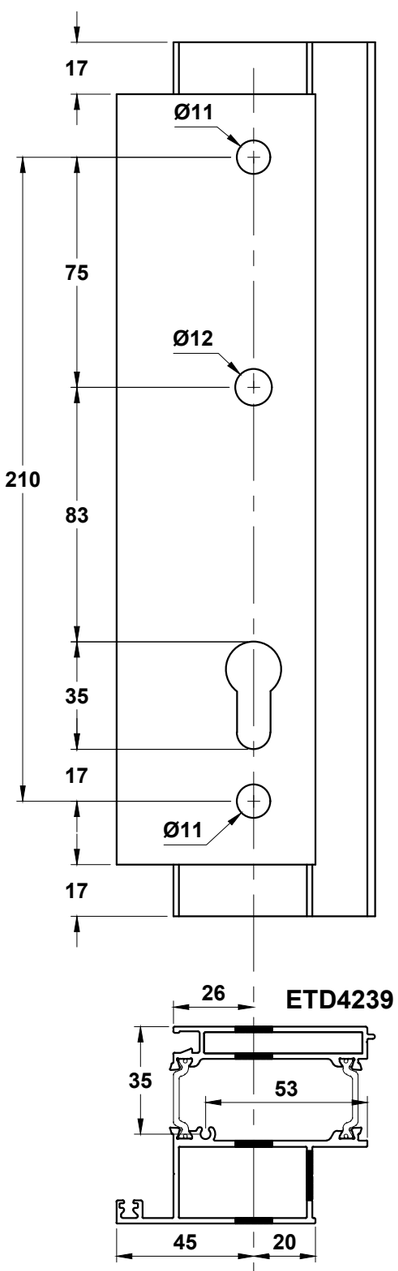
Lever Handle & Oval Rose



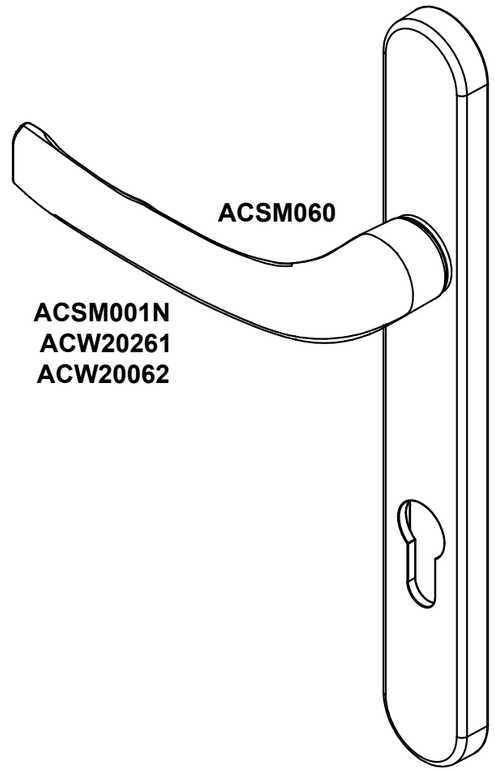
ACW4239L/R
Pre Prepared Lock Casing

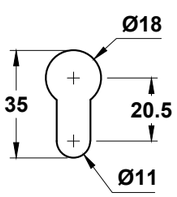






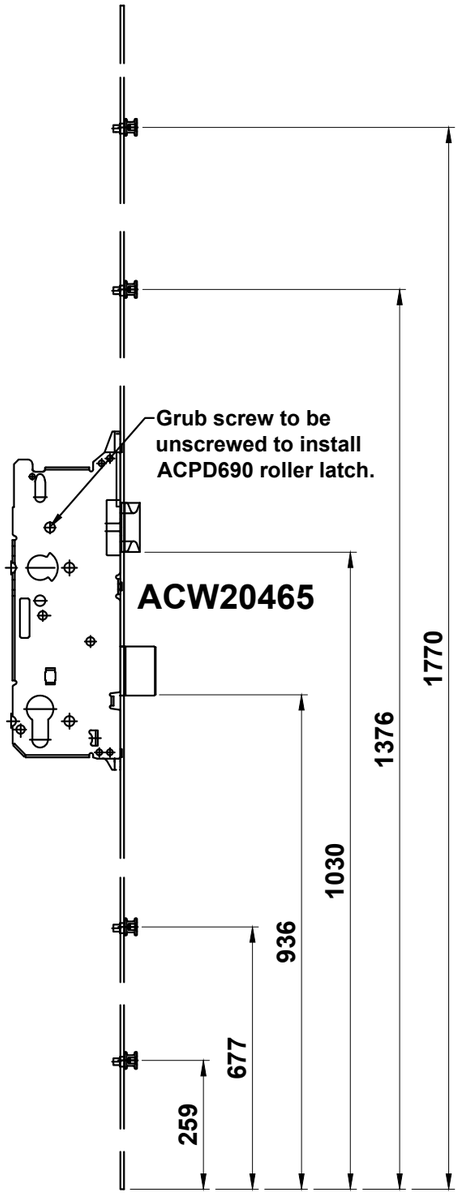
Long Escutcheon Handles





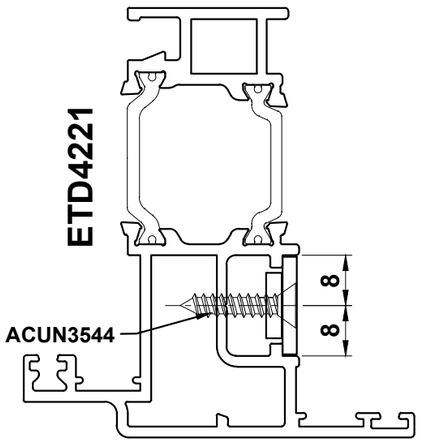
Do Not Scale From This Drawing

Heritage ACW20367 Door Keep Position Guide



Locking Positions (in unlocked position)

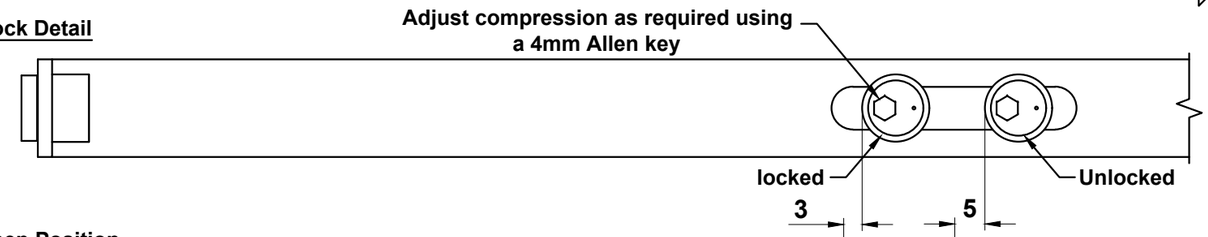
Lock Fixing to Sash



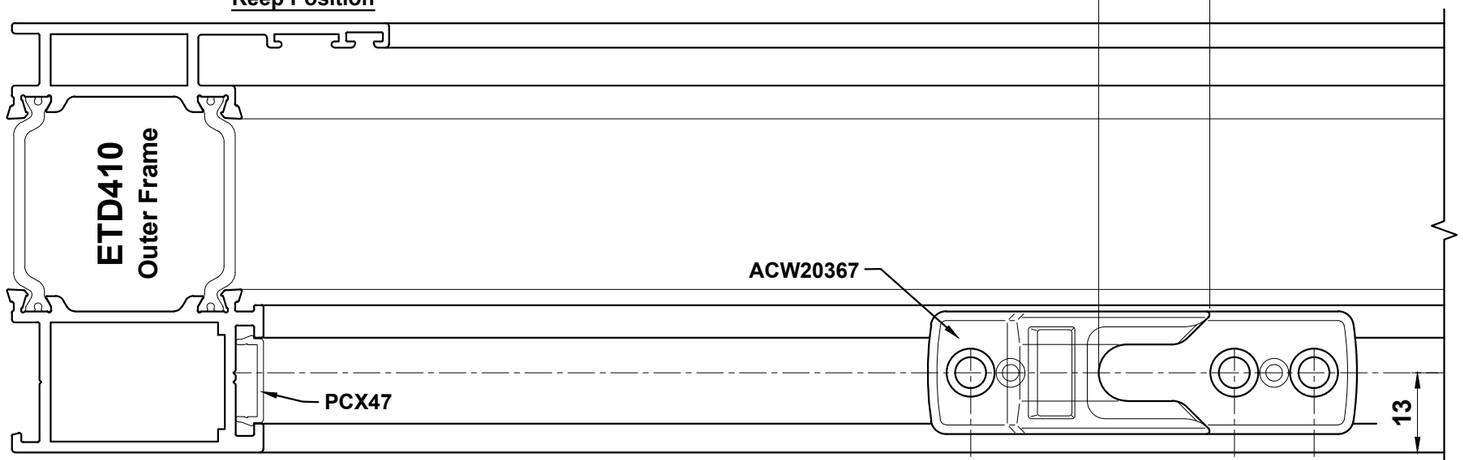
Cill

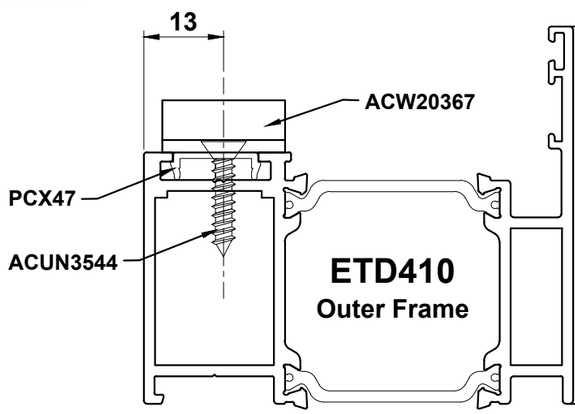
Head

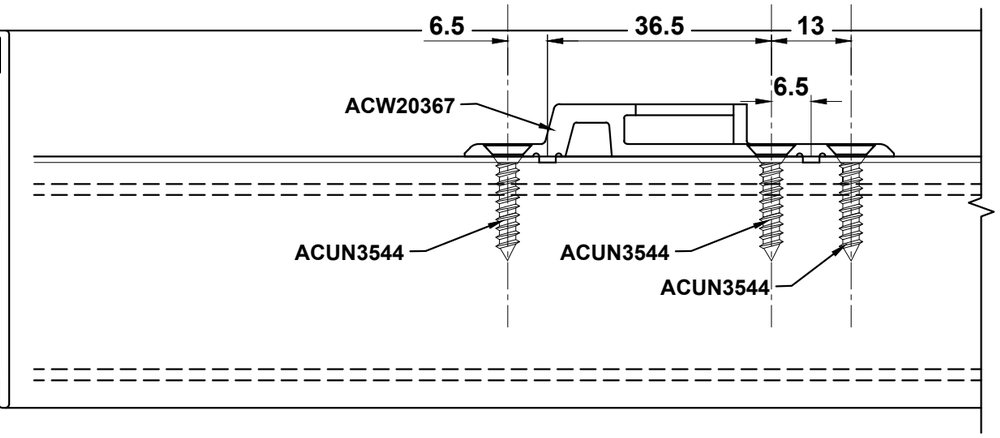
Lock Detail



Keep Position





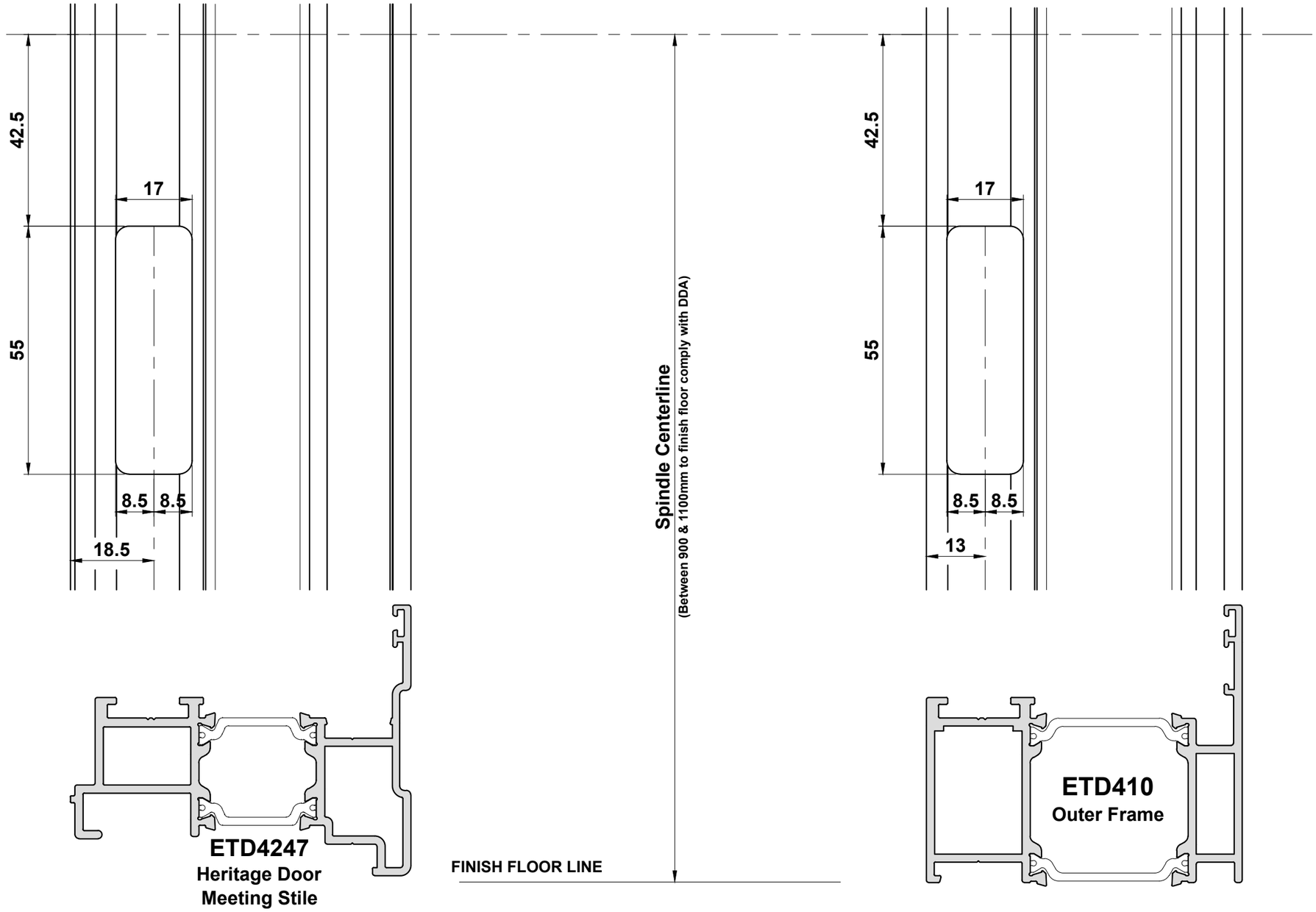


Cill

Do Not Scale From This Drawing

Heritage ACW20066 L/R Door Centre Keep Preparation

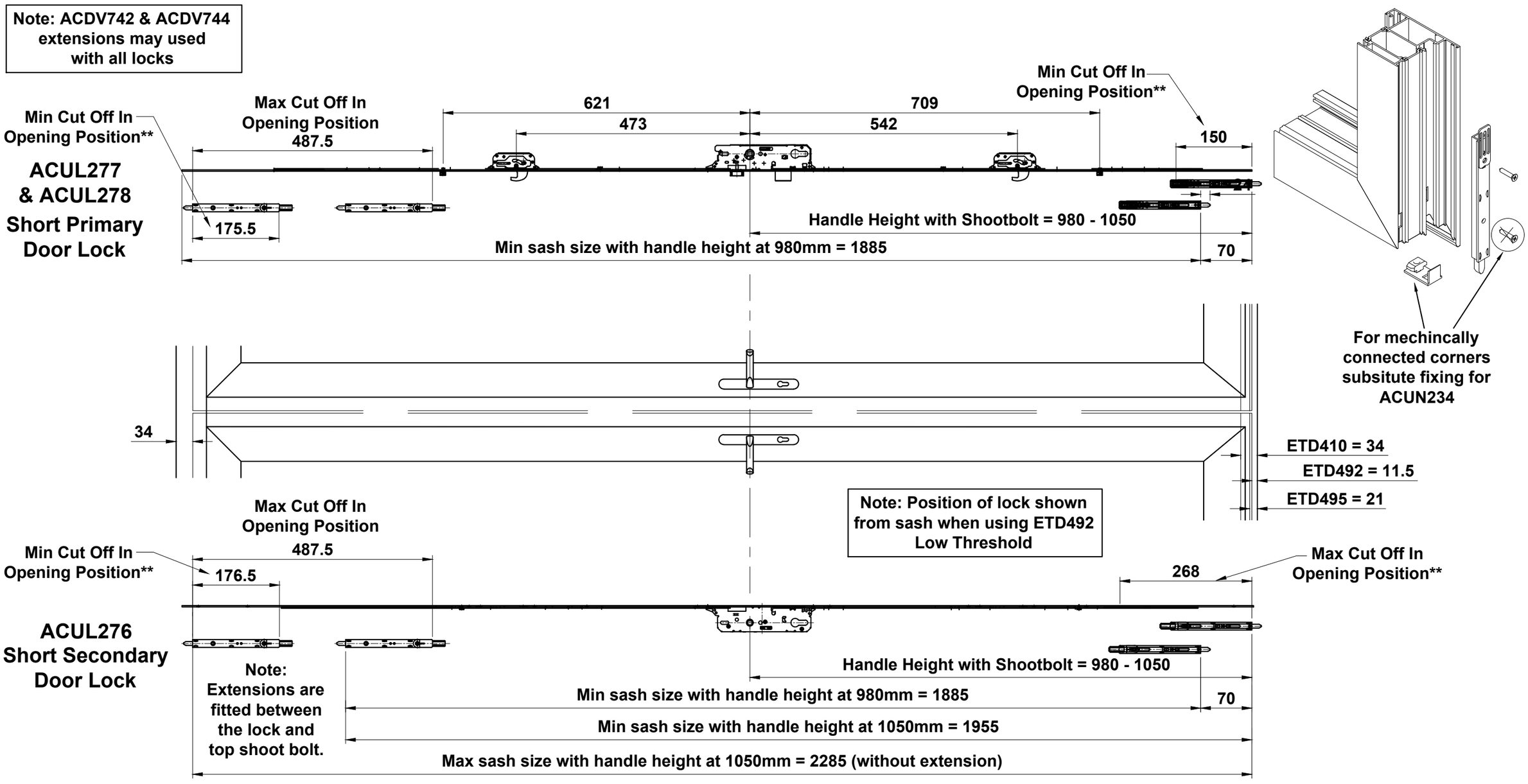
ACW20066 Open Out Centre Keep



Do Not Scale From This Drawing

Double Door Lift Lever Shootbolt Layout

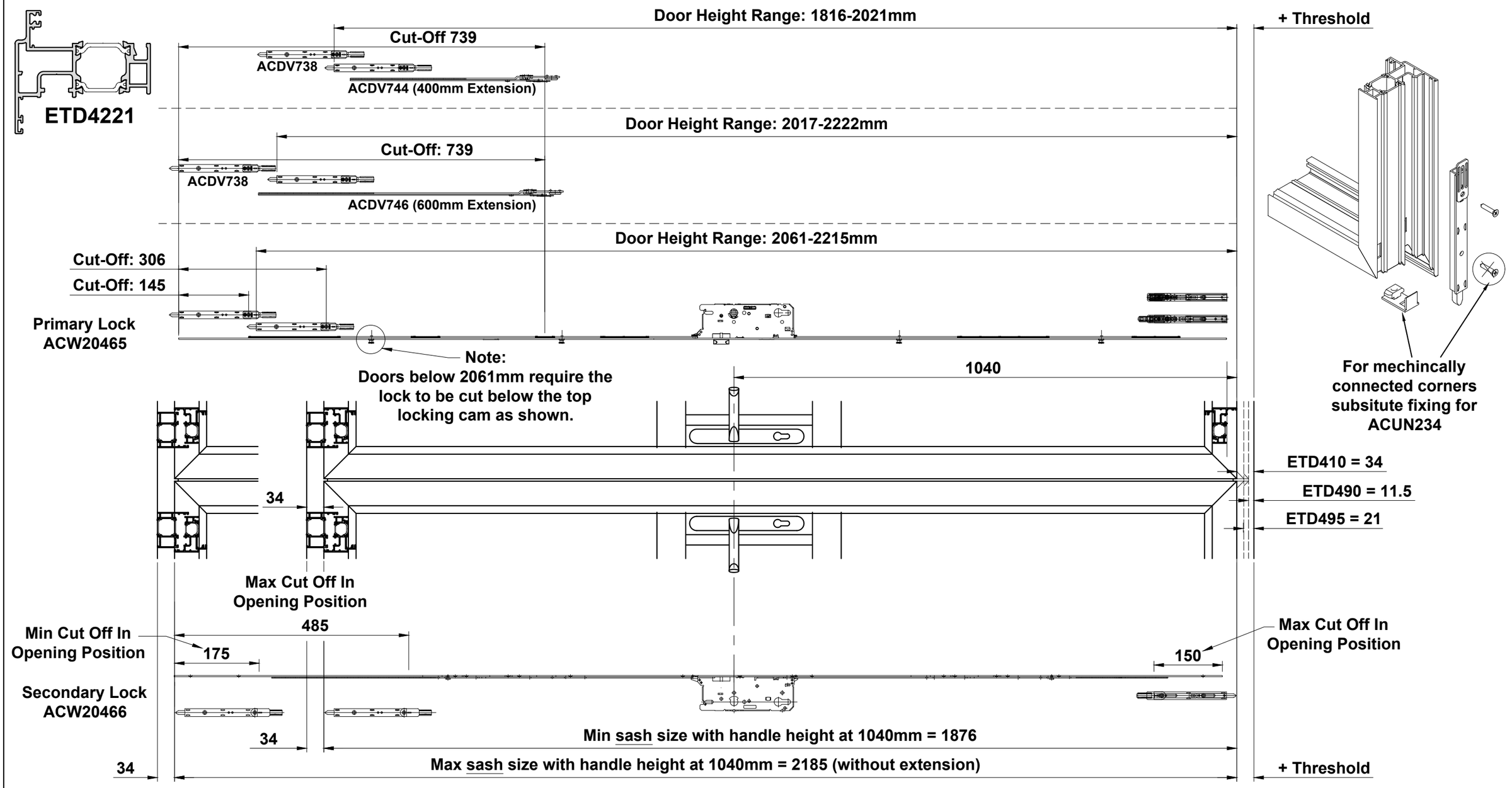
Note: ACDV742 & ACDV744 extensions may used with all locks



*Maximum sash height is 2500mm. Sizes shown here only indicate sizes with ACDV744.

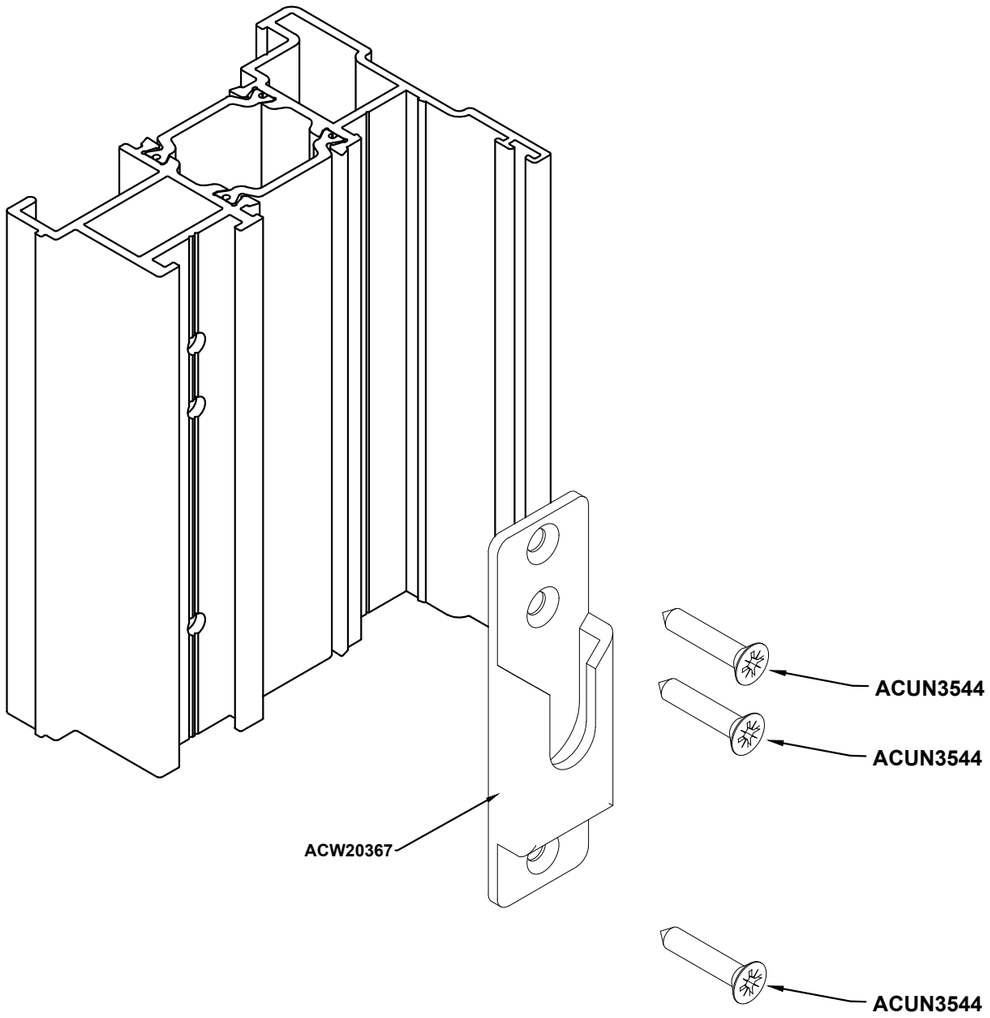
Do Not Scale From This Drawing

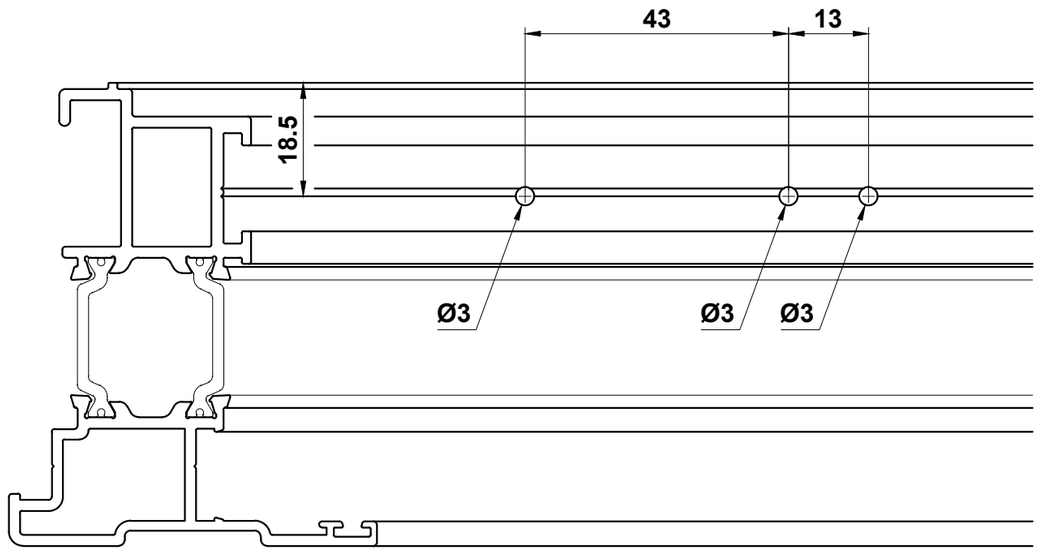
Heritage Double Door Lift Lever Shootbolt Layout

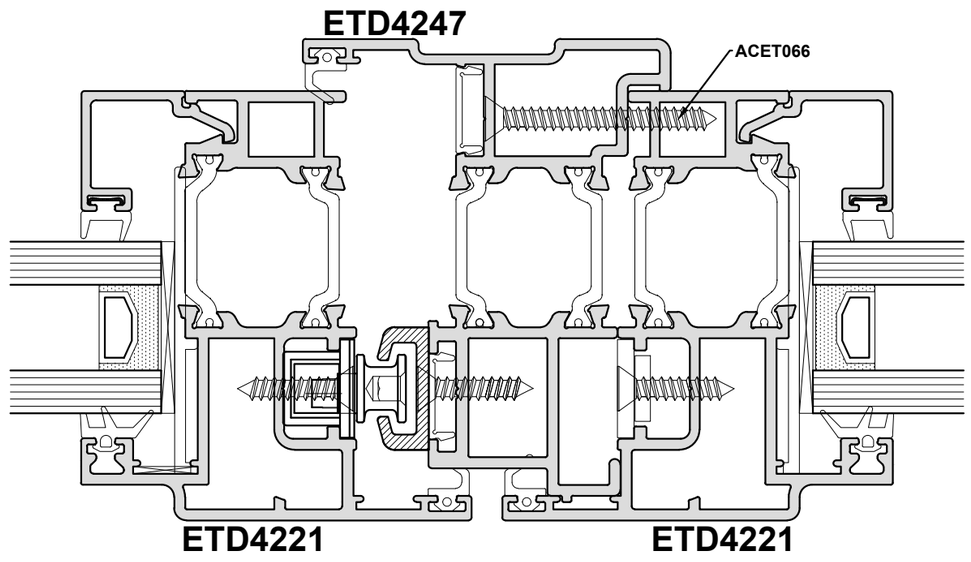


Do Not Scale From This Drawing

Heritage ACW20367 Floating Mullion Installation

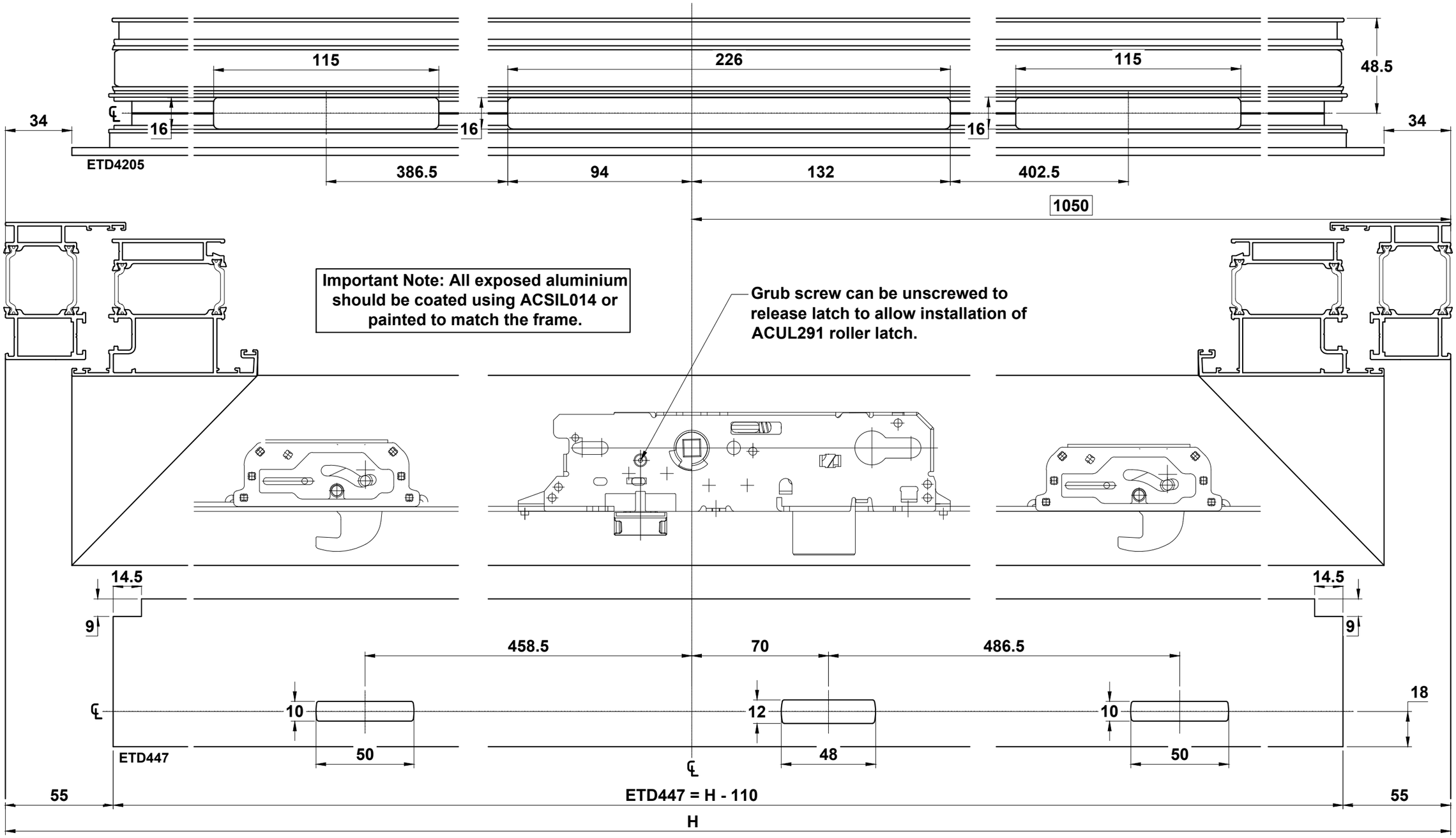






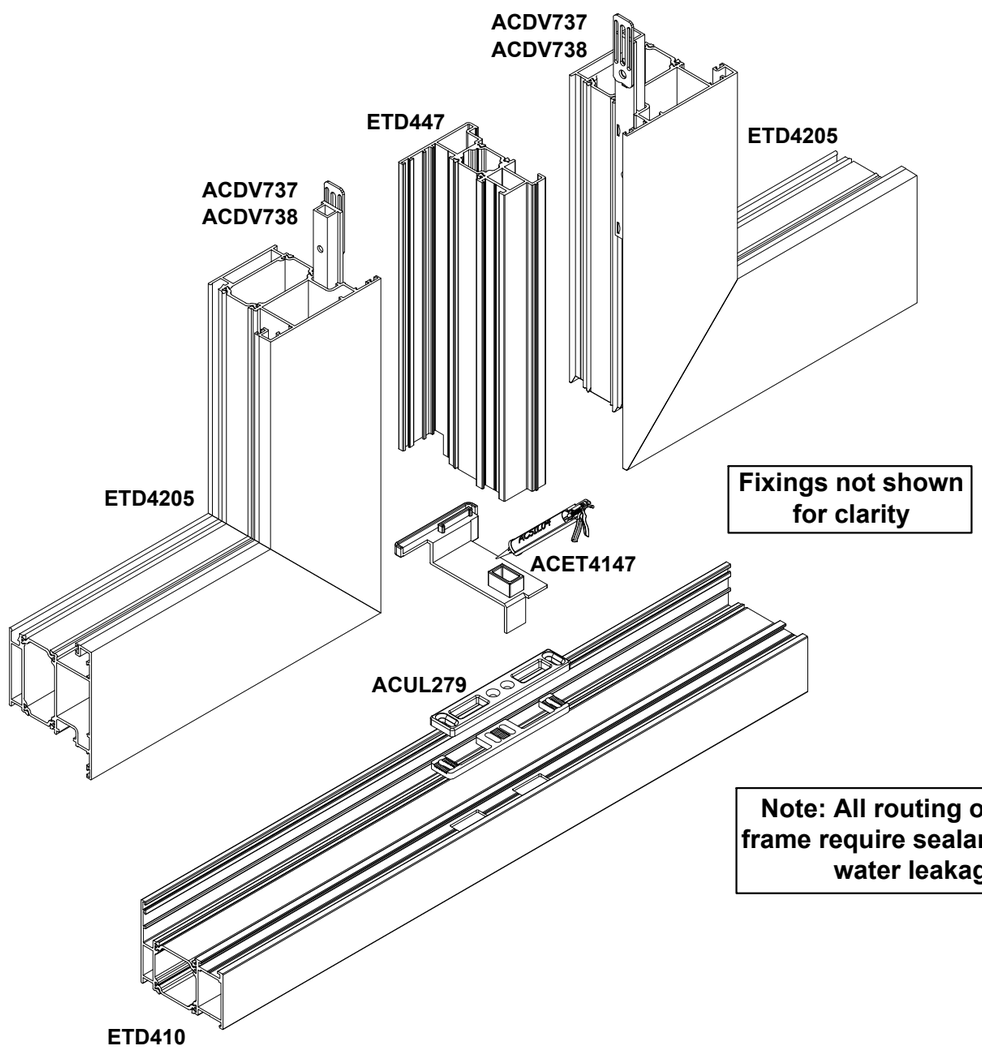
Do Not Scale From This Drawing

Double Door Lift Lever Lock Preparation for Full Frame



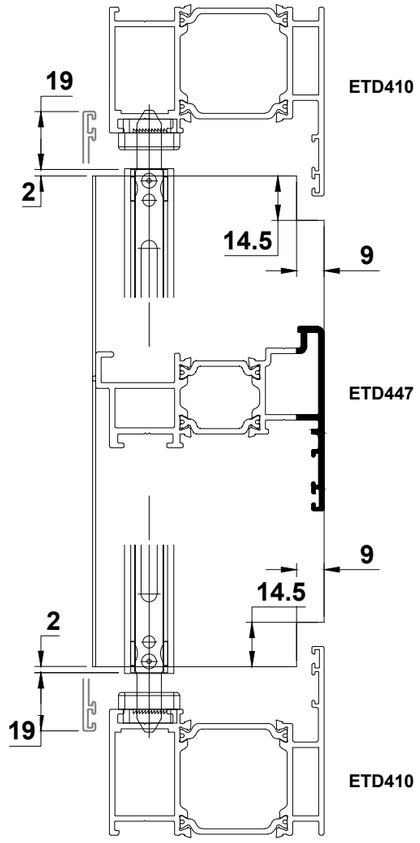
Do Not Scale From This Drawing

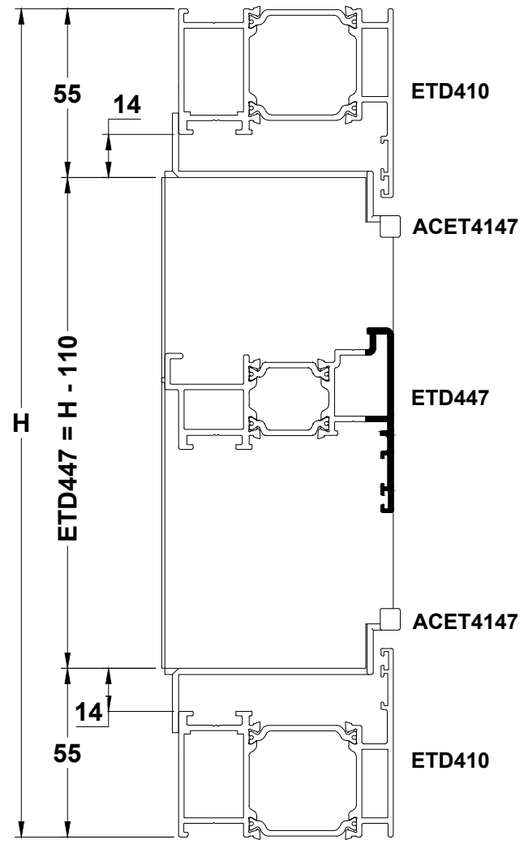
Double Door Lift Lever Meeting Stile Assembly for Full Frame

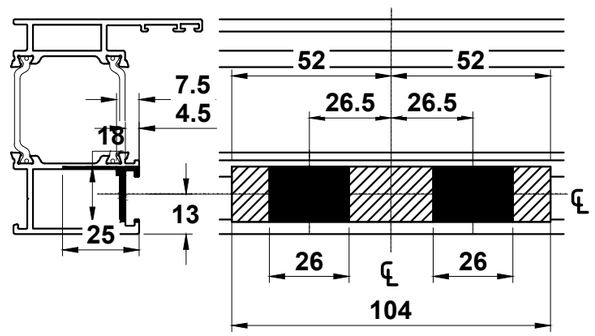


Fixings not shown for clarity

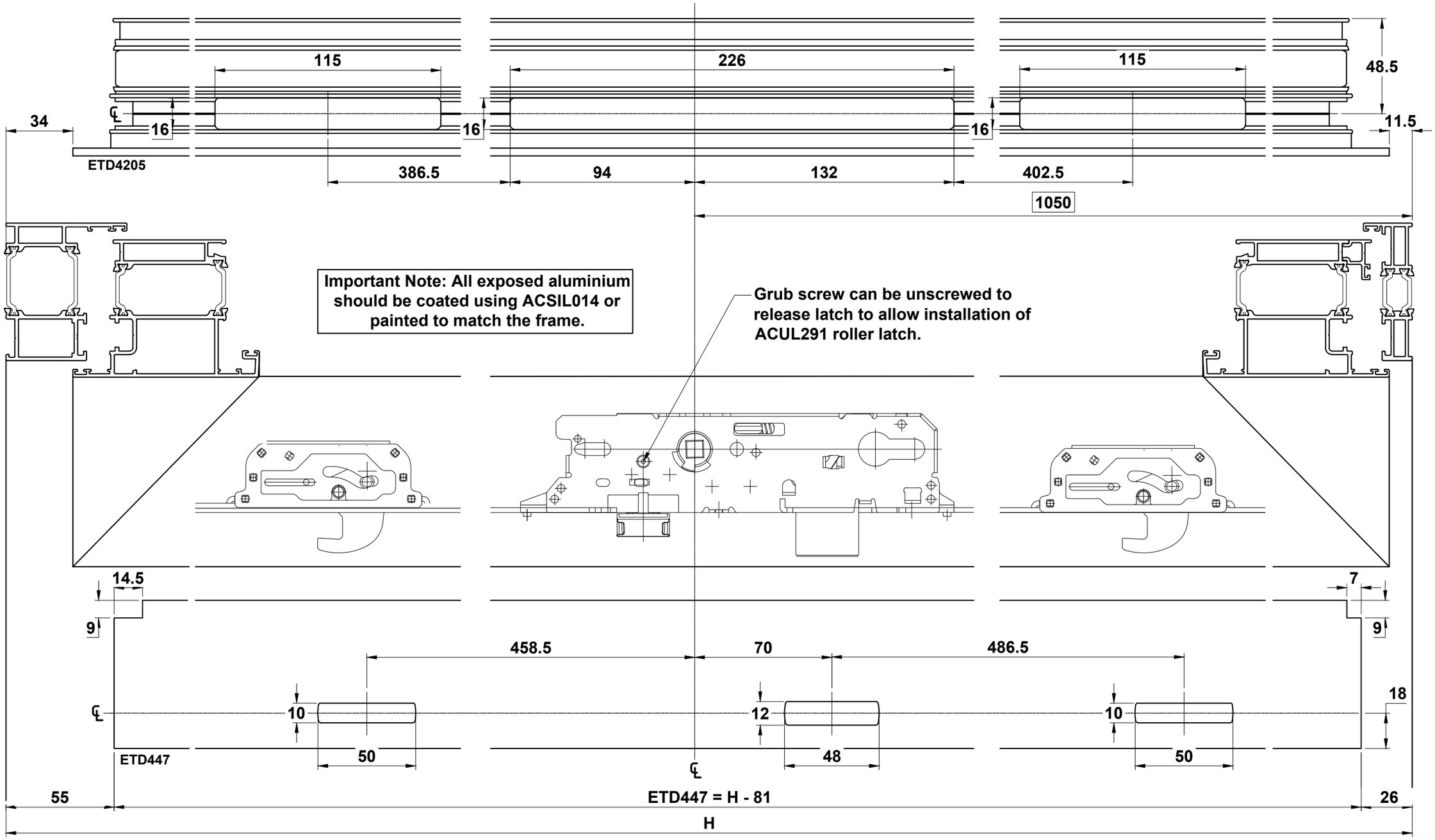
Note: All routing on outer frame require sealant to stop water leakage





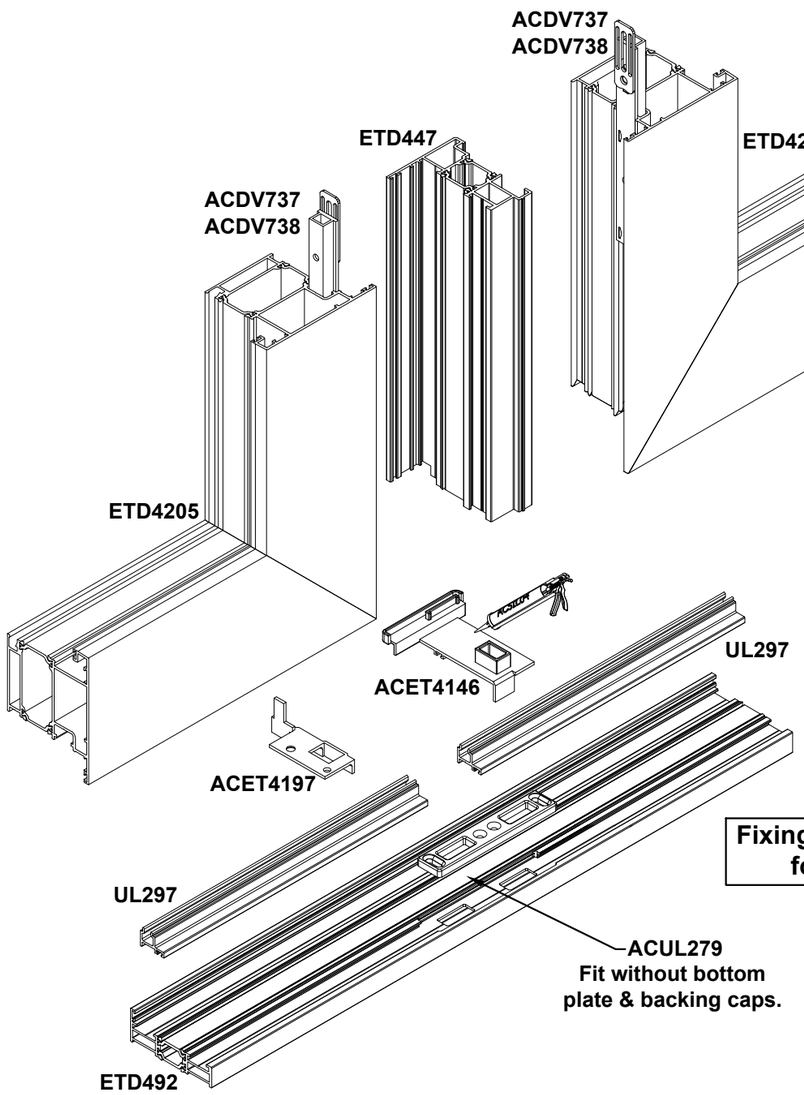


Double Door Lift Lever Lock Preparation for Low Rebate Threshold



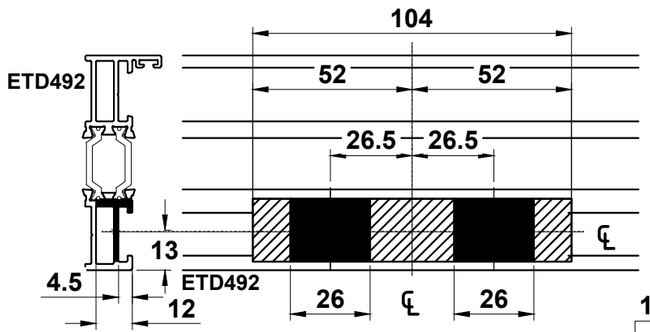
Do Not Scale From This Drawing

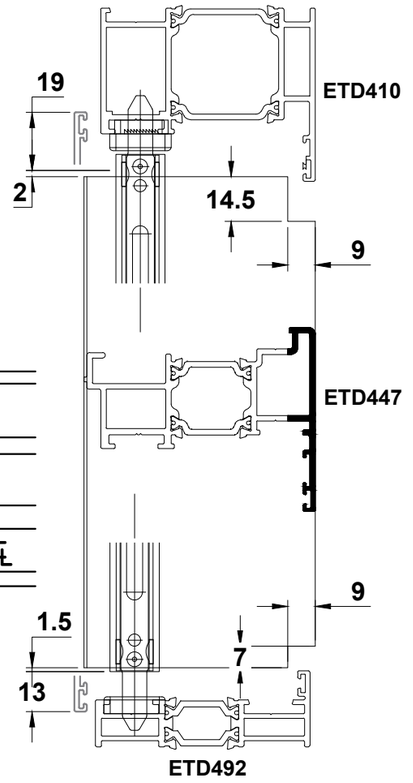
Double Door Lift Lever Meeting Stile Assembly for Low Rebate Threshold

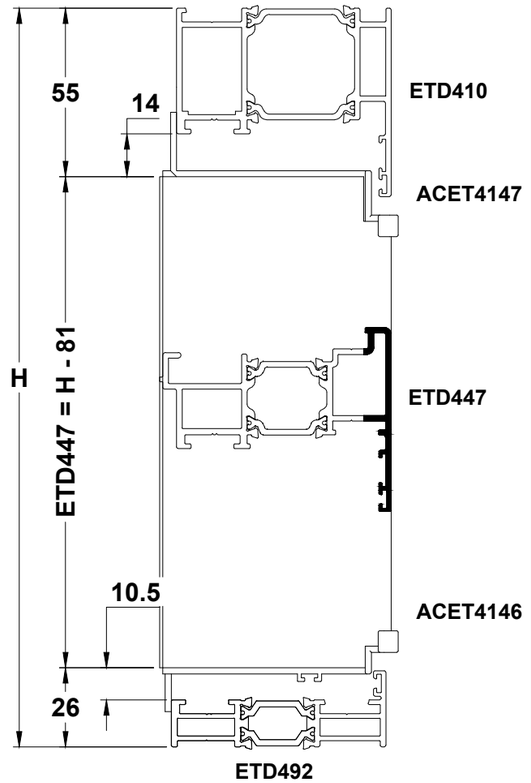


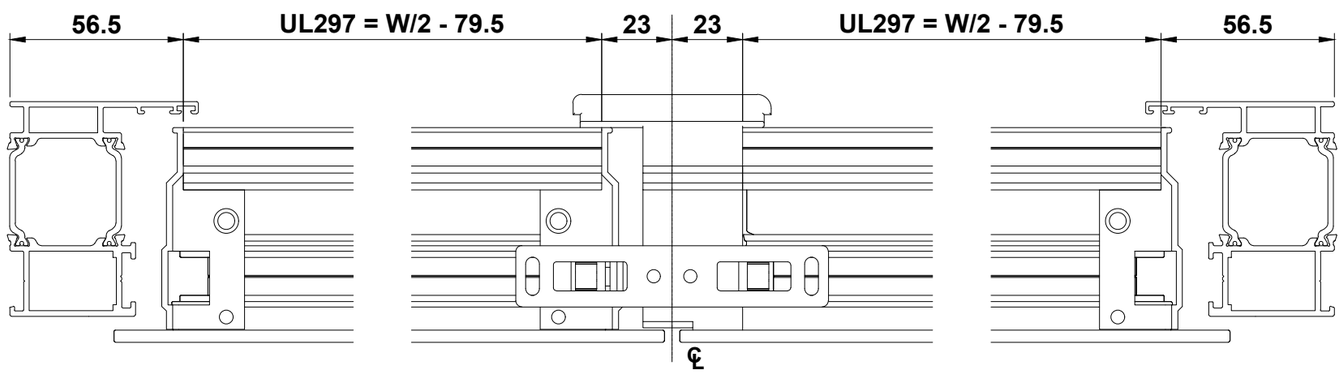
Note: All routing on outer frame require sealant to stop water leakage

Fixings not shown for clarity



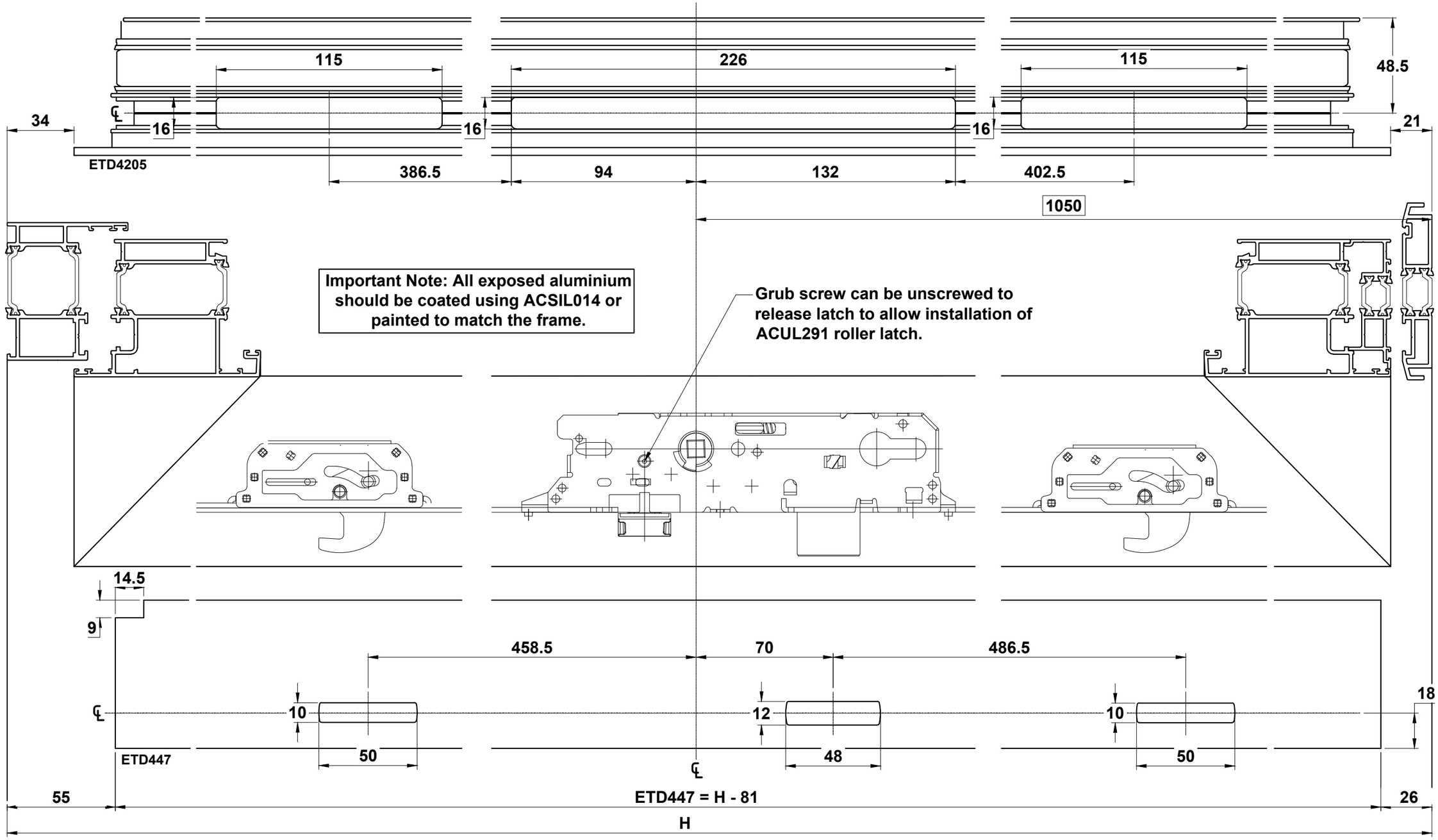




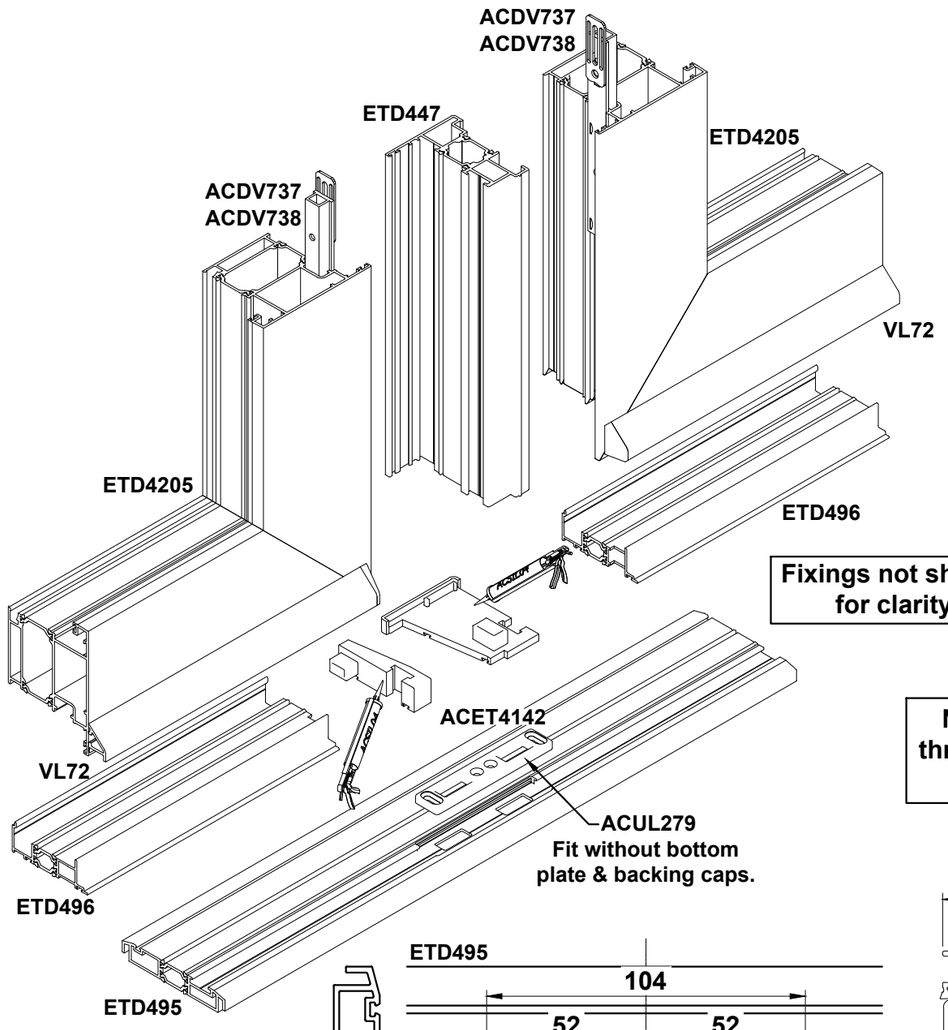


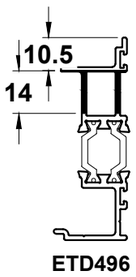
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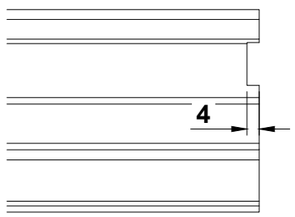
Double Door Lift Lever Lock Preparation for Low Ramp Threshold

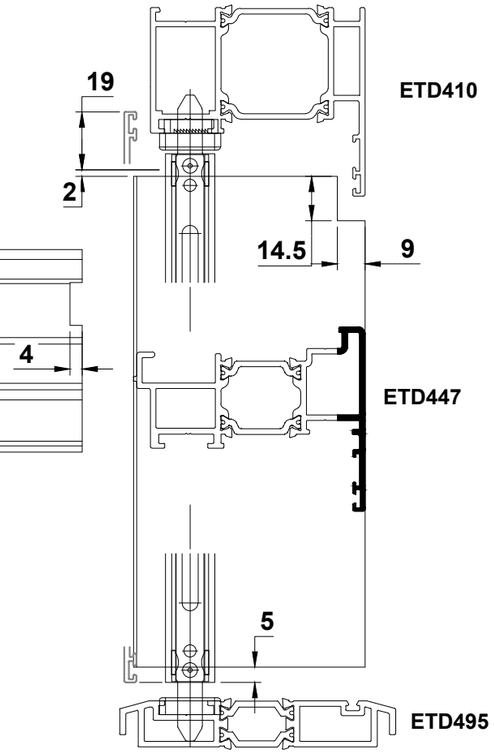


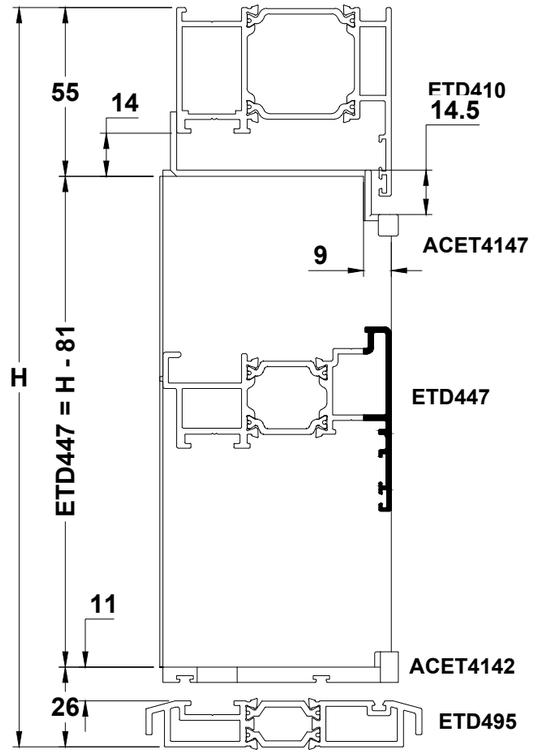
Double Door Lift Lever Meeting Stile Assembly for Low Ramp Threshold



