

STEEL

Est. 1982

THERMALLY BROKEN WINDOWS AND DOORS

EBE 75

TECHNICAL CATALOG

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Sistema integrato di profili, accessori e guarnizioni a taglio termico con profili aventi sezione di 73.5 mm, idoneo per la realizzazione di porte e finestre, rettangolari, sagomate o curve con o senza fissi laterali e superiori.
I profili in metallo componenti il sistema sono dello spessore di 15/10 mm e sono ottenuti tramite profilatura a freddo di nastri nei vari materiali previsti dal sistema.
Il taglio termico dei profili è realizzato tramite un estruso in poliammide rinforzato con fibra di vetro reso solidale alle parti in metallo esterne da una resina poliuretanica ad alta densità, iniettata ad alta pressione. Il collegamento che si ottiene è continuo, privo di interruzioni e garantisce la massima resistenza torsionale e flettente.
La costruzione dei telai prevede l'unione tra i profili tramite saldatura in continuo delle sezioni in contatto e la successiva ripresa delle superfici in vista, o l'utilizzo di un sistema misto ad assiemaggio meccanico a saldatura interna che non necessita di riprese di finitura.
Il sistema prevede al possibilità di alloggiare **vetri singoli o stratificati** (di sicurezza) a una o più camere.

Sistema porte:
Complanarità delle ante;
Doppia guarnizione di tenuta per elevate caratteristiche prestazionali e acustiche;
Completa dotazione di accessori negli stessi materiali del profilo;
Cerniere a saldare, ad avvitare e a scomparsa per grandi portate;
Maniglie dedicate nei materiali previsti dal sistema;
Paraspifferi inferiore con guarnizione a pinna.

Sistema finestre:
Complanarità delle ante;
Sistema di guarnizioni a giunto aperto per le massime prestazioni di resistenza all'aria, acqua e vento ed elevati valori di resistenza acustica;
Finestra a due ante con nodo centrale da 107 mm senza l'aggiunta di profili per l'inversione di battuta;
Completa dotazione di accessori:
Ferramenta per apertura ad anta ribalta a scomparsa per portate fino a 130 kg e classe RC3 all'effrazione
Ferramenta per apertura a vasistas per portate fino a 100 kg
Maniglie dedicate nei materiali previsti dal sistema.

Thermally insulated integrated system of profiles, accessories and gaskets *with section of 73.5 mm suitable for rectangular, trapezoidal, arched shaped doors and windows with or without fixed side light.*
The metal profiles *that make up the system are 15/10 mm thick and are obtained from the cold-forming of the coils in the various materials available.*
The profile thermal break *is connected by means of a glass-fibre reinforced, extruded polyamide that becomes one with the external metal parts with the use of a high density polyurethane resin, injected at high pressure. The connection is continuous, without interruptions, guaranteeing maximum resilience to torsional and bending stress.*
The assembly of the frames *requires that the profiles be connected by welding together the sections in contact and then that the visible welds must be ground down neatly and finished, or by combining mechanical assembly and internal welding that does not require the retouching of the finish.*
The system permits to use double or triple thermal insulated glazing with ***single or stratified glass*** *(security glass).*

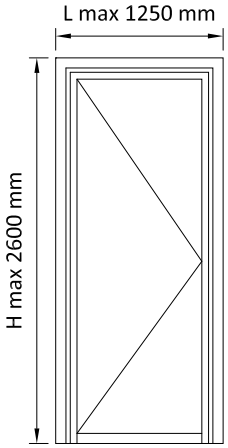
Doors system:
Coplanarity of the doors;
Double sealing gasket for high performance and acoustics;
Complete with accessories in same material as profile;
Hinges to be welded, screwed or concealed for large capacities;
Selection of handles in materials provided for by the system;
Bottom draught excluder with fin gasket.

Windows system:
Coplanarity of the leaves;
System of open joint gaskets for maximum resistance to air, water and wind, as well as high levels of acoustic resistance;
Two-leaved window with 107 mm central section without the addition of profiles for reverting rebate;
All accessories furnished;
Hardware for opening of tilt-and-turn retractable window for capacities up to 130 kg and class RC3 break-in resistance;
Hardware for bottom-hung openings for capacities up to 100 kg;
Handles in the materials provided for by the system.

