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Updates

DATE	PAGE	DESCRIPTION
January 2024	A07, A11, B11, C05, C11, C14, C17, F07, F08, F09, F10	ETC4014 long leg outer frame and ACET619 foam added.
May 2024	Throughout	ACET4012 replaced with ACET4110
June 2025	Throughout	Added New Profiles: ETC4016, ETC4018, ETC4028, ETC4036, ECT4079
July 2026	Throughout	Added New Profiles: ETC4017, ETC4019, ETC4027, ETC4039, UN3270 ETC4021 replaced with ETC4026 Introduced ACET4079 foam infill into Transom/Mullions Added ETC4037 floating mullion for French Casement

Specification

GENERAL DESCRIPTION

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

The system incorporates internally beaded fixed lights & sashes.

The low line gaskets and extended polyamide thermal breaks help to provide excellent U Values and Window Energy Rating capable of achieving an 'A' Rating when used in conjunction with the correct double glazed unit.

Alitherm 400 Tilt & Turn Quick-Glaze beads with integrated gasket, providing a fast and efficient glazing process. Non integrated gasket options are also available.

PROFILE SPECIFICATION

The window frame 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.

GENERAL MANUFACTURING

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

The corners are joined using the Alitherm 400 Tilt & Turn crimping cleats to form a cold forged corner joint (made by deforming small slugs of metal into the groove of the corner cleat).

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.

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

Specification

WINDOW DRAINAGE

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

OUTER FRAME MANUFACTURING INFORMATION

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

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

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

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

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

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

VENT

Prior to crimping the vents, remove the corners to the hardware channels to allow assembly of the tilt & turn hardware.

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

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

Specification

GLAZING

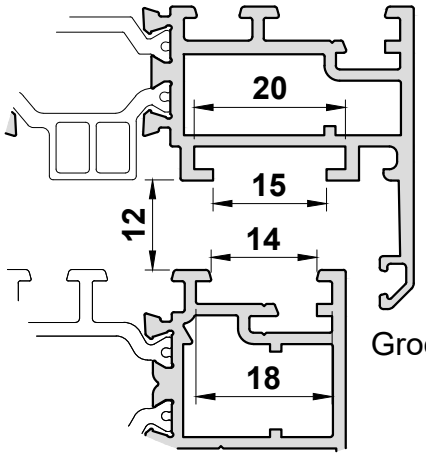
All beads are cut to suit the glazing aperture on the fully assembled window for glazing either at factory or on site as required.

INTERNALLY BEADED GLAZING

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

Hardware

For Hardware components, please refer to the SB-Chrono manual.



Groove Dimensions

Specification

Alitherm 400 Tilt & Turn Window Weather Performance (BS6375-1) Audited and assessed by BSI. Kitemark KM81580

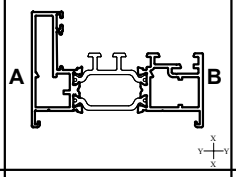
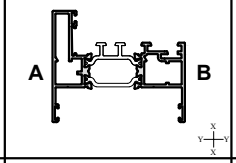
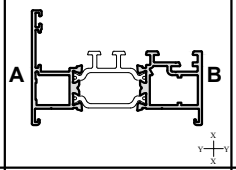
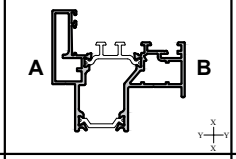
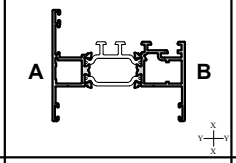
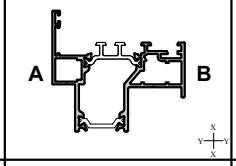
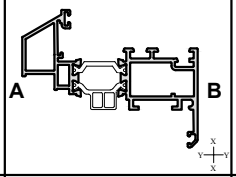
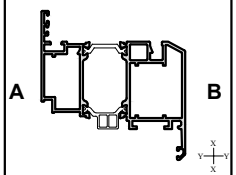
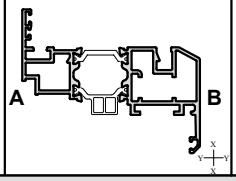
BS EN 1026: 2000 Air Permeability: Class 4
BS EN 1027: 2000 Watertightness: Class 9A
BS EN 12211: 2000 Resistance to Wind Load: BE2400

Alitherm 400 Tilt & Turn Window With Sobinco Safe Invision Security (PAS 24) Audited and assessed by BSI. Kitemark KM81580

PAS24:2022

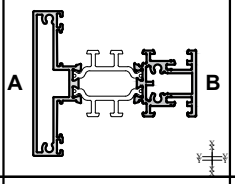
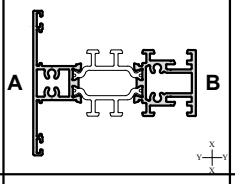
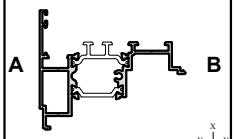
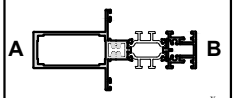
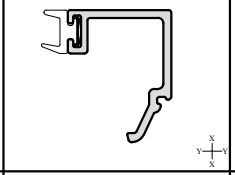
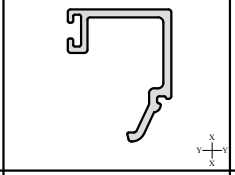
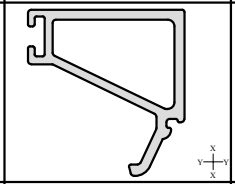
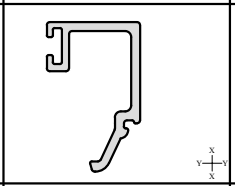
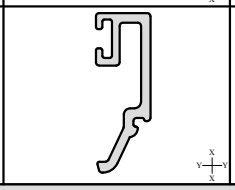
Alitherm 400 Tilt & Turn Window U Values

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

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ETC4014		A13	412	114	32.69 — 10.97	8.45 — 2.63	6.5	1	✓	✓	✓	✓	✓
ETC4016		A14	358	82	26.29 — 7.28	3.93 — 2.15	6.5	1	✓	✓	✓	✓	✓
ETC4017		A15	436	123	29.85 — 7.62	18.10 — 5.42	6.5	1	✓	✓	✓	✓	✓
ETC4018		A14	415	106	30.95 — 8.60	6.14 — 2.22	6.5	1	✓	✓	✓	✓	✓
ETC4019		A15	436	114	28.67 — 7.56	16.17 — 4.81	6.5	1	✓	✓	✓	✓	✓
ETC4026		A16	442	114	35.41 — 9.89	7.86 — 2.79	6.5	1	✓	✓	✓	✓	✓
ETC4027		A17	516	141	51.82 — 13.39	31.90 — 7.65	6.5	1	✓	✓	✓	✓	✓
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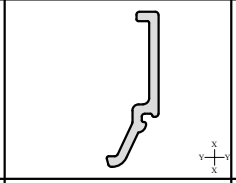
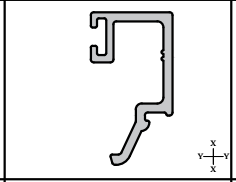
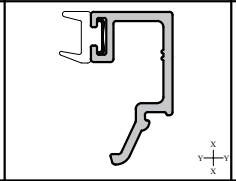
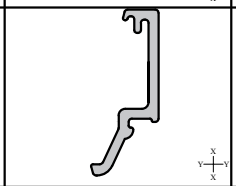
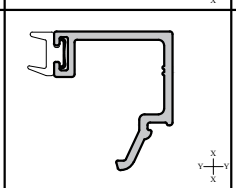
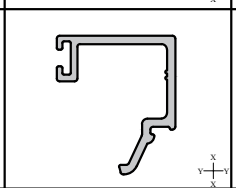
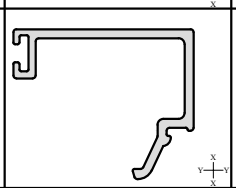
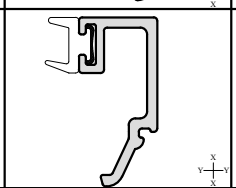
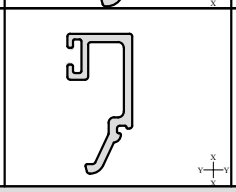
A = Outside
B = Inside

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

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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ETC4036		A19	425	69	32.59 — 8.69	6.19 — 1.99	6.5	1	✓	✓	✓	✓	✓
ETC4037		A19	429	87	23.80 — 4.71	7.47 — 2.29	6.5	1	✓	✓	✓	✓	✓
ETC4039		A20	537	211	129.00 — 20.00	10.66 — 3.43	6.5	1	✓	✓	✓	✓	✓
UN3160G		A21	120	39	- — -	- — -	6.5	1	✓	✓	✓	✓	
UN3160		A21	105	41	- — -	- — -	6.5	1	✓	✓	✓	✓	
UN3162		A21	120	120	- — -	- — -	6.5	1	✓	✓	✓	✓	
UN3164		A22	112	33	- — -	- — -	6.5	1	✓	✓	✓	✓	
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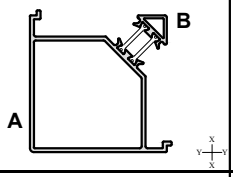
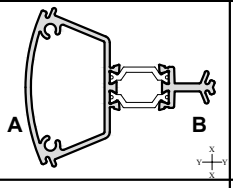
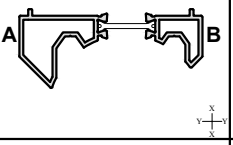
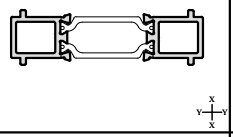
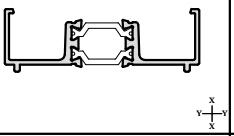
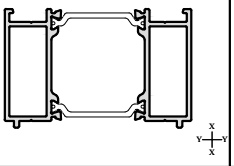
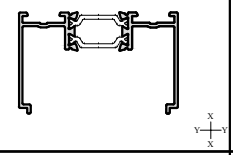
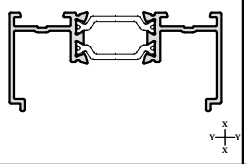
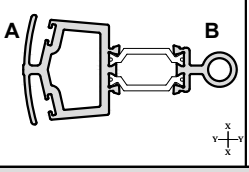
A = Outside
B = Inside

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

Number	Picture	Page	Perim. mm	Mec. mm	Ix(cm4) wx(cm3)	Iy(cm4) wy(cm3)	Length	Pack pr.	MF	SA	KL	HP	M
UN3168		A24	65	23	- — -	- — -	6.5	1	✓	✓	✓	✓	
ETC4061		A22	112	33	- — -	- — -	6.5	1	✓	✓	✓	✓	
ETC4061G		A22	112	33	- — -	- — -	6.5	1	✓	✓	✓	✓	
ETC4063		A24	82	24	- — -	- — -	6.5	1	✓	✓	✓	✓	
ETC4067G		A21	127	41	- — -	- — -	6.5	1	✓	✓	✓	✓	
ETC4067		A21	127	41	- — -	- — -	6.5	1	✓	✓	✓	✓	
ETC4079		A22	144	47	- — -	- — -	6.5	1	✓	✓	✓	✓	
ETC4179G		A23	104	29	- — -	- — -	6.5	1	✓	✓	✓	✓	
ETC4179		A23	104	29	- — -	- — -	6.5	1	✓	✓	✓	✓	

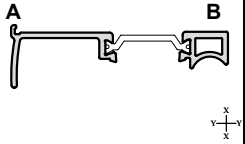
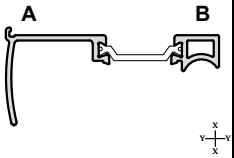
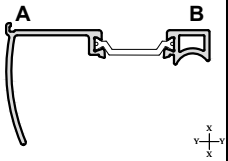
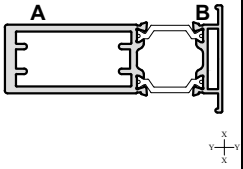
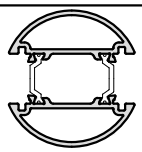
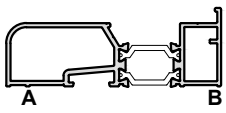
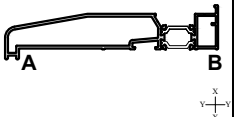
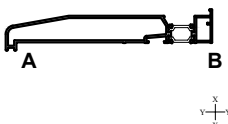
A = Outside
B = Inside

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

Number	Picture	Page	Perim. mm	Mec. mm	Ix(cm4) wx(cm3)	Iy(cm4) wy(cm3)	Length	Pack pr.	MF	SA	KL	HP	M
UN3010		A25	369	226	41.4 ----- 10.7	40 ----- 11.6	6.5	1	✓	✓	✓	✓	✓
UN3011		A25	288	130	22.3 --- 5	12.2 --- 4.1	6.5	**1**	✓	✓	✓	✓	✓
UN3012		A31	238	76	1.53 --- 0.79	17.24 --- 5.09	6.5	1	✓	✓	✓	✓	✓
UN3015		A26	214.5	56	18.1 --- 5.2	1 --- 1	6.5	1	✓	✓	✓	✓	✓
UN3020		A26	281.6	70.4	14.8 --- 4.2	0.9 --- 1	6.5	1	✓	✓	✓	✓	✓
UN3042		A26	288.4	111	31.2 --- 8.9	9.5 --- 4.3	6.5	1	✓	✓	✓	✓	✓
UN3270		A27	407	85	23.39 --- 6.68	5.8 --- 1.83	6.5	**1**	✓	✓	✓	✓	✓
UN3370		A27	360	61	18.4 --- 5.26	2.15 --- 1.97	6.5	**1**	✓	✓	✓	✓	✓
ETC080		A28	344	61	25.58 ----- 5.47	4.88 ----- 2.57	6.5	1	✓	✓	✓	✓	✓

A = Outside
B = Inside

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

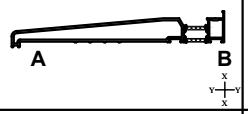
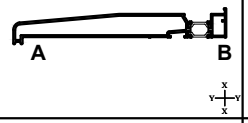
Number	Picture	Page	Perim. mm	Mec. mm	Ix(cm4) wx(cm3)	Iy(cm4) wy(cm3)	Length	Pack pr.	MF	SA	KL	HP	M
ETC081		A28	197	35	13.85 ----- 3.8	0.36 ----- 0.52	6.5	1	✓	✓	✓	✓	✓
ETC082		A28	221	47	16.21 ----- 4.19	1.15 ----- 1.29	6.5	1	✓	✓	✓	✓	✓
ETC083		A28	243	58	17.66 ----- 4.32	2.64 ----- 2.36	6.5	1	✓	✓	✓	✓	✓
ETC357		A27	297	138	41.5 --- 9.86	52 --- 2.67	6.5	1	✓	✓	✓	✓	✓
ETC869		A31	332	144	18.38 --- 6.13	14.3 --- 5.17	6.5	1	✓	✓	✓	✓	✓
ETC451		A29	271	180	32.44 ----- 7.29	3.46 ----- 2.79	6.5	1	✓	✓	✓	✓	✓
ETC452		A29	414	382	122.46 ----- 18.03	6.01 ----- 3.34	6.5	1	✓	✓	✓	✓	✓
ETC457		A29	444	212	164.27 — 21.60	6.79 — 3.73	6.5	1	✓	✓	✓	✓	✓
ETC458		A30	524	492	313.62 ----- 32.63	8.87 ----- 4.79	6.5	1	✓	✓	✓	✓	✓

A = Outside
B = Inside

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

Alitherm 400 Tilt & Turn

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
ETC477		A30	752	408	1591.6 ----- 105.33	26.84 ----- 12.84	6.5	1	✓	✓	✓	✓	✓
ETC479N		A30	594	559	501.64 ----- 44.04	9.72 ----- 5.34	6.5	1	✓	✓	✓	✓	✓

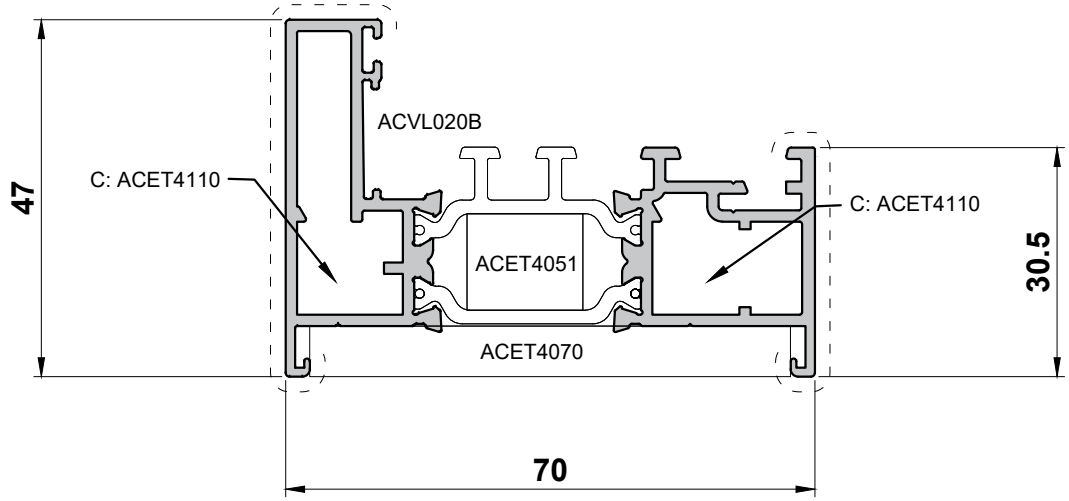
A = Outside
B = Inside

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

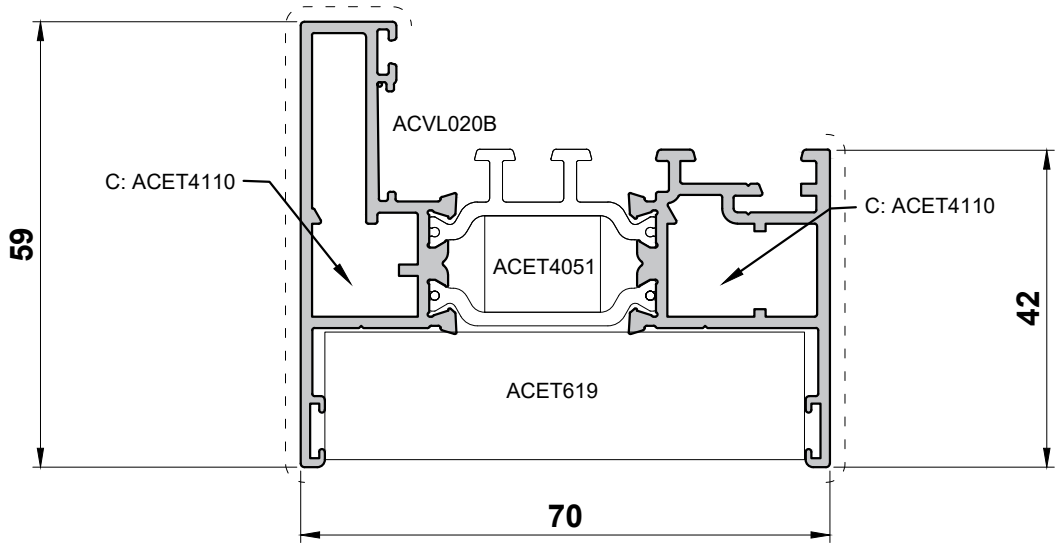
ISSUED : July 2026

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

ETC4011
Outer Frame



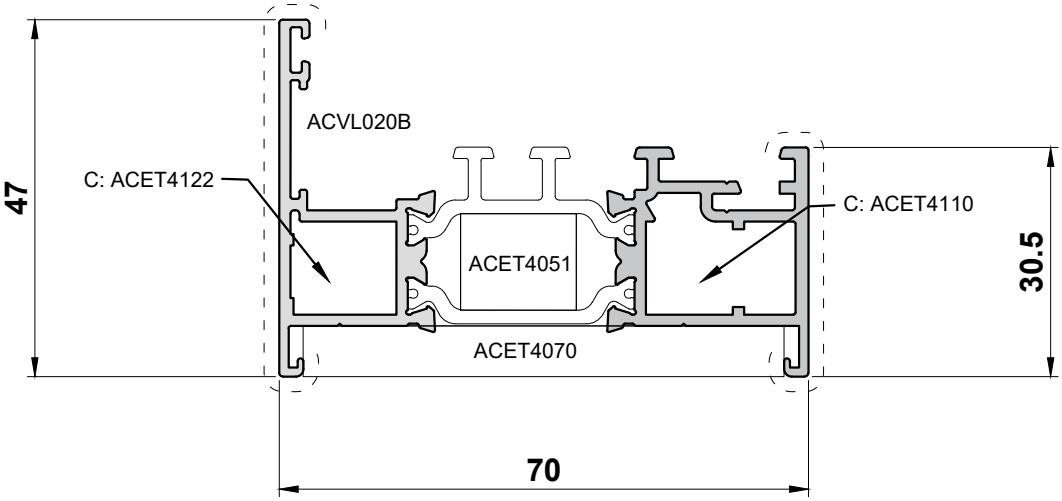
ETC4014
Long Leg Outer Frame



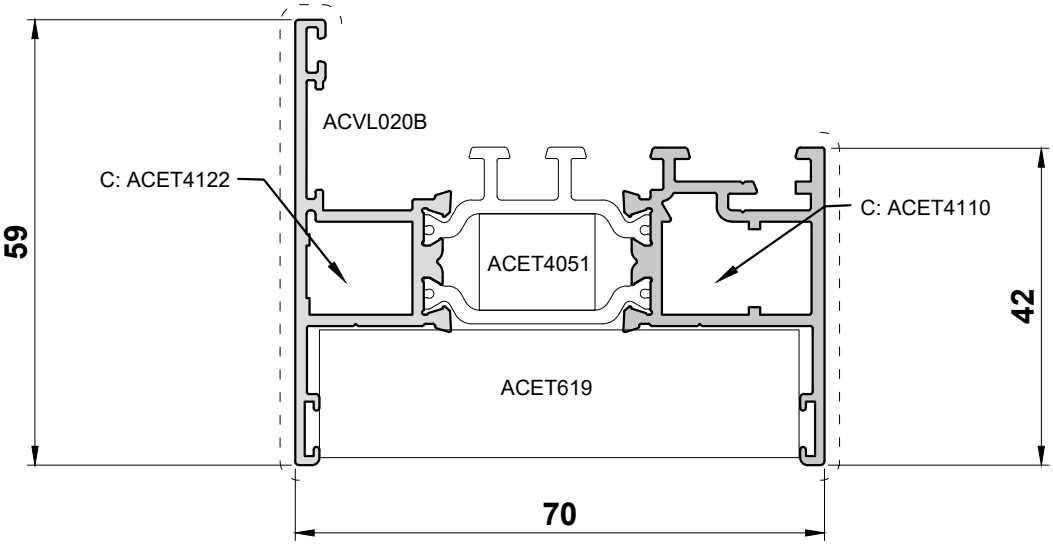
Scale 1:1

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

ETC4016
Outer Frame



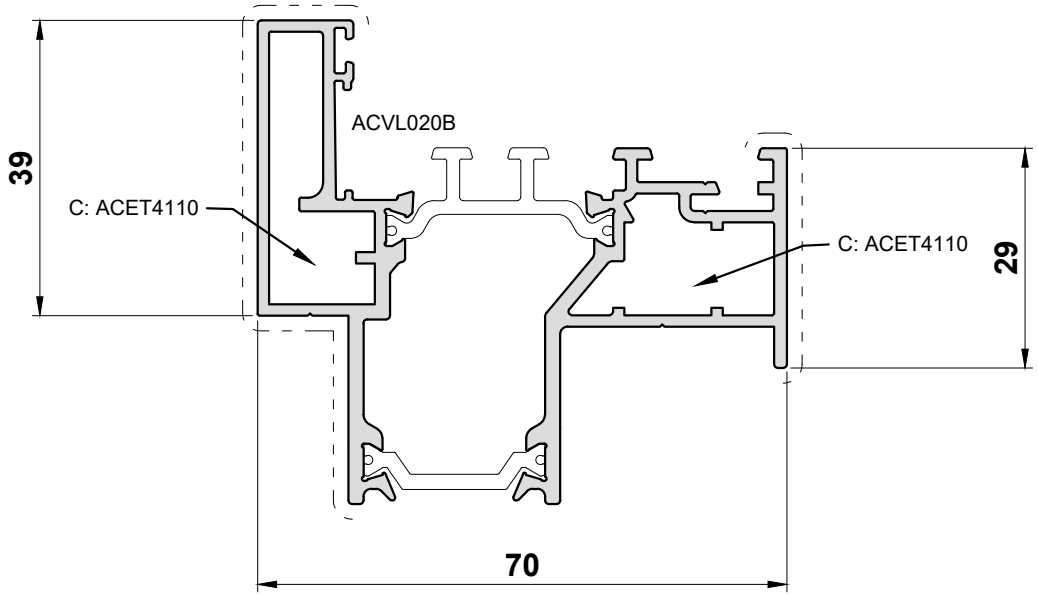
ETC4018
Long Leg Outer Frame



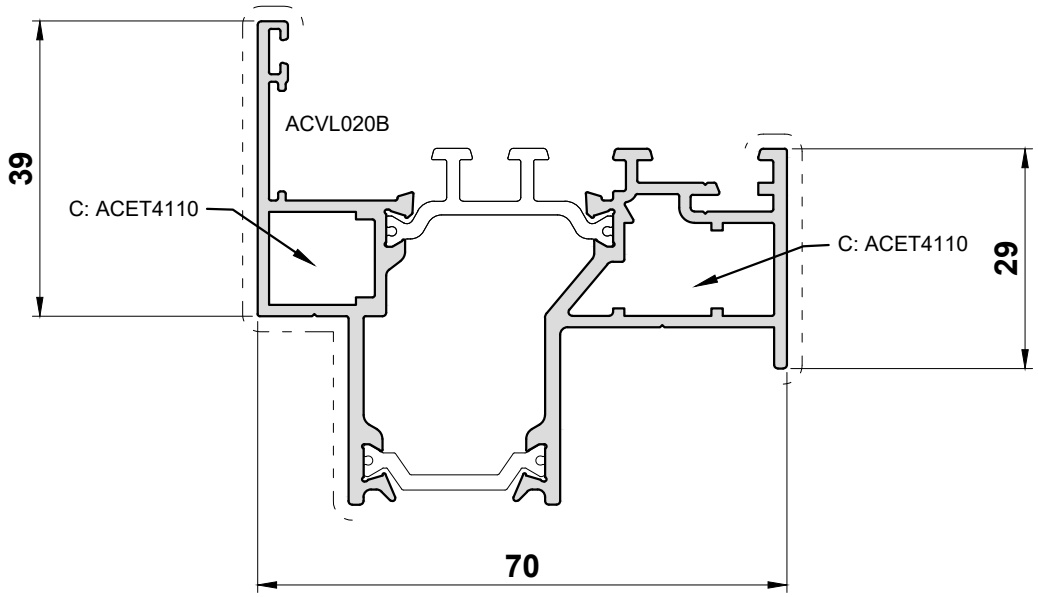
Scale 1:1

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

ETC4017
Curtain Wall Outer Frame



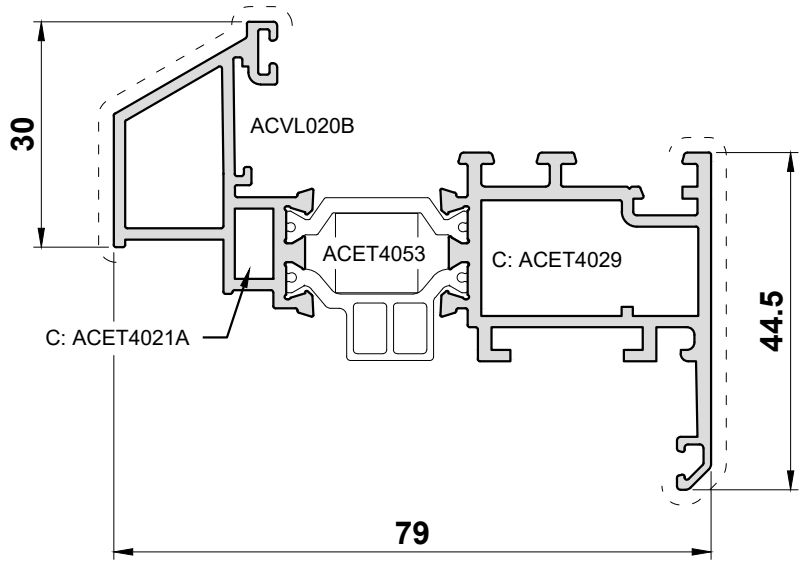
ETC4019
Curtain Wall Outer Frame



Scale 1:1

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

ETC4026
Sash



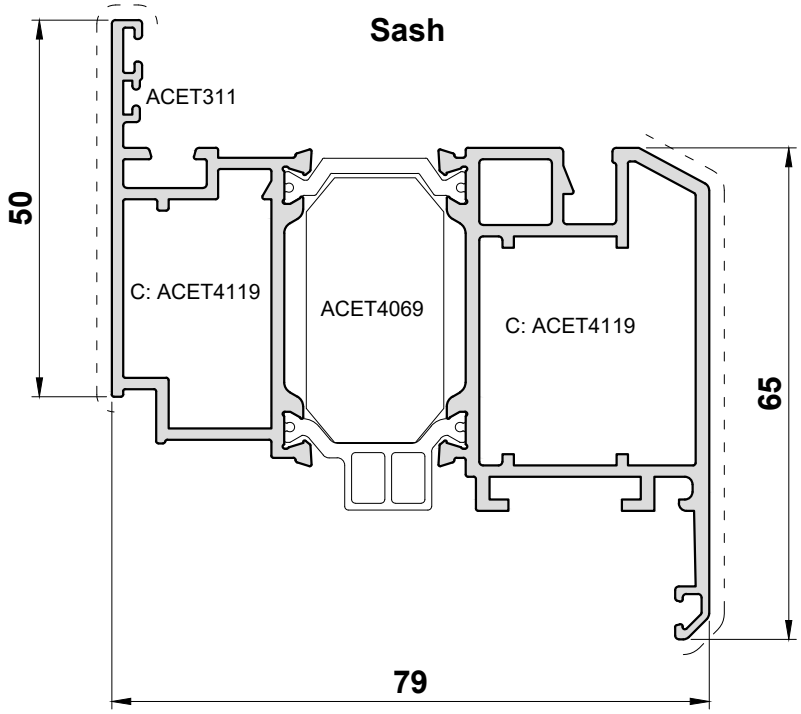
Scale 1:1

ISSUED : July 2026

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

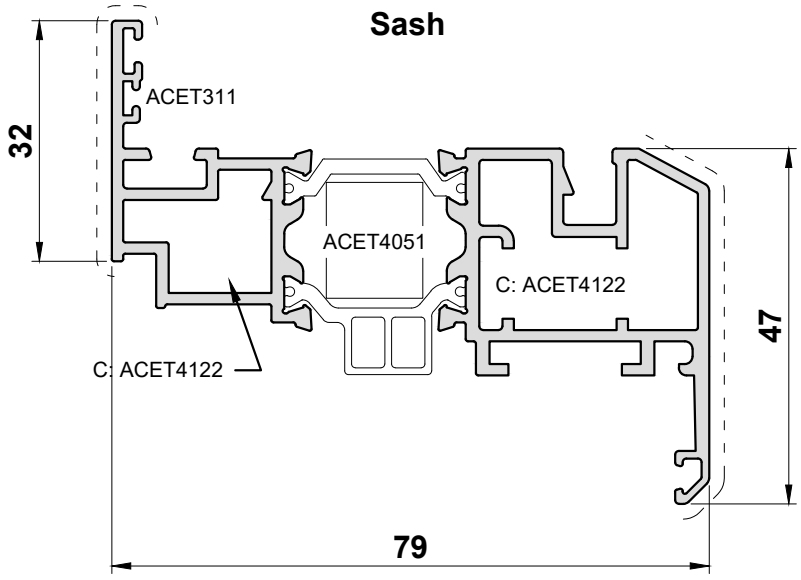
ETC4027

Sash



ETC4028

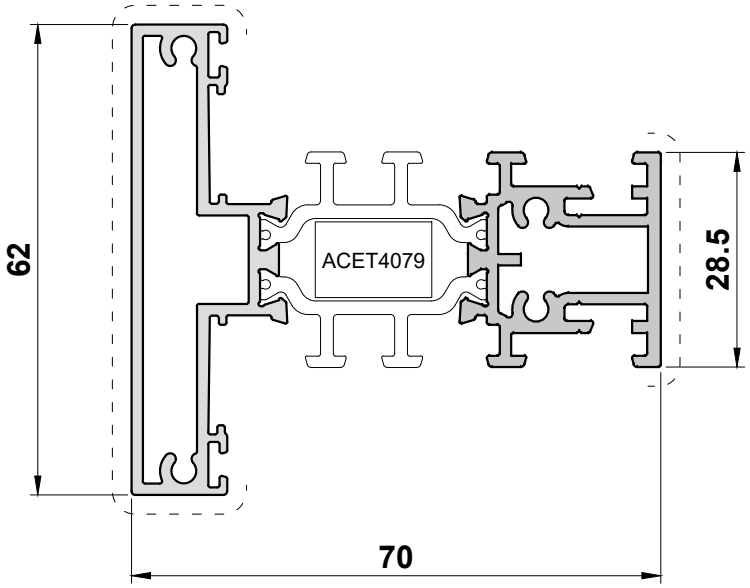
Sash



Scale 1:1

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

ETC4031
Transom / Mullion

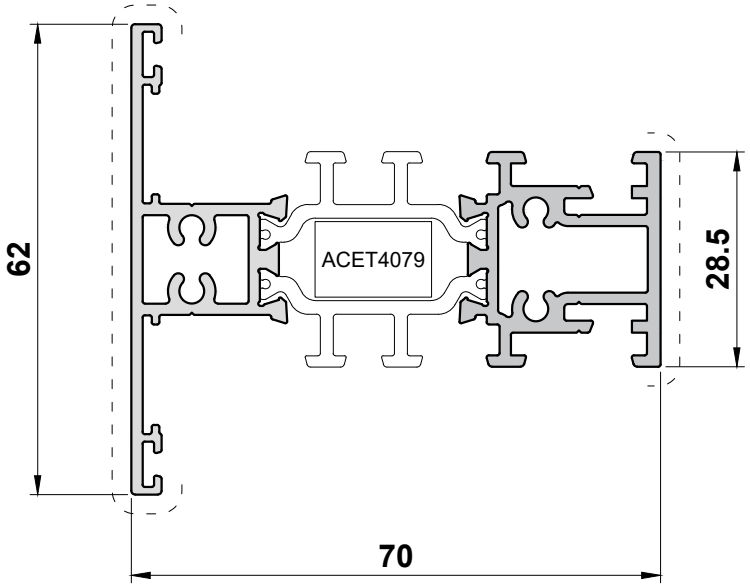


Scale 1:1

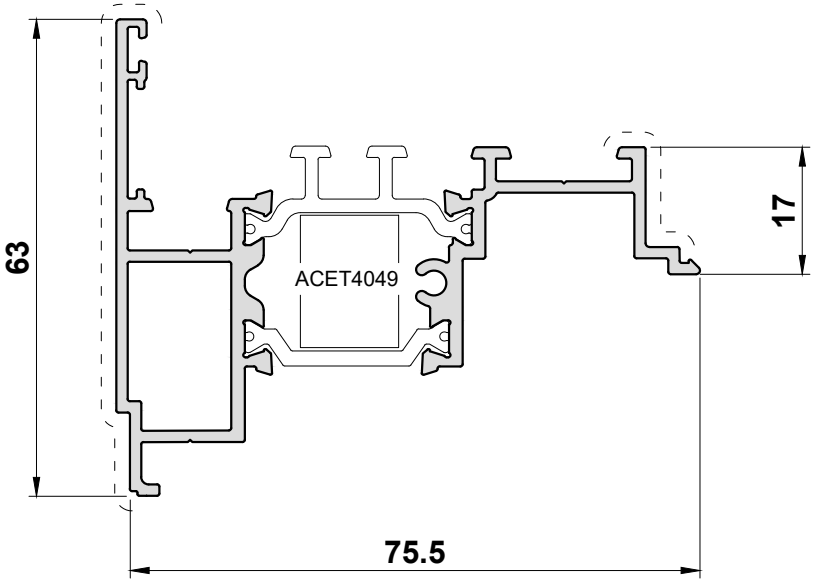
ISSUED : July 2026

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

ETC4036
Transom / Mullion



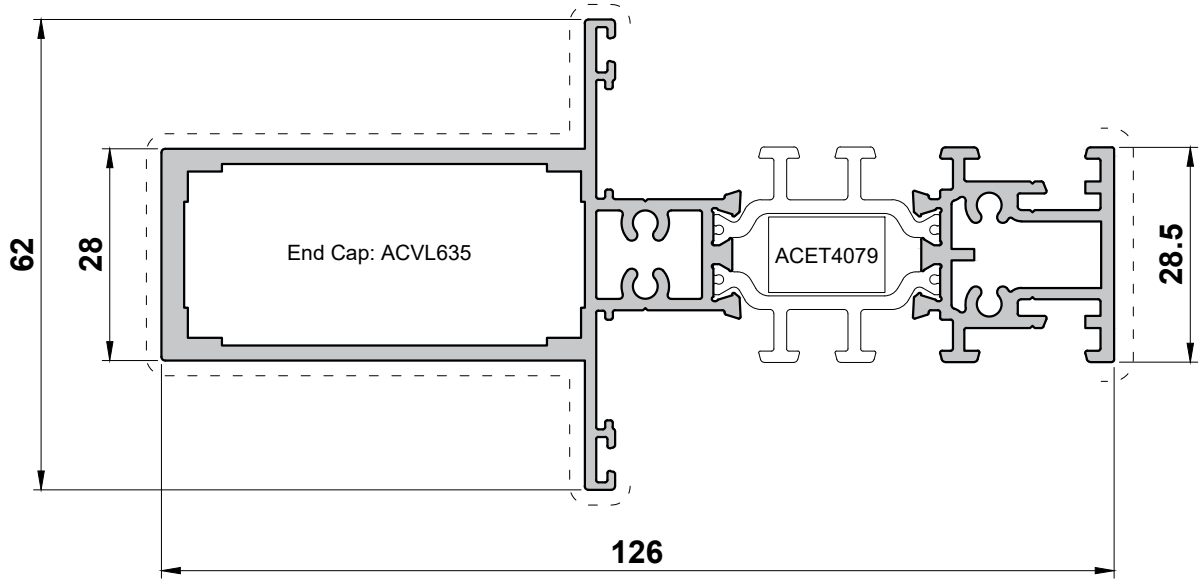
ETC4037
Floating Mullion



Scale 1:1

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

ETC4039
Transom / Mullion

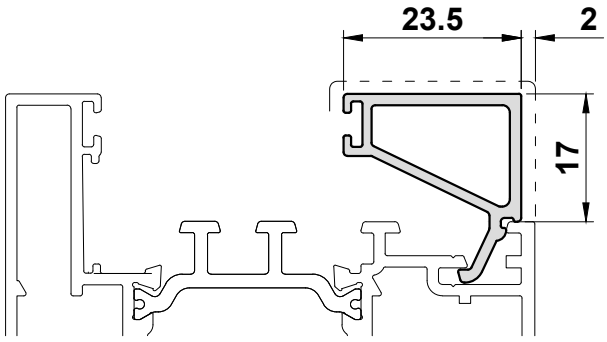


Scale 1:1

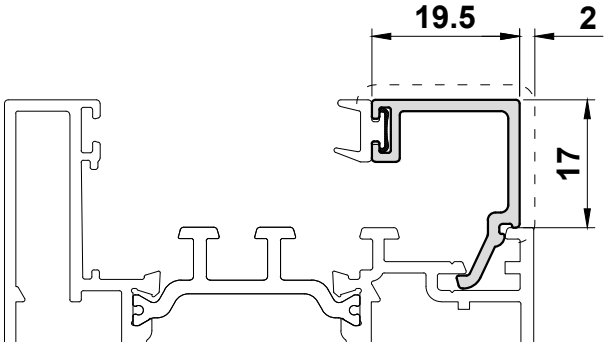
ISSUED : July 2026

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

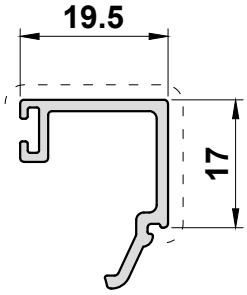
UN3162
24mm Glazing
Tap In Glazing Bead



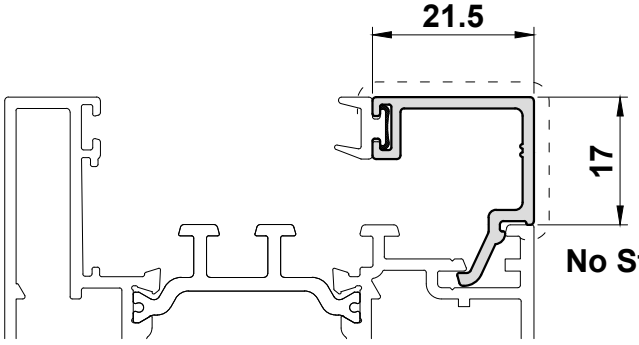
UN3160G
28mm Glazing
Tap In Glazing Bead



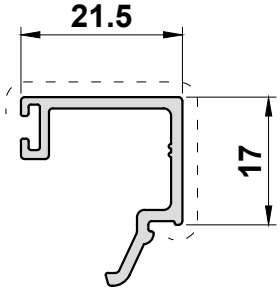
UN3160
28mm Glazing
Tap In Glazing Bead



ETC4067G
28mm Glazing
Tap In Glazing Bead



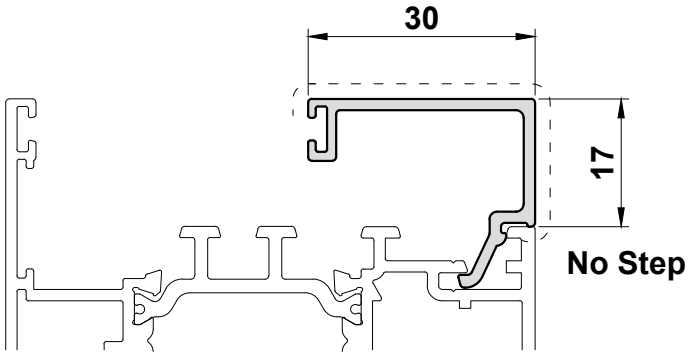
ETC4067
28mm Glazing
Tap In Glazing Bead



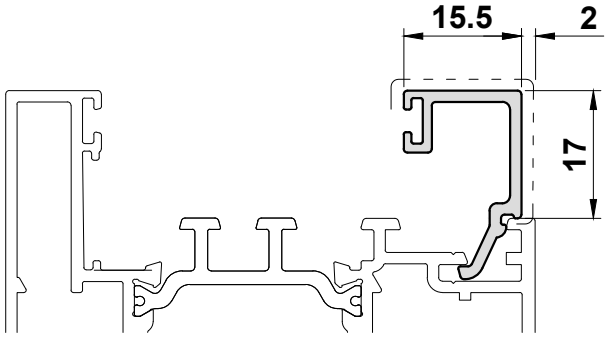
Scale 1:1

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

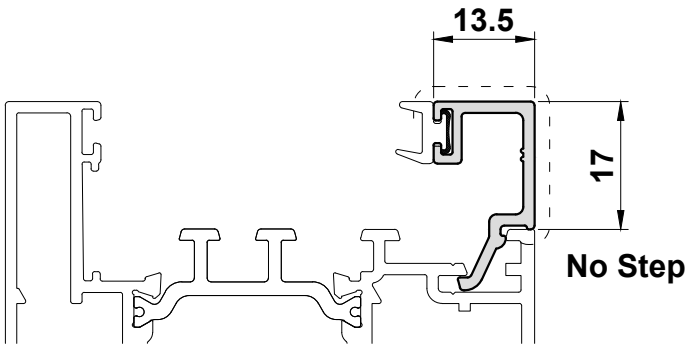
ETC4079
28mm Glazing
Tap In Glazing Bead



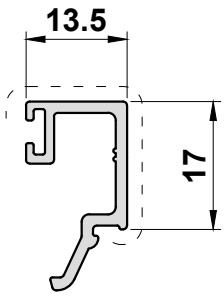
UN3164
32mm Glazing
Tap In Glazing Bead



ETC4061G
36mm Glazing
Tap In Glazing Bead



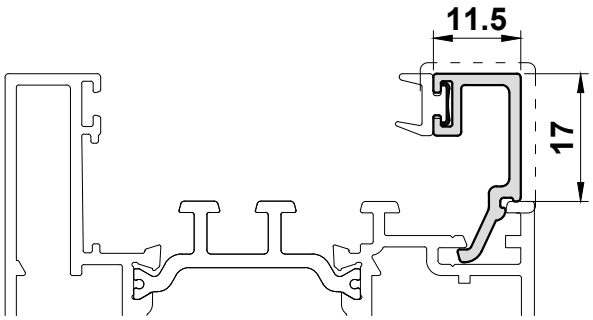
ETC4061
36mm Glazing
Tap In Glazing Bead



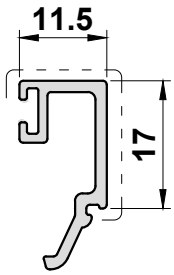
Scale 1:1

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

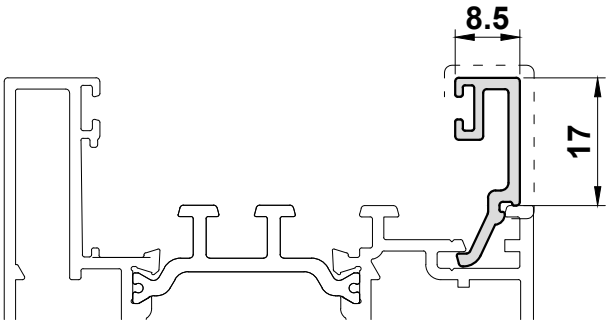
ETC4179G
36mm Glazing
Tap In Glazing Bead



ETC4179
36mm Glazing
Tap In Glazing Bead



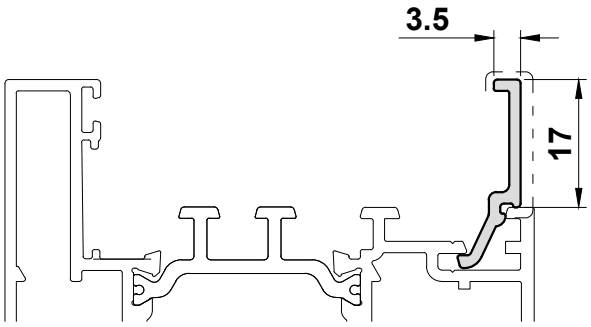
UN3166
40mm Glazing
Tap In Glazing Bead



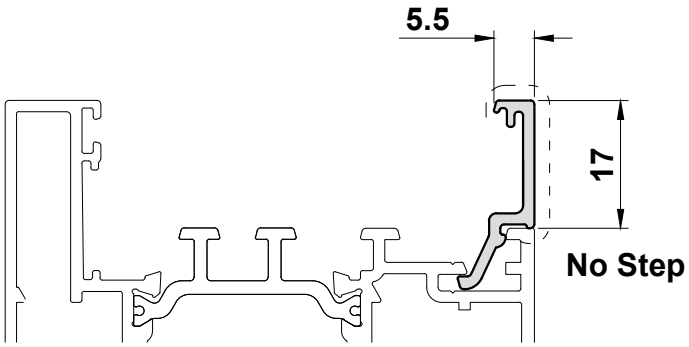
Scale 1:1

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

UN3168
45mm Glazing
Tap In Glazing Bead



ETC4063
45mm Glazing
Tap In Glazing Bead

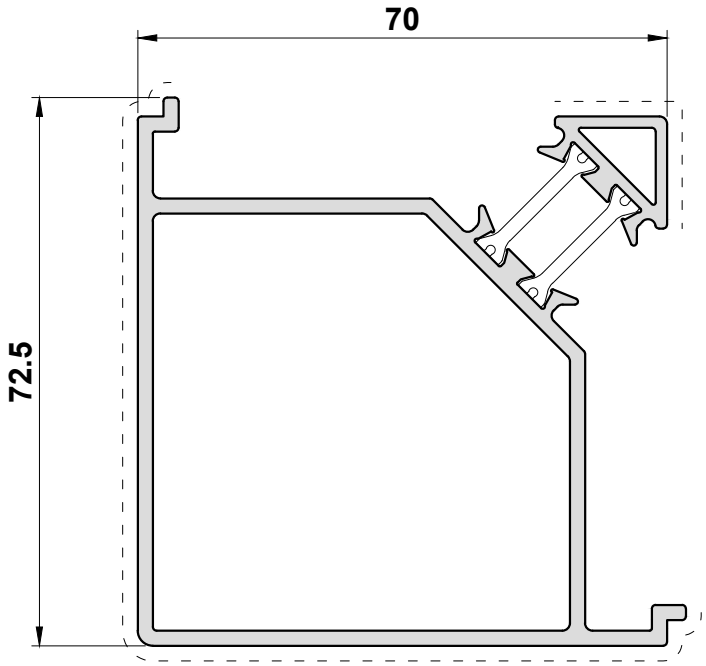


Scale 1:1

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

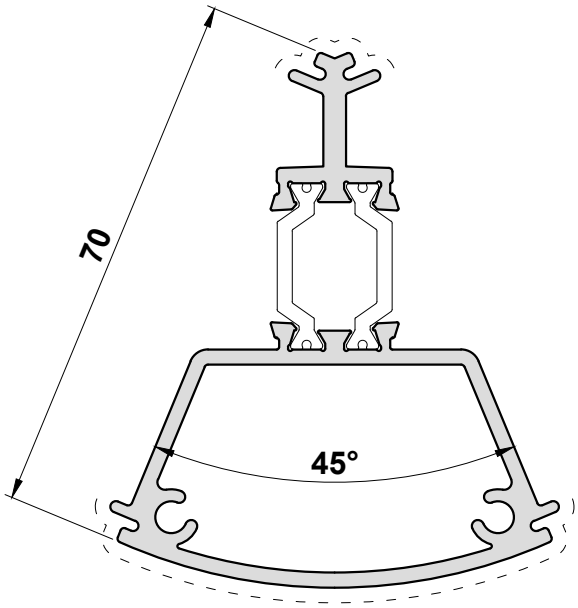
UN3010

70mm 90° Corner Post



UN3011

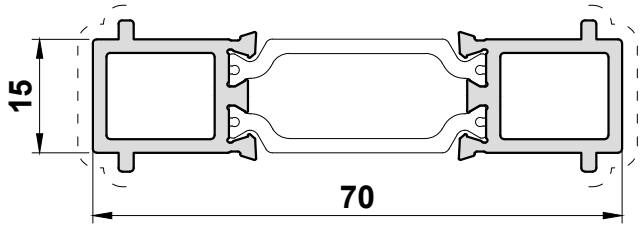
135° Bay Pole



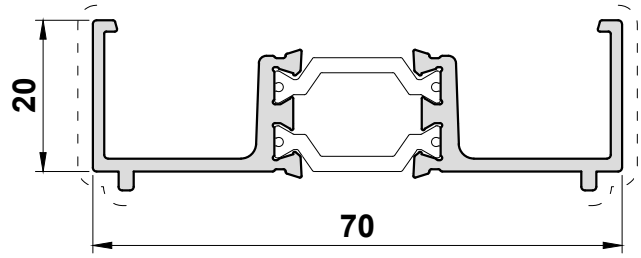
Scale 1:1

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

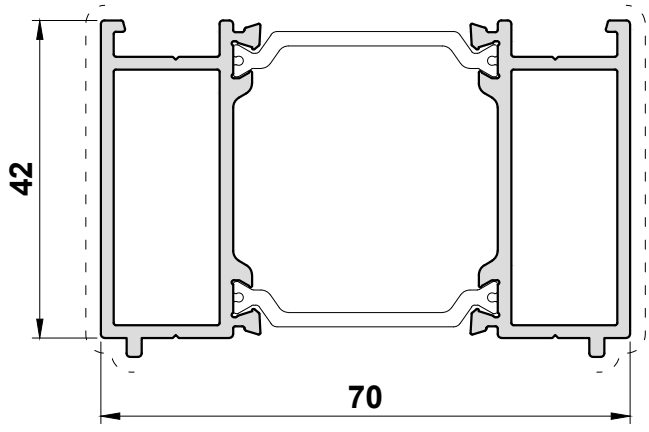
UN3015
70mm x 15mm Coupler



UN3020
20mm Frame Extension



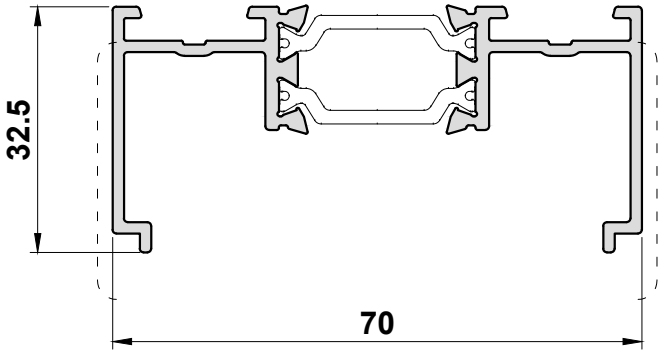
UN3042
70mm x42mm Head Extension



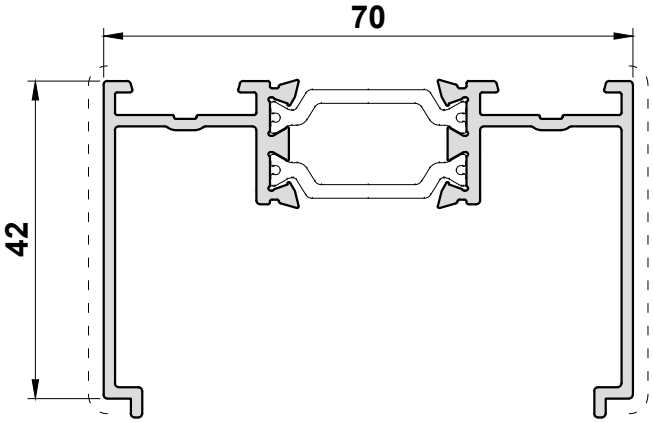
Scale 1:1

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

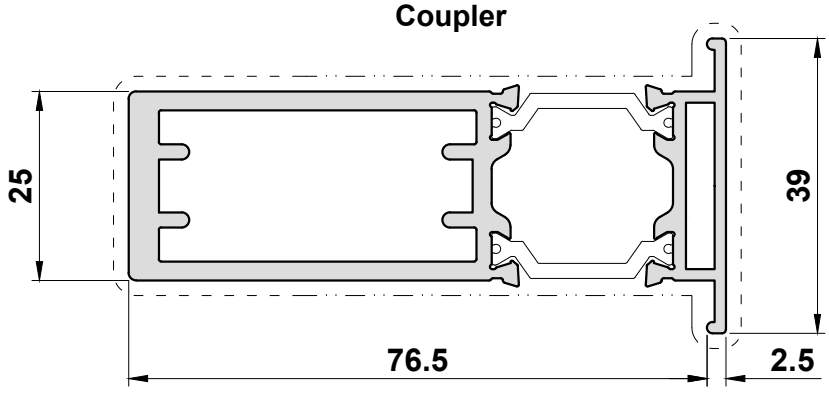
UN3370
70mm x 32.5mm Head Extension



UN3270
70 x 42mm Head Extension



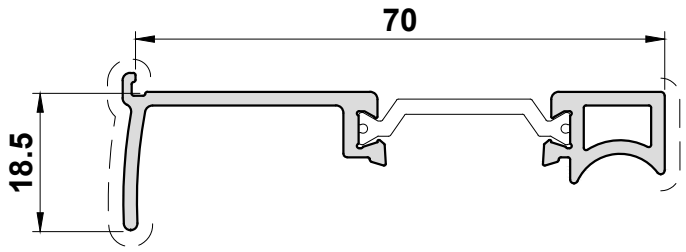
ETC357
Coupler



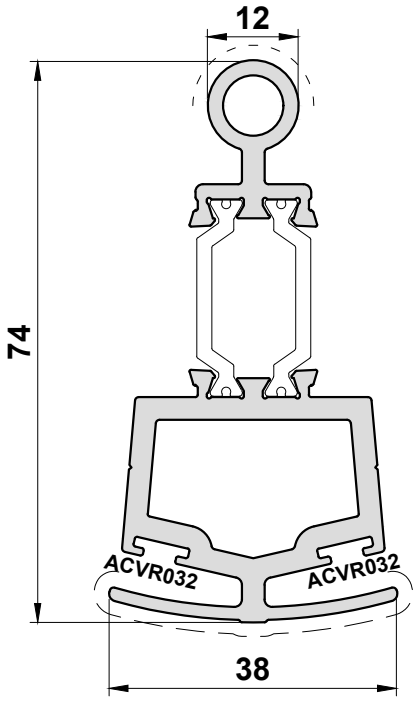
Scale 1:1

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

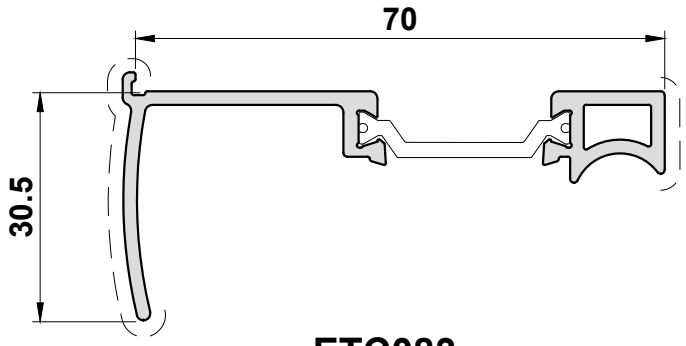
ETC081
169° - 150°
Bay Pole Adaptor



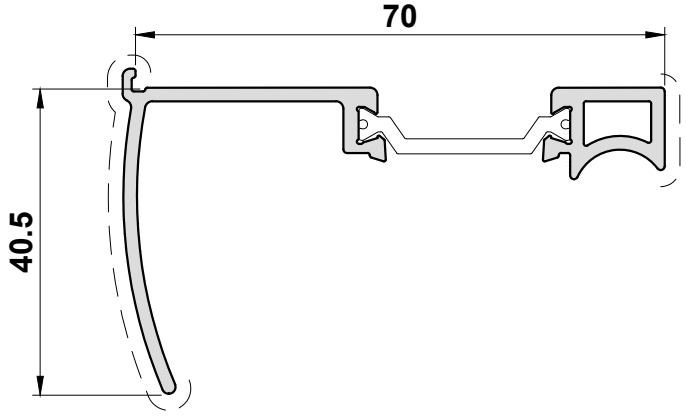
ETC080
Bay Pole



ETC082
149° - 130°
Bay Pole Adaptor

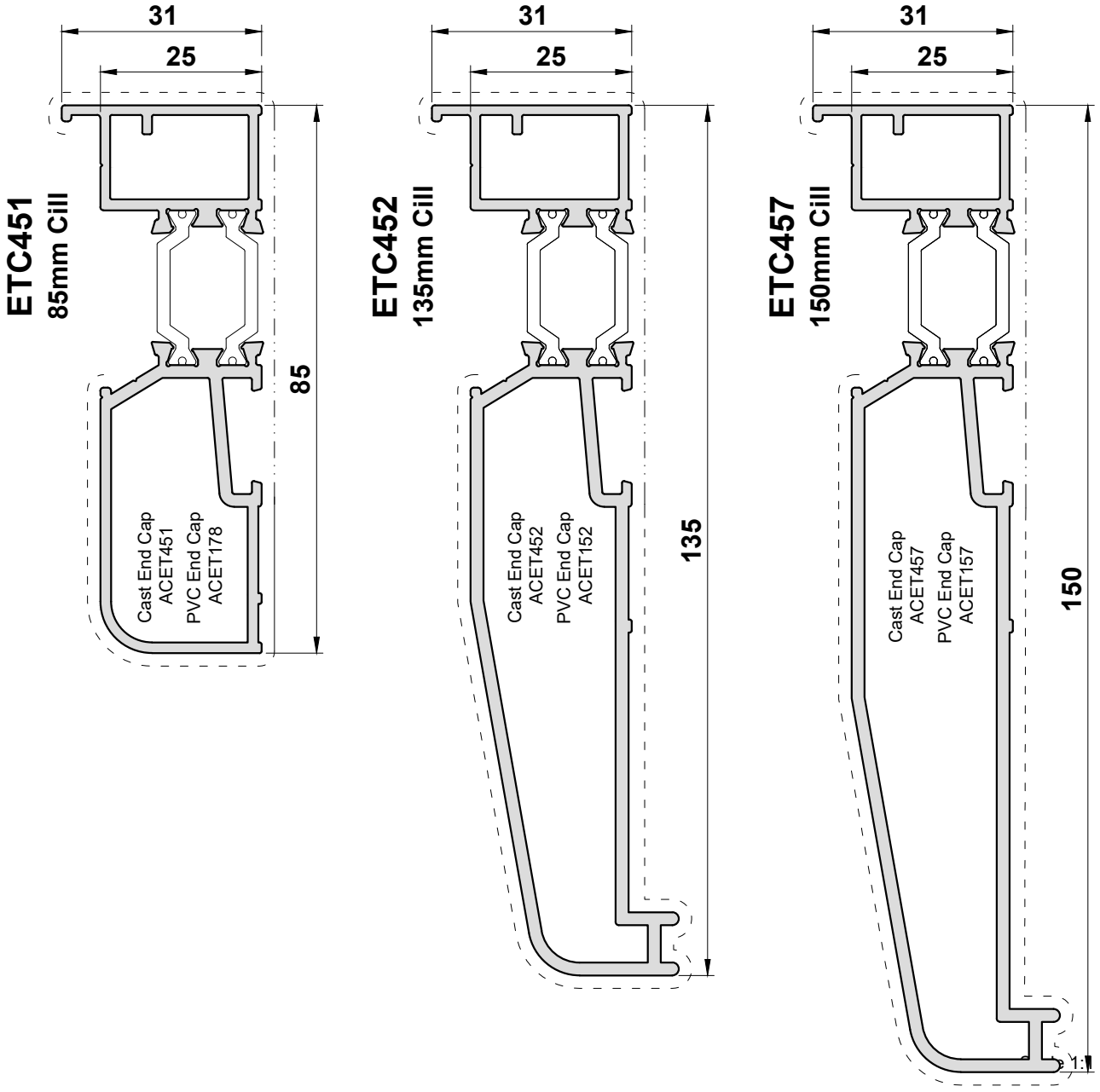


ETC083
129° - 115°
Bay Pole Adaptor



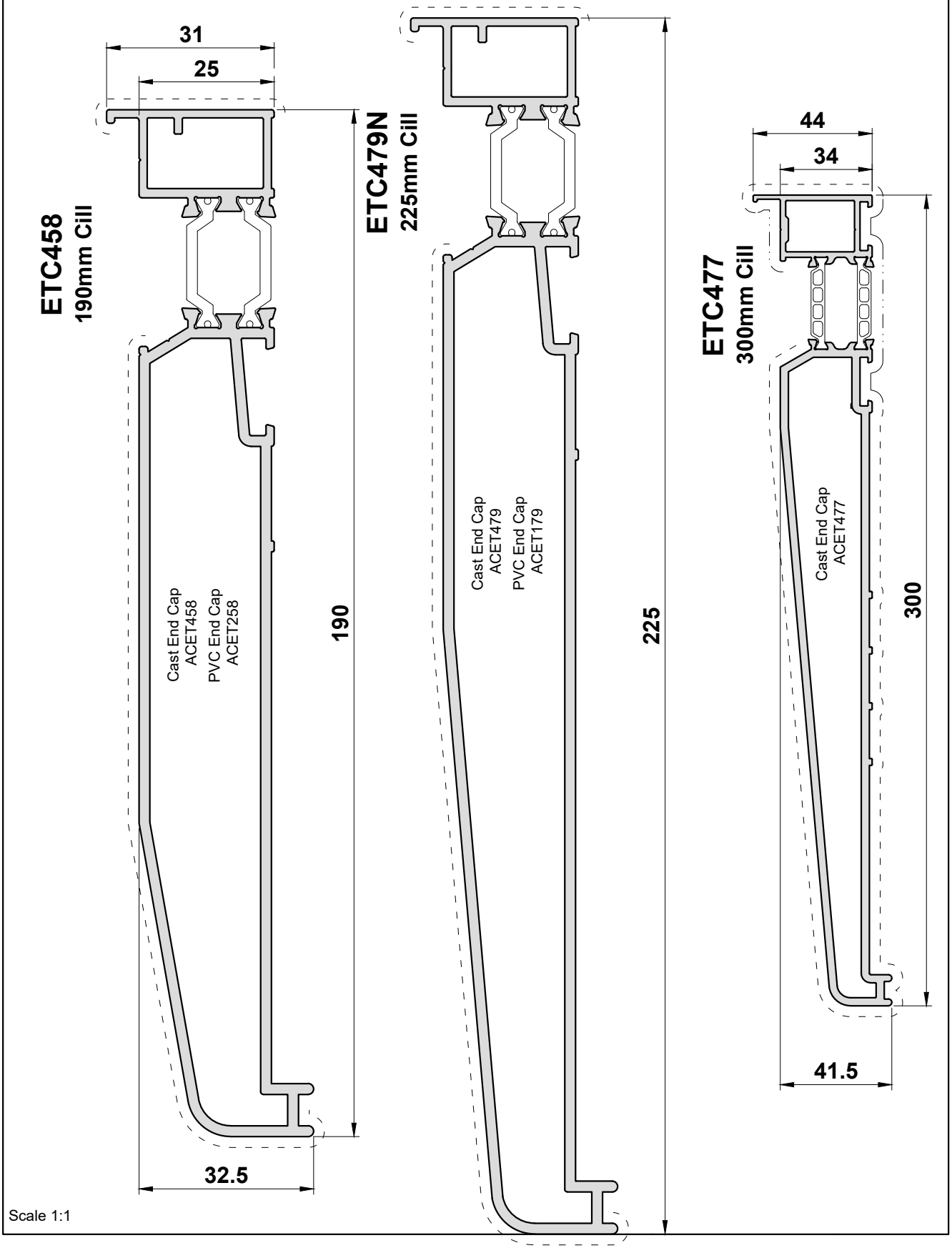
Scale 1:1

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



Scale 1:1

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

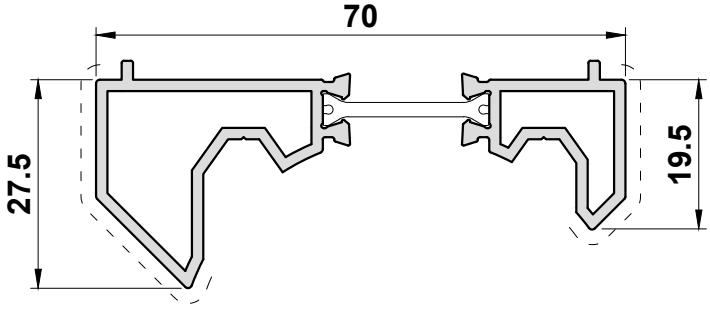


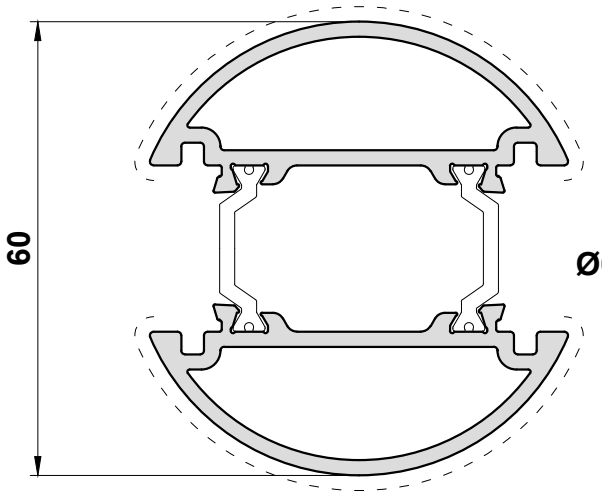
Scale 1:1

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

UN3012

Bay Pole Adaptor





ETC869

Ø60mm Bay Pole

Scale 1:1

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

Scale 1:1

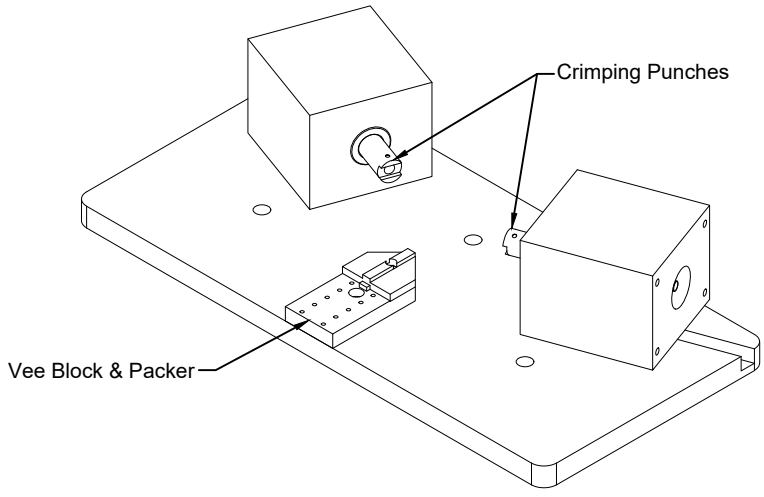
Section B

Accessories

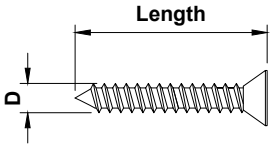
Photos & Drawings

Corner Joint - Crimping

		MANUAL CRIMPER = ACCR300 PNEUMATIC CRIMPER = ACCR200N				
		Profile	**Crimping Punches**	**Vee Block**	**Nylon Support**	**Packer**
Outerframe		ETC4011 ETC4014 ETC4016 ETC4018	ACET4395	ACUN3950 ACUN3951	ACUN3952	ACET4381 ACET4383
C/W Outerframe		ETC4017 ETC4019	ACET4385	ACUN3950 ACUN3951	ACUN3952	ACET4381 ACET4382
Sash		ETC4026	ACET4394N	ACUN3950 ACUN3951	ACUN3952	ACET4381 ACET4383
Sash		ETC4028	ACET4394N	ACUN3950 ACUN3964	ACUN3952	ACET4381 ACET4382