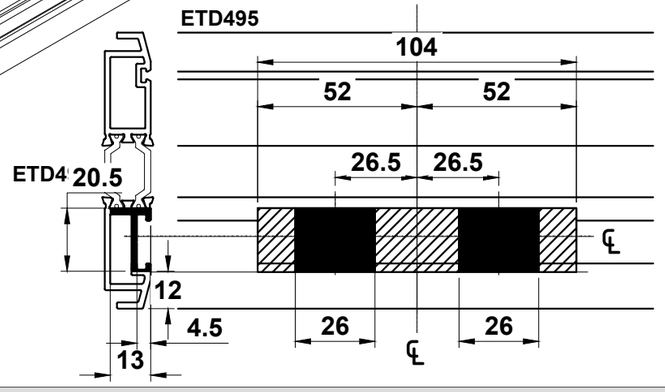


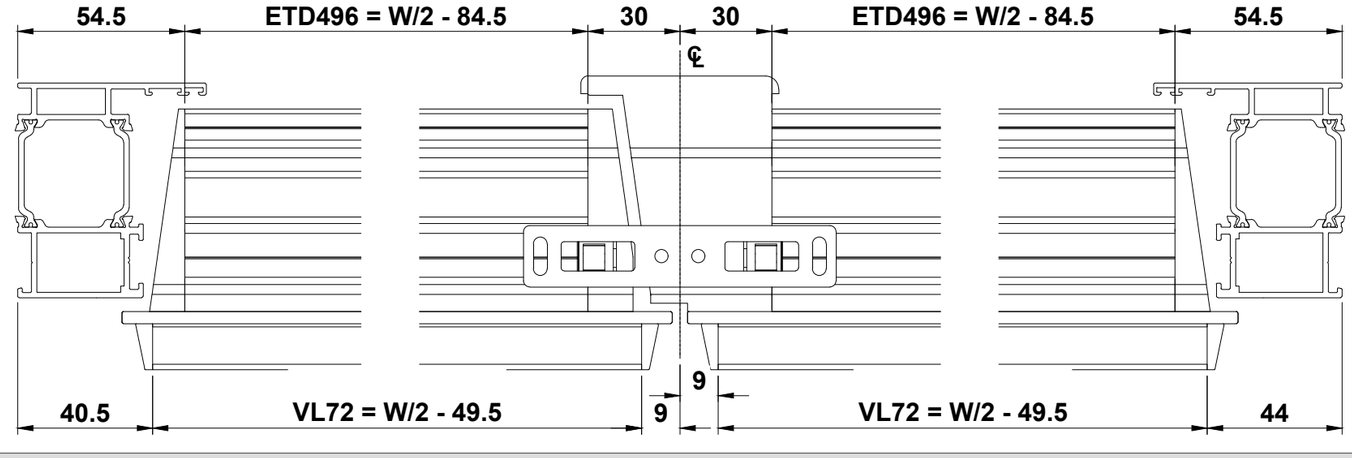




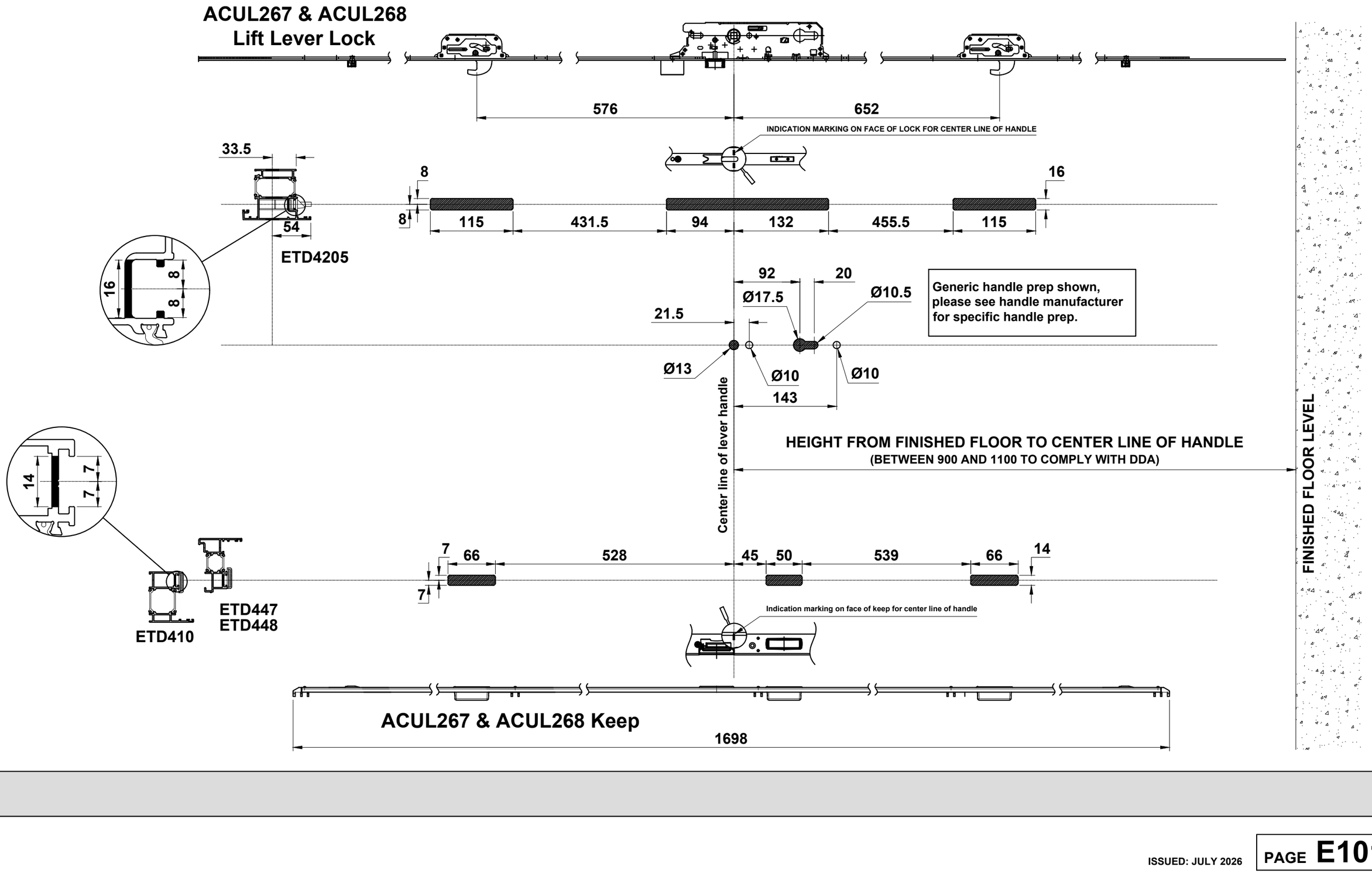


Note: All routing on low threshold require sealant to stop water leakage

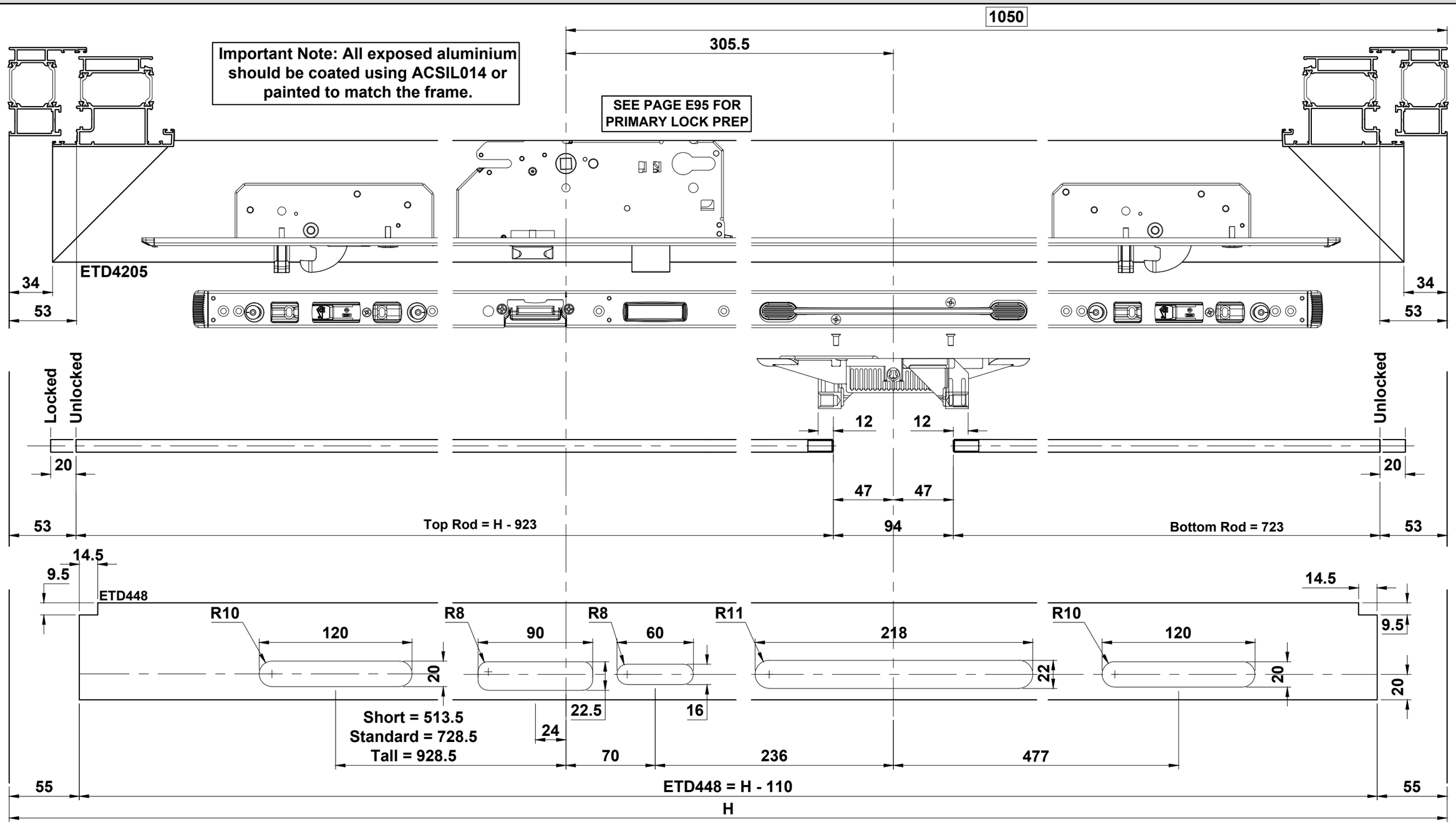




ACUL267 & ACUL268 Lift Lever Lock Preparation

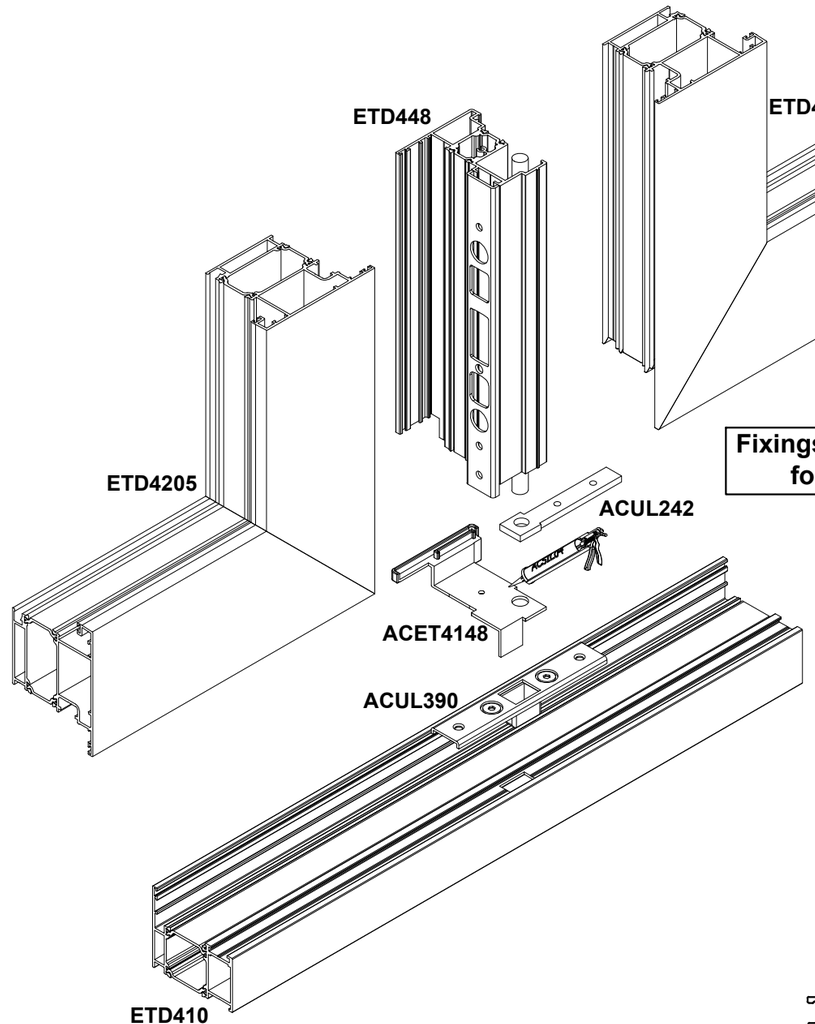


Double Door Finger Bolt Lock Preparation for Full Frame



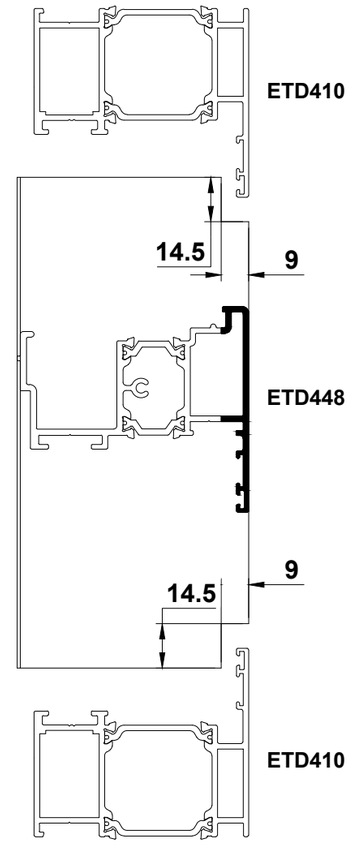
Do Not Scale From This Drawing

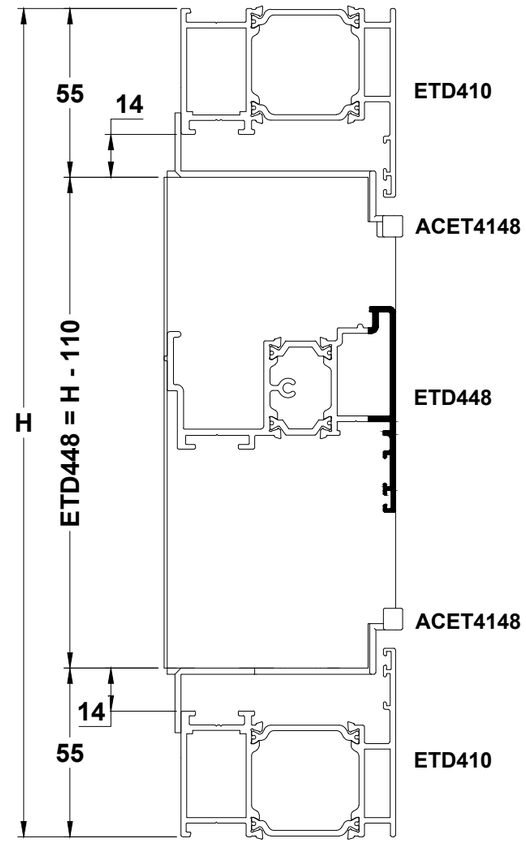
Double Door Finger Bolt Meeting Stile Assembly for Full Frame



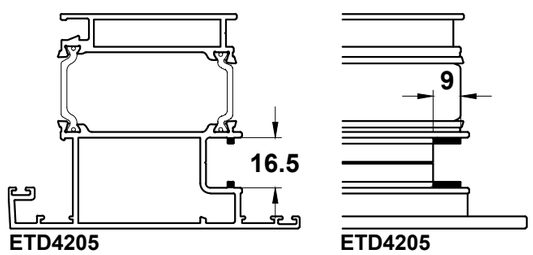
Fixings not shown for clarity

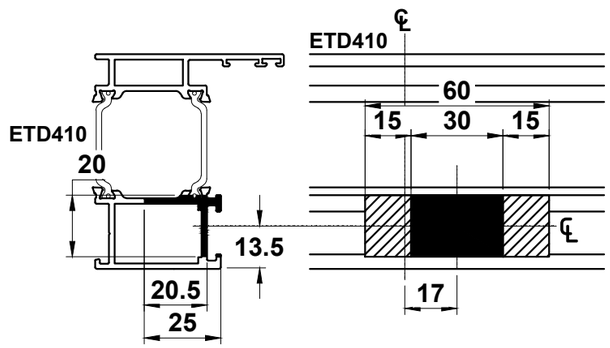
Note: All routing on outer frame require sealant to stop water leakage





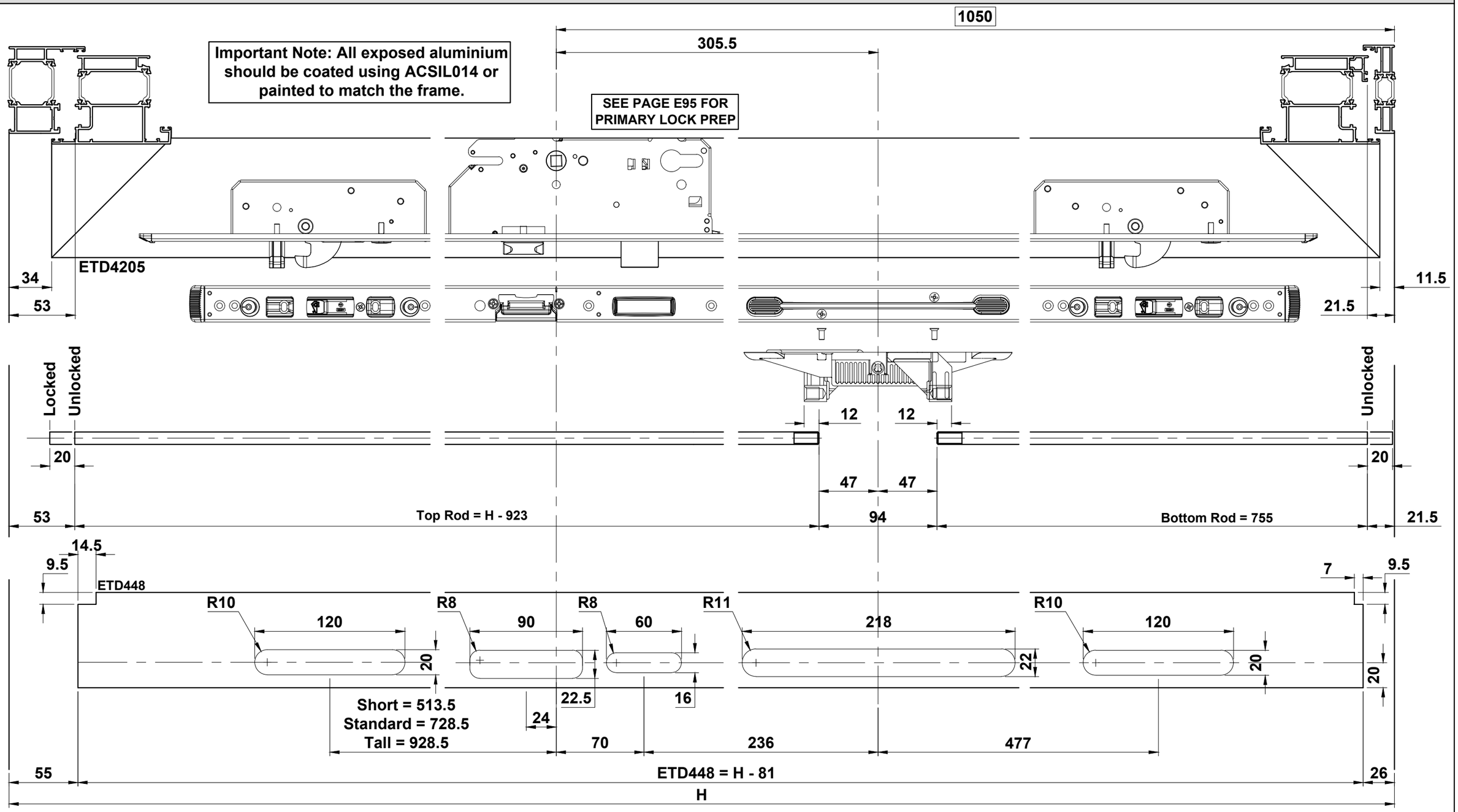
Sash to be notched to allow ACUL242 to fit into position





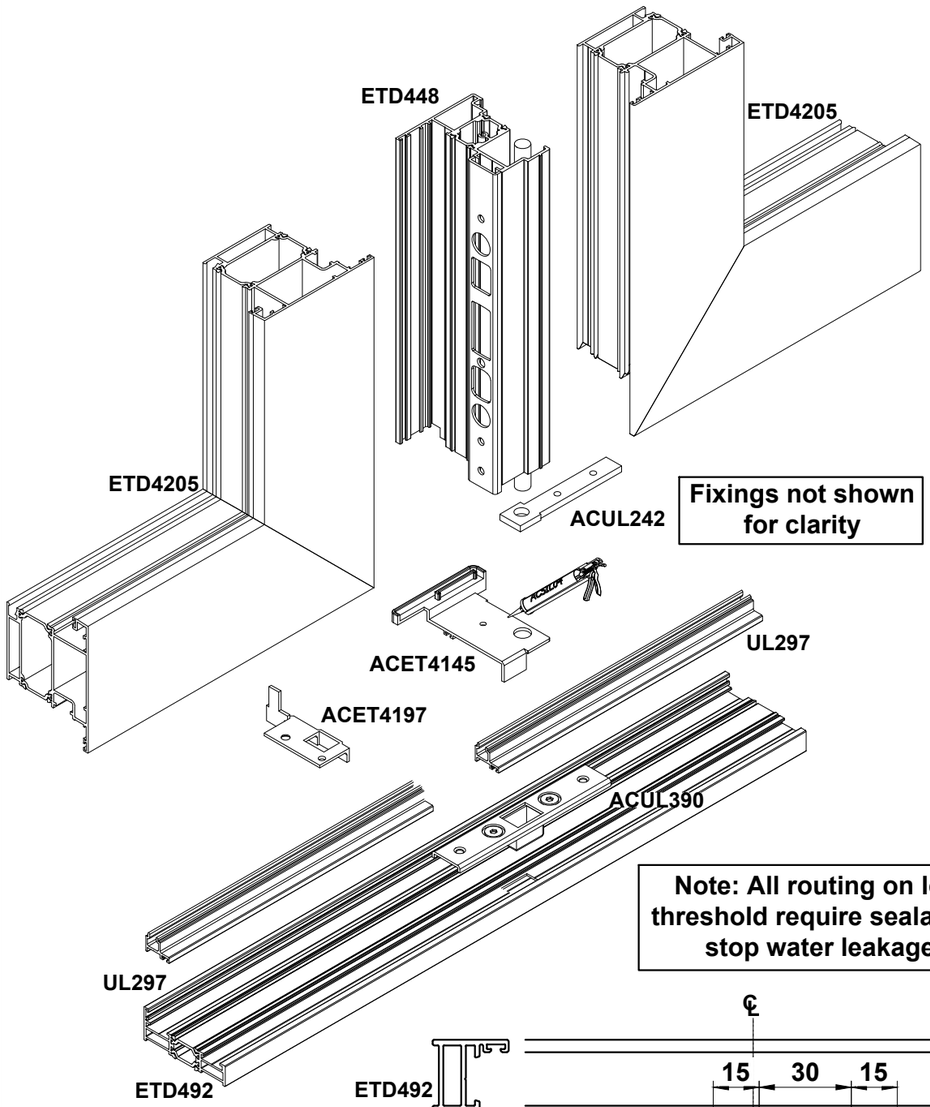
Do Not Scale From This Drawing

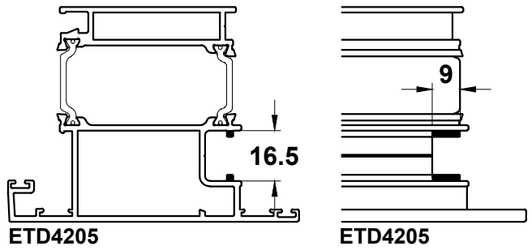
Double Door Finger Bolt Lock Preparation for Low Rebate Threshold

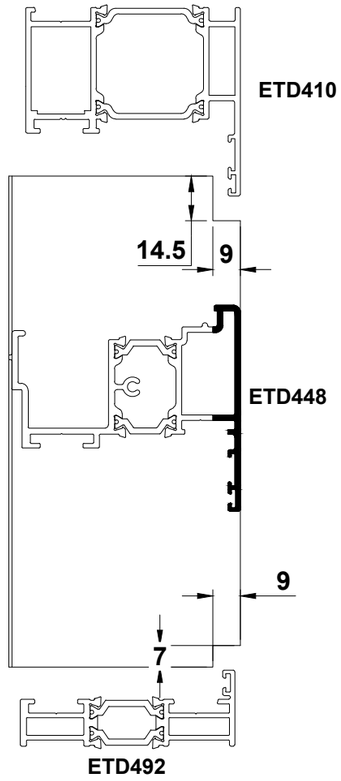


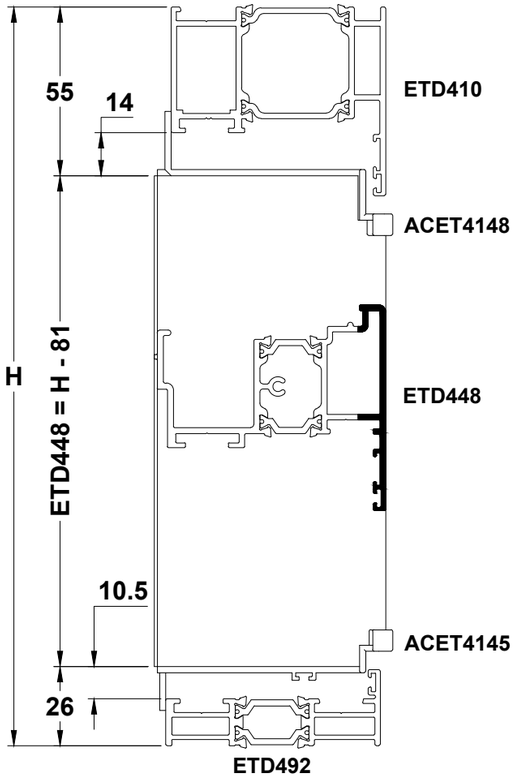
Do Not Scale From This Drawing

Double Door Finger Bolt Meeting Stile Assembly for Low Rebate Threshold

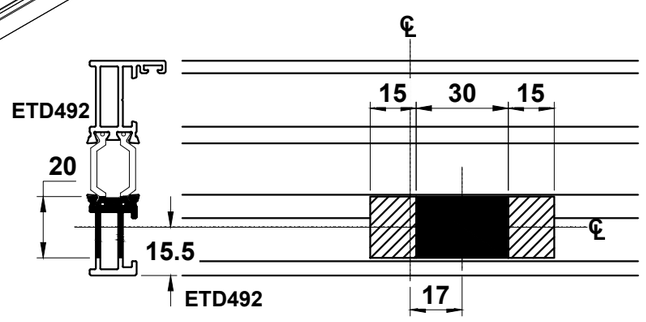


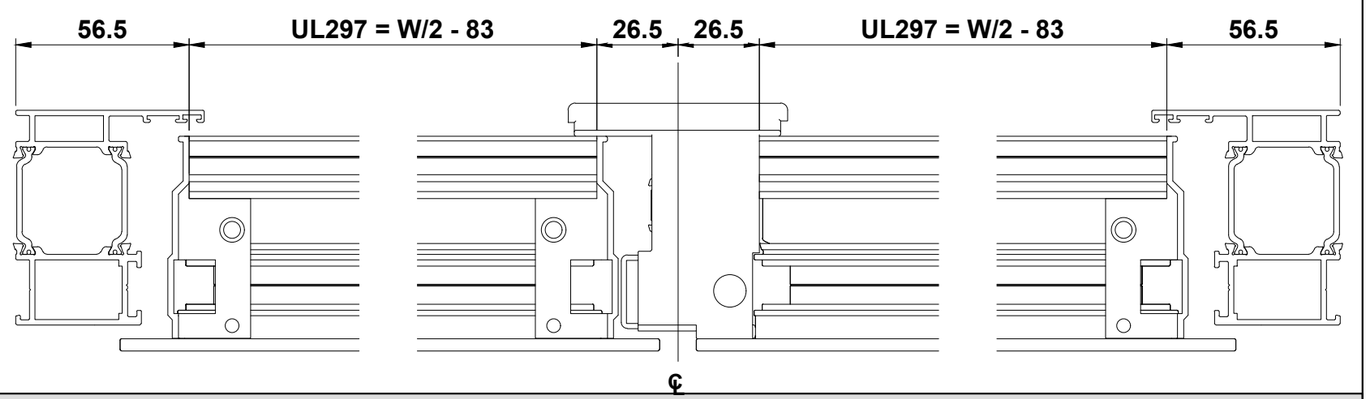




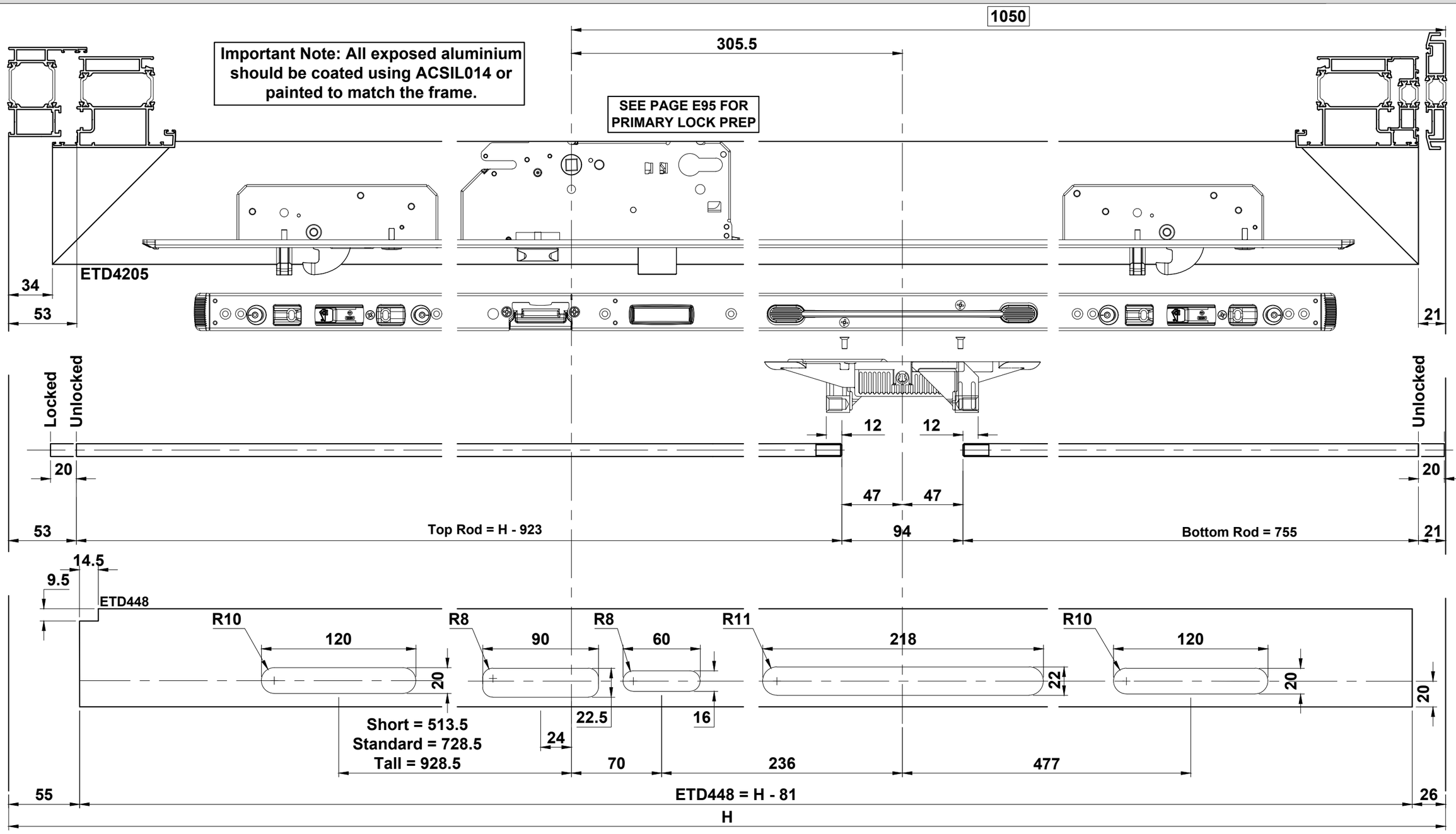


Note: All routing on low threshold require sealant to stop water leakage



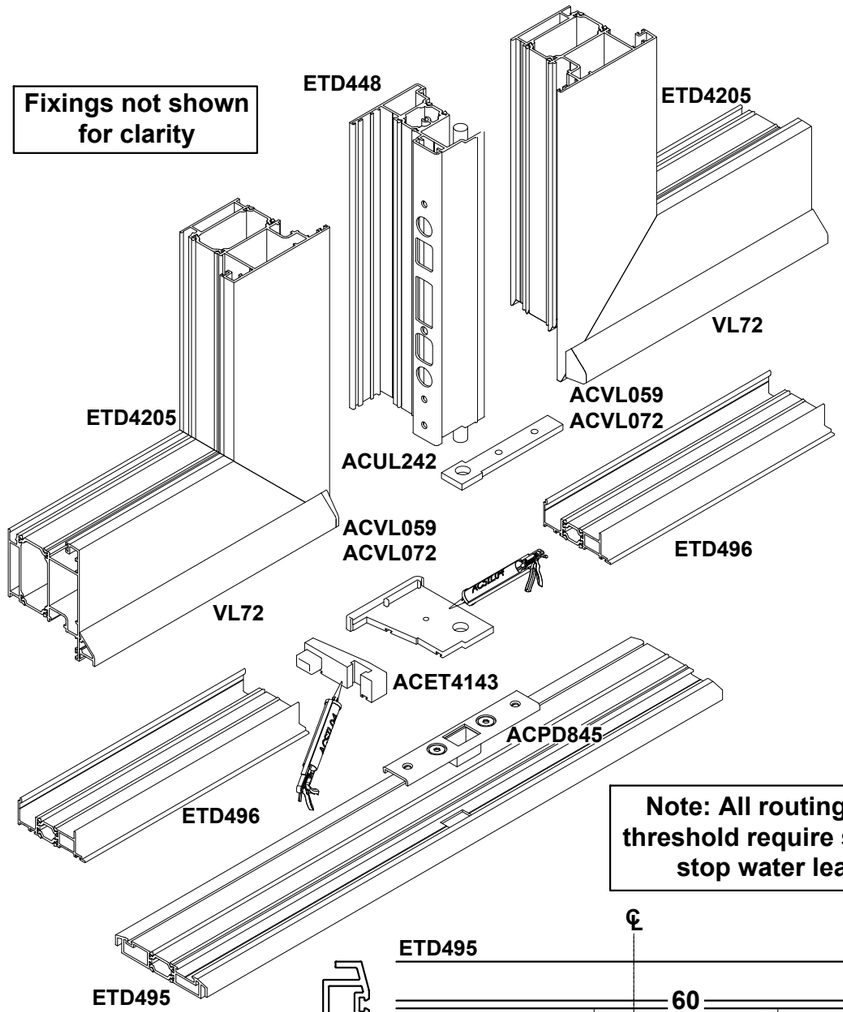


Double Door Finger Bolt Lock Preparation for Low Ramp Threshold

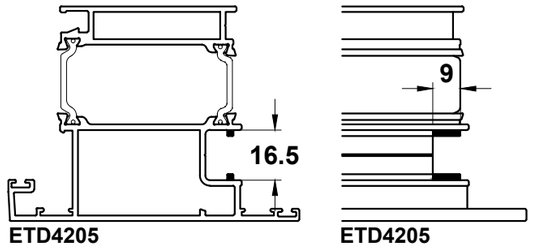


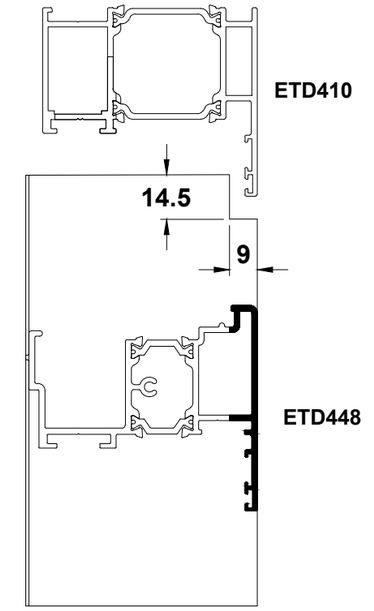
Do Not Scale From This Drawing

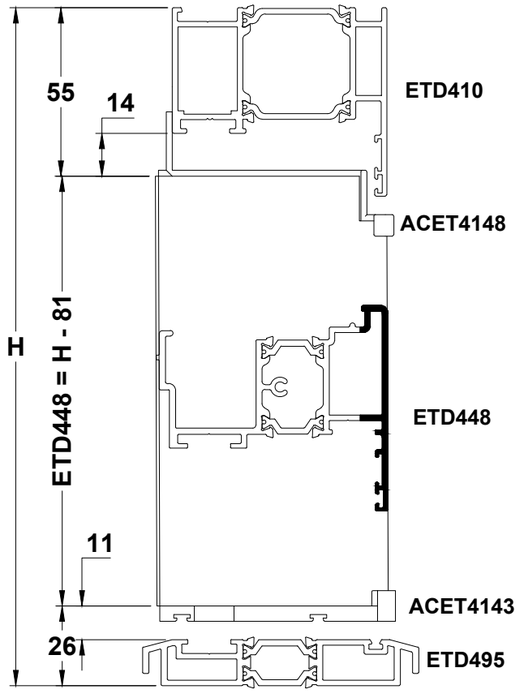
Double Door Finger Bolt Meeting Stile Assembly for Low Ramp Threshold



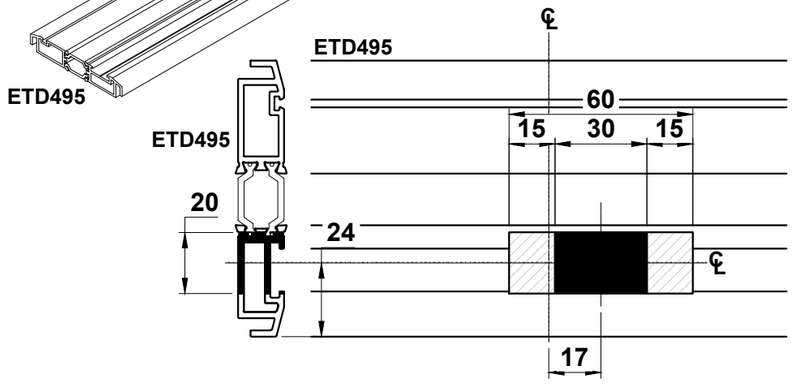
Sash to be notched to allow ACUL242 to fit into position

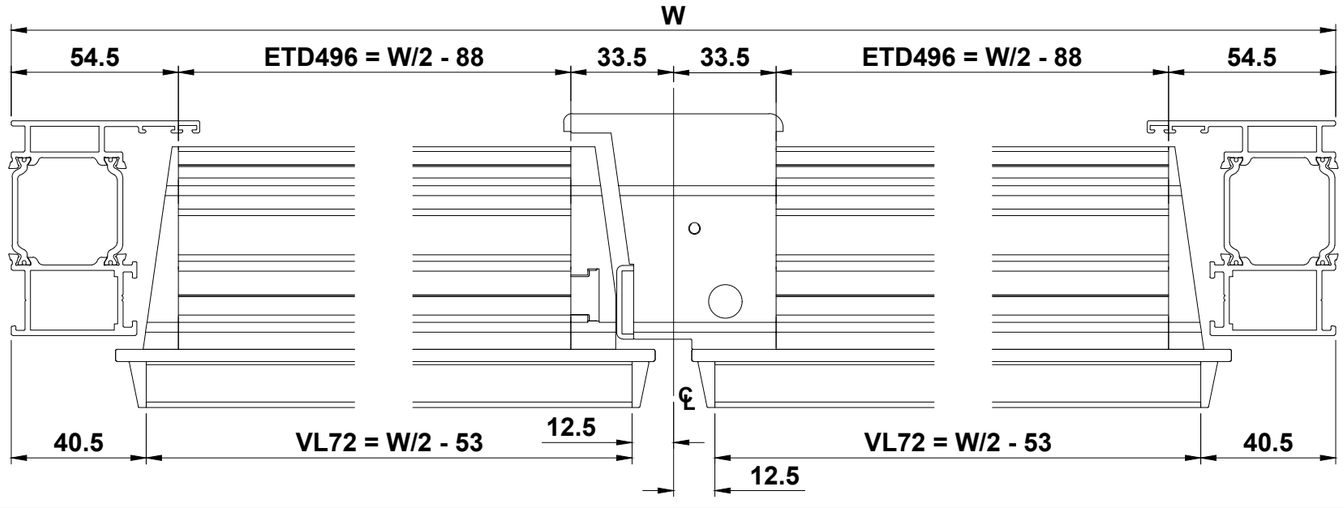




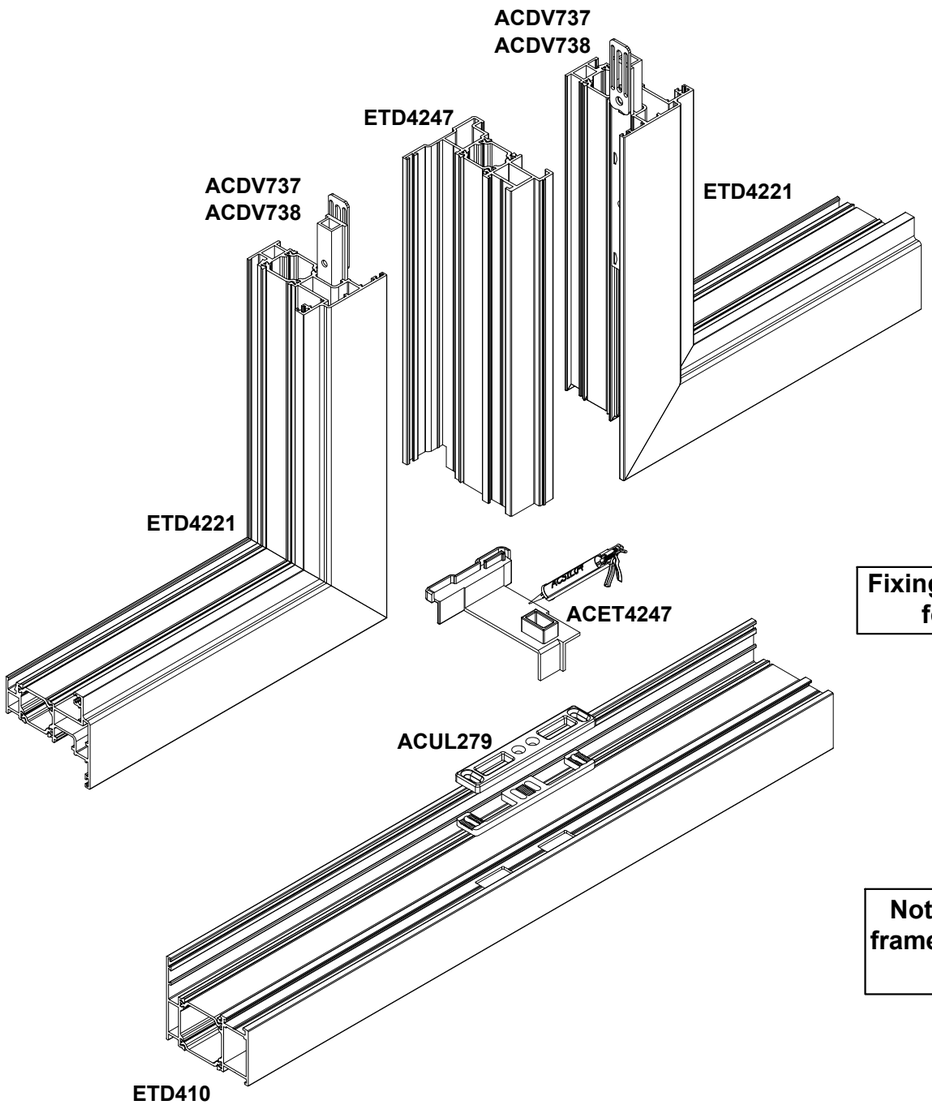


Note: All routing on low threshold require sealant to stop water leakage

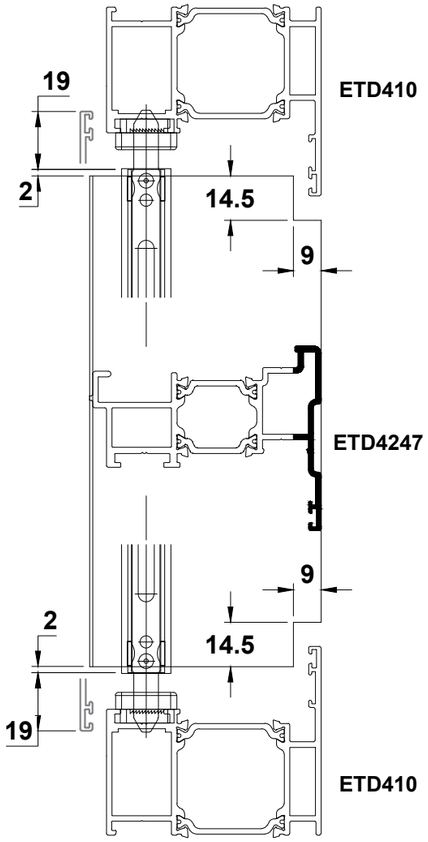


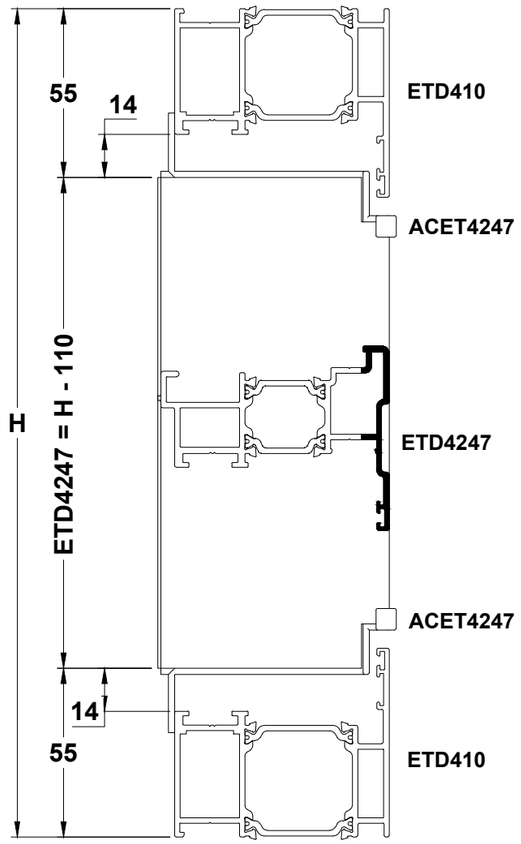


Heritage Double Door Lift Lever Meeting Stile Assembly for Full Frame

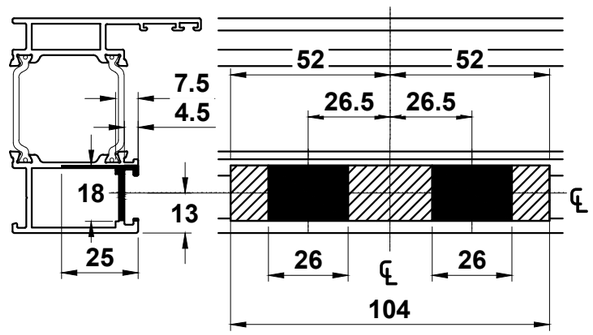


Fixings not shown for clarity



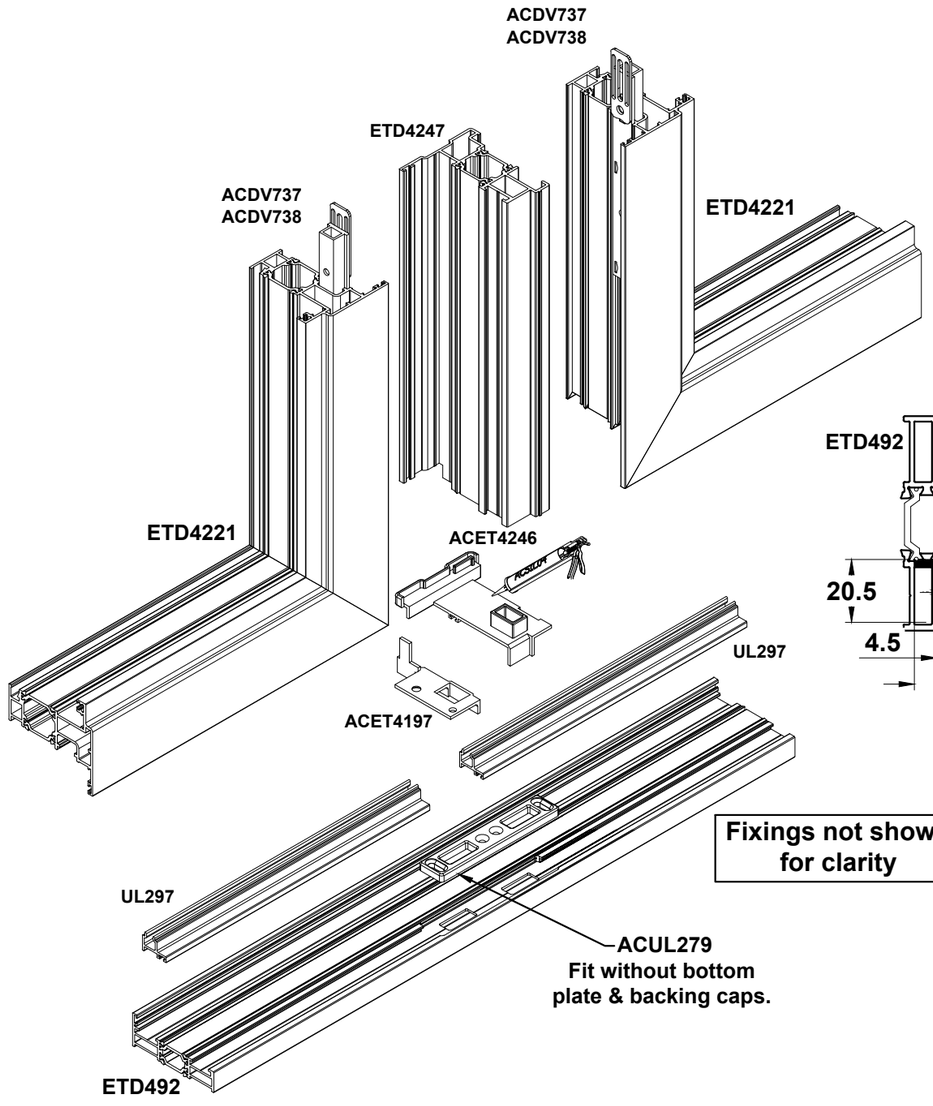


Note: All routing on outer frame require sealant to stop water leakage



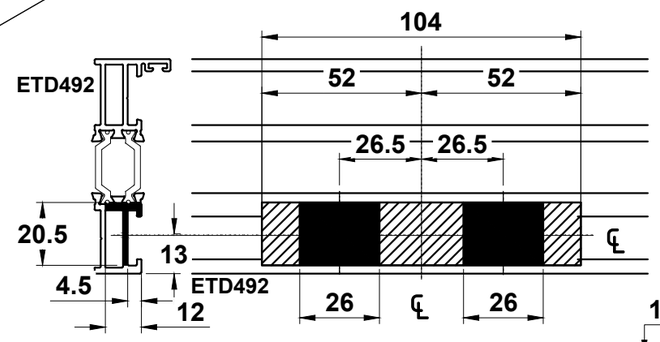
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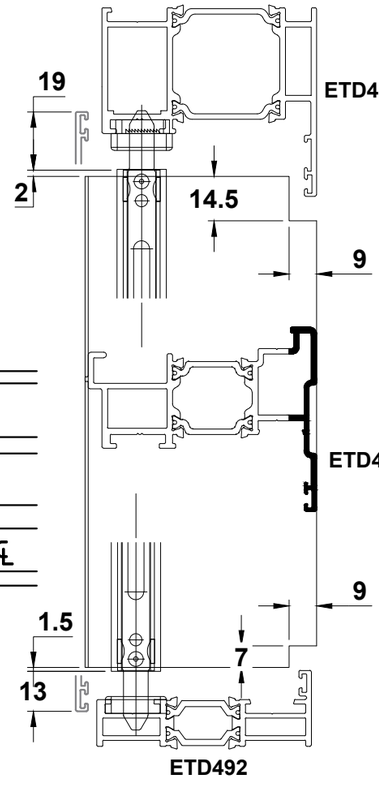
Heritage Double Door Lift Lever Meeting Stile Assembly for Low Rebate Threshold

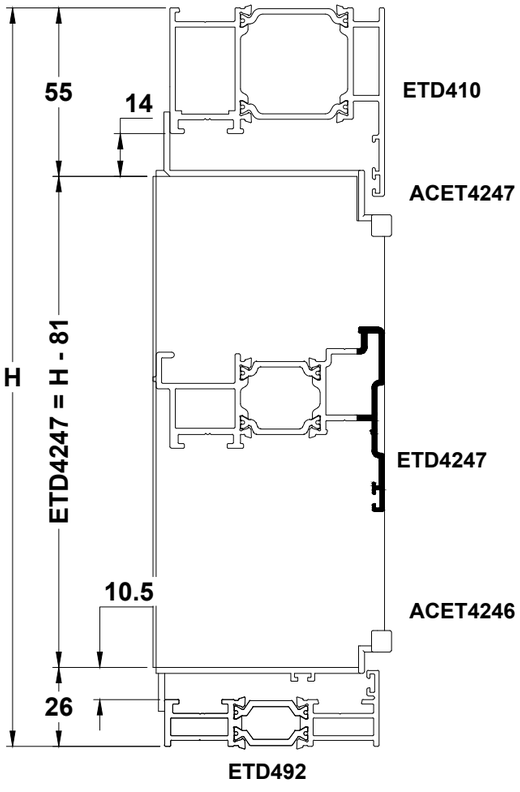


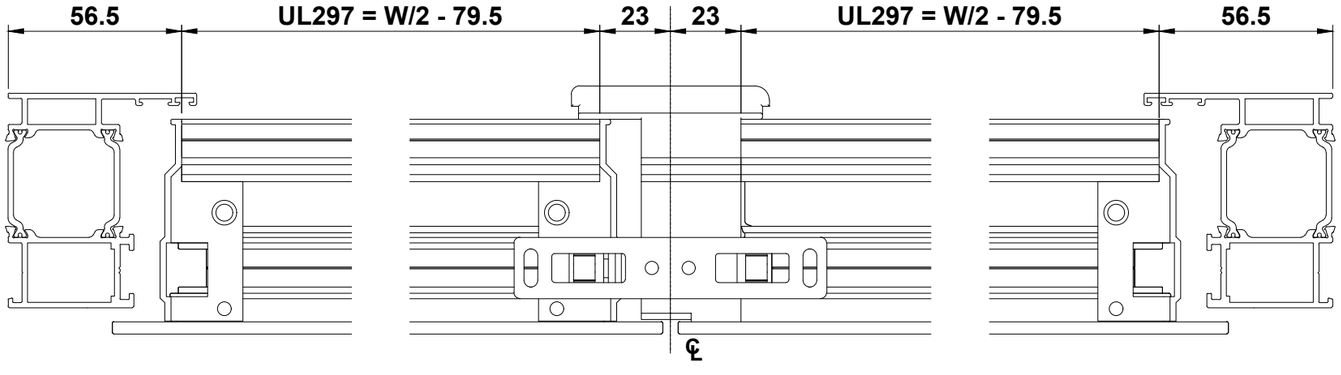
Note: All routing on outer frame require sealant to stop water leakage

Fixings not shown for clarity

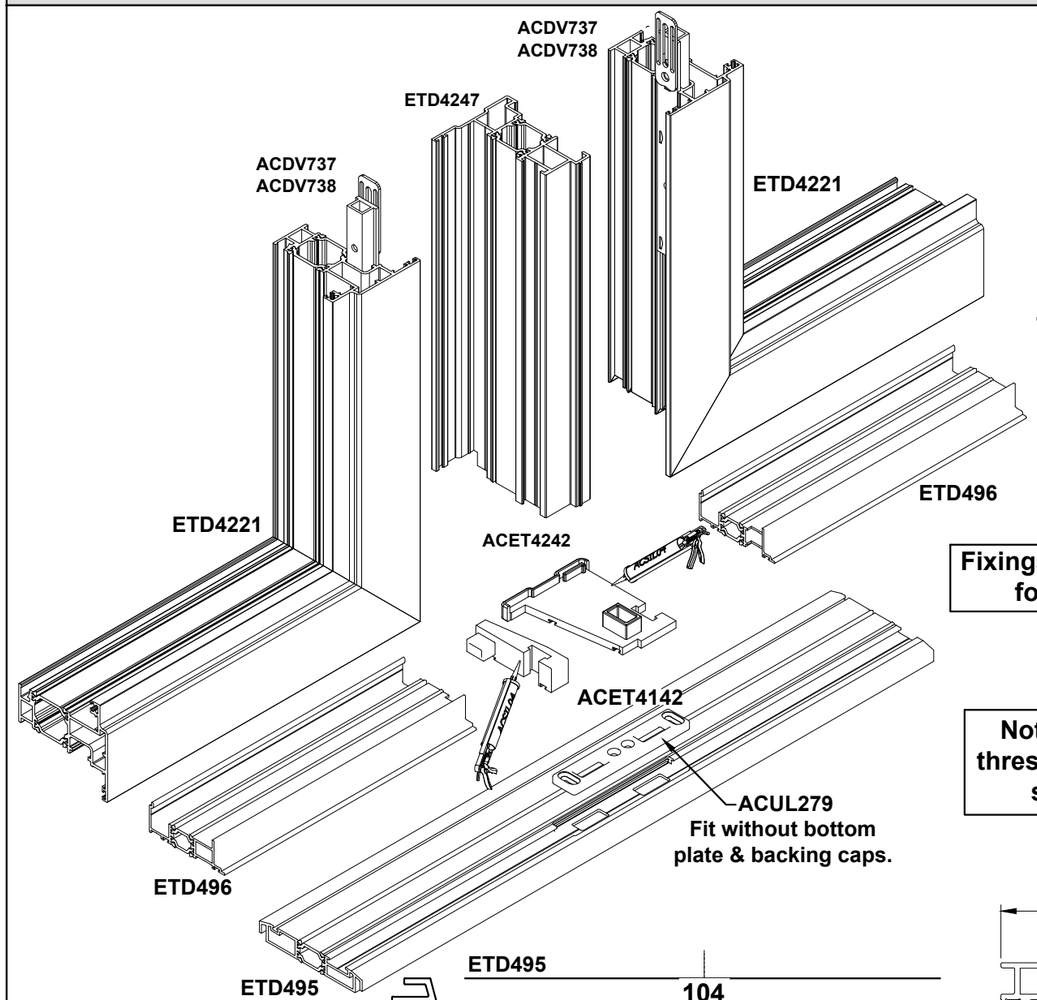


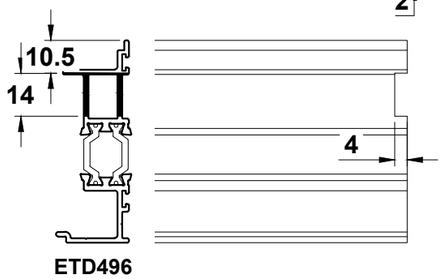






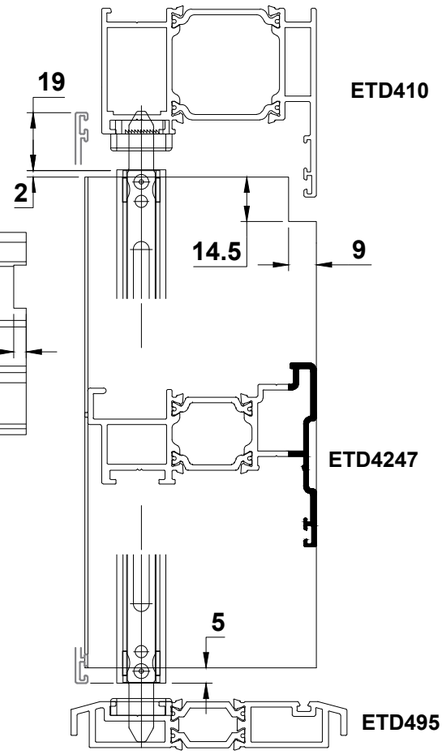
Heritage Double Door Lift Lever Meeting Stile Assembly for Low Ramp Threshold

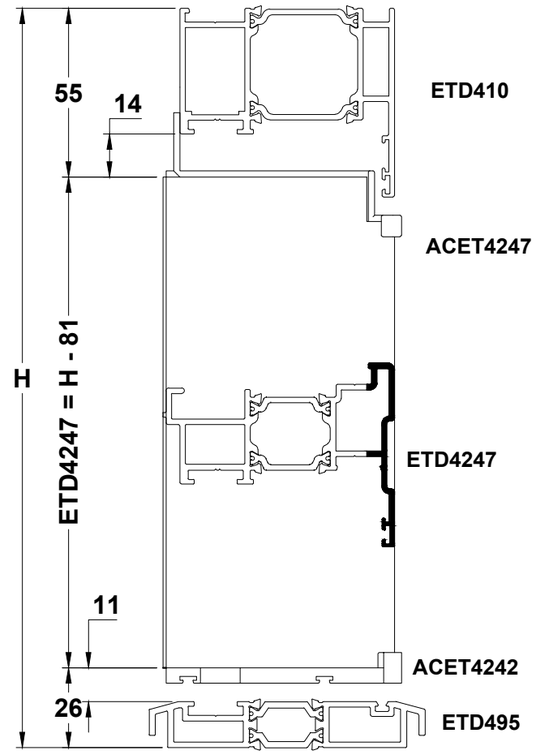


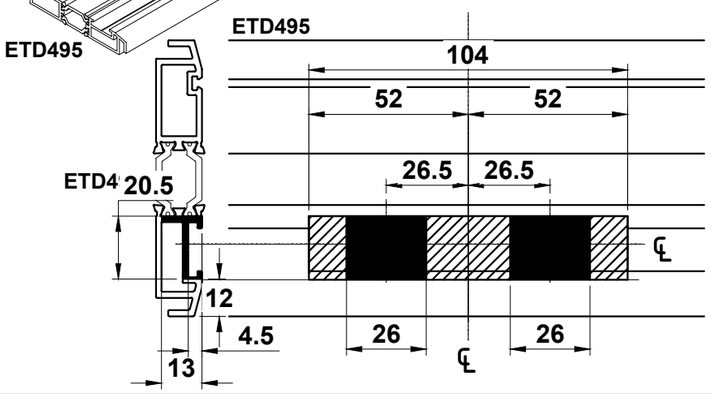


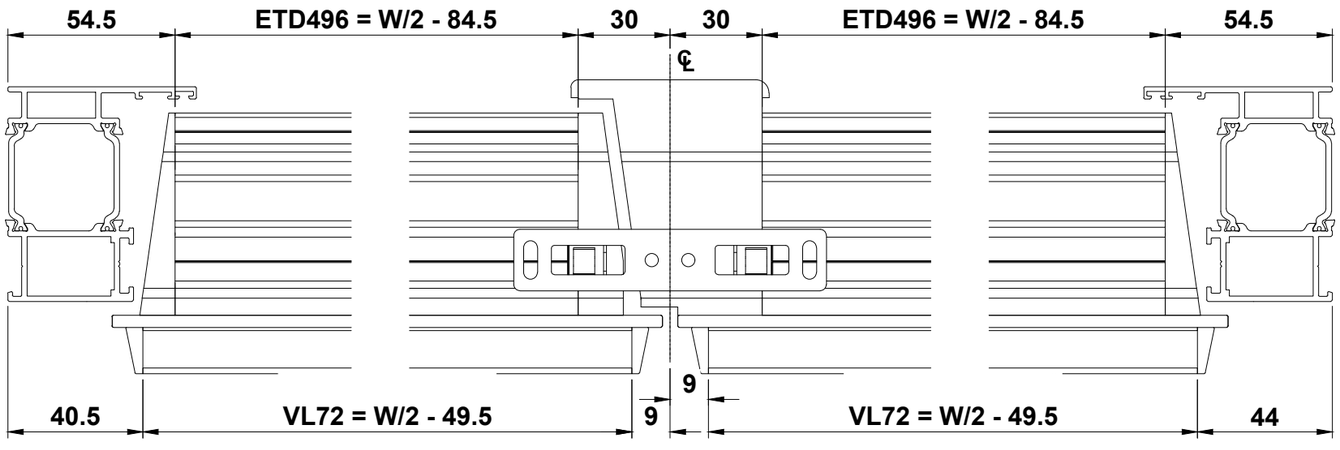
Fixings not shown for clarity

Note: All routing on low threshold require sealant to stop water leakage



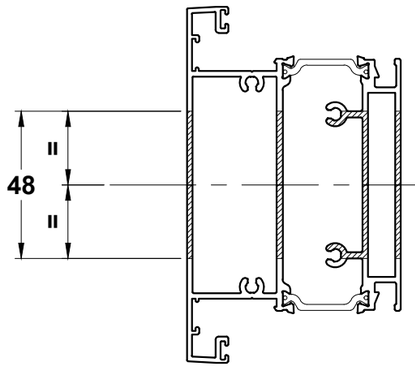


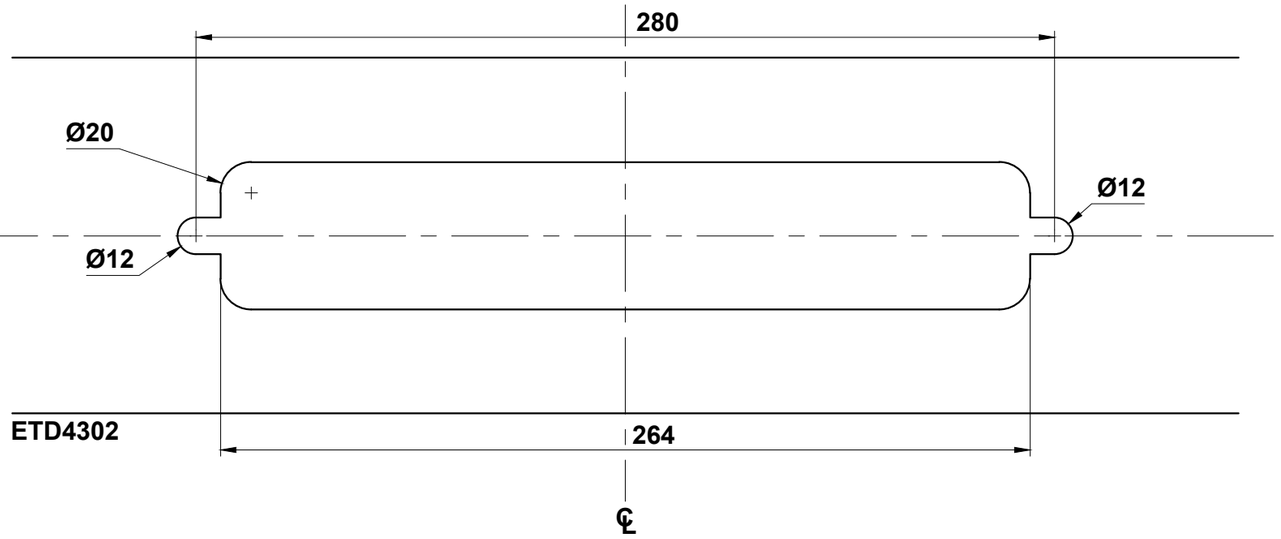


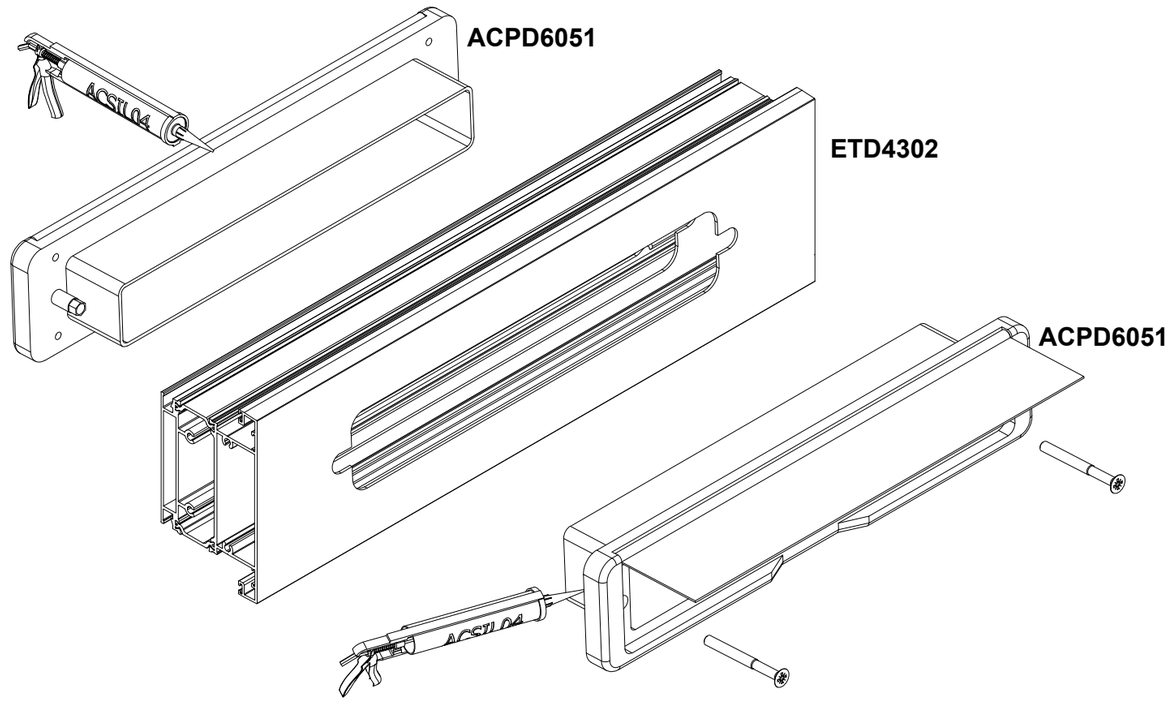


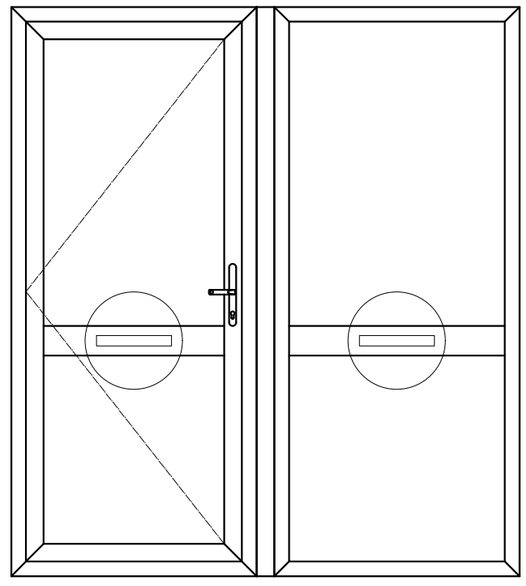
Do Not Scale From This Drawing

Letter Plate Fitting







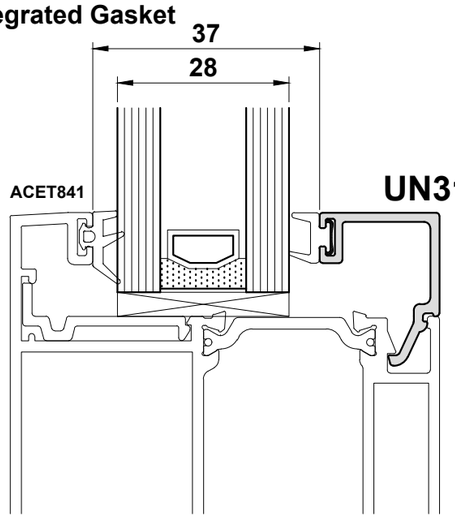


Alitherm 400 Stepped Door

Glazing Chart

28mm Glazing

Integrated Gasket

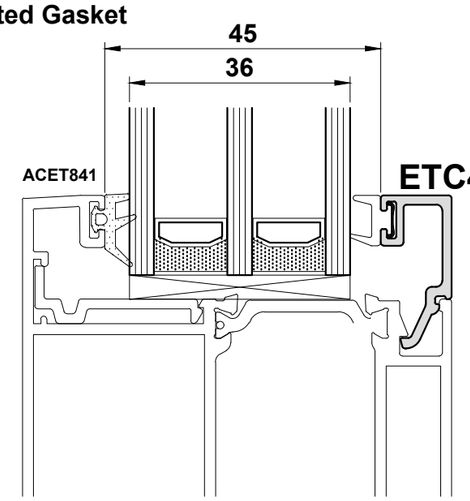


ETD4205 ETD4221

Low Profile Gaskets		
Glazing Thickness	External Gasket	Internal Gasket
28	ACET841	-
29 (28.8)	ACET842	-