PRESTAZIONI
Sistema finestre
Trasmittanza termica (UNI EN 10077-2)
-Nodo tipo (acciaio inox) con U_f=2,1 W/m^{2}K
-Finestra tipo (1230x1480 mm con U_g1,0) U_W=1,5 W/m^{2}K
Isolamento acustico (UNI EN 717-1)
-Fino a 47 dB
Resistenza all'aria (UNI EN 12207)
-Classe 4
Resistenza all'acqua (UNI EN 12208)
-Classe 9A
Resistenza al vento (UNI EN 12210)
-Classe C5
Resistenza alla forza di azionamento (UNI EN 13115)
-Classe 1 - < 100 N
Prova carico verticale e torsione statica (UNI EN 13115)
-Classe 4 - 800 N / 350 N
Prova di durata a cicli di apertura (UNI EN 12400)
-Classe 2 - 10.000 cicli
Resistenza della giunzione a taglio temico (EN14024)
-Classe CW / TC2

PERFORMANCES
Windows system
Thermal trasmittance (UNI EN 10077-2)
-Typical section (stainless steel) with U_f=2,1 W/m^{2}K
-Typical window (1230x1480 mm with U_g1,0) U_W=1,5 W/m^{2}K
Acoustic performance (UNI EN 717-1)
-Up to 47 dB
Air permeability (UNI EN 12207)
-Class 4
Watertightness (UNI EN 12208)
-Class 9A
Resistance to wind load (UNI EN 12210)
-Class C5
Operating forces (UNI EN 13115)
-Classe 1 - < 100 N
Mechanical properties (UNI EN 13115)
-Classe 4 - 800 N / 350 N
Resistance to repeated opening and closing (UNI EN 12400)
-Class 2 - 10 000 opening and closing movements
Thermal break resistance of joint (EN12024)
-Class CW / TC2

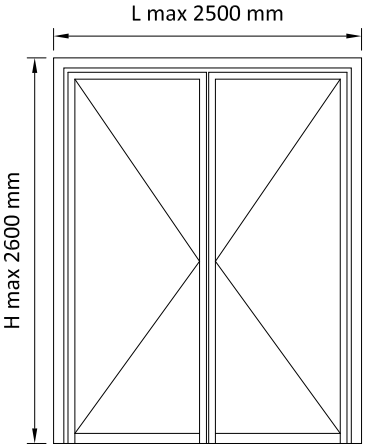
Limiti dimensionali - *Maximum dimension*