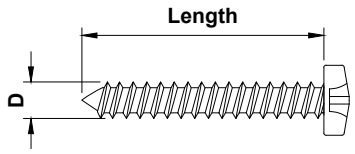
Countersunk Screws



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

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

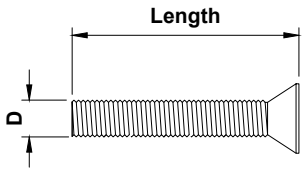
Pan Head Screws



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

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

Machine Screws

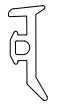
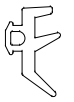
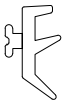


Thread	'D' (mm) Nominal
M4	4
M5	5
M6	6
M8	8
M10	10

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

Glazing Gaskets

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

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

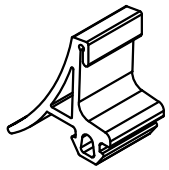
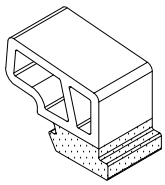
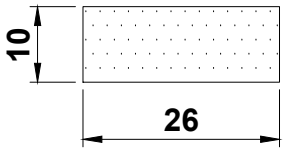
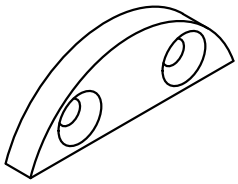
Thickness	Drawing 1:1	**Part number**
		Coil length
		Available Colours

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

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

Alitherm 400 Tilt & Turn

ACCESSORIES : PHOTOS & DRAWINGS

Image	Part Code	Pack	Unit	Application	Colour	
	**ACEF030A** **Central gasket outward** **(Pre-formed corners = ACEF031A)**	**100**	**m**	**Outer Frames, Transoms & Mullions**	MF SA KL HP SSC SMC W Z PC	 ✓
	**ACEF030B** **Central gasket inward**	**100**	**m**	**Outer Frames, Transoms & Mullions**	MF SA KL HP SSC SMC W Z PC	 ✓
	**ACEF031A** **Pre-formed corners for ACEF030A**	**48**	**Pack**	**Outer Frames, Transoms & Mullions**	MF SA KL HP SSC SMC W Z PC	 ✓
	**ACEF043** **Foam**	**100**	**M**	**ETC4026**	MF SA KL HP SSC SMC W Z PC	
	**ACET041** **Cill Nose Bracket**	**1**	**Pack**	**ETC451 ETC452 ETC457 ETC458 ETC479**	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**	**W**	**= White**
SA	**= Silver Anodised**	**Z**	**= Black**
KL	**= Basic Colour**		
HP	**= Special Colour**		
SSC	**= Smooth Satin Chrome**		
SMC	**= Smokey Chrome**		
PC	**= Polished Chrome**		

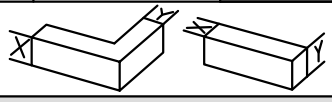
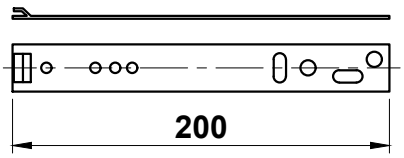
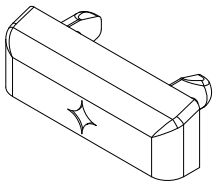
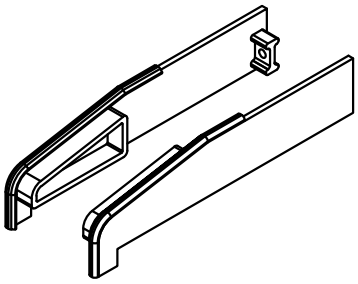
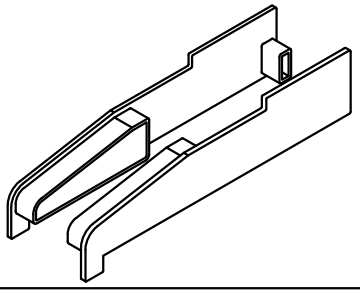
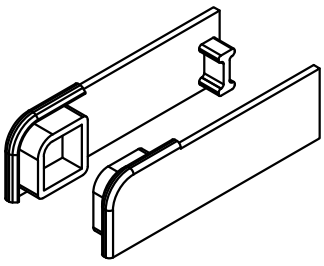


Image	Part Code	Pack	Unit	Application	Colour	
	**ACET130** **Galvanized Steel Fixing Strap** **200mm x 25mm x 1.5mm**	**100**	**Pack**	**ETC4011** **ETC4014** **ETC4016** **ETC4018**	MF SA KL HP SSC SMC W Z PC	
	**ACET131** **Drainage Cover Cap** **For colour matched drainage caps, please order ACET432**	**100**	**Pack**	**ETC4011** **ETC4014** **ETC4016** **ETC4017** **ETC4018** **ETC4019**	MF SA KL HP SSC SMC W Z PC	 ✓ ✓
	**ACET152** **PVC End Cap**	**10**	**Pair**	**ACET452**	MF SA KL HP SSC SMC W Z PC	 ✓ ✓
	**ACET157** **PVC End Cap**	**10**	**Pair**	**ETC457**	MF SA KL HP SSC SMC W Z PC	 ✓ ✓
	**ACET178** **PVC End Cap**	**10**	**Pair**	**ETC451**	MF SA KL HP SSC SMC W Z PC	 ✓ ✓



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



Screw (Grub)

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

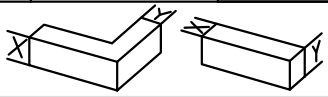
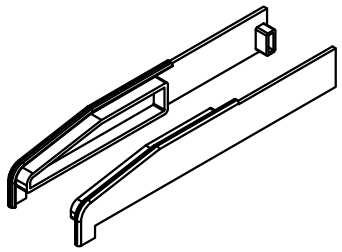
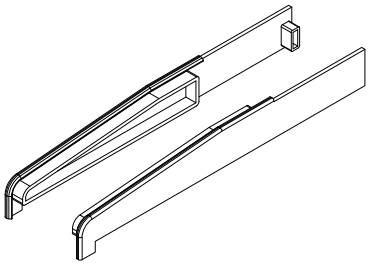
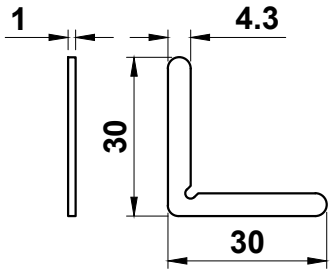
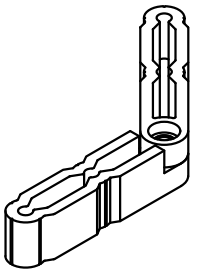
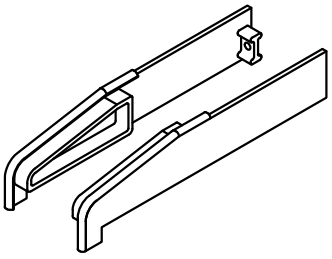


Image	Part Code	Pack	Unit	Application	Colour	
	**ACET258** **PVC End Cap**	**10**	**Pair**	**ETC458**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	✓
					Z	✓
					PC	
	**ACET179** **PVC End Cap**	**10**	**Pair**	**ETC479**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	✓
					Z	✓
					PC	
	**ACET311** **Stainless Steel Chevron**	**50**	**Pack**	**ETC4027** **ETC4028**	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
	**ACET440** **Variable Cill Angle Bracket**	**10**	**Pack**		MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
	**ACET457** **Cast End Cap**	**1**	**Pair**	**ETC457**	MF	✓
					SA	
					KL	✓
					HP	✓
					SSC	
					SMC	
					W	
					Z	✓
					PC	✓



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



Screw (Grub)

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

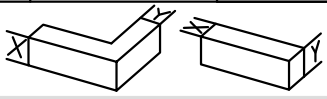
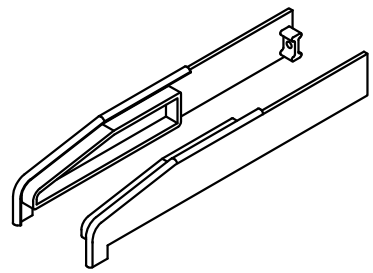
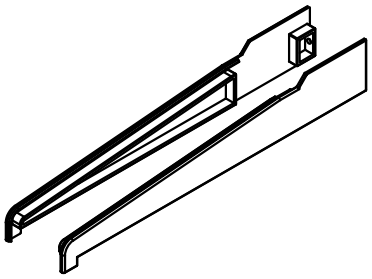
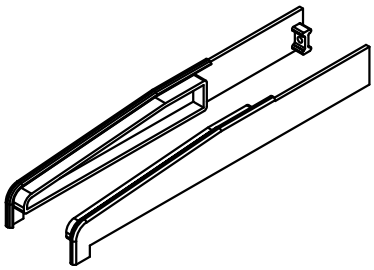
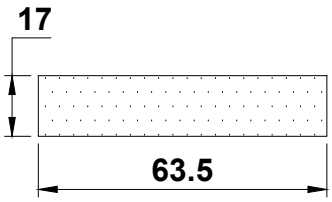
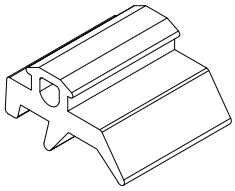
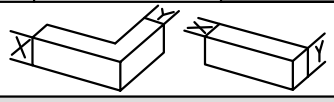


Image	Part Code	Pack	Unit	Application	Colour
	**ACET458** **Cast End Cap**	**1**	**Pair**	**ETC458**	MF ✓ SA KL ✓ HP ✓ SSC SMC W Z ✓ PC ✓
	**ACET477** **Cast End Cap**	**1**	**pair**	**ETC477**	MF ✓ SA KL ✓ HP ✓ SSC SMC W Z ✓ PC ✓
	**ACET479** **Cast End Cap**	**1**	**pair**	**ETC479**	MF ✓ SA KL ✓ HP ✓ SSC SMC W Z ✓ PC ✓
	**ACET619** **Foam** **Length = 1250mm**	**1**	**Each**	**ETC4014** **ETC4018**	MF ✓ SA KL HP SSC SMC W Z PC
	**ACET842** **3mm Low Line External Gasket**	**200**	**m**	**Outer Frames, Sashes, Transoms & Mullions**	MF SA KL HP SSC SMC W Z ✓ PC



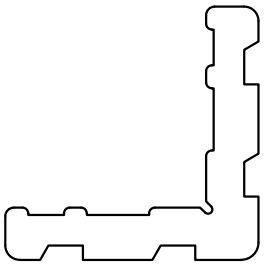
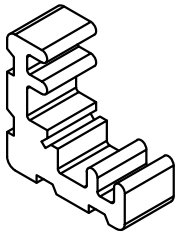
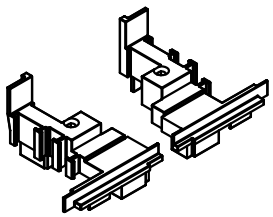
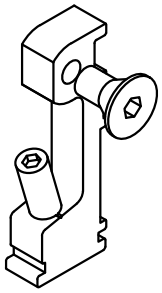
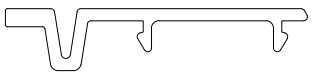


MF	**= Mill Finish**	**W**	**= White**
SA	**= Silver Anodised**	**Z**	**= Black**
KL	**= Basic Colour**		
HP	**= Special Colour**		
SSC	**= Smooth Satin Chrome**		
SMC	**= Smokey Chrome**		
PC	**= Polished Chrome**		



Alitherm 400 Tilt & Turn

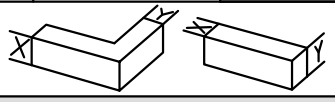
ACCESSORIES : PHOTOS & DRAWINGS

Image	Part Code	Pack	Unit	Application	Colour	
	**ACET4021A** **Crimping Cleat**	**24**	**Pack**	**ETC4026**	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
	**ACET4029** **Crimping Cleat**	**24**	**Pack**	**ETC4026**	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
	**ACET4037** **ETC4037 End Cap**	**10**	**Pairs**	**ETC4037**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	✓
					Z	✓
					PC	
	**ACET4040** **Transom Cleat**	**24**	**Pack**	**ETC4031** **ETC4036** **ETC4039**	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
	**ACET4041** **Bridge Packer**	**12**	**Pack**	**ETC4011** **ETC4014** **ETC4017** **ETC4031**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	

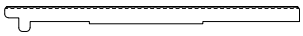
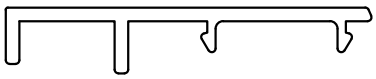
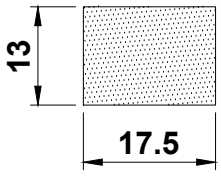
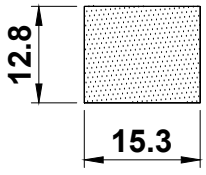




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SSC = Smooth Satin Chrome
SMC = Smokey Chrome
PC = Polished Chrome
W = White
Z = Black



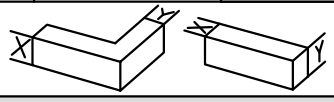
ISSUED : July 2026

Image	Part Code	Pack	Unit	Application	Colour	
	**ACET4042** **Bridge Packer**	**12**	**Pack**	**ETC4021** **ETC4028**	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
	**ACET4043**	**12**	**Pack**	**ETC4016** **ETC4018** **ETC4036**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
					MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
	**ACET4049** **Foam** **Length = 1250mm**	**1**	**Each**	**ETC4037**	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
	**ACET4051** **Foam** **Length = 1250mm**	**1**	**Each**	**ETC4011** **ETC4014** **ETC4016** **ETC4018**	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	



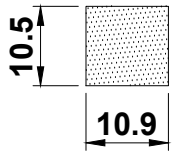
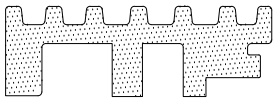
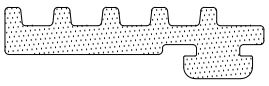
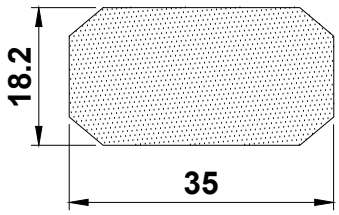
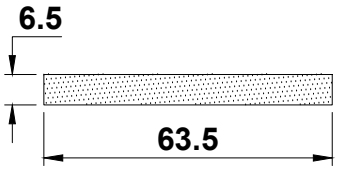


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W = White
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Alitherm 400 Tilt & Turn

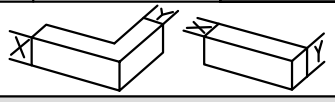
ACCESSORIES : PHOTOS & DRAWINGS

Image	Part Code	Pack	Unit	Application	Colour
	**ACET4053** **Foam** **Length = 1250mm**	**1**	**Each**	**ETC4021** **ETC4028**	MF ✓ SA KL HP SSC SMC W Z PC
	**ACET4056** **Foam**	**150**	**M**	**ETC4011** **ETC4014** **ETC4016** **ETC4018** **ETC4031** **ETC4036**	MF ✓ SA KL HP SSC SMC W Z PC
	**ACET4059** **Foam**	**150**	**M**	**ETC4021** **ETC4028**	MF ✓ SA KL HP SSC SMC W Z PC
	**ACET4069** **Foam** **Length = 1250mm**	**1**	**Each**	**ETC4027**	MF ✓ SA KL HP SSC SMC W Z PC
	**ACET4070** **Foam** **Length = 1250mm**	**1**	**Each**	**ETC4011** **ETC4016**	MF ✓ SA KL HP SSC SMC W Z PC

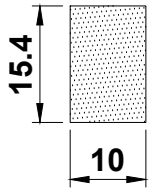
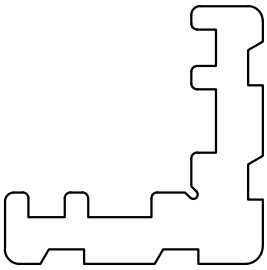
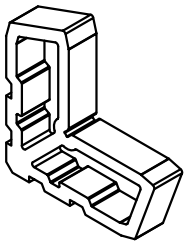
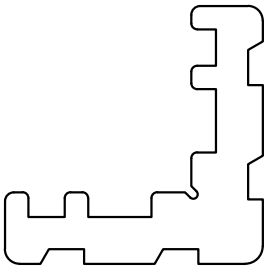
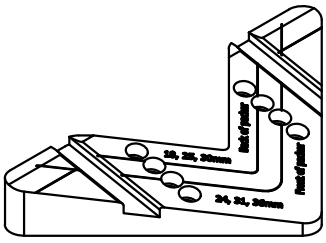

T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm


Screw (Grub)

MF	**= Mill Finish**	**W**	**= White**
SA	**= Silver Anodised**	**Z**	**= 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
	**ACET4079** **Foam** **Length = 1250mm**	**1**	**Each**	**ETC4011** **ETC4016**	MF ✓ SA KL HP SSC SMC W Z PC
	**ACET4110** **Crimping Cleat**	**24**	**Pack**	**ETC4011** **ETC4014** **ETC4016** **ETC4018**	MF ✓ SA KL HP SSC SMC W Z PC
	**ACET4119** **Crimping Cleat**	**24**	**Pack**	**ETC4027**	MF ✓ SA KL HP SSC SMC W Z PC
	**ACET4122** **Crimping Cleat**	**24**	**Pack**	**ETC4016** **ETC4018** **ETC4028**	MF ✓ SA KL HP SSC SMC W Z PC
	**ACET4381** **Adjustable Packer**	**1**	**Each**	**ETC4011** **ETC4014** **ETC4016** **ETC4018** **ETC4021** **ETC4028**	MF SA KL HP SSC SMC W Z PC



T-BARS
ACVG65=2.5mm
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SSC	**= Smooth Satin Chrome**		
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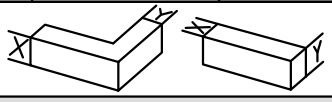
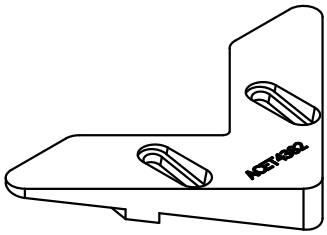
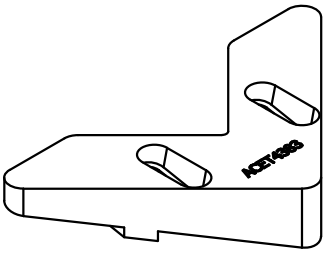
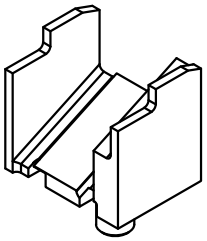
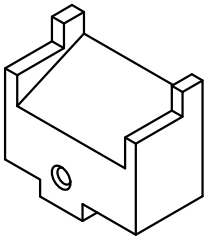
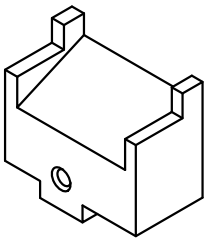


Image	Part Code	Pack	Unit	Application	Colour
	**ACET4382** **Adjustable Packer**	**1**	**Each**	**ETC4028**	MF SA KL HP SSC SMC W Z PC
	**ACET4383** **Adjustable Packer**	**1**	**Each**	**ETC4011** **ETC4014** **ETC4016** **ETC4018** **ETC4021**	MF SA KL HP SSC SMC W Z PC
	**ACET4385** **Punches**	**1**	**Each**	**ETC4017** **ETC4019**	MF SA KL HP SSC SMC W Z PC
	**ACET4394N** **Punches**	**1**	**Each**	**ETC4021** **ETC4028**	MF SA KL HP SSC SMC W Z PC
	**ACET4395** **Punches**	**1**		**ETC4011** **ETC4014** **ETC4016** **ETC4018**	MF SA KL HP SSC SMC W Z PC



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ACVG66=3.0mm
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W = White
Z = Black

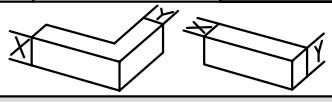
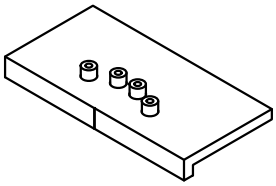
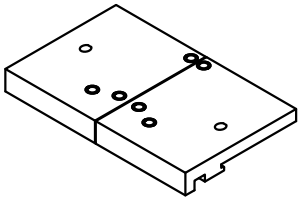
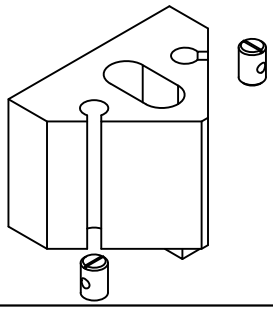
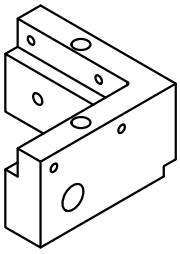
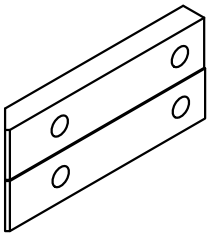


Image	Part Code	Pack	Unit	Application	Colour
	**ACET4931** **Jig mark**	**1**	**Each**	**ETC4031**	MF SA KL HP SSC SMC W Z PC
	**ACET4932** **Jig mark**	**1**	**Each**	**ETC4036**	MF SA KL HP SSC SMC W Z PC
	**ACUN3950** **VEE Block**	**1**	**Each**	**ETC4011** **ETC4014** **ETC4016** **ETC4018** **ETC4021**	MF SA KL HP SSC SMC W Z PC
	**ACUN3951** **VEE Packer**	**1**	**Each**	**ETC4011** **ETC4014** **ETC4016** **ETC4018** **ETC4021** **ETC4028**	MF SA KL HP SSC SMC W Z PC
	**ACUN3952** **Nylon Packer**	**1**	**Each**	**ETC4011** **ETC4014** **ETC4016** **ETC4018** **ETC4021** **ETC4028**	MF SA KL HP SSC SMC W Z PC

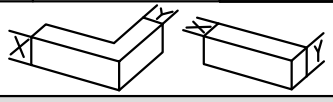


T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm



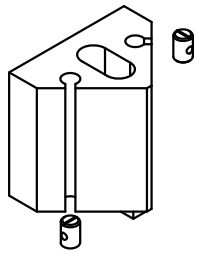
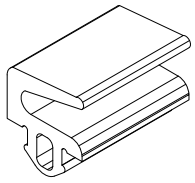
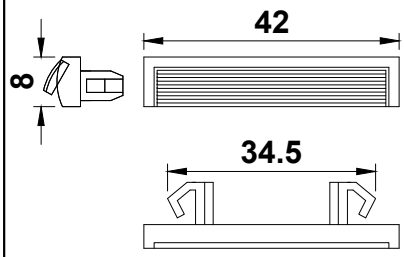
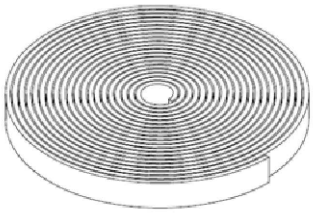
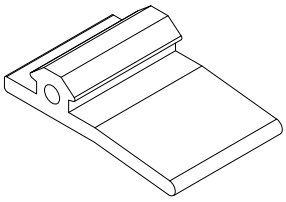
Screw (Grub)

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



Alitherm 400 Tilt & Turn

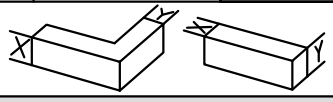
ACCESSORIES : PHOTOS & DRAWINGS

Image	Part Code	Pack	Unit	Application	Colour
	**ACUN3964** **Vee Block**	**1**	**Each**	**ETC4011** **ETC4014** **ETC4016** **ETC4018** **ETC4028**	MF SA KL HP SSC SMC W Z PC
	**ACVL031** **EPDM Flipper Gasket**	**100**	**m**	**ETC4021** **ETC4028**	MF SA KL HP SSC SMC W Z ✓ PC
	**ACGSL045** **Drainage Cap**	**100**	**Pack**	**ETC4011** **ETC4014** **ETC4016** **ETC4018**	MF SA KL HP SSC SMC W ✓ Z ✓ PC
	**ACMX09815N** **Double Sided Tape** **1.6mm**	**46**	**m**	**ACEF043**	MF ✓ SA KL HP SSC SMC W Z PC
	**ACW20131** **Outer Frame External Gasket**	**100**	**m**	**ETC4011** **ETC4014** **ETC4016** **ETC4018** **ETC4031** **ETC4036**	MF SA KL HP SSC SMC W Z ✓ PC

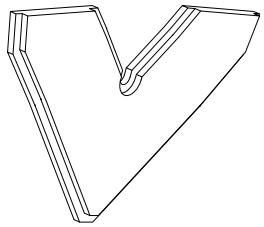
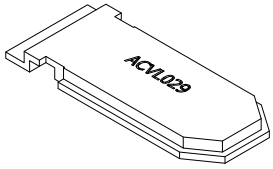

T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm


Screw (Grub)

MF	**= Mill Finish**	**W**	**= White**
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KL	**= Basic Colour**		
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SSC	**= Smooth Satin Chrome**		
SMC	**= Smokey Chrome**		
PC	**= Polished Chrome**		



ISSUED : July 2026

Image	Part Code	Pack	Unit	Application	Colour	
	**ACVL020B** **Plastic chevron**	**100**	**pack**	**ETC4011** **ETC4014** **ETC4016** **ETC4018**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	✓
					PC	
	**ACVL029** **Strengthening piece**	**100**	**Pack**	**ETC4031** **ETC4036**	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
					MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
					MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
					MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	



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ACVL150=4.0mm



Screw (Grub)

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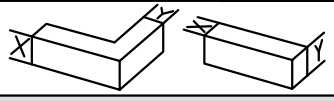


Image	Part Code	Pack	Unit	Application	Colour
					MF SA KL HP SSC SMC W Z PC
					MF SA KL HP SSC SMC W Z PC
					MF SA KL HP SSC SMC W Z PC
					MF SA KL HP SSC SMC W Z PC
					MF SA KL HP SSC SMC W Z PC

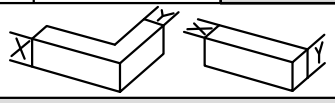


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ACVG66=3.0mm
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Alitherm 400 Tilt & Turn

STANDARD ACCESSORIES

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



T-BARS
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ACVG66=3.0mm
ACVL150=4.0mm



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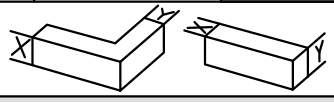


Image	Part Code	Pack	Unit	Application	Colour
	**ACMX09765** **Alu. Cleaner**	**1**	**each**		MF SA KL HP SSC SMC W Z PC
	**ACMX09770** **Roll & Wrap 100mm**	**1**	**each**		MF SA KL HP SSC SMC W Z PC
	**ACMX09775** **Grip Handwrap**	**1**	**each**		MF SA KL HP SSC SMC W Z PC
	**ACMX09801** **Protective Tape 50mm**	**1**	**each**		MF SA KL HP SSC SMC W Z PC
	**ACMX09802** **Protective Tape 70mm**	**1**	**each**		MF SA KL HP SSC SMC W Z PC

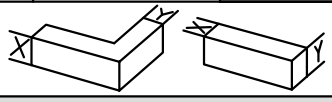


T-BARS
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ACVL150=4.0mm



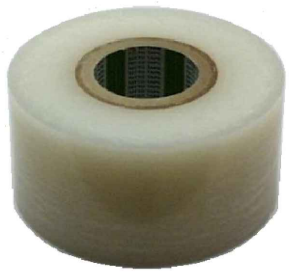
Screw (Grub)

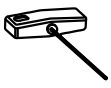
MF	**= Mill Finish**	**W**	**= White**
SA	**= Silver Anodised**	**Z**	**= Black**
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Alitherm 400 Tilt & Turn

STANDARD ACCESSORIES

Image	Part Code	Pack	Unit	Application	Colour
	**ACMX09803** **Protective Tape 100mm**	**1**	**each**		MF SA KL HP SSC SMC W Z PC
	**ACMX09830** **Rubber Sealant**	**1**	**each**		MF SA KL HP SSC SMC W Z PC
	**ACSIL04** **Sealing Glue** **Order with suffix of KL colour (eg.ACSIL04KL005) or BL=Black/WP=White/ CL=Clear**	**1**	**each**		MF SA KL ✓ HP SSC SMC W ✓ Z ✓ PC
	**ACSIL08** **Silicon Gun**	**1**	**each**		MF SA KL HP SSC SMC W Z PC
	**ACSIL013** **Glue for Mitre**	**1**	**each**		MF SA KL HP SSC SMC W Z PC





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HP	**= Special Colour**		
SSC	**= Smooth Satin Chrome**		
SMC	**= Smokey Chrome**		
PC	**= Polished Chrome**		

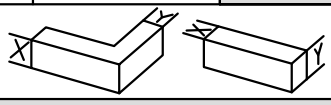


Image	Part Code	Pack	Unit	Application	Colour
	**ACSIL014** **Anti-Corrosion Coating**	**1**	**each**		MF ✓ SA KL HP SSC SMC W Z PC
	**ACUN3900** **Gasket Roller**	**1**	**each**		MF SA KL HP SSC SMC W Z PC
					MF SA KL HP SSC SMC W Z PC
					MF SA KL HP SSC SMC W Z PC
					MF SA KL HP SSC SMC W Z PC

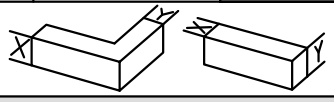


T-BARS
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Screw (Grub)

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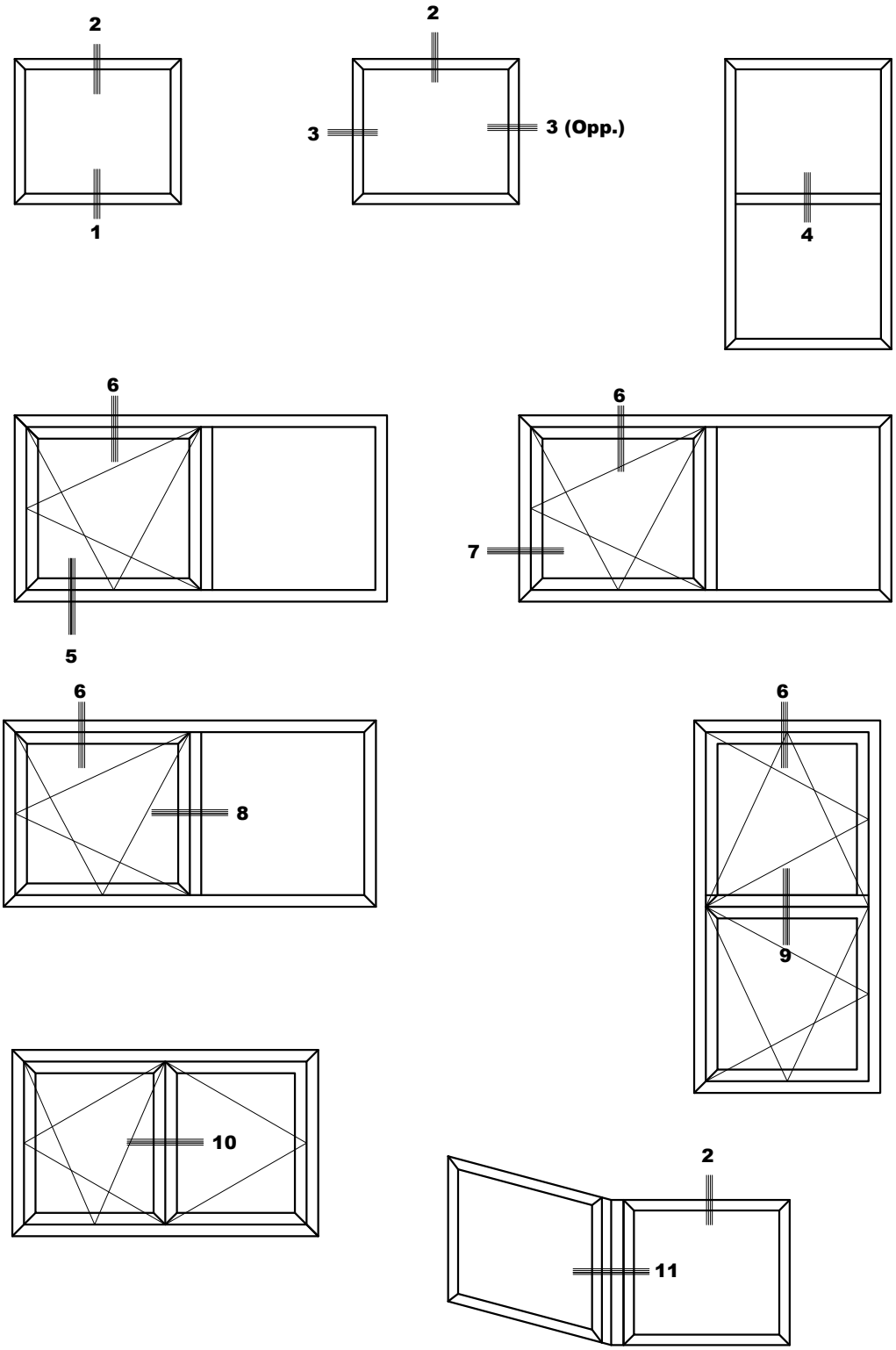


Section C

Sections

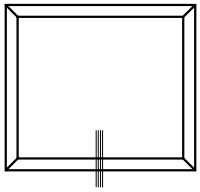
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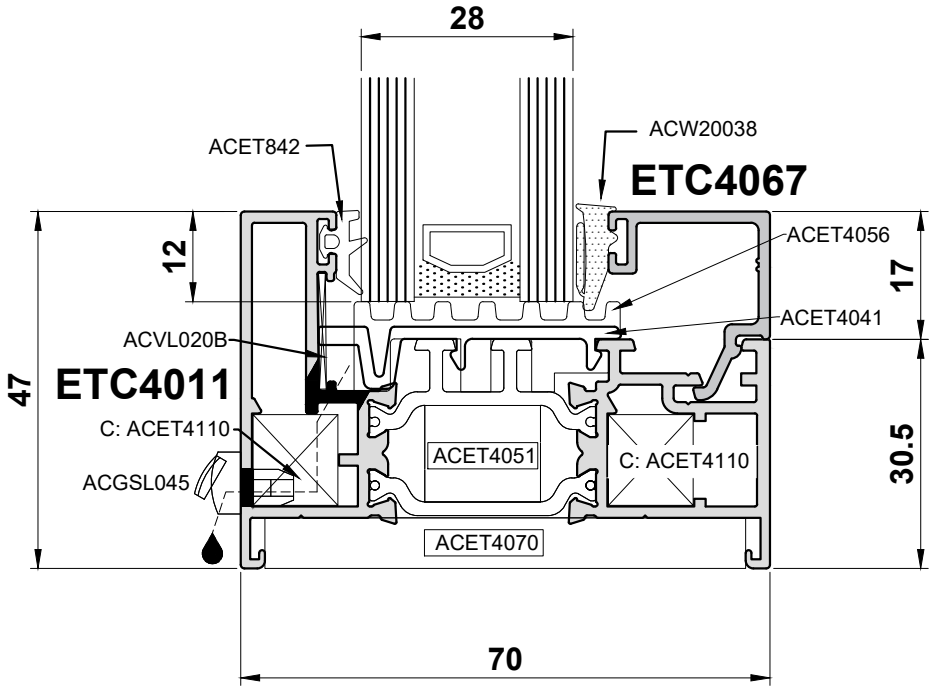
Detail



