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Updates

DATE	PAGE	DESCRIPTION
May 2026	Various	Parallel, Reversible and internally glazed options added.

Specification

GENERAL DESCRIPTION

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

The system incorporates parallel, top hung, side hung & reversible window types with internally beaded vent frames suitable for shootbolt locking. The outer frames may be internally or externally glazed as preferred.

Alitherm 400 HD parallel windows are often used with chain operators which can be connected to the building management system as part of an automated solution for climate control.

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

Corner assembly of Alitherm 400 HD is crimping only.

RECOMMENDED DESIGN LIMITATIONS

Parallel Vents:

Maximum Width: 2000mm (sash width up to 1800mm covered by Kitemark)
Minimum Width: 400mm
Maximum Height: 3000mm (sash height up to 2100mm covered by Kitemark)
Minimum Height: 750mm
Maximum Weight: 220kg
NOTE:
Parallel windows over 1500mm wide or weighing over 200kg should be motorised operation only

Reversible Vents:

Maximum Width: 1500mm
Minimum Width: 359mm (with multi-point locking)
Maximum Height: 1558mm
Minimum Height: 458mm
Maximum Weight: 60kg with hinges 4 to 16. 80kg with hinges 17 & 18.
NOTE:
Order Top Swing Arms from Carl F Groupco. See page E20 for more information.

Top Hung Vents:

Maximum Width: 2000mm (sash width up to 1600mm covered by Kitemark)
Maximum Height: 2500mm (sash height up to 1600mm covered by Kitemark)
Minimum Height: 267mm
Maximum Weight: 100kg (Stays)
50kg (ACET750)

Side Hung Vents:

Maximum Width: 840mm
Minimum Width: 327mm
Maximum Height: 1500mm **(**Please consult our technical department for heights over 1500mm)
Maximum Weight: 55kg (Stays)
40kg (ACET750)

Specification

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

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

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

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

Specification

WINDOW DRAINAGE

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

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

OUTER FRAME MANUFACTURING INFORMATION

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

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

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

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

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

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

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

Specification

VENT

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

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

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

INTERNALLY BEADED ADAPTOR FRAME

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

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

GLAZING

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

EXTERNALLY BEADED GLAZING

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

INTERNALLY BEADED GLAZING

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

Specification

Casement:

Alitherm 400 HD Casement Window Weather Performance (BS6375-1)

	Side Hung	Side Hung
Sash Size of Test Sample	838 x 1400mm	838 x 1680mm
BS EN 1026: 2000 Air Permeability:	Class 3 600Pa	Class 2 300Pa
BS EN 1027: 2000 Watertightness:	Class E 900Pa	Class E 600Pa
BS EN 12211: 2000 Resistance to Wind Load:	Class AE 2400Pa	Class AE 2400Pa

	Top Hung	Top Hung	Top Hung
Sash Size of Test Sample	1680 x 1000mm	1680 x 1400mm	1680 x 1700mm
BS EN 1026: 2000 Air Permeability:	Class 2 300Pa	Class 2 300Pa	Class 1 150Pa
BS EN 1027: 2000 Watertightness:	Class E 1500Pa	Class E 1050Pa	Class E 1050Pa
BS EN 12211: 2000 Resistance to Wind Load:	Class AE 2400Pa	Class AE 2400Pa	Class AE 2400pa

Alitherm 400 HD Caasement Window Security (PAS 24)

Alitherm 400 HD Casement has been successfully tested to PAS24:2022. Please refer to KM 530838 which can be downloaded from: https://previous.smartsystems.co.uk/documentlibrary

Reversible:

Alitherm 400 HD Reversible Window Weather Performance (BS6375-1)

Sash Size of Test Sample	1500 x 1713mm
BS EN 1026: 2000 Air Permeability:	Class 3 600Pa
BS EN 1027: 2000 Watertightness:	Class E 1050Pa
BS EN 12211: 2000 Resistance to Wind Load:	Class AE 2400Pa

Alitherm 400 HD Reversible Window Security (PAS 24)

To be tested.

Parallel:

Alitherm 400 HD Parallel Window Weather Performance (BS6375-1)

Sash Size of Test Sample	1000 x 2100mm
BS EN 1026: 2000 Air Permeability:	Class 4 600Pa
BS EN 1027: 2000 Watertightness:	Class E 1050Pa
BS EN 12211: 2000 Resistance to Wind Load:	Class AE 2400Pa

Alitherm 400 HD Parallel Window Security (PAS 24)

Alitherm 400 HD Parallel has been successfully tested to PAS24:2022. Please refer to KM 530838 which can be downloaded from: https://previous.smartsystems.co.uk/documentlibrary

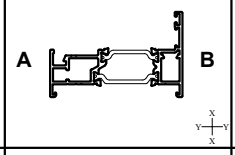
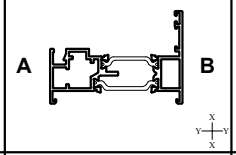
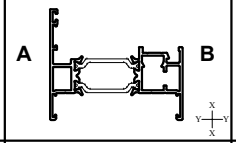
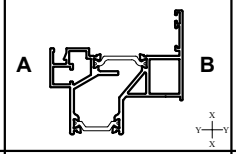
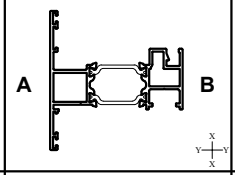
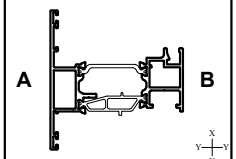
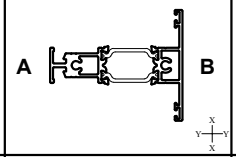
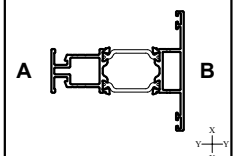
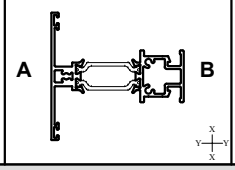
Alitherm 400 HD Window U Values

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

Kitemark™ Certificate No. KM 81580

Alitherm 400 HD Window

PROFILES : TECHNICAL INFORMATION

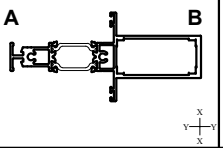
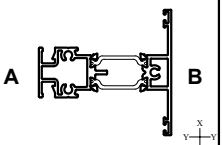
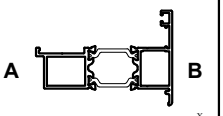
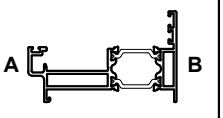
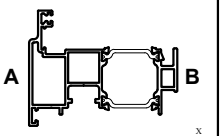
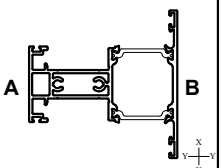
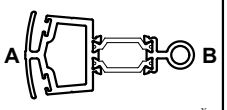
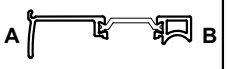
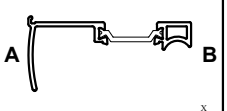
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A = Outside
B = Inside

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

Alitherm 400 HD Window

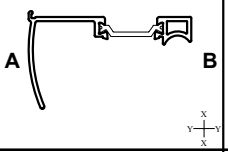
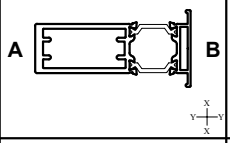
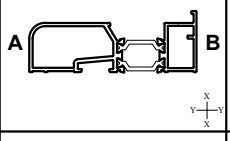
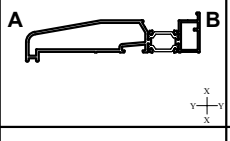
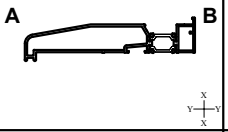
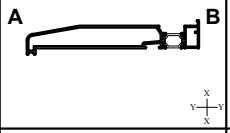
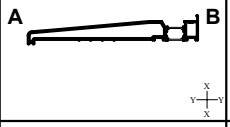
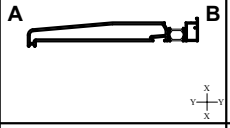
PROFILES : TECHNICAL INFORMATION

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ISSUED: MAY 2026

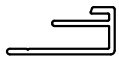
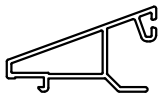
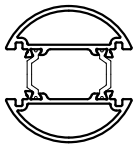
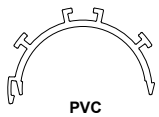
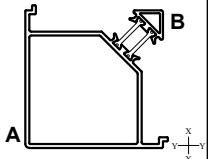
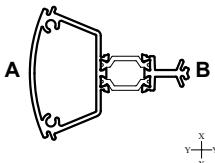
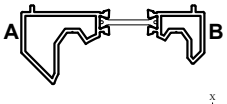
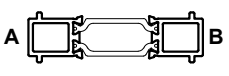
Number	Picture	Page	Perim. mm	Mec. mm	Ix(cm4) wx(cm3)	Iy(cm4) wy(cm3)	Length	Pack pr.	MF	SA	KL	HP	M
ETC083		A29	243	58	17.66 --- 4.32	2.64 --- 2.36	6.5	1	✓	✓	✓	✓	✓
ETC357		A30	297	138	41.5 --- 9.86	52 --- 2.67	6.5	1	✓	✓	✓	✓	✓
ETC451		A31	304	109	32.44 --- 7.29	3.46 --- 2.79	6.5	1	✓	✓	✓	✓	✓
ETC452		A31	414	197	122.46 --- 18.03	6.01 --- 3.34	6.5	1	✓	✓	✓	✓	✓
ETC457		A31	444	212	164.27 --- 21.60	6.79 --- 3.73	6.5	1	✓	✓	✓	✓	✓
ETC458		A32	524	252	313.62 --- 32.63	8.87 --- 4.79	6.5	1	✓	✓	✓	✓	✓
ETC477		A33	752	408	1591.6 --- 105.33	26.84 --- 12.84	6.5	1	✓	✓	✓	✓	✓
ETC479N		A32	594	287	501.64 --- 44.04	9.72 --- 5.34	6.5	1	✓	✓	✓	✓	✓
ETC572		A26	82	39	- --- -	- --- -	6.5	1	✓	✓	✓	✓	

A = Outside
B = Inside

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

Alitherm 400 HD Window

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
ETC770		A20	119	-	- --- -	- --- -	6.5	1	✓	✓	✓	✓	
ETC771		A20	159	47	- --- -	- --- -	6.5	1	✓	✓	✓	✓	
ETC869		A26	332	144	18.38 --- 6.13	14.3 --- 5.17	6.5	1	✓	✓	✓	✓	✓
PCX55		A35	207	-	- --- -	- --- -	3	1	✓				
UN3000		A30	251	41	15.8 --- 4.51	0.79 --- 0.84	6.5	1	✓	✓	✓	✓	✓
UN3010		A28	369	226	41.4 --- 10.7	40.0 --- 11.6	6.5	1	✓	✓	✓	✓	✓
UN3011		A28	288	130.3	22.3 --- 5	12.2 --- 4.1	6.5	1	✓	✓	✓	✓	✓
UN3012		A26	238	76	17.24 --- 4.78	1.53 --- 1.46	6.5	1	✓	✓	✓	✓	✓
UN3015		A30	214.5	56	18.1 --- 5.2	1 --- 1	6.5	1	✓	✓	✓	✓	✓

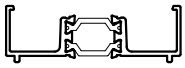
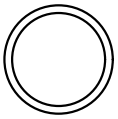
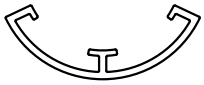
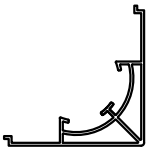
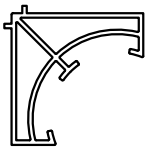
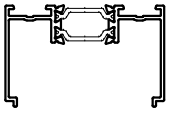
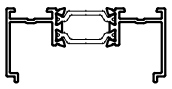
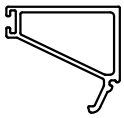
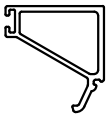
A = Outside
B = Inside

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

ISSUED: MAY 2026

Alitherm 400 HD Window

PROFILES : TECHNICAL INFORMATION

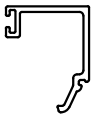
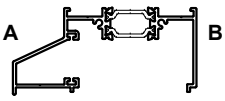
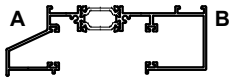
Number	Picture	Page	Perim. mm	Mec. mm	Ix(cm4) wx(cm3)	Iy(cm4) wy(cm3)	Length	Pack pr.	MF	SA	KL	HP	M
UN3020		A27	281.6	70.4	14.8 --- 4.2	0.9 --- 1	6.5	1	✓	✓	✓	✓	✓
UN3080		A35	-	-	4.69 --- 4.69	2.47 --- 2.47	6.5	1	✓				
UN3081		A35	189	68	- --- -	- --- -	6.5	1	✓	✓	✓	✓	
UN3082		A36	379	151	- --- -	- --- -	6.5	1	✓	✓	✓	✓	
UN3083		A36	235	12	- --- -	- --- -	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	✓	✓	✓	✓	✓
UN3400		A23	121	51	- --- -	- --- -	6.5	1	✓	✓	✓	✓	
UN3401		A23	114	47	- --- -	- --- -	6.5	1	✓	✓	✓	✓	

A = Outside
B = Inside

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

Alitherm 400 HD Window

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
UN3402		A24	131	43	- --- -	- --- -	6.5	1	✓	✓	✓	✓	
UN3403		A24	123	39	- --- -	- --- -	6.5	1	✓	✓	✓	✓	
UN3404		A25	115	35	- --- -	- --- -	6.5	1	✓	✓	✓	✓	
UN3405		A25	107	31	- --- -	- --- -	6.5	1	✓	✓	✓	✓	
UN3570		A34	545	140	47.47 --- 9.53	9.26 --- 4.87	6.5	1	✓	✓	✓	✓	✓
UN3577		A34	751	178	117.89 --- 17.11	15.81 --- 8.83	6.5	1	✓	✓	✓	✓	✓
VG964		A25	69	24	- --- -	- --- -	6.5	1	✓	✓	✓	✓	
VL72		A26	101	51	16.30 --- 4.66	1.12 --- 1.55	6.5	1	✓	✓	✓	✓	

A = Outside
B = Inside

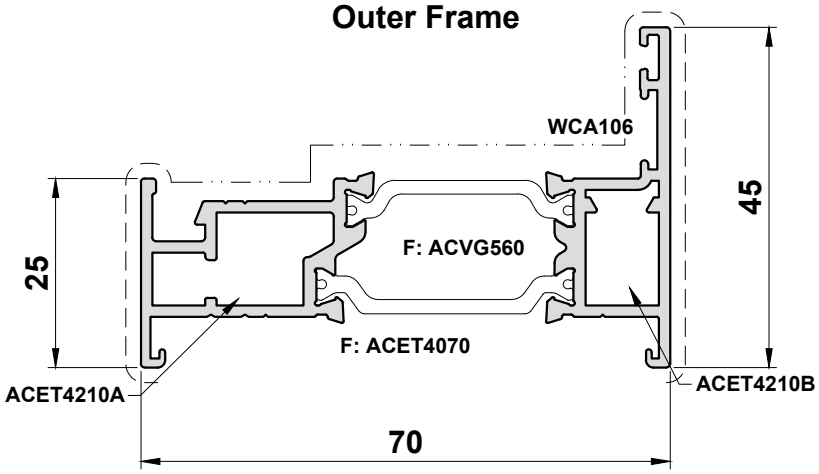
MF = Mill Finish
SA = Silver Anodised
KL = Basic Colour
HP = Special Colour
M = Dual Colour

ISSUED: MAY 2026

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

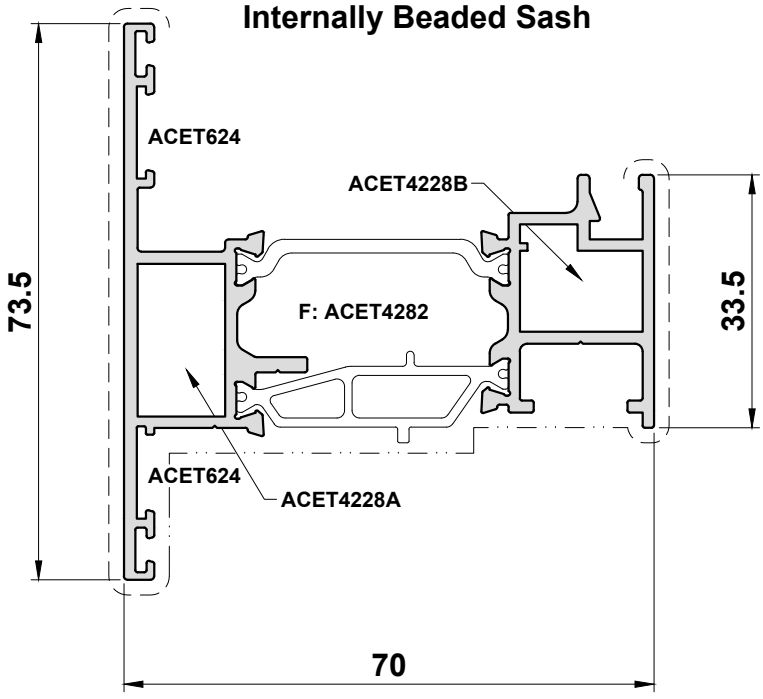
ETC4210

Outer Frame



ETC4229

Internally Beaded Sash

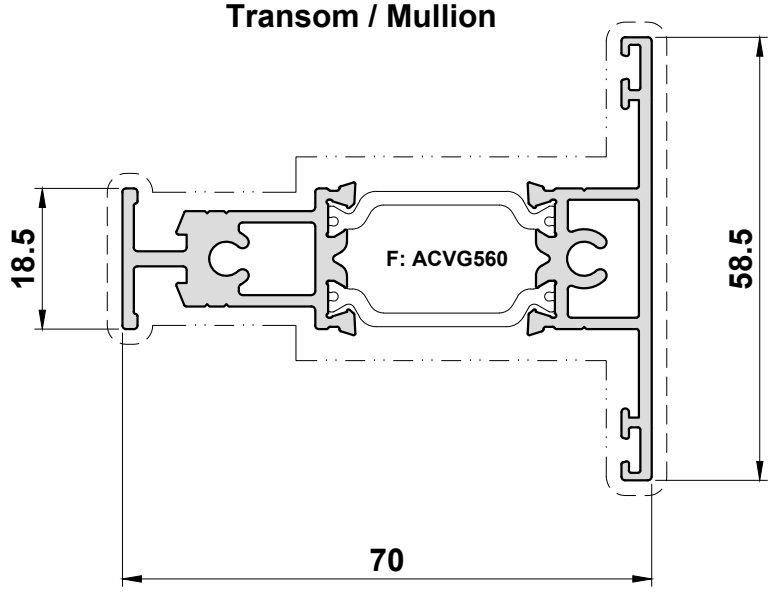


Scale 1:1

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

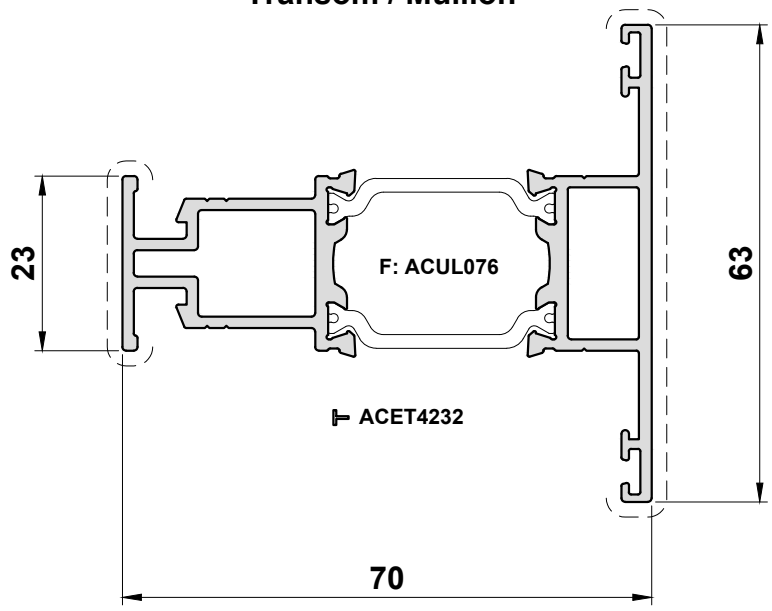
ETC4230

Transom / Mullion



ETC4232

Transom / Mullion

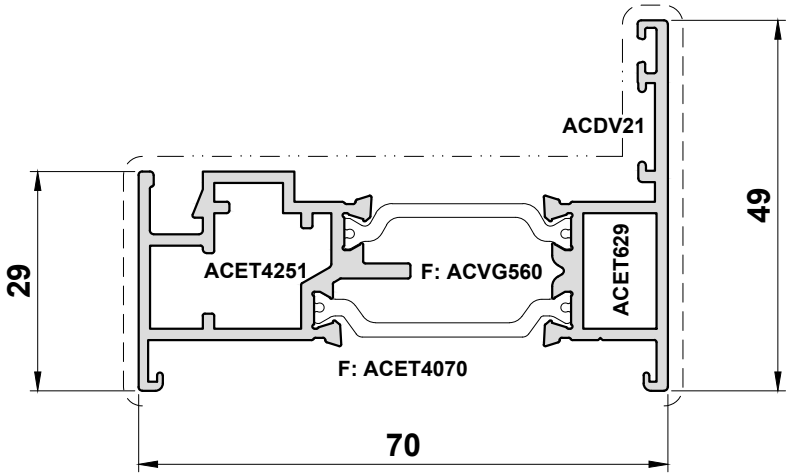


Scale 1:1

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

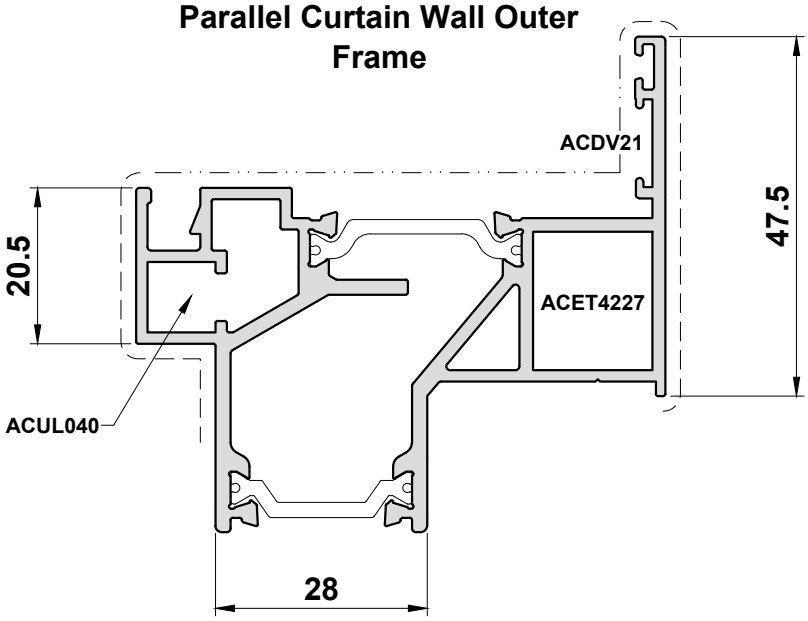
ETC4211

Parallel Outer Frame



ETC4217

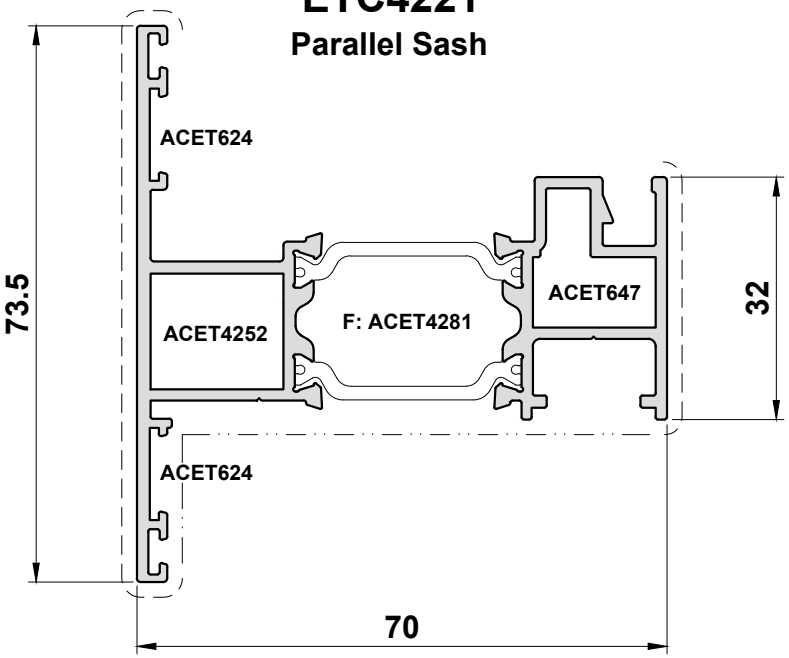
Parallel Curtain Wall Outer Frame



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

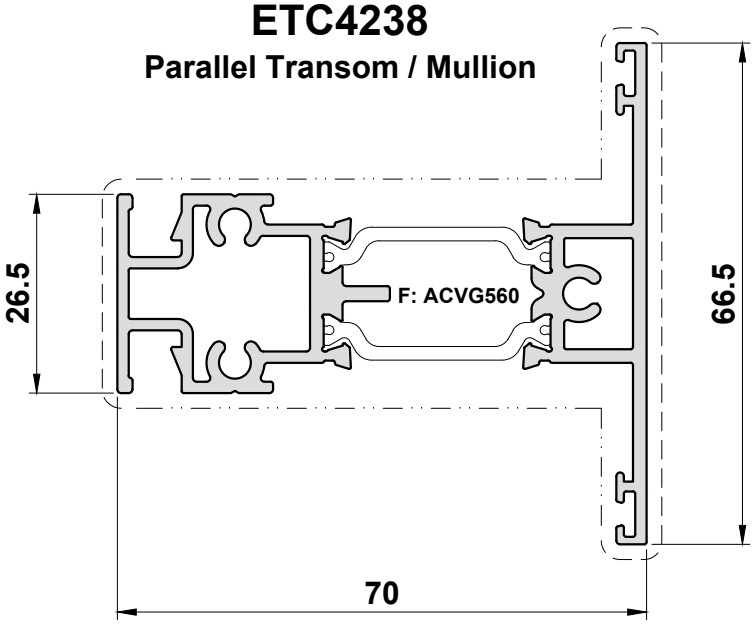
ETC4221

Parallel Sash



ETC4238

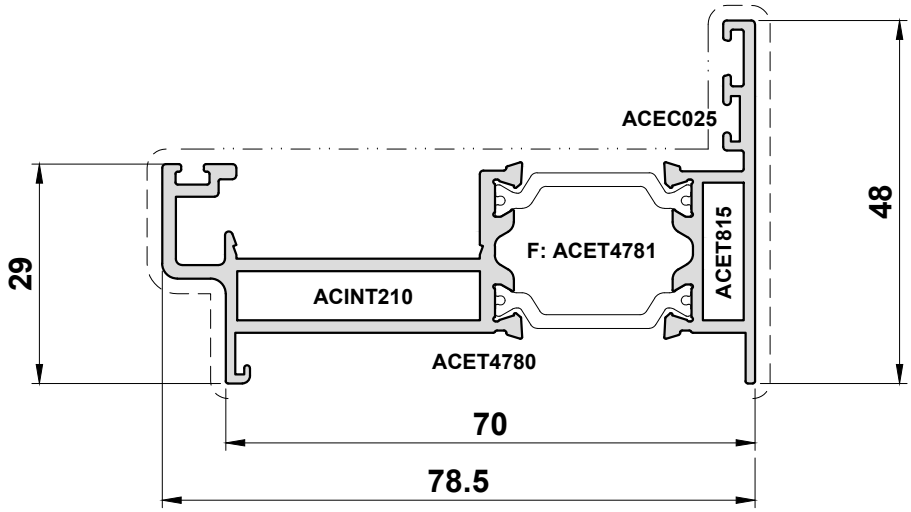
Parallel Transom / Mullion



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

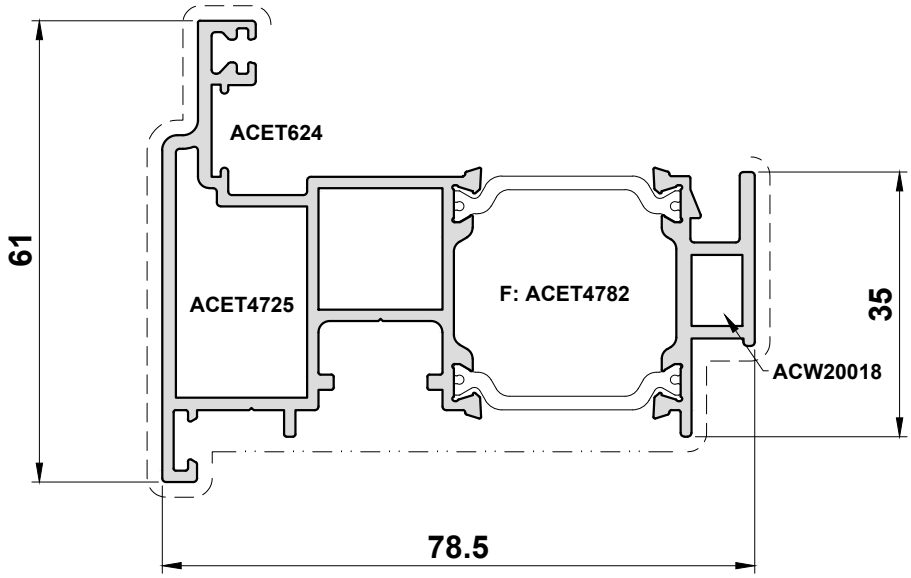
ETC4715

Reversible Outer Frame



ETC4725

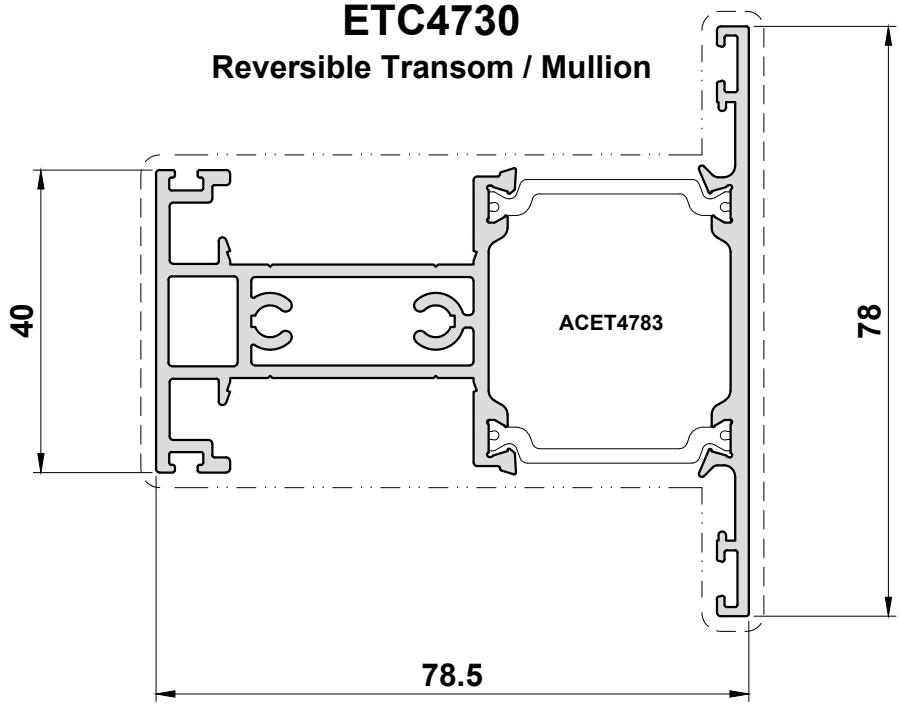
Reversible Sash



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

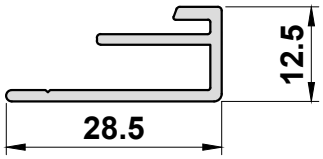
ETC4730

Reversible Transom / Mullion



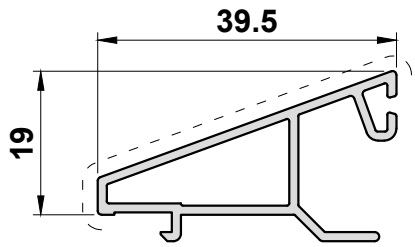
ETC770

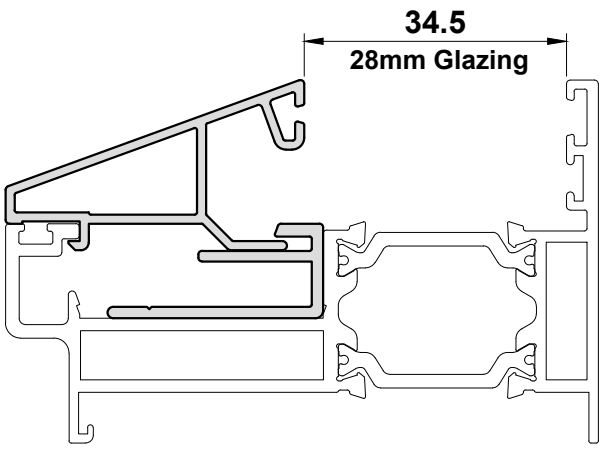
Glazing Adaptor



ETC771

39.5mm Glazing Bead

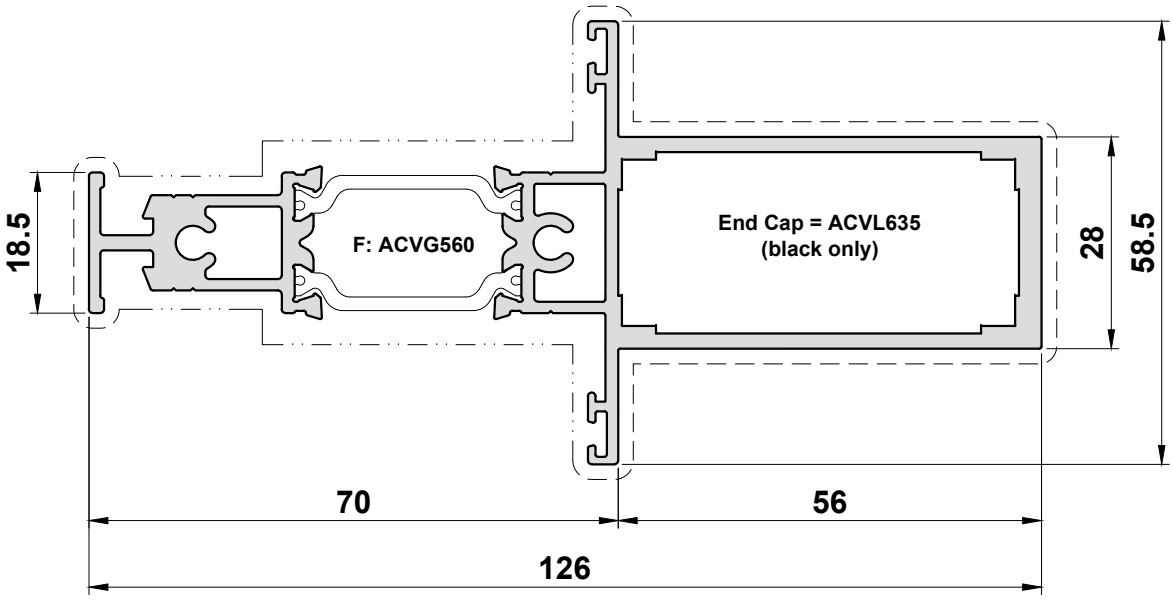




Primary Visible Side - - - - - - - - - - - - - - - - - - Secondary Visible Side — · — · — · — · — · —

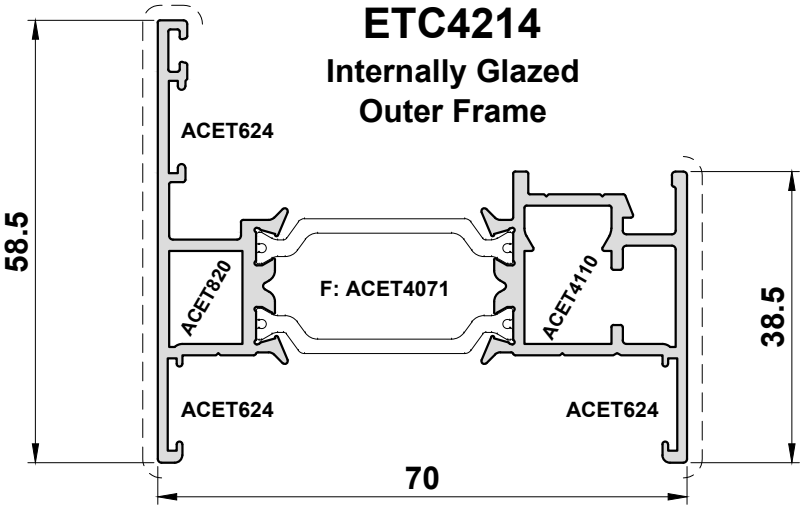
ETC4236

Reinforced Transom / Mullion

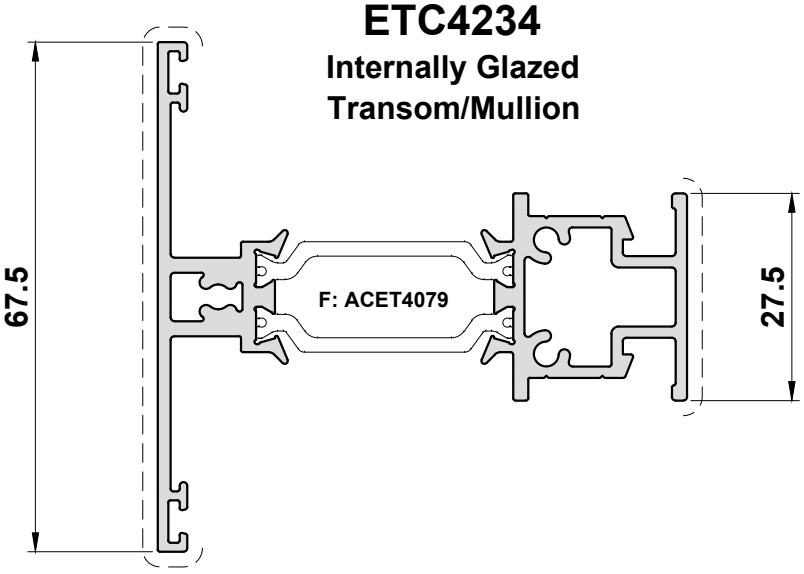


Primary Visible Side - - - - - - - - - - - - - - - - - - Secondary Visible Side — · — · — · — · — · — · —

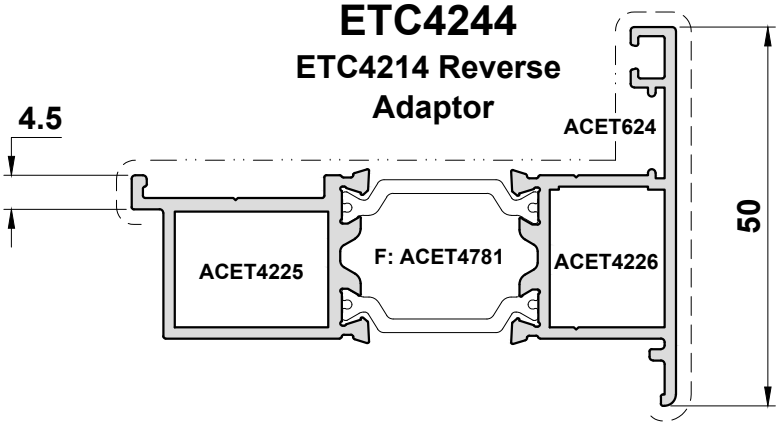
ETC4214
Internally Glazed Outer Frame



ETC4234
Internally Glazed Transom/Mullion

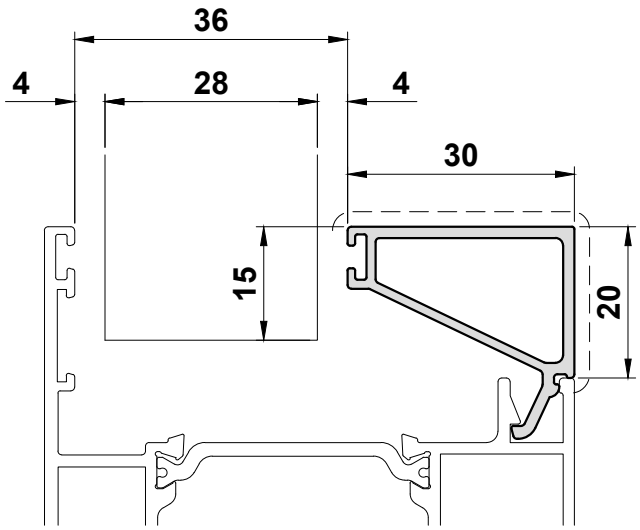


ETC4244
ETC4214 Reverse Adaptor



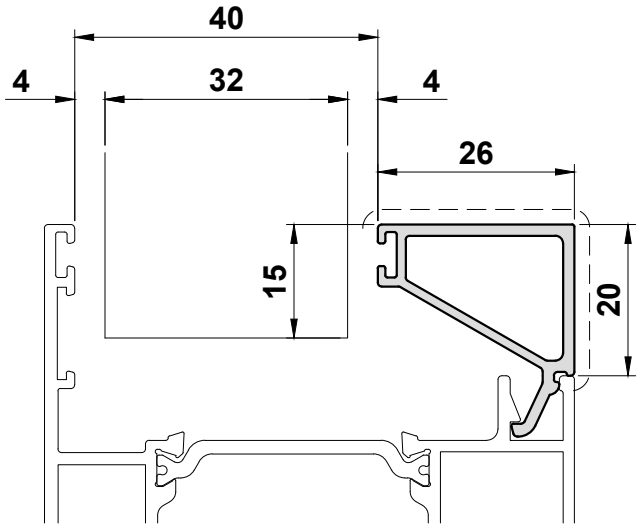
Scale 1:1

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



UN3400

30mm x 20mm
Tap In Bead

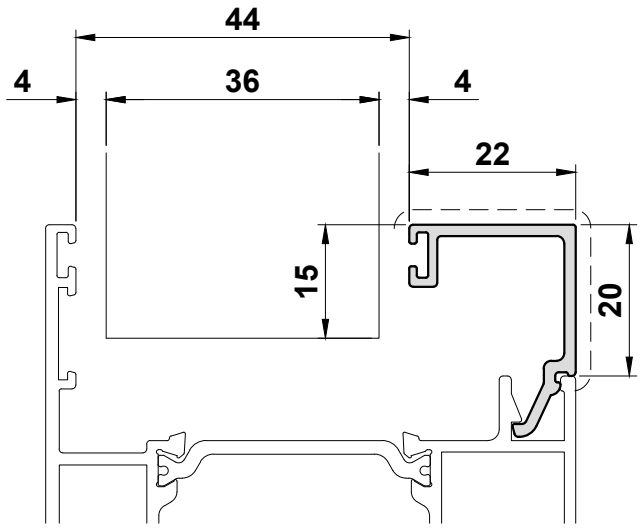


UN3401

26mm x 20mm
Tap In Bead

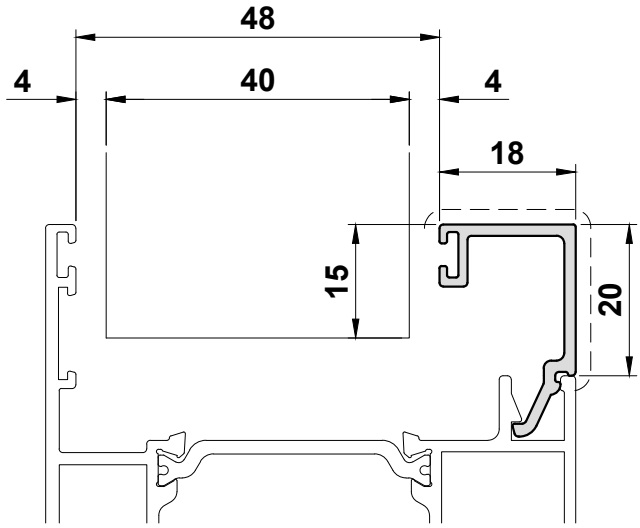
Scale 1:1

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



UN3402

22mm x 20mm
Tap In Bead

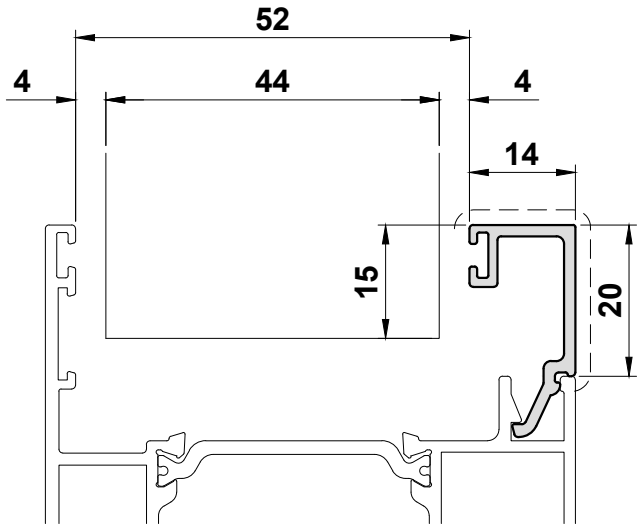


UN3403

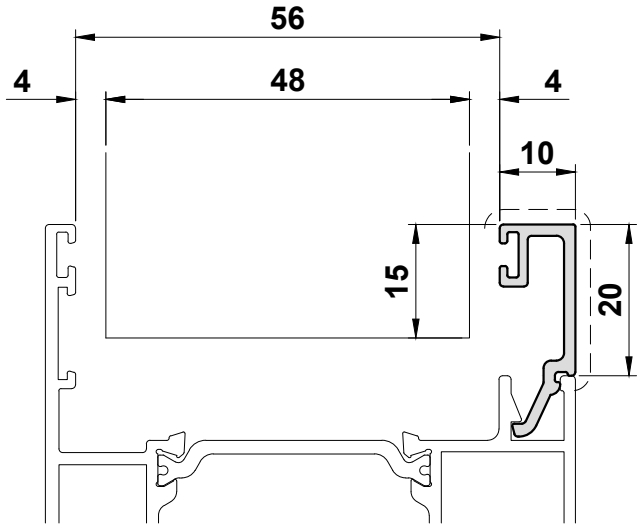
18mm x 20mm
Tap In Bead

Scale 1:1

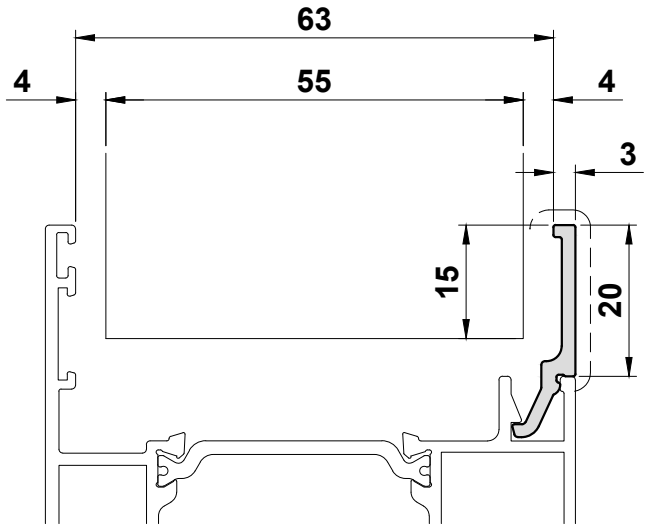
Primary Visible Side - - - - - - - - - - - - - - - - - - Secondary Visible Side — · — · — · — · — · — · —



UN3404
14mm x 20mm
Tap In Bead



UN3405
10mm x 20mm
Tap In Bead



VG964
3mm x 20mm
Tap In Bead

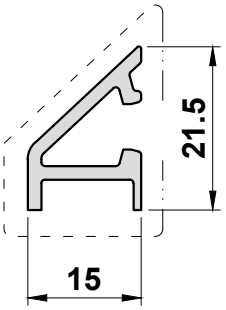
Scale 1:1

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

VL72

Drip / Weather Bar

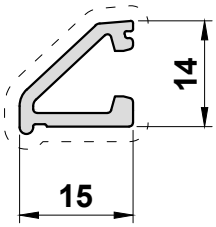
End Caps: ACVL059
Rivets: ACVL061



ETC572

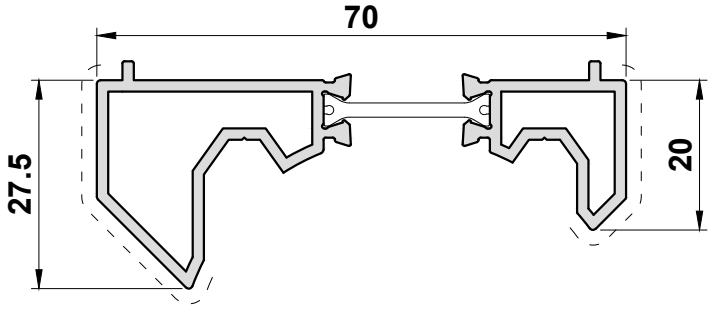
Drip / Weather Bar

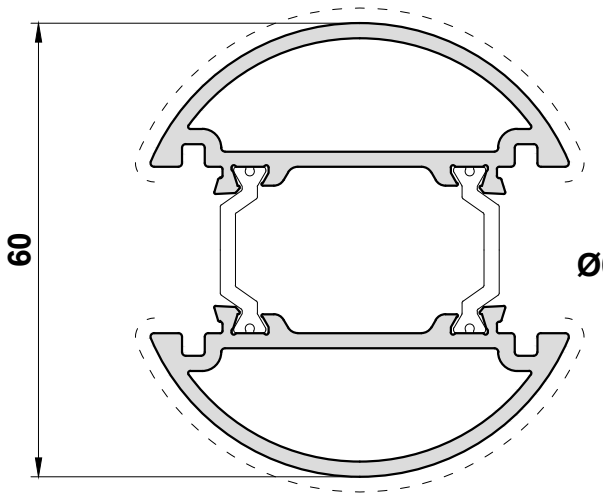
End Caps: ACVL059
Rivets: ACVL061



UN3012

Bay Pole Adaptor





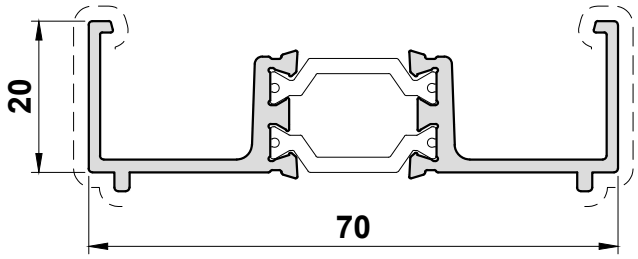
ETC869

Ø60mm Bay Pole

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

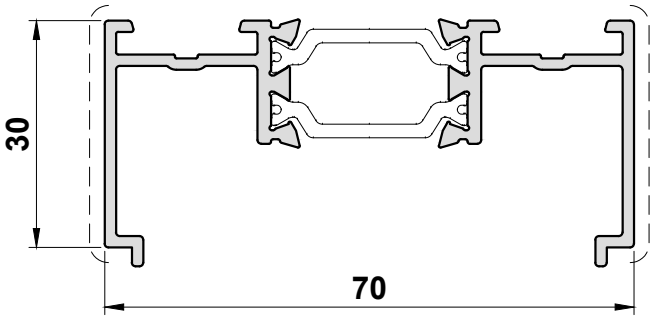
UN3020

70mm x 20mm Frame Extension



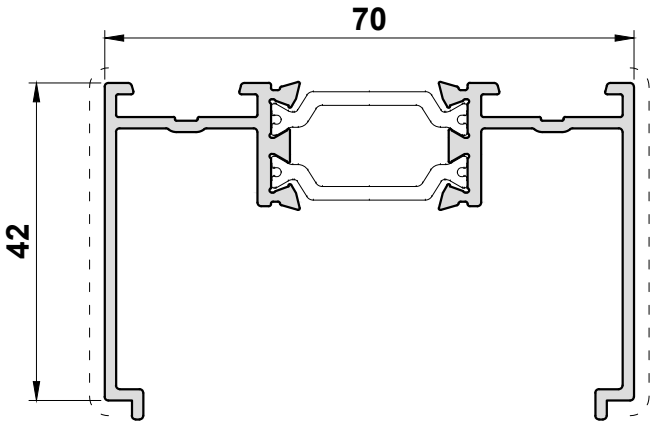
UN3370

30 x 70mm Head Extension



UN3270

70 x 42mm Head Extension

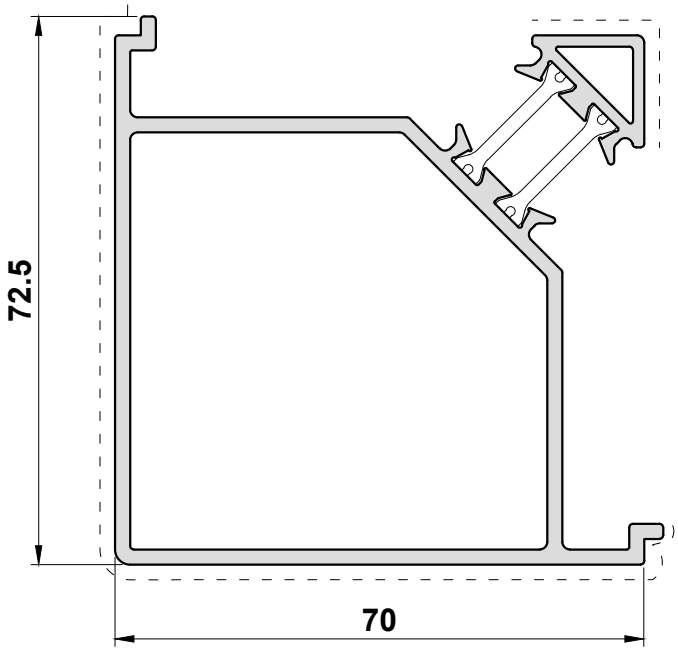


Scale 1:1

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

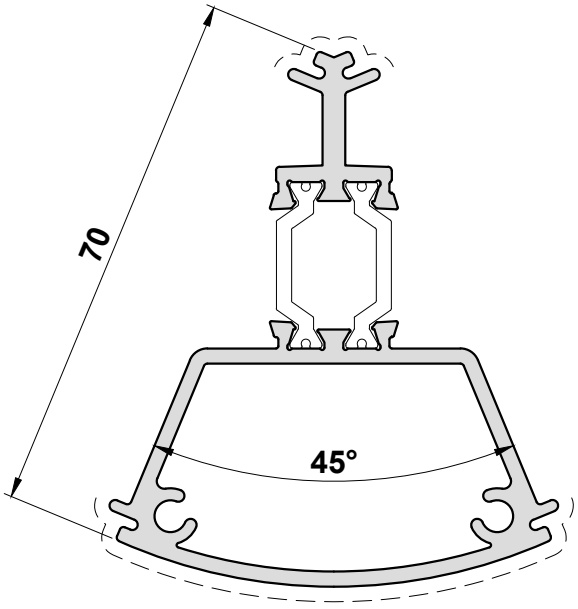
UN3010

90° Corner Post



UN3011

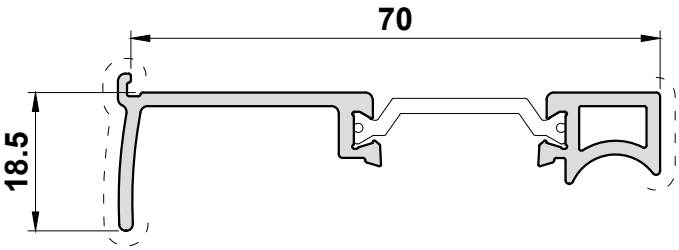
135° Bay Pole



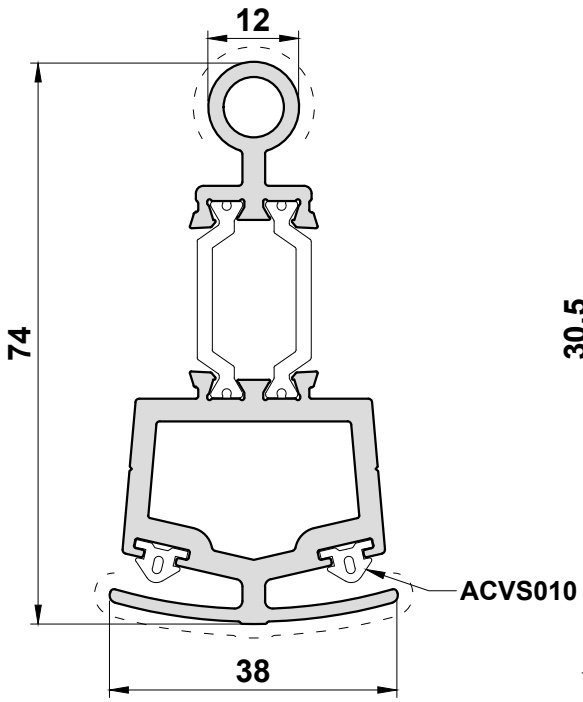
Scale 1:1

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

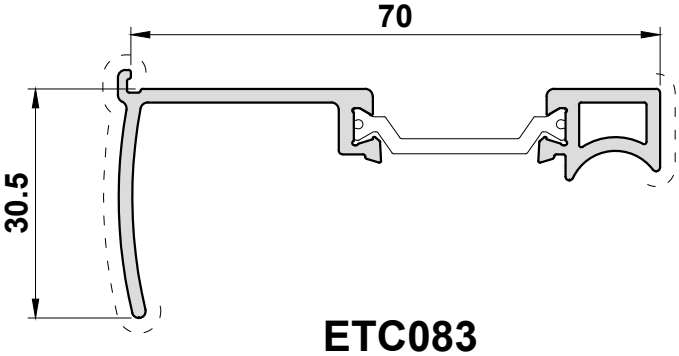
ETC081
169° - 150°
Bay Pole Adaptor



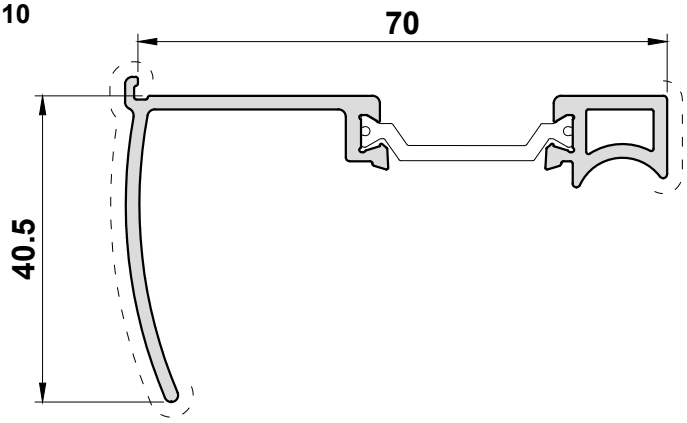
ETC080
Bay Pole



ETC082
149° - 130°
Bay Pole Adaptor



ETC083
129° - 115°
Bay Pole Adaptor

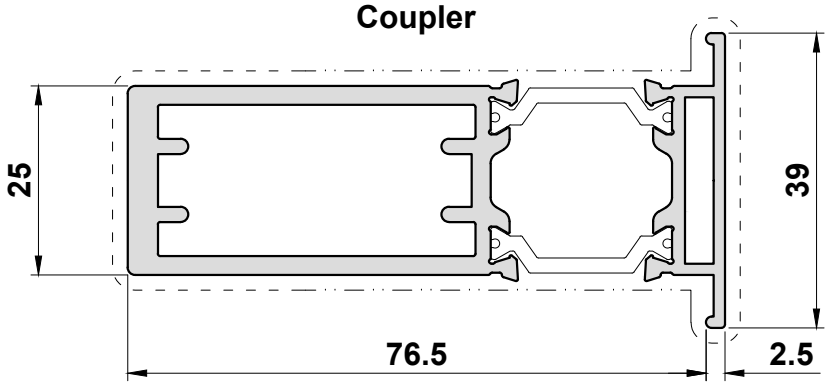


Scale 1:1

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

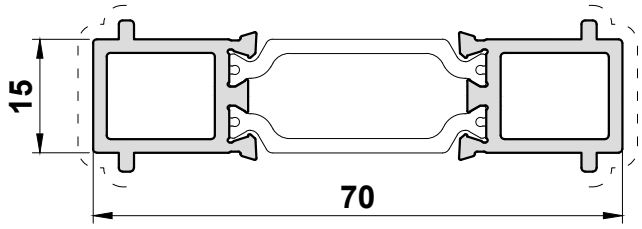
ETC357

Coupler



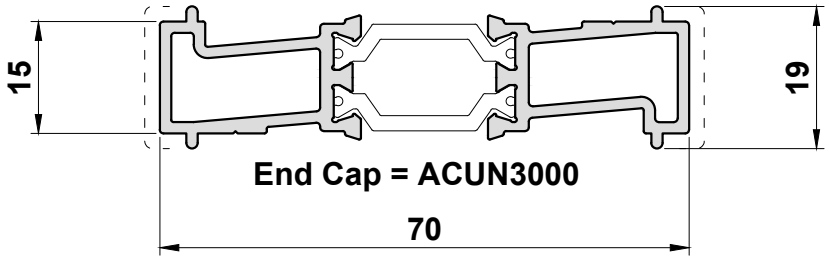
UN3015

70mm x 15mm Coupler



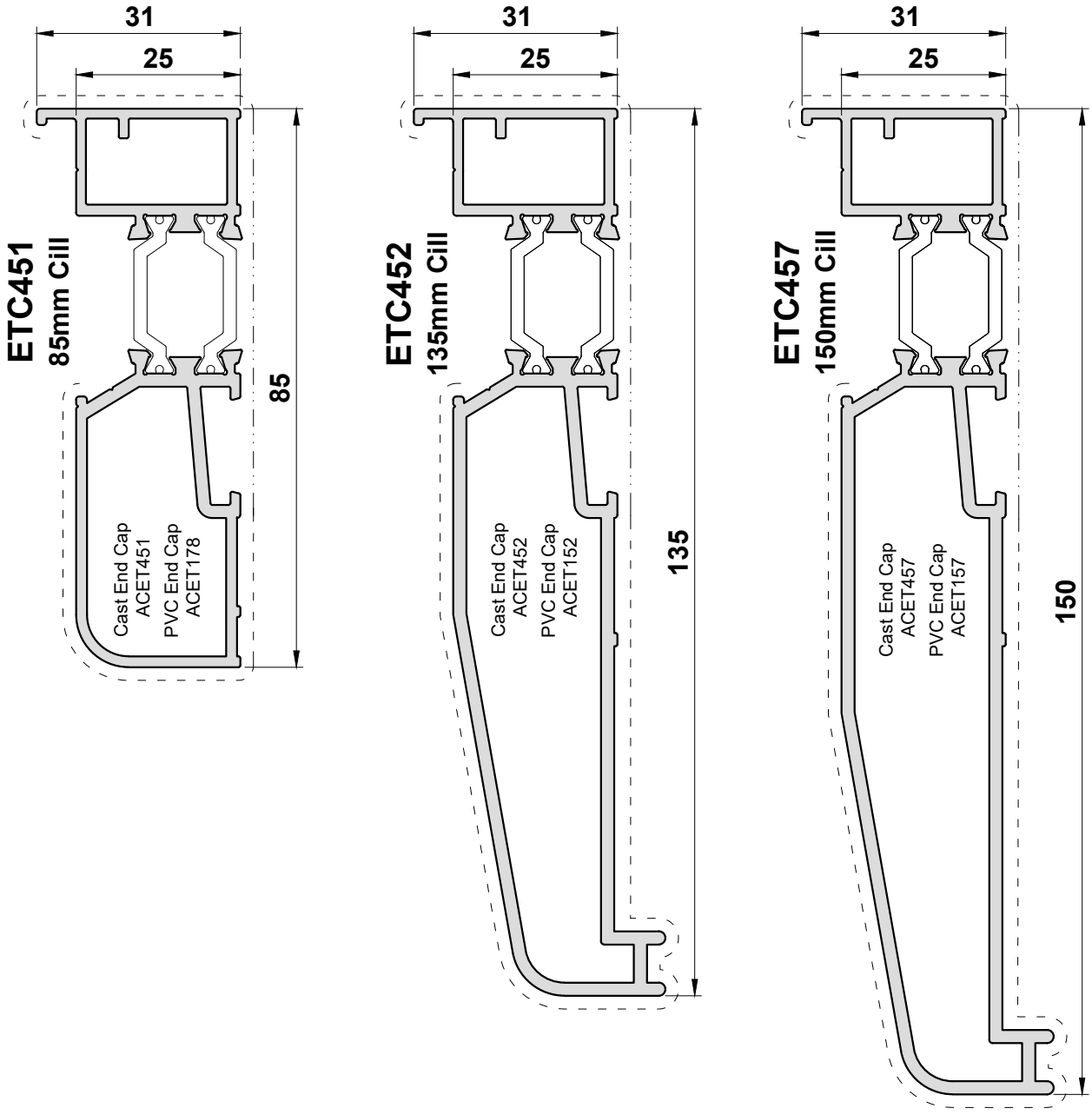
UN3000

Flush Horizontal Coupler



Scale 1:1

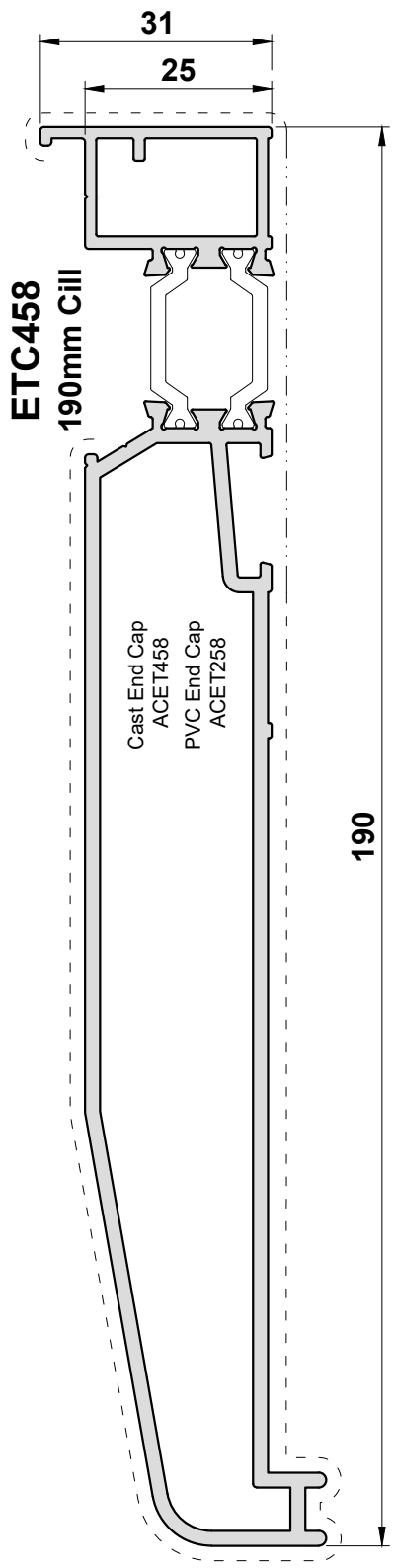
Primary Visible Side - - - - - - - - - - - - - - - - - - Secondary Visible Side —·—·—·—·—·—·—

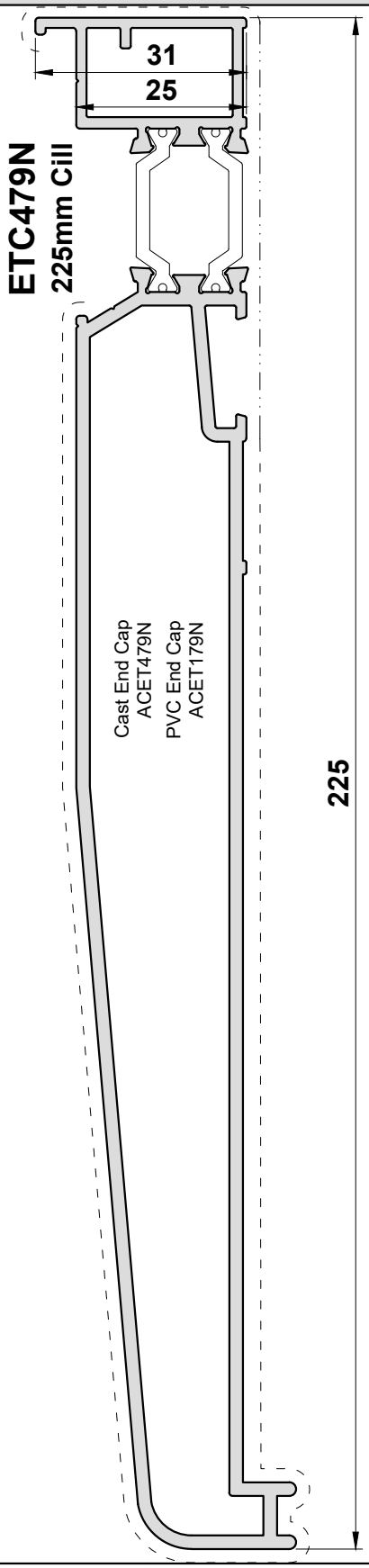


Scale 1:1

Primary Visible Side

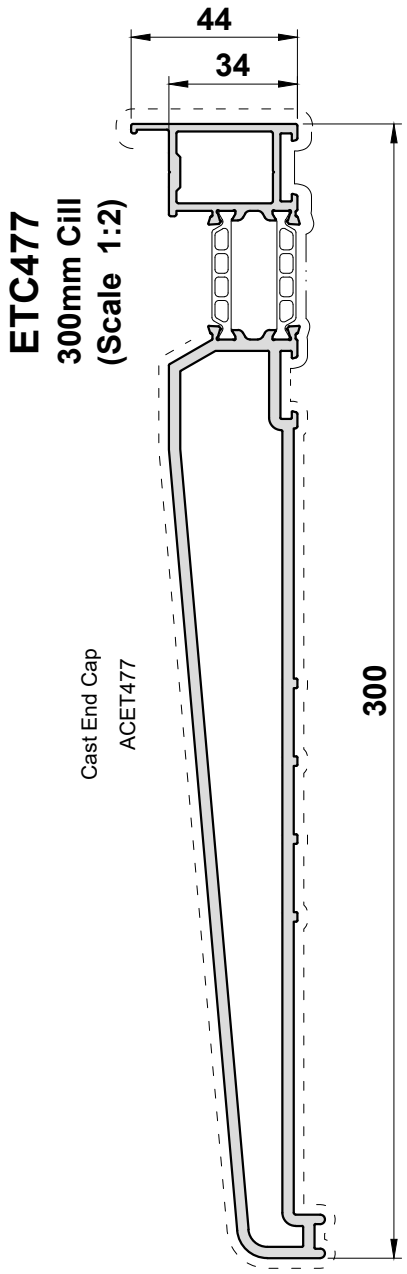
Secondary Visible Side





Scale 1:1

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

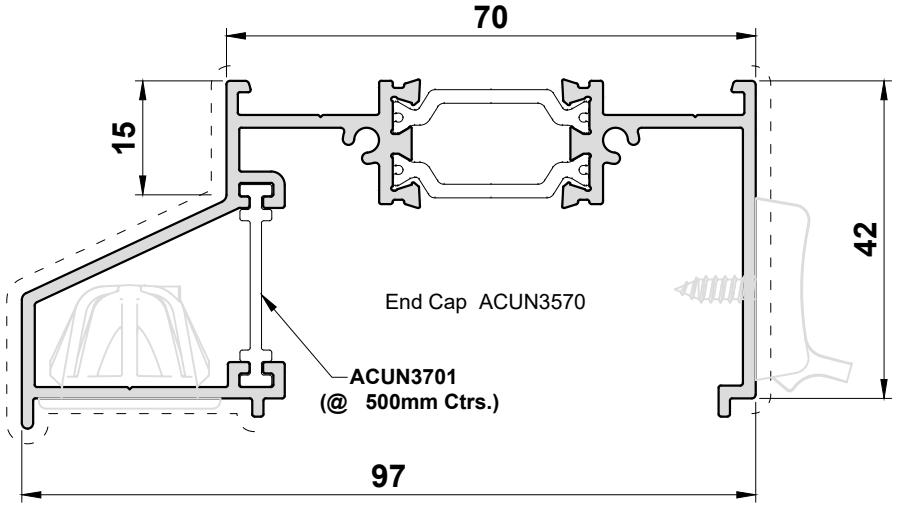


Scale NTS

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

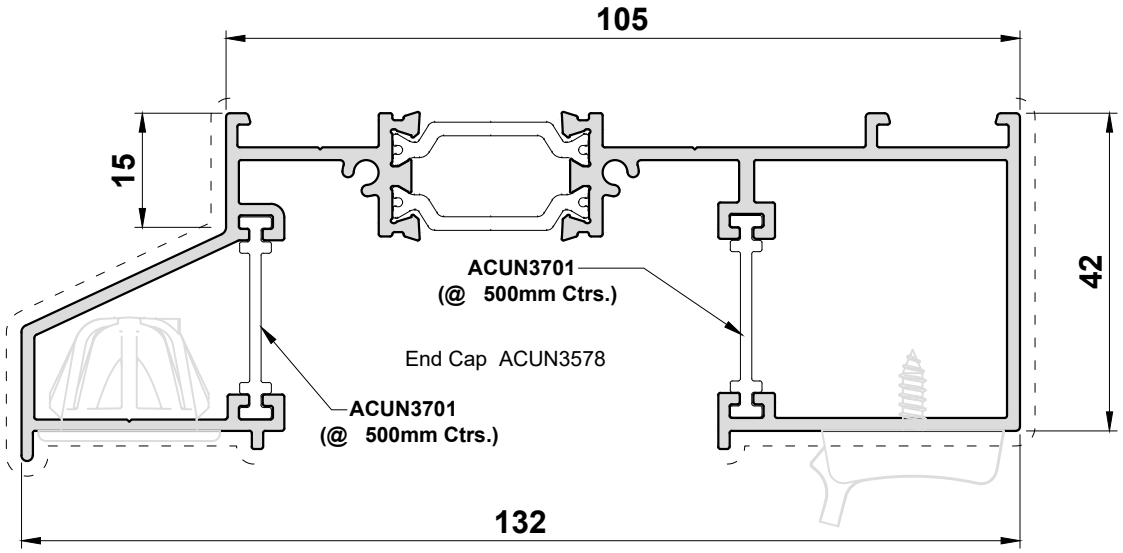
UN3570

42mm Hooded Head Extension For 70mm Sections



UN3577

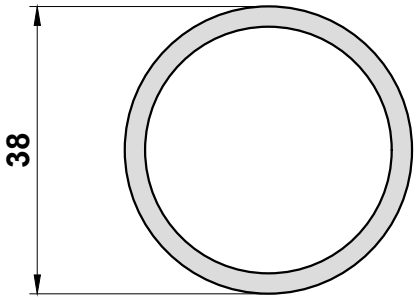
42mm Hooded Wide Head Extension For 70mm Sections



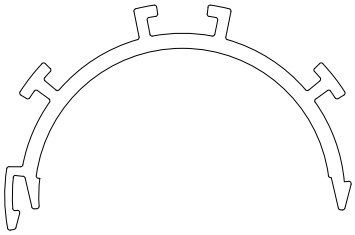
Scale 1:1

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

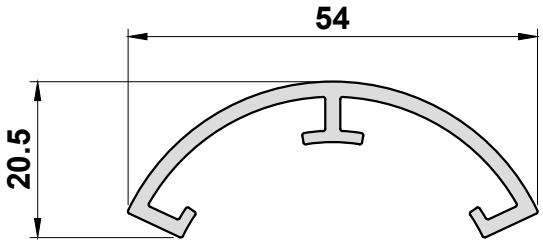
UN3080
Bay Pole



PCX55
PVC Isolator for UN3080



UN3081
Round Bay Pole Cover for UN3080

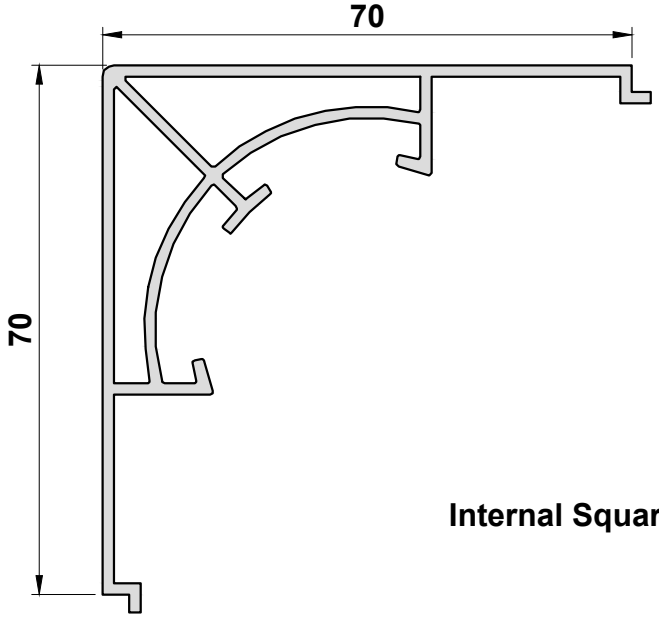


Scale 1:1

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

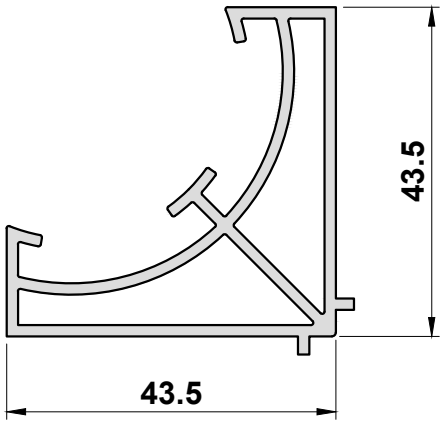
UN3082

External Square Bay Pole Cover for UN3080



UN3083

Internal Square Bay Pole Cover for UN3080



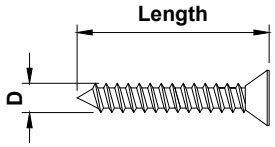
Scale 1:1

Section B

Accessories

Photos & Drawings

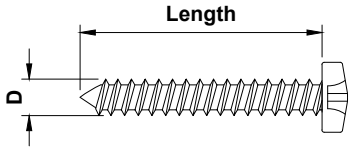
Countersunk Screws



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

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

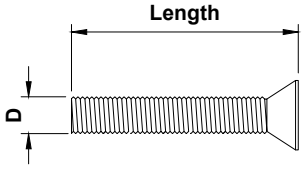
Pan Head Screws



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

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

Machine Screws

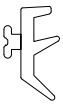


Thread	'D' (mm) Nominal
M4	4
M5	5
M6	6
M8	8
M10	10

Part Number	Thread	X	Length	Description	Box Qty.
ACET122	M4	X	10	CSK Pozi Machine Screw	100
ACET123	M4	X	20	CSK Pozi Machine Screw	100
ACDV264	M4	X	35	CSK Pozi Machine Screw	100
ACSG071	M4	X	40	CSK Pozi Machine Screw	100
ACDV266	M4	X	45	CSK Pozi Machine Screw	100
ACDV262	M4	X	50	CSK Pozi Machine Screw	100
ACDV265	M4	X	60	CSK Pozi Machine Screw	100
ACDR051	M5	X	10	CSK Pozi Machine Screw	100
ACET069	M5	X	12	CSK Pozi Machine Screw	100
HEA132	M5	X	16	CSK Pozi Machine Screw	100
WCA134	M5	X	20	CSK Pozi Machine Screw	100
WCA143	M5	X	25	CSK Pozi Machine Screw	50
ACVS061	M5	X	40	CSK Pozi Machine Screw	100
ACET133	M5	X	50	CSK Pozi Machine Screw	100
ACET220	M5	X	60	CSK Pozi Machine Screw	100
ACET238	M5	X	70	CSK Pozi Machine Screw	100
ACMX861	M5	X	80	DIN965 - CSK Machine Screw	10
ACMX862	M5	X	90	DIN965 - CSK Machine Screw	10
ACUN3503	M6	X	10	CSK Socket Machine Screw	24
ACUN3525	M6	X	13	CSK Flange Socket Machine Screw	48
ACMX852	M6	X	16	DIN965 - CSK Machine Screw	10
ACET235	M6	X	60	CSK Pozi Machine Screw	100
ACET237	M6	X	70	CSK Pozi Machine Screw	100

Glazing Gaskets

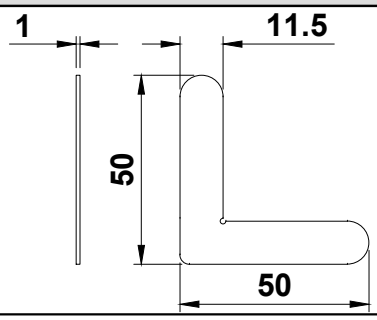
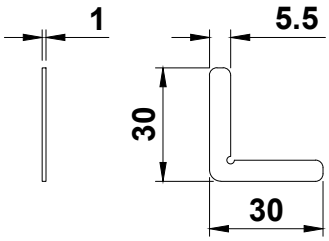
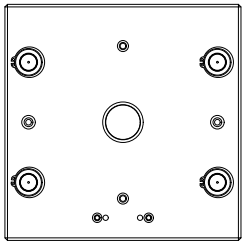
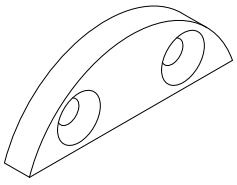
Retaining Gasket
Commonly known as an E Gasket. Retaining gaskets create a seal between the Glass and the Aluminium Profile.