porta ad un anta
one-leaf doors

peso massimo anta*
*maximum leaf weight**

AC1033 - 150 kg
AC1037 - 250 kg
AC1068 - 180 kg
AC6023 - 200 kg



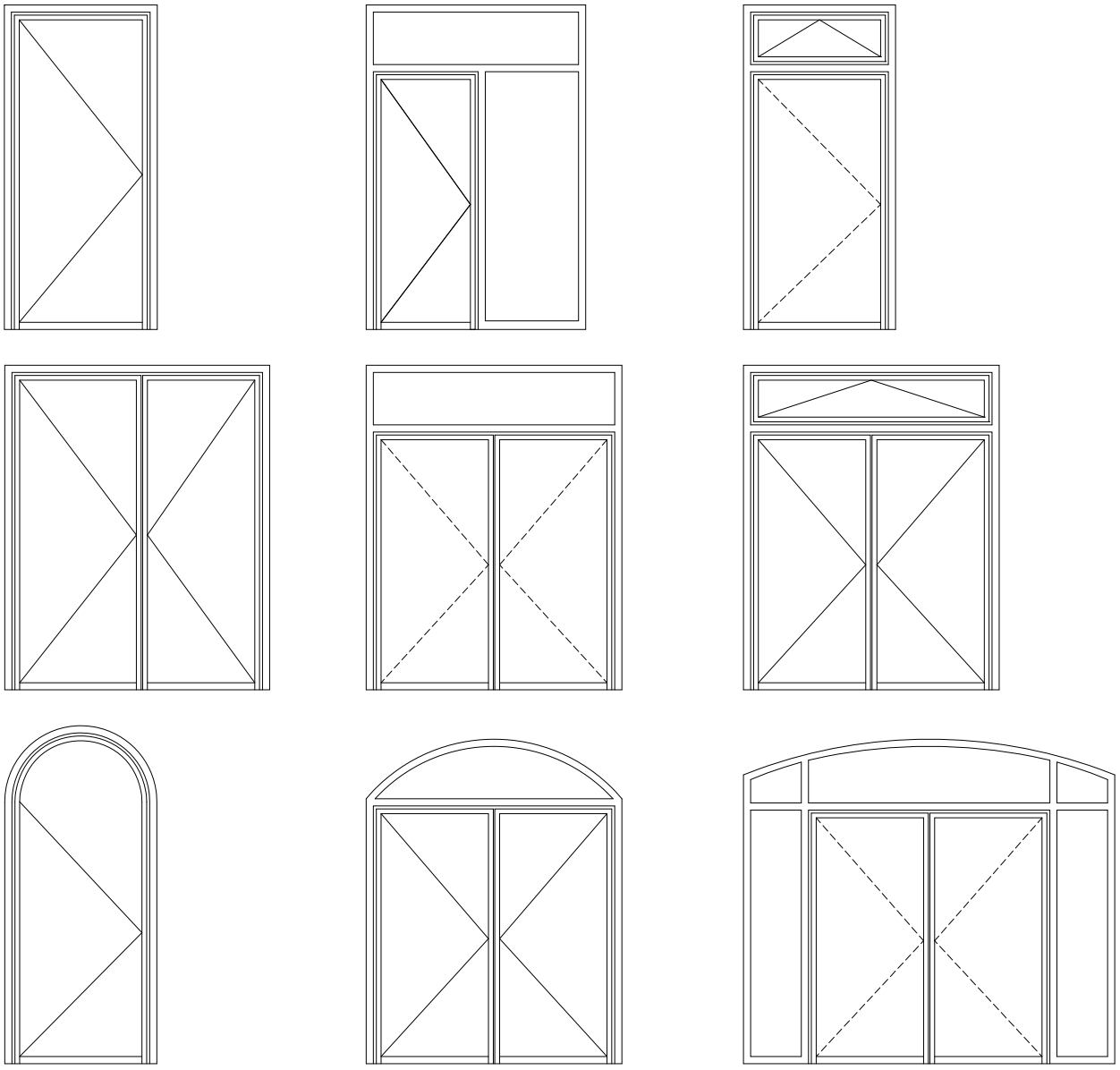
porta a due ante
two-leaf doors

peso massimo anta*
*maximum leaf weight**

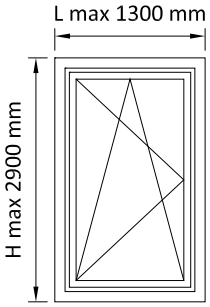
AC1033 - 150 kg
AC1037 - 250 kg
AC1068 - 180 kg
AC6023 - 200 kg

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

Esempi tipologie realizzabili - *Types of door*



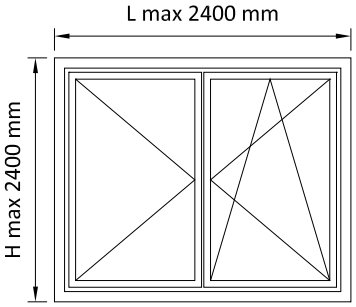
Limiti dimensionali - *Maximum dimension*