36mm Glazing

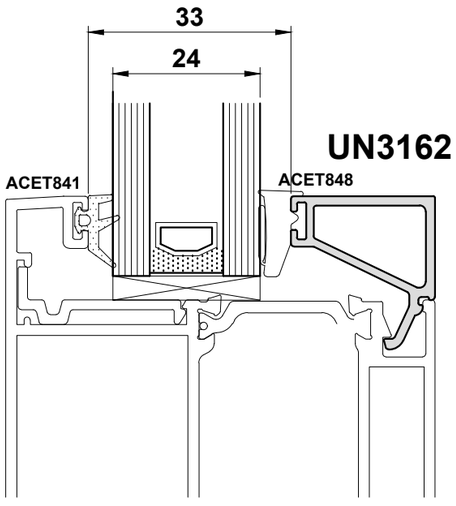
Integrated Gasket



ETD4205 ETD4221

Low Profile Gaskets		
Glazing Thickness	External Gasket	Internal Gasket
36	ACET841	-
37	ACET842	-

24-26mm Glazing

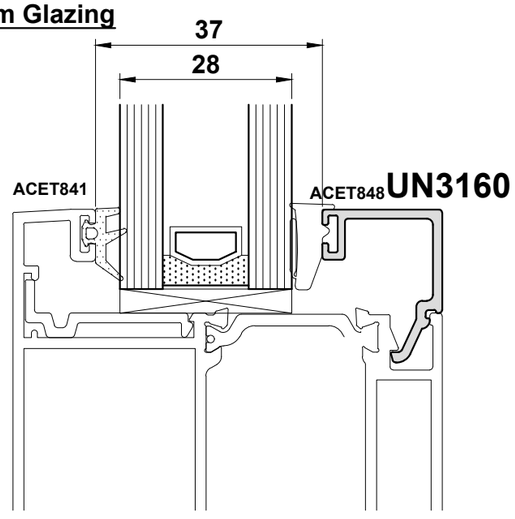


ETD4205 ETD4221

Low Profile Gaskets		
Glazing Thickness	External Gasket	Internal Gasket
24	ACET841	ACET848
25	ACET842	ACET848
26	ACET843	ACET848

Standard Gaskets		
Glazing Thickness	External Gasket	Internal Gasket
24	ACVG31	ACUN036
25	ACVG231	ACUN036
26	ACVG231	ACUN036

28-30mm Glazing



ETD4205 ETD4221

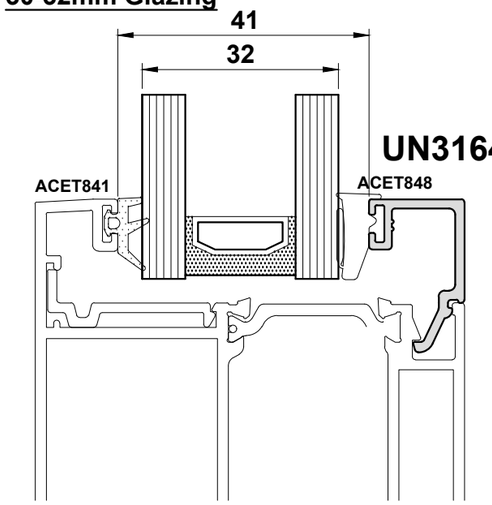
Low Profile Gaskets		
Glazing Thickness	External Gasket	Internal Gasket
28	ACET841	ACET848
29 (28.8)	ACET842	ACET848
30	ACET843	ACET848

Standard Gaskets		
Glazing Thickness	External Gasket	Internal Gasket
28	ACVG31	ACUN036
29 (28.8)	ACVG231	ACUN036
30	ACVG231	ACUN036

Do Not Scale From This Drawing

Glazing Chart

30-32mm Glazing



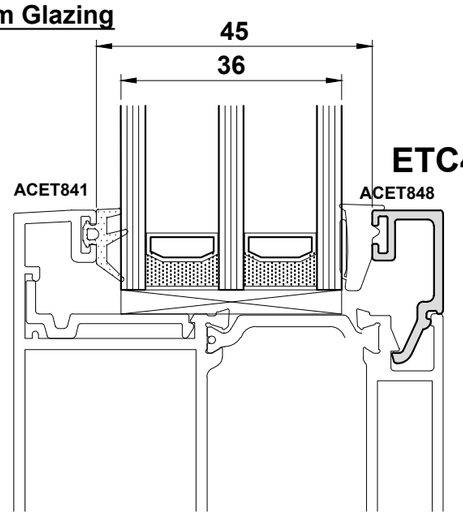
UN3164

ETD4205 ETD4221

Low Profile Gaskets		
Glazing Thickness	External Gasket	Internal Gasket
30	ACET841	ACET848
31	ACET842	ACET848
32	ACET843	ACET848

Standard Gaskets		
Glazing Thickness	External Gasket	Internal Gasket
30	ACVG31	ACUN036
31	ACVG231	ACUN036
32	ACVG231	ACUN036

36mm Glazing



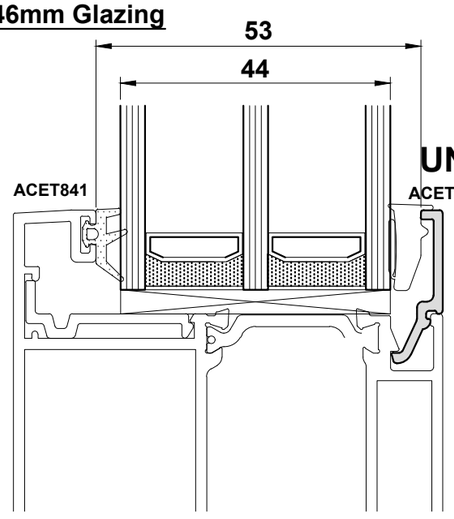
ETC4179

ETD4205 ETD4221

Low Profile Gaskets		
Glazing Thickness	External Gasket	Internal Gasket
36	ACET841	ACET848
37	ACET842	ACET848
38	ACET843	ACET848

Standard Gaskets		
Glazing Thickness	External Gasket	Internal Gasket
36	ACVG31	ACUN036
37	ACVG231	ACUN036
38	ACVG231	ACUN036

44-46mm Glazing



UN3168

ETD4205 ETD4221

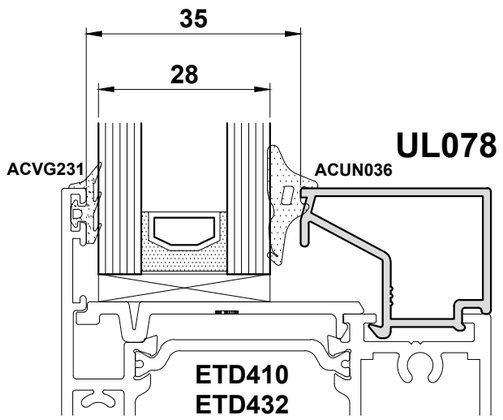
Low Profile Gaskets		
Glazing Thickness	External Gasket	Internal Gasket
44	ACET841	ACET848
45	ACET842	ACET848
46	ACET843	ACET848

Standard Gaskets		
Glazing Thickness	External Gasket	Internal Gasket
44	ACVG31	ACUN036
45	ACVG231	ACUN036
46	ACVG231	ACUN036

Do Not Scale From This Drawing

Glazing Chart

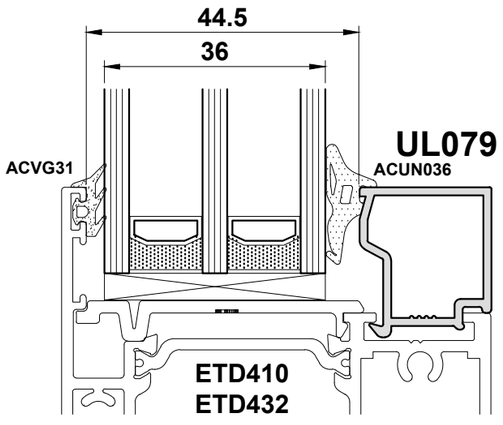
27-29mm Glazing



Low Profile Gaskets		
Glazing Thickness	External Gasket	Internal Gasket
27	ACET842	ACET848
28	ACET843	ACET848
29 (28.8)	ACET843	ACW20038

Standard Gaskets		
Glazing Thickness	External Gasket	Internal Gasket
27	ACVG231	ACUN036
28	ACVG231	ACUN036
29 (28.8)	ACVG231	ACUN033

36-38mm Glazing

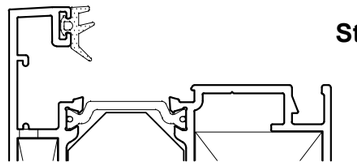


Low Profile Gaskets		
Glazing Thickness	External Gasket	Internal Gasket
36	ACET841	ACET848
37	ACET842	ACET848
38	ACET843	ACET848

Standard Gaskets		
Glazing Thickness	External Gasket	Internal Gasket
36	ACVG31	ACUN036
37	ACVG231	ACUN036
38	ACVG231	ACUN036

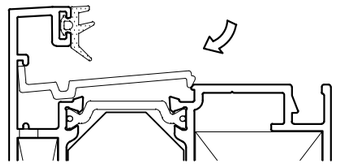
Do Not Scale From This Drawing

Glazing Details



Step One. Install Captive Gasket

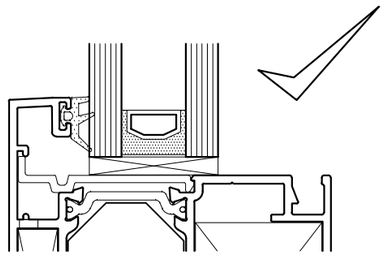
- Follow Gasket Configuration from pages E112 - E114



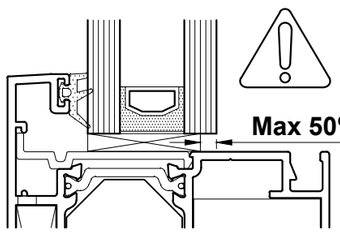
Step Two. Install Bridge Packer

- Follow Packer Placement diagrams

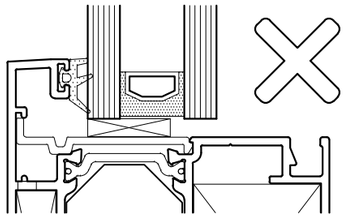
Step Three. Install Support Packer



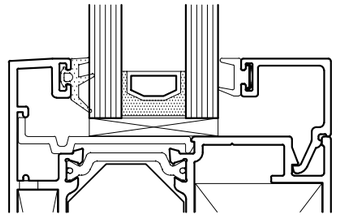
Ensure the packer supports both panes of glass



Minimium Packer Support Coverage 50%

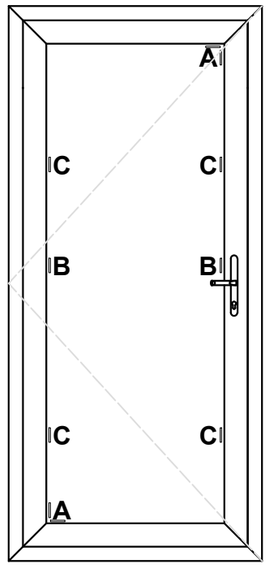


Incorrect Support



Step Four. Install Glazing Beads

- Guidlines on Page E116



Door Packer Placement

Standard

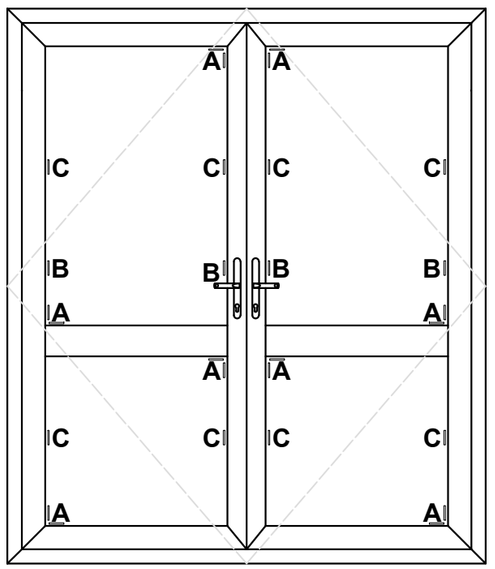
A Toe & Heel Packing Points

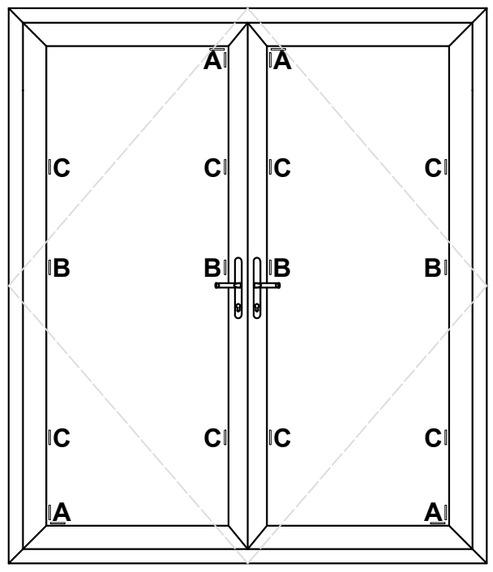
PAS24

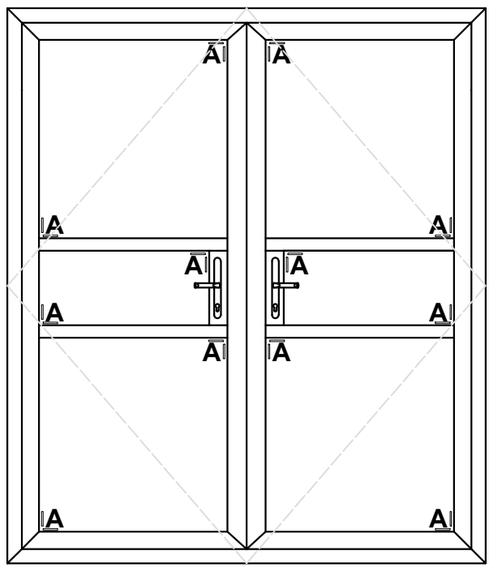
B Latch Packing Points

C Locking Packing Points

Note:- When packing around the locking/latch points. Pack adjescent on the hinge side.





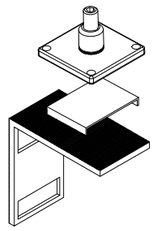


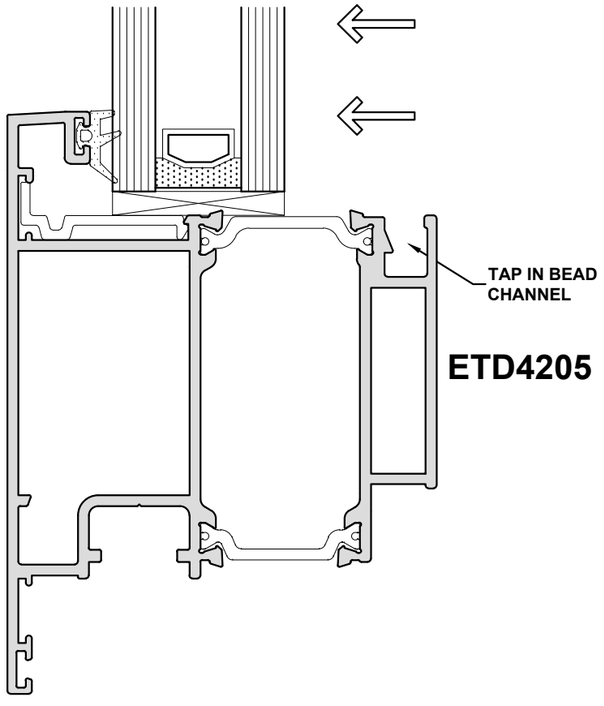
Quick-Glaze Bead Installation

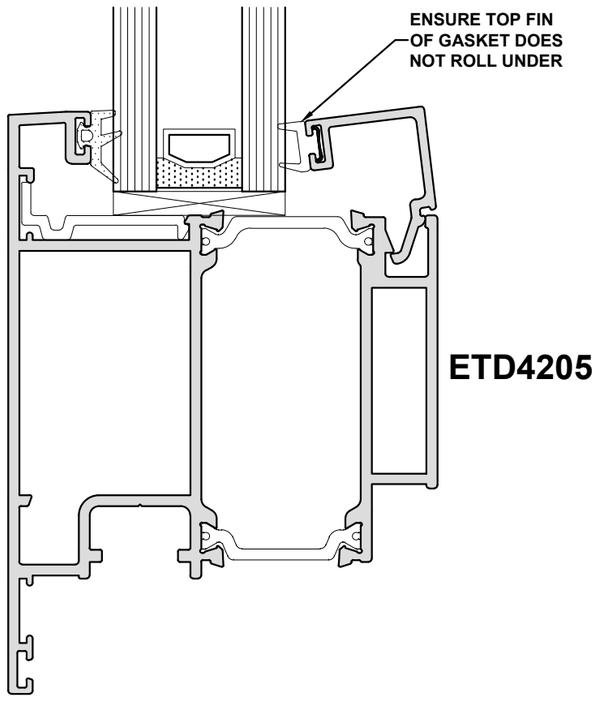
QUICK-GLAZE BEAD INSTALLATION

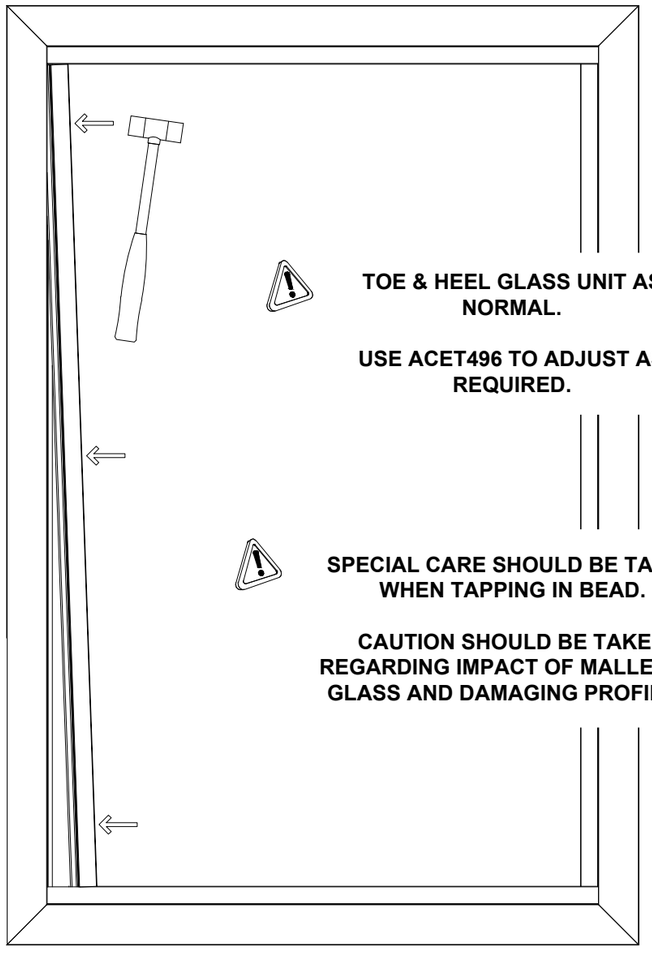
1. INSTALL GLASS UNIT, ENSURING IT HAS BEEN PUSHED FORWARD TO ENGAGE COMPRESSION OF E GASKET.
2. BEGINNING WITH HORIZONTAL BEADS, LOCATE BEAD IN CLIP CHANNEL OF SASH AS SHOWN. INTEGRATED GASKET MAY REST AGAINST GLASS UNIT.
3. APPLY FIRM PRESSURE TO THE BEAD TO HOLD IN POSITION. THIS MAY CAUSE THE BEAD 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 ACET496 GLASS ADJUSTERS WHEN USING QUICK-GLAZE BEADS. THIS WILL REMOVE THE NEED TO REMOVE BEADS IN ORDER TO ADJUST GLASS POSITION.









Do Not Scale From This Drawing

Quick-Glaze Bead Removal

KEEP INTEGRATED GASKET

QUICK-GLAZE BEAD REMOVAL

1. STARTING ON VERTICAL BEADS, APPLY PRESSURE TO BEAD IN DIRECTION SHOWN IN ORDER TO CREATE SMALL GAP BETWEEN SASH AND BEAD.
2. GENTLY INSERT DE-GLAZING TOOL TAKING PARTICULAR CARE AS NOT TO DAMAGE PAINT FINISH.
3. SLOWLY PRISE THE BEAD UP AND AWAY FROM THE SASH.
4. THE BEAD SHOULD NOW BE EASILY REMOVABLE FROM QUICK-GLAZE BEAD CHANNEL IN SASH

BEAD AND INTEGRATED GASKET CAN BE REUSED.

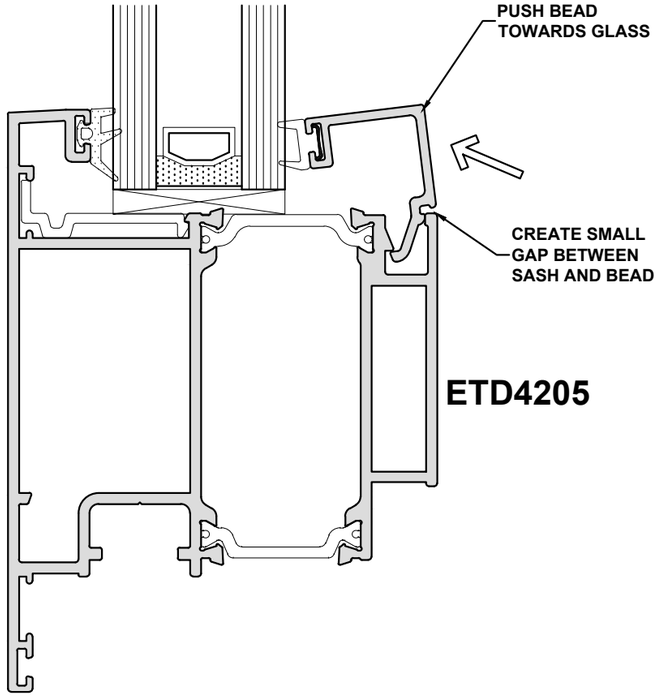
OR

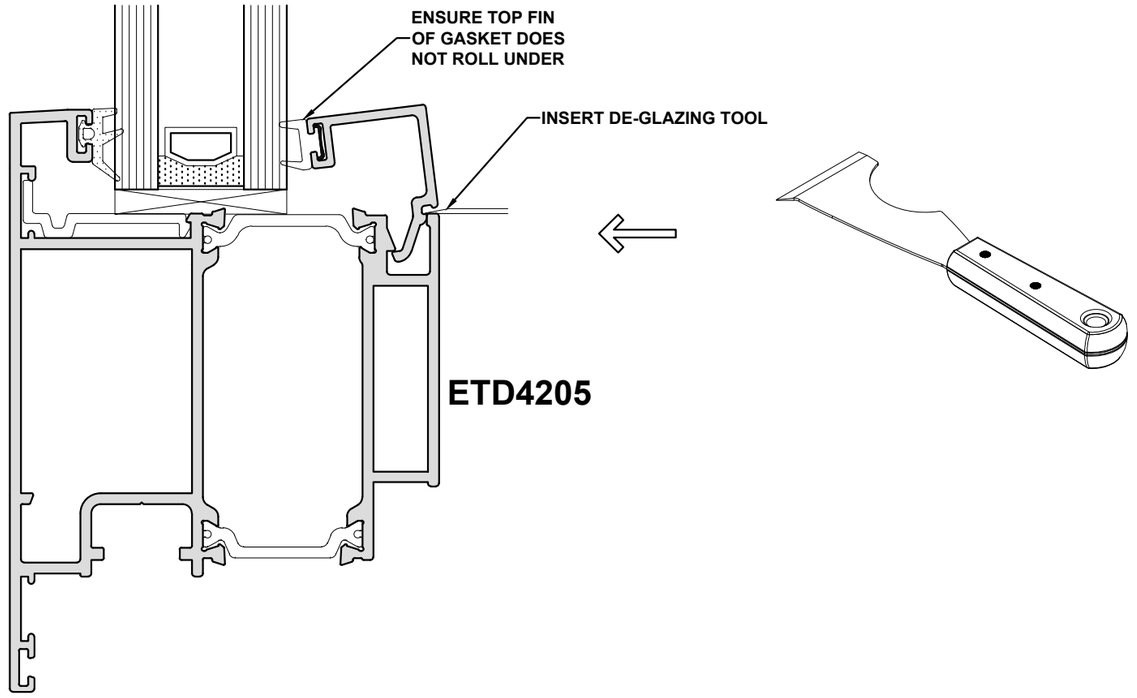
REPLACE INTEGRATED GASKET

QUICK-GLAZE BEAD REMOVAL

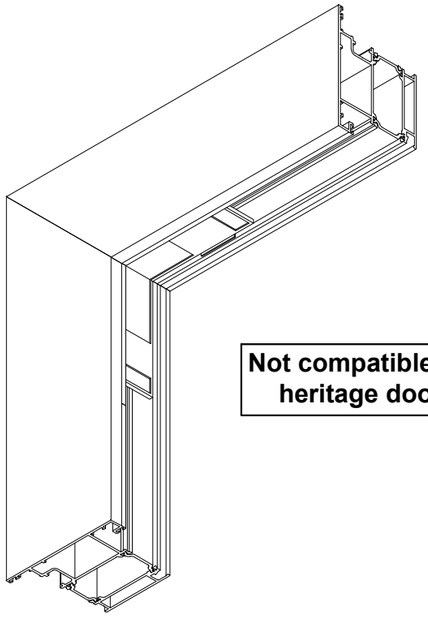
1. USING SMALL FLAT HEADED SCREWDRIVER OR SIMILAR, WEDGE TIP BETWEEN CO EXTRUDED GASKET AND ALUMINIUM.
2. IN A LEVERING MOTION, PRISE THE GASKET AWAY FROM THE ALUMINIUM. PARTICULAR CARE SHOULD BE TAKEN NOT TO DAMAGE THE GLASS UNIT AND ALUMINIUM.
3. COMPLETE THIS AT SEVERAL LOCATIONS ALONG THE LENGTH OF THE BEAD.
4. REMOVE GASKET AND DISCARD. THIS GASKET CAN NO LONGER BE USED.
5. THE BEAD SHOULD NOW BE EASILY REMOVABLE FROM TAP IN BEAD CHANNEL IN SASH

PLEASE SEE GLAZING CHART FOR REPLACEMENT GASKET CODES.

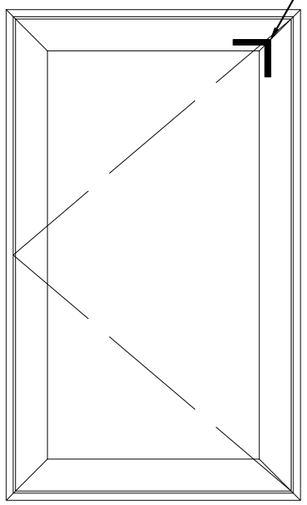




Glass Adjuster

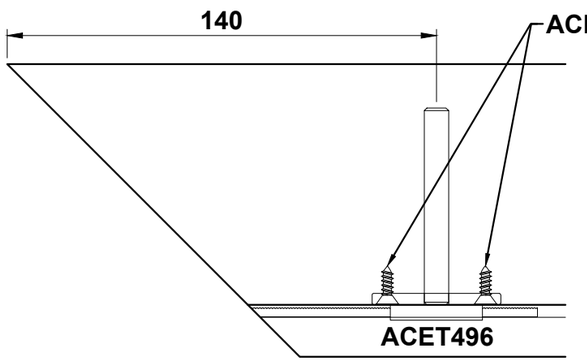


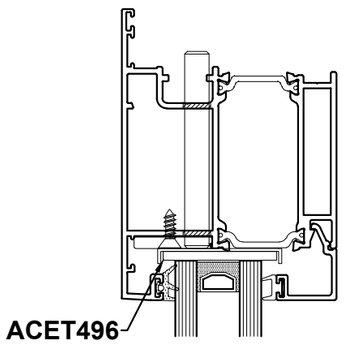
Not compatible with the heritage door sash

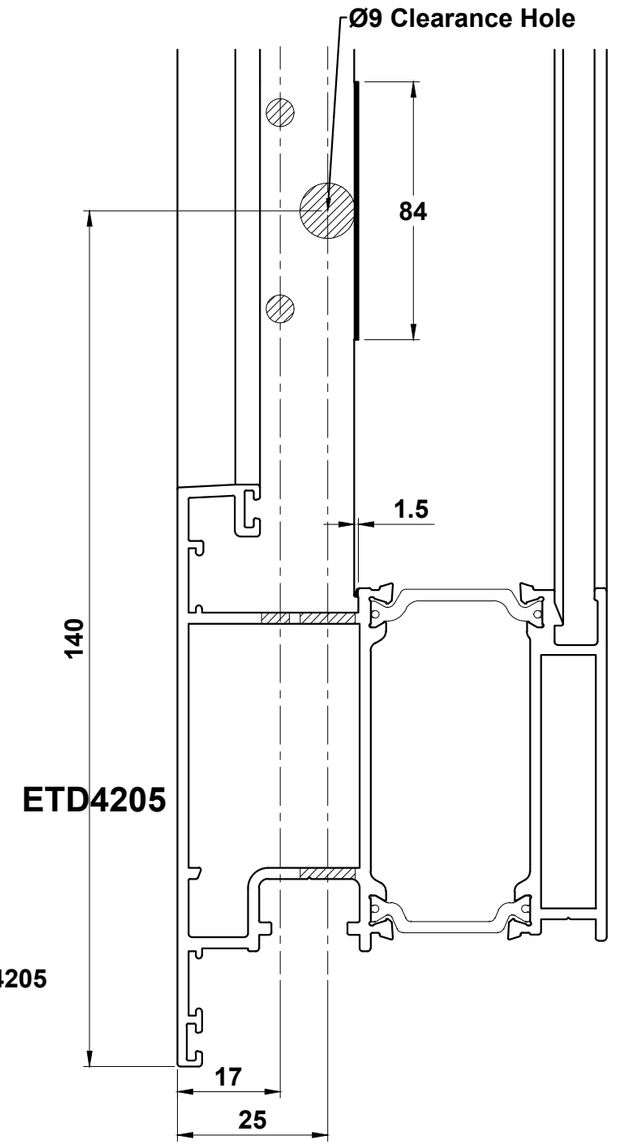


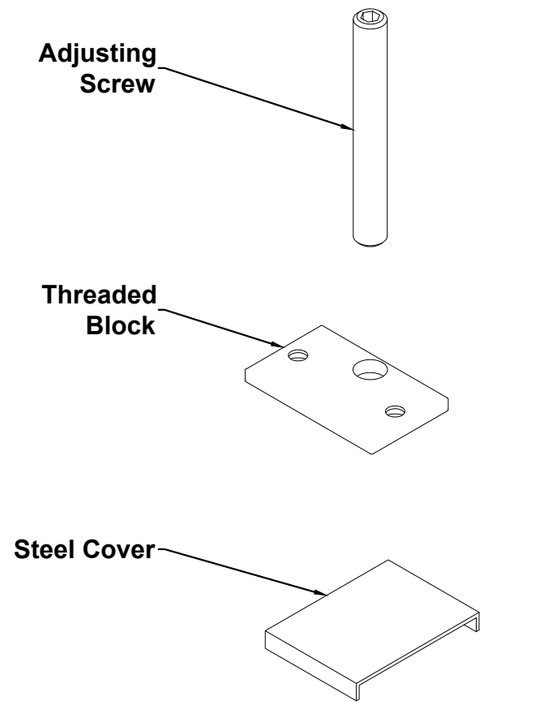
To ensure accuracy use ACET497 drill jig

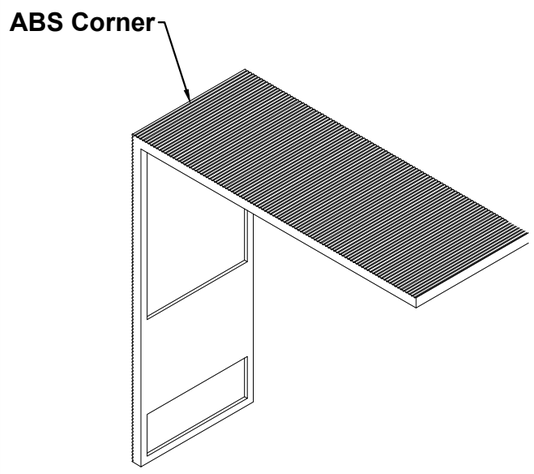
Note: Do not tighten the adjusting screw too tightly as it can lead to cracked glass.







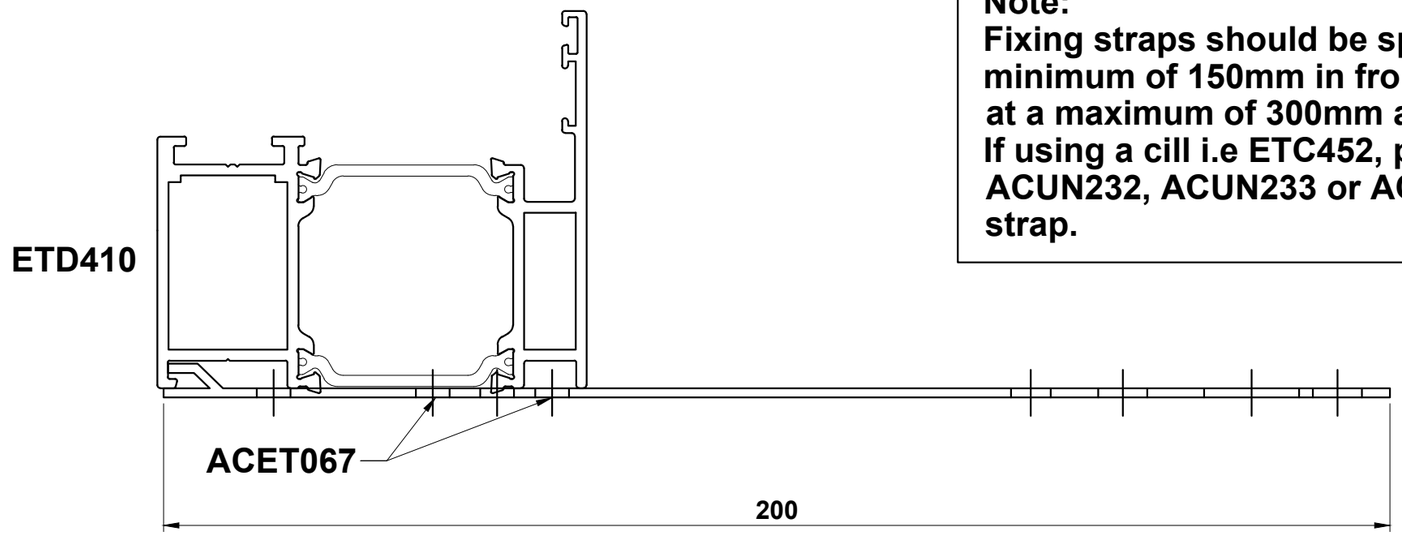


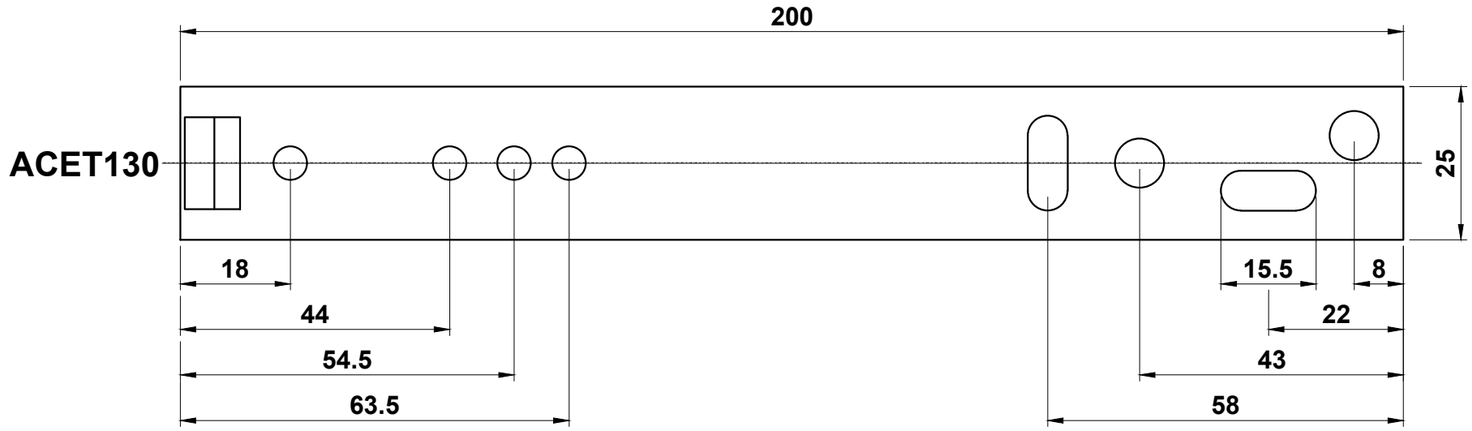


Do Not Scale From This Drawing

Fixing Strap Detail

Note:
Fixing straps should be spaced a minimum of 150mm in from each end & at a maximum of 300mm apart.
If using a cill i.e ETC452, please use ACUN232, ACUN233 or ACUN234 fixing strap.



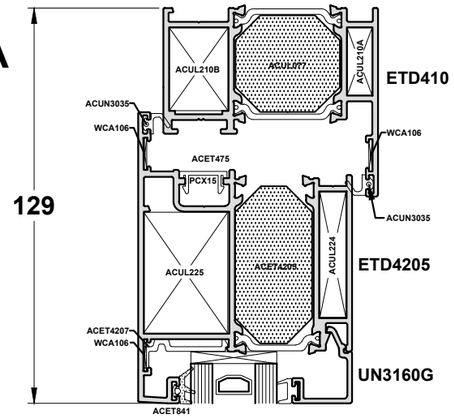


Do Not Scale From This Drawing

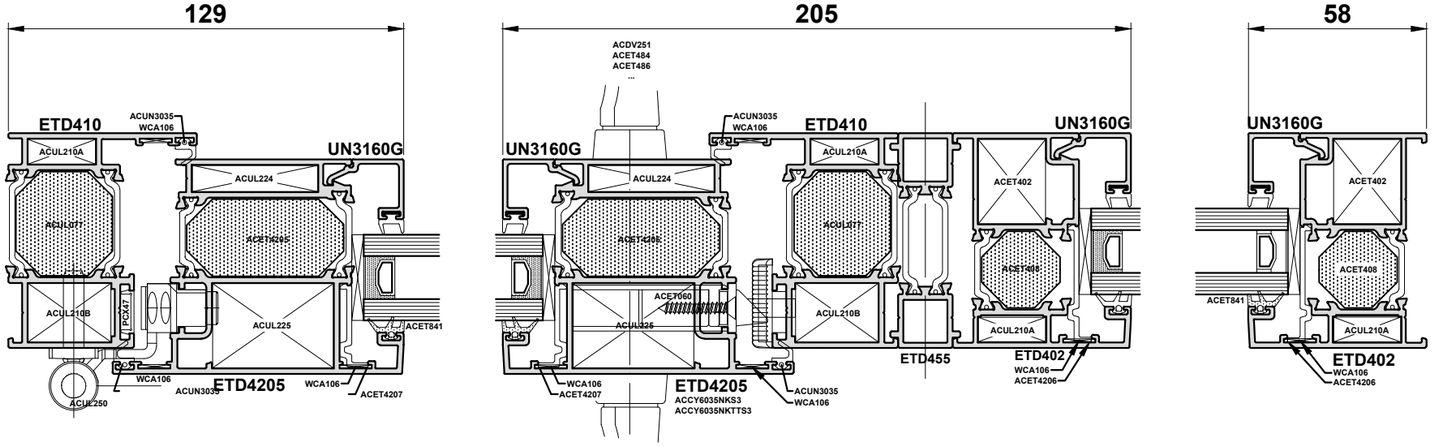
Alitherm 400 Stepped Door

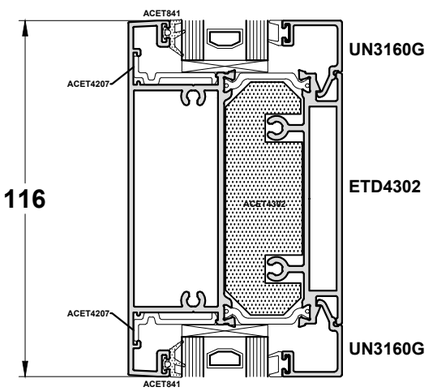
Example Layout

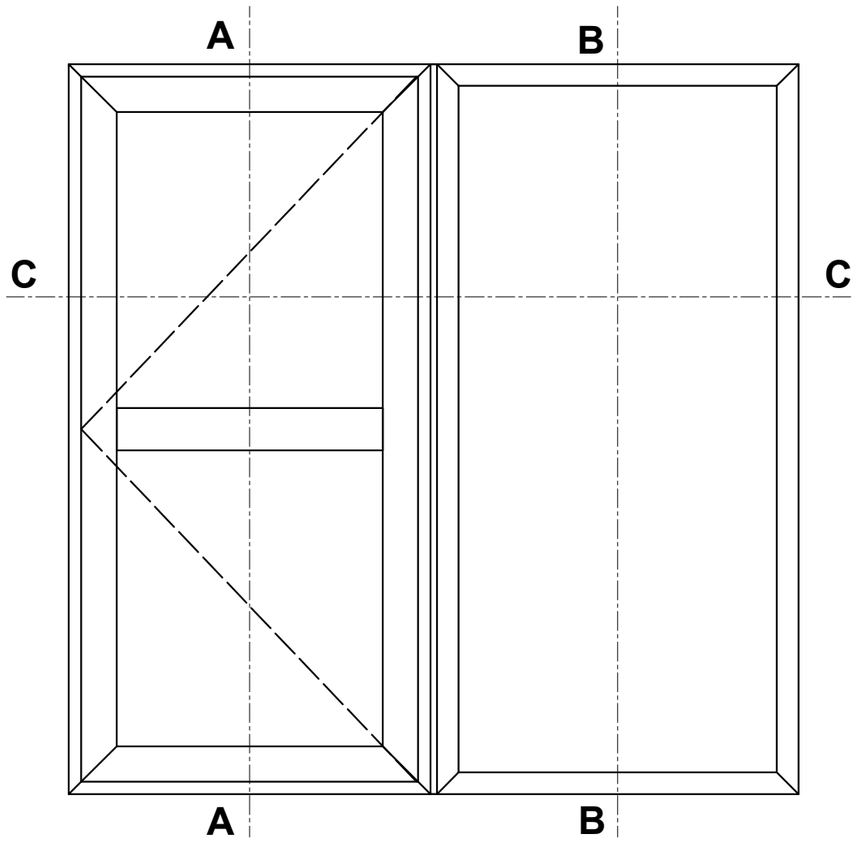
AA



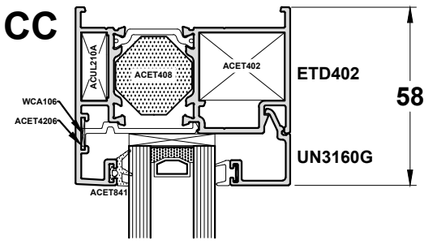
BB

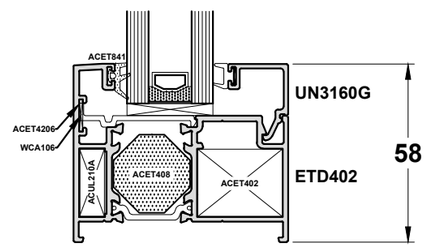






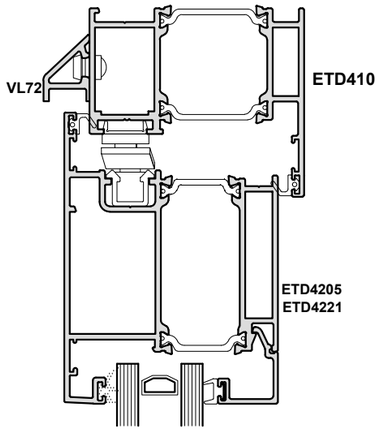
CC

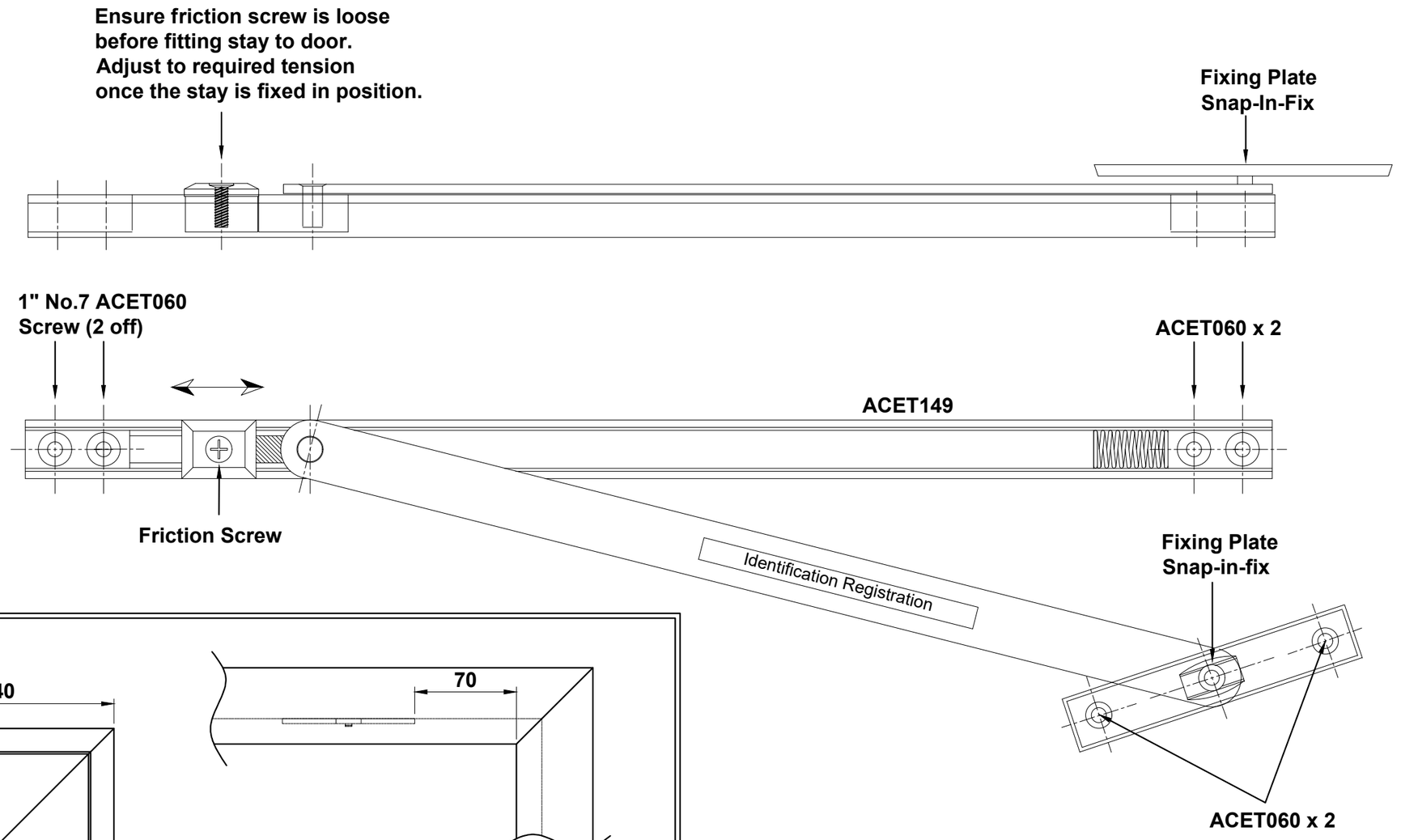


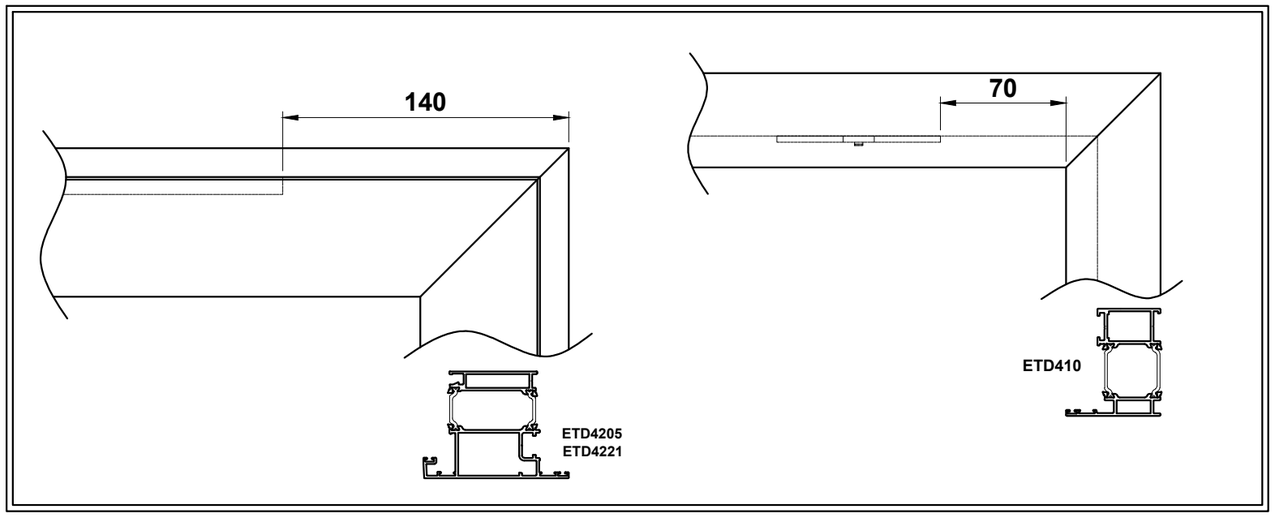


Do Not Scale From This Drawing

ACET149 Fitting Instructions



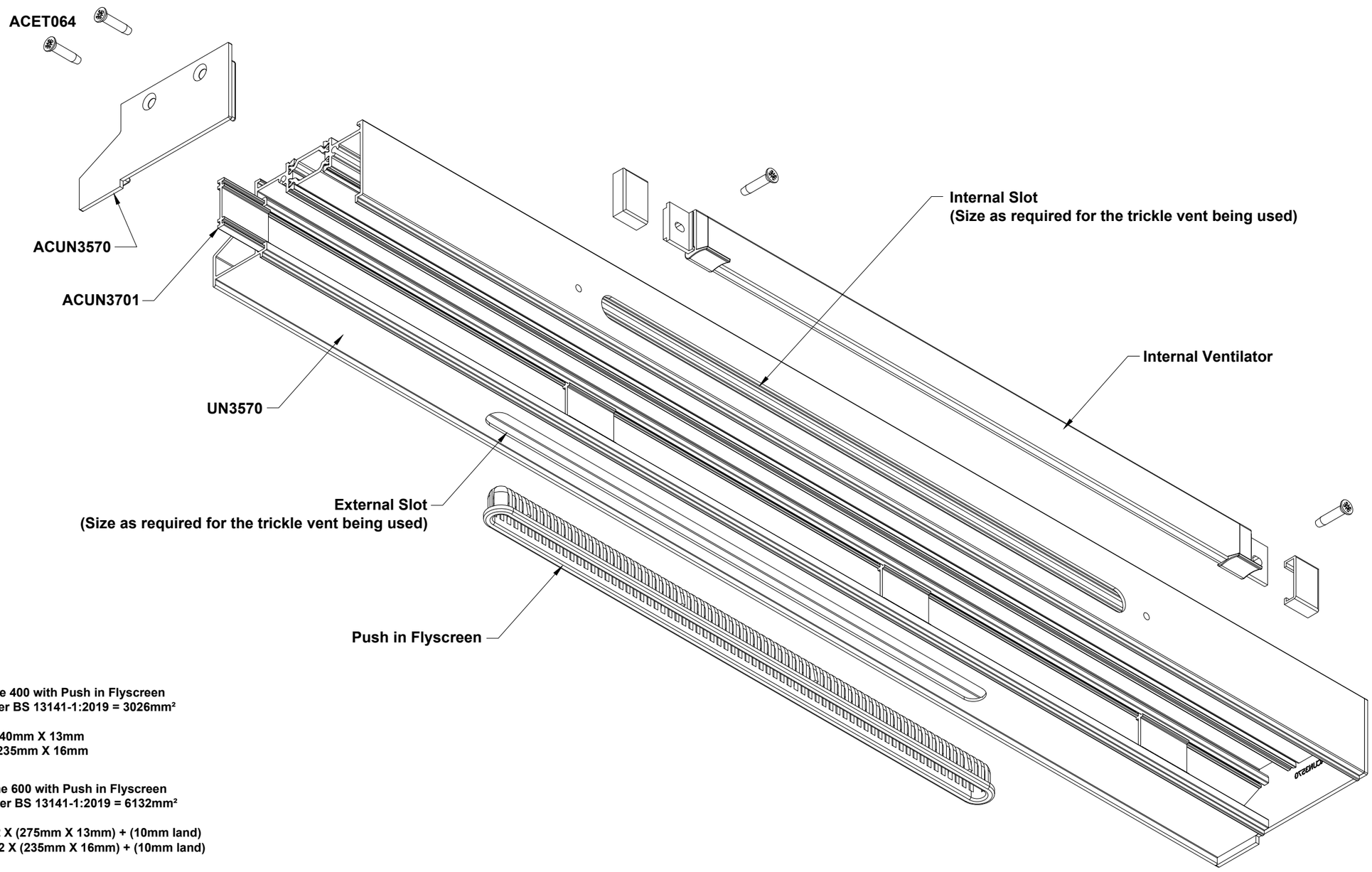




Do Not Scale From This Drawing

Alitherm 400 Stepped Door

Trickle Vent



R. W. Simon Sightline 400 with Push in Flyscreen
Equivalent area as per BS 13141-1:2019 = 3026mm²
Length = 400mm
Internal Slot Size = 340mm X 13mm
External Slot Size = 235mm X 16mm

R. W. Simon Sightline 600 with Push in Flyscreen
Equivalent area as per BS 13141-1:2019 = 6132mm²
Length = 600mm
Internal Slot Size = 2 X (275mm X 13mm) + (10mm land)
External Slot Size = 2 X (235mm X 16mm) + (10mm land)

Do Not Scale From This Drawing

Section F

F ETD

Sawing Tables

Open In

Single Door..... F03 - F10
Heritage Single Door..... F11 - F13
Double Door Lift Lever..... F14 - F18
Double Door Finger Bolt..... F19 - F22
Heritage Double Door..... F23 - F27

Open Out

Single Door..... F28 - F30
Heritage Single Door..... F31 - F33
Double Door Lift Lever..... F34 - F36
Double Door Finger Bolt..... F37 - F39
Heritage Double Door..... F40 - F42

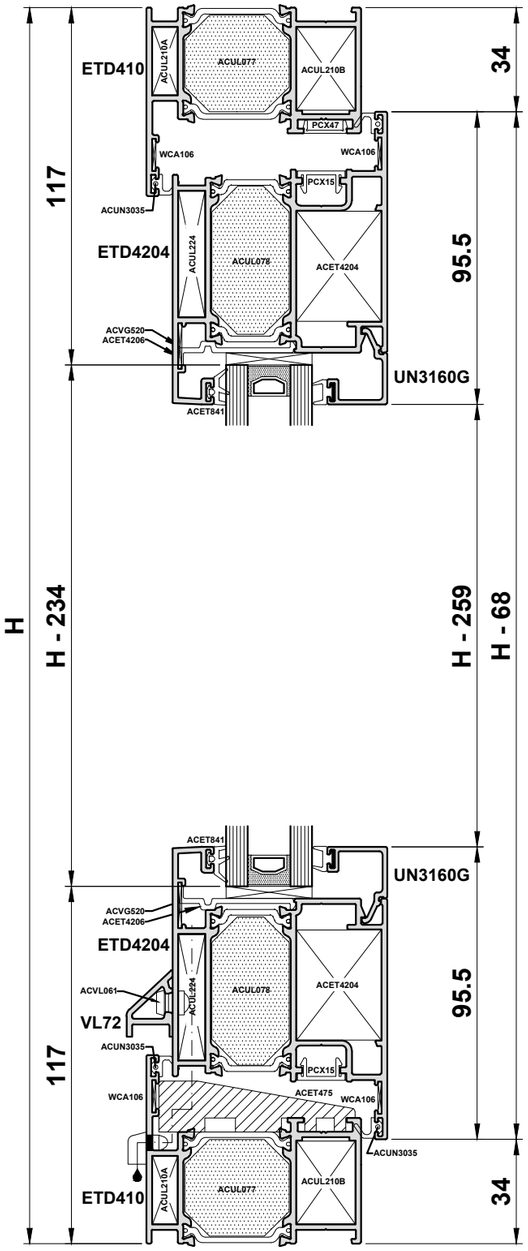
Fan Light F43

Side Light F44

Section F

Alitherm 400 Stepped Door

Open In Single Door Full Frame Quick-Glaze Bead



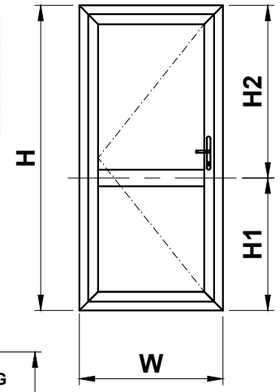
Profile Cutting Schedule				
ETD410	2			W
ETD410	2			H
ETD4204	2			W - 68
ETD4204	2			H - 68
UN3160G	2			H - 259
UN3160G	2			W - 225
PCX15	2			H - 106
PCX15	2			W - 106
PCX47	2			H - 82
PCX47	2			W - 82
VL72	1			W - 144
MIDRAIL: ETD4301	1			W - 225
MIDRAIL: UN3160G	4			W - 225
MIDRAIL: UN3160G	2			H1 - 187.5
MIDRAIL: UN3160G	2			H2 - 187.5

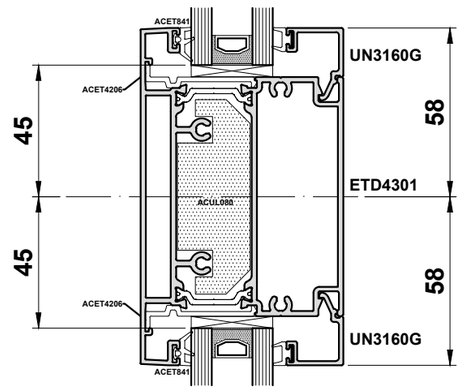
Glass Sizes		
Without ETD4301	H - 234	W - 234
Top Glass With ETD4301	H2 - 162	W - 234
Bottom Glass With ETD4301	H1 - 162	W - 234

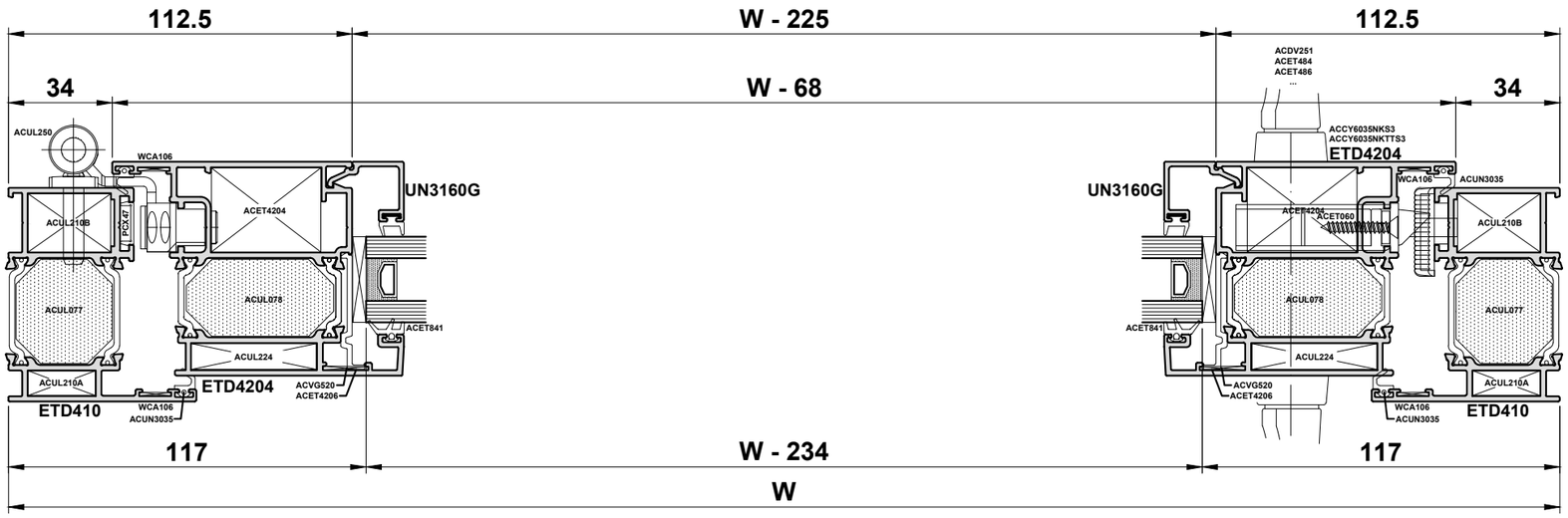
Accessories		
ACCY6035S3	1	Euro Cylinder
**	**	Handles
ACET060	16	Screws for Lock
ACET131	2	Drainage Cap
ACET4204	4	Sash Cleat
ACET4206	10	Bridge Packers
ACET475	2	Run Up Block
ACET841	2 x W & 2 x H	Gasket
ACIM062	12	Screw for ACUL250
ACUL077	2 x W & 2 x H	Outer Frame Foam
ACUL078	2 x W & 2 X H	Sash Foam
ACUL210A	4	Outer Frame Cleat
ACUL210B	4	Outer Frame Cleat
ACUL224	4	Sash Cleat
ACUL250	3	Hinge
ACUN3035	4 x W & 4 x H	Flipper Gasket
ACUN3512	9	Screw for ACUL250
ACVL059 / ACVL072	1 Pair	VL72 End Cap
ACVL061	W/300 + 2	VL72 Rivet
WCA106	12	Chevrons
*	1	Primary Lock

*See Page E20 for lock options.
**See B & E for handle options.