High Line	2mm		**ACVG231**
			200m
			BL
	3mm		**ACVG31 (S)**
			200m
			BL
	4mm		**ACVG131 (N)**
			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.

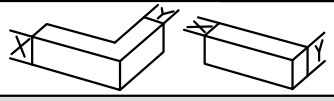
High Line	3mm		**ACVG32**
			100m
			BL
	3mm		**ACVG32N**
			100m
			BL
	4mm		**ACVG33**
			100m
			BL
	4mm		**ACVG33N**
			100m
			BL
	5mm		**ACVG34**
			100m
			BL
	5mm		**ACVG34N**
			100m
			BL
	6mm		**ACVG340**
			200m
			BL
	6mm		**ACVG340N**
			100m
			BL
Low Line	4mm - 3mm		**ACW20038**
			200m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

Image	Part Code	Pack	Unit	Application	Colour
	**ACDV21** **Stainless Steel Chevron**	**100**	**pack**	**ETC4211**	MF SA KL HP SSC SMC W Z PC
	**ACDV268** **Bubble Gasket with Arrow Head**	**100**	**m**	**ETC4715**	MF SA KL HP SSC SMC W Z PC
	**ACEC025** **Stainless Steel Chevron**	**100**	**pack**	**ETC4715**	MF SA KL HP SSC SMC W Z PC
	**ACDV916** **Bead Punch Tool**	**1**	**each**		MF SA KL HP SSC SMC W Z PC
	**ACET041** **Cill Nose Bracket**	**1**	**Each**	**ETC451** **ETC452** **ETC457** **ETC458** **ETC477** **ETC479**	MF ✓ SA KL HP SSC SMC W Z PC



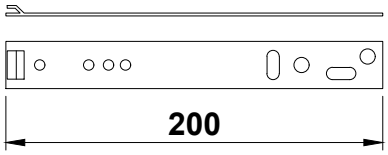
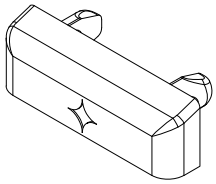
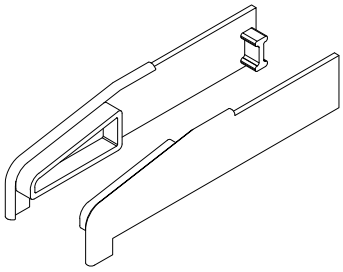
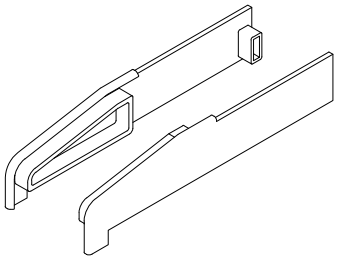
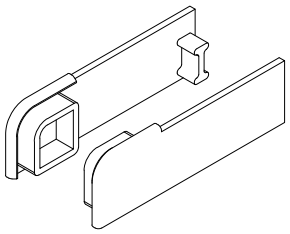


MF = Mill Finish
SA = Silver Anodised
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HP = Special Colour
SSC = Smooth Satin Chrome
SMC = Smokey Chrome
PC = Polished Chrome
W = White
Z = Black



Alitherm 400 HD Window

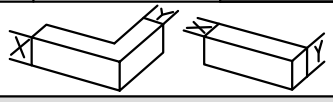
ACCESSORIES : PHOTOS & DRAWINGS

Image	Part Code	Pack	Unit	Application	Colour	
	**ACET130** **Galvanised Steel Fixing Strap** **200mm x 25mm x 1.5mm**	**100**	**Pack**	**ETC4210**	MF SA KL HP SSC SMC W Z PC	
	**ACET131** **Drainage Cover Cap** **For colour matched drainage caps, please order ACET432**	**100**	**Pack**	**ETC4210** **ETC4229** **UN3000**	MF SA KL HP SSC SMC W Z PC	 ✓ ✓
	**ACET152** **Cill End Cap**	**10**	**Pair**	**ETC452**	MF SA KL HP SSC SMC W Z PC	 ✓ ✓
	**ACET157** **Cill End Cap**	**10**	**Pair**	**ETC457**	MF SA KL HP SSC SMC W Z PC	 ✓ ✓
	**ACET178** **Cill End Cap**	**10**	**Pair**	**ETC451**	MF SA KL HP SSC SMC W Z PC	 ✓ ✓

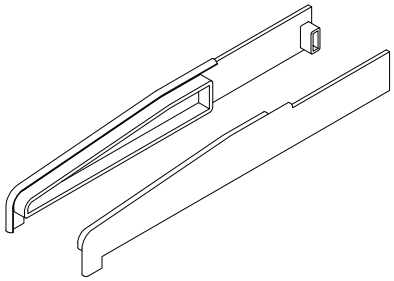
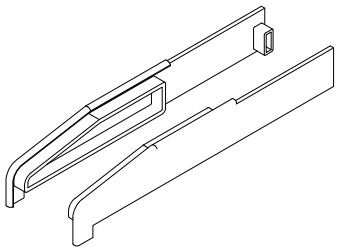
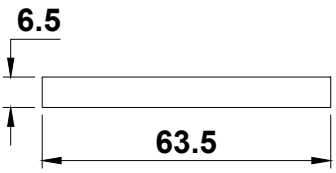
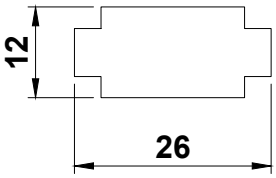
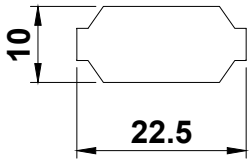




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ISSUED: MAY 2026

Image	Part Code	Pack	Unit	Application	Colour	
	**ACET179N** **Cill End Cap**	**10**	**Pair**	**ETC479N**	MF SA KL HP SSC SMC W Z PC	 ✓ ✓
	**ACET258** **Cill End Cap**	**10**	**Pair**	**ETC458**	MF SA KL HP SSC SMC W Z PC	 ✓ ✓
	**ACET4070** **Foam** **Length = 1250mm**	**1**	**Each**	**ETC4210**	MF SA KL HP SSC SMC W Z PC	 ✓
	**ACET4071** **Foam** **Length = 1250mm**	**1**	**Each**	**ETC4214**	MF SA KL HP SSC SMC W Z PC	 ✓
	**ACET4079** **Foam** **Length = 1250mm**	**1**	**Each**	**ETC4234**	MF SA KL HP SSC SMC W Z PC	 ✓





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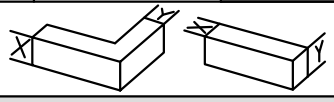
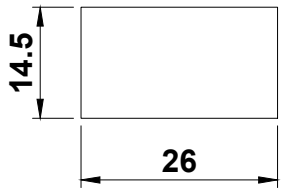
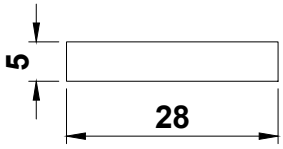
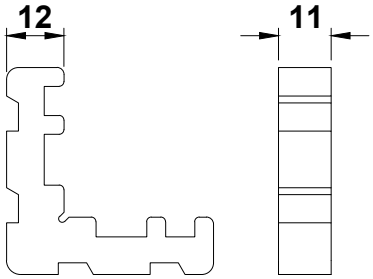
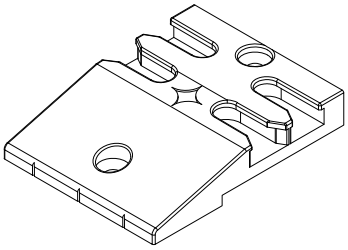
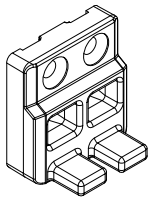


Image	Part Code	Pack	Unit	Application	Colour
	**ACET4081** **Self Adhesive Foam**	**150**	**m**	**ETC4229**	MF SA KL HP SSC SMC W Z ✓ PC
	**ACET4082** **Self Adhesive Foam**	**200**	**m**	**ETC4210**	MF SA KL HP SSC SMC W Z ✓ PC
	**ACET4110** **Crimping Cleat**	**24**	**Pack**	**ETC4214**	MF SA KL HP SSC SMC W Z PC
	**ACET4218** **Mushroom Keep**	**1**	**Each**		MF SA KL HP SSC SMC W Z PC
	**ACET4219** **Shootbolt Keep**	**1**	**Each**		MF SA KL HP SSC SMC W Z PC



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



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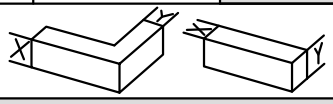
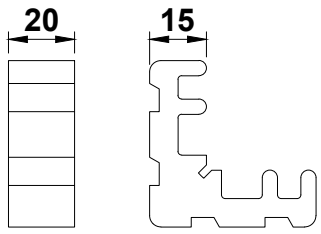
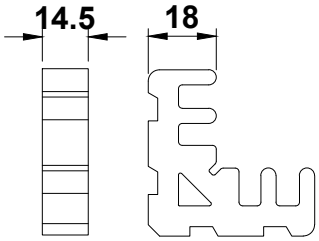
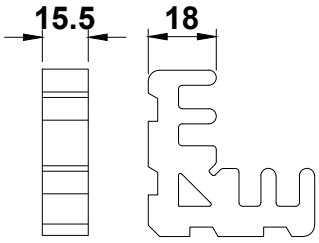
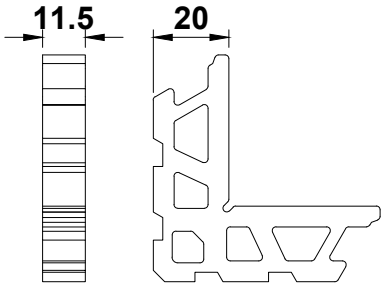
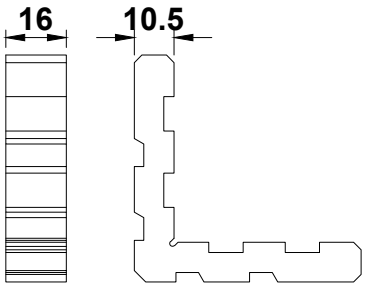


Image	Part Code	Pack	Unit	Application	Colour
	**ACET4225** **Crimping Cleat**	**24**	**Pack**	**ETC4244**	MF SA KL HP SSC SMC W Z PC
	**ACET4226** **Crimping Cleat**	**24**	**Pack**	**ETC4244**	MF SA KL HP SSC SMC W Z PC
	**ACET4227** **Crimping Cleat**	**24**	**Pack**	**ETC4217**	MF SA KL HP SSC SMC W Z PC
	**ACET4228A** **Crimping Cleat**	**24**	**Pack**	**ETC4229**	MF ✓ SA KL HP SSC SMC W Z PC
	**ACET4228B** **Crimping Cleat**	**24**	**Pack**	**ETC4229**	MF ✓ SA KL HP SSC SMC W Z PC



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ACVG66=3.0mm
ACVL150=4.0mm



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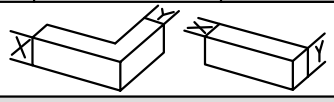
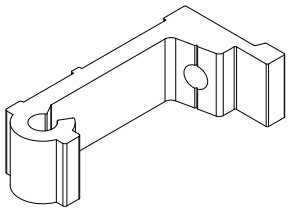
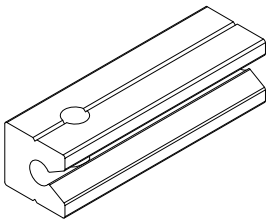
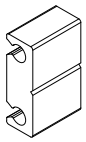
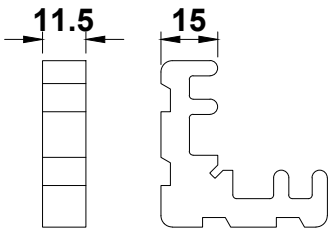
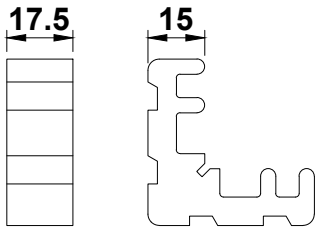


Image	Part Code	Pack	Unit	Application	Colour	
	**ACET4232** **Cruciform Bracket**	**10**	**Pack**	**ETC4232**	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
	**ACET4233** **Transom Bracket**	**10**	**Pack**	**ETC4232**	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
	**ACET4234** **Anti-Twist Block**	**10**	**Pack**	**ETC4232**	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
	**ACET4251** **Crimping Cleat**	**24**	**Pack**	**ETC4211**	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
	**ACET4252** **Crimping Cleat**	**24**	**Pack**	**ETC4221**	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	

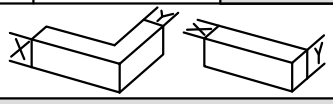


T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm



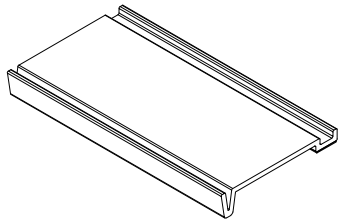
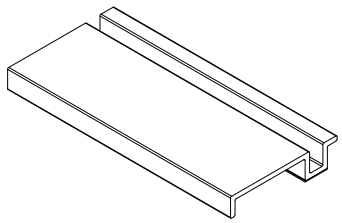
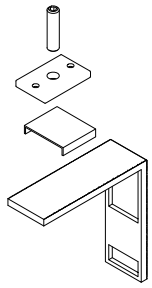
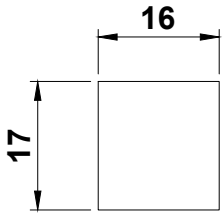
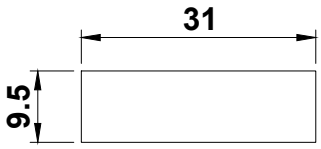
Screw (Grub)

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Alitherm 400 HD Window

ACCESSORIES : PHOTOS & DRAWINGS

Image	Part Code	Pack	Unit	Application	Colour	
	**ACET4258** **Bridge Packer**	**12**	**Pack**	**ETC4229**	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
	**ACET4259** **Bridge Packer**	**12**	**Pack**	**ETC4221**	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
	**ACET4280** **Glass Adjuster Kit** **Kit Includes:** **1 x Adjusting Screw** **1 x Threaded Block** **1 x Steel Cover** **1 x ABS Corner**	**1**	**Kit**	**ETC4229**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	✓
					PC	
	**ACET4281** **Foam** **Length = 1250mm**	**1**	**Each**	**ETC4221**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	✓
					PC	
	**ACET4282** **Foam** **Length = 1250mm**	**1**	**Each**	**ETC4229**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	✓
					PC	



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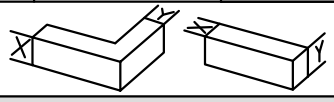
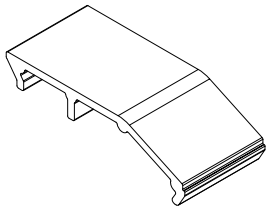
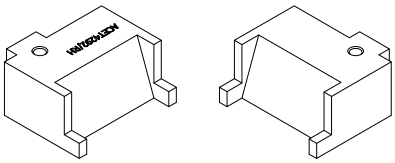
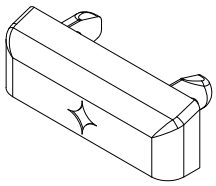


Image	Part Code	Pack	Unit	Application	Colour	
	**ACET4285** **Run Up Block**	**100**	**Pack**	**ETC4229**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	✓
					PC	
	**ACET4292** **Punches**	**1**	**Each**	**ETC4210**	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
	**ACET432** **Drainage Cover Cap (Colour Match)**	**10**	**Pack**	**ETC4210 ETC4229 UN3000**	MF	
					SA	
					KL	✓
					HP	✓
					SSC	
					SMC	
					W	✓
					Z	✓
					PC	
	**ACET4380** **8mm Crimping Support**	**1**	**Each**	**ACET4383**	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
	**ACET4381** **10mm Crimping Support**	**1**	**Each**	**ACET4383**	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	



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

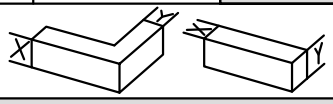
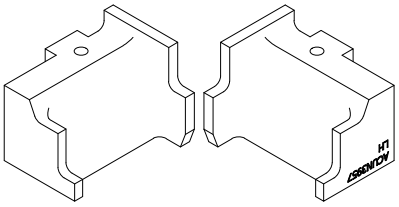
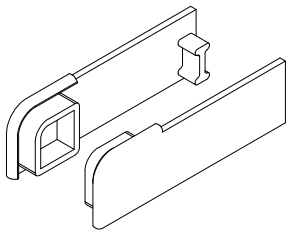
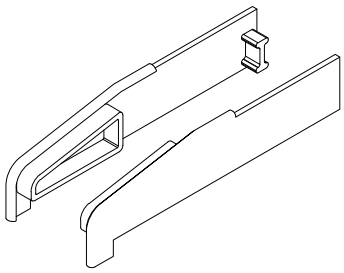
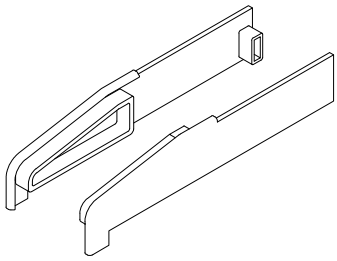


Image	Part Code	Pack	Unit	Application	Colour
	**ACET4383** **22.5mm Crimping Support**	**1**	**Each**	**ACET4380** **ACET4381** **ETC4210** **ETC4229**	MF ✓ SA KL HP SSC SMC W Z PC
	**ACET4399** **Punches**	**1**	**Each**	**ETC4229**	MF SA KL HP SSC SMC W Z PC
	**ACET451** **Cill End Cap**	**1**	**Pair**	**ETC451**	MF ✓ SA KL ✓ HP ✓ SSC SMC W ✓ Z ✓ PC
	**ACET452** **Cill End Cap**	**1**	**Pair**	**ETC452**	MF ✓ SA KL ✓ HP ✓ SSC SMC W ✓ Z ✓ PC
	**ACET457** **Cill End Cap**	**1**	**Pair**	**ETC457**	MF ✓ SA KL ✓ HP ✓ SSC SMC W ✓ Z ✓ PC

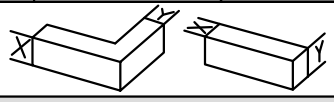


T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm



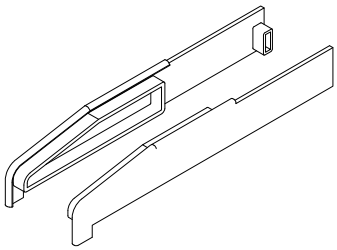
Screw (Grub)

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



Alitherm 400 HD Window

ACCESSORIES : PHOTOS & DRAWINGS

Image	Part Code	Pack	Unit	Application	Colour	
	**ACET458** **Cill End Cap**	**1**	**Pair**	**ETC458**	MF	✓
					SA	
					KL	✓
					HP	✓
					SSC	
					SMC	
					W	✓
					Z	✓
					PC	
	**ACET460** **Inline Espag Handle with 9mm Spindle**	**1**	**Each**	**ACET4260**	MF	
					SA	
					KL	✓
					HP	✓
					SSC	✓
					SMC	✓
					W	✓
					Z	✓
					PC	✓
	**ACET461** **Inline Espag Handle with 15mm Spindle**	**1**	**Each**	**ACET4211 to ACET4215 ACET4271 to ACET4277**	MF	
					SA	
					KL	✓
					HP	✓
					SSC	✓
					SMC	✓
					W	✓
					Z	✓
					PC	✓
	**ACET465** **Cranked Espag Handle with 9mm Spindle**	**1**	**Each**	**ACET4260**	MF	
					SA	
					KL	✓
					HP	✓
					SSC	✓
					SMC	✓
					W	✓
					Z	✓
					PC	✓
	**ACET466 L/R** **Cranked Espag Handle with 15mm Spindle**	**1**	**Each**	**ACET4211 to ACET4215 ACET4271 to ACET4277**	MF	
					SA	
					KL	✓
					HP	✓
					SSC	✓
					SMC	✓
					W	✓
					Z	✓
					PC	✓

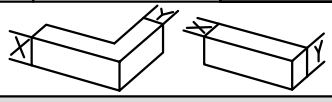


T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm

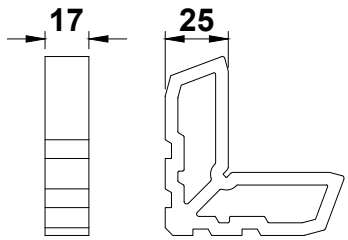
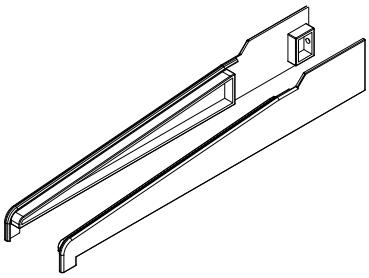
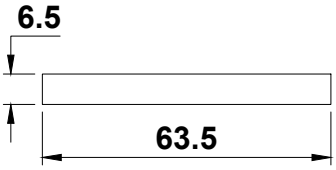


Screw (Grub)

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ISSUED: MAY 2026

Image	Part Code	Pack	Unit	Application	Colour
	**ACET4725** **Crimping Cleat**	**24**	**Pack**	**ETC4725**	MF SA KL HP SSC SMC W Z PC
	**ACET477** **Cill End Cap**	**1**	**Pair**	**ETC477**	MF ✓ SA KL ✓ HP ✓ SSC SMC W ✓ Z ✓ PC
	**ACET4762** **Inline Espag Handle with 55mm Spindle**	**1**	**Each**	**ACET4771 to ACET4778**	MF SA KL ✓ HP ✓ SSC ✓ SMC ✓ W ✓ Z ✓ PC ✓
	**ACET4763 L/R** **Cranked Espag Handle with 55mm Spindle**	**1**	**Each**	**ACET4771 to ACET4778**	MF SA KL ✓ HP ✓ SSC ✓ SMC ✓ W ✓ Z ✓ PC ✓
	**ACET4780** **Foam** **Length = 1250mm**	**1**	**Each**	**ETC4715**	MF SA KL HP SSC SMC W Z PC





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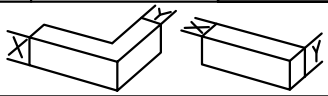
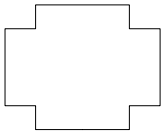
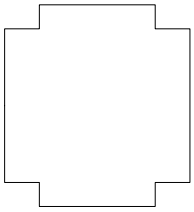
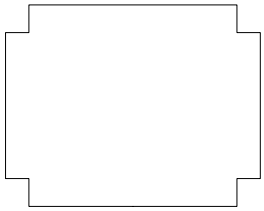
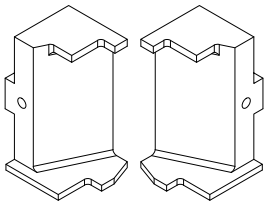
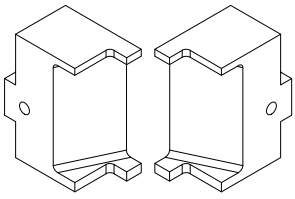


Image	Part Code	Pack	Unit	Application	Colour
	**ACET4781** **Foam** **Length = 1250mm**	**1**	**Each**	**ETC4244** **ETC4715**	MF SA KL HP SSC SMC W Z PC
	**ACET4782** **Foam** **Length = 1250mm**	**1**	**Each**	**ETC4725**	MF SA KL HP SSC SMC W Z PC
	**ACET4783** **Foam** **Length = 1250mm**	**1**	**Each**	**ETC4725**	MF SA KL HP SSC SMC W Z PC
	**ACET4790** **Crimping Punches**	**1**	**Pair**	**ETC4715**	MF SA KL HP SSC SMC W Z PC
	**ACET4791** **Crimping Punches**	**1**	**Pair**	**ETC4725**	MF SA KL HP SSC SMC W Z PC



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



Screw (Grub)

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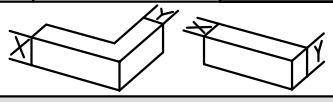
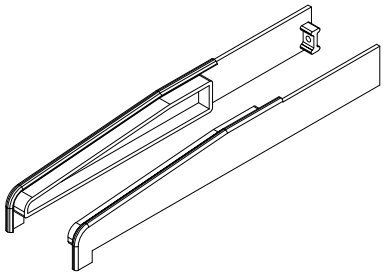
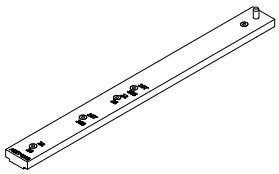
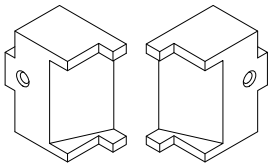
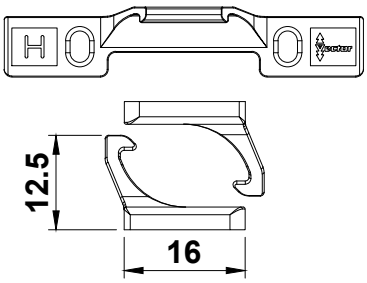
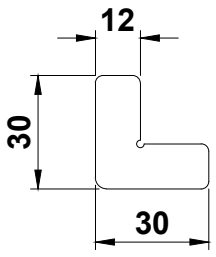
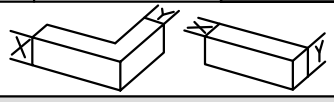


Image	Part Code	Pack	Unit	Application	Colour	
	**ACET479N** **Cill End Cap**	**1**	**Pair**	**ETC479N**	MF SA KL HP SSC SMC W Z PC	✓ ✓ ✓ ✓ ✓
	**ACET4915** **Sterling Stay Drill Jig**	**1**	**Pair**	**ETC4229**	MF SA KL HP SSC SMC W Z PC	✓
	**ACET4919** **Crimping Punches**	**1**	**Pair**	**ETC4221**	MF SA KL HP SSC SMC W Z PC	✓
	**ACET516** **16mm Cavity Hinge Protector** **4 Per Set (2 pairs)**	**50**	**Sets**	**ETC4229**	MF SA KL HP SSC SMC W Z PC	✓
	**ACET624** **Stainless Steel Chevron**	**100**	**Pack**	**ETC4229**	MF SA KL HP SSC SMC W Z PC	



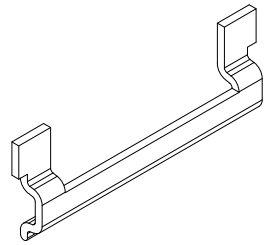
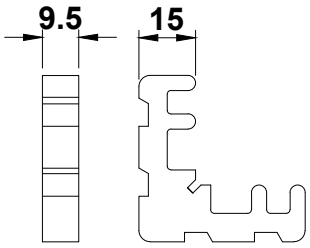
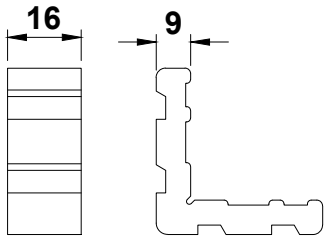
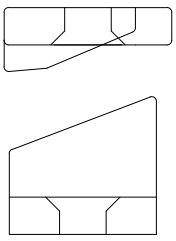
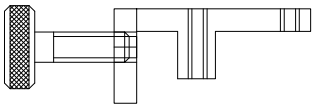


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SSC = Smooth Satin Chrome
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Alitherm 400 HD Window

ACCESSORIES : PHOTOS & DRAWINGS

Image	Part Code	Pack	Unit	Application	Colour	
	**ACET625** **Anti-Twist Clip**	**100**	**Pack**		MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
	**ACET629** **Crimping Cleat**	**24**	**pack**	**ETC4211**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
	**ACET647** **Crimping Cleat**	**24**	**pack**	**ETC4221**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
	**ACET652** **Pull-In Blocks**	**50**	**Pack**	**ETC4229**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	✓
					Z	✓
					PC	
	**ACET798** **Drill Jig**	**1**	**each**	**ETC4715** **ETC4730**	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**		

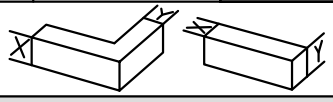
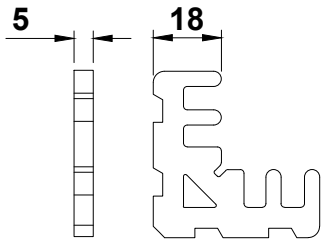
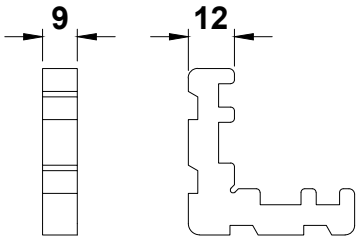
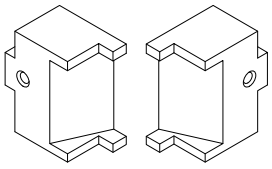
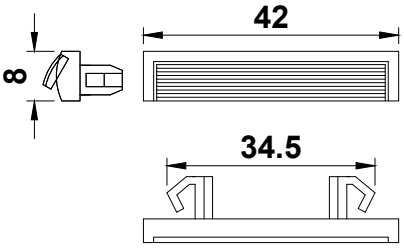
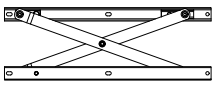


Image	Part Code	Pack	Unit	Application	Colour	
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					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
	**ACET820** **Crimping Cleat**	**24**	**pack**	**ETC4214**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
	**ACET978** **Crimping Punches**	**1**	**Pair**	**ETC4244**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
	**ACGSL045** **Drainage Cover Cap**	**100**	**Pack**		MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	✓
					Z	✓
					PC	
	**ACETPPS45 L/R** **450mm Parallel Hinge**	**1**	**pair**	**ETC4211** **ETC4221**	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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SMC	**= Smokey Chrome**		
PC	**= Polished Chrome**		

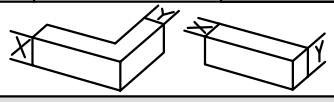
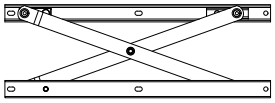
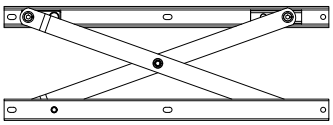
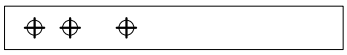
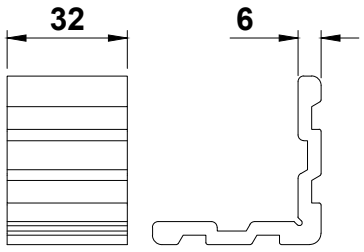


Image	Part Code	Pack	Unit	Application	Colour	
	**ACETPPS67 L/R** **670mm Parallel Hinge**	**1**	**pair**	**ETC4211** **ETC4221**	MF SA KL HP SSC SMC W Z PC	
	**ACETPPS95 L/R** **925mm Parallel Hinge**	**1**	**pair**	**ETC4211** **ETC4221**	MF SA KL HP SSC SMC W Z PC	
	**ACETPRS01** **Restrictor for Parallel Stay**	**50**	**each**	**ACETPPS45** **ACETPPS95**	MF SA KL HP SSC SMC W Z PC	
	**ACETPRS02** **Restrictor for Parallel Stay**	**50**	**each**	**ACETPPS02**	MF SA KL HP SSC SMC W Z PC	
	**ACINT210** **Crimping Corner Cleat**	**24**	**pack**	**ETC4175**	MF SA KL HP SSC SMC W Z PC	✓

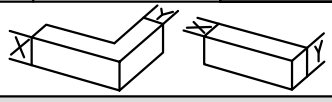


T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm



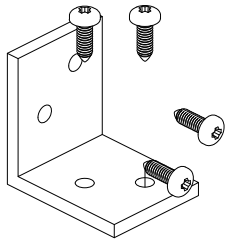
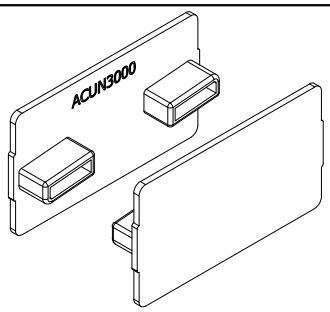
Screw (Grub)

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**		



Alitherm 400 HD window

ACCESSORIES : PHOTOS & DRAWINGS

Image	Part Code	Pack	Unit	Application	Colour	
	**ACRV020** **Cruciform Bracket**	**1**	**each**	**ETC4175**	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
	**ACRV030** **Flipper Gasket**	**50**	**m**	**ETC4725**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	✓
					PC	
	**ACRV031** **Head Gasket**	**50**	**m**	**ETC4715** **ETC4730**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	✓
					PC	
	**ACRV032** **Infill Section**	**50**	**m**	**ETC4715** **ETC4730**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	✓
					PC	
	**ACUN3000** **End Caps for UN3000**	**10**	**Pairs**	**UN3000**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	✓
					PC	





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SSC = Smooth Satin Chrome
SMC = Smokey Chrome
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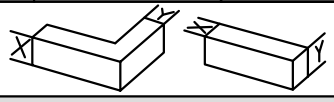
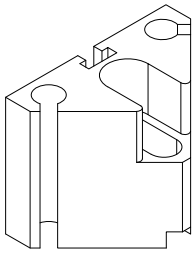
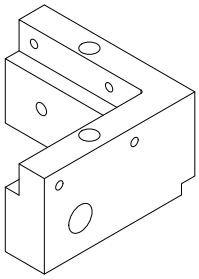
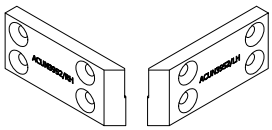
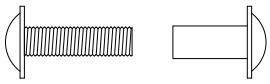
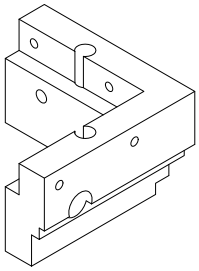


Image	Part Code	Pack	Unit	Application	Colour	
	**ACUN3950** **Adjustable Vee Block**	**1**	**Each**	**ETC4210** **ETC4229**	MF SA KL HP SSC SMC W Z PC	✓
	**ACUN3951** **Faceplate**	**1**	**Each**	**ETC4210**	MF SA KL HP SSC SMC W Z PC	✓
	**ACUN3952** **Nylon Support**	**1**	**Each**	**ETC4715**	MF SA KL HP SSC SMC W Z PC	✓
	**ACUN3953** **M4 Back to Back Fixing Kit**	**10**	**Pack**	**ETC4238**	MF SA KL HP SSC SMC W Z PC	
	**ACUN3954** **Faceplate**	**1**	**Each**	**ETC4229**	MF SA KL HP SSC SMC W Z PC	✓

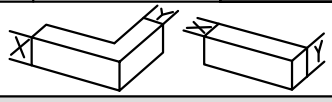


T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm



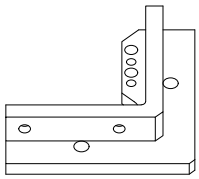
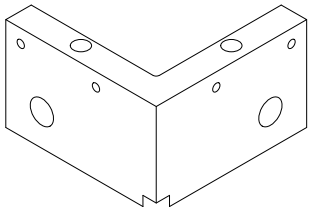
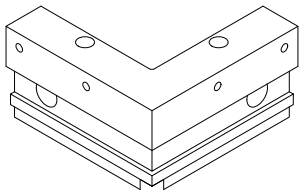
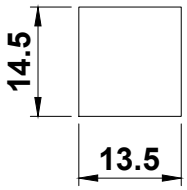
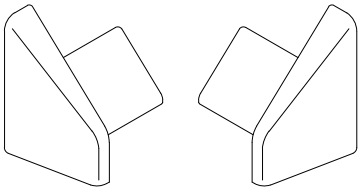
Screw (Grub)

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



Alitherm 400 HD window

ACCESSORIES : PHOTOS & DRAWINGS

Image	Part Code	Pack	Unit	Application	Colour
	**ACUN3955** **Packer**	**1**	**Each**	**ETC4210** **ETC4229**	MF ✓ SA KL HP SSC SMC W Z PC
	**ACUN3964** **Adjustable Vee Block**	**1**	**Each**	**ETC4210** **ETC4229**	MF ✓ SA KL HP SSC SMC W Z PC
	**ACUN3967** **Vee Block**	**1**	**Each**	**ETC4214**	MF ✓ SA KL HP SSC SMC W Z PC
	**ACVG560** **Foam** **Length = 1250mm**	**1**	**Each**	**ETC4210** **ETC4230**	MF SA KL HP SSC SMC W Z ✓ PC
	**ACVL059** **End Cap**	**1**	**Pair**	**VL72**	MF SA KL HP SSC SMC W ✓ Z ✓ PC

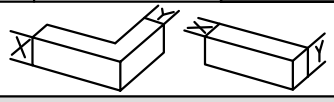


T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm



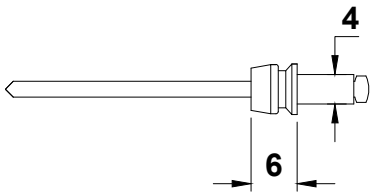
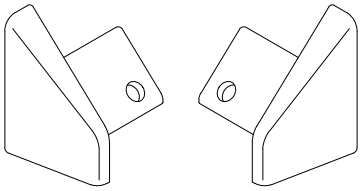
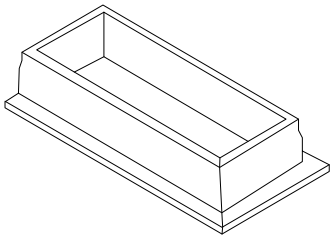
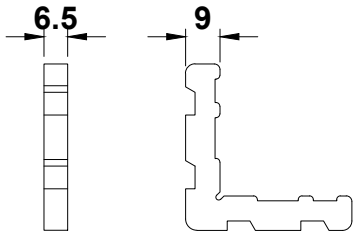
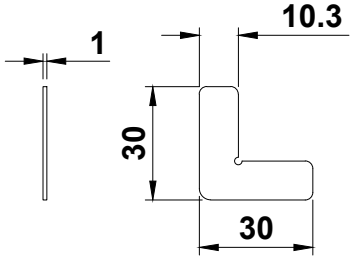
Screw (Grub)

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SMC = Smokey Chrome
PC = Polished Chrome
W = White
Z = Black



Alitherm 400 HD window

ACCESSORIES : PHOTOS & DRAWINGS

Image	Part Code	Pack	Unit	Application	Colour	
	**ACVL061** **Rivet**	**100**	**Pack**	**VL72**	MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
	**ACVL072** **Cast End Cap**	**1**	**Pair**	**VL72**	MF	✓
					SA	
					KL	✓
					HP	✓
					SSC	
					SMC	
					W	✓
					Z	✓
					PC	
	**ACVL635** **PVC End Cap**	**1**	**each**	**ETC4236**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	✓
					PC	
	**ACW20018** **Crimping Cleat**	**24**	**pack**	**ETC4725**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	
	**WCA106** **Stainless Steel Chevron**	**50**	**Pack**	**ETC4210**	MF	
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	


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


Screw (Grub)

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

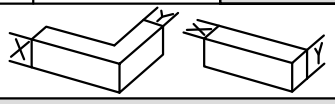
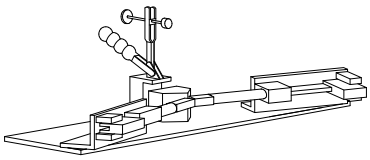


Image	Part Code	Pack	Unit	Application	Colour
	**WUT024HSZA** **Manual Crimper** **Note: Vee Blocks & Punches are Sold Separately**	**1**	**Each**		MF SA KL HP SSC SMC W Z PC
					MF SA KL HP SSC SMC W Z PC
					MF SA KL HP SSC SMC W Z PC
					MF SA KL HP SSC SMC W Z PC
					MF SA KL HP SSC SMC W Z PC

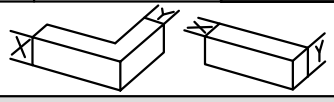


T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm

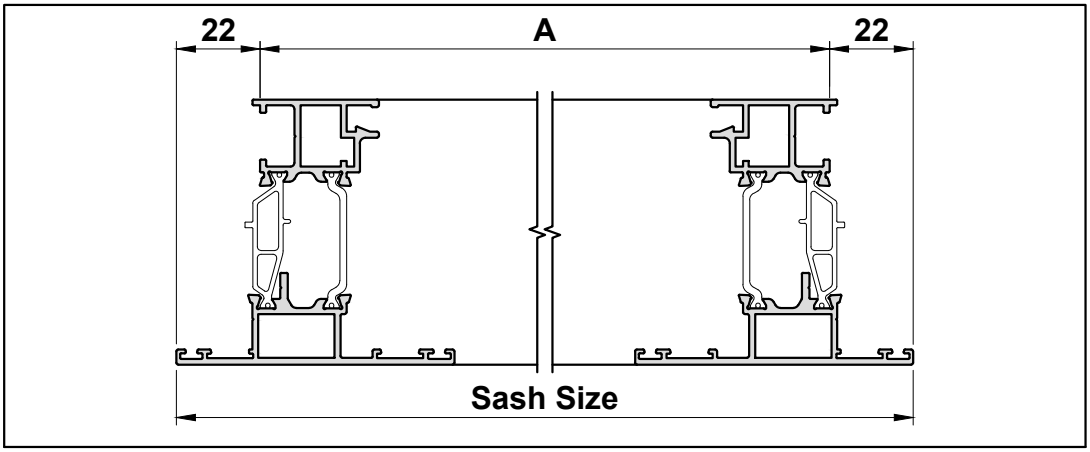


Screw (Grub)

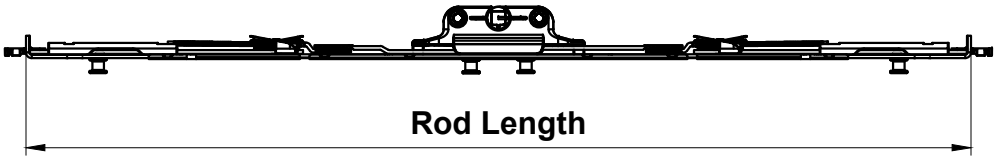
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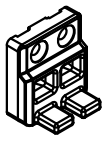
Telescopic Locking



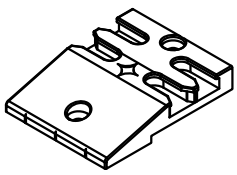
Part Code	Rod Length (mm)	Number of Keeps	Sash Rebate Size ('A')	
			Minimum	Maximum
ACET4211	500-576	3 x ACET4218 2 x ACET4219	540	616
ACET4212	577-728		617	768
ACET4213	729-1032		769	1072
ACET4214	1033-1336		1073	1376
ACET4215	1337-1640		1377	1680



ACET4219



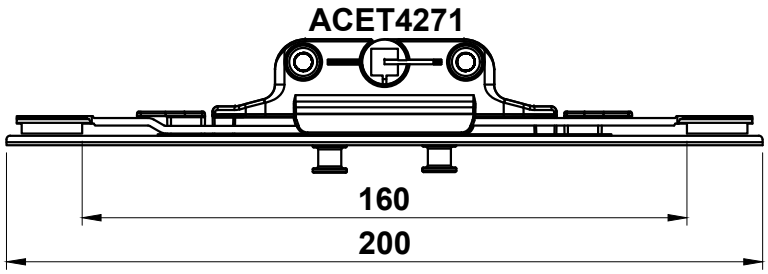
ACET4218

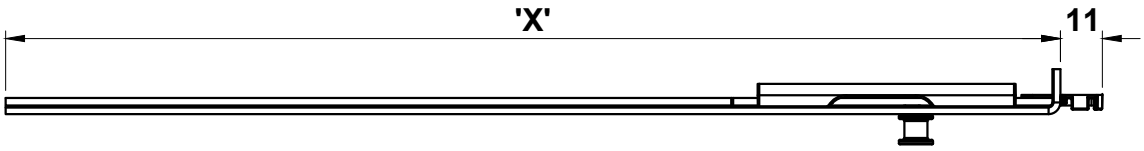


Croppable Locking

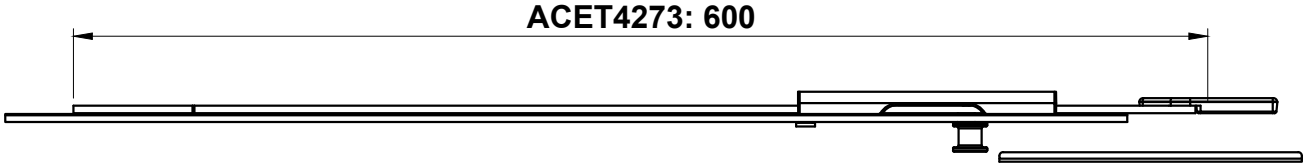
Basic locking Kit: ACET4271				
Locking Rod Part Codes	Dimension X	Number of Keeps	Sash Size	
			Minimum (mm)	Maximum (mm)
ACET4274	125.5	1 x ACET4218 2 x ACET4219	320	410
ACET4275	279	3 x ACET4218 2 x ACET4219	411	720
ACET4276	512		721	1185
ACET4277	748		1186	1655

ACET4271

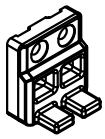




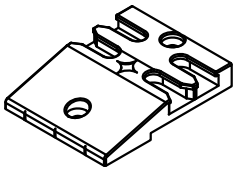
Extension Rods
ACET4272: 300
ACET4273: 600



ACET4219



ACET4218

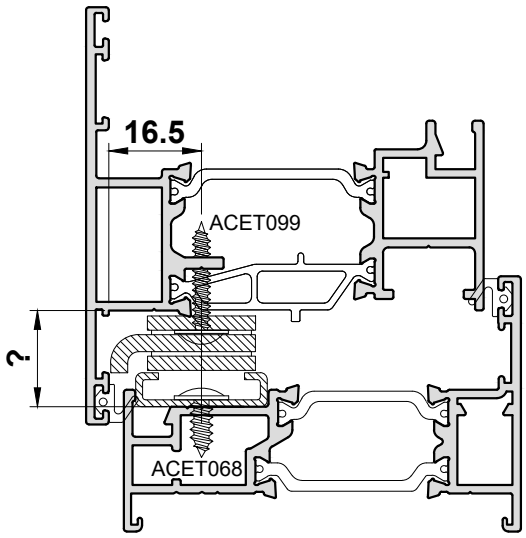


Notes:

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

Casement - Friction Hinge Stays Heavy Duty

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

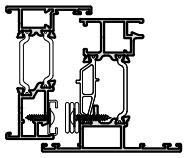


Hinge Code Top Hung	Hinge Length (mm)	Max Vent Weight (kg)	Min Vent Height (mm)	Max Vent Height (mm)	Opening Angle (+/-2.5°)
ACINS10	262	40	315	640	50
ACINS12	313	50	640	800	50
ACINS16	415	65	800	1100	50
ACINS22	567	100	1090	1500	45
ACINS22W	567	100	1500	2000	20
ACINS26	680	180	2000	2500	20
Side Hung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

Please Note:

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

Casement - Friction Hinge Stays



ETC4229

Friction Hinge Stays 16mm Stack (Standard)

Top Hung Windows

Top Hung	Type of Hinge / Stay	Max. Vent Weight (kgs)	Height		Opening Angle (+/- 2.5°)
			Mimimum	Maximum	
ACETDHS08	Standard	12	200	350	65°
ACETDHS10		16	275	400	80°
ACETDHS12		20	350	550	80°
ACETDHS16		21	500	780	80°
ACETDHS20		26	700	1100	50°
ACETDHS24		40	850	1300	37.5°
ACETDTH24	Heavy Duty	50	850	1500	32°
ACETDHS12R	Restricted	20	350	550	14° / 65°
ACETDHS16R		21	500	780	10° / 59°
ACETDHS20R		26	700	1100	8° / 50°
ACETDHS24R		40	850	1300	7° / 37.5°

Side Hung Windows

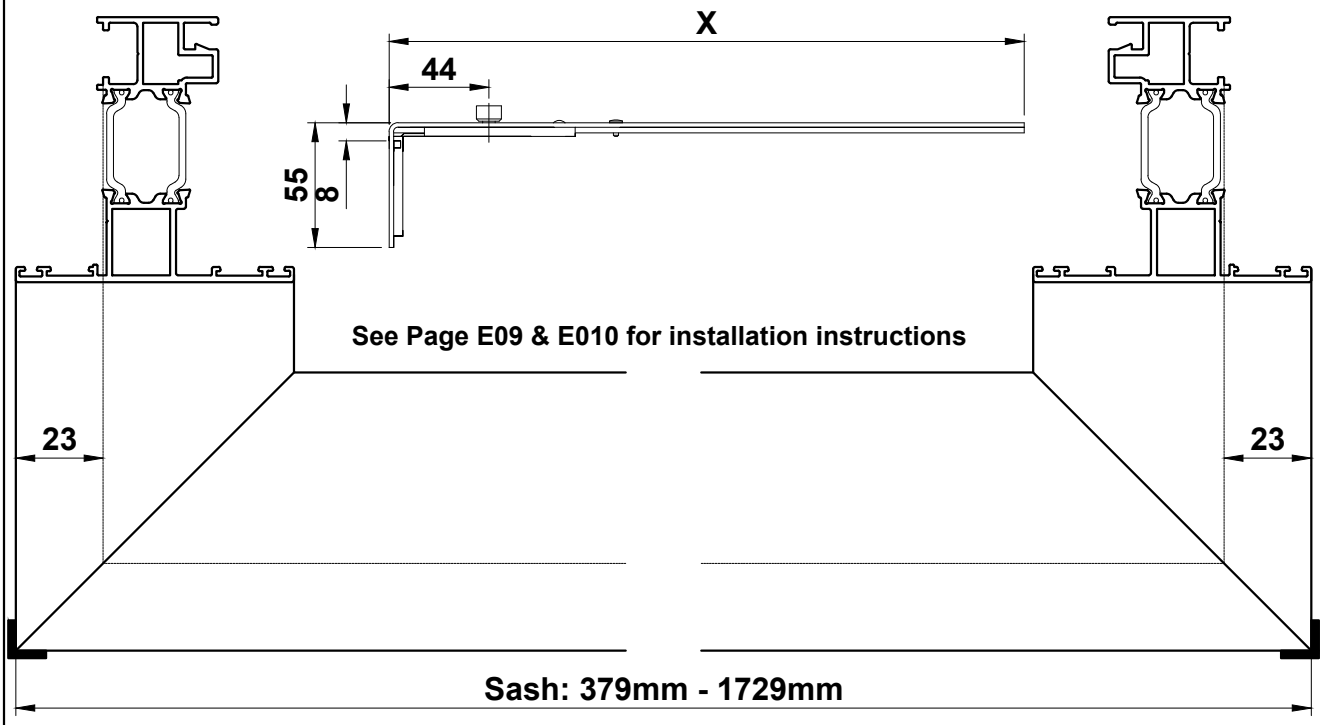
Side Hung	Type of Hinge / Stay	Max. Vent Weight (kgs)	Width ('A')		Opening Angle (+/- 2.5°)
			Minimum	Maximum	
ACETDHSSH12	Standard	22	300	600	60°
ACETDHSSH16		24	400	600	60°
ACETSH1612L ACETSH1612R	Restricted Left Hand R/H Non-Restricted / Right Hand L/H Non-Restricted VIEWED FROM OUTSIDE L/H Restricted / R/H Restricted	22	300	600	13°/58°
ACETSH1616L ACETSH1616R		24	400	600	11°/58°
ACETME16	Egress *use with ACET652 pull in blocks	40	365	865	90°
ACETDSH16	Heavy Duty	40	400	1000	60°

Note1: Vent Height / Width is measured in mm from rebate to rebate (not overall size or outer frame)
Note2: Top hung height and side hung width sizes to be reduced by 2mm where size is 450mm or smaller
Note3: Typical Dimensions based on Max. Size and Glass 30kg/metre
Note4: For additional security use ACET516 hinge protectors
Note5: Kitemark specification covers Top Hung Max. height up to 1400mm.
Note6: For sashes over 600mm, ACETME99 is recommended for ACETME16 to disable easy clean function

Parallel - Shootbolt Locking

Basic locking Kit: ACET4260					
Locking Rod Part Codes	Dimension X	Rebate Size		Sash Size	
		Minimum (mm)	Maximum (mm)	Minimum (mm)	Maximum (mm)
ACET711	280	330	640	379	689
ACET712	410	590	900	639	949
ACET713	540	850	1160	899	1209
ACET714	670	1110	1420	1159	1469
ACET715	800	1370	1680	1419	1729

Note: ACET716 222-522mm Lock Extension Rod may be used on windows over 1729mm with the appropriate locking rods.

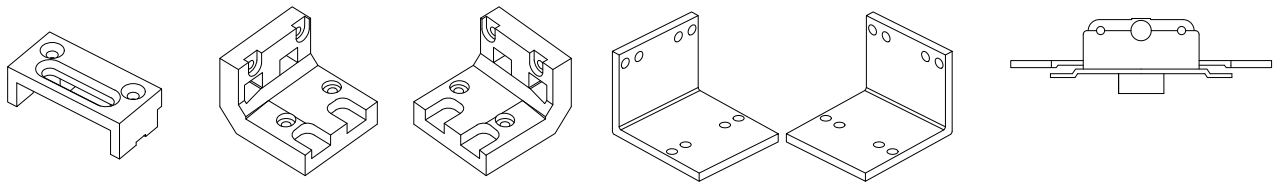


See Page E09 & E010 for installation instructions

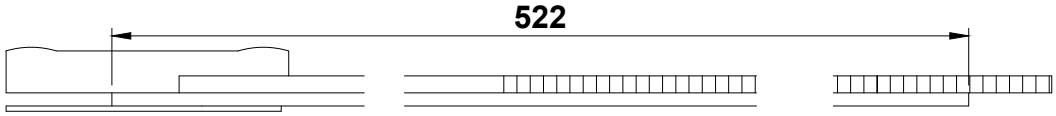
Sash: 379mm - 1729mm

ACET4260 Kit Includes:

1 Centre Keep | **1 Pair Corner Keeps** | **2 Corner Keep Packers** | **1 Gearbox**

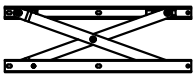


ACET716 (Sold Separately):

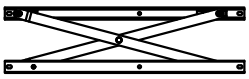


Off Set Parallel Hinge

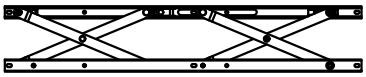
Parallel Hinge Part Codes	Length (mm)	Restrictor
ACETPPS35L/R	350	N/A
ACETPPS45L/R	450	ACETPRS01
ACETPPS67L/R	670	ACETPRS02
ACETPPS95L/R	925	ACETPRS01



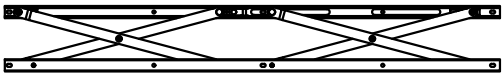
ACETPPS35



ACETPPS45



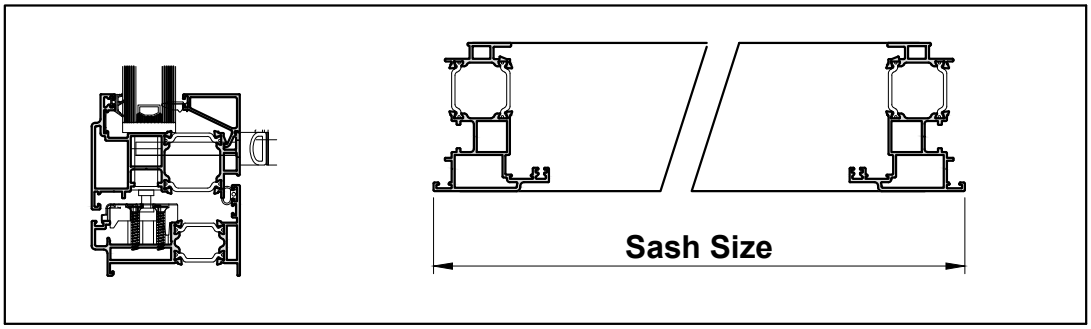
ACETPPS67



ACETPPS95

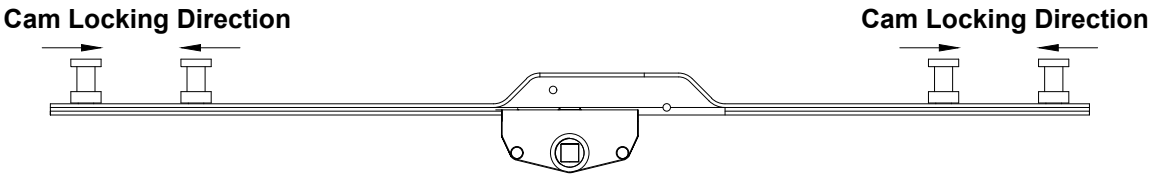
Please note that ACETPPS45, 67 & 95 will open to 250mm with automatic operators. We recommend that manually operated vents are restricted to 150mm due to the increased force required to close the vents over this dimension.