finestra ad un anta
one-leaf opening windows

peso massimo anta
maximum leaf weight

AGE281 - 130 kg
AGE282 - 130 kg

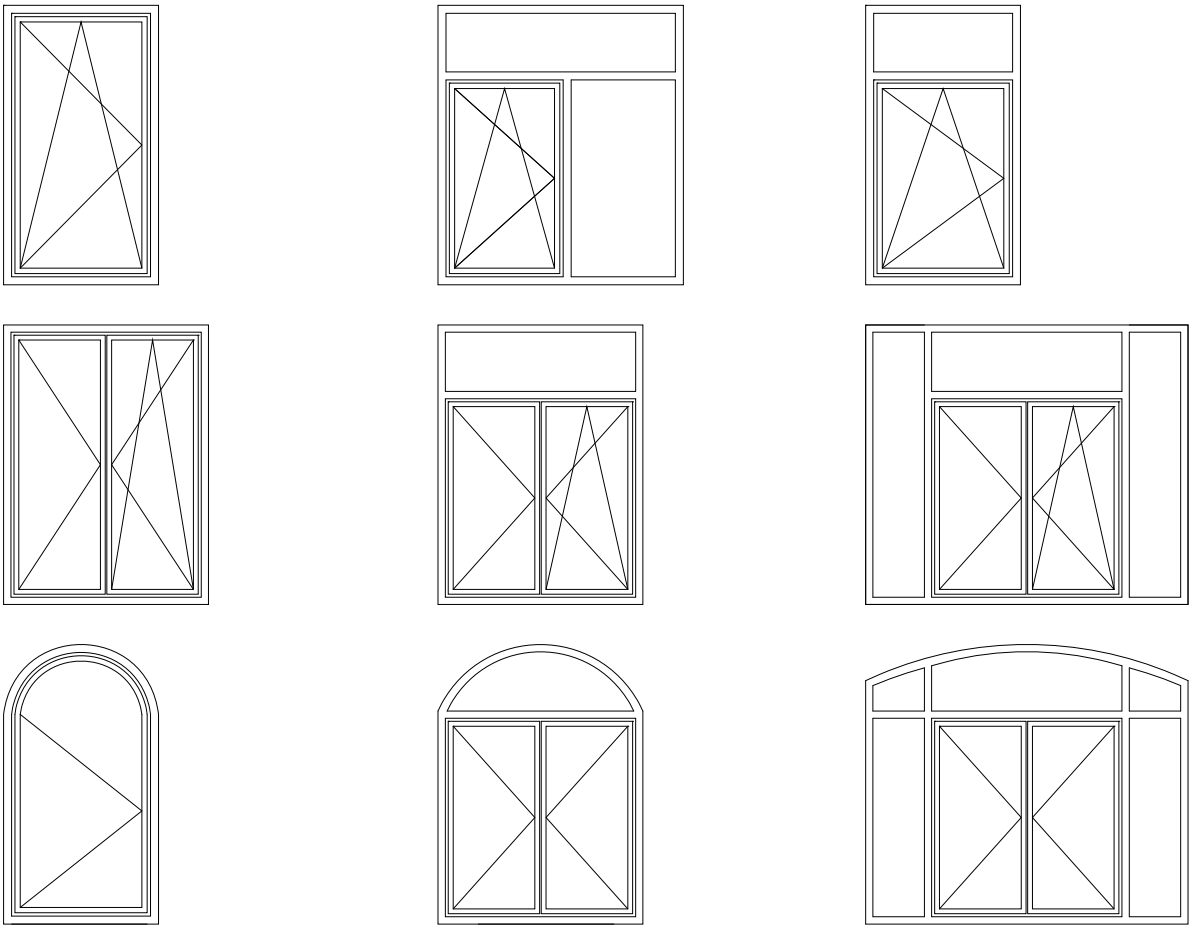


finestra a due ante
two-leaf opening windows

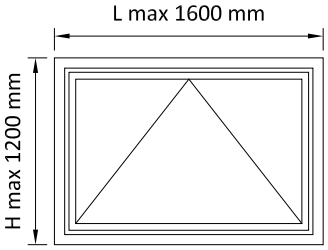
peso massimo anta
maximum leaf weight

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

Esempi tipologie realizzabili - *Types of window*



Limiti dimensionali - *Maximum dimension*

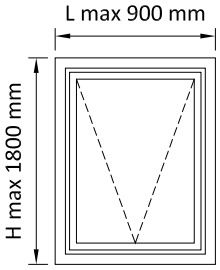


finestra a vasistas
bottom-hung window

peso massimo anta
maximum leaf weight

AG1264 - AG1274
AC2632/C - 100 kg

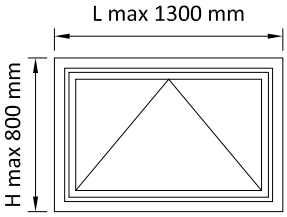
ferramenta e cremonese
hardware and cremone



finestra a sporgere
awning window

peso massimo anta
maximum leaf weight

AC1046 - 75 kg
AC1046M - 120 kg



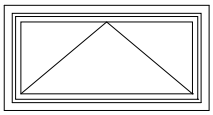
finestra a vasistas
bottom-hung window

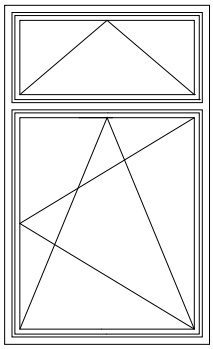
peso massimo anta
maximum leaf weight

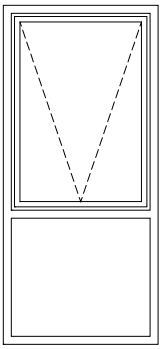
AC1235
AC2632/C - 70 kg

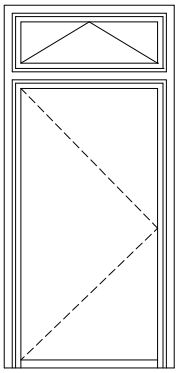
braccetti e cricchetto
stays and finger catch

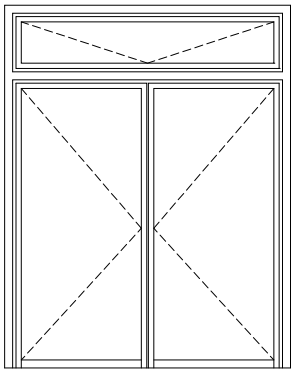
Esempi tipologie realizzabili - *Types of window*