Do Not Scale From This Drawing

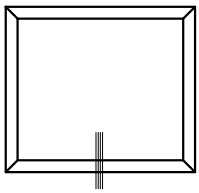
Detail 1A

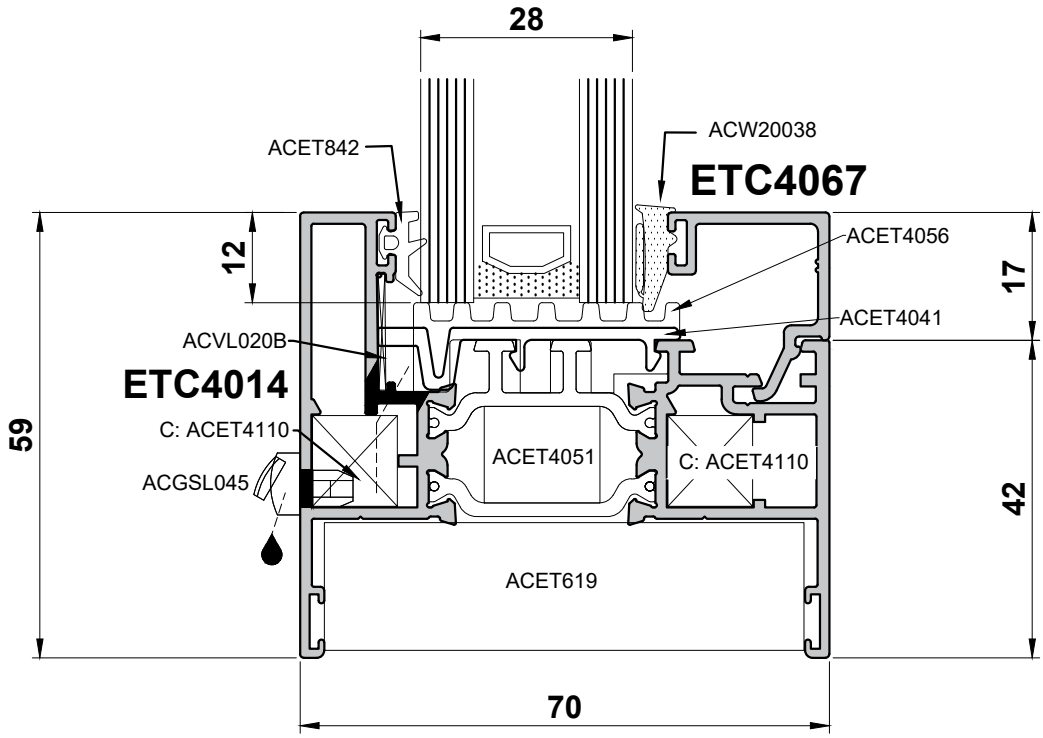




Do Not Scale From This Drawing

Detail 1B

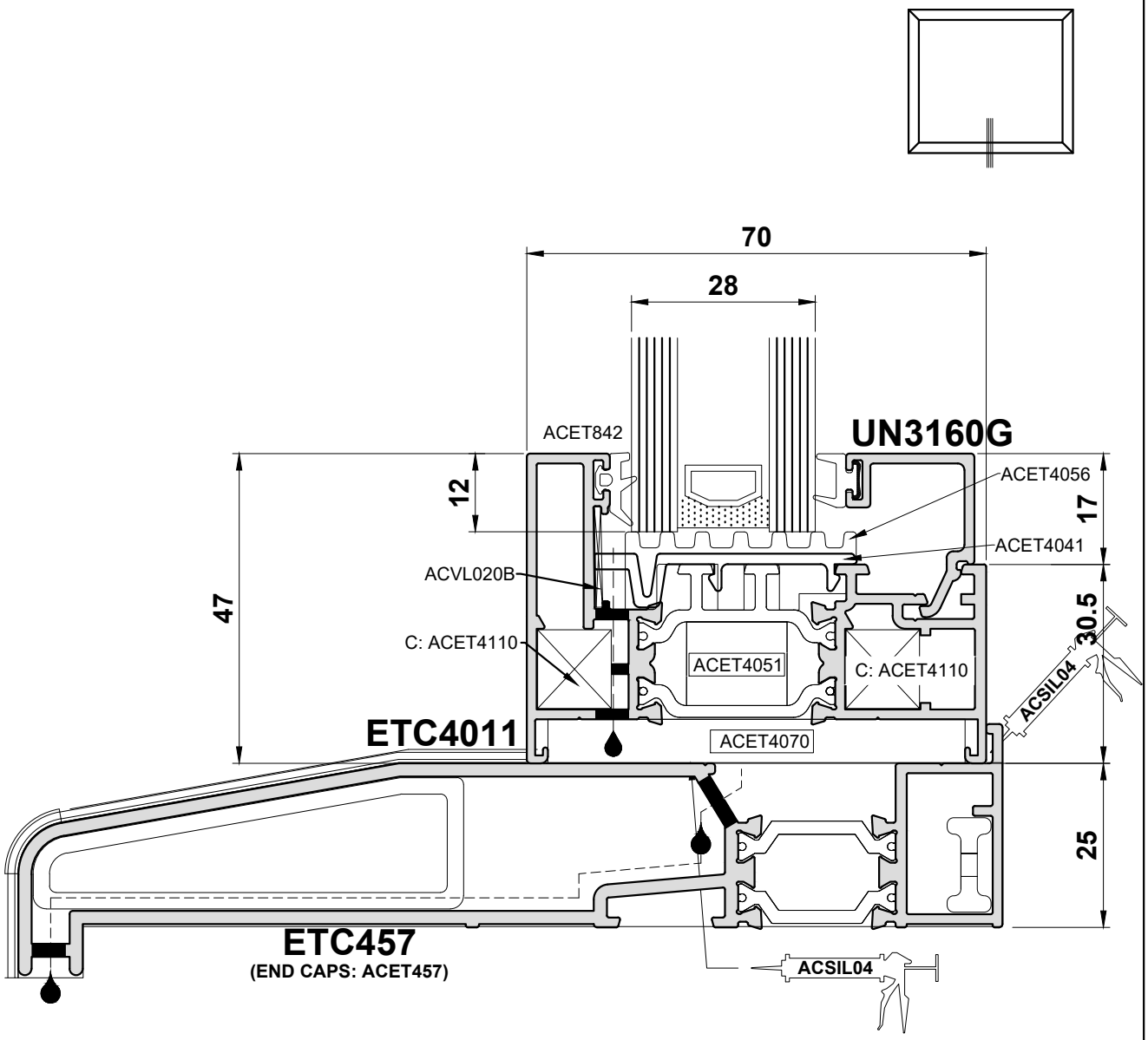




Do Not Scale From This Drawing

Alitherm 400 Tilt & Turn

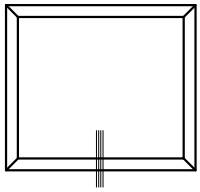
Detail 1C

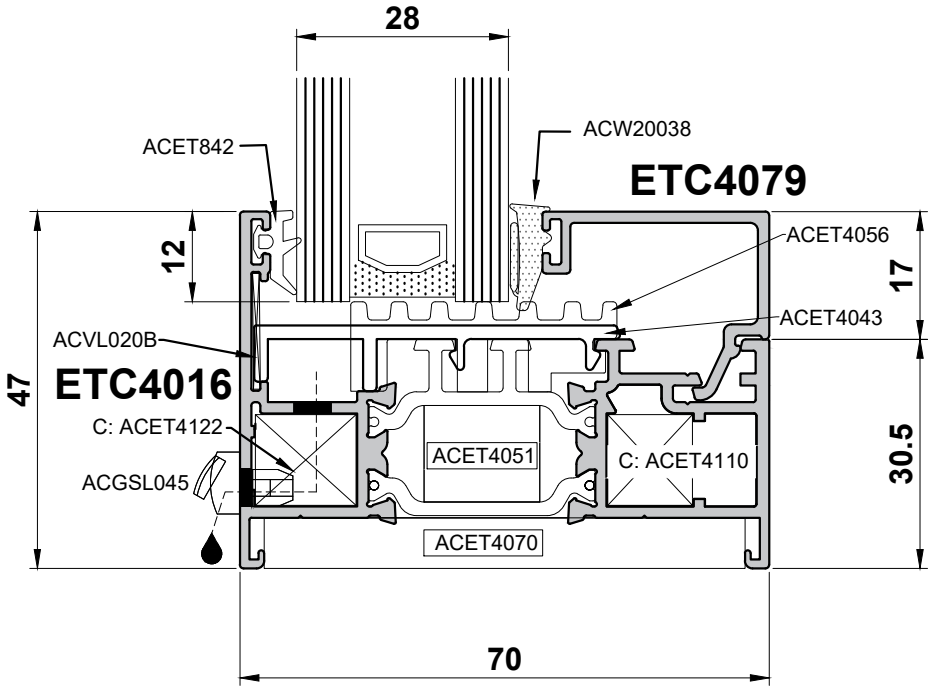


Do Not Scale From This Drawing

ISSUED : July 2026

Detail 1D

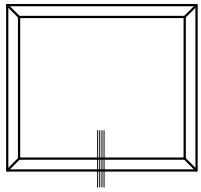


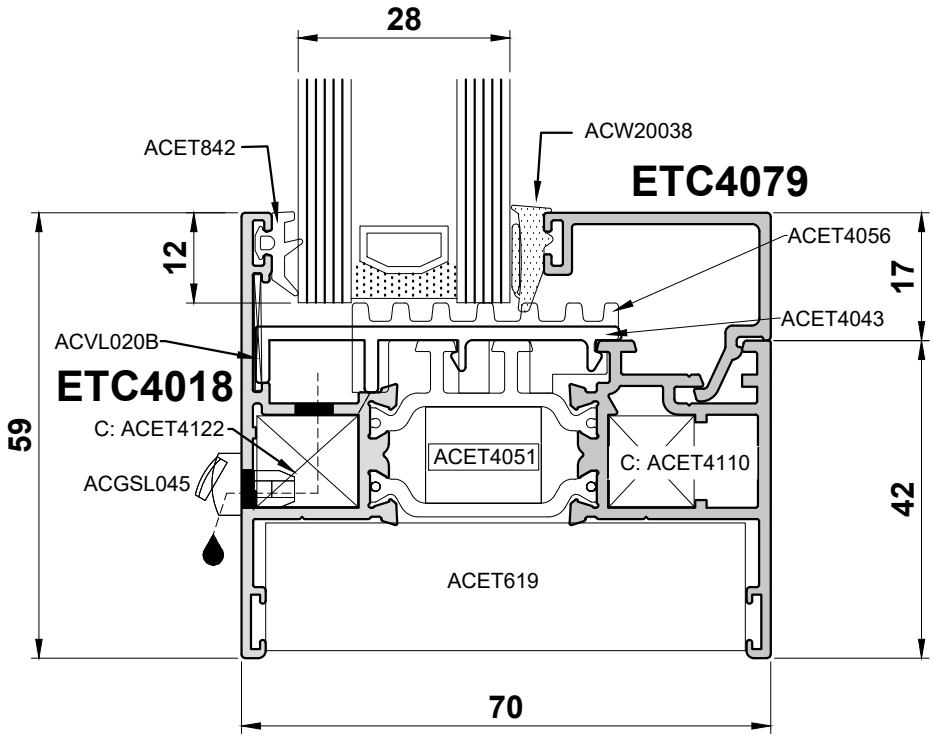


Do Not Scale From This Drawing

Alitherm 400 Tilt & Turn

Detail 1E



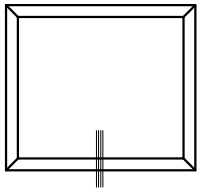


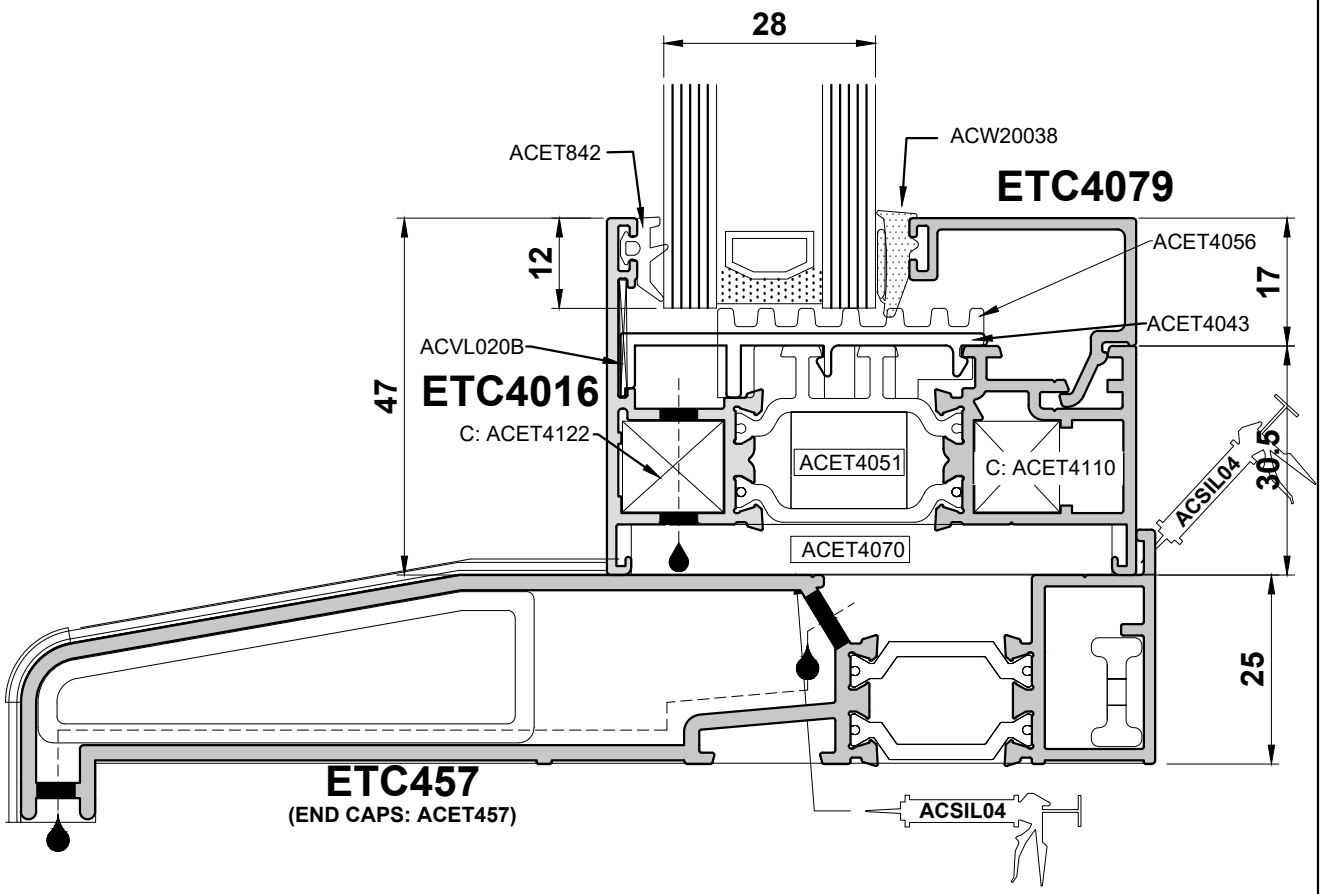
Do Not Scale From This Drawing

ISSUED : July 2026

Alitherm 400 Tilt & Turn

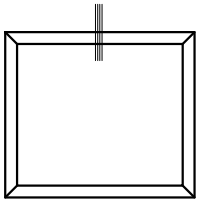
Detail 1F

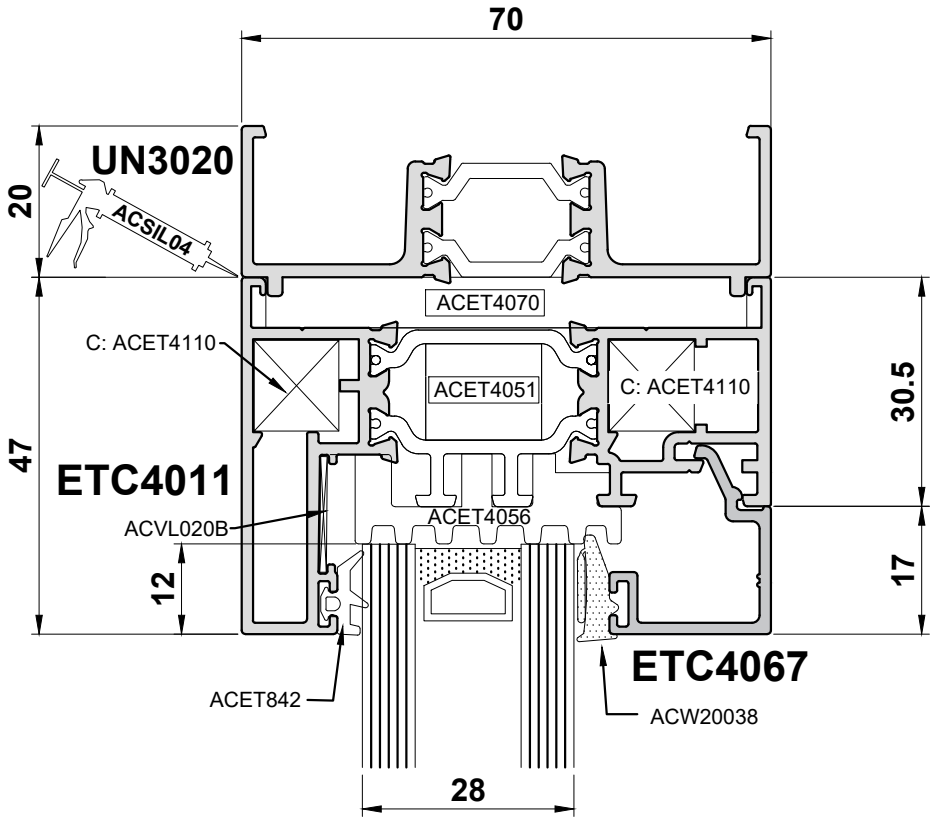




Do Not Scale From This Drawing

Detail 2A

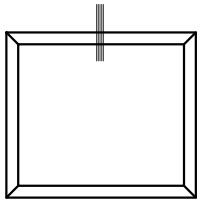


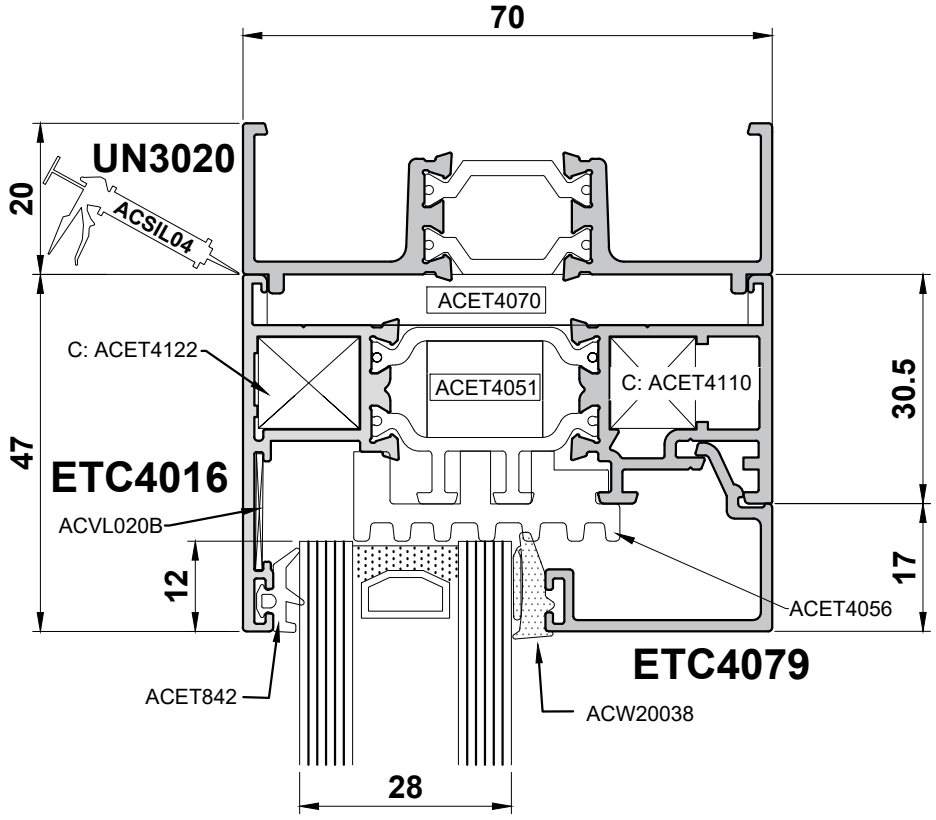


Do Not Scale From This Drawing

ISSUED : July 2026

Detail 2B

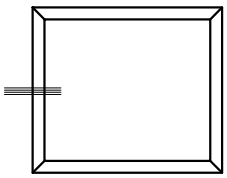


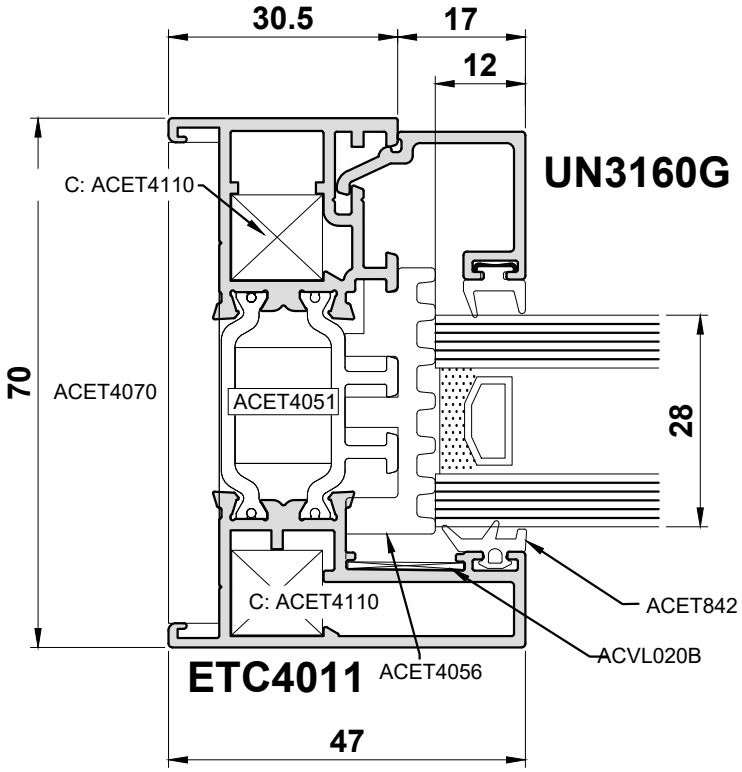


Do Not Scale From This Drawing

Alitherm 400 Tilt & Turn

Detail 3A

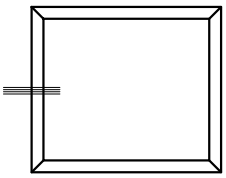


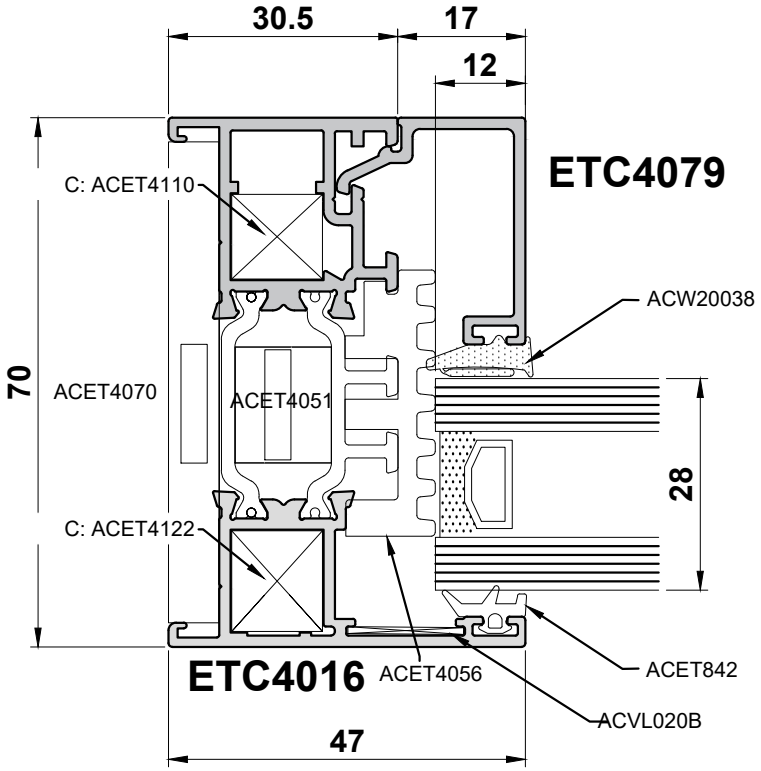


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ISSUED : July 2026

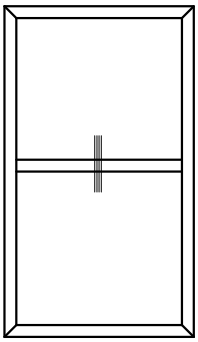
Detail 3B

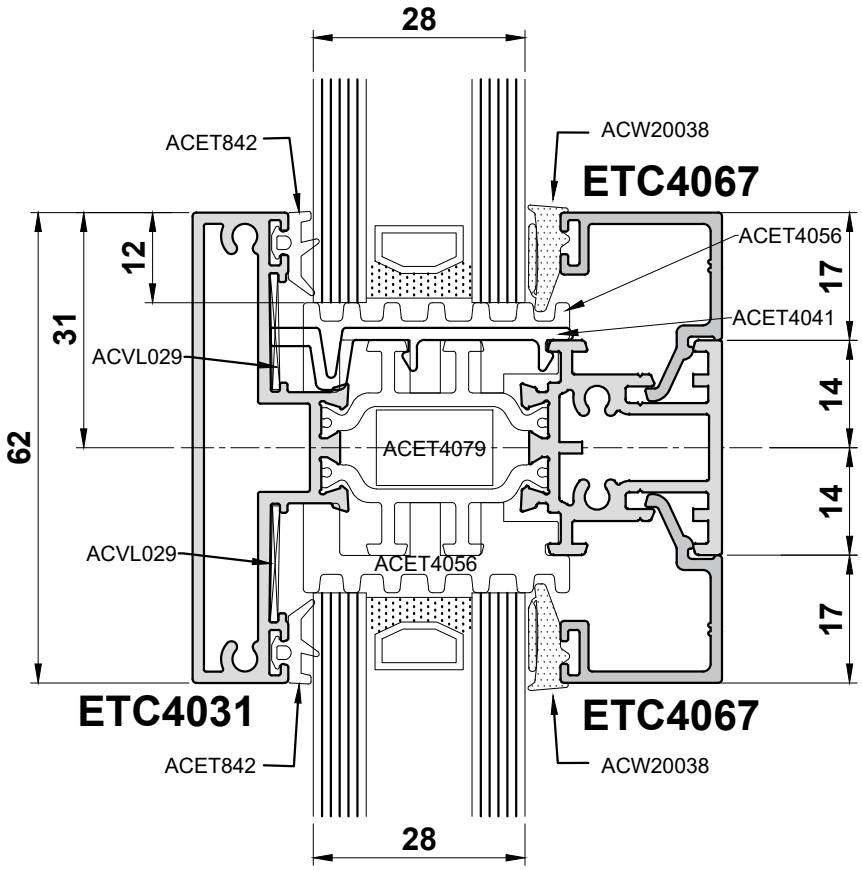




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Detail 4A

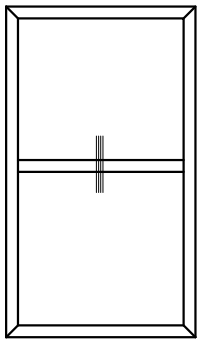


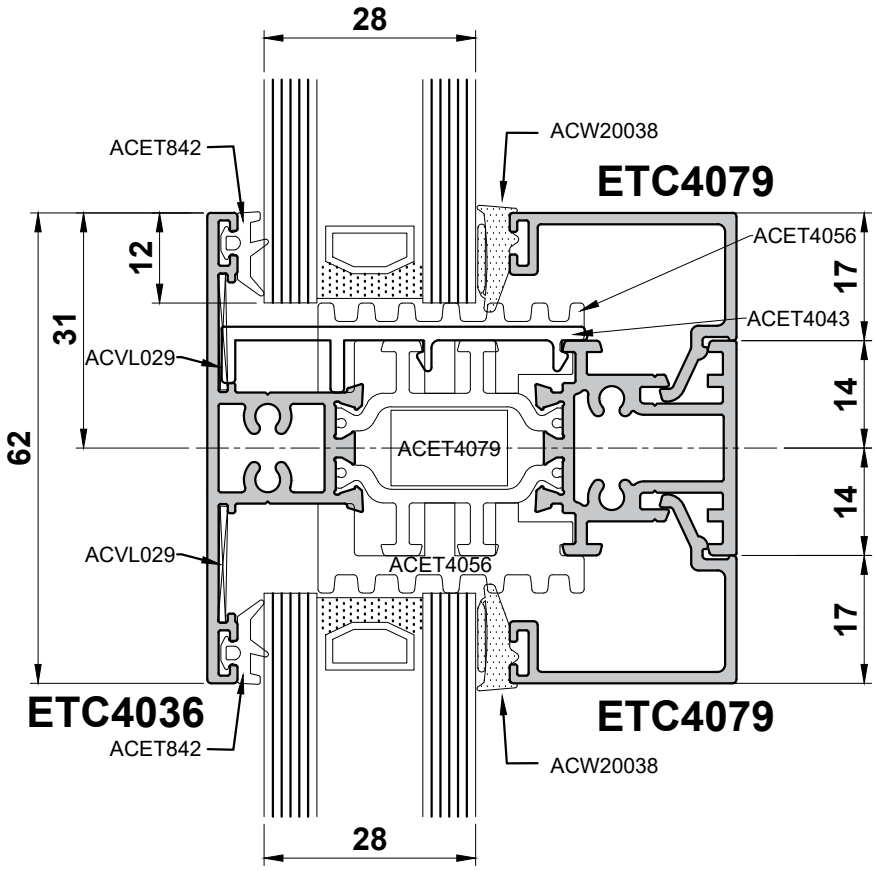


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ISSUED : July 2026

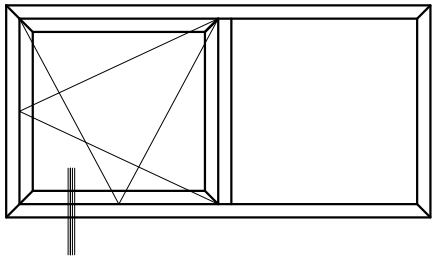
Detail 4B

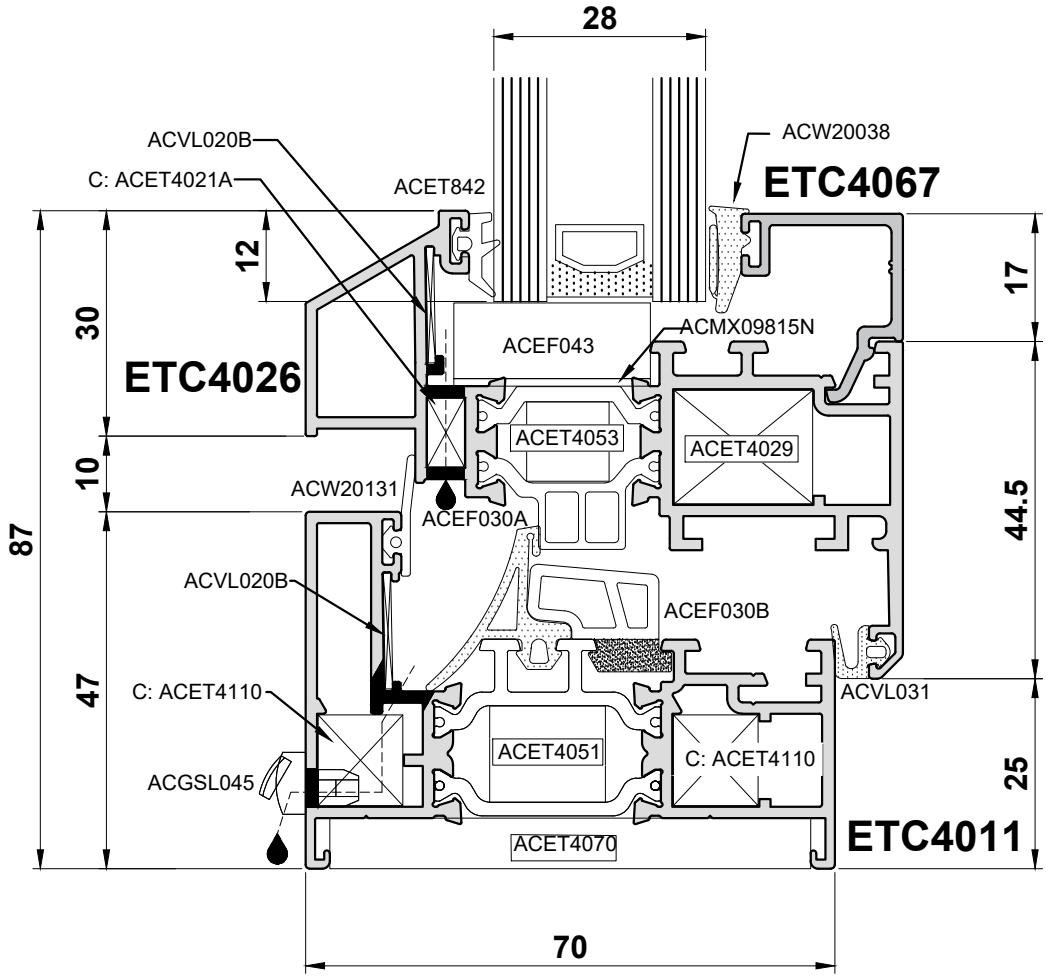




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Detail 5A



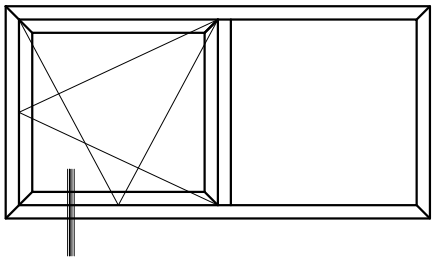


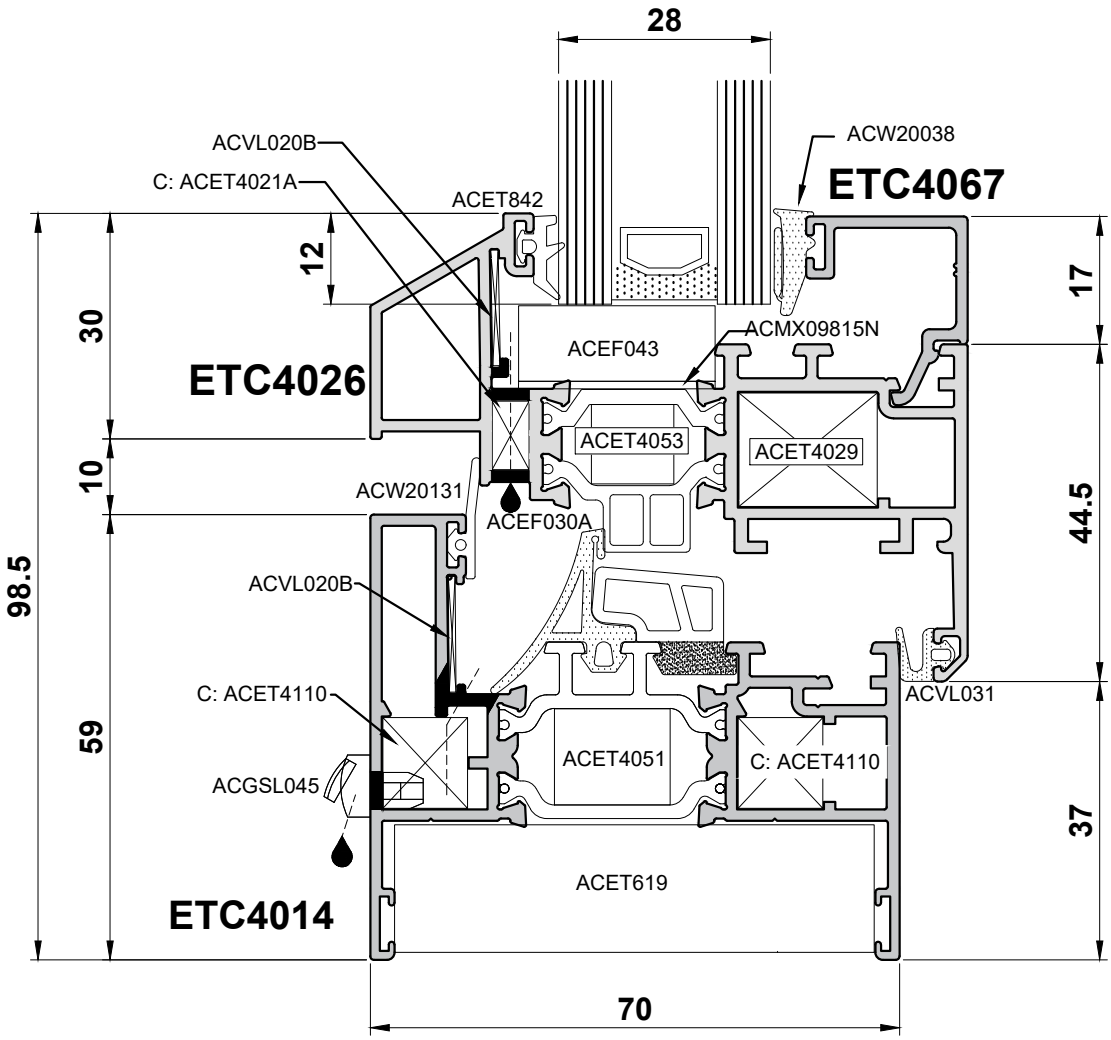
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ISSUED : July 2026

Alitherm 400 Tilt & Turn

Detail 5B

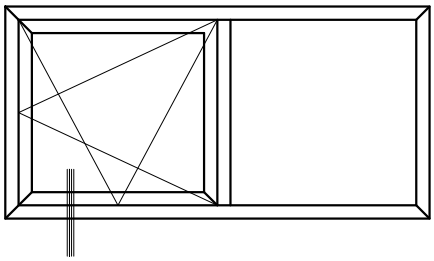


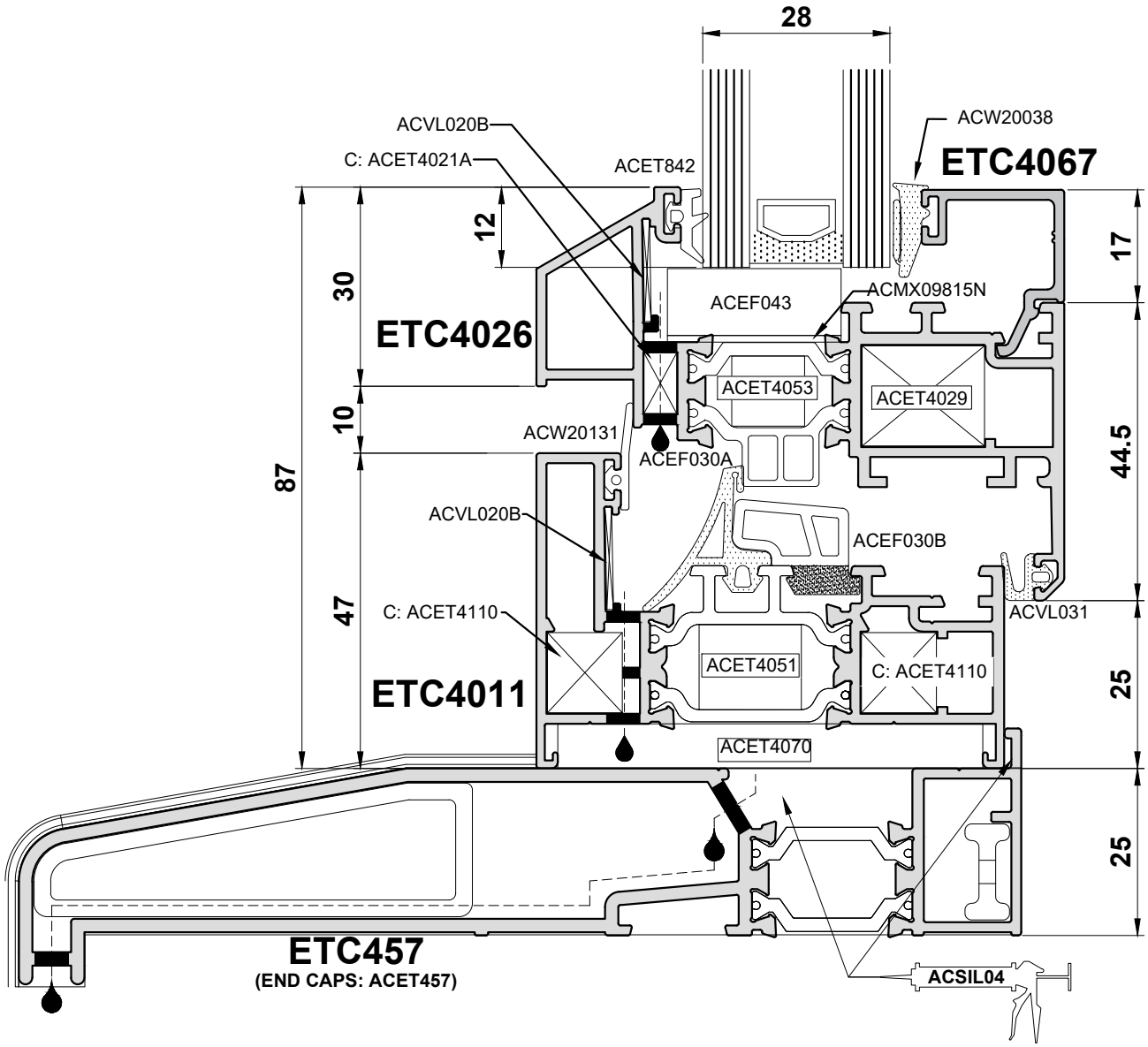


Do Not Scale From This Drawing

Alitherm 400 Tilt & Turn

Detail 5C



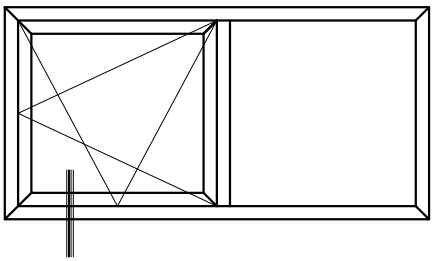


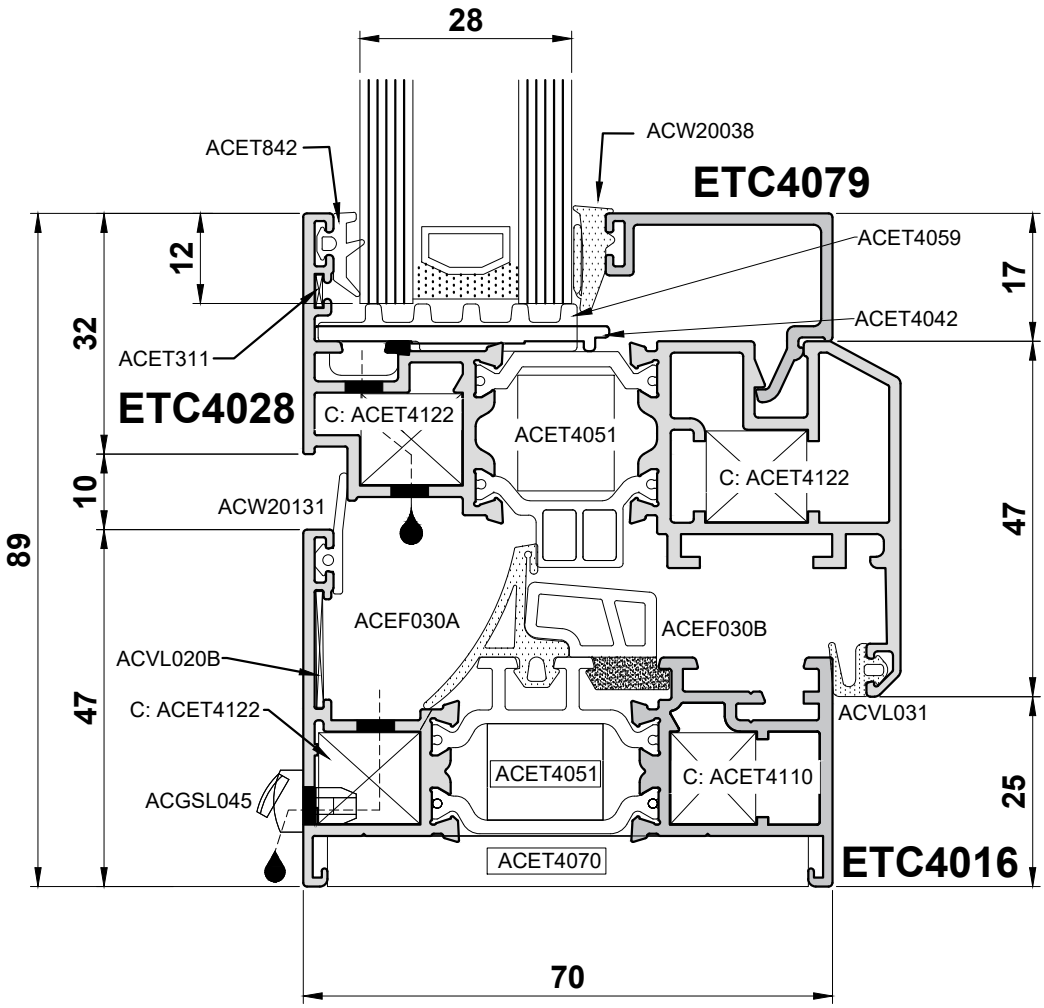
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ISSUED : July 2026