Midrail Accessories		
ACET841	2 x W	E Gasket
ACUL080	W	ETD4301 Foam
ACUN3512	4	Screws
ACET4206	4	Bridge Packers



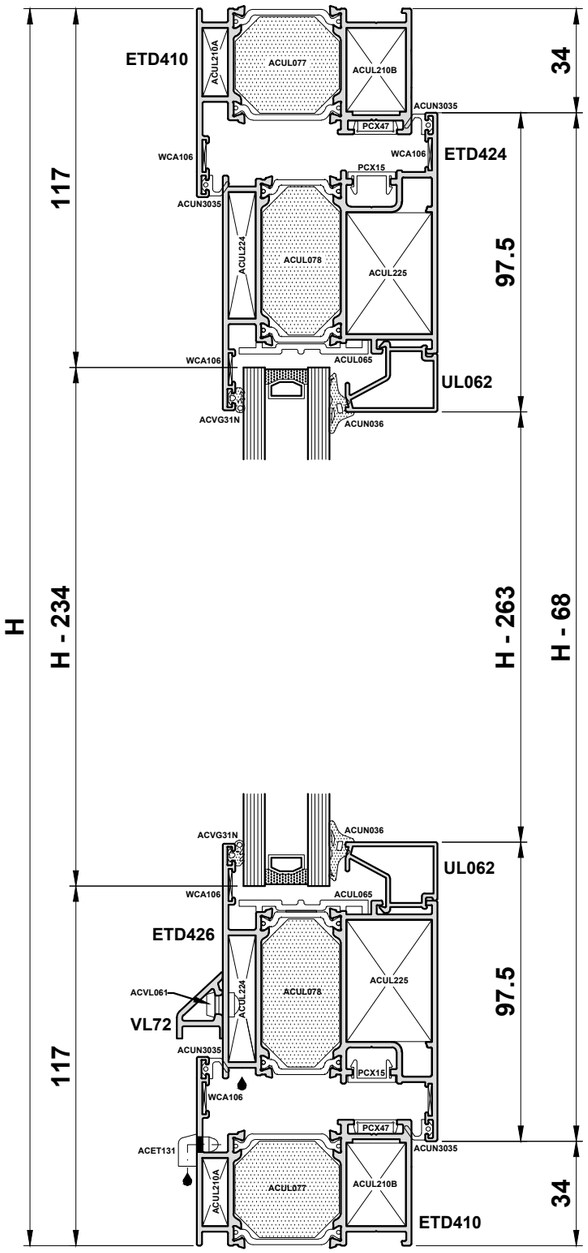




Do Not Scale From This Drawing

Alitherm 400 Stepped Door

Open In Single Door Full Frame



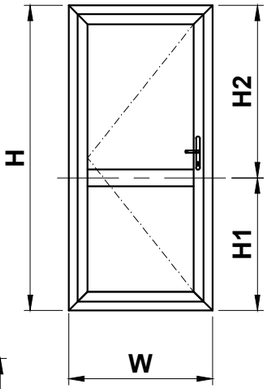
Profile Cutting Schedule				
ETD410	2			W
ETD410	2			H
ETD424	2			W - 68
ETD424	2			H - 68
BEAD	2			H - 263
BEAD	2			W - 225
PCX15	2			H - 106
PCX15	2			W - 106
PCX47	2			H - 82
PCX47	2			W - 82
VL72	1			W - 144
MIDRAIL: ETD430	1			W - 225
BEAD	4			W - 225
BEAD	2			H1 - 190
BEAD	2			H2 - 190

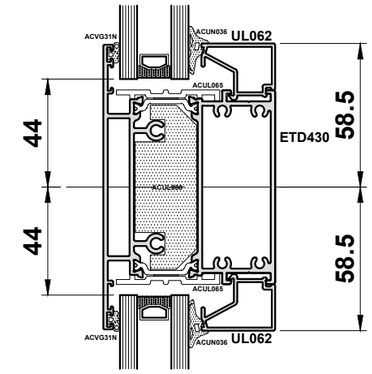
Glass Sizes		
Without ETD430	H - 234	W - 234
Top Glass With ETD430	H2 - 161	W - 234
Bottom Glass With ETD430	H1 - 161	W - 234

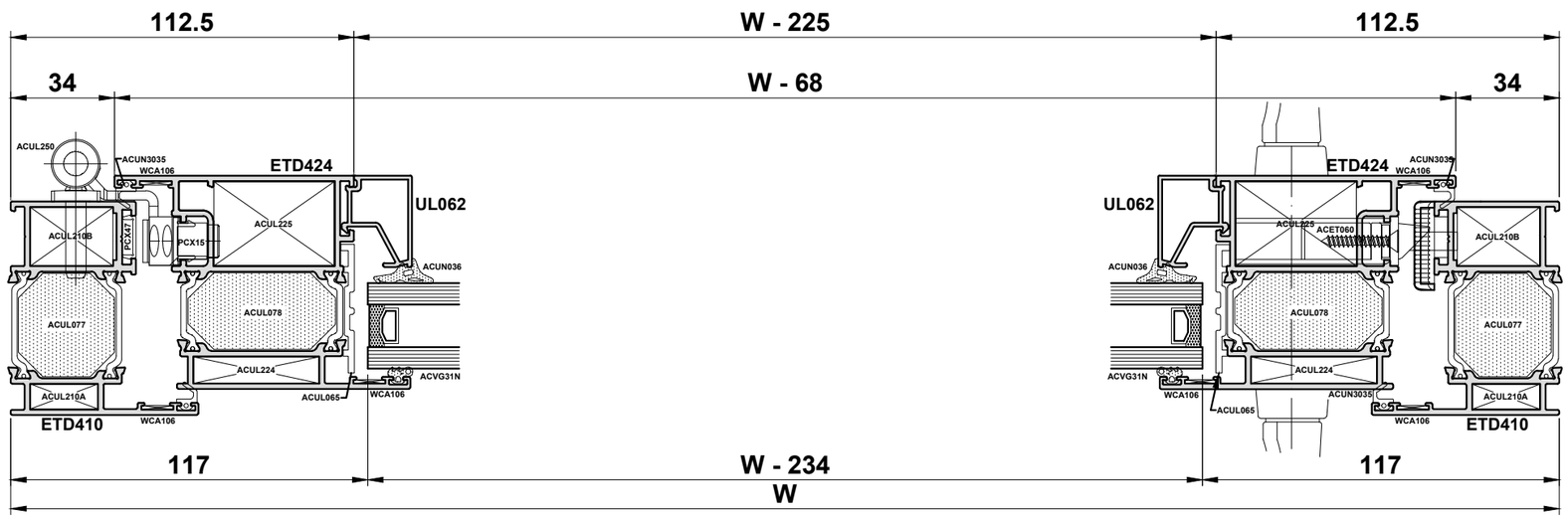
Accessories		
ACCY6035S3	1	Euro Cylinder
**	**	Handles
ACET060	16	Screws for Lock
ACET131	2	Drainage Cap
ACET475	2	Run Up Block
ACIM062	12	Screw for ACUL250
ACUL065	10	Bridge Packers
ACUL077	2 x W & 2 x H	Outer Frame Foam
ACUL078	2 x W & 2 X H	Sash Foam
ACUL210A	4	Outer Frame Cleat
ACUL210B	4	Outer Frame Cleat
ACUL224	4	Sash Cleat
ACUL225	4	Sash Cleat
ACUL250	3	Hinge
ACUN036	2 x W & 2 x H	Wedge Gasket
ACUN3035	4 x W & 4 x H	Flipper Gasket
ACUN3512	9	Screw for ACUL250
ACVG31N	2 x W & 2 x H	E Gasket
ACVL059 / ACVL072	1 Pair	VL72 End Cap
ACVL061	W/300 + 2	VL72 Rivet
WCA106	12	Chevrons
*	1	Primary Lock

*See Page E20 for lock options.
**See B & E for handle options.

Midrail Accessories		
ACUL080	W	ETD430 Foam
ACUL025	4	Anti-Twist Clip
ACUL065	4	Bridge Packers
ACUL299	2	Bracket
ACUN036	2 x W	Wedge Gasket
ACUN3512	4	Screws
ACVG31N	2 x W	E Gasket



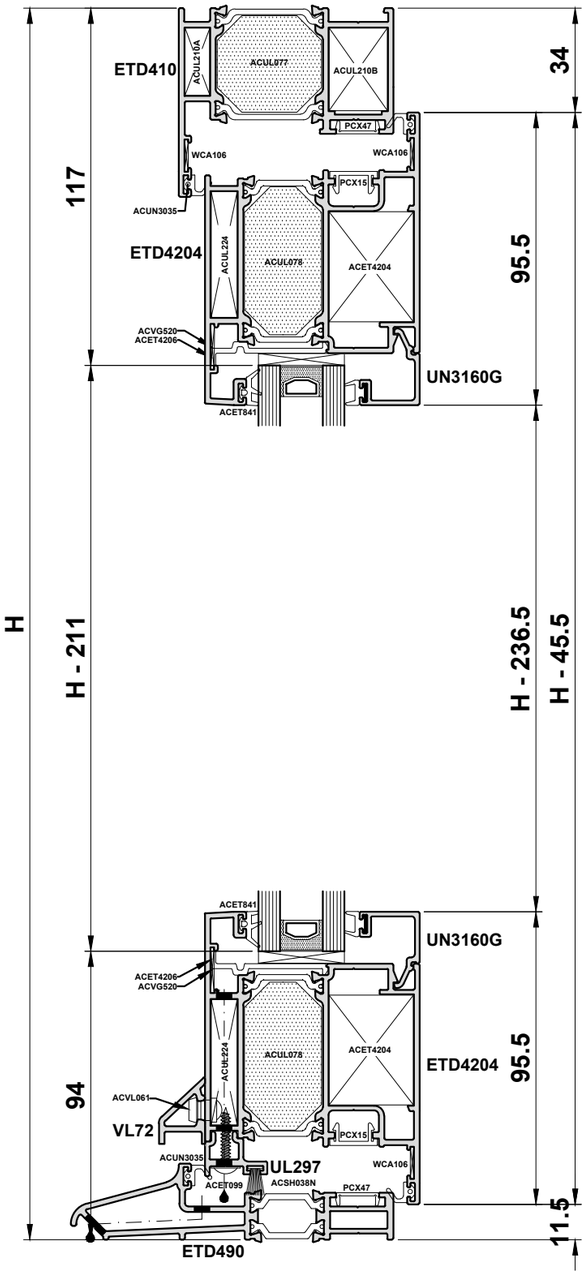




Do Not Scale From This Drawing

Alitherm 400 Stepped Door

Open In Single Door ETD490 Low Rebate Threshold Quick-Glaze Bead



Profile Cutting Schedule				
ETD410	1			W
ETD410	2			H - 15.5
ETD490	1			W
ETD4204	2			W - 68
ETD4204	2			H - 45.5
UL297	1			W - 113
UN3160G	2			H - 236.5
UN3160G	2			W - 225
PCX15	2			H - 84.5
PCX15	2			W - 106
PCX47	2			H - 56.5
PCX47	2			W - 82
VL72	1			W - 144
MIDRAIL	ETD4301	1		W - 225
	UN3160G	4		W - 225
	UN3160G	2		H1 - 165
	UN3160G	2		H2 - 187.5

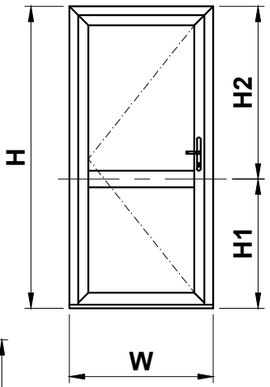
Glass Sizes		
Without ETD4301	H - 211	W - 234
Top Glass With ETD4301	H2 - 162	W - 234
Bottom Glass With ETD4301	H1 - 139	W - 234

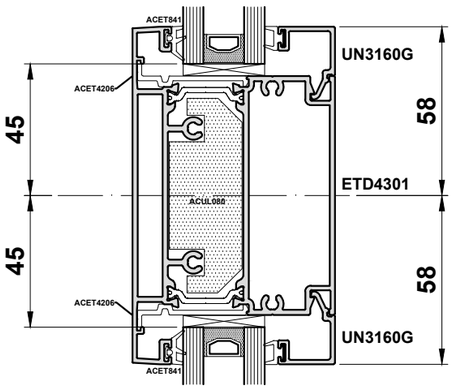
Accessories		
ACCY6035S3	1	Euro Cylinder
**	**	Handles
ACET060	4	Screw for ACET4190
ACET060	16	Screw for Lock
ACET099	W - 100 / 300	Screw for UL297
ACET4190	Pair	ETD490 End Cap
ACET4197	Pair	UL297 End Cap
ACET4204	4	Sash Cleat
ACET4206	10	Bridge Packers
ACET475	2	Run Up Block
ACET841	2 x W & 2 x H	E Gasket
ACIM062	12	Screw for ACUL250
ACSH038N	W	Woolpile
ACUL077	W & 2 x H	Outer Frame Foam
ACUL078	2 x W & 2 X H	Sash Foam
ACUL210A	2	Outer Frame Cleat
ACUL210B	2	Outer Frame Cleat
ACUL224	4	Sash Cleat
ACUL250	3	Hinge
ACUL295	2	Low Threshold Bracket
ACUN3035	4 x W & 4 x H	Flipper Gasket
ACUN3512	9	Screws for ACUL250
ACVL059 / ACVL072	1 Pair	VL72 End Cap

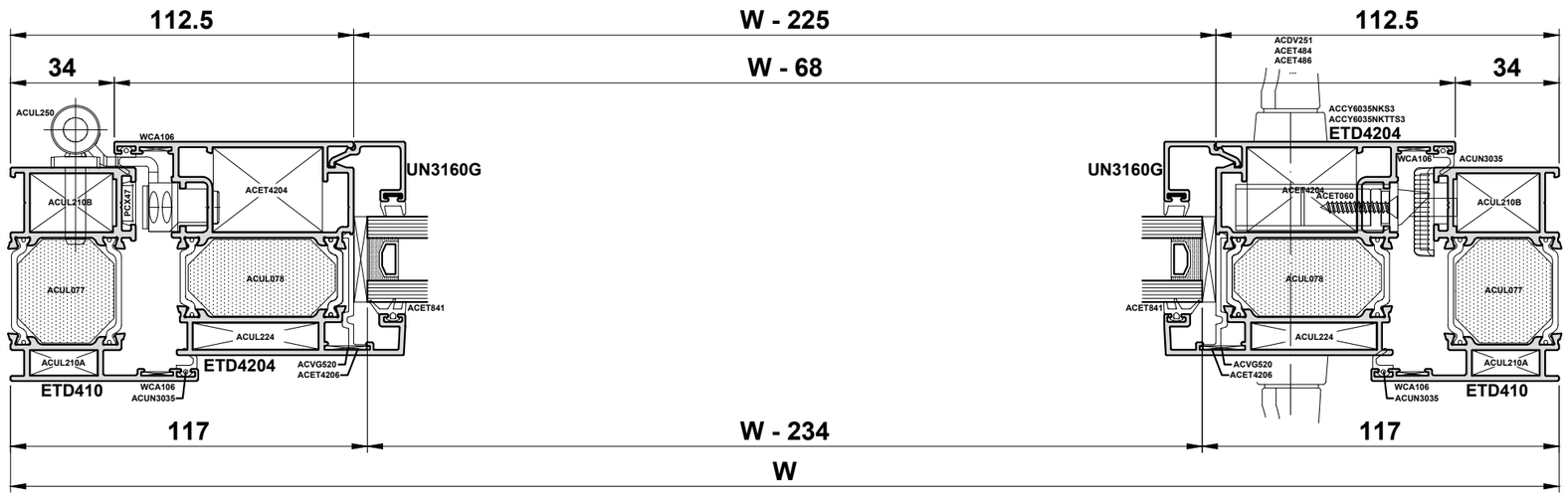
ACVL061	W/300 + 2	VL72 Rivet
WCA106	10	Chevrons
*	1	Primary Lock

*See Page E20 for lock options.
**See B & E for handle options.

Midrail Accessories		
ACET841	2 x W	E Gasket
ACUL080	W	ETD4301 Foam
ACUN3512	4	Screws
ACET4206	4	Bridge Packers

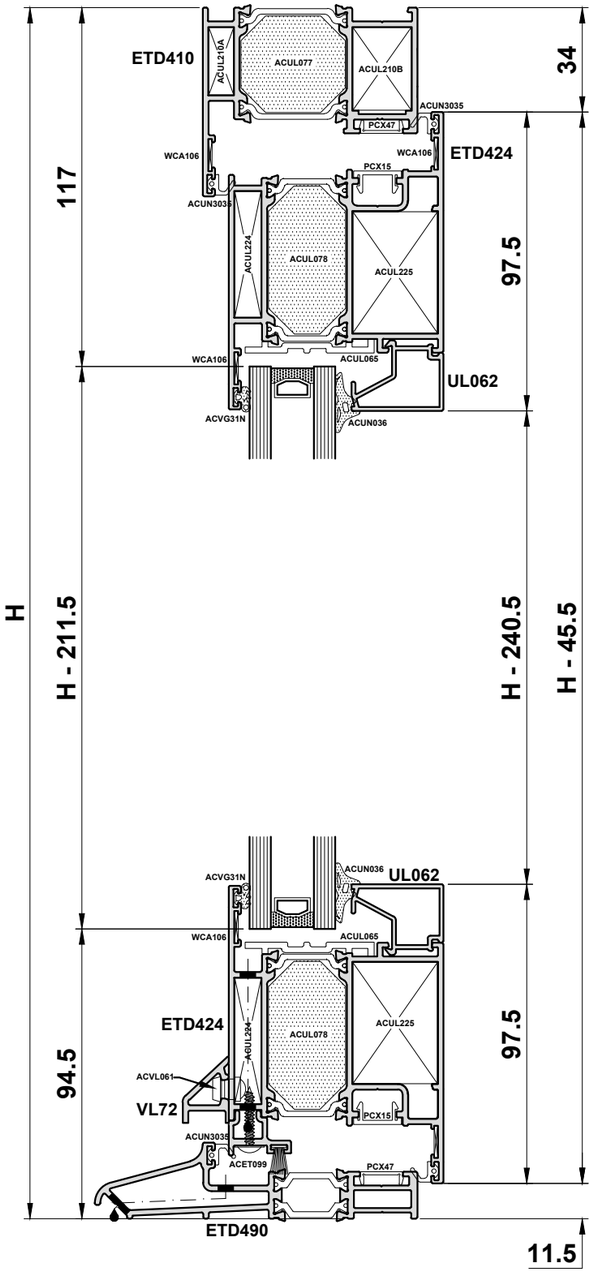






Do Not Scale From This Drawing

Open In Single Door ETD490 Low Rebate Threshold



Profile Cutting Schedule			
ETD410	1		W
ETD410	2		H - 15.5
ETD490	1		W
ETD424	2		W - 68
ETD424	2		H - 45.5
UL297	1		W - 113
BEAD	2		H - 240.5
BEAD	2		W - 225
PCX15	2		H - 84.5
PCX15	2		W - 106
PCX47	2		H - 56.5
PCX47	2		W - 82
VL72	1		W - 144
MIDRAIL	ETD430	1	W - 225
	BEAD	4	W - 225
	BEAD	2	H1 - 167.5
	BEAD	2	H2 - 190

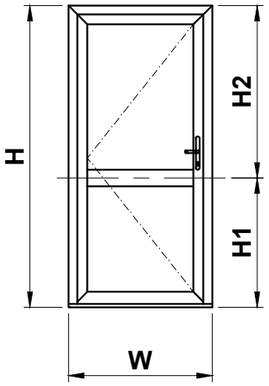
Glass Sizes		
Without ETD430	H - 211.5	W - 234
Top Glass With ETD430	H2 - 161	W - 234
Bottom Glass With ETD430	H1 - 138.5	W - 234

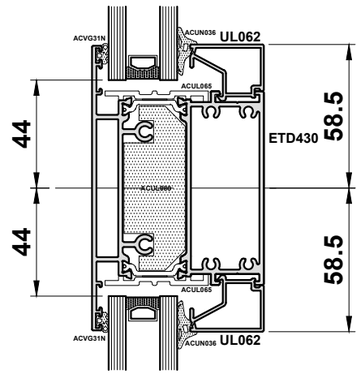
Accessories		
ACCY6035S3	1	Euro Cylinder
**	**	Handles
ACET060	4	Screw for ACET4190
ACET060	16	Screw for Lock
ACET099	W - 100 / 300	Screw for UL297
ACET4190	Pair	ETD490 End Cap
ACET4197	Pair	UL297 End Cap
ACET475	2	Run Up Block
ACIM062	12	Screw for ACUL250
ACSH038N	W	Woolpile
ACUL025	2	Anti-Twist Clip
ACUL065	10	Bridge Packers
ACUL077	W & 2 x H	Outer Frame Foam
ACUL078	2 x W & 2 X H	Sash Foam
ACUL210A	2	Outer Frame Cleat
ACUL210B	2	Outer Frame Cleat
ACUL224	4	Sash Cleat
ACUL225	4	Sash Cleat
ACUL250	3	Hinge
ACUL295	2	Low Threshold Bracket
ACUN036	2 x W & 2 x H	Wedge Gasket
ACUN3035	4 x W & 4 x H	Flipper Gasket
ACUN3512	9	Screws for ACUL250
ACVG31N	2 x W & 2 x H	E Gasket
ACVL059 / ACVL072	1 Pair	VL72 End Cap

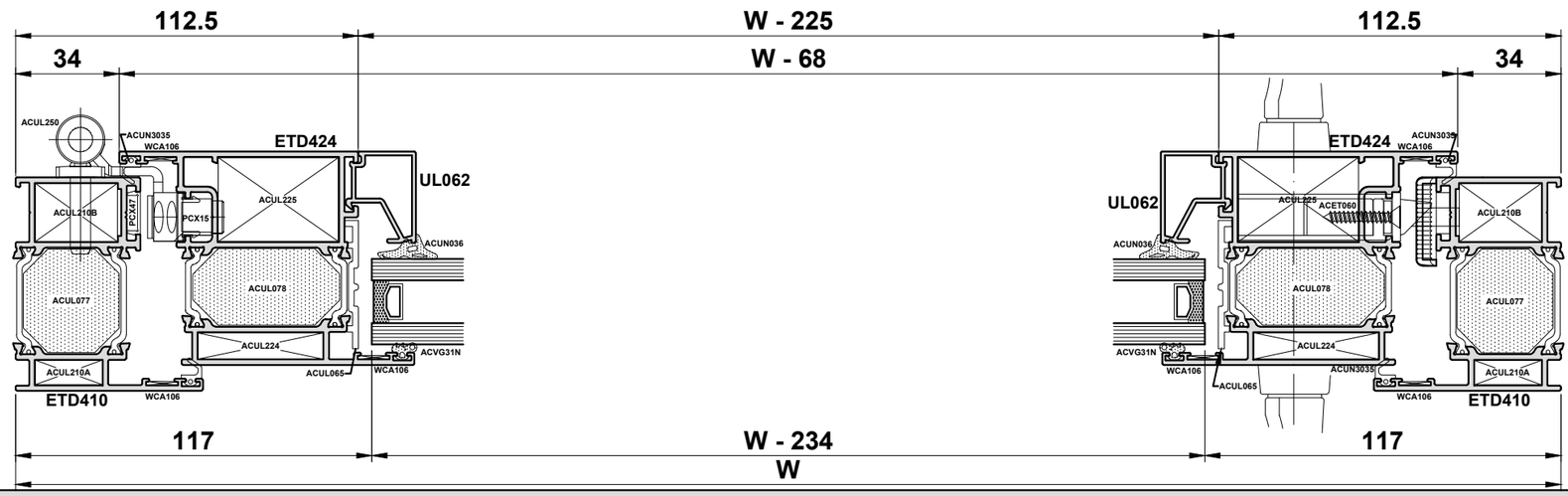
ACVL061	W/300 + 2	VL72 Rivet
WCA106	10	Chevrons
*	1	Primary Lock

*See Page E20 for lock options.
**See B & E for handle options.

Midrail Accessories		
ACUL080	W	ETD430 Foam
ACUL025	4	Anti-Twist Clip
ACUL065	4	Bridge Packers
ACUL299	2	Bracket
ACUN036	2 x W	Wedge Gasket
ACUN3512	4	Screws
ACVG31N	2 x W	E Gasket



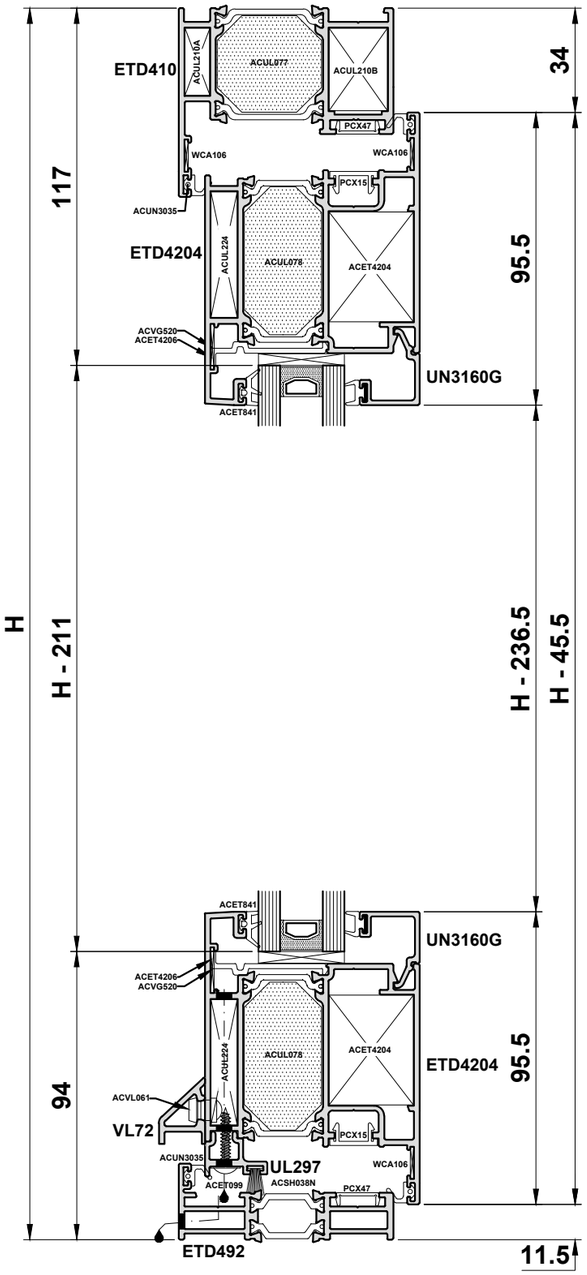




Do Not Scale From This Drawing

Alitherm 400 Stepped Door

Open In Single Door ETD492 Low Rebate Threshold Quick-Glaze Bead



Profile Cutting Schedule				
ETD410	1			W
ETD410	2			H - 15.5
ETD492	1			W
ETD4204	2			W - 68
ETD4204	2			H - 45.5
UL297	1			W - 113
UN3160G	2			H - 236.5
UN3160G	2			W - 225
PCX15	2			H - 84.5
PCX15	2			W - 106
PCX47	2			H - 56.5
PCX47	2			W - 82
VL72	1			W - 144
MIDRAIL	ETD4301	1		W - 225
	UN3160G	4		W - 225
	UN3160G	2		H1 - 165
	UN3160G	2		H2 - 187.5

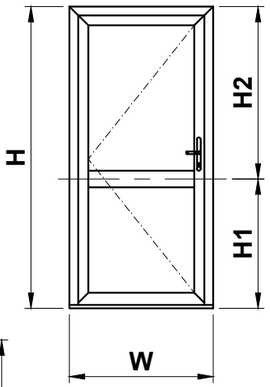
Glass Sizes		
Without ETD4301	H - 211	W - 234
Top Glass With ETD4301	H2 - 162	W - 234
Bottom Glass With ETD4301	H1 - 139	W - 234

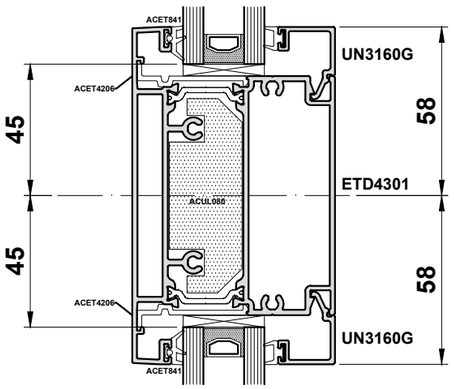
Accessories		
ACCY6035S3	1	Euro Cylinder
**	**	Handles
ACET060	4	Screw for ACET4190
ACET060	16	Screw for Lock
ACET099	W - 100 / 300	Screw for UL297
ACET4192	Pair	ETD492 End Cap
ACET4197	Pair	UL297 End Cap
ACET4204	4	Sash Cleat
ACET4206	10	Bridge Packers
ACET475	2	Run Up Block
ACET841	2 x W & 2 x H	E Gasket
ACIM062	12	Screw for ACUL250
ACSH038N	W	Woolpile
ACUL077	W & 2 x H	Outer Frame Foam
ACUL078	2 x W & 2 X H	Sash Foam
ACUL210A	2	Outer Frame Cleat
ACUL210B	2	Outer Frame Cleat
ACUL224	4	Sash Cleat
ACUL250	3	Hinge
ACUL295	2	Low Threshold Bracket
ACUN3035	4 x W & 4 x H	Flipper Gasket
ACUN3512	9	Screws for ACUL250
ACVL059 / ACVL072	1 Pair	VL72 End Cap

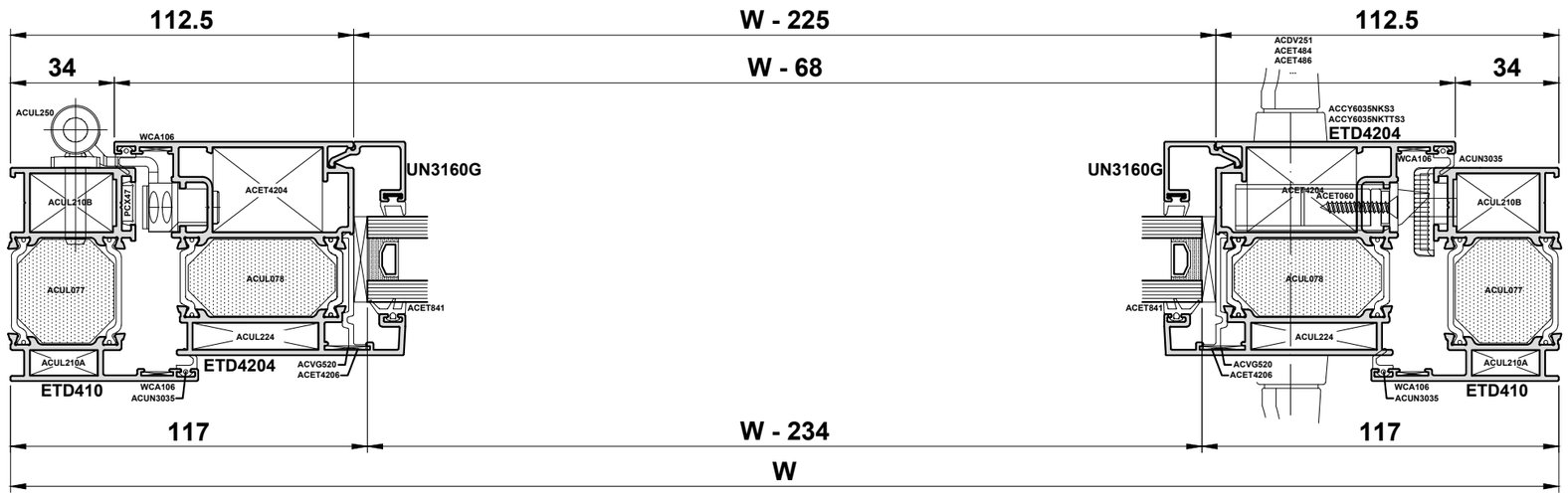
ACVL061	W/300 + 2	VL72 Rivet
WCA106	10	Chevrons
*	1	Primary Lock

*See Page E20 for lock options.
**See B & E for handle options.

Midrail Accessories		
ACET841	2 x W	E Gasket
ACUL080	W	ETD4301 Foam
ACUN3512	4	Screws
ACET4206	4	Bridge Packers

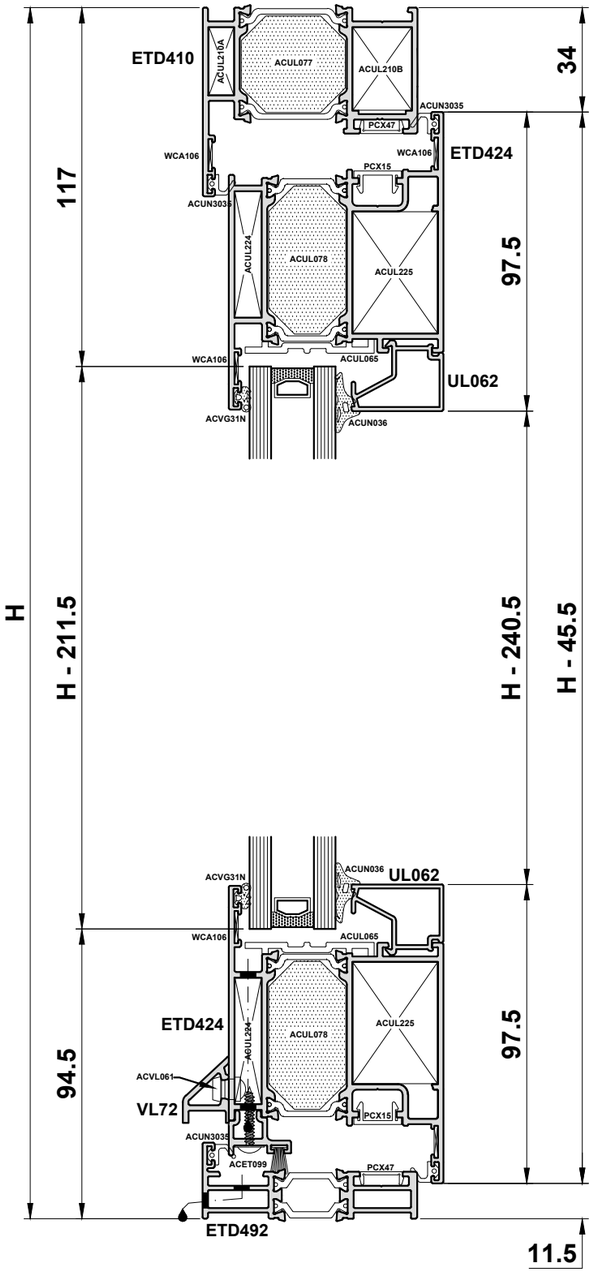






Do Not Scale From This Drawing

Open In Single Door ETD492 Low Rebate Threshold



Profile Cutting Schedule			
ETD410	1		W
ETD410	2		H - 15.5
ETD492	1		W
ETD424	2		W - 68
ETD424	2		H - 45.5
UL297	1		W - 113
BEAD	2		H - 240.5
BEAD	2		W - 225
PCX15	2		H - 84.5
PCX15	2		W - 106
PCX47	2		H - 56.5
PCX47	2		W - 82
VL72	1		W - 144
MIDRAIL	ETD430	1	W - 225
	BEAD	4	W - 225
	BEAD	2	H1 - 167.5
	BEAD	2	H2 - 190

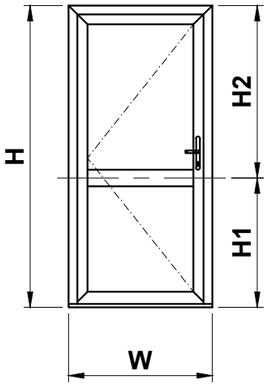
Glass Sizes		
Without ETD430	H - 211.5	W - 234
Top Glass With ETD430	H2 - 161	W - 234
Bottom Glass With ETD430	H1 - 138.5	W - 234

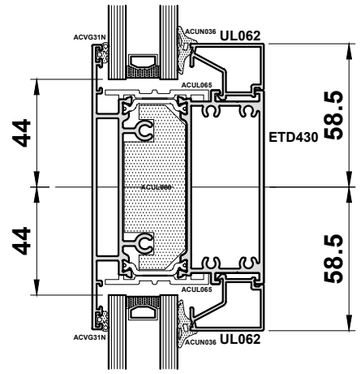
Accessories		
ACCY6035S3	1	Euro Cylinder
**	**	Handles
ACET060	4	Screw for ACET4190
ACET060	16	Screw for Lock
ACET099	W - 100 / 300	Screw for UL297
ACET4192	Pair	ETD492 End Cap
ACET4197	Pair	UL297 End Cap
ACET475	2	Run Up Block
ACIM062	12	Screw for ACUL250
ACSH038N	W	Woolpile
ACUL025	2	Anti-Twist Clip
ACUL065	10	Bridge Packers
ACUL077	W & 2 x H	Outer Frame Foam
ACUL078	2 x W & 2 X H	Sash Foam
ACUL210A	2	Outer Frame Cleat
ACUL210B	2	Outer Frame Cleat
ACUL224	4	Sash Cleat
ACUL225	4	Sash Cleat
ACUL250	3	Hinge
ACUL295	2	Low Threshold Bracket
ACUN036	2 x W & 2 x H	Wedge Gasket
ACUN3035	4 x W & 4 x H	Flipper Gasket
ACUN3512	9	Screws for ACUL250
ACVG31N	2 x W & 2 x H	E Gasket
ACVL059 / ACVL072	1 Pair	VL72 End Cap

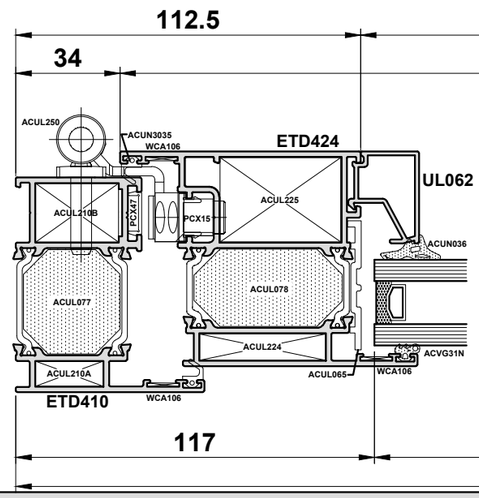
ACVL061	W/300 + 2	VL72 Rivet
WCA106	10	Chevrons
*	1	Primary Lock

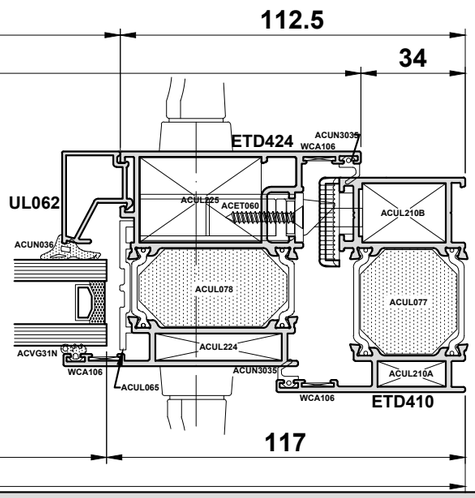
*See Page E20 for lock options.
**See B & E for handle options.

Midrail Accessories		
ACUL080	W	ETD430 Foam
ACUL025	4	Anti-Twist Clip
ACUL065	4	Bridge Packers
ACUL299	2	Bracket
ACUN036	2 x W	Wedge Gasket
ACUN3512	4	Screws
ACVG31N	2 x W	E Gasket





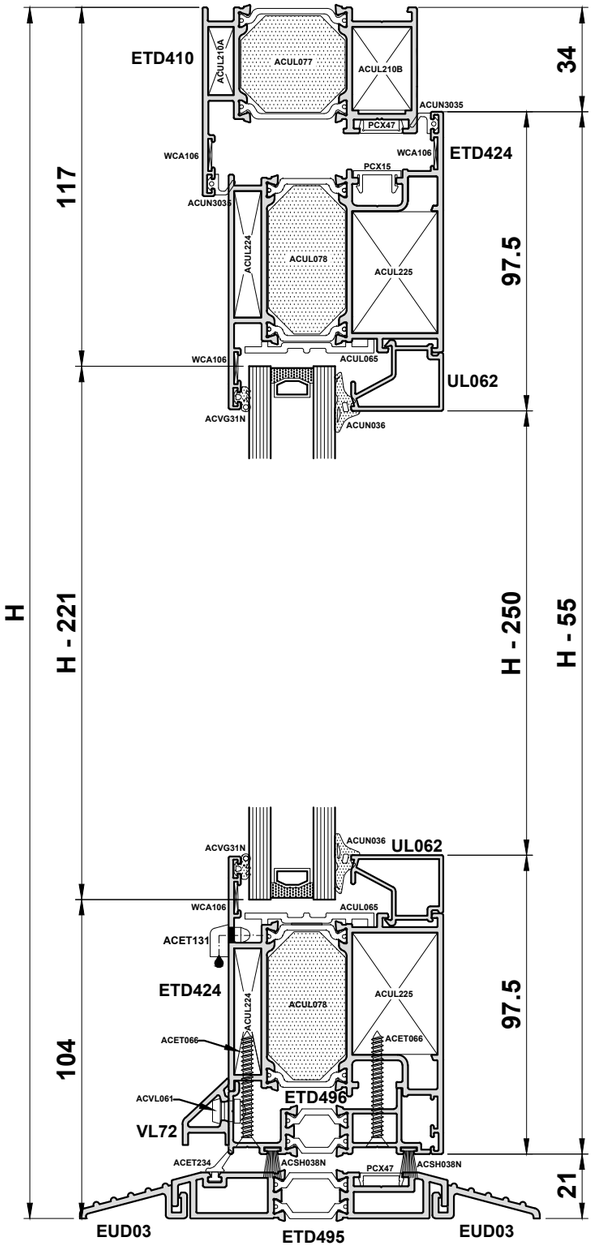




Do Not Scale From This Drawing

Alitherm 400 Stepped Door

Open In Single Door Low Ramp Threshold



Profile Cutting Schedule			
ETD410	1		W
ETD410	2		H - 15
ETD495	1		W
EUD03	2		W
ETD424	2		W - 68
ETD424	2		H - 55
ETD496	1		W - 115
BEAD	2		H - 250
BEAD	2		W - 225
PCX15	2		H - 68.5
PCX15	1		W - 106
PCX47	2		H - 56
PCX47	2		W - 82
VL72	1		W - 144
MIDRAIL: ETD430	1		W - 225
MIDRAIL: BEAD	4		W - 225
MIDRAIL: BEAD	2		H1 - 177
MIDRAIL: BEAD	2		H2 - 190

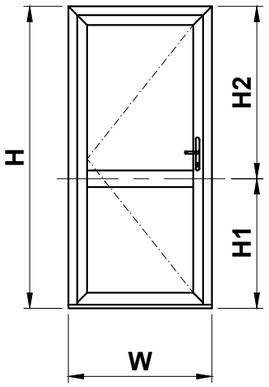
Glass Sizes		
Without ETD430	H - 221	W - 234
Top Glass With ETD430	H2 - 161	W - 234
Bottom Glass With ETD430	H1 - 138.5	W - 234

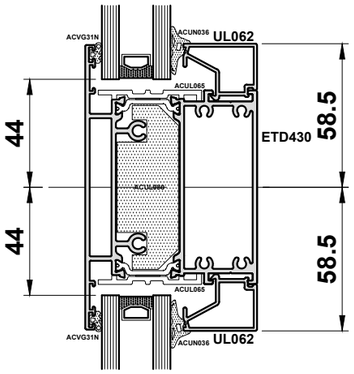
Accessories		
ACCY6035S3	1	Euro Cylinder
**	**	Handles
ACSH038N	2 x W - 115	Woolpile
ACET060	4	Screw for ACET4195
ACET060	16	Screw for Lock
ACET066	2 x W - 100 / 300	Fixing Screw for ETD496
ACET234	1 x W	Flipper Gasket
ACET4195	Pair	ETD495 End Cap
ACET4196	Pair	ETD496 End Cap
ACET475	2	Run Up Block
ACIM062	12	Screw for ACUL250
ACSH038N	2 x W	Brush Pile
ACUL065	10	Bridge Packers
ACUL077	W & 2 x H	Outer Frame Foam
ACUL078	2 x W & 2 x H	Sash Foam
ACUL210A	2	Outer Frame Cleat
ACUL210B	2	Outer Frame Cleat
ACUL224	4	Sash Cleat
ACUL225	4	Sash Cleat
ACUL250	3	Hinge
ACUL295	2	Low Threshold Bracket
ACUN036	2 x W & 2 x H	Wedge Gasket
ACUN3035	2 x W & 4 x H	Flipper Gasket
ACUN3512	9	Screw for ACUL250
ACVG31N	2 x W & 2 x H	E Gasket
ACVL059 / ACVL072	1 Pair	VL72 End Cap
ACVL061	W/300 + 2	VL72 Rivet

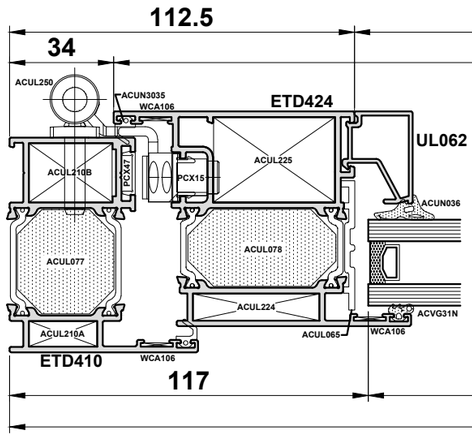
WCA106	10	Chevrons
*	1	Primary Lock

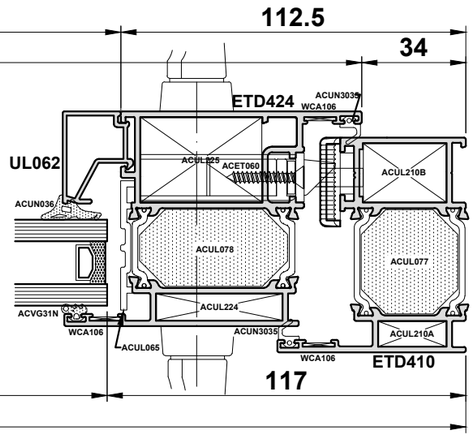
*See Page E20 for lock options.
**See B & E for handle options.

Midrail Accessories		
ACUL080	W	ETD430 Foam
ACUL025	4	Anti-Twist Clip
ACUL065	4	Bridge Packers
ACUL299	2	Bracket
ACUN036	2 x W	Wedge Gasket
ACUN3512	4	Screws
ACVG31N	2 x W	E Gasket



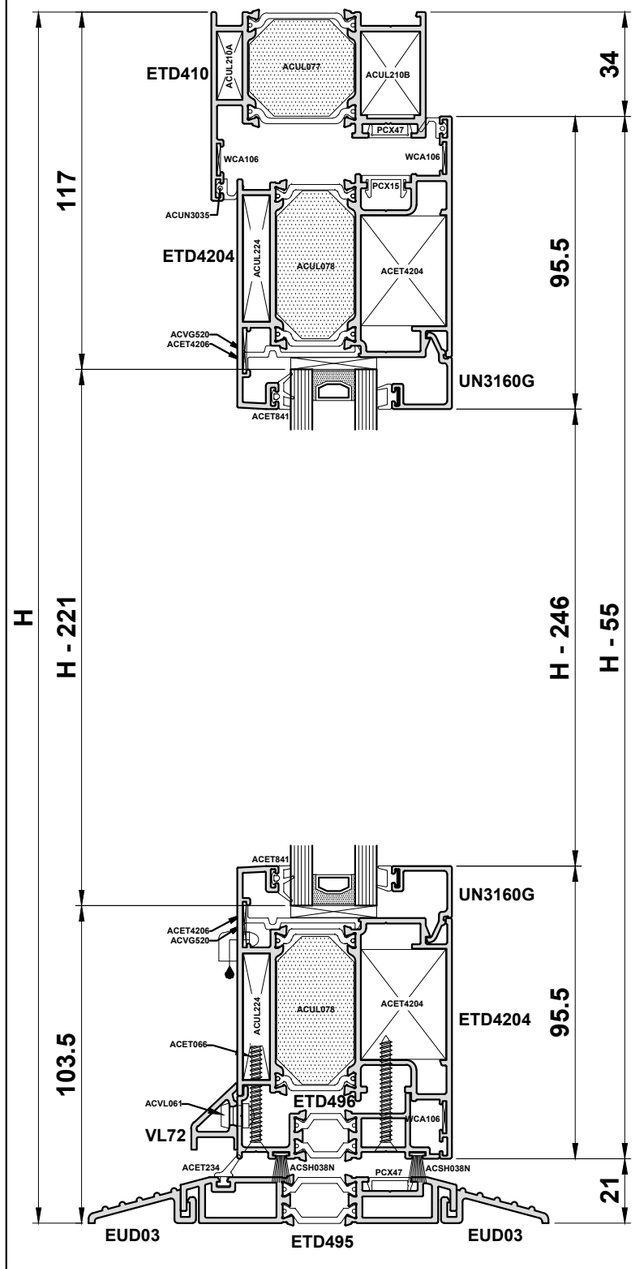






Do Not Scale From This Drawing

Open In Single Door Low Ramp Threshold Quick-Glaze Bead



Profile Cutting Schedule				
ETD410	1			W
ETD410	2			H - 15
ETD495	1			W
EUD03	2			W
ETD4204	2			W - 68
ETD4204	2			H - 55
ETD496	1			W - 115
UN3160G	2			H - 246
UN3160G	2			W - 225
PCX15	2			H - 68.5
PCX15	1			W - 106
PCX47	2			H - 56
PCX47	2			W - 82
VL72	1			W - 144
MIDRAIL ETD4301	1			W - 225
MIDRAIL UN3160G	4			W - 225
MIDRAIL UN3160G	2			H1 - 174.5
MIDRAIL UN3160G	2			H2 - 187.5

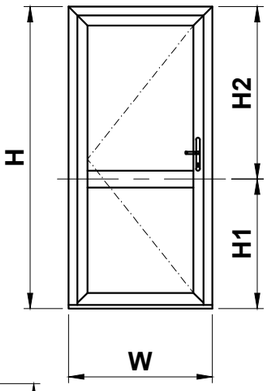
Glass Sizes		
Without ETD4301	H - 221	W - 234
Top Glass With ETD4301	H2 - 162	W - 234
Bottom Glass With ETD4301	H1 - 148.5	W - 234

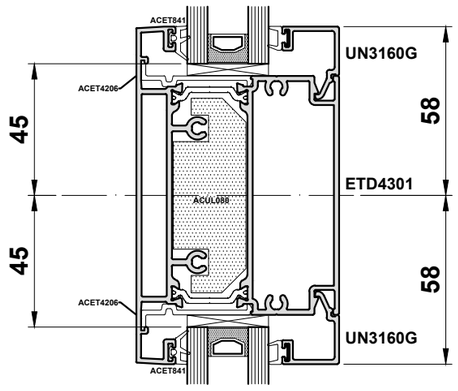
Accessories		
ACCY6035S3	1	Euro Cylinder
**	**	Handles
ACSH038N	2 x W - 115	Woolpile
ACET060	4	Screw for ACET4195
ACET060	16	Screw for Lock
ACET066	2 x W - 100 / 300	Fixing Screw for ETD496
ACET234	1 x W	Flipper Gasket
ACET4195	Pair	ETD495 End Cap
ACET4196	Pair	ETD496 End Cap
ACET4204	4	Sash Cleat
ACET4206	10	Bridge Packers
ACET475	2	Run Up Block
ACET841	2 x W & 2 x H	E Gasket
ACIM062	12	Screw for ACUL250
ACSH038N	2 x W	Brush Pile
ACUL077	W & 2 x H	Outer Frame Foam
ACUL078	2 x W & 2 x H	Sash Foam
ACUL210A	2	Outer Frame Cleat
ACUL210B	2	Outer Frame Cleat
ACUL224	4	Sash Cleat
ACUL250	3	Hinge
ACUL295	2	Low Threshold Bracket
ACUN3035	2 x W & 4 x H	Flipper Gasket
ACUN3512	9	Screw for ACUL250
ACVL059 / ACVL072	1 Pair	VL72 End Cap
ACVL061	W/300 + 2	VL72 Rivet

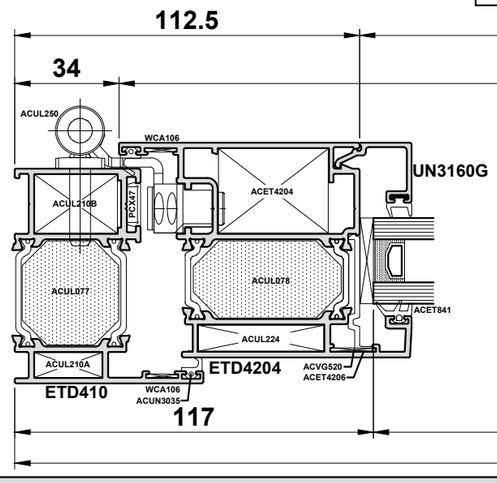
WCA106	10	Chevrons
*	1	Primary Lock

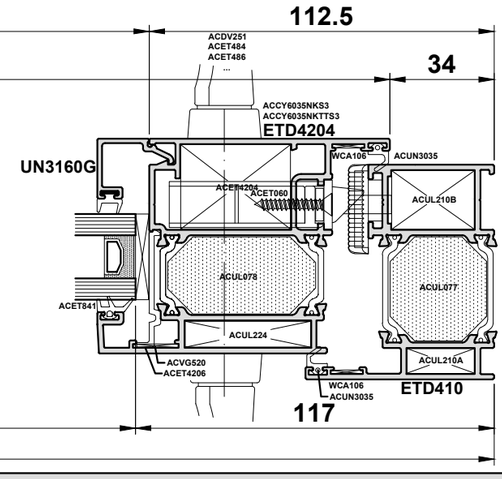
*See Page E20 for lock options.
**See B & E for handle options.

Midrail Accessories		
ACET841	2 x W	E Gasket
ACUL080	W	ETD4301 Foam
ACUN3512	4	Screws
ACET4206	4	Bridge Packers





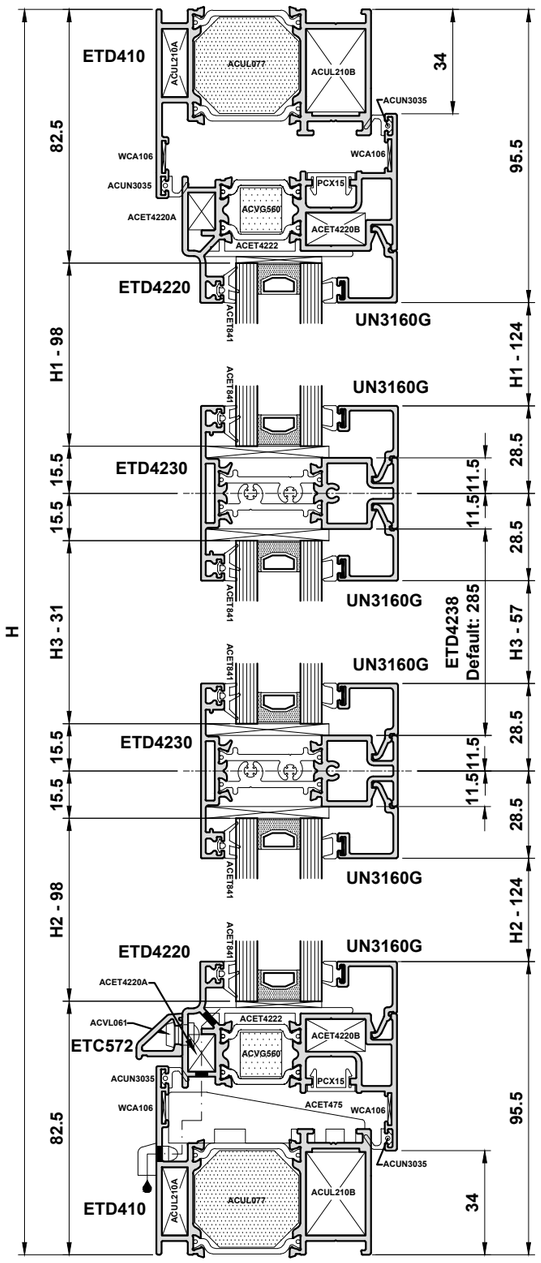




Do Not Scale From This Drawing

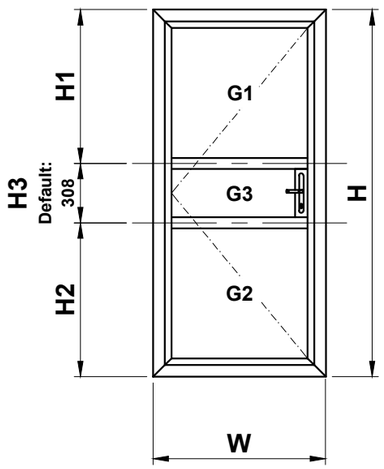
Alitherm 400 Stepped Door

Open In Heritage Single Door Full Frame Quick-Glaze Bead



Profile Cutting Schedule			
ETD410	2		W
ETD410	2		H
ETD4220	2		W - 68
ETD4220	2		H - 68
UN3160G	4		W - 157
UN3160G	2		W - 220.5
UN3160G	2		H1 - 124
UN3160G	2		H2 - 124
UN3160G	2		H3 - 57
ETD4230	2		W - 157
ETD4238	1		285
PCX15	2		H - 106
PCX15	2		W - 106
PCX47	2		H - 82
PCX47	2		W - 82
ETC572	1		W - 144

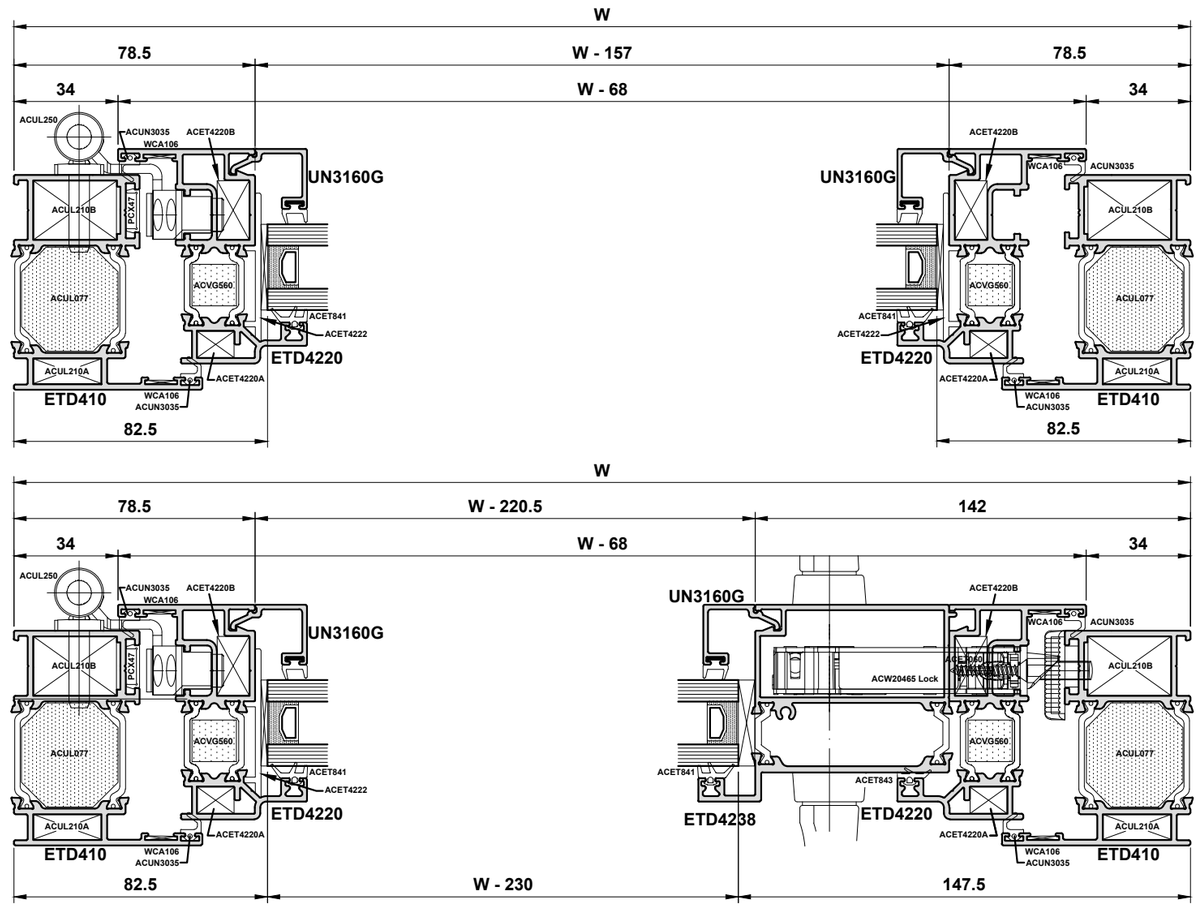
Glass Sizes		
G1	H1 - 98	W - 165
G2	H2 - 98	W - 165
G3	H3 - 31	W - 230



Accessories		
ACUL210A	4	Outerframe Cleat
ACUL210B	4	Outerframe Cleat
ACET4220A	4	Sash Cleat
ACET4220B	4	Sash Cleat
ACET4222	7	Bridge Packers
WCA106	8	Chevrons
ACUN3035	4W + 4H	Flipper Gasket
ACUL077	2W + 2H	Outerframe Foam
ACVG560	2W + 2H	Sash Foam
ACET843	1 @ 385mm	Lock Box E Gakset
E Gasket	6W + 2H	Glazing Gasket

ACET475	2	Run Up Block
ACET062	4	Transom Screws
ACET066	6	Transom Screws
ACVL061	W/300 + 2	Pop Rivets
ACET572	1 Pair	Drip End Cap
ACUL250	3	Hinges
ACUN3512	9	Hinge Screw
ACUN3577	12	Hinge Screw
ACET131	2	Drainage Cap
ACW20465	1	Lock
ACW20066 L/R	1	Center Keep

ACW20367	4	Keep
ACUN3544	16	Screw For Lock
Page E50	1	Euro Cylinder
Page E50	1	Handles

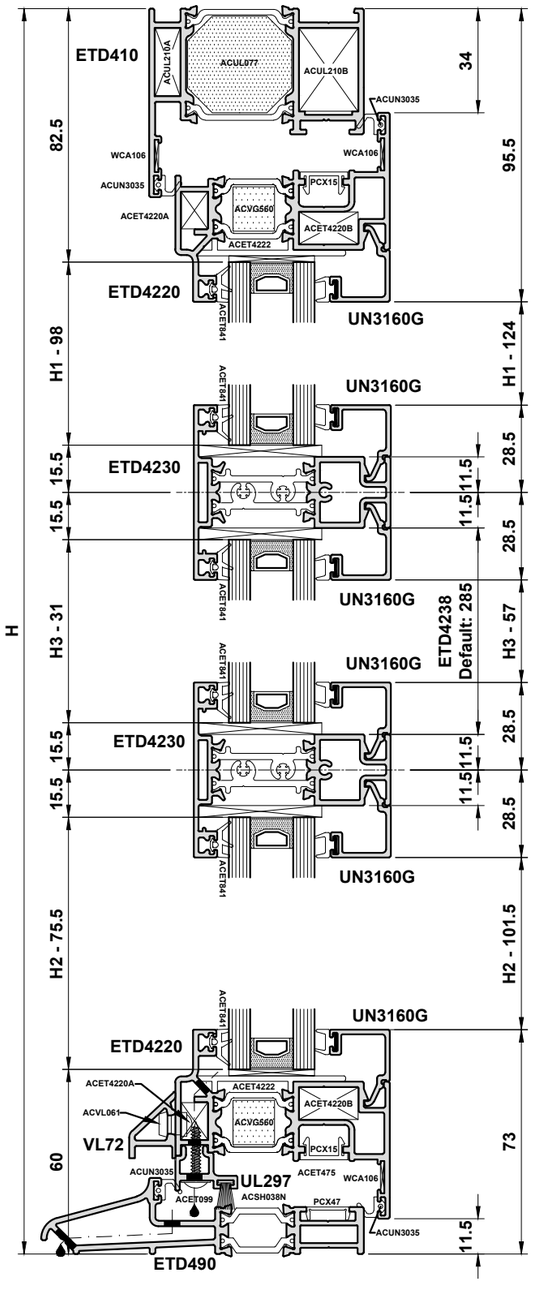


Do Not Scale From This Drawing

Alitherm 400 Stepped Door

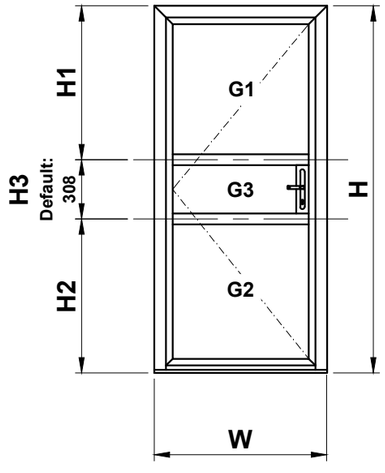
SAWING TABLES : OPEN IN

Open In Heritage Single Door Low Rebate Quick-Glaze Bead



Profile Cutting Schedule			
ETD410	1		W
ETD410	Pair		H-15.5
ETD490	1		W
ETD4220	2		W - 68
ETD4220	2		H - 45.5
UL297	1		W - 113
UN3160G	4		W - 157
UN3160G	2		W - 220.5
UN3160G	2		H1 - 124
UN3160G	2		H2 - 101.5
UN3160G	2		H3 - 57
ETD4230	2		W - 157
ETD4238	1		285
PCX15	2		H - 83.5
PCX15	2		W - 106
PCX47	2		H - 56.5
PCX47	2		W - 82
VL72	1		W - 144