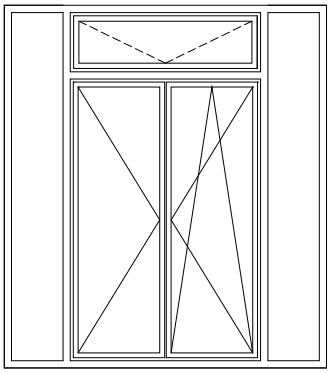


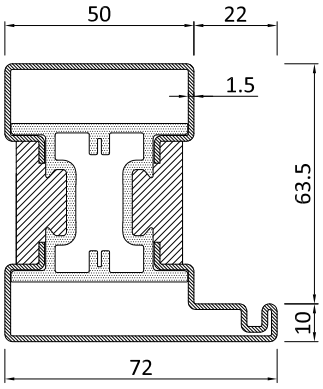




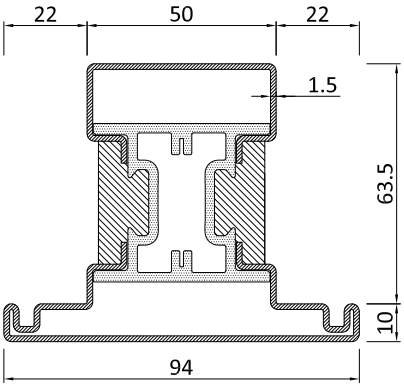




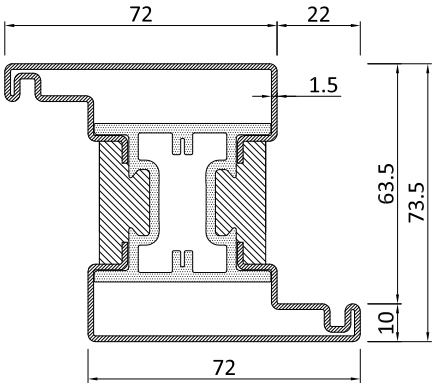




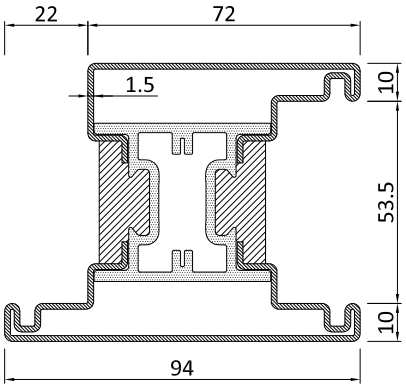
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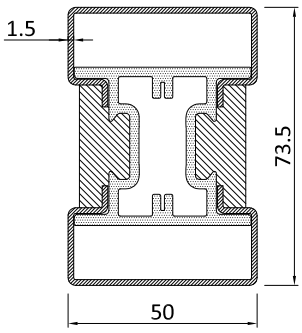
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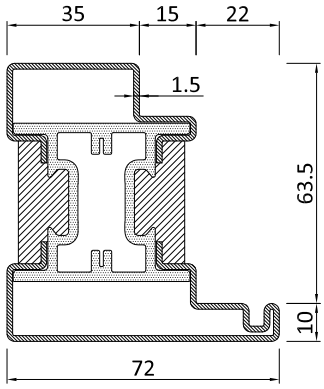
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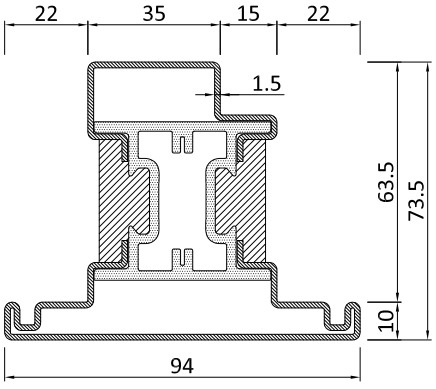
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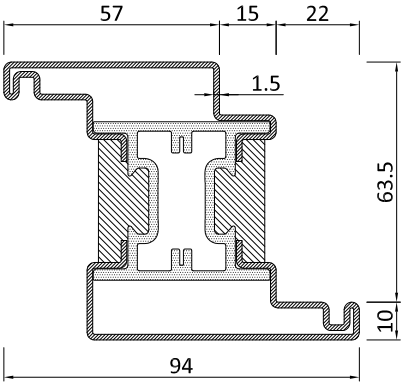
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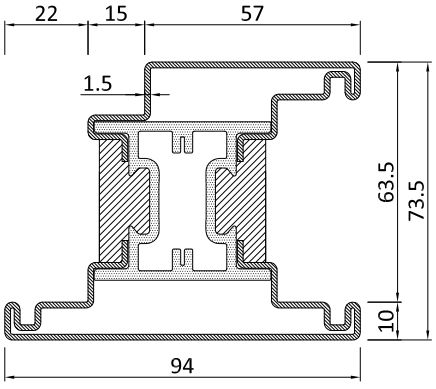
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P.1612



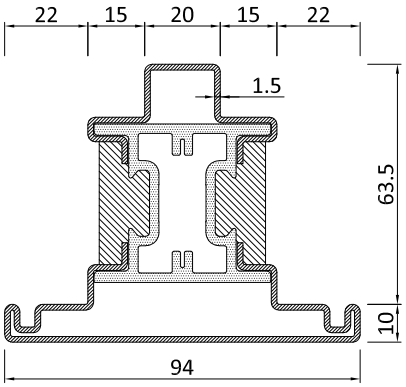
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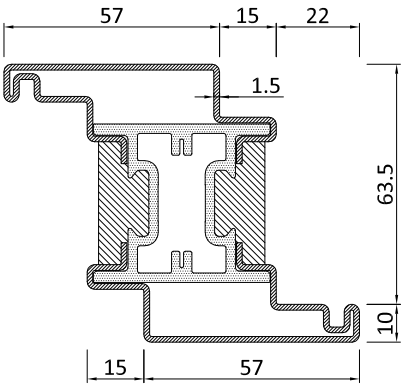
P.1615