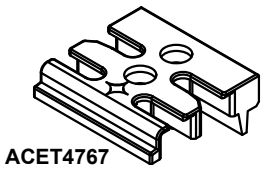
Reversible - Locking



Part Code	Rod Length (mm)	Number of ACET4767 Keeps	Sash Size	
			Minimum	Maximum
ACET4771	250	2	320	419
ACET4772	350	2	420	619
ACET4773	550	2	620	819
ACET4774	750	4	820	919
ACET4775	850	4	920	1019
ACET4776	950	4	1020	1119
ACET4777	1050	4	1120	1219
ACET4778	1150	4	1220	1399
ACET4779	1350	4	1400	1500

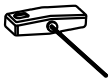
Note: To Suit Handles ACET4762 & ACET4763





STANDARD ACCESSORIES

Image	Part Code	Pack	Unit	Application	Colour
	**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
	**ACMX09765** **Alu. Cleaner**	**1**	**each**		MF SA KL HP SSC SMC W Z PC

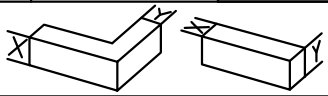


T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm



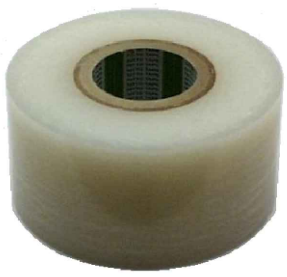
Screw (Grub)

MF	**= Mill Finish**	**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 HD Window

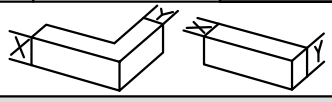
STANDARD ACCESSORIES

Image	Part Code	Pack	Unit	Application	Colour
	**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
	**ACMX09803** **Protective Tape 100mm**	1	each		MF SA KL HP SSC SMC W Z PC





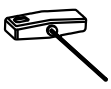
MF	= Mill Finish	W	= White
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KL	= Basic Colour		
HP	= Special Colour		
SSC	= Smooth Satin Chrome		
SMC	= Smokey Chrome		
PC	= Polished Chrome		



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STANDARD ACCESSORIES

Image	Part Code	Pack	Unit	Application	Colour	
	**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	
	**ACSIL05** **Rubber Sealant**	**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	
	**ACSIL014** **Anti-Corrosion Coating**	**1**	**each**		MF	✓
					SA	
					KL	
					HP	
					SSC	
					SMC	
					W	
					Z	
					PC	

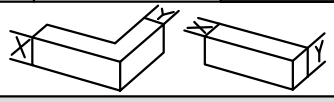


T-BARS
ACVG65=2.5mm
ACVG66=3.0mm
ACVL150=4.0mm



Screw (Grub)

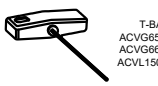
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SA	**= Silver Anodised**	**Z**	**= Black**
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Alitherm 400 HD Window

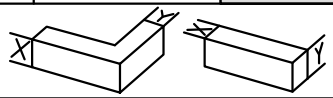
STANDARD ACCESSORIES

Image	Part Code	Pack	Unit	Application	Colour
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					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	**= 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**		



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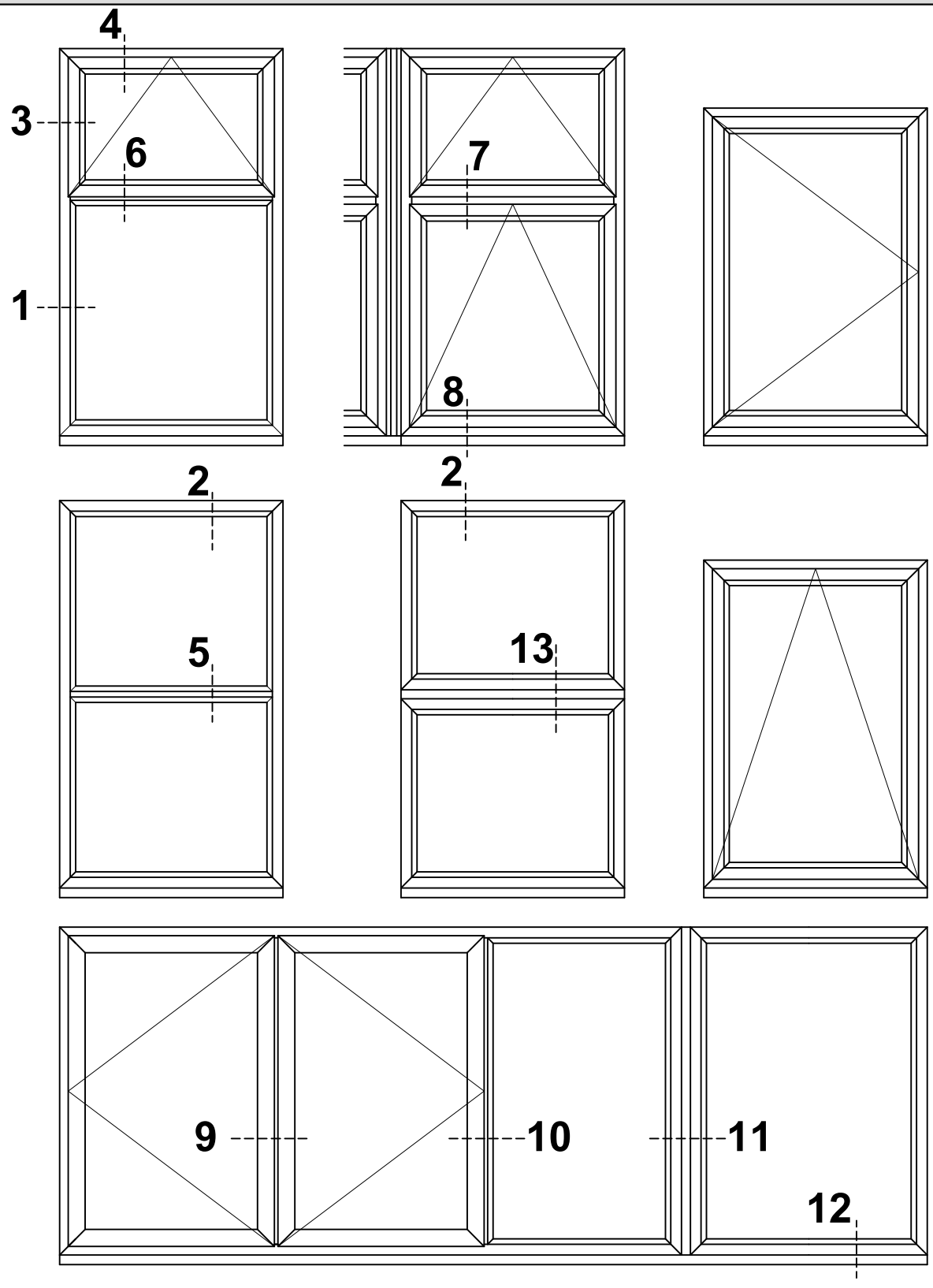
Section C

Sections

Scale Elevations

Alitherm 400 HD Window

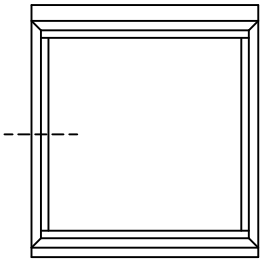
Scale Elevations - Casement

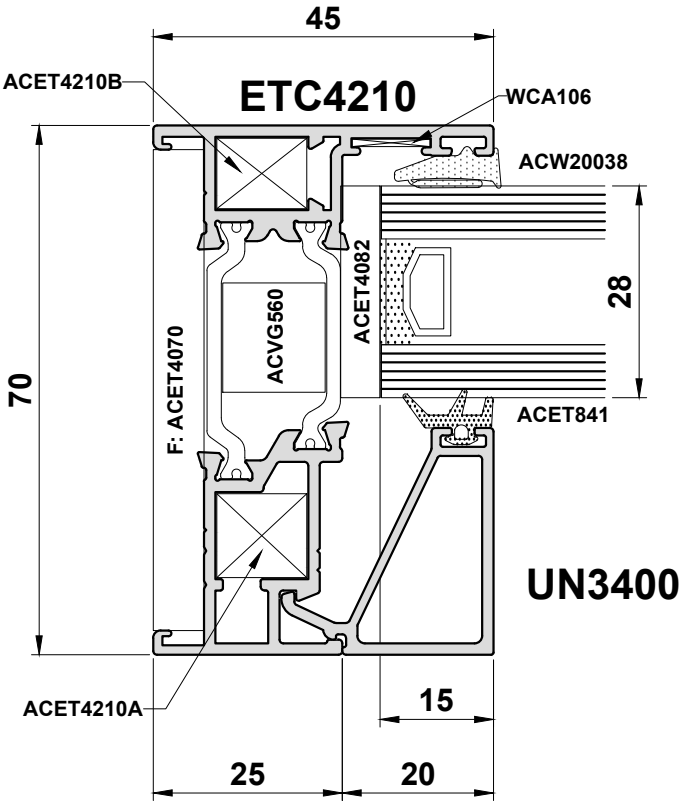


Do Not Scale From This Drawing

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Detail 1

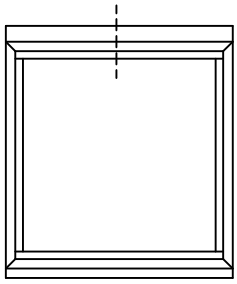


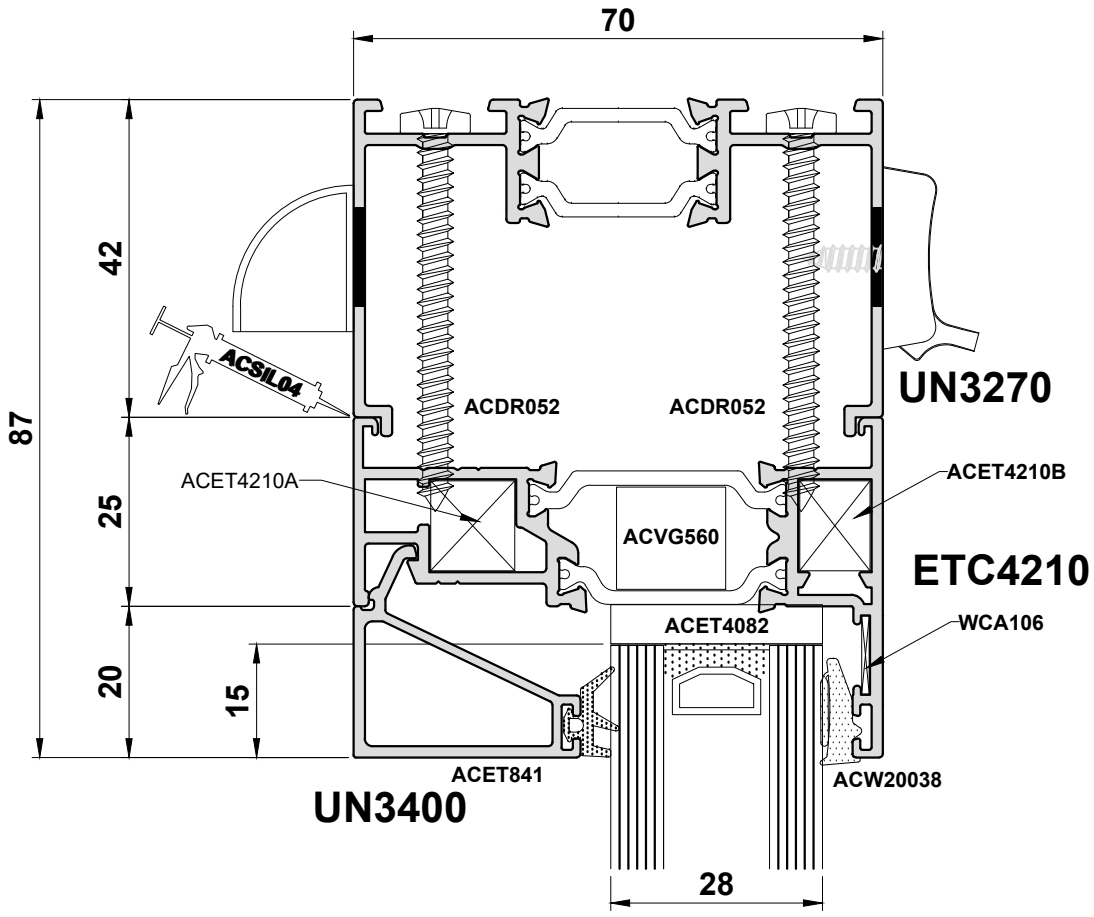


Do Not Scale From This Drawing

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Detail 2

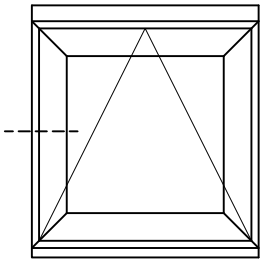


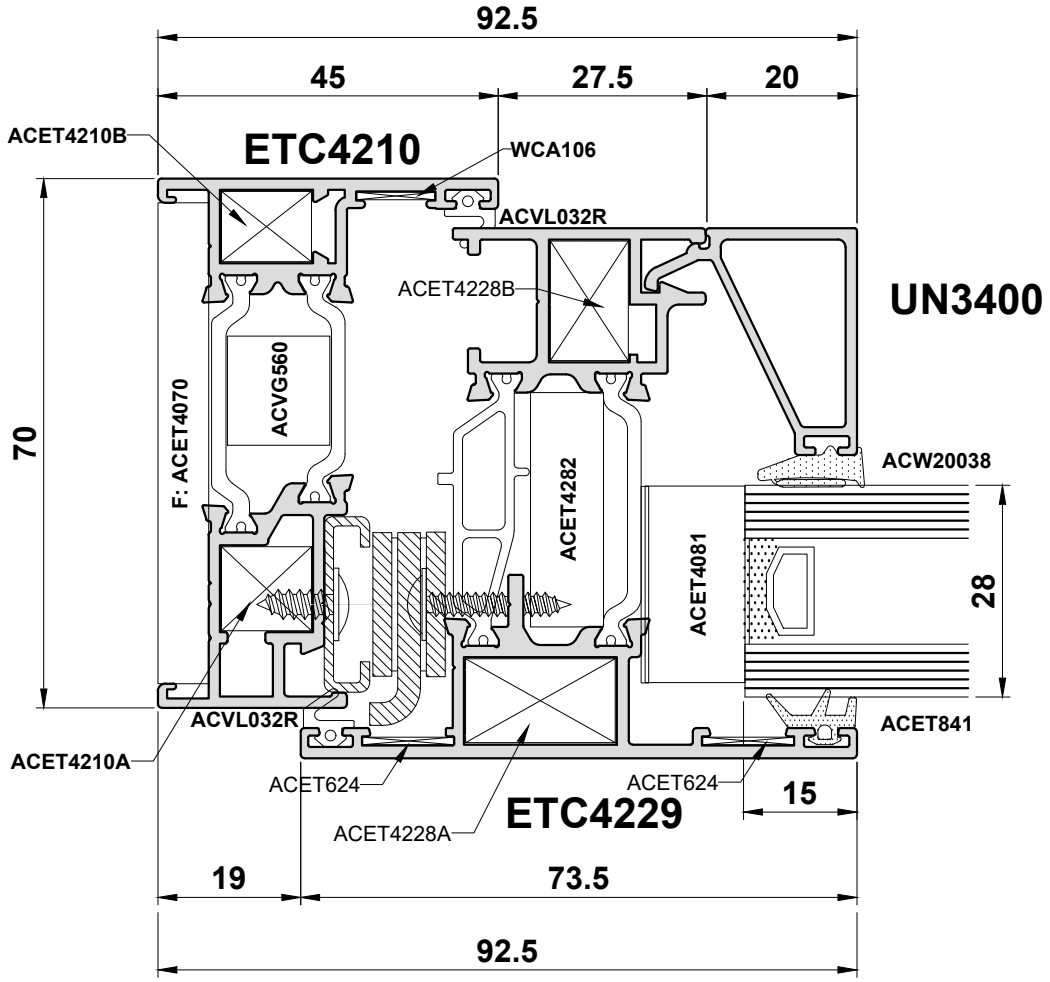


Do Not Scale From This Drawing

Alitherm 400 HD Window

Detail 3

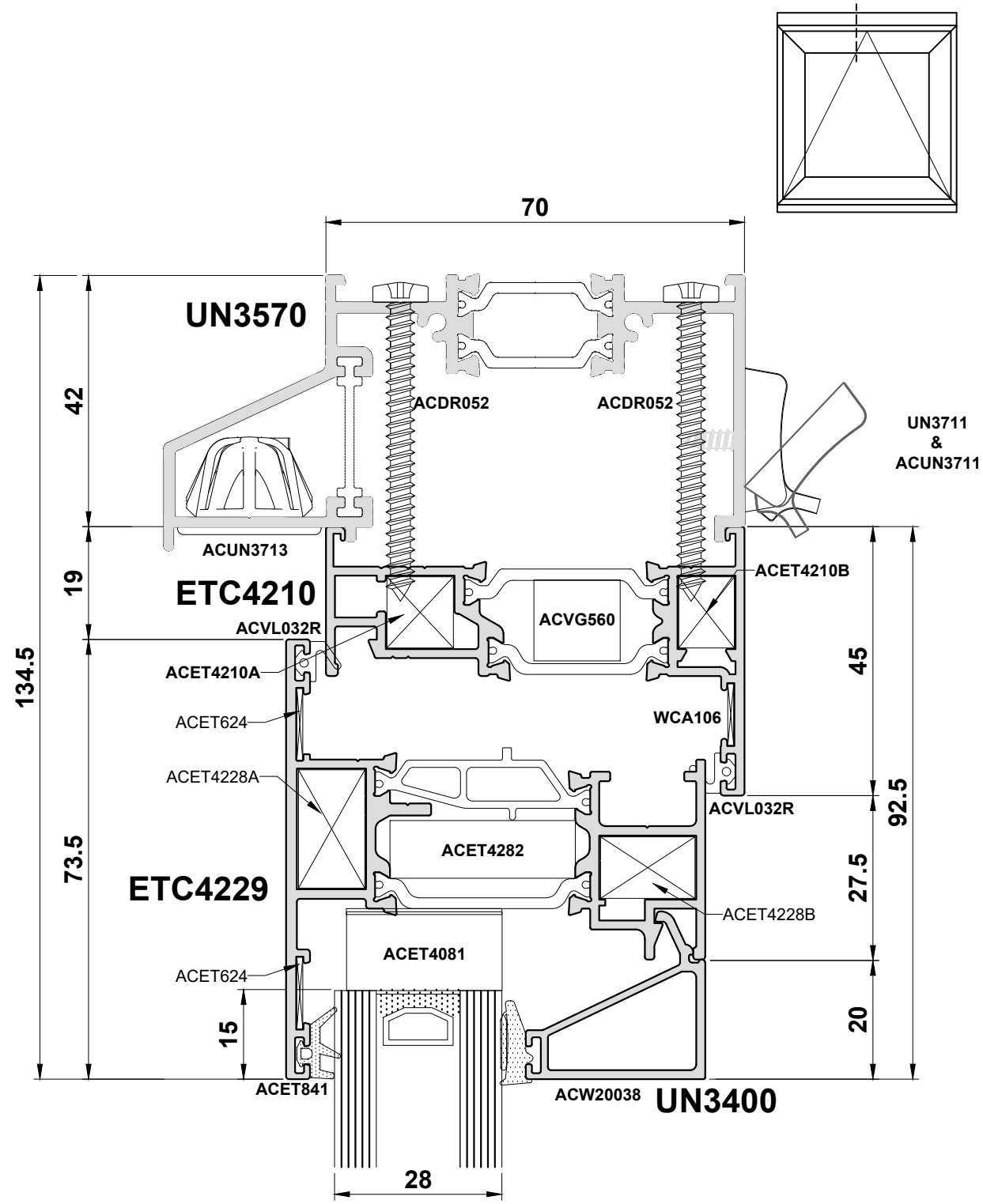




Do Not Scale From This Drawing

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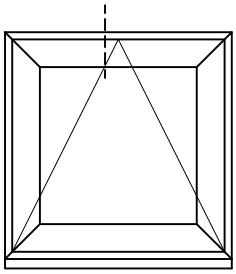
Detail 4A

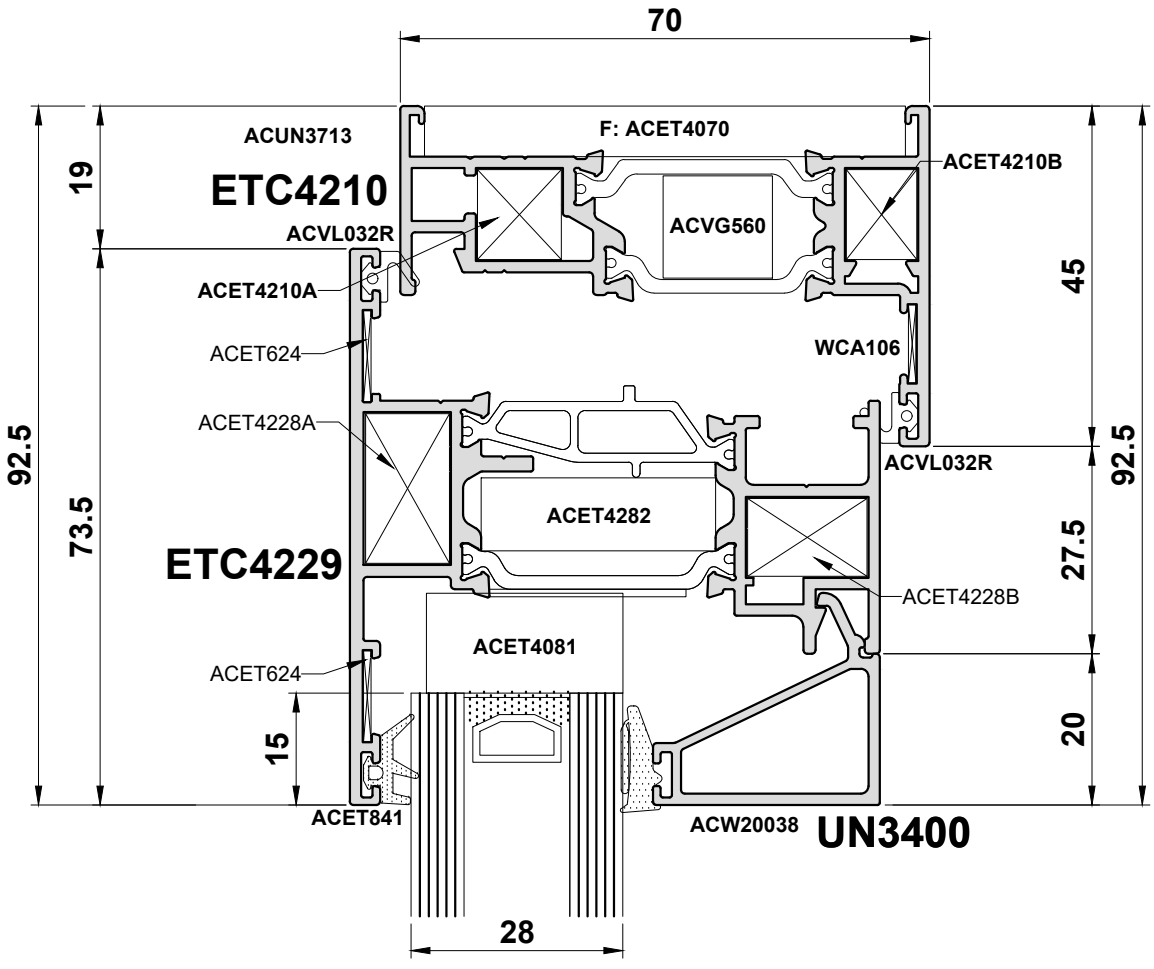


Do Not Scale From This Drawing

Alitherm 400 HD Window

Detail 4B



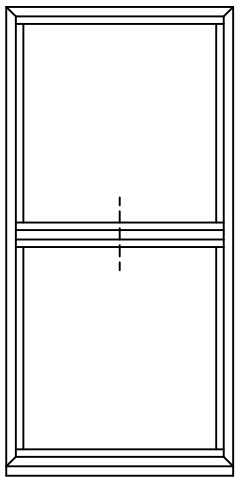


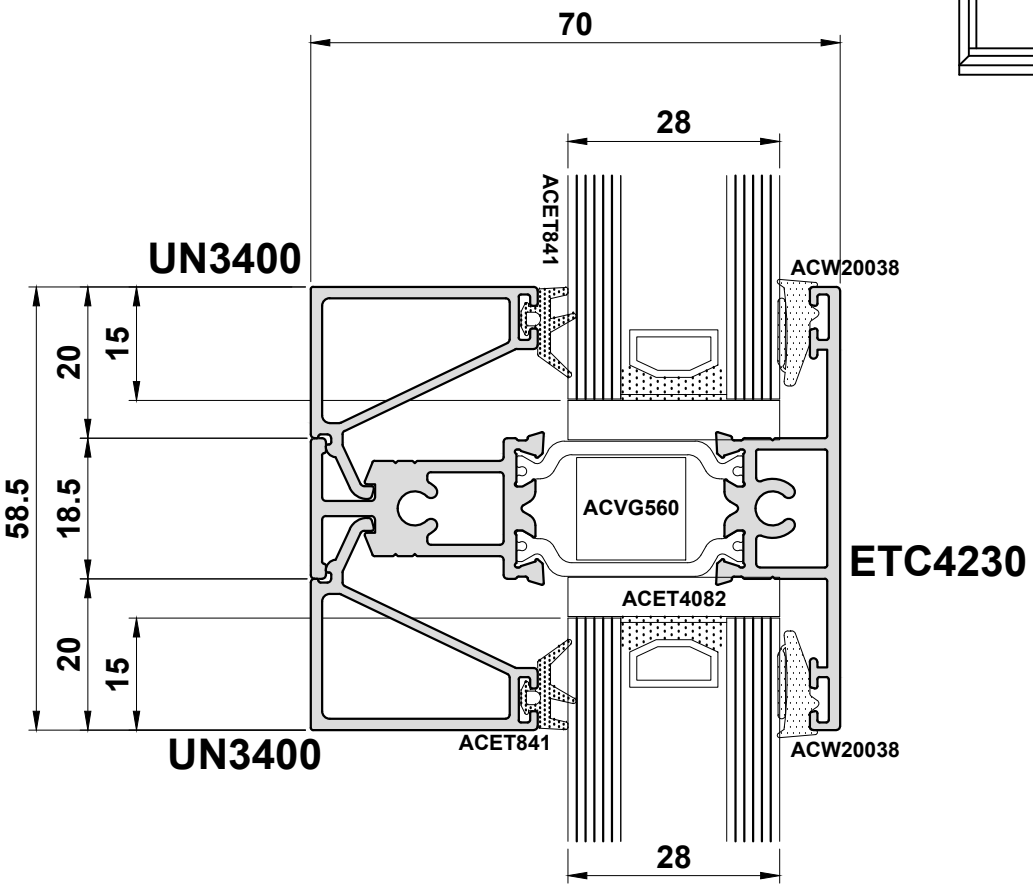
Do Not Scale From This Drawing

ISSUED: MAY 2026

Alitherm 400 HD Window

Detail 5



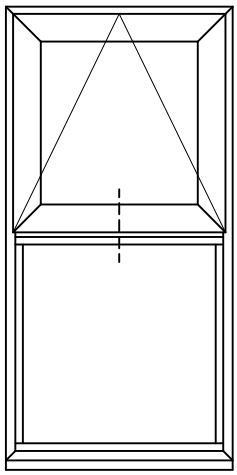


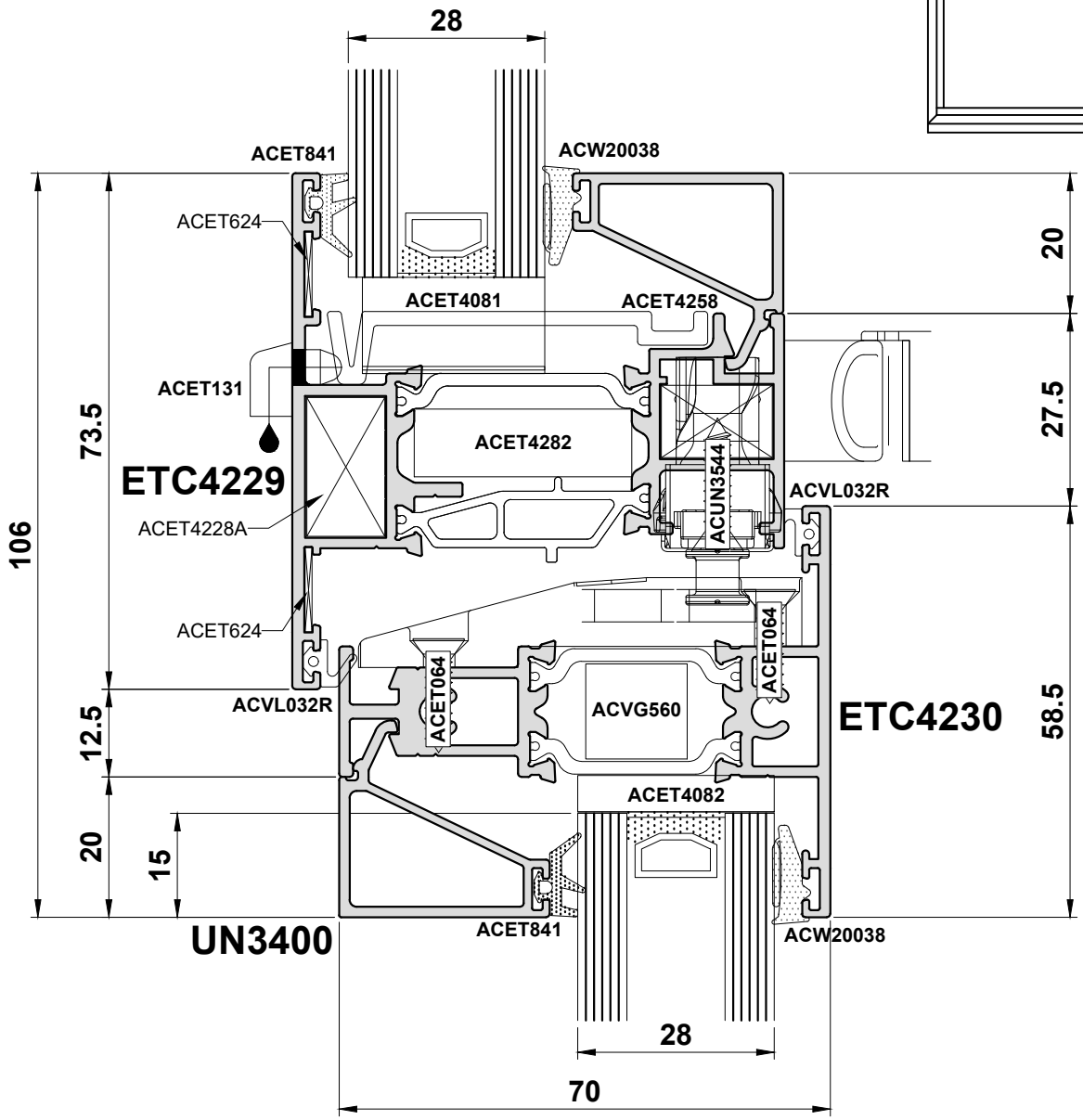
Note: Transoms will drain through the join to the outerframe.

Do Not Scale From This Drawing

Alitherm 400 HD Window

Detail 6



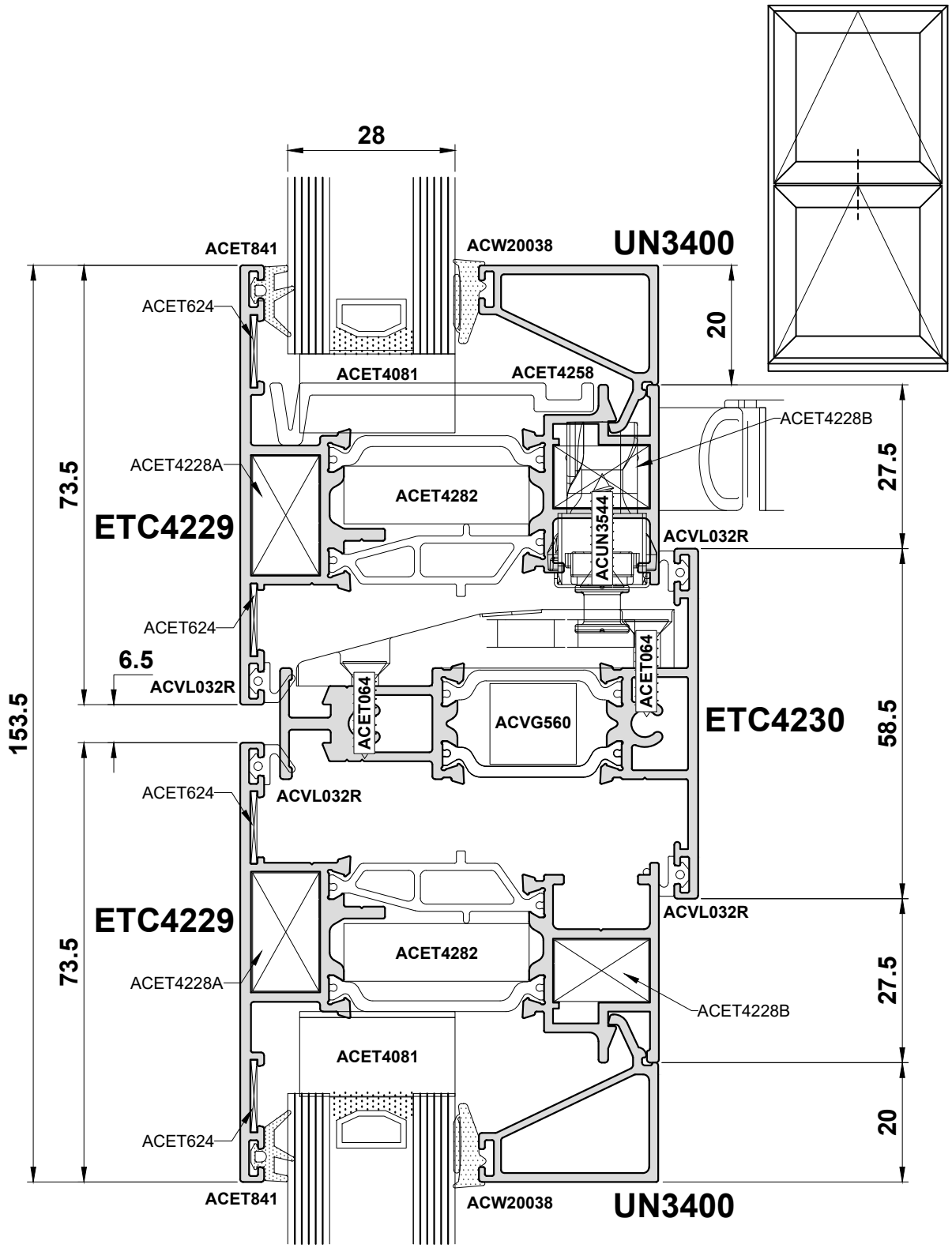


Note: Transoms will drain through the join to the outerframe.

Do Not Scale From This Drawing

ISSUED: MAY 2026

Detail 7

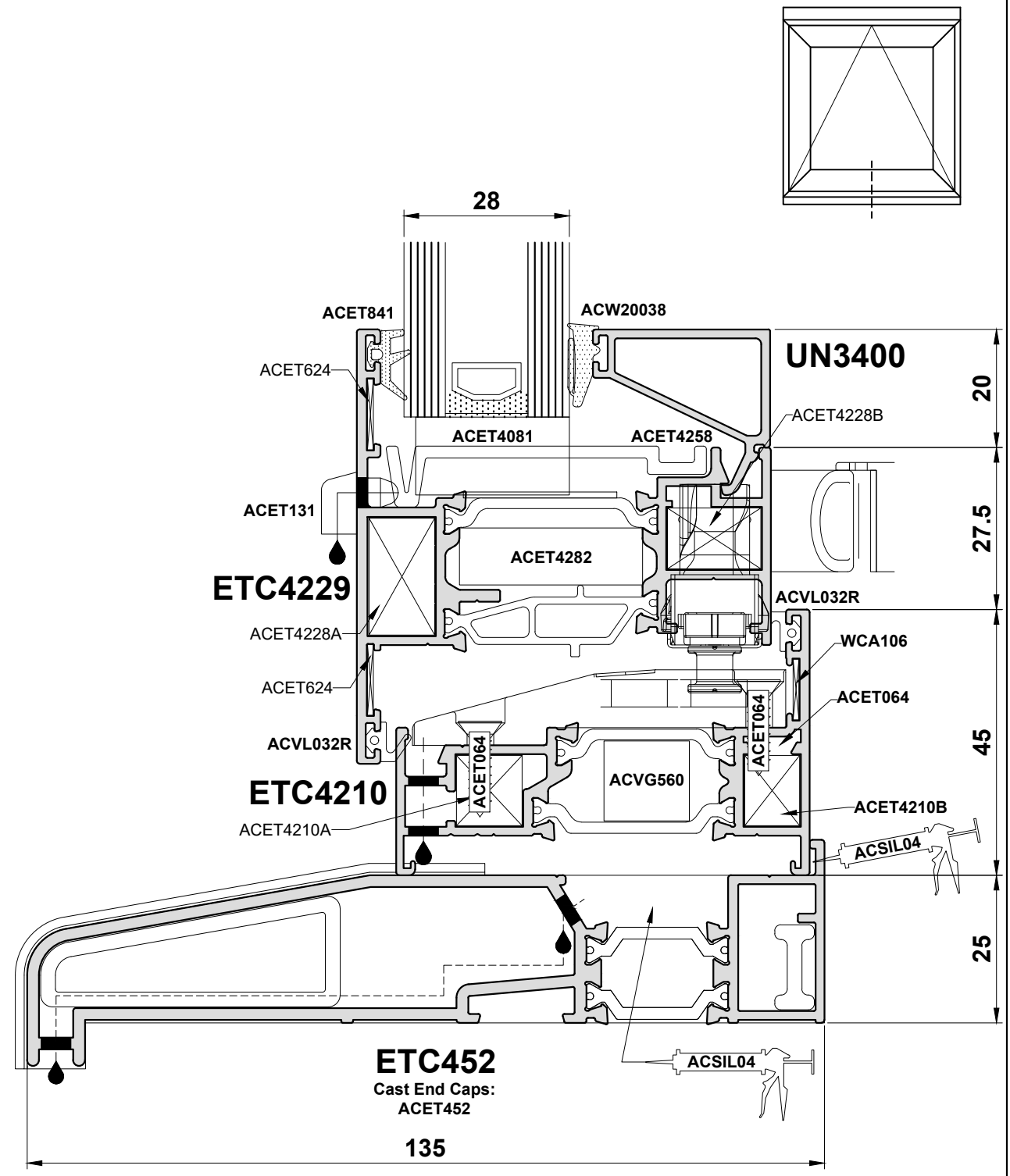


Note: Transoms will drain through the join to the outerframe.

Do Not Scale From This Drawing

Alitherm 400 HD Window

Detail 8

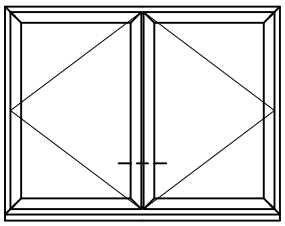


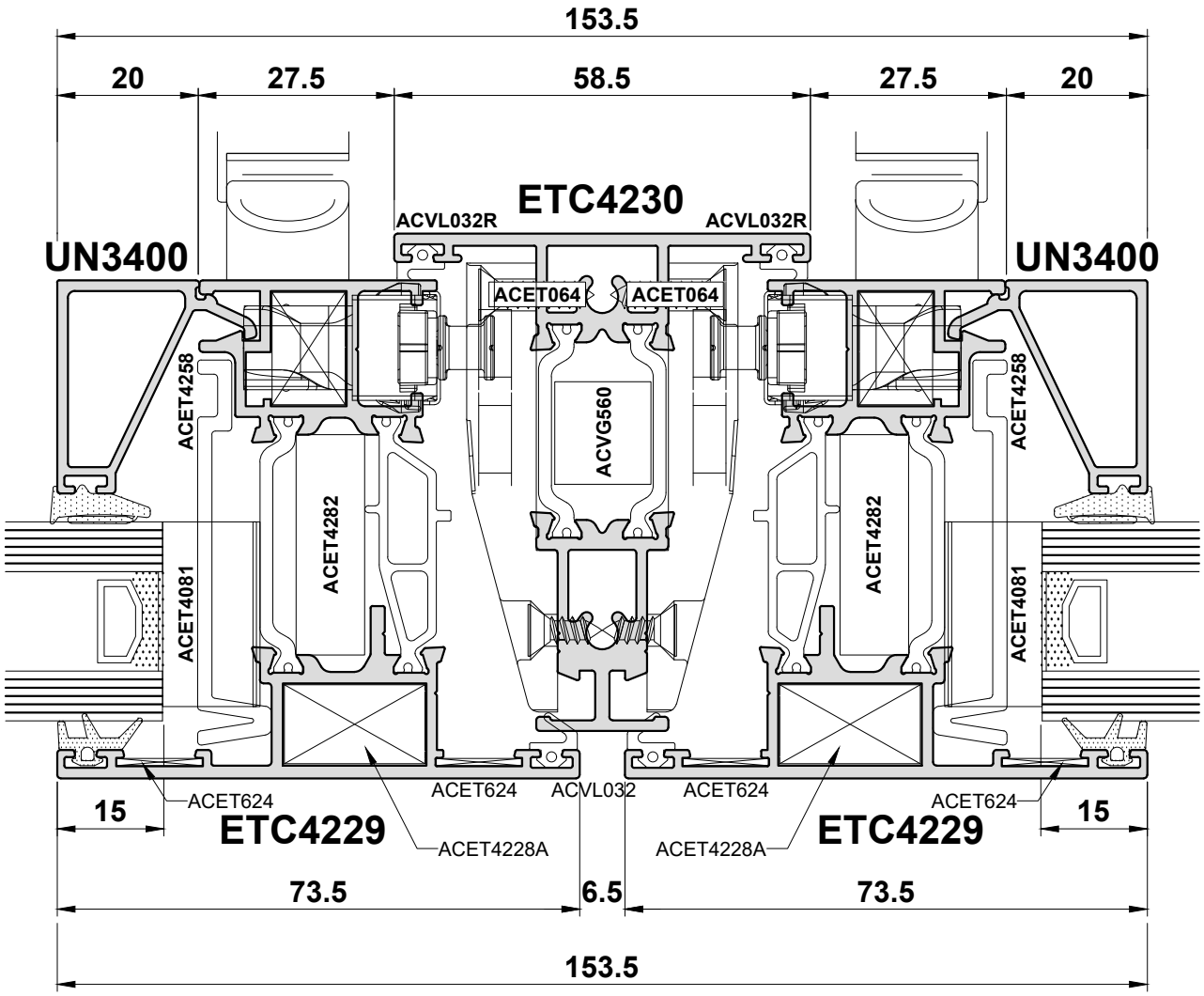
Cill end caps shall be sealed to cill to prevent water egress over edge

Do Not Scale From This Drawing

Alitherm 400 HD Window

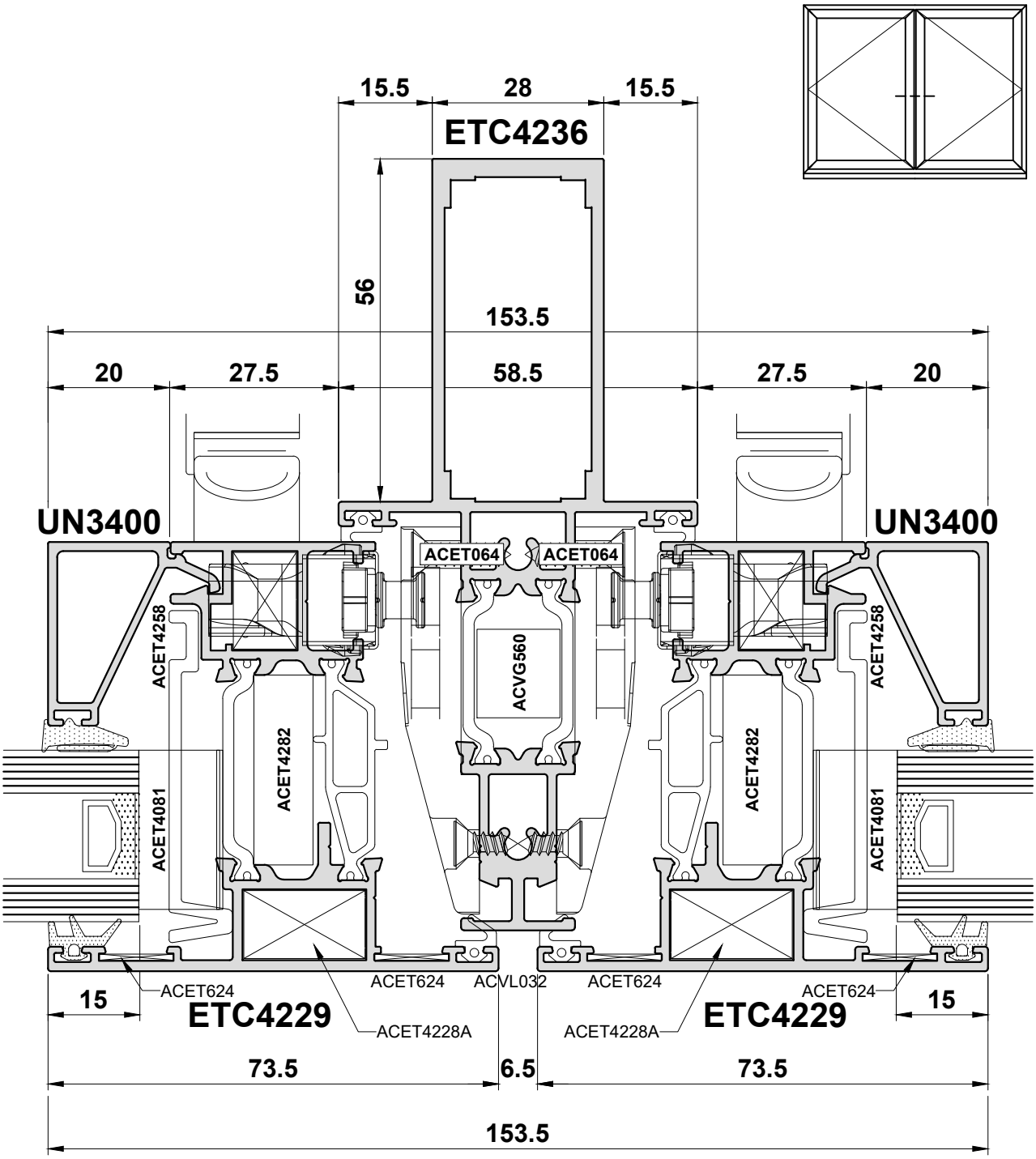
Detail 9A





Do Not Scale From This Drawing

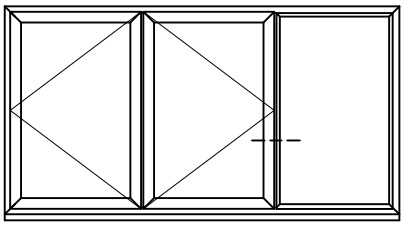
Detail 9B

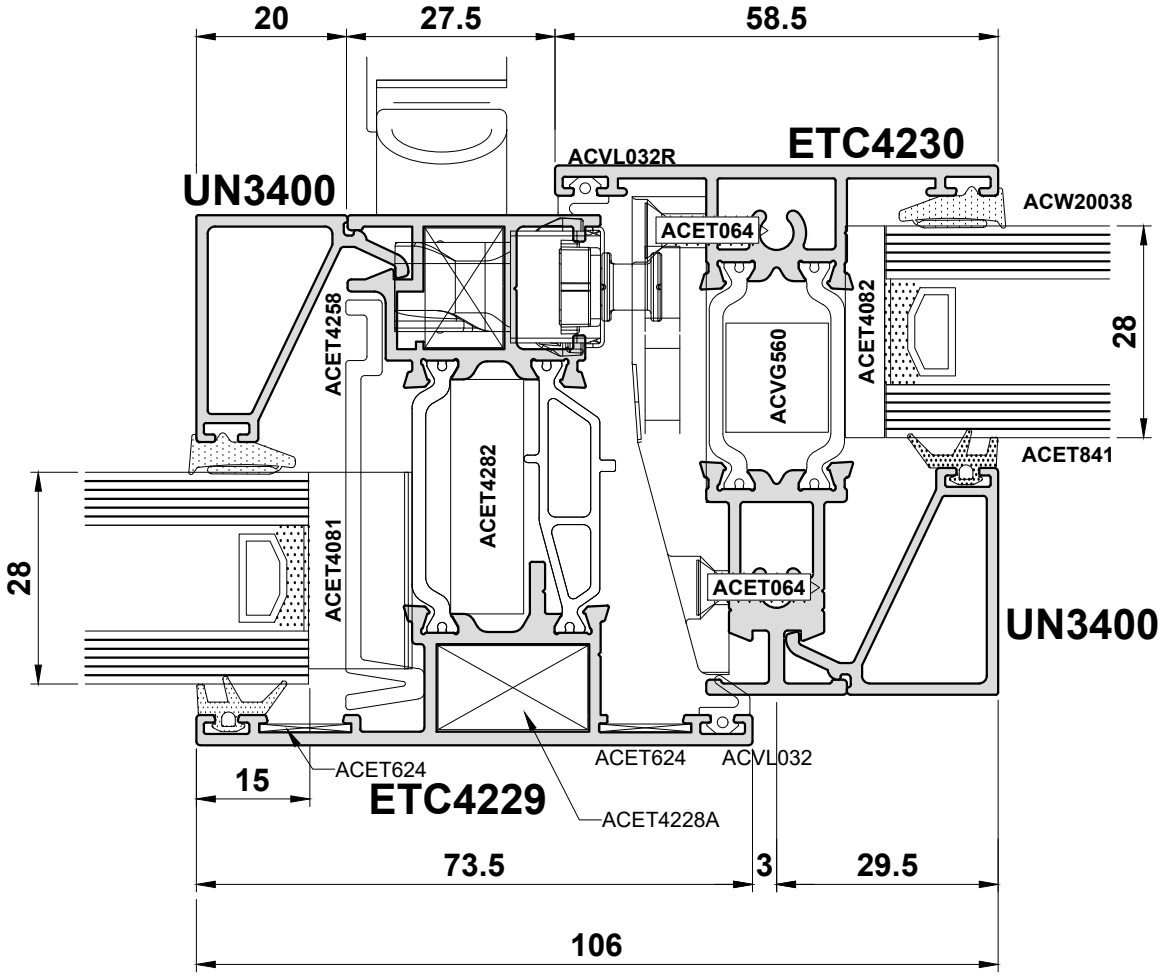


Do Not Scale From This Drawing

Alitherm 400 HD Window

Detail 10A

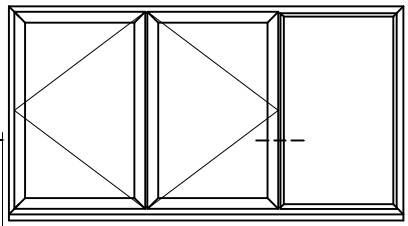


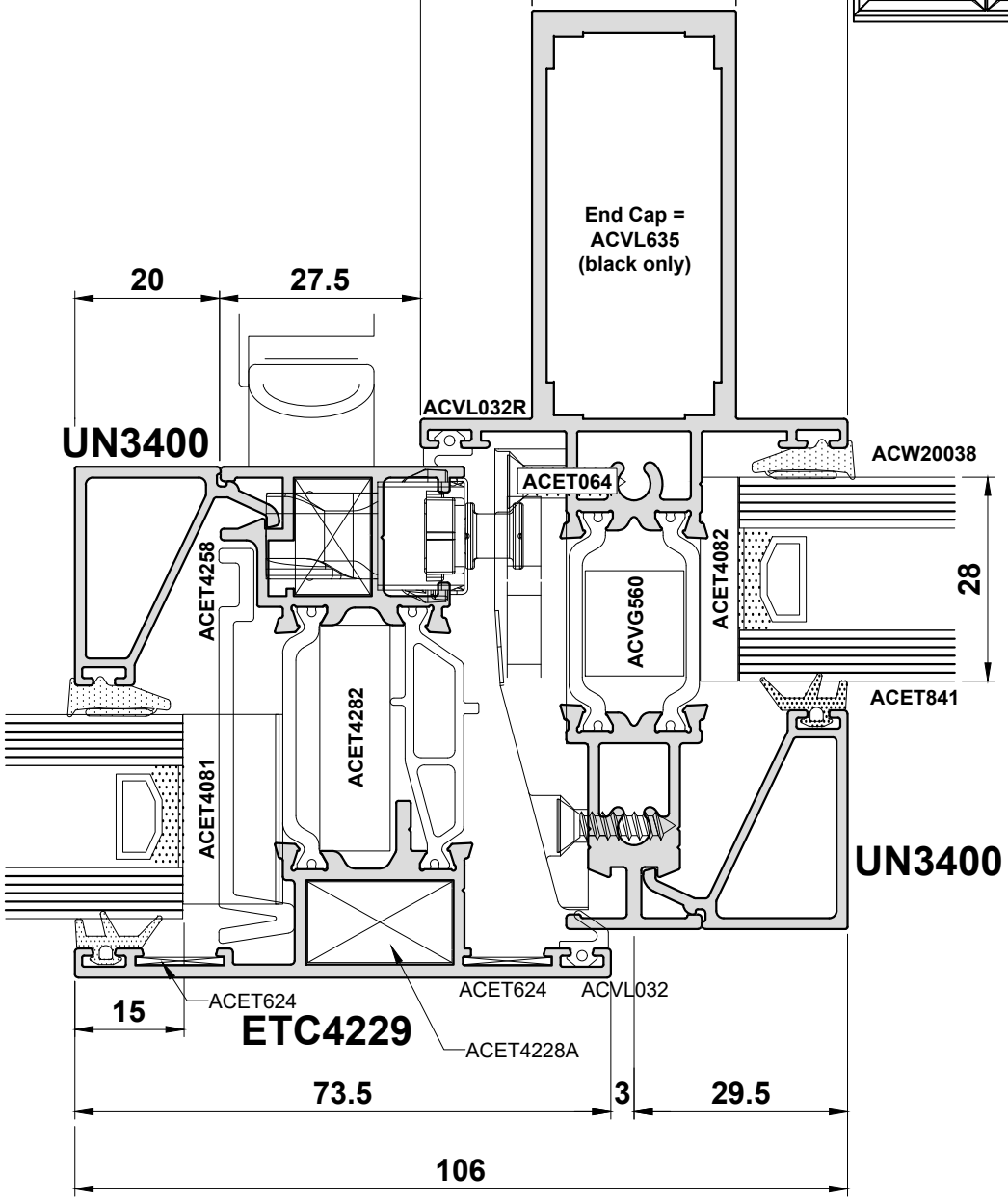


Do Not Scale From This Drawing

Alitherm 400 HD Window

Detail 10B



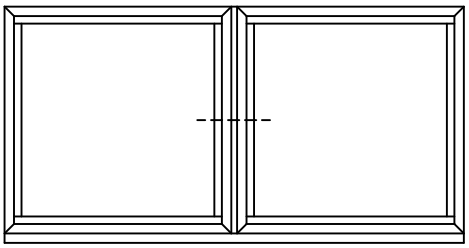


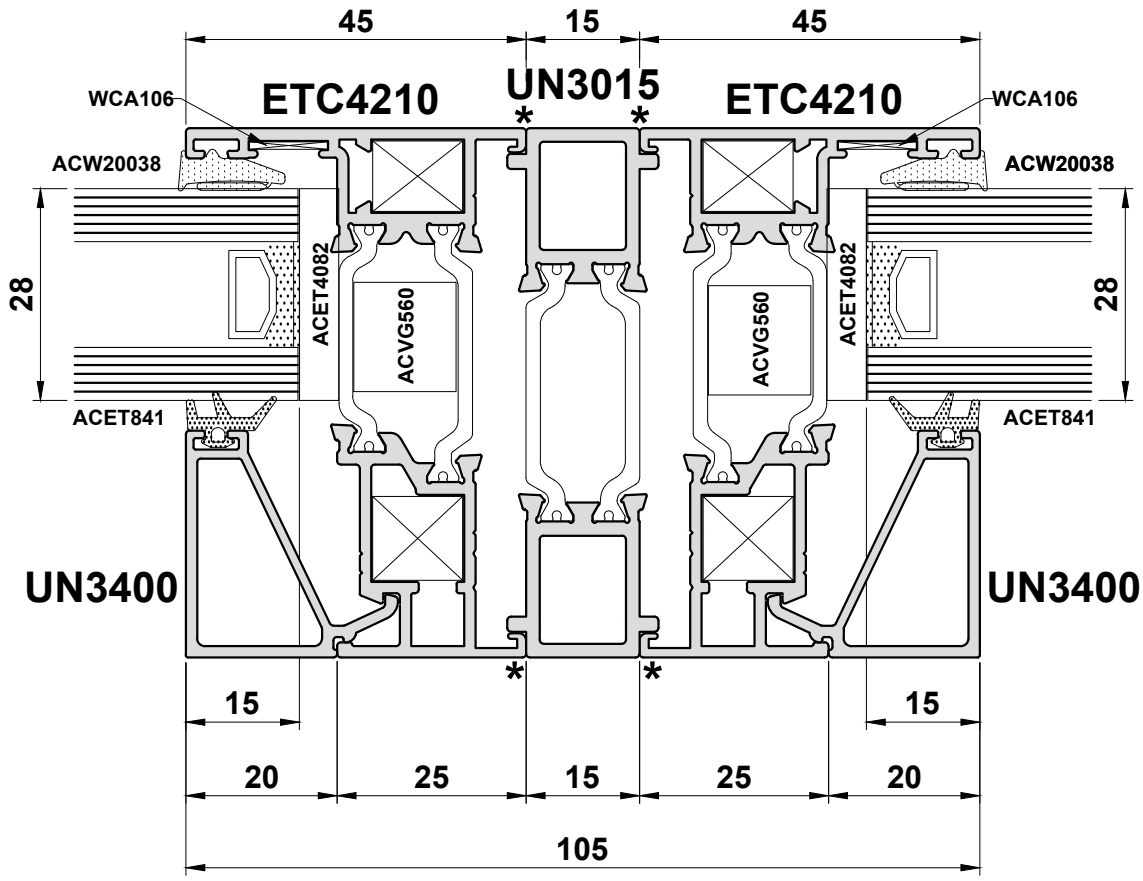
Do Not Scale From This Drawing

ISSUED: MAY 2026

Alitherm 400 HD Window

Detail 11A







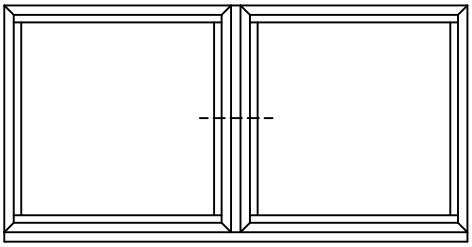
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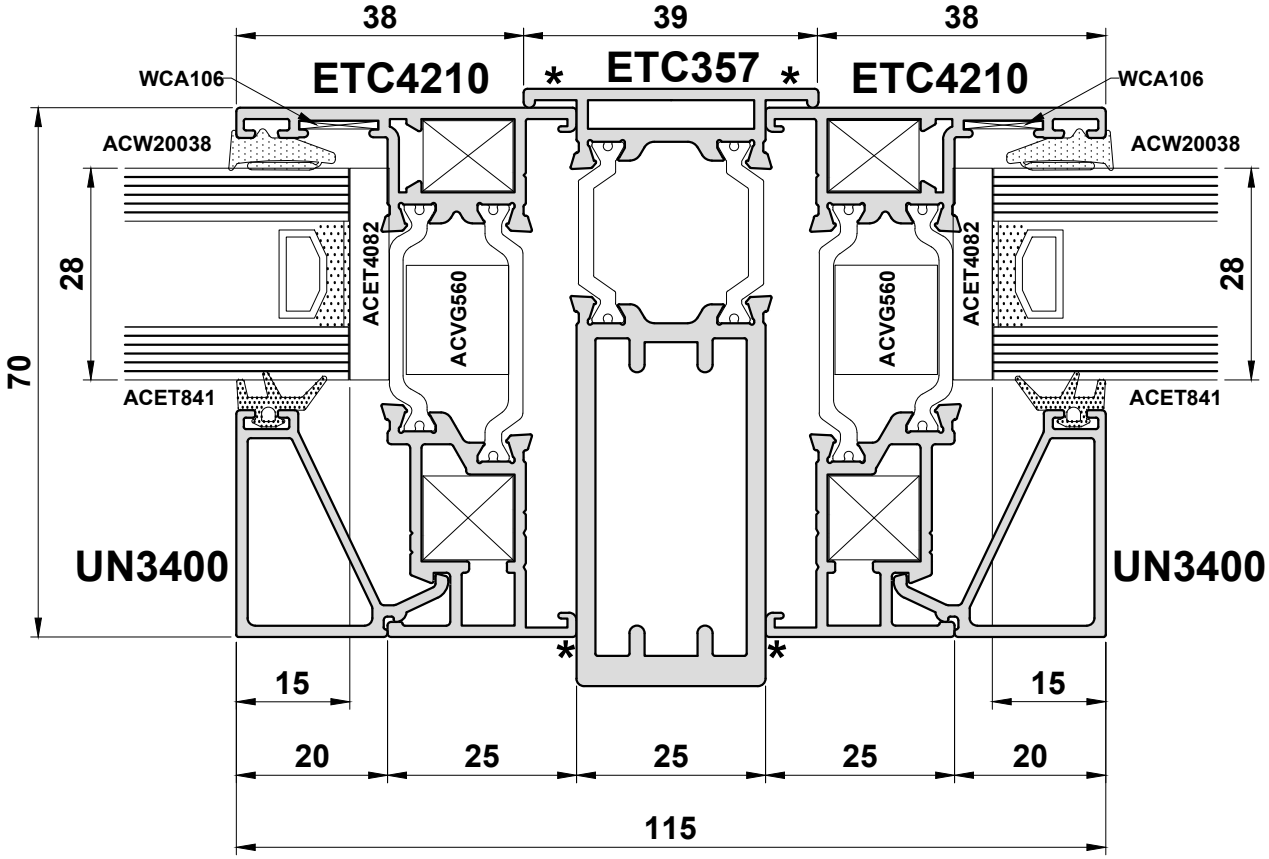
Coupler fixing not shown for clarity

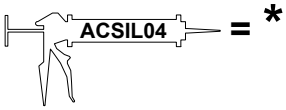
Do Not Scale From This Drawing

Alitherm 400 HD Window

Detail 11B





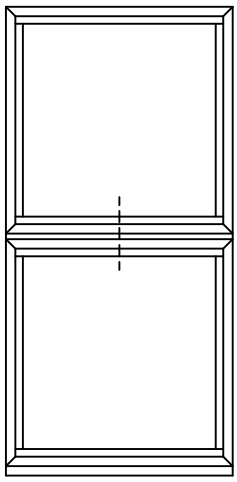


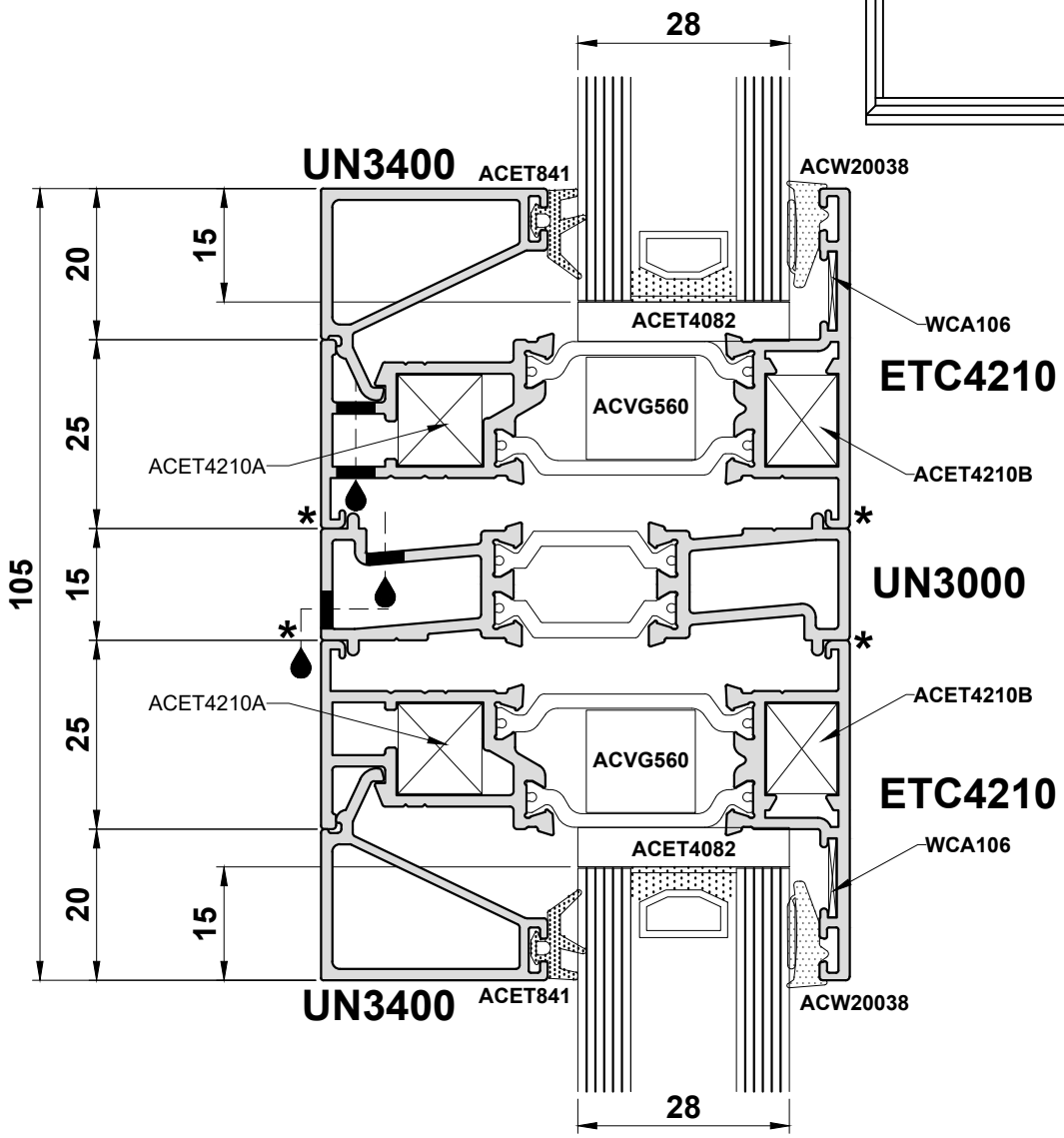
Coupler fixing not shown for clarity

Do Not Scale From This Drawing

ISSUED: MAY 2026

Detail 12





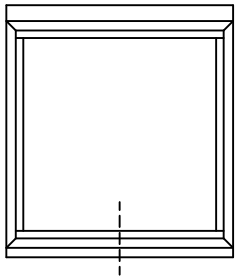
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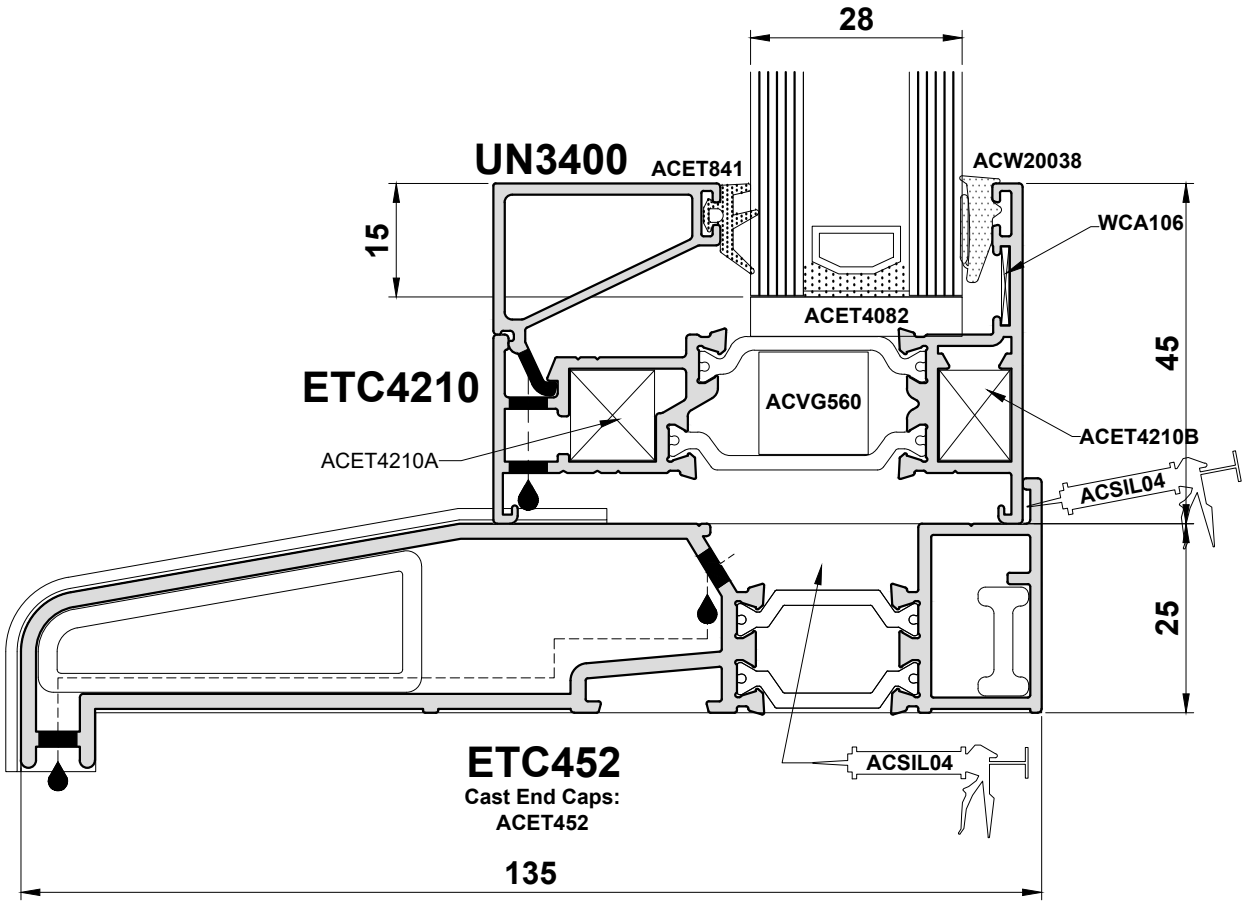
Coupler fixing not shown for clarity
Cill end caps should be sealed to cill to prevent water egress over edge

Do Not Scale From This Drawing

Alitherm 400 HD Window

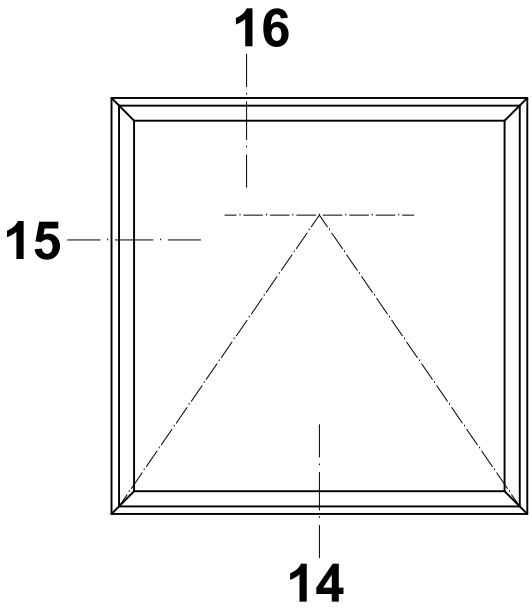
Detail 13

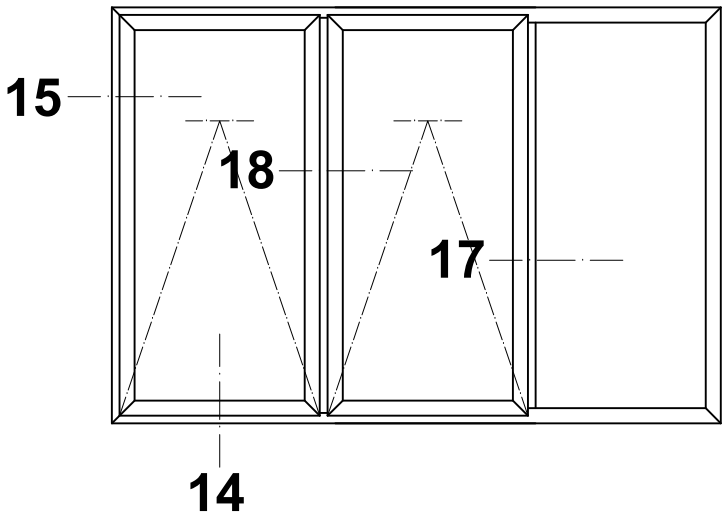




Do Not Scale From This Drawing

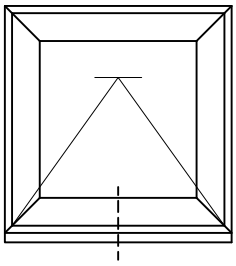
Scale Elevations - Reversible

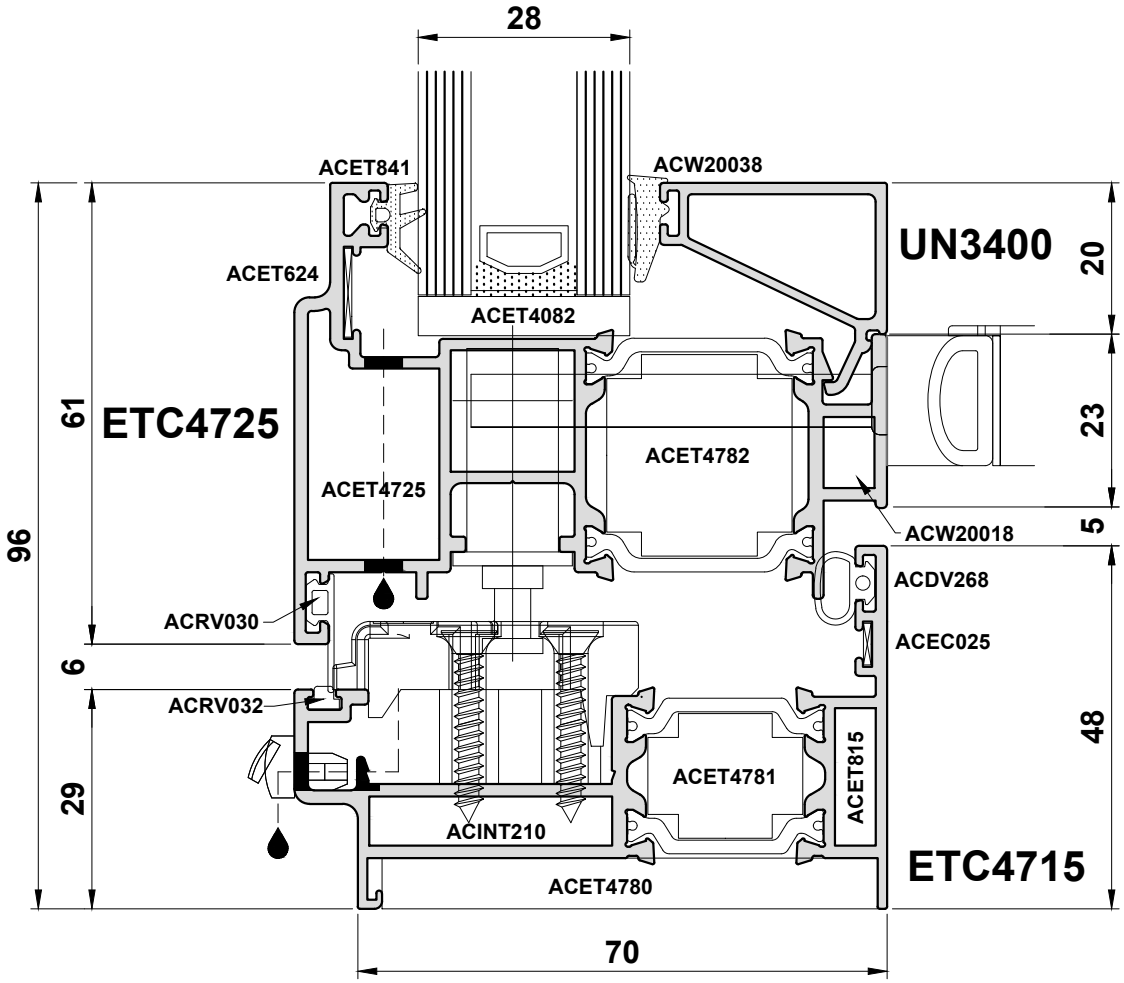




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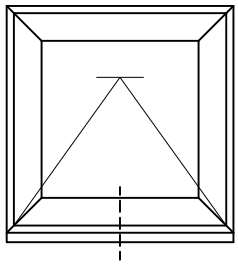
Detail 15EA