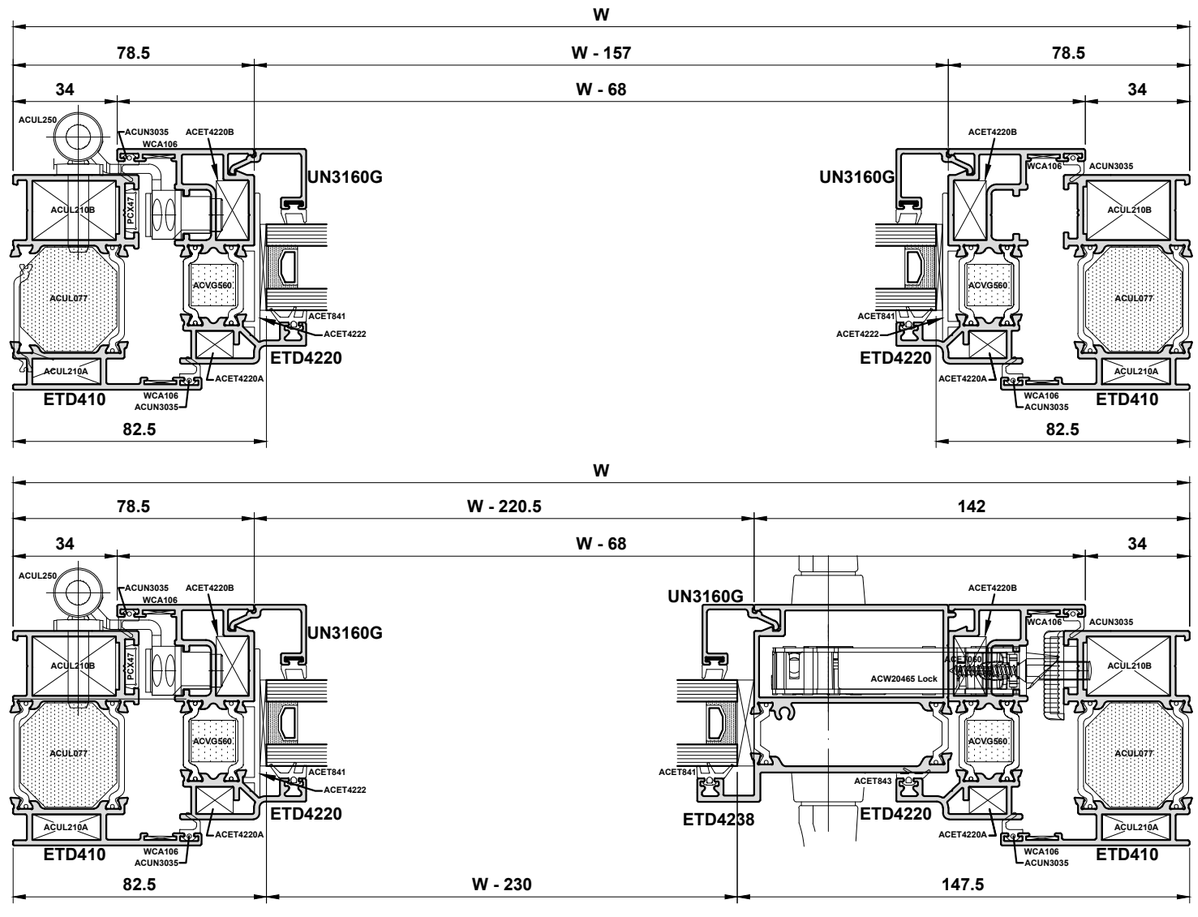
Glass Sizes		
G1	H1 - 98	W - 165
G2	H2 - 75.5	W - 165
G3	H3 - 31	W - 230



Accessories		
ACUL210A	2	Outerframe Cleat
ACUL210B	2	Outerframe Cleat
ACUL025	2	Anti-Twist Clip
ACUL295	2	Low Threshold Bracket
ACMX852	2	M6 x 16 Screw
ACET060	4	Screw For End Cap
ACET099	W - 100 / 300	Screw For UL297
ACET4190	Pair	ETD490 End Cap
ACET4197	Pair	UL297 End Cap
ACET4220A	4	Sash Cleat
ACET4220B	4	Sash Cleat

ACET4222	7	Bridge Packers
WCA106	6	Chevrons
ACUN3035	4W + 4H	Flipper Gasket
ACUL077	1W + 2H	Outerframe Foam
ACVG560	2W + 2H	Sash Foam
ACET843	1 @ 385mm	Lock Box E Gakset
E Gasket	6W + 2H	Glazing Gasket
ACSH038N	W - 113	Woolpile
ACET062	4	Transom Screws
ACET066	6	Transom Screws
ACVL061	W/300 + 2	Pop Rivets

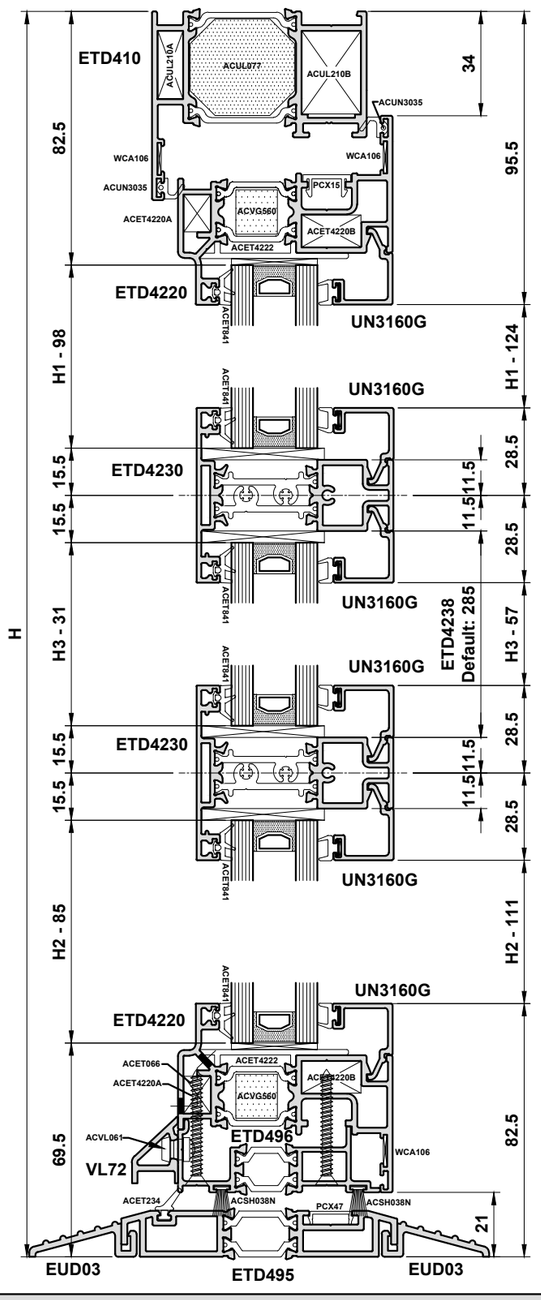
ACVL059	1 pair	Drip End Cap
ACUL250	3	Hinges
ACUN3512	9	Hinge Screw
ACUN3577	12	Hinge Screw
ACET131	2	Drainage Cap
ACW20465	1	Lock
ACW20066 L/R	1	Center Keep
ACW20367	4	Keep
ACUN3544	16	Screw For Lock
Page E50	1	Euro Cylinder
Page E50	1	Handles



Do Not Scale From This Drawing

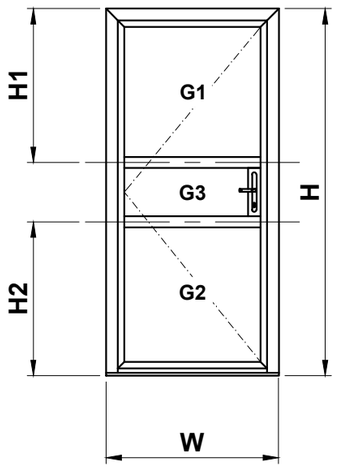
ISSUED: JULY 2026

Open In Heritage Single Door Low Ramp Quick-Glaze Bead



Profile Cutting Schedule			
ETD410	1		W
ETD410	Pair		H - 15
ETD495	1		W
EUD03	2		W
ETD4220	2		W - 68
ETD4220	2		H - 55
ETD496	1		W - 115
UN3160G	4		W - 157
UN3160G	2		W - 220.5
UN3160G	2		H1 - 124
UN3160G	2		H2 - 111
UN3160G	2		H3 - 57
ETD4230	2		W - 157
ETD4238	1		285
PCX15	2		H - 84
PCX15	2		W - 106
PCX47	2		H - 57
PCX47	2		W - 82
VL72	1		W - 144

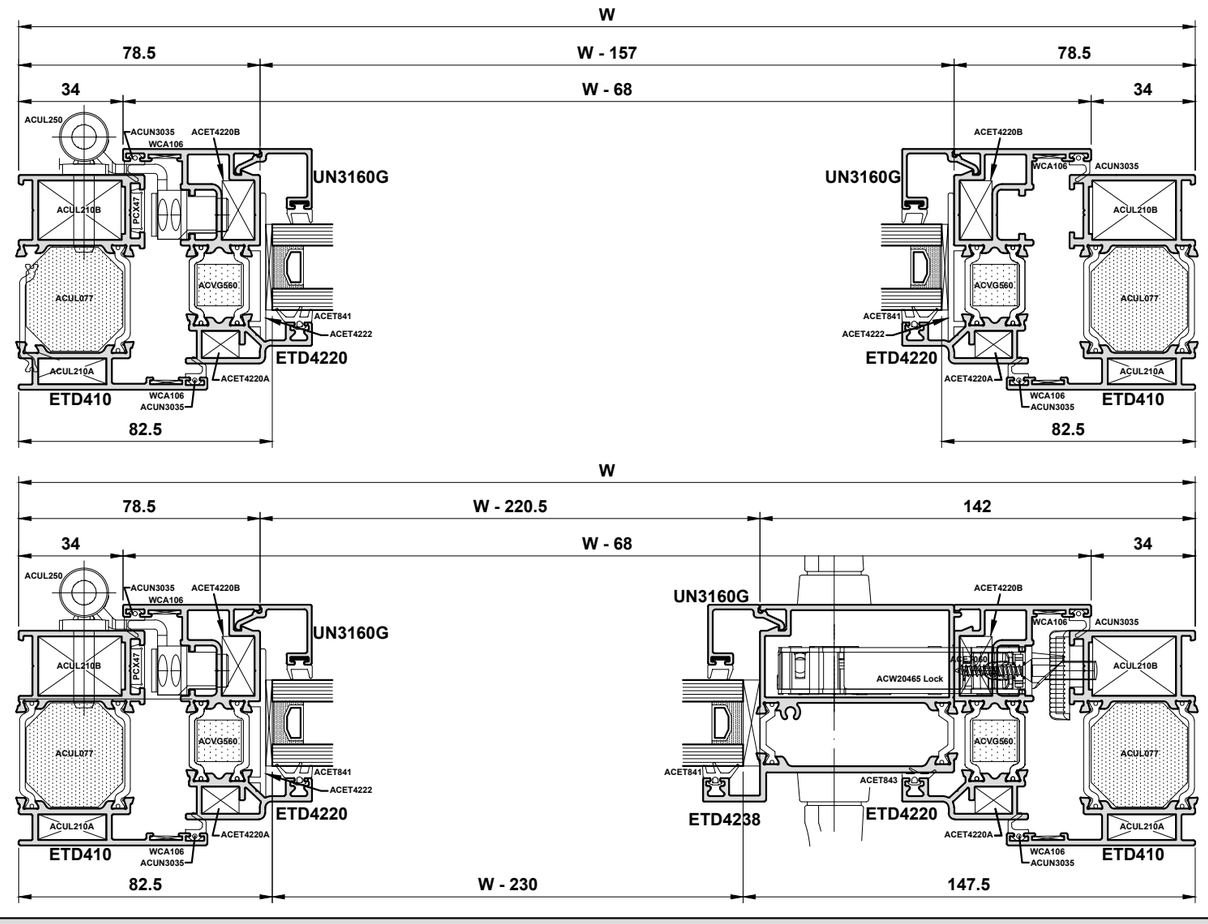
Glass Sizes		
G1	H1 - 98	W - 165
G2	H2 - 85	W - 165
G3	H3 - 31	W - 230



Accessories		
ACUL210A	2	Outerframe Cleat
ACUL210B	2	Outerframe Cleat
ACUL295	2	Low Threshold Bracket
ACMX852	2	M6 x 16 Screw
ACET060	4	Screw For End Cap
ACET4196	Pair	ETD496 End Cap
ACET066	2x W - 100 / 300	Fixing Screw for ETD496
ACET4195	Pair	ETD495 End Cap
ACET4220A	4	Sash Cleat
ACET4220B	4	Sash Cleat
ACET4222	7	Bridge Packers

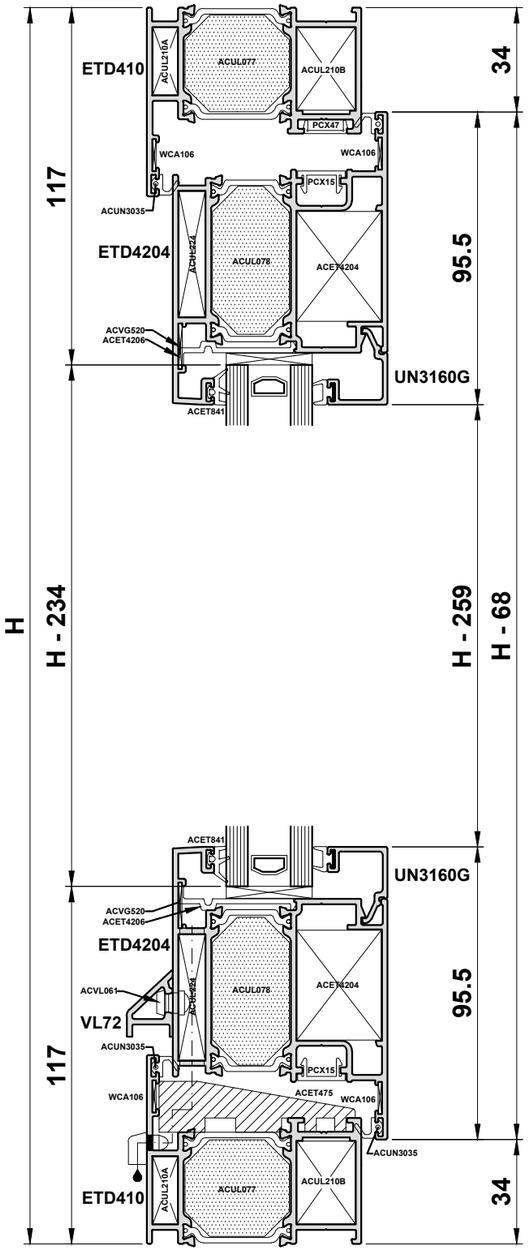
WCA106	6	Chevrons
ACUN3035	4W + 4H	Flipper Gasket
ACUL077	1W + 2H	Outerframe Foam
ACVG560	2W + 2H	Sash Foam
ACET843	1 @ 385mm	Lock Box E Gakset
E Gasket	6W + 2H	Glazing Gasket
ACSH038N	2 x W	Woolpile
ACET234	W	Flipper Gasket
ACET062	4	Transom Screws
ACET066	6	Transom Screws
ACVL061	W/300 + 2	Pop Rivets

ACVL059	1 pair	Drip End Cap
ACUL250	3	Hinges
ACUN3512	9	Hinge Screw
ACUN3577	12	Hinge Screw
ACET131	2	Drainage Cap
ACW20465	1	Lock
ACW20066 L/R	1	Center Keep
ACW20367	4	Keep
ACUN3544	16	Screw For Lock
Page E50	1	Euro Cylinder
Page E50	1	Handles



Do Not Scale From This Drawing

Open In Double Door Lift Lever Full Frame Quick-Glaze Bead



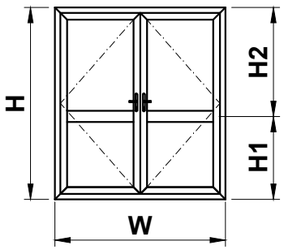
Profile Cutting Schedule				
ETD410	2			W
ETD410	2			H
ETD4204	2			W / 2 - 36.5
ETD4204	2			H - 68
ETD447	1			H - 110
UN3160G	4			H - 259
UN3160G	4			W / 2 - 152.5
PCX15	4			H - 106
PCX15	4			W / 2 - 74
PCX47	2			H - 56.5
PCX47	1			H - 110
PCX47	2			W - 82
VL72	2			W / 2 - 112.5
MIDRAIL ETD4302	2			W/2 - 152.5
UN3160G	4			W/2 - 152.5
UN3160G	2			H1 - 187.5
UN3160G	2			H2 - 187.5

Glass Sizes		
Without ETD4301	H - 234	W / 2 - 202.5
Top Glass With ETD4301	H2 - 162	W / 2 - 202.5
Bottom Glass With ETD4301	H1 - 162	W / 2 - 202.5

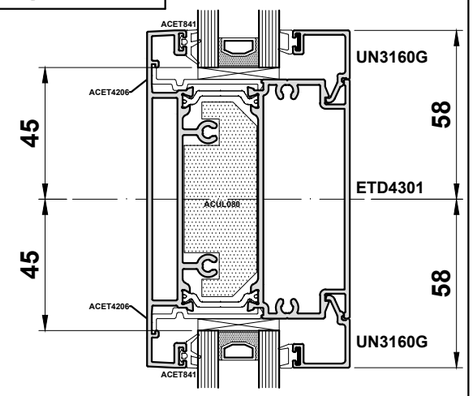
Accessories		
ACCY6035S3	2	Euro Cylinder
ACDV251	2 Pair	Handles
ACDV737	2	Bottom Shootbolt
ACDV738	2	Top Shootbolt
ACET060	40	Screw for Lock & Keep
ACET060	8	Screw for ACDV737/738
ACET131	4	Drainage Cap
ACET4147	Pair	ETD447 End Cap
ACET4204	8	Sash Cleat
ACET4206	20	Bridge Packers
ACET475	4	Run Up Block
ACET841	4 x W / 2 & 4 x H	E Gasket
ACIM062	24	Screw for ACUL250
ACUL076	H - 110	Floating Mullion Foam
ACUL077	2 x W & 2 x H	Outer Frame Foam
ACUL078	4 x W / 2 & 4 x H	Sash Foam
ACUL210A	4	Outer Frame Cleat
ACUL210B	4	Outer Frame Cleat
ACUL224	8	Sash Cleat
ACUL250	6	Hinge
ACUL276	1	Secondary Lock
ACUL277/8	1	Double Door Primary Lock
ACUL279	1	Double Door Keep Kit

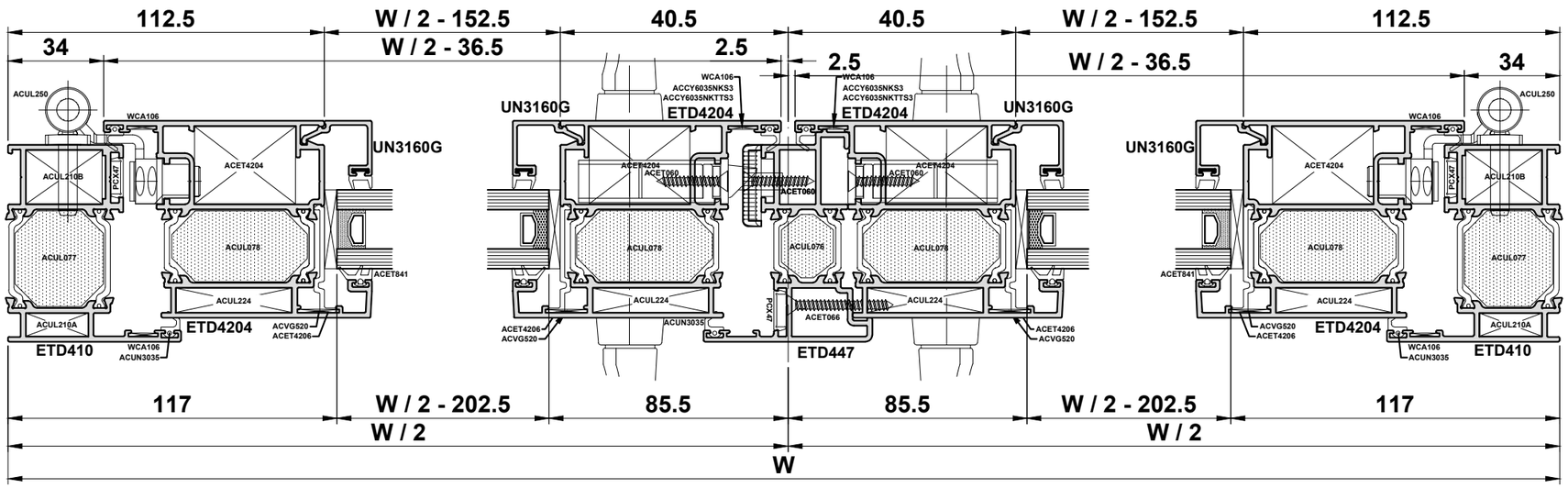
ACUN3035	4 x W & 7 x H	Flipper Gasket
ACUN3512	18	Screw for ACUL250
ACUN3513	2 + H / 300	Screw for ETD447
ACVL072	2 Pairs	VL72 End Cap
ACVL061	W/300 + 2	VL72 Rivet
WCA106	20	Chevrons

*See Page E20 for lock options.
**See B & E for handle options.



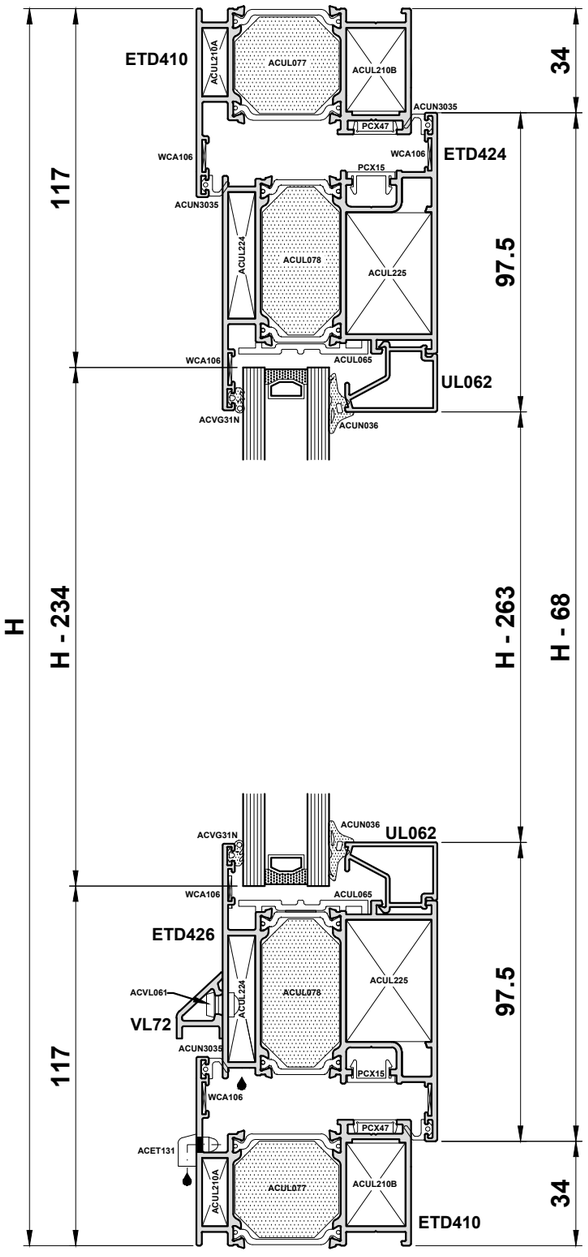
Midrail Accessories		
ACET841	2 x W	E Gasket
ACUL080	W	ETD4301 Foam
ACUN3512	4	Screws
ACET4206	4	Bridge Packers





Do Not Scale From This Drawing

Open In Double Door Lift Lever Full Frame

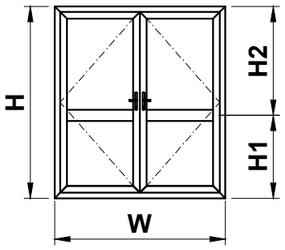


Profile Cutting Schedule			
ETD410	2		W
ETD410	2		H
ETD424	4		W / 2 - 36.5
ETD424	4		H - 68
ETD447	1		H - 110
BEAD	4		H - 263
BEAD	4		W / 2 - 193.5
PCX15	4		H - 106
PCX15	4		W / 2 - 74
PCX47	2		H - 56.5
PCX47	1		H - 110
PCX47	2		W - 82
VL72	2		W / 2 - 112.5
MIDRAIL	ETD430	2	W / 2 - 193.5
	BEAD	8	W / 2 - 193.5
	BEAD	4	H2 - 190
	BEAD	4	H1 - 190

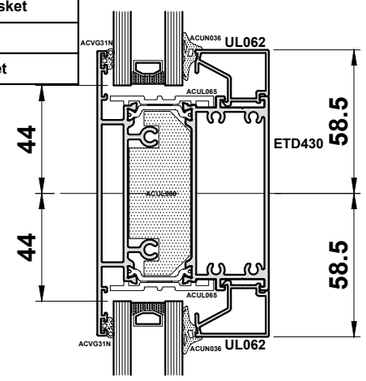
Glass Sizes		
Without ETD430	H - 234	W / 2 - 202.5
Top Glass With ETD430	H2 - 161	W / 2 - 202.5
Bottom Glass With ETD430	H1 - 161	W / 2 - 202.5

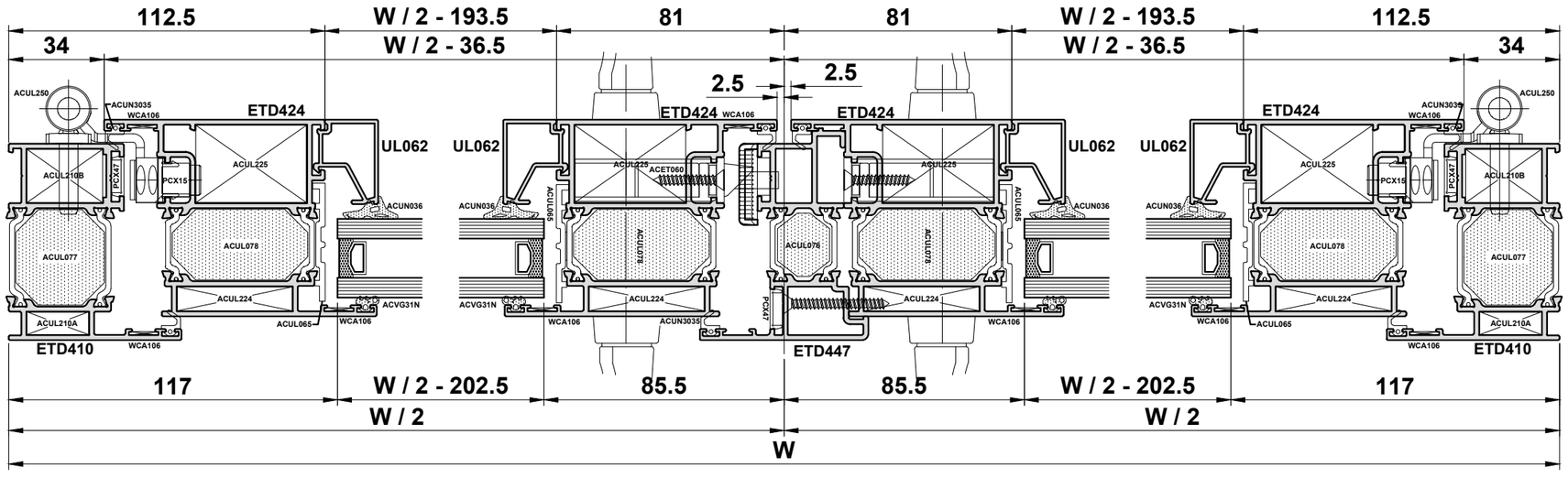
Accessories		
ACCY6035S3	2	Euro Cylinder
ACDV251	2 Pair	Handles
ACDV737	2	Bottom Shootbolt
ACDV738	2	Top Shootbolt
ACET060	40	Screw for Lock & Keep
ACET060	8	Screw for ACDV737/738
ACET131	4	Drainage Cap
ACET4147	Pair	ETD447 End Cap
ACET475	4	Run Up Block
ACIM062	24	Screw for ACUL250
ACUL065	20	Bridge Packers
ACUL076	H - 110	Floating Mullion Foam
ACUL077	2 x W & 2 x H	Outer Frame Foam
ACUL078	4 x W / 2 & 4 x H	Sash Foam
ACUL210A	4	Outer Frame Cleat
ACUL210B	4	Outer Frame Cleat
ACUL224	8	Sash Cleat
ACUL225	8	Sash Cleat
ACUL250	6	Hinge
ACUL276	1	Secondary Lock
ACUL277/8	1	Double Door Primary Lock
ACUL279	1	Double Door Keep Kit
ACUN036	4 x W / 2 & 4 x H	Wedge Gasket
ACUN3035	4 x W & 7 x H	Flipper Gasket

ACUN3512	18	Screw for ACUL250
ACUN3513	2 + H / 300	Screw for ETD447
ACVG31N	4 x W / 2 & 4 x H	E Gasket
ACVL072	2 Pairs	VL72 End Cap
ACVL061	W/300 + 2	VL72 Rivet
WCA106	20	Chevrons



Midrail Accessories		
ACUL080	2 x W / 2	ETD430 Foam
ACUL065	8	Bridge Packer
ACUL025	8	Anti-Twist Clip
ACUL299	2	Bracket
ACUN036	4 x W / 2	Wedge Gasket
ACUN3512	4	Screw
ACVG31N	4 x W / 2	E Gasket

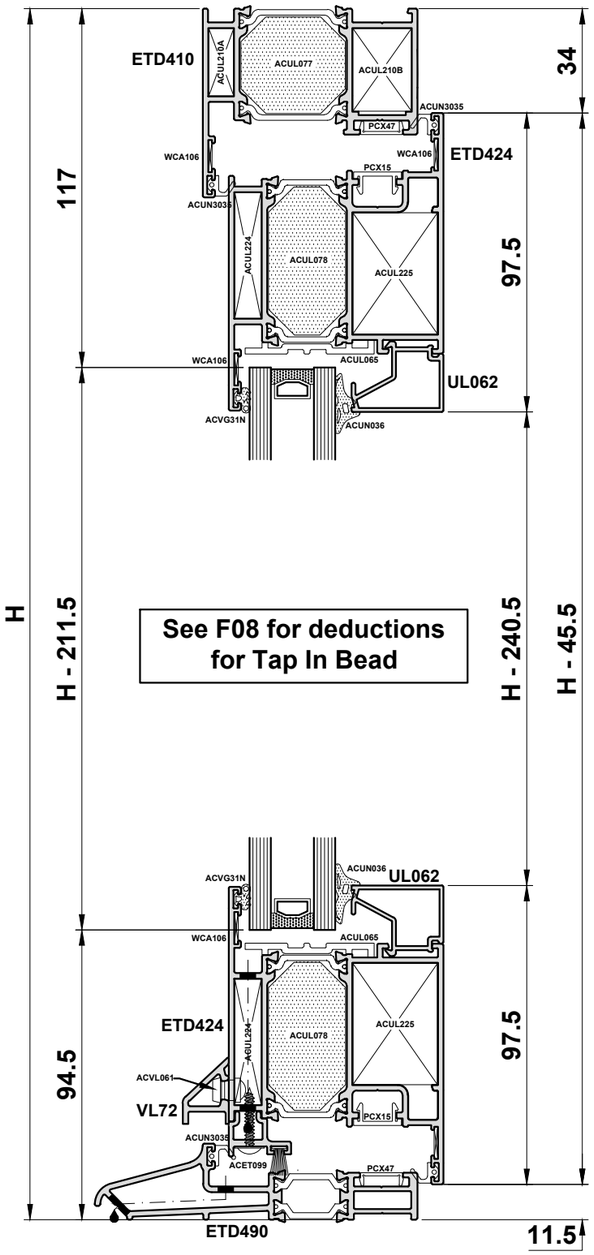




Do Not Scale From This Drawing

Alitherm 400 Stepped Door

Open In Double Door ETD490 Lift Lever Low Rebate Threshold



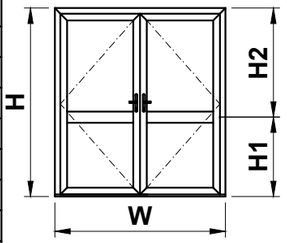
See F08 for deductions for Tap In Bead

Profile Cutting Schedule			
ETD410	1		W
ETD410	2		H - 15.5
ETD490	1		W
ETD424	4		W / 2 - 36.5
ETD424	4		H - 45.5
ETD447	1		H - 81
UL297	2		W / 2 - 79.5
BEAD	4		H - 240.5
BEAD	4		W / 2 - 193.5
PCX15	4		H - 106
PCX15	4		W / 2 - 74
PCX47	2		H - 56.5
PCX47	1		H - 81
PCX47	2		W - 82
VL72	2		W / 2 - 112.5
MIDRAIL	ETD430	2	W / 2 - 193.5
	BEAD	8	W / 2 - 193.5
	BEAD	4	H1 - 167.5
	BEAD	4	H2 - 190

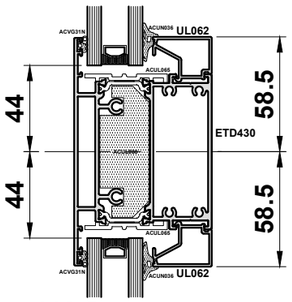
Glass Sizes		
Without ETD430	H - 211.5	W / 2 - 202.5
Top Glass With ETD430	H2 - 161	W / 2 - 202.5
Bottom Glass With ETD430	H1 - 138.5	W / 2 - 202.5

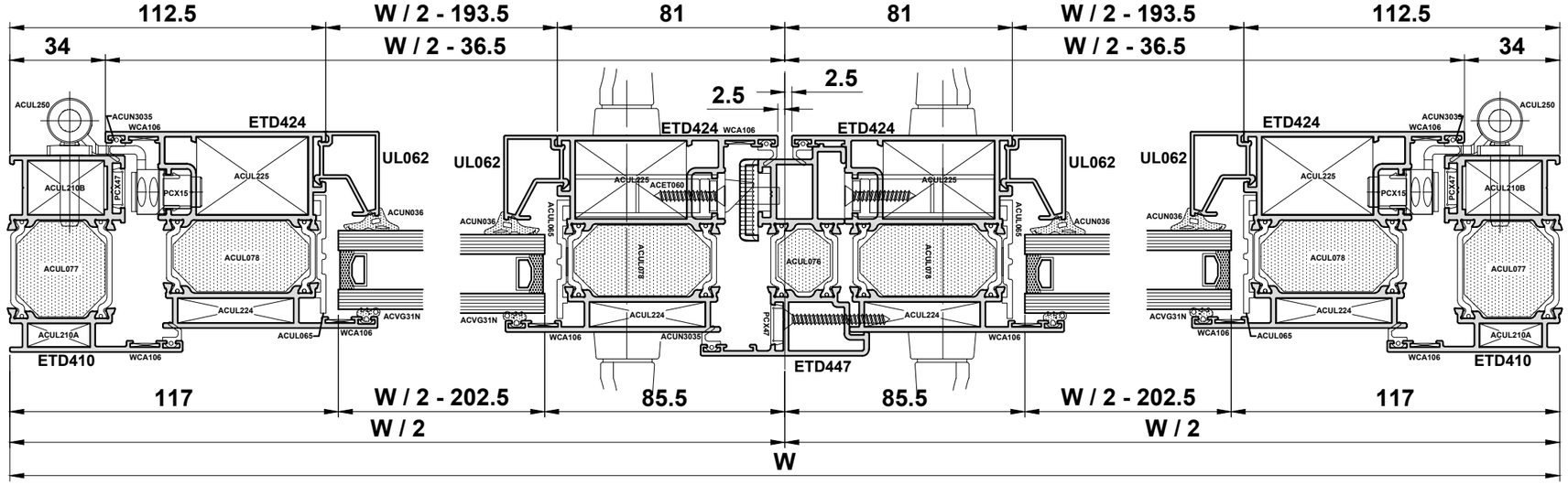
Accessories		
ACCY6035S3	2	Euro Cylinder
ACDV251	2 Pairs	Handles
ACDV737	2	Bottom Shootbolt
ACDV738	2	Top Shootbolt
ACET060	4	Screw for ACET4190
ACET060	40	Screw for Lock & Keep
ACET060	8	Screw for ACDV737/738
ACET099	W - 100 / 300	Fixing Screw for UL297
ACET4146	Pair	ETD447 End Cap at Cill
ACET4147	Pair	ETD447 End Cap at Head
ACET4190	Pair	ETD490 End Cap
ACET4197	2 Pairs	UL297 End Cap
ACET475	4	Run Up Block
ACIM062	24	Screw for ACUL250
ACSH038N	1 x W	Woolpile
ACUL025	2	Anti-Twist Clip
ACUL065	20	Bridge Packers
ACUL076	H - 81	Floating Mullion Foam
ACUL077	W & 2 x H	Outer Frame Foam
ACUL078	4 x W / 2 & 4 x H	Sash Foam
ACUL210A	2	Outer Frame Cleat
ACUL210B	2	Outer Frame Cleat
ACUL224	8	Sash Cleat
ACUL225	8	Sash Cleat

ACUL250	6	Hinge
ACUL276	1	Secondary Lock
ACUL277/8	1	Double Door Primary Lock
ACUL279	1	Double Door Keep Kit
ACUL295	2	Low Threshold Bracket
ACUN036	4 x W / 2 & 4 x H	Wedge Gasket
ACUN3035	4 W & 7 x H	Flipper Gasket
ACUN3512	18	Screw for ACUL250
ACUN3513	2 + H / 300	Screw for ETD447
ACVG31N	4 x W / 2 & 4 x H	E Gasket
ACVL072	2 Pair	VL72 End Cap
ACVL061	W/300 + 2	VL72 Rivet
WCA106	18	Chevrons



Midrail Accessories		
ACUL080	2 x W / 2	ETD430 Foam
ACUL065	8	Bridge Packer
ACUL025	8	Anti-Twist Clip
ACUL299	2	Bracket
ACUN036	4 x W / 2	Wedge Gasket
ACUN3512	4	Screw
ACVG31N	4 x W / 2	E Gasket





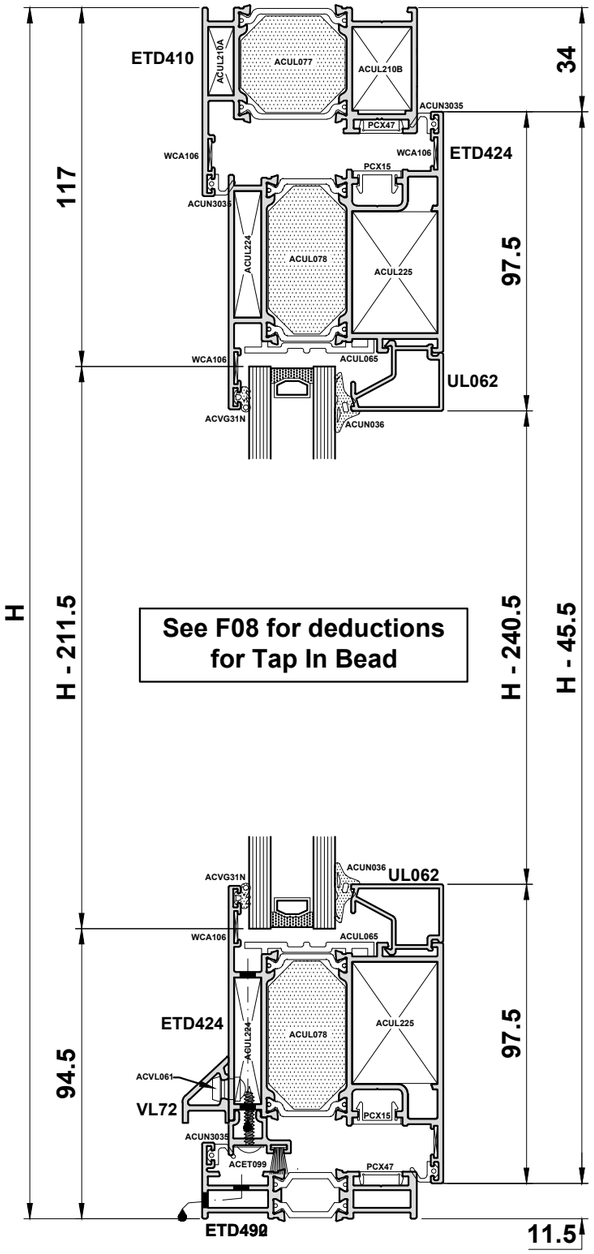
Do Not Scale From This Drawing

smart architectural aluminium

Alitherm 400 Stepped Door

SAWING TABLES : OPEN IN

Open In Double Door ETD492 Lift Lever Low Rebate Threshold

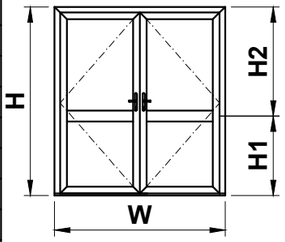


See F08 for deductions for Tap In Bead

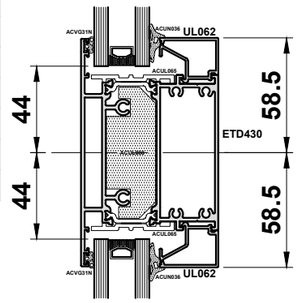
Profile Cutting Schedule				
ETD410	1			W
ETD410	2			H - 15.5
ETD490	1			W
ETD424	4			W / 2 - 36.5
ETD424	4			H - 45.5
ETD447	1			H - 81
UL297	2			W / 2 - 79.5
BEAD	4			H - 240.5
BEAD	4			W / 2 - 193.5
PCX15	4			H - 106
PCX15	4			W / 2 - 74
PCX47	2			H - 56.5
PCX47	1			H - 81
PCX47	2			W - 82
VL72	2			W / 2 - 112.5
MIDRAIL	ETD430	2		W / 2 - 193.5
	BEAD	8		W / 2 - 193.5
	BEAD	4		H1 - 167.5
	BEAD	4		H2 - 190

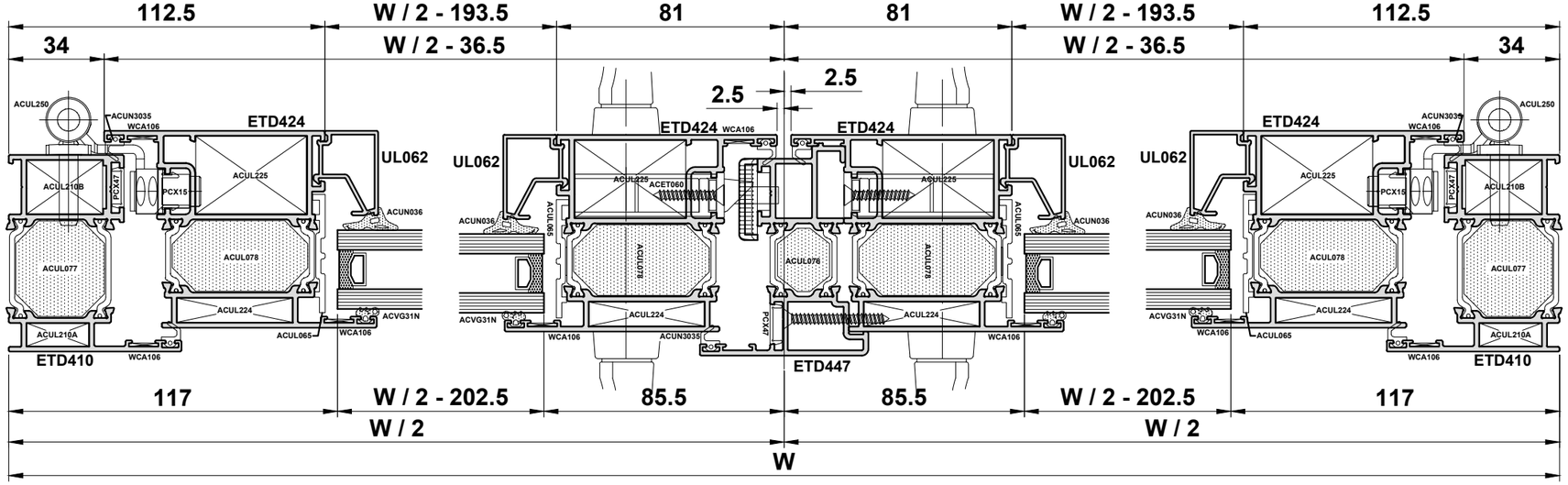
Glass Sizes		
Without ETD430	H - 211.5	W / 2 - 202.5
Top Glass With ETD430	H2 - 161	W / 2 - 202.5
Bottom Glass With ETD430	H1 - 138.5	W / 2 - 202.5

Accessories		
ACCY6035S3	2	Euro Cylinder
ACDV251	2 Pairs	Handles
ACDV737	2	Bottom Shootbolt
ACDV738	2	Top Shootbolt
ACET060	4	Screw for ACET4190
ACET060	40	Screw for Lock & Keep
ACET060	8	Screw for ACDV737/738
ACET099	W - 100 / 300	Fixing Screw for UL297
ACET4146	Pair	ETD447 End Cap at Cill
ACET4147	Pair	ETD447 End Cap at Head
ACET4192	Pair	ETD492 End Cap
ACET4197	2 Pairs	UL297 End Cap
ACET475	4	Run Up Block
ACIM062	24	Screw for ACUL250
ACSH038N	1 x W	Woolpile
ACUL025	2	Anti-Twist Clip
ACUL065	20	Bridge Packers
ACUL076	H - 81	Floating Mullion Foam
ACUL077	W & 2 x H	Outer Frame Foam
ACUL078	4 x W / 2 & 4 x H	Sash Foam
ACUL210A	2	Outer Frame Cleat
ACUL210B	2	Outer Frame Cleat
ACUL224	8	Sash Cleat
ACUL225	8	Sash Cleat
ACUL250	6	Hinge
ACUL276	1	Secondary Lock
ACUL277/8	1	Double Door Primary Lock
ACUL279	1	Double Door Keep Kit
ACUL295	2	Low Threshold Bracket
ACUN036	4 x W / 2 & 4 x H	Wedge Gasket
ACUN3035	4 W & 7 x H	Flipper Gasket
ACUN3512	18	Screw for ACUL250
ACUN3513	2 + H / 300	Screw for ETD447
ACVG31N	4 x W / 2 & 4 x H	E Gasket
ACVL072	2 Pair	VL72 End Cap
ACVL061	W/300 + 2	VL72 Rivet
WCA106	18	Chevrons



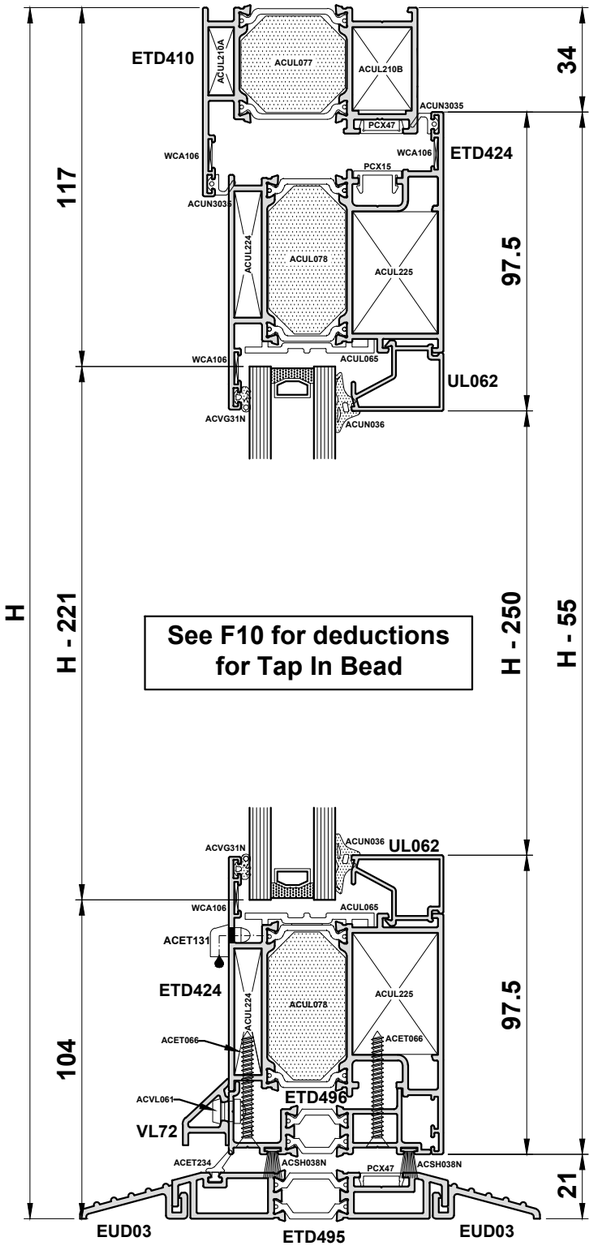
Midrail Accessories		
ACUL080	2 x W / 2	ETD430 Foam
ACUL065	8	Bridge Packer
ACUL025	8	Anti-Twist Clip
ACUL299	2	Bracket
ACUN036	4 x W / 2	Wedge Gasket
ACUN3512	4	Screw
ACVG31N	4 x W / 2	E Gasket





Do Not Scale From This Drawing

Open In Double Door Lift Lever Low Ramp Threshold

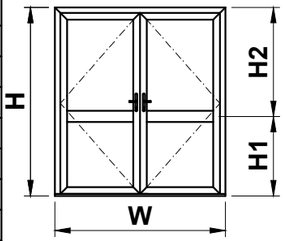


See F10 for deductions for Tap In Bead

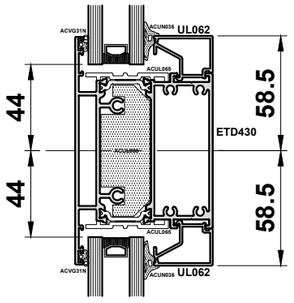
Profile Cutting Schedule			
ETD410	1		W
ETD410	2		H - 15
ETD495	1		W
EUD03	2		W
ETD424	4		W / 2 - 36.5
ETD424	4		H - 55
ETD496	2		W / 2 - 84.5
ETD447	1		H - 81
BEAD	4		H - 250
BEAD	4		W / 2 - 193.5
PCX15	4		H - 68
PCX15	4		W / 2 - 75
PCX47	2		H - 55
PCX47	1		H - 81
PCX47	2		W - 82
VL72	2		W / 2 - 112.5
MIDRAIL: ETD430	2		W / 2 - 193.5
MIDRAIL: BEAD	8		W / 2 - 193.5
MIDRAIL: BEAD	4		H1 - 177
MIDRAIL: BEAD	4		H2 - 190

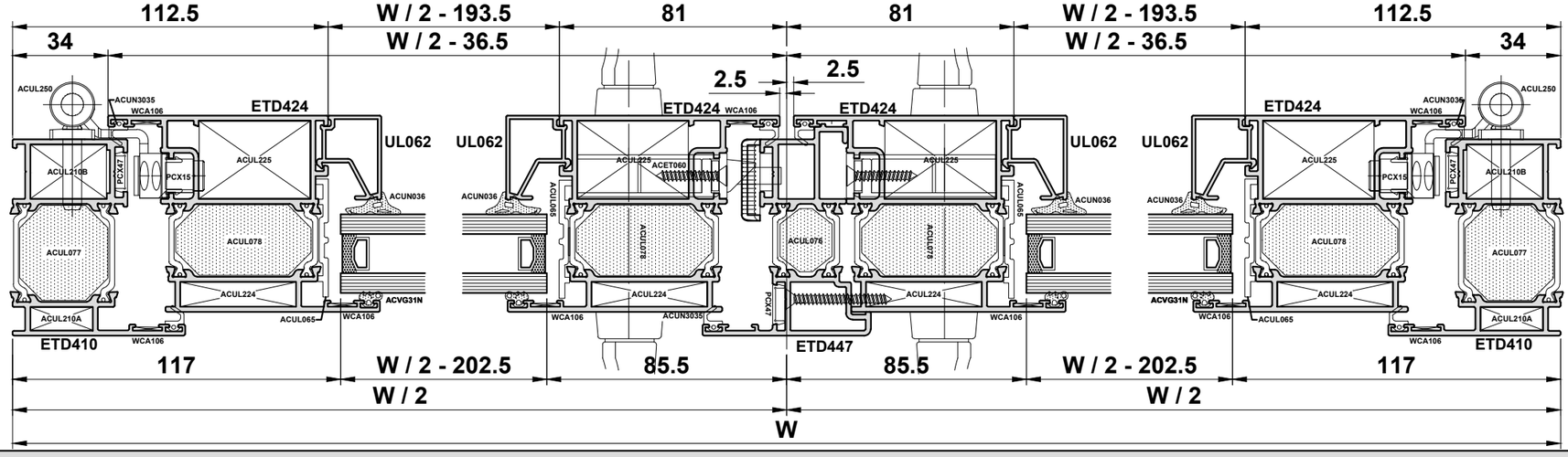
Glass Sizes		
Without ETD430	H - 221	W / 2 - 202.5
Top Glass With ETD430	H2 - 161	W / 2 - 202.5
Bottom Glass With ETD430	H1 - 148	W / 2 - 202.5

Accessories		
ACCY6035S3	2	Euro Cylinder
ACDV251	2 Pairs	Handles
ACDV737	2	Bottom Shootbolt
ACDV738	2	Top Shootbolt
ACET060	4	Fixing Screw for ACET4195
ACET060	40	Screw for Lock & Keep
ACET060	8	Screw for ACDV737/738
ACET066	2 x W - 100 / 300	Fixing Screw for ETD496
ACET234	1 x W	Flipper Gasket
ACET4142	Kit	ETD447/ETD496 End Cap
ACET4147	Pair	End Cap at Head
ACET4195	Pair	ETD495 End Cap
ACET4196	Pair	ETD496 End Cap
ACET475	4	Run Up Block
ACIM062	24	Screw for ACUL250
ACSH038N	2 x W	Woolpile
ACUL065	20	Bridge Packers
ACUL076	H - 81	Floating Mullion Foam
ACUL077	W & 2 x H	Outer Frame Foam
ACUL078	4 x W / 2 & 4 x H	Sash Foam
ACUL210A	2	Outer Frame Cleat
ACUL210B	2	Outer Frame Cleat
ACUL224	8	Sash Cleat
ACUL225	8	Sash Cleat
ACUL250	6	Hinge
ACUL276	1	Secondary Lock
ACUL277/8	1	Double Door Primary Lock
ACUL279	1	Double Door Keep Kit
ACUL295	2	Low Threshold Bracket
ACUN036	4 x W / 2 & 4 x H	Wedge Gasket
ACUN3035	4 x W & 7 x H	Flipper Gasket
ACUN3512	18	Screw for ACUL250
ACUN3513	2 + H / 300	Screw for ETD447
ACVG31N	4 x W / 2 & 4 x H	E Gasket
ACVL072	2 Pair	VL72 End Cap
ACVL061	W/300 + 2	VL72 Rivet
WCA106	18	Chevrons



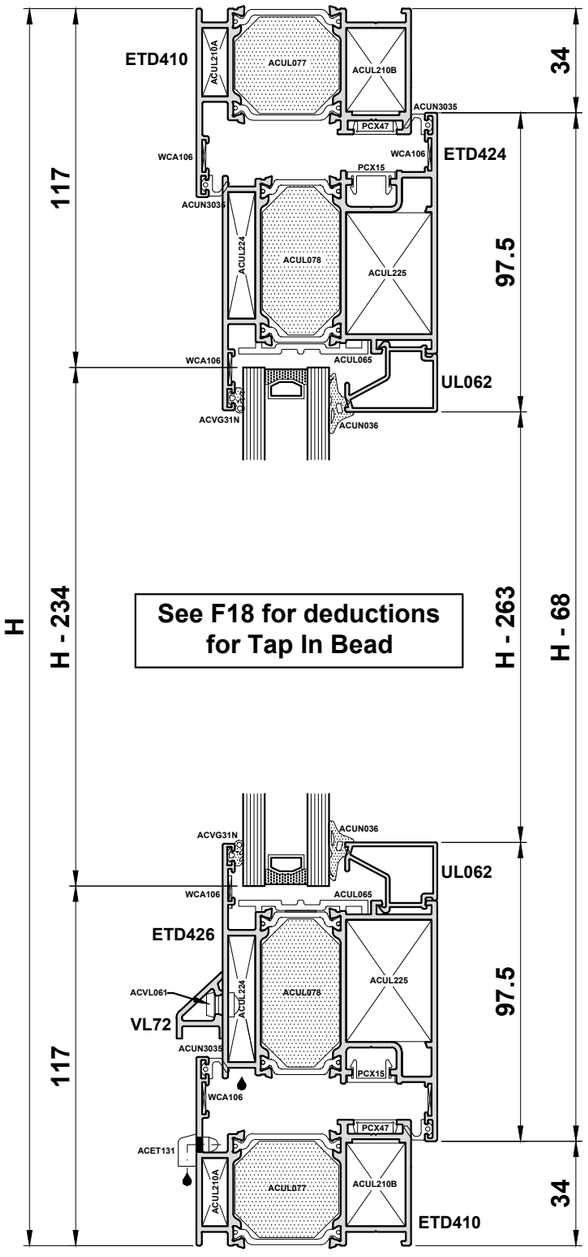
Midrail Accessories		
ACUL080	2 x W / 2	ETD430 Foam
ACUL065	8	Bridge Packer
ACUL025	8	Anti-Twist Clip
ACUL299	2	Bracket
ACUN036	4 x W / 2	Wedge Gasket
ACUN3512	4	Screw
ACVG31N	4 x W / 2	E Gasket





Do Not Scale From This Drawing

Open In Double Door Finger Bolt Full Frame

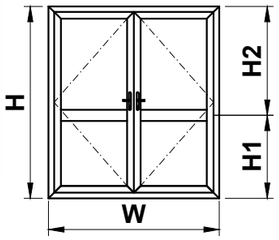


Profile Cutting Schedule			
ETD410	2		W
ETD410	2		H
ETD424	4		W / 2 - 40
ETD424	4		H - 68
ETD448	1		H - 110
BEAD	4		H - 263
BEAD	4		W / 2 - 197
PCX15	4		H - 106
PCX15	4		W / 2 - 58
PCX47	2		H - 82
PCX47	1		H - 110
PCX47	2		W / 2 - 82
VL72	2		W / 2 - 116
MIDRAIL	ETD430	1	W / 2 - 197
	BEAD	8	W / 2 - 197
	BEAD	4	H2 - 190
	BEAD	4	H1 - 190

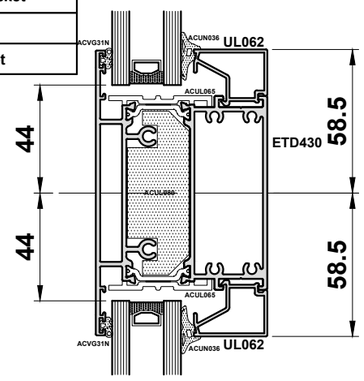
Glass Sizes		
Without ETD430	H - 234	W / 2 - 206
Top Glass With ETD430	H2 - 161	W / 2 - 206
Bottom Glass With ETD430	H1 - 161	W / 2 - 206

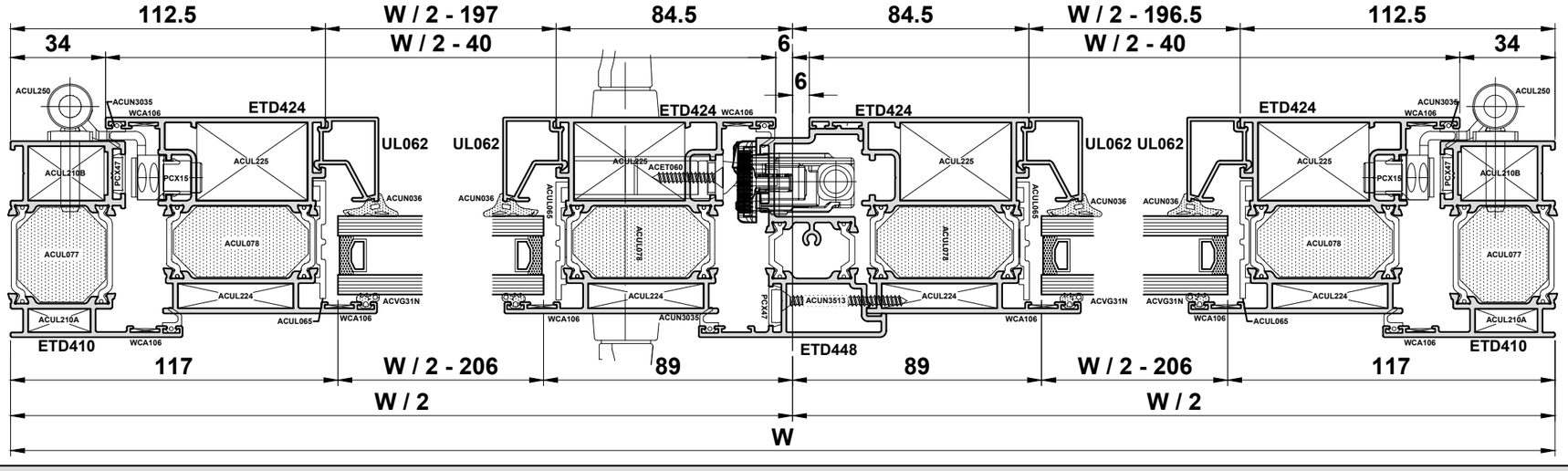
Accessories		
ACCY6035S3	1	Euro Cylinder
**	**	Handles
ACET060	16	Screw for Lock
ACET131	4	Drainage Cap
ACET4148	Pair	ETD448 End Cap
ACET475	4	Run Up Block
ACIM062	24	Screw for ACUL250
ACPD844	1	Shootbolt Adaptor
ACPD84..	2	10mm Dia Glavanised Rod
ACSM015	Pair	Escutcheon
ACUL065	20	Bridge Packers
ACUL076	H - 110	Floating Mullion Foam
ACUL077	2 x W & 2 x H	Outer Frame Foam
ACUL078	4 x W / 2 & 4 x H	Sash Foam
ACUL210A	4	Outer Frame Cleat
ACUL210B	4	Outer Frame Cleat
ACUL224	8	Sash Cleat
ACUL225	8	Sash Cleat
ACUL242	2	Finger Bolt Guide
ACUL250	6	Hinge
ACUL390	Pair	Finger Bolt Flat Keep
ACUN036	4 x W / 2 & 4 x H	Wedge Gasket
ACUN3035	4 x W & 6 x H	Flipper Gasket
ACUN3512	18	Screw for ACUL250
ACUN3513	2 + H / 300	Screw for ETD448
ACVG31N	4 x W / 2 & 4 x H	E Gasket
ACVL072	2 Pairs	VL72 End Cap
ACVL061	W/300 + 2	VL72 Rivet
WCA106	20	Chevron
*	1	Double Door Primary Lock

*See Page E20 for lock options.
**See B & E for handle options.