Profilo / Profile n°	P Kg/m ZN / I - CT	P Kg/m OT	A m^2/m	Jx cm^4	Jy cm^4	L m
P.1601	4,59	4,50		25,24	21,92	6,0
P.1602	5,13	5,43		27,63	37,36	6,0
P.1603	5,16	5,48		30,04	34,49	6,0
P.1605	5,70	6,06		33,18	47,37	6,0
P.1610	4,02	4,22		21,49	12,17	6,0

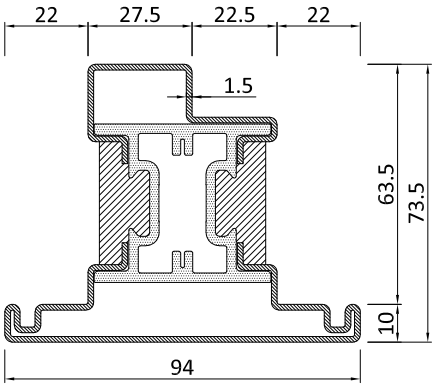
Profilo / Profile n°	P Kg/m ZN / I - CT	P Kg/m OT	A m^2/m	Jx cm^4	Jy cm^4	L m
P.1611	4,55	4,81		23,62	21,11	6,0
P.1612	5,09	5,39		25,88	36,22	6,0
P.1613	5,15	5,46		28,83	33,08	6,0
P.1615	5,69	6,04		31,86	45,72	6,0



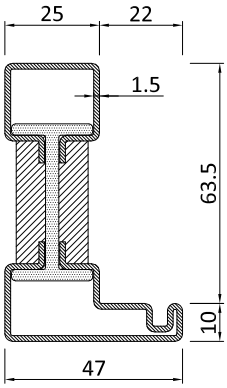
P.1622 Non fornito in acciaio zincato
Not in galvanized steel



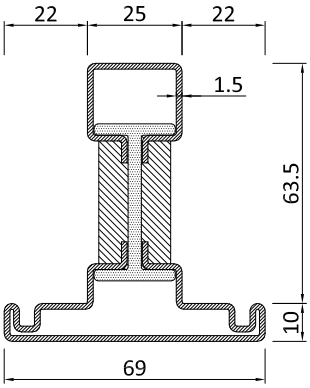
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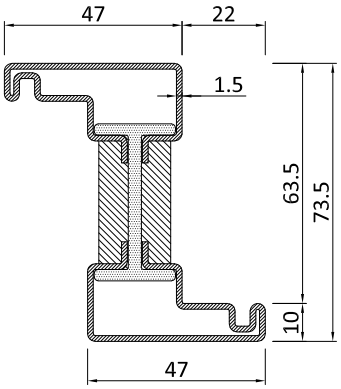
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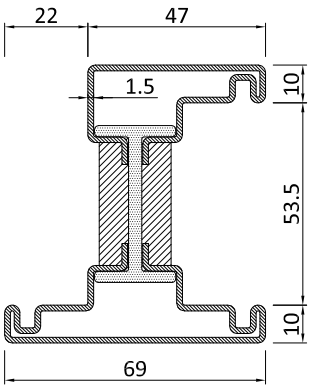
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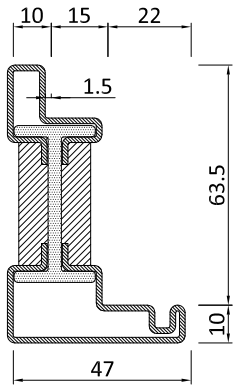
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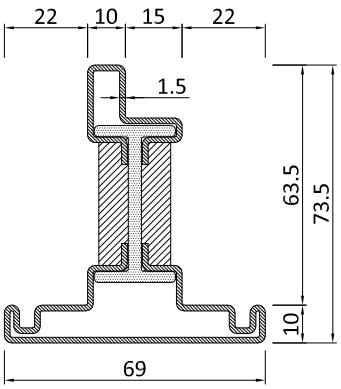
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P.1705



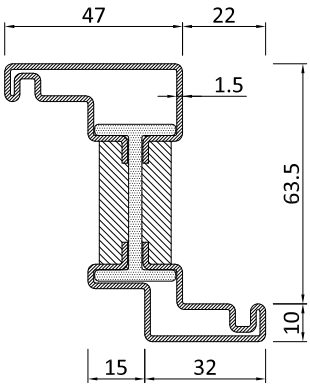
P.1711



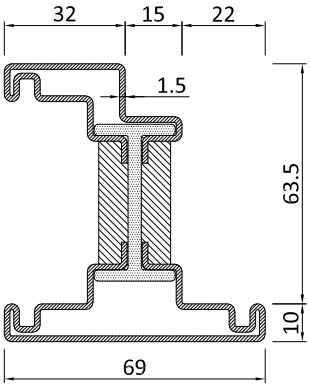
P.1712

Profilo / Profile n°	P Kg/m ZN / I - CT	P Kg/m OT	A m^2/m	Jx cm^4	Jy cm^4	L m
P.1622	5,15	5,46	0,38	24,05	35,22	3
P.1623	5,14	5,44	0,38	27,65	31,70	6
P.1627	5,13	5,43	0,38	25,00	36,05	3
P.1701	3,43	3,64	0,28	19,26	6,59	6
P.1702	3,98	4,24	0,33	19,28	14,14	6