Alitherm 400 Tilt & Turn

Detail 5D

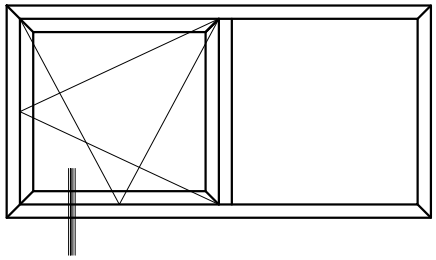


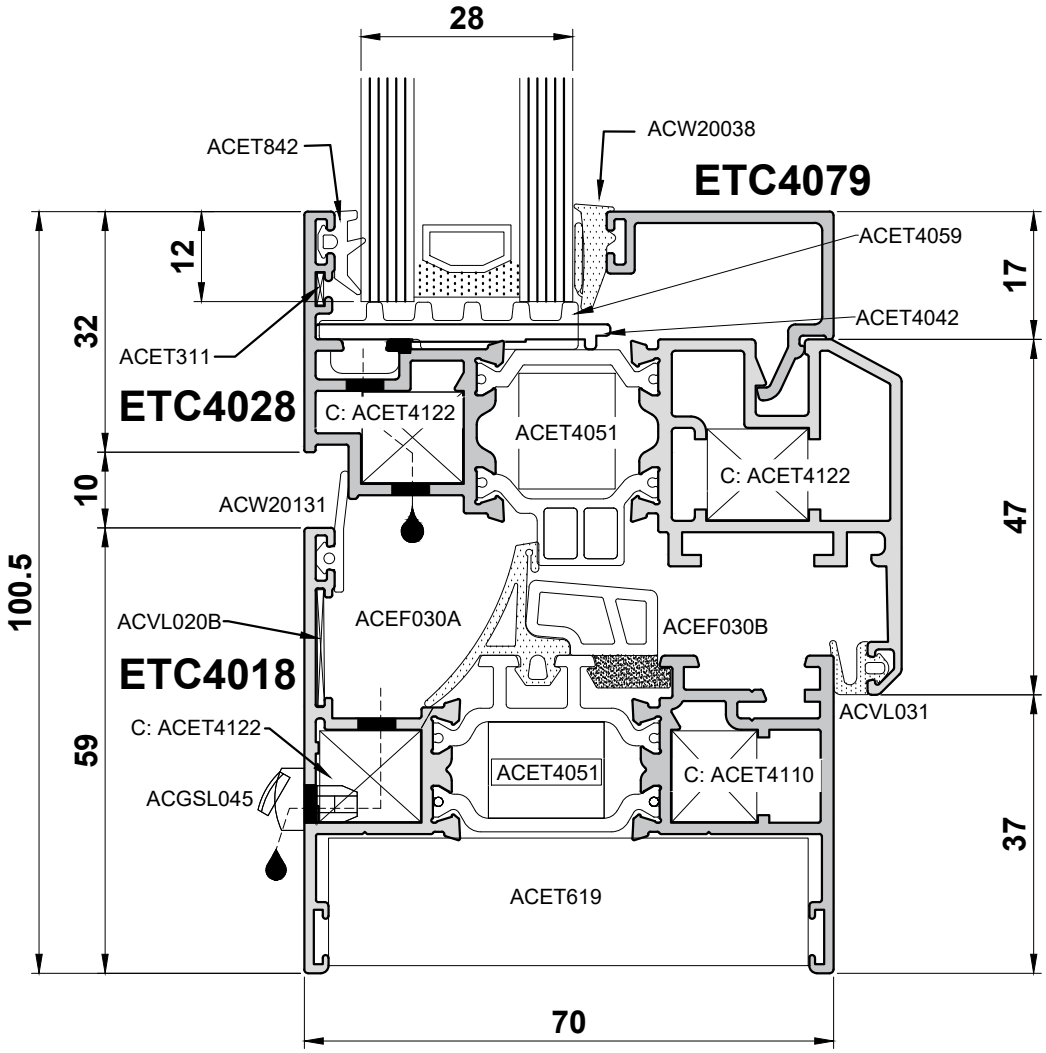


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Alitherm 400 Tilt & Turn

Detail 5E

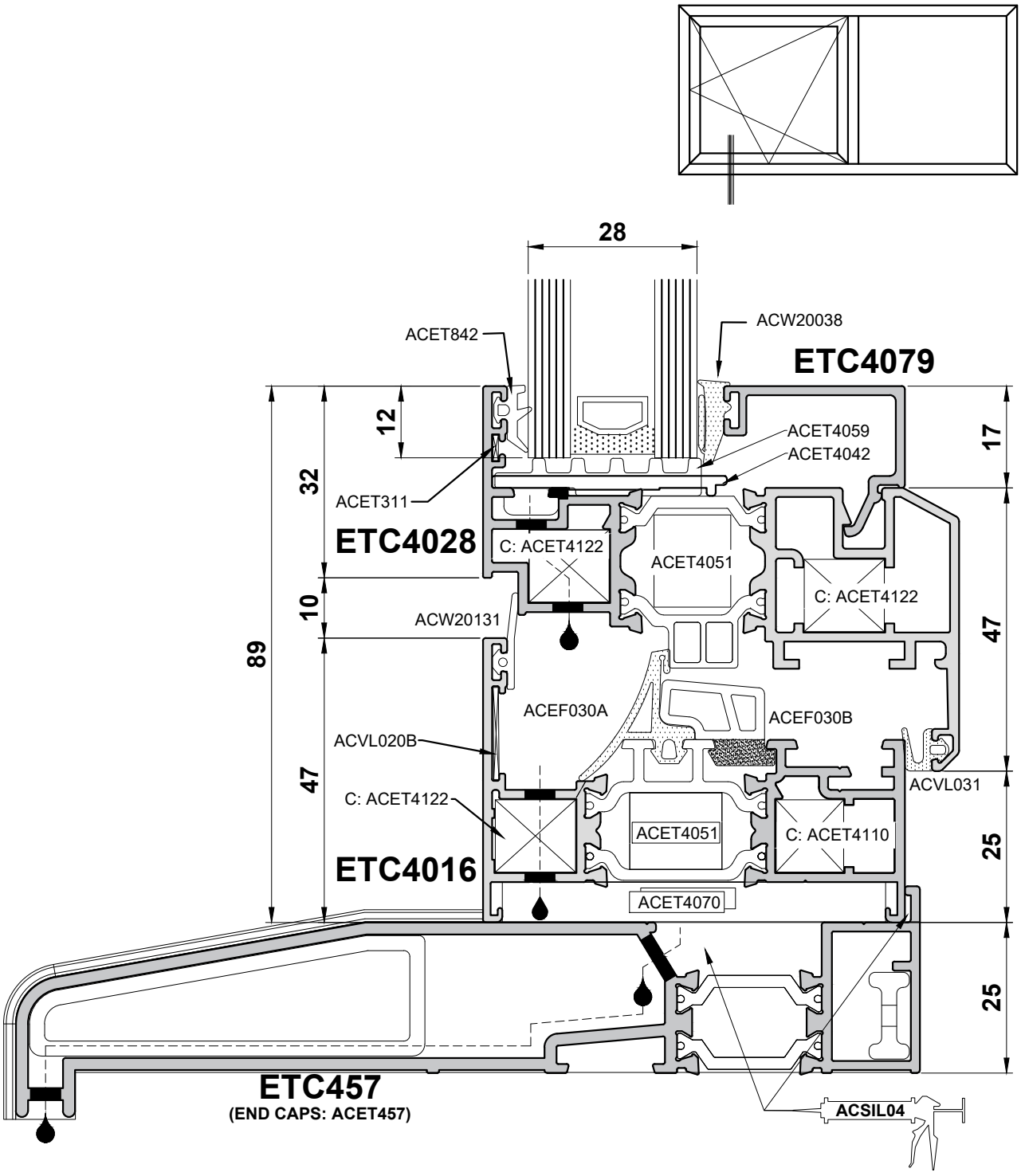




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ISSUED : July 2026

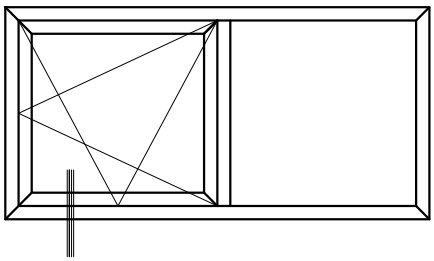
Detail 5F

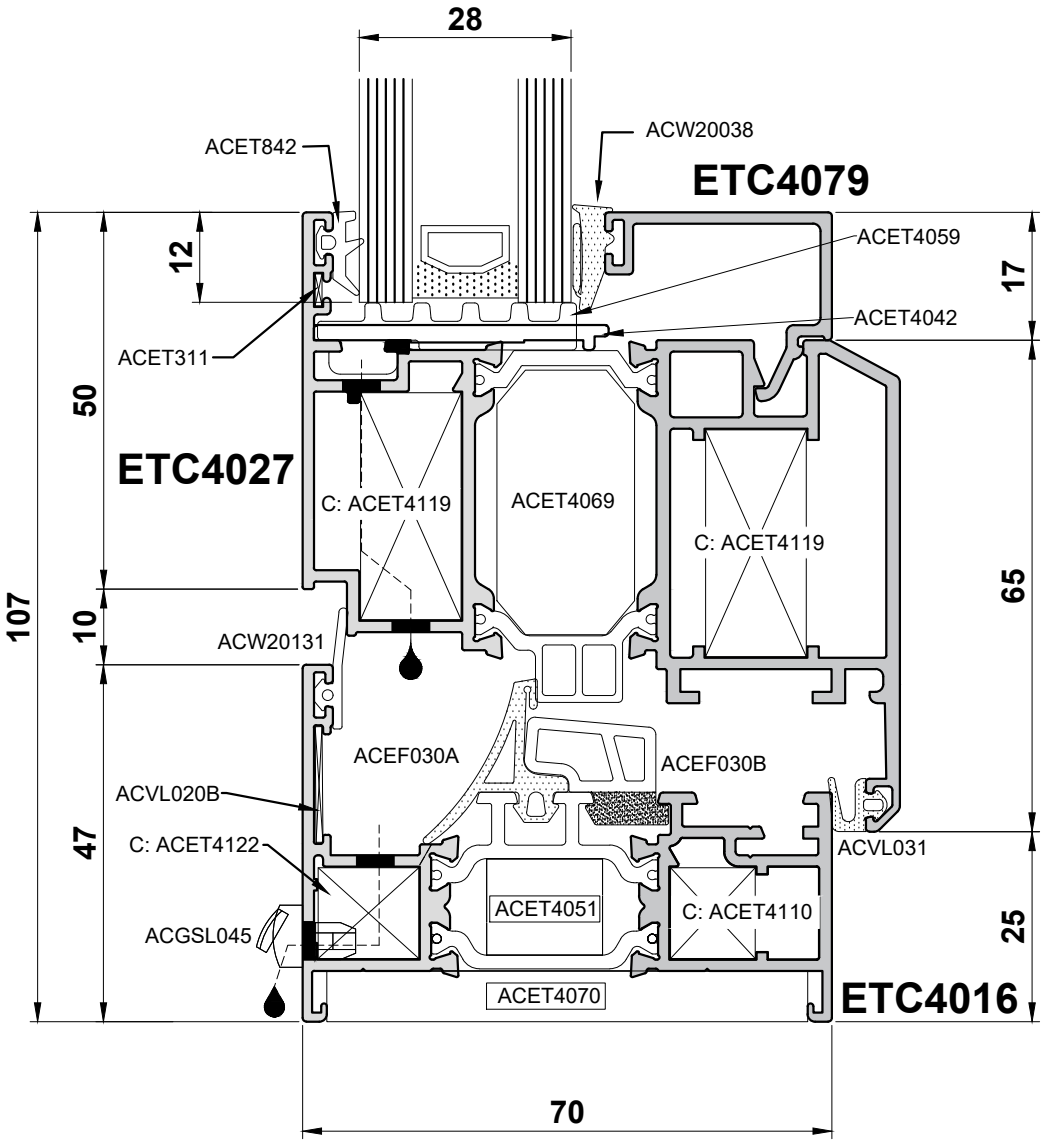


Do Not Scale From This Drawing

Alitherm 400 Tilt & Turn

Detail 5G



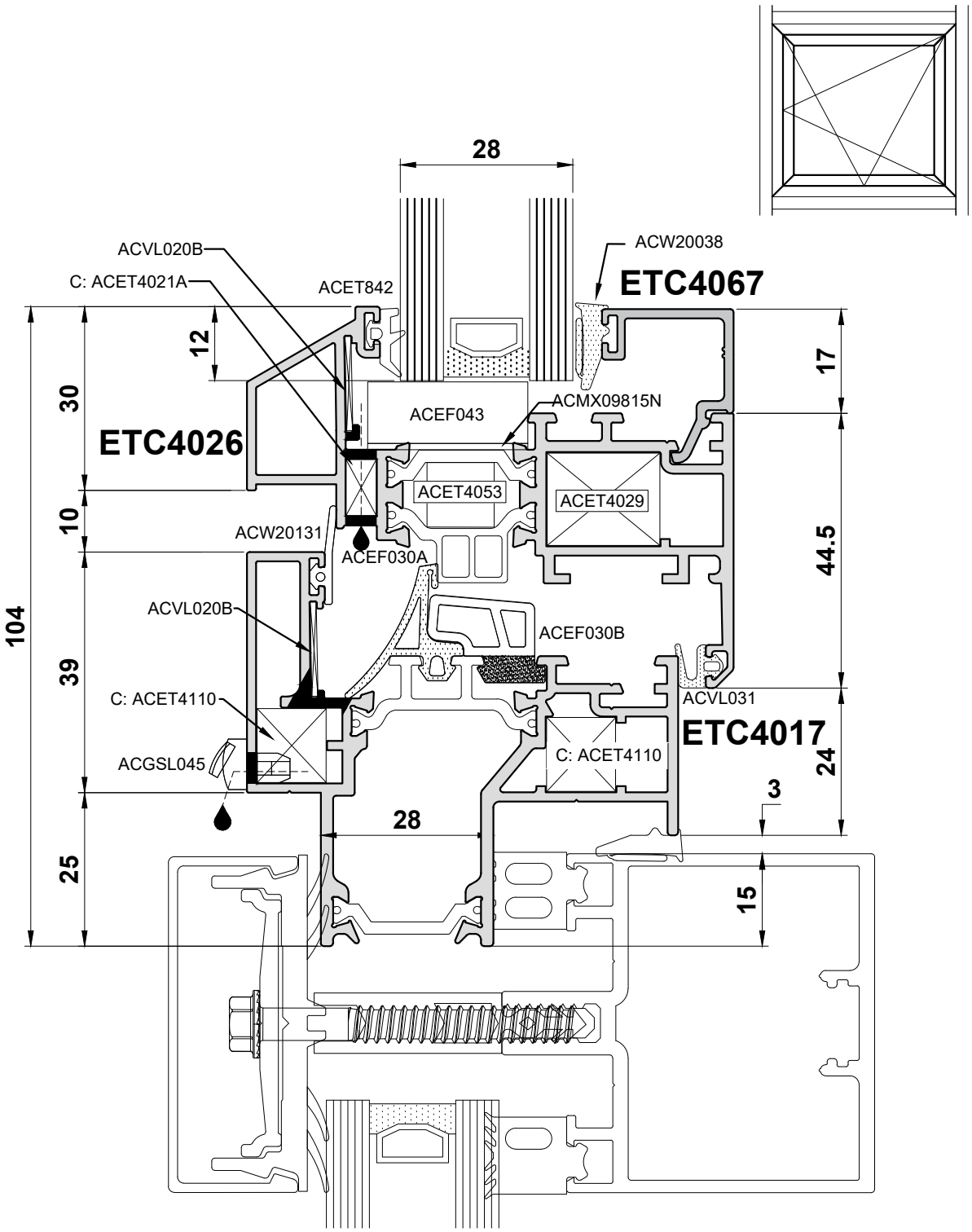


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ISSUED : July 2026

Alitherm 400 Tilt & Turn

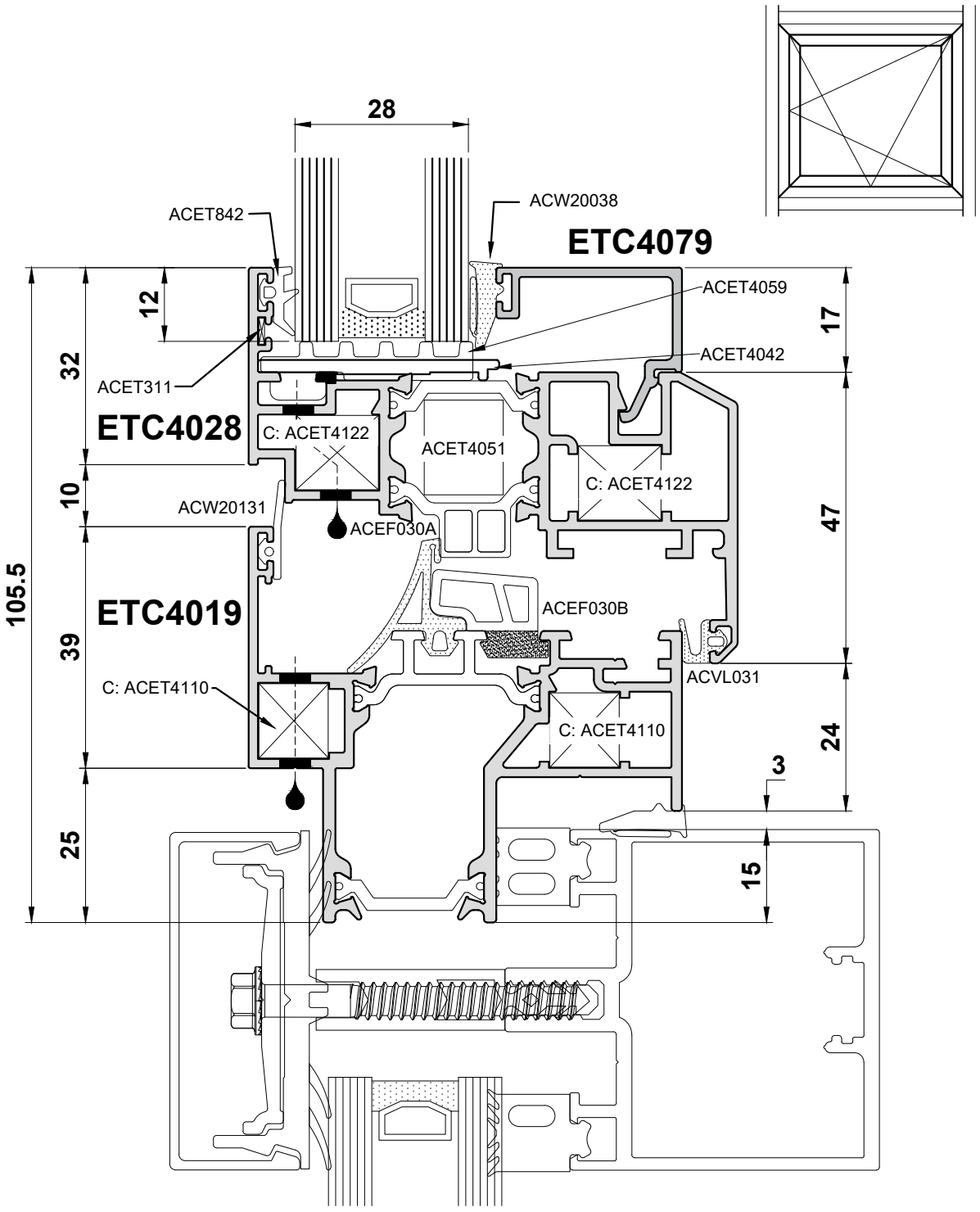
Detail 5H



Do Not Scale From This Drawing

Alitherm 400 Tilt & Turn

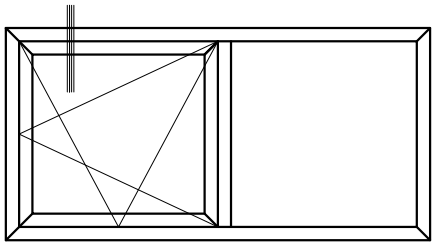
Detail 5l

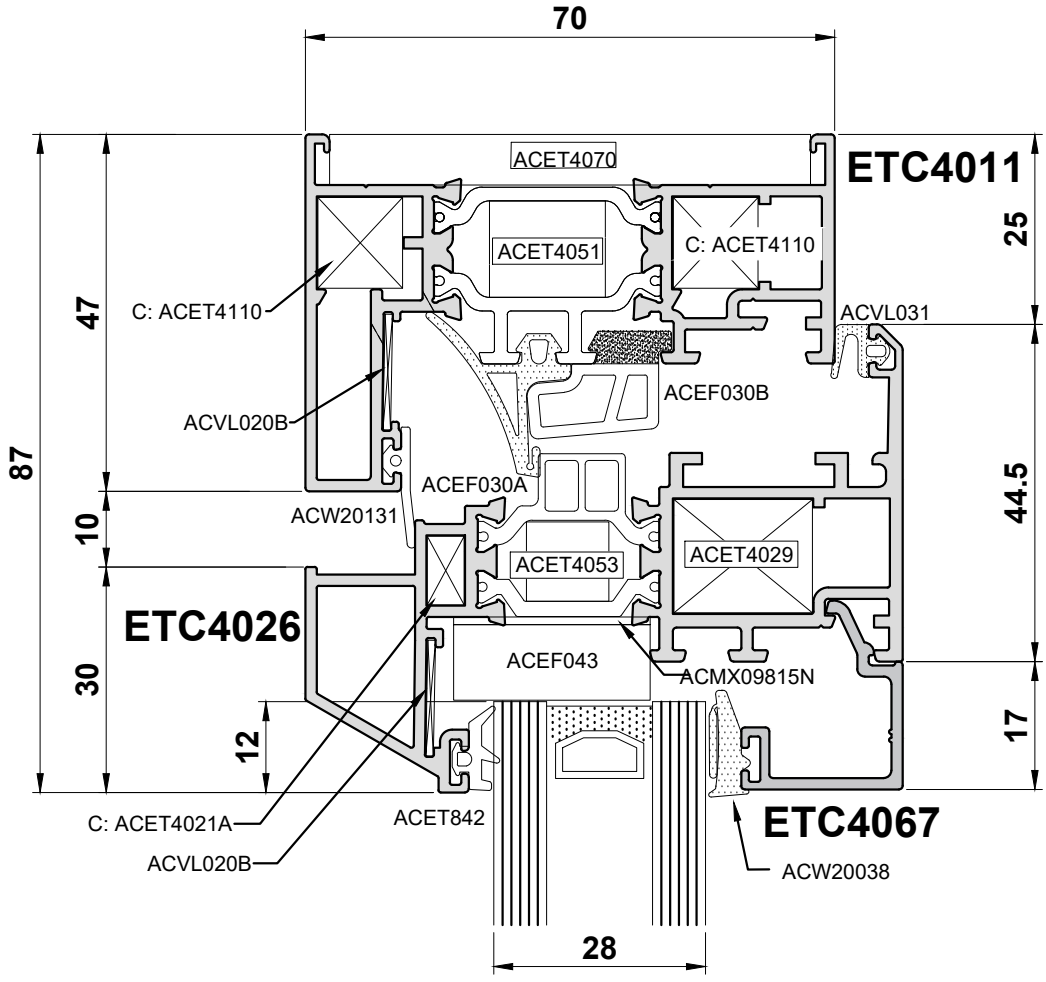


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ISSUED : July 2026

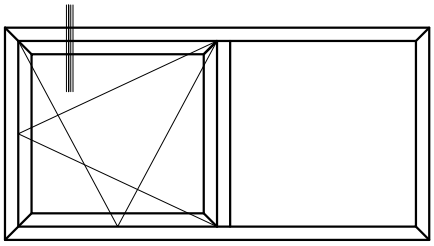
Detail 6A

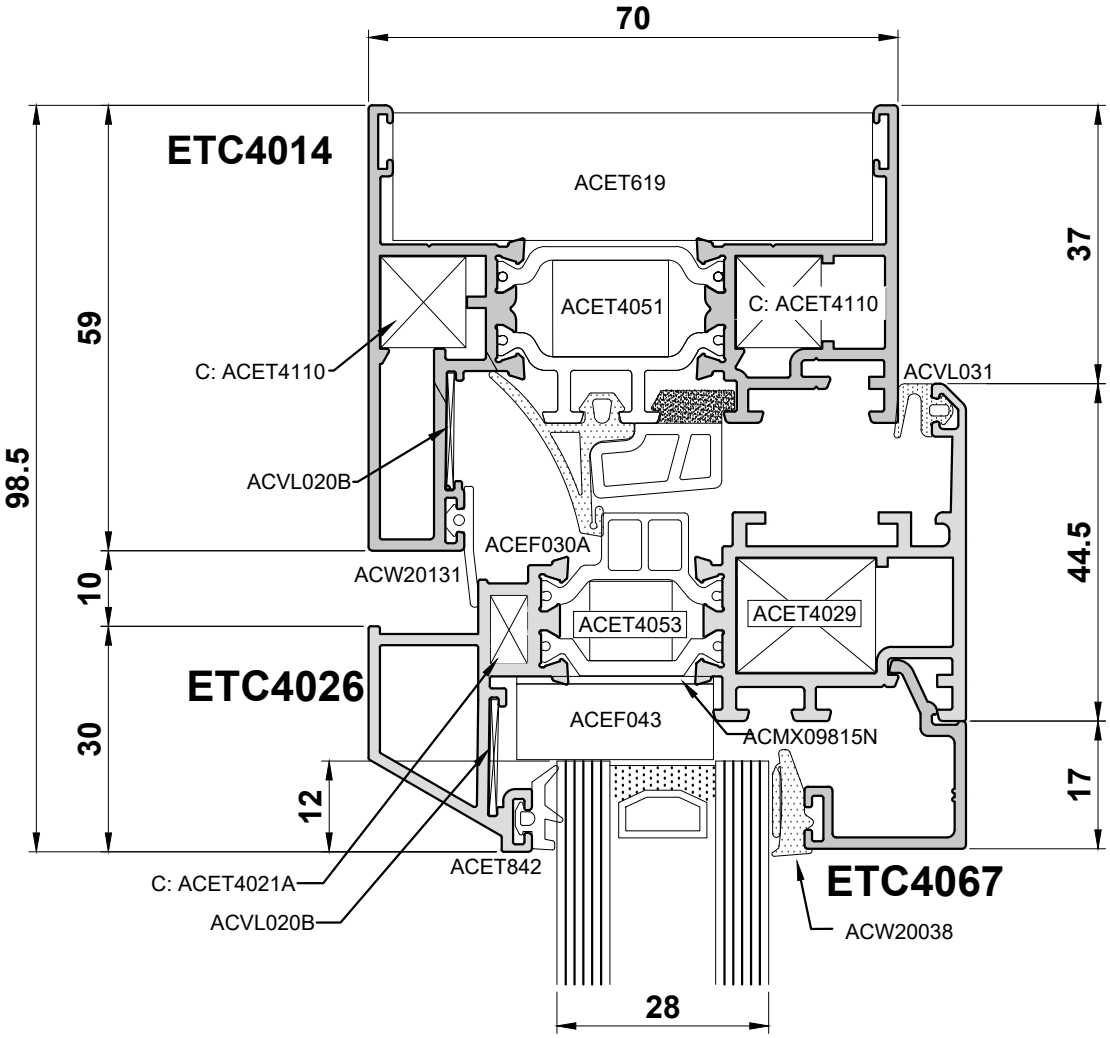




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Detail 6B

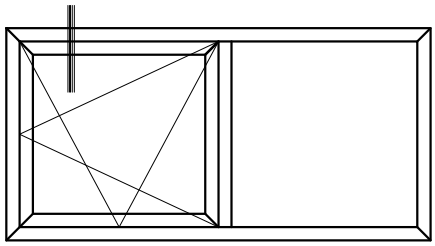


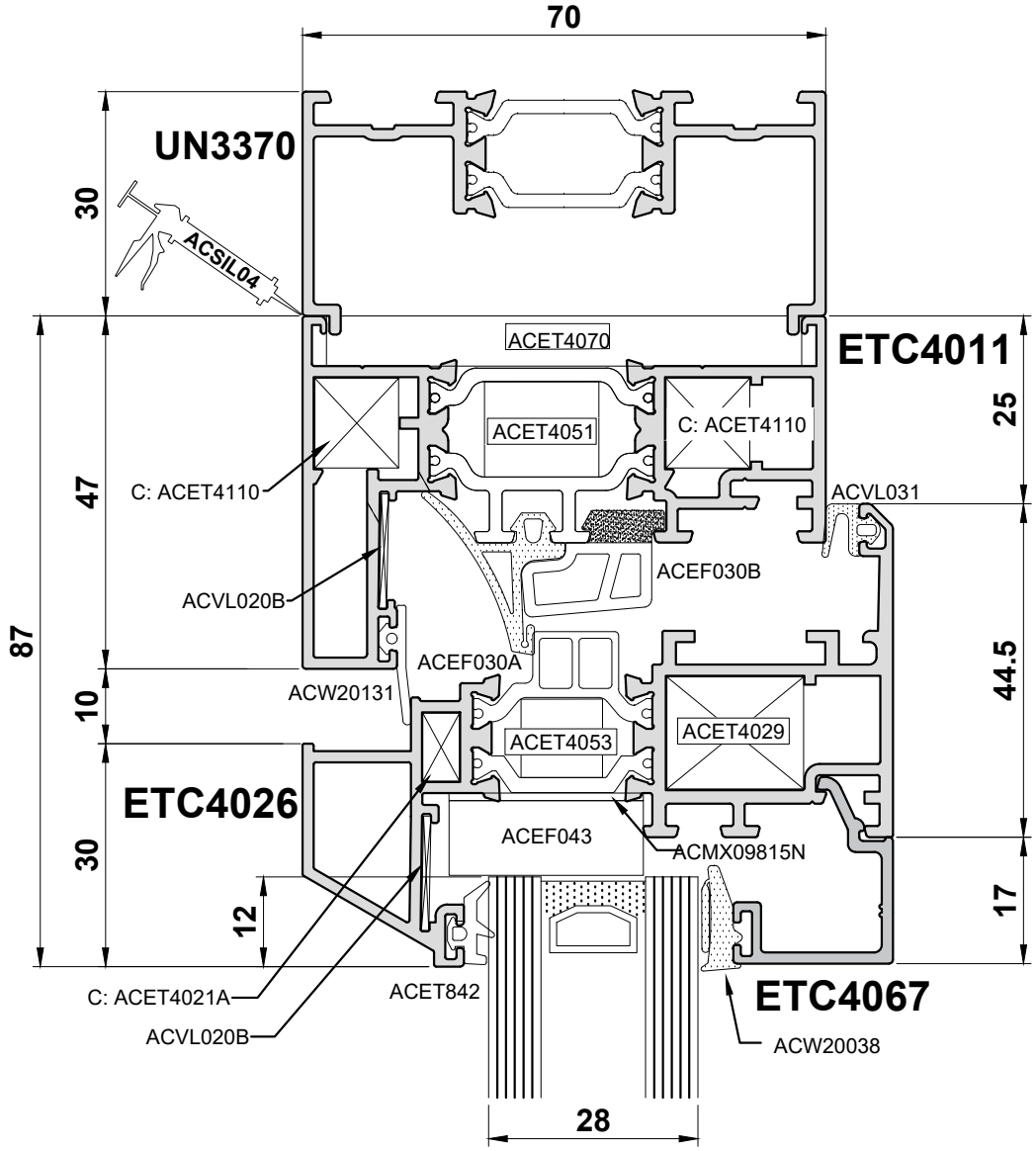


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ISSUED : July 2026

Detail 6C

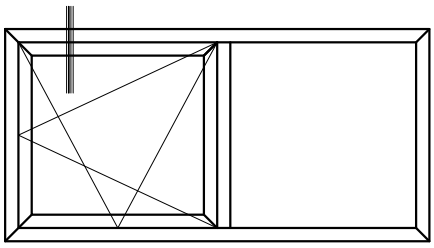


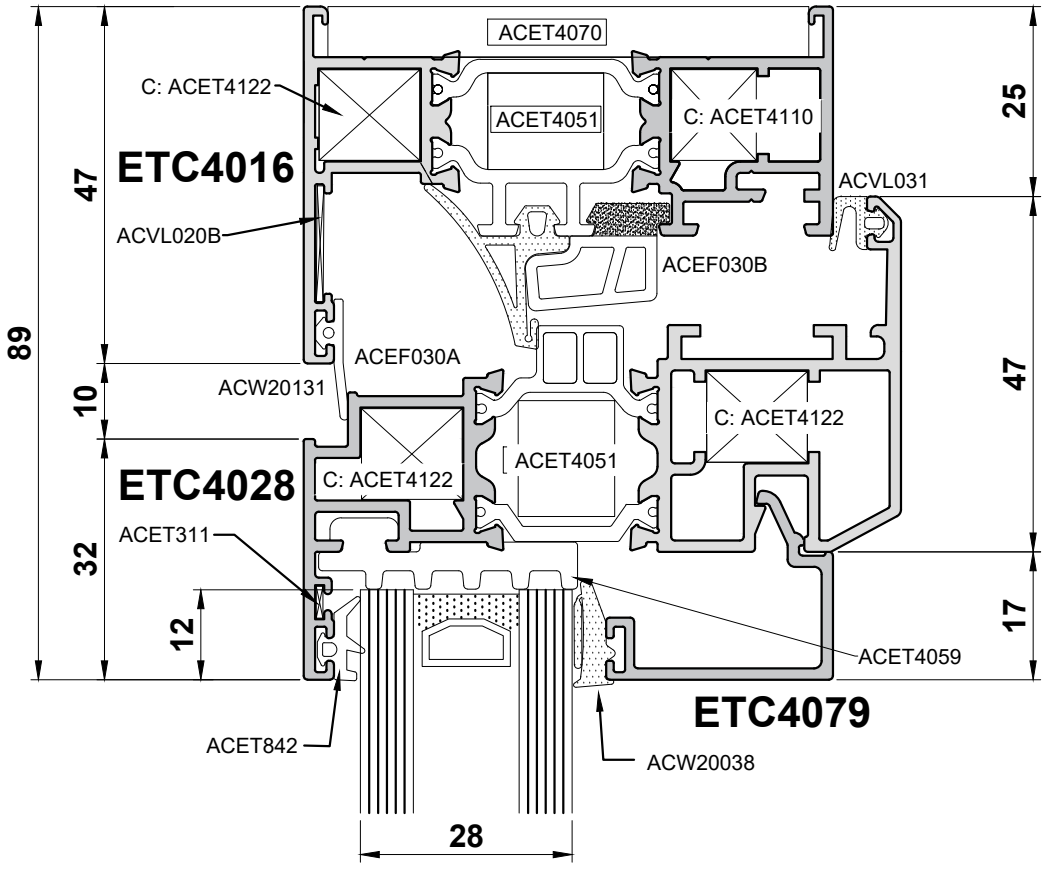


Do Not Scale From This Drawing

Alitherm 400 Tilt & Turn

Detail 6D

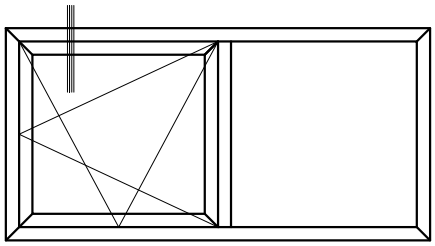


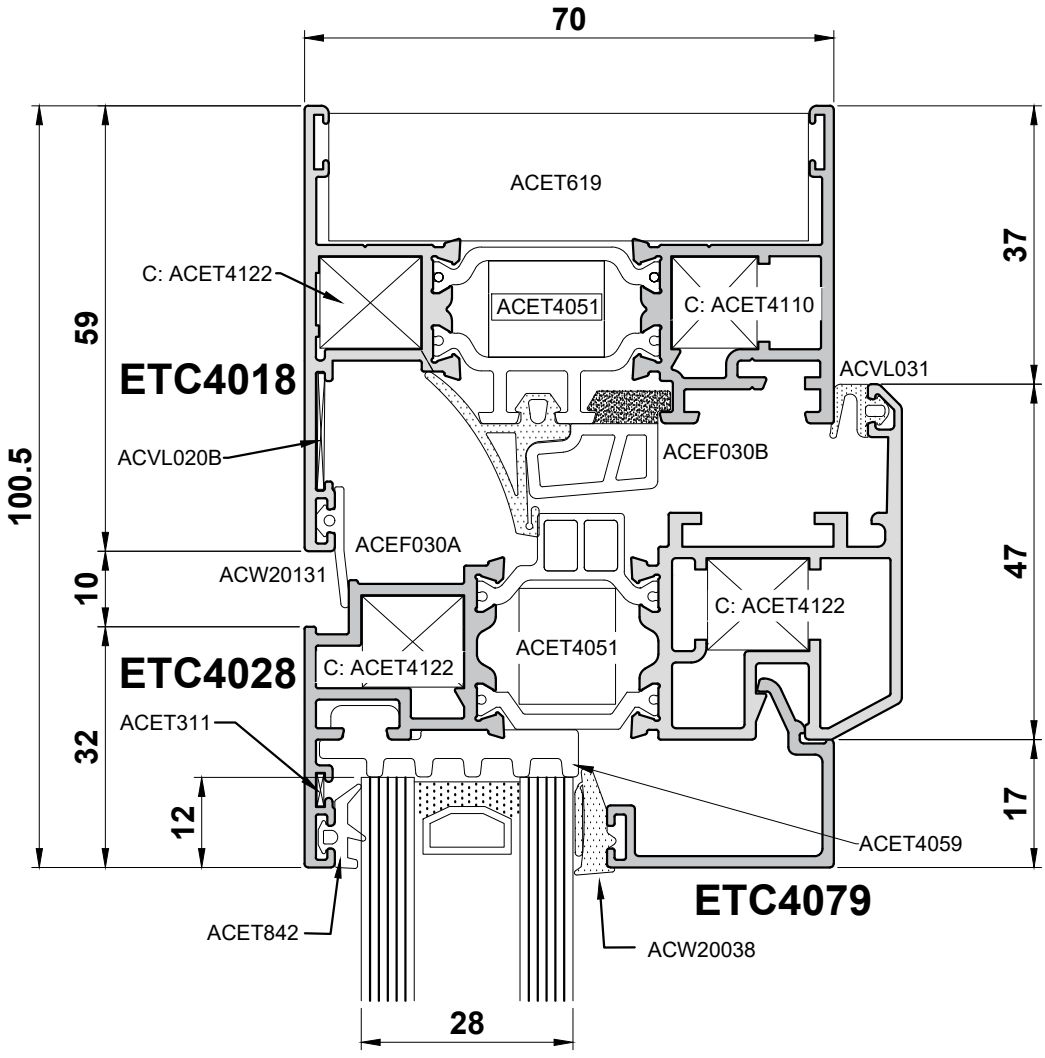


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ISSUED : July 2026

Detail 6E

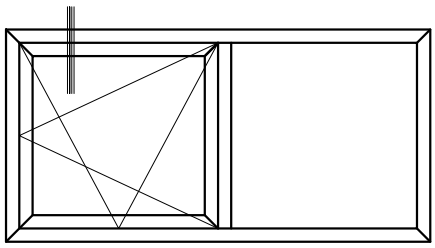


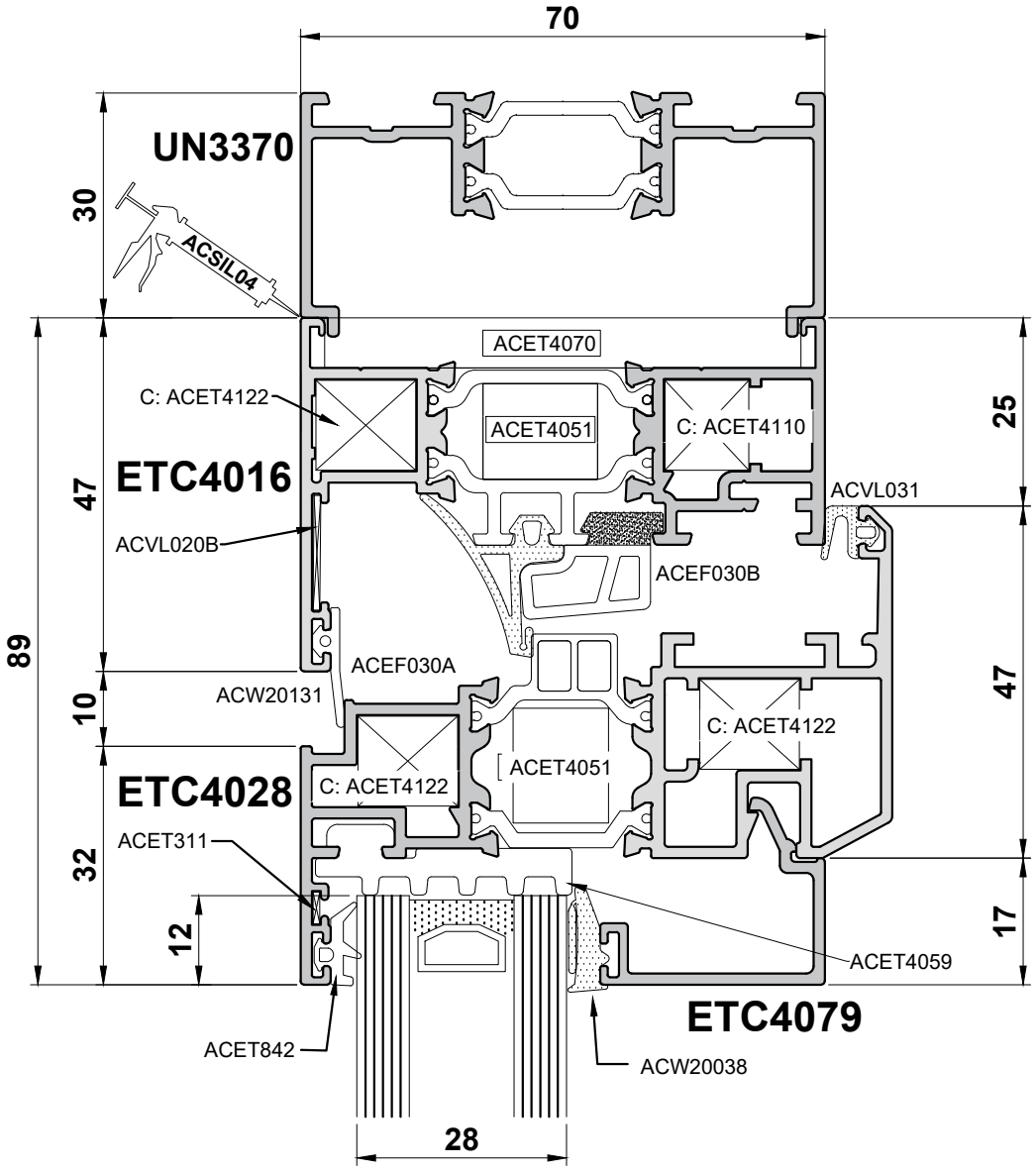


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Alitherm 400 Tilt & Turn

Detail 6F

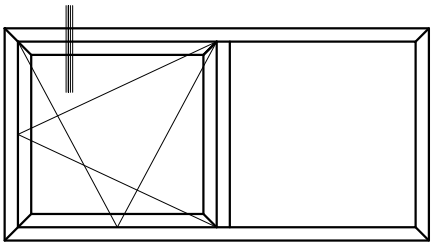


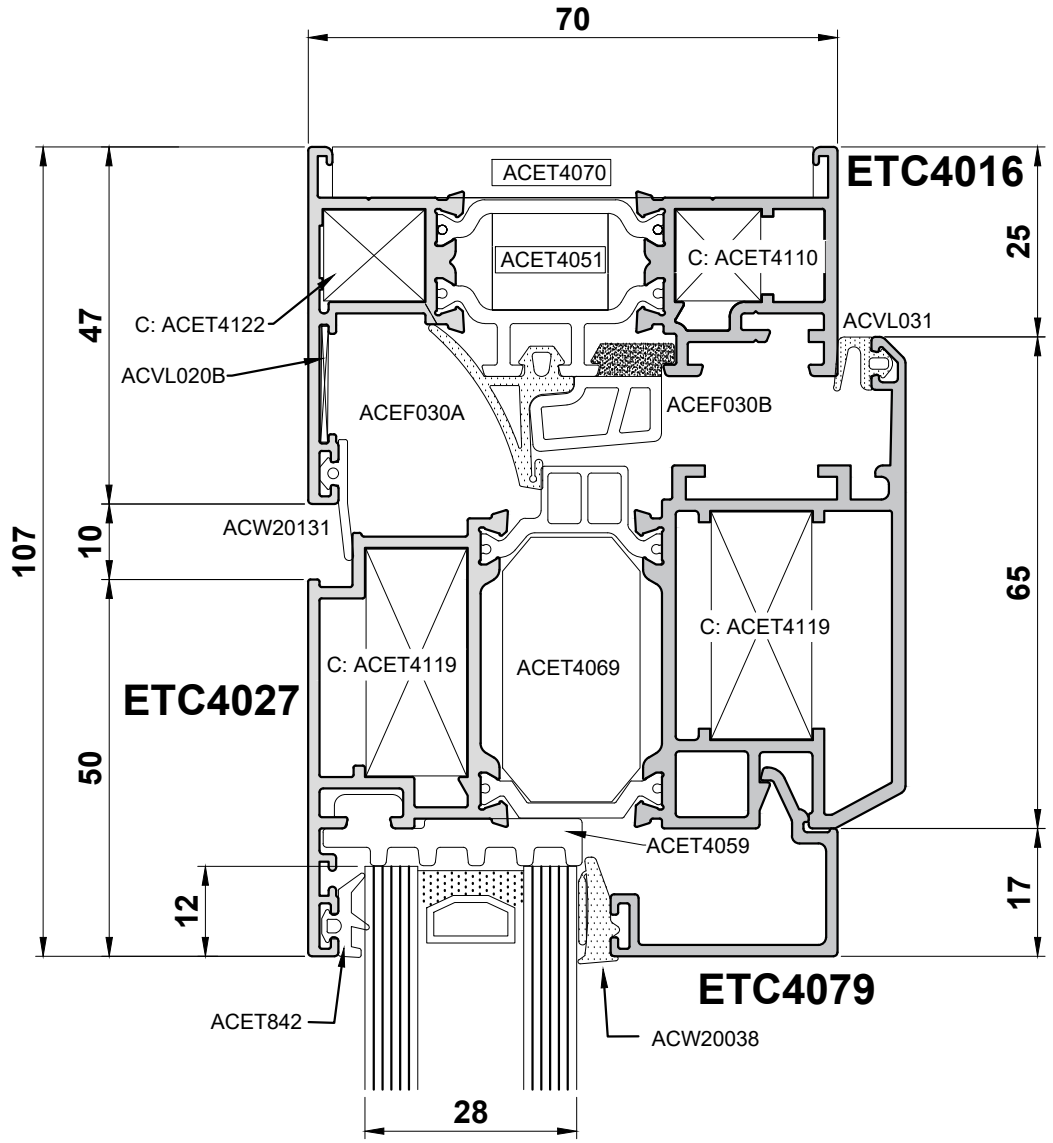


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ISSUED : July 2026

Detail 6G

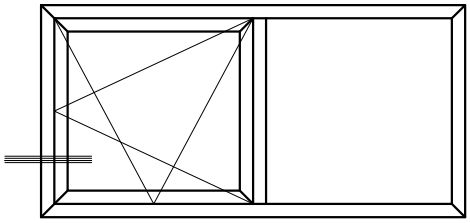


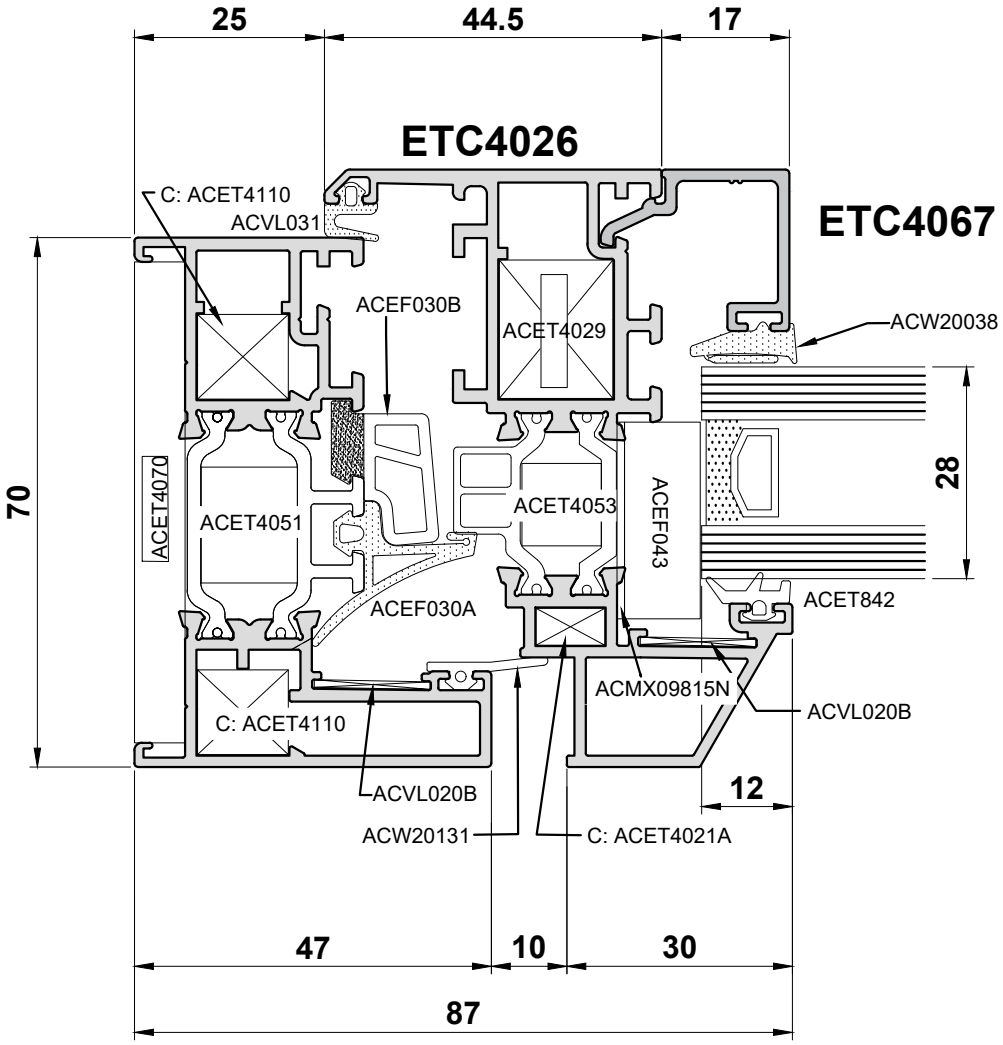


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Alitherm 400 Tilt & Turn

Detail 7A

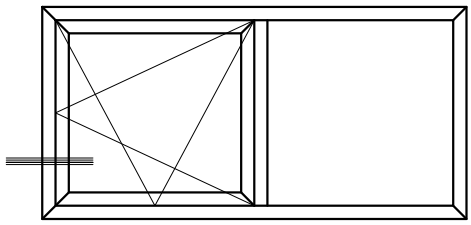


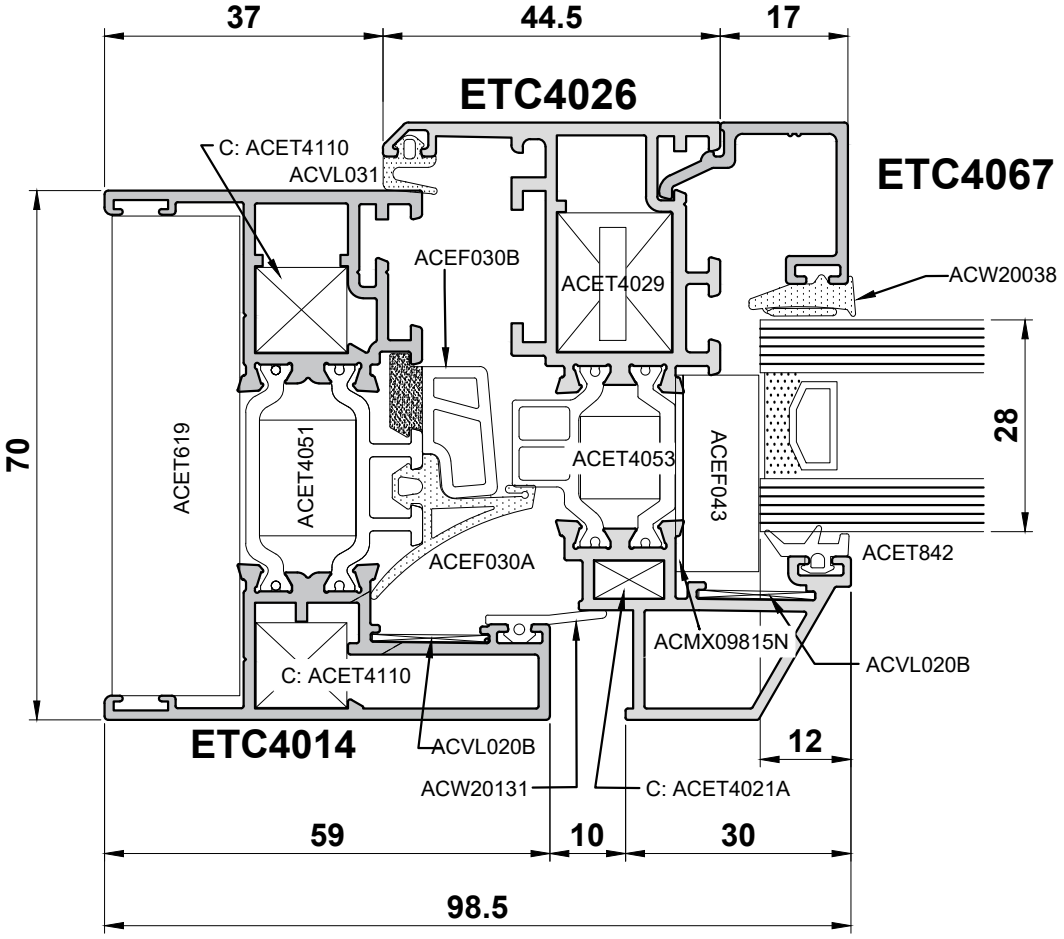


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ISSUED : July 2026

Detail 7B

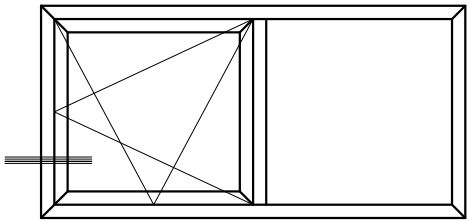


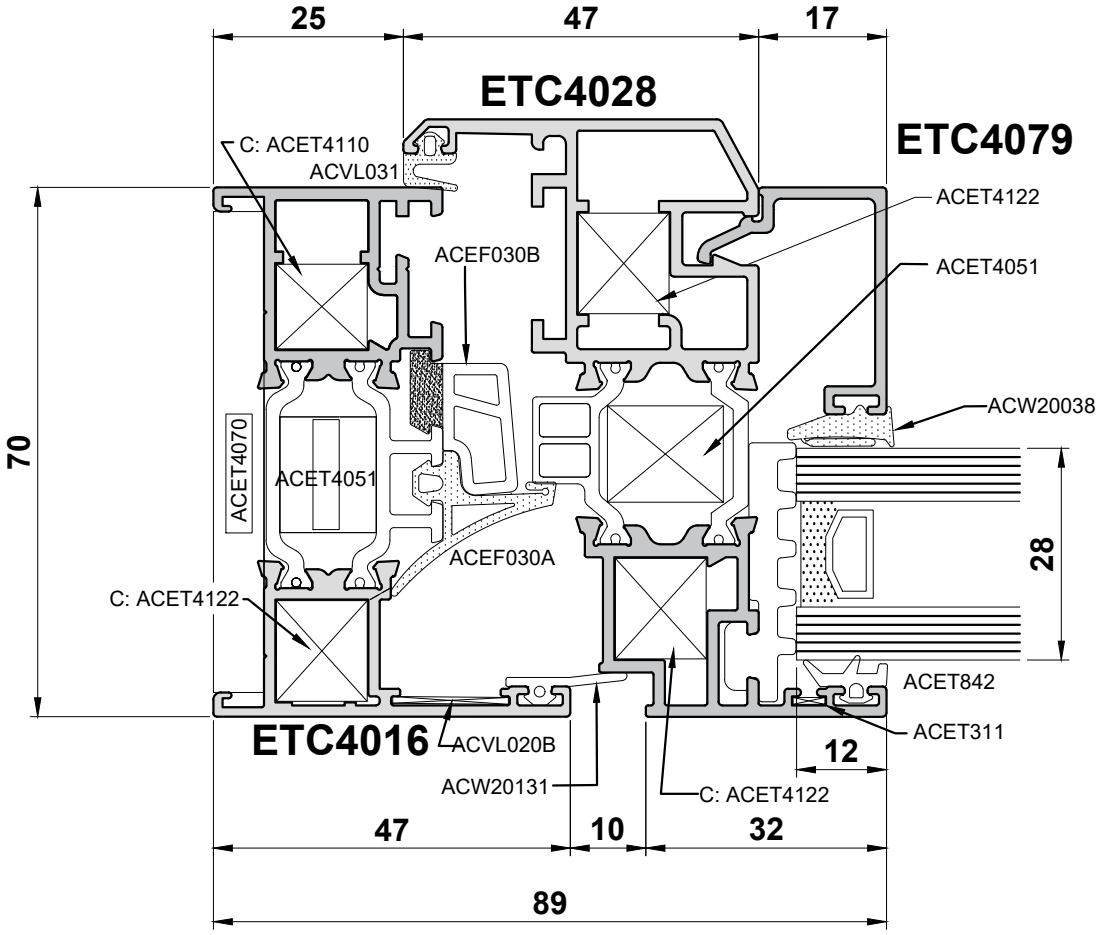


Do Not Scale From This Drawing

Alitherm 400 Tilt & Turn

Detail 7C

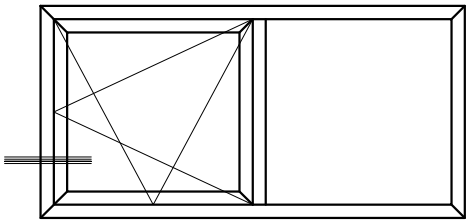


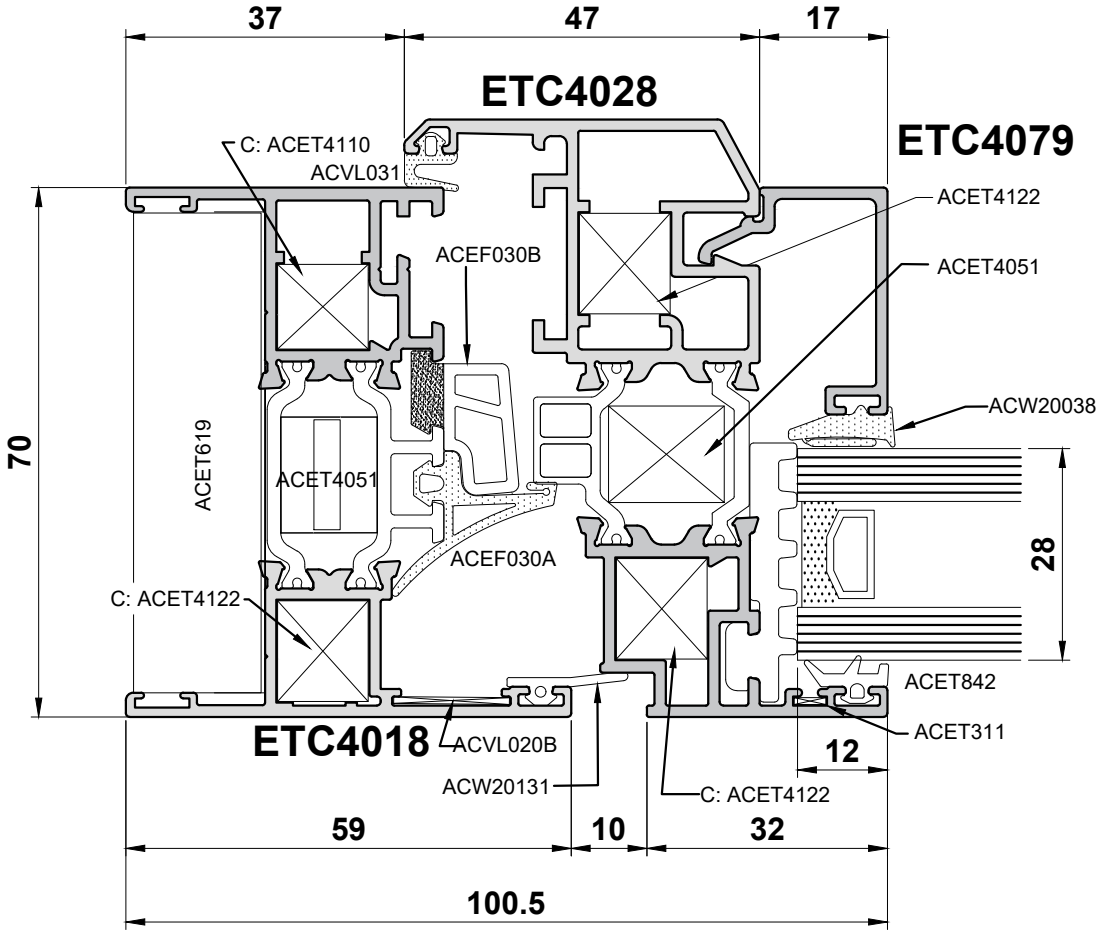


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ISSUED : July 2026

Detail 7D

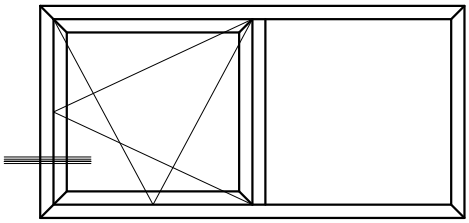


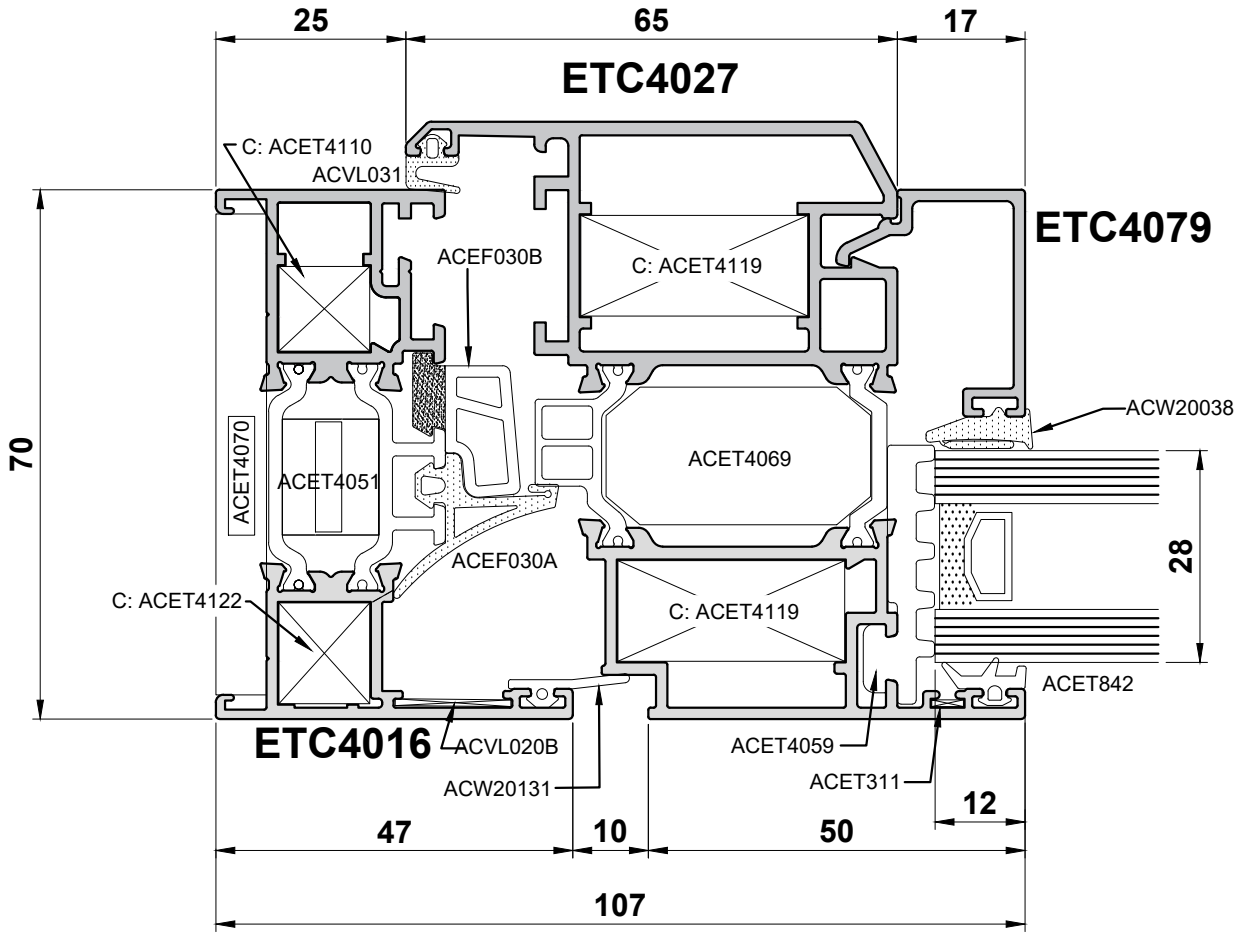


Do Not Scale From This Drawing

Alitherm 400 Tilt & Turn

Detail 7E

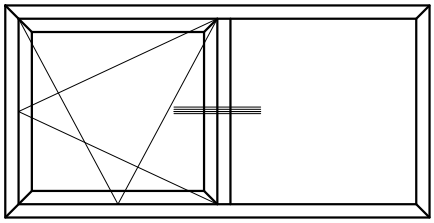


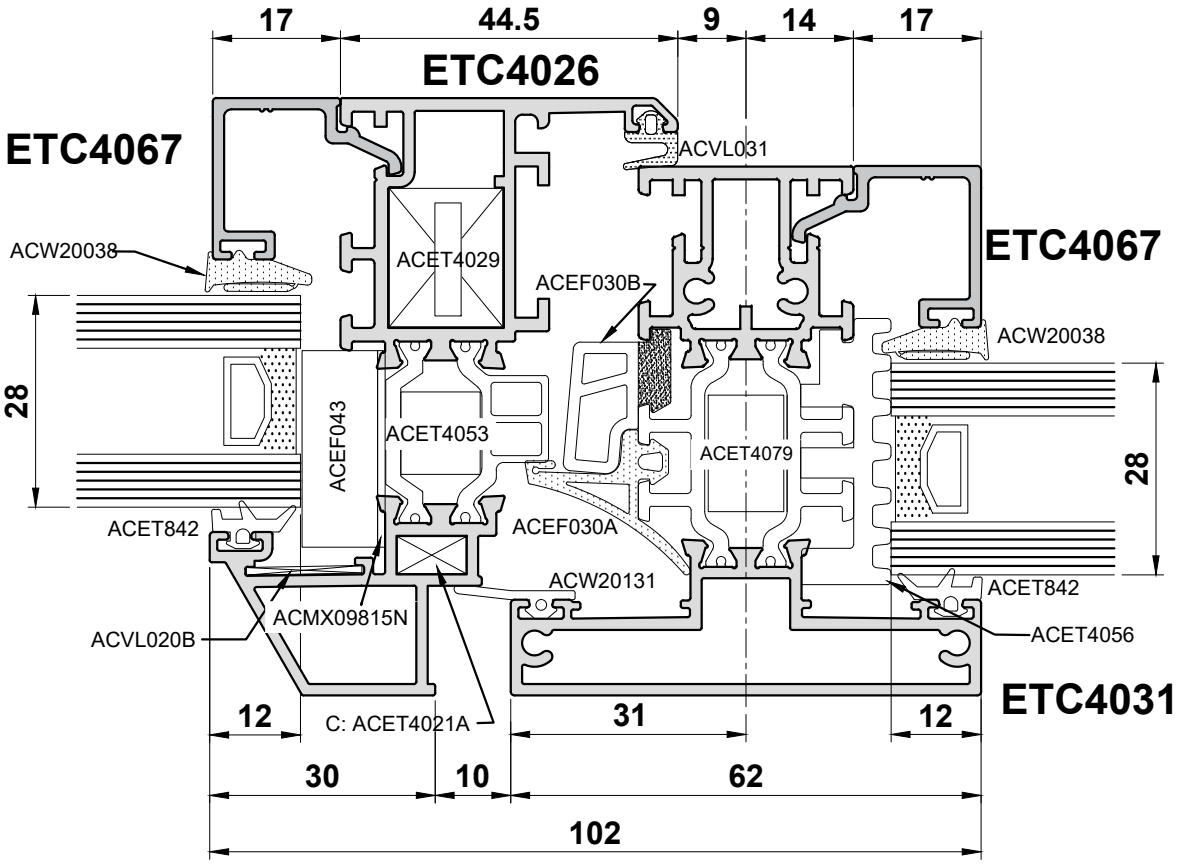


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ISSUED : July 2026

Detail 8A

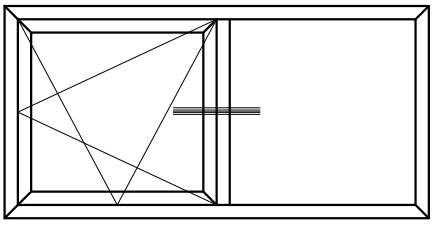


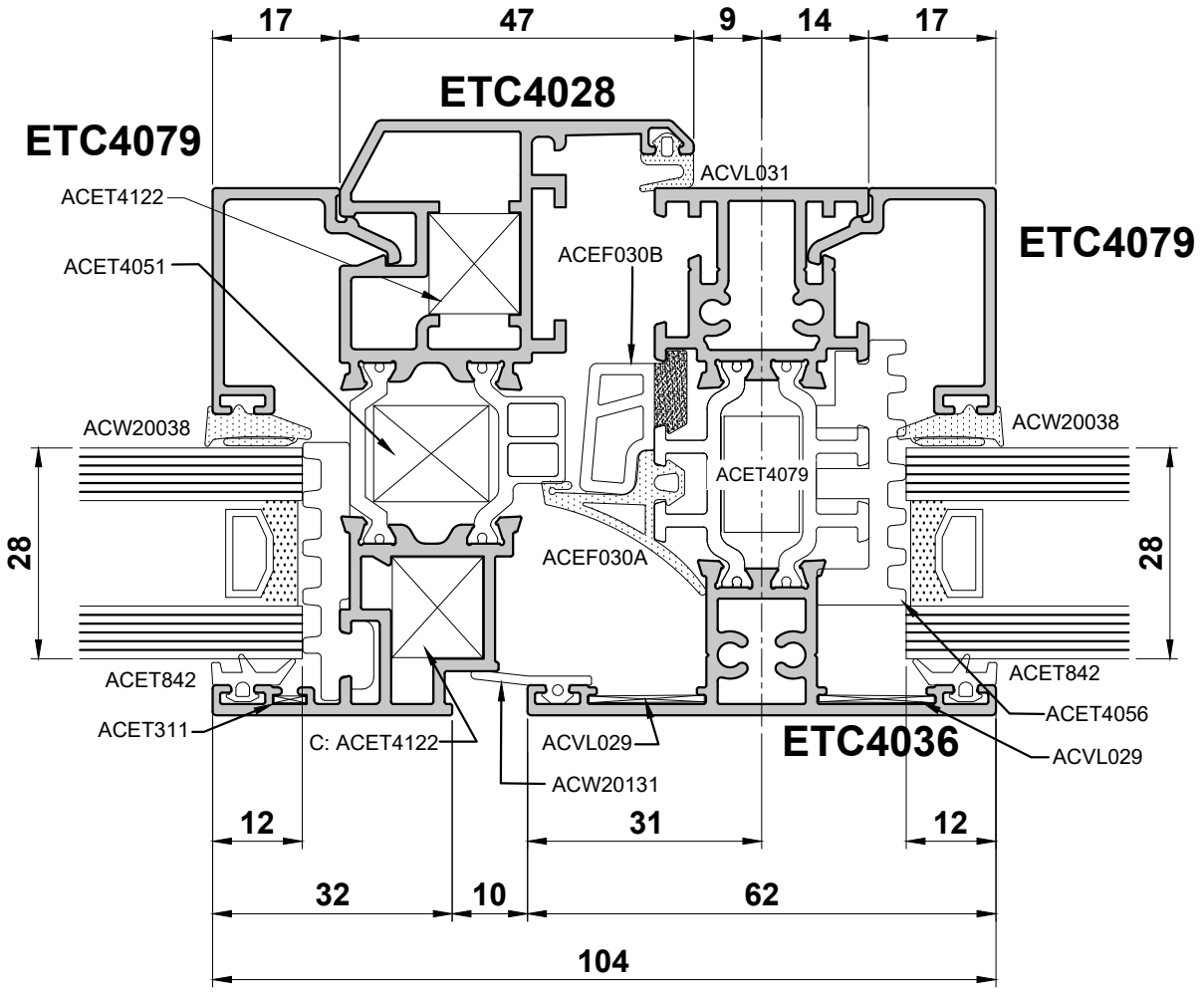


Do Not Scale From This Drawing

Alitherm 400 Tilt & Turn

Detail 8B

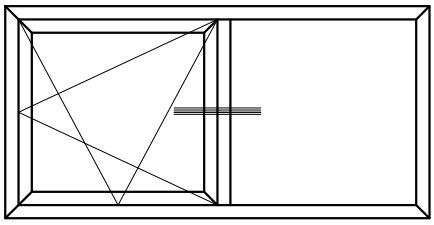


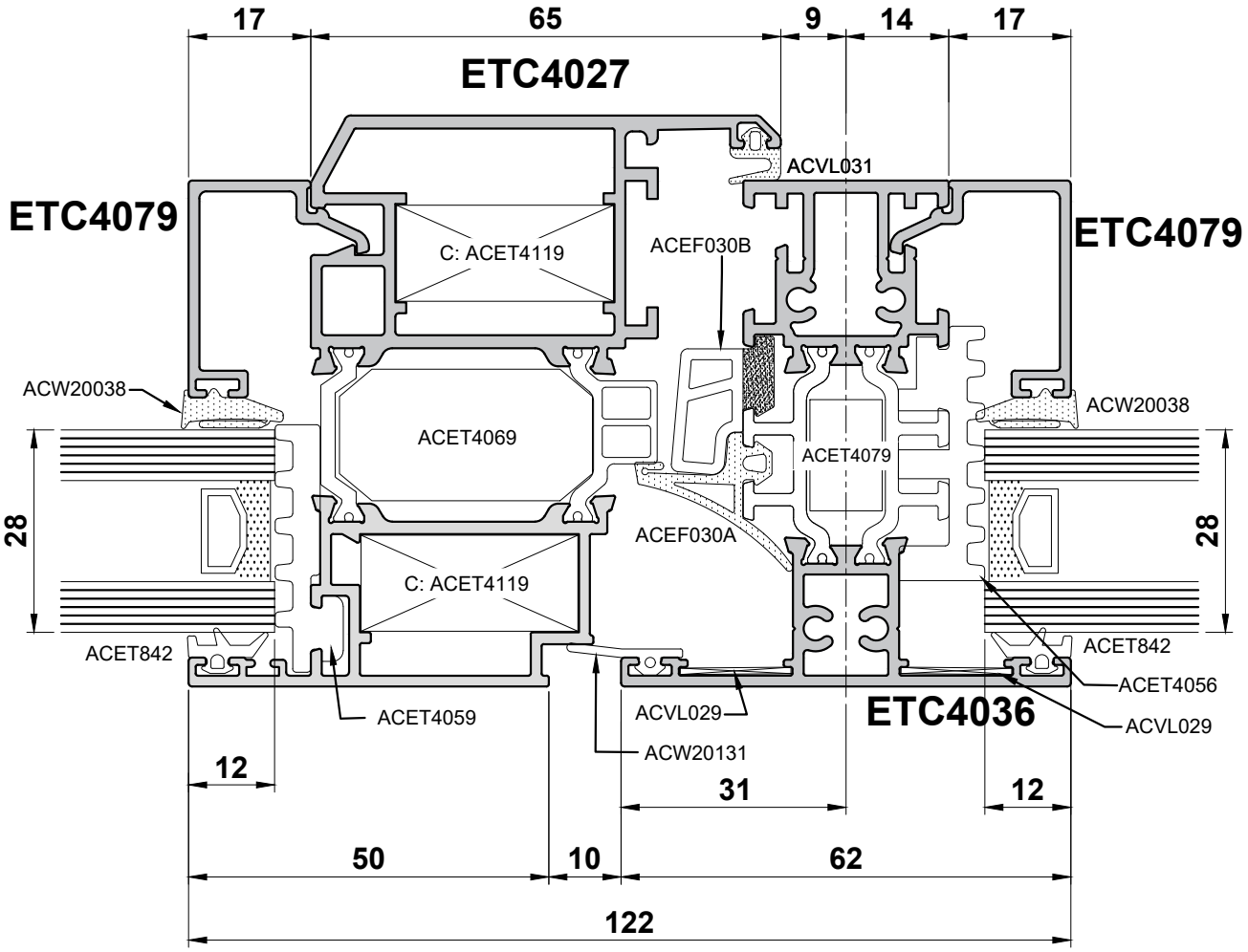


Do Not Scale From This Drawing

ISSUED : July 2026

Detail 8C

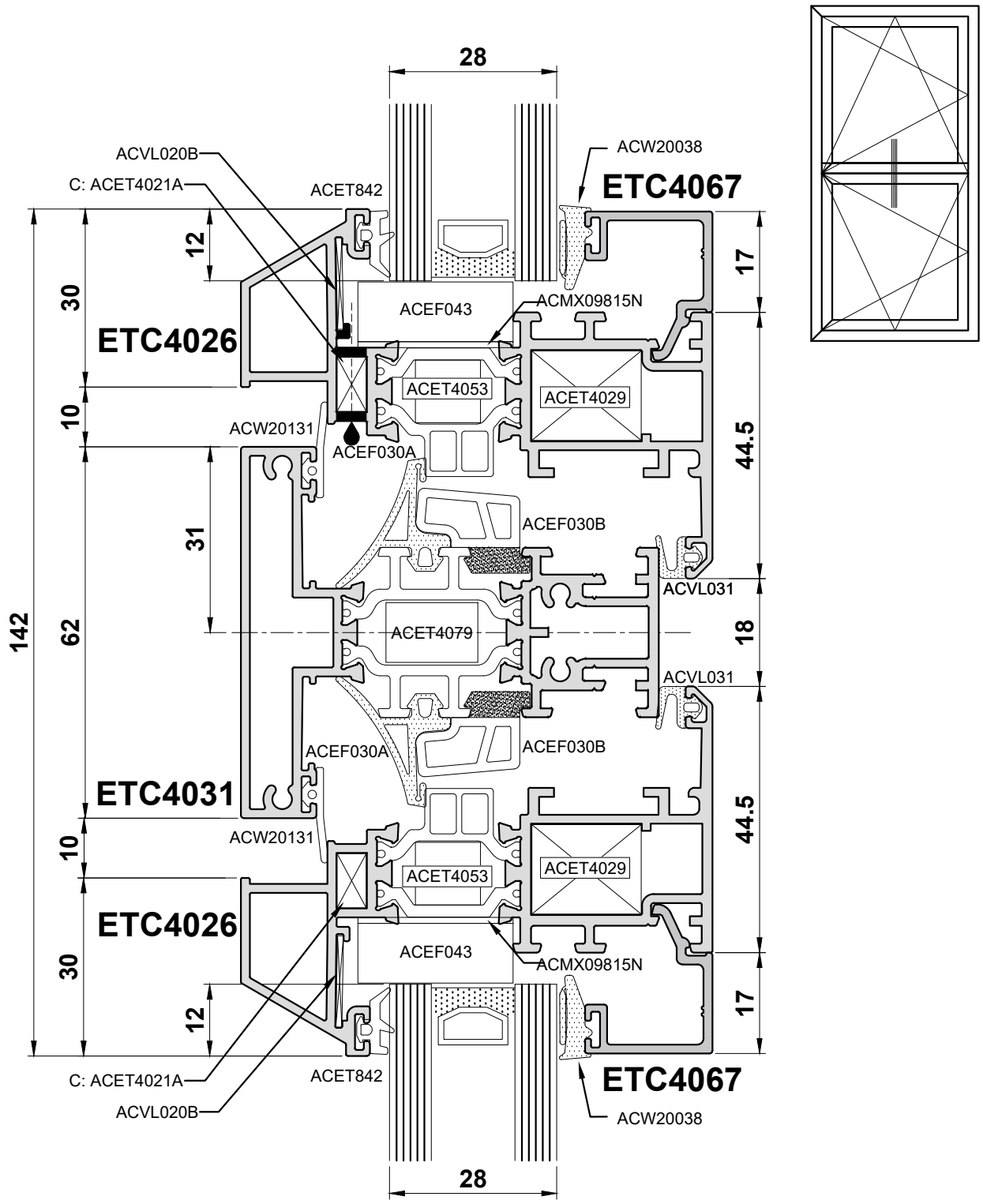




Do Not Scale From This Drawing

Alitherm 400 Tilt & Turn

Detail 9A

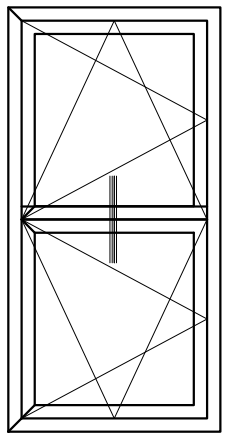


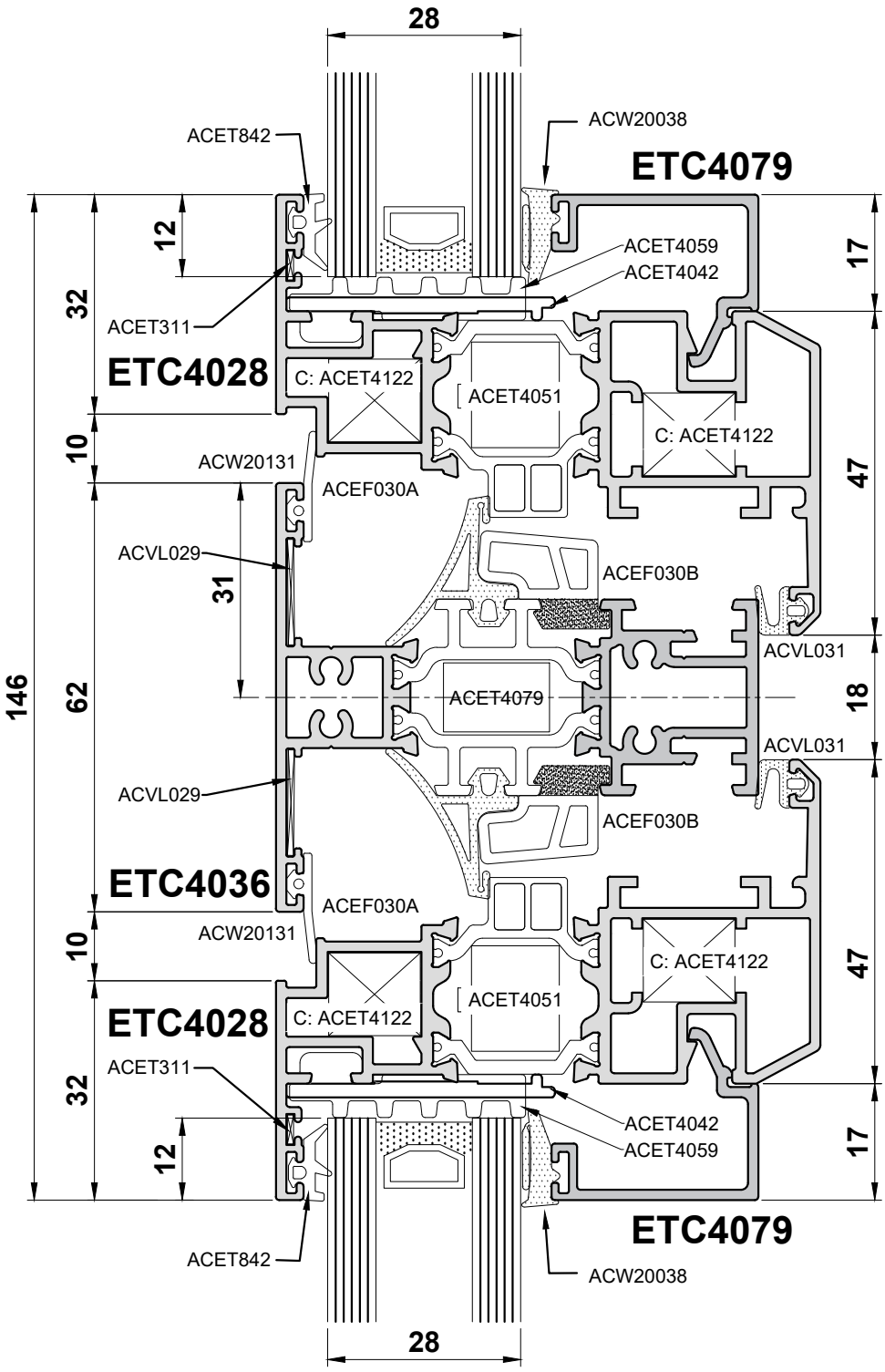
Do Not Scale From This Drawing

ISSUED : July 2026

Alitherm 400 Tilt & Turn

Detail 9B

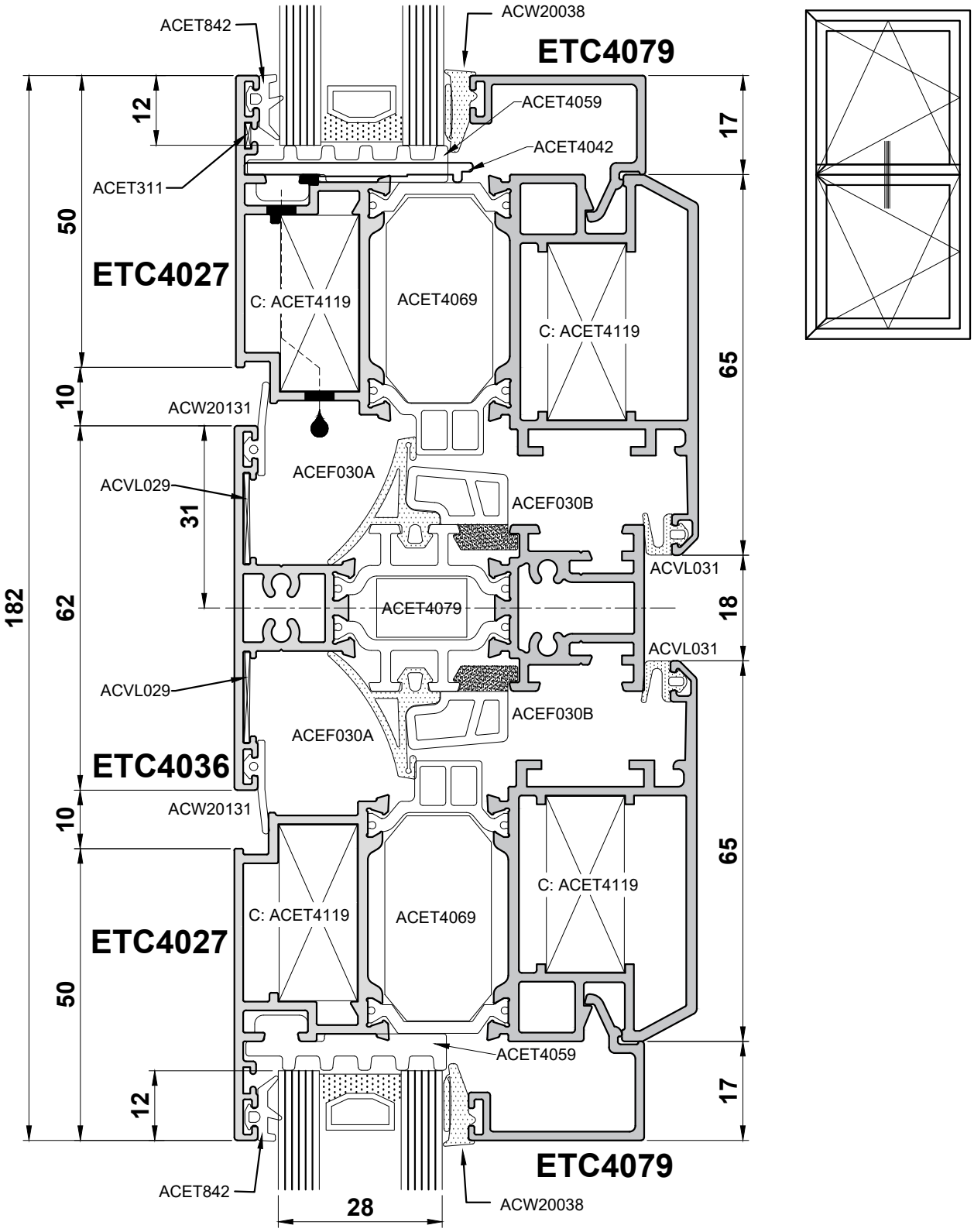




Do Not Scale From This Drawing

Alitherm 400 Tilt & Turn

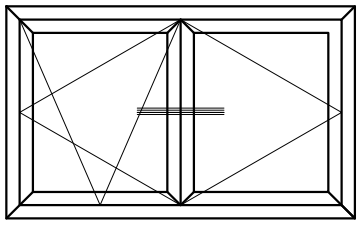
Detail 9C

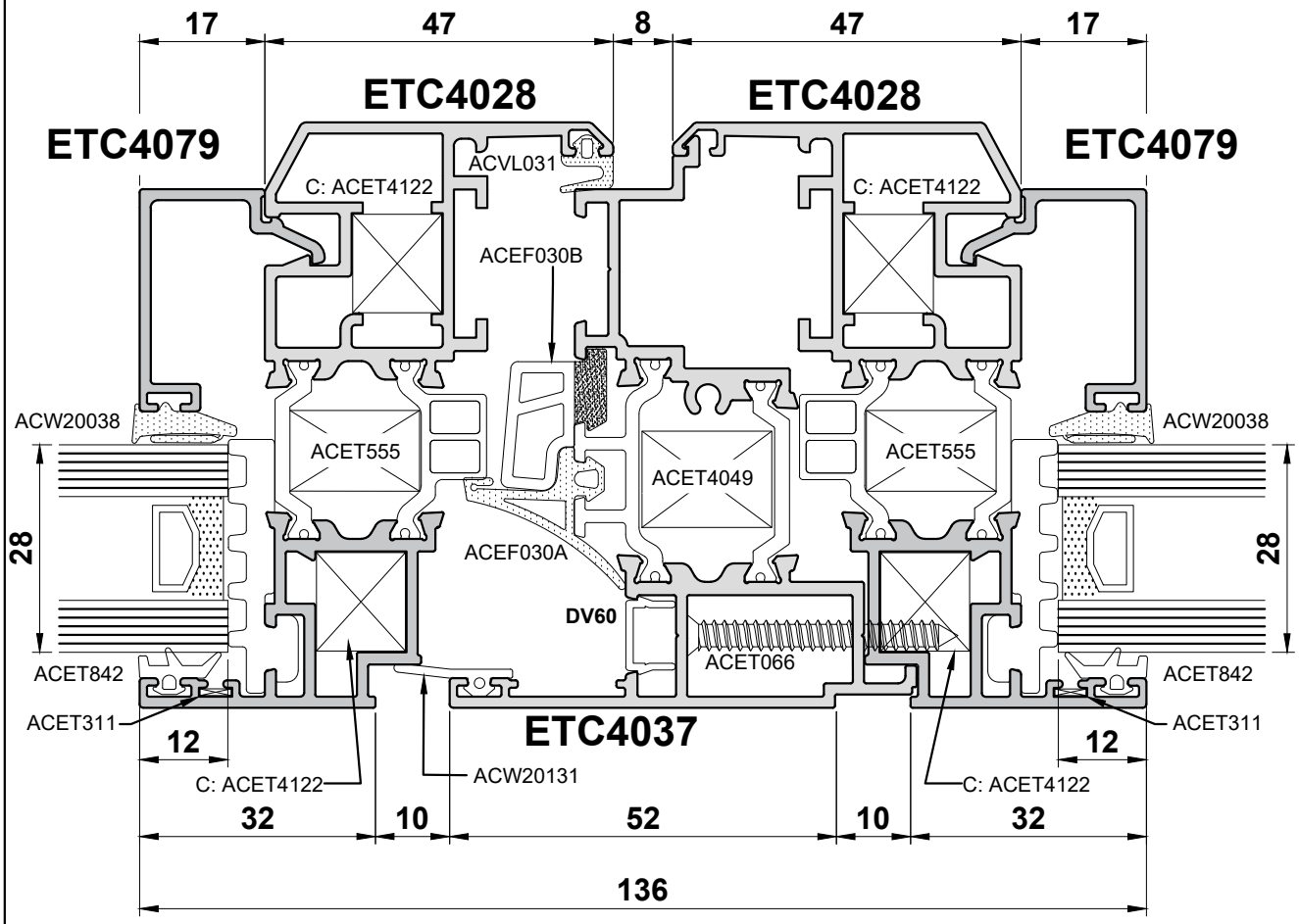


Do Not Scale From This Drawing

ISSUED : July 2026

Detail 10A

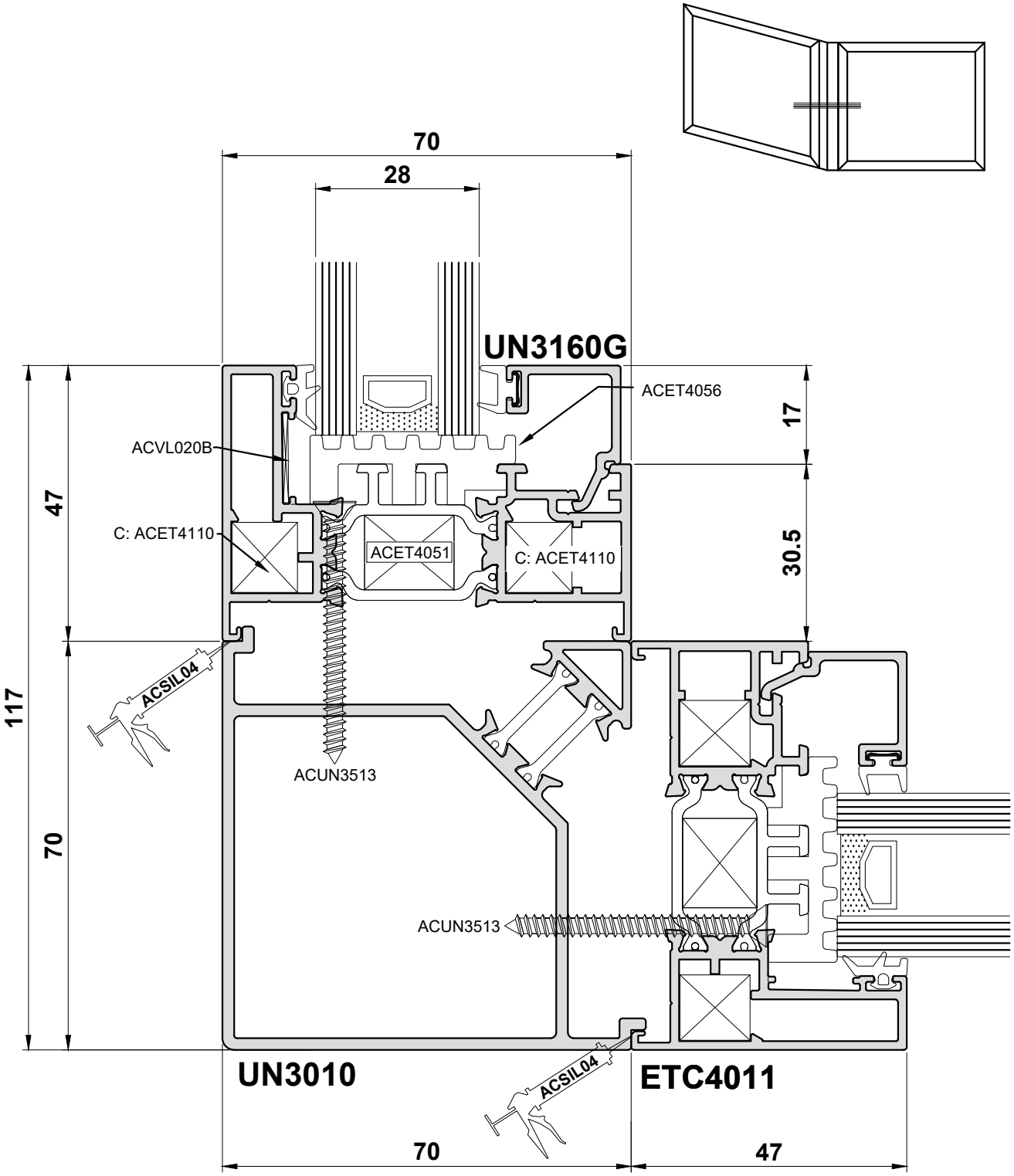




Do Not Scale From This Drawing

Alitherm 400 Tilt & Turn

Detail 11



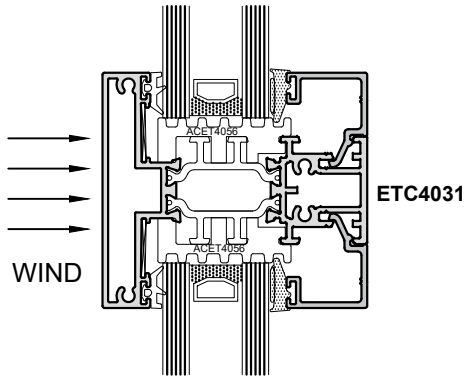
Do Not Scale From This Drawing

ISSUED : July 2026

Section D

Statics

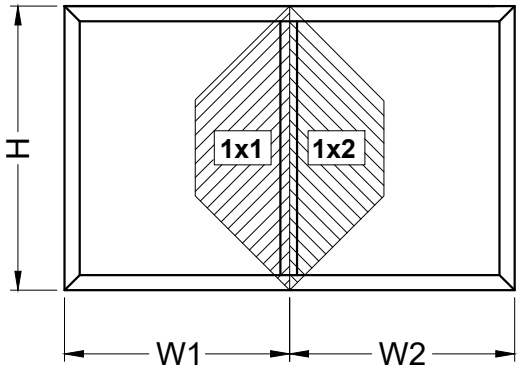
For Wind Loading Limitations, Please Contact
The Technical Department - T: 01934 833100



The position of the axes is an indication for the use and application of the moments of inertia (Ix and Iy) and the section modulus (Wx and Wy). We always choose the values of the axis perpendicular to the load to resist it.

- **To resist the wind loads we use the values Ix and Wx.**

EXAMPLE



H = 175cm

W1 = 120cm

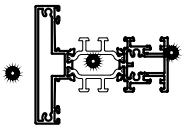
W2 = 100cm

P = 1250 Pa (wind pressure)

1) Determine Ixx value for the stiles (if required) using the Specification Wizard

Ixx = 21.0 cm4

2) Determine suitability

Number	Picture	Ix(cm4) wx(cm3)	Iy(cm4) wy(cm3)
ETC4031		**34.93** --- **8.73**	**12.29** --- **3.95**

OK

Section E

E ETC

Construction Drawings

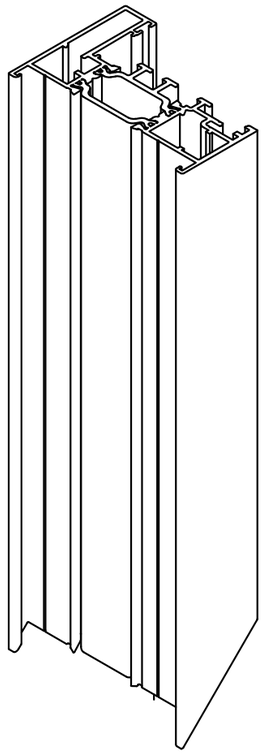
Corner Joint Details..... E03
Corner Crimping - ACCR300 & ACCR200N..... E04
Cill Drainage..... E05
Angle Sub Cill..... E06
Tilt & Turn Outer Frame & Sash..... E07
Tilt & Turn Overview..... E08
ACUN3140..... E09
Window Drainage..... E10 - E11
Mullion/Transom Detail..... E12 - E13
Reinforced Mullion E14
ETC4037 Floating Mullion Details..... E15
Glazing Chart..... E16 - E21
70mm Outer Frame Bay Pole Angles/Deductions..... E22 - E23
Fixing Details..... E24

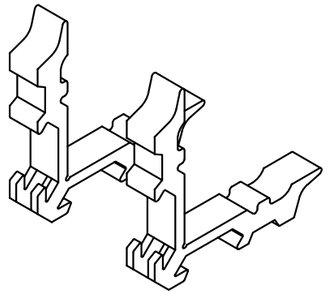
Corner Joint Details

Notes

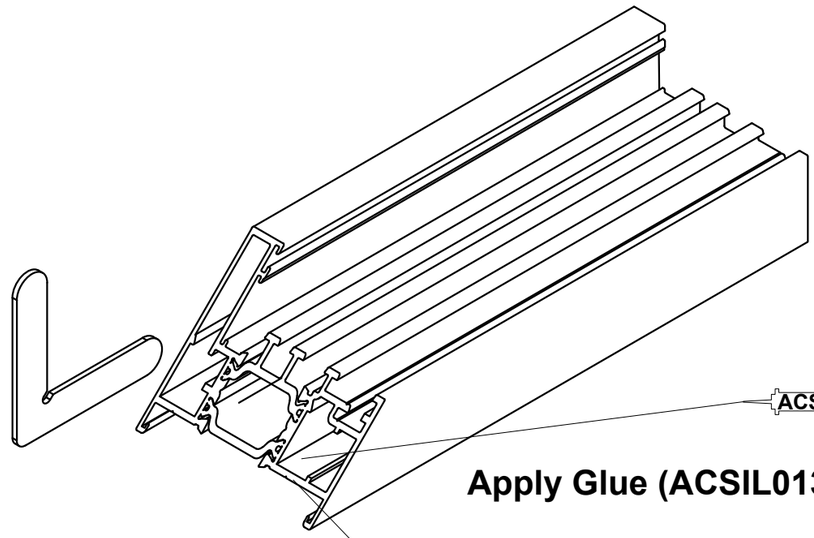
1. Degrease mitre sections
2. Cover mitred faces with ACSIL04
3. Apply ACSIL013 to cleat chamber
4. Apply ACSIL04 to any fractures formed by crimping to make watertight

Table 1	
KL Colour	Sealant Part Number
Black	ACSIL04BL
White	ACSIL04WP
Clear	ACSIL04CL
KL001	ACSIL04KL001
KL002	ACSIL04KL002
KL003	ACSIL04KL003
KL004	ACSIL04KL004
KL005	ACSIL04KL005
KL006	ACSIL04KL006
KL007	ACSIL04KL007
KL010	ACSIL04KL010
KL011	ACSIL04KL011
KL012	ACSIL04KL012
KL013	ACSIL04KL013





Corner Chevron



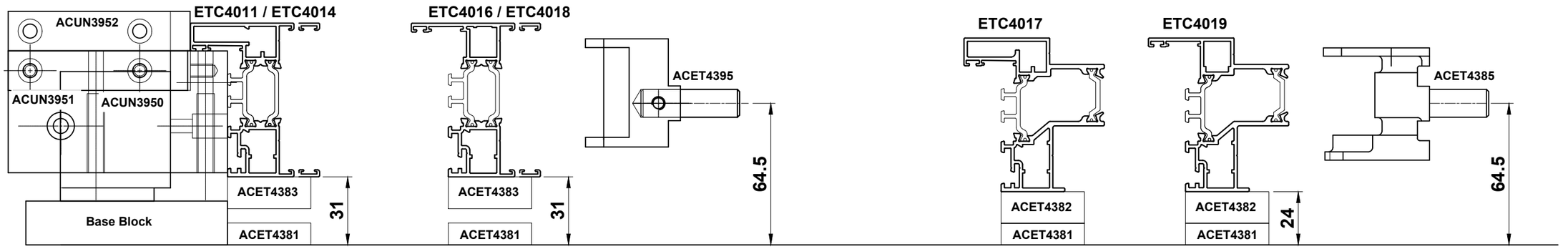
Apply Glue (ACSIL013) to all Cleat Apertures

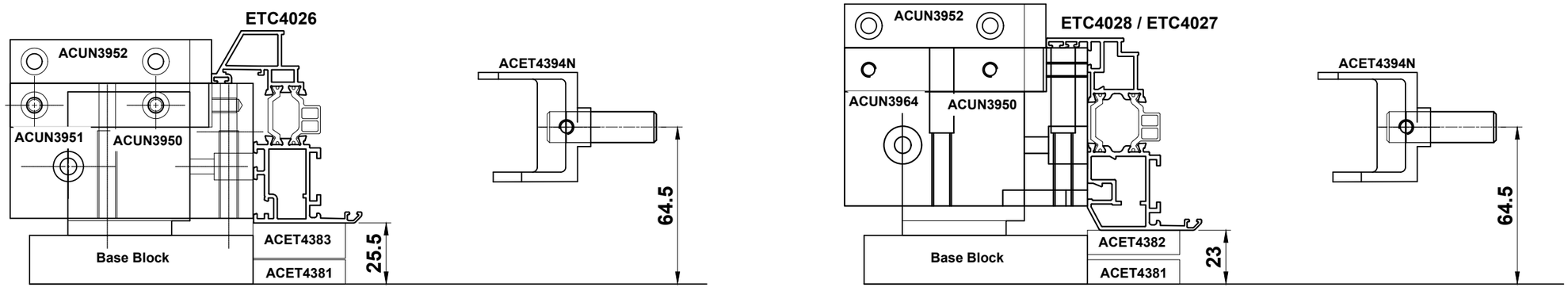
Coat Cut Face of Profile with ACSIL04 Prior to Crimping (available in KL colours - see Table 1)

Do Not Scale From This Drawing

Corner Crimping - ACCR300 & ACCR200N

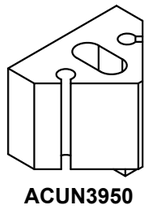
Manual Crimper = ACCR300 | **Power Crimper = ACCR200N**

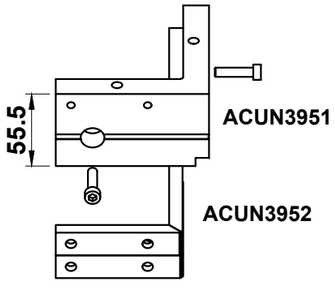


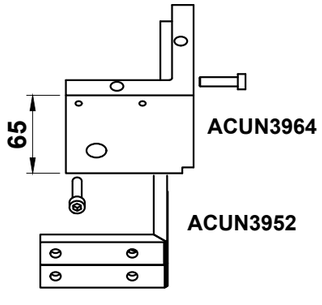


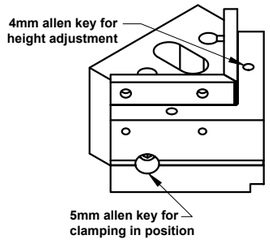
Please consult our Technical Department for support with alternative crimper models

Adjustable Vee Block









Section Packers



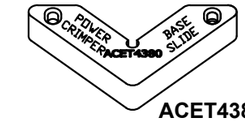
ACET4383



ACET4382



ACET4381

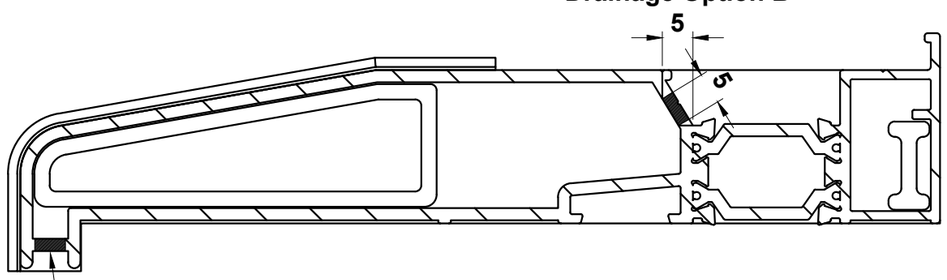


ACET4380

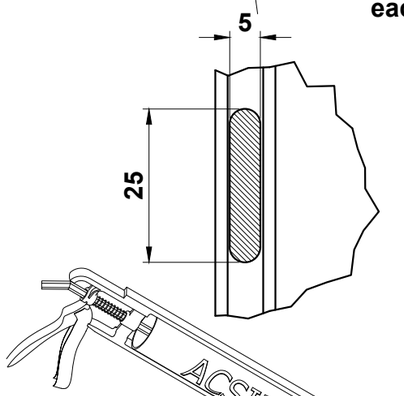
Do Not Scale From This Drawing

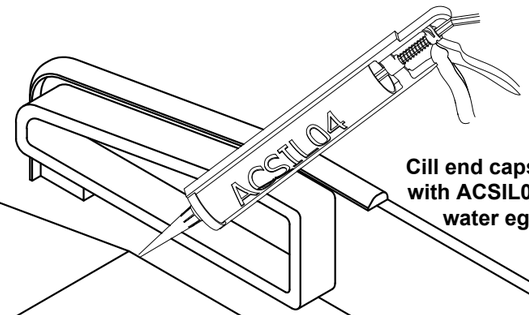
Cill Drainage

Drainage Option B



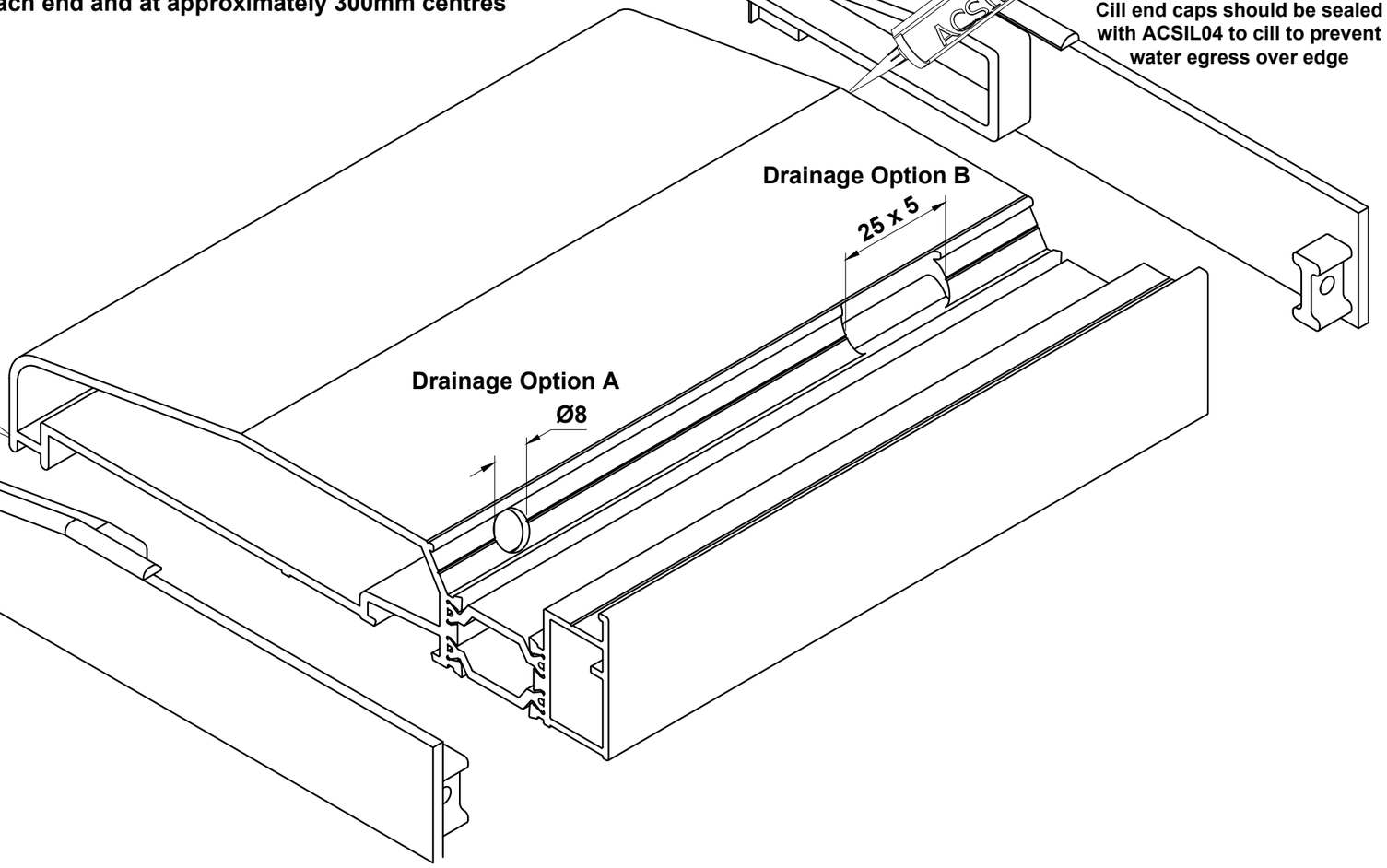
Drainage holes to be spaced 100mm in from each end and at approximately 300mm centres





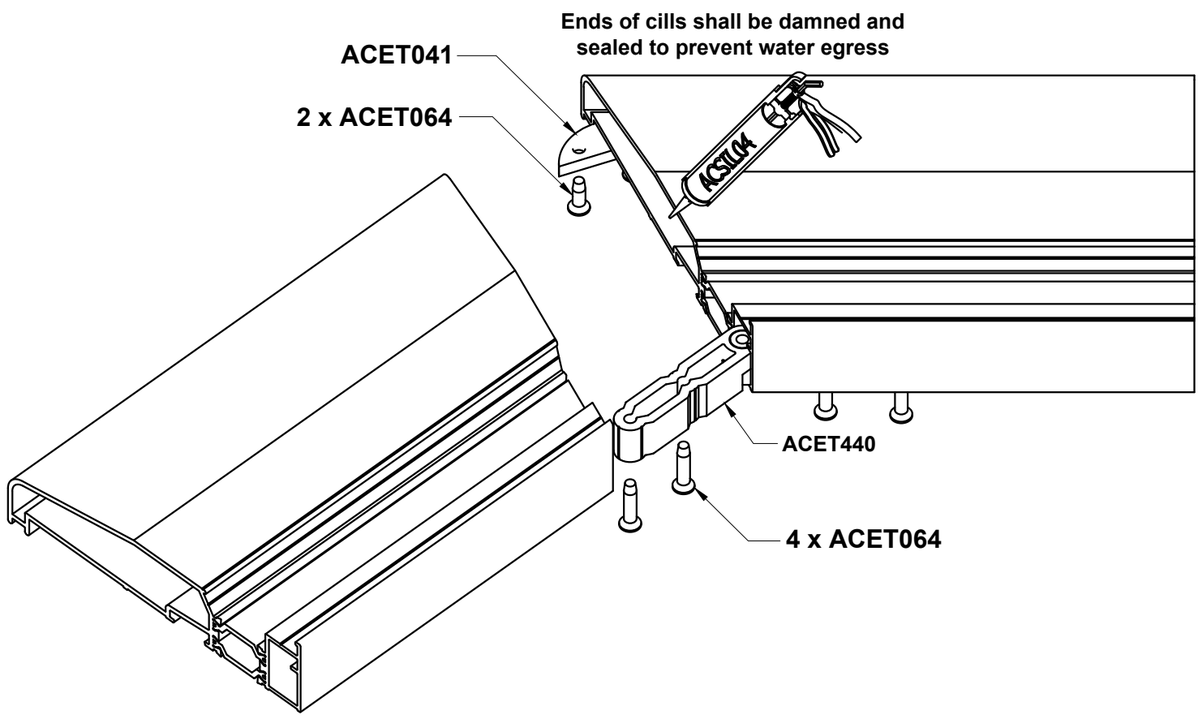
Cill end caps should be sealed with ACSIL04 to cill to prevent water egress over edge

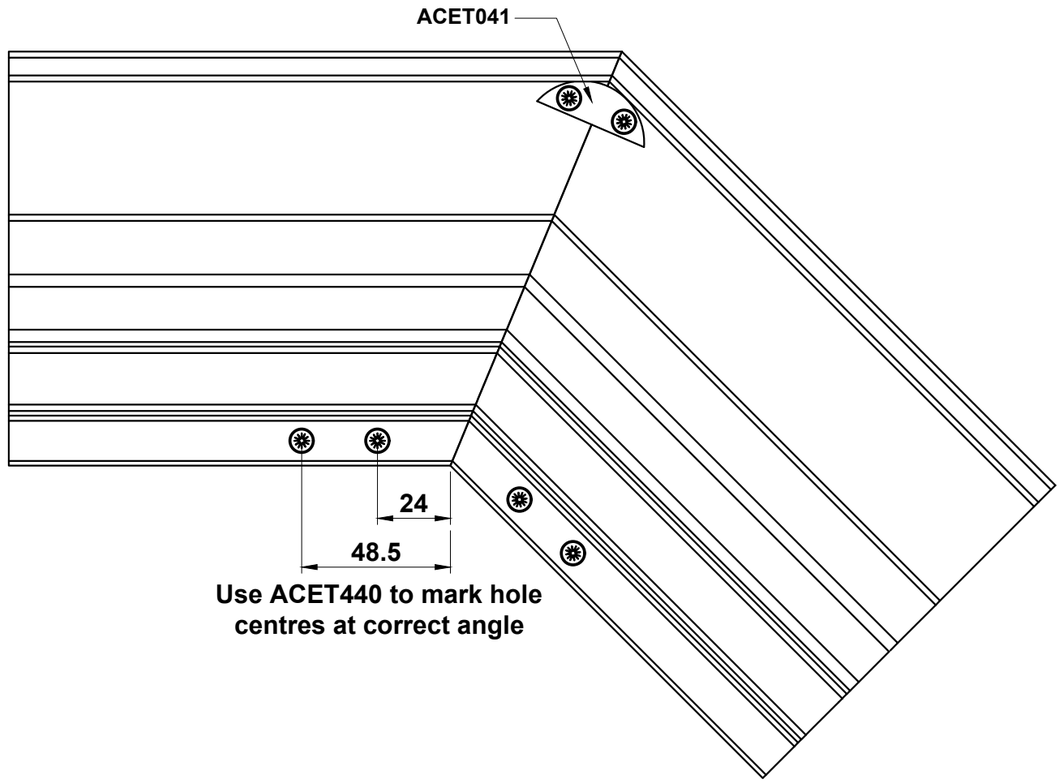
Drainage Option B



Do Not Scale From This Drawing

Angled Sub Cill

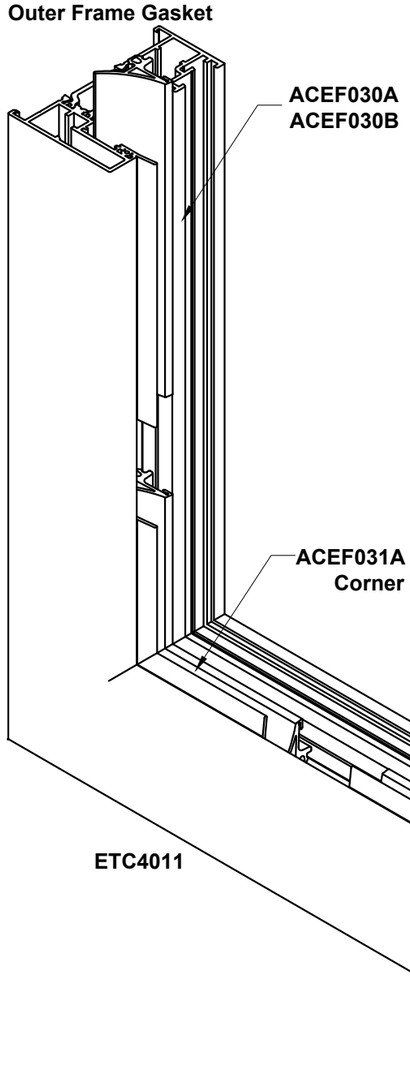




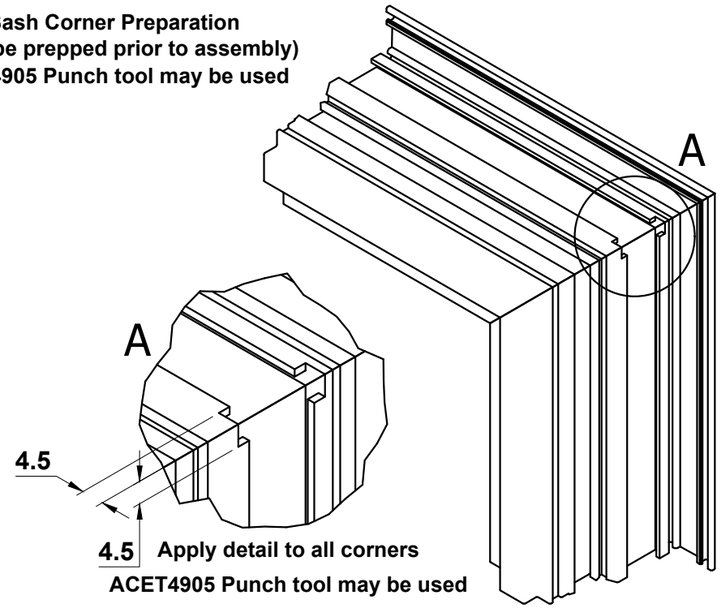
Do Not Scale From This Drawing

Tilt & Turn Outer Frame & Sash

Outer Frame Gasket

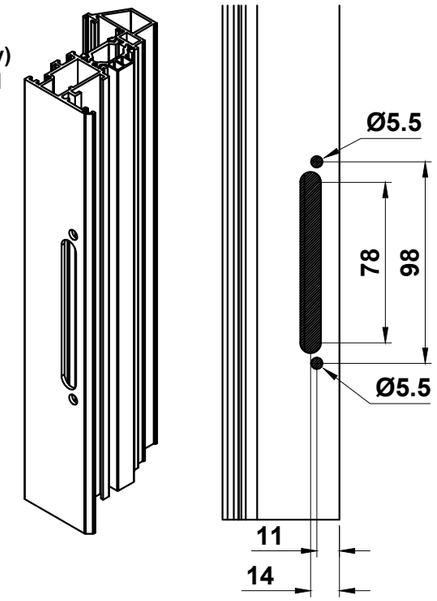


Sash Corner Preparation
(must be prepped prior to assembly)
ACET4905 Punch tool may be used

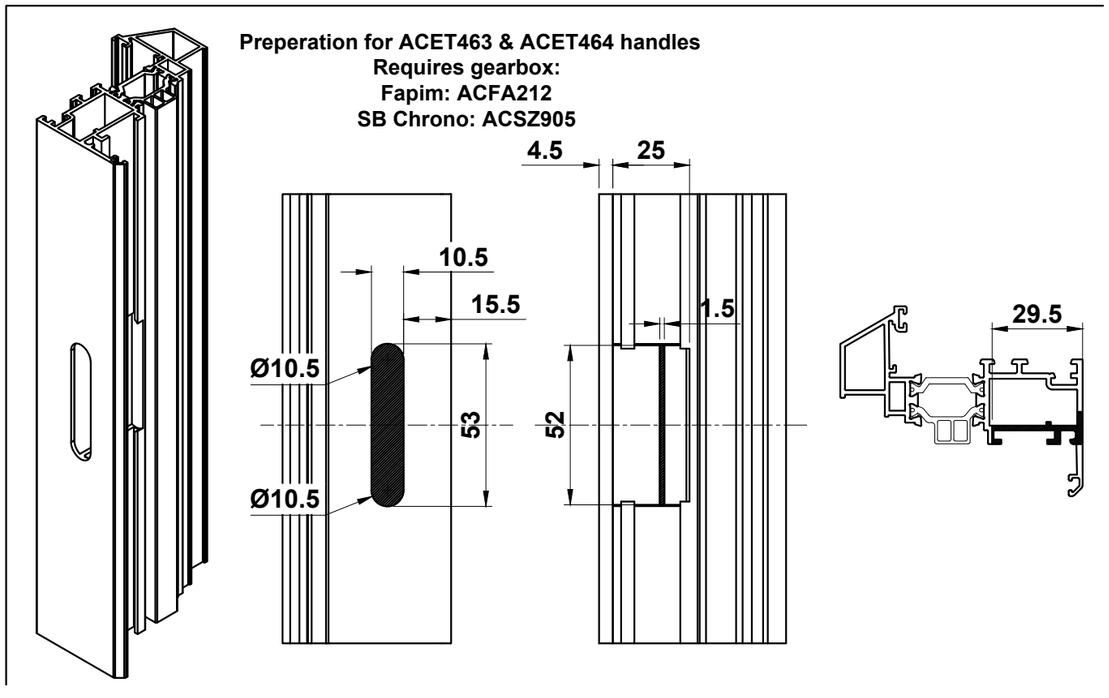


Important Note:
For PAS24 use
Sobinco Safe Invision

Handle Preparation
(must be prepped prior to assembly)
ACET4905 Punch tool may be used



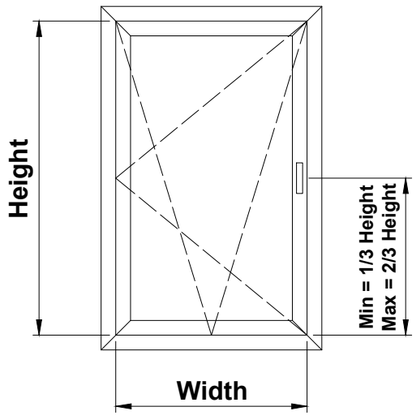
Preperation for ACET463 & ACET464 handles
Requires gearbox:
Fapim: ACFA212
SB Chrono: ACSZ905



Do Not Scale From This Drawing

Alitherm 400 Tilt & Turn

Tilt & Turn Overview

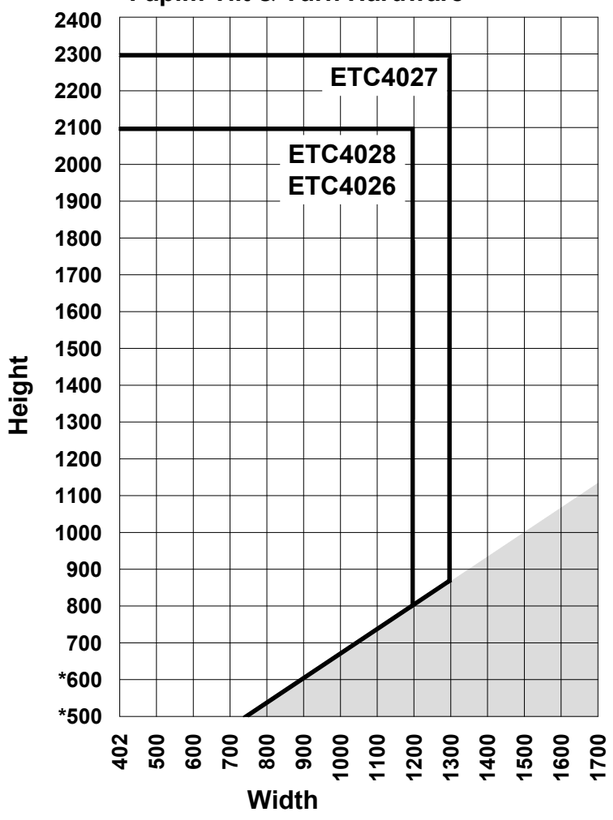


Important Notes:

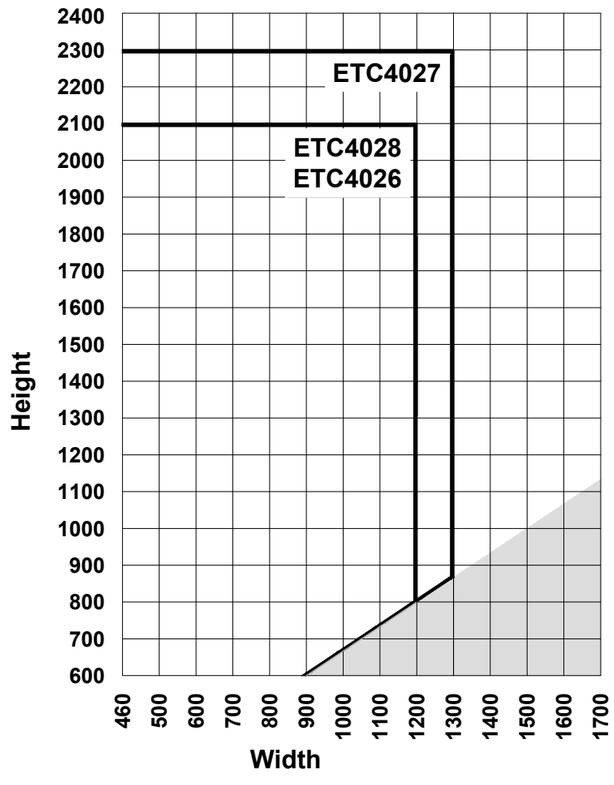
1. The size limitations of the chosen tilt & turn hardware must be adhered to
2. The width of the sash cannot be more than 1.5 times the height
3. Maximum sash weight = 90kg
4. Please refer to the tilt & turn hardware manuals for the latest information.

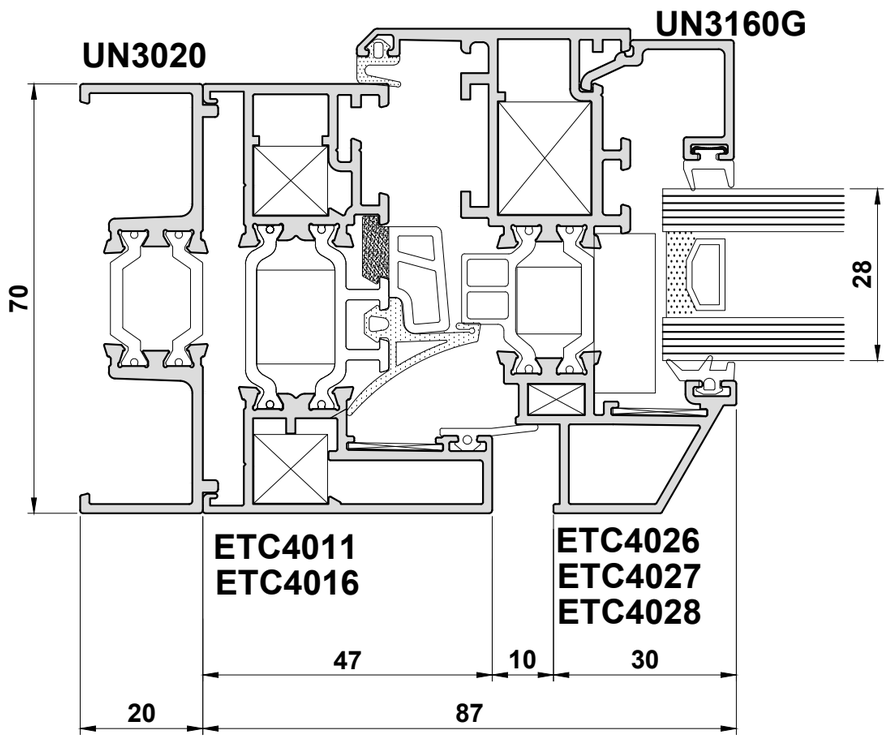
***Due to the narrow outer frame, we recommend using the Chrono Invision tilt & turn gear to avoid issue with the internal render. Alternatively, an extension section maybe used as shown.**
Please see the SB Chrono manual or the Fapim manual for full gearing details

Fapim Tilt & Turn Hardware



Sobinco Tilt & Turn Hardware

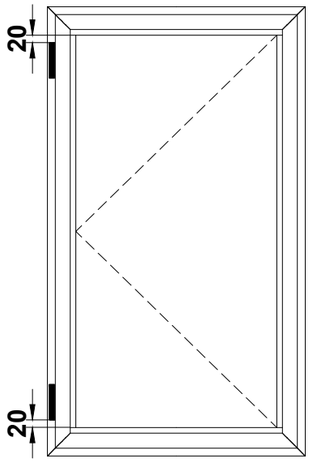




Important Note:
For PAS24 use Sobinco Safe Invision

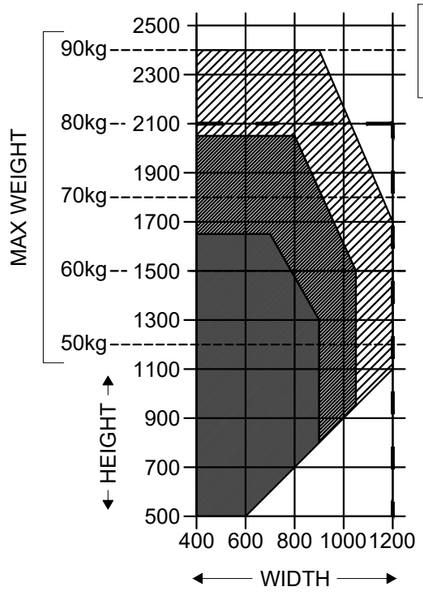
Do Not Scale From This Drawing

ACUN3140 Hinge



2 Hinge Locations

ACUN3140 - Hinge Limitations

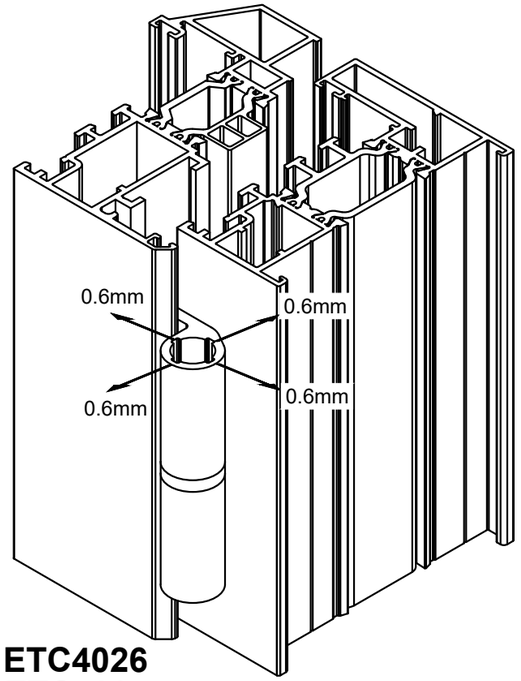


FOR BOTTOM OR SIDE HUNG OPEN IN WINDOWS. (hardware by others)

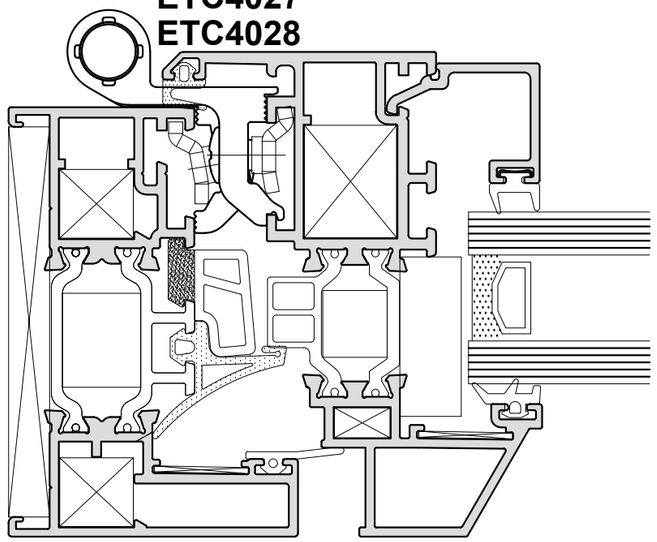
Please note:
Sash and Hinge Limitations are different.

Anything fabricated outside of Smart Systems Ltd. sash limitations will not be covered by Kitemark.

Smart Systems Ltd. sash size limitations

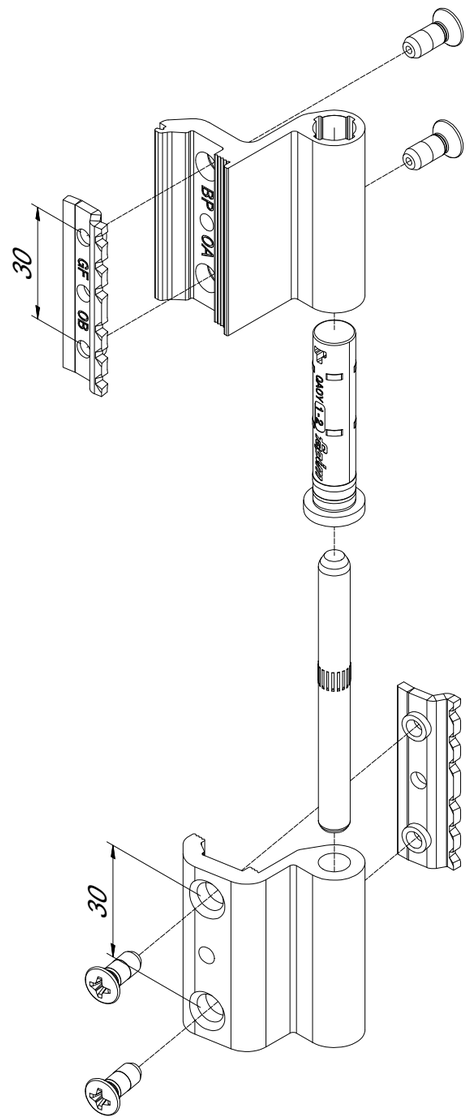


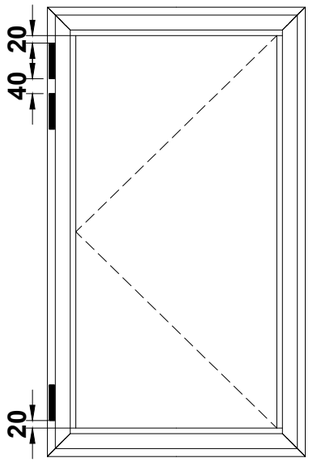
ETC4026
ETC4027
ETC4028



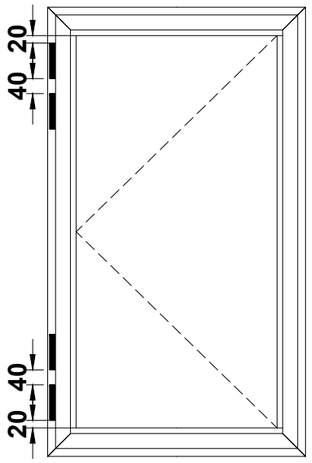
ETC4011
ETC4016

ACUN3140 - Hinge Assembly



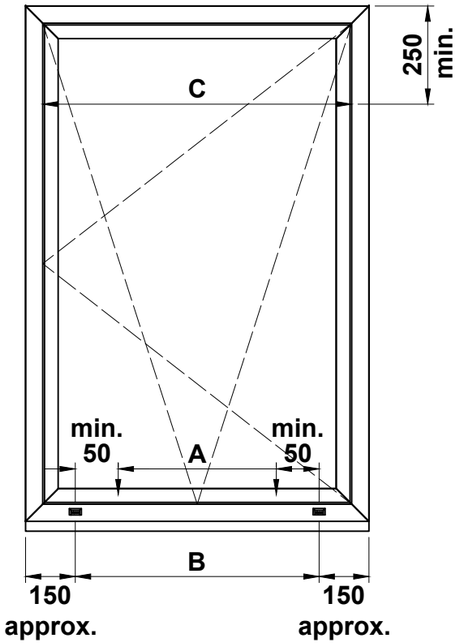


3 Hinge Locations

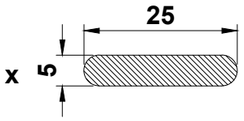


4 Hinge Locations

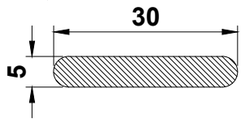
Window Drainage



A: Vent Drainage = 2 x Ø8 & 2 x

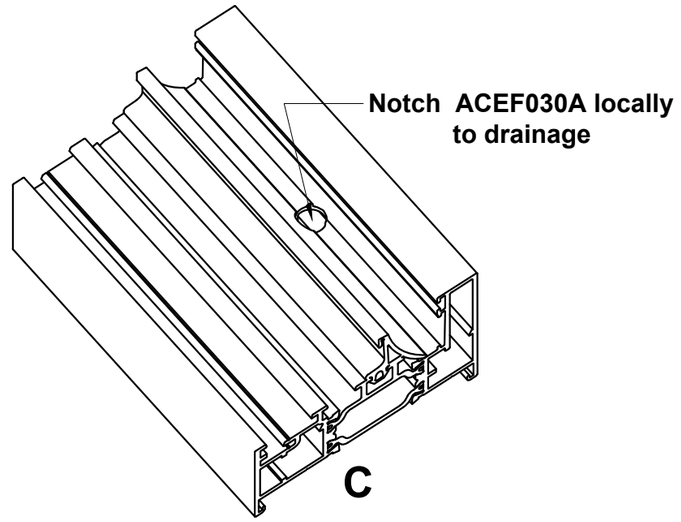


B1: Outer Frame Drainage = 2 x



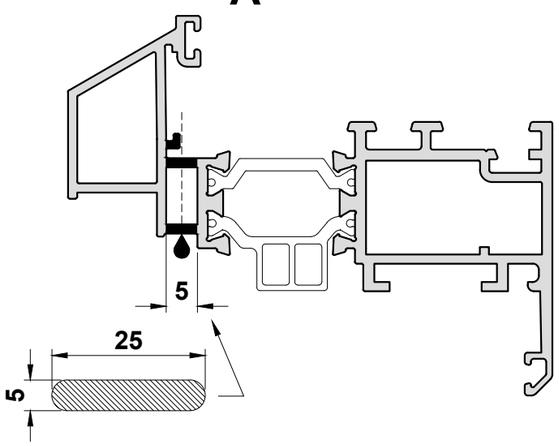
B2: Outer Frame Drainage = 2 x Ø8

C: Sash Ventilation Holes = 2 x Ø5

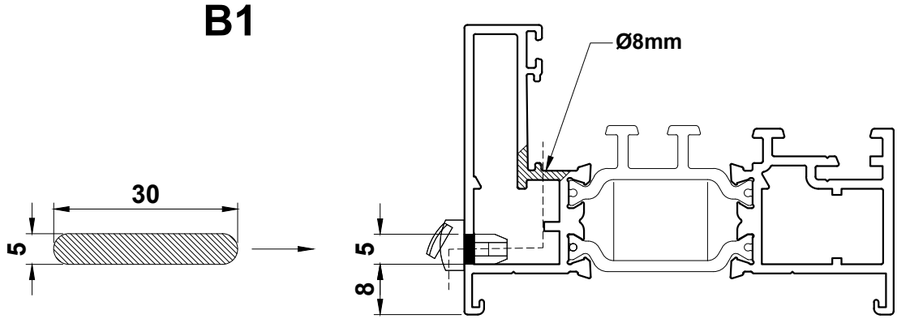


Important Note: All exposed aluminium should be coated using ACSIL014 or painted to match the frame.

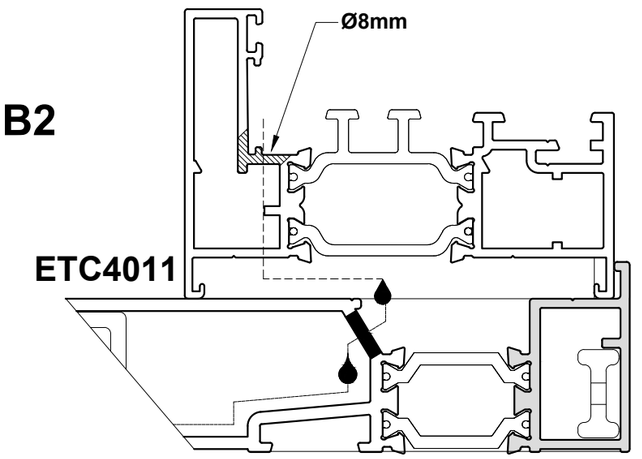
A



B1

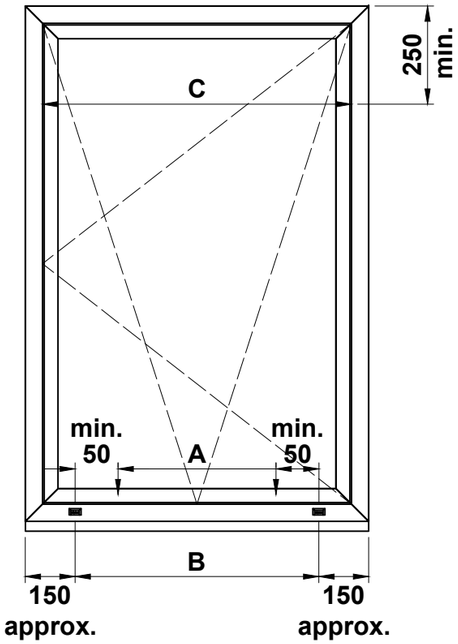


B2

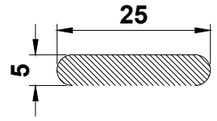


Do Not Scale From This Drawing

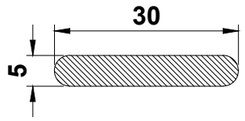
Window Drainage



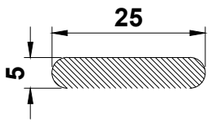
A: Vent Drainage = 2 x



B1: Outer Frame Drainage = 2 x

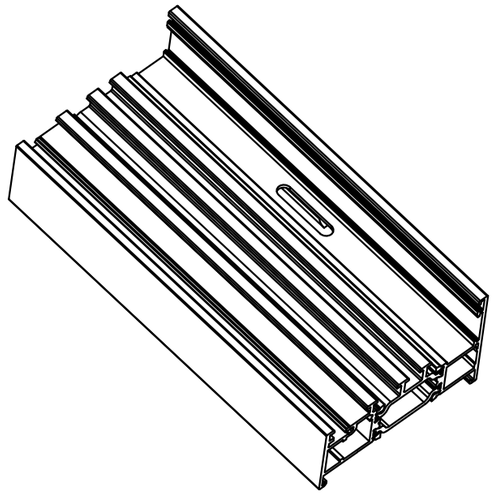


B2: Outer Frame Drainage = 2 x Ø8 Or 2 x



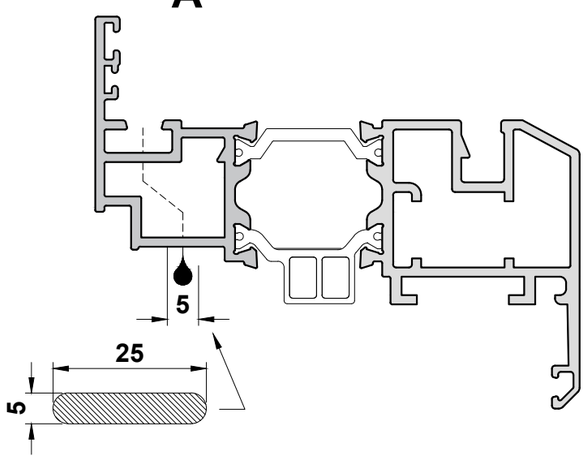
C: Sash Ventilation Holes = 2 x Ø5



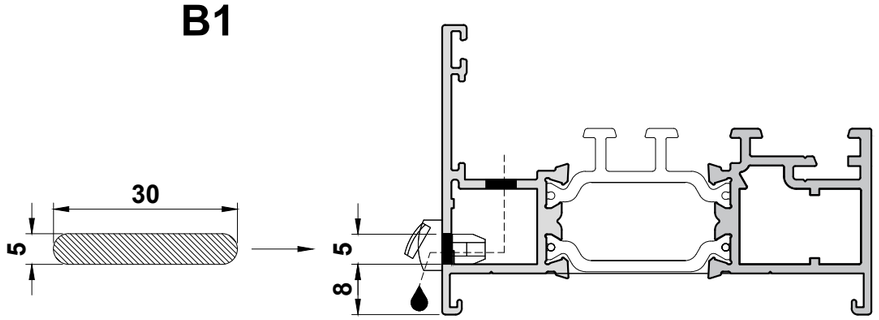


Important Note: All exposed aluminium should be coated using ACSIL014 or painted to match the frame.

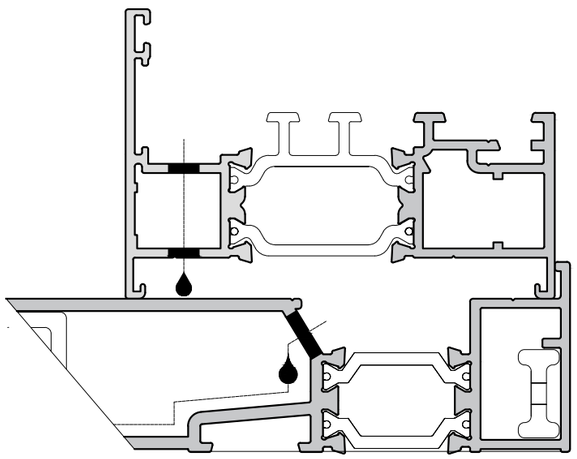
A



B1

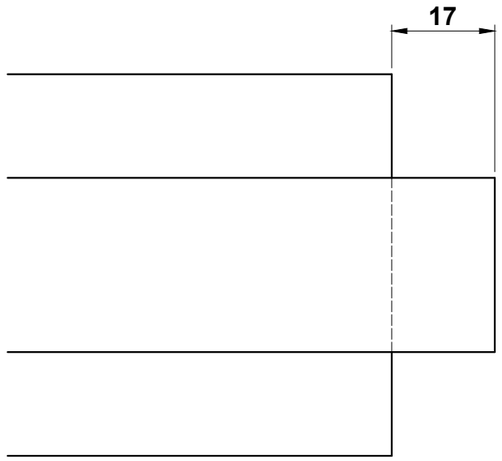


B2

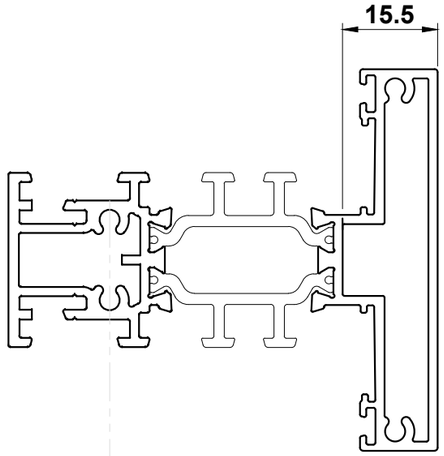


Do Not Scale From This Drawing

Mullion/Transom Detail



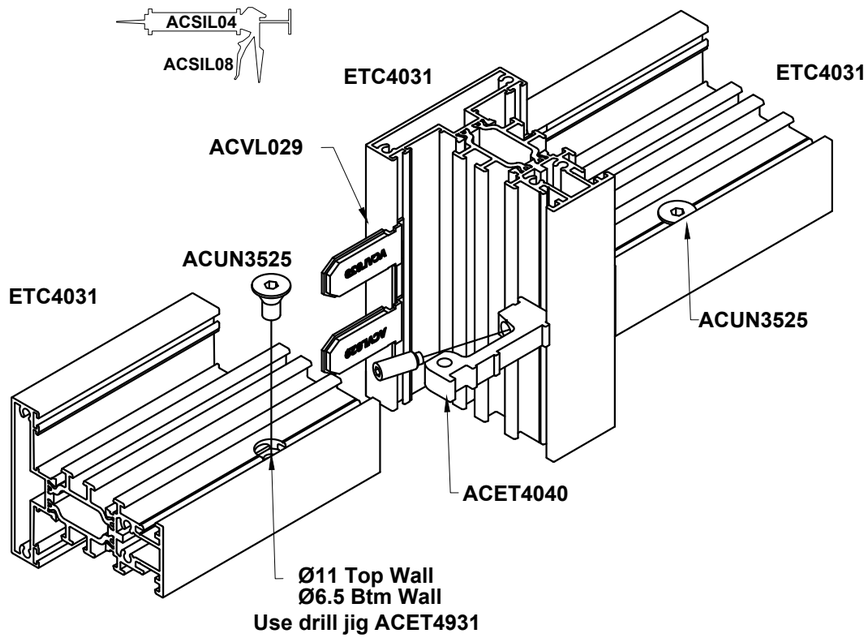
ACET4931 - Drill Jig
Note: Jig must be clamped in position
to avoid risk of injury.



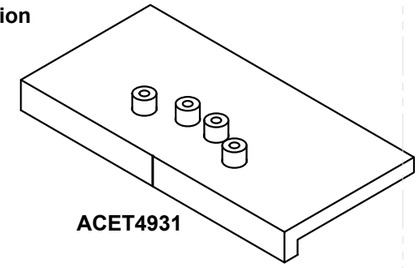


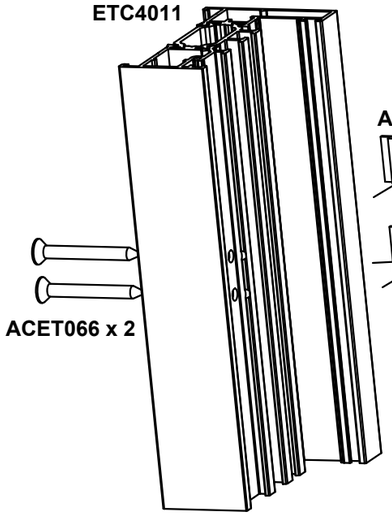
ACVL029

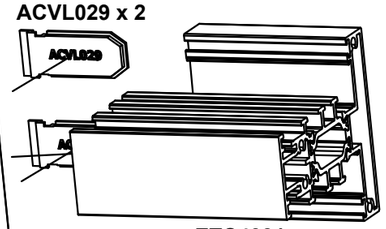
Important Fabrication Note:
All joints shall be sealed using ACSIL04

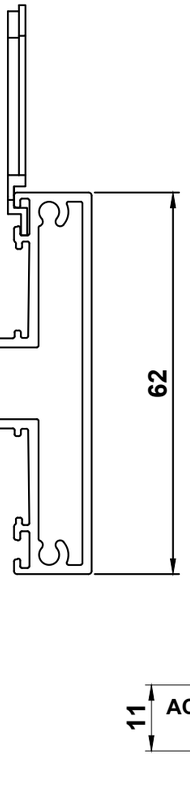


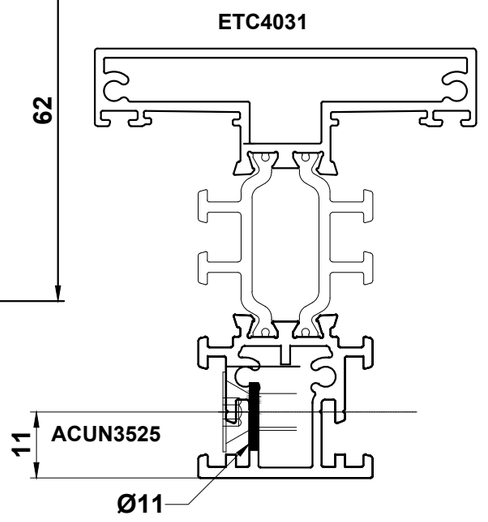
Ø11 Top Wall
Ø6.5 Btm Wall
Use drill jig ACET4931

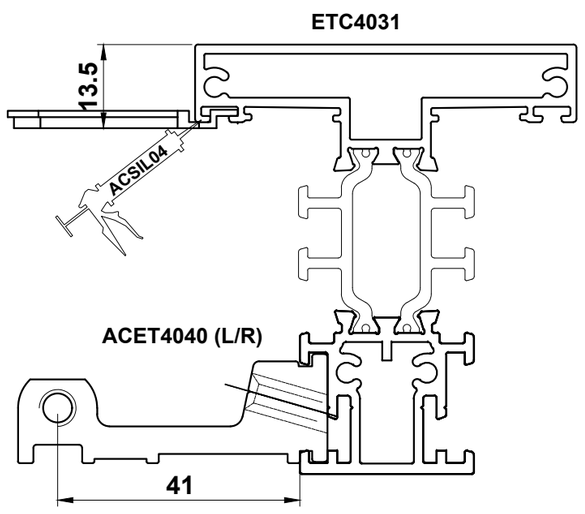








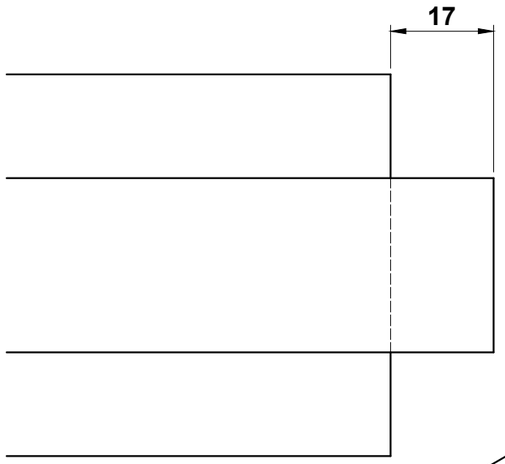




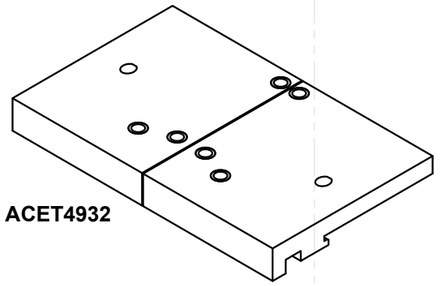
Note:
End mill cutters can be ordered through Smart Systems Ltd.
Please contact the Technical Department for an order form.
Standard delivery is 2-3 weeks approx.

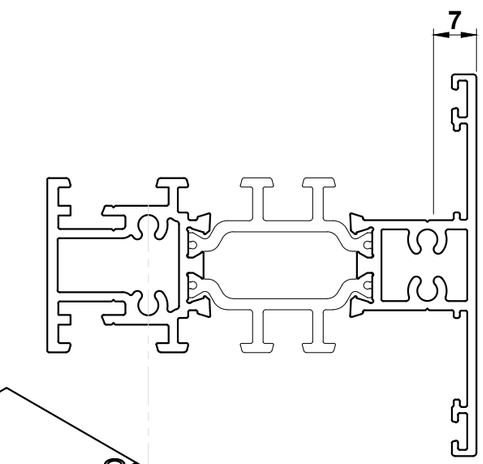
Do Not Scale From This Drawing

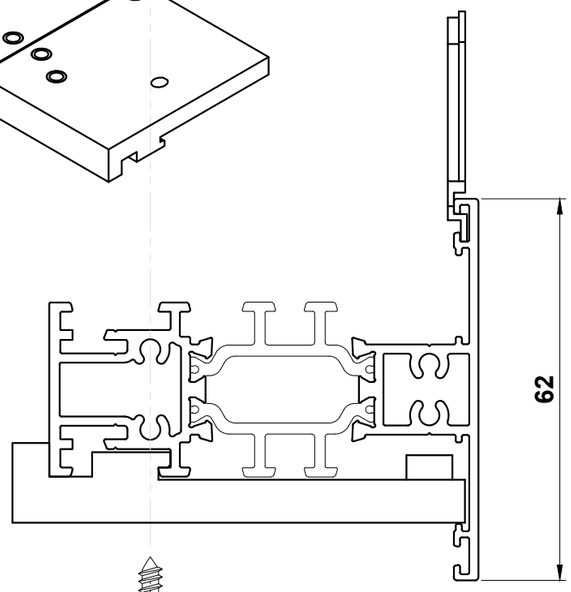
Mullion/Transom Detail

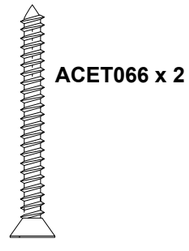


ACET4932 - Drill Jig
Note: Jig must be clamped in position to avoid risk of injury.

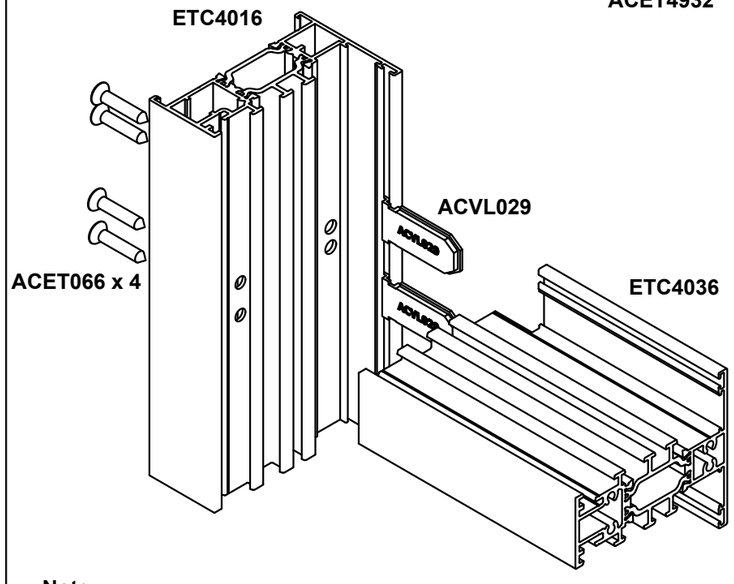






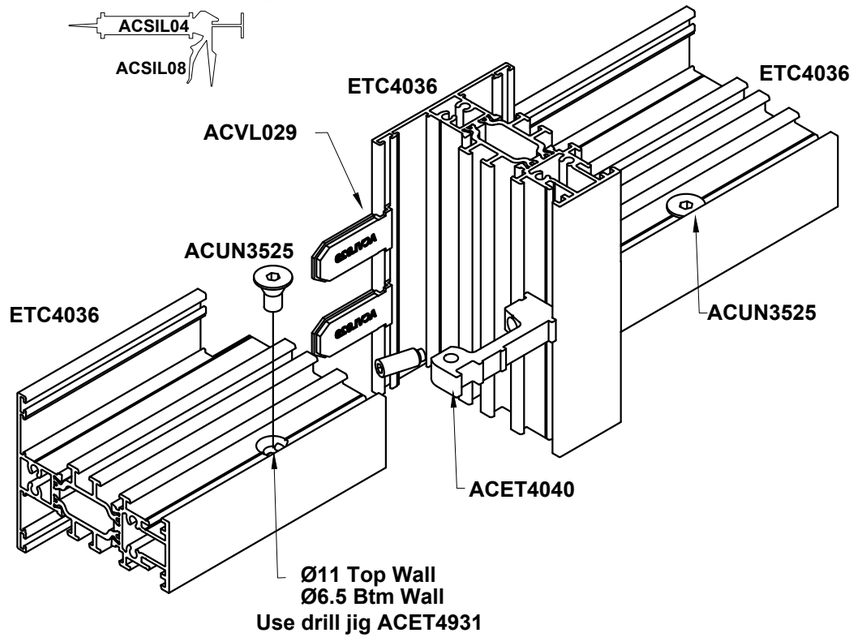


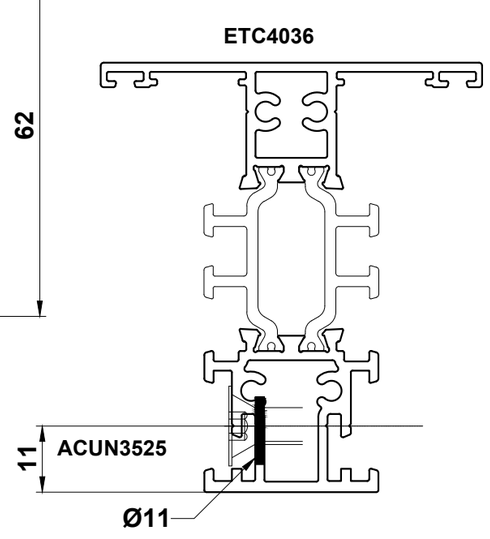


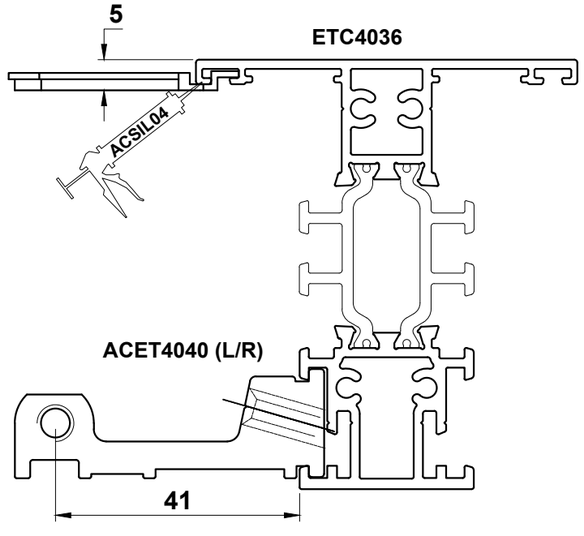


Note:
End mill cutters can be ordered through Smart Systems Ltd.
Please contact the Technical Department for an order form.
Standard delivery is 2-3 weeks approx.

Important Fabrication Note:
All joints shall be sealed using ACSIL04

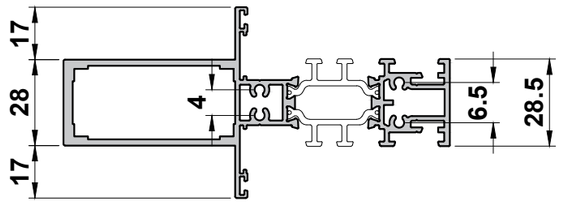




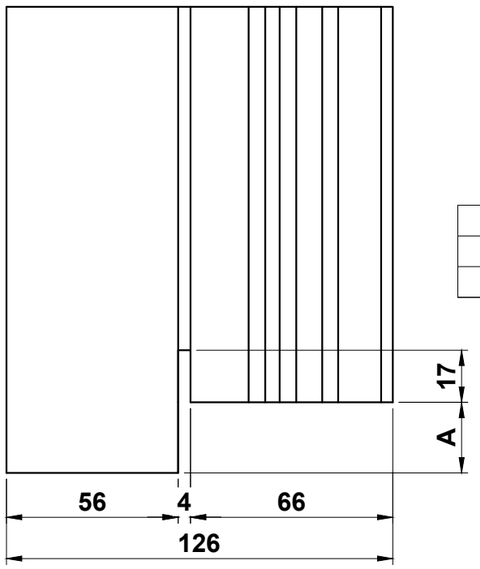


Do Not Scale From This Drawing

Reinforced Mullion Detail

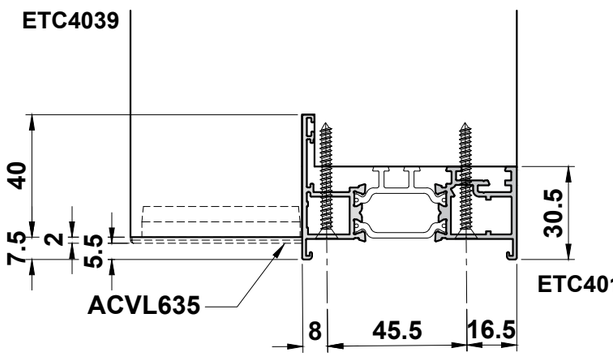


ETC4039



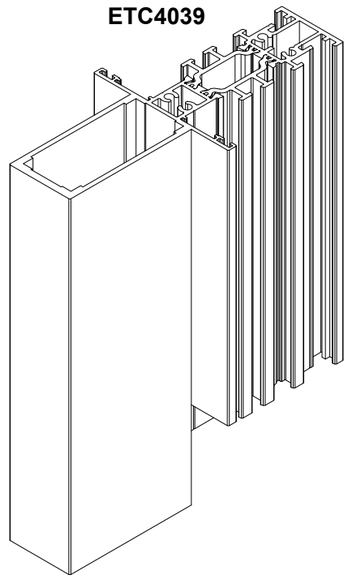
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ETC4018	34.5

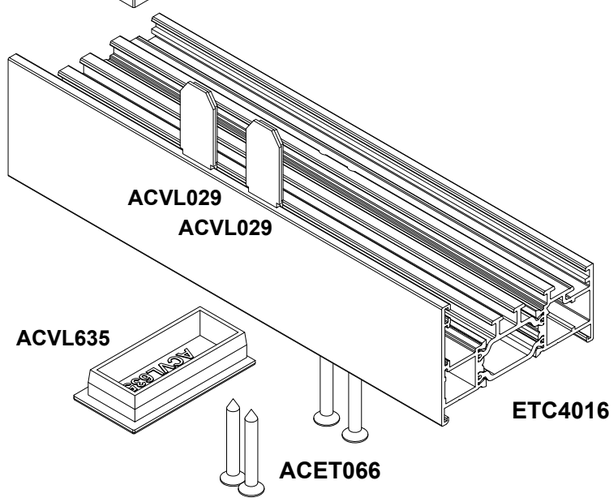
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ETC4016

ETC4039

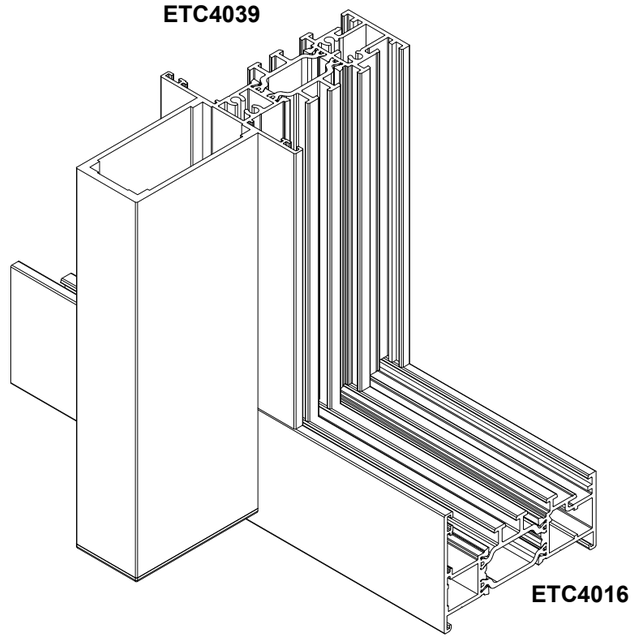




Important Fabrication Note:
All joints shall be sealed using ACSIL04

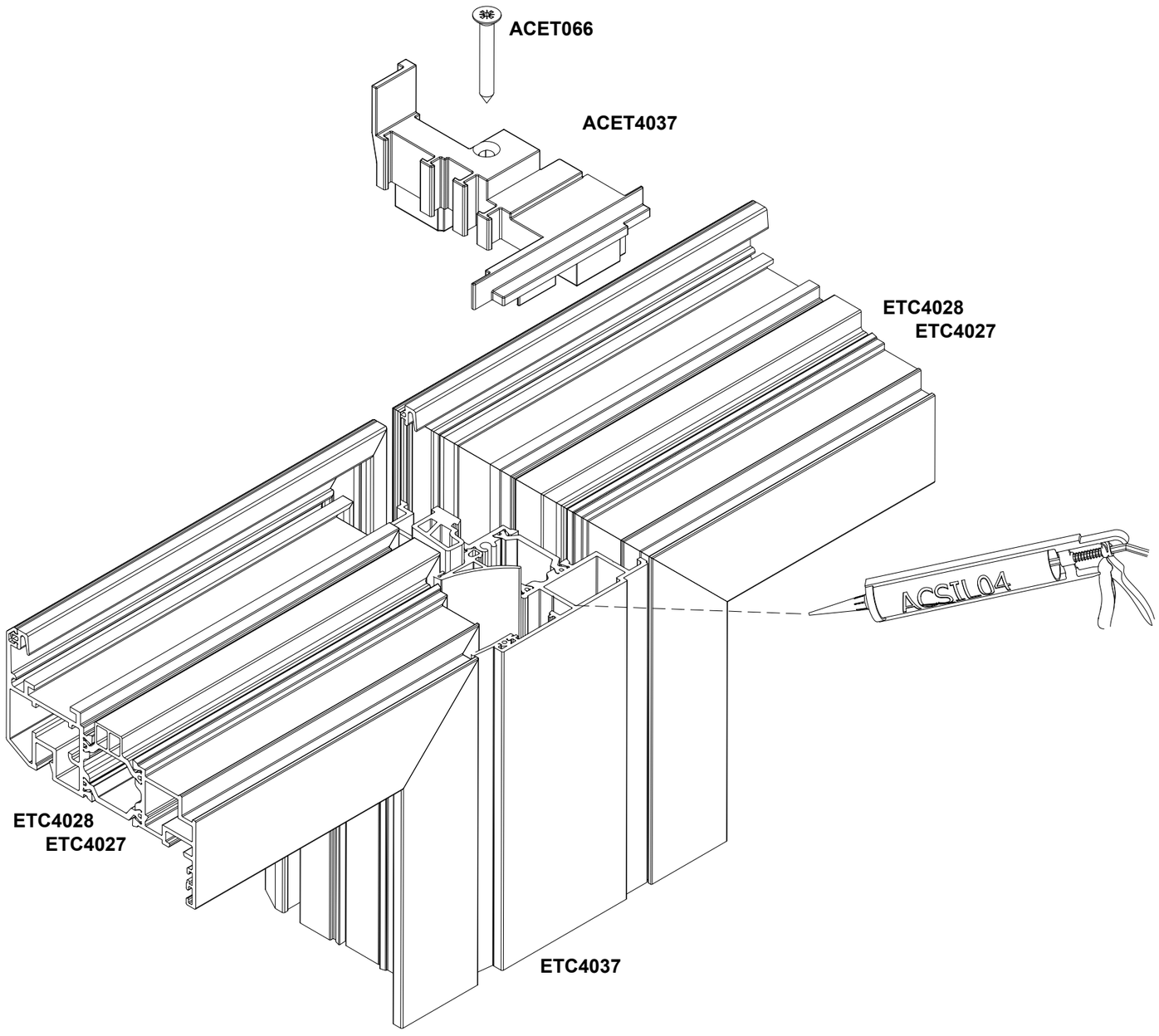


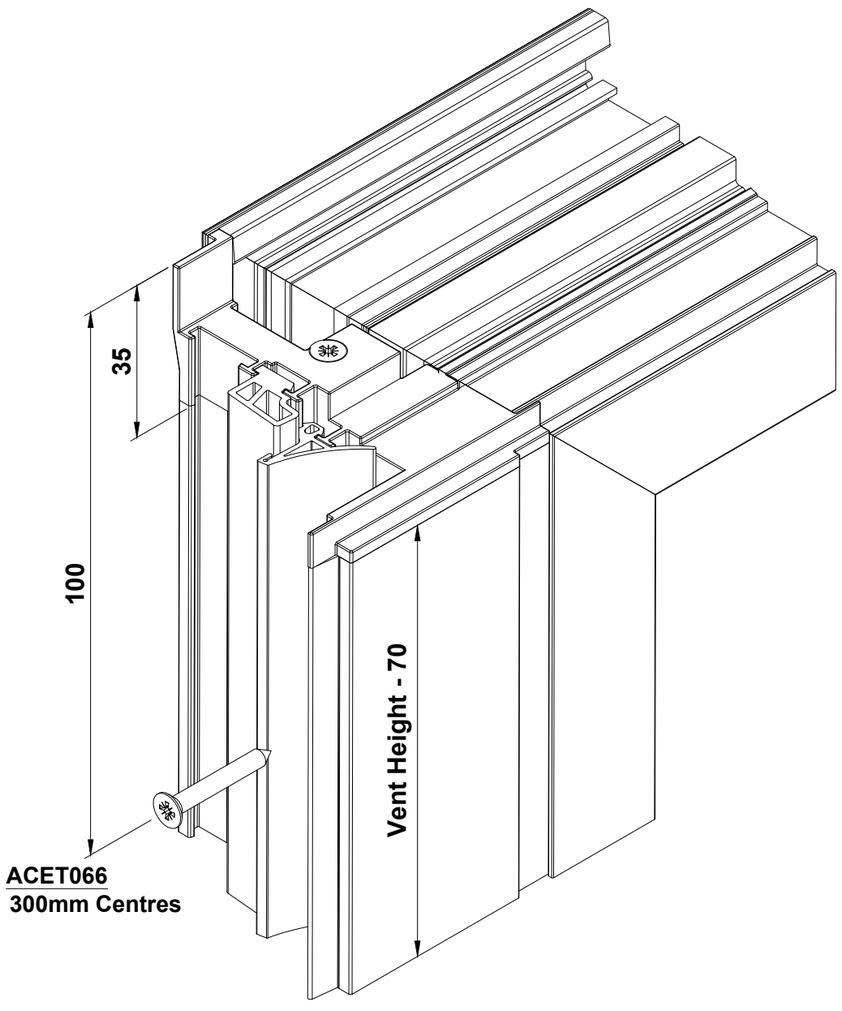
ETC4039



Do Not Scale From This Drawing

ETC4037 Floating Mullion Details

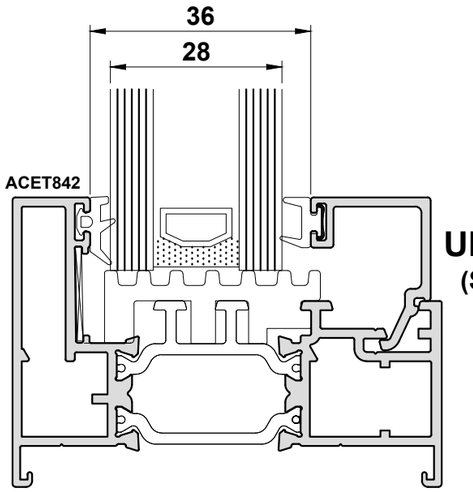




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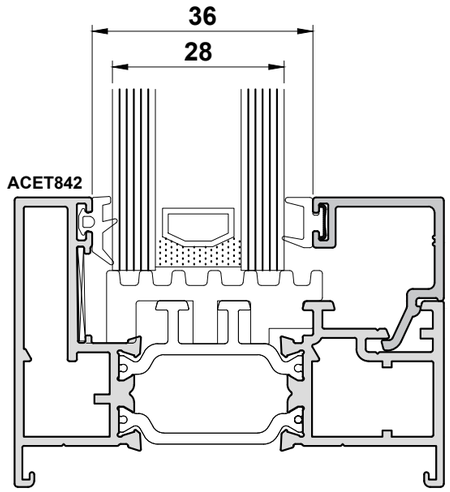
Glazing Chart

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ETC4014
ETC4017
ETC4031
ETC4026



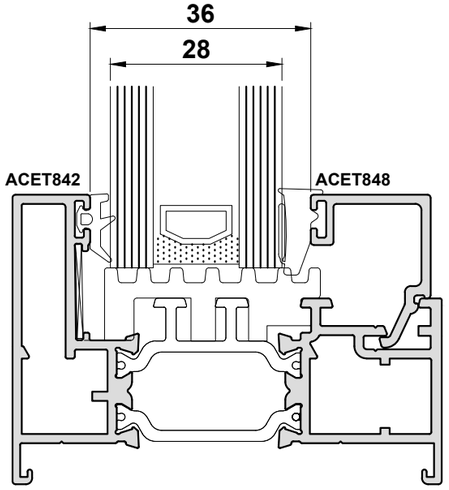
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(Stepped)

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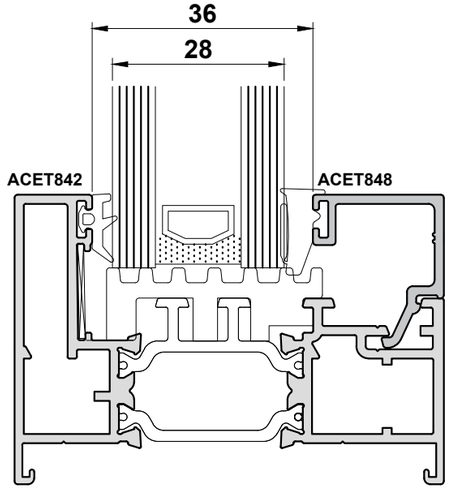
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UN3160
(Stepped)

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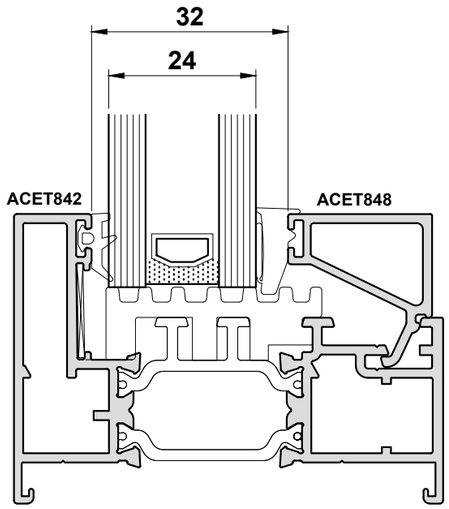


ETC4067

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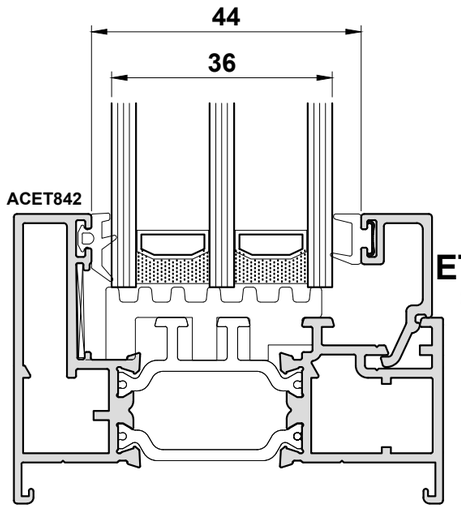
Glazing Chart

ETC4011
ETC4014
ETC4017
ETC4031
ETC4026



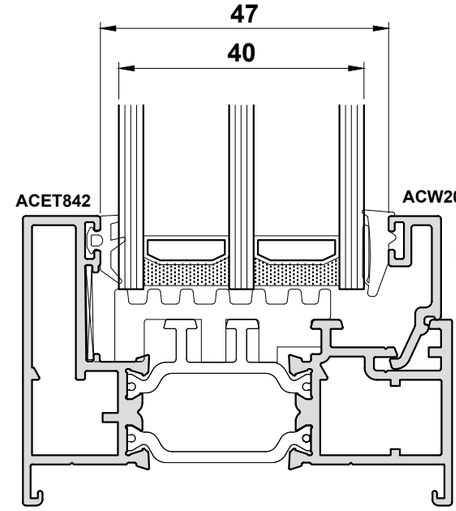
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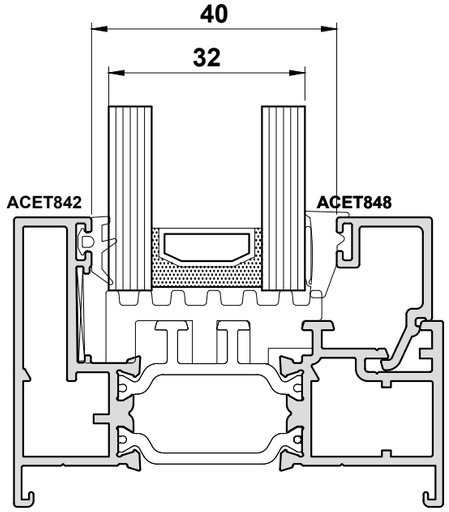
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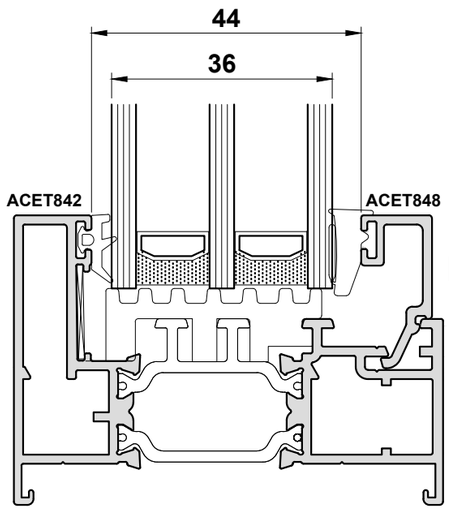
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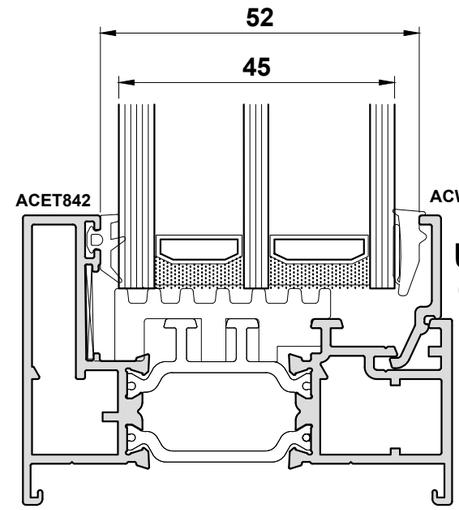
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ETC4179
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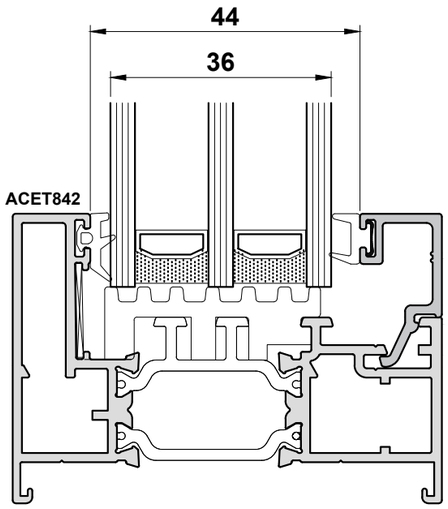


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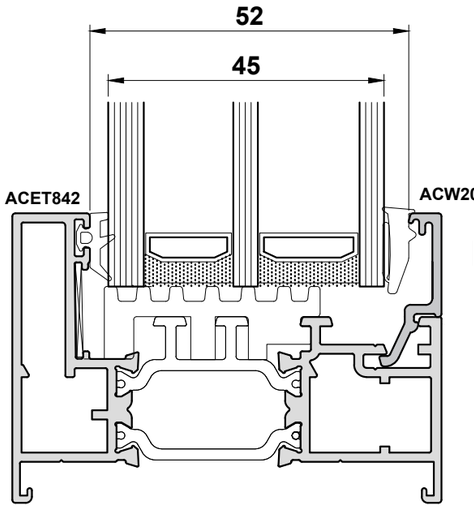
Glazing Chart

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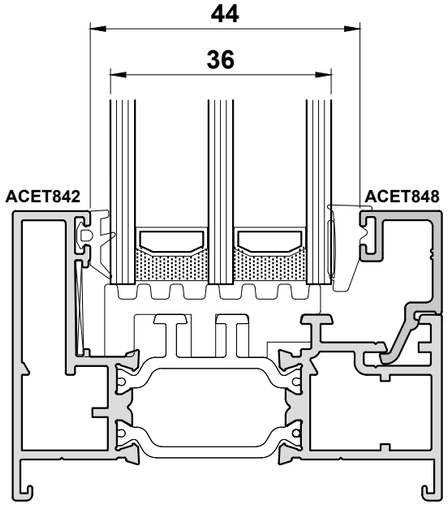
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ETC4063

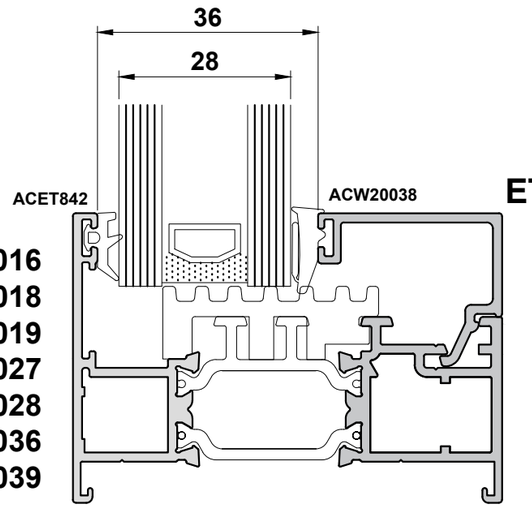
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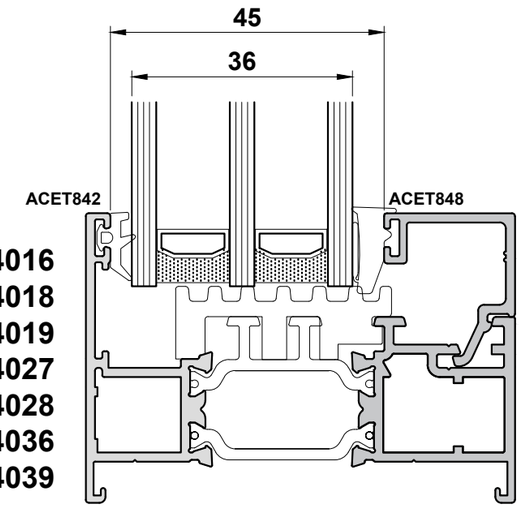
Do Not Scale From This Drawing

Glazing Chart



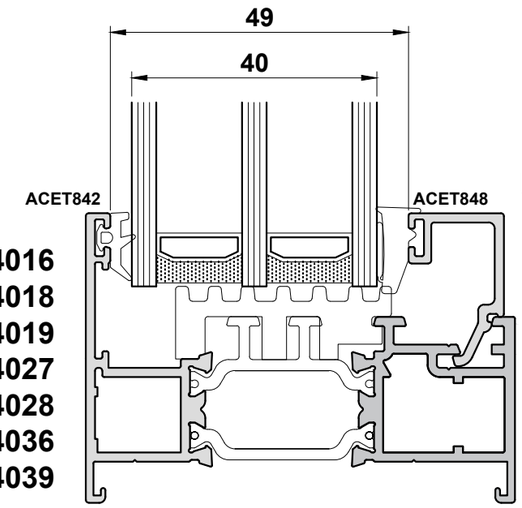
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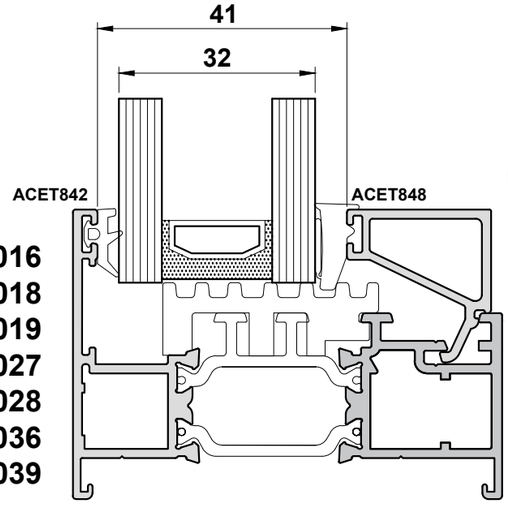
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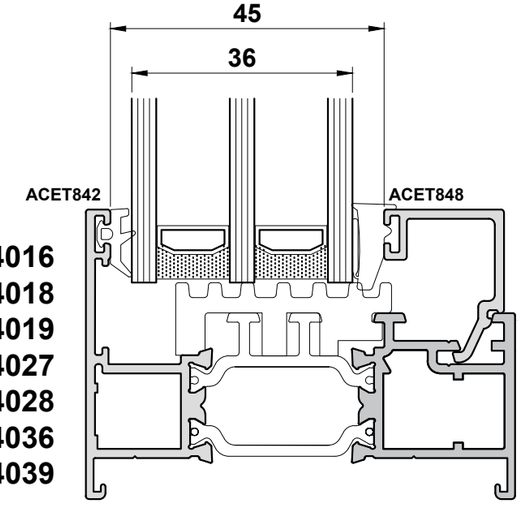
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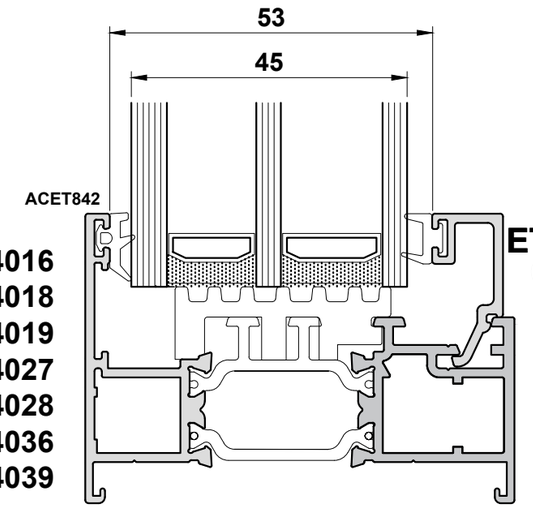
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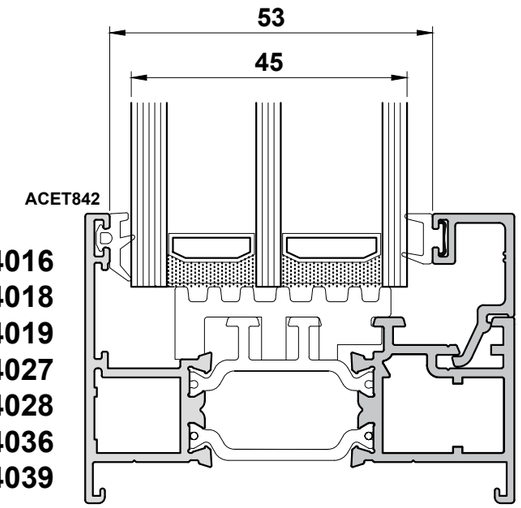
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Glazing Chart



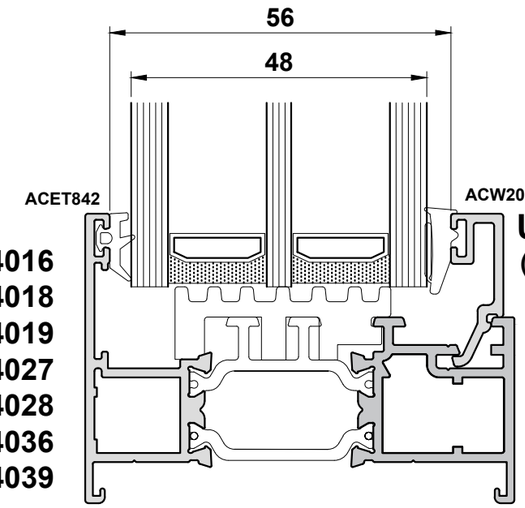
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ETC4019
ETC4027
ETC4028
ETC4036
ETC4039

ETC4179G
(Stepped)



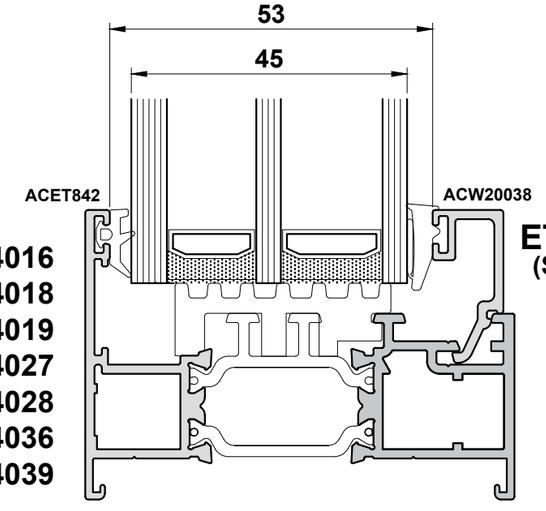
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ETC4061G



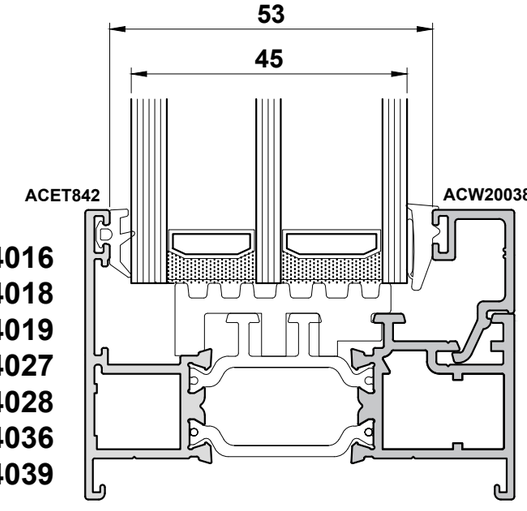
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ETC4018
ETC4019
ETC4027
ETC4028
ETC4036
ETC4039

UN3166
(Stepped)



ETC4016
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ETC4019
ETC4027
ETC4028
ETC4036
ETC4039

ETC4179
(Stepped)

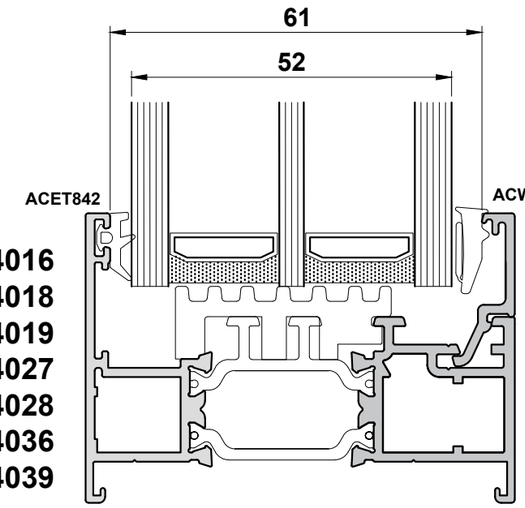


ETC4016
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ETC4019
ETC4027
ETC4028
ETC4036
ETC4039

ETC4061

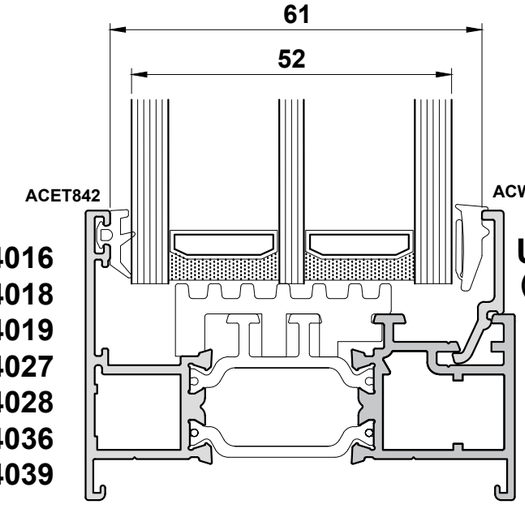
Do Not Scale From This Drawing

Glazing Chart



ETC4016
ETC4018
ETC4019
ETC4027
ETC4028
ETC4036
ETC4039

ETC4063

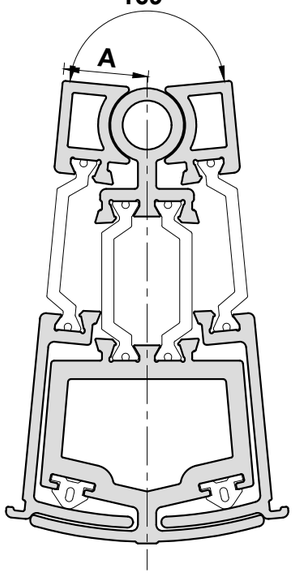


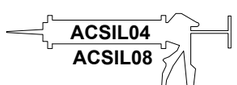
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ETC4019
ETC4027
ETC4028
ETC4036
ETC4039

UN3168
(Stepped)

Fixed Bay Pole Angle / Deductions

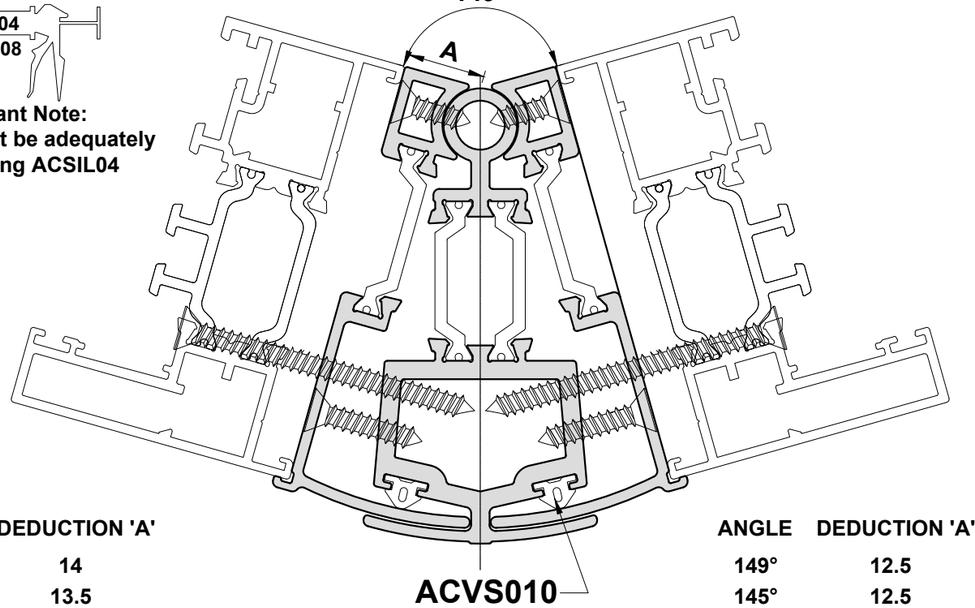
169°



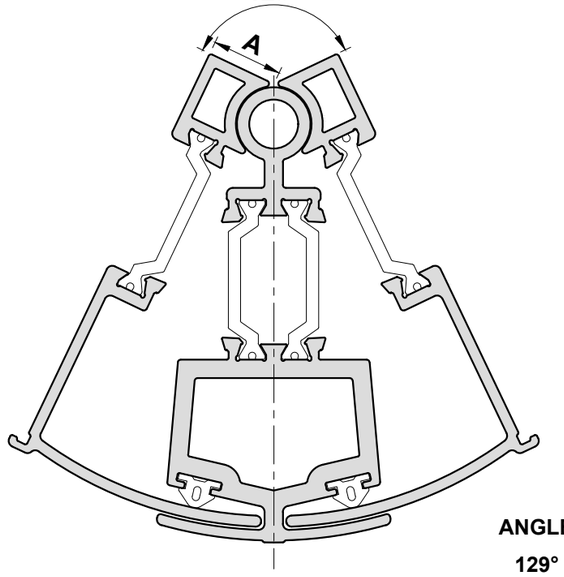


Important Note:
All joints must be adequately sealed using ACSIL04

149°



129°

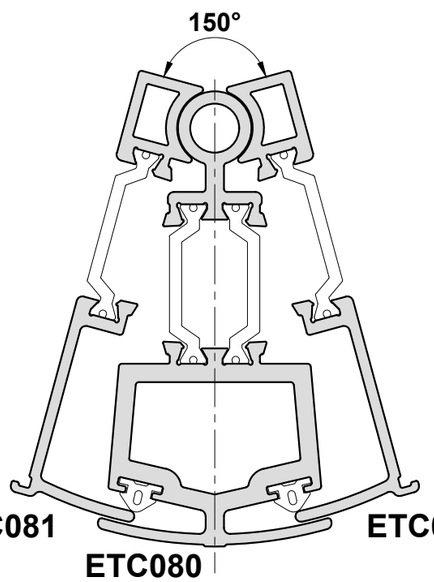


ANGLE	DEDUCTION 'A'
169°	14
165°	13.5
160°	13.6
155°	13
150°	13

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

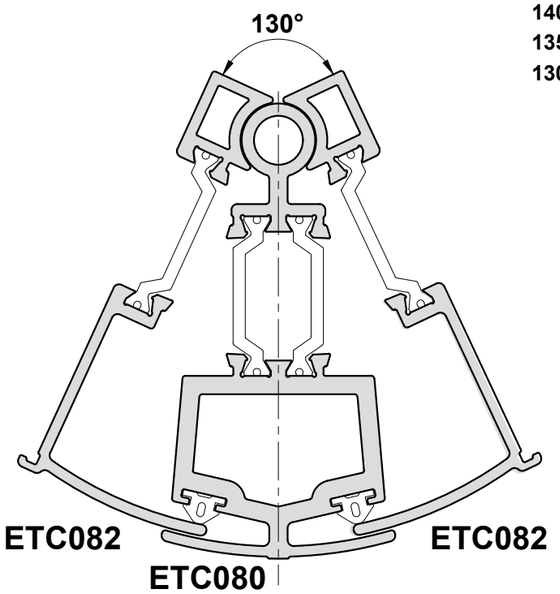
ANGLE	DEDUCTION 'A'
129°	11.5
125°	11.5
120°	11
115°	10.5

150°



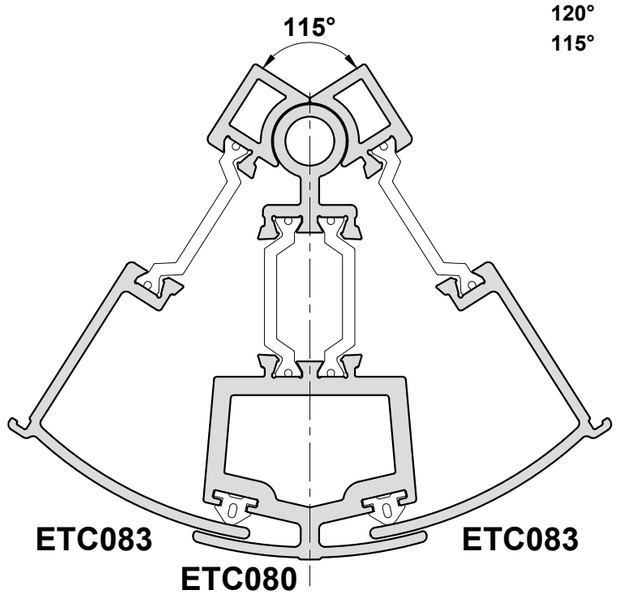
ETC081 ETC081
ETC080

130°



ETC082 ETC082
ETC080

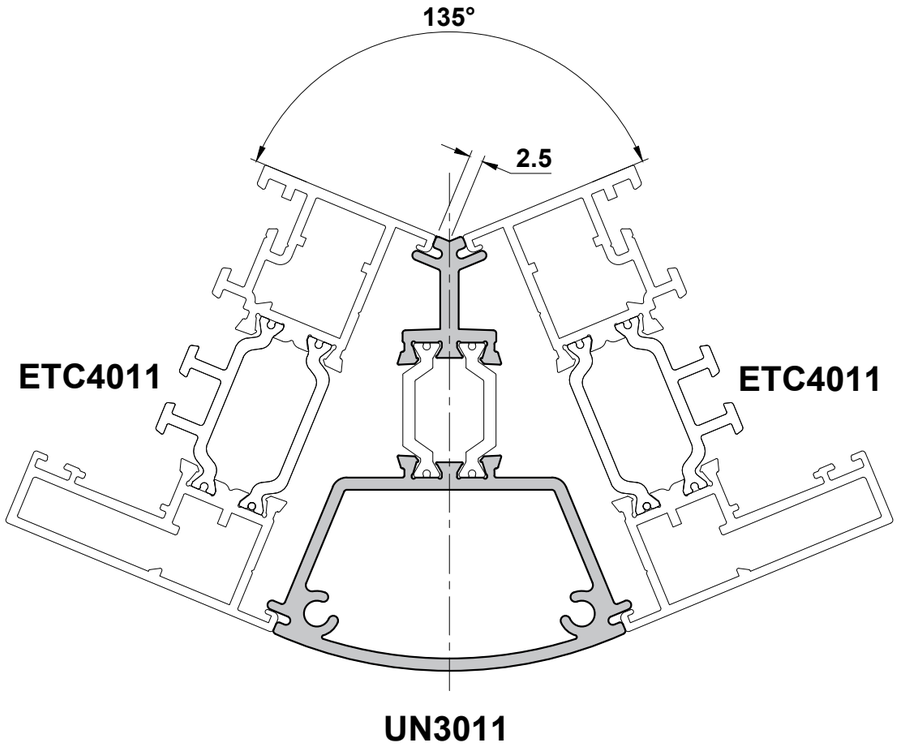
115°

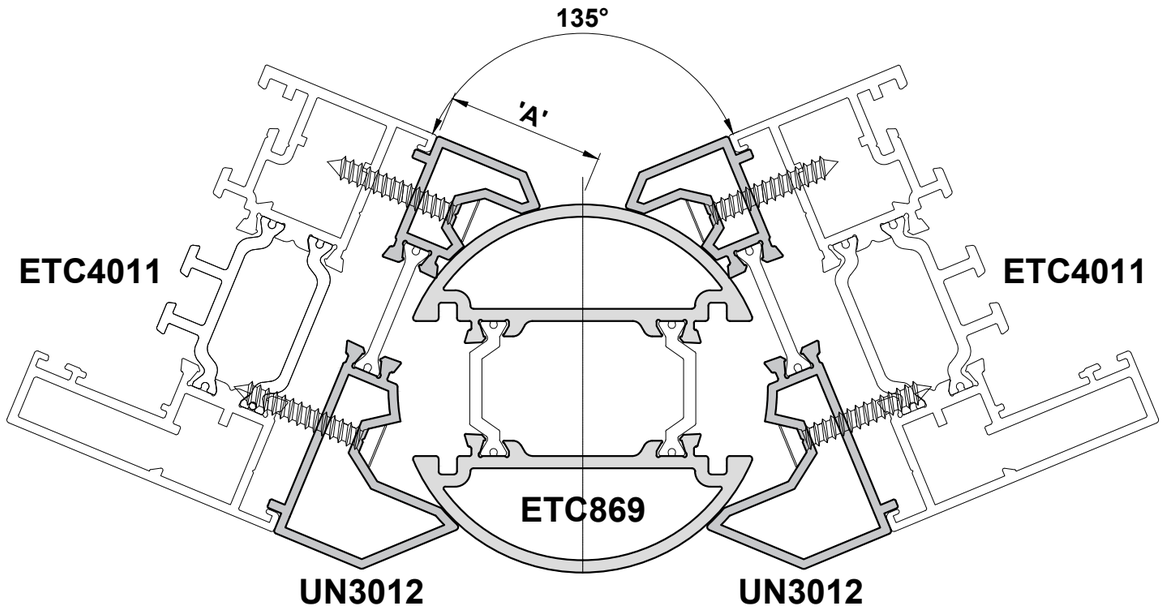


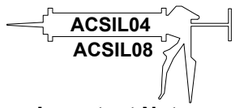
ETC083 ETC083
ETC080

Do Not Scale From This Drawing

Fixed Bay Pole Angle / Deductions



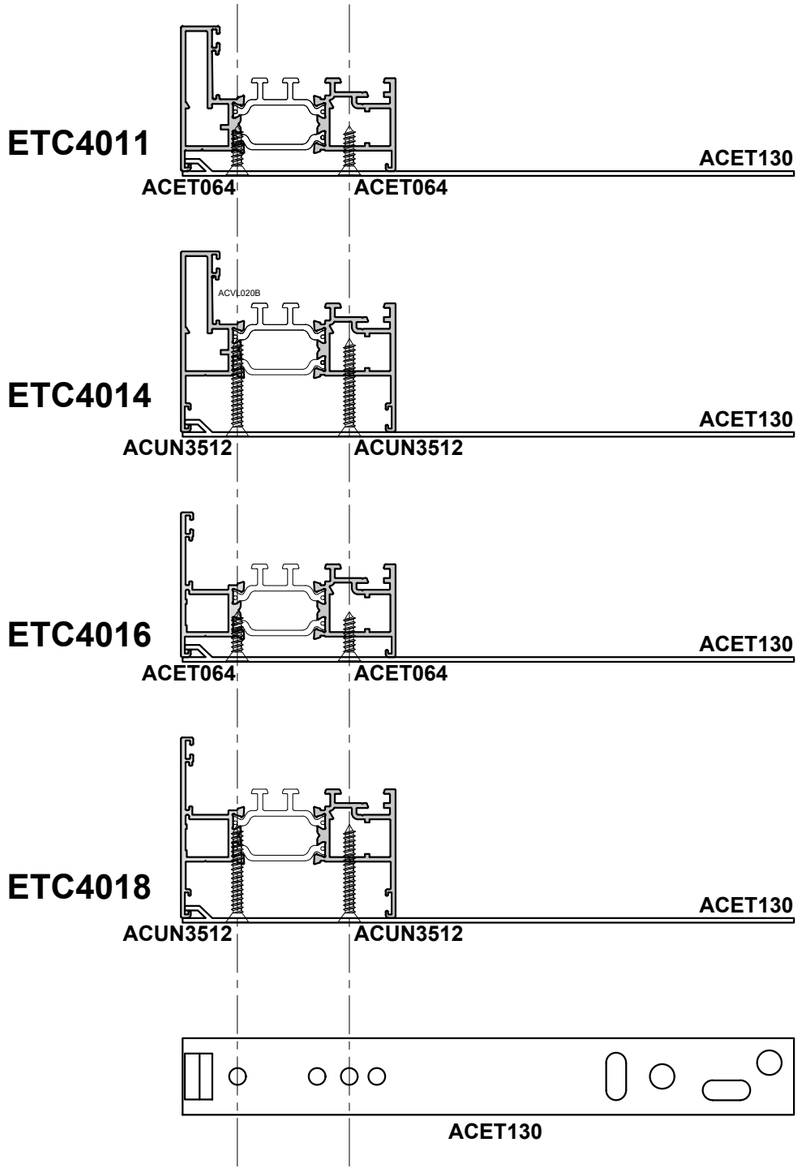




Important Note:
All joints must be adequately sealed using ACSIL04

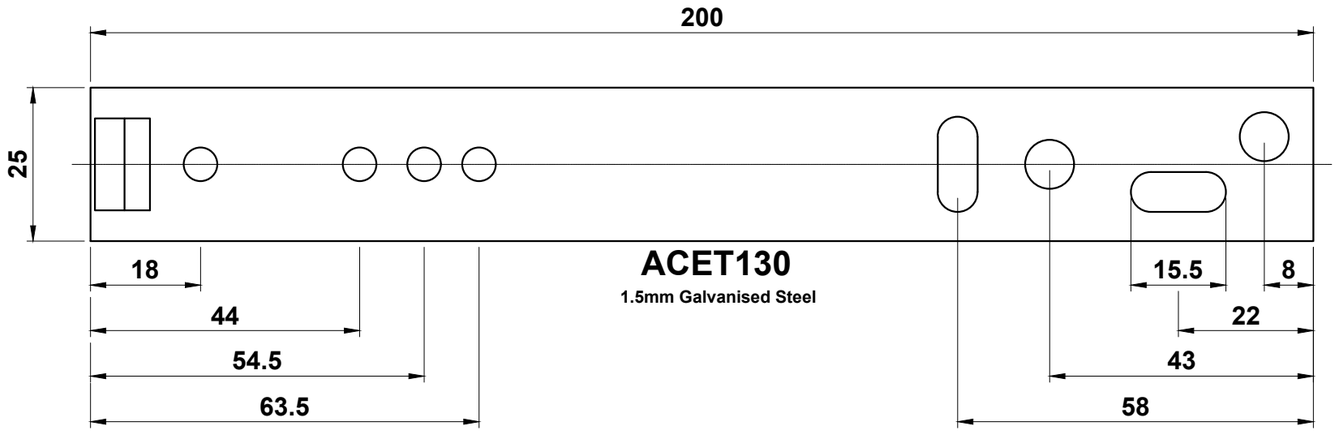
ANGLE	DEDUCTION 'A'
180°	37.5
175°	36
170°	35
165°	33.5
160°	32.5
155°	31
150°	30
145°	28.5
140°	27
135°	25.5

Fixing Details

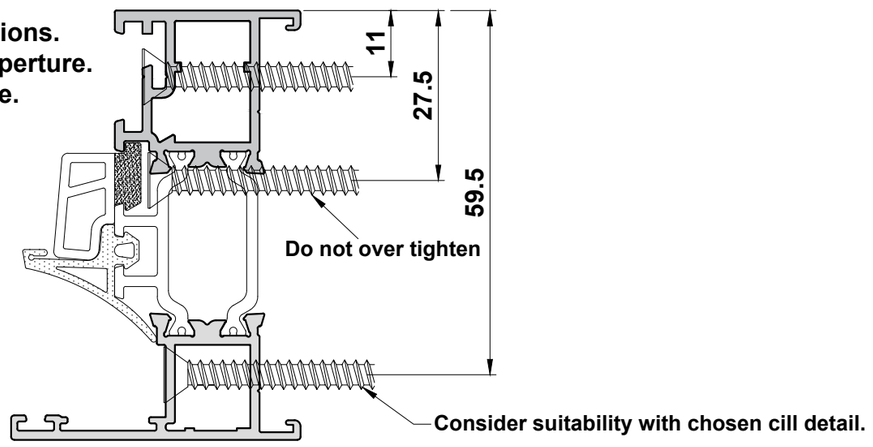


NOTE:

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



Suggested direct fixing options.
Fixings must be suitable for aperture.
Pre-drill a clearance hole.
Do not over tighten.



Do Not Scale From This Drawing

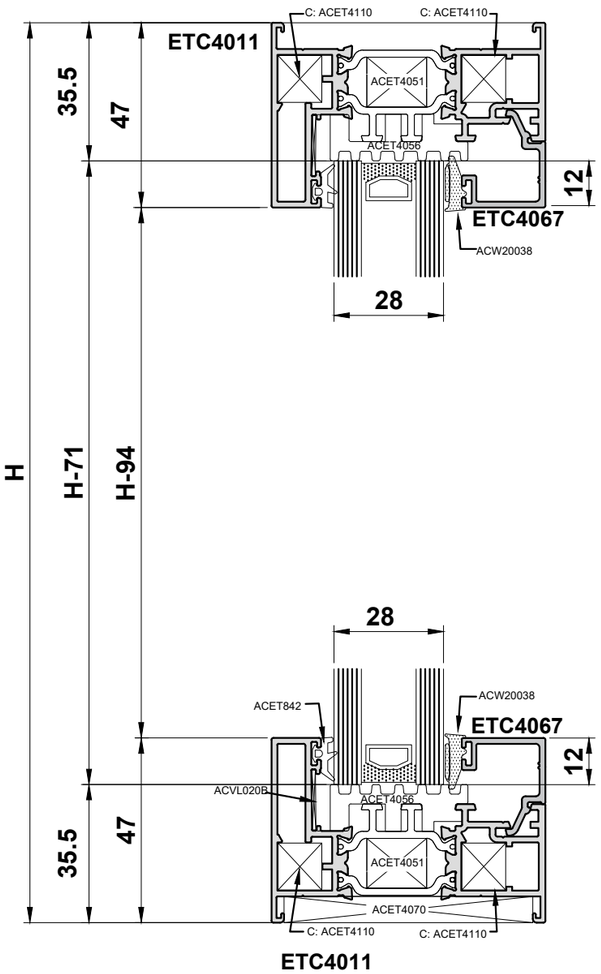
Section F

F ETC Sawing Tables

Cutting information..... F03 - F28

Section F

Cutting Information



Sections

ETC4011		2		H
ETC4011		2		W
Bead		2		W - 61
Bead		2		H - 94

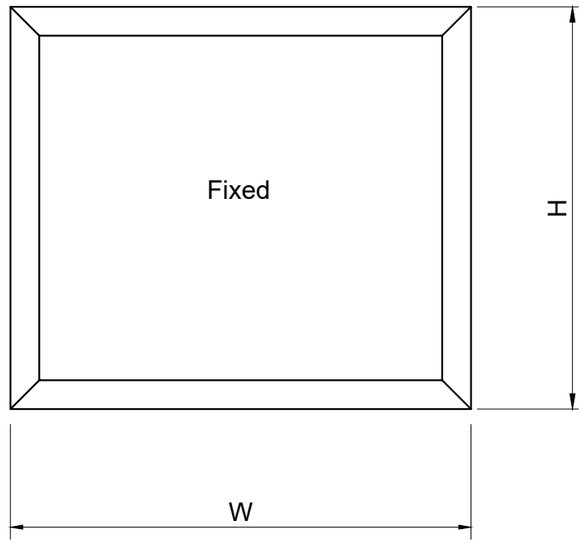
Glass
W - 71
H - 71

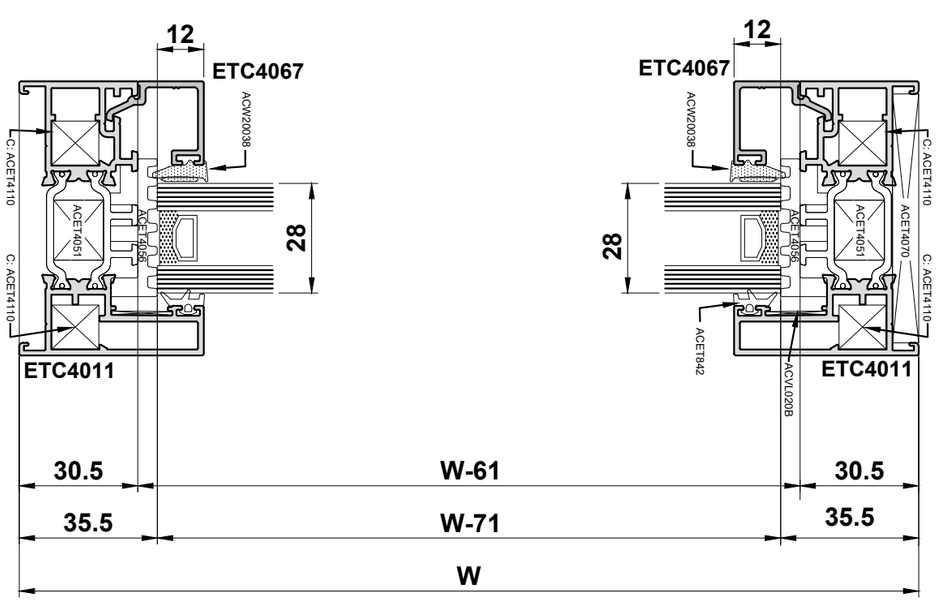
Accessories

ACVL020B	4	Chevron
ACET4110	8	Cleat Outerframe
ACET842	2(W+H)	E Gasket
ACW20038	2(W+H)	Wedge Gasket
ACGSL045	2	Drainage Cap
ACET4041	2	Bridge Packer

Foam

ACET4070	2(W+H)	Foam
ACET4051	2(W+H)	Foam
ACET4056	2(W+H)	Foam

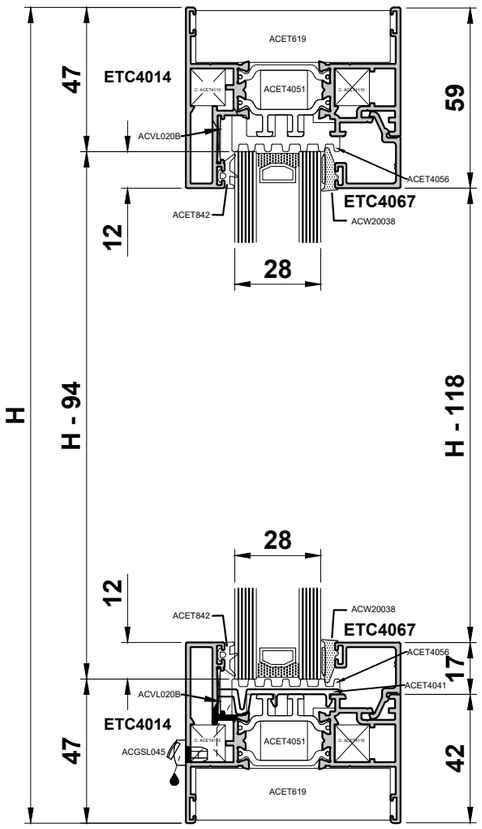




Do Not Scale From This Drawing

Alitherm 400 Tilt & Turn

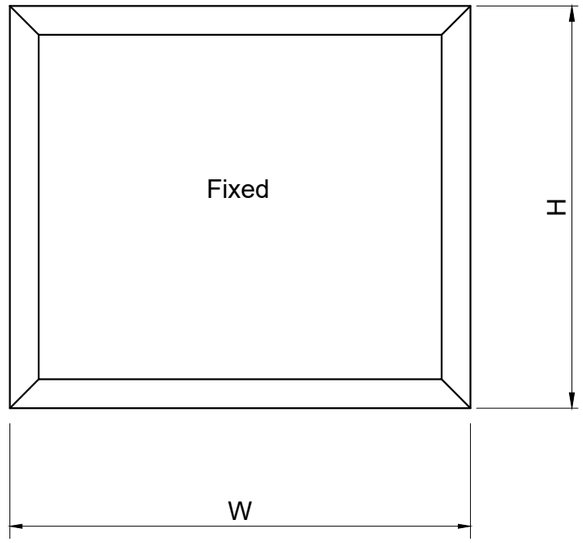
Cutting Information



Sections

ETC4014		2		H
ETC4014		2		W
Bead		2		W - 84
Bead		2		H - 118

Glass
W - 94
H - 94

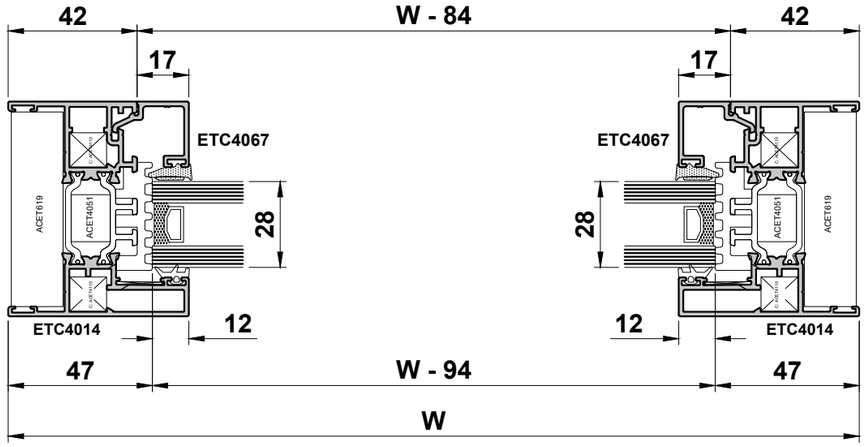


Accessories

ACVL020B	4	Chevron
ACET4110	8	Cleat Outerframe
ACET842	2(W+H)	E Gasket
ACW20038	2(W+H)	Wedge Gasket
ACGSL045	2	Drainage Cap
ACET4041	2	Bridge Packer

Foam

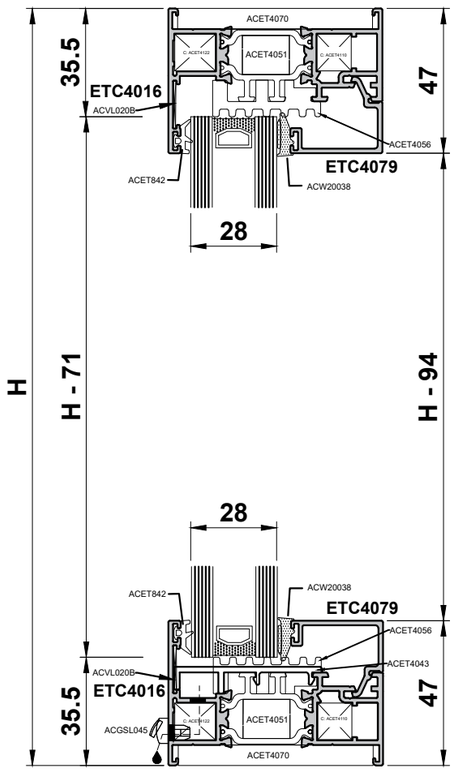
ACET619	2(W+H)	Foam
ACET4051	2(W+H)	Foam
ACET4056	2(W+H)	Foam



Do Not Scale From This Drawing

Alitherm 400 Tilt & Turn

Cutting Information



Sections

ETC4016		2		H
ETC4016		2		W
Bead		2		W - 61
Bead		2		H - 94

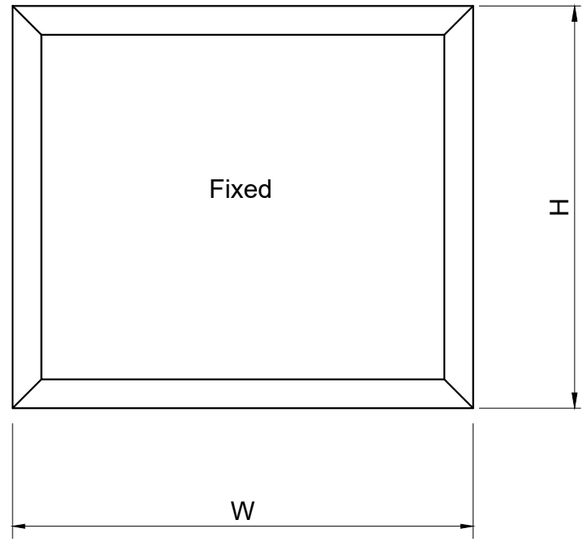
Glass
W - 71
H - 71

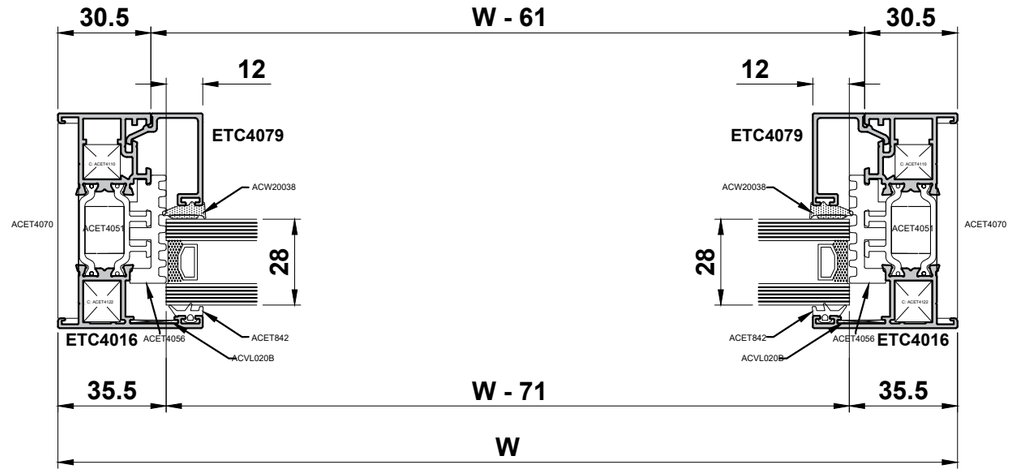
Accessories

ACVL020B	4	Chevron
ACET4110	4	Cleat Outerframe
ACET4122	4	Cleat Outerframe
ACET842	2(W+H)	E Gasket
ACW20038	2(W+H)	Wedge Gasket
ACGSL045	2	Drainage Cap
ACET4043	2	Bridge Packer

Foam

ACET4070	2(W+H)	Foam
ACET4051	2(W+H)	Foam
ACET4056	2(W+H)	Foam

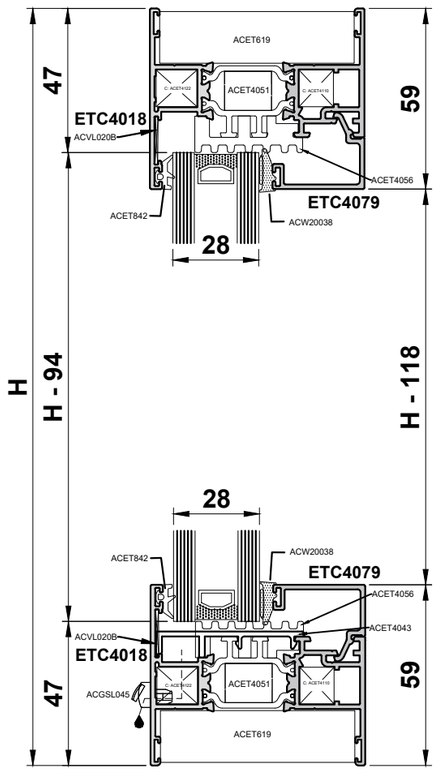




Do Not Scale From This Drawing

Alitherm 400 Tilt & Turn

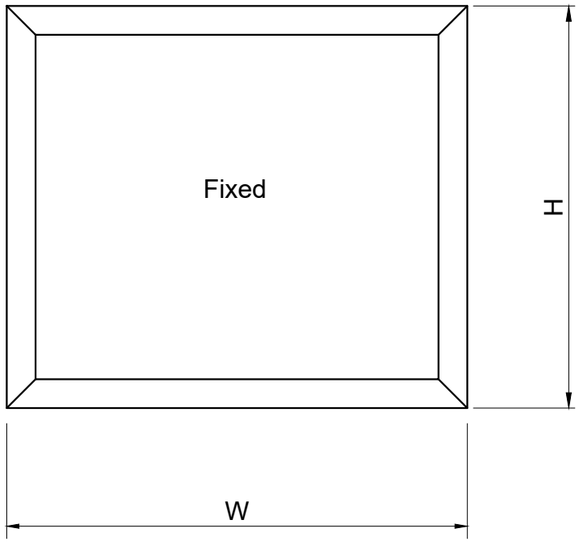
Cutting Information



Sections

ETC4018		2		H
ETC4018		2		W
Bead		2		W - 84
Bead		2		H - 118

Glass
W - 94
H - 94

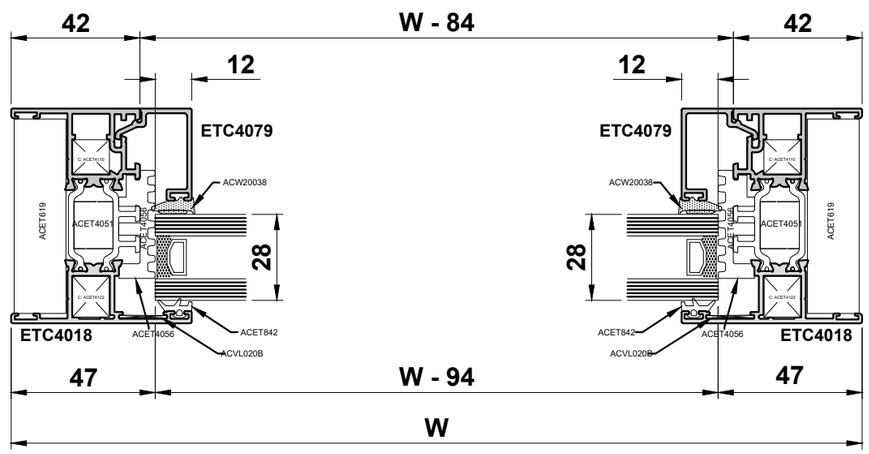


Accessories

ACVL020B	4	Chevron
ACET4110	4	Cleat Outerframe
ACET4122	4	Cleat Outerframe
ACET842	2(W+H)	E Gasket
ACW20038	2(W+H)	Wedge Gasket
ACGSL045	2	Drainage Cap
ACET4043	2	Bridge Packer

Foam

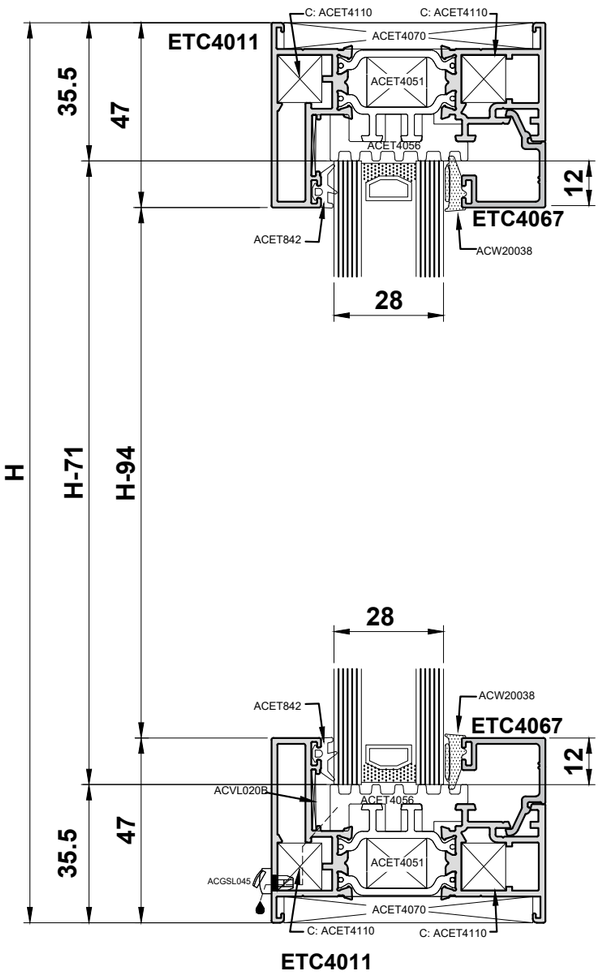
ACET619	2(W+H)	Foam
ACET4051	2(W+H)	Foam
ACET4056	2(W+H)	Foam



Do Not Scale From This Drawing

Alitherm 400 Tilt & Turn

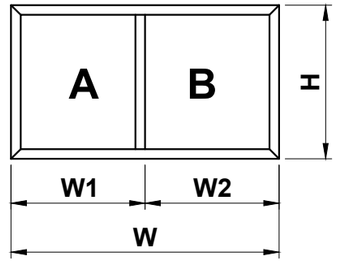
Cutting Information



Sections

ETC4011		2		H
ETC4011		2		W
ETC4031		1		H - 61
Bead		2		W1 - 44.5
Bead		2		W2 - 44.5
Bead		4		H - 94

	Glass
A	W1 - 54.5 x H-71
B	W2 - 54.5 x H-71

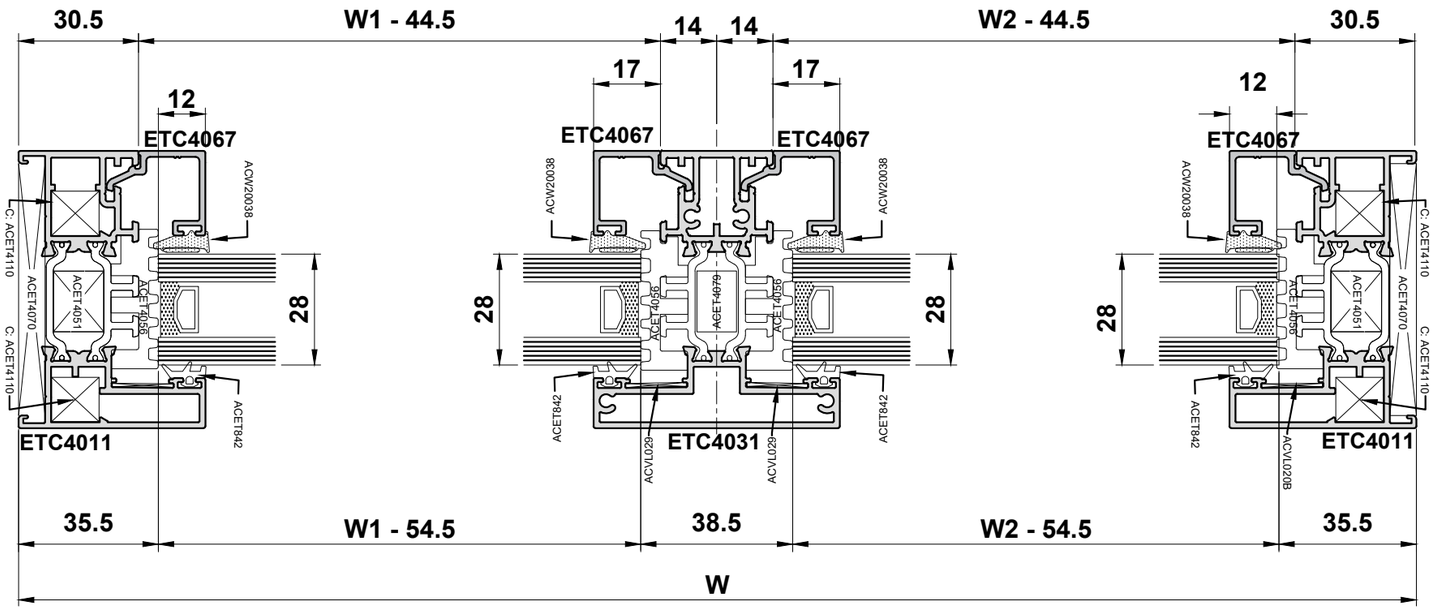


Accessories

ACVL020B	4	Chevron
ACET4110	8	Cleat Outerframe
ACVL029	4	Anti-Twist Clip
ACET066	4	Mullion Screws
ACET842	(2W)+(4H)	E Gasket
ACW20038	(2W)+(4H)	Wedge Gasket
ACGSL045	2	Drainage Cap
ACET4041	4	Bridge Packer

Foam

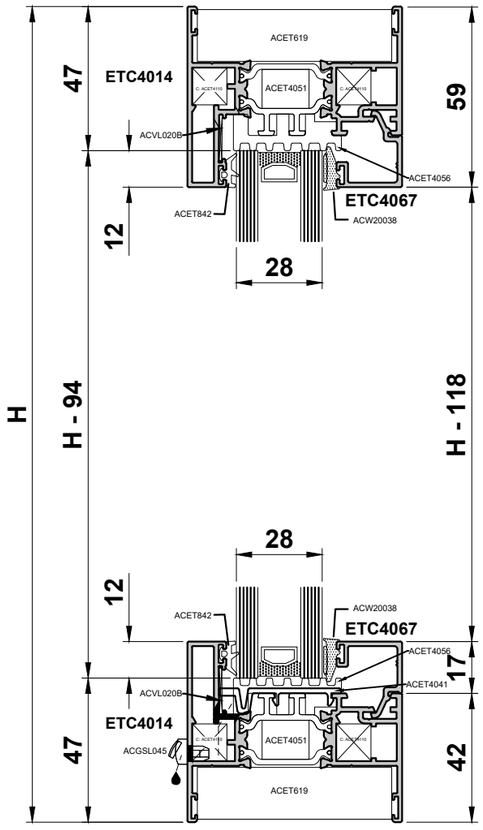
ACET4070	2(W+H)	Foam
ACET4051	2(W+H)	Foam
ACET4056	(2 x W) + (4 x H)	Foam
ACET4079	H	Foam



Do Not Scale From This Drawing

Alitherm 400 Tilt & Turn

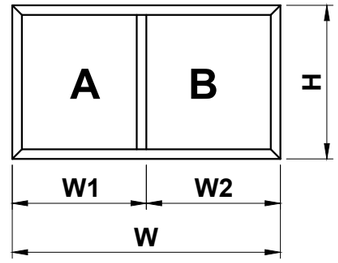
Cutting Information



Sections

ETC4014		2		H
ETC4014		2		W
ETC4031		1		H - 84
Bead		2		W1 - 56
Bead		2		W2 - 56
Bead		4		H - 118

	Glass
A	W1 - 66 x H - 94
B	W2 - 66 x H - 94

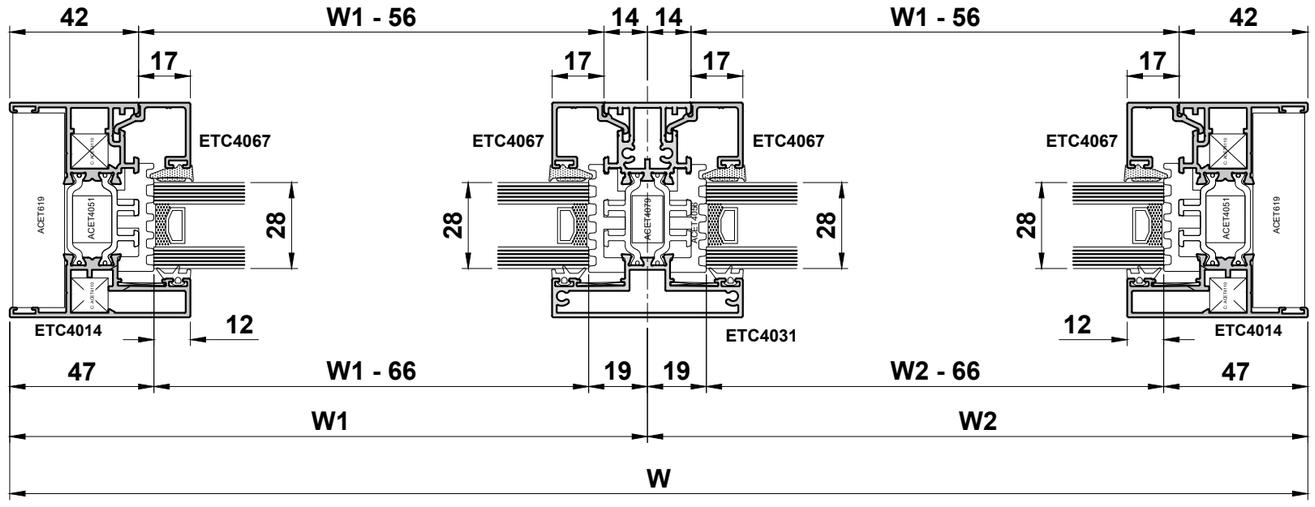


Accessories

ACVL020B	4	Chevron
ACET4110	8	Cleat Outerframe
ACVL029	4	Anti-Twist Clip
ACET066	4	Mullion Screws
ACET842	(2W)+(4H)	E Gasket
ACW20038	(2W)+(4H)	Wedge Gasket
ACGSL045	2	Drainage Cap
ACET4041	4	Bridge Packer

Foam

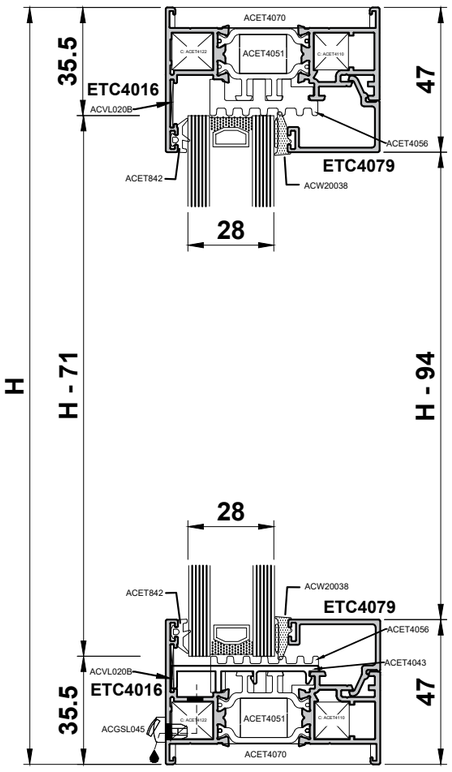
ACET619	2(W+H)	Foam
ACET4051	2(W+H)	Foam
ACET4056	(2 x W) + (4 x H)	Foam
ACET4079	H	Foam



Do Not Scale From This Drawing

Alitherm 400 Tilt & Turn

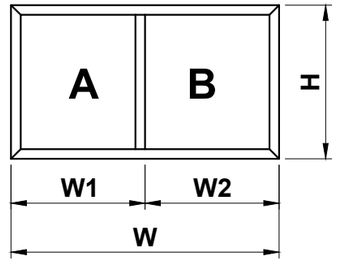
Cutting Information



Sections

ETC4016		2		H
ETC4016		2		W
ETC4036		1		H - 61
Bead		2		W1 - 44.5
Bead		2		W2 - 44.5
Bead		4		H - 94

	Glass
A	W1 - 54.5 x H-71
B	W2 - 54.5 x H-71

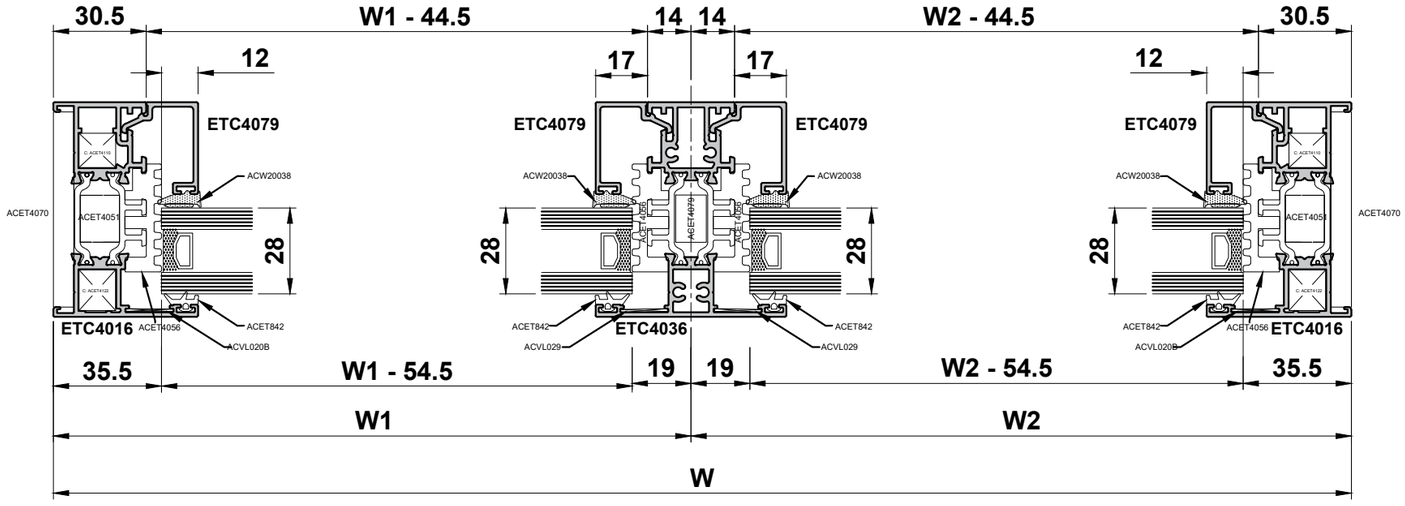


Accessories

ACVL020B	4	Chevron
ACET4110	4	Cleat Outerframe
ACET4122	4	Cleat Outerframe
ACVL029	4	Anti-Twist Clip
ACET066	4	Mullion Screws
ACET842	(2W)+(4H)	E Gasket
ACW20038	(2W)+(4H)	Wedge Gasket
ACGSL045	2	Drainage Cap
ACET4043	4	Bridge Packer

Foam

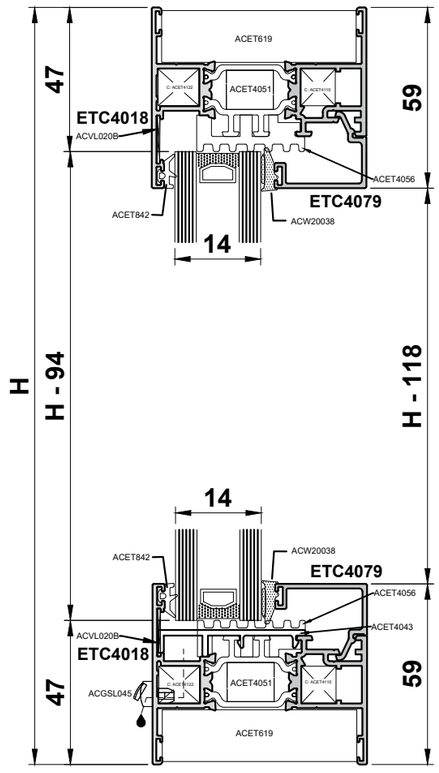
ACET4070	2(W+H)	Foam
ACET4051	2(W+H)	Foam
ACET4056	(2 x W) + (4 x H)	Foam
ACET4079	H	Foam



Do Not Scale From This Drawing

Alitherm 400 Tilt & Turn

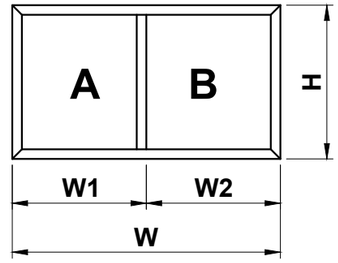
Cutting Information



Sections

ETC4018		2		H
ETC4018		2		W
ETC4036		1		H - 84
Bead		2		W1 - 56
Bead		2		W2 - 56
Bead		4		H - 118

	Glass
A	W1 - 66 x H - 94
B	W2 - 66 x H - 94

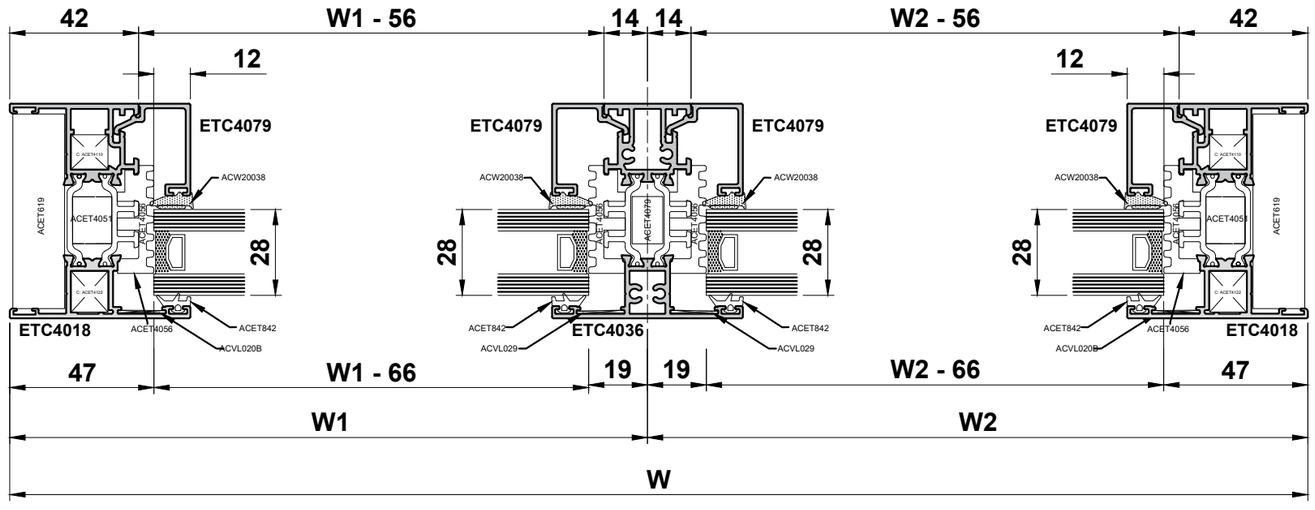


Accessories

ACVL020B	4	Chevron
ACET4110	4	Cleat Outerframe
ACET4122	4	Cleat Outerframe
ACVL029	4	Anti-Twist Clip
ACET066	4	Mullion Screws
ACET842	(2W)+(4H)	E Gasket
ACW20038	(2W)+(4H)	Wedge Gasket
ACGSL045	2	Drainage Cap
ACET4043	4	Bridge Packer

Foam

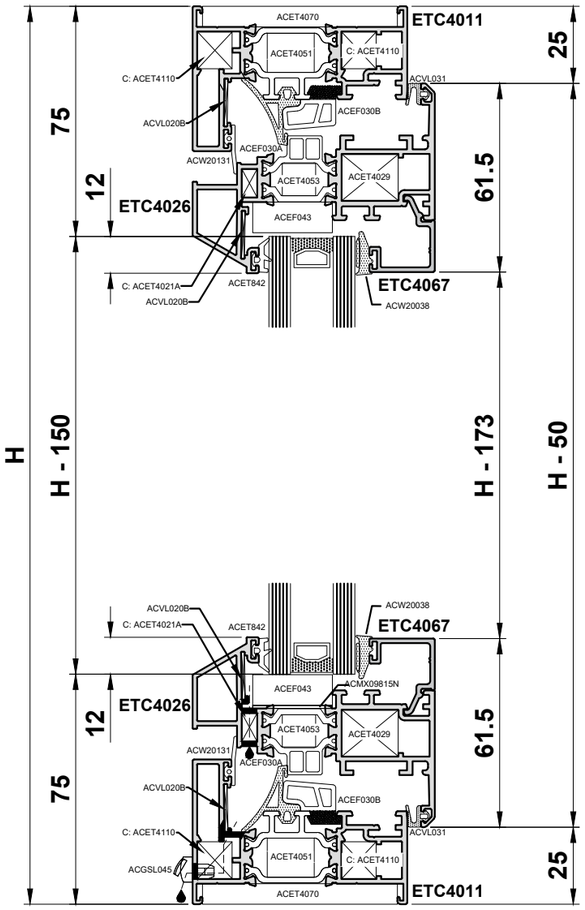
ACET619	2(W+H)	Foam
ACET4051	2(W+H)	Foam
ACET4056	(2 x W) + (4 x H)	Foam
ACET4079	H	Foam



Do Not Scale From This Drawing

Alitherm 400 Tilt & Turn

Cutting Information



Sections

ETC4011		2		H
ETC4011		2		W
ETC4026		2		H - 50
ETC4026		2		W - 50
Bead		2		W - 139
Bead		2		H - 173

Glass
W - 150
H - 150

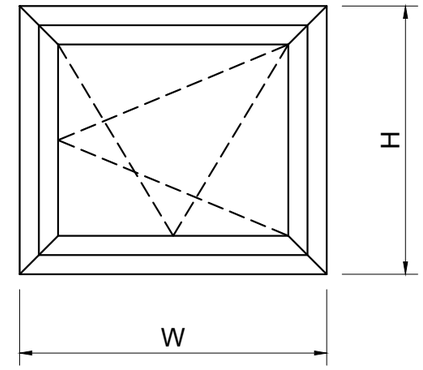
Accessories

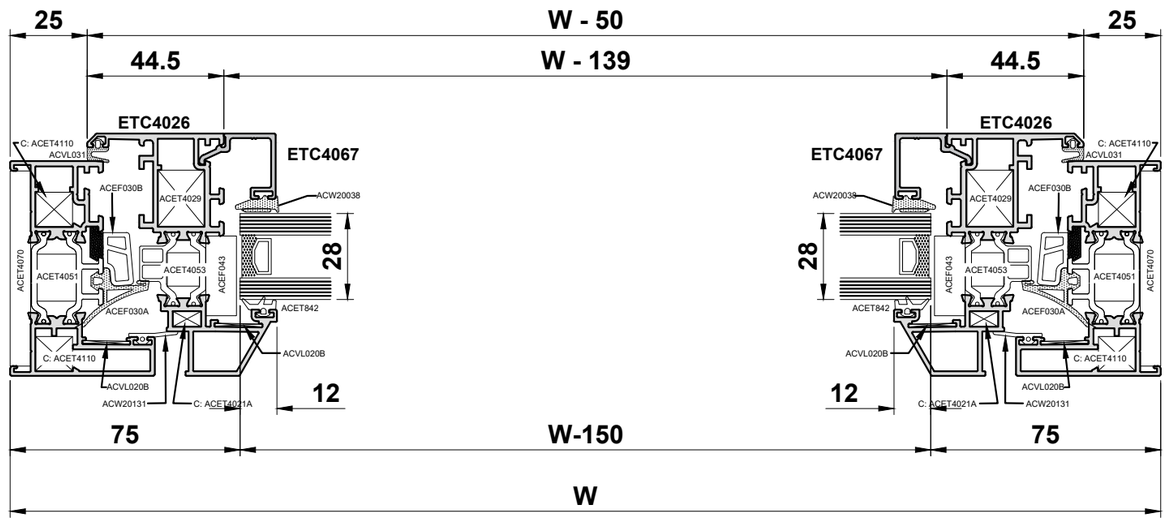
ACVL020B	4	Chevron (sash)
ACVL020B	4	Chevron (frame)
ACET4110	8	Frame Cleat
ACET4029	4	Sash Cleat (inner)
ACET4021A	4	Sash Cleat (outer)
ACW20131	2(W+H)	External Flat Gasket (frame)
ACEF030A	2(W+H)	Centre Gasket (frame)
ACEF030B	2(W+H)	Centre Gasket (frame)
ACEF031B	4	Centre Gasket Corner (frame)
ACVL031	2(W+H)	Flipper Gasket (sash)
ACET842	2(W+H)	Gasket E
ACW20038	2(W+H)	Wedge Gasket
ACGSL045	2	Drainage Cap

Please refer to the SB Chrono or Fapim manual for tilt & turn hardware

Foam

ACEF043 + ACMX09815N	2(W+H)	Foam (sash)
ACET4070	2(W+H)	Foam (frame)
ACET4051	2(W+H)	Foam (frame)
ACET4053	2(W+H)	Foam (sash)

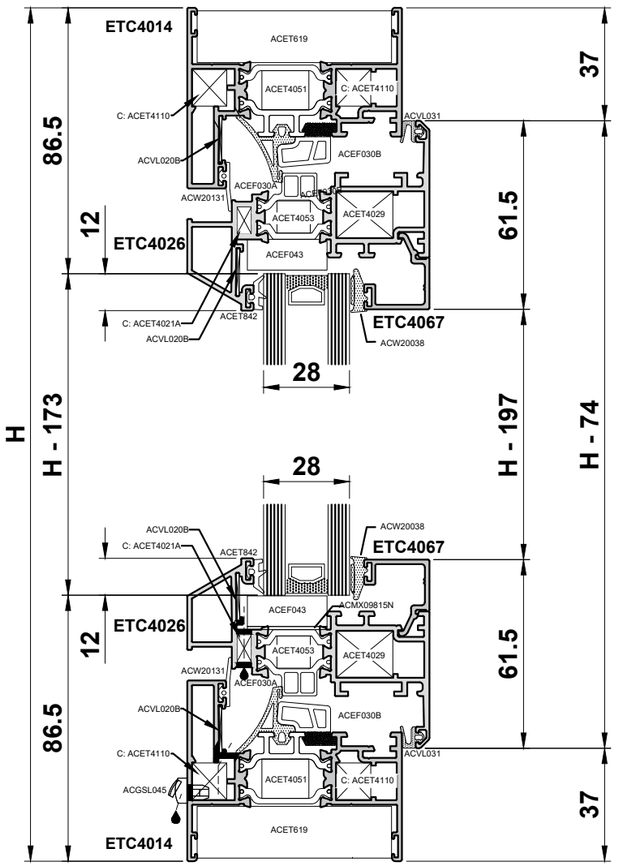




Do Not Scale From This Drawing

Alitherm 400 Tilt & Turn

Cutting Information



Sections

ETC4014		2		H
ETC4014		2		W
ETC4026		2		H - 74
ETC4026		2		W - 74
Bead		2		W - 163
Bead		2		H - 197

Glass
W - 173
H - 173

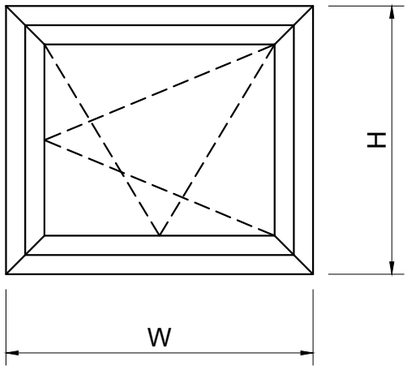
Accessories

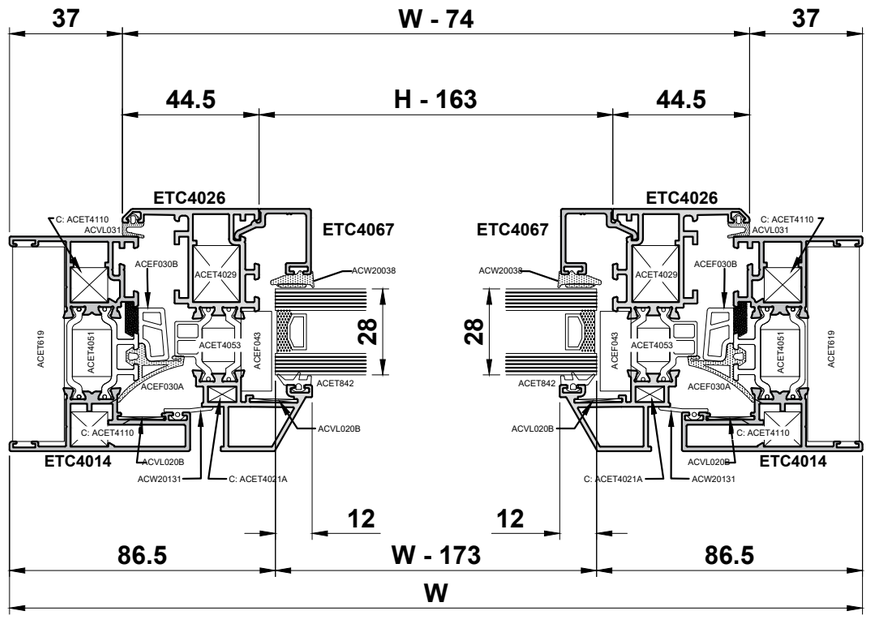
ACVL020B	4	Chevron (sash)
ACVL020B	4	Chevron (frame)
ACET4110	8	Frame Cleat
ACET4029	4	Sash Cleat (outer)
ACET4021A	4	Sash Cleat (inner)
ACW20131	2(W+H)	External Flat Gasket (frame)
ACEF030A	2(W+H)	Centre Gasket (frame)
ACEF030B	2(W+H)	Centre Gasket (frame)
ACEF031B	4	Centre Gasket Corner (frame)
ACVL031	2(W+H)	Flipper Gasket (sash)
ACET842	2(W+H)	Gasket E
ACW20038	2(W+H)	Wedge Gasket
ACGSL045	2	Drainage Cap

Please refer to the SB Chrono or Fapim manual for tilt & turn hardware

Foam

ACEF043 + ACMX09815N	2(W+H)	Foam (sash)
ACET619	2(W+H)	Foam (frame)
ACET4051	2(W+H)	Foam (frame)
ACET4053	2(W+H)	Foam (sash)

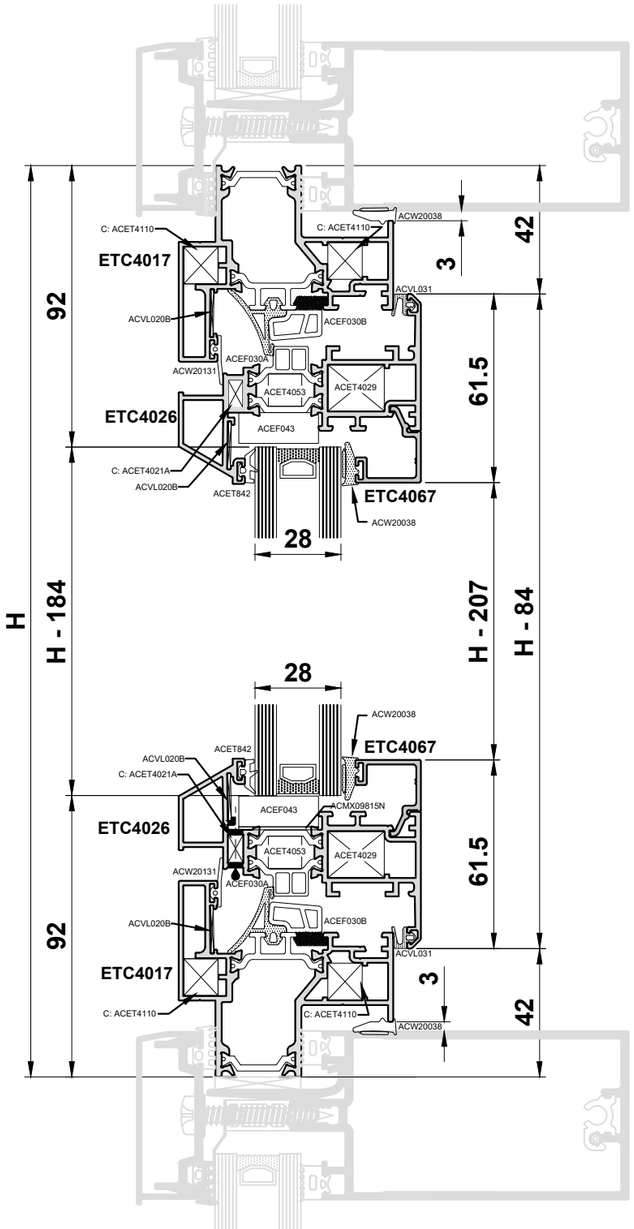




Do Not Scale From This Drawing

Alitherm 400 Tilt & Turn

Cutting Information



Sections

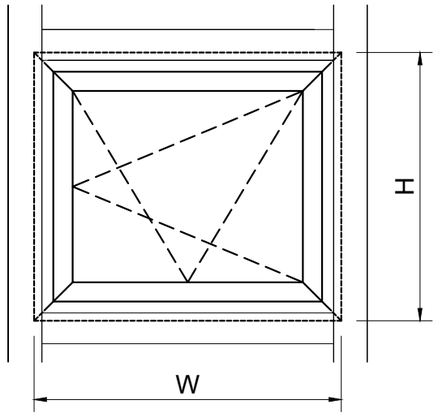
ETC4017		2		H
ETC4017		2		W
ETC4026		2		H - 84
ETC4026		2		W - 84
Bead		2		W - 173
Bead		2		H - 207

Glass
W - 184
H - 184

Accessories

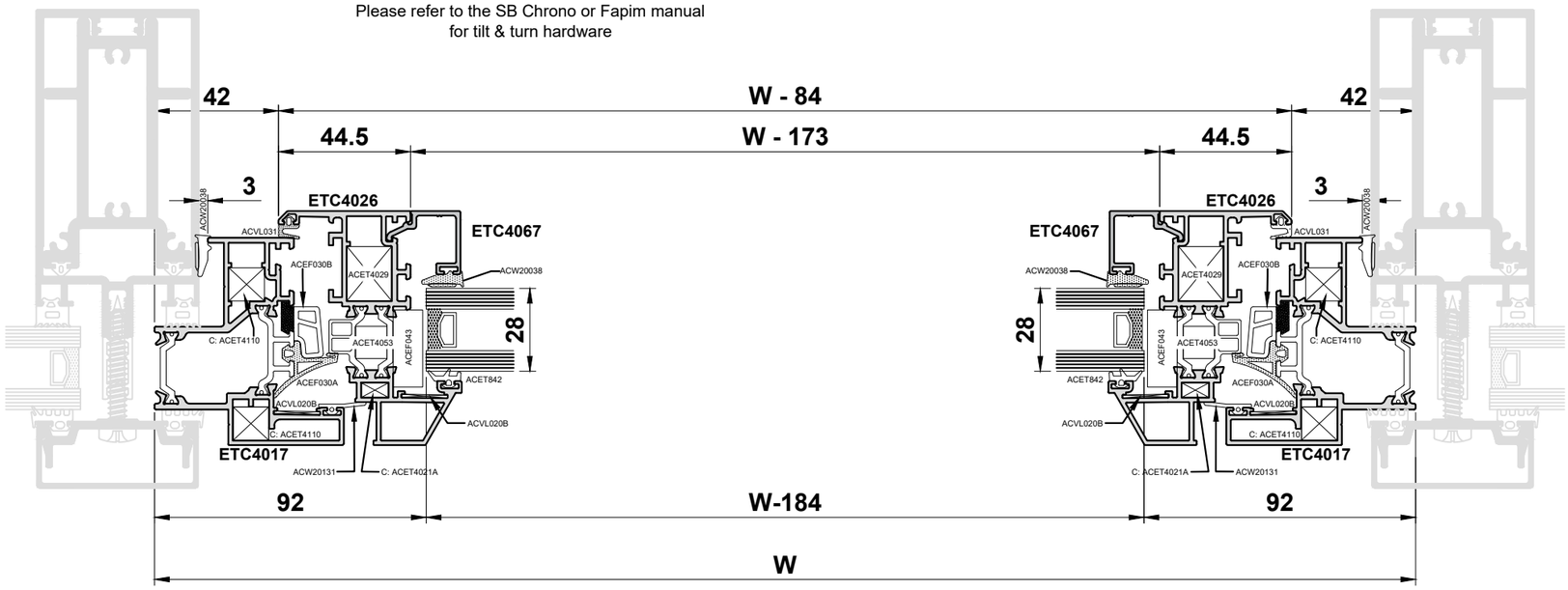
ACVL020B	4	Chevron (sash)
ACVL020B	4	Chevron (frame)
ACET4110	8	Frame Cleat
ACET4021A	4	Sash Cleat (outer)
ACET4029	4	Sash Cleat (inner)
ACW20131	2(W+H)	External Flat Gasket (frame)
ACEF030A	2(W+H)	Centre Gasket (frame)
ACEF030B	2(W+H)	Centre Gasket (frame)
ACEF031B	4	Centre Gasket Corner (frame)
ACVL031	2(W+H)	Flipper Gasket (sash)
ACET842	2(W+H)	Gasket E
ACW20038	4(W+H)	Wedge Gasket
ACGSL045	2	Drainage Cap

Please refer to the SB Chrono or Fapim manual for tilt & turn hardware



Foam

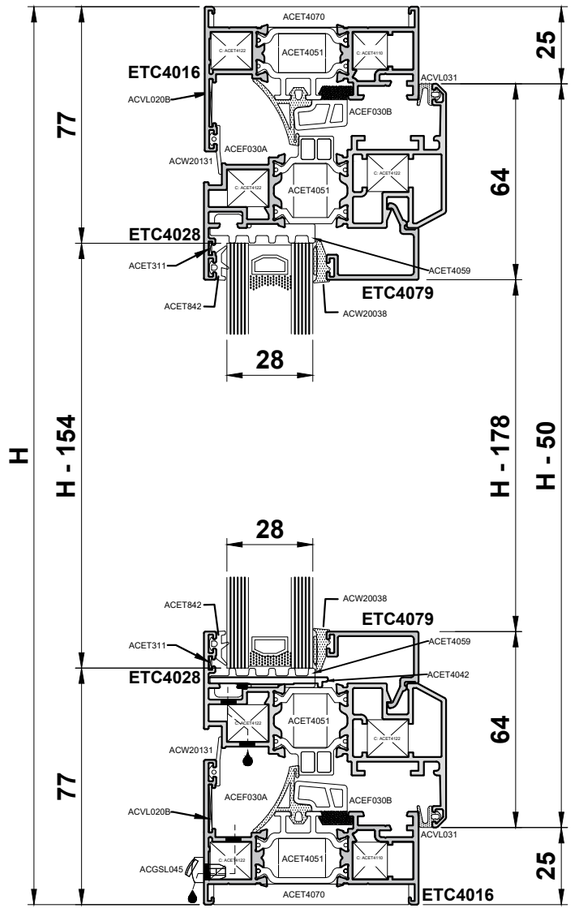
ACEF043 + ACMX09815N	2(W+H)	Foam (sash)
ACET4053	2(W+H)	Foam (sash)



Do Not Scale From This Drawing

Alitherm 400 Tilt & Turn

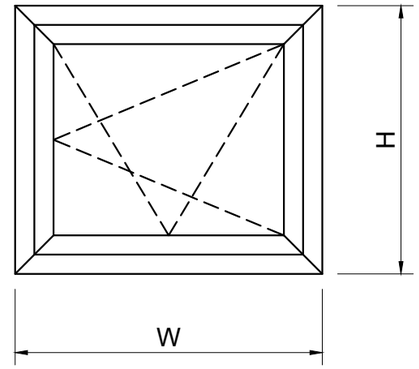
Cutting Information



Sections

ETC4016		2		H
ETC4016		2		W
ETC4028		2		H - 50
ETC4028		2		W - 50
Bead		2		W - 144
Bead		2		H - 178

Glass
W - 154
H - 154



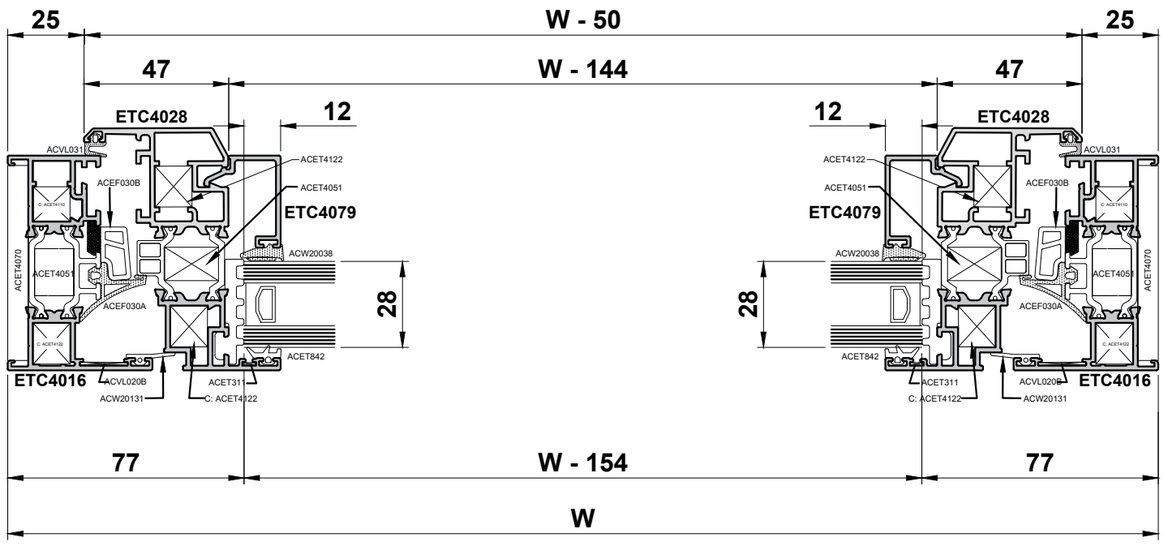
Accessories

ACET311	4	Chevron (sash)
ACVL020B	4	Chevron (frame)
ACET4110	4	Frame Cleat (Inner)
ACET4122	4	Frame Cleat (Outer)
ACET4122	8	Sash Cleat
ACW20131	2(W+H)	External Flat Gasket (frame)
ACEF030A	2(W+H)	Centre Gasket (frame)
ACEF030B	2(W+H)	Centre Gasket (frame)
ACEF031B	4	Centre Gasket Corner (frame)
ACVL031	2(W+H)	Flipper Gasket (sash)
ACET4042	6	Bridge Packer
ACET842	2(W+H)	Gasket E
ACW20038	2(W+H)	Wedge Gasket
ACGSL045	2	Drainage Cap

Please refer to the SB Chrono or Fapim manual for tilt & turn hardware

Foam

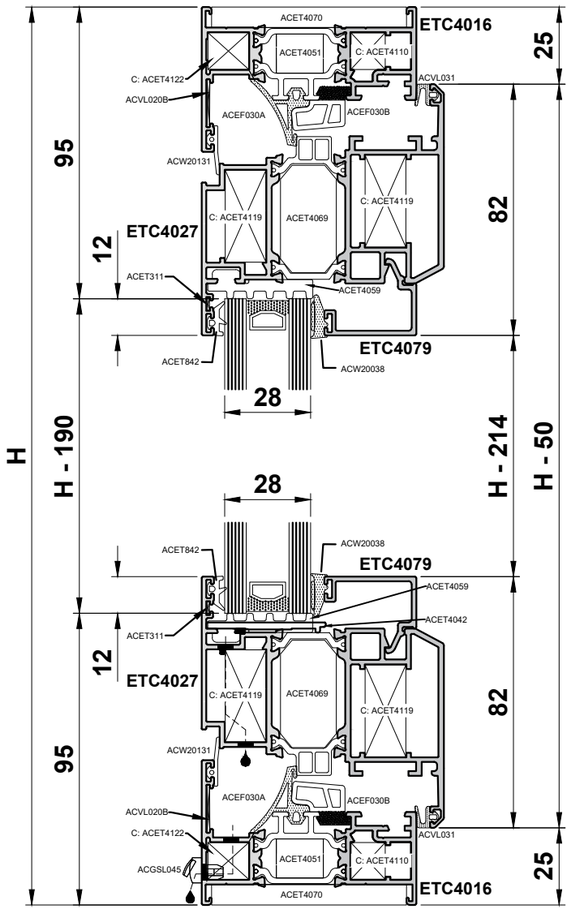
ACET4070	2(W+H)	Foam (frame)
ACET4051	2(W+H)	Foam (frame)
ACET4051	2(W+H)	Foam (sash)
ACET4059	2(W+H)	Foam (sash)



Do Not Scale From This Drawing

Alitherm 400 Tilt & Turn

Cutting Information



Sections

ETC4016		2		H
ETC4016		2		W
ETC4027		2		H - 50
ETC4027		2		W - 50
Bead		2		W - 180
Bead		2		H - 214

Glass
W - 190
H - 190

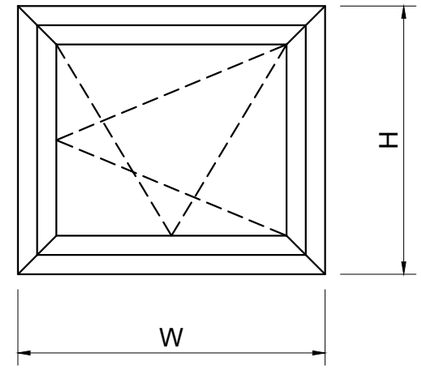
Accessories

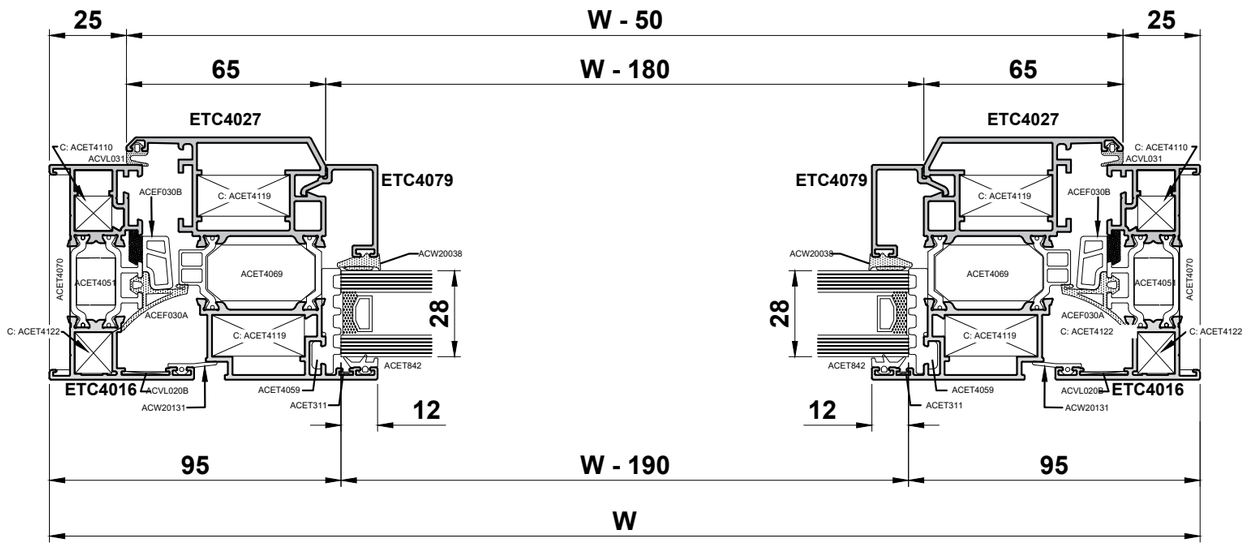
ACET311	4	Chevron (sash)
ACVL020B	4	Chevron (frame)
ACET4110	4	Frame Cleat (Inner)
ACET4122	4	Frame Cleat (Outer)
ACET4119	8	Sash Cleat
ACW20131	2(W+H)	External Flat Gasket (frame)
ACEF030A	2(W+H)	Centre Gasket (frame)
ACEF030B	2(W+H)	Centre Gasket (frame)
ACEF031B	4	Centre Gasket Corner (frame)
ACVL031	2(W+H)	Flipper Gasket (sash)
ACET4042	6	Bridge Packer
ACET842	2(W+H)	Gasket E
ACW20038	2(W+H)	Wedge Gasket
ACGSL045	2	Drainage Cap

Please refer to the SB Chrono or Fapim manual for tilt & turn hardware

Foam

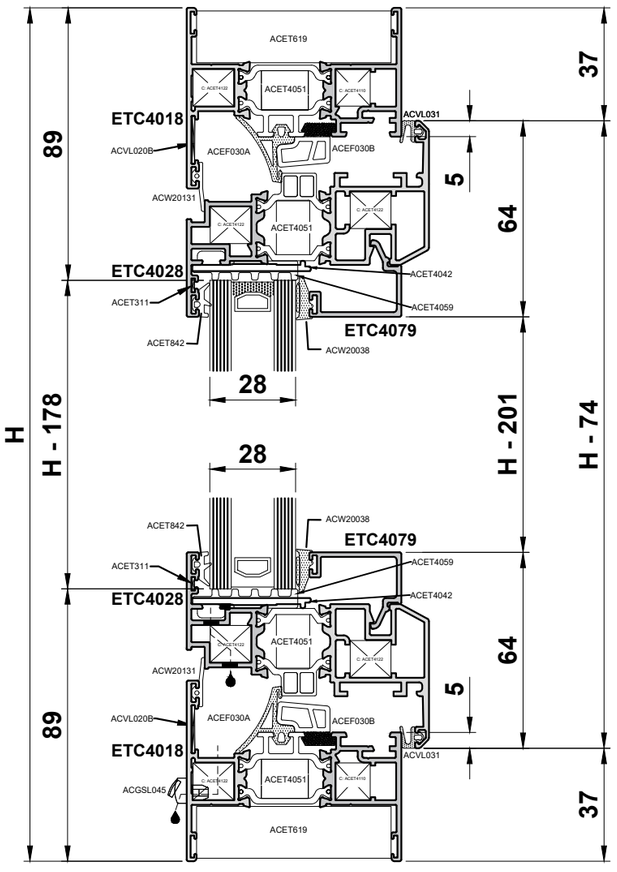
ACET4070	2(W+H)	Foam (frame)
ACET4051	2(W+H)	Foam (frame)
ACET4069	2(W+H)	Foam (sash)
ACET4059	2(W+H)	Foam (sash)





Do Not Scale From This Drawing

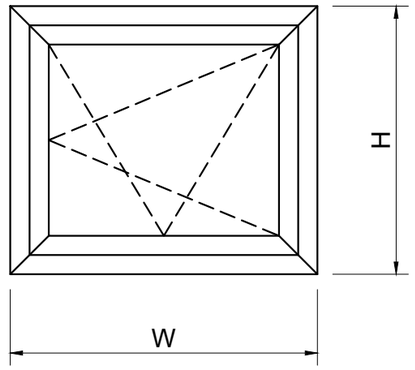
Cutting Information



Sections

ETC4018		2		H
ETC4018		2		W
ETC4028		2		H - 74
ETC4028		2		W - 74
Bead		2		W - 168
Bead		2		H - 201

Glass
W - 178
H - 178



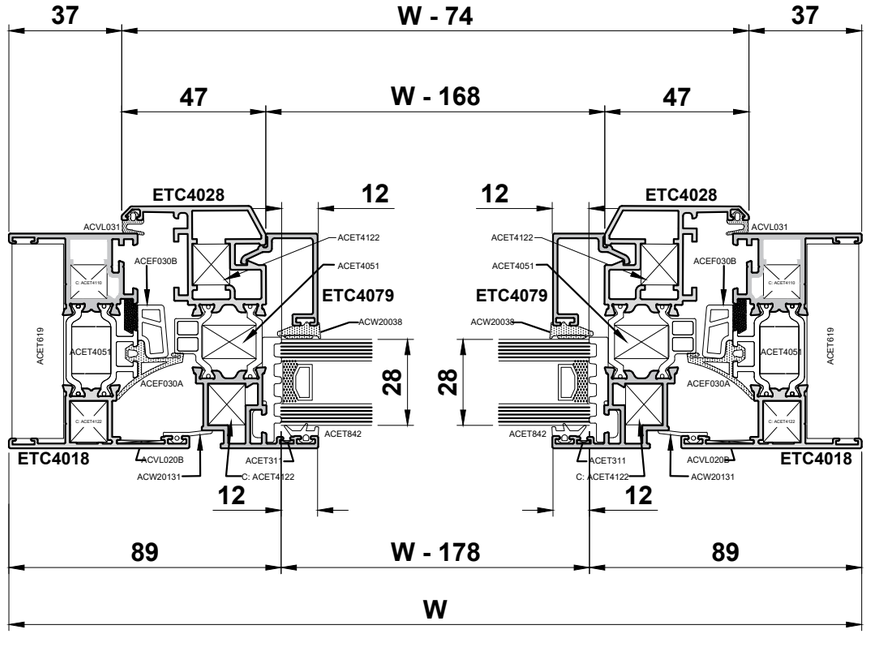
Accessories

ACET311	4	Chevron (sash)
ACVL020B	4	Chevron (frame)
ACET4110	4	Frame Cleat (Inner)
ACET4122	4	Frame Cleat (Outer)
ACET4122	8	Sash Cleat
ACW20131	2(W+H)	External Flat Gasket (frame)
ACEF030A	2(W+H)	Centre Gasket (frame)
ACEF030B	2(W+H)	Centre Gasket (frame)
ACEF031B	4	Centre Gasket Corner (frame)
ACVL031	2(W+H)	Flipper Gasket (sash)
ACET4042	6	Bridge Packer
ACET842	2(W+H)	Gasket E
ACW20038	2(W+H)	Wedge Gasket
ACGSL045	2	Drainage Cap

Please refer to the SB Chrono or Fapim manual for tilt & turn hardware

Foam

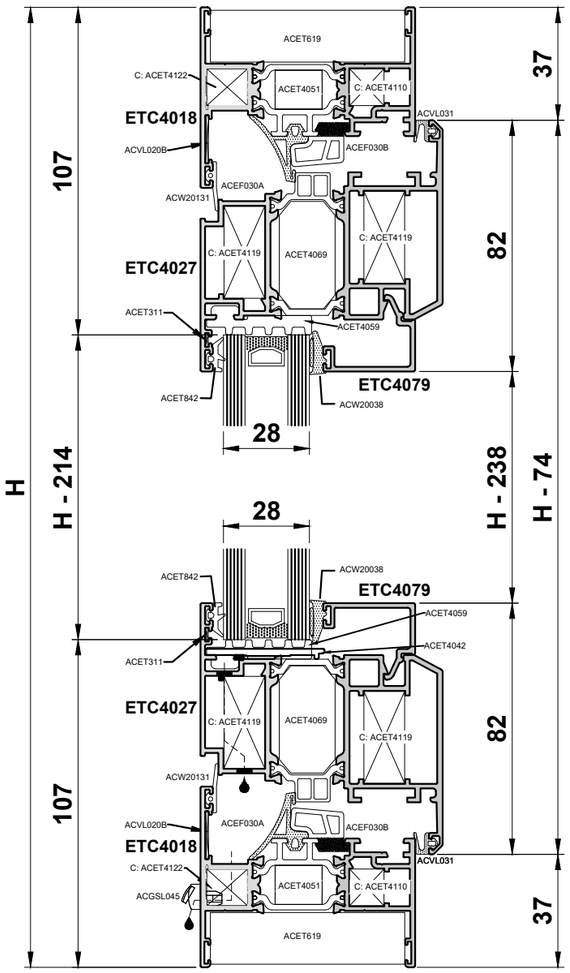
ACET619	2(W+H)	Foam (frame)
ACET4051	2(W+H)	Foam (frame)
ACET4051	2(W+H)	Foam (sash)
ACET4059	2(W+H)	Foam (sash)



Do Not Scale From This Drawing

Alitherm 400 Tilt & Turn

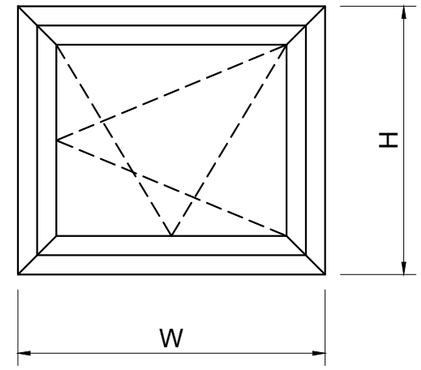
Cutting Information



Sections

ETC4018		2		H
ETC4018		2		W
ETC4027		2		H - 74
ETC4027		2		W - 74
Bead		2		W - 204
Bead		2		H - 214

Glass
W - 214
H - 214



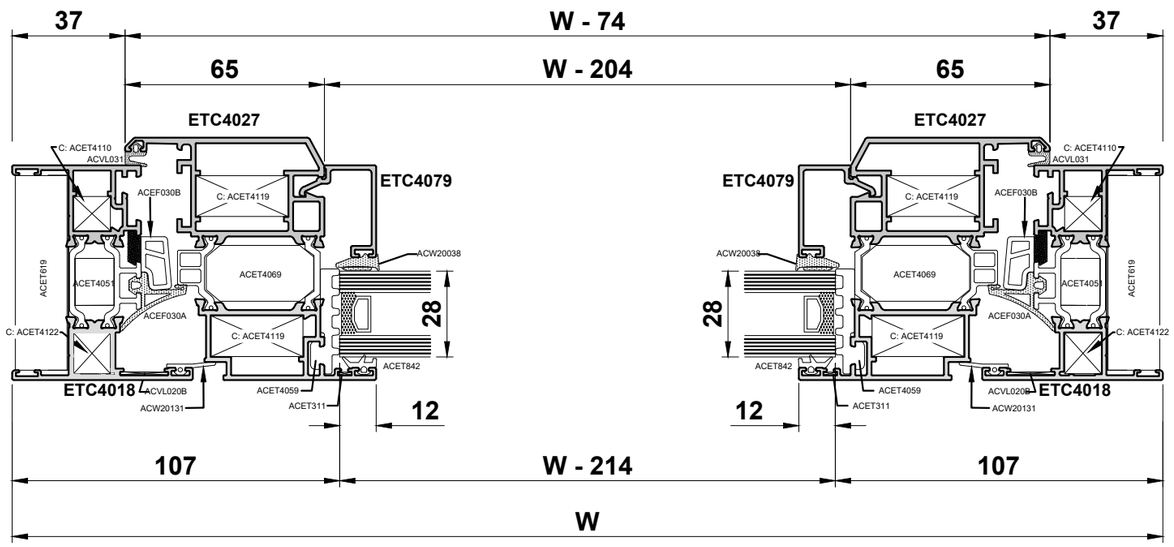
Accessories

ACET311	4	Chevron (sash)
ACVL020B	4	Chevron (frame)
ACET4110	4	Frame Cleat (Inner)
ACET4122	4	Frame Cleat (Outer)
ACET4119	8	Sash Cleat
ACW20131	2(W+H)	External Flat Gasket (frame)
ACEF030A	2(W+H)	Centre Gasket (frame)
ACEF030B	2(W+H)	Centre Gasket (frame)
ACEF031B	4	Centre Gasket Corner (frame)
ACVL031	2(W+H)	Flipper Gasket (sash)
ACET4042	6	Bridge Packer
ACET842	2(W+H)	Gasket E
ACW20038	2(W+H)	Wedge Gasket
ACGSL045	2	Drainage Cap

Please refer to the SB Chrono or Fapim manual for tilt & turn hardware

Foam

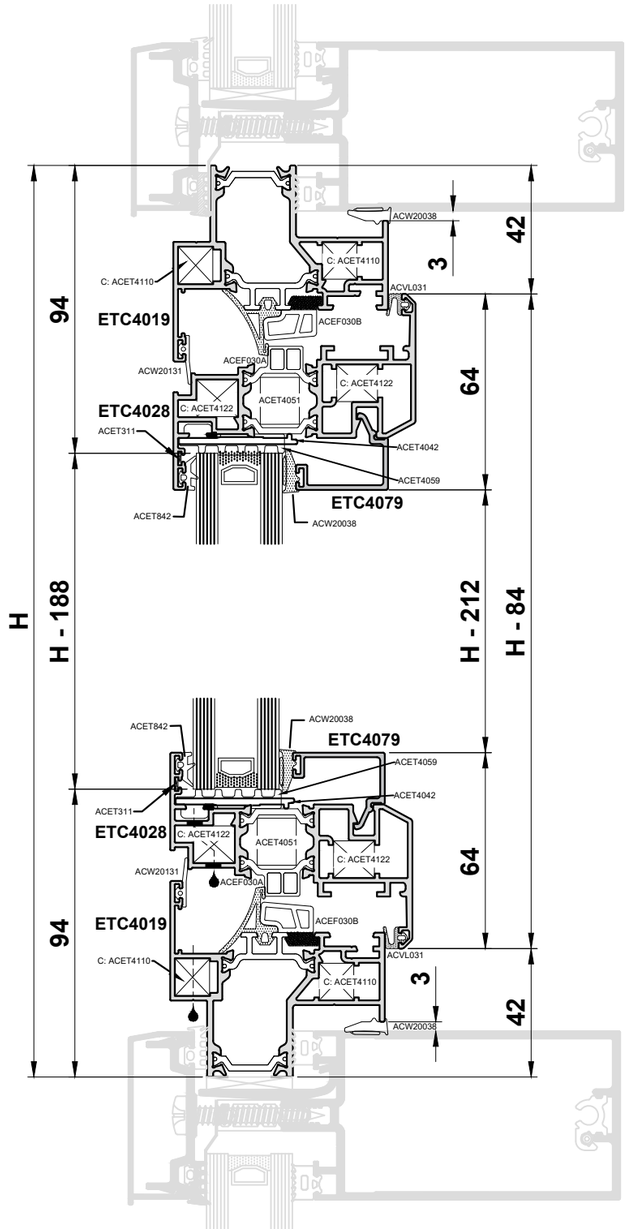
ACET619	2(W+H)	Foam (frame)
ACET4051	2(W+H)	Foam (frame)
ACET4059	2(W+H)	Foam (sash)
ACET4069	2(W+H)	Foam (sash)



Do Not Scale From This Drawing

Alitherm 400 Tilt & Turn

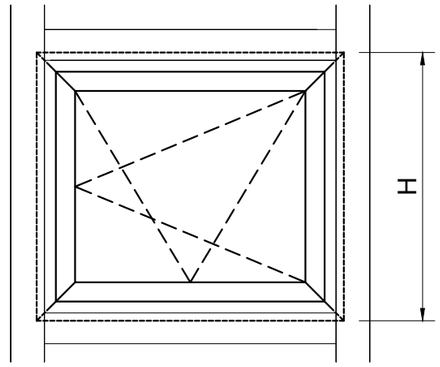
Cutting Information



Sections

ETC4019		2		H
ETC4019		2		W
ETC4027		2		H - 84
ETC4027		2		W - 84
Bead		2		W - 178
Bead		2		H - 212

Glass
W - 188
H - 188



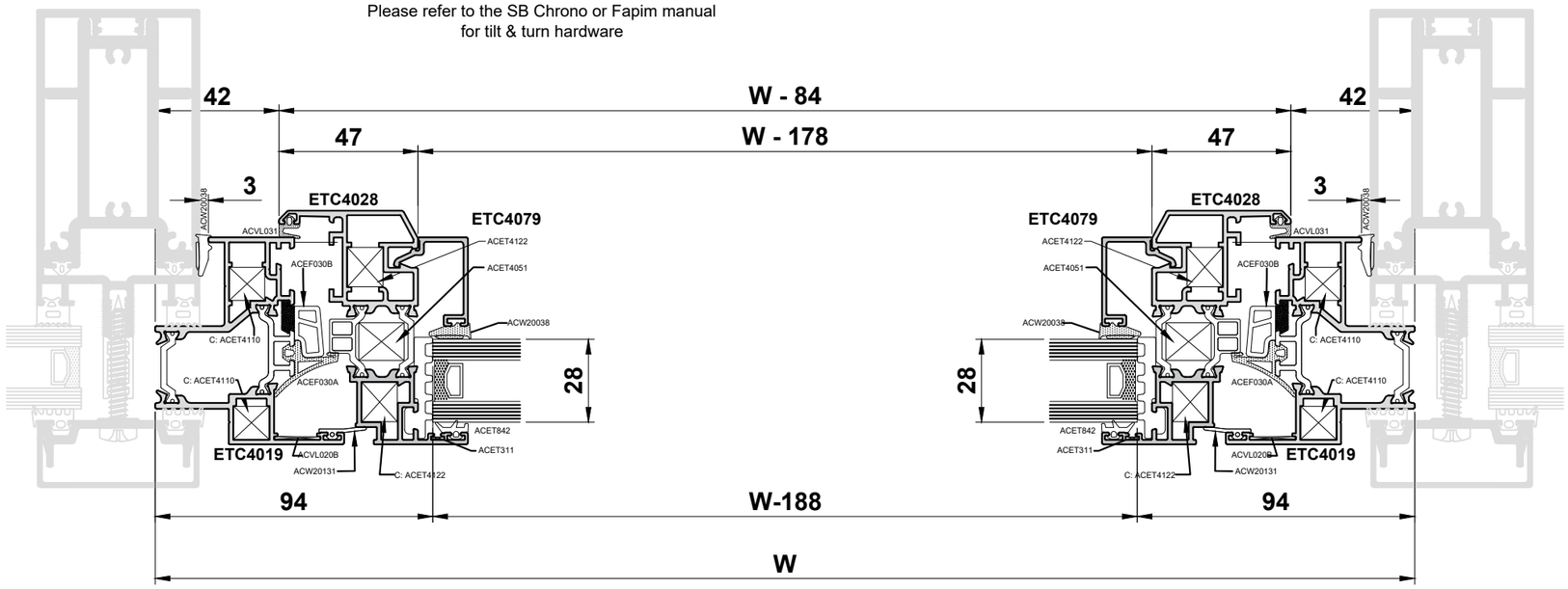
Accessories

ACET311	4	Chevron (sash)
ACVL020B	4	Chevron (frame)
ACET4110	8	Frame Cleat
ACET4122	8	Sash Cleat (outer)
ACW20131	2(W+H)	External Flat Gasket (frame)
ACEF030A	2(W+H)	Centre Gasket (frame)
ACEF030B	2(W+H)	Centre Gasket (frame)
ACEF031B	4	Centre Gasket Corner (frame)
ACVL031	2(W+H)	Flipper Gasket (sash)
ACET4042	6	Bridge Packer
ACET842	2(W+H)	Gasket E
ACW20038	4(W+H)	Wedge Gasket
ACGSL045	2	Drainage Cap

Please refer to the SB Chrono or Fapim manual for tilt & turn hardware

Foam

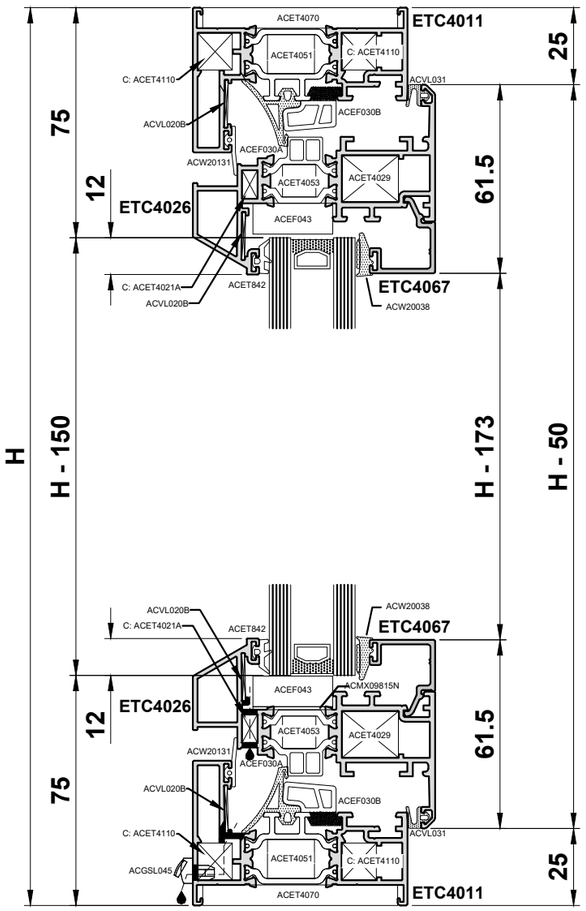
ACET4051	2(W+H)	Foam (sash)
ACET4059	2(W+H)	Foam (sash)



Do Not Scale From This Drawing

Alitherm 400 Tilt & Turn

Cutting Information



Sections

ETC4011		2		H
ETC4011		2		W
ETC4026		2		H - 50
ETC4026		2		W1 - 34
ETC4031		1		H - 61
Bead		2		W1 - 123
Bead		2		H - 173
Bead		2		W2 - 44.5
Bead		2		H - 94

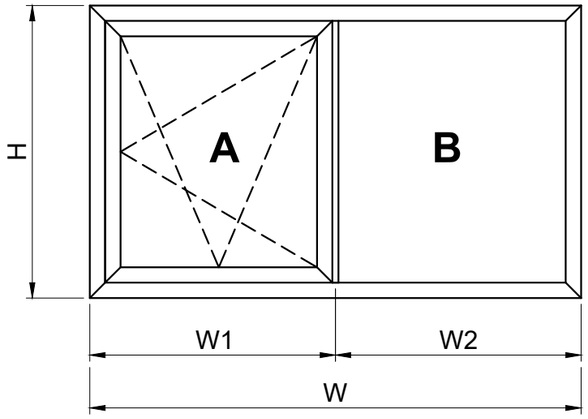
Foam

ACEF043 + ACMX09815N	(2 x W1) + (2 x H)	Foam (sash)
ACET4070	2(W+H)	Foam (frame)
ACET4051	2(W+H)	Foam (frame)
ACET4053	(2 x W1) + (2 x H)	Foam (sash)
ACET4056	(2 x W2) + (2 x H)	Foam (frame)
ACET4079	H	Foam (mullion)

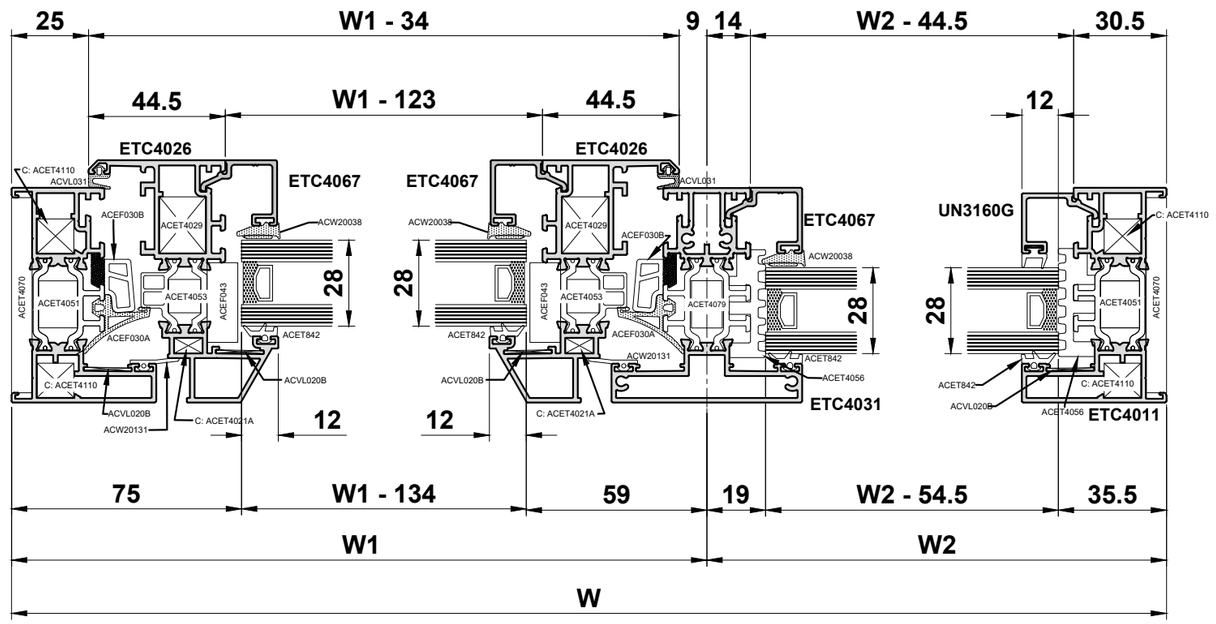
Accessories

ACVL020B	4	Chevron (sash)
ACVL020B	4	Chevron (frame)
ACET4110	8	Frame Cleat
ACET4029	4	Sash Cleat (outer)
ACET4021A	4	Sash Cleat (inner)
ACVL029	4	Anti-Twist Clip (mullion)
ACET066	4	Mullion Screws
ACW20131	2(W1+H)	External Flat Gasket (frame A)
ACEF030A	2(W1+H)	Centre Gasket (frame A)
ACEF030B	2(W1+H)	Centre Gasket (frame A)
ACEF031B	4	Centre Gasket Corner (frame A)
ACVL031	2(W1+H)	Flipper Gasket (sash)
ACET4041	2	Bridge Packer (frame B)
ACET842	(2W)+(4H)	Gasket E
ACW20038	(2W)+(4H)	Wedge Gasket
ACGSL045	4	Drainage Cap

Please refer to the SB Chrono or Fapim manual for tilt & turn hardware



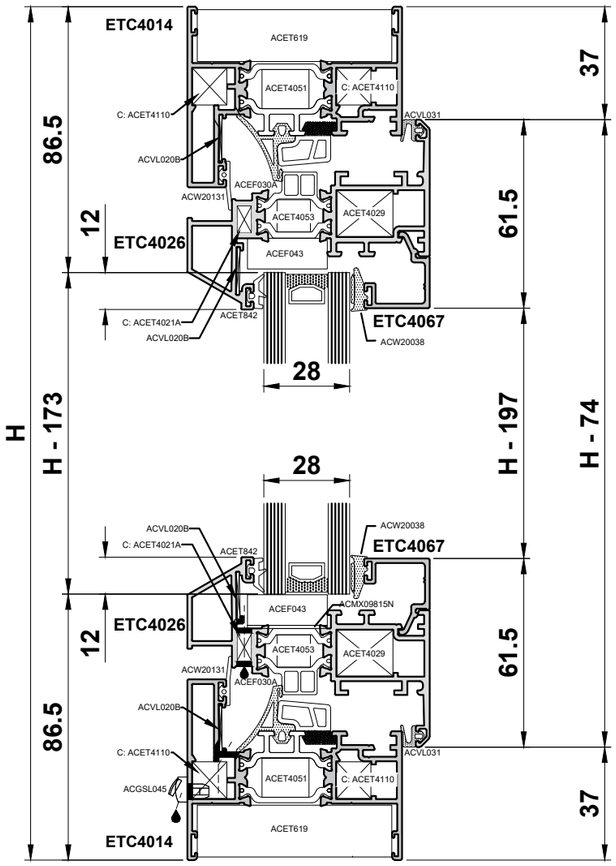
	Glass
A	W1 - 134 x H - 150
B	W2 - 54.5 x H - 71



Do Not Scale From This Drawing

Alitherm 400 Tilt & Turn

Cutting Information



Sections

ETC4014		2		H
ETC4014		2		W
ETC4026		2		H - 74
ETC4026		2		W1 - 46
ETC4031		1		H - 84
Bead		2		W1 - 135
Bead		2		H - 197
Bead		2		W2 - 56
Bead		2		H - 118

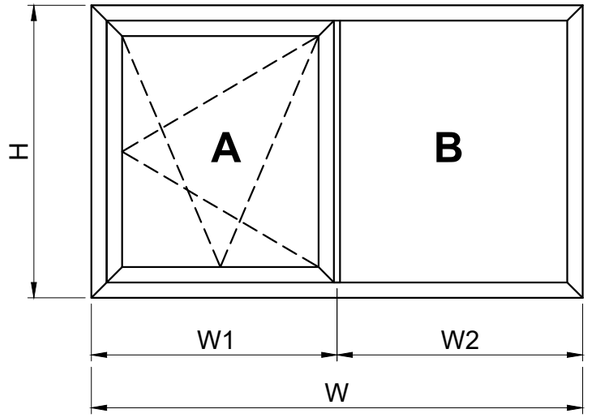
Foam

ACEF043 + ACMX09815N	(2 x W1) + (2 x H)	Foam (sash)
ACET619	2(W+H)	Foam (frame)
ACET4051	2(W+H)	Foam (frame)
ACET4053	(2 x W1) + (2 x H)	Foam (sash)
ACET4056	(2 x W2) + (2 x H)	Foam (frame)
ACET4079	H	Foam (Mullion)

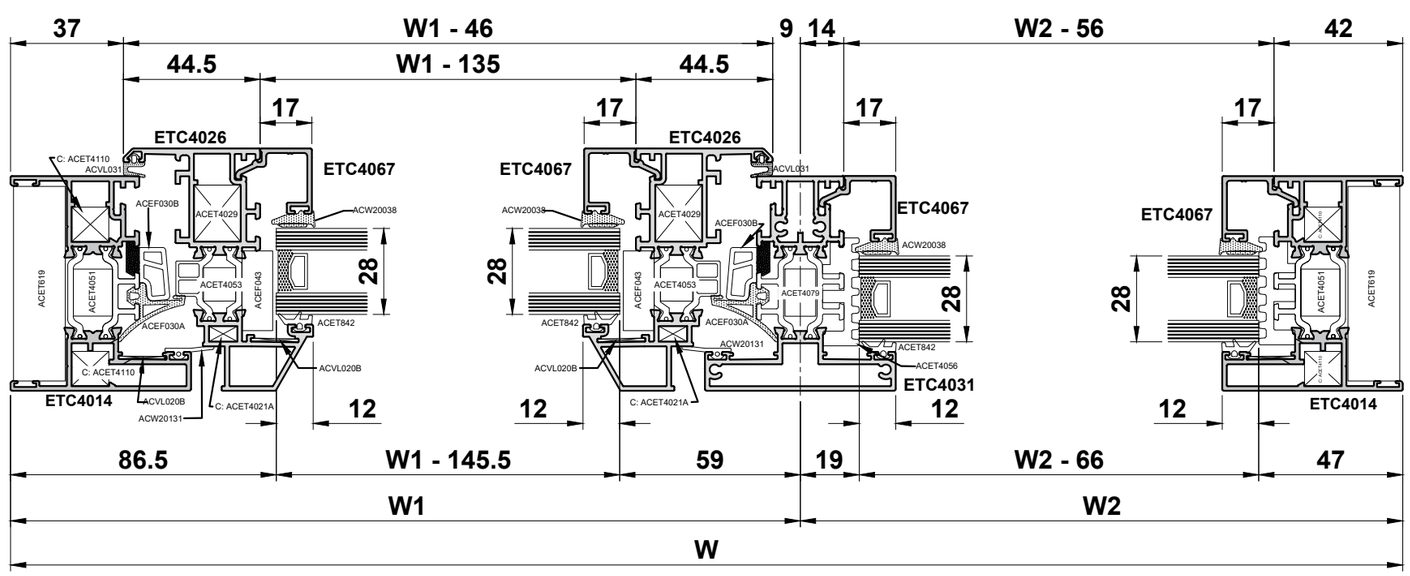
Accessories

ACVL020B	4	Chevron (sash)
ACVL020B	4	Chevron (frame)
ACET4110	8	Frame Cleat
ACET4029	4	Sash Cleat (outer)
ACET4021A	4	Sash Cleat (inner)
ACVL029	4	Anti-Twist Clip (mullion)
ACET066	4	Mullion Screws
ACW20131	2(W1+H)	External Flat Gasket (frame A)
ACEF030A	2(W1+H)	Centre Gasket (frame A)
ACEF030B	2(W1+H)	Centre Gasket (frame A)
ACEF031B	4	Centre Gasket Corner (frame A)
ACVL031	2(W1+H)	Flipper Gasket (sash)
ACET4041	2	Bridge Packer (frame B)
ACET842	(2W)+(4H)	Gasket E
ACW20038	(2W)+(4H)	Wedge Gasket
ACGSL045	4	Drainage Cap

Please refer to the SB Chrono or Fapim manual for tilt & turn hardware



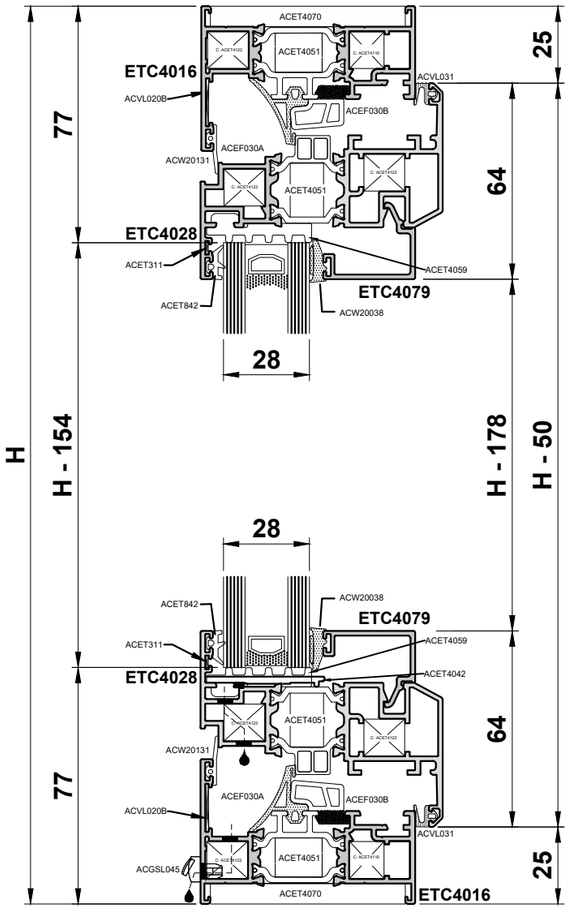
	Glass
A	W1 - 145.5 x H - 173
B	W2 - 66 x H - 94



Do Not Scale From This Drawing

Alitherm 400 Tilt & Turn

Cutting Information



Sections

ETC4016		2		H
ETC4016		2		W
ETC4028		2		H - 50
ETC4028		2		W1 - 34
ETC4036		1		H - 61
Bead		2		W1 - 128
Bead		2		H - 178
Bead		2		W2 - 44.5
Bead		2		H - 94

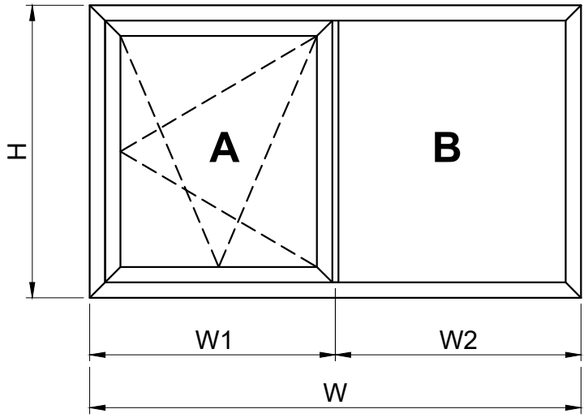
Foam

ACET4070	2(W+H)	Foam (frame)
ACET4051	2(W+H)	Foam (frame)
ACET4051	(2 x W1) + (2 x H)	Foam (sash)
ACET4056	(2 x W2) + (2 x H)	Foam (frame)
ACET4059	(2 x W1) + (2 x H)	Foam (sash)
ACET4079	H	Foam (mullion)

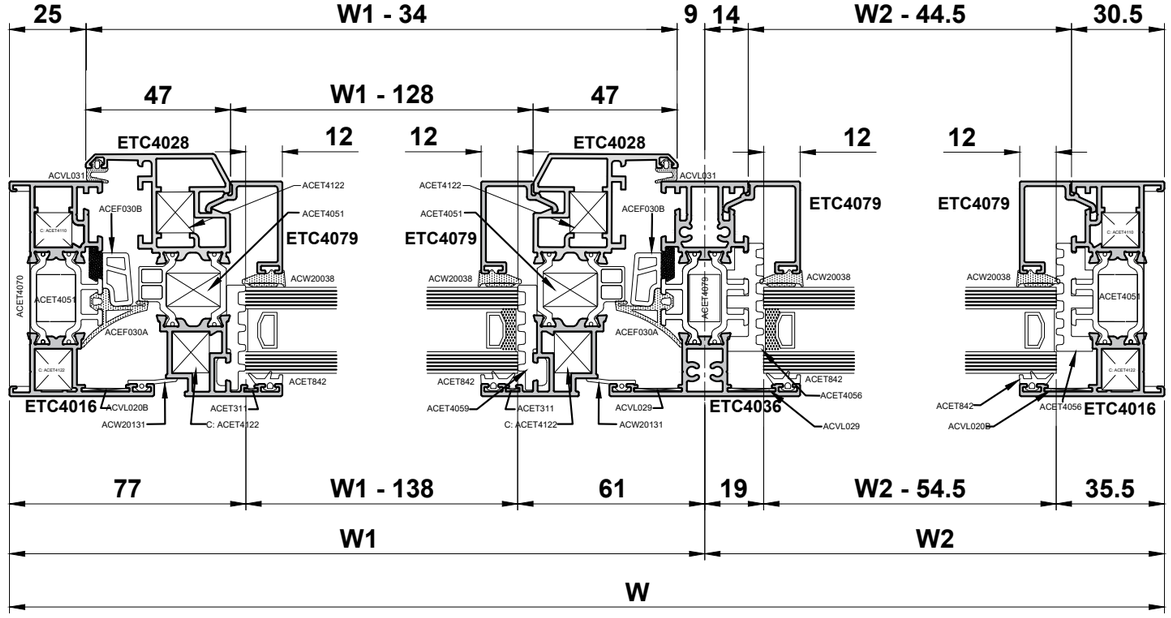
Accessories

ACET311	4	Chevron (sash)
ACVL020B	4	Chevron (frame)
ACET4110	4	Frame Cleat (Inner)
ACET4122	4	Frame Cleat (Outer)
ACET4122	8	Sash Cleat
ACVL029	4	Anti-Twist Clip (mullion)
ACET066	4	Mullion Screws
ACW20131	2(W1+H)	External Flat Gasket (frame A)
ACEF030A	2(W1+H)	Centre Gasket (frame A)
ACEF030B	2(W1+H)	Centre Gasket (frame A)
ACEF031B	4	Centre Gasket Corner (frame A)
ACVL031	2(W1+H)	Flipper Gasket (sash)
ACET4042	6	Bridge Packer (sash)
ACET4043	2	Bridge Packer (frame B)
ACET842	(2W)+(4H)	Gasket E
ACW20038	(2W)+(4H)	Wedge Gasket
ACGSL045	4	Drainage Cap

Please refer to the SB Chrono or Fapim manual for tilt & turn hardware



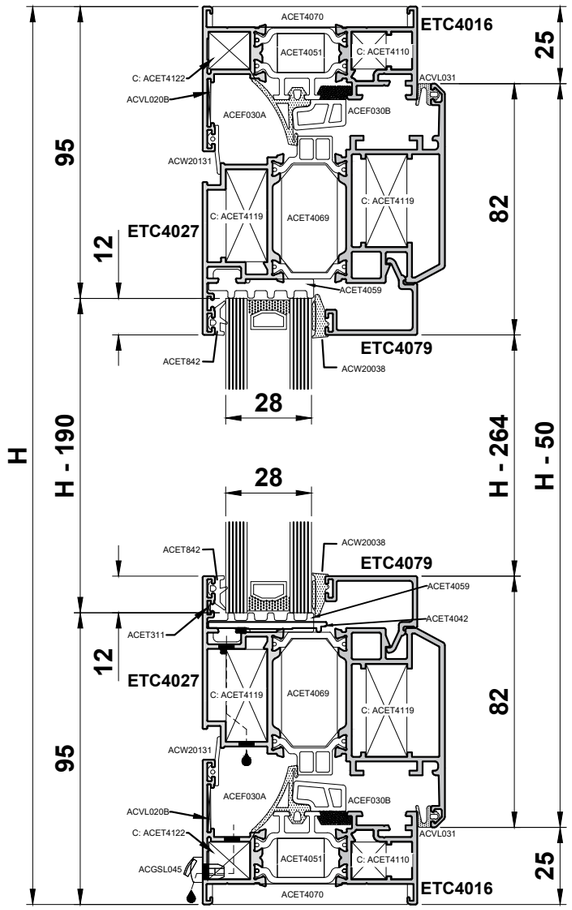
	Glass
A	W1 - 138 x H - 154
B	W2 - 54.5 x H - 94



Do Not Scale From This Drawing

Alitherm 400 Tilt & Turn

Cutting Information



Sections

ETC4016		2		H
ETC4016		2		W
ETC4027		2		H - 50
ETC4027		2		W1 - 34
ETC4036		1		H - 61
Bead		2		W1 - 164
Bead		2		H - 214
Bead		2		W2 - 44.5
Bead		2		H - 94

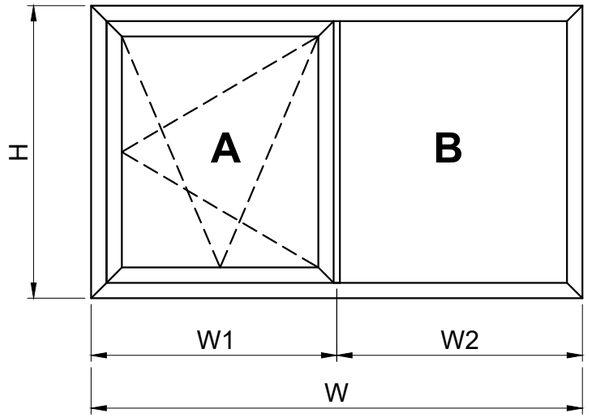
Foam

ACET4070	2(W+H)	Foam (frame)
ACET4051	2(W+H)	Foam (frame)
ACET4056	(2 x W2) + (2 x H)	Foam (frame)
ACET4059	(2 x W1) + (2 x H)	Foam (sash)
ACET4069	(2 x W1) + (2 x H)	Foam (sash)
ACET4079	H	Foam (mullion)

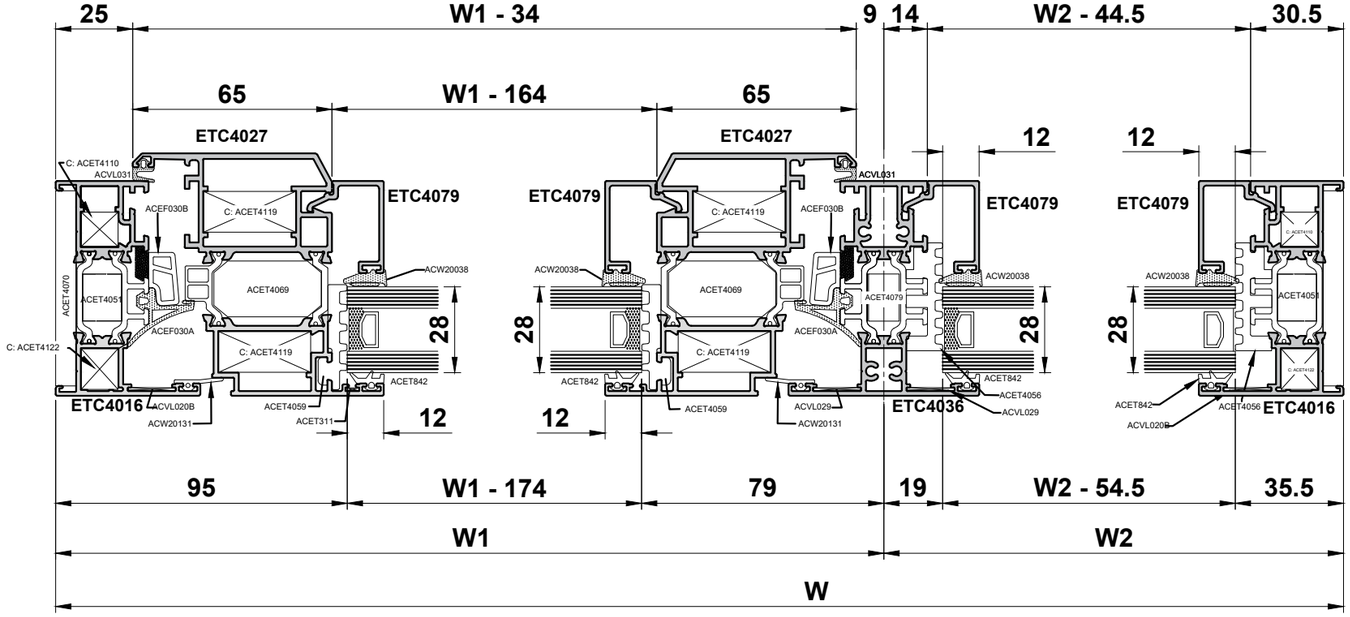
Accessories

ACET311	4	Chevron (sash)
ACVL020B	4	Chevron (frame)
ACET4110	4	Frame Cleat (Inner)
ACET4122	4	Frame Cleat (Outer)
ACET4119	8	Sash Cleat
ACVL029	4	Anti-Twist Clip (mullion)
ACET066	4	Mullion Screws
ACW20131	2(W1+H)	External Flat Gasket (frame A)
ACEF030A	2(W1+H)	Centre Gasket (frame A)
ACEF030B	2(W1+H)	Centre Gasket (frame A)
ACEF031B	4	Centre Gasket Corner (frame A)
ACVL031	2(W1+H)	Flipper Gasket (sash)
ACET4042	6	Bridge Packer (sash)
ACET4043	2	Bridge Packer (frame B)
ACET842	(2W)+(4H)	Gasket E
ACW20038	(2W)+(4H)	Wedge Gasket
ACGSL045	4	Drainage Cap

Please refer to the SB Chrono or Fapim manual for tilt & turn hardware



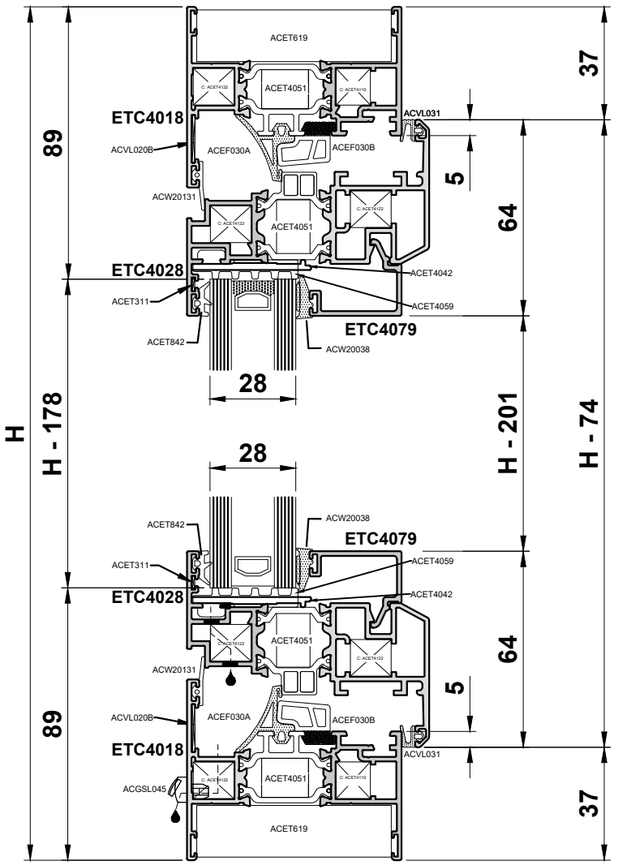
	Glass
A	W1 - 174 x H - 190
B	W2 - 54.5 x H - 94



Do Not Scale From This Drawing

Alitherm 400 Tilt & Turn

Cutting Information



Sections

ETC4018		2		H
ETC4018		2		W
ETC4028		2		H - 74
ETC4028		2		W1 - 46
ETC4036		1		H - 84
Bead		2		W1 - 140
Bead		2		H - 201
Bead		2		W2 - 56
Bead		2		H - 118

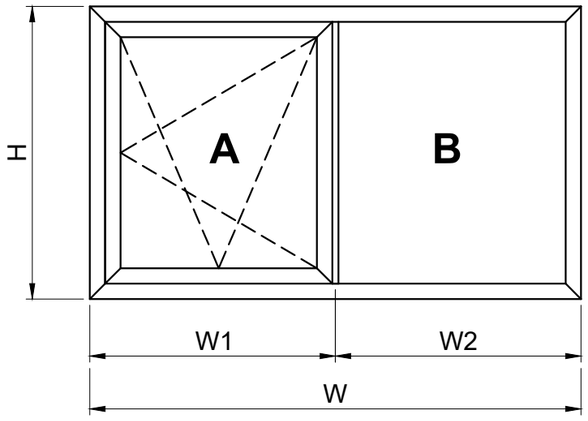
Foam

ACET619	2(W+H)	Foam (frame)
ACET4051	2(W+H)	Foam (frame)
ACET4051	(2 x W1) + (2 x H)	Foam (sash)
ACET4056	(2 x W2) + (2 x H)	Foam (frame)
ACET4059	(2 x W1) + (2 x H)	Foam (sash)
ACET4079	H	Foam (mullion)

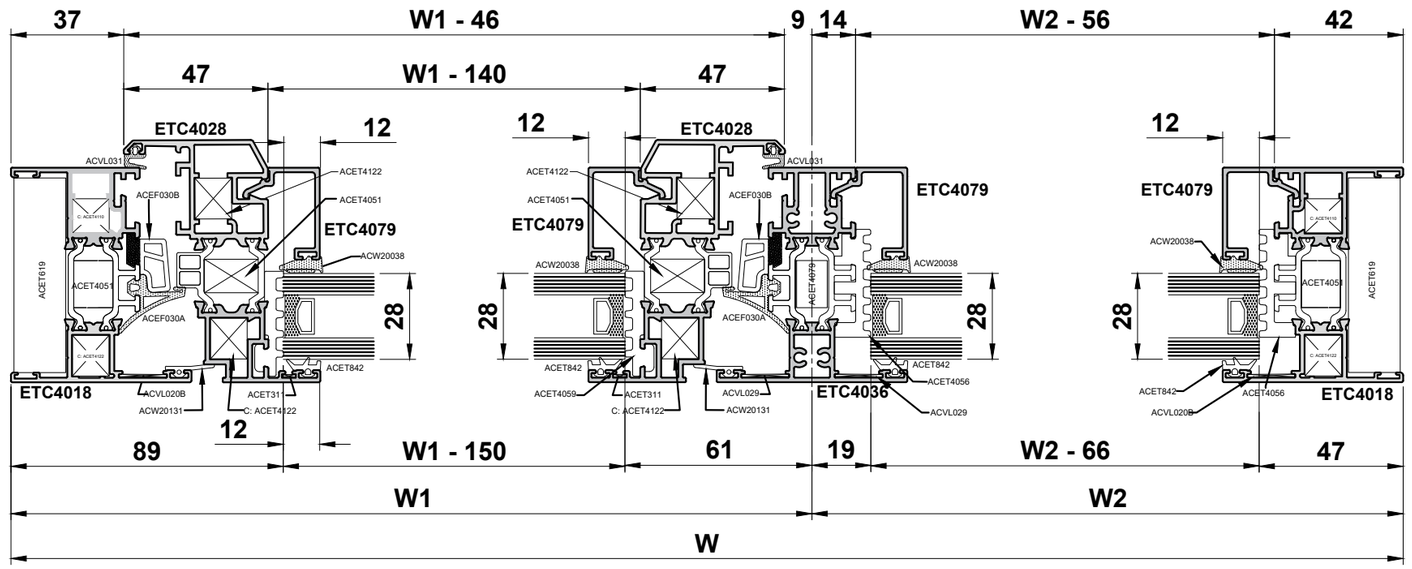
Accessories

ACET311	4	Chevron (sash)
ACVL020B	4	Chevron (frame)
ACET4110	4	Frame Cleat (Inner)
ACET4122	4	Frame Cleat (Outer)
ACET4122	8	Sash Cleat
ACVL029	4	Anti-Twist Clip (mullion)
ACET066	4	Mullion Screws
ACW20131	2(W1+H)	External Flat Gasket (frame A)
ACEF030A	2(W1+H)	Centre Gasket (frame A)
ACEF030B	2(W1+H)	Centre Gasket (frame A)
ACEF031B	4	Centre Gasket Corner (frame A)
ACVL031	2(W1+H)	Flipper Gasket (sash)
ACET4042	6	Bridge Packer (sash)
ACET4043	2	Bridge Packer (frame B)
ACET842	(2W)+(4H)	Gasket E
ACW20038	(2W)+(4H)	Wedge Gasket
ACGSL045	4	Drainage Cap

Please refer to the SB Chrono or Fapim manual for tilt & turn hardware



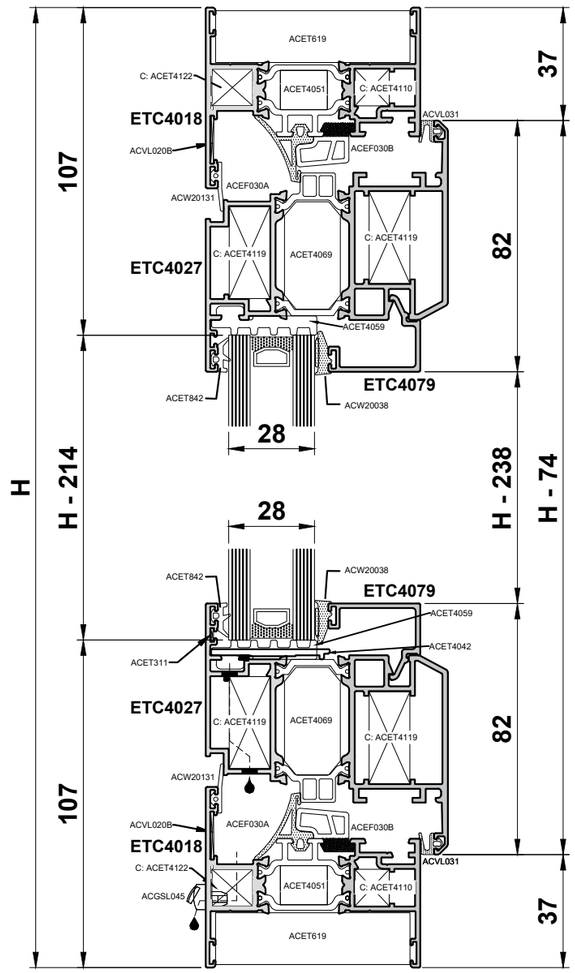
	Glass
A	W1 - 150 x H - 178
B	W2 - 66 x H - 94



Do Not Scale From This Drawing

Alitherm 400 Tilt & Turn

Cutting Information



Sections

ETC4018		2		H
ETC4018		2		W
ETC4027		2		H - 74
ETC4027		2		W1 - 46
ETC4036		1		H - 84
Bead		2		W1 - 176
Bead		2		H - 238
Bead		2		W2 - 56
Bead		2		H - 118

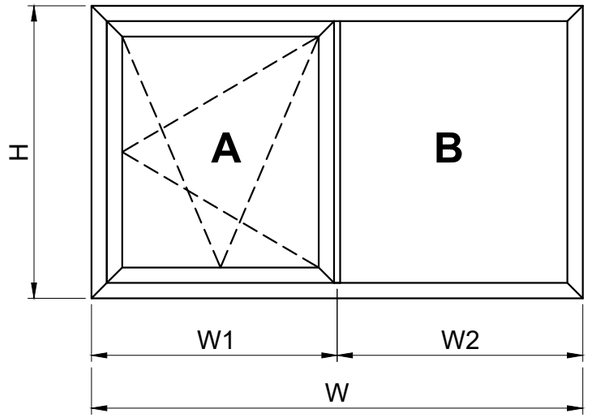
Foam

ACET619	2(W+H)	Foam (frame)
ACET4051	2(W+H)	Foam (frame)
ACET4056	(2 x W2) + (2 x H)	Foam (frame)
ACET4059	(2 x W1) + (2 x H)	Foam (sash)
ACET4069	(2 x W1) + (2 x H)	Foam (sash)
ACET4079	H	Foam (mullion)

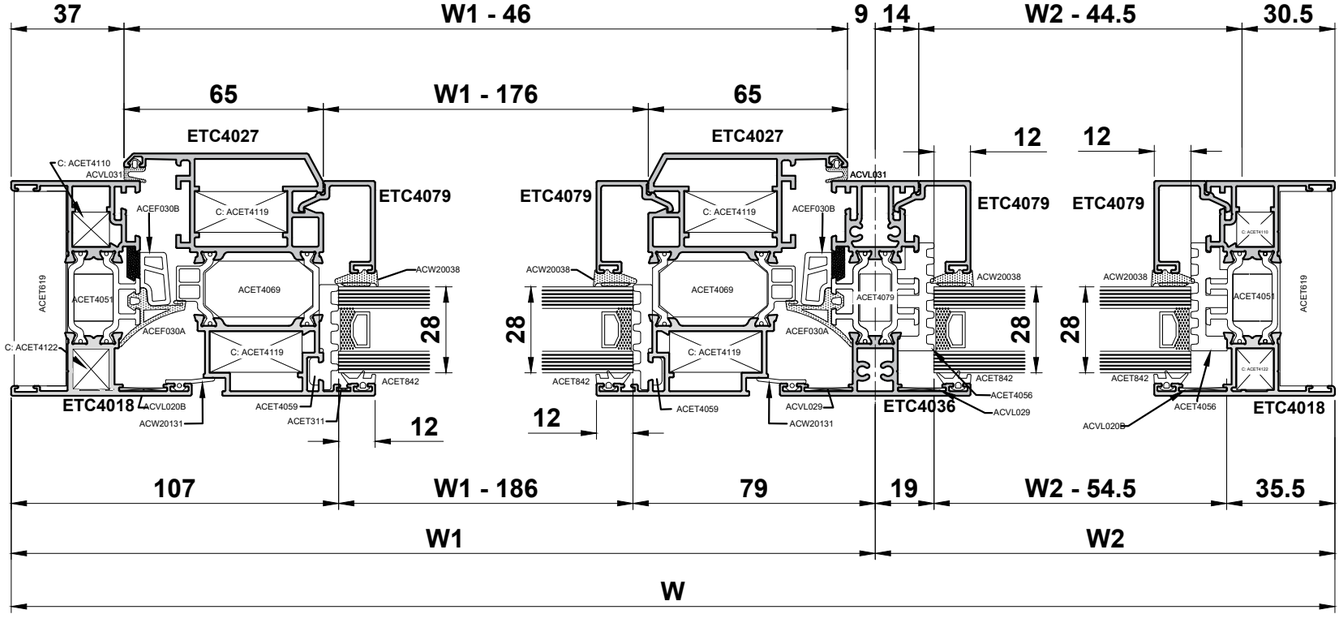
Accessories

ACET311	4	Chevron (sash)
ACVL020B	4	Chevron (frame)
ACET4110	4	Frame Cleat (Inner)
ACET4122	4	Frame Cleat (Outer)
ACET4119	8	Sash Cleat
ACVL029	4	Anti-Twist Clip (mullion)
ACET066	4	Mullion Screws
ACW20131	2(W1+H)	External Flat Gasket (frame A)
ACEF030A	2(W1+H)	Centre Gasket (frame A)
ACEF030B	2(W1+H)	Centre Gasket (frame A)
ACEF031B	4	Centre Gasket Corner (frame A)
ACVL031	2(W1+H)	Flipper Gasket (sash)
ACET4042	6	Bridge Packer (sash)
ACET4043	2	Bridge Packer (frame B)
ACET842	(2W)+(4H)	Gasket E
ACW20038	(2W)+(4H)	Wedge Gasket
ACGSL045	4	Drainage Cap

Please refer to the SB Chrono or Fapim manual for tilt & turn hardware



	Glass
A	W1 - 186 x H - 214
B	W2 - 66 x H - 94

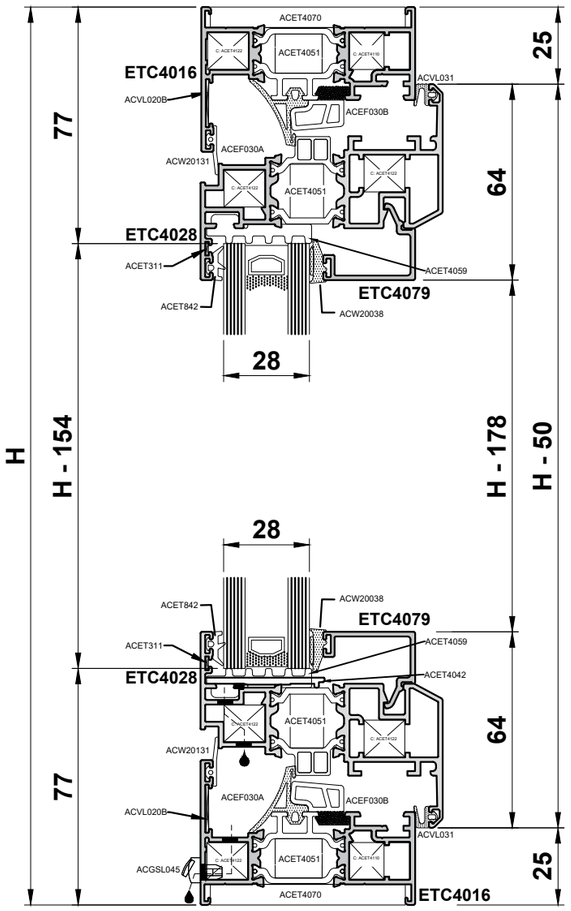


Do Not Scale From This Drawing

ISSUED : July 2026

Alitherm 400 Tilt & Turn

Cutting Information



Sections

ETC4016		2		H
ETC4016		2		W
ETC4028		2		H - 50
ETC4028		2		W1 - 29
ETC4028		2		W2 - 29
ETC4037		1		H - 120
Bead		2		W1 - 123
Bead		2		W2 - 123
Bead		2		H - 178

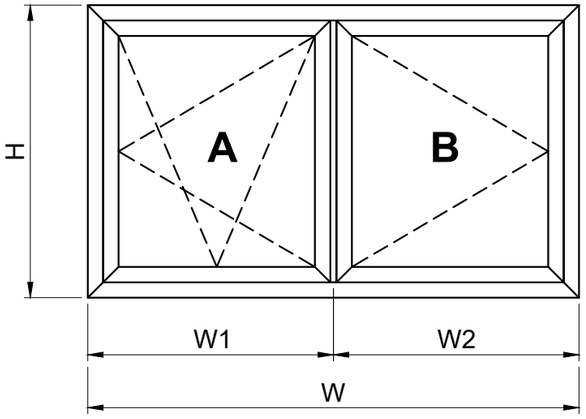
Foam

ACET4070	2(W+H)	Foam (frame)
ACET4049	H - 120	Foam (mullion)
ACET4051	2(W+H)	Foam (frame)
ACET4051	(2W)+(4H)	Foam (sash)
ACET4069	(2W)+(4H)	Foam (sash)

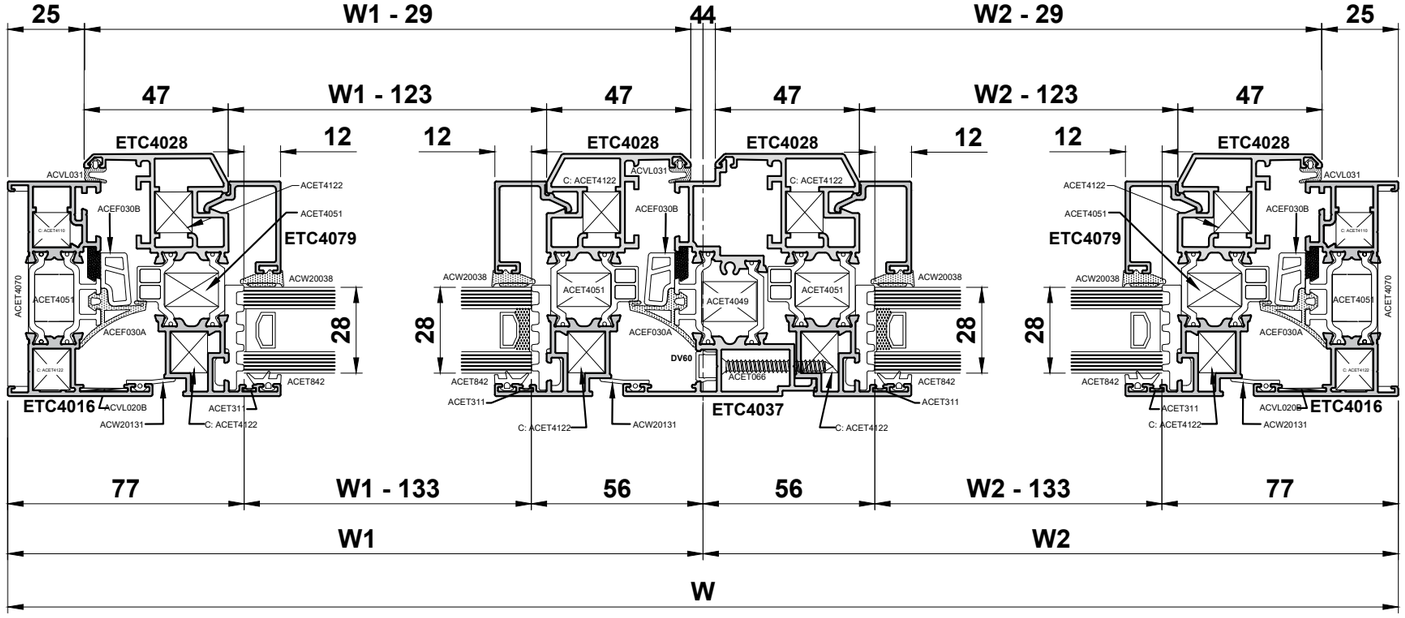
Accessories

ACET311	8	Chevron (sash)
ACVL020B	4	Chevron (frame)
ACET4110	4	Frame Cleat (Inner)
ACET4122	4	Frame Cleat (Outer)
ACET4122	16	Sash Cleat
ACET066	4 + (H / 300)	Mullion Screws
ACET4037	1 Pair	ETC4037 End Caps
ACW20131	(2W)+(3H)	External Flat Gasket (frame A)
ACEF030A	(2W)+(3H)	Centre Gasket (frame A)
ACEF030B	(2W)+(3H)	Centre Gasket (frame A)
ACEF031B	4	Centre Gasket Corner (frame A)
ACVL031	(2W)+(3H)	Flipper Gasket (sash)
ACET4042	12	Bridge Packer (sash)
ACET842	(2W)+(4H)	Gasket E
ACW20038	(2W)+(4H)	Wedge Gasket
ACGSL045	2	Drainage Cap

Please refer to the SB Chrono or Fapim manual for tilt & turn hardware



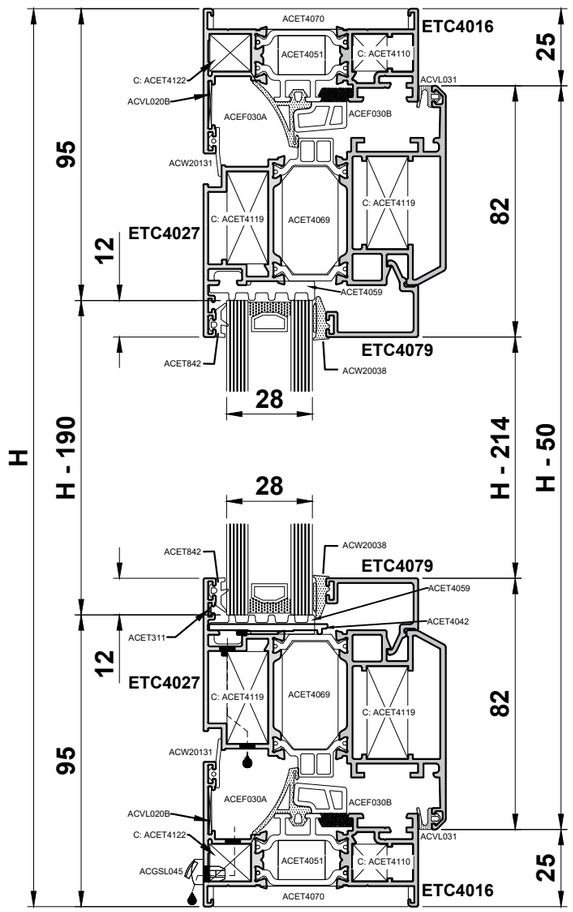
	Glass
A	W1 - 133 x H - 154
B	W2 - 133 x H - 154



Do Not Scale From This Drawing

Alitherm 400 Tilt & Turn

Cutting Information



Sections

ETC4016		2		H
ETC4016		2		W
ETC4027		2		H - 50
ETC4027		2		W1 - 29
ETC4027		2		W2 - 29
ETC4037		1		H - 120
Bead		2		W1 - 159
Bead		2		W2 - 159
Bead		2		H - 214

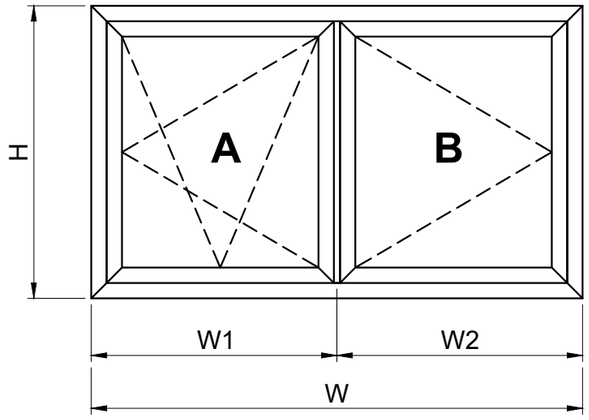
Foam

ACET4070	2(W+H)	Foam (frame)
ACET4049	H - 120	Foam (mullion)
ACET4051	2(W+H)	Foam (frame)
ACET4059	(2W)+(4H)	Foam (sash)
ACET4069	(2W)+(4H)	Foam (sash)

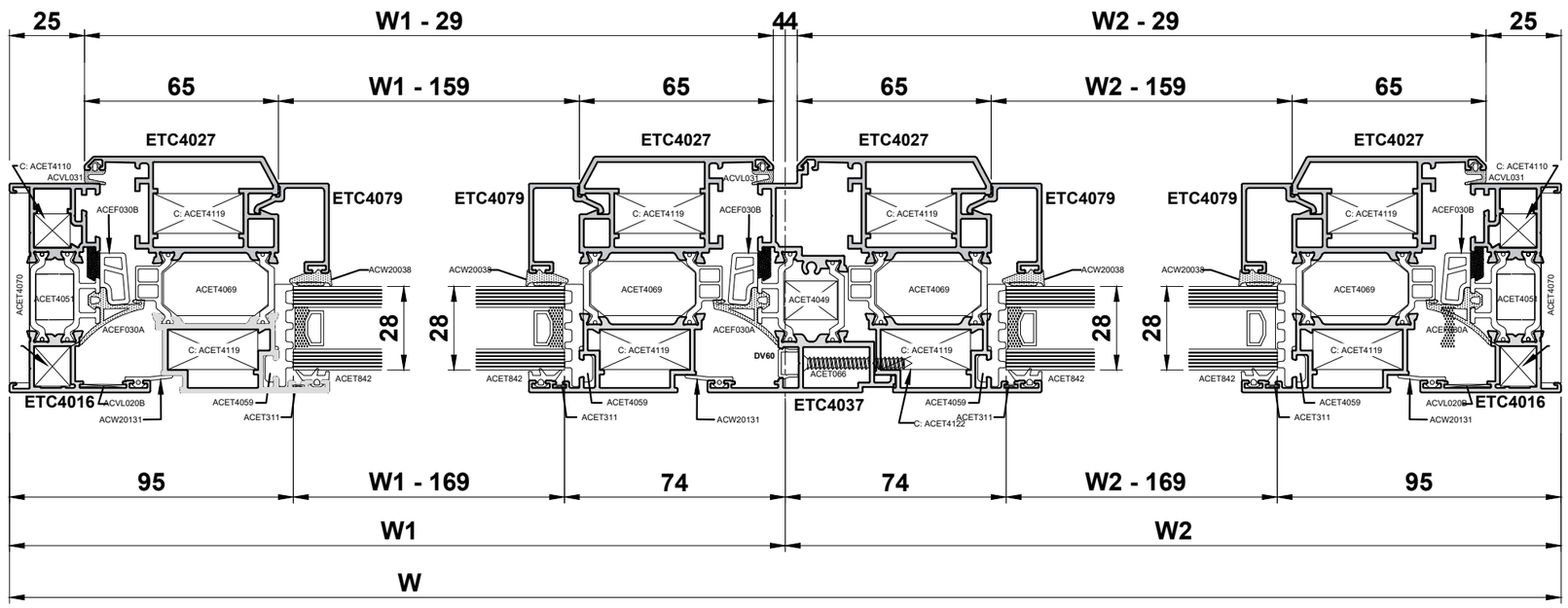
Accessories

ACET311	8	Chevron (sash)
ACVL020B	4	Chevron (frame)
ACET4110	4	Frame Cleat (Inner)
ACET4122	4	Frame Cleat (Outer)
ACET4119	16	Sash Cleat
ACET066	4 + (H / 300)	Mullion Screws
ACET4037	1 Pair	ETC4037 End Caps
ACW20131	(2W)+(3H)	External Flat Gasket (frame A)
ACEF030A	(2W)+(3H)	Centre Gasket (frame A)
ACEF030B	(2W)+(3H)	Centre Gasket (frame A)
ACEF031B	4	Centre Gasket Corner (frame A)
ACVL031	(2W)+(3H)	Flipper Gasket (sash)
ACET4042	12	Bridge Packer (sash)
ACET842	(2W)+(4H)	Gasket E
ACW20038	(2W)+(4H)	Wedge Gasket
ACGSL045	2	Drainage Cap

Please refer to the SB Chrono or Fapim manual for tilt & turn hardware



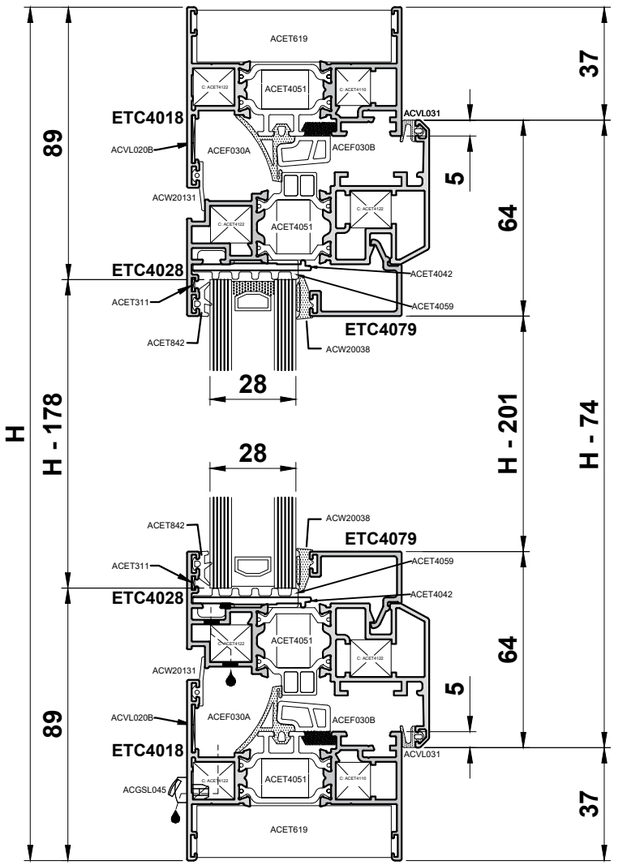
	Glass
A	W1 - 169 x H - 190
B	W2 - 169 x H - 190



Do Not Scale From This Drawing

Alitherm 400 Tilt & Turn

Cutting Information



Sections

ETC4018		2		H
ETC4018		2		W
ETC4028		2		H - 74
ETC4028		2		W1 - 41
ETC4028		2		W2 - 41
ETC4037		1		H - 144
Bead		2		W1 - 135
Bead		2		W2 - 135
Bead		2		H - 201

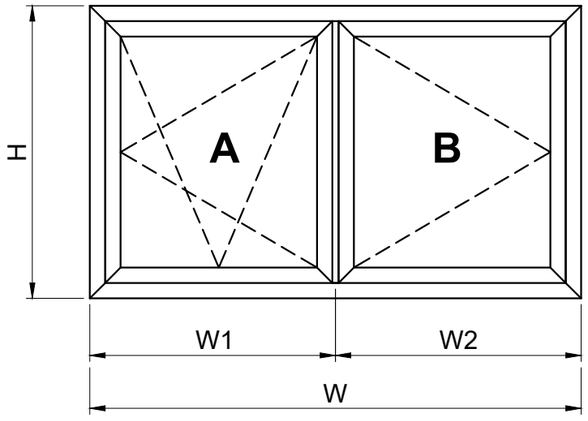
Foam

ACET619	2(W+H)	Foam (frame)
ACET4049	H - 144	Foam (mullion)
ACET4051	2(W+H)	Foam (frame)
ACET4051	(2W)+(4H)	Foam (sash)
ACET4059	(2W)+(4H)	Foam (sash)

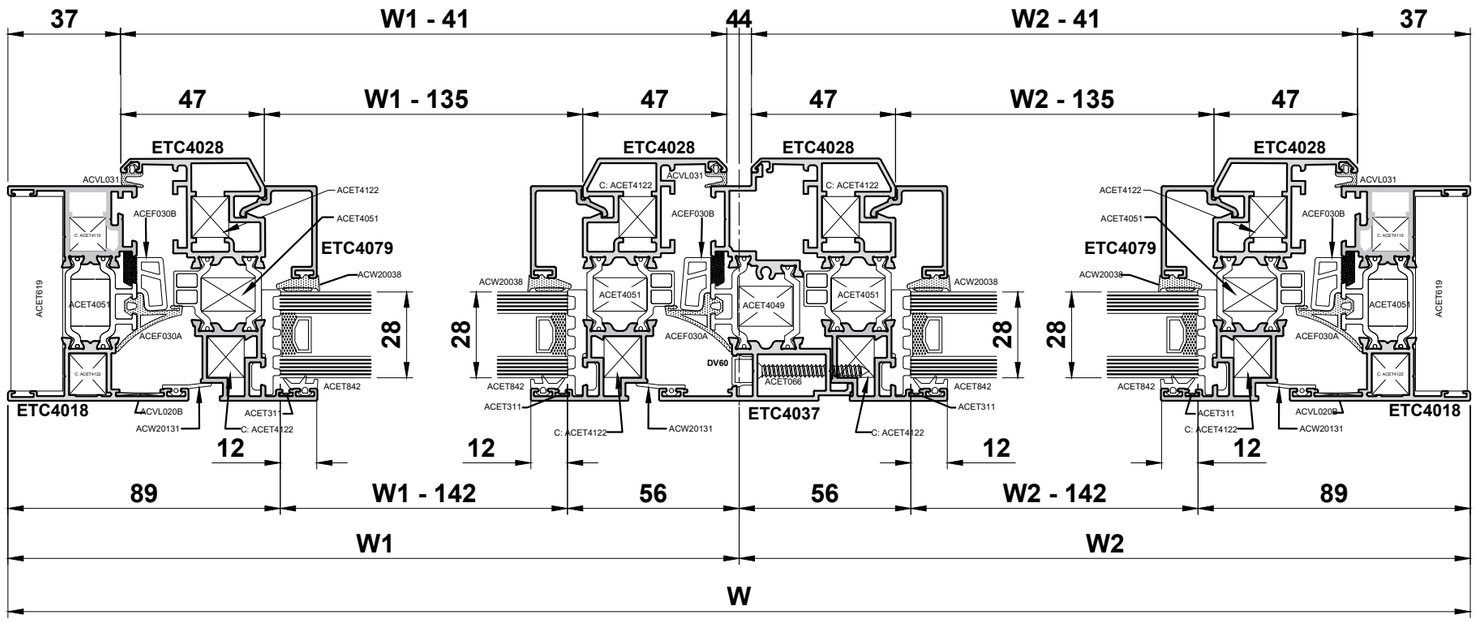
Accessories

ACET311	8	Chevron (sash)
ACVL020B	4	Chevron (frame)
ACET4110	4	Frame Cleat (Inner)
ACET4122	4	Frame Cleat (Outer)
ACET4122	16	Sash Cleat
ACET066	4 + (H / 300)	Mullion Screws
ACET4037	1 Pair	ETC4037 End Caps
ACW20131	(2W)+(3H)	External Flat Gasket (frame A)
ACEF030A	(2W)+(3H)	Centre Gasket (frame A)
ACEF030B	(2W)+(3H)	Centre Gasket (frame A)
ACEF031B	4	Centre Gasket Corner (frame A)
ACVL031	(2W)+(3H)	Flipper Gasket (sash)
ACET4042	12	Bridge Packer (sash)
ACET842	(2W)+(4H)	Gasket E
ACW20038	(2W)+(4H)	Wedge Gasket
ACGSL045	2	Drainage Cap

Please refer to the SB Chrono or Fapim manual for tilt & turn hardware



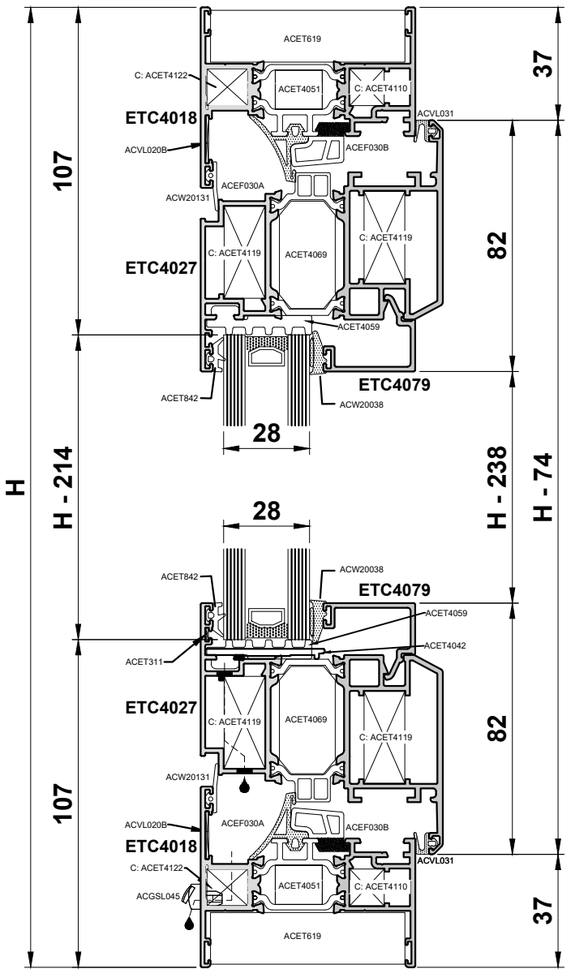
	Glass
A	W1 - 142 x H - 178
B	W2 - 142 x H - 178



Do Not Scale From This Drawing

Alitherm 400 Tilt & Turn

Cutting Information



Sections

ETC4018		2		H
ETC4018		2		W
ETC4027		2		H - 74
ETC4027		2		W1 - 41
ETC4027		2		W2 - 41
ETC4037		1		H - 144
Bead		2		W1 - 171
Bead		2		W2 - 171
Bead		2		H - 238

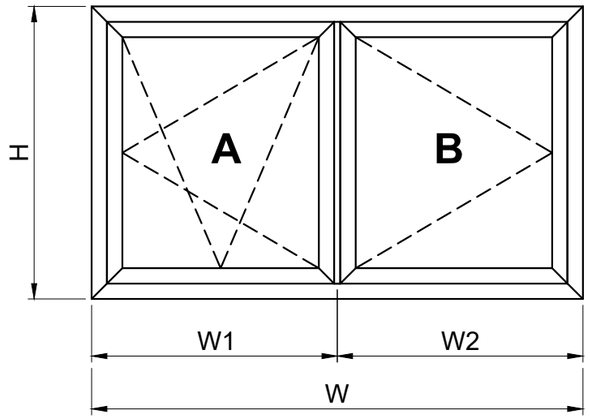
Foam

ACET619	2(W+H)	Foam (frame)
ACET4049	H - 144	Foam (mullion)
ACET4051	2(W+H)	Foam (frame)
ACET4059	(2W)+(4H)	Foam (sash)
ACET4069	(2W)+(4H)	Foam (sash)

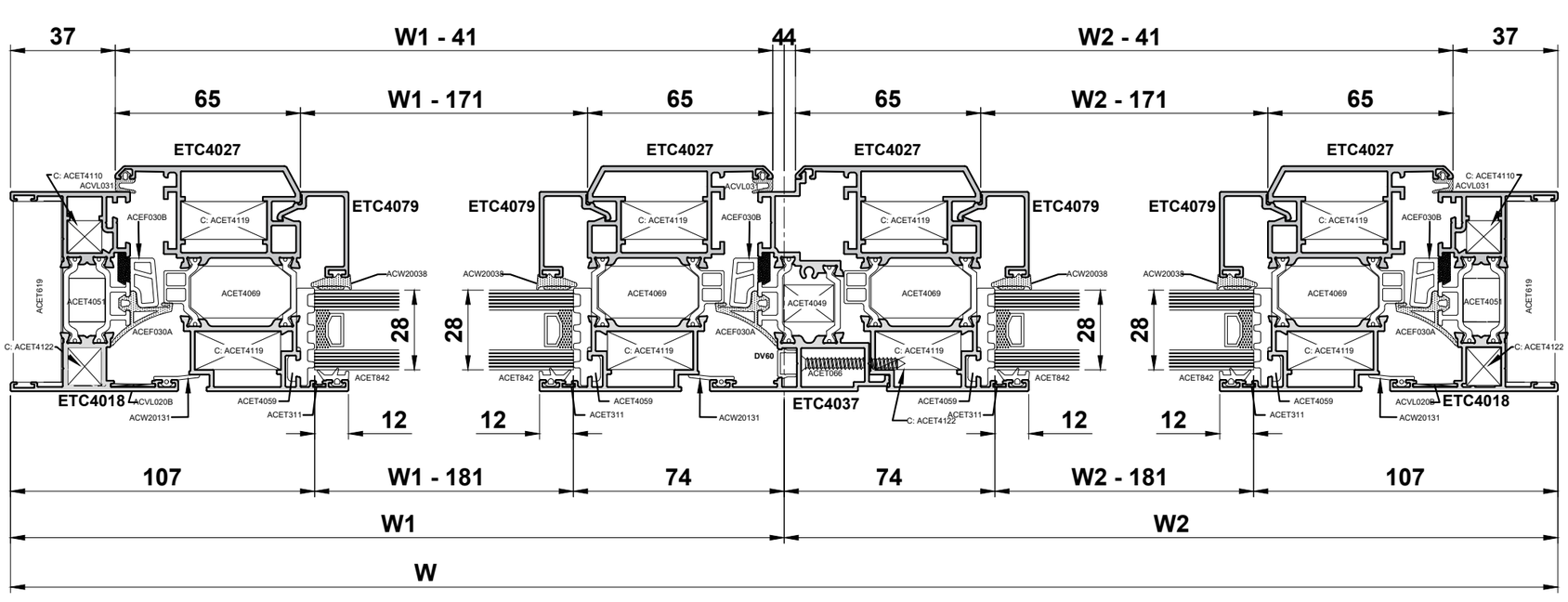
Accessories

ACET311	8	Chevron (sash)
ACVL020B	4	Chevron (frame)
ACET4110	4	Frame Cleat (Inner)
ACET4122	4	Frame Cleat (Outer)
ACET4119	16	Sash Cleat
ACET066	4 + (H / 300)	Mullion Screws
ACET4037	1 Pair	ETC4037 End Caps
ACW20131	(2W)+(3H)	External Flat Gasket (frame A)
ACEF030A	(2W)+(3H)	Centre Gasket (frame A)
ACEF030B	(2W)+(3H)	Centre Gasket (frame A)
ACEF031B	4	Centre Gasket Corner (frame A)
ACVL031	(2W)+(3H)	Flipper Gasket (sash)
ACET4042	12	Bridge Packer (sash)
ACET842	(2W)+(4H)	Gasket E
ACW20038	(2W)+(4H)	Wedge Gasket
ACGSL045	2	Drainage Cap

Please refer to the SB Chrono or Fapim manual for tilt & turn hardware



	Glass
A	W1 - 181 x H - 214
B	W2 - 181 x H - 214



Do Not Scale From This Drawing