Midrail Accessories		
ACUL080	2 x W / 2	ETD430 Foam
ACUL065	8	Bridge Packer
ACUL025	8	Anti-Twist Clip
ACUL299	2	Bracket
ACUN036	4 x W / 2	Wedge Gasket
ACUN3512	4	Screw
ACVG31N	4 x W / 2	E Gasket

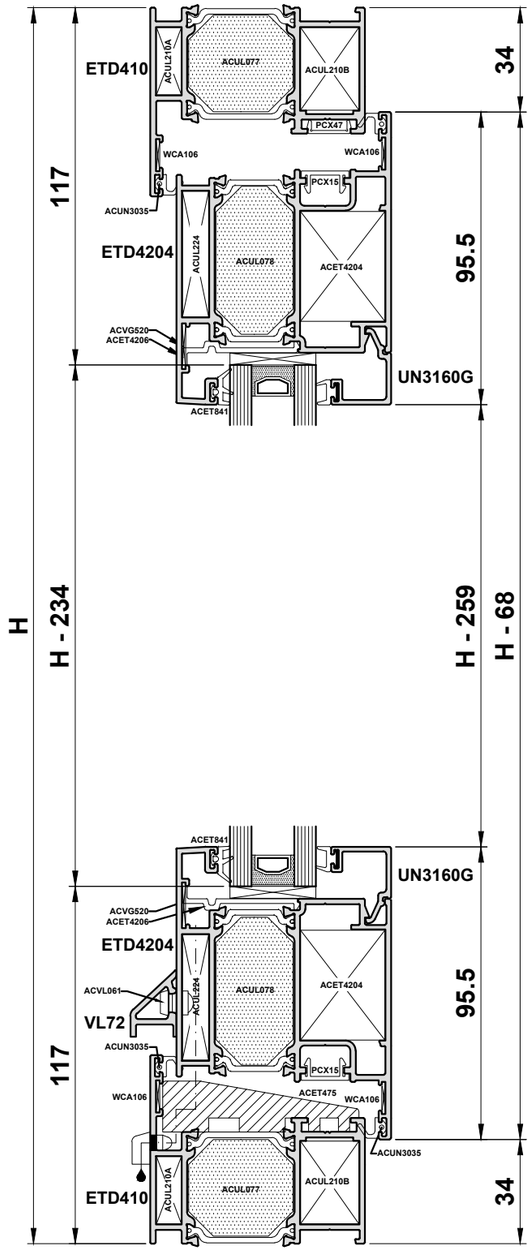




Do Not Scale From This Drawing

Alitherm 400 Stepped Door

Open In Double Door Finger Bolt Full Frame Quick-Glaze Bead



Profile Cutting Schedule				
ETD410	2			W
ETD410	2			H
ETD4204	4			W / 2 - 40
ETD4204	4			H - 68
ETD448	1			H - 110
UN3160G	4			H - 259
UN3160G	4			W / 2 - 197
PCX15	4			H - 106
PCX15	4			W / 2 - 58
PCX47	2			H - 82
PCX47	1			H - 110
PCX47	2			W - 82
VL72	2			W / 2 - 116
MIDRAIL	ETD4301	2		W / 2 - 197
	UN3160G	4		W / 2 - 197
	UN3160G	2		H1 - 187.5
	UN3160G	2		H2 - 187.5

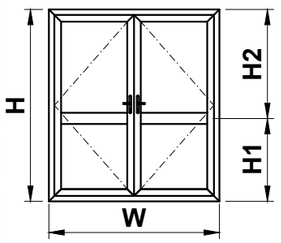
Glass Sizes		
Without ETD4301	H - 234	W / 2 - 206
Top Glass With ETD4301	H2 - 162	W / 2 - 206
Bottom Glass With ETD4301	H1 - 162	W / 2 - 206

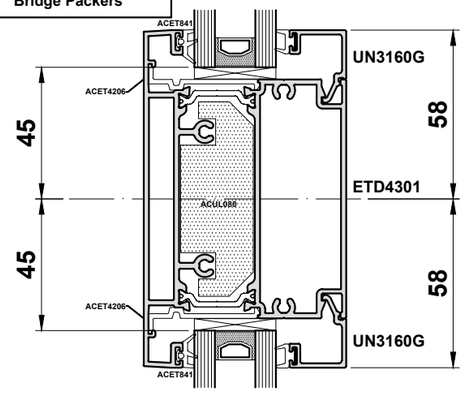
Accessories		
ACCY6035S3	1	Euro Cylinder
**	**	Handles
ACET060	16	Screw for Lock
ACET131	4	Drainage Cap
ACET4148	Pair	ETD448 End Cap
ACET4204	8	Sash Cleat
ACET4206	20	Bridge Packers
ACET475	4	Run Up Block
ACET841	4 x W / 2 & 4 x H	E Gasket
ACIM062	24	Screw for ACUL250
ACPD844	1	Shootbolt Adaptor
ACPD84..	2	10mm Dia Glavanised Rod
ACSM015	Pair	Escutcheon
ACUL077	2 x W & 2 x H	Outer Frame Foam
ACUL078	4 x W / 2 & 4 x H	Sash Foam
ACUL210A	4	Outer Frame Cleat
ACUL210B	4	Outer Frame Cleat
ACUL224	8	Sash Cleat
ACUL242	2	Finger Bolt Guide
ACUL250	6	Hinge
ACUL390	Pair	Finger Bolt Flat Keep
ACUN3035	4 x W & 6 x H	Flipper Gasket
ACUN3512	18	Screw for ACUL250
ACUN3513	2 + H / 300	Screw for ETD448

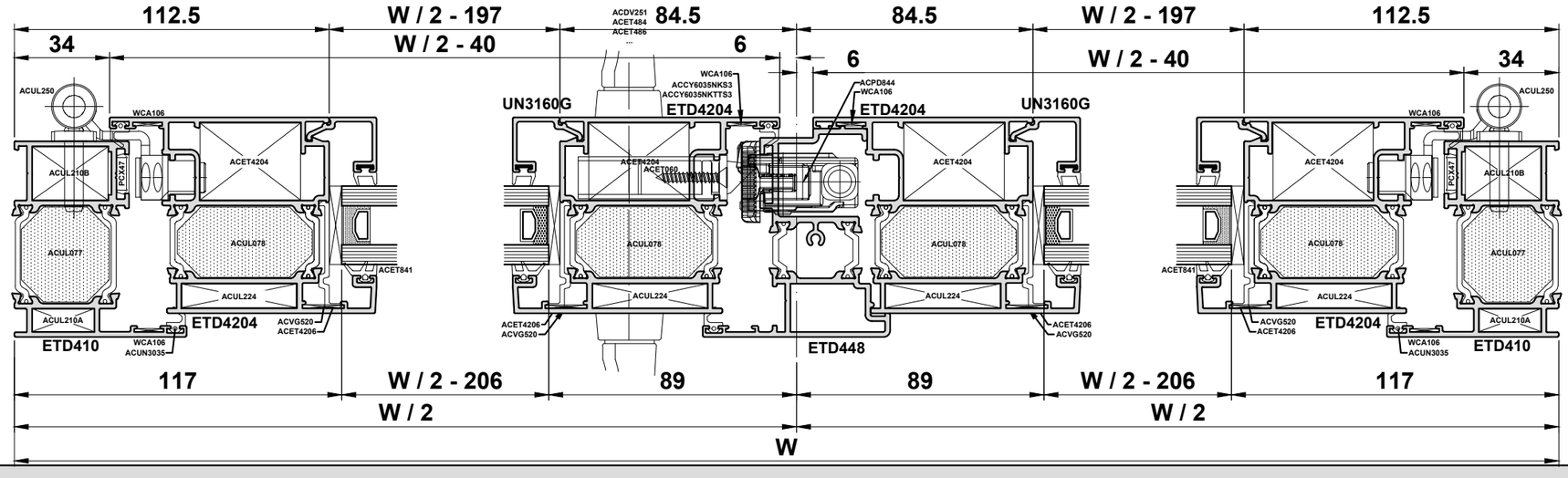
ACVL072	2 Pairs	VL72 End Cap
ACVL061	W/300 + 2	VL72 Rivet
WCA106	20	Chevron
*	1	Double Door Primary Lock

*See Page E20 for lock options.
**See B & E for handle options.

Midrail Accessories		
ACUL080	2 x W / 2	ETD4301 Foam
ACUL299	4	Bracket
ACUN036	4 x W / 2	Wedge Gasket
ACUN3512	8	Screw
ACET841	4 x W / 2	E Gasket
ACET4206	8	Bridge Packers



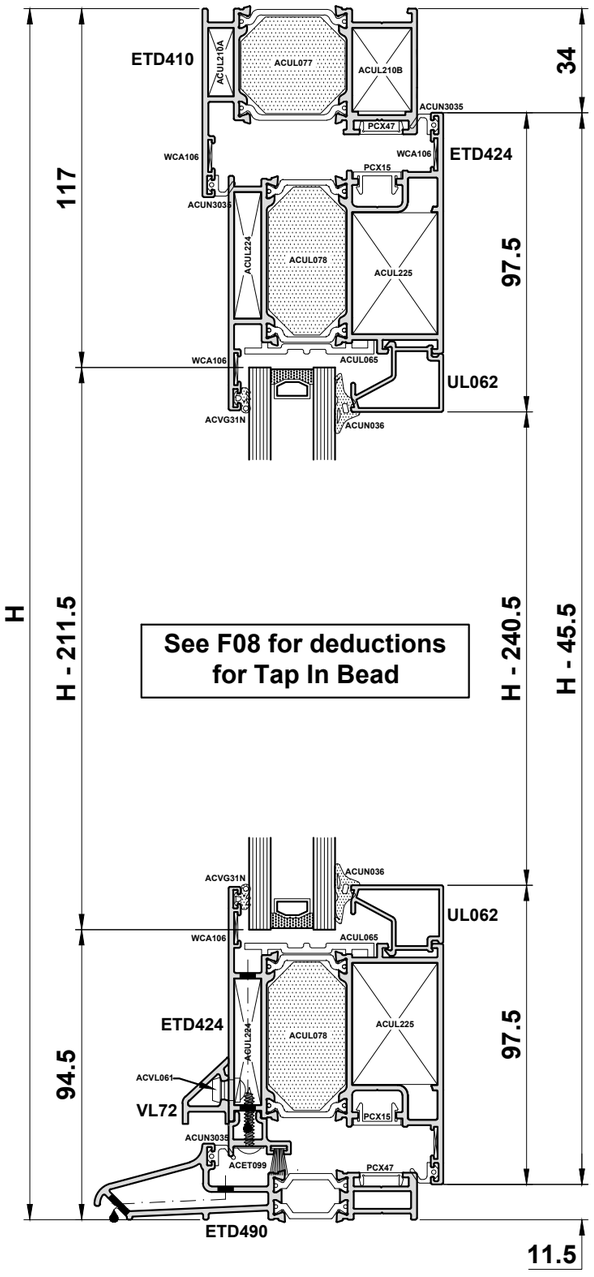




Do Not Scale From This Drawing

Alitherm 400 Stepped Door

Open In Double Door Finger Bolt ETD490 Low Rebate Threshold



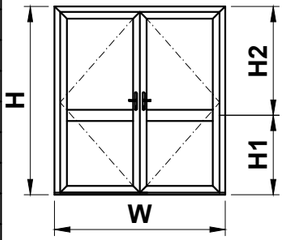
Profile Cutting Schedule			
ETD410	1		W
ETD410	2		H - 15.5
ETD490	1		W
ETD424	4		W / 2 - 40
ETD424	4		H - 45.5
ETD448	1		H - 81
UL297	2		W / 2 - 83
BEAD	4		H - 240.5
BEAD	4		W / 2 - 197
PCX15	4		H - 106
PCX15	4		W / 2 - 74
PCX47	2		H - 56.5
PCX47	1		H - 81
PCX47	2		W - 82
VL72	2		W / 2 - 116
MIDRAIL ETD430	2		W / 2 - 197
MIDRAIL BEAD	8		W / 2 - 197
MIDRAIL BEAD	4		H1 - 167.5
MIDRAIL BEAD	4		H2 - 190

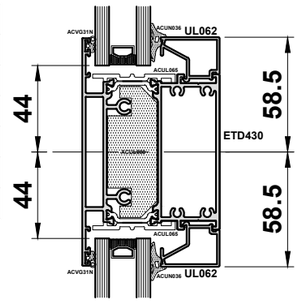
Glass Sizes		
Without ETD430	H - 211.5	W / 2 - 206
Top Glass With ETD430	H2 - 161	W / 2 - 206
Bottom Glass With ETD430	H1 - 138.5	W / 2 - 206

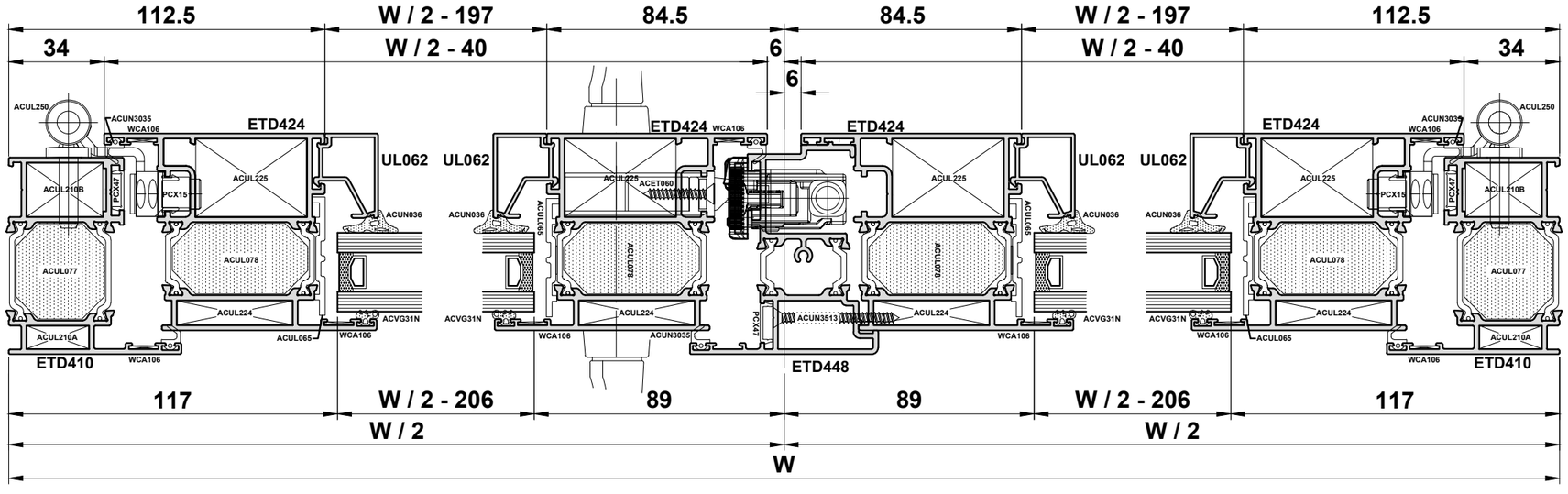
Accessories		
ACCY6035S3	1	Euro Cylinder
**	**	Handles
ACET060	4	Screw for ACET4190
ACET060	16	Screw for Lock
ACET099	W / 2 - 100 / 300	Fixing Screw for UL297
ACET4145	Pair	ETD448 End Cap at Cill
ACET4148	Pair	ETD448 End Cap at Head
ACET4190	Pair	ETD490 End Cap
ACET4197	2 Pairs	UL297 End Cap
ACET475	4	Run Up Block
ACIM062	24	Screw for ACUL250
ACPD844	1	Shootbolt Adaptor
ACPD84..	2	10mm Dia Glavanised Rod
ACSH038N	1 x W	Woolpile
ACSM015	Pair	Escutcheon
ACUL065	20	Bridge Packers
ACUL077	W & 2 x H	Outer Frame Foam
ACUL078	4 x W / 2 & 4 x H	Sash Foam
ACUL210A	2	Outer Frame Cleat
ACUL210B	2	Outer Frame Cleat
ACUL224	8	Sash Cleat
ACUL225	8	Sash Cleat
ACUL242	2	Finger Bolt Guide
ACUL250	6	Hinge
ACUL295	2	Low Threshold Bracket
ACUL390	Pair	Finger Bolt Flat Keep
ACUN036	4 x W / 2 & 4 x H	Wedge Gasket
ACUN3035	4 x W & 6 x H	Flipper Gasket
ACUN3512	18	Screw for ACUL250
ACUN3513	2 + H / 300	Screw for ETD448
ACVG31N	4 x W / 2 & 4 x H	E Gasket
ACVL072	2 Pair	VL72 End Cap
ACVL061	W/300 + 2	VL72 Rivet
WCA106	18	Chevrons
*	1	Double Door Primary Lock

*See Page E20 for lock options.
**See B & E for handle options.

Midrail Accessories		
ACUL080	2 x W / 2	ETD430 Foam
ACUL065	8	Bridge Packer
ACUL025	8	Anti-Twist Clip
ACUL299	2	Bracket
ACUN036	4 x W / 2	Wedge Gasket
ACUN3512	4	Screw
ACVG31N	4 x W / 2	E Gasket



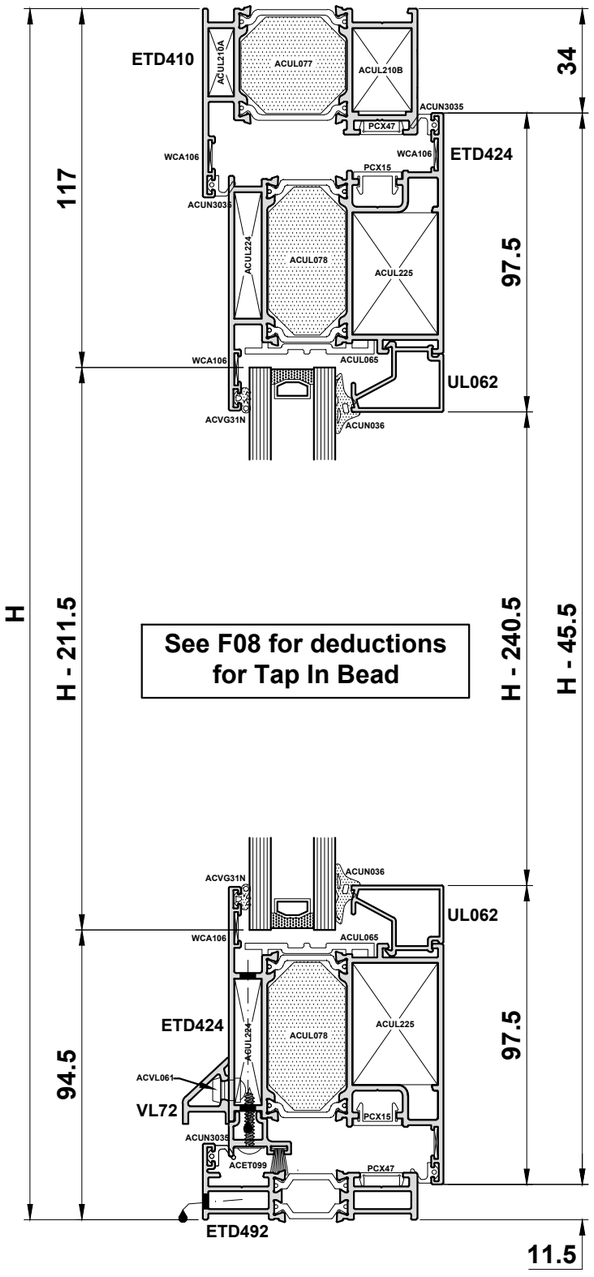




Do Not Scale From This Drawing

Alitherm 400 Stepped Door

Open In Double Door Finger Bolt ETD492 Low Rebate Threshold



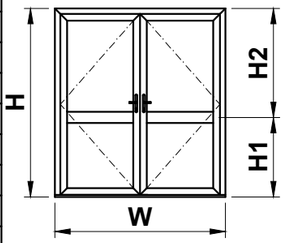
See F08 for deductions for Tap In Bead

Profile Cutting Schedule			
ETD410	1		W
ETD410	2		H - 15.5
ETD492	1		W
ETD424	4		W / 2 - 40
ETD424	4		H - 45.5
ETD448	1		H - 81
UL297	2		W / 2 - 83
BEAD	4		H - 240.5
BEAD	4		W / 2 - 197
PCX15	4		H - 106
PCX15	4		W / 2 - 74
PCX47	2		H - 56.5
PCX47	1		H - 81
PCX47	2		W - 82
VL72	2		W / 2 - 116
MIDRAIL: ETD430	2		W / 2 - 197
MIDRAIL: BEAD	8		W / 2 - 197
MIDRAIL: BEAD	4		H1 - 167.5
MIDRAIL: BEAD	4		H2 - 190

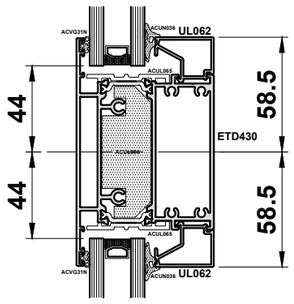
Glass Sizes		
Without ETD430	H - 211.5	W / 2 - 206
Top Glass With ETD430	H2 - 161	W / 2 - 206
Bottom Glass With ETD430	H1 - 138.5	W / 2 - 206

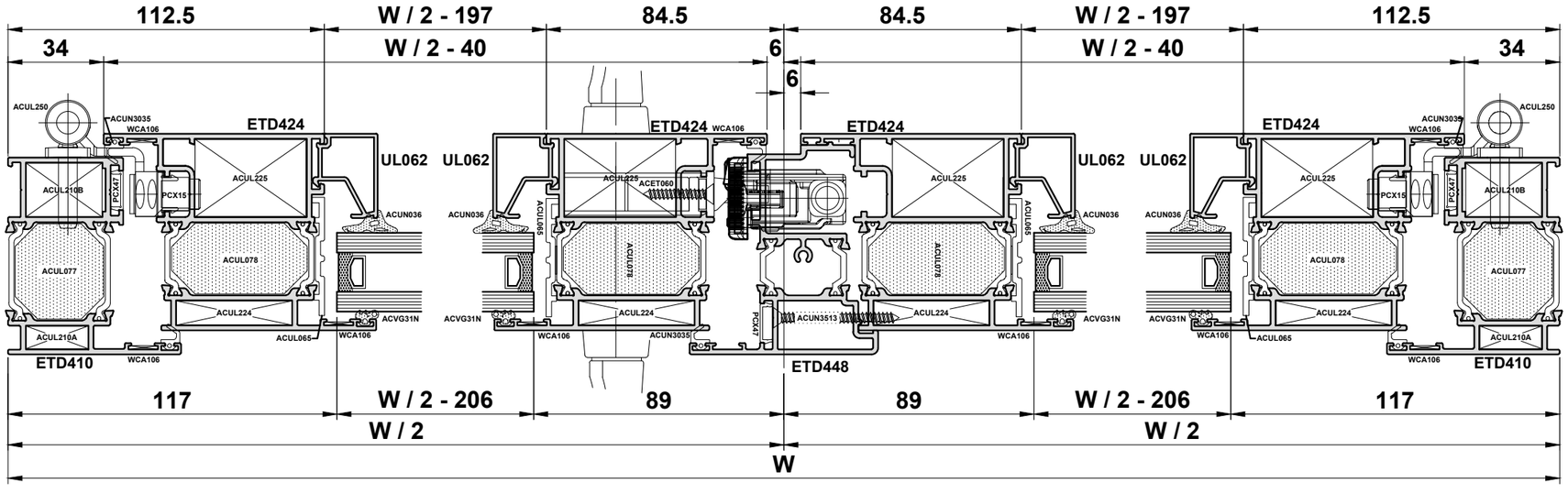
Accessories		
ACCY6035S3	1	Euro Cylinder
**	**	Handles
ACET060	4	Screw for ACET4190
ACET060	16	Screw for Lock
ACET099	W / 2 - 100 / 300	Fixing Screw for UL297
ACET4145	Pair	ETD448 End Cap at Cill
ACET4148	Pair	ETD448 End Cap at Head
ACET4192	Pair	ETD492 End Cap
ACET4197	2 Pairs	UL297 End Cap
ACET475	4	Run Up Block
ACIM062	24	Screw for ACUL250
ACPD844	1	Shootbolt Adaptor
ACPD84..	2	10mm Dia Glavanised Rod
ACSH038N	1 x W	Woolpile
ACSM015	Pair	Escutcheon
ACUL065	20	Bridge Packers
ACUL077	W & 2 x H	Outer Frame Foam
ACUL078	4 x W / 2 & 4 x H	Sash Foam
ACUL210A	2	Outer Frame Cleat
ACUL210B	2	Outer Frame Cleat
ACUL224	8	Sash Cleat
ACUL225	8	Sash Cleat
ACUL242	2	Finger Bolt Guide
ACUL250	6	Hinge
ACUL295	2	Low Threshold Bracket
ACUL390	Pair	Finger Bolt Flat Keep
ACUN036	4 x W / 2 & 4 x H	Wedge Gasket
ACUN3035	4 x W & 6 x H	Flipper Gasket
ACUN3512	18	Screw for ACUL250
ACUN3513	2 + H / 300	Screw for ETD448
ACVG31N	4 x W / 2 & 4 x H	E Gasket
ACVL072	2 Pair	VL72 End Cap
ACVL061	W/300 + 2	VL72 Rivet
WCA106	18	Chevrons
*	1	Double Door Primary Lock

*See Page E20 for lock options.
**See B & E for handle options.



Midrail Accessories		
ACUL080	2 x W / 2	ETD430 Foam
ACUL065	8	Bridge Packer
ACUL025	8	Anti-Twist Clip
ACUL299	2	Bracket
ACUN036	4 x W / 2	Wedge Gasket
ACUN3512	4	Screw
ACVG31N	4 x W / 2	E Gasket

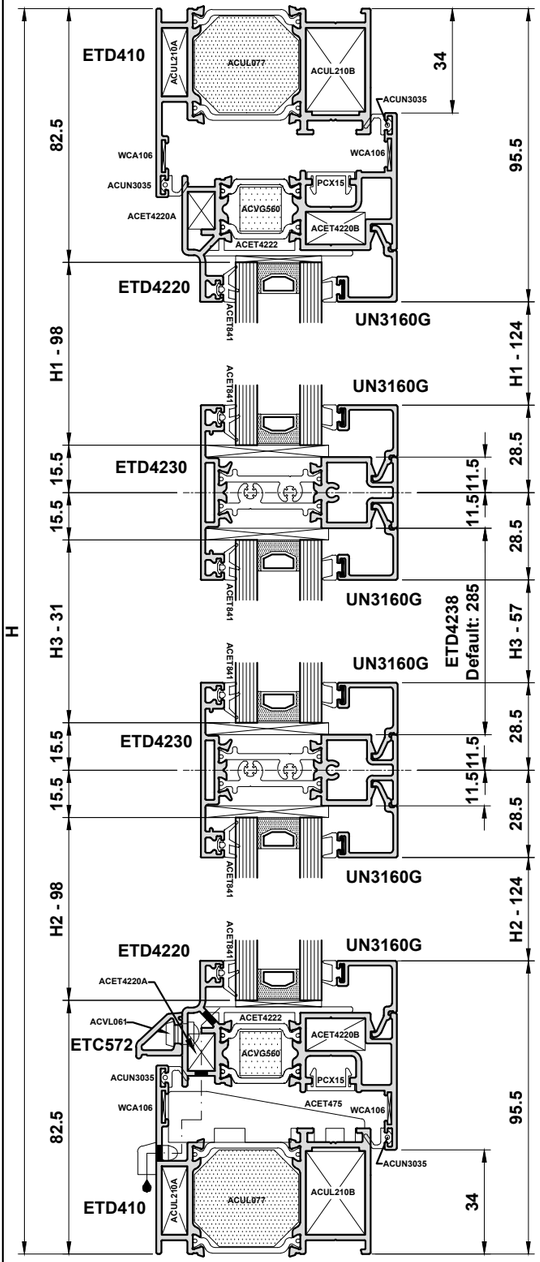




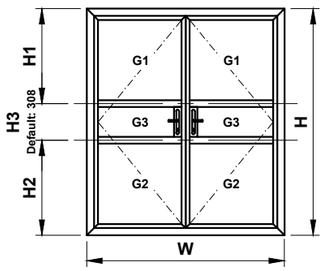
Do Not Scale From This Drawing

Alitherm 400 Stepped Door

Open In Heritage Double Door Full Frame Quick-Glaze Bead



Profile Cutting Schedule			
ETD410	2		W
ETD410	2		H
ETD4220	4		W/2 - 36.5
ETD4220	4		H - 68
ETD4247	1		H - 110
UN3160G	8		W/2 - 125.5
UN3160G	4		W/2 - 189
UN3160G	4		H1 - 124
UN3160G	4		H2 - 124
UN3160G	4		H3 - 57
ETD4230	4		W/2 - 125.5
ETD4238	2		285
PCX15	4		H - 106
PCX15	4		W/2 - 75.5
PCX47	2		H - 82
PCX47	2		W - 82
PCX47	2		H - 110
ETC572	2		W/2 - 112.5

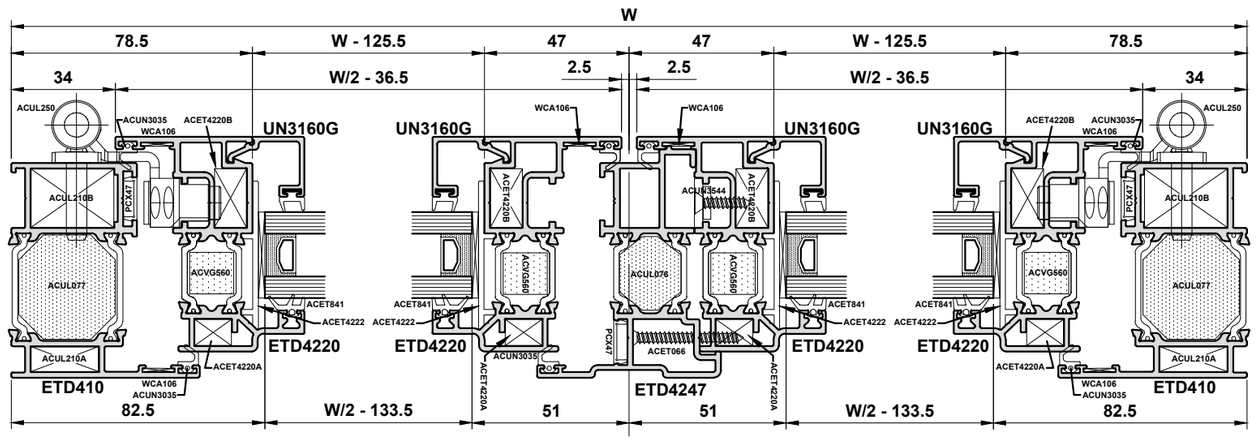


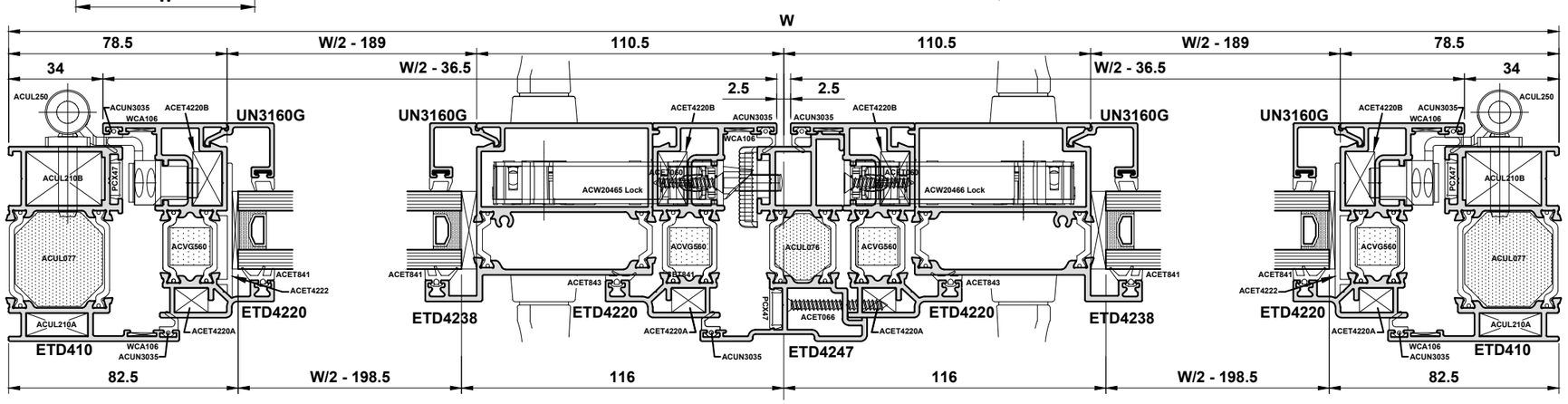
Accessories		
ACUL210A	4	Outerframe Cleat
ACUL210B	4	Outerframe Cleat
ACET4220A	8	Sash Cleat
ACET4220B	8	Sash Cleat
ACET4222	14	Bridge Packers
WCA106	12	Chevrons
ACUN3035	4W + 7H	Flipper Gasket
ACUL076	H - 110	Floating Mullion Foam
ACUL077	2W + 2H	Outerframe Foam
ACVG560	2W + 4H	Sash Foam
ACET843	2x 385mm	Lock Box E Gakset
E Gasket	6W + 4H	Glazing Gasket
ACET475	4	Run Up Block

ACET062	8	Transom Screws
ACET066	12	Transom Screws
ACVL061	W / 300 + 2	Pop Rivets
ACET572	2 Pair	Drip End Cap
ACUL250	6	Hinges
ACUN3512	18	Hinge Screw
ACUN3577	24	Hinge Screw
ACET4247	Pair	EDT4247 End Cap
ACET066	2 + H / 300	Screw for ETD4247
ACET131	4	Drainage Cap
ACW20465	1	Master Lock
ACW20466	1	Slave Lock
ACDV737	2	Bottom Shootbolt

ACDV738	2	Top Shootbolt
ACW20066 L/R	1	Center Keep
ACW20367	4	Keep
ACUL279	2	Shootbolt Keep
ACUN3544	32	Screw For Lock
Page E50	2	Euro Cylinder
Page E50	2	Handles

Glass Sizes		
G1	H1 - 98	W/2 - 133.5
G2	H2 - 98	W/2 - 133.5
G3	H3 - 31	W/2 - 198.5



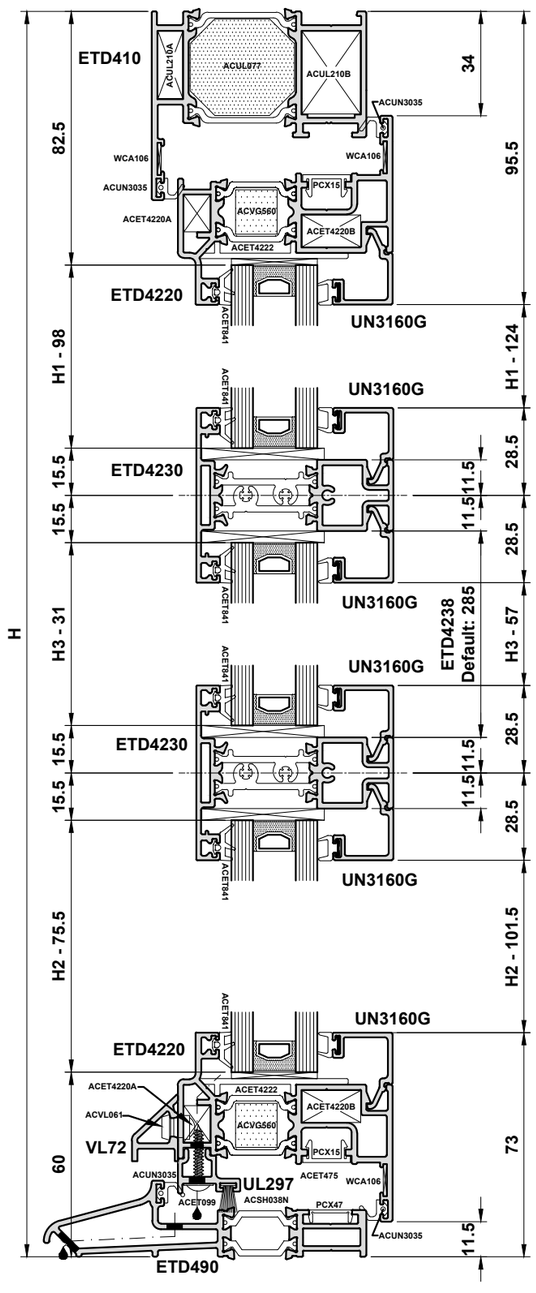


Do Not Scale From This Drawing

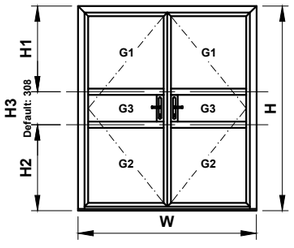
Alitherm 400 Stepped Door

SAWING TABLES : OPEN IN

Open In Heritage Double Door ETD490 Low Rebate Quick-Glaze Bead



Profile Cutting Schedule			
ETD410	1		W
ETD410	Pair		H - 15.5
ETD490	1		W
ETD4220	4		W/2 - 36.5
ETD4220	4		H - 45.5
ETD297	2		W/2 - 79.5
ETD4247	1		H - 81
UN3160G	8		W/2 - 125.5
UN3160G	4		W/2 - 189
UN3160G	4		H1 - 124
UN3160G	4		H2 - 101.5
UN3160G	4		H3 - 57
ETD4230	4		W/2 - 125.5
ETD4238	2		285
PCX15	4		H - 83.5
PCX15	4		W/2 - 75.5
PCX47	2		H - 56.5
PCX47	2		W - 82
PCX47	2		H - 81
VL72	2		W/2 - 112.5

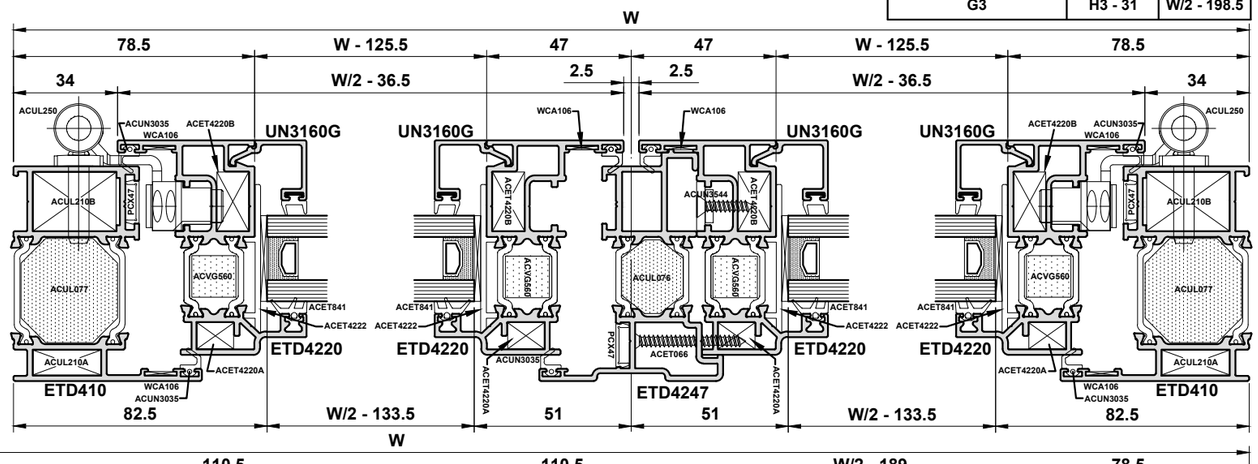


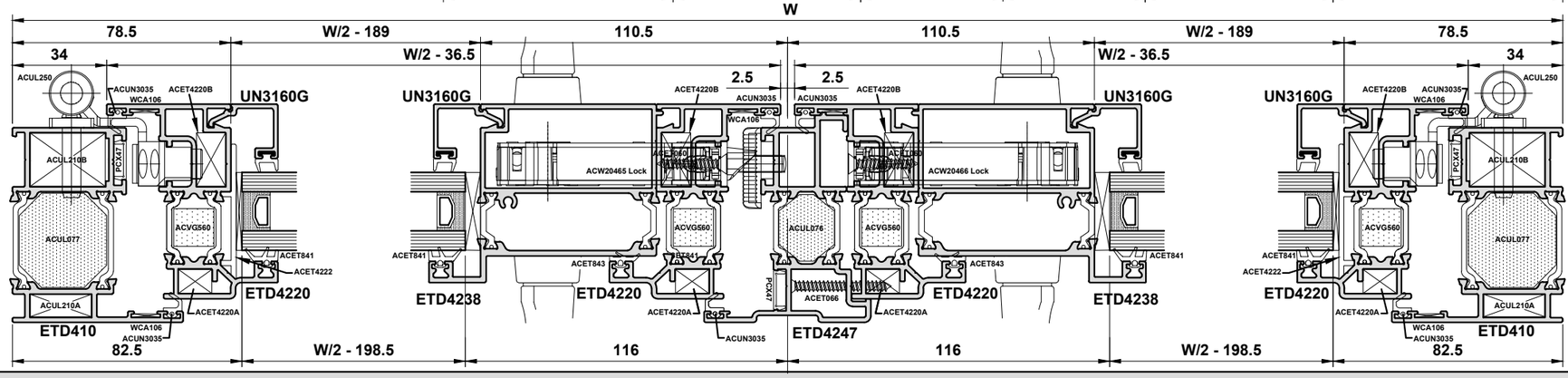
Accessories		
ACUL210A	2	Outerframe Cleat
ACUL210B	2	Outerframe Cleat
ACUL025	2	Anti-Twist Clip
ACUL295	2	Low Threshold Bracket
ACMX852	2	M6 x 16 Screw
ACET060	4	Screw For End Cap
ACET099	W - 100 / 300	Screw For UL297
ACET4190	Pair	ETD490 End Cap
ACET4197	2 Pair	UL297 End Cap
ACET4220A	8	Sash Cleat
ACET4220B	8	Sash Cleat
ACET4222	14	Bridge Packers
WCA106	10	Chevrons
ACUN3035	4W + 7H	Flipper Gasket

ACUL076	H - 81	Floating Mullion Foam
ACUL077	1W + 2H	Outerframe Foam
ACVG560	2W + 4H	Sash Foam
ACET843	2x 385mm	Lock Box E Gakset
E Gasket	6W + 4H	Glazing Gasket
ACSH038N	W - 113	Woolpile
ACET062	8	Transom Screws
ACET066	12	Transom Screws
ACVL061	W / 300 + 2	Pop Rivets
ACVL059	2 Pair	Drip End Cap
ACUL250	6	Hinges
ACUN3512	18	Hinge Screw
ACUN3577	24	Hinge Screw
ACET4246	Pair	EDT4247 Cill End Cap
ACET4247	Pair	EDT4247 Head End Cap

ACET066	2 + H / 300	Screw for ETD4247
ACET131	4	Drainage Cap
ACW20465	1	Master Lock
ACW20466	1	Slave Lock
ACDV737	2	Bottom Shootbolt
ACDV738	2	Top Shootbolt
ACW20066 L/R	1	Center Keep
ACW20367	4	Keep
ACUL279	2	Shootbolt Keep
ACUN3544	32	Screw For Lock
Page E50	2	Euro Cylinder
Page E50	2	Handles

Glass Sizes		
G1	H1 - 98	W/2 - 133.5
G2	H2 - 75.5	W/2 - 133.5
G3	H3 - 31	W/2 - 198.5

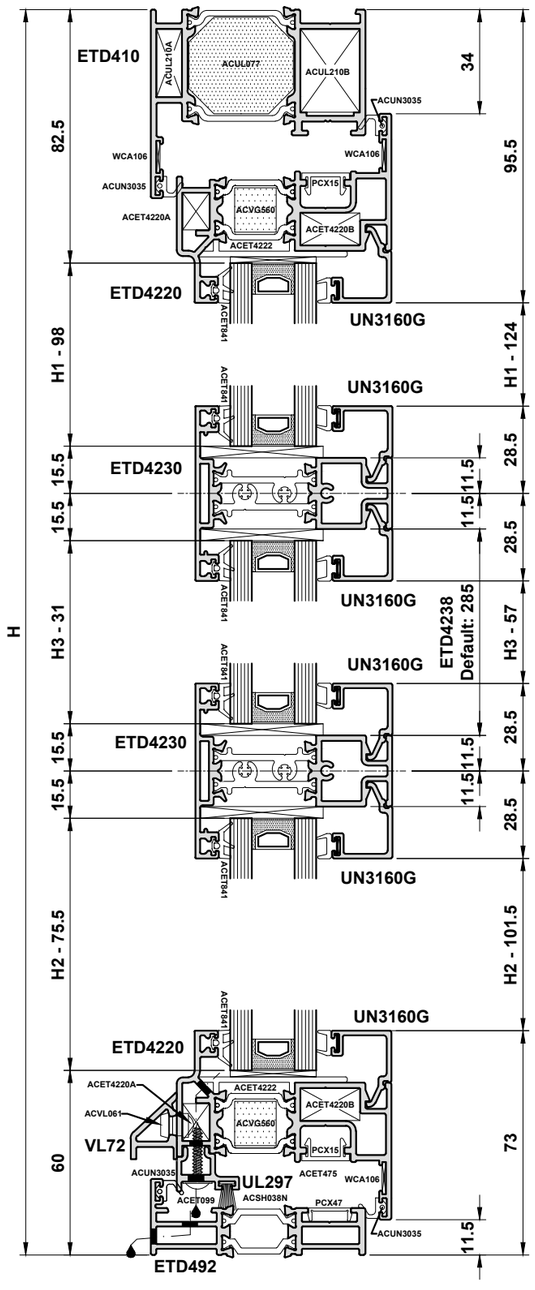




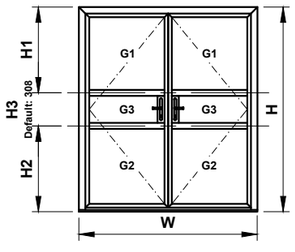
Do Not Scale From This Drawing

ISSUED: JULY 2026

Open In Heritage Double Door ETD492 Low Rebate Quick-Glaze Bead



Profile Cutting Schedule			
ETD410	1		W
ETD410	Pair		H - 15.5
ETD492	1		W
ETD4220	4		W/2 - 36.5
ETD4220	4		H - 45.5
ETD297	2		W/2 - 79.5
ETD4247	1		H - 81
UN3160G	8		W/2 - 125.5
UN3160G	4		W/2 - 189
UN3160G	4		H1 - 124
UN3160G	4		H2 - 101.5
UN3160G	4		H3 - 57
ETD4230	4		W/2 - 125.5
ETD4238	2		285
PCX15	4		H - 83.5
PCX15	4		W/2 - 75.5
PCX47	2		H - 56.5
PCX47	2		W - 82
PCX47	2		H - 81
VL72	2		W/2 - 112.5

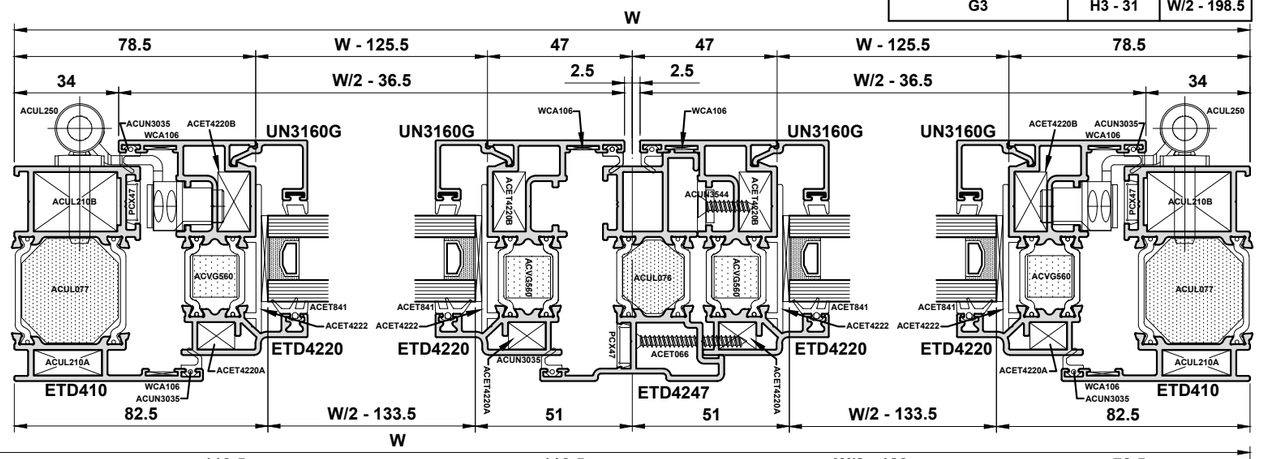


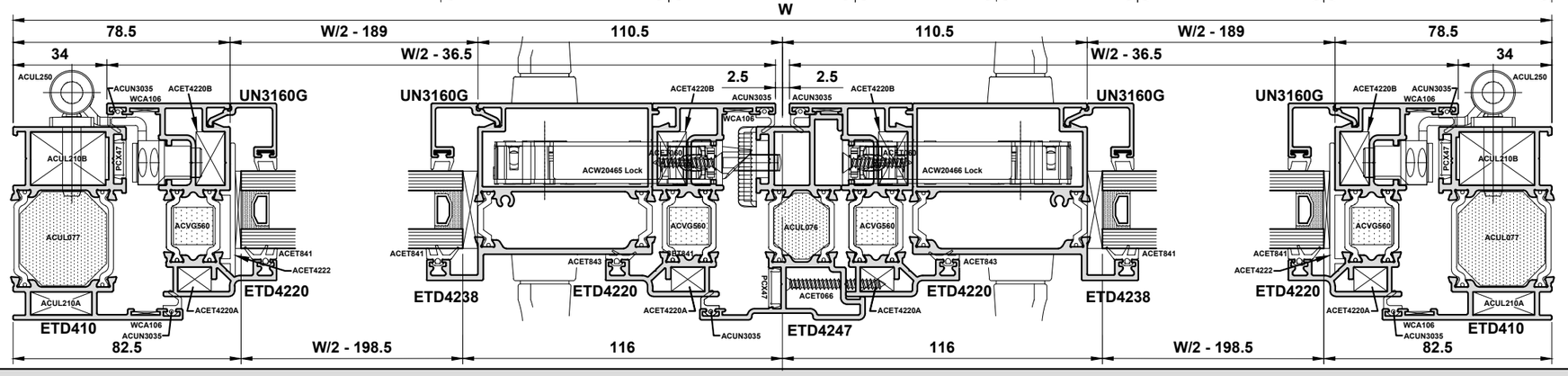
Accessories		
ACUL210A	2	Outerframe Cleat
ACUL210B	2	Outerframe Cleat
ACUL025	2	Anti-Twist Clip
ACUL295	2	Low Threshold Bracket
ACMX852	2	M6 x 16 Screw
ACET060	4	Screw For End Cap
ACET099	W - 100 / 300	Screw For UL297
ACET4192	Pair	ETD492 End Cap
ACET4197	2 Pair	UL297 End Cap
ACET4220A	8	Sash Cleat
ACET4220B	8	Sash Cleat
ACET4222	14	Bridge Packers
WCA106	10	Chevrons
ACUN3035	4W + 7H	Flipper Gasket

ACUL076	H - 81	Floating Mullion Foam
ACUL077	1W + 2H	Outerframe Foam
ACVG560	2W + 4H	Sash Foam
ACET843	2x 385mm	Lock Box E Gakset
E Gasket	6W + 4H	Glazing Gasket
ACSH038N	W - 113	Woolpile
ACET062	8	Transom Screws
ACET066	12	Transom Screws
ACVL061	W / 300 + 2	Pop Rivets
ACVL059	2 Pair	Drip End Cap
ACUL250	6	Hinges
ACUN3512	18	Hinge Screw
ACUN3577	24	Hinge Screw
ACET4246	Pair	EDT4247 Cill End Cap
ACET4247	Pair	EDT4247 Head End Cap

ACET066	2 + H / 300	Screw for ETD4247
ACET131	4	Drainage Cap
ACW20465	1	Master Lock
ACW20466	1	Slave Lock
ACDV737	2	Bottom Shootbolt
ACDV738	2	Top Shootbolt
ACW20066 L/R	1	Center Keep
ACW20367	4	Keep
ACUL279	2	Shootbolt Keep
ACUN3544	32	Screw For Lock
Page E50	2	Euro Cylinder
Page E50	2	Handles

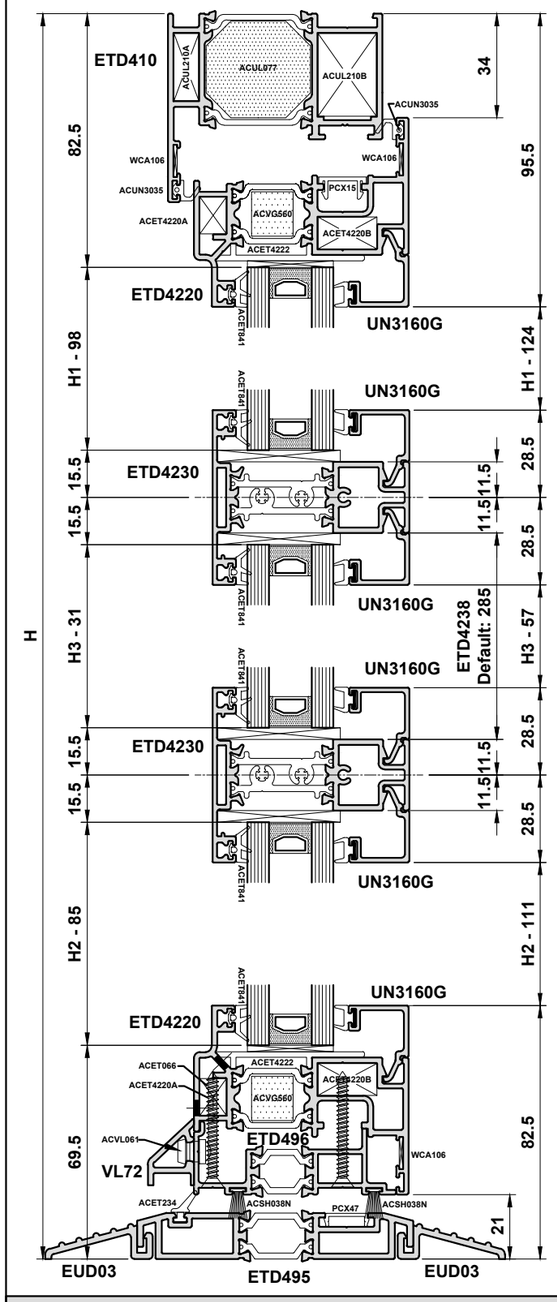
Glass Sizes		
G1	H1 - 98	W/2 - 133.5
G2	H2 - 75.5	W/2 - 133.5
G3	H3 - 31	W/2 - 198.5



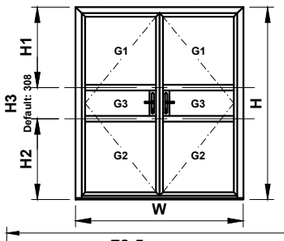


Do Not Scale From This Drawing

Open In Heritage Double Door Low Ramp Quick-Glaze Bead



Profile Cutting Schedule			
ETD410	1		W
ETD410	Pair		H - 15
ETD495	1		W
EUD03	2		W
ETD4220	4		W/2 - 36.5
ETD4220	4		H - 55
ETD496	2		W/2 - 84.5
ETD4247	1		H - 81
UN3160G	8		W/2 - 125.5
UN3160G	4		W/2 - 189
UN3160G	4		H1 - 124
UN3160G	4		H2 - 111
UN3160G	4		H3 - 57
ETD4230	4		W/2 - 125.5
ETD4238	2		285
PCX15	4		H - 84
PCX15	4		W/2 - 75.5
PCX47	2		H - 57
PCX47	2		W - 82
PCX47	2		H - 81
VL72	2		W/2 - 112.5

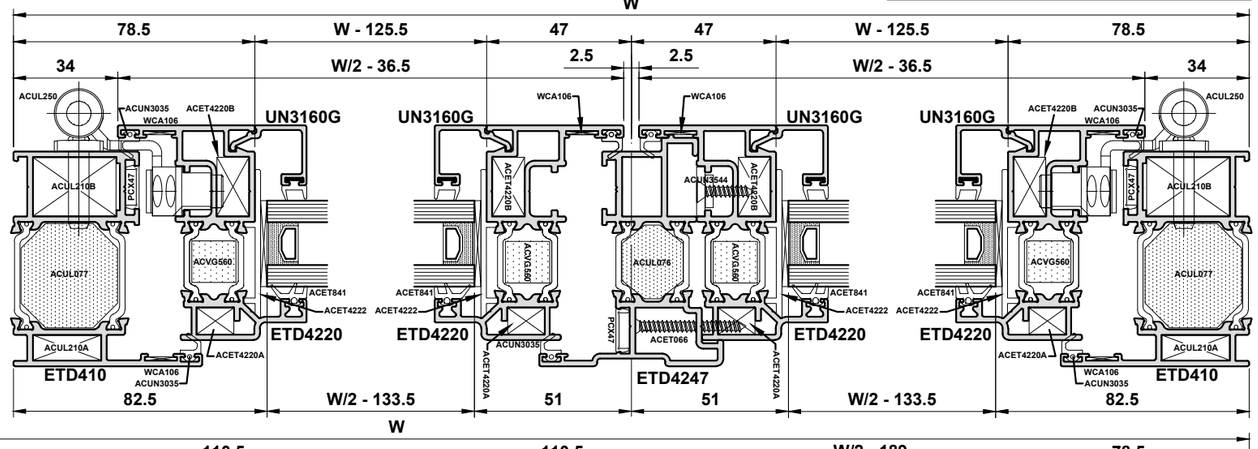


Accessories		
ACUL210A	2	Outerframe Cleat
ACUL210B	2	Outerframe Cleat
ACUL295	2	Low Threshold Bracket
ACMX852	2	M6 x 16 Screw
ACET060	4	Screw For End Cap
ACET4196	2 Pair	ETD496 End Cap
ACET066	2x W-100 / 300	Fixing Screw for ETD496
ACET4195	Pair	ETD495 End Cap
ACET4220A	8	Sash Cleat
ACET4220B	8	Sash Cleat
ACET4222	14	Bridge Packers
WCA106	10	Chevrons
ACUN3035	4W + 7H	Flipper Gasket
ACUL076	H - 81	Floating Mullion Foam

ACUL077	1W + 2H	Outerframe Foam
ACVG560	2W + 4H	Sash Foam
ACET843	2x 385mm	Lock Box E Gakset
E Gasket	6W + 4H	Glazing Gasket
ACSH038N	2x W - 113	Woolpile
ACET062	8	Transom Screws
ACET066	12	Transom Screws
ACVL061	W / 300 + 2	Pop Rivets
ACVL059	2 Pair	Drip End Cap
ACUL250	6	Hinges
ACUN3512	18	Hinge Screw
ACUN3577	24	Hinge Screw
ACET4242	Pair	EDT4247 Cill End Cap
ACET4247	Pair	EDT4247 Head End Cap
ACET066	2 + H / 300	Screw for ETD4247

ACET131	4	Drainage Cap
ACW20465	1	Master Lock
ACW20466	1	Slave Lock
ACDV737	2	Bottom Shootbolt
ACDV738	2	Top Shootbolt
ACW20066 L/R	1	Center Keep
ACW20367	4	Keep
ACUL279	2	Shootbolt Keep
ACUN3544	32	Screw For Lock
Page E50	2	Euro Cylinder
Page E50	2	Handles

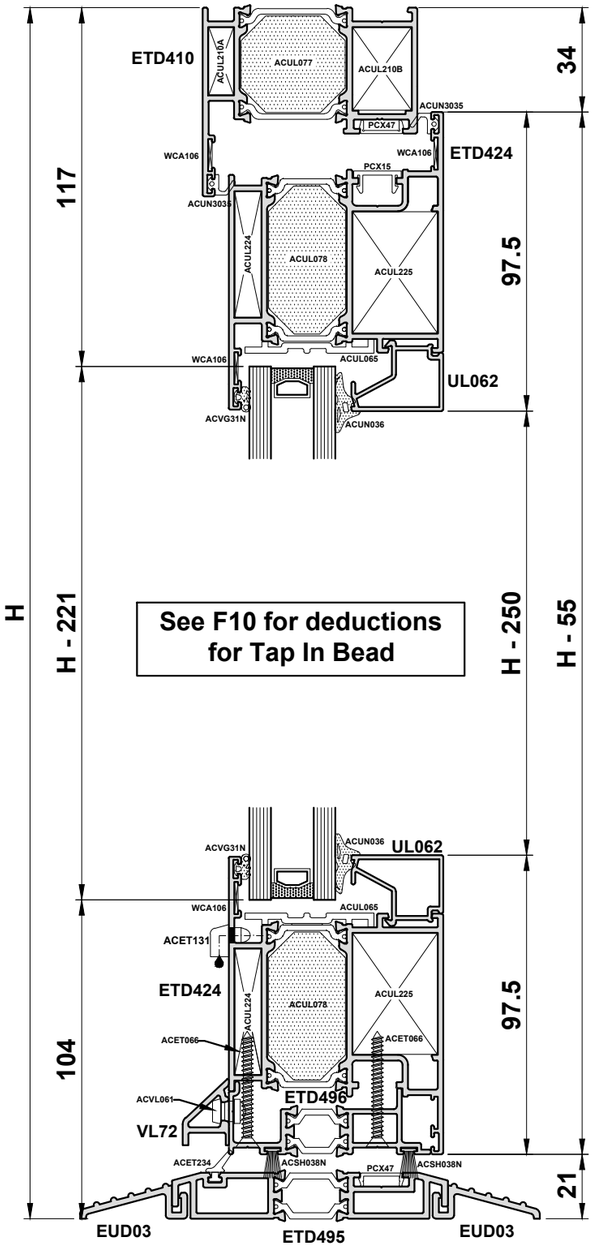
Glass Sizes		
G1	H1 - 98	W/2 - 133.5
G2	H2 - 85	W/2 - 133.5
G3	H3 - 31	W/2 - 198.5



Do Not Scale From This Drawing

Alitherm 400 Stepped Door

Open In Double Door Finger Bolt Full Frame



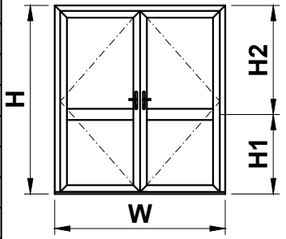
Profile Cutting Schedule			
ETD410	1		W
ETD410	2		H - 15
ETD495	1		W
EUD03	2		W
ETD424	4		W / 2 - 40
ETD424	4		H - 55
ETD496	2		W / 2 - 88
ETD448	1		H - 81
BEAD	4		H - 250
BEAD	4		W / 2 - 197
PCX15	4		H - 68
PCX15	4		W / 2 - 75
PCX47	2		H - 55
PCX47	1		H - 81
PCX47	2		W - 82
VL72	2		W / 2 - 116
MIDRAIL	ETD430	2	W / 2 - 197
MIDRAIL	BEAD	8	W / 2 - 197
MIDRAIL	BEAD	4	H1 - 177
MIDRAIL	BEAD	4	H2 - 190

Glass Sizes		
Without ETD430	H - 221	W / 2 - 206
Top Glass With ETD430	H2 - 161	W / 2 - 206
Bottom Glass With ETD430	H1 - 148	W / 2 - 206

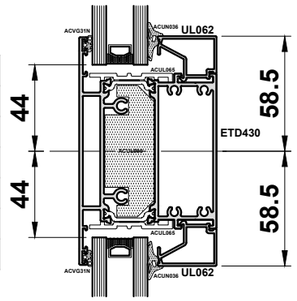
Accessories		
ACCY6035S3	1	Euro Cylinder
**	**	Handles
ACET060	4	Fixing Screw for ACET4195
ACET060	16	Screw for Lock
ACET066	2 x W - 100 / 300	Fixing Screw for ETD496
ACET234	1 x W	Flipper Gasket
ACET4190	Pair	ETD490 End Cap
ACET4143	Kit	ETD448/ETD496 End Cap
ACET4148	Pair	ETD448 End Cap at Head
ACET4195	Pair	ETD495 End Cap
ACET4196	Pair	ETD496 End Cap
ACET475	4	Run Up Block
ACIM062	24	Screw for ACUL250
ACPD844	1	Shootbolt Adaptor
ACPD84..	2	10mm Dia Glavanised Rod
ACSH038N	2 x W	Woolpile
ACSM015	Pair	Escutcheon
ACUL065	20	Bridge Packers
ACUL077	W & 2 x H	Outer Frame Foam
ACUL078	4 x W / 2 & 4 x H	Sash Foam
ACUL210A	2	Outer Frame Cleat
ACUL210B	2	Outer Frame Cleat
ACUL224	8	Sash Cleat
ACUL225	8	Sash Cleat
ACUL242	2	Finger Bolt Guide

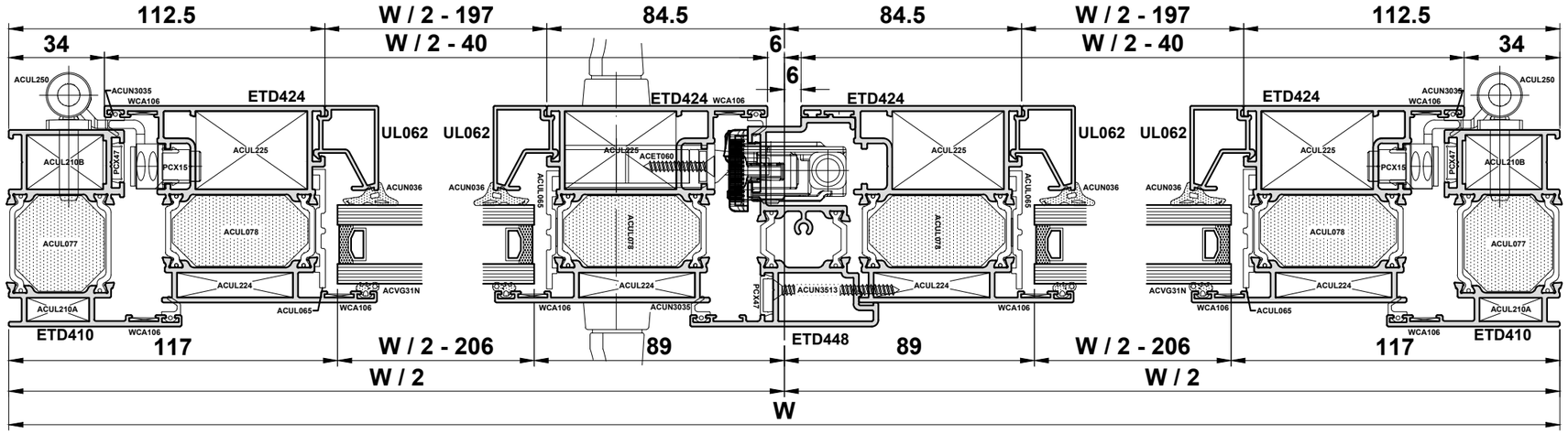
ACUL250	6	Hinge
ACUL295	2	Low Threshold Bracket
ACUL390	Pair	Finger Bolt Flat Keep
ACUN036	4 x W / 2 & 4 x H	Wedge Gasket
ACUN3035	4 x W & 6 x H	Flipper Gasket
ACUN3512	18	Screw for ACUL250
ACUN3513	2 + H / 300	Screw for ETD448
ACVG31N	4 x W / 2 & 4 x H	E Gasket
ACVL072	2 Pair	VL72 End Cap
ACVL061	W/300 + 2	VL72 Rivet
WCA106	18	Chevrons
*	1	Double Door Primary Lock

*See Page E20 for lock options.
**See B & E for handle options.