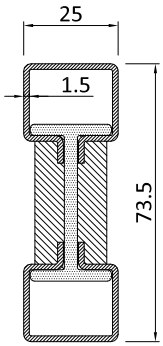
Profilo / Profile n°	P Kg/m ZN / I - CT	P Kg/m OT	A m^2/m	Jx cm^4	Jy cm^4	L m
P.1703	4,01	4,27	0,33	24,95	12,71	6
P.1705	4,56	4,87	0,38	28,43	18,76	6
P.1711	3,41	3,62	0,28	17,41	6,56	6
P.1712	3,96	4,22	0,33	19,66	13,83	6



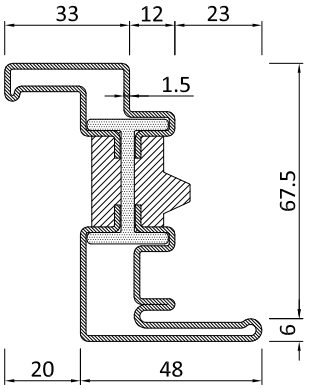
P.1713



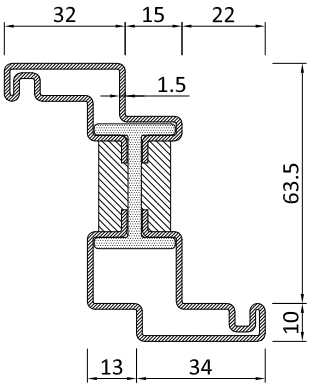
P.1715



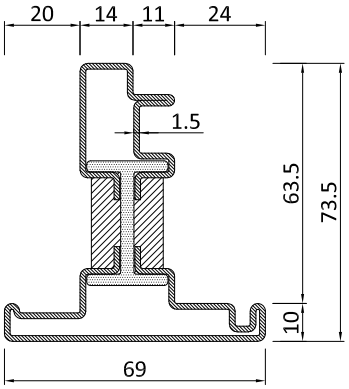
P.1720



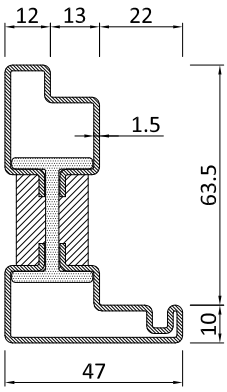
P.1233



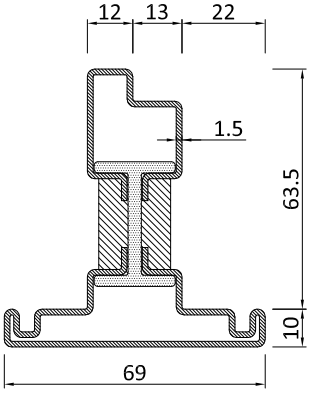
P.1723



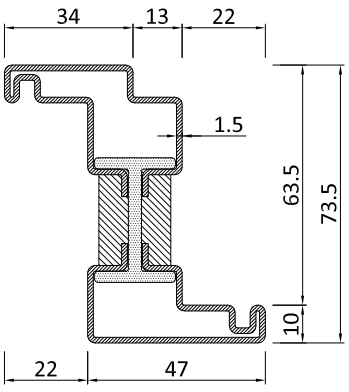
P.1724



P.1727



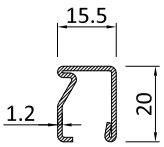
P.1728



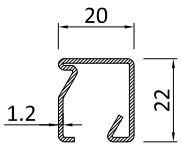
P.1729

Profilo / Profile n°	P Kg/m ZN / I - CT	P Kg/m OT	A m^2/m	Jx cm^4	Jy cm^4	L m
P.1713	3,96	4,22	0,33	23,64	12,21	6
P.1715	4,51	4,82	0,38	26,96	18,06	6
P.1720	2,85	3,01	0,23	15,15	2,16	6
P.1233	4,21	4,50	0,35	24,52	9,86	6
P.1723	4,03	4,31	0,33	22,71	12,31	6

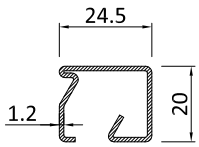
Profilo / Profile n°	P Kg/m ZN / I - CT	P Kg/m OT	A m^2/m	Jx cm^4	Jy cm^4	L m
P.1724	4,10	4,38	0,34	20,15	13,34	6
P.1727	3,48	4,03	0,28	17,74	6,94	6
P.1728	4,03	4,31	0,33	20,03	14,31	6
P.1729	4,08	4,36	0,33	23,97	12,81	6