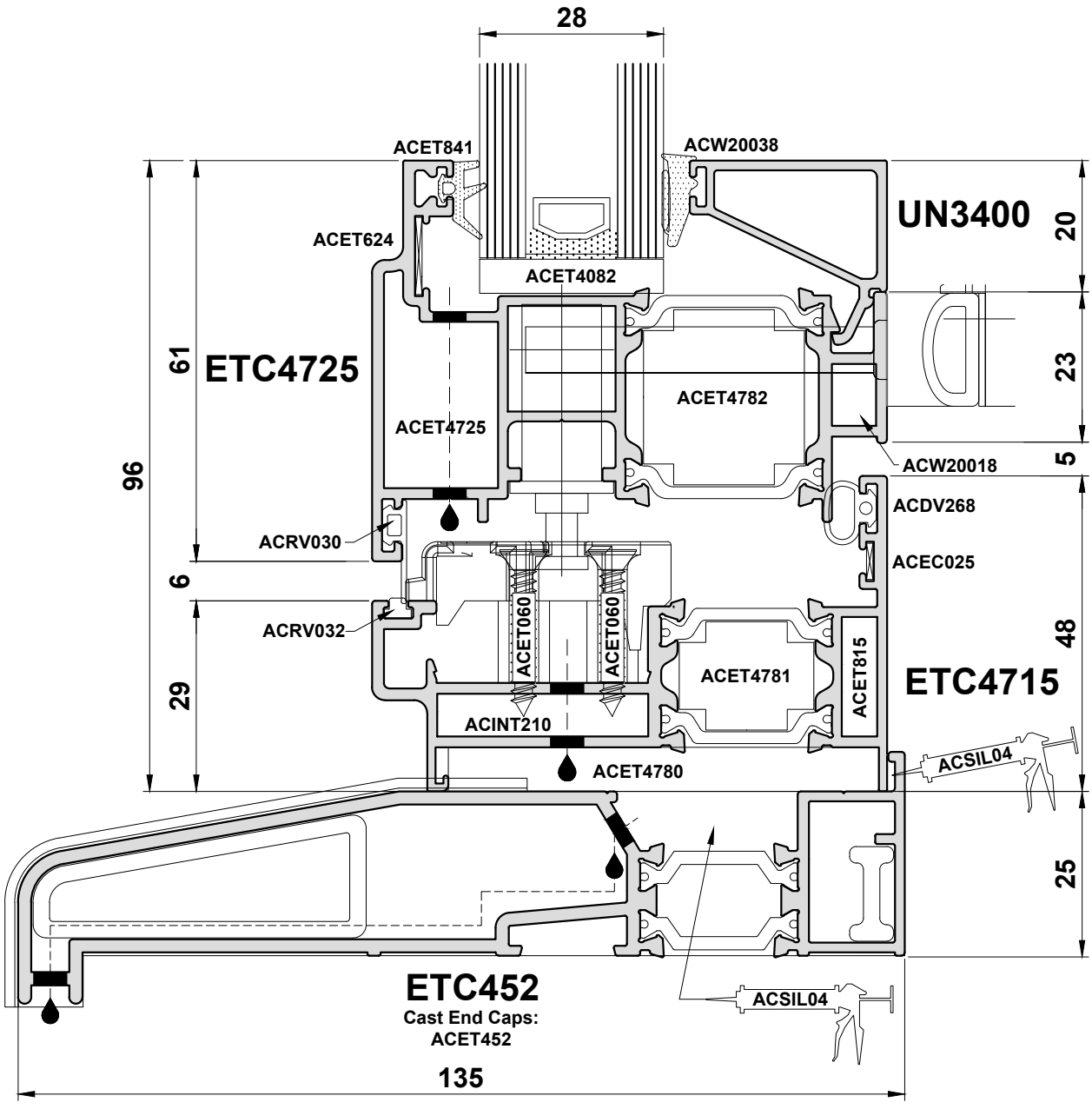




Do Not Scale From This Drawing

Detail 14B

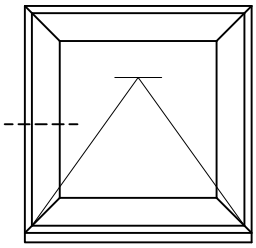


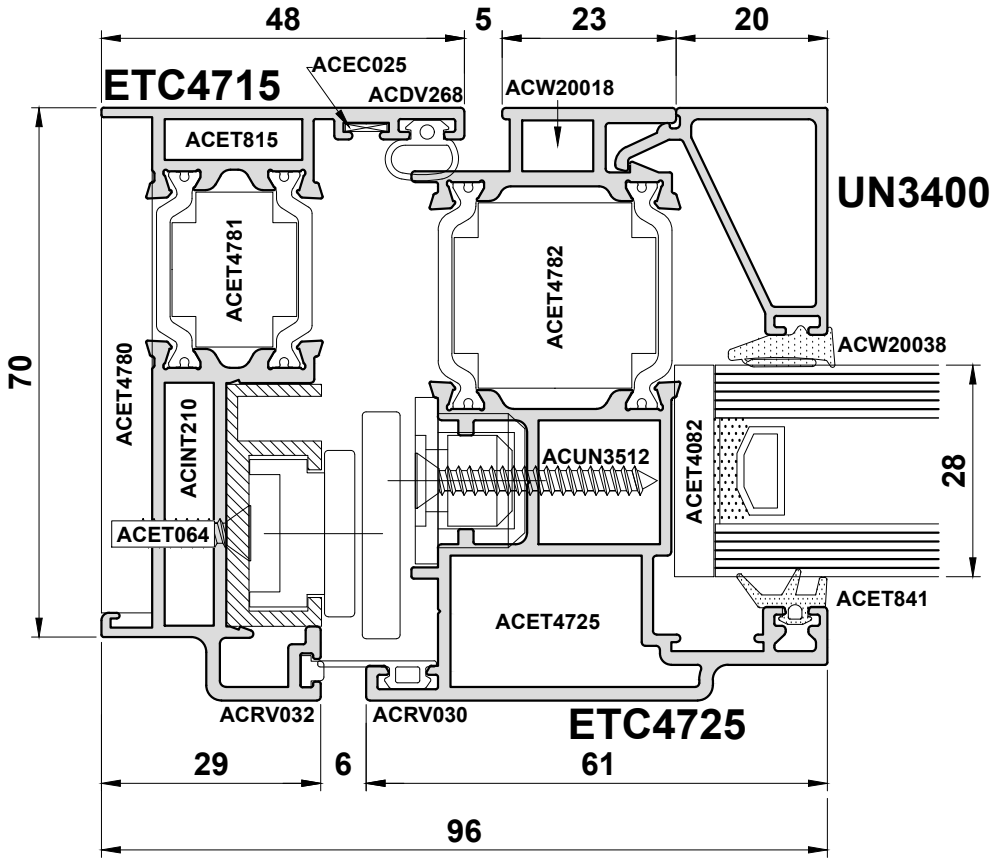


Do Not Scale From This Drawing

Alitherm 400 HD Window

Detail 15



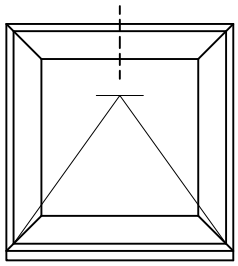


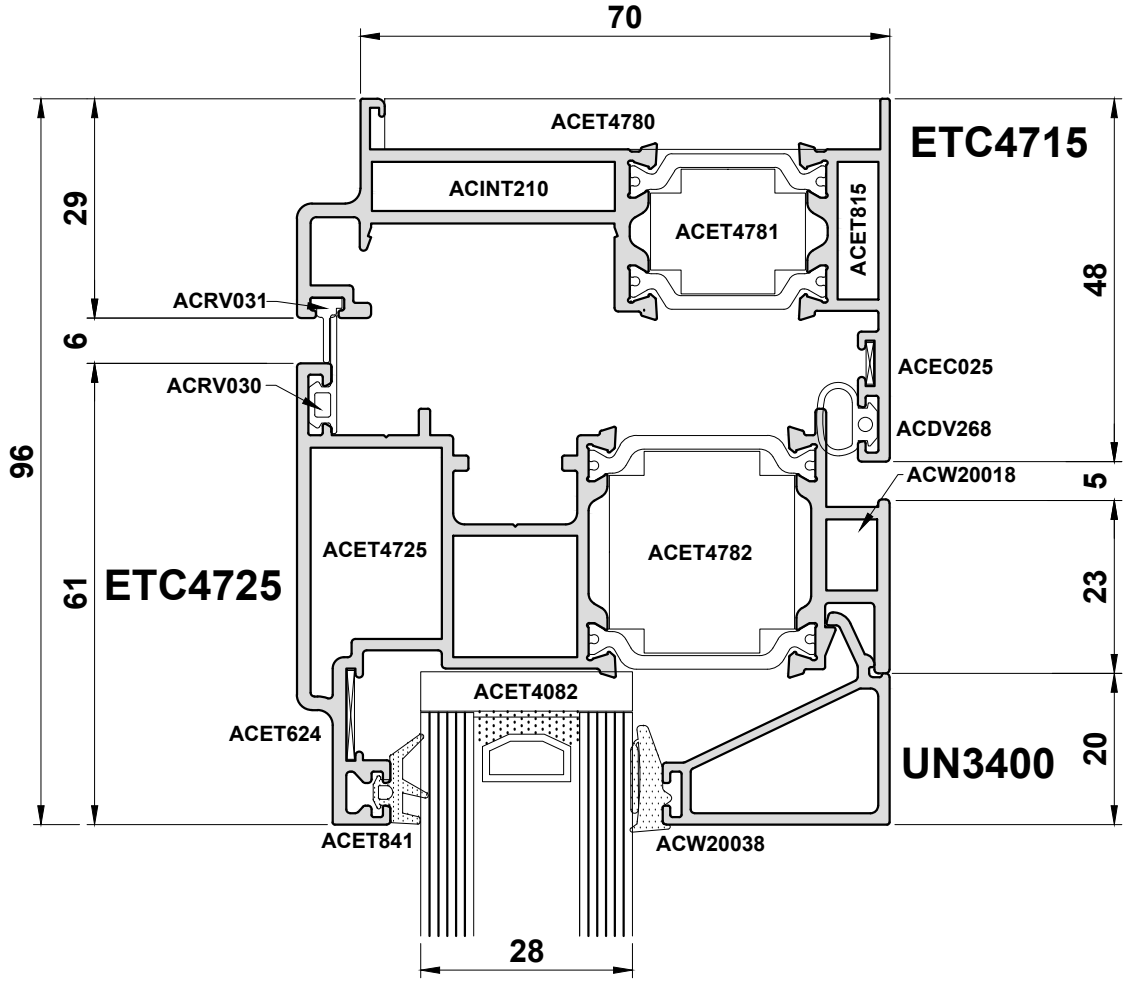
Do Not Scale From This Drawing

ISSUED: MAY 2026

Alitherm 400 HD Window

Detail 16A

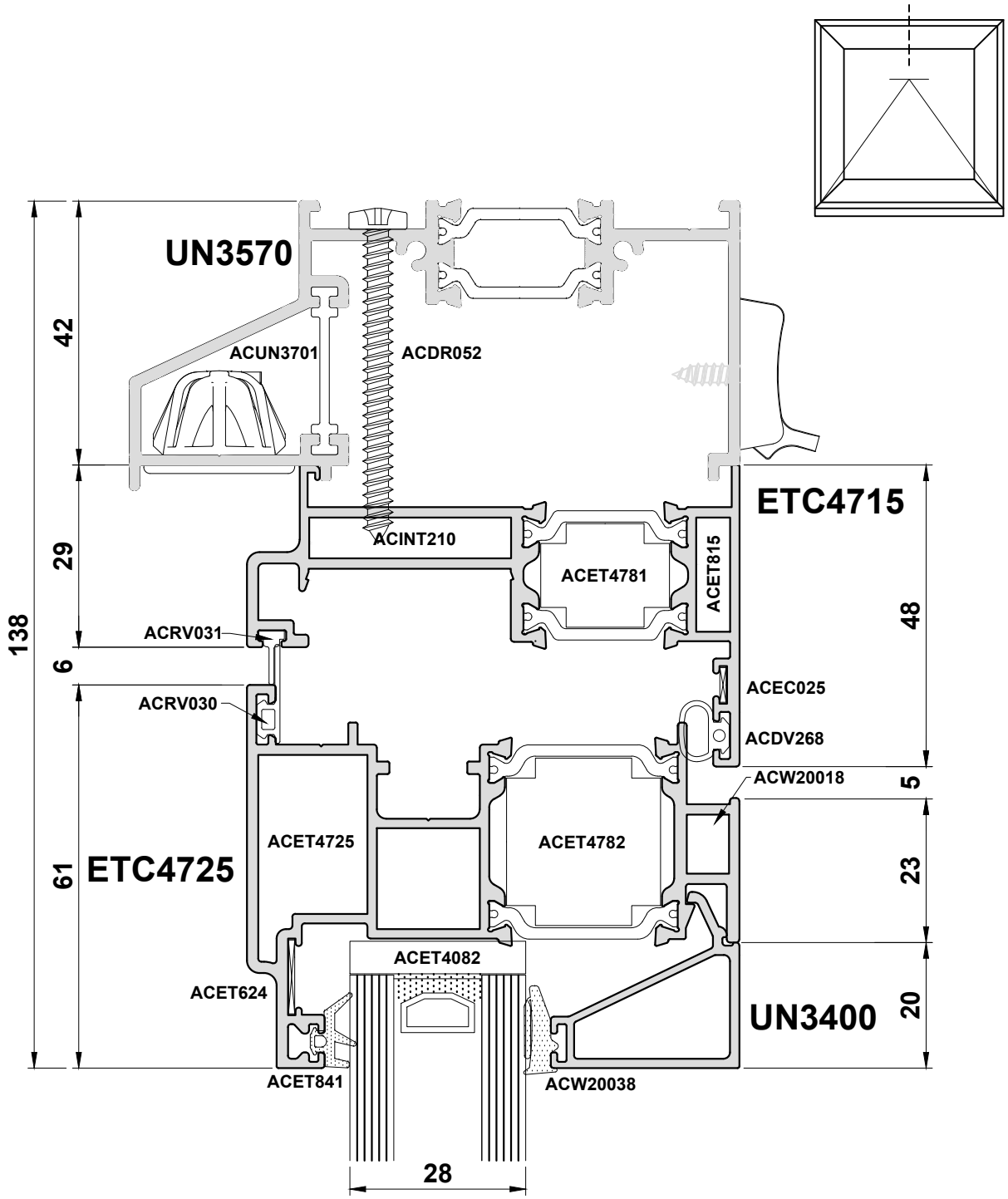




Do Not Scale From This Drawing

Alitherm 400 HD Window

Detail 16B

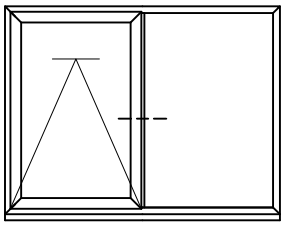


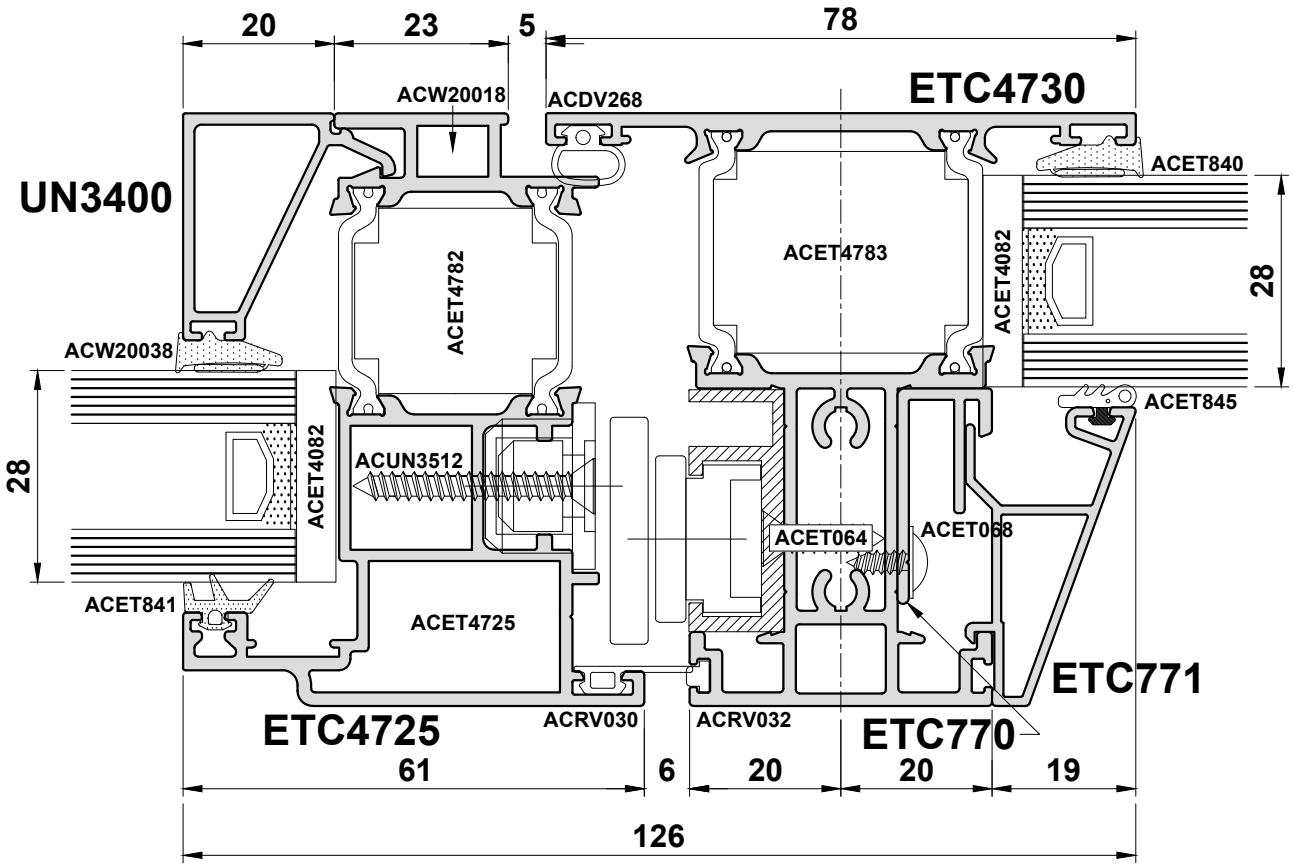
Do Not Scale From This Drawing

ISSUED: MAY 2026

Alitherm 400 HD Window

Detail 17

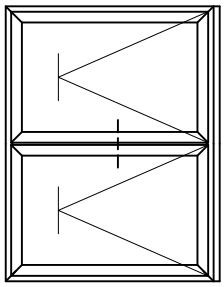


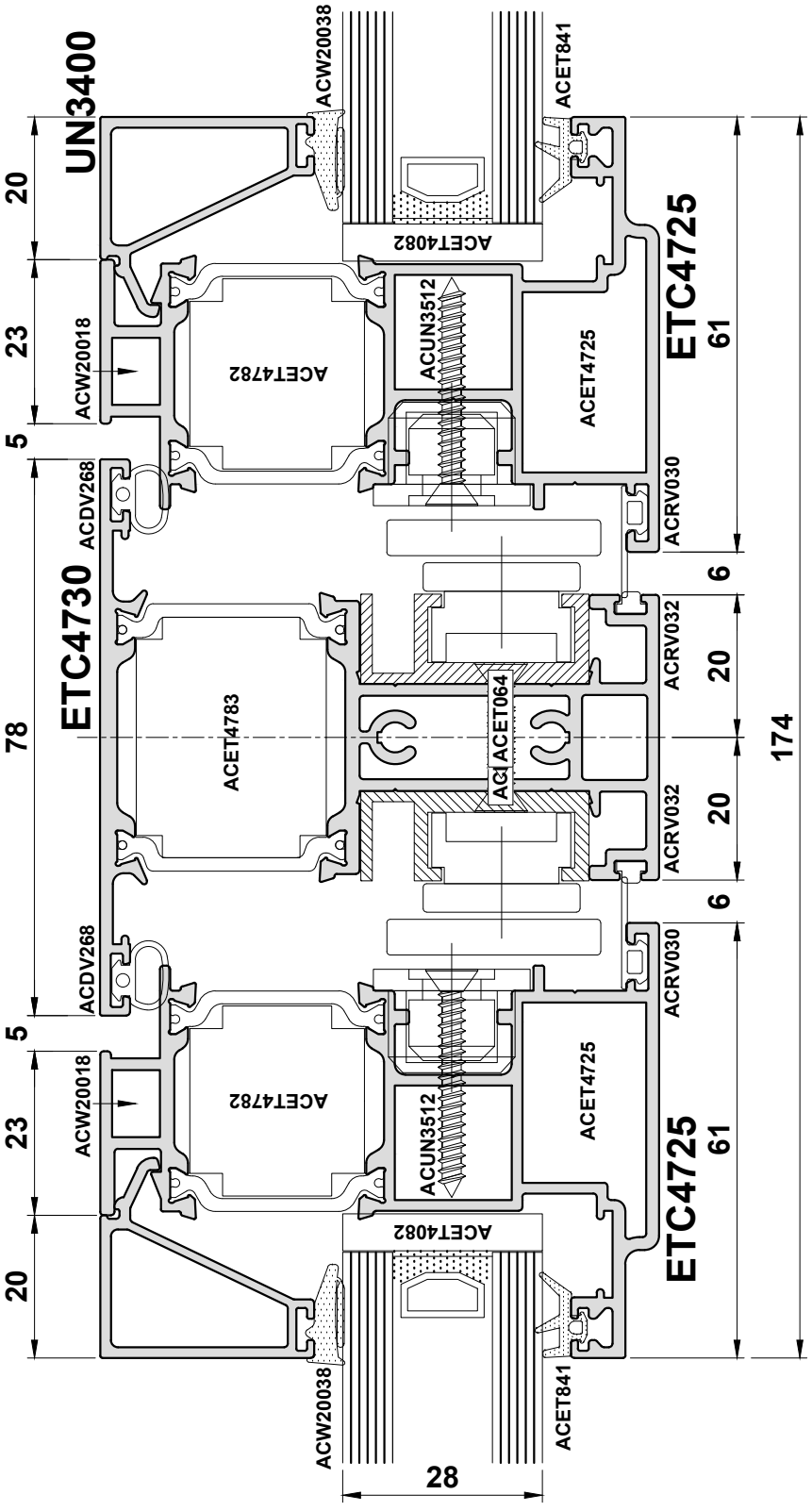


Do Not Scale From This Drawing

Alitherm 400 HD Window

Detail 18

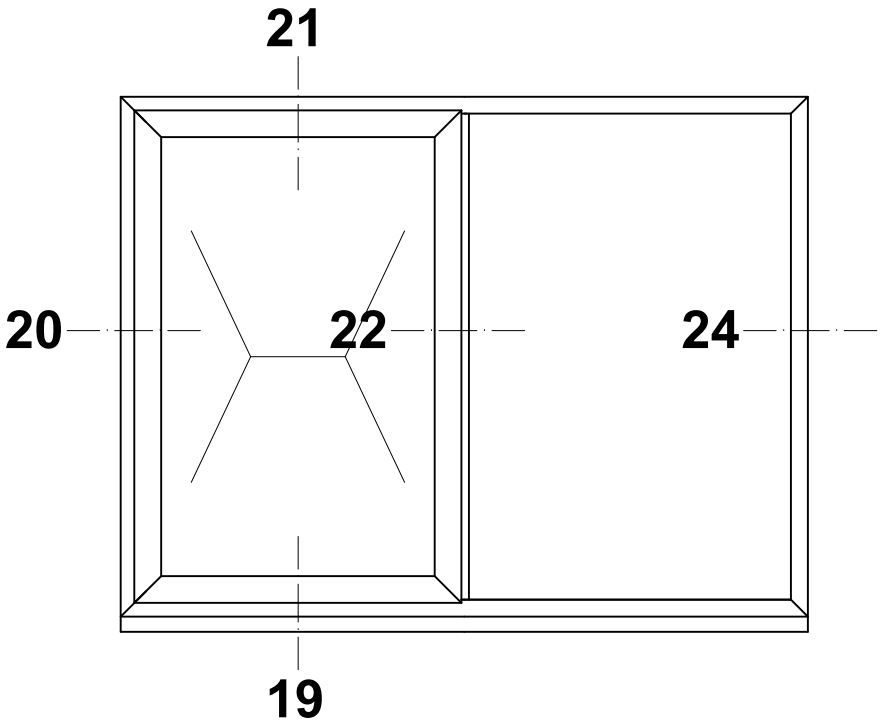


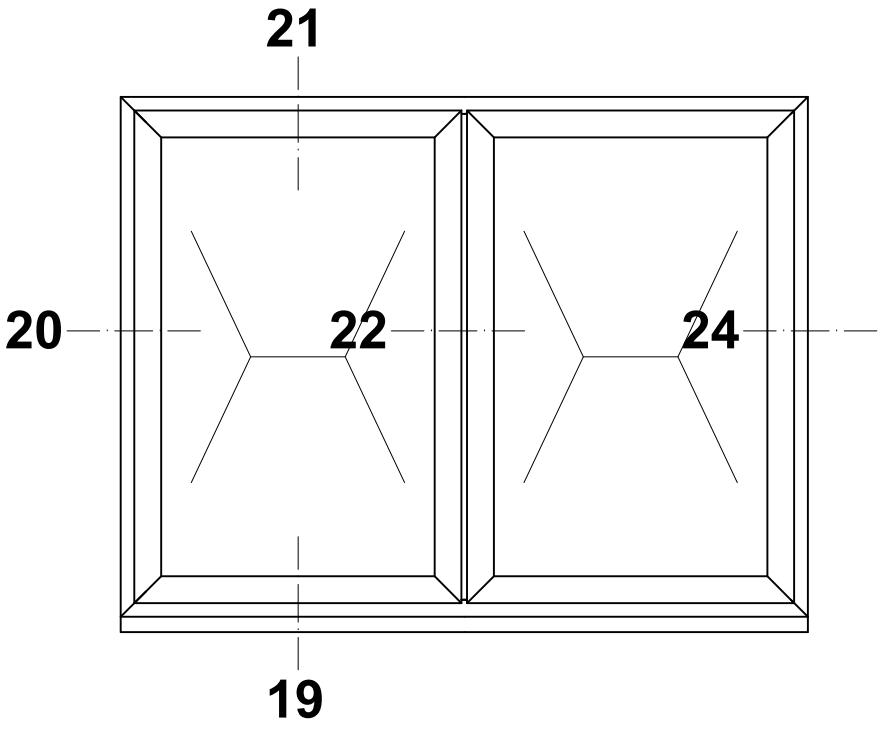


Do Not Scale From This Drawing

ISSUED: MAY 2026

Scale Elevations - Parallel

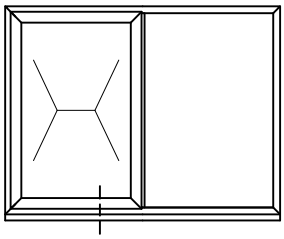


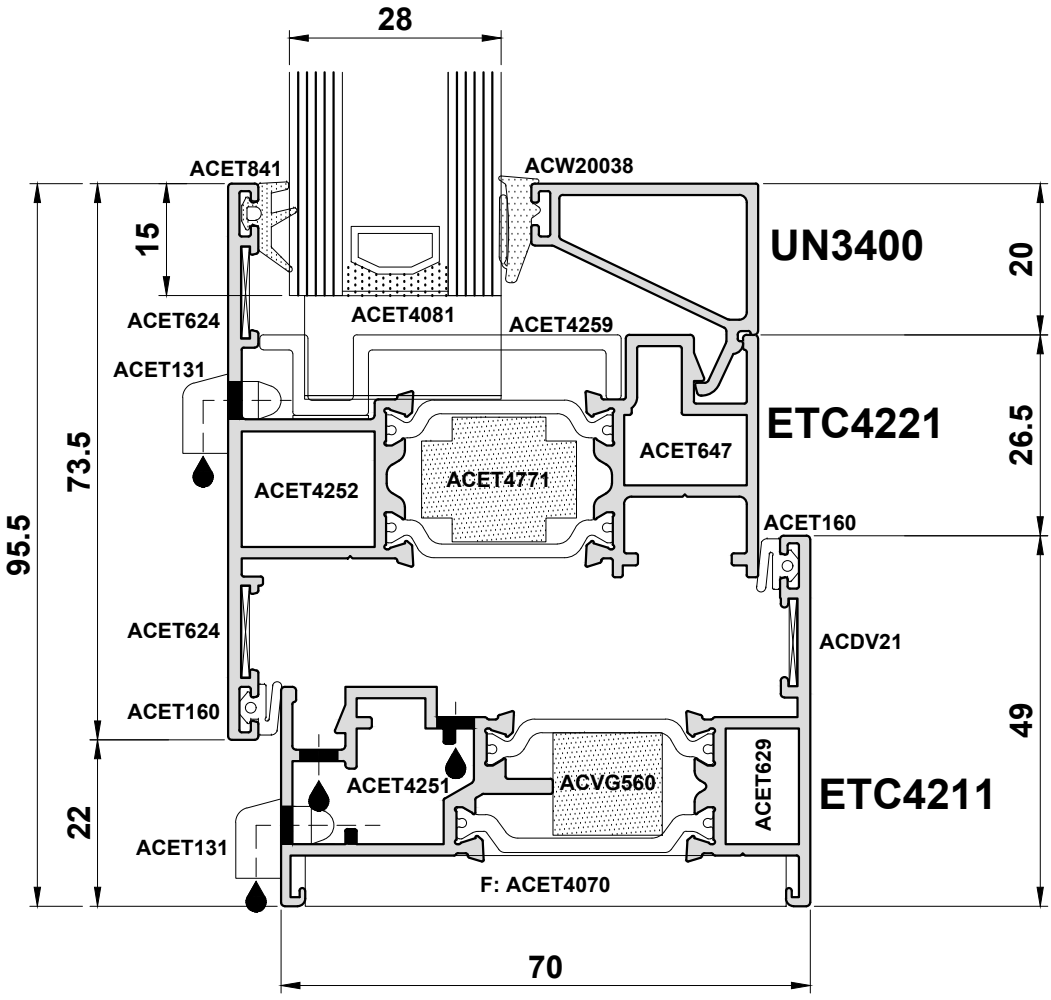


Do Not Scale From This Drawing

Alitherm 400 HD Window

Detail 19A



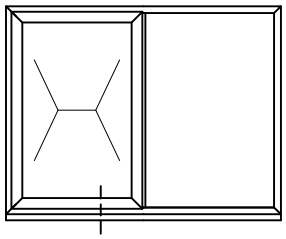


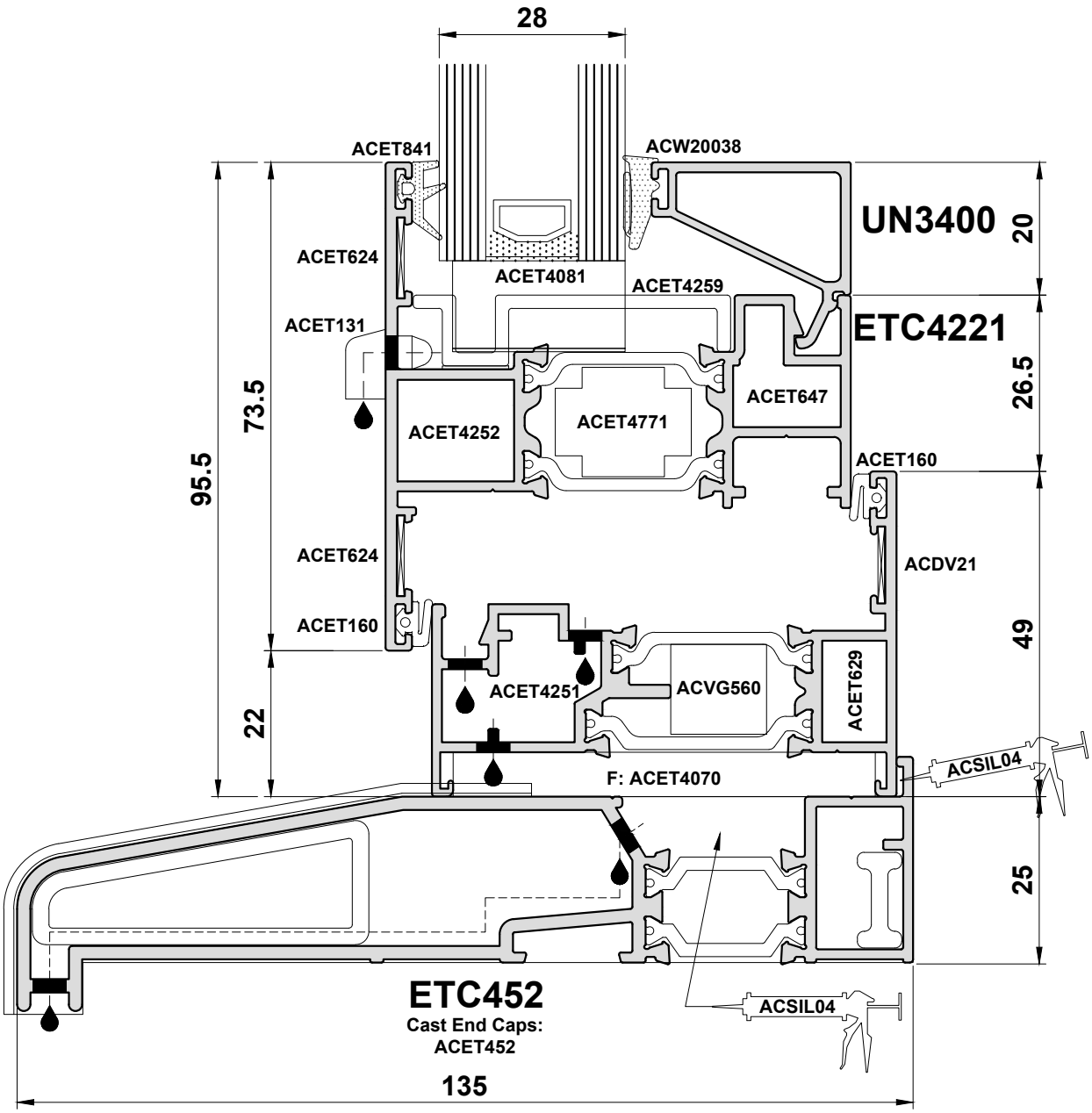
Do Not Scale From This Drawing

ISSUED: MAY 2026

Alitherm 400 HD Window

Detail 19B

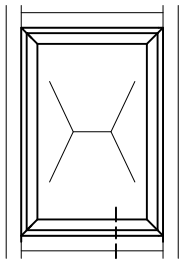


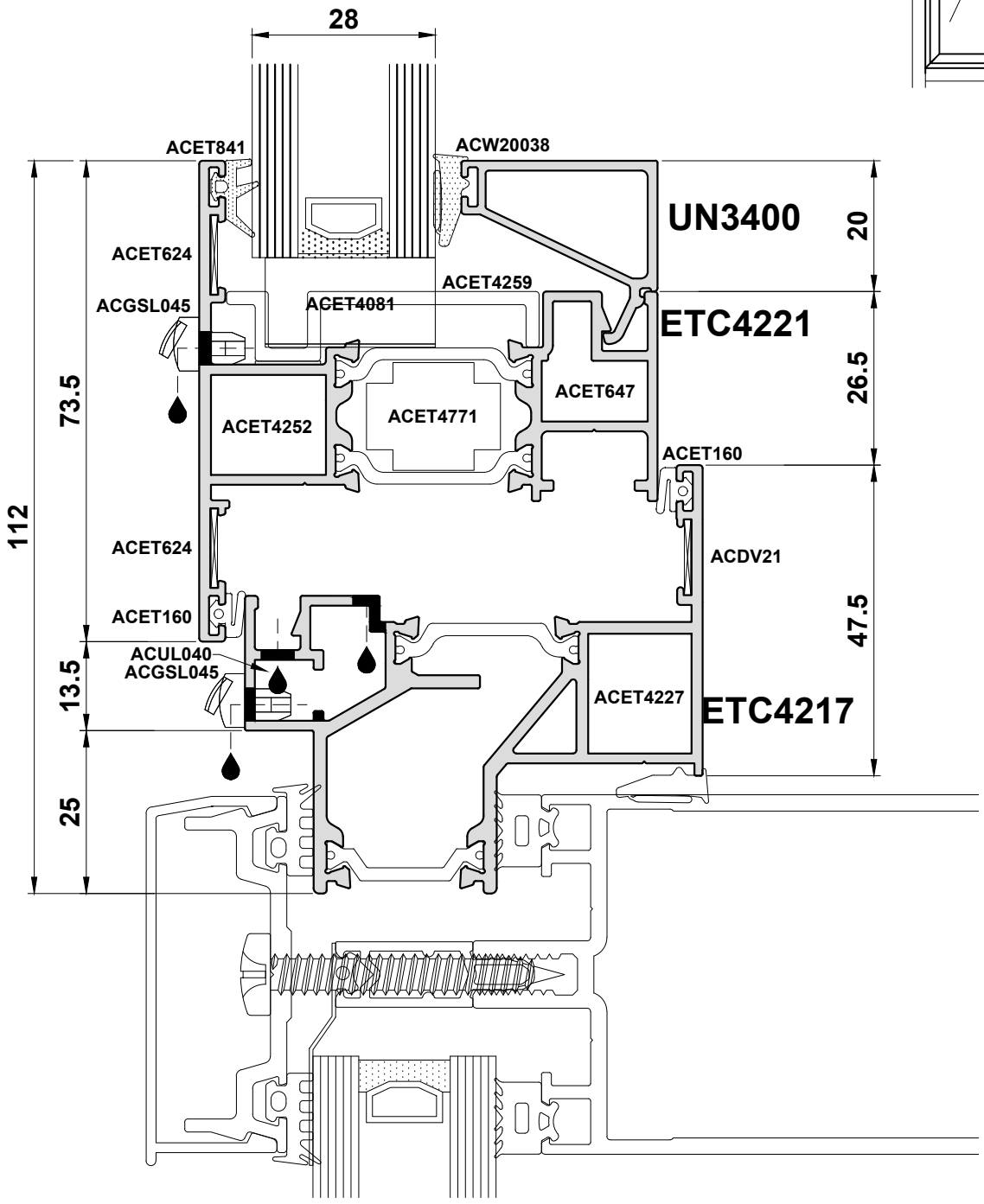


Do Not Scale From This Drawing

Alitherm 400 HD Window

Detail 19C

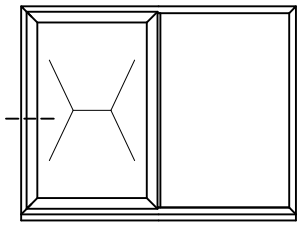


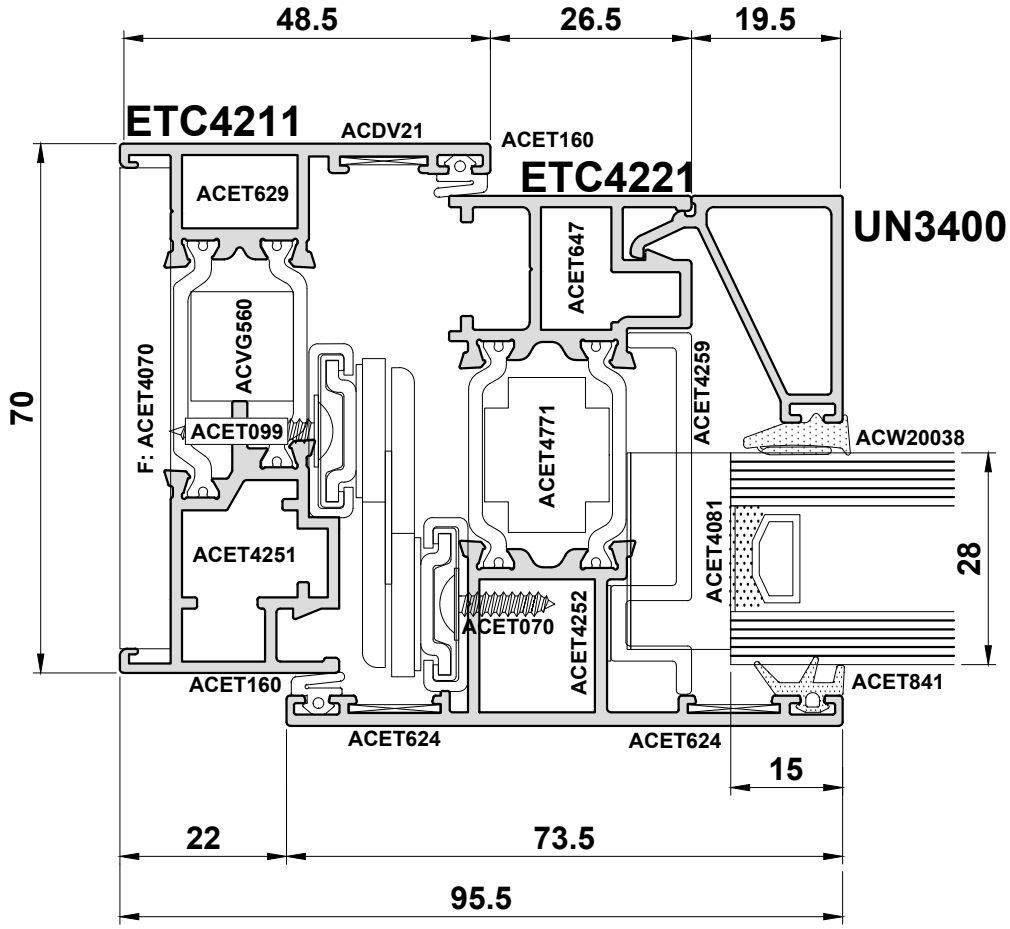


Do Not Scale From This Drawing

ISSUED: MAY 2026

Detail 20

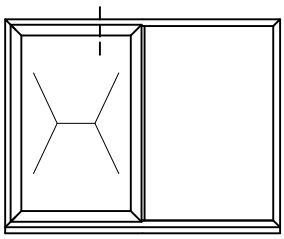


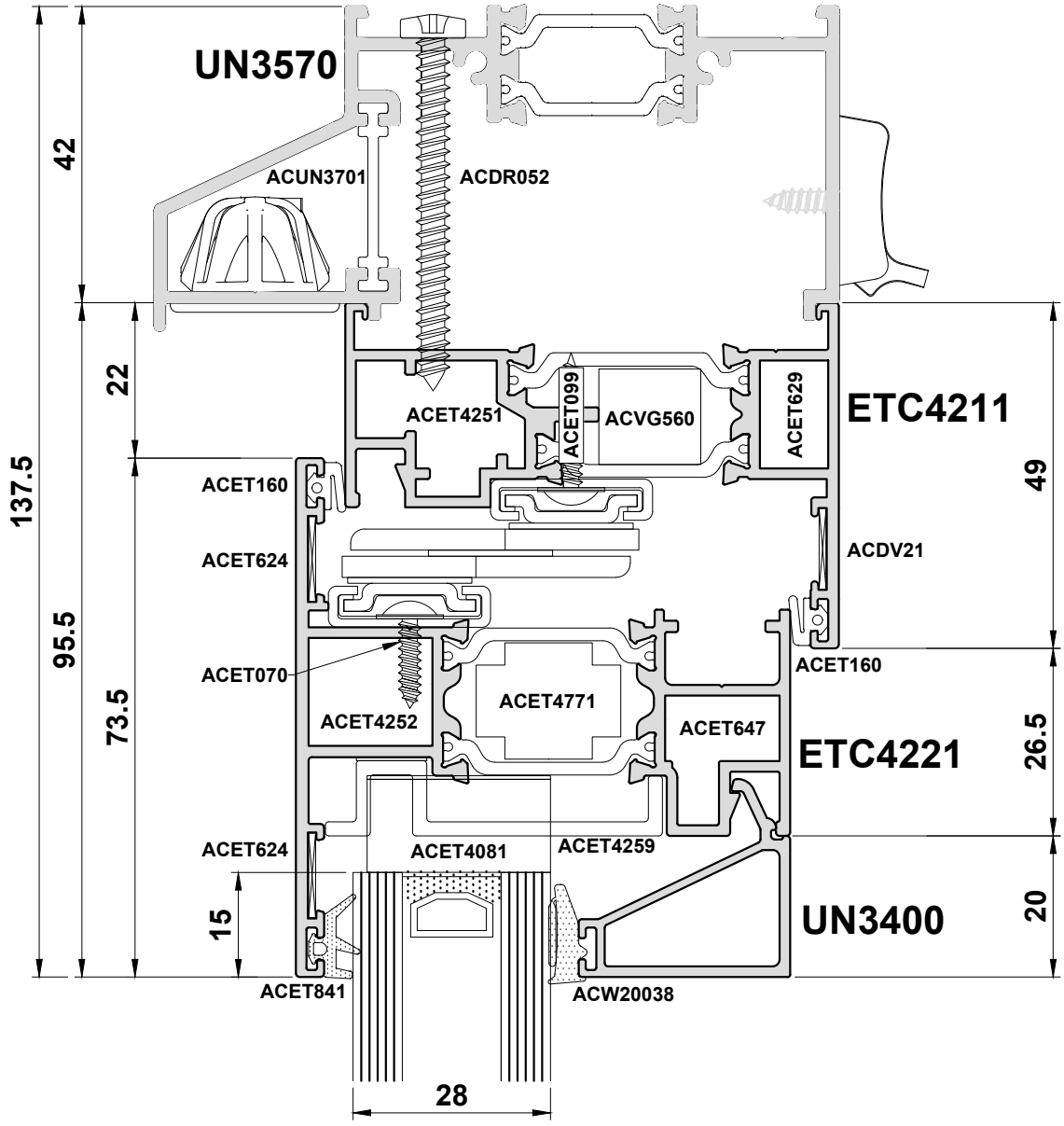


Do Not Scale From This Drawing

Alitherm 400 HD Window

Detail 21



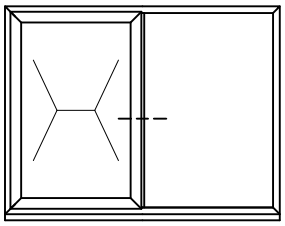


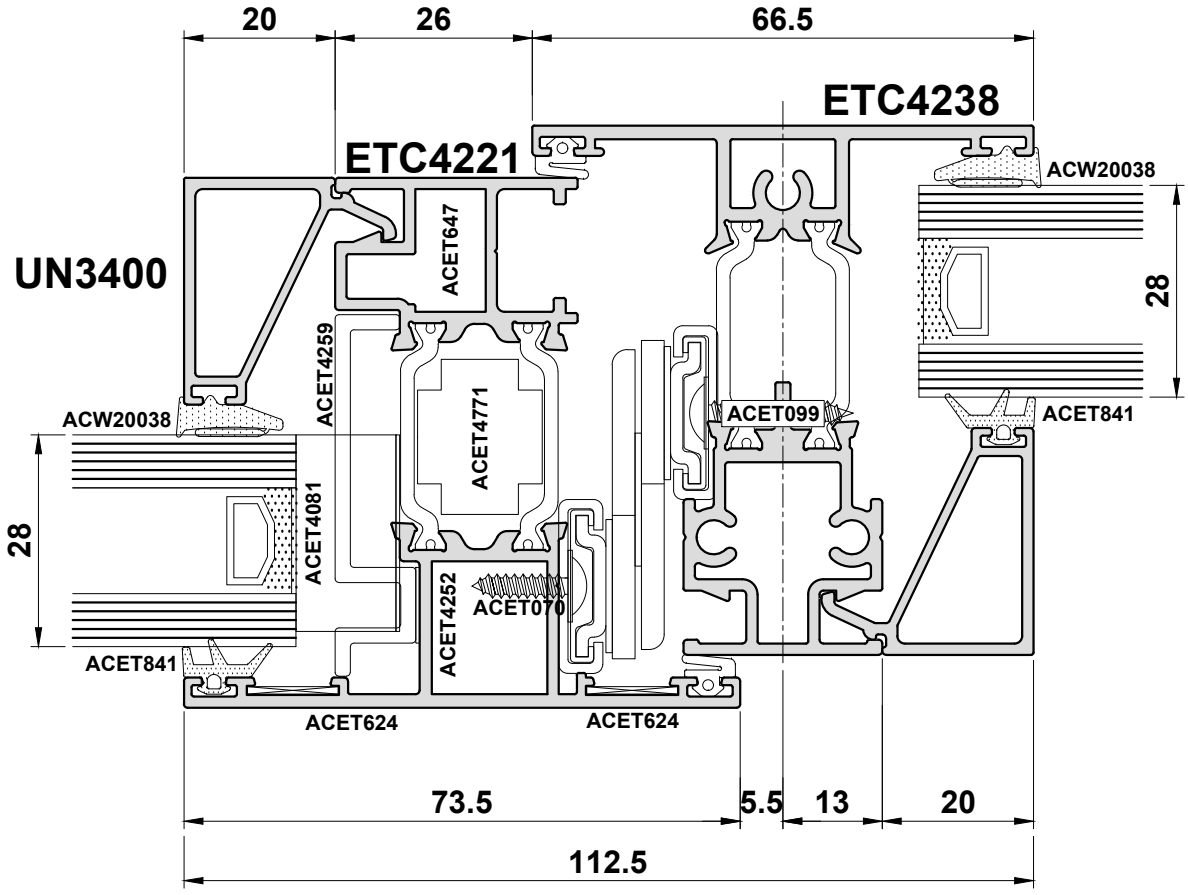
Do Not Scale From This Drawing

ISSUED: MAY 2026

Alitherm 400 HD Window

Detail 22

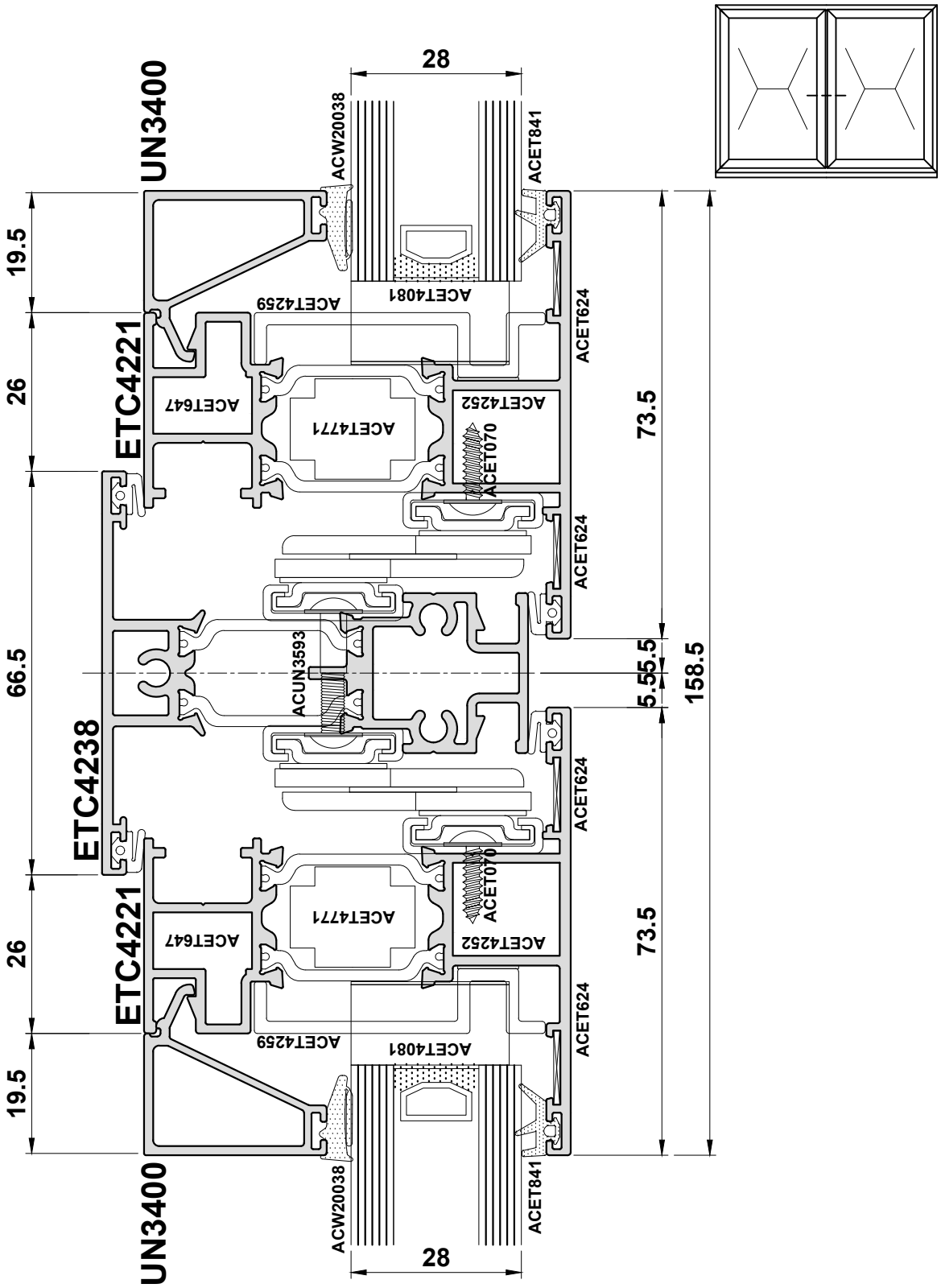




Do Not Scale From This Drawing

Alitherm 400 HD Window

Detail 23

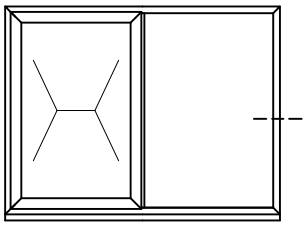


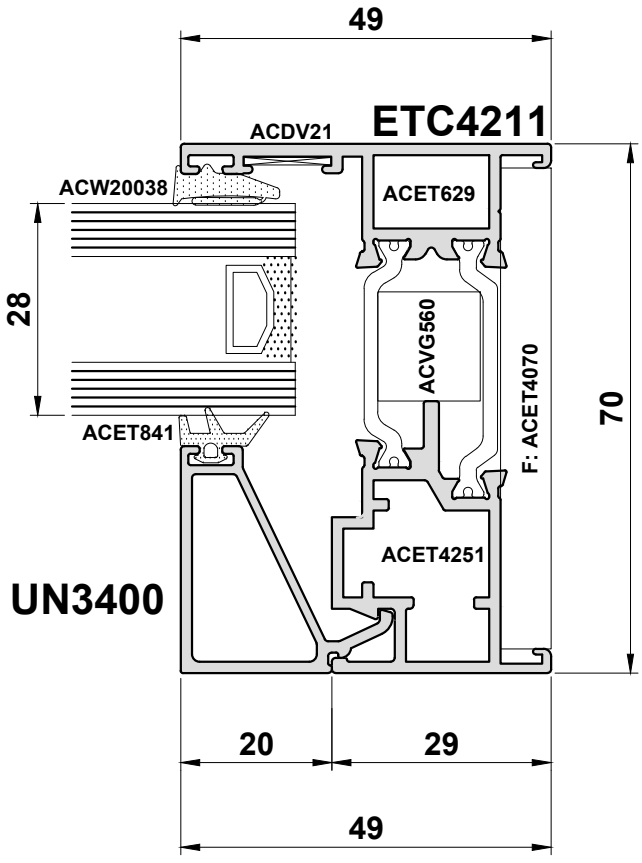
Do Not Scale From This Drawing

ISSUED: MAY 2026

Alitherm 400 HD Window

Detail 24

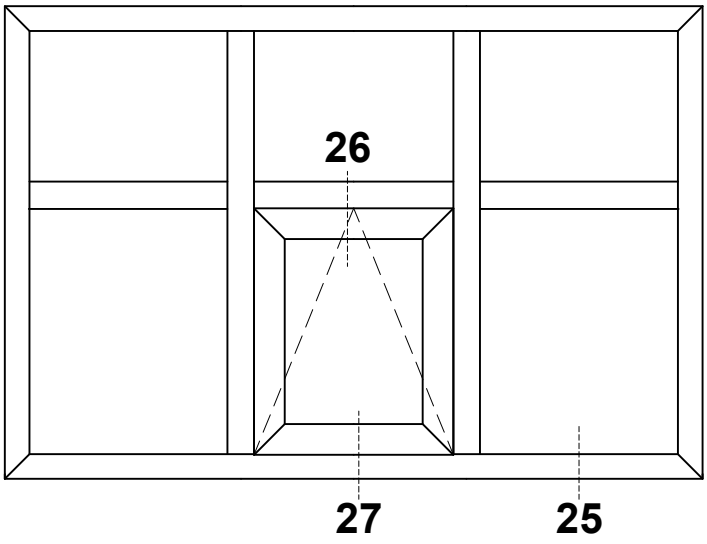


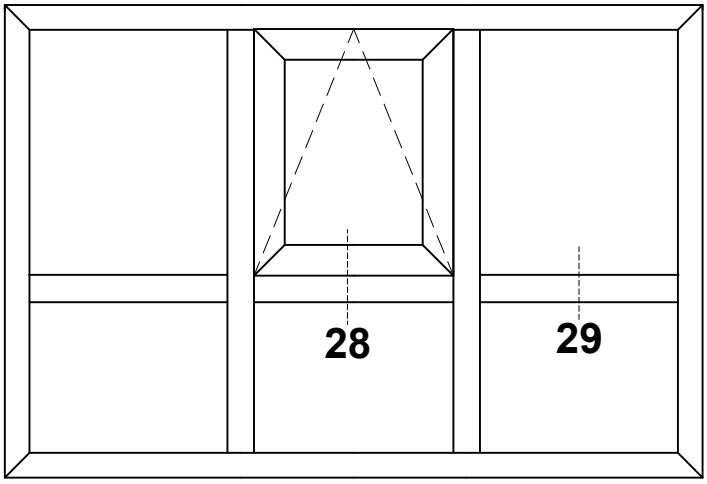


Do Not Scale From This Drawing

Alitherm 400 HD Window

Scale Elevations - Internally Glazed

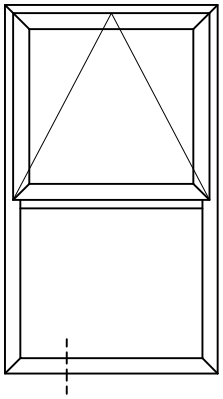


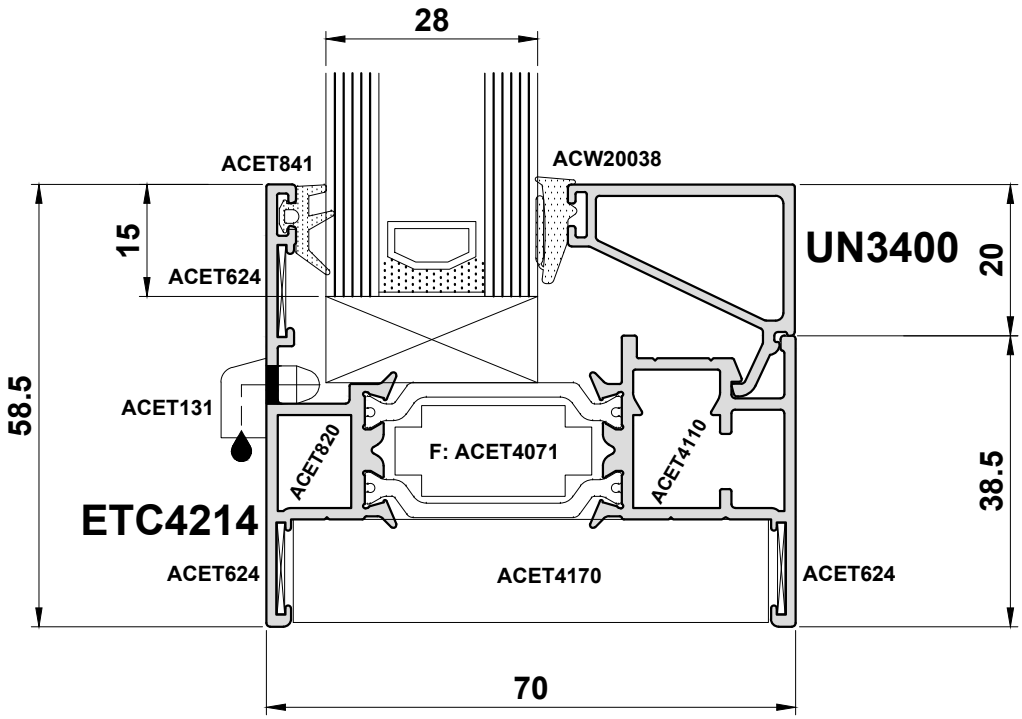


Do Not Scale From This Drawing

Alitherm 400 HD Window

Detail 25



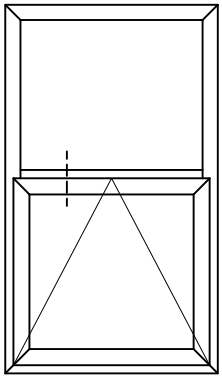


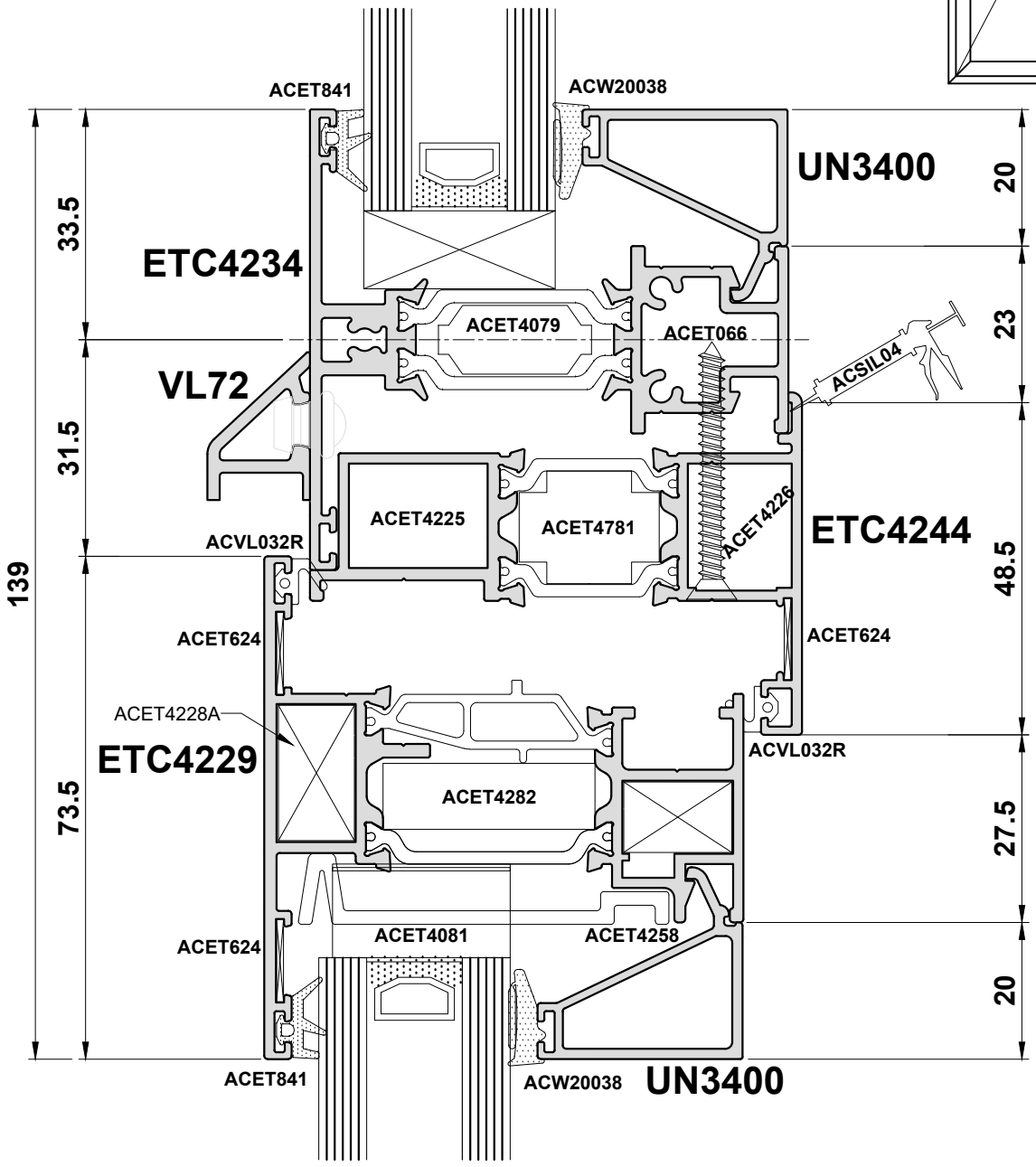
Note: Transoms will drain through the join to the outerframe.

Do Not Scale From This Drawing

Alitherm 400 HD Window

Detail 26



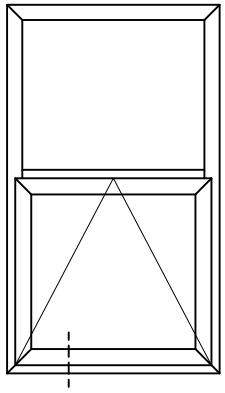


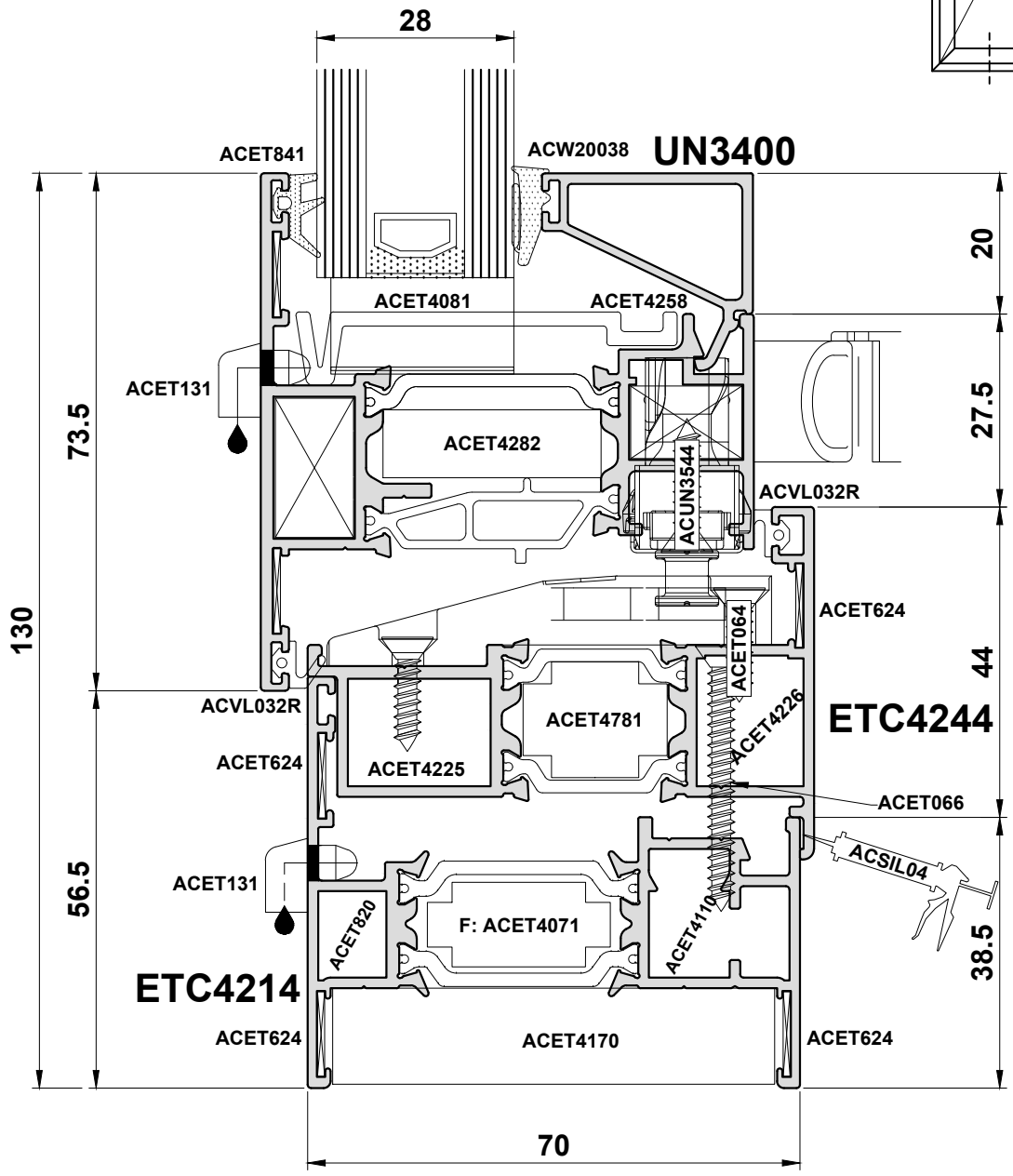
Do Not Scale From This Drawing

ISSUED: MAY 2026

Alitherm 400 HD Window

Detail 27

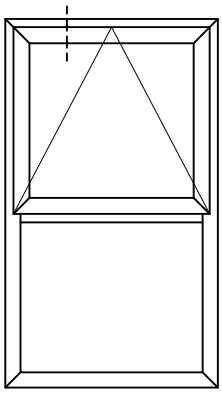


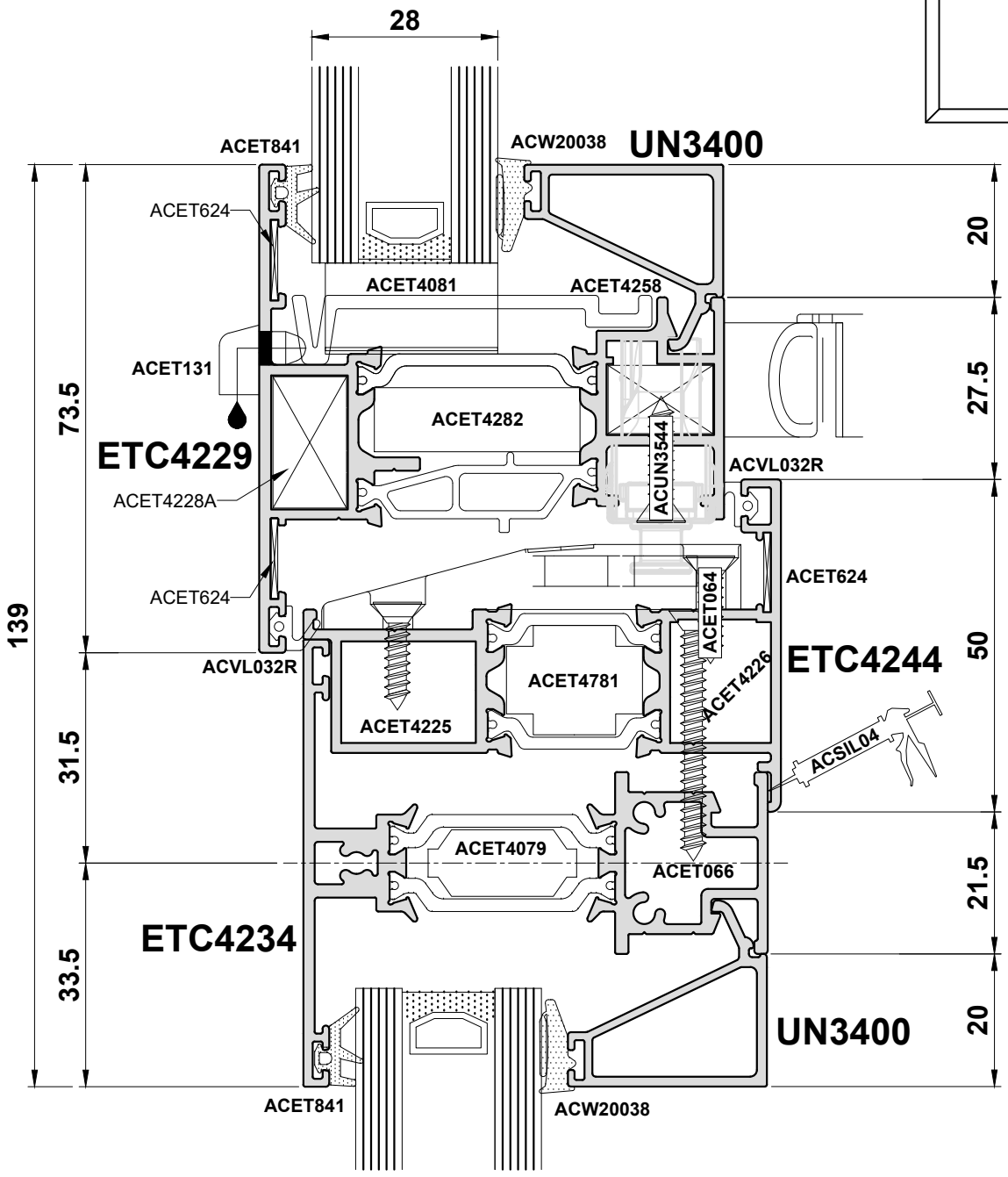


Do Not Scale From This Drawing

Alitherm 400 HD Window

Detail 28



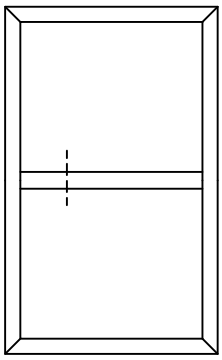


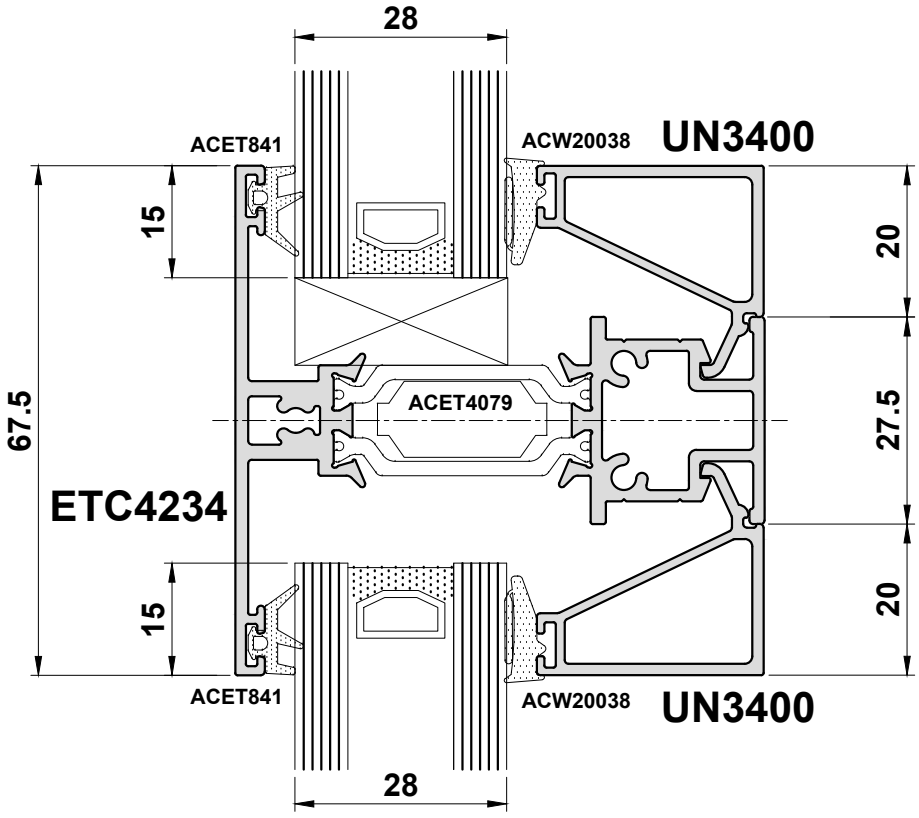
Note: Transoms will drain through the join to the outerframe.

Do Not Scale From This Drawing

Alitherm 400 HD Window

Detail 29





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

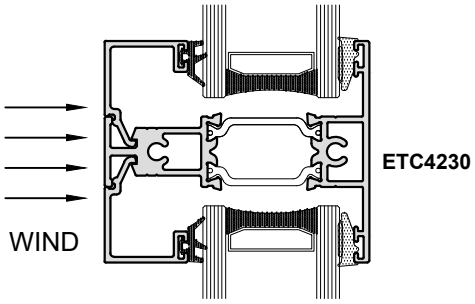
Do Not Scale From This Drawing

Do Not Scale From This Drawing

Section D

Statics

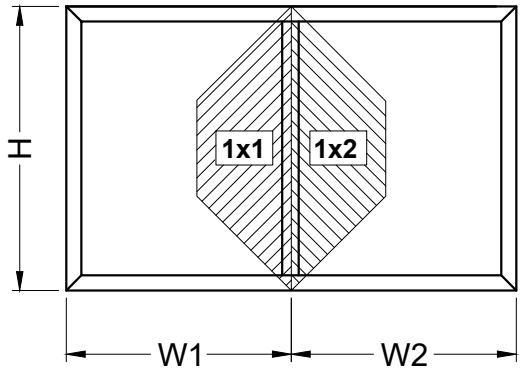
For Wind Loading Limitations, Please Contact
The Technical Department - T: 01934 833100



The position of the axes is an indication for the use and application of the moments of inertia (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

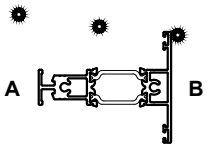
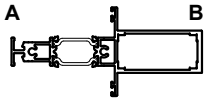
P = 1250 Pa (wind pressure)

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

Ixx = 21.0 cm4

2) Determine suitability

OK

Number	Picture	Ix(cm4) wx(cm3)	Iy(cm4) wy(cm3)
ETC4230		**28.81** — **7.17**	**4.75** — **1.62**
ETC4236		**115.69** — **17.22**	**9.23** — **3.15**

Section E

E ETC Construction Drawings

Casement

Corner Joint Details..... E03-E04
Drainage..... E05
Friction Hinges & Accessories..... E06-E07
Transom/Mullion Details..... E08-E11
Locking Details..... E12-E14
Glass Adjustor..... E15

Reversible

Corner Joint Details..... E16
Drainage..... E17
Transom/Mullion Details..... E18
Locking Details..... E19
Hinge Details..... E20-E22

Parallel

Corner Joint Details..... E23
Drainage..... E05
Locking Details..... E24-E25
Hinge Details..... E26-E28

Internally Glazed

Corner Joint Details..... E29
Drainage..... E30
Transom/Mullion Details..... E31

General

Cill Drainage & Joining Details..... E32-E33
Glazing..... E34-E38
UN3570 Head Extension..... E39
Fixing Strap Details..... E40
Bay Poles..... E41-E46
Horizontal Coupler..... E47

Corner Joint Details

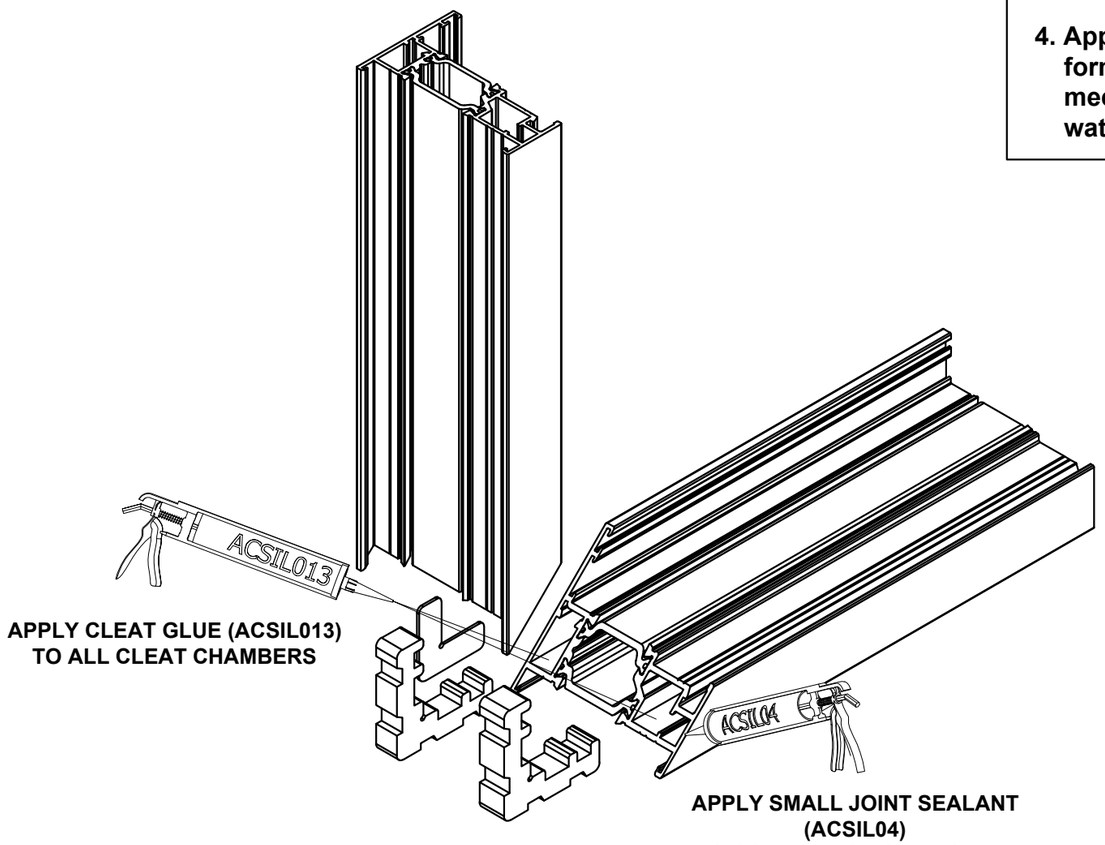
To ensure accurate corners, we recommend the use of support blocks (by others) whilst cutting. Do NOT clamp directly onto the polyamide.