Midrail Accessories		
ACUL080	2 x W / 2	ETD430 Foam
ACUL065	8	Bridge Packer
ACUL025	8	Anti-Twist Clip
ACUL299	2	Bracket
ACUN036	4 x W / 2	Wedge Gasket
ACUN3512	4	Screw
ACVG31N	4 x W / 2	E Gasket

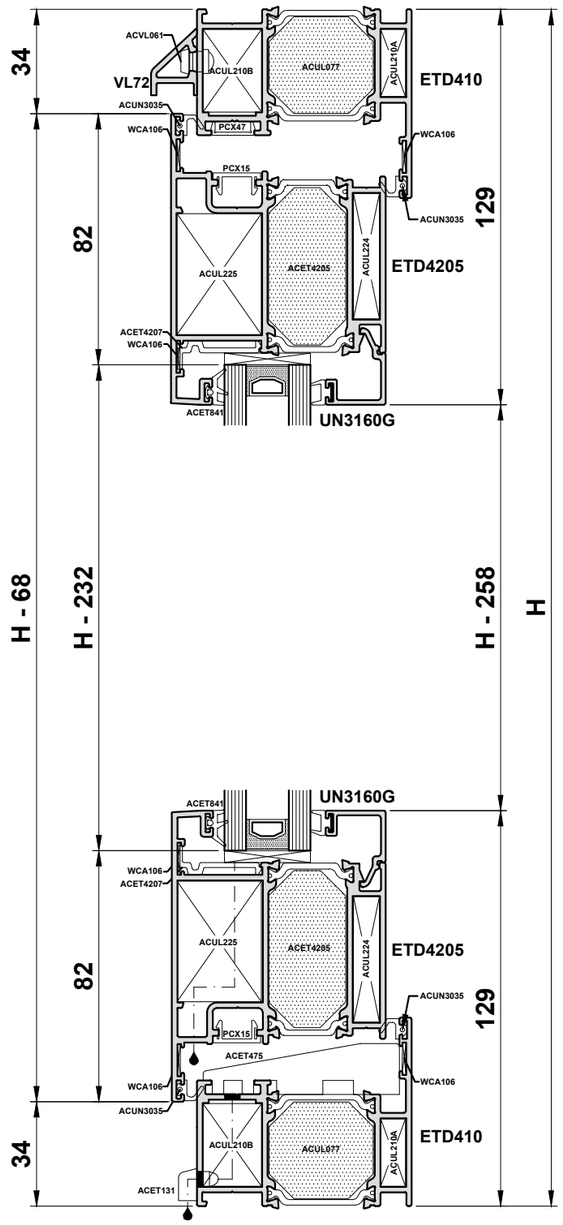




Do Not Scale From This Drawing

Alitherm 400 Stepped Door

Open Out Single Door Full Frame Quick-Glaze Bead



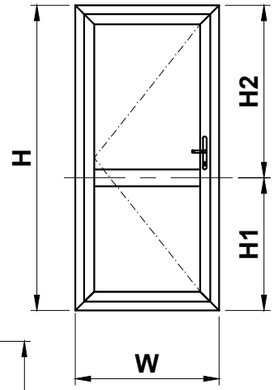
Profile Cutting Schedule				
UN3160G	2			H - 258
UN3160G	2			W - 224
ETD410	2			W
ETD410	2			H
ETD4205	2			W - 68
ETD4205	2			H - 68
PCX15	2			H - 106
PCX15	2			W - 106
PCX47	2			H - 82
PCX47	2			W - 82
VL72	1			W - 11
MIDRAIL: ETD4302	1			W - 224
MIDRAIL: UN3160G	4			W - 224
MIDRAIL: UN3160G	2			H1 - 187
MIDRAIL: UN3160G	2			H2 - 187

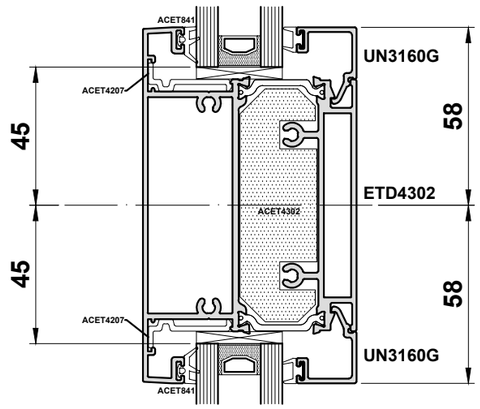
Glass Sizes		
Without ETD4302	H - 232	W - 232
Top Glass With ETD4302	H2 - 161	W - 232
Bottom Glass With ETD4302	H1 - 161	W - 232

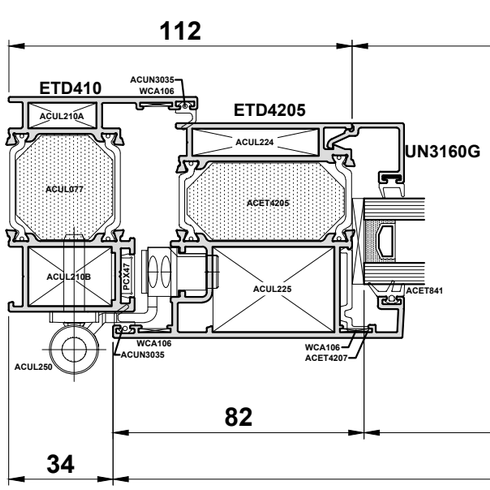
Accessories		
ACCY3560S3	1	Euro Cylinder
**	**	Handles
ACET060	16	Screws for Lock
ACET131	2	Drainage Cap
ACET4205	2 x W & 2 X H	Sash Foam
ACET4207	10	Bridge Packers
ACET475	2	Run Up Block
ACET841	2 x W & 2 x H	E Gasket
ACIM062	12	Screw for ACUL250
ACUL077	2 x W & 2 x H	Outer Frame Foam
ACUL210A	4	Outer Frame Cleat
ACUL210B	4	Outer Frame Cleat
ACUL224	4	Sash Cleat
ACUL225	4	Sash Cleat
ACUL250	3	Hinge
ACUN3035	4 x W & 4 x H	Flipper Gasket
ACUN3512	9	Screw for ACUL250
ACVL059 / ACVL072	1 Pair	VL72 End Cap
ACVL061	W/300 + 2	VL72 Rivet
WCA106	12	Chevrons
*	1	Primary Lock

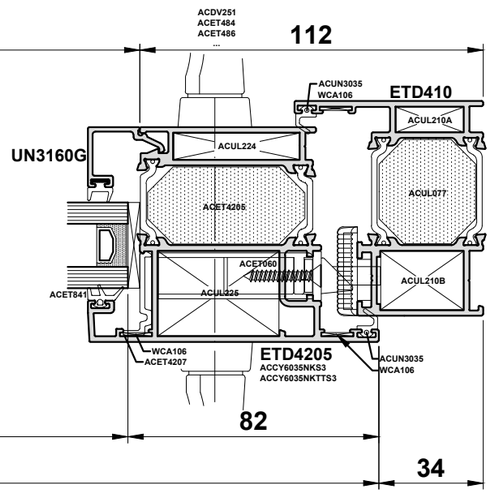
*See Page E72 for lock options.
**See B & E for handle options.

Midrail Accessories		
ACET4302	W	ETD4302 Foam
ACUN3512	4	Screws
ACET841	2 x W	E Gasket
ACET4207	4	Bridge Packer





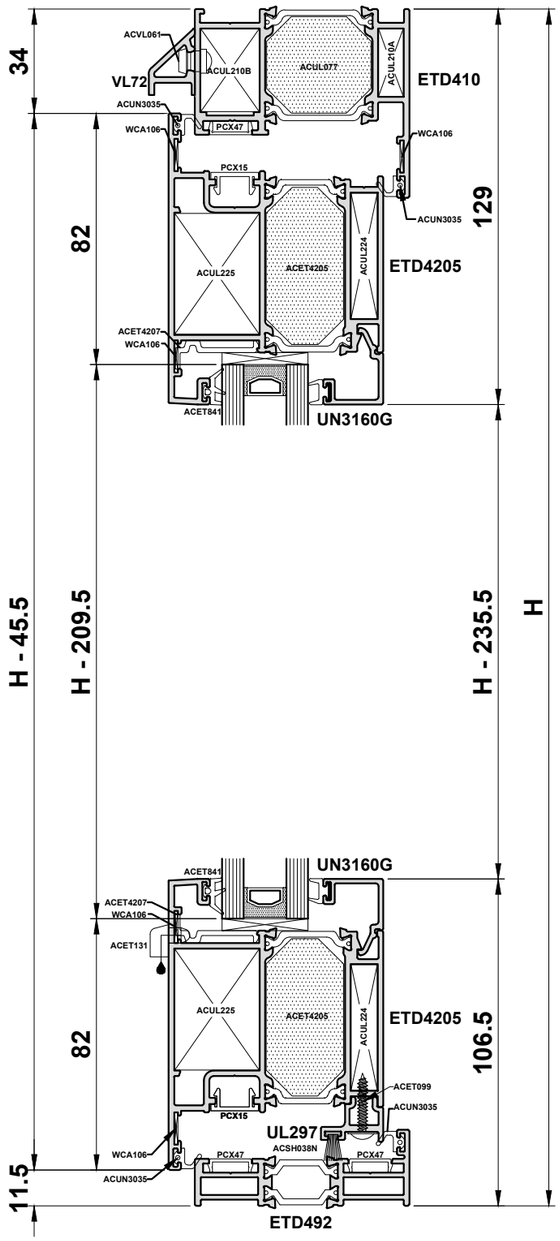




Do Not Scale From This Drawing

Alitherm 400 Stepped Door

Open Out Single Door Low Rebate Threshold Quick-Glaze Bead



Profile Cutting Schedule				
UN3160G	2			H - 235.5
UN3160G	2			W - 224
ETD410	1			W
ETD410	2			H - 15.5
ETD4205	2			W - 68
ETD4205	2			H - 45.5
ETD492	1			W
UL297	1			W - 113
PCX15	2			H - 83.5
PCX15	2			W - 106
PCX47	2			H - 56.5
PCX47	2			W - 82
VL72	1			W - 11
MIDRAIL: ETD4302	1			W - 224
UN3160G	4			W - 224
UN3160G	2			H1 - 164.5
UN3160G	2			H2 - 187

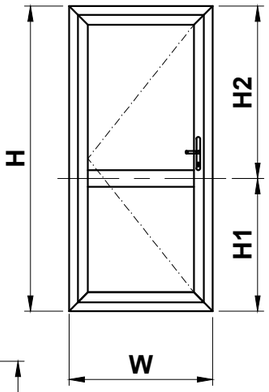
Glass Sizes		
Without ETD4302	H - 209.5	W - 232
Top Glass With ETD4302	H2 - 161	W - 232
Bottom Glass With ETD4302	H1 - 138.5	W - 232

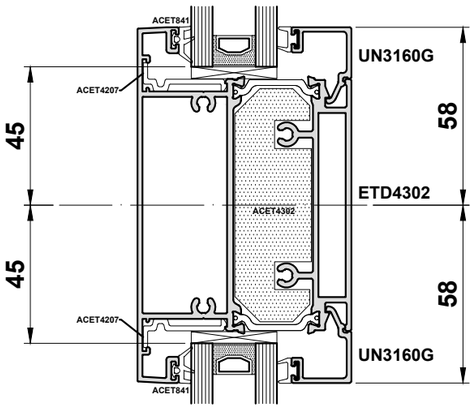
Accessories		
ACCY3560S3	1	Euro Cylinder
**	**	Handles
ACET060	16	Screws for Lock
ACET099	W - 100 / 300	Screw for UL297
ACET131	2	Drainage Cap
ACET4192	Pair	ETD492 End Cap
ACET4197	Pair	UL297 End Cap
ACET4205	2 x W & 2 X H	Sash Foam
ACET4207	10	Bridge Packers
ACET475	2	Run Up Block
ACET841	2 x W & 2 x H	E Gasket
ACIM062	12	Screw for ACUL250
ACSH038N	W	Woolpile
ACUL077	W & 2 x H	Outer Frame Foam
ACUL210A	2	Outer Frame Cleat
ACUL210B	2	Outer Frame Cleat
ACUL224	4	Sash Cleat
ACUL225	4	Sash Cleat
ACUL250	3	Hinge
ACUL295	2	Low Threshold Bracket
ACUN3035	4 x W & 4 x H	Flipper Gasket
ACUN3512	9	Screw for ACUL250

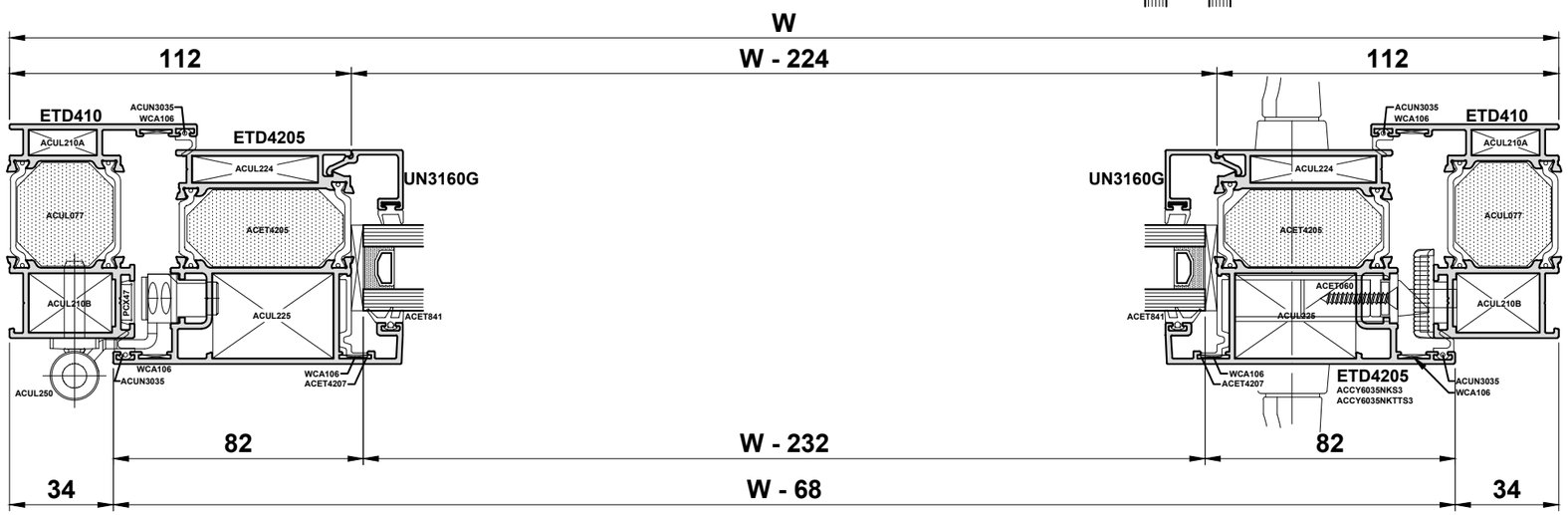
ACVL059 / ACVL072	1 Pair	VL72 End Cap
ACVL061	W/300 + 2	VL72 Rivet
WCA106	12	Chevrons
*	1	Primary Lock

*See Page E72 for lock options.
**See B & E for handle options.

Midrail Accessories		
ACET4302	W	ETD4302 Foam
ACUN3512	4	Screws
ACET841	2 x W	E Gasket
ACET4207	4	Bridge Packer



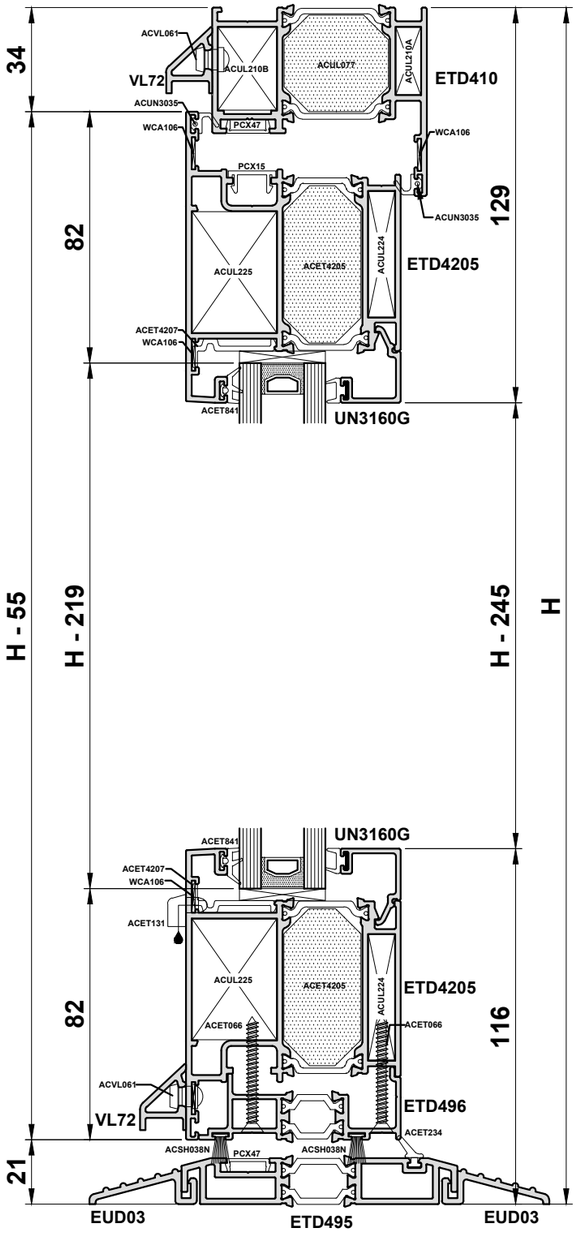




Do Not Scale From This Drawing

Alitherm 400 Stepped Door

Open Out Single Door Low Ramp Threshold Quick-Glaze Bead



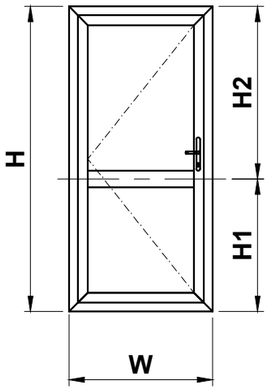
Profile Cutting Schedule				
UN3160G	2			H - 245
UN3160G	2			W - 224
ETD410	1			W
ETD410	2			H - 15
ETD4205	2			W - 68
ETD4205	2			H - 55
ETD495	1			W
ETD496	1			W - 109
EUD03	2			W
PCX15	2			H - 68.5
PCX15	1			W - 106
PCX47	2			H - 56
PCX47	2			W - 82
VL72	1			W - 11
VL72	1			W - 81
MIDRAIL: ETD4302	1			W - 224
UN3160G	4			W - 224
UN3160G	2			H1 - 174
UN3160G	2			H2 - 187

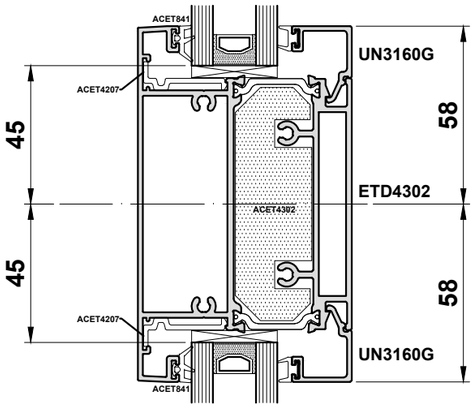
Glass Sizes		
Without ETD4302	H - 219	W - 232
Top Glass With ETD4302	H2 - 161	W - 232
Bottom Glass With ETD4302	H1 - 148	W - 232

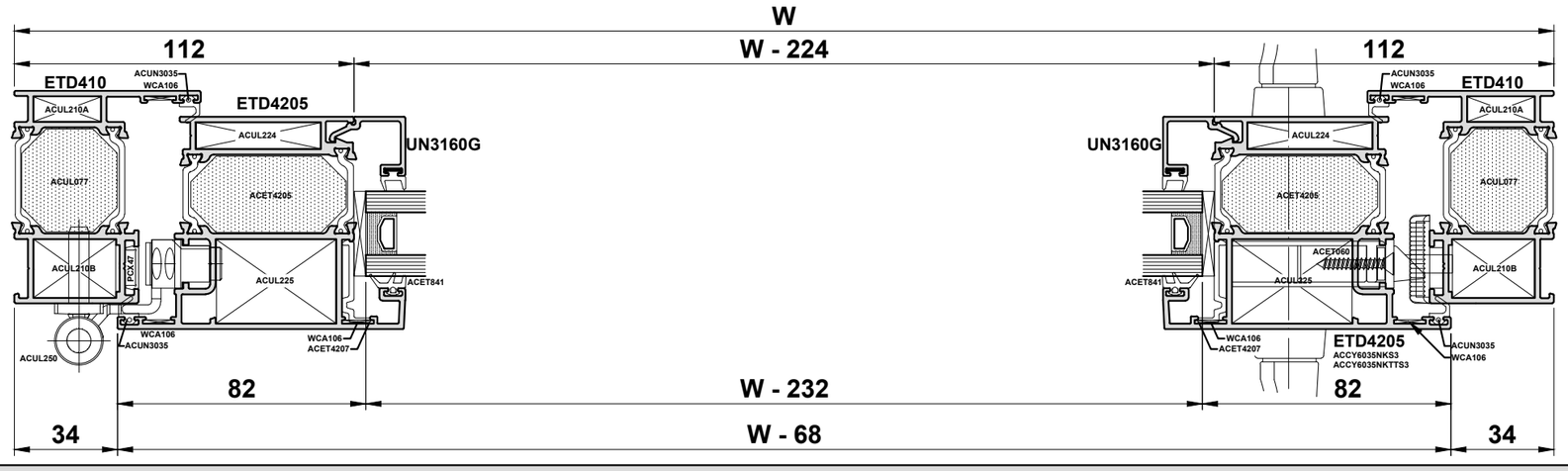
Accessories		
ACCY3560S3	1	Euro Cylinder
ACDV251	Pair	Handles
ACET060	16	Screws for Lock
ACET060	4	Screw for ACET4195
ACET066	2 x W - 100 / 300	Fixing Screw for ETD496
ACET131	2	Drainage Cap
ACET234	1 x W	Flipper Gasket
ACET4195	Pair	ETD495 End Cap
ACET4196	Pair	ETD496 End Cap
ACET4205	2 x W & 2 X H	Sash Foam
ACET4207	10	Bridge Packers
ACET475	2	Run Up Block
ACET841	2 x W & 2 x H	E Gasket
ACIM062	12	Screw for ACUL250
ACUL077	W & 2 x H	Outer Frame Foam
ACUL210A	2	Outer Frame Cleat
ACUL210B	2	Outer Frame Cleat
ACUL224	4	Sash Cleat
ACUL225	4	Sash Cleat
ACUL250	3	Hinge
ACUL295	2	Low Threshold Bracket
ACSH038N	2 x W	Woolpile
ACUN3035	2 x W & 4 x H	Flipper Gasket
ACUN3512	9	Screw for ACUL250
ACVL059 / ACVL072	1 Pair	VL72 End Cap
ACVL061	W/300 + 2	VL72 Rivet
WCA106	10	Chevrons
*	1	Primary Lock

*See Page E72 for lock options.
**See B & E for handle options.

Midrail Accessories		
ACET4302	W	ETD4302 Foam
ACUN3512	4	Screws
ACET841	2 x W	E Gasket
ACET4207	4	Bridge Packer

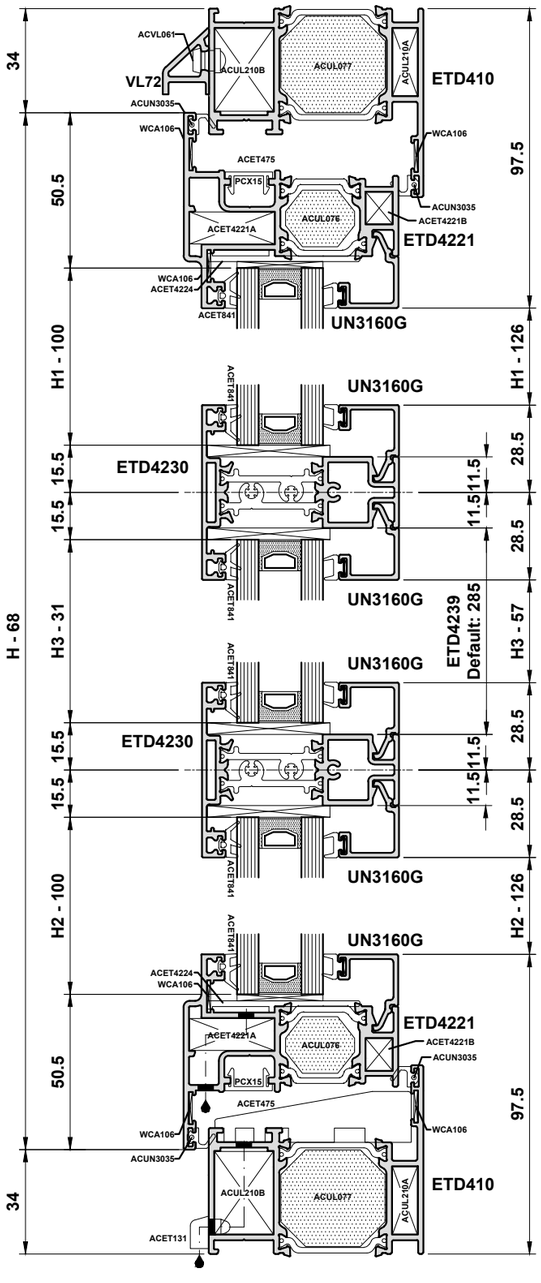






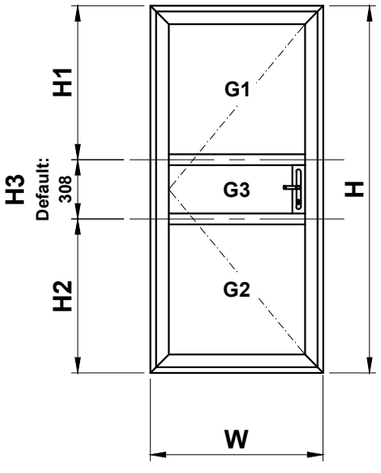
Do Not Scale From This Drawing

Open Out Heritage Single Door Full Frame Quick-Glaze Bead



Profile Cutting Schedule				
ETD410	2			W
ETD410	2			H
ETD4221	2			W - 68
ETD4221	2			H - 68
UN3160G	4			W - 161
UN3160G	2			W - 224.5
UN3160G	2			H1 - 126
UN3160G	2			H2 - 126
UN3160G	2			H3 - 57
ETD4230	2			W - 161
ETD4239	1			285
PCX15	2			H - 106
PCX15	2			W - 106
PCX47	2			H - 82
PCX47	2			W - 82
VL72	1			W - 11

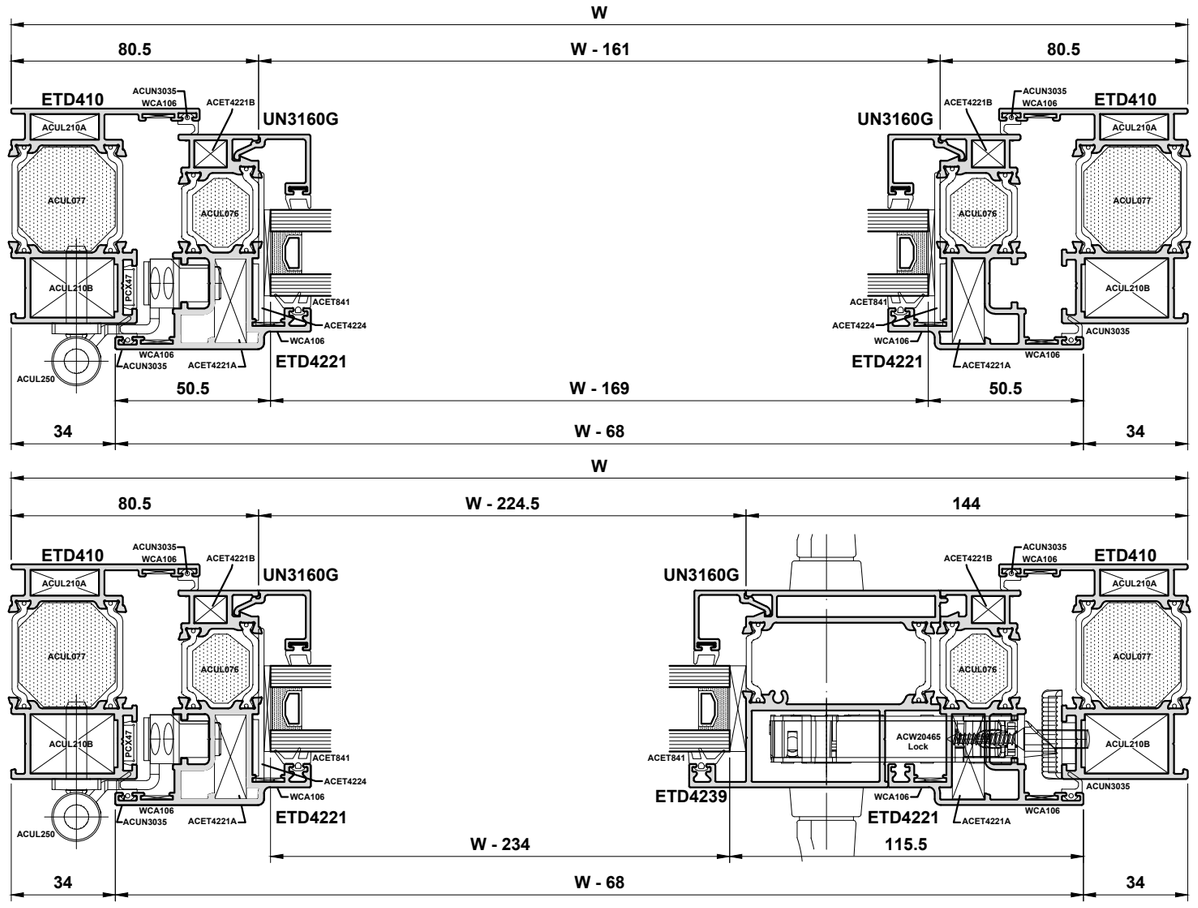
Glass Sizes		
G1	H1 - 100	W - 169
G2	H2 - 100	W - 169
G3	H3 - 31	W - 234



Accessories		
ACUL210A	4	Outerframe Cleat
ACUL210B	4	Outerframe Cleat
ACET4221A	4	Sash Cleat
ACET4221B	4	Sash Cleat
ACET4224	7	Bridge Packers
WCA106	8	Chevrons
ACUN3035	4W + 4H	Flipper Gasket
ACUL076	2W + 2H	Sash Foam
ACUL077	2W + 2H	Outerframe Foam
E Gasket	6W + 2H	Glazing Gasket
ACET475	2	Run Up Block

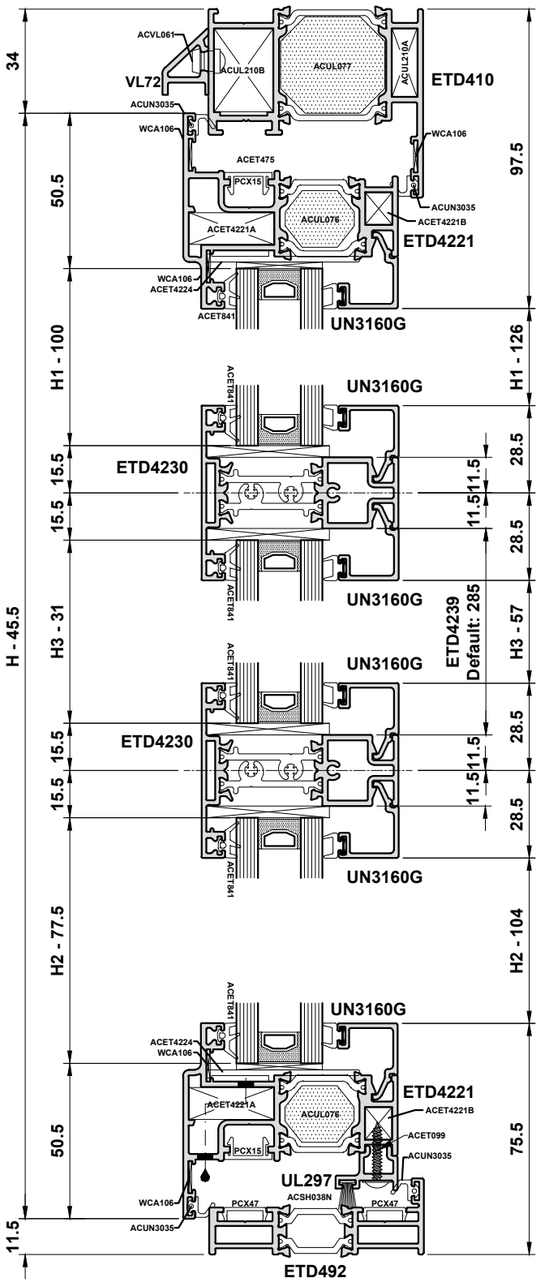
ACET062	4	Transom Screws
ACET066	6	Transom Screws
ACVL061	W/300 + 2	Pop Rivets
ACVL059	1 Pair	Drip End Cap
ACUL250	3	Hinges
ACUN3512	9	Hinge Screw
ACUN3577	12	Hinge Screw
ACET131	2	Drainage Cap
ACW20465	1	Lock
ACW20066 L/R	1	Center Keep
ACW20367	4	Keep

ACUN3544	16	Screw For Lock
Page E50	1	Euro Cylinder
Page E50	1	Handles



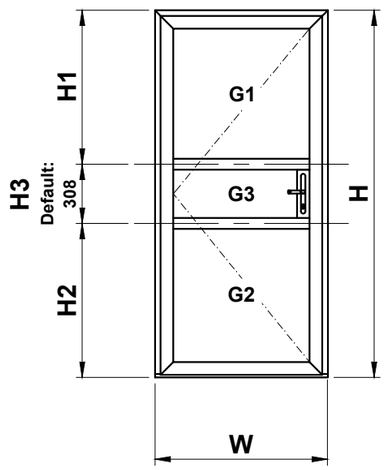
Do Not Scale From This Drawing

Open Out Heritage Single Door Low Rebate Quick-Glaze Bead



Profile Cutting Schedule			
ETD410	1		W
ETD410	Pair		H - 15.5
ETD492	1		W
ETD4221	2		W - 68
ETD4221	2		H - 45.5
UL297	1		W - 113
UN3160G	4		W - 161
UN3160G	2		W - 224.5
UN3160G	2		H1 - 126
UN3160G	2		H2 - 104
UN3160G	2		H3 - 57
ETD4230	2		W - 161
ETD4239	1		285
PCX15	2		H - 83.5
PCX15	2		W - 106
PCX47	2		H - 56.5
PCX47	3		W - 82
VL72	1		W - 11

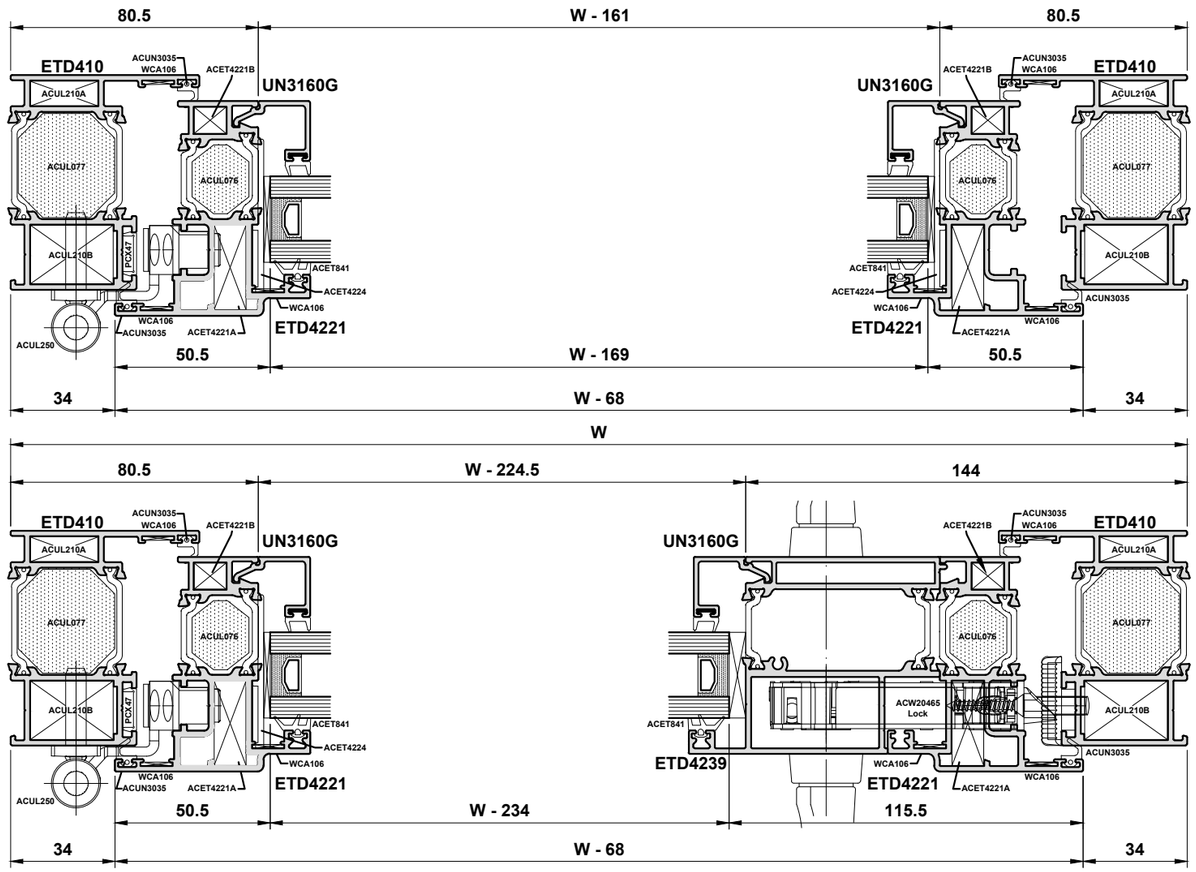
Glass Sizes		
G1	H1 - 100	W - 169
G2	H2 - 77.5	W - 169
G3	H3 - 31	W - 234



Accessories		
ACUL210A	2	Outerframe Cleat
ACUL210B	2	Outerframe Cleat
ACUL025	2	Anti-Twist Clip
ACUL295	2	Low Threshold Bracket
ACMX852	2	M6 x 16 Screw
ACET060	4	Screw For End Cap
ACET099	W - 100 / 300	Screw For UL297
ACET4192	Pair	ETD492 End Cap
ACET4197	Pair	UL297 End Cap
ACET4221A	4	Sash Cleat
ACET4221B	4	Sash Cleat

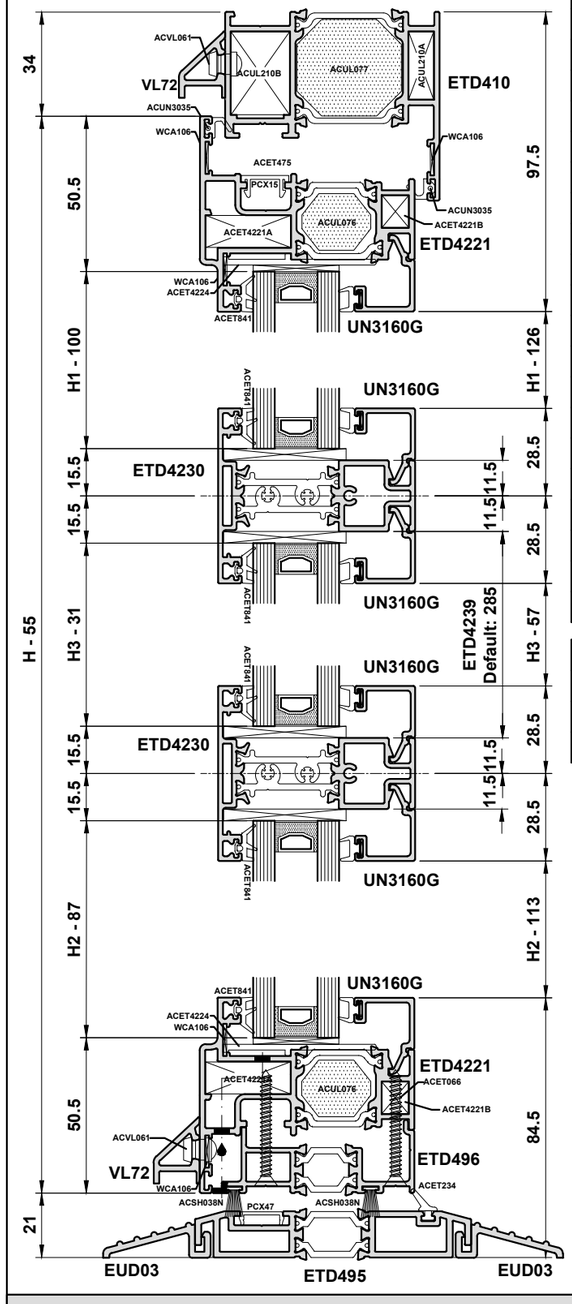
ACET4224	7	Bridge Packers
WCA106	6	Chevrons
ACUN3035	4W + 4H	Flipper Gasket
ACUL076	2W + 2H	Sash Foam
ACUL077	1W + 2H	Outerframe Foam
E Gasket	6W + 2H	Glazing Gasket
ACSH038N	W - 113	Woolpile
ACET062	4	Transom Screws
ACET066	6	Transom Screws
ACVL061	W/300 + 2	Pop Rivets
ACVL059	Pair	Drip End Cap

ACUL250	3	Hinges
ACUN3512	9	Hinge Screw
ACUN3577	12	Hinge Screw
ACET131	2	Drainage Cap
ACW20465	1	Lock
ACW20066 L/R	1	Center Keep
ACW20367	4	Keep
ACUN3544	16	Screw For Lock
Page E50	1	Euro Cylinder
Page E50	1	Handles



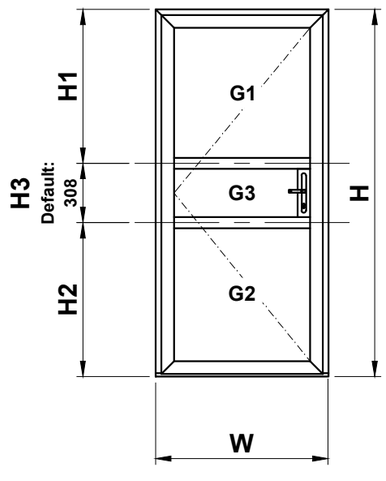
Do Not Scale From This Drawing

Open Out Heritage Single Door Low Ramp Quick-Glaze Bead



Profile Cutting Schedule			
ETD410	1		W
ETD410	Pair		H - 15
ETD495	1		W
EUD03	2		W
ETD4221	2		W - 68
ETD4221	2		H - 55
ETD496	1		W - 115
UN3160G	4		W - 161
UN3160G	2		W - 224.5
UN3160G	2		H1 - 126
UN3160G	2		H2 - 113
UN3160G	2		H3 - 57
ETD4230	2		W - 161
ETD4239	1		285
PCX15	2		H - 84
PCX15	2		W - 106
PCX47	2		H - 57
PCX47	2		W - 82
VL72	1		W - 81
VL72	1		W - 11

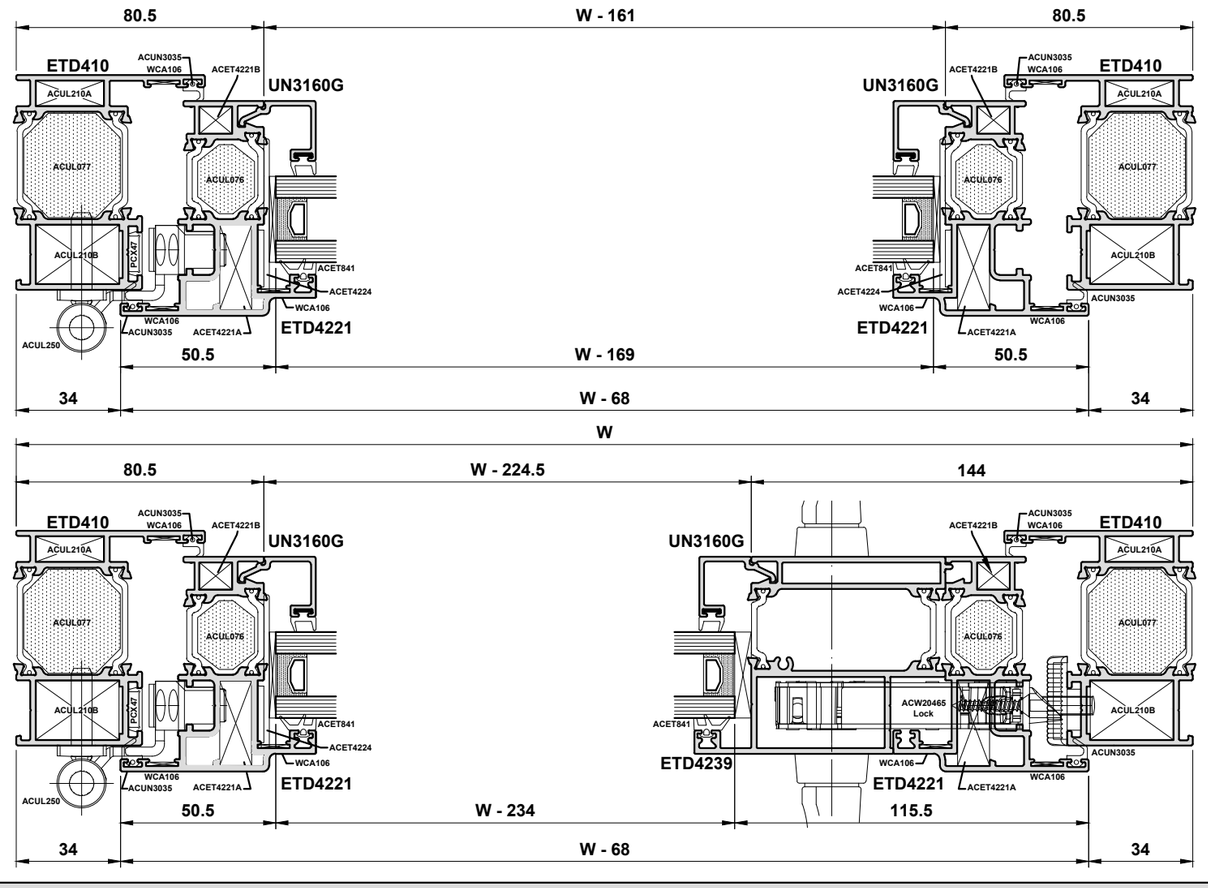
Glass Sizes		
G1	H1 -100	W - 169
G2	H2 - 87	W - 169
G3	H3 - 31	W - 234



Accessories		
ACUL210A	2	Outerframe Cleat
ACUL210B	2	Outerframe Cleat
ACUL295	2	Low Threshold Bracket
ACMX852	2	M6 x 16 Screw
ACET060	4	Screw For End Cap
ACET4196	Pair	ETD496 End Cap
ACET066	2x W - 100/ 300	Fixing Screw for ETD496
ACET4195	Pair	ETD495 End Cap
ACET4221A	4	Sash Cleat
ACET4221B	4	Sash Cleat
ACET4224	7	Bridge Packers

WCA106	6	Chevrons
ACUN3035	4W + 4H	Flipper Gasket
ACUL076	2W + 2H	Sash Foam
ACUL077	1W + 2H	Outerframe Foam
E Gasket	6W + 2H	Glazing Gasket
ACSH038N	2 x W	Woolpile
ACET234	W	Flipper Gasket
ACET062	4	Transom Screws
ACET066	6	Transom Screws
ACVL061	2x W/300 + 2	Pop Rivets
ACVL059	2 Pair	Drip End Cap

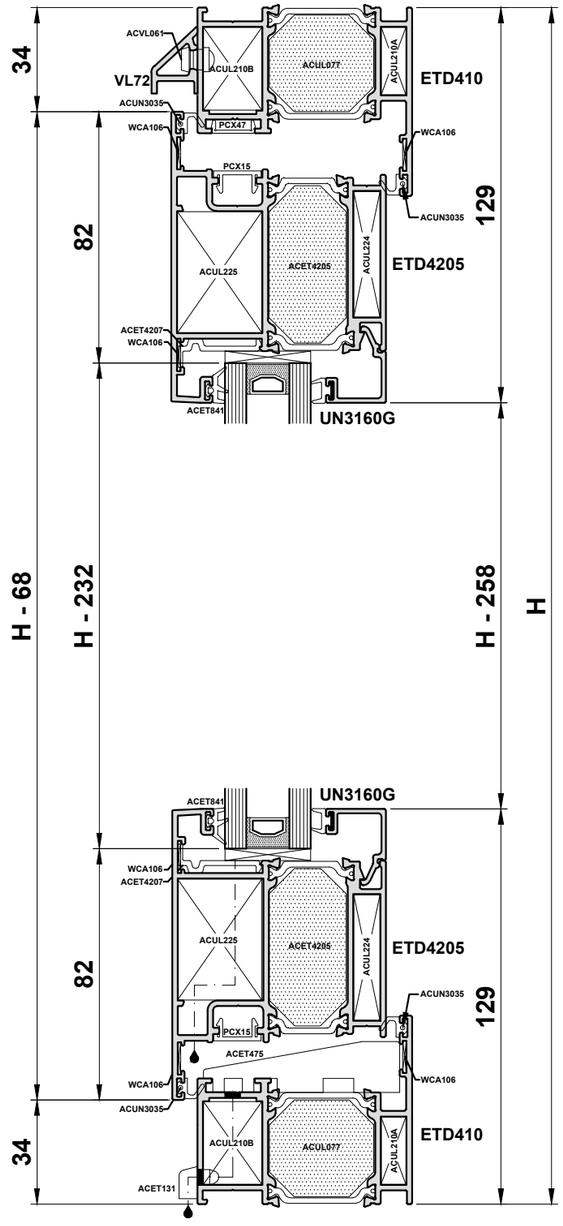
ACUL250	3	Hinges
ACUN3512	9	Hinge Screw
ACUN3577	12	Hinge Screw
ACET131	2	Drainage Cap
ACW20465	1	Lock
ACW20066 L/R	1	Center Keep
ACW20367	4	Keep
ACUN3544	16	Screw For Lock
Page E50	1	Euro Cylinder
Page E50	1	Handles



Do Not Scale From This Drawing

Alitherm 400 Stepped Door

Open Out Double Door Lift Lever Full Frame Quick-Glaze Bead

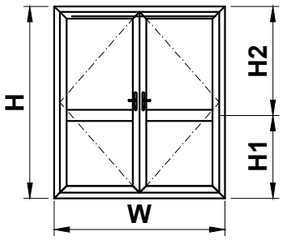


Profile Cutting Schedule			
UN3160G	4		H - 258
UN3160G	4		W / 2 - 192.5
ETD410	2		W
ETD410	2		H
ETD4205	4		W / 2 - 36.5
ETD4205	4		H - 68
ETD447	1		H - 110
PCX15	4		H - 106
PCX15	4		W / 2 - 106
PCX47	2		H - 82
PCX47	1		H - 81
PCX47	2		W / 2 - 82
VL72	1		W - 11
MIDRAIL ETD4302	2		W / 2 - 192.5
MIDRAIL UN3160G	8		W / 2 - 192.5
MIDRAIL UN3160G	4		H2 - 187
MIDRAIL UN3160G	4		H1 - 187

Glass Sizes		
Without ETD4302	H - 232	W / 2 - 200.5
Top Glass With ETD4302	H2 - 161	W / 2 - 200.5
Bottom Glass With ETD4302	H1 - 161	W / 2 - 200.5

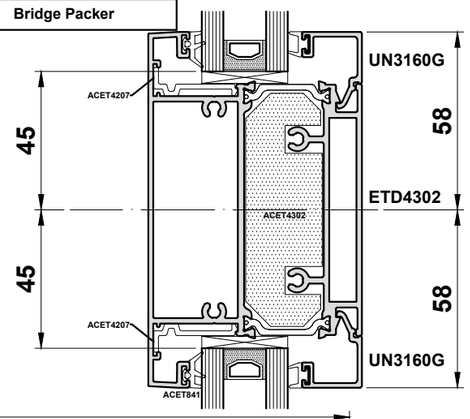
Accessories		
ACCY3560S3	2	Euro Cylinder
ACDV251	2 Pair	Handles
ACDV737	2	Shootbolt
ACDV738	2	Shootbolt
ACET060	40	Screw for Lock & Keep
ACET060	8	Screw for ACDV737/738
ACET131	4	Drainage Cap
ACET4147	Pair	ETD447 End Cap
ACET475	4	Run Up Block
ACIM062	24	Screw for ACUL250
ACET4207	20	Bridge Packers
ACUL076	H - 110	Floating Mullion Foam
ACUL077	2 x W & 2 x H	Outer Frame Foam
ACET4205	4 x W / 2 & 4 x H	Sash Foam
ACET841	4 x W / 2 & 4 x H	E Gasket
ACUL210A	4	Outer Frame Cleat
ACUL210B	4	Outer Frame Cleat
ACUL224	8	Sash Cleat
ACUL225	8	Sash Cleat
ACUL250	6	Hinge
ACUL276	1	Double Door Secondary Lock
ACUL277/8	1	Double Door Primary Lock
ACUL279	1	Double Door Keep Kit

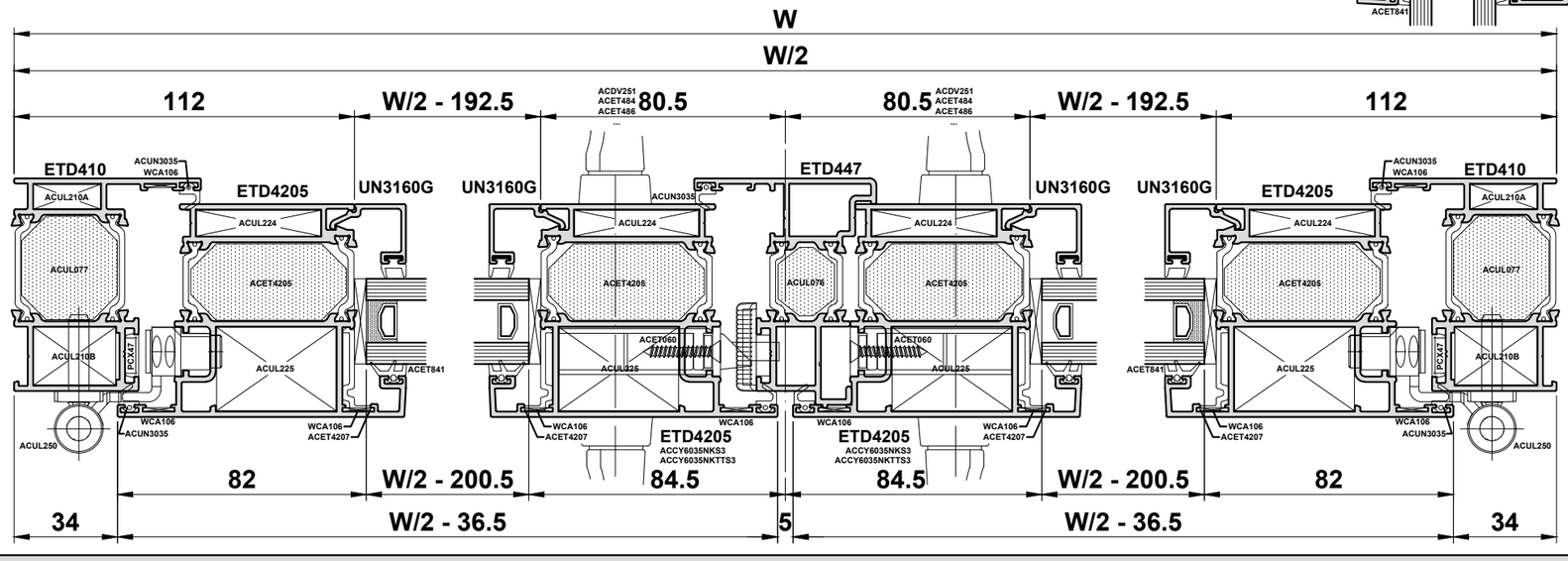
ACUN3035	4 x W & 7 x H	Flipper Gasket
ACUN3512	18	Screw for ACUL250
ACUN3513	2 + H / 300	Screw for ETD447
ACVL059 / ACVL072	2 Pair	VL72 End Cap
ACVL061	W/300 + 2	VL72 Rivet
WCA106	20	Chevrons



*See Page E72 for lock options.
**See B & E for handle options.

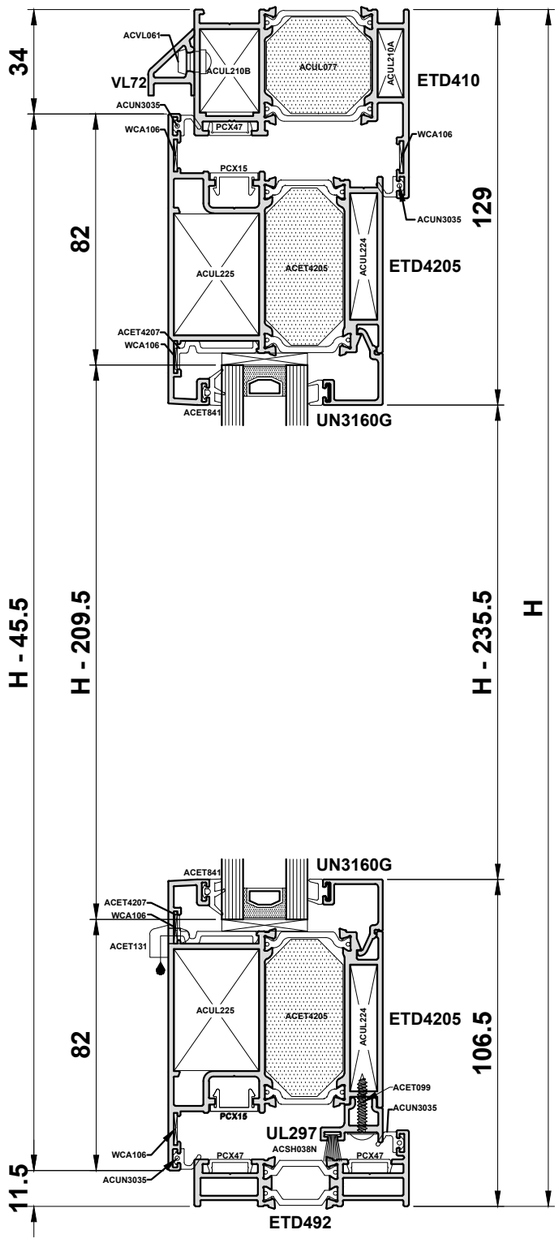
Midrail Accessories		
ACET4302	2 x W / 2	ETD4302 Foam
ACUN3512	8	Screws
ACET841	4 x W	E Gasket
ACET4207	8	Bridge Packer





Do Not Scale From This Drawing

Open Out Double Door Lift Lever Low Rebate Threshold Quick-Glaze Bead

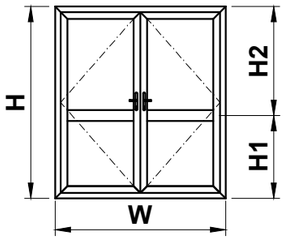


Profile Cutting Schedule			
UN3160G	4		H - 235.5
UN3160G	4		W / 2 - 192.5
ETD410	1		W
ETD410	2		H - 15.5
ETD4205	4		W / 2 - 36.5
ETD4205	4		H - 45.5
ETD447	1		H - 81
ETD492	1		W
UL297	2		W / 2 - 79.5
PCX15	4		H - 106
PCX15	4		W / 2 - 106
PCX47	2		H - 82
PCX47	1		H - 81
PCX47	2		W / 2 - 82
VL72	1		W - 11
MIDRAIL ETD4302	2		W / 2 - 192.5
MIDRAIL UN3160G	8		W / 2 - 192.5
MIDRAIL UN3160G	4		H2 - 187
MIDRAIL UN3160G	4		H1 - 164.5

Glass Sizes		
Without ETD4302	H - 209.5	W / 2 - 200.5
Top Glass With ETD4302	H2 - 161	W / 2 - 200.5
Bottom Glass With ETD4302	H1 - 138.5	W / 2 - 200.5

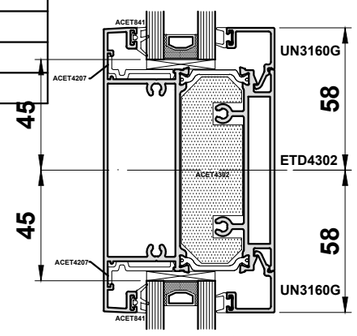
Accessories		
ACCY3560S3	2	Euro Cylinder
ACDV251	2 Pairs	Handles
ACDV737	2	Bottom Shootbolt
ACDV738	2	Top Shootbolt
ACET060	40	Screw for Lock & Keep
ACET060	8	Screw for ACDV737/738
ACET099	W / 2 - 100 / 300	Fixing Screw for UL297
ACET4146	Pair	ETD447 End Cap at Cill
ACET4147	Pair	ETD447 End Cap at Head
ACET4192	Pair	ETD492 End Cap
ACET4197	2 Pairs	UL297 End Cap
ACET4205	4 x W / 2 & 4 x H	Sash Foam
ACET4207	20	Bridge Packers
ACET475	4	Run Up Block
ACET841	4 x W / 2 & 4 x H	E Gasket
ACIM062	24	Screw for ACUL250
ACSH038N	1 x W	Woolpile
ACUL076	H - 81	Floating Mullion Foam
ACUL077	W & 2 x H	Outer Frame Foam
ACUL210A	2	Outer Frame Cleat
ACUL210B	2	Outer Frame Cleat
ACUL224	8	Sash Cleat
ACUL225	8	Sash Cleat

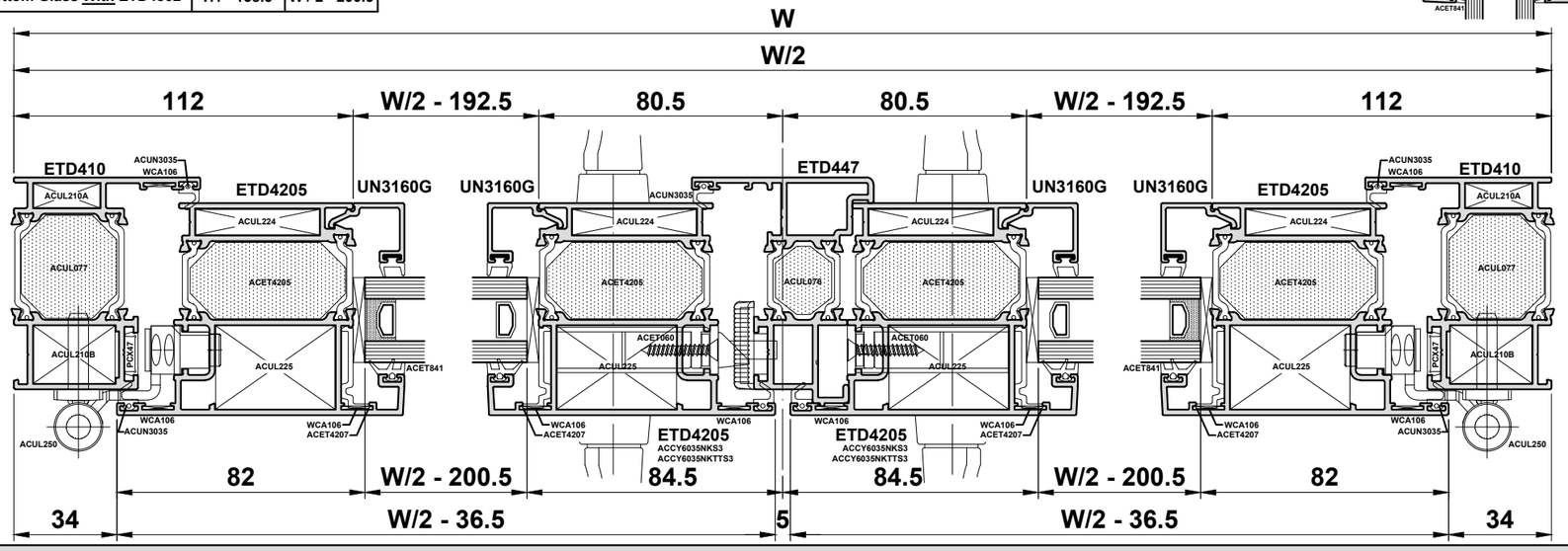
ACUL250	6	Hinge
ACUL276	1	Double Door Secondary Lock
ACUL277/8	1	Double Door Primary Lock
ACUL279	1	Double Door Keep Kit
ACUL295	2	Low Threshold Bracket
ACUN3035	4 W & 7 x H	Flipper Gasket
ACUN3512	18	Screw for ACUL250
ACUN3513	2 + H / 300	Screw for ETD447
ACVL059 / ACVL072	2 Pair	VL72 End Cap
ACVL061	W/300 + 2	VL72 Rivet
WCA106	18	Chevrons



*See Page E72 for lock options.
**See B & E for handle options.