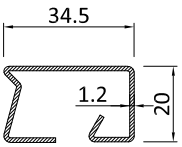
P.2007



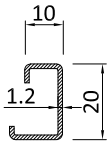
P.1007



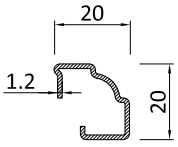
P.2008



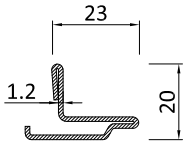
P.2009



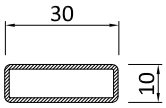
P.2015



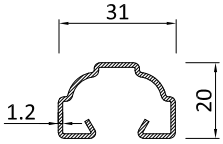
P.2028



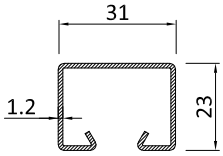
P.2038



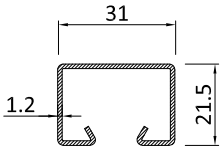
P.1234



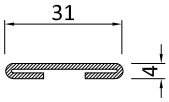
P.2030



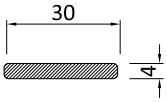
P.2031



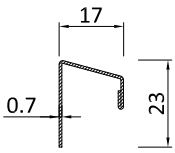
P.2032



P.2034



P.2035



P.2027

MATERIALE | *MATERIAL*

PZ _ _ _ _ acciaio zincato | *galvanized steel*

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

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

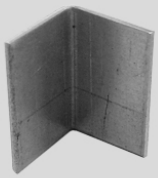
PI _ _ _ _ SB acciaio inox scotch brite | *scotch brite stainless steel*

PI _ _ _ _ L3 acciaio inox lucido | *polisched stainless steel*

PB _ _ _ _ BR ottone grezzo | *untreated brass*

Profilo / Profile n°	P Kg/m ZN / I - CT	P Kg/m OT	A m^2/m	Jx cm^4	Jy cm^4	L m
P.2007	0,57	0,62	0,13			6
P.1007	0,70	0,75	0,16			6
P.2008	0,75	0,82	0,17			6
P.2009	0,91	0,99	0,20			6
P.2015	0,43	0,46	0,09			6
P.2028	0,48	0,52	0,11			6
P.2038	0,68	0,74	0,16			6
P.1234	0,94	1,02	0,08			6
P.2030	0,73	0,79	0,17			6
P.2031	0,98	1,06	0,20			4

Profilo / Profile n°	P Kg/m ZN / I - CT	P Kg/m OT	A m^2/m	Jx cm^4	Jy cm^4	L m
P.2032	0,95	1,03	0,19			4
P.2034	0,51	0,56	0,10			4
P.2035	0,94	1,02	0,06			6
P.2027	0,51	0,56	0,10			3



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

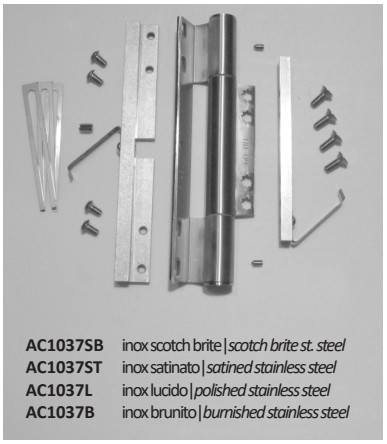
AC 1014

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

n.2 pz. per ogni angolo

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

n. 2 pieces for each corner



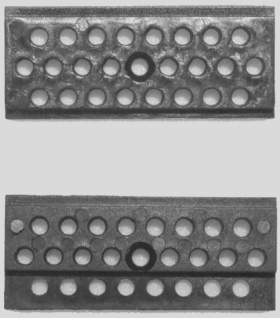
AC1037SB inox scotch brite | *scotch brite st. steel*
AC1037ST inox satinato | *satined stainless steel*
AC1037L inox lucido | *polished stainless steel*
AC1037B inox brunito | *burnished stainless steel*

AC1037.

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

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

AISI 304



AC 1020M

Supporto per spessore vetro
Vetro da 23 a 44 mm

Glass spacer
Glass from 23 to 44 mm

AC 1020R

Supporto per spessore vetro
Vetro fino a 22 mm

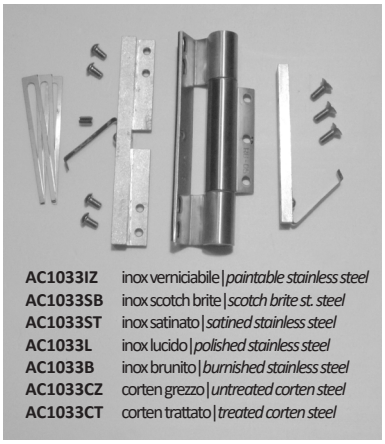
Glass spacer
Glass up to 22 mm



AC 1037/R

Rinforzo cerniera AC1037