Notes

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

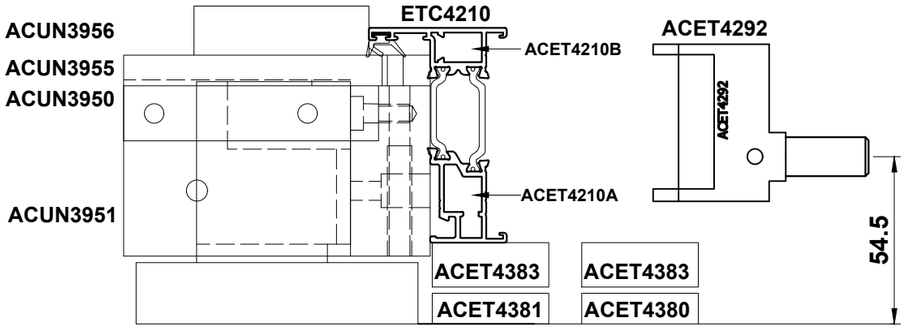
Table 1

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

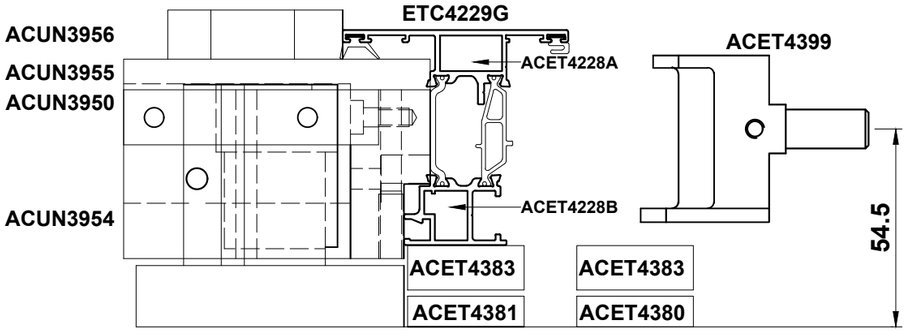


Do Not Scale From This Drawing

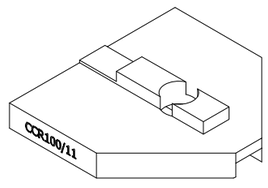
Casement Corner Crimping



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

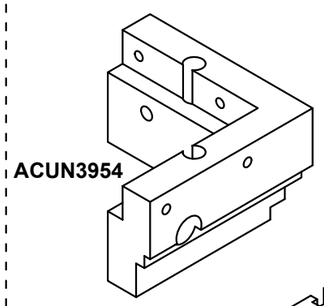


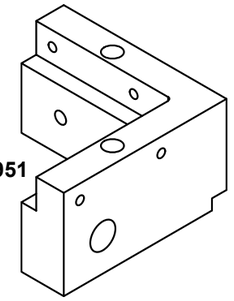
Hand crimper ACET4380 set 26.5mm
Power crimper ACET4381 set 36.5mm

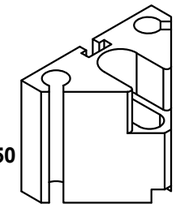


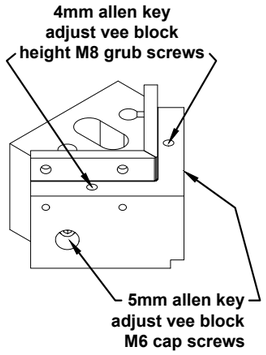
Power crimper use 10mm packer ACCR200N

Adjustable Vee Block

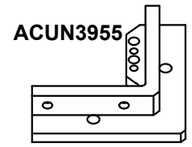




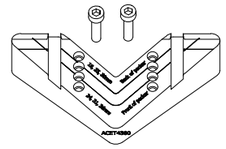


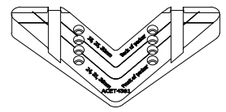




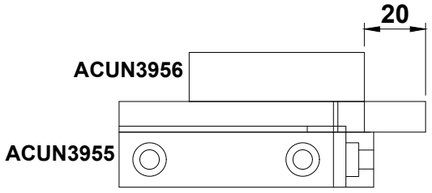


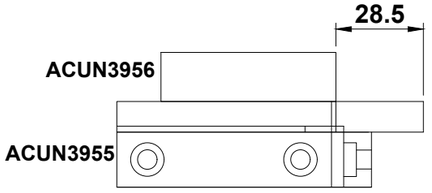
Section Packers

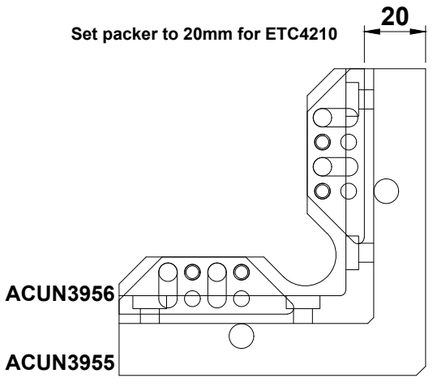


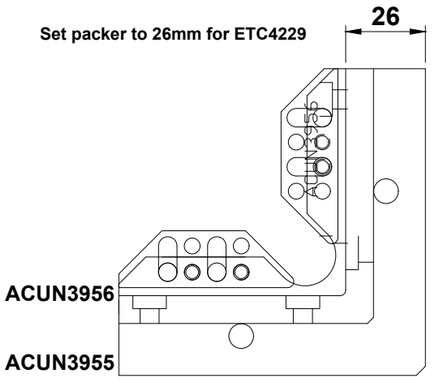






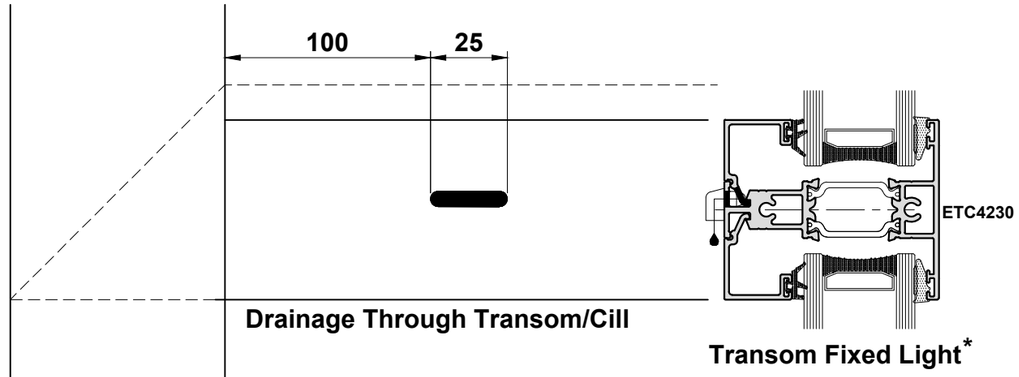






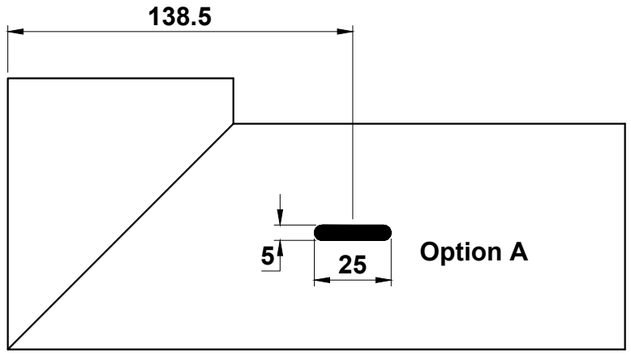
Do Not Scale From This Drawing

Drainage

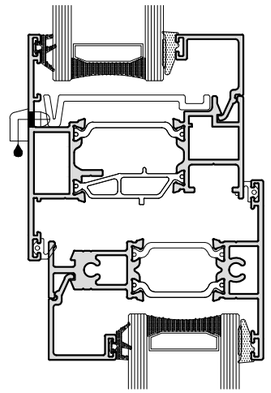


Drainage Through Transom/Cill

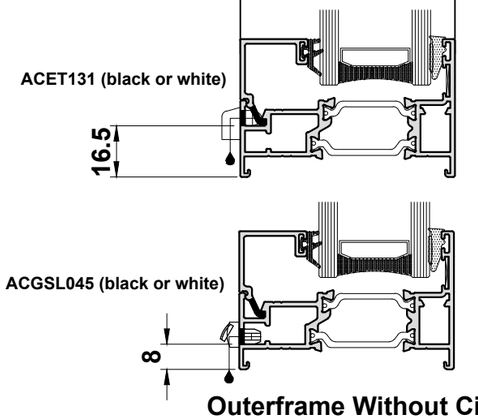
Transom Fixed Light*



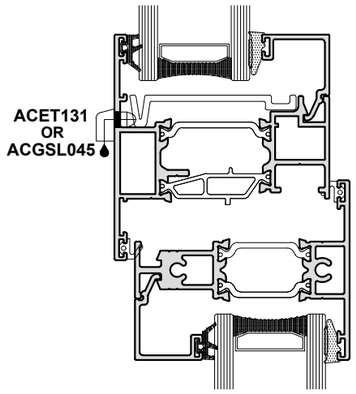
Drainage Through Vent



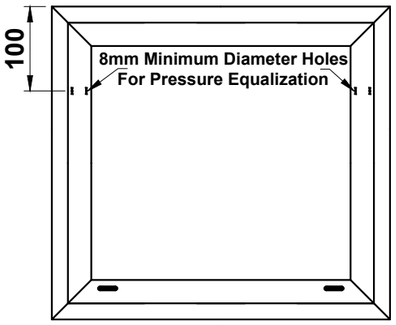
* Note: Transoms will drain through the join to the outerframe.

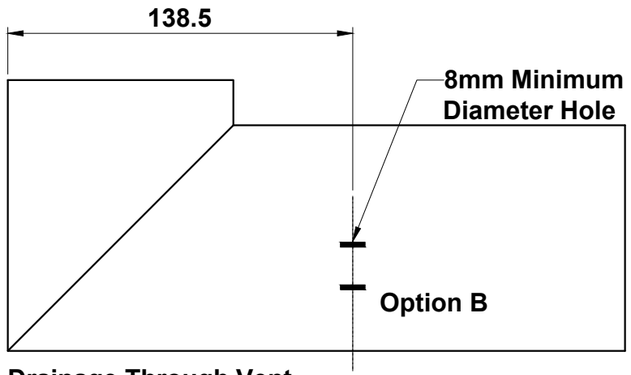


Outerframe Without Cill with opener

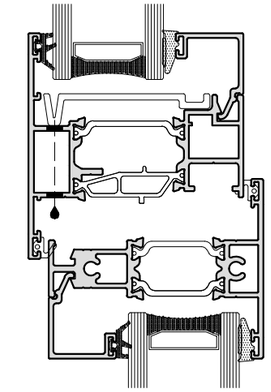


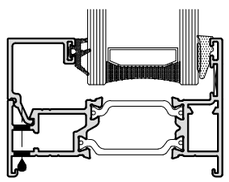
Transom With Vent*



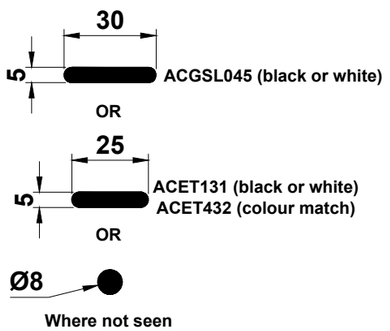


Drainage Through Vent





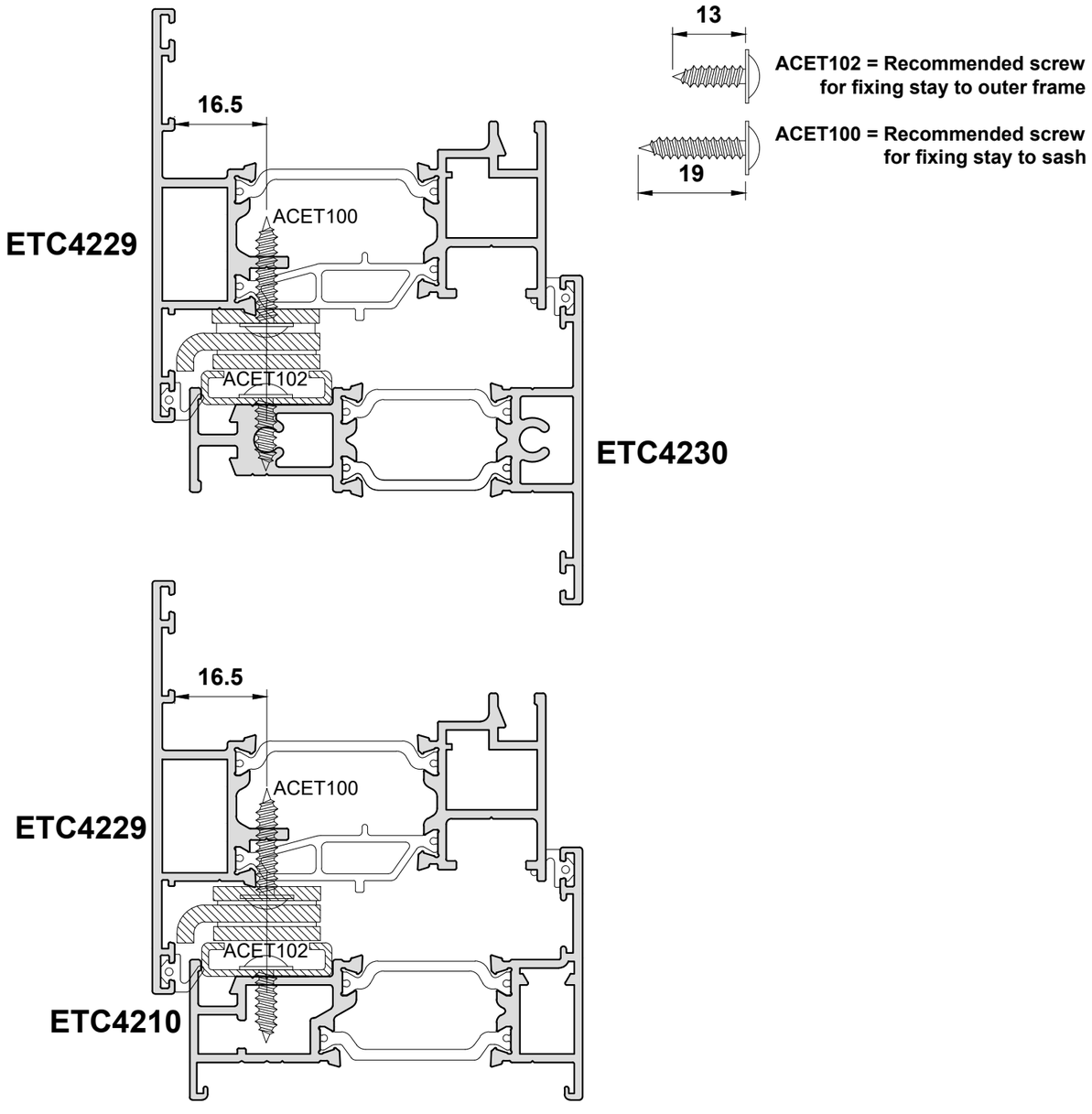
Outerframe With Cill



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

Do Not Scale From This Drawing

Friction Stay

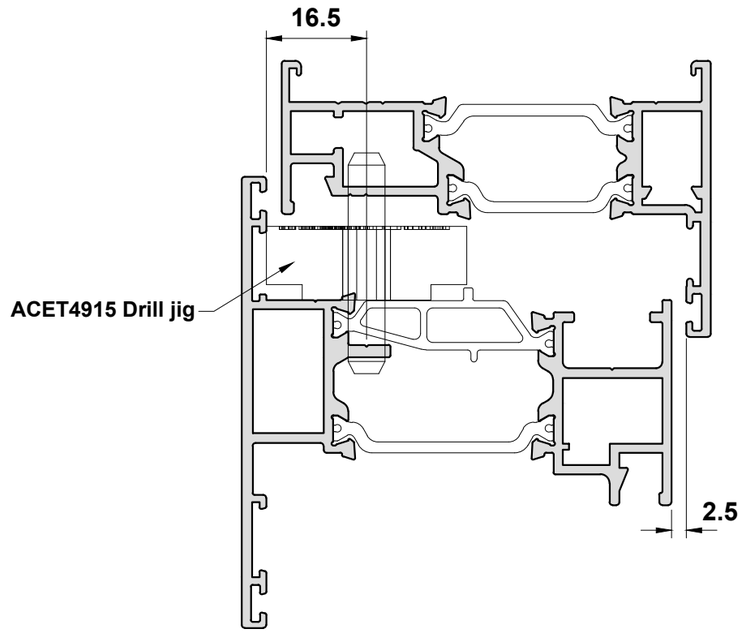


ACET102 = Recommended screw for fixing stay to outer frame

ACET100 = Recommended screw for fixing stay to sash

Heavy Duty (Sterling) Stays

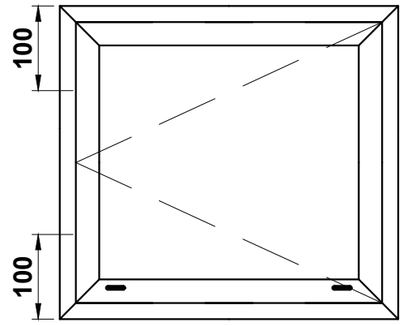
Hinge Code Top Hung	Hinge Length (mm)	Max Vent Weight (kg)	Min Vent Height (mm)	Max Vent Height (mm)	Opening Angle (+/-2.5°)
ACINS10	262	40	315	640	50
ACINS12	313	50	640	800	50
ACINS16	415	65	800	1100	50
ACINS22	567	100	1090	1500	45
ACINS22W	567	100	1500	2000	20
ACINS26	680	180	2000	2500	20
Side Hung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



Do Not Scale From This Drawing

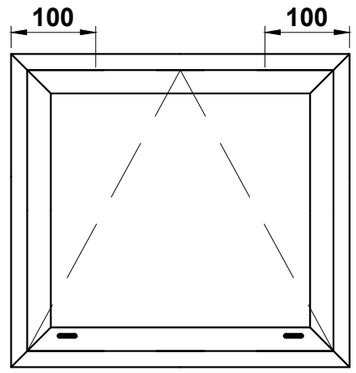
Alitherm 400 HD Window

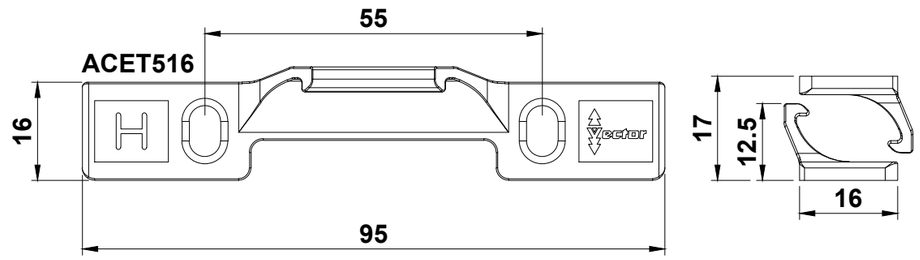
Friction Stay Accessories

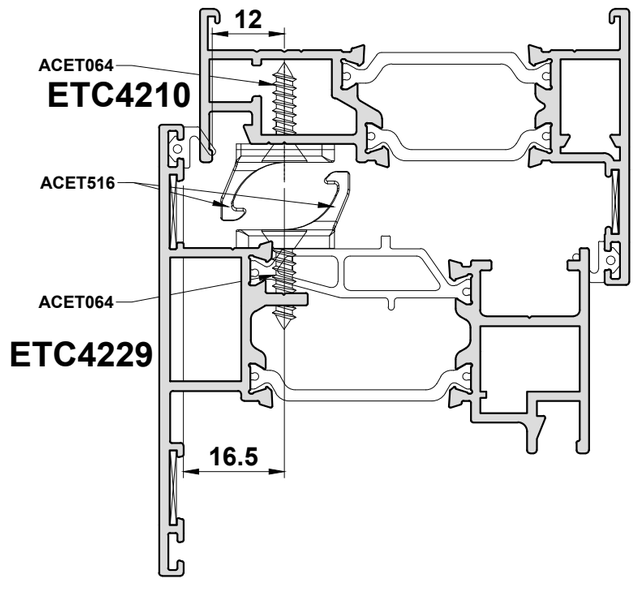


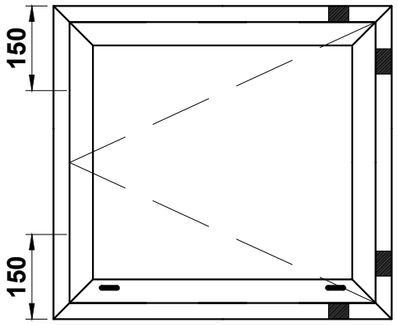
Please Note:

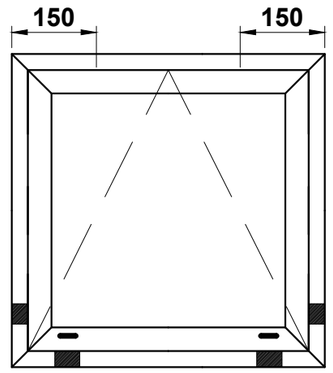
- **2 pairs per opening vent to be fitted to hinged side of window**
- **Each pair must be fitted with the hook centre within 100mm of each hinge**







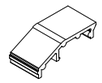




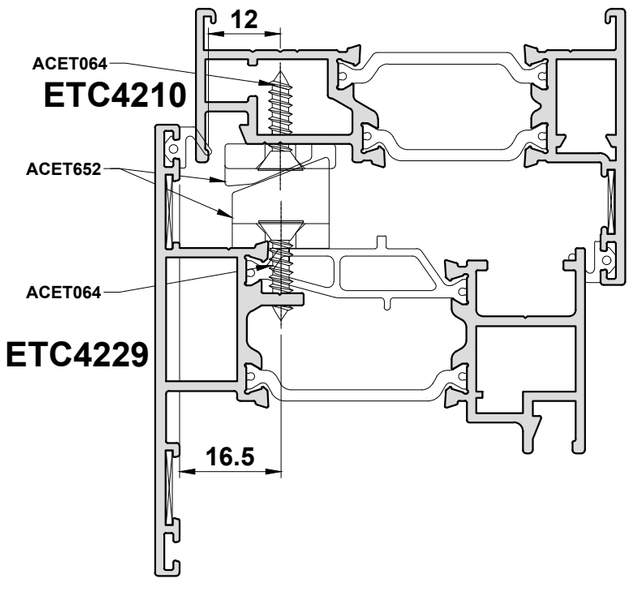
Please Note:

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

ACET4285

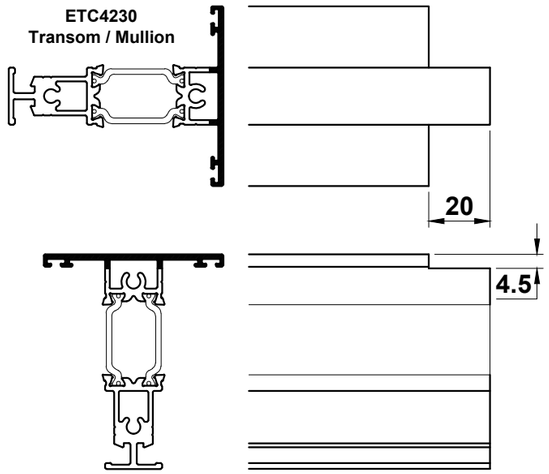


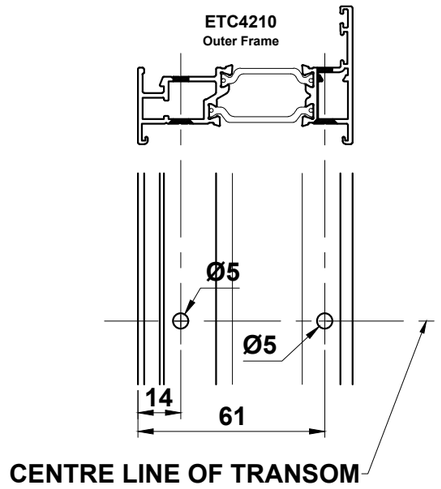
Please note that for fitting each sash, we recommend using 4 x ACET4285, as shown in the images above.

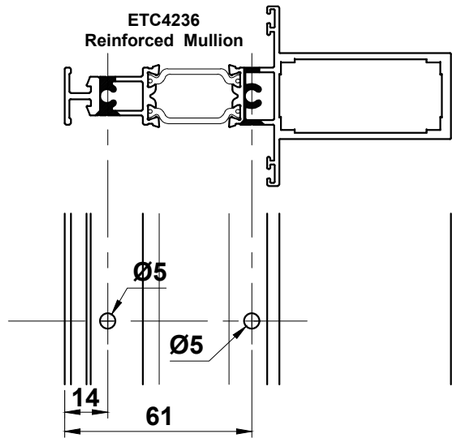


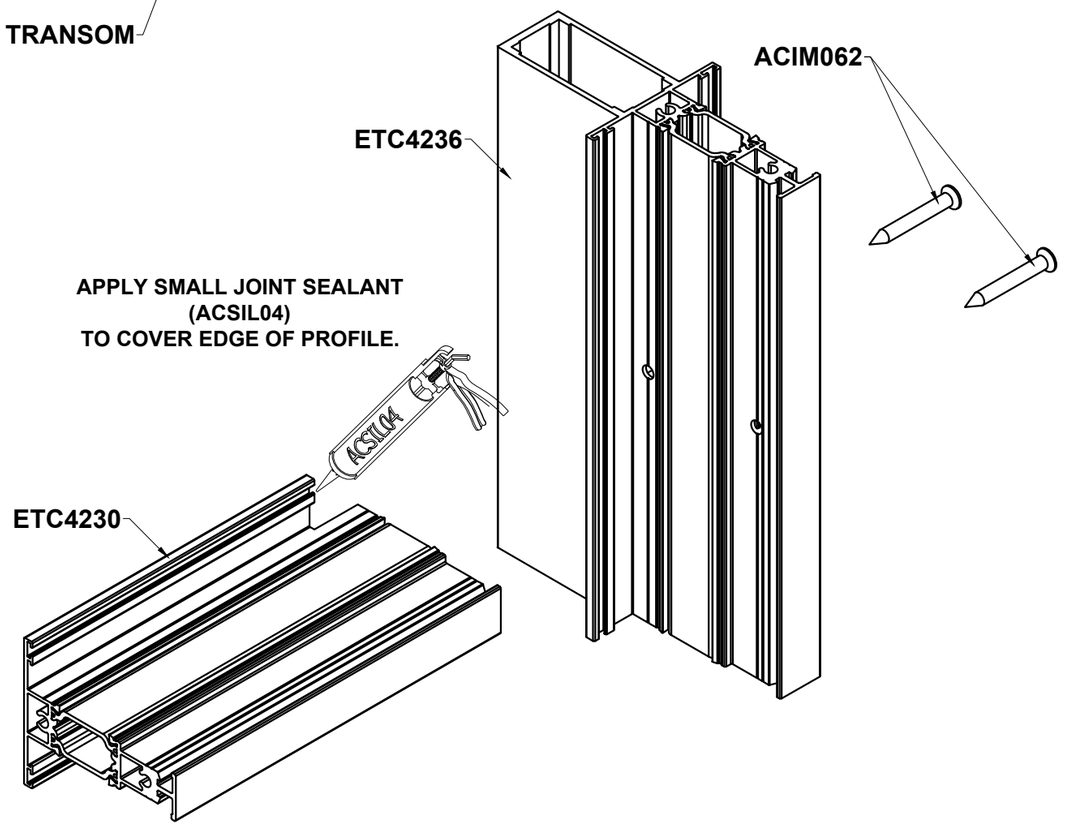
Do Not Scale From This Drawing

Transom Details



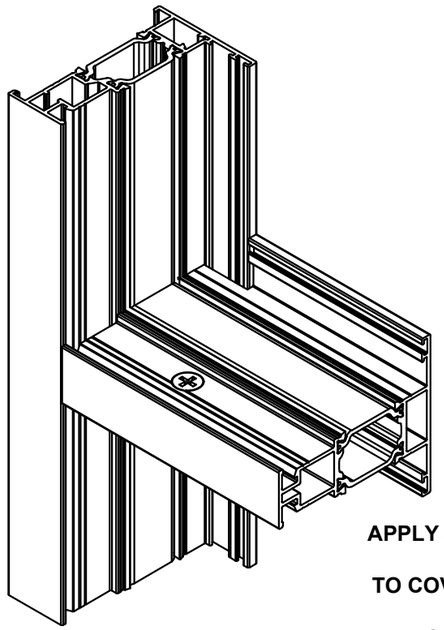


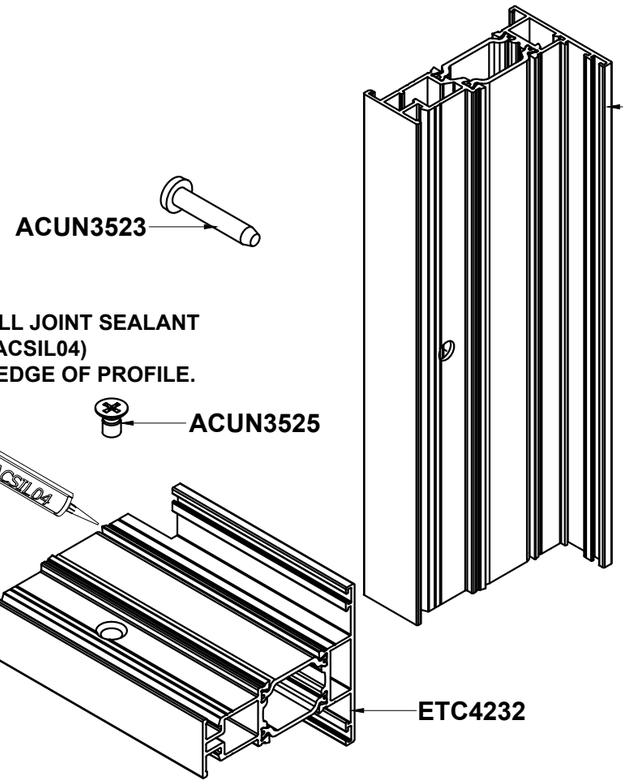


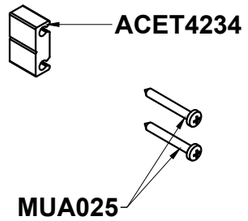


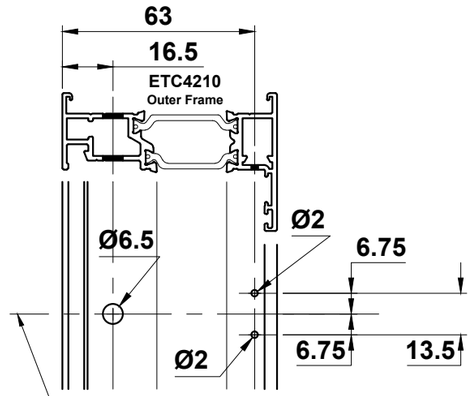
Do Not Scale From This Drawing

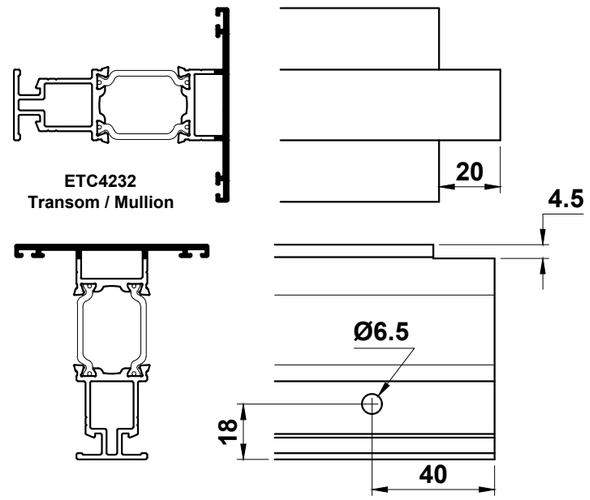
Transom Details



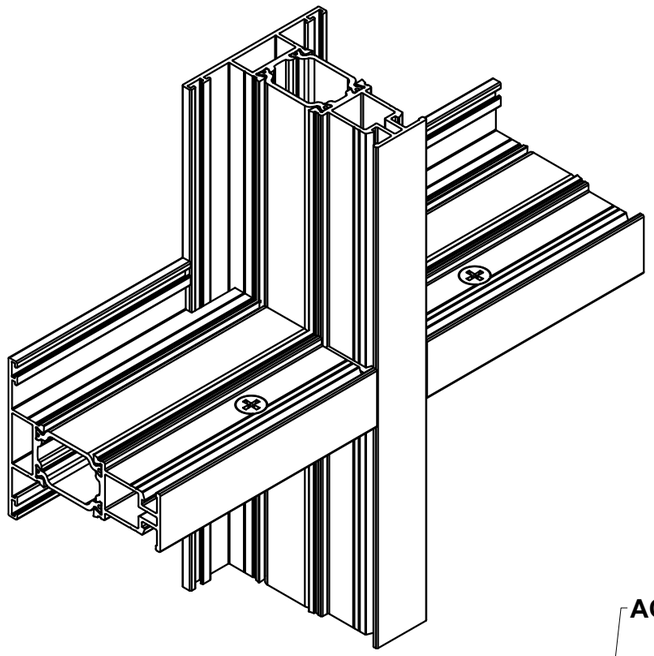


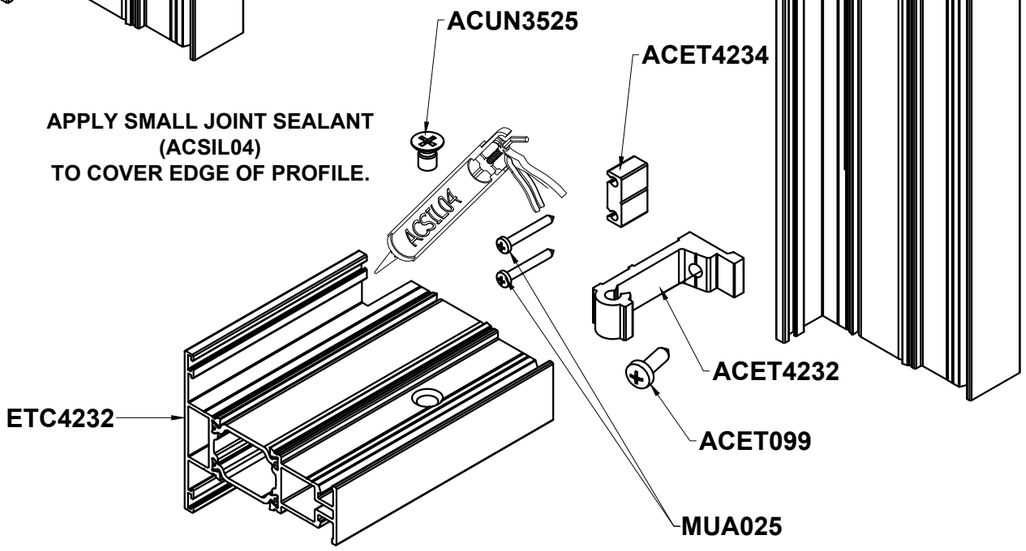


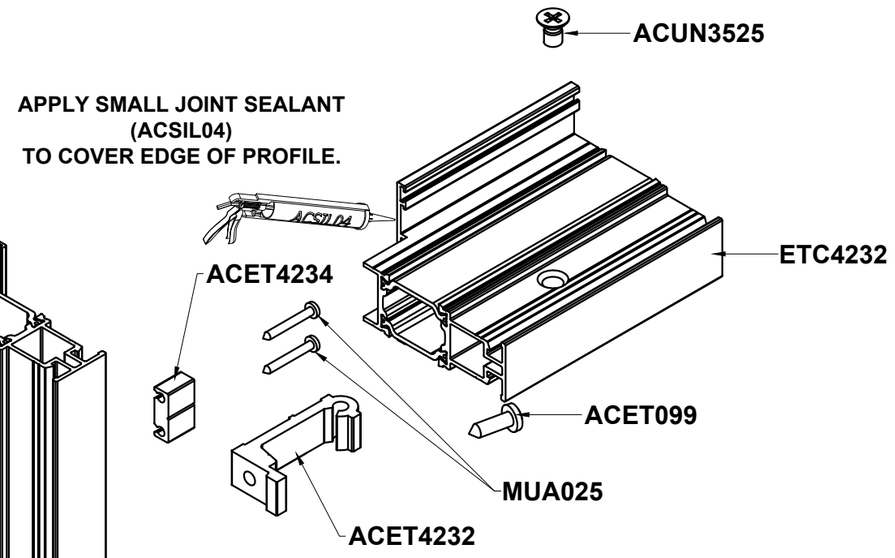


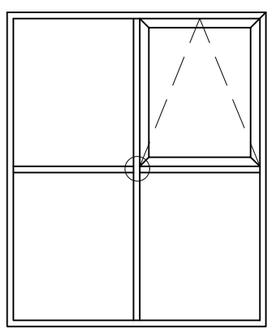


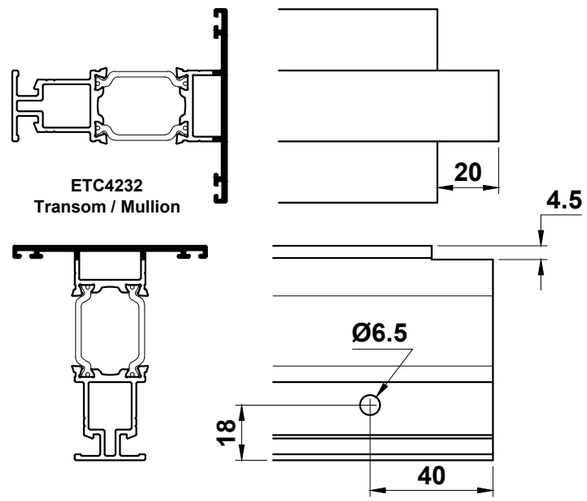
Cruciform Joint





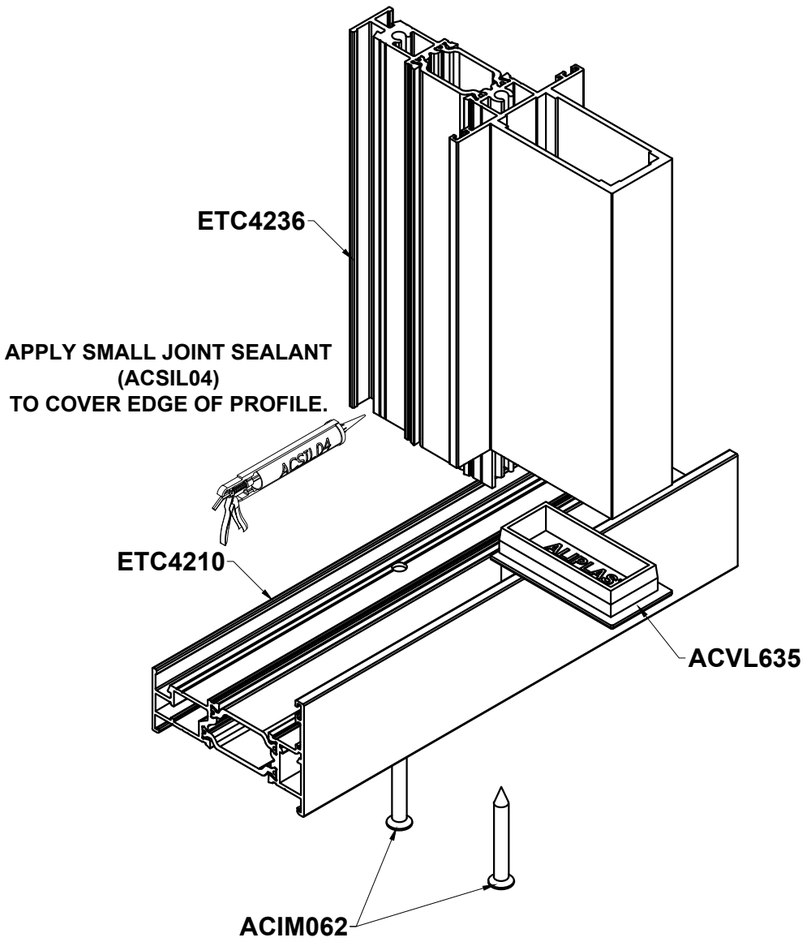


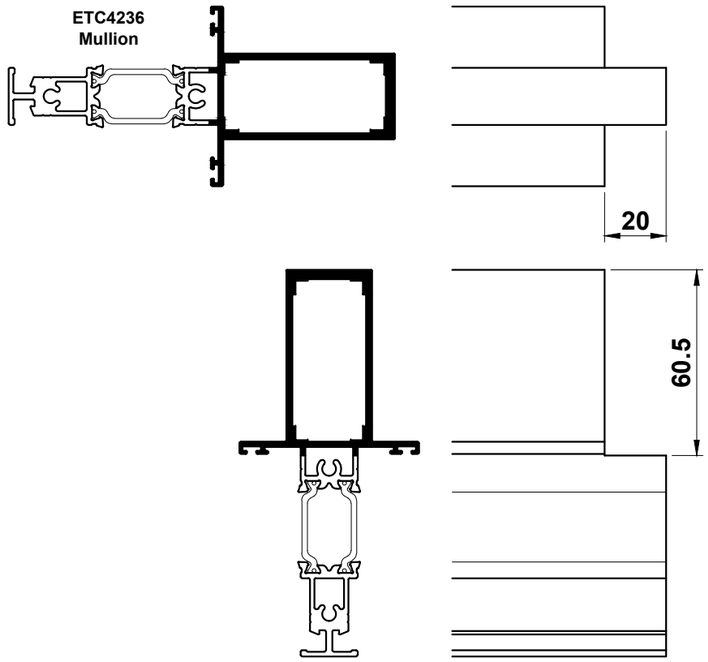


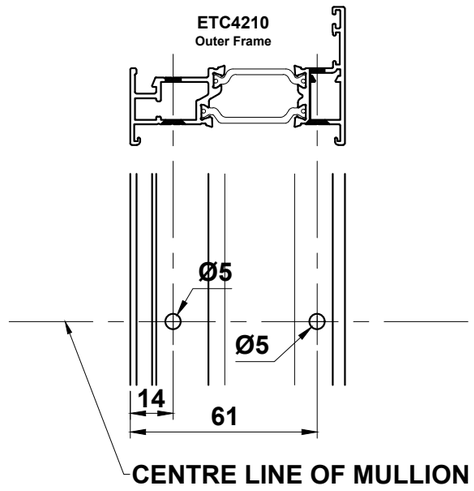


Do Not Scale From This Drawing

Mullion Details

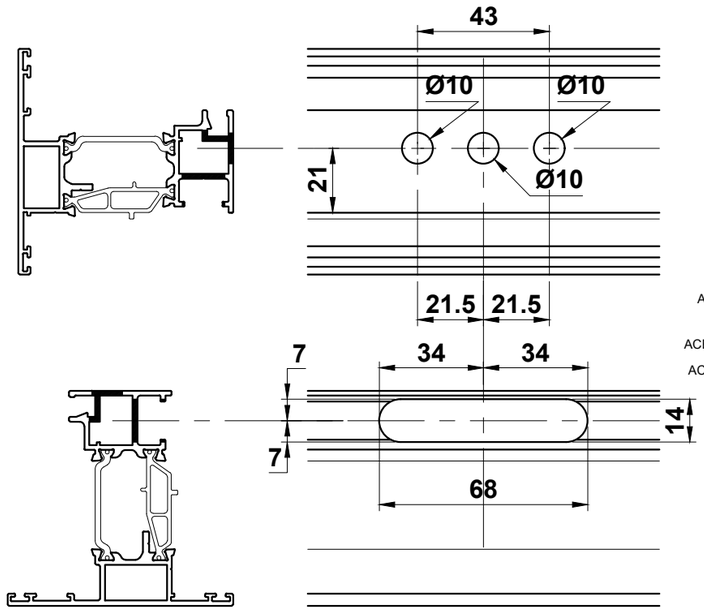


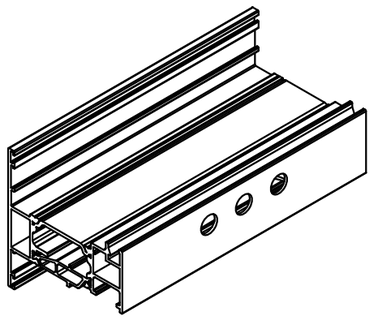




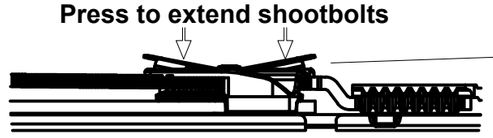
Do Not Scale From This Drawing

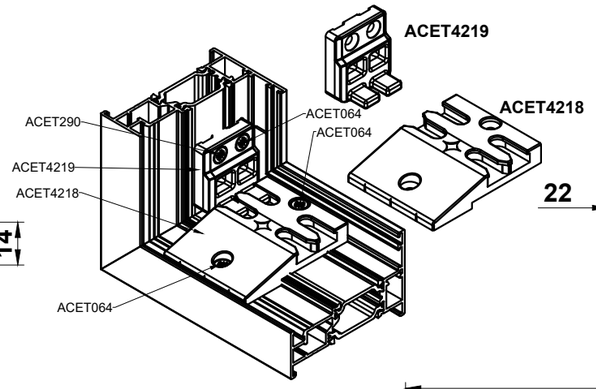
Telescopic Lock Details



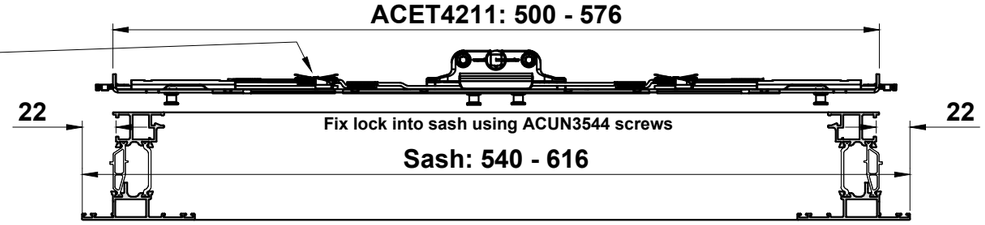


Press to extend shootbolts

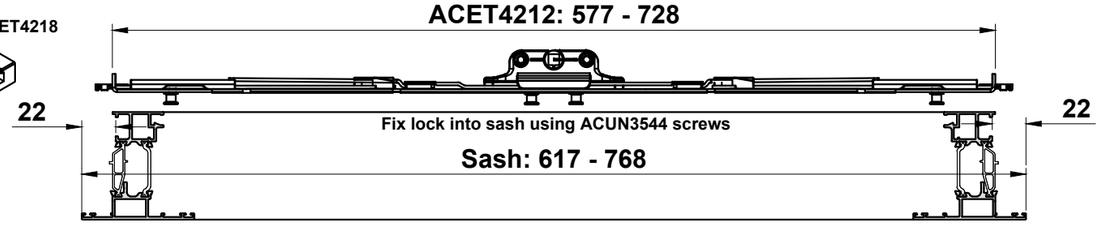




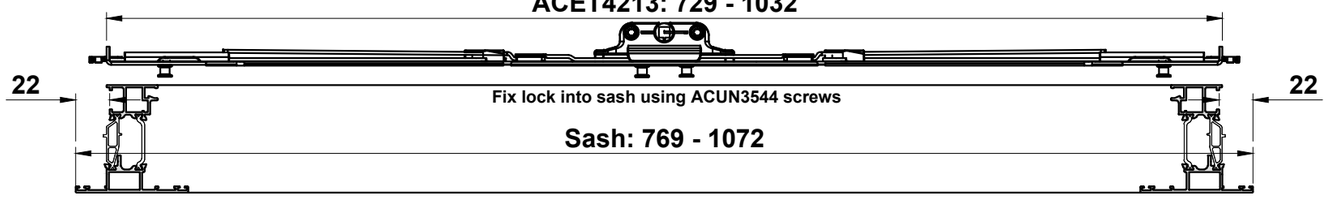
ACET4211: 500 - 576



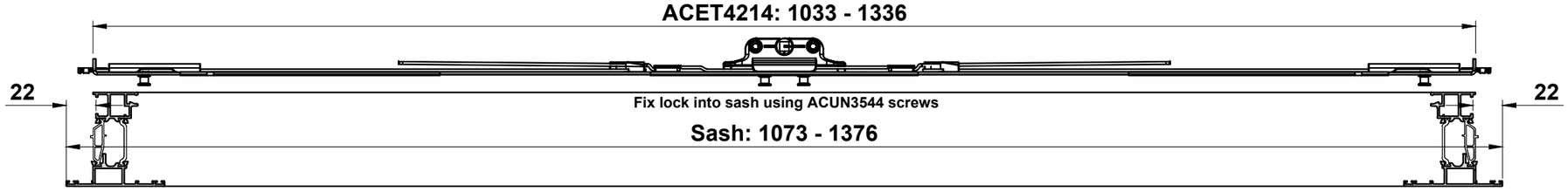
ACET4212: 577 - 728



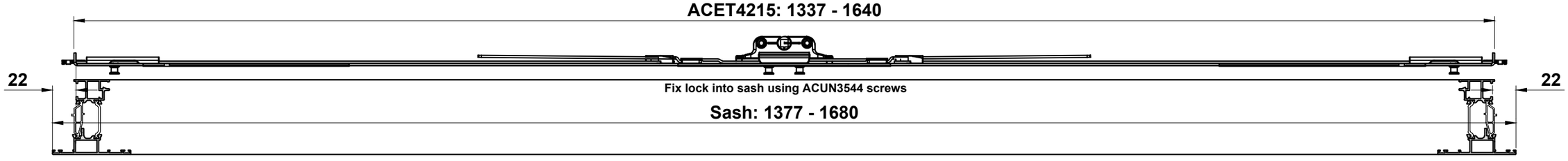
ACET4213: 729 - 1032



ACET4214: 1033 - 1336



ACET4215: 1337 - 1640

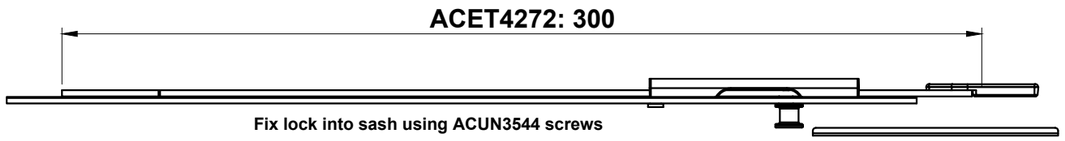


Do Not Scale From This Drawing

Croppable Lock Details

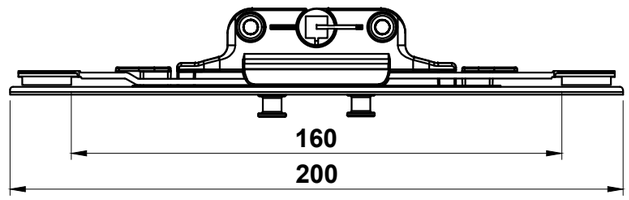
Extension rods with additional locking mushroom

ACET4272: 300



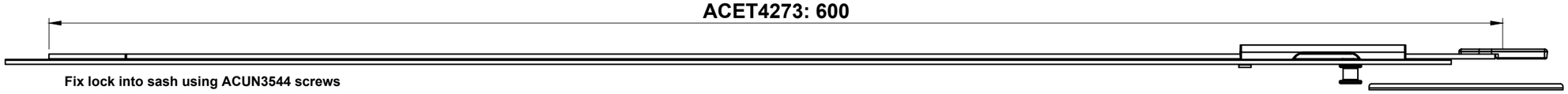
Fix lock into sash using ACUN3544 screws

ACET4271 Drive Gear

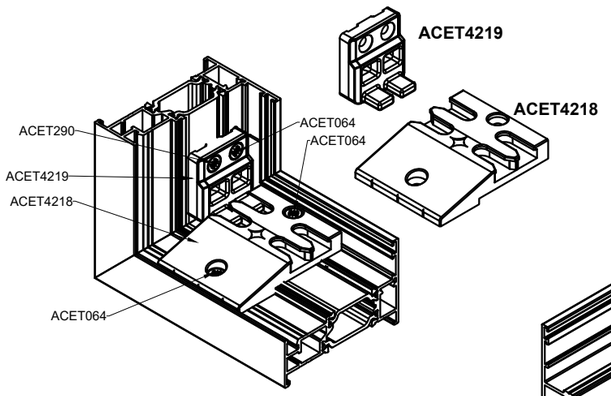


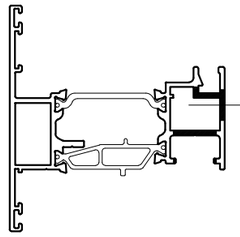
Fix lock into sash using ACUN3544 screws

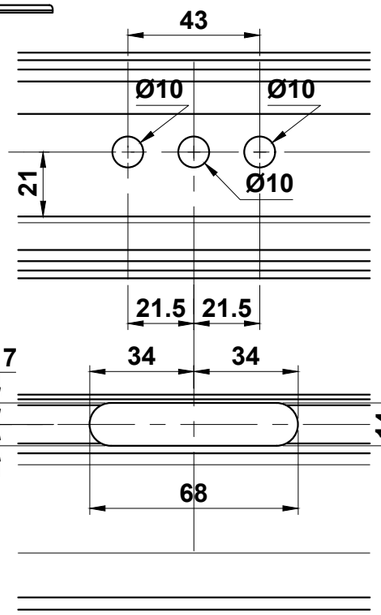
ACET4273: 600

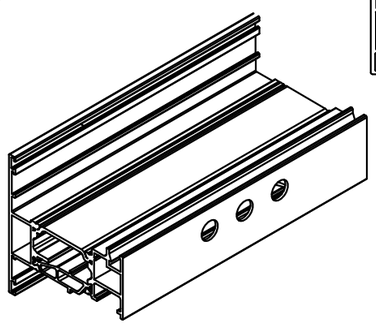


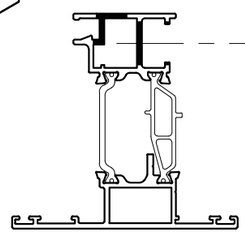
Fix lock into sash using ACUN3544 screws





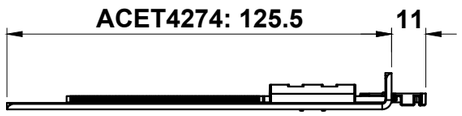






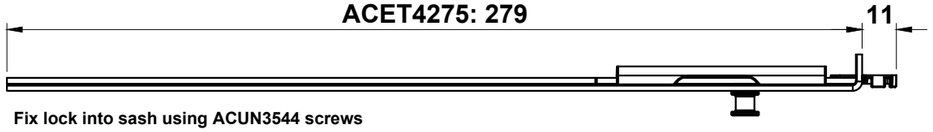
Locking rods

ACET4274: 125.5 — 11



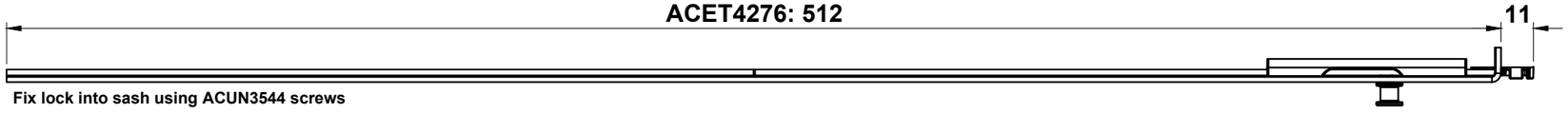
Fix lock into sash using ACUN3544 screws

ACET4275: 279 — 11



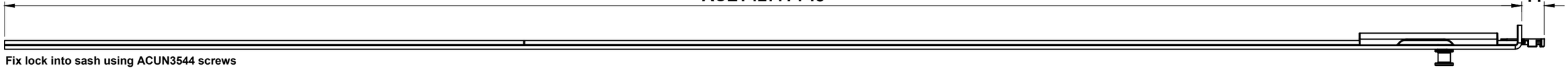
Fix lock into sash using ACUN3544 screws

ACET4276: 512 — 11



Fix lock into sash using ACUN3544 screws

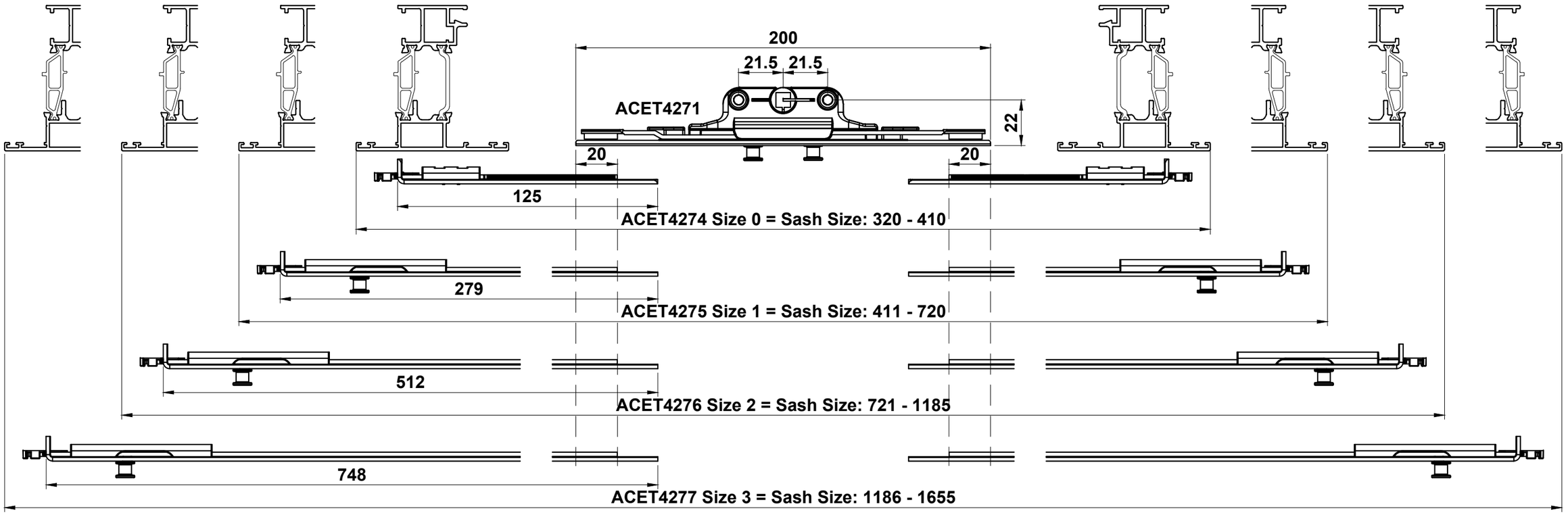
ACET4277: 748 — 11



Fix lock into sash using ACUN3544 screws

Do Not Scale From This Drawing

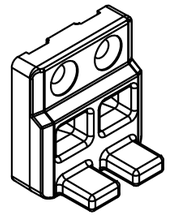
Croppable Lock Selection



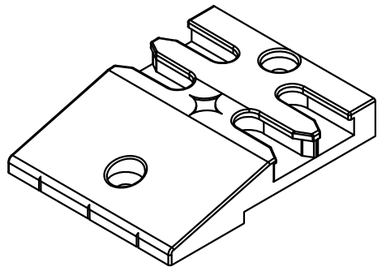
Notes:

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

ACET4219



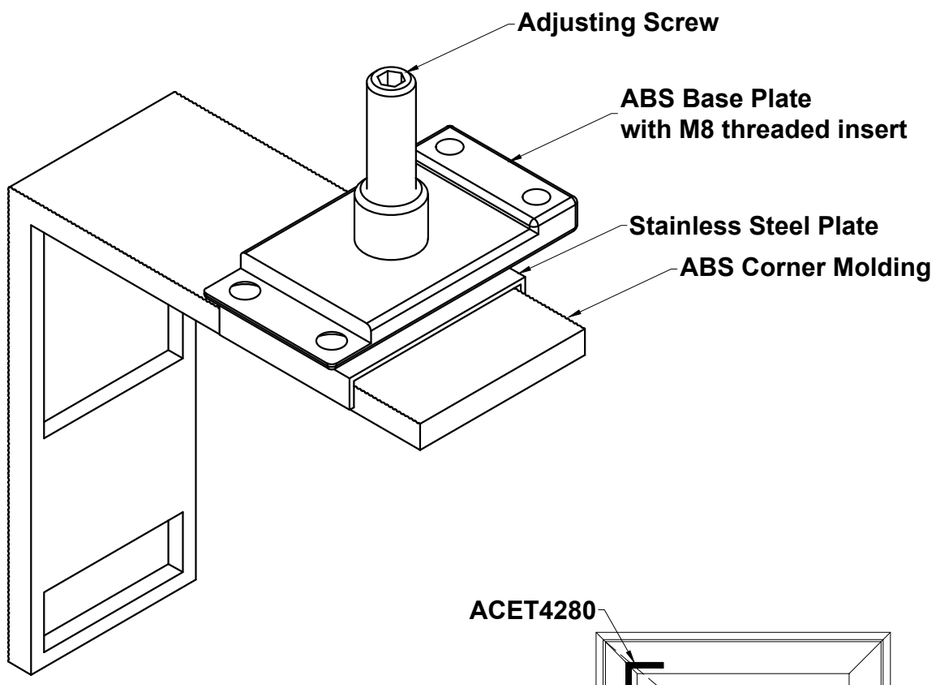
ACET4218

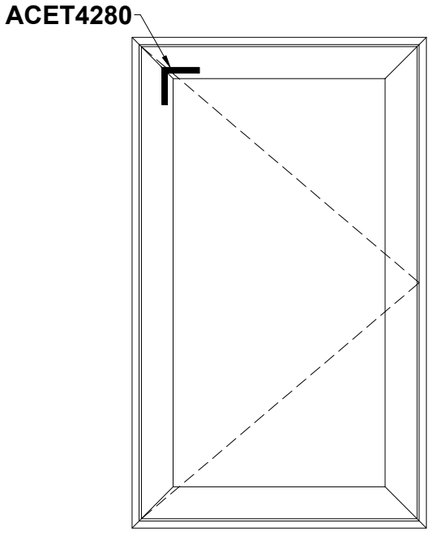


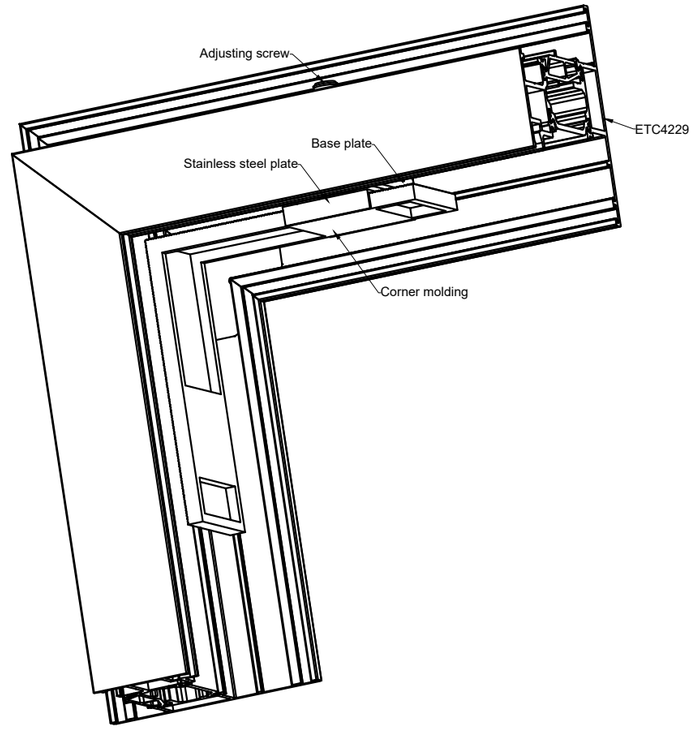
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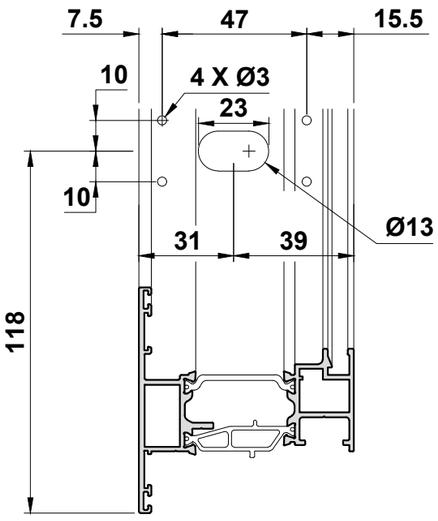
Glass Adjuster Details

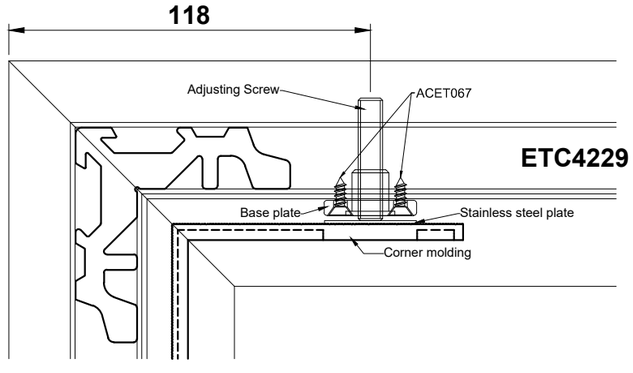
ACET4280 Glass Adjuster Kit

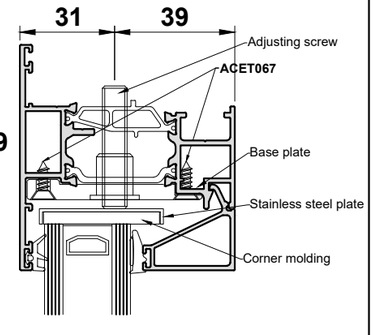






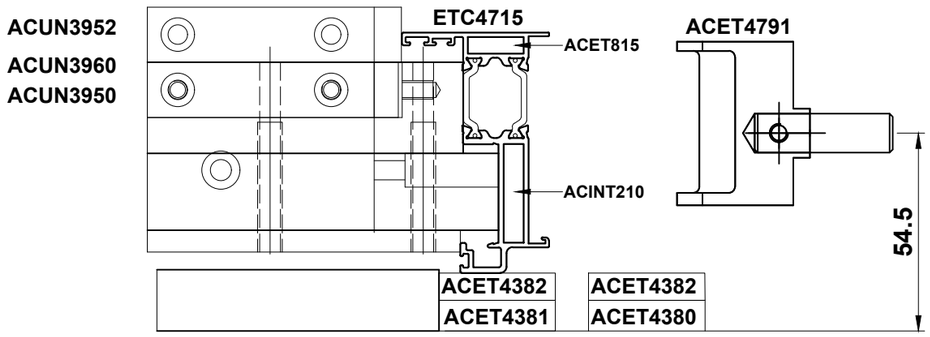




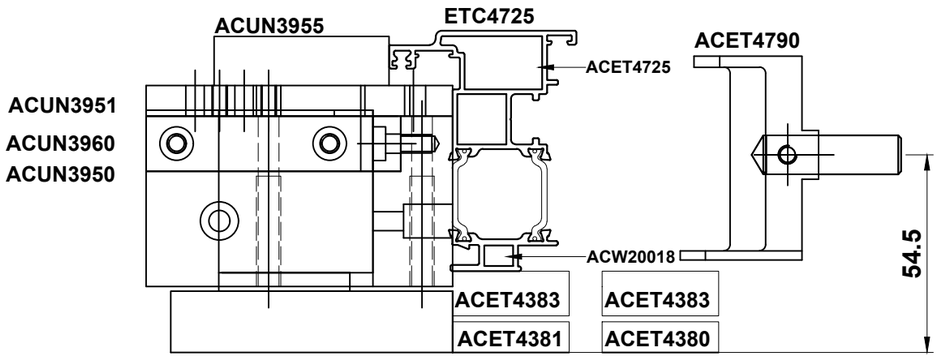


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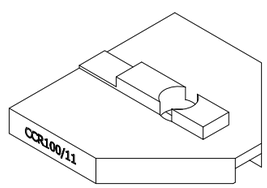
Reversible Crimping



Hand crimper ACET4380 set 19mm
Power crimper ACET4381 set 26.5mm

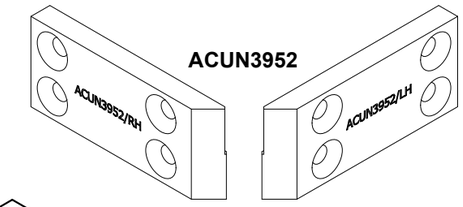


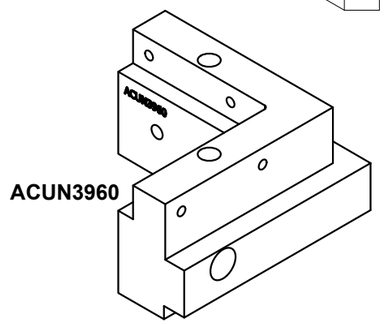
Hand crimper ACET4380 set 26.5mm
Power crimper ACET4381 set 36.5mm



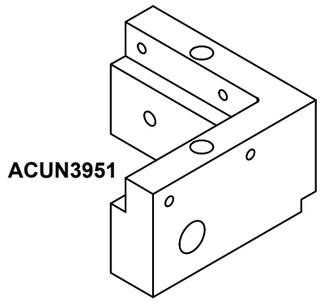
Power crimper use 10mm packer ACCR200N

Adjustable Vee Block

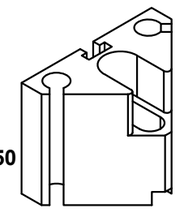




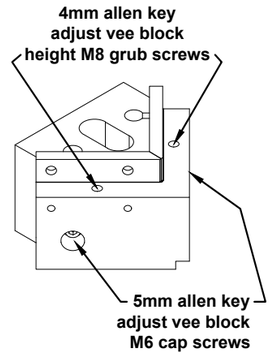
ACUN3960

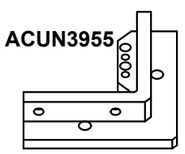


ACUN3951



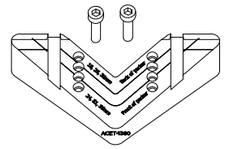
ACUN3950



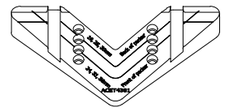


ACUN3955

Section Packers



ACET4380



ACET4381

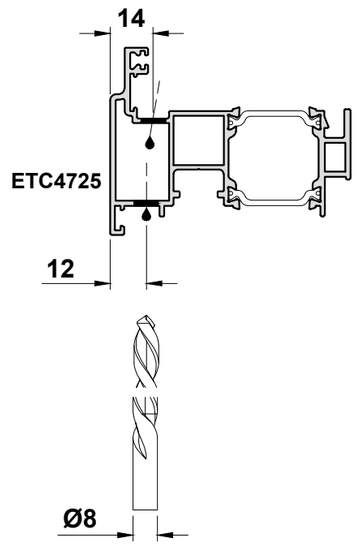


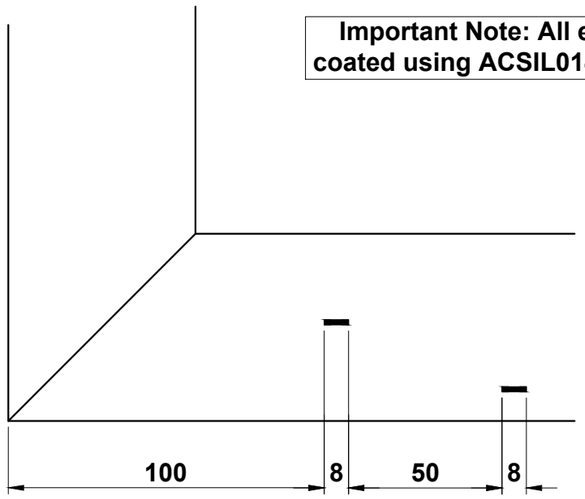
ACET4383

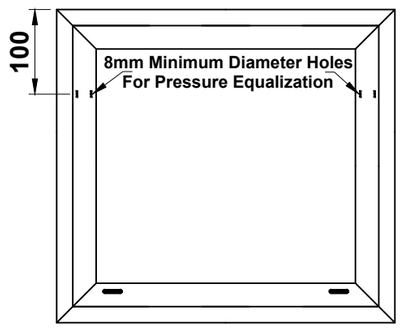
Do Not Scale From This Drawing

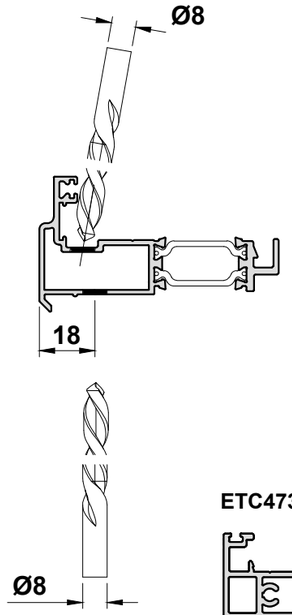
Reversible Drainage Details

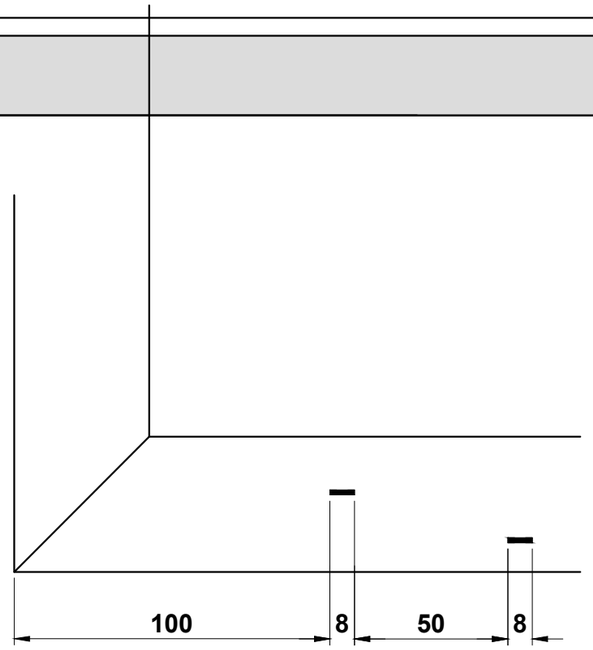
Important Note: All exposed aluminium should be coated using ACSIL014 or painted to match the frame.

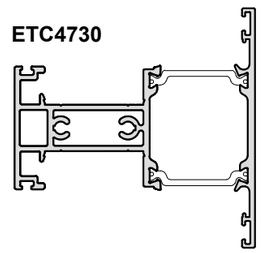






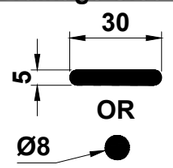




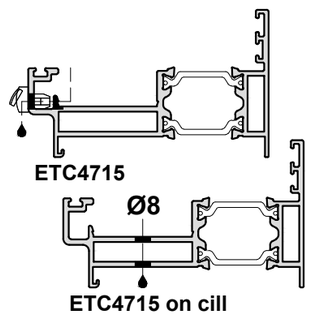


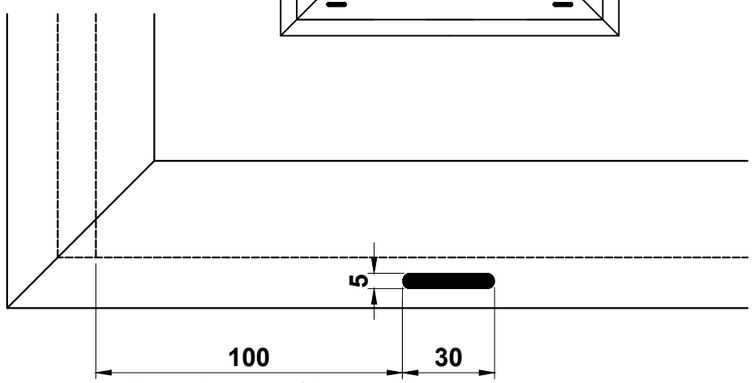
Option A: ETC4730 will drain at each end

Drainage Slot Types

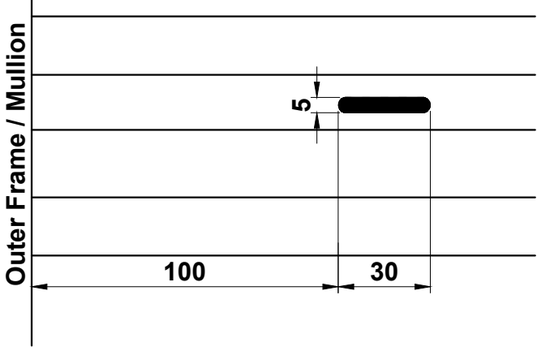


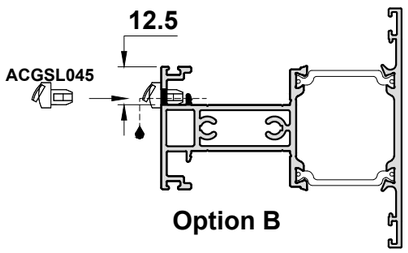
Where not seen





From inside of jambs
&
either side of mullion

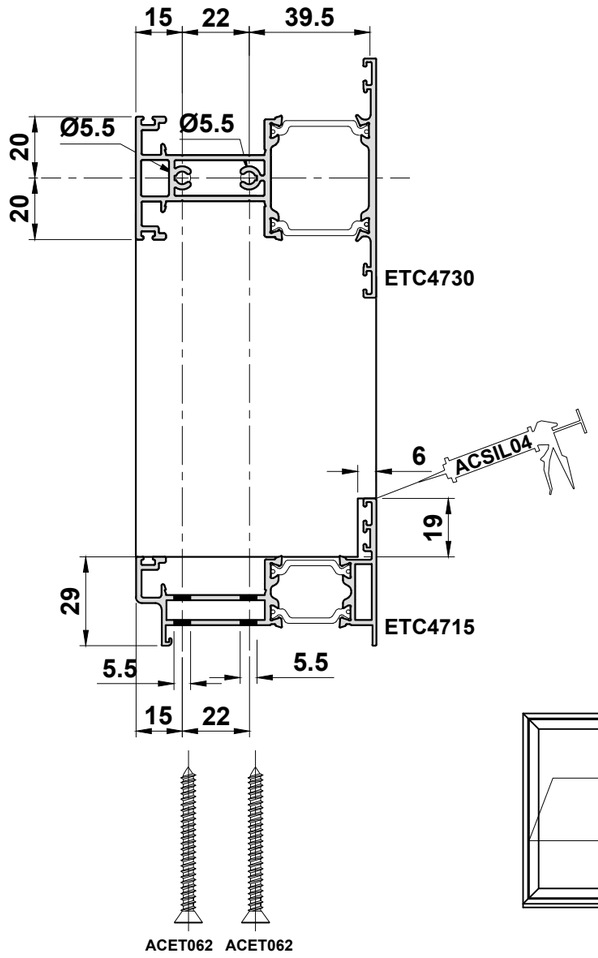




Option B

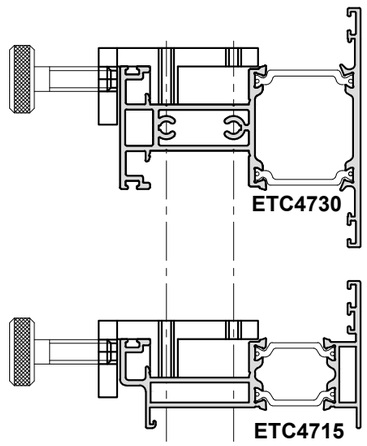
Do Not Scale From This Drawing

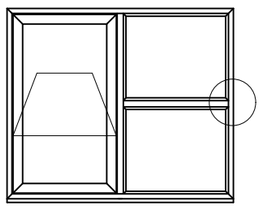
Reversible Mullion/Transom Details

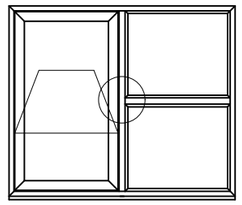


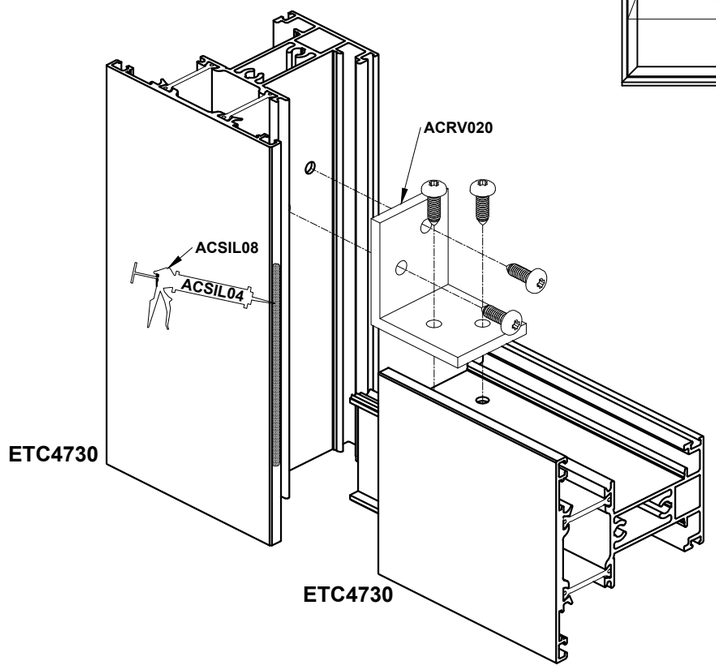
Drill Jig = ACET798

Use jig to drill 3mm pilot holes then increase hole size to 5.5mm



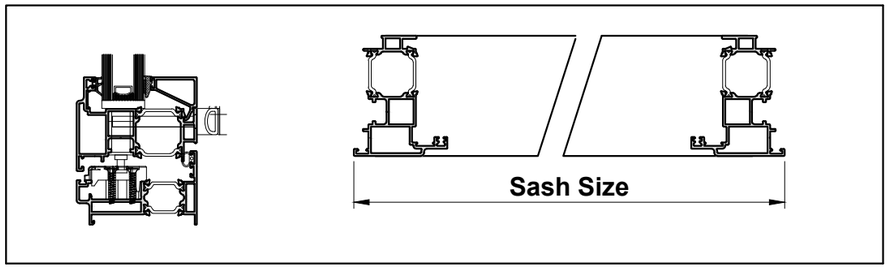






Do Not Scale From This Drawing

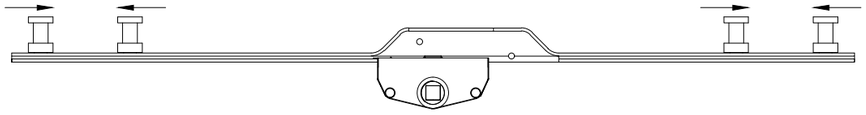
Reverse Espag Locking



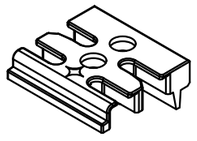
Part Code	Rod Length (mm)	Number of ACET4767 Keeps	Sash Size	
			Minimum	Maximum
ACET4771	250	2	320	419
ACET4772	350	2	420	619
ACET4773	550	2	620	819
ACET4774	750	4	820	919
ACET4775	850	4	920	1019
ACET4776	950	4	1020	1119
ACET4777	1050	4	1120	1219
ACET4778	1150	4	1220	1399
ACET4779	1350	4	1400	1500

Note: To Suit Handles ACET4762 & ACET4763

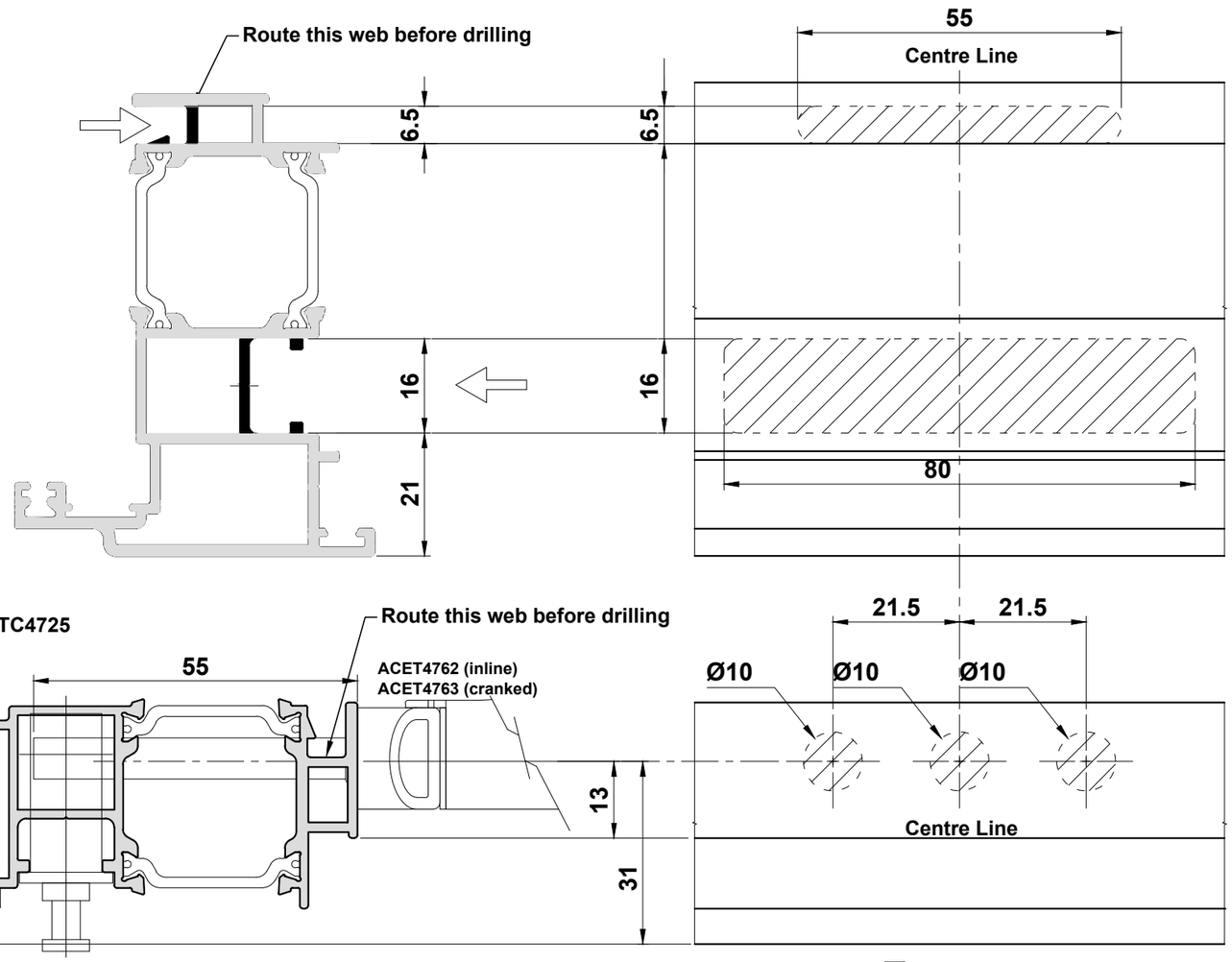
Cam Locking Direction

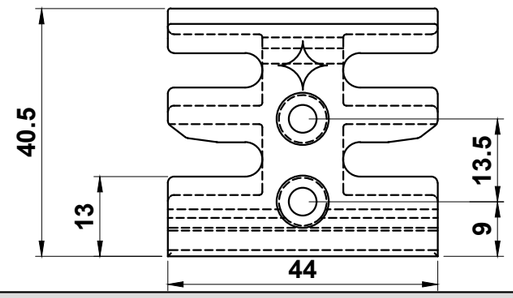


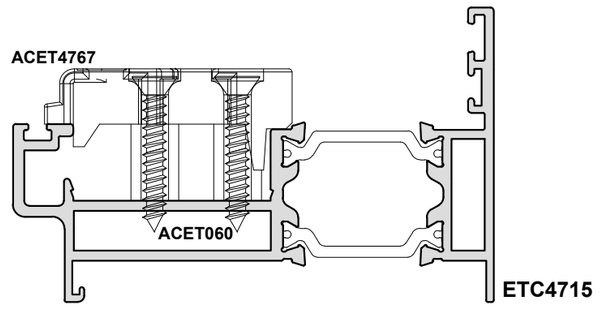
Cam Locking Direction



Keep: ACET4767







Hinge Selection & Fitting

Please order the below components from:
Carl F Groupco
Tel: 01733 393 330

Hinge Size Chart

Module Size	Standard Hinge	Hinge Length	Sash Height	Box Quantity	Dimension F	Hotel Variant
5	777156A	424	405 - 504	5 Pairs	186	777156A
6	777527A	524	505 - 560	5 Pairs	238	777158A
6.5	777540A	580	561 - 604	5 Pairs	264	777190A
7	777528A	624	605 - 660	5 Pairs	288	777160A
7.5	777541A	680	661 - 704	5 Pairs	312	777192A
8	777529A	724	705 - 760	5 Pairs	338	777162A
8.5	777542A	780	761 - 804	5 Pairs	364	777194A
9	777530A	824	805 - 860	5 Pairs	388	777165A
9.5	777543A	880	861 - 904	5 Pairs	412	777197A
10	777531A	924	905 - 960	5 Pairs	438	777168A
10.5	777544A	980	961 - 1004	5 Pairs	458	777200A
11	777532A	1024	1005 - 1060	5 Pairs	488	777171A
11.5	777545A	1080	1061 - 1104	5 Pairs	512	777203A
12	777533A	1124	1105 - 1160	5 Pairs	538	777174A
12.5	777546A	1180	1161 - 1204	5 Pairs	564	777206A
13	777534A	1224	1205 - 1260	5 Pairs	588	777177A
13.5	777547A	1280	1261 - 1304	5 Pairs	612	777209A
14	777535A	1324	1305 - 1360	5 Pairs	638	777180A
14.5	777548A	1380	1361 - 1404	5 Pairs	664	777212A
15	777536A	1424	1405 - 1460	5 Pairs	688	777182A
15.5	777549A	1480	1461 - 1504	5 Pairs	712	777214A
16	777537A	1524	1505 - 1560	5 Pairs	738	777184A
17	777538A	1624	1605 - 1660	5 Pairs	778	777186A
18	777539A	1724	1705 - 1760	5 Pairs	828	777188A

Required Accessories

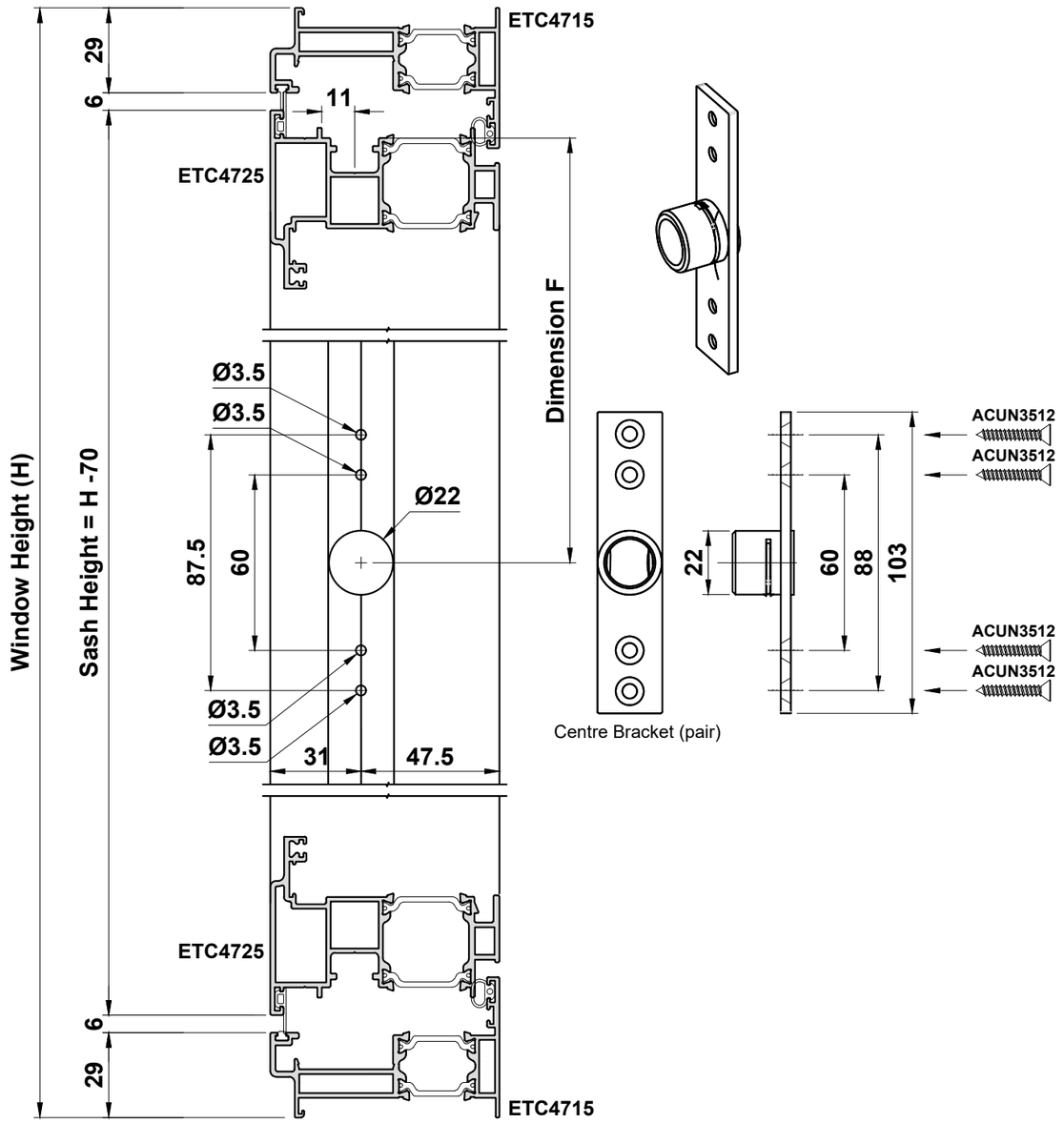
		Box Quantity
Top Glider (pair)	777557	50
Centre Bracket (pair)	777132	50

Optional Accessories

		Box Quantity
Stop Block	777554	100
Guide Block	777525	100
Blocking Device	777573	100

Please Note:

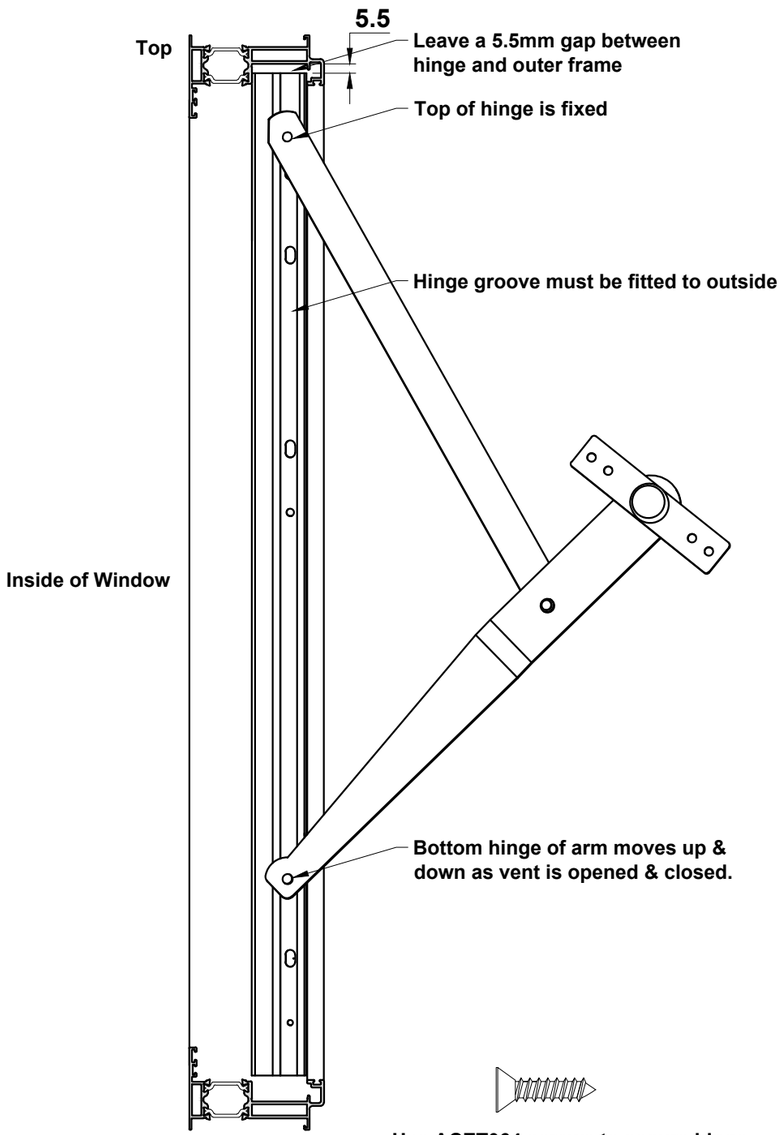
1. **Reversible hinges are sold in pairs (1 restricted & 1 unrestricted hinge)**
2. **Max sash height 1705mm**
3. **Max sash weight: Sizes 5-16 = 60kg**
   Sizes 17-18 = 80kg
4. **One reversible sash requires a pair of hinges, a pair of centre brackets & a pair of top gliders**
5. **Where hinges a cut down to fit into the outer frame, Dimension F shall be reduced by the same amount**
6. **Hotel Variant hinges can be closed without operating the 'PRESS' button**



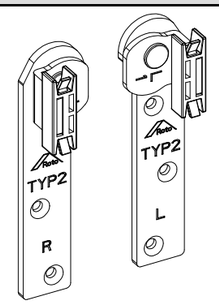
Do Not Scale From This Drawing

Hinge & Top Guide Fixing

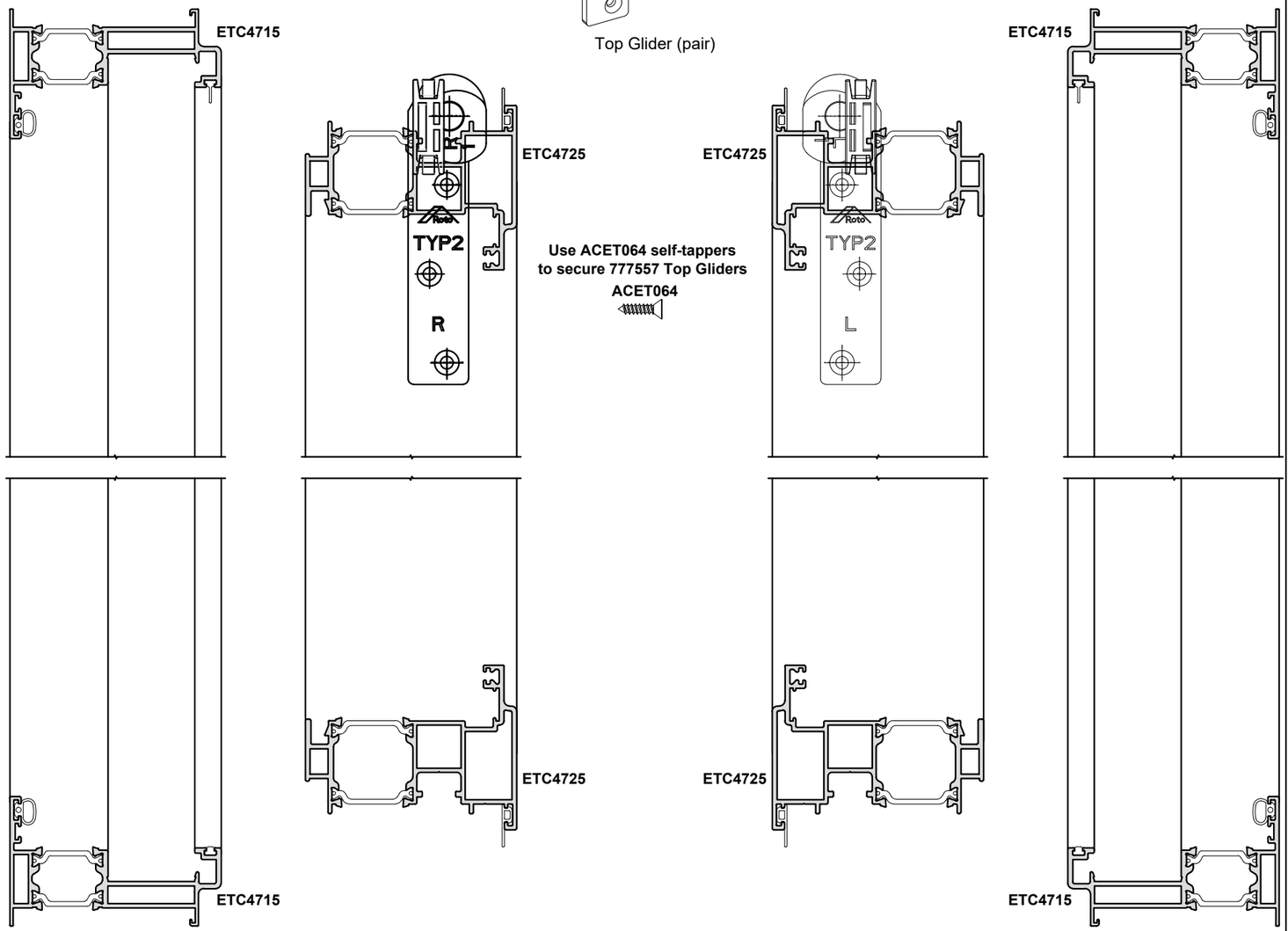
Hinge Fitting



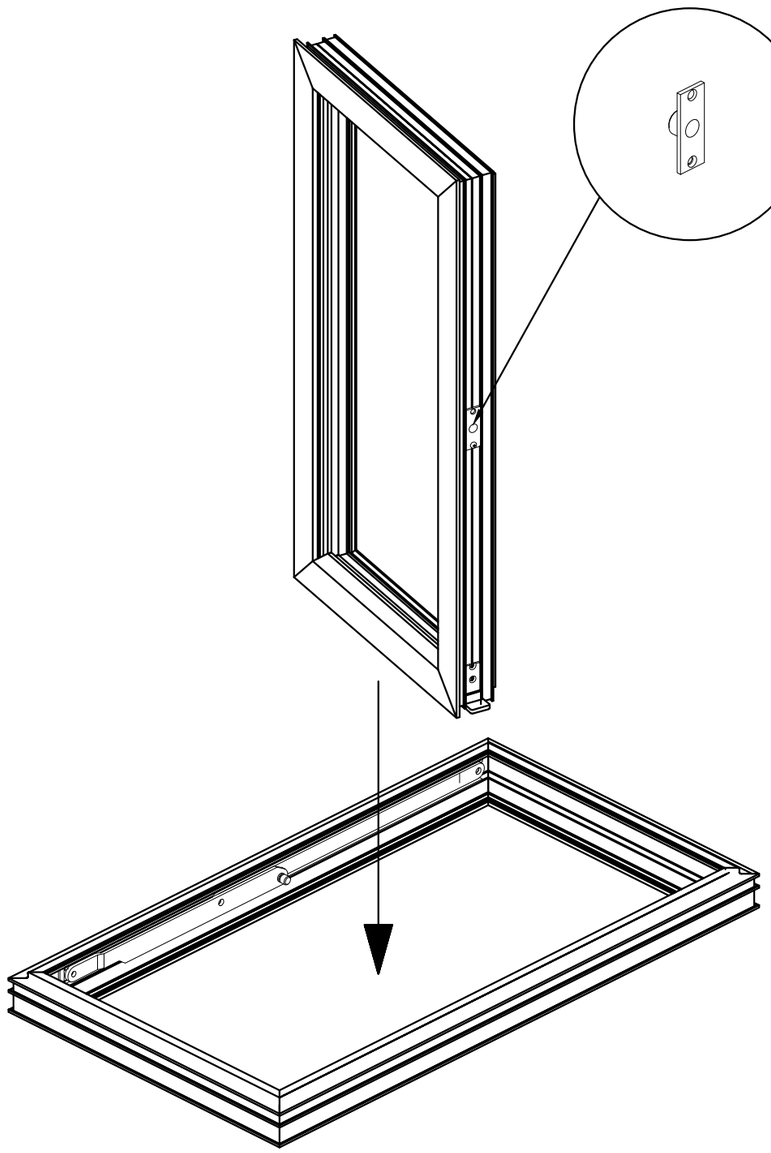
Top Guide Fitting



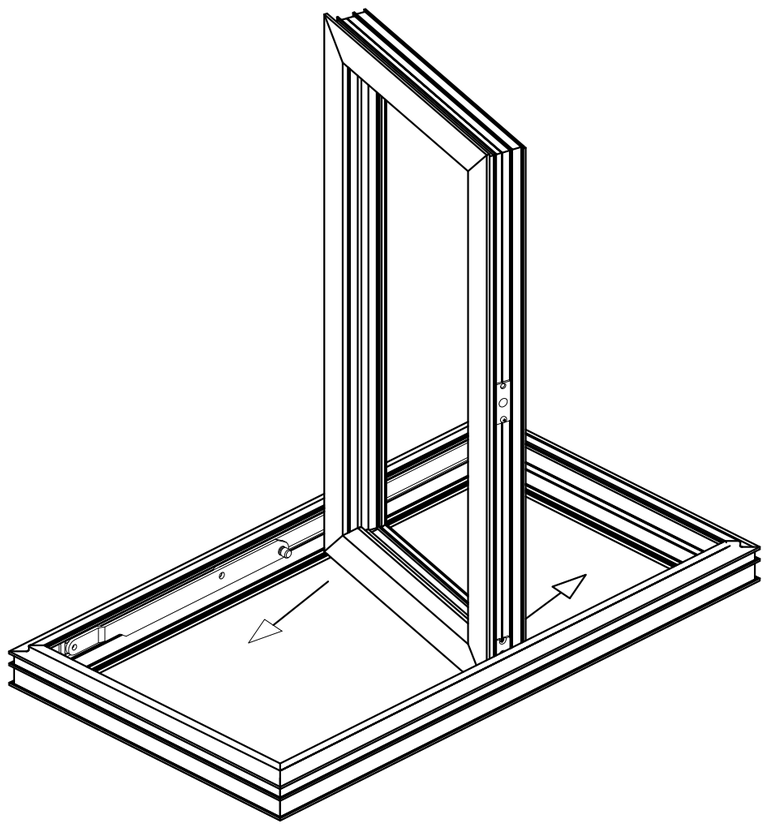
Top Glider (pair)



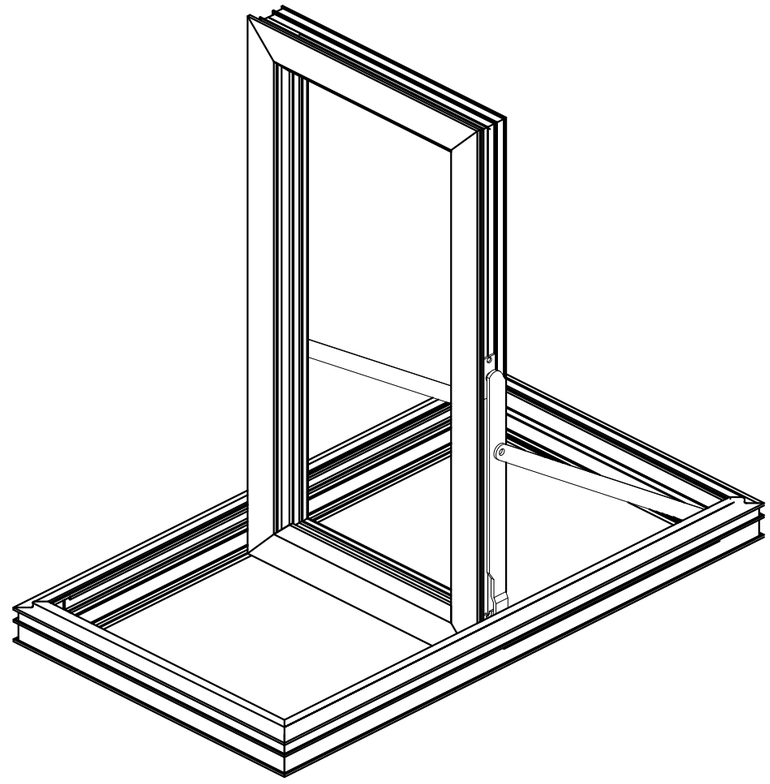
Reversible Sash Hanging Instructions



Fix the hinge to the frame jambs.
Fix the head slide bracket and one screw in the centre sash assembly.



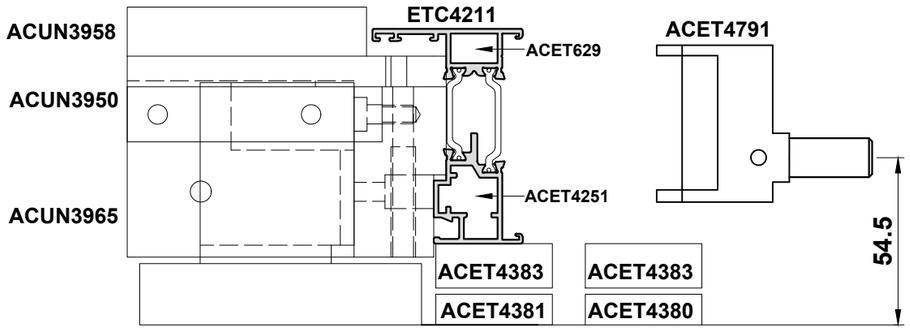
Place the frame flat, inside down.
Lower the sash vertically with headslides down.
Slide the headslides into the sliding channel.



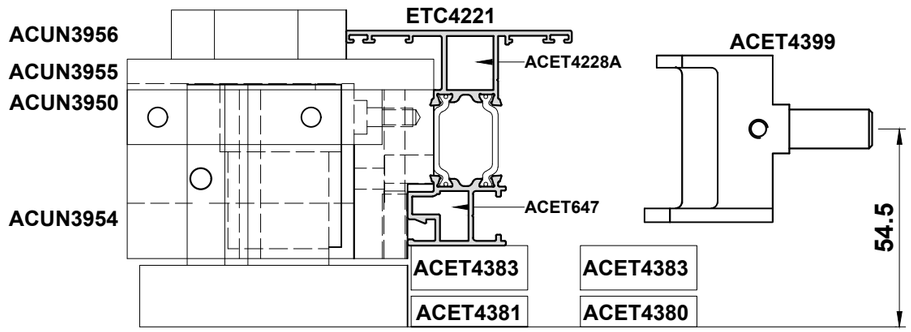
Lift one hinge at a time, couple hinge pivot to centre sash assembly and secure with second screw.

Do Not Scale From This Drawing

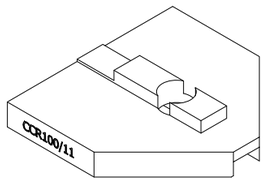
Parallel Crimping



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



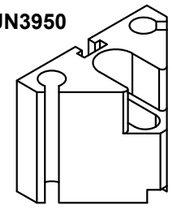
Hand crimper ACET4381 set 26.5mm
Power crimper ACET4380 set 36.5mm



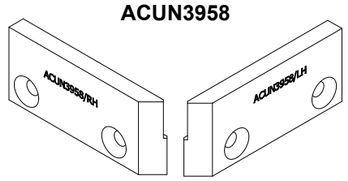
Power crimper use 10mm packer ACCR200N

Adjustable Vee Block

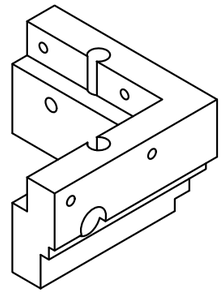
ACUN3950

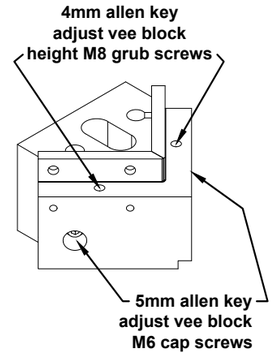


ACUN3958

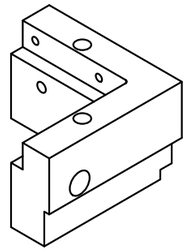


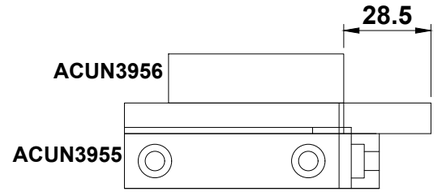
ACUN3954

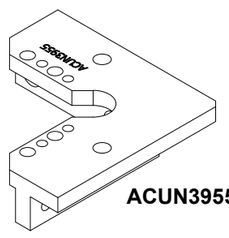




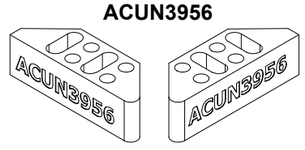
ACUN3965

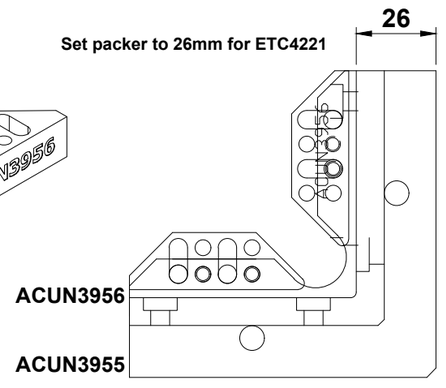




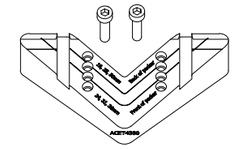


ACUN3956

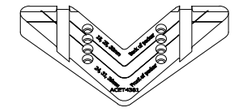




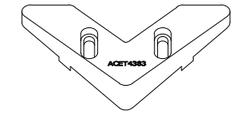
Section Packers



ACET4380



ACET4381

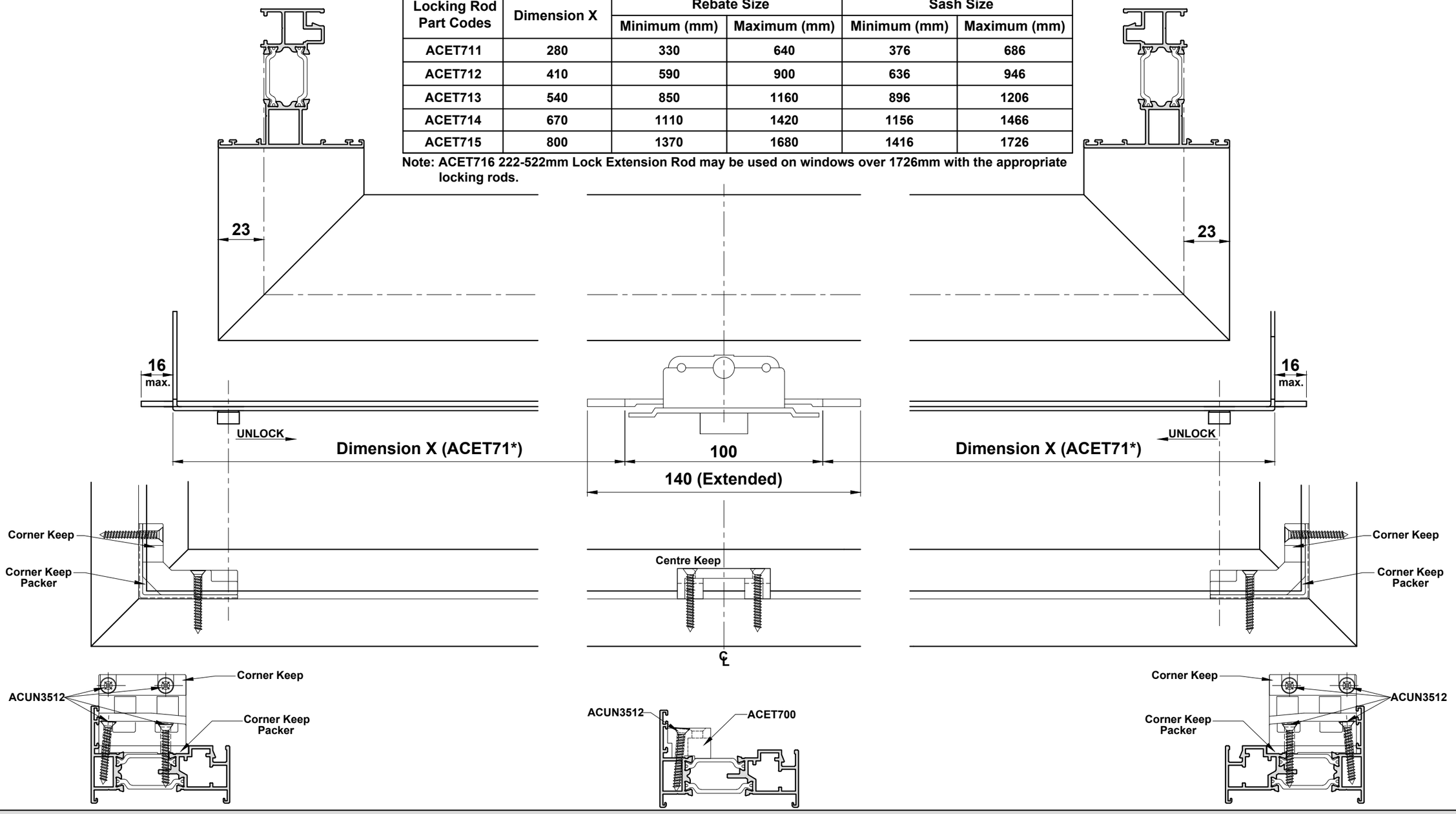


ACET4383

Parallel Multi-Point Locking

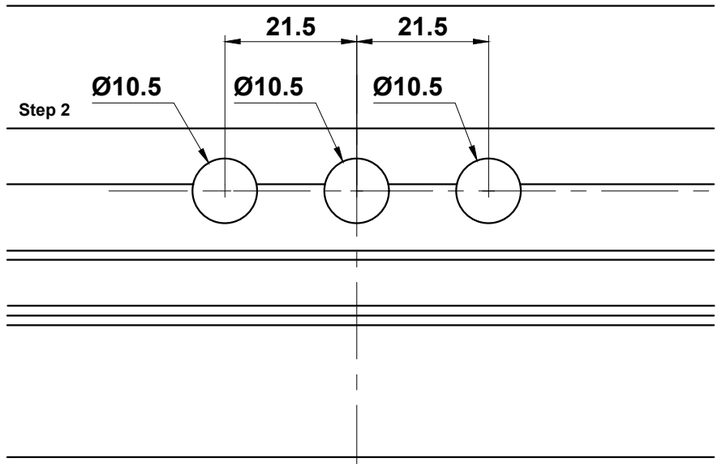
Basic locking Kit: ACET4260					
Locking Rod Part Codes	Dimension X	Rebate Size		Sash Size	
		Minimum (mm)	Maximum (mm)	Minimum (mm)	Maximum (mm)
ACET711	280	330	640	376	686
ACET712	410	590	900	636	946
ACET713	540	850	1160	896	1206
ACET714	670	1110	1420	1156	1466
ACET715	800	1370	1680	1416	1726

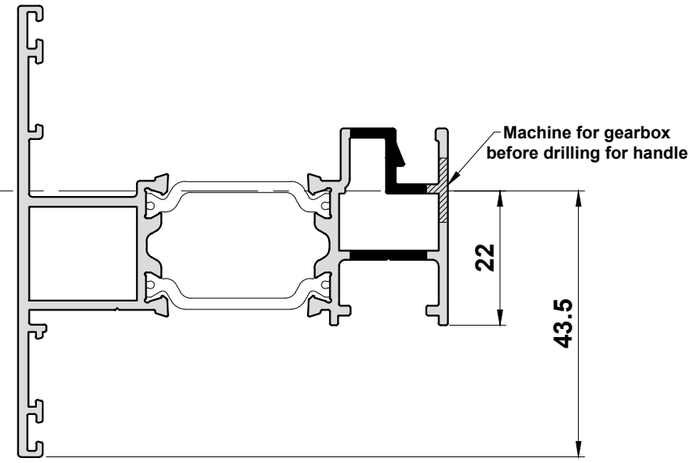
Note: ACET716 222-522mm Lock Extension Rod may be used on windows over 1726mm with the appropriate locking rods.

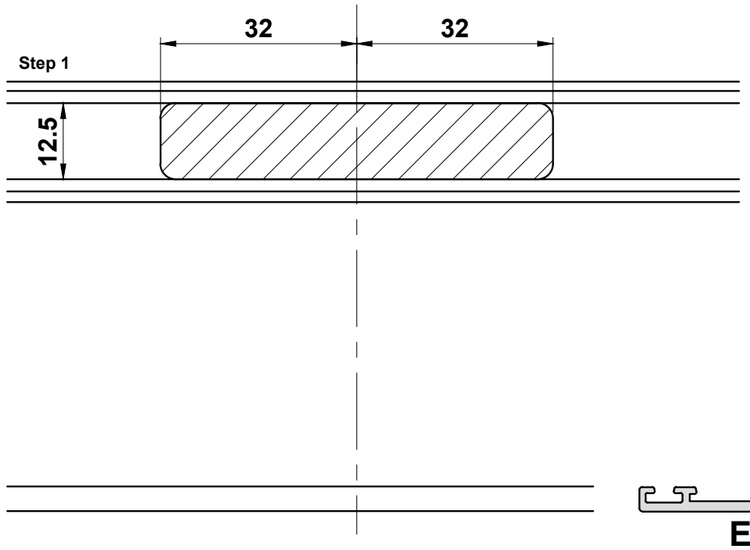


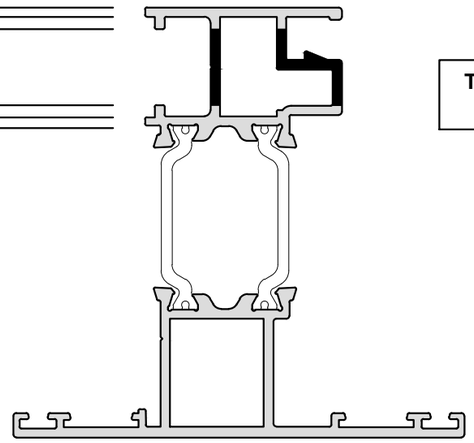
Do Not Scale From This Drawing

Parallel Multi-Point Lock Installation



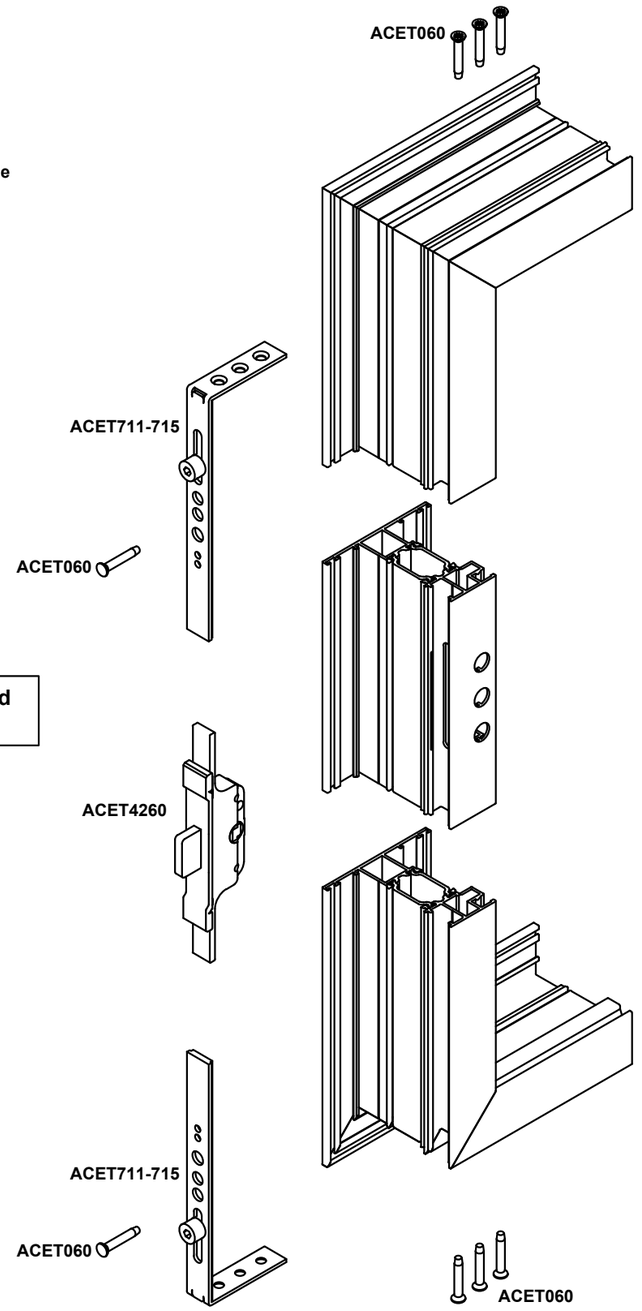






ETC4221

The locking mechanism shall be fitted before the parallel hinges.



Do Not Scale From This Drawing

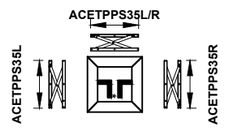
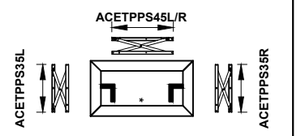
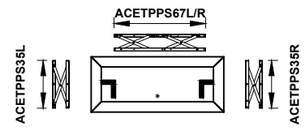
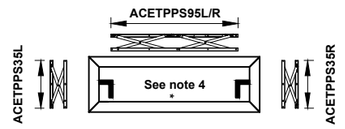
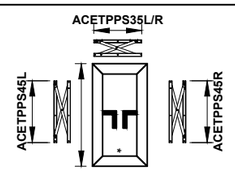
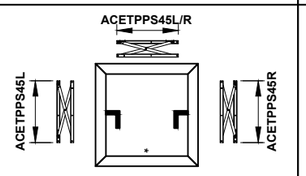
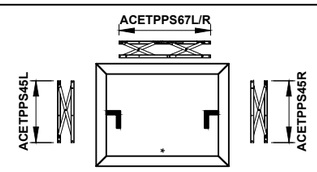
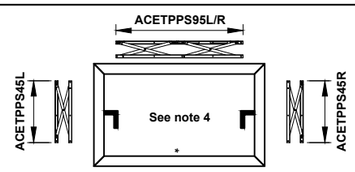
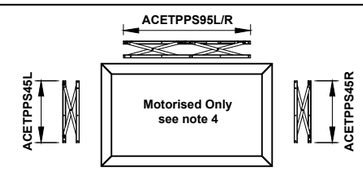
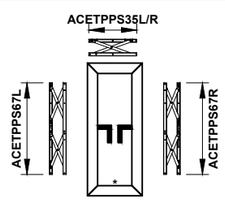
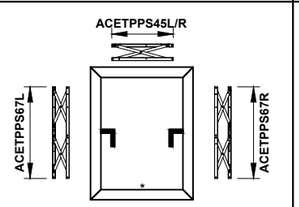
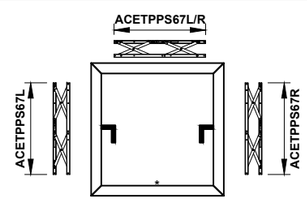
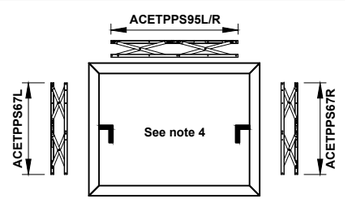
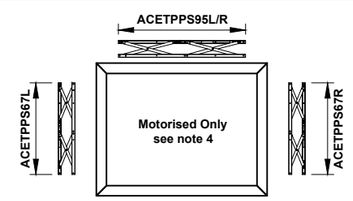
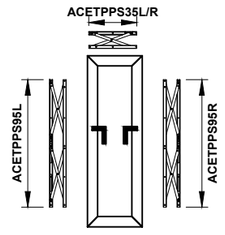
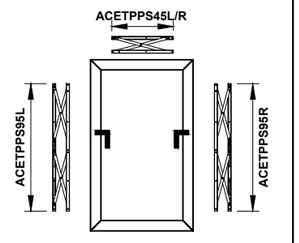
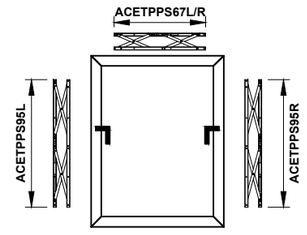
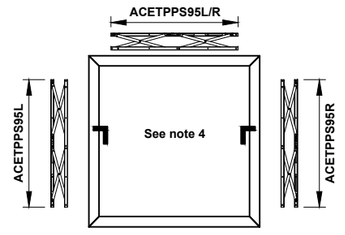
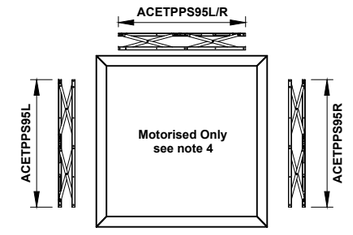
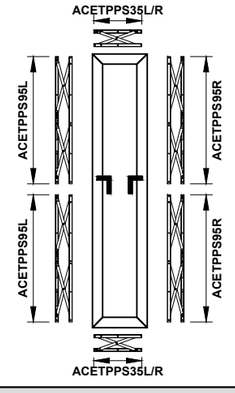
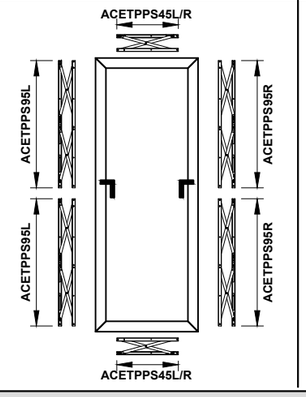
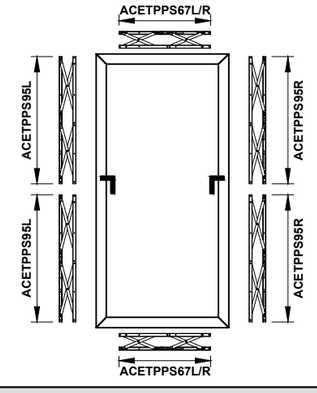
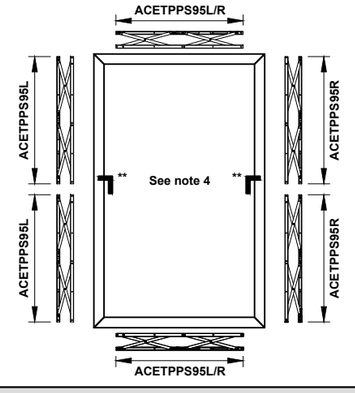
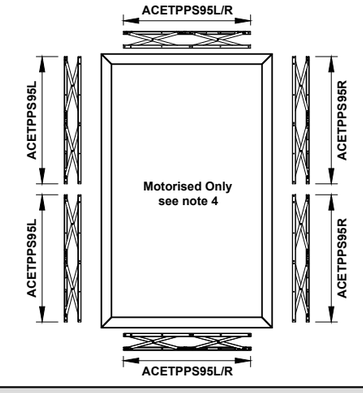
Alitherm 400 HD Window

CONSTRUCTION DRAWINGS - PARALLEL

Parallel Hinge Selection

Vent Height (mm)

Vent Width (mm) Dimension are overall vent sizes

Vent Height (mm)	400* to 600 *440mm min when using multipoint locking.	600 to 970	970 to 1250	1250 to 2000	1500 to 2000
375 to 750	Manual or Motorised Operation				Motorised Operation Only
Vents under 465mm high = Cockspur handle only to prevent clash between hinge & keeps					
750 to 1000					
970 to 1250					
Vents over 1729mm require extension rods ACET716. See page E17 for more details. 1250 to 2000					
Vents over 2700mm cannot use existing shootbolt locks. Motorised operation is recommended. 2000 to 3000					

NOTES

1) Hinge Selection Guide for Guidance Only.

Horizontal Hinge	Width
350 ACETPPS35	400-600
450 ACETPPS45	500-970
670 ACETPPS67	970-1250
930 ACETPPS95	1250-2000

Vertical Hinge	Height
450 ACETPPS45	750-970
670 ACETPPS67	970-1250
930 ACETPPS95	1250-4000

2) All handles and hinges to be mounted centrally or equally spaced for multiple hinge applications.

3) Whilst one handle is possible on designs marked * for optimum performance it is recommended to offer two handles for all manual operation designs.

4) Designs over 1500mm wide are only suitable for motorised operation.

5) Designs over 2000mm high require two vertical hinges and two horizontal hinges mounted one on the top and one on the bottom of the sash.

4) Maximum sash weight for manual operation is 200Kg but it is the responsibility of the specifier and window manufacturer to ensure the vent operating force meets the requirements of standards where applicable. For motorised vents and for vents where the weight, size, shape or handle position are not covered by these details, please contact Smart Systems Ltd - Technical Department.

6) Optional drop in limit stop restrictors can be fitted to each vent. Two restrictors are required per sash. ACETPRS01 or ACETPRS02 dependent on height.

Hinge Restrictor	Height
ACETPRS01	750-970
ACETPRS02	970-1250
ACETPRS01	1250-4000

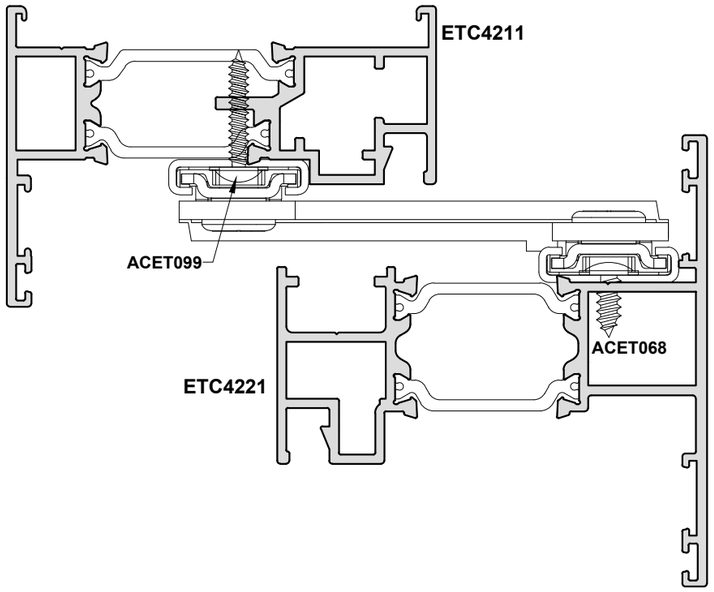
For All Parallel Projects Requiring A Smart Systems Guarantee, Contact Smart Systems Technical Department For A Full Hardware Specification. The Hinges Do Not Provide Weather Seal Compression. Multiple Locking Points are Required To Provide Weather Seal Compression

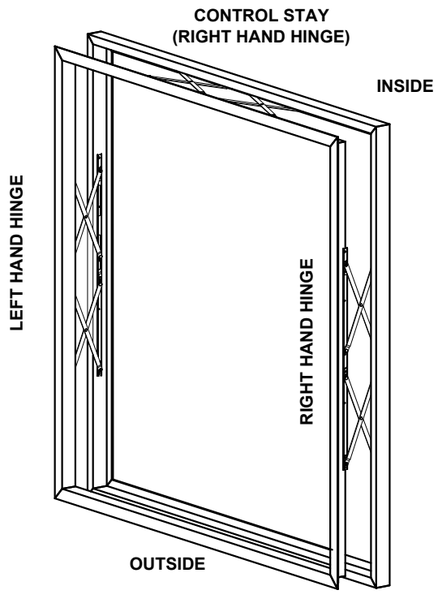
Tolerances u.o.s.
x = ±0.5
x.0 = ±0.2
x.00 = ±0.1
Angles ±0.5°
remove sharp edges Concentricity within 0.3 T.I.R.

Do Not Scale From This Drawing

ISSUED: MAY 2026

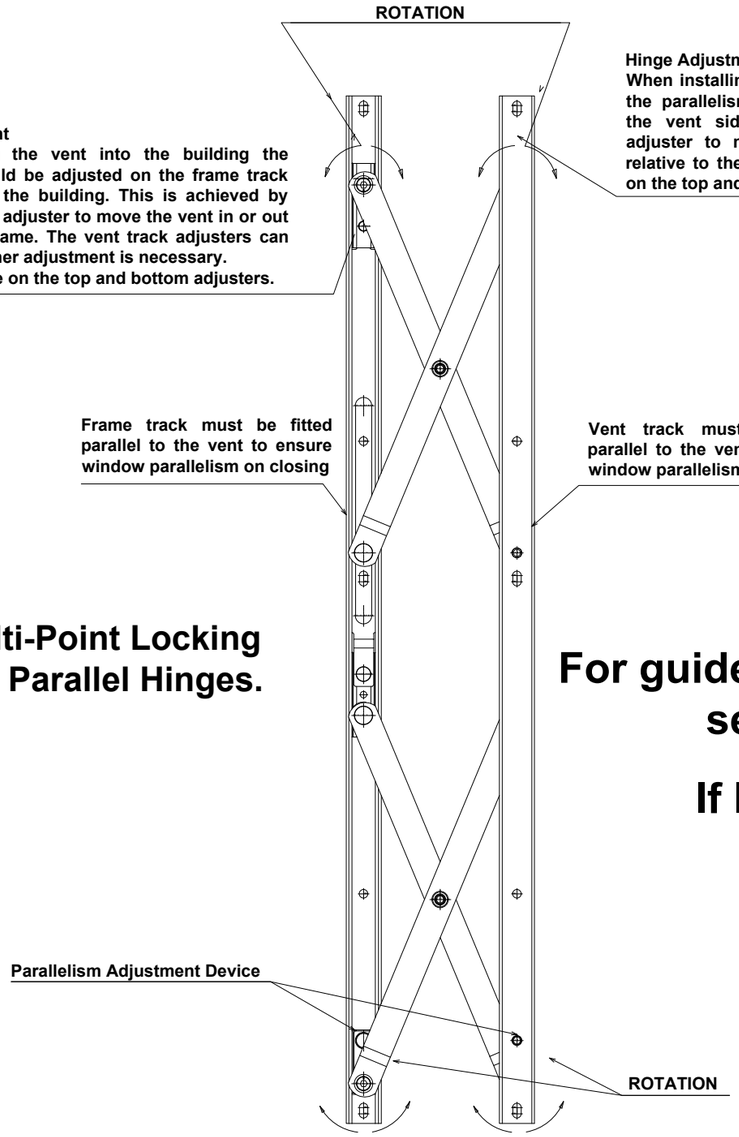
Parallel Hinge Installation





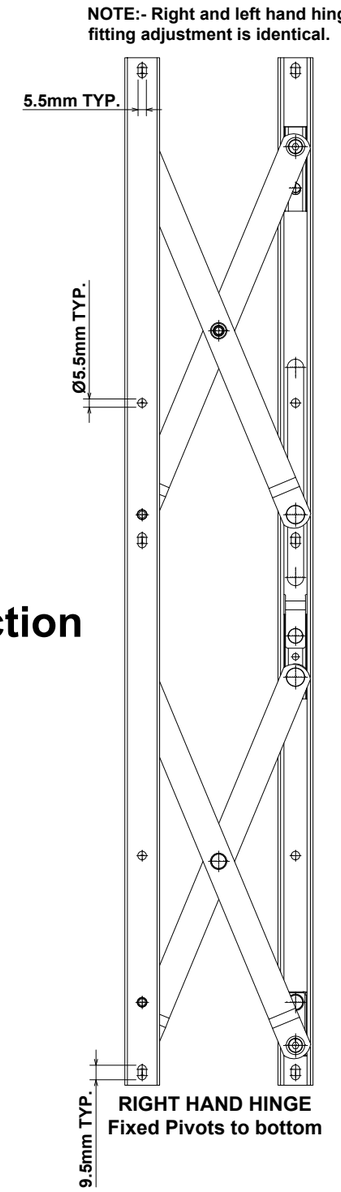
Hinge Adjustment
When installing the vent into the building the parallelism should be adjusted on the frame track from inside the the building. This is achieved by rotating the cam adjuster to move the vent in or out relative to the frame. The vent track adjusters can be altered if further adjustment is necessary.
This can be done on the top and bottom adjusters.

Fit Multi-Point Locking Before Parallel Hinges.



For guide to hinge selection see section B

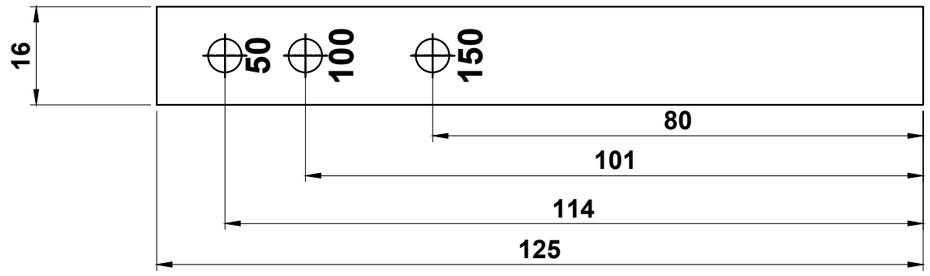
If In Doubt Ask.



Do Not Scale From This Drawing

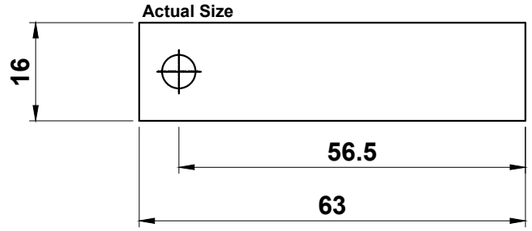
Parallel Hinge Opening Restrictor

Actual Size



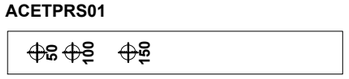
ACETPRS01
(For ACETPPS45
ACETPPS95)

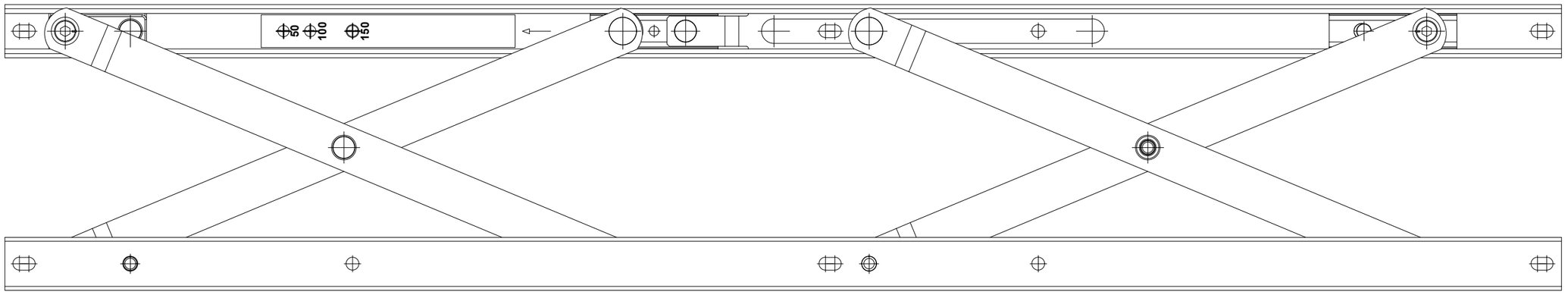
Actual Size



ACETPRS02
(For ACETPPS67)

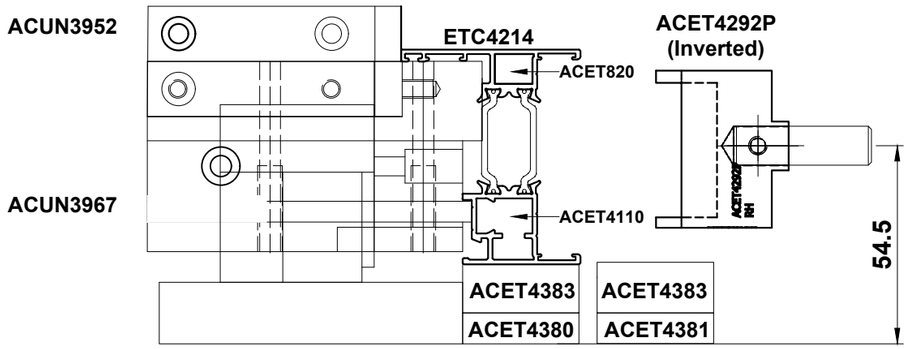
ACETPRS01

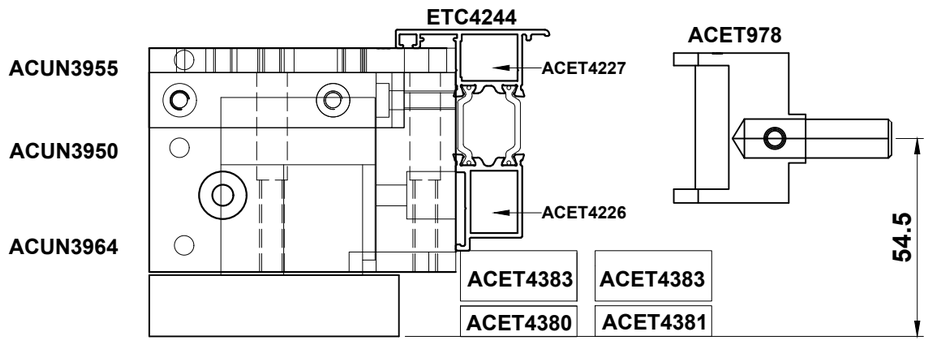




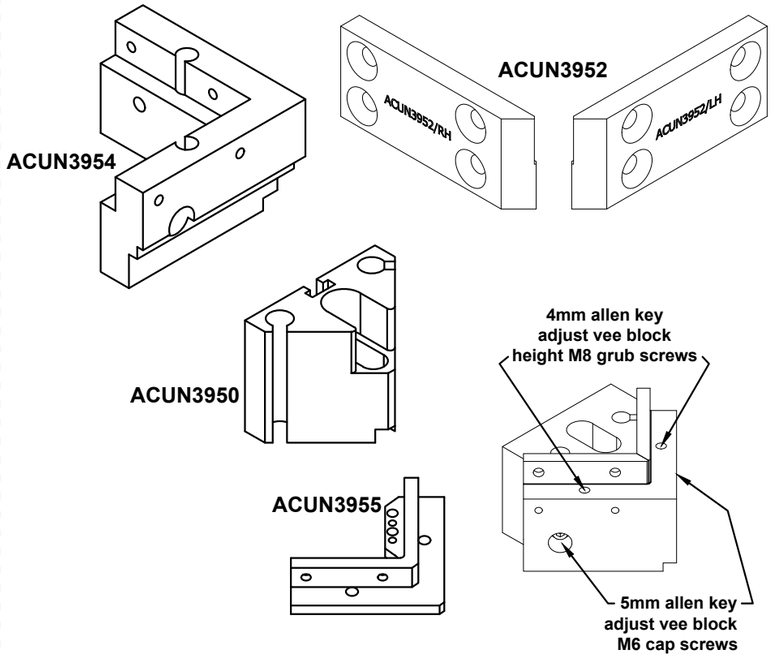
Do Not Scale From This Drawing

Internally Glazed Crimping

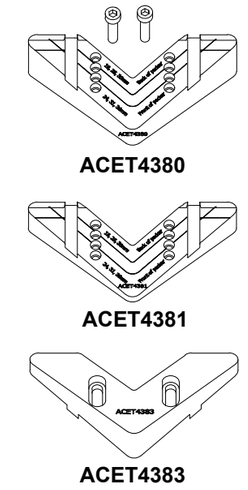


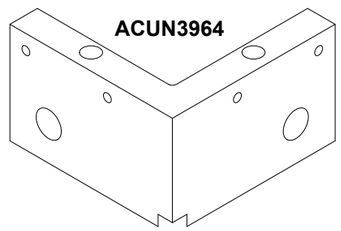


Adjustable Vee Block



Section Packers



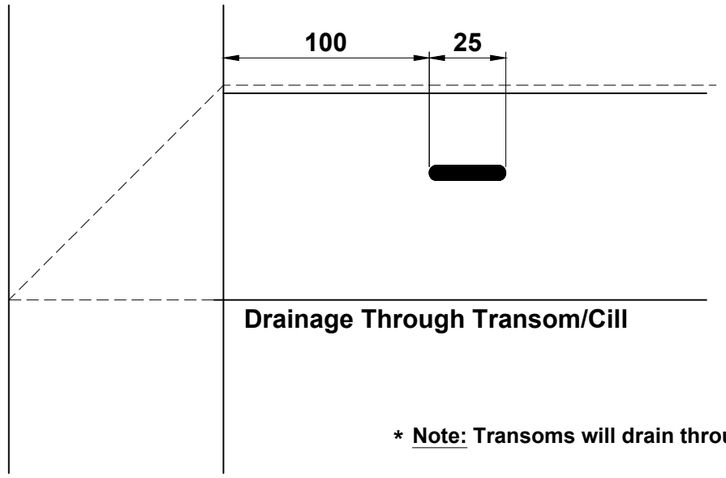


ACUN3967

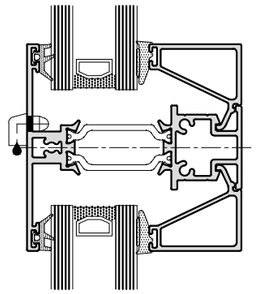
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Do Not Scale From This Drawing

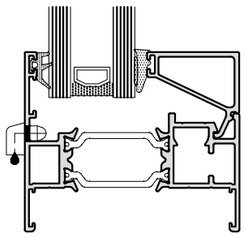
Internally Glazed Drainage



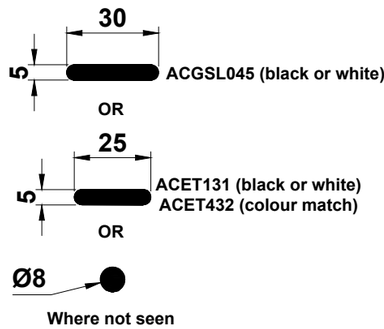
Drainage Through Transom/Cill

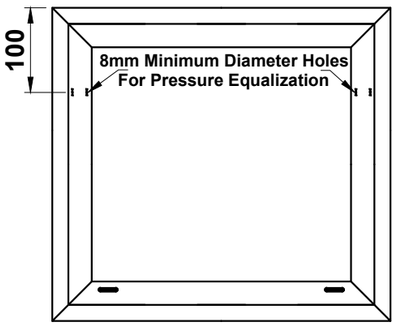


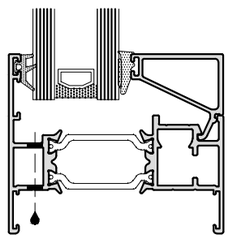
* Note: Transoms will drain through the join to the outerframe.



Outerframe Without Cill
with opener







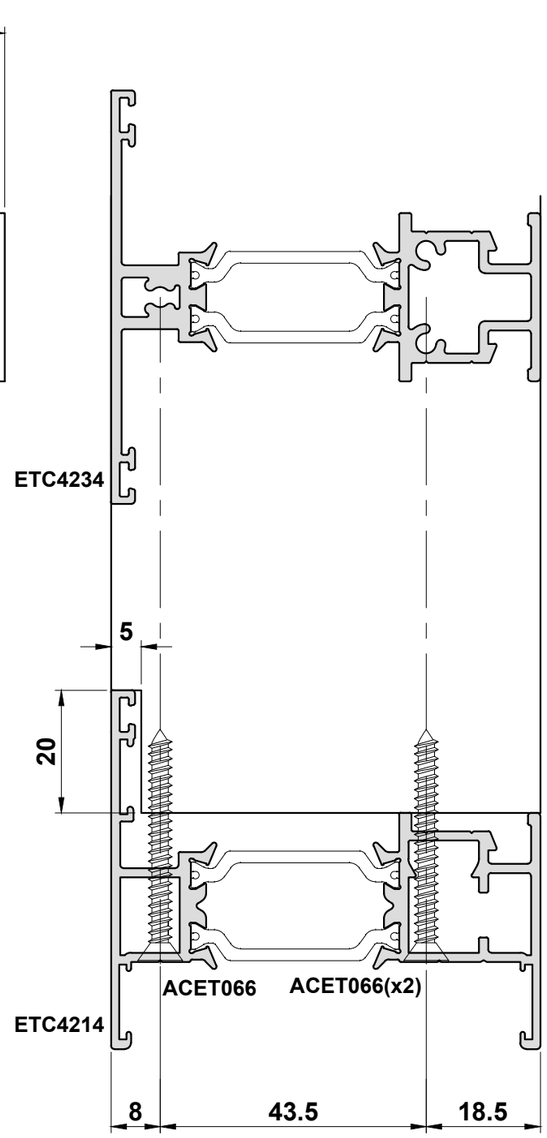
Outerframe With Cill

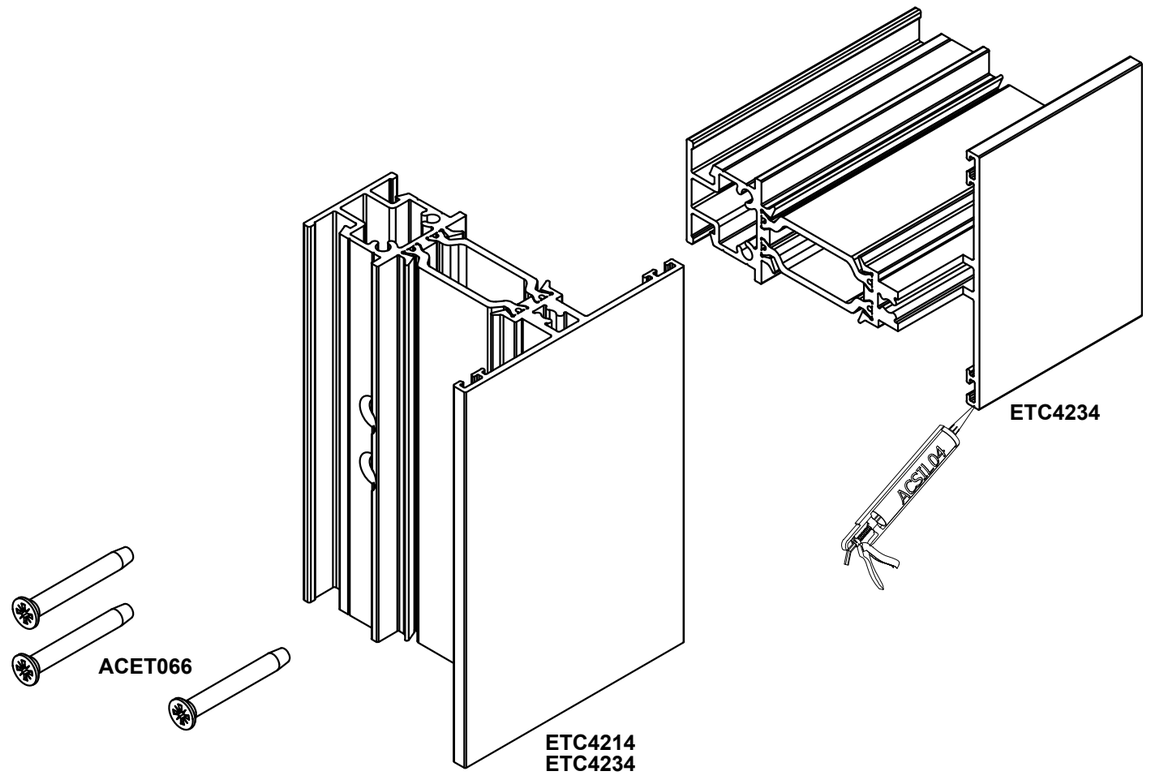
Important Note: All exposed aluminium should be coated using ACSIL014 or painted to match the frame.

Do Not Scale From This Drawing

Internally Glazed Transom/Mullion

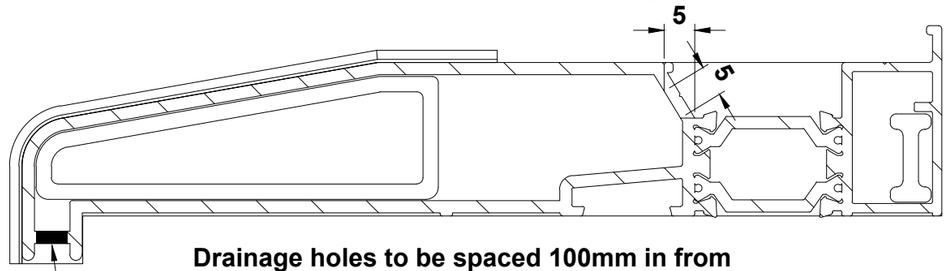






Alitherm 400 HD Window

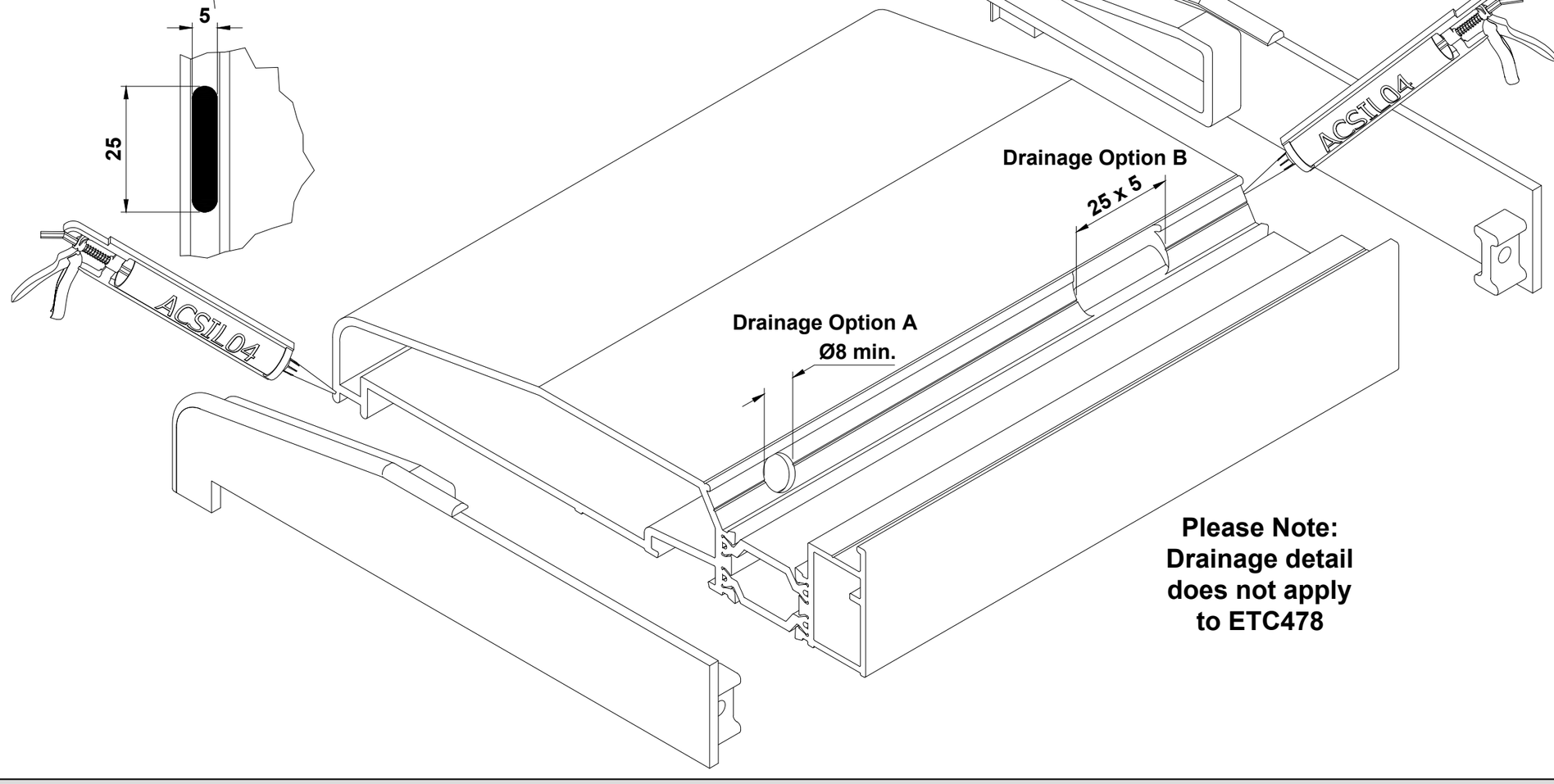
Drainage Option B



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

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

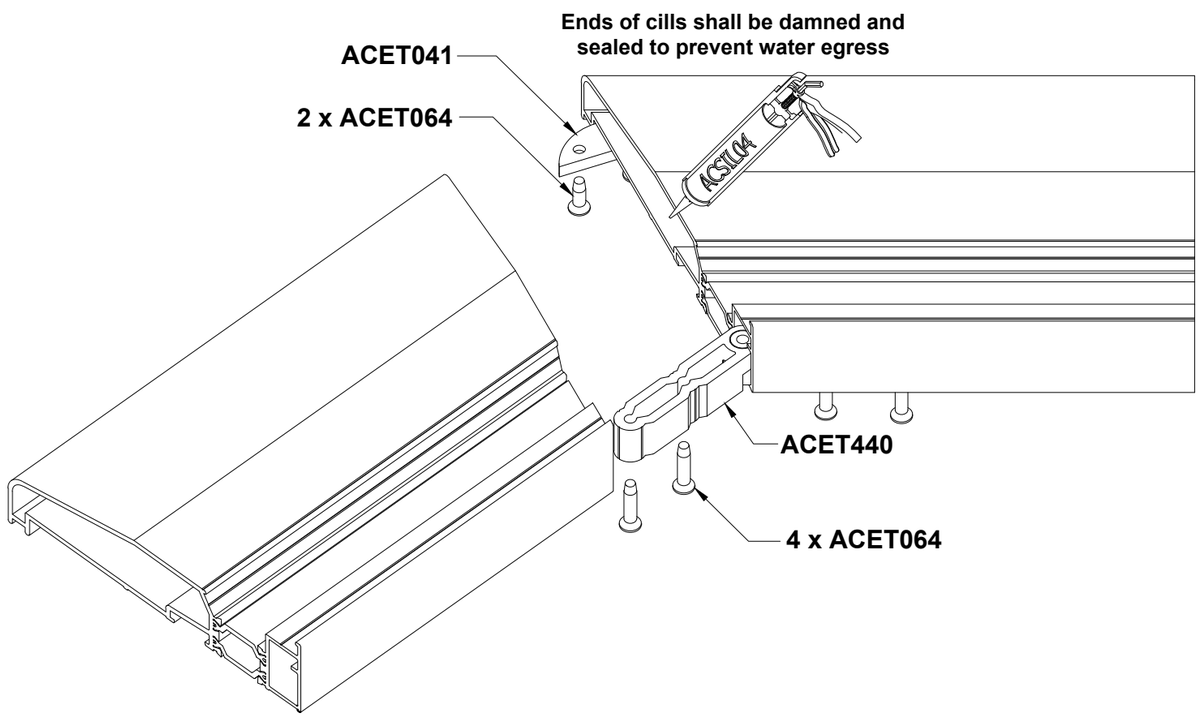
Ends of cills shall be dammed and sealed to prevent water egress

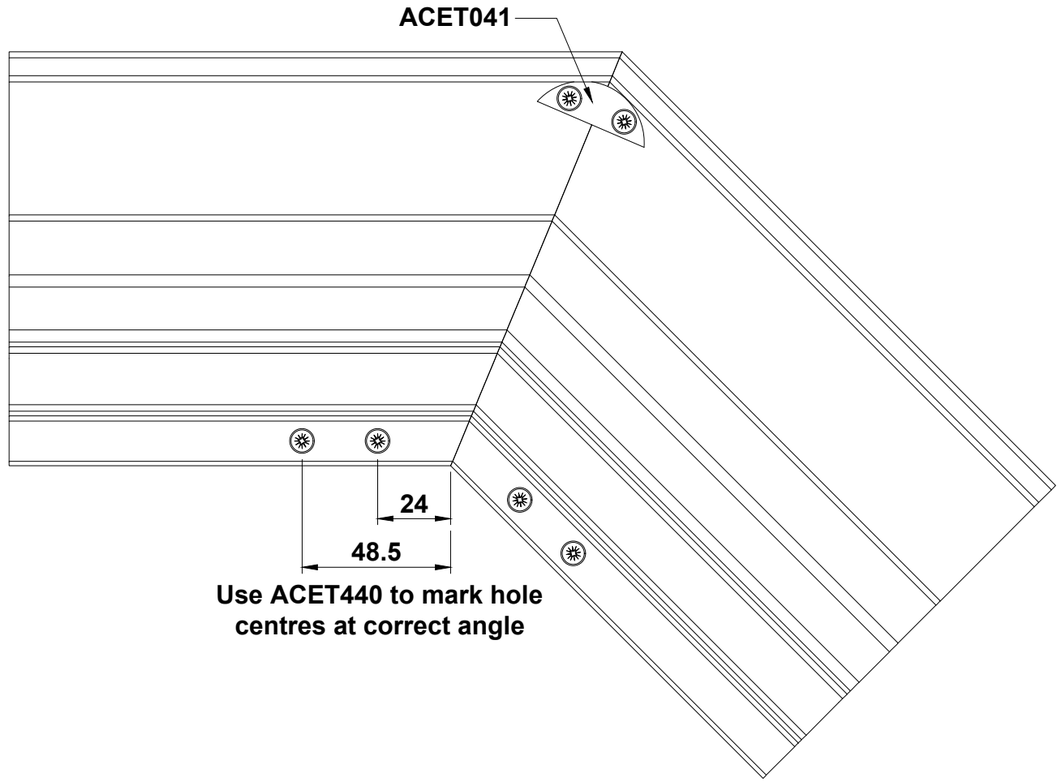


Please Note: Drainage detail does not apply to ETC478

Do Not Scale From This Drawing

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

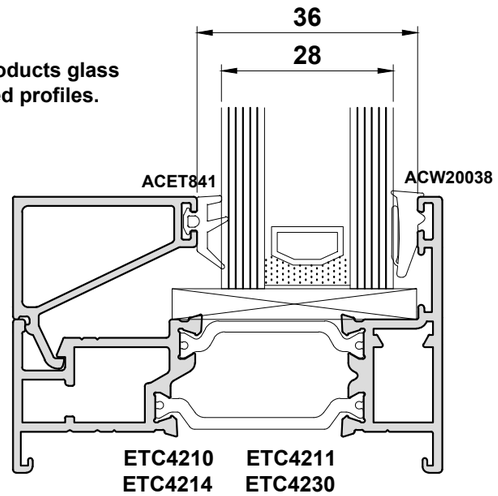




Alitherm 400 HD Window

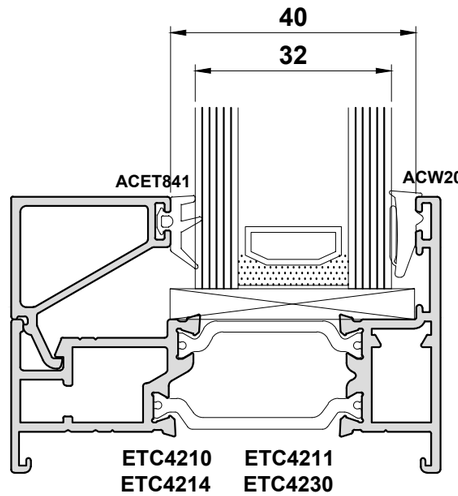
Please use GT Window Products glass clips for externally glazed profiles.

UN3400



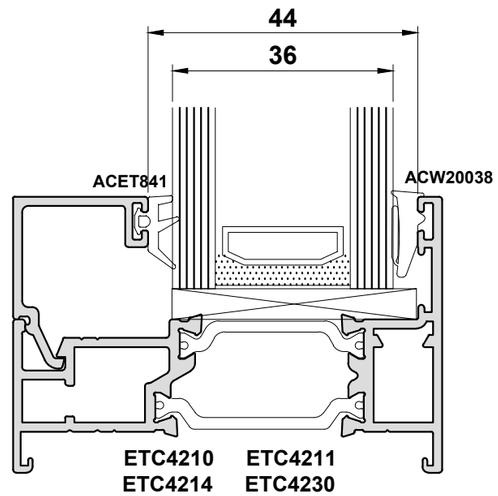
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ETC4214 ETC4230
ETC4232 ETC4234
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UN3401



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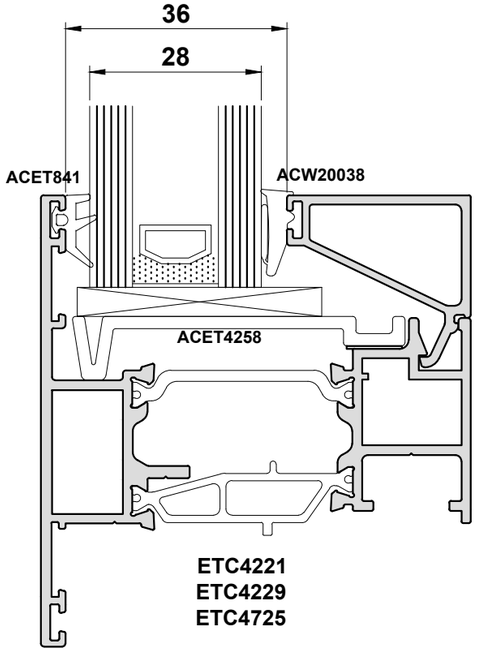
UN3402



ETC4210 ETC4211
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ETC4236 ETC4238

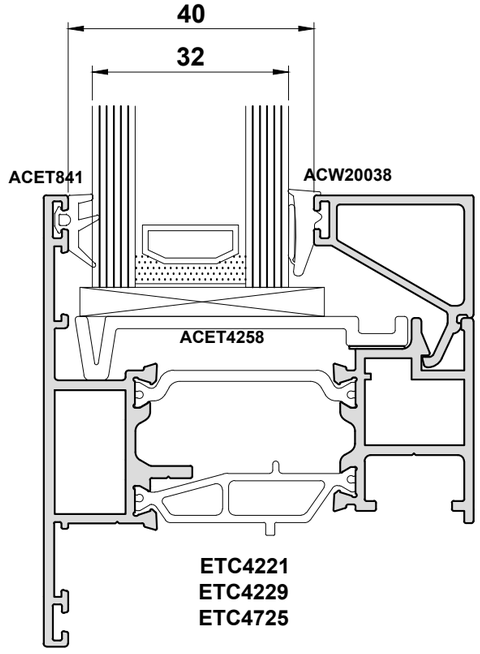
Externally Glazed

UN3400



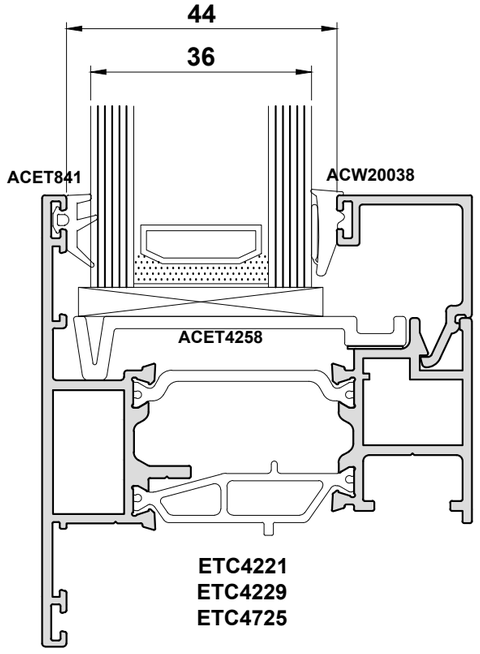
ETC4221
ETC4229
ETC4725

UN3401



ETC4221
ETC4229
ETC4725

UN3402



ETC4221
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ETC4725

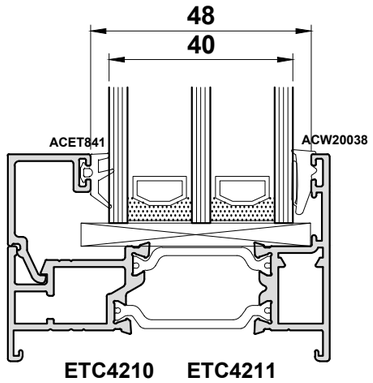
Internally Glazed

Do Not Scale From This Drawing

Alitherm 400 HD Window

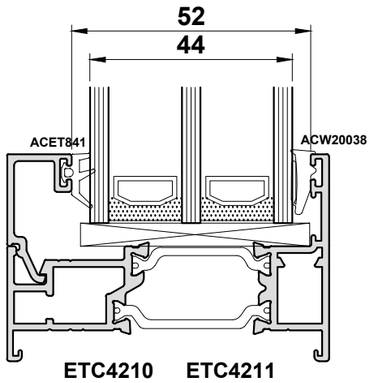
Please use GT Window Products glass clips for externally glazed profiles.

UN3403



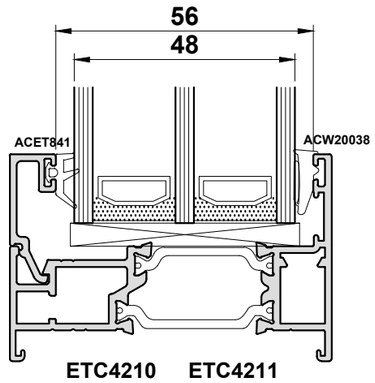
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ETC4214 ETC4230
ETC4232 ETC4234
ETC4236 ETC4238

UN3404



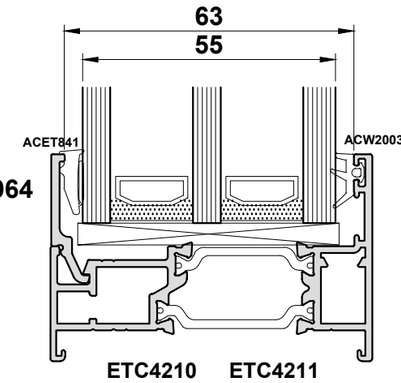
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ETC4214 ETC4230
ETC4232 ETC4234
ETC4236 ETC4238

UN3405



ETC4210 ETC4211
ETC4214 ETC4230
ETC4232 ETC4234
ETC4236 ETC4238

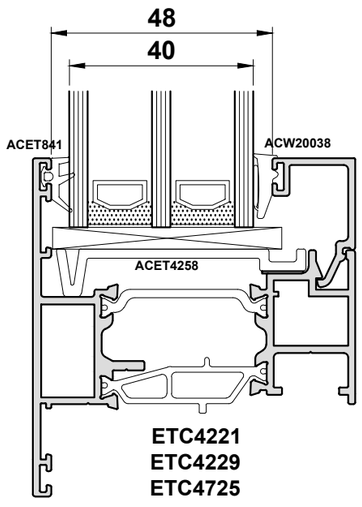
VG964



ETC4210 ETC4211
ETC4214 ETC4230
ETC4232 ETC4234
ETC4236 ETC4238

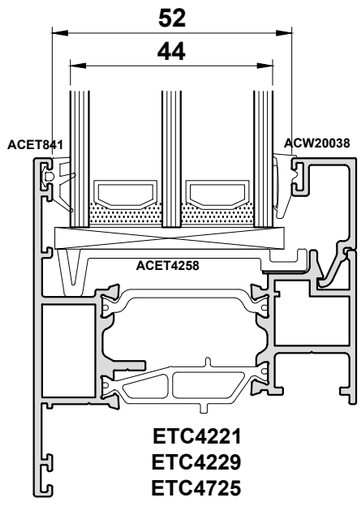
Externally Glazed

UN3403



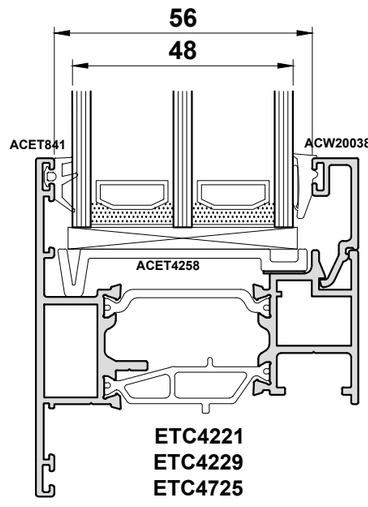
ETC4221
ETC4229
ETC4725

UN3404



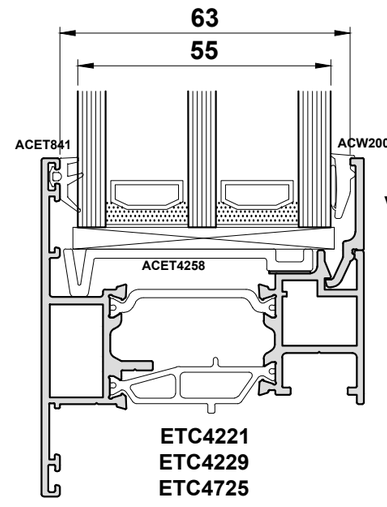
ETC4221
ETC4229
ETC4725

UN3405



ETC4221
ETC4229
ETC4725

VG964

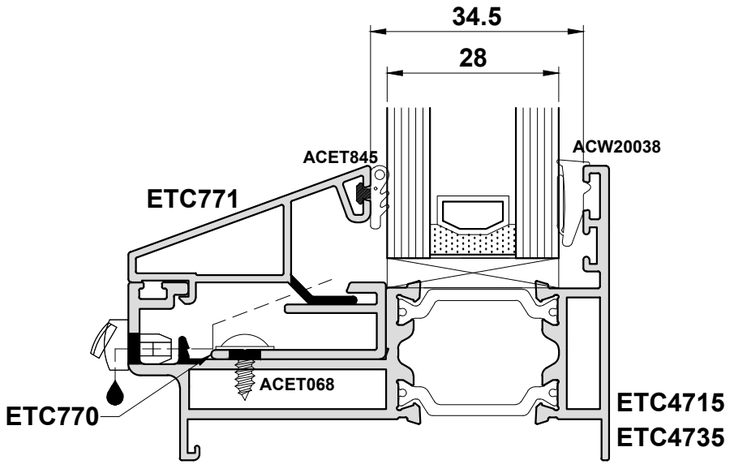


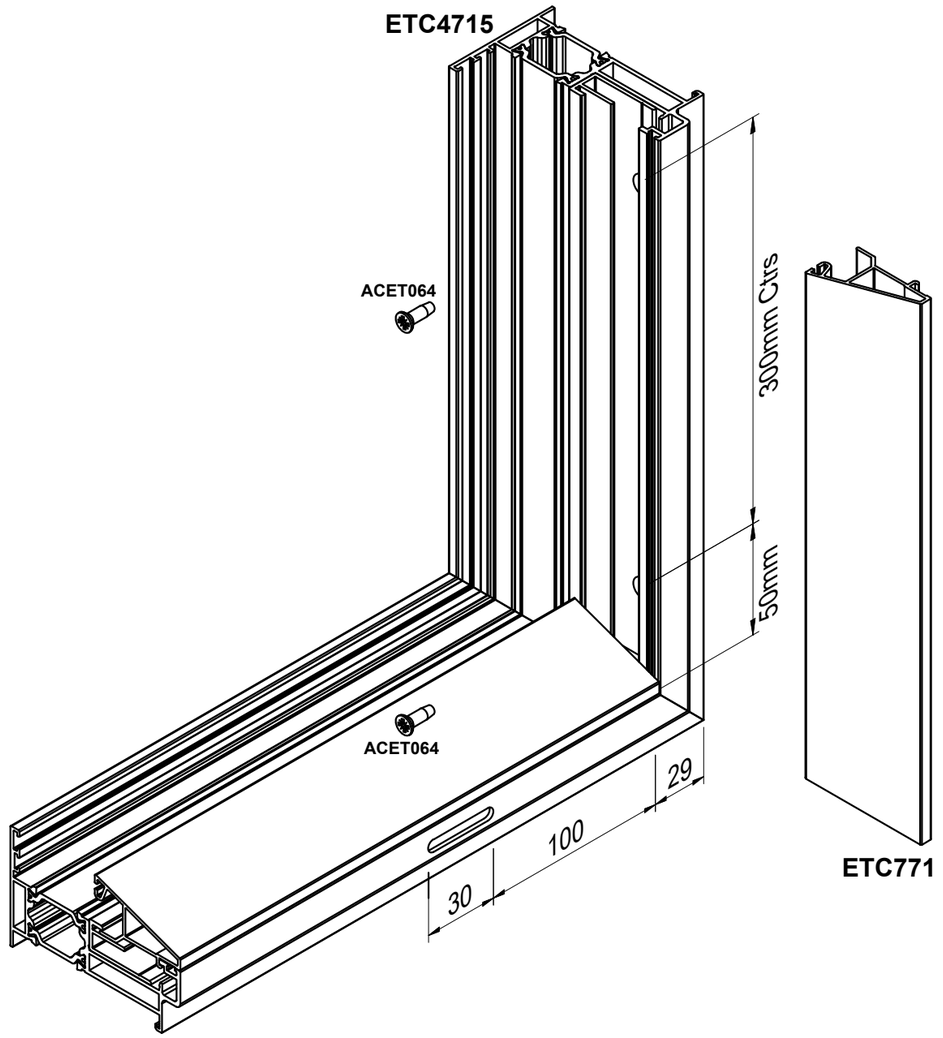
ETC4221
ETC4229
ETC4725

Internally Glazed

Do Not Scale From This Drawing

Glazing Details



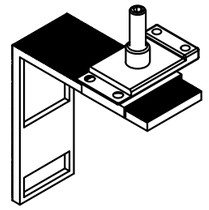


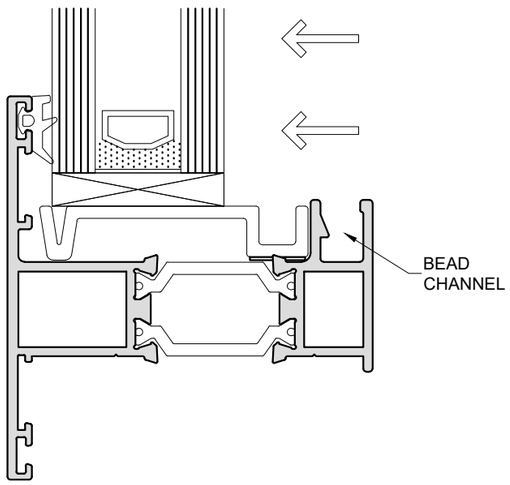
Do Not Scale From This Drawing

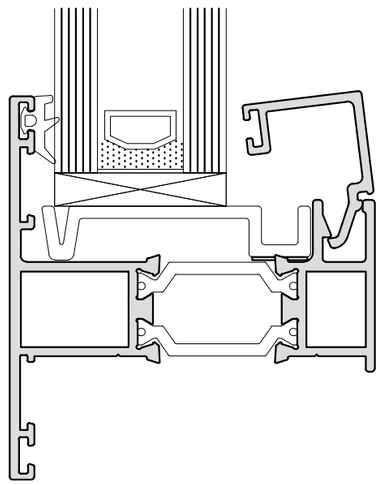
QUICK-GLAZE BEAD INSTALLATION

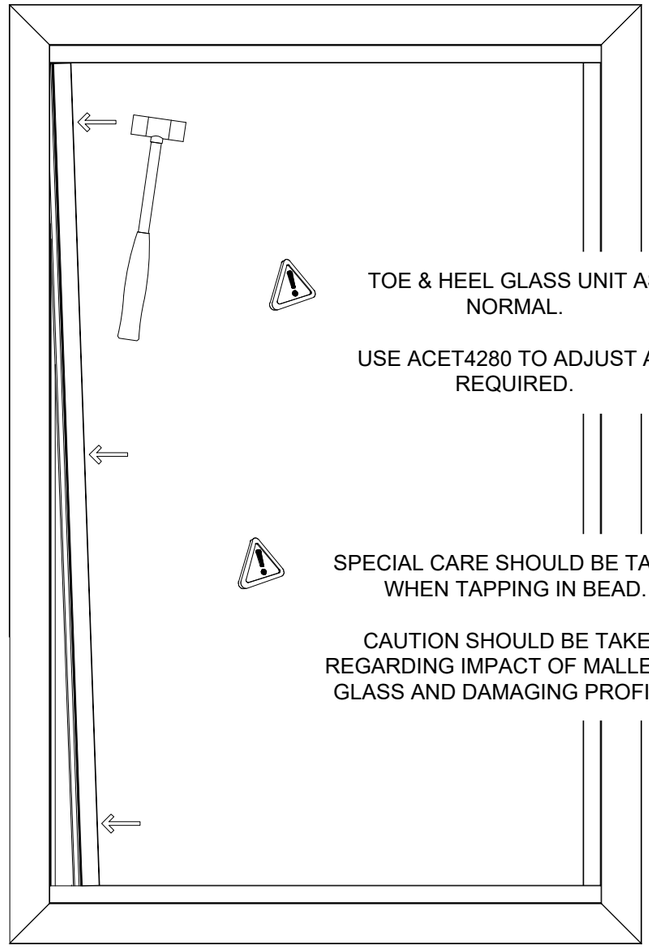
1. INSTALL GLASS UNIT, ENSURING IT HAS BEEN PUSHED FORWARD TO ENGAGE COMPRESSION OF E GASKET.
2. BEGINNING WITH HORIZONTAL BEADS, LOCATE BEAD IN CLIP CHANNEL OF SASH AS SHOWN. INTEGRATED GASKET MAY REST AGAINST GLASS UNIT.
3. APPLY FIRM PRESSURE TO THE BEAD TO HOLD IN POSITION. THIS MAY CAUSE THE BEAD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

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









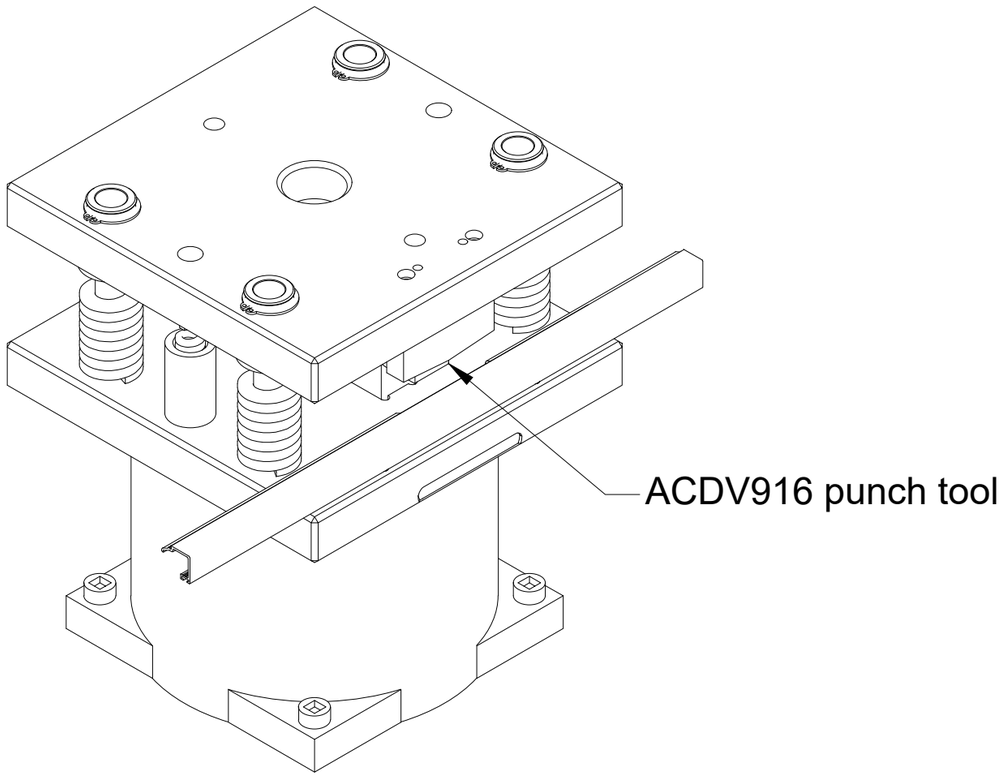
TOE & HEEL GLASS UNIT AS NORMAL.

USE ACET4280 TO ADJUST AS REQUIRED.

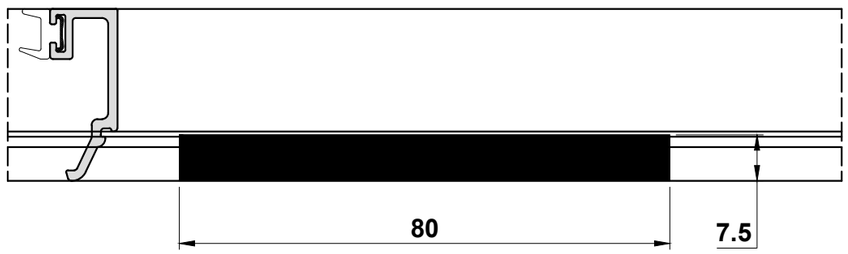
SPECIAL CARE SHOULD BE TAKEN WHEN TAPPING IN BEAD.

CAUTION SHOULD BE TAKEN REGARDING IMPACT OF MALLET ON GLASS AND DAMAGING PROFILES.

ACDV916 Punch Tool



Bead prep

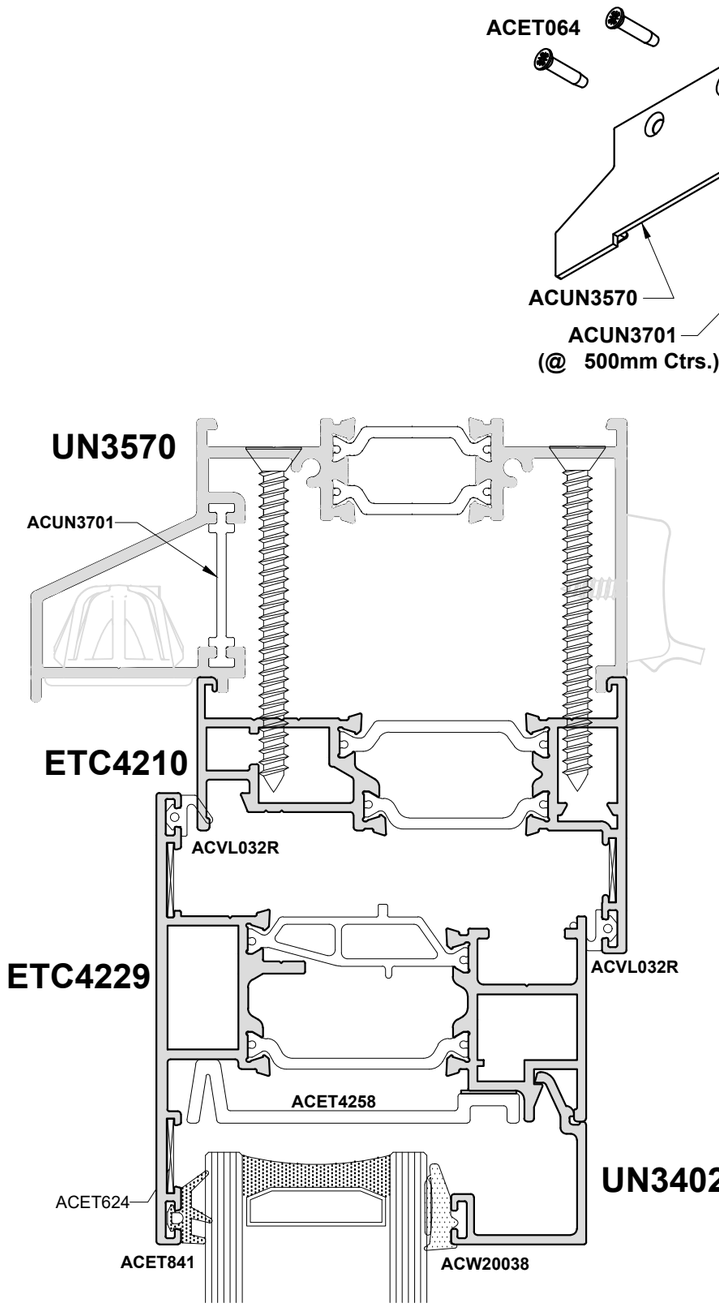


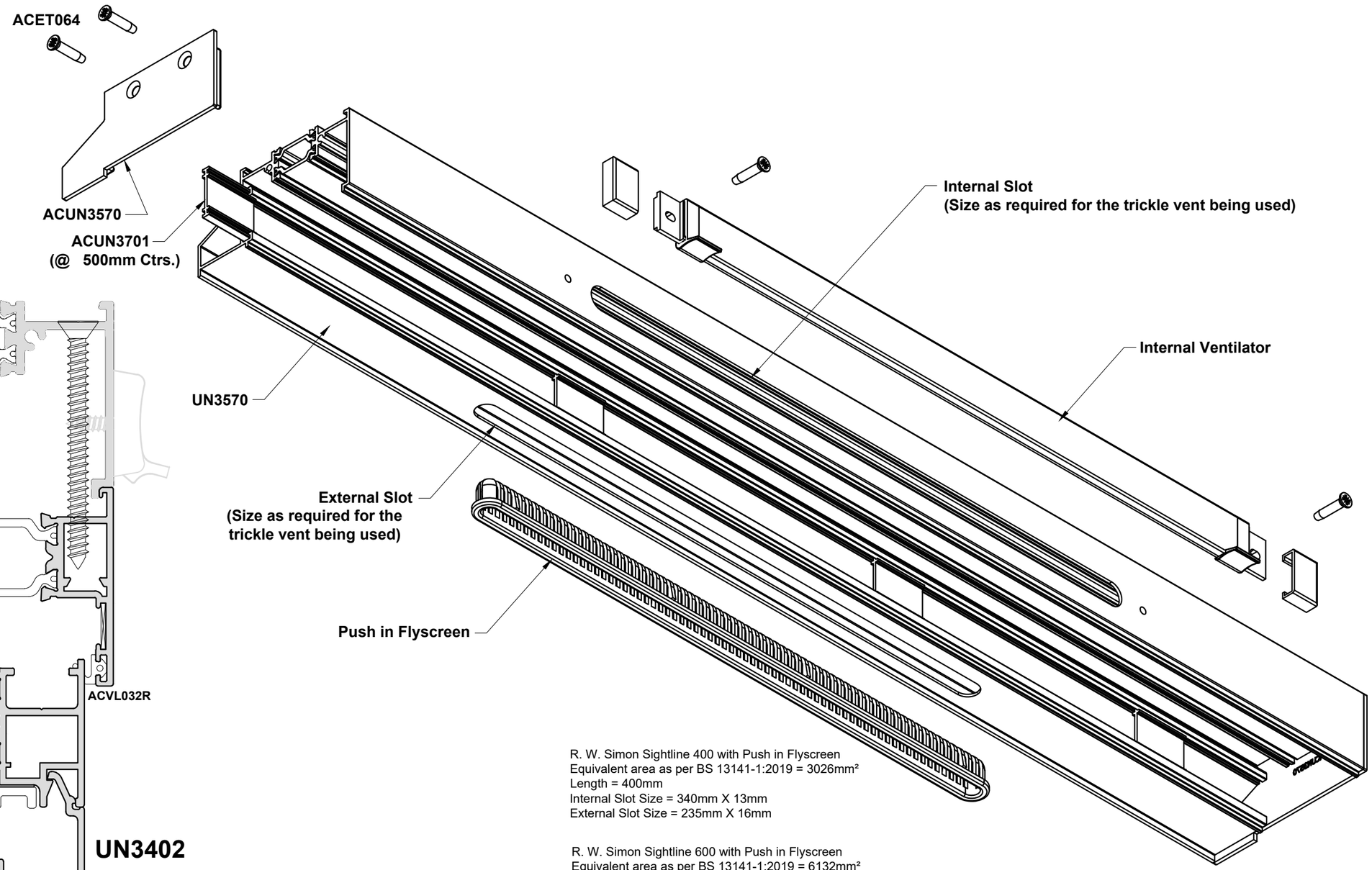
Please contact Technical Department for further information.

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

Do Not Scale From This Drawing

UN3570



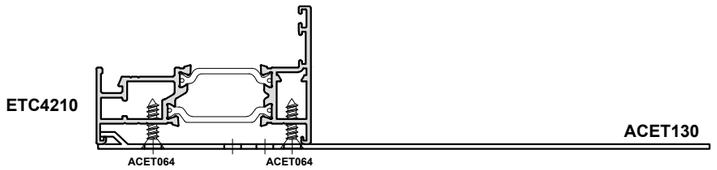


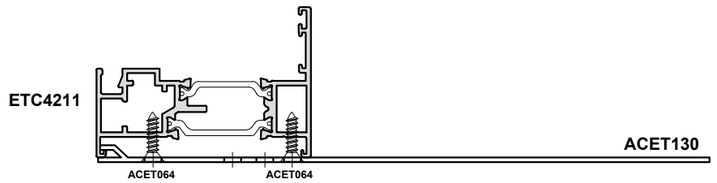
R. W. Simon Sightline 400 with Push in Flyscreen
Equivalent area as per BS 13141-1:2019 = 3026mm²
Length = 400mm
Internal Slot Size = 340mm X 13mm
External Slot Size = 235mm X 16mm

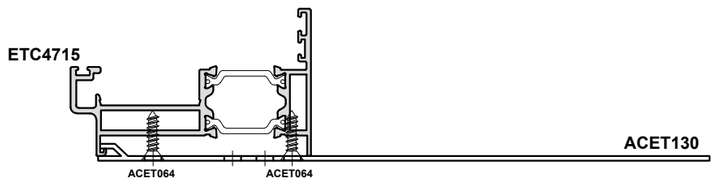
R. W. Simon Sightline 600 with Push in Flyscreen
Equivalent area as per BS 13141-1:2019 = 6132mm²
Length = 600mm
Internal Slot Size = 2 X (275mm X 13mm) + (10mm land)
External Slot Size = 2 X (235mm X 16mm) + (10mm land)

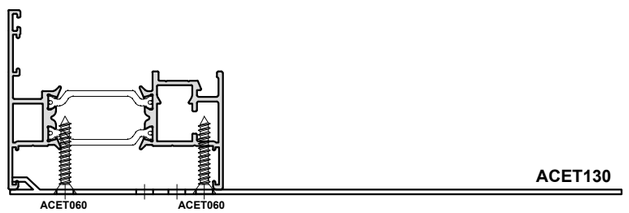
Do Not Scale From This Drawing

Fixing Strap Details



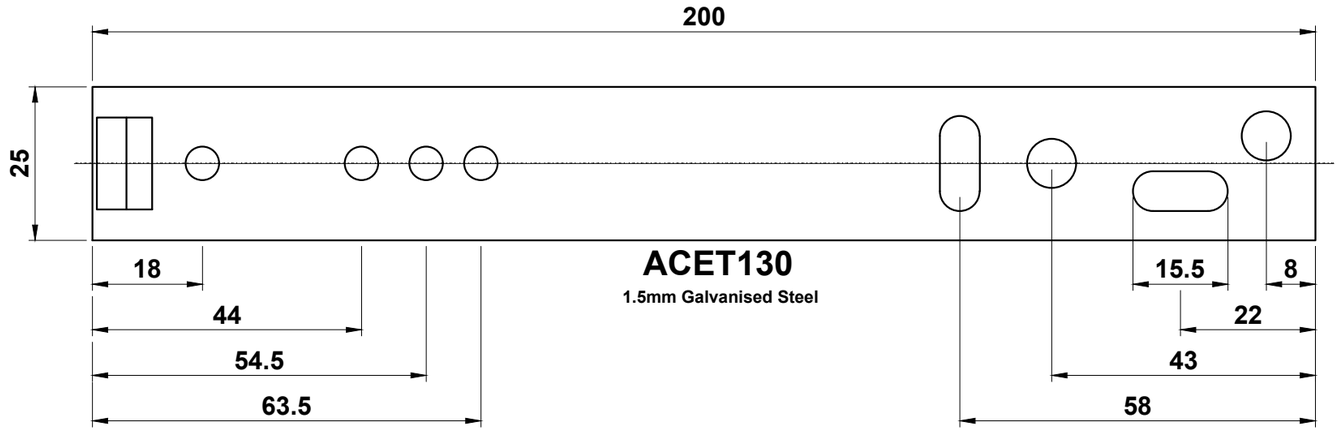






NOTE:

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

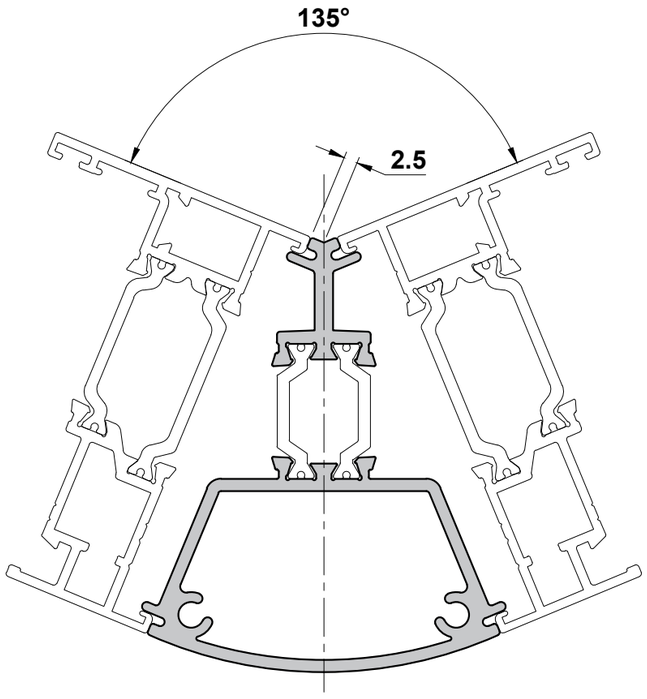


ACET130

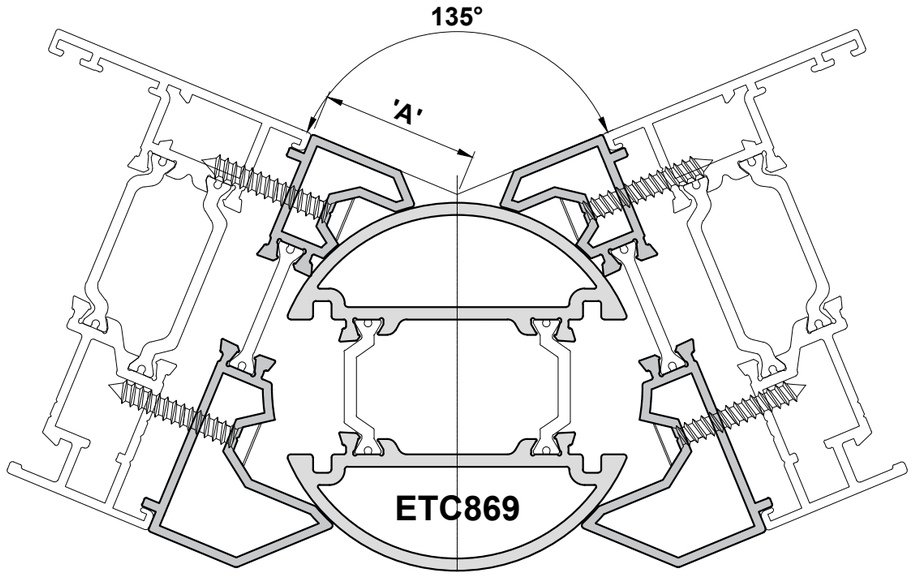
1.5mm Galvanised Steel

Do Not Scale From This Drawing

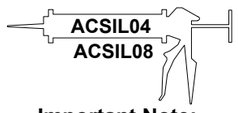
Bay Pole Options



UN3011



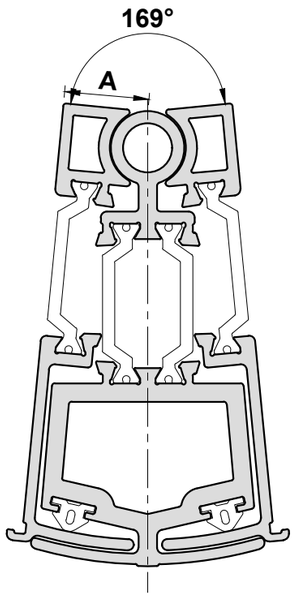
UN3012 UN3012



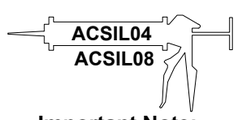
Important Note:
All joints must be adequately sealed using ACSIL04

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

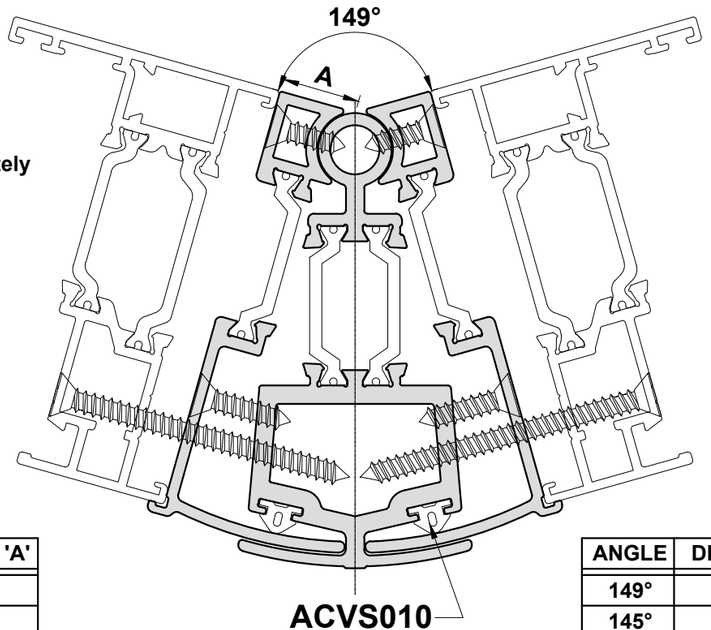
Bay Pole Options



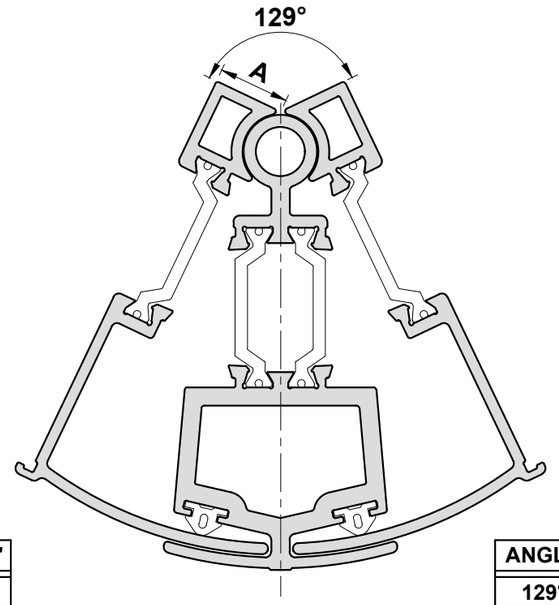
ANGLE	DEDUCTION 'A'
169°	14
165°	13.5
160°	13.6
155°	13
150°	13



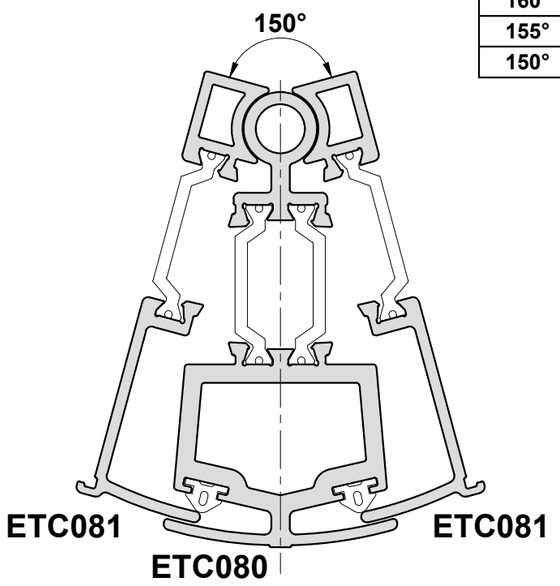
Important Note:
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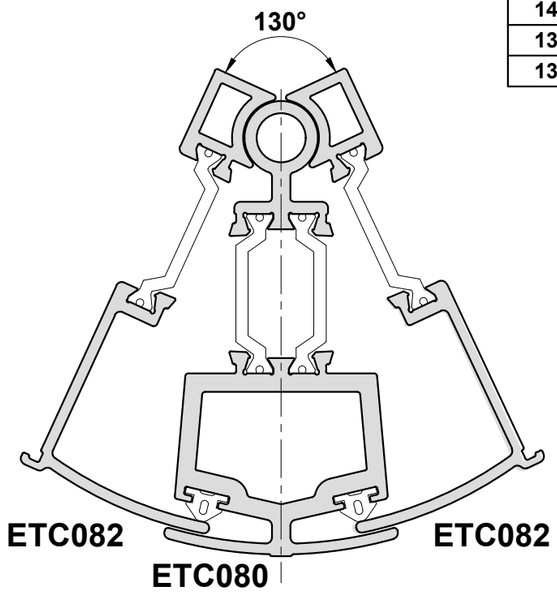


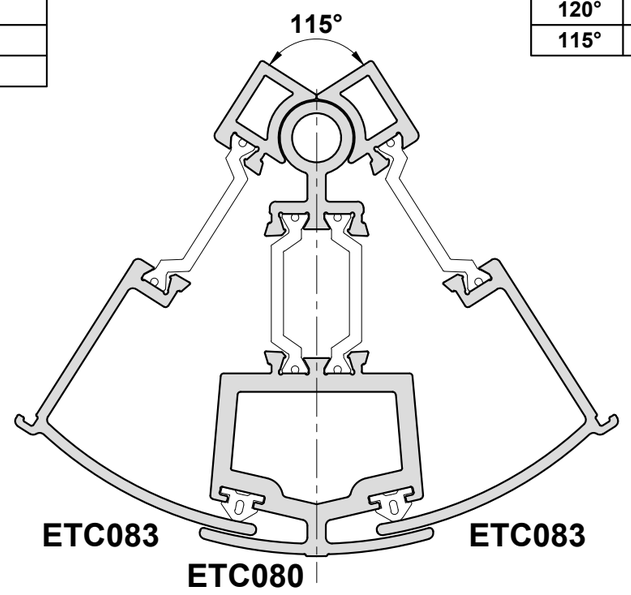
ANGLE	DEDUCTION 'A'
149°	12.5
145°	12.5
140°	12
135°	12
130°	11.5



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

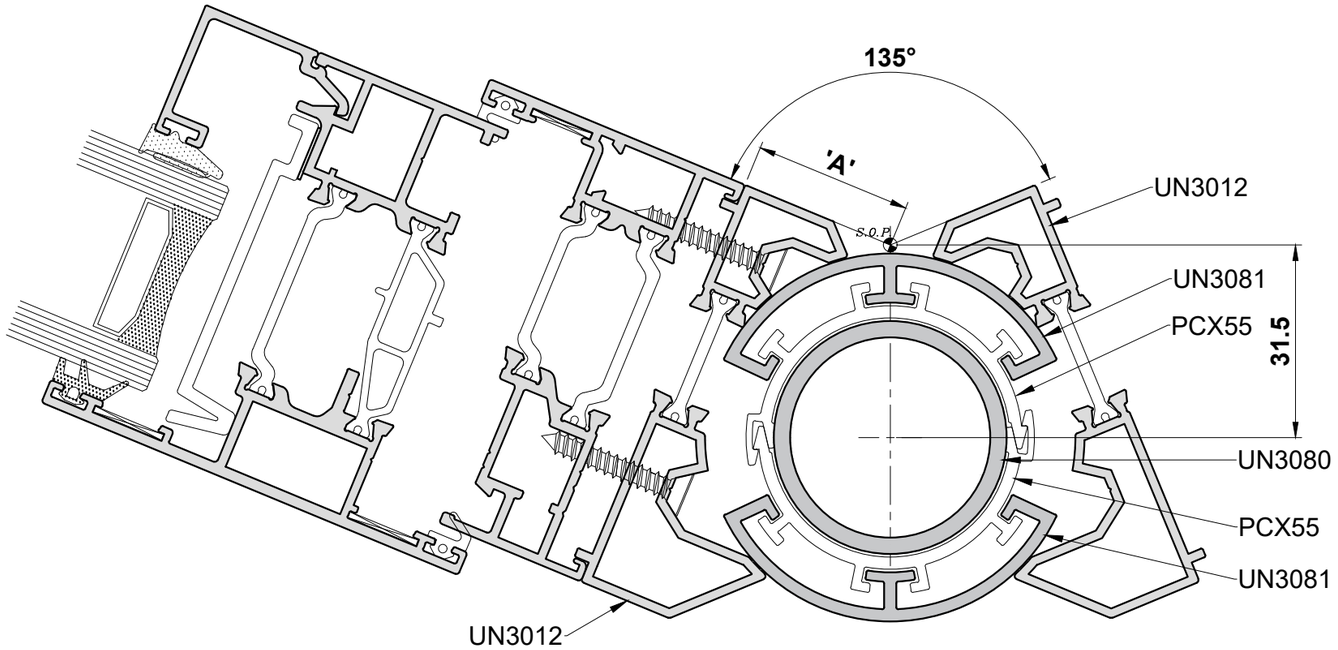


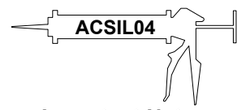




Do Not Scale From This Drawing

Jackable Bay Pole





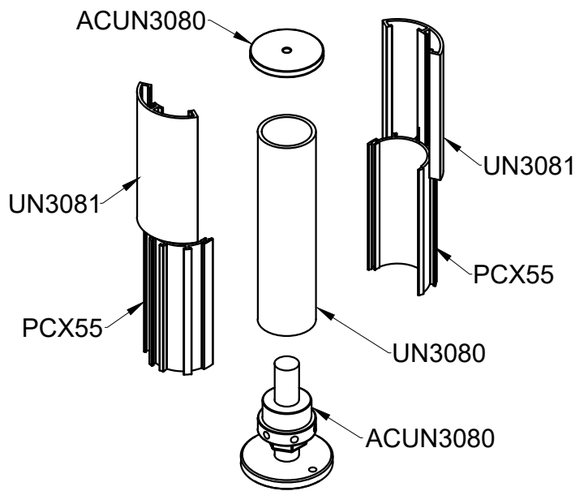
Important Note:
All joints must be adequately sealed using ACSIL04

ANGLE	DEDUCTION 'A'
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160°	32.5
155°	31
150°	30
145°	28.5
140°	27
135°	25.5
130°	24
125°	23
120°	21
115°	19.5
110°	18

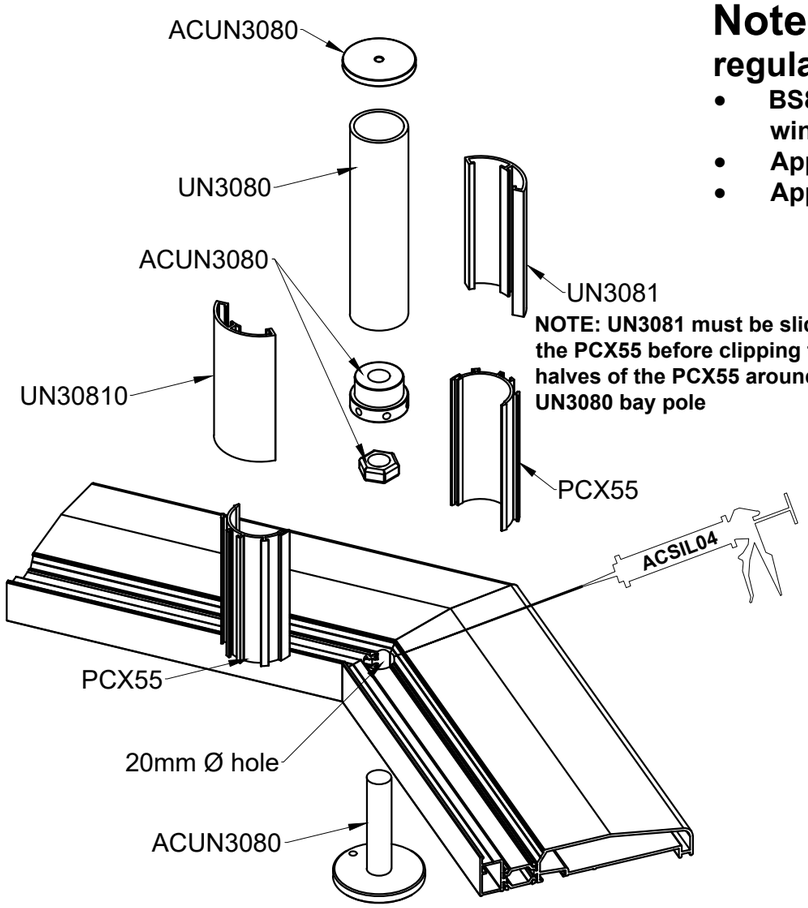
Note: Installation to comply with relevant building regulations and British standards :-

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

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



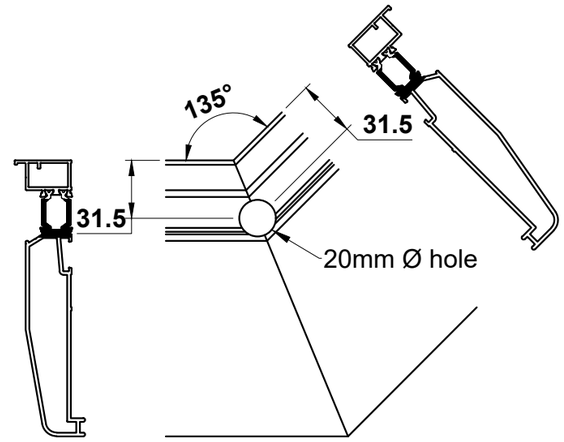
Jackable Bay Pole

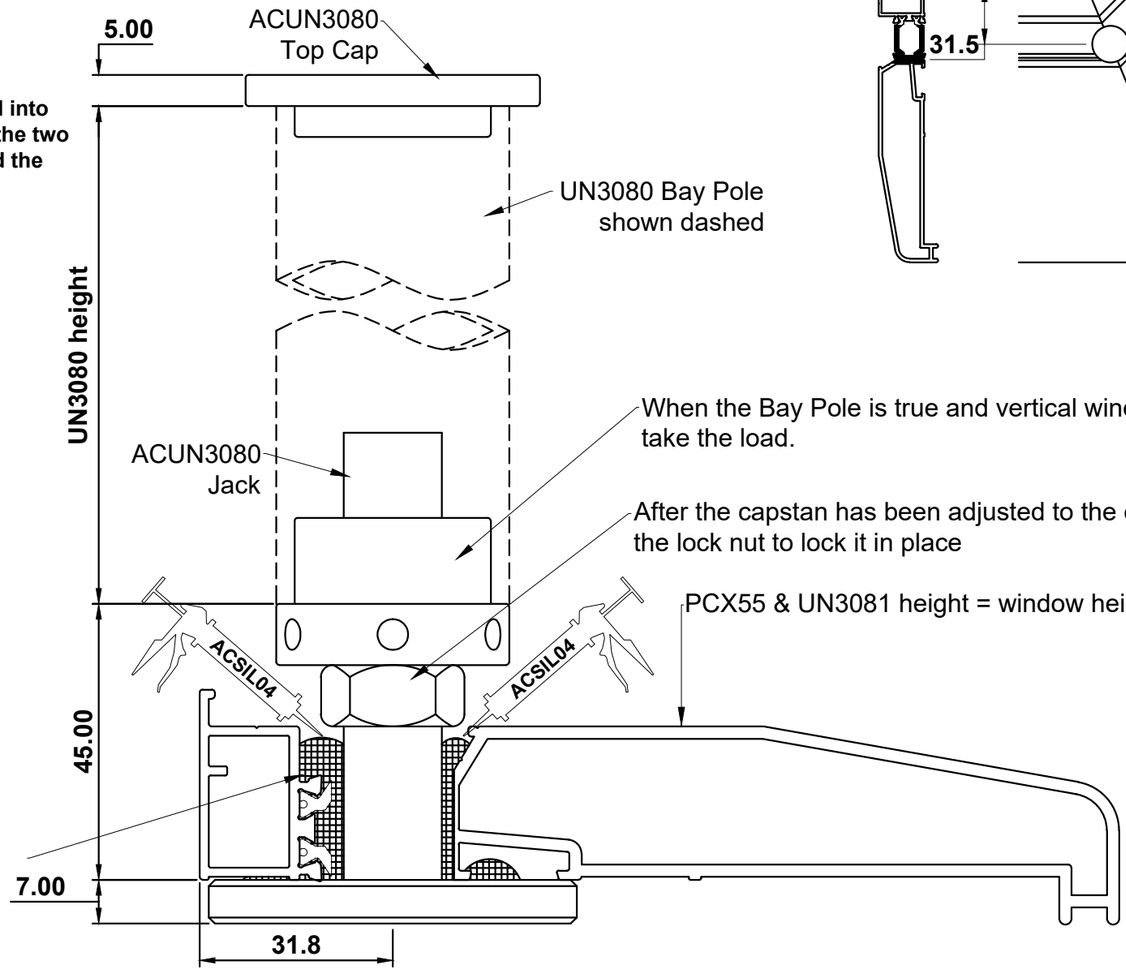


Note: Installation to comply with relevant building regulations and British standards :-

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

NOTE: UN3081 must be slid into the PCX55 before clipping the two halves of the PCX55 around the UN3080 bay pole





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

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

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



Important Note:
All joints must be adequately sealed using ACSIL04

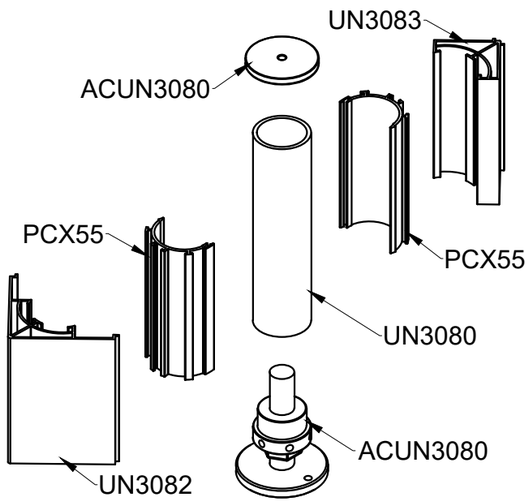
Do Not Scale From This Drawing

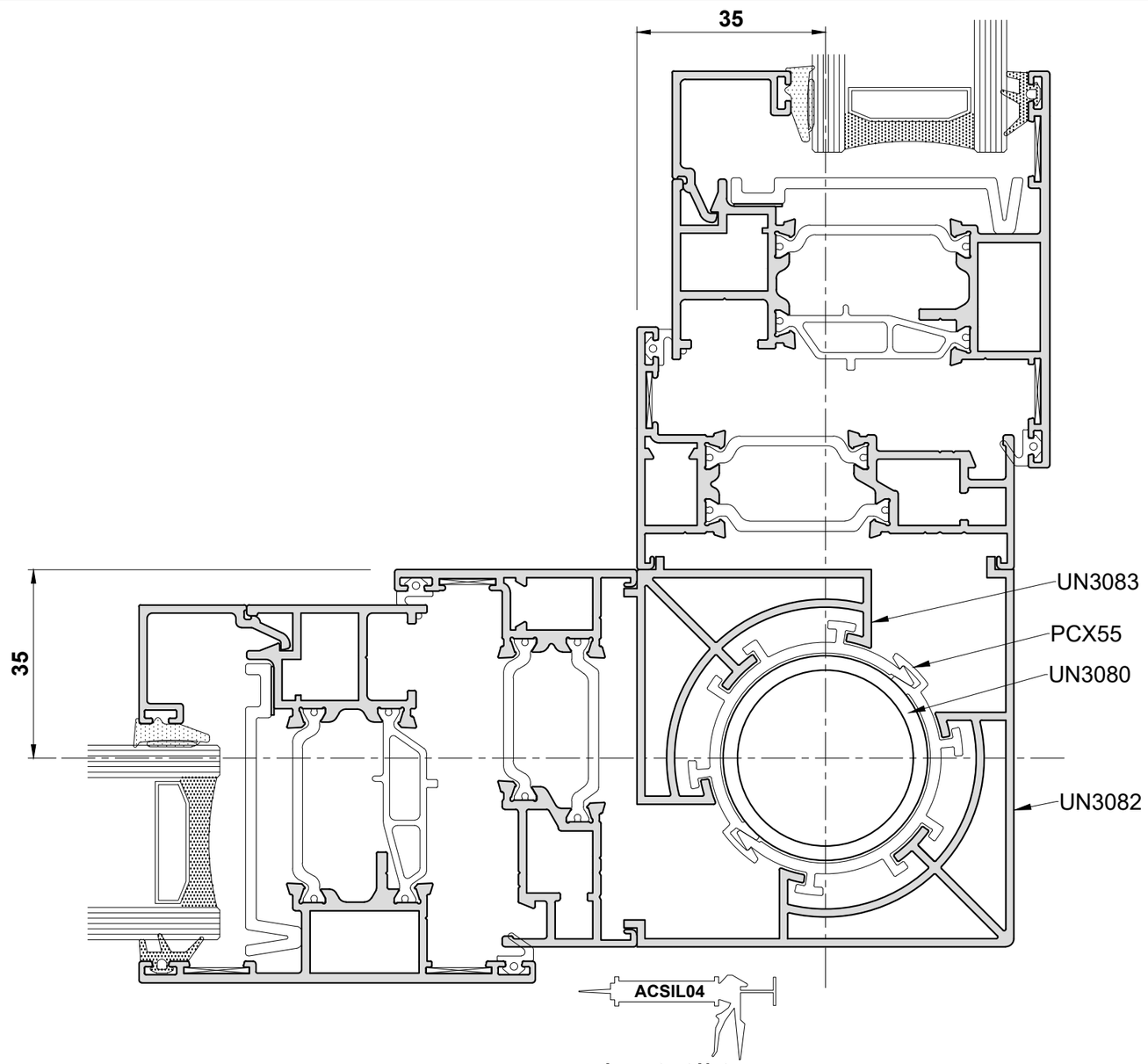
90° Bay Pole

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

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- Approved document A structure.
- Approved document C resistance to the passage of moisture.

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

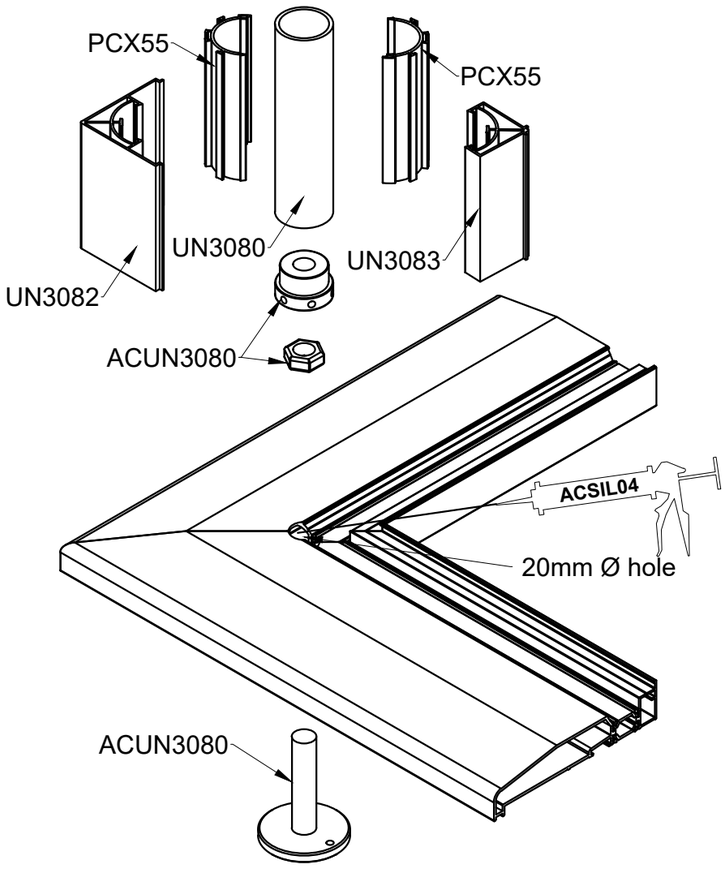




Important Note:
All joints must be adequately sealed using ACSIL04

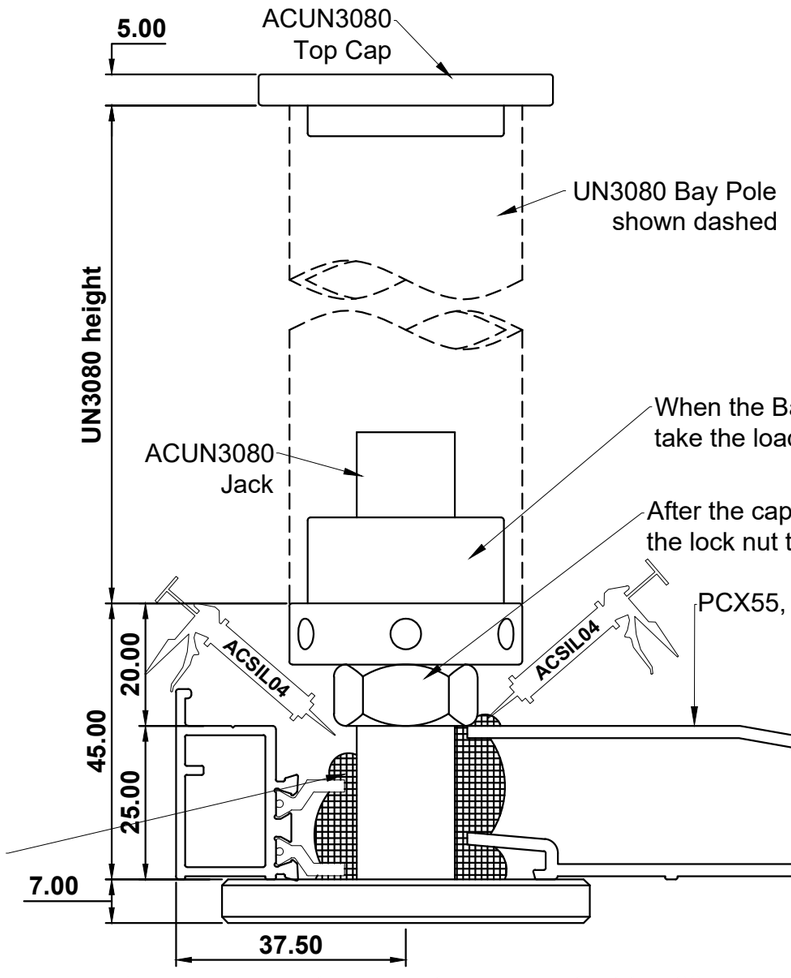
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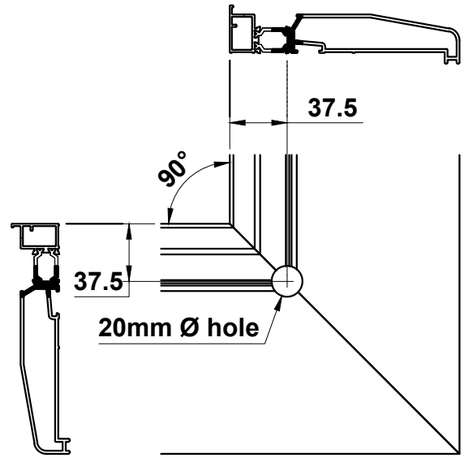
90° Bay Pole



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

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

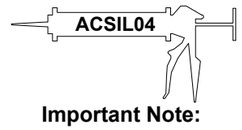




Fully seal between the jack and sub cill with ACSIL04 so that water is not able to track through the 20mm hole.

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

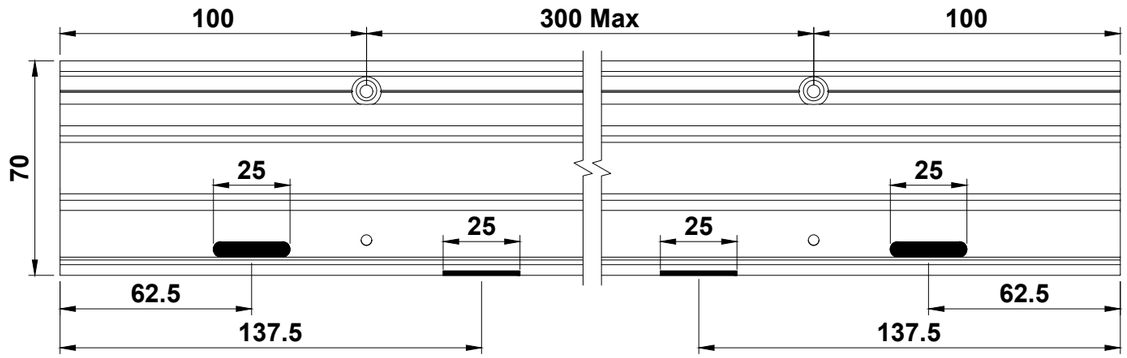
Remove old mortar under the jack so that the 60mm base rests on a sound and level surface. When required use spreader plate under the jack and above the top cap.

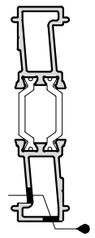


Important Note:
All joints must be adequately sealed using ACSIL04

Do Not Scale From This Drawing

Horizontal Coupler Details

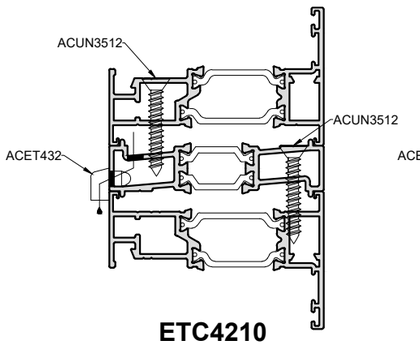




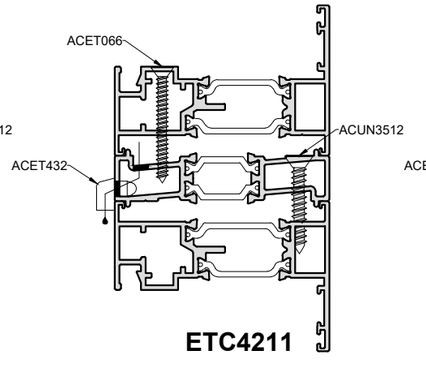
UN3000

Important Note: Seal all joints to UN3000 using ACSIL04.

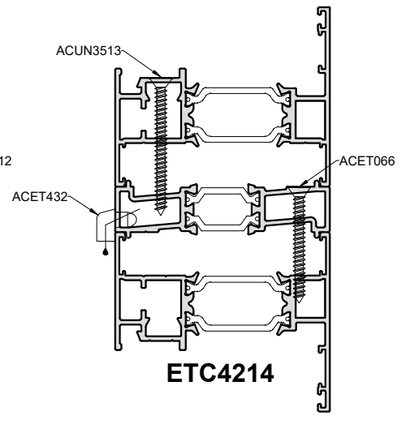




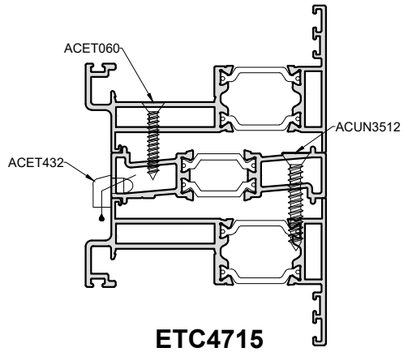
ETC4210



ETC4211

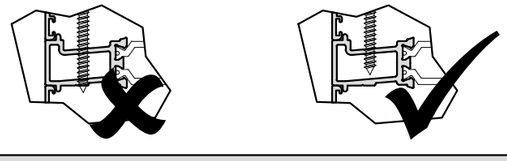


ETC4214



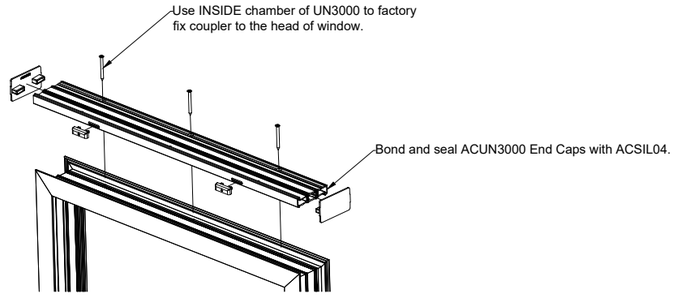
ETC4715

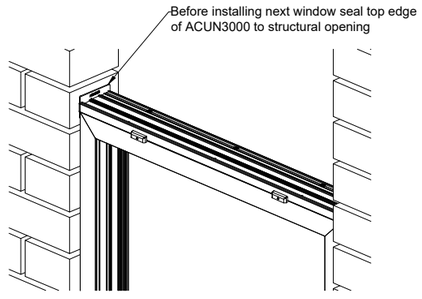
Important Note: Do not screw through drainage channel.

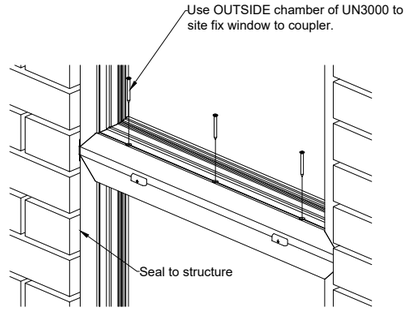


Zone Drainage of Jamb Cavity

CWCT Built up wall guidance recommends drainage of Jamb Cavity







Do Not Scale From This Drawing

Do Not Scale From This Drawing

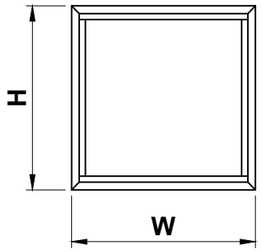
Section F

F | ETC Sawing Tables F03-12

Section F

Alitherm 400 HD Window

Cutting Information



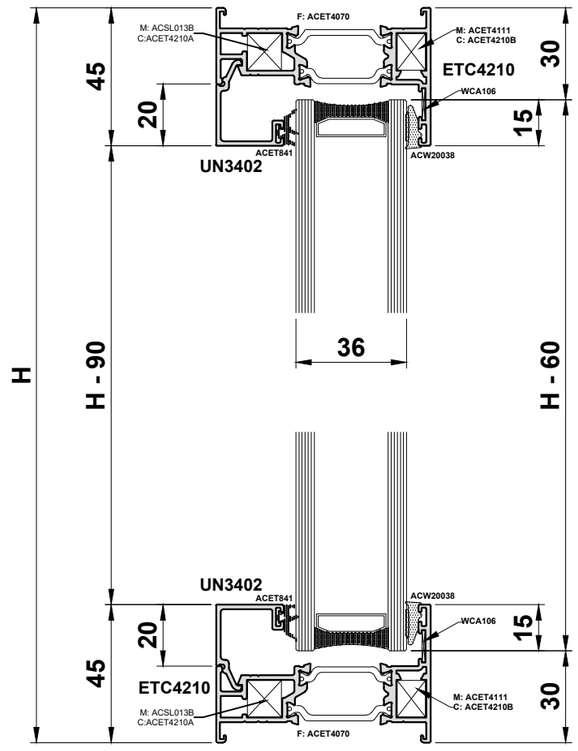
GLASS
W - 60 X H - 60

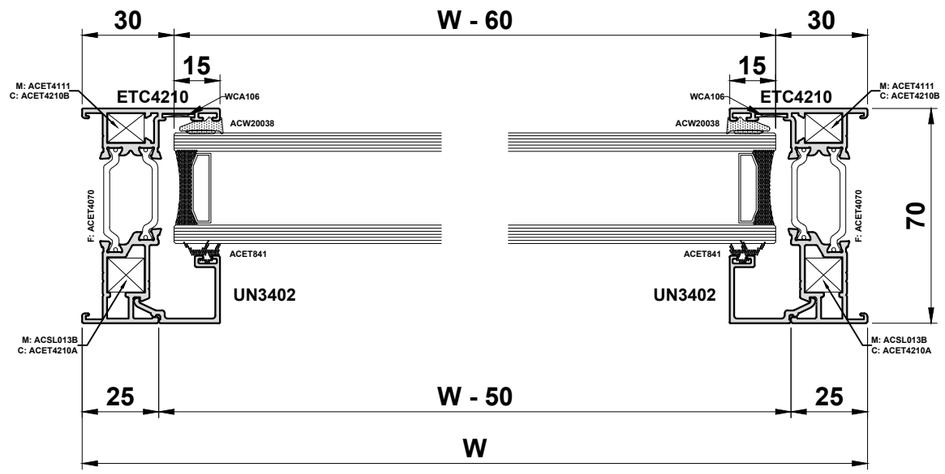
PROFILES

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

ACCESSORIES

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

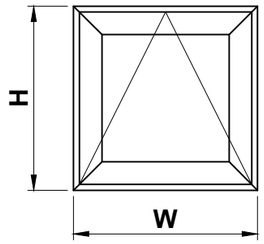




Do Not Scale From This Drawing

Alitherm 400 HD Window

Cutting Information



GLASS
W - 155 X H - 155

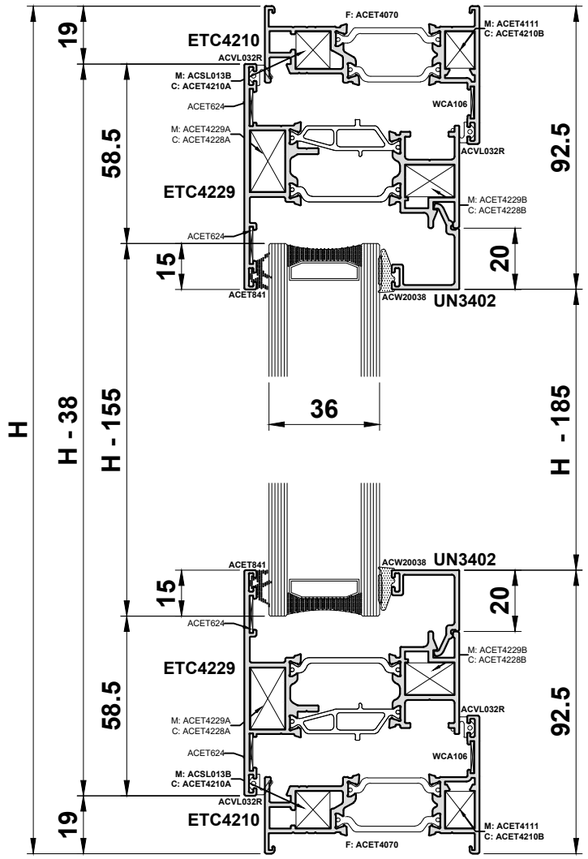
PROFILES

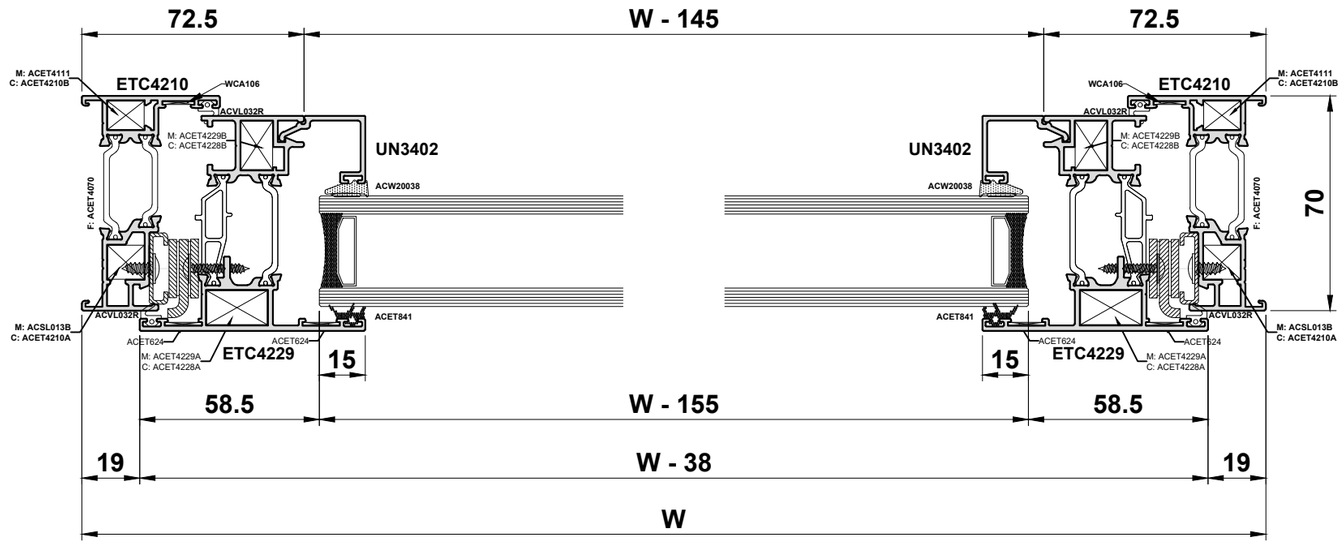
ETC4210	2		W
ETC4210	2		H
ETC4229	2		W - 38
ETC4229	2		H - 38
BEAD	2		W - 145
BEAD	2		H - 185

ACCESSORIES

ACET4210A	4	Cleat - Outerframe
ACET4210B	4	Cleat - Outerframe
WCA106	4	Chevron - Outerframe
ACET4228A	4	Cleat - Sash
ACET4228B	4	Cleat - Sash
ACET624	8	Chevron - Sash
ACVL032R	4 (W+H)	Flipper Seal
ACET841	2 (W+H)	E Gasket
ACW20038	2 (W+H)	Wedge Gasket
ACVG560	2 (W+H)-20	Polyamide Foam
ACET4070	2 (W+H)	Cavity Foam
ACET4282	2 (W+H)-95	Sash Polyamide Foam
ACET4081	2 (W+H)-130	Glazing Perimeter Foam

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



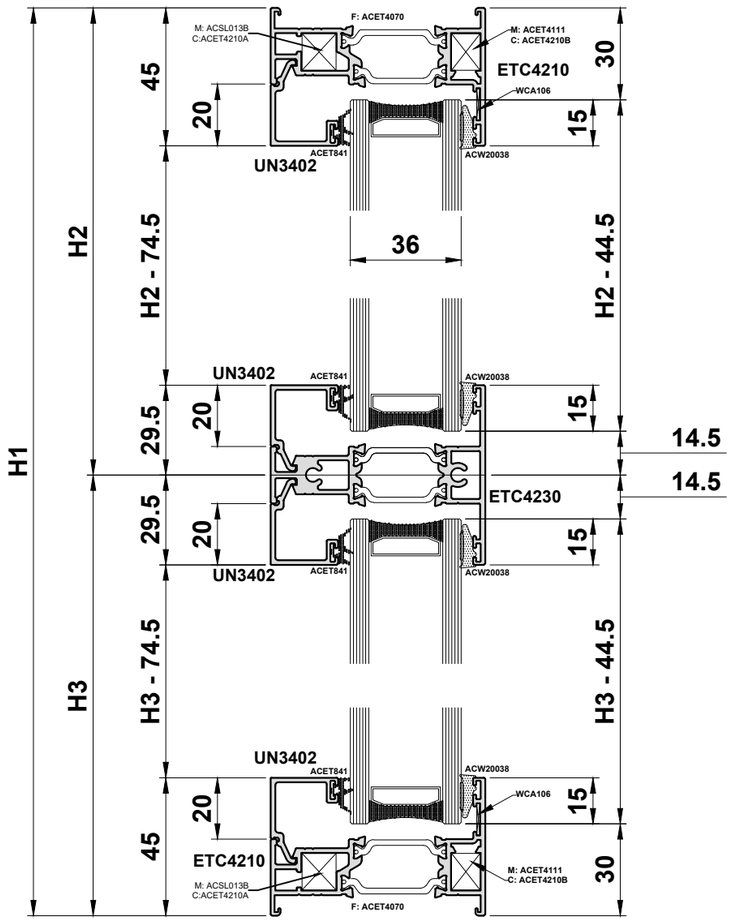


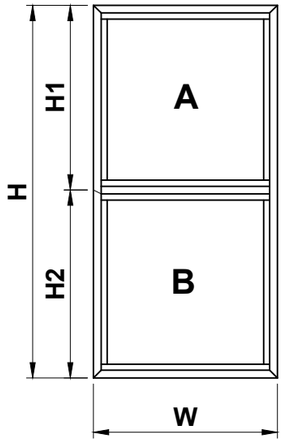
Do Not Scale From This Drawing

Alitherm 400 HD Window

SAWING TABLES : OPEN OUT

Cutting Information





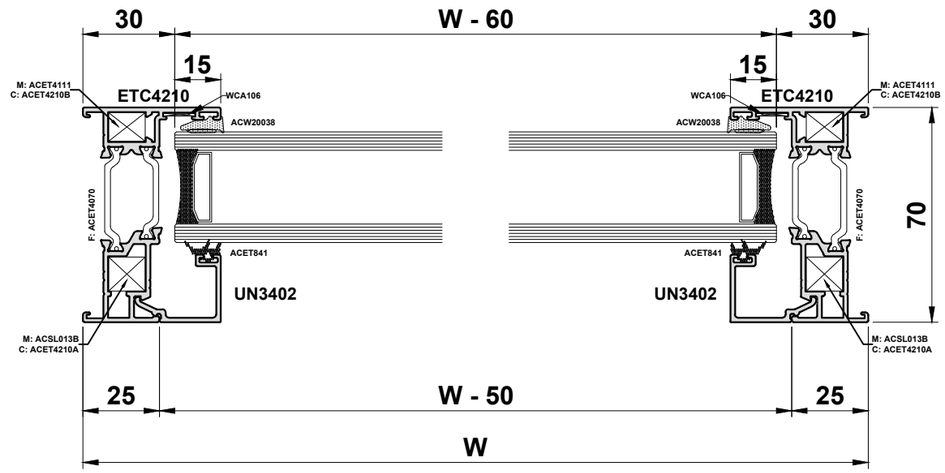
GLASS	
A	W - 60 X H2 - 44.5
B	W - 60 X H3 - 44.5

PROFILES

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

ACCESSORIES

ACET4210A	4	Cleat - Outerframe
ACET4210B	4	Cleat - Outerframe
WCA106	4	Chevron - Outerframe
ACIM062	4	Transom Screws
ACET841	2 (W+H)	E Gasket
ACW20038	2 (W+H)	Wedge Gasket
ACVG560	2 (W+H)-20	Polyamide Foam
ACVG560	2 W-50	Transom Polyamide Foam
ACET4070	2 (W+H)	Cavity Foam
ACET4282	2 (W+H)-95	Sash Polyamide Foam
ACET4081	2 (W+H)-130	Glazing Perimeter Foam

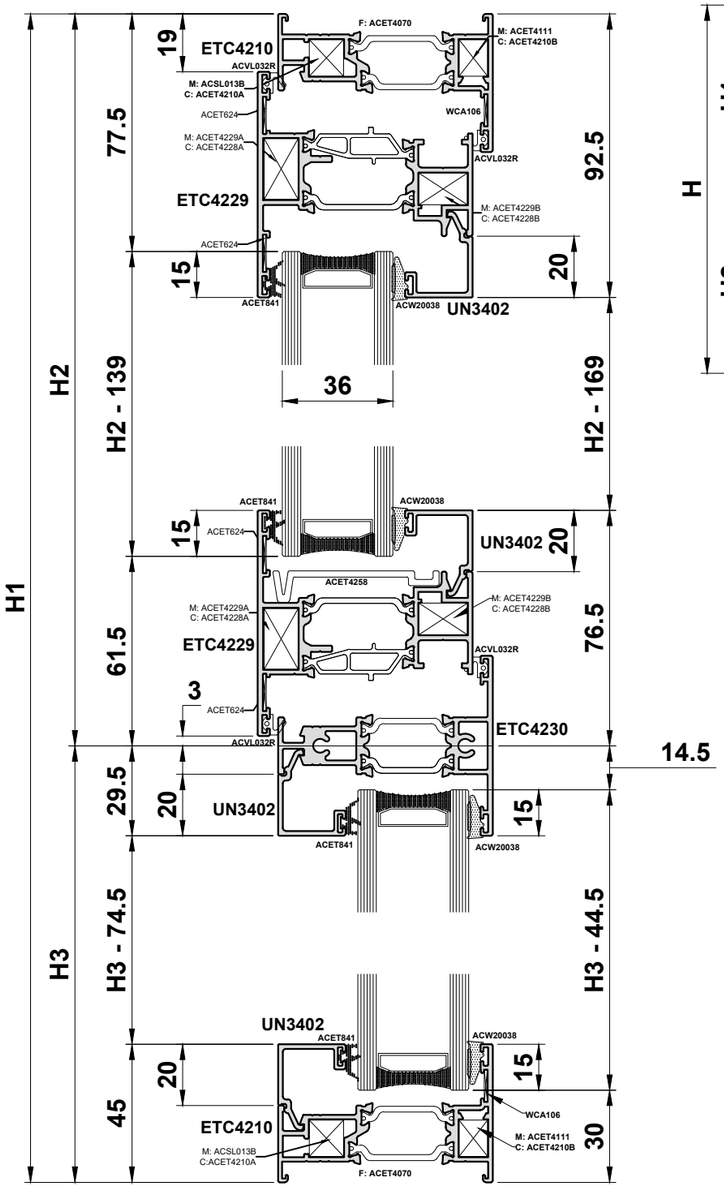


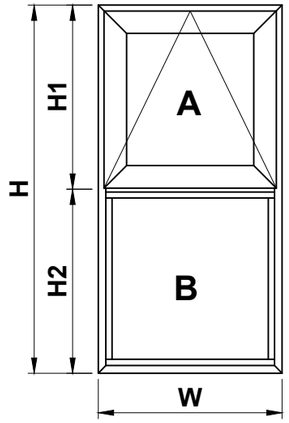
Do Not Scale From This Drawing

Alitherm 400 HD Window

SAWING TABLES : OPEN OUT

Cutting Information





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

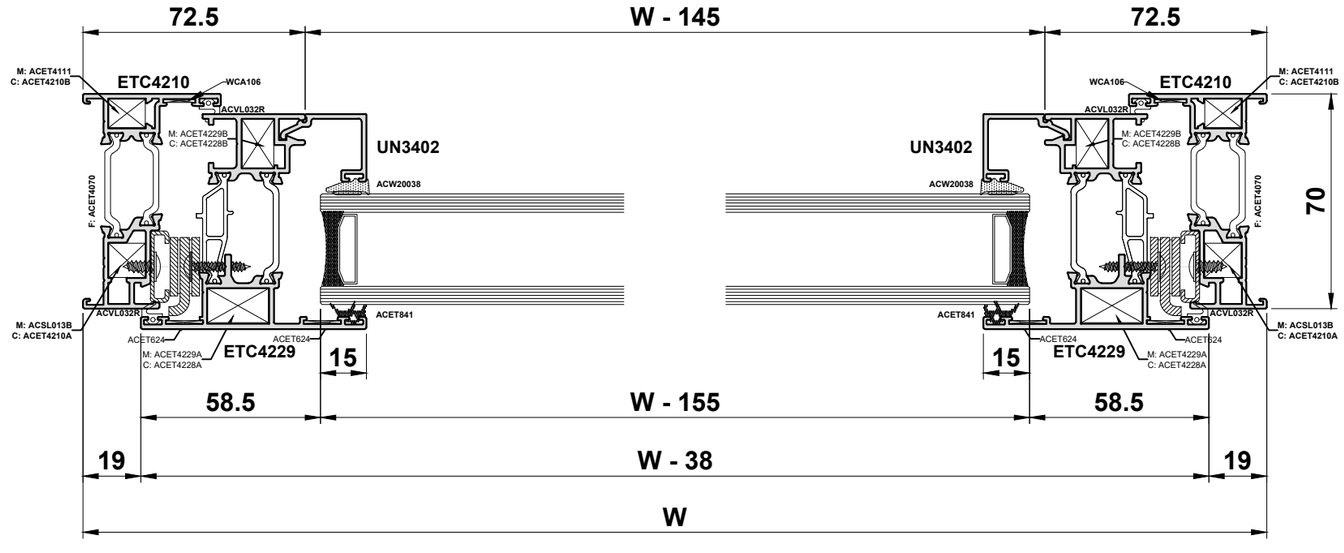
PROFILES

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

ACCESSORIES

ACET4210A	4	Cleat - Outerframe
ACET4210B	4	Cleat - Outerframe
WCA106	4	Chevron - Outerframe
ACIM062	4	Transom Screws
ACET4228A	4	Cleat - Sash
ACET4228B	4	Cleat - Sash
ACET624	8	Chevron - Sash
ACET841	2 (W+H)	E Gasket
ACW20038	2 (W+H)	Wedge Gasket
ACVG560	2 (W+H)-20	Polyamide Foam
ACVG560	2 W-50	Transom Polyamide Foam
ACET4070	2 (W+H)	Cavity Foam
ACET4282	2 (W+H)-95	Sash Polyamide Foam
ACET4081	2 (W+H)-130	Glazing Perimeter Foam

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

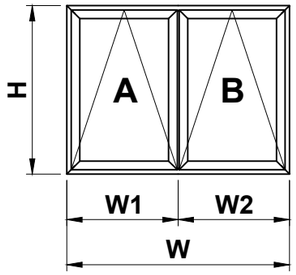


Do Not Scale From This Drawing

ISSUED: MAY 2026

Alitherm 400 HD Window

Cutting Information



GLASS	
A	W2 - 139 X H - 155
B	W3 - 139 X H - 155

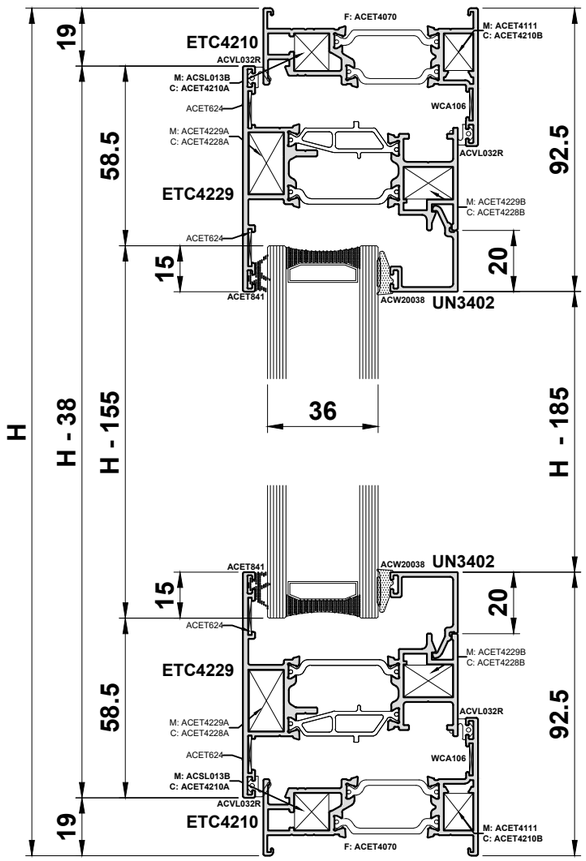
PROFILES

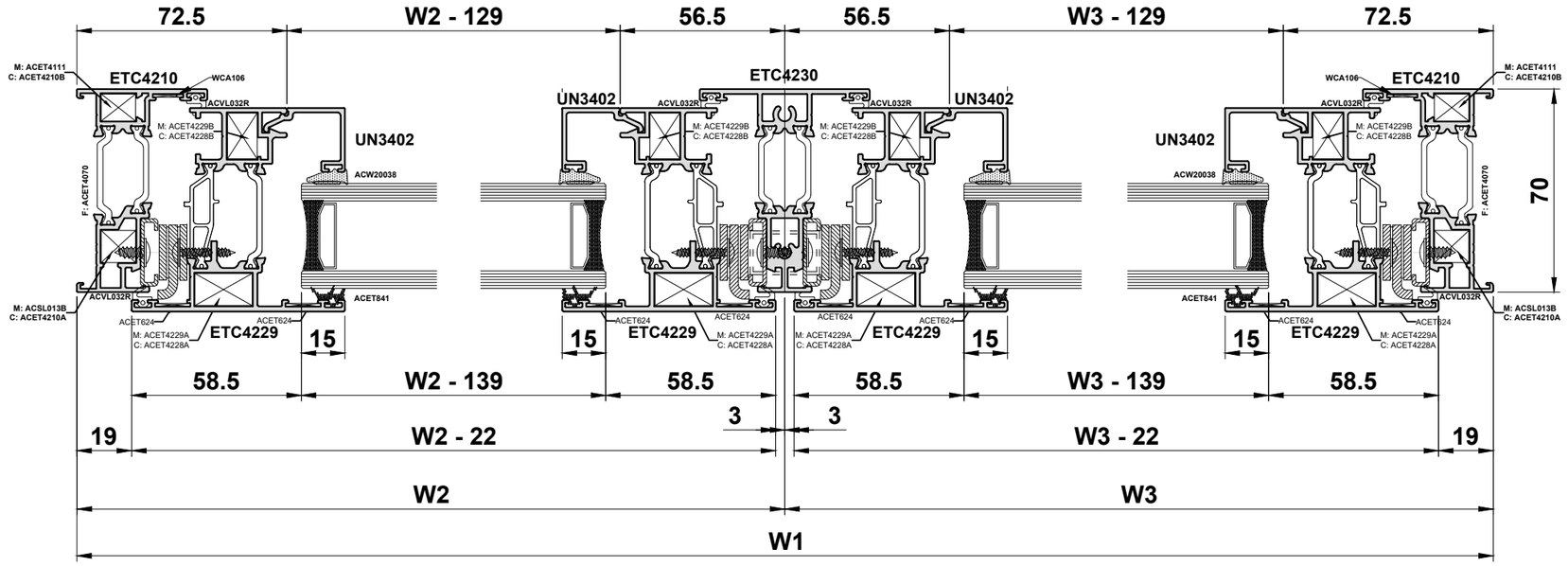
ETC4210	2		W
ETC4210	2		H
ETC4229	2		W2 - 22
ETC4229	2		W3 - 22
ETC4229	4		H - 38
ETC4230	1		H - 50
UN3402	2		W2 - 129
UN3402	2		W3 - 129
UN3402	4		H - 185

ACCESSORIES

ACET4210A	4	Cleat - Outerframe
ACET4210B	4	Cleat - Outerframe
WCA106	4	Chevron - Outerframe
ACET4228A	8	Cleat - Sash
ACET4228B	8	Cleat - Sash
ACET624	16	Chevron - Sash
ACVL032R	(4W) + (8H)	Flipper Seal
ACET841	(2W) + (4H)	E Gasket
ACW20038	(2W) + (4H)	Wedge Gasket
ACVG560	2 (W+H)-20	Polyamide Foam
ACVG560	2 W-50	Mullion Polyamide Foam
ACET4070	2 (W+H)	Cavity Foam
ACET4282	2 (W+H)-95	Sash Polyamide Foam
ACET4081	2 (W+H)-130	Glazing Perimeter Foam

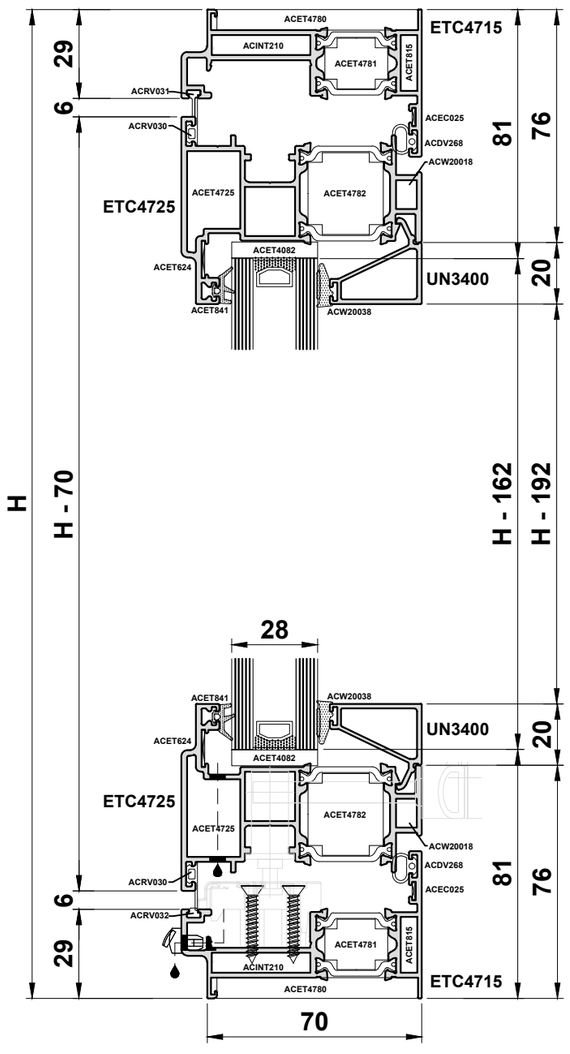
Note: Friction Hinges, Locking & Handles not shown.
Please select preferred options from Section B.





Do Not Scale From This Drawing

Cutting Information



PROFILES

ETC4715	2		W
ETC4715	2		H
ETC4725	2		W - 70
ETC4725	2		H - 70
BEAD	2		W - 152
BEAD	2		H - 192

GLASS
W - 162 X H - 162

ACCESSORIES

ACET815	4	Cleat - Outerframe
ACINT210	4	Cleat - Outerframe
ACEC025	4	Chevron - Outerframe
ACET4725	4	Cleat - Sash
ACW20018	4	Cleat - Sash
ACET624	4	Chevron - Sash
ACET841	2 (W+H)	E Gasket
ACW20038	2 (W+H)	Wedge Gasket
ACET4781	2 (W+H)-18	Polyamide Foam
ACET4780	2 (W+H)	Cavity Foam
ACET4782	2 (W+H)-93	Sash Polyamide Foam
ACET4082	2 (W+H)-151	Glazing Perimeter Foam
ACRV030	2 (W-70)	Sash Gasket
ACRV031	1 (W-58)	Head Gasket
ACRV032	1 W-58 2 H-58	Outer Frame Gasket
ACDV268	2 (W+H) - 96	Outer Frame Gasket
ACGSL045	2	Drainage Cover Caps

LOCKING

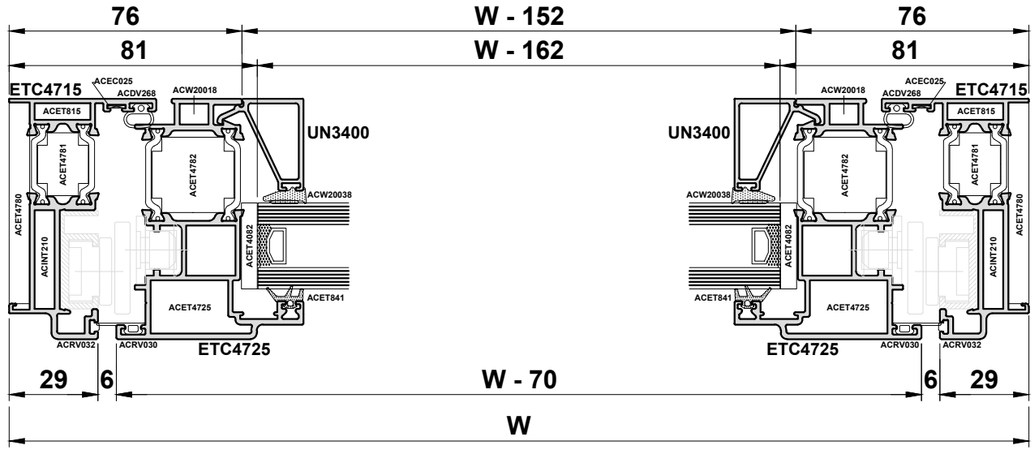
ACET4771-4778	1	Espag Locking Rods
ACET4767	See Section B	Keeps
ACET4762/4763	1	55mm Spindle Handle

REVERSIBLE HARDWARE

777****	1 Pair	Reversible Hinges
777557	1 Pair	Top Glider
777132	1 Pair	Centre Bracket

OPTIONAL REVERSIBLE HARDWARE

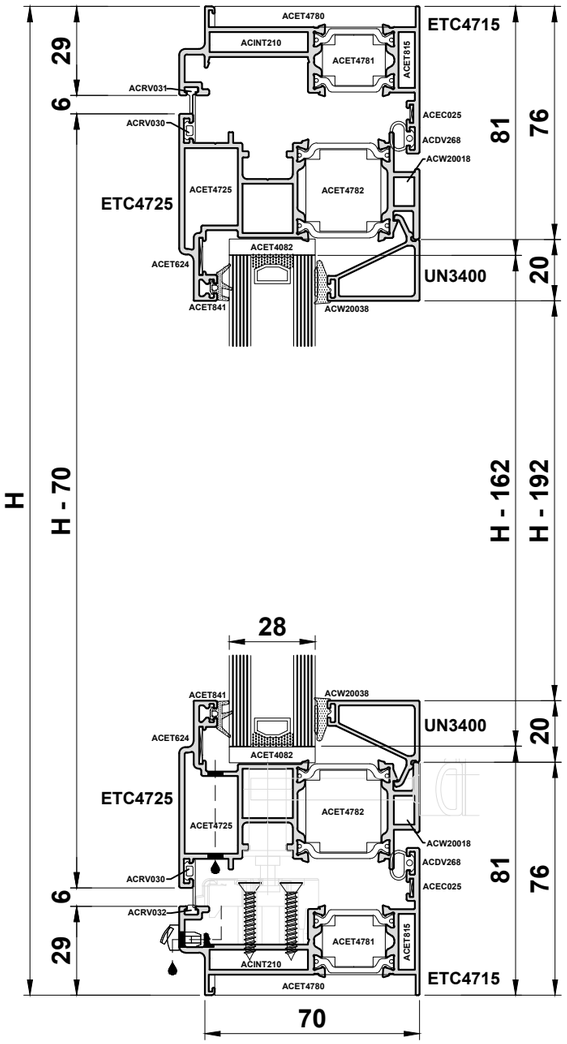
777554	2	Stop Block
777525	2	Guide Block
777573	2	Blocking Device



Do Not Scale From This Drawing

Alitherm 400 HD Window

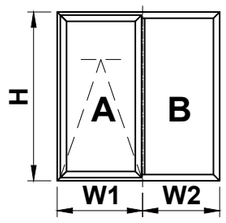
Cutting Information



PROFILES

ETC4715	2		W
ETC4715	2		H
ETC4725	2		W1 - 61
ETC4725	2		H - 70
BEAD	2		W1 - 143
BEAD	2		H - 192
ETC4730	1		H - 58
ETC770	2		W2 - 23.5
ETC770	2		H - 58
ETC771	2		W2 - 49
ETC771	2		H - 59

GLASS	
A	W1 - 153 X H - 162
B	W2 - 57 X H - 66



ACCESSORIES

ACET815	4	Cleat - Outerframe
ACINT210	4	Cleat - Outerframe
ACEC025	4	Chevron - Outerframe
ACET4725	4	Cleat - Sash
ACW20018	4	Cleat - Sash
ACET624	4	Chevron - Sash
ACET841	2 (W1+H)	E Gasket
ACW20038	2 (W+H)	Wedge Gasket
ACET4781	2 (W+H)-18	Polyamide Foam
ACET4780	2 (W+H)	Cavity Foam
ACET4782	2 W1-84 2 H-93	Sash Polyamide Foam
ACET4783	1 H-58	Mullion Polyamide Foam
ACET4082	2 (W+H)-151	Glazing Perimeter Foam
ACRV030	2 (W1-70)	Sash Gasket
ACRV031	1 (W1-58)	Head Gasket
ACRV032	1 W1-58 2 H-58	Outer Frame Gasket
ACDV268	2 (W1+H) - 96	Outer Frame Gasket
ACGSL045	2	Drainage Cover Caps
ACET062	4	ETC4730 Screws
ACET845	2 (W2+H)	Bead E Gasket

LOCKING

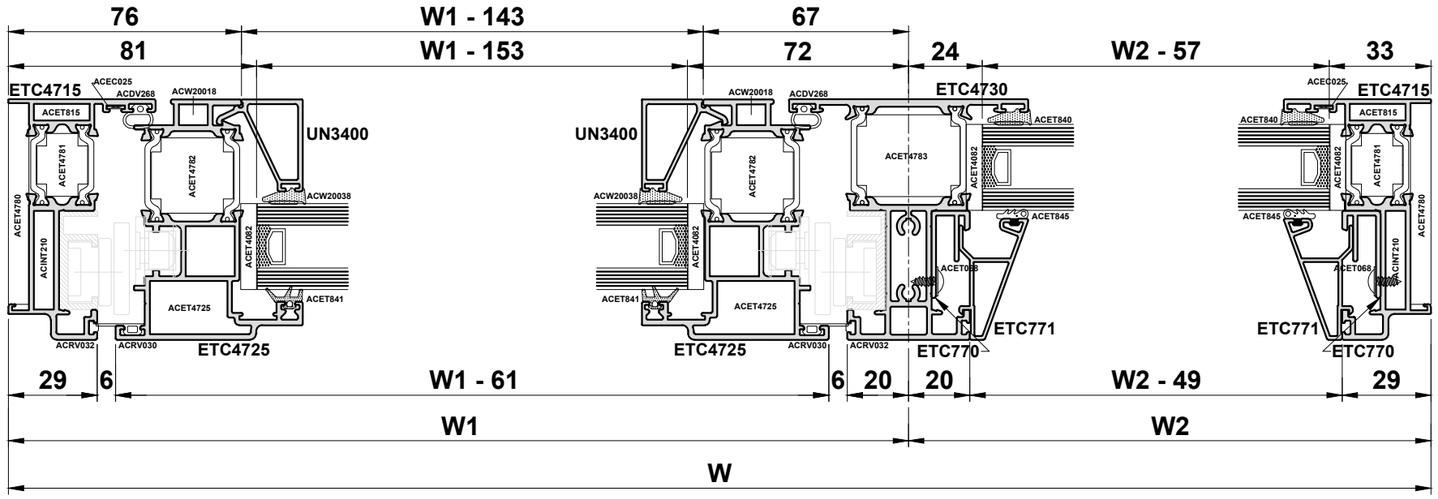
ACET4771-4778	1	Espag Locking Rods
ACET4767	See Section B	Keeps
ACET4762/4763	1	55mm Spindle Handle

REVERSIBLE HARDWARE

777****	1 Pair	Reversible Hinges
777557	1 Pair	Top Glider
777132	1 Pair	Centre Bracket

OPTIONAL REVERSIBLE HARDWARE

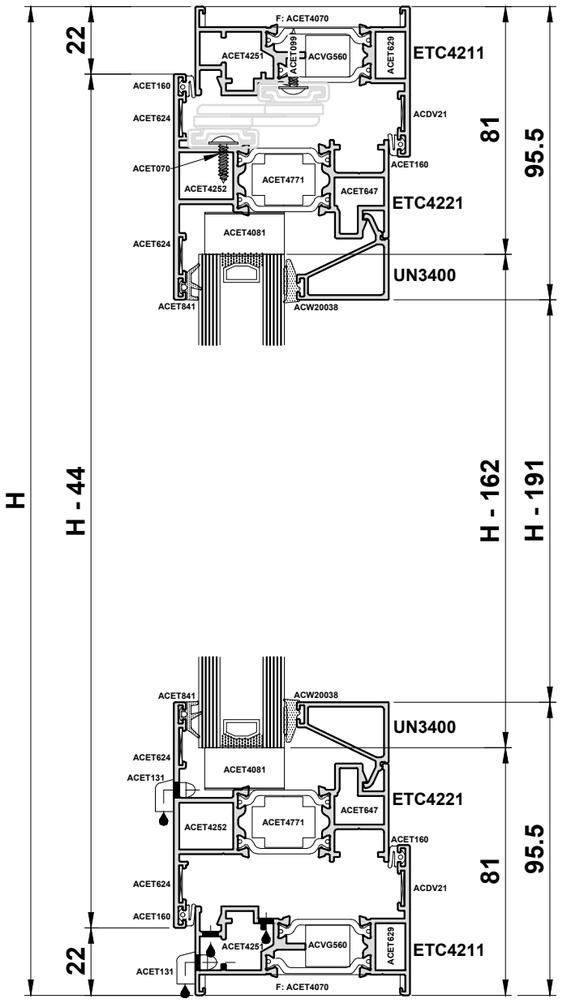
777554	2	Stop Block
777525	2	Guide Block
777573	2	Blocking Device



Do Not Scale From This Drawing

Alitherm 400 HD Window

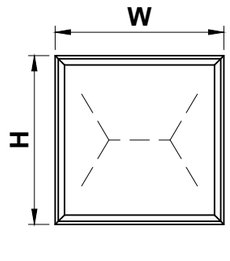
Cutting Information



PROFILES

ETC4211	2		W
ETC4211	2		H
ETC4221	2		W - 44
ETC4221	2		H - 44
BEAD	2		W - 151
BEAD	2		H - 191

GLASS
W - 162 X H - 162



ACCESSORIES

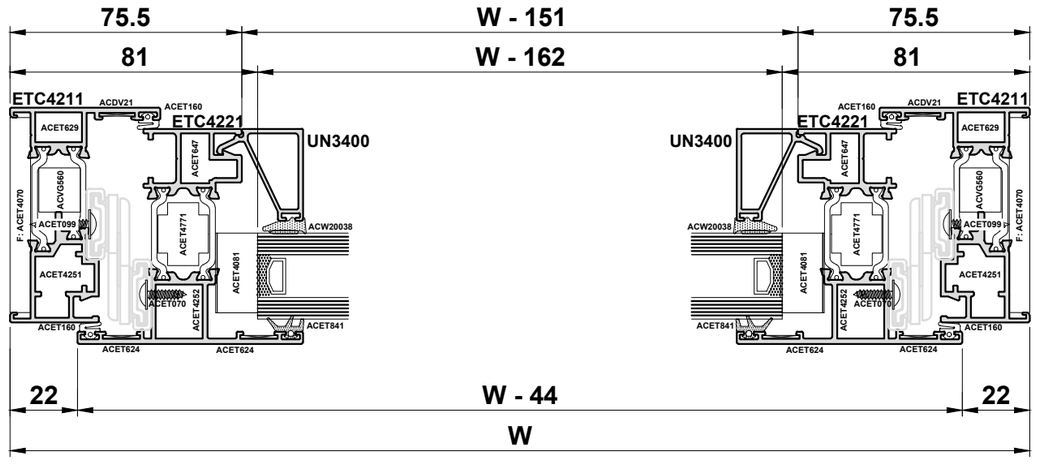
ACET4251	4	Cleat - Outerframe
ACET629	4	Cleat - Outerframe
ACDV21	4	Chevron - Outerframe
ACET4252	4	Cleat - Sash
ACET647	4	Cleat - Sash
ACET624	8	Chevron - Sash
ACET841	2 (W+H)	E Gasket
ACW20038	2 (W+H)	Wedge Gasket
ACVG560	2 (W+H)-19	Polyamide Foam
ACET4070	2 (W+H)	Cavity Foam
ACET4281	2 (W+H)-93	Sash Polyamide Foam
ACET4081	2 (W+H)-134	Glazing Perimeter Foam
ACET160	2 (W+H)-44	Sash Gasket
ACET160	2 (W+H)-98	Outer Frame Gasket
ACET131	4	Drainage Cover Caps

LOCKING

ACET710	2	Basic Locking Kit
ACET71*	4	Espag Locking Rods
ACET460/465	2	9mm Spindle Handle

PARALLEL HARDWARE

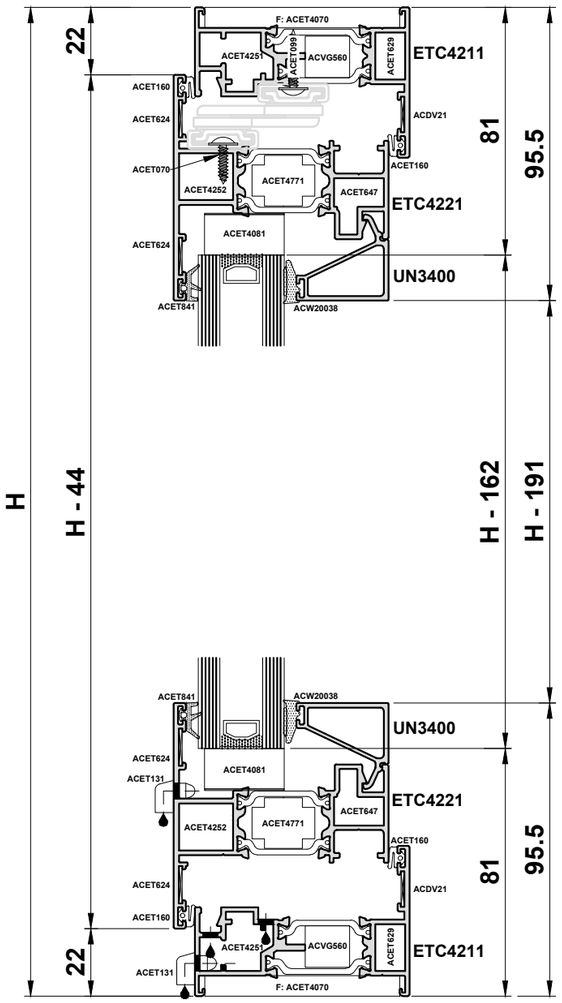
ACETPPS*	1	Control Stay
ACETPPS*	1 Pair	Side Stays
ACETPPS*	1 Pair	150mm Restrictor



Do Not Scale From This Drawing

Alitherm 400 HD Window

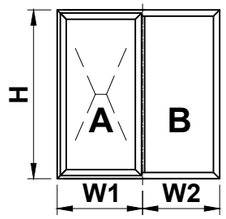
Cutting Information



PROFILES

ETC4211	2		W
ETC4211	2		H
ETC4221	2		W - 44
ETC4221	2		H - 44
ETC4238	1		H - 58
BEAD	2		W1 - 134.5
BEAD	2		H - 191
BEAD	2		W2 - 42
BEAD	2		H - 98

GLASS	
A	W1 - 145.5 X H - 162
B	W2 - 52 X H - 68



ACCESSORIES

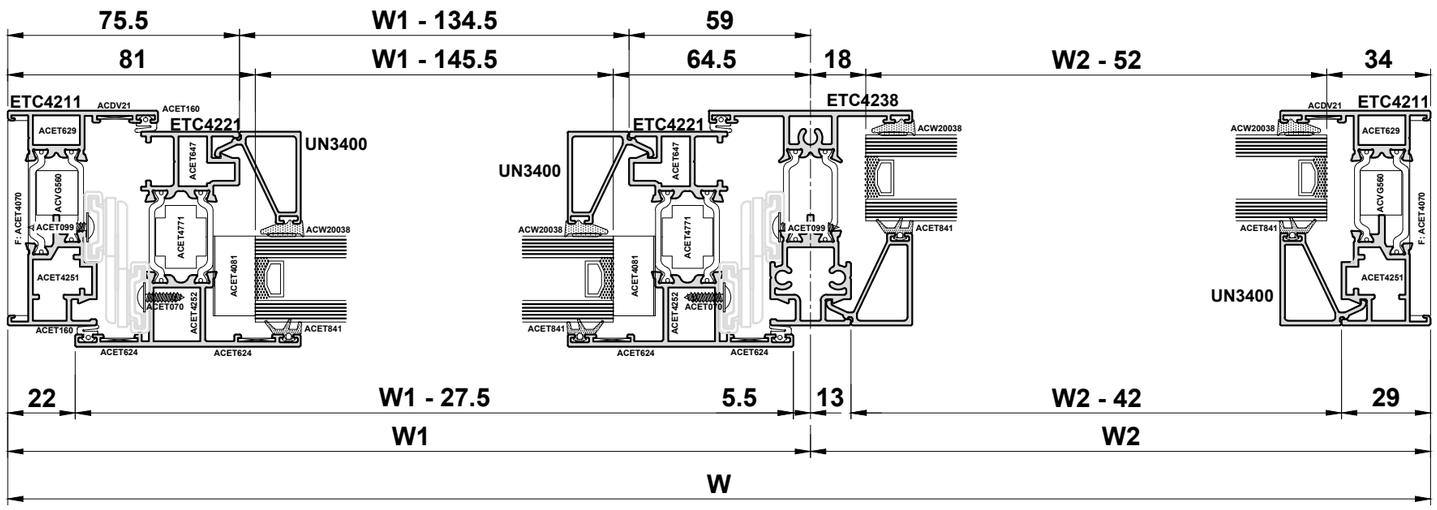
ACET4251	4	Cleat - Outerframe
ACET629	4	Cleat - Outerframe
ACDV21	4	Chevron - Outerframe
ACET4252	4	Cleat - Sash
ACET647	4	Cleat - Sash
ACET624	8	Chevron - Sash
ACET841	4 (W+H)	E Gasket
ACW20038	4 (W+H)	Wedge Gasket
ACVG560	2 (W+H)-19	Polyamide Foam
ACET4070	2 (W+H)	Cavity Foam
ACET4281	2 (W+H)-93	Sash Polyamide Foam
ACET4081	2 (W1- 27 + H)-134	Glazing Perimeter Foam
ACET160	2 (W1+H)-44	Sash Gasket
ACET160	2 (W1+H)-98	Outer Frame Gasket
ACET131	4	Drainage Cover Caps

LOCKING

ACET710	2	Basic Locking Kit
ACET71*	4	Espag Locking Rods
ACET460/465	2	9mm Spindle Handle

PARALLEL HARDWARE

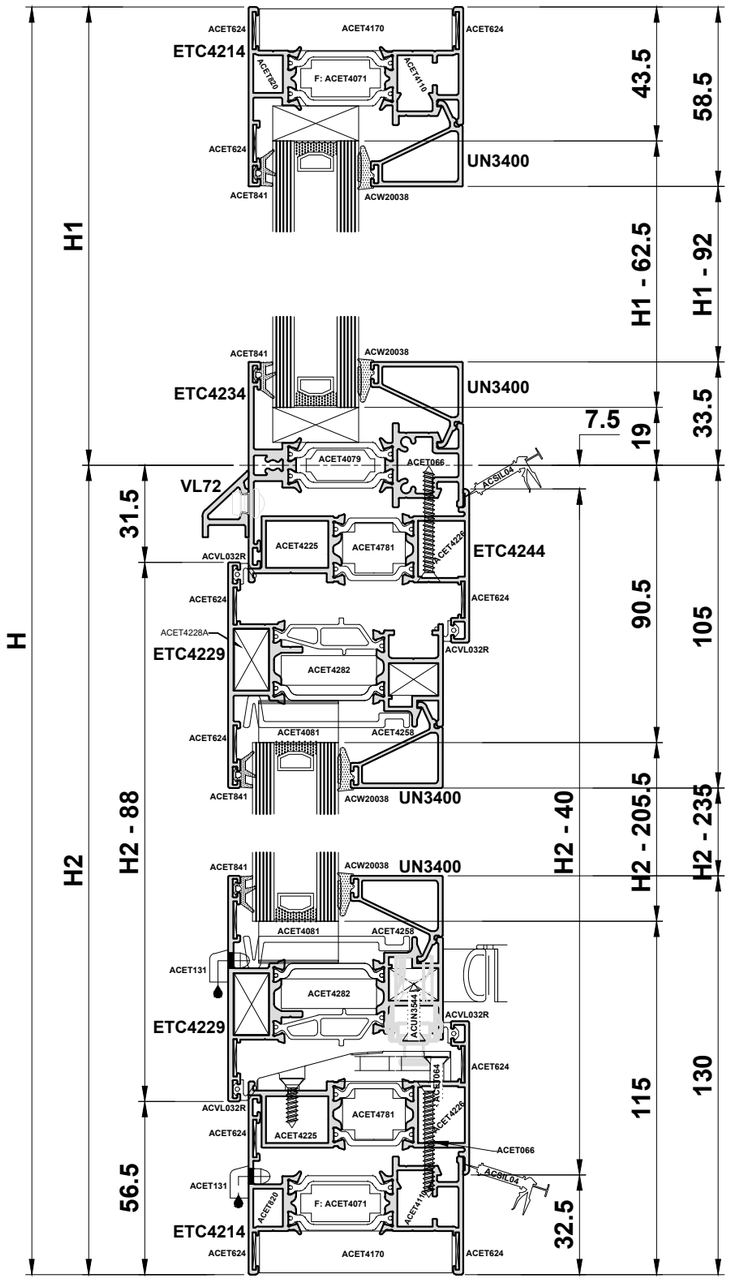
ACETPPS*	1	Control Stay
ACETPPS*	1 Pair	Side Stays
ACETPPS*	1 Pair	150mm Restrictor



Do Not Scale From This Drawing

Alitherm 400 HD Window

Cutting Information



PROFILES

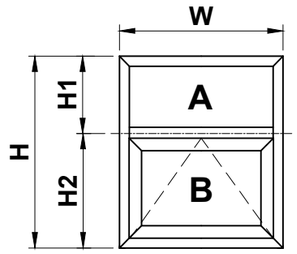
ETC4214	2		W
ETC4214	2		H
ETC4229	2		W - 113
ETC4229	2		H2 - 88
ETC4234	1		W - 77
ETC4244	2		W - 65
ETC4224	2		H2 - 40
BEAD	2		W - 77
BEAD	2		H1 - 62.5
BEAD	2		W - 220
BEAD	2		H2 - 235
VL72	1		W - 9

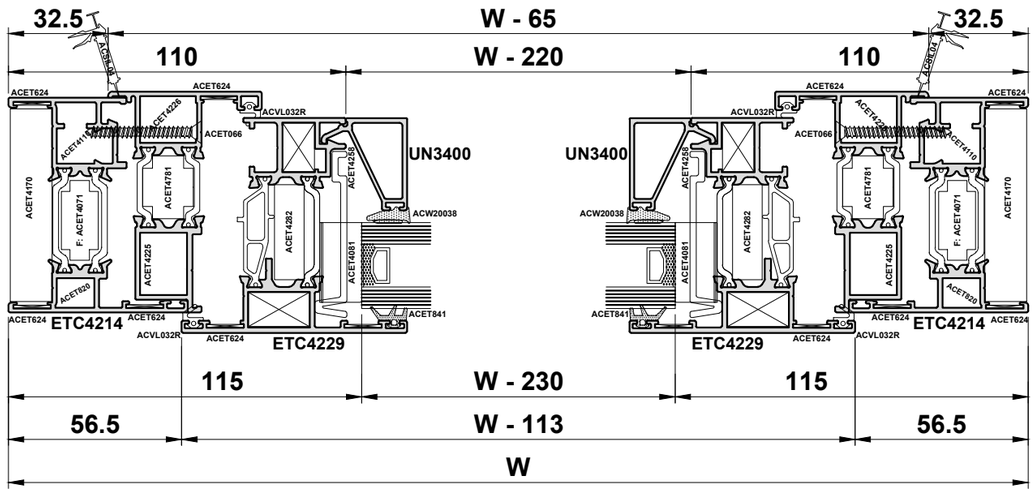
GLASS	
A	W - 87 X H1 - 62.5
B	W - 230 X H2 - 205.5

ACCESSORIES

ACET4110	4	Cleat - Outerframe
ACET820	4	Cleat - Outerframe
ACET624	24	Chevron
ACET066	6	Transom Screws
ACET066	8 + 1 at 300mm centres	Transom Screws
ACET131	4	Drainage Cover Caps
ACET841	4 (W+H)	E Gasket
ACW20038	4 (W+H)	Wedge Gasket
ACET4071	2 (W+H)-32	O/F Polyamide Foam
ACET4282	2 (W+H)-172	Sash Polyamide Foam
ACET4079	1 W-77	Transom Polyamide Foam
ACET4081	2 (W+H)-203	Glazing Perimeter Foam
ACET4170	2 (W+H)	Cavity Foam
ACET4225	4	Cleat - ETC4244
ACET4226	4	Cleat - ETC4244
ACET4228A	4	Cleat - Sash
ACET4228B	4	Cleat - Sash
ACET4258	8	Bridge Packer
ACET4781	2 (W+H)-87	ETC4244 Polyamide Foam
ACVL059	1 Pair	VL72 End Caps
ACVL061	W/300 + 2	VL72 Rivets

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





Do Not Scale From This Drawing