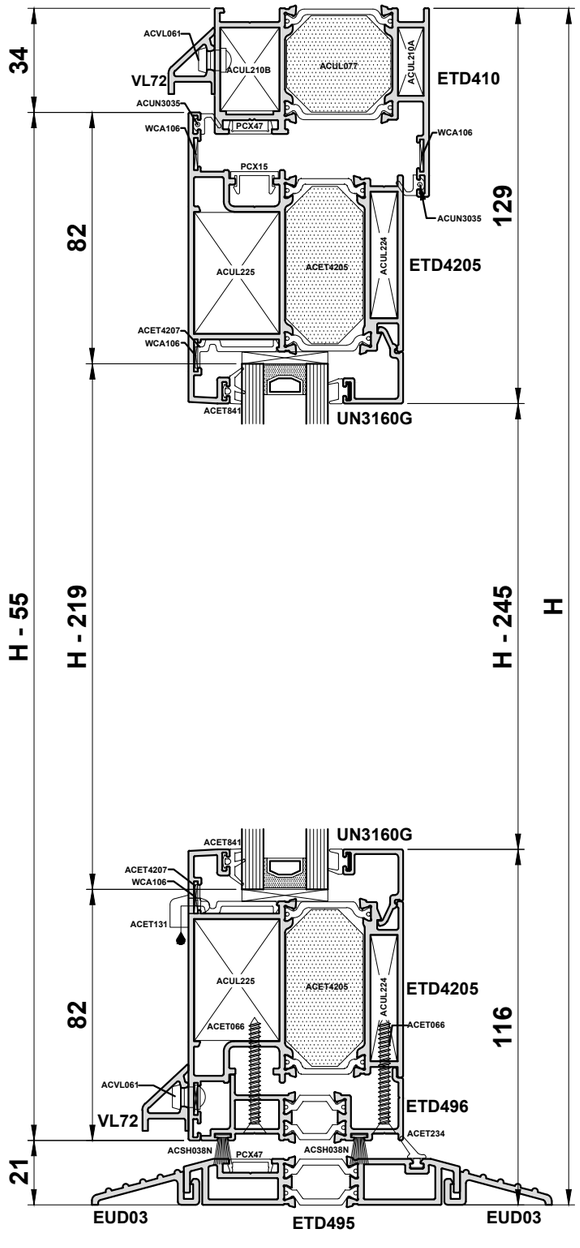
Midrail Accessories		
ACET4302	2 x W / 2	ETD4302 Foam
ACUN3512	8	Screws
ACET841	4 x W	E Gasket
ACET4207	8	Bridge Packer





Do Not Scale From This Drawing

Open Out Double Door Lift Lever Low Ramp Threshold Quick-Glaze Bead



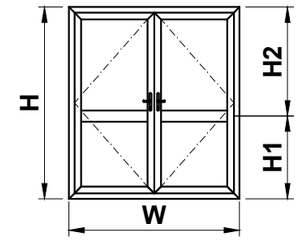
Profile Cutting Schedule			
ETD410	1		W
ETD410	2		H - 15
ETD495	1		W
EUD03	2		W
ETD4205	4		W / 2 - 36.5
ETD4205	4		H - 55
ETD496	2		W / 2 - 84.5
ETD447	1		H - 81
UN3160G	4		H - 245
UN3160G	4		W / 2 - 192.5
PCX15	4		H - 53.5
PCX15	4		W / 2 - 106
PCX47	2		H - 55
PCX47	1		H - 81
PCX47	2		W / 2 - 82
VL72	1		W - 11
VL72	2		W / 2 - 49.5
MIDRAIL	ETD4302	2	W / 2 - 192.5
	UN3160G	8	W / 2 - 192.5
	UN3160G	4	H1 - 175
	UN3160G	4	H2 - 188

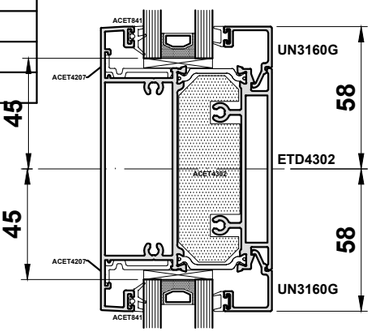
Glass Sizes		
Without ETD4302	H - 219	W / 2 - 200.5
Top Glass With ETD4302	H2 - 161	W / 2 - 200.5
Bottom Glass With ETD4302	H1 - 148	W / 2 - 200.5

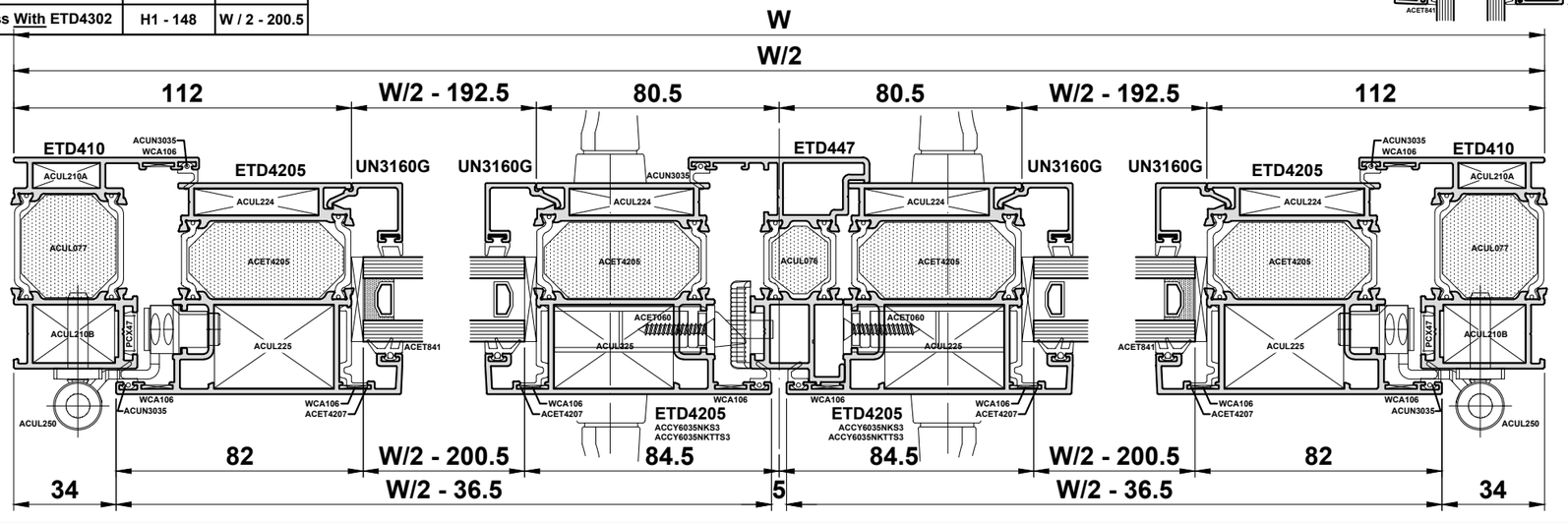
Accessories		
ACCY3560S3	2	Euro Cylinder
ACDV251	2 Pairs	Handles
ACDV737	2	Shootbolt
ACDV738	2	Shootbolt
ACET060	4	Fixing Screw for ACET4195
ACET060	40	Screw for Lock & Keep
ACET060	8	Screw for ACDV737/738
ACET066	2 x W - 100 / 300	Fixing Screw for ETD496
ACET234	1 x W	Flipper Gasket
ACET4142	Kit	ETD447/ETD496 End Cap
ACET4147	Kit	End Cap at Head
ACET4195	Pair	ETD495 End Cap
ACET4196	Pair	ETD496 End Cap
ACET4205	4 x W / 2 & 4 x H	Sash Foam
ACET4207	20	Bridge Packers
ACET475	4	Run Up Block
ACET841	4 x W / 2 & 4 x H	E Gasket
ACIM062	24	Screw for ACUL250
ACSH038N	2 x W	Woolpile
ACUL076	H - 81	Floating Mullion Foam
ACUL077	W & 2 x H	Outer Frame Foam
ACUL210A	2	Outer Frame Cleat
ACUL210B	2	Outer Frame Cleat
ACUL224	8	Sash Cleat
ACUL225	8	Sash Cleat
ACUL250	6	Hinge
ACUL276	1	Double Door Secondary Lock
ACUL277/8	1	Double Door Primary Lock
ACUL279	1	Double Door Keep Kit
ACUL295	2	Low Threshold Bracket
ACUN3035	4 x W & 7 x H	Flipper Gasket
ACUN3512	18	Screw for ACUL250
ACUN3513	2 + H / 300	Screw for ETD447
ACVL059 / ACVL072	2 Pair	VL72 End Cap
ACVL061	W/300 + 2	VL72 Rivet
WCA106	18	Chevrons

*See Page E72 for lock options.
**See B & E for handle options.

Midrail Accessories		
ACET4302	2 x W / 2	ETD4302 Foam
ACUN3512	8	Screws
ACET841	4 x W	E Gasket
ACET4207	8	Bridge Packer



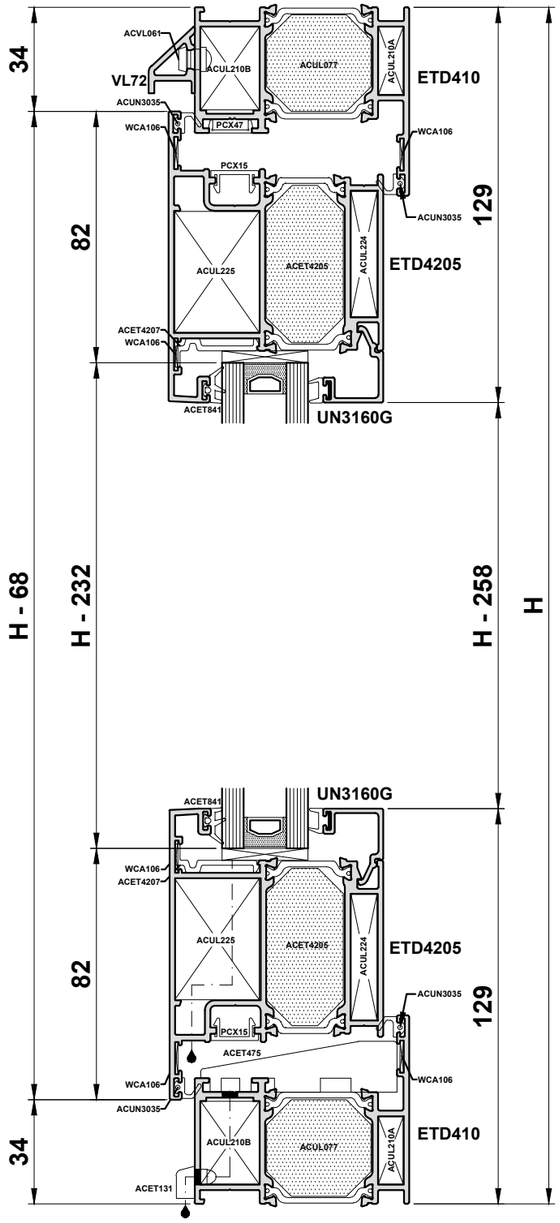




Do Not Scale From This Drawing

Alitherm 400 Stepped Door

Open Out Double Door Finger Bolt Full Frame Quick-Glaze Bead



Profile Cutting Schedule				
UN3160G	4			H - 258
UN3160G	4			W / 2 - 196
ETD410	2			W
ETD410	2			H
ETD4205	4			W / 2 - 40
ETD4205	4			H - 68
ETD448	1			H - 110
PCX15	4			H - 106
PCX15	4			W / 2 - 106
PCX47	2			H - 82
PCX47	1			H - 81
PCX47	2			W / 2 - 82
VL72	1			W - 11
MIDRAIL: ETD4302	2			W / 2 - 196
MIDRAIL: UN3160G	8			W / 2 - 196
MIDRAIL: UN3160G	4			H1 - 187
MIDRAIL: UN3160G	4			H2 - 187

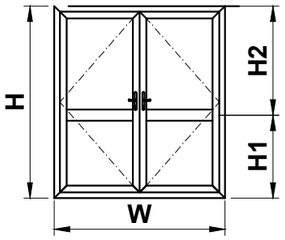
Glass Sizes		
Without ETD4302	H - 232	W / 2 - 204
Top Glass With ETD4302	H2 - 161	W / 2 - 204
Bottom Glass With ETD4302	H1 - 161	W / 2 - 204

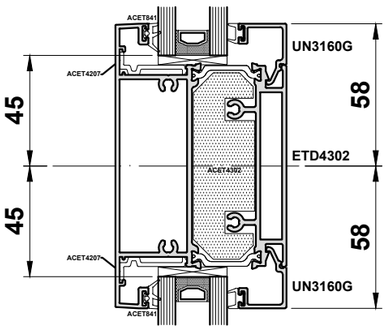
Accessories		
ACCY3560S3	1	Euro Cylinder
**	**	Handles
ACET060	16	Screw for Lock
ACET131	X	Drainage Cap
ACET4148	Pair	ETD448 End Cap
ACET4205	2 x W & 4 x H	Sash Foam
ACET4207	20	Bridge Packers
ACET475	4	Run Up Block
ACIM062	24	Screw for ACUL250
ACPD844	1	Shootbolt Adaptor
ACPD84..	1	10mm Dia Glavanised Rod
ACSM015	Pair	Escutcheon
ACUL077	2 x W & 2 x H	Outer Frame Foam
ACUL210A	4	Outer Frame Cleat
ACUL210B	4	Outer Frame Cleat
ACUL224	8	Sash Cleat
ACUL225	8	Sash Cleat
ACUL242	2	Finger Bolt Guide
ACUL250	6	Hinge
ACUL390	Pair	Finger Bolt Flat Keep
ACUN3035	4 x W & 6 x H	Flipper Gasket
ACUN3512	18	Screw for ACUL250
ACUN3513	2 + H / 300	Screw for ETD448

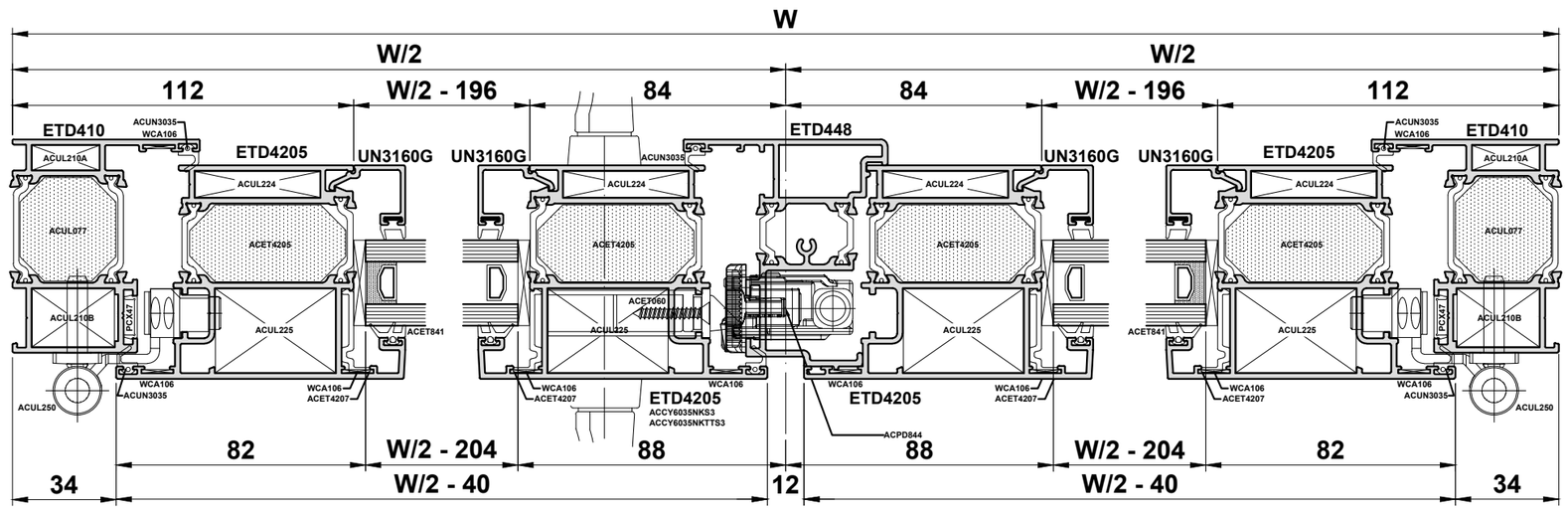
ACET841	2 x W & 4 x H	E Gasket
ACVL072	2 Pair	VL72 End Cap
ACVL061	W/300 + 2	VL72 Rivet
WCA106	20	Chevrons
*	1	Double Door Primary Lock

*See Page E72 for lock options.
**See B & E for handle options.

Midrail Accessories		
ACET4302	2 x W / 2	ETD4302 Foam
ACUN3512	8	Screws
ACET841	4 x W	E Gasket
ACET4207	8	Bridge Packer

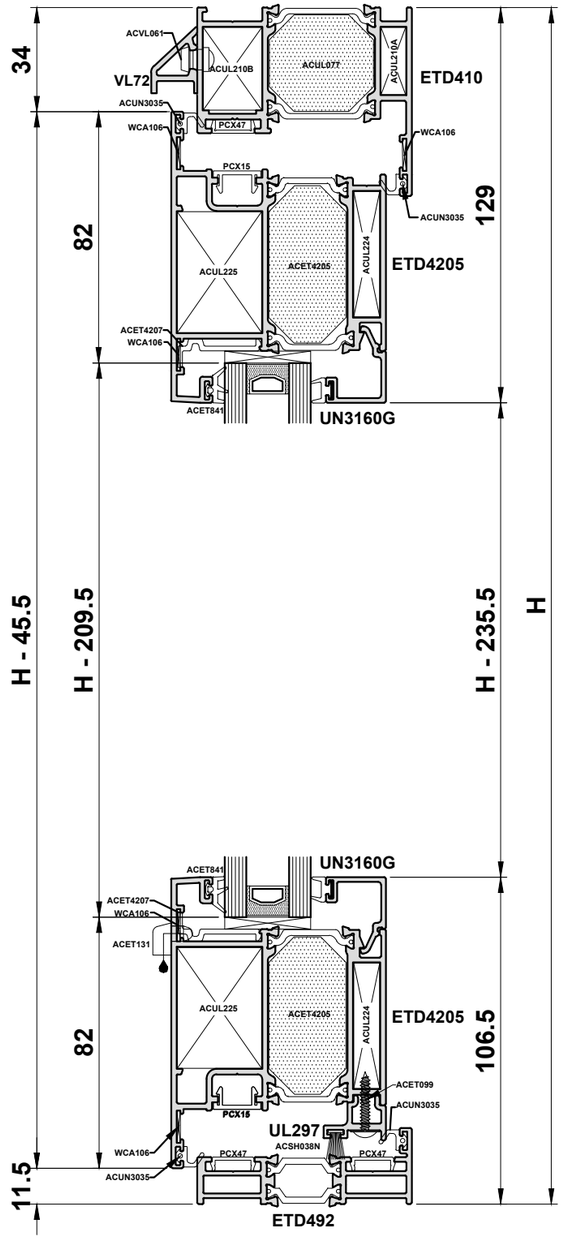






Do Not Scale From This Drawing

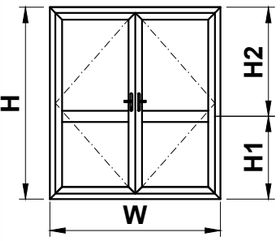
Open Out Double Door Finger Bolt Low Rebate Threshold Quick-Glaze Bead



Profile Cutting Schedule				
ETD410	1			W
ETD410	2			H - 15.5
ETD492	1			W
ETD4205	4			W / 2 - 40
ETD4205	4			H - 45.5
ETD448	1			H - 81
UL297	2			W / 2 - 83
UN3160G	4			H - 235.5
UN3160G	4			W / 2 - 196
PCX15	2			H - 106
PCX15	4			W / 2 - 106
PCX47	2			H - 82
PCX47	1			H - 81
PCX47	2			W / 2 - 82
VL72	1			W - 11
MIDRAIL ETD4302	2			W / 2 - 196
MIDRAIL UN3160G	8			W / 2 - 196
MIDRAIL UN3160G	4			H1 - 164.5
MIDRAIL UN3160G	4			H2 - 187

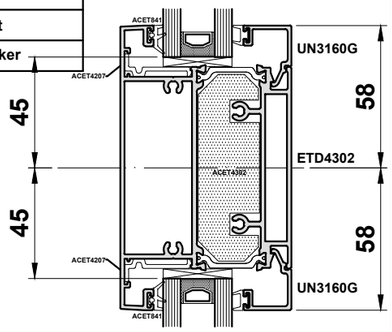
Glass Sizes		
Without ETD430	H - 209.5	W / 2 - 204
Top Glass With ETD430	H2 - 161	W / 2 - 204
Bottom Glass With ETD430	H1 - 138.5	W / 2 - 204

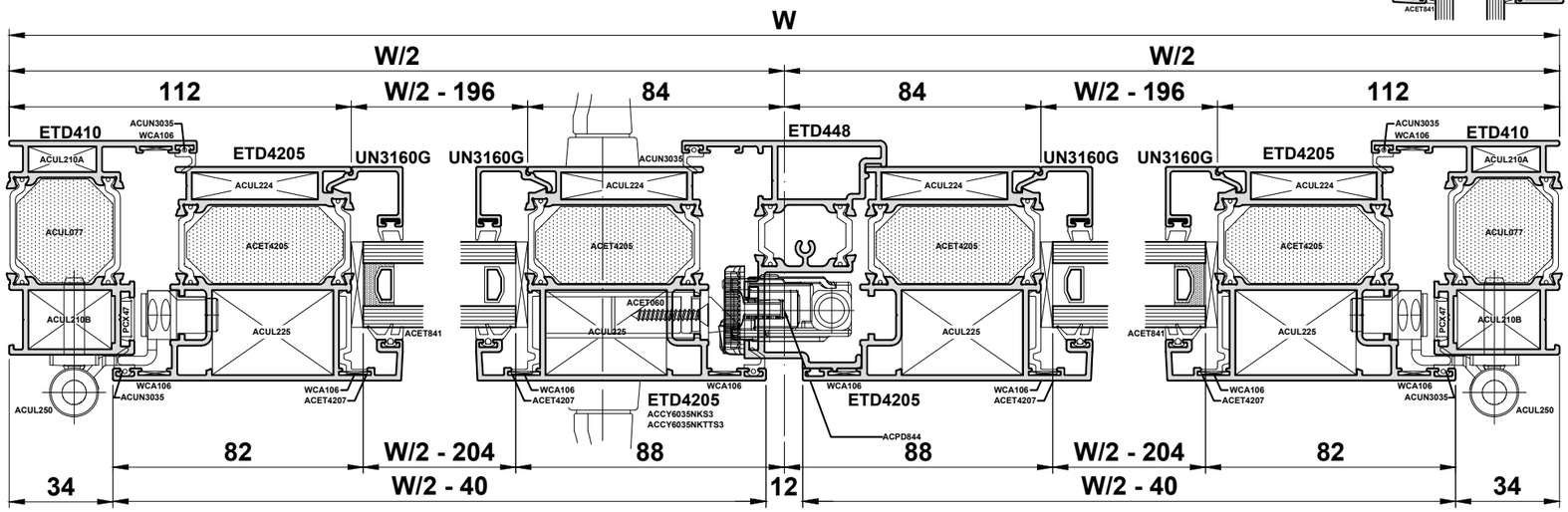
Accessories		
ACCY3560S3	1	Euro Cylinder
**	**	Handles
ACET060	4	Screw for ACET4190
ACET060	16	Screw for Lock
ACET099	W / 2 - 100 / 300	Fixing Screw for UL297
ACET4145	Pair	ETD448 End Cap
ACET4148	Pair	ETD448 End Cap at Head
ACET4190	Pair	ETD490 End Cap
ACET4192	Pair	ETD492 End Cap
ACET4197	2 Pairs	UL297 End Cap
ACET4205	4 x W / 2 & 4 x H	Sash Foam
ACET4207	20	Bridge Packers
ACET475	4	Run Up Block
ACET841	4 x W / 2 & 4 x H	E Gasket
ACIM062	24	Screw for ACUL250
ACPD844	1	Shootbolt Adaptor
ACPD84..	1	10mm Dia Glavanised Rod
ACSH038N	1 x W	Woolpile
ACSM015	Pair	Escutcheon
ACUL077	W & 2 x H	Outer Frame Foam
ACUL210A	2	Outer Frame Cleat
ACUL210B	2	Outer Frame Cleat
ACUL224	8	Sash Cleat
ACUL225	8	Sash Cleat
ACUL242	1	Finger Bolt Guide
ACUL250	6	Hinge
ACUL295	2	Low Threshold Bracket
ACUL390	Pair	Finger Bolt Flat Keep
ACUN3035	4 x W & 6 x H	Flipper Gasket
ACUN3512	18	Screw for ACUL250
ACUN3513	2 + H / 300	Screw for ETD448
ACVL072	2 Pair	VL72 End Cap
ACVL061	W/300 + 2	VL72 Rivet
WCA106	18	Chevrons
*	1	Double Door Primary Lock



*See Page E72 for lock options.
**See B & E for handle options.

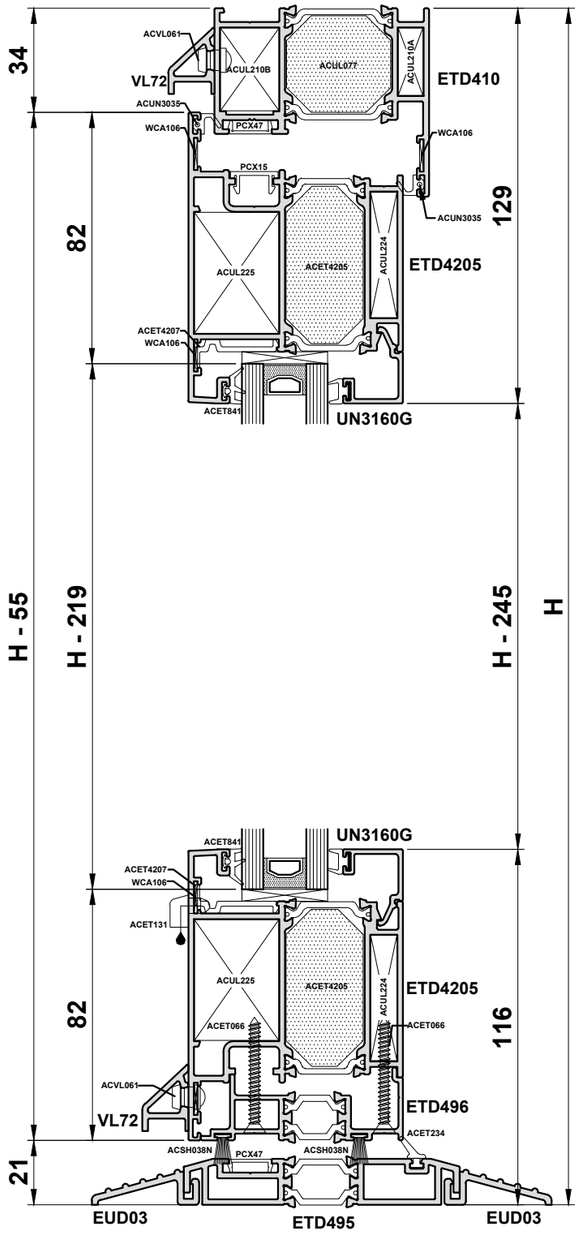
Midrail Accessories		
ACET4302	2 x W / 2	ETD4302 Foam
ACUN3512	8	Screws
ACET841	4 x W	E Gasket
ACET4207	8	Bridge Packer





Do Not Scale From This Drawing

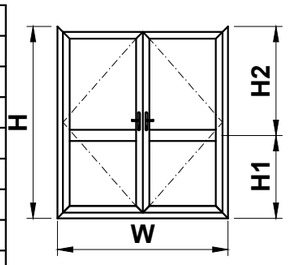
Open Out Double Door Finger Bolt Low Ramp Threshold Quick-Glaze Bead



Profile Cutting Schedule			
UN3160G	4		H - 245
UN3160G	4		W / 2 - 196
ETD410	1		W
ETD410	2		H - 15
ETD4205	4		W / 2 - 40
ETD4205	4		H - 55
ETD448	1		H - 81
ETD495	1		W
ETD496	2		W / 2 - 88
EUD03	2		W
PCX15	2		H - 53.5
PCX15	4		W / 2 - 106
PCX47	2		H - 55
PCX47	1		H - 81
PCX47	2		W / 2 - 82
VL72	1		W - 11
VL72	2		W / 2 - 53
MIDRAIL: ETD4302	2		W / 2 - 196
MIDRAIL: UN3160G	8		W / 2 - 196
MIDRAIL: UN3160G	4		H1 - 174
MIDRAIL: UN3160G	4		H2 - 187

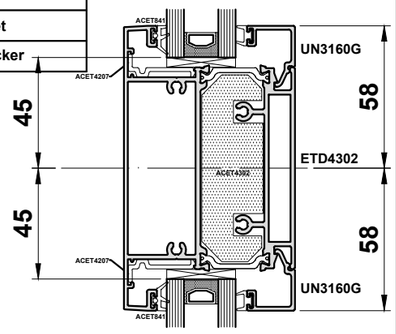
Glass Sizes		
Without ETD4302	H - 219	W / 2 - 204
Top Glass With ETD4302	H2 - 161	W / 2 - 204
Bottom Glass With ETD4302	H1 - 148	W / 2 - 204

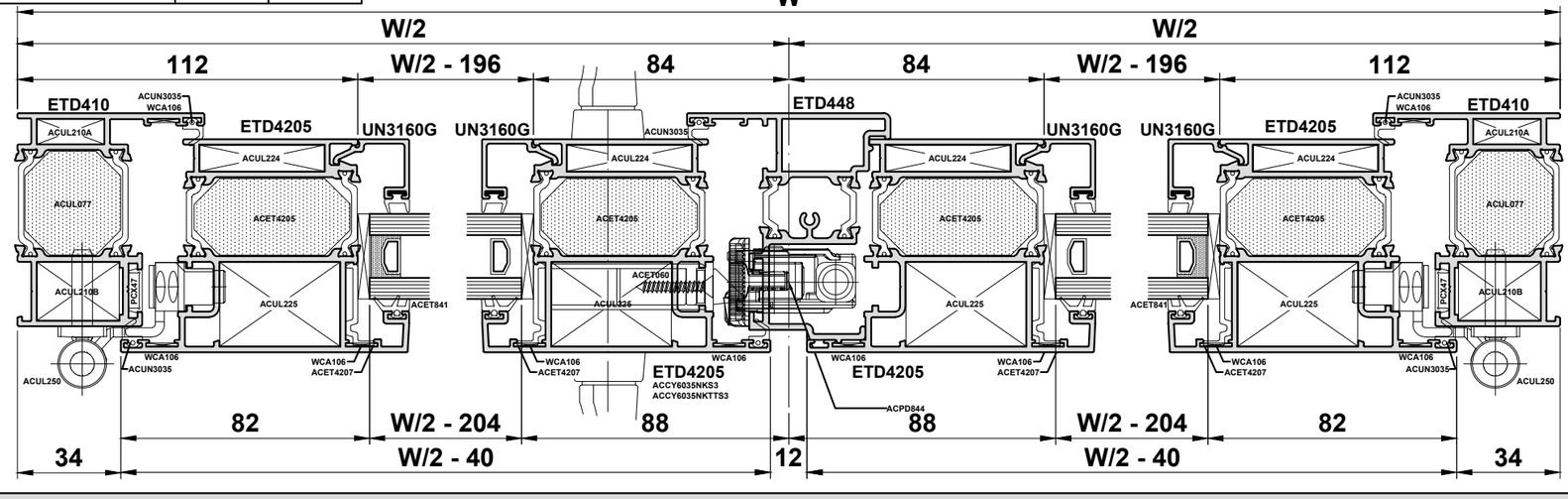
Accessories		
ACCY3560S3	1	Euro Cylinder
**	**	Handles
ACET060	4	Fixing Screw for ACET4195
ACET060	16	Screw for Lock
ACET066	2 x W - 100 / 300	Fixing Screw for ETD496
ACET234	1 x W	Flipper Gasket
ACET4190	Pair	ETD490 End Cap
ACET4143	Kit	ETD448/ETD496 End Cap
ACET4148	Pair	ETD448 End Cap at Head
ACET4195	Pair	ETD495 End Cap
ACET4196	Pair	ETD496 End Cap
ACET4205	4 x W / 2 & 4 x H	Sash Foam
ACET4207	20	Bridge Packers
ACET475	4	Run Up Block
ACET841	4 x W / 2 & 4 x H	E Gasket
ACIM062	24	Screw for ACUL250
ACPD844	1	Shootbolt Adaptor
ACPD84..	1	10mm Dia Glavanised Rod
ACSH038N	2 x W	Woolpile
ACSM015	Pair	Escutcheon
ACUL077	W & 2 x H	Outer Frame Foam
ACUL210A	2	Outer Frame Cleat
ACUL210B	2	Outer Frame Cleat
ACUL224	8	Sash Cleat
ACUL225	8	Sash Cleat
ACUL242	1	Finger Bolt Guide
ACUL250	6	Hinge
ACUL295	2	Low Threshold Bracket
ACUL390	Pair	Finger Bolt Flat Keep
ACUN3035	4 x W & 6 x H	Flipper Gasket
ACUN3512	18	Screw for ACUL250
ACUN3513	2 + H / 300	Screw for ETD448
ACVL072	2 Pair	VL72 End Cap
ACVL061	W/300 + 2	VL72 Rivet
WCA106	18	Chevrons
*	1	Double Door Primary Lock



*See Page E72 for lock options.
**See B & E for handle options.

Midrail Accessories		
ACET4302	2 x W / 2	ETD4302 Foam
ACUN3512	8	Screws
ACET841	4 x W	E Gasket
ACET4207	8	Bridge Packer

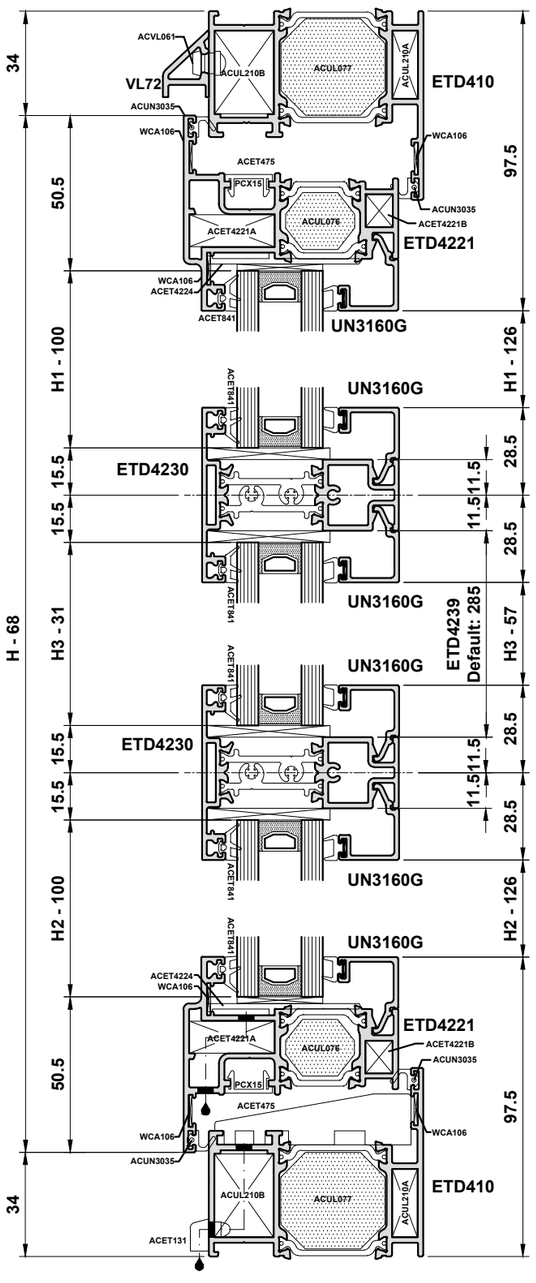




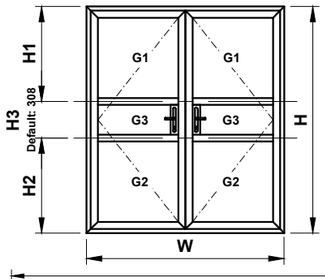
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Alitherm 400 Stepped Door

Open Out Heritage Double Door Full Frame Quick-Glaze Bead



Profile Cutting Schedule			
ETD410	2		W
ETD410	2		H
ETD4221	4		W/2 - 36.5
ETD4221	4		H - 68
ETD4247	1		H - 110
UN3160G	8		W/2 - 129.5
UN3160G	4		W/2 - 193
UN3160G	4		H1 - 126
UN3160G	4		H2 - 126
UN3160G	4		H3 - 57
ETD4230	4		W/2 - 129.5
ETD4239	2		285
PCX15	4		H - 106
PCX15	4		W/2 - 75.5
PCX47	2		H - 82
PCX47	2		W - 82
PCX47	2		H - 110
VL72	1		W - 11

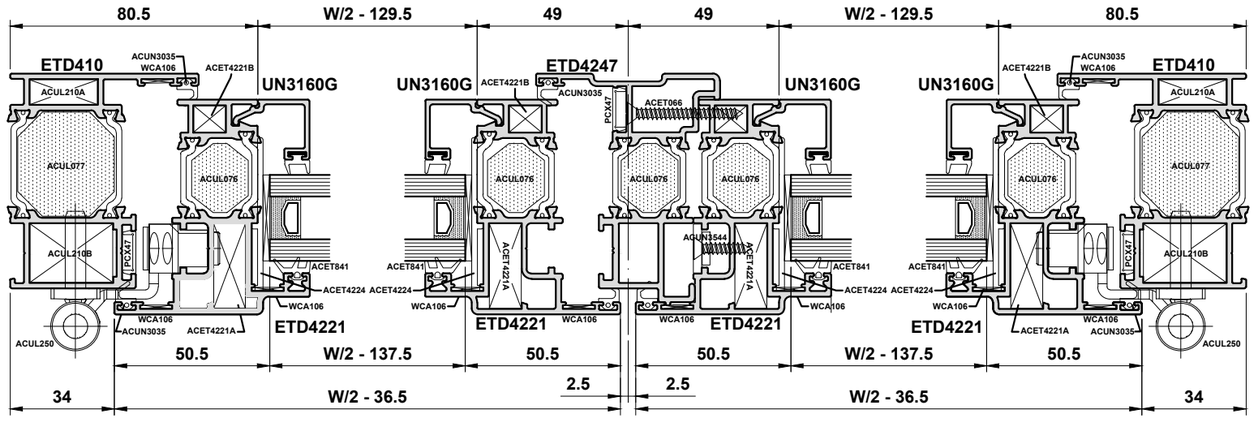


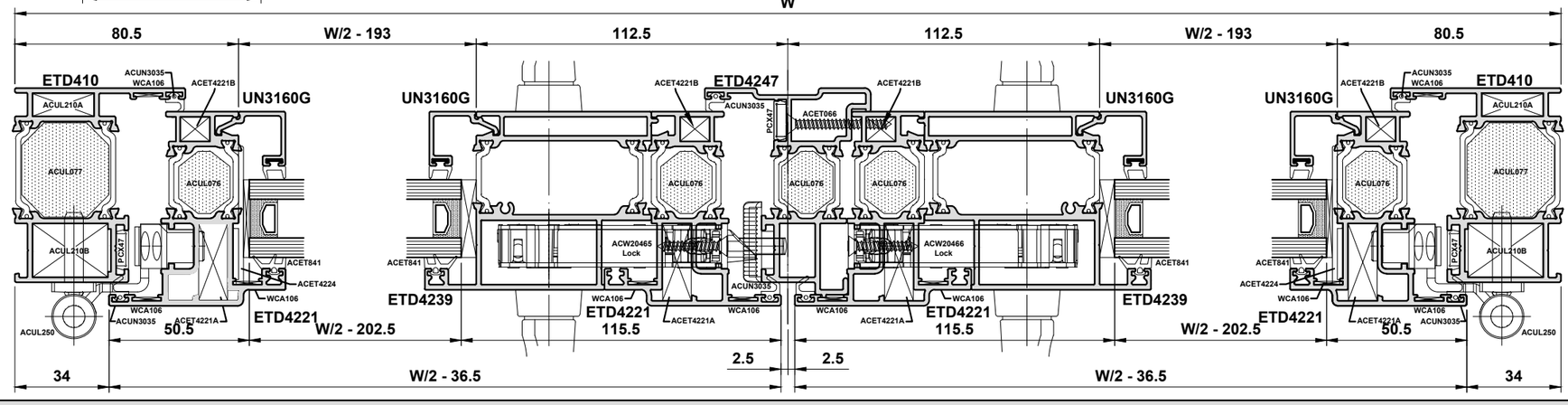
Accessories		
ACUL210A	4	Outerframe Cleat
ACUL210B	4	Outerframe Cleat
ACET4221A	8	Sash Cleat
ACET4221B	8	Sash Cleat
ACET4224	14	Bridge Packers
WCA106	12	Chevrons
ACUN3035	4W + 7H	Flipper Gasket
ACUL076	2W + 4H	Sash Foam
ACUL076	H - 110	Floating Mullion Foam
ACUL077	2W + 4H	Outerframe Foam
E Gasket	6W + 4H	Glazing Gasket
ACET475	4	Run Up Block
ACET062	8	Transom Screws

ACET066	12	Transom Screws
ACVL061	W / 300 + 2	Pop Rivets
ACVL059	Pair	Drip End Cap
ACUL250	6	Hinges
ACUN3512	18	Hinge Screw
ACUN3577	24	Hinge Screw
ACET4247	Pair	EDT4247 End Cap
ACET066	2 + H / 300	Screw for ETD4247
ACET131	4	Drainage Cap
ACW20465	1	Master Lock
ACW20466	1	Slave Lock
ACDV737	2	Bottom Shootbolt
ACDV738	2	Top Shootbolt

ACW20066 L/R	1	Center Keep
ACW20367	4	Keep
ACUL279	2	Shootbolt Keep
ACUN3544	32	Screw For Lock
Page E50	2	Euro Cylinder
Page E50	2	Handles

Glass Sizes		
G1	H1 - 100	W/2 - 137.5
G2	H2 - 100	W/2 - 137.5
G3	H3 - 31	W/2 - 202.5

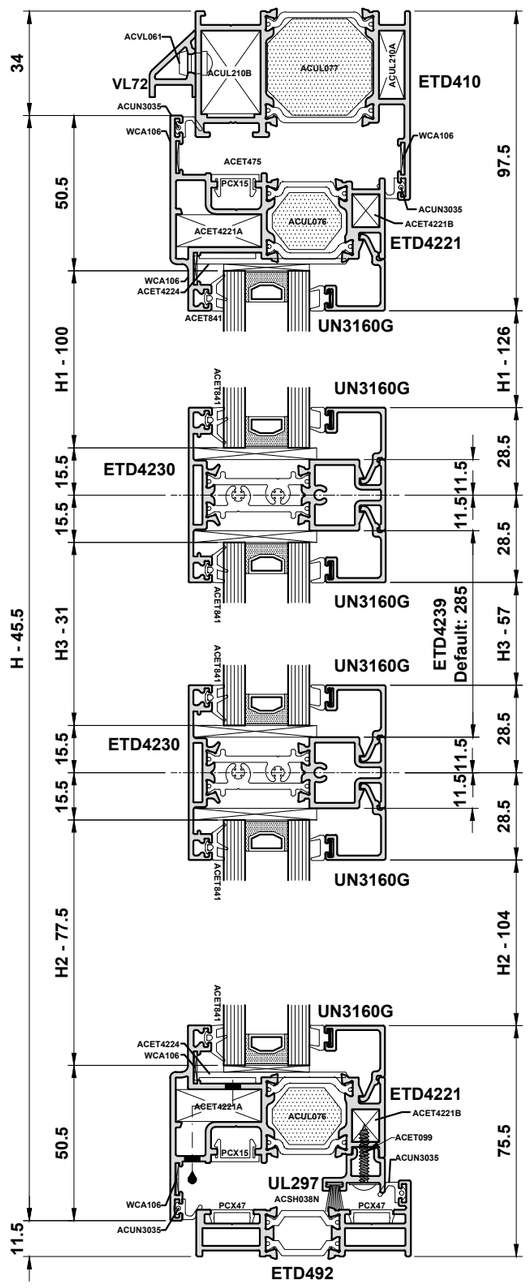




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Alitherm 400 Stepped Door

Open Out Heritage Double Door Low Rebate Quick-Glaze Bead



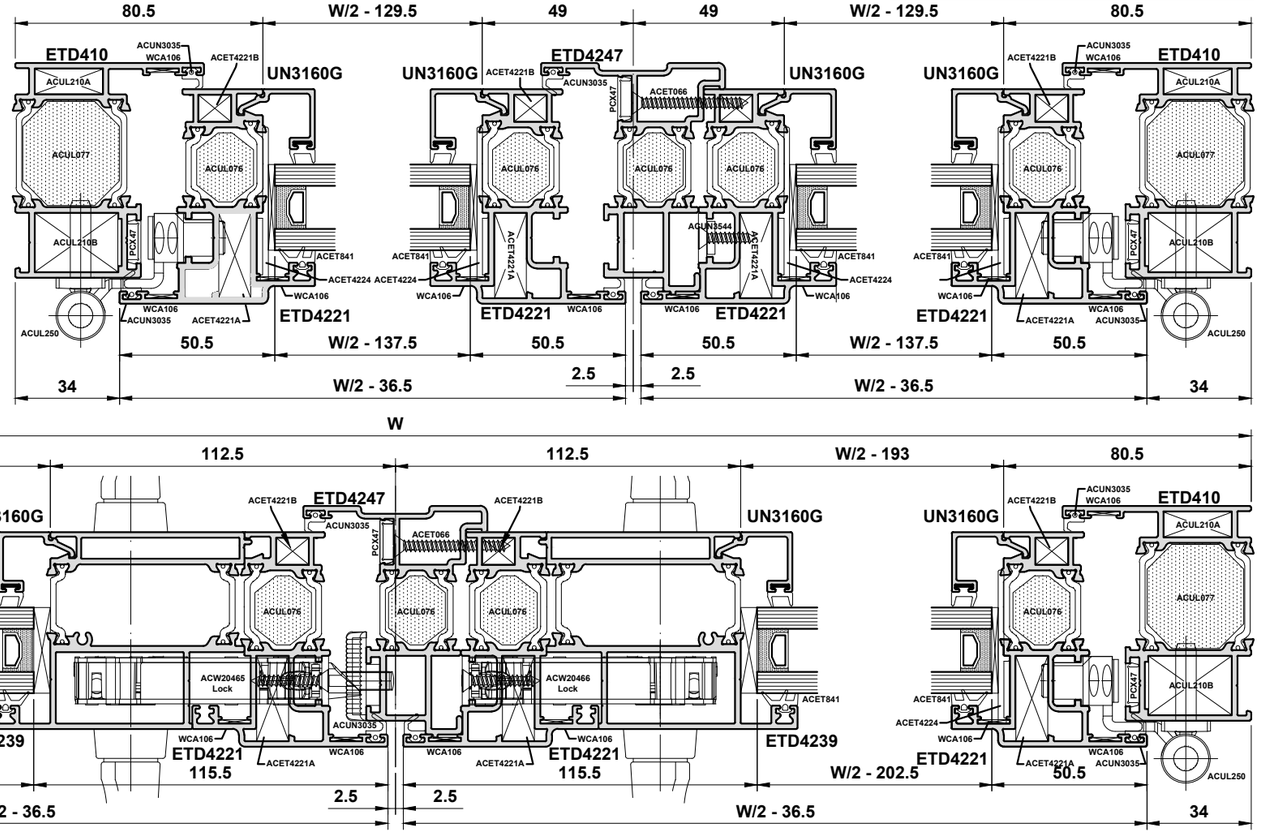
Profile Cutting Schedule			
ETD410	1		W
ETD410	Pair		H - 15.5
ETD492	1		W
ETD4221	4		W/2 - 36.5
ETD4221	4		H - 45.5
ETD297	2		W/2 - 79.5
ETD4247	1		H - 81
UN3160G	8		W/2 - 129.5
UN3160G	4		W/2 - 193
UN3160G	4		H1 - 126
UN3160G	4		H2 - 104
UN3160G	4		H3 - 57
ETD4230	4		W/2 - 129.5
ETD4239	2		285
PCX15	4		H - 83.5
PCX15	4		W/2 - 75.5
PCX47	2		H - 56.5
PCX47	3		W - 82
PCX47	2		H - 81
VL72	1		W - 11

Accessories		
ACUL210A	2	Outerframe Cleat
ACUL210B	2	Outerframe Cleat
ACUL025	2	Anti-Twist Clip
ACUL295	2	Low Threshold Bracket
ACMX852	2	M6 x 16 Screw
ACET060	4	Screw For End Cap
ACET099	W - 100 / 300	Screw For UL297
ACET4192	Pair	ETD492 End Cap
ACET4197	2 Pair	UL297 End Cap
ACET4221A	8	Sash Cleat
ACET4221B	8	Sash Cleat
ACET4224	14	Bridge Packers
WCA106	10	Chevrons
ACUN3035	4W + 7H	Flipper Gasket

ACUL076	2W + 4H	Sash Foam
ACUL076	H - 110	Floating Mullion Foam
ACUL077	1W + 2H	Outerframe Foam
E Gasket	6W + 4H	Glazing Gasket
ACSH038N	W - 113	Woolpile
ACET062	8	Transom Screws
ACET066	12	Transom Screws
ACVL061	W / 300 + 2	Pop Rivets
ACVL059	Pair	Drip End Cap
ACUL250	6	Hinges
ACUN3512	18	Hinge Screw
ACUN3577	24	Hinge Screw
ACET4246	Pair	EDT4247 Cill End Cap
ACET4247	Pair	EDT4247 Head End Cap
ACET066	2 + H / 300	Screw for ETD4247

ACET131	4	Drainage Cap
ACW20465	1	Master Lock
ACW20466	1	Slave Lock
ACDV737	2	Bottom Shootbolt
ACDV738	2	Top Shootbolt
ACW20066 L/R	1	Center Keep
ACW20367	4	Keep
ACUL279	2	Shootbolt Keep
ACUN3544	32	Screw For Lock
Page E50	2	Euro Cylinder
Page E50	2	Handles

Glass Sizes		
G1	H1 - 100	W/2 - 137.5
G2	H2 - 77.5	W/2 - 137.5
G3	H3 - 31	W/2 - 202.5



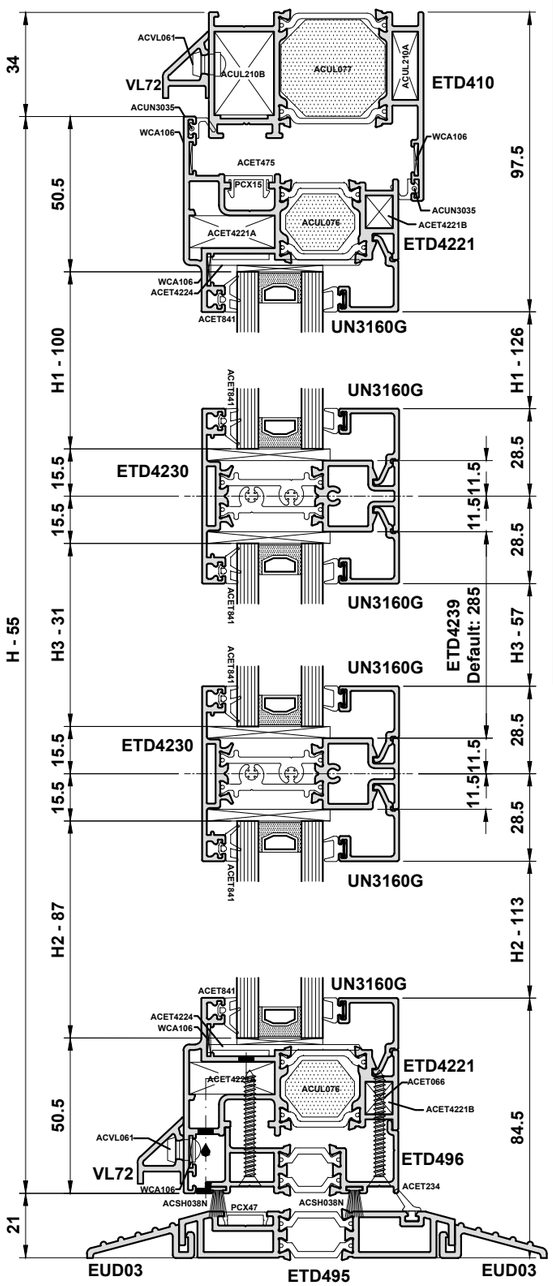
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smart architectural aluminium

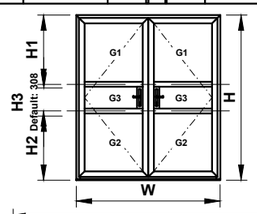
Alitherm 400 Stepped Door

SAWING TABLES : OPEN OUT

Open Out Heritage Double Door Low Ramp Quick-Glaze Bead

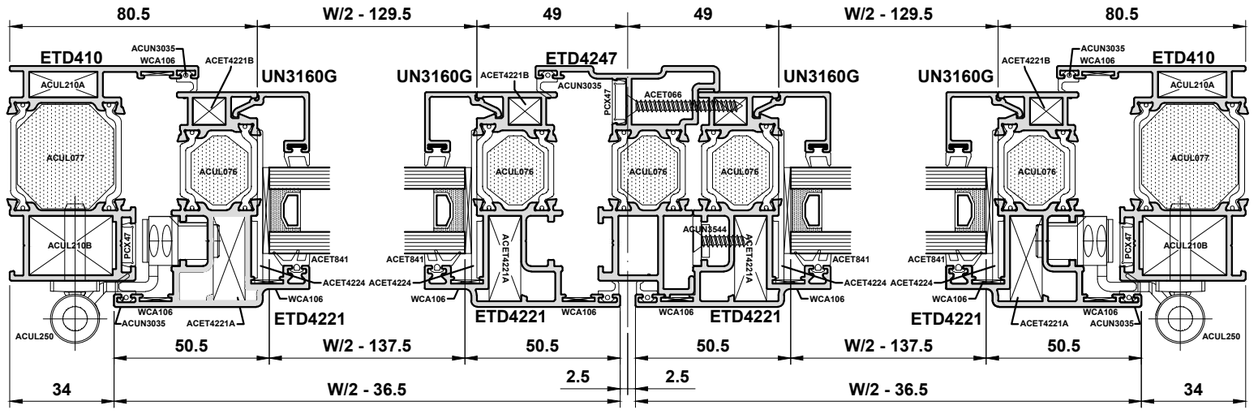


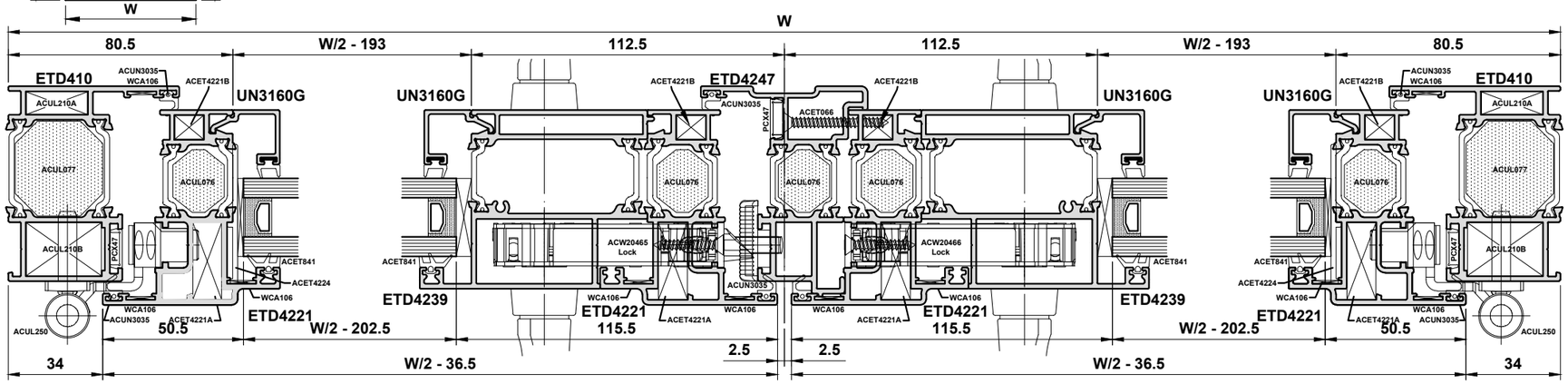
Profile Cutting Schedule			
ETD410	1		W
ETD410	Pair		H - 15
ETD495	1		W
EUD03	2		W
ETD4221	4		W/2 - 36.5
ETD4221	4		H - 55
ETD496	2		W/2 - 84.5
ETD4247	1		H - 81
UN3160G	8		W/2 - 129.5
UN3160G	4		W/2 - 193
UN3160G	4		H1 - 126
UN3160G	4		H2 - 113
UN3160G	4		H3 - 57
ETD4230	4		W/2 - 129.5
ETD4239	2		285
PCX15	4		H - 84
PCX15	4		W/2 - 75.5
PCX47	2		H - 57
PCX47	2		W - 82
PCX47	2		H - 81
VL72	2		W/2 - 49.5
VL72	1		W - 11



Accessories		
ACUL210A	2	Outerframe Cleat
ACUL210B	2	Outerframe Cleat
ACUL295	2	Low Threshold Bracket
ACMX852	2	M6 x 16 Screw
ACET060	4	Screw For End Cap
ACET4196	2 Pair	ETD496 End Cap
ACET066	2x W-100 / 300	Fixing Screw for ETD496
ACET4195	Pair	ETD495 End Cap
ACET4221A	8	Sash Cleat
ACET4221B	8	Sash Cleat
ACET4224	14	Bridge Packers
WCA106	10	Chevrons
ACUN3035	4W + 7H	Flipper Gasket
ACUL076	2W + 4H	Sash Foam
ACUL076	H - 81	Floating Mullion Foam
ACUL077	1W + 2H	Outerframe Foam
E Gasket	6W + 4H	Glazing Gasket
ACSH038N	2x W - 113	Woolpile
ACET062	8	Transom Screws
ACET066	12	Transom Screws
ACVL061	2x W / 300 + 2	Pop Rivets
ACVL059	3 Pair	Drip End Cap
ACUL250	6	Hinges
ACUN3512	18	Hinge Screw
ACUN3577	24	Hinge Screw
ACET4242	Pair	EDT4247 Cill End Cap
ACET4247	Pair	EDT4247 Head End Cap
ACET066	2 + H / 300	Screw for ETD4247
ACET131	4	Drainage Cap
ACW20465	1	Master Lock
ACW20466	1	Slave Lock
ACDV737	2	Bottom Shootbolt
ACDV738	2	Top Shootbolt
ACW20066 L/R	1	Center Keep
ACW20367	4	Keep
ACUL279	2	Shootbolt Keep
ACUN3544	32	Screw For Lock
Page E50	2	Euro Cylinder
Page E50	2	Handles

Glass Sizes		
G1	H1 - 100	W/2 - 137.5
G2	H2 - 87	W/2 - 137.5
G3	H3 - 31	W/2 - 202.5

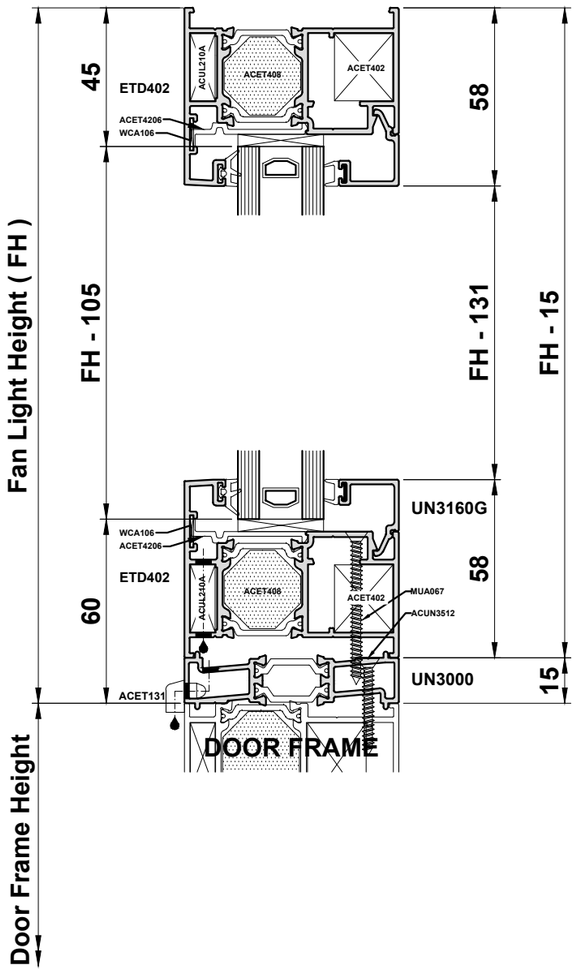




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ISSUED: JULY 2026

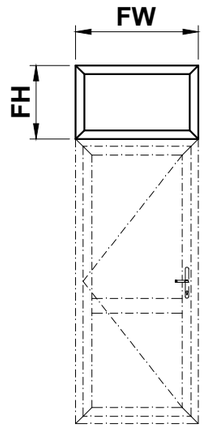
Fan Light Quick-Glaze Bead

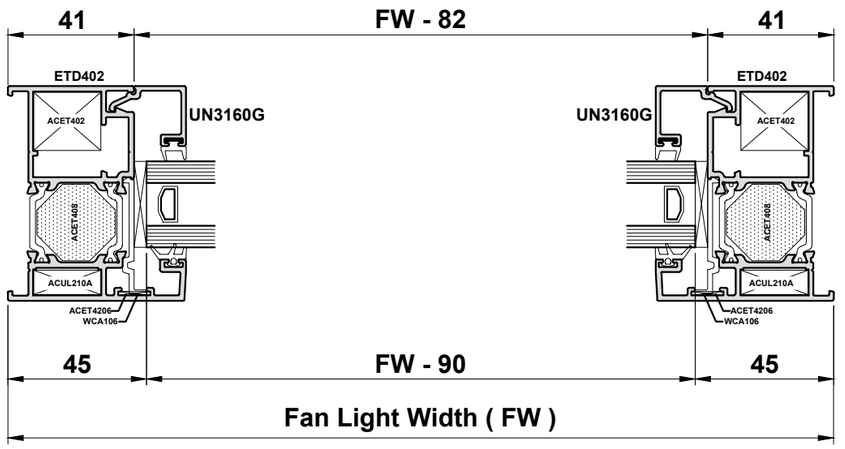


Profile Cutting Schedule				
UN3000	1			FW
UN3160G	4			FH - 131
UN3160G	4			FW - 82
ETD402	2			FW
ETD402	2			FH - 15

Accessories		
ACET402	4	Frame Cleat
ACUL210A	4	Frame Cleat
ACET4206	4	Corner Chevron
ACET4207	8	Bridge Packers
ACET131	2	Drainage Cap
ACET408	2 X FW + 2 X FH	Outer Frame Foam
ACET841	2 X FW + 2 X FH	E Gasket

Glass Sizes		
	FH - 131	FW - 82

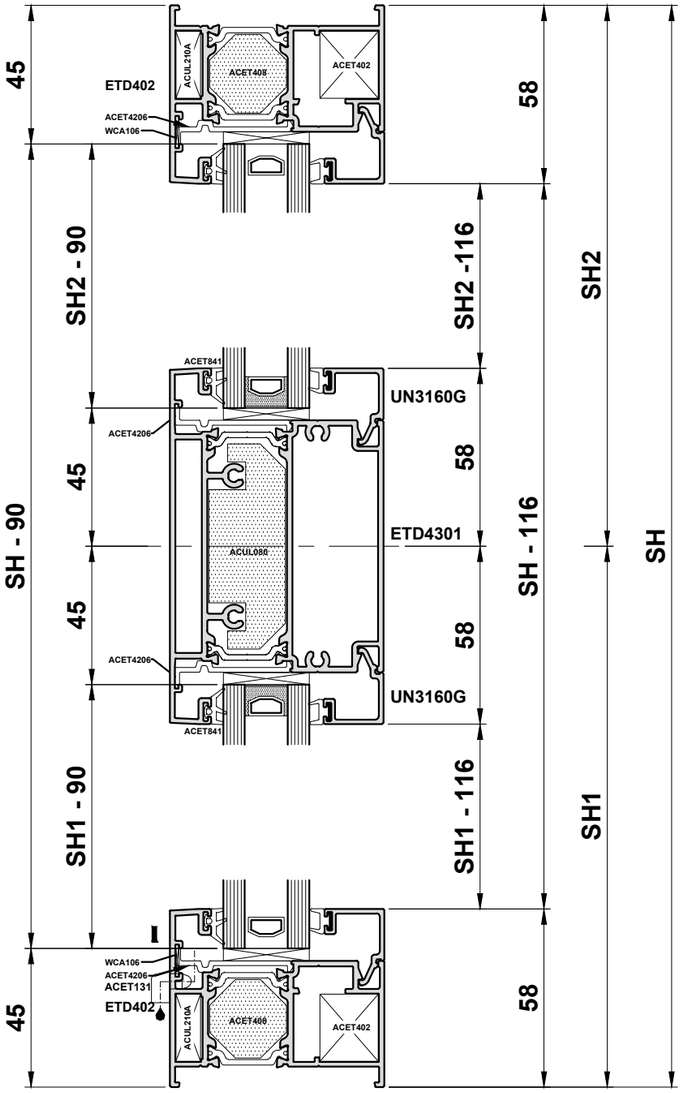




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Alitherm 400 Stepped Door

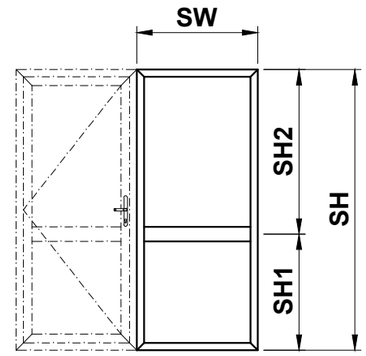
Side Light Quick-Glaze Bead



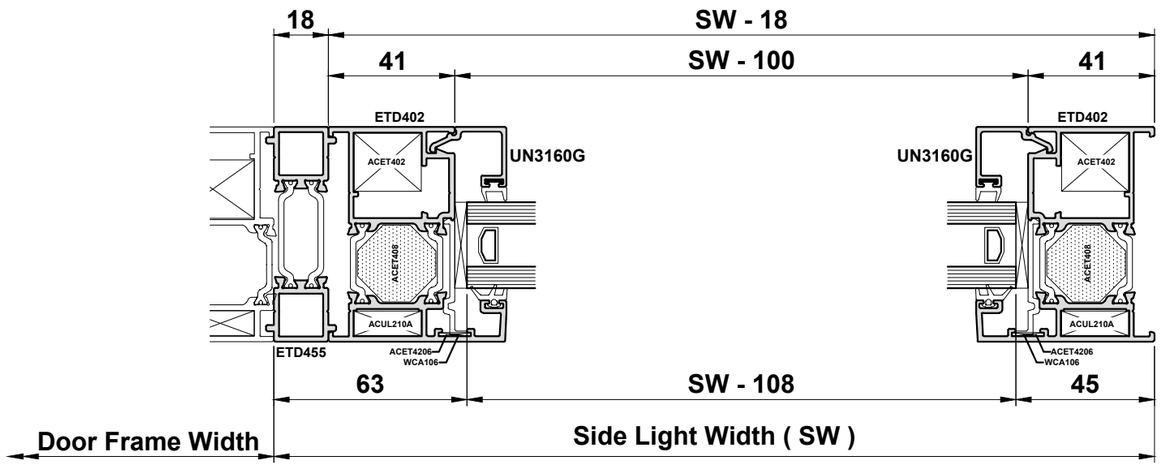
Profile Cutting Schedule			
UN3160G	2		SH - 116
UN3160G	2		SW - 100
ETD402	2		SW - 18
ETD402	2		SH
MIDRAIL ETD4301	1		SW - 100
MIDRAIL UN3160G	2		SW - 100
MIDRAIL UN3160G	2		SH - 90
MIDRAIL UN3160G	2		SH - 90

Accessories		
ACET402	4	Frame Cleat
ACUL210A	4	Frame Cleat
ACET4206	4	Corner Chevron
ACET4207	8	Bridge Packers
ACET131	2	Drainage Cap
ACET408	2 X SW + 2 X SH	Outer Frame Foam
ACET841	2 X SW + 2 X SH	E Gasket

Midrail Accessories		
ACUL080	7 X SW	ETD4301 Foam
ACUN3512	8	Screws
ACET841	2 X SW	E Gasket
ACET4207	4	Bridge Packer



Glass Sizes		
Without ETD4301	SH - 90	SW - 100
Top Glass With ETD4301	SH2 - 90	SW - 100
Bottom Glass With ETD4301	SH1 - 90	SW - 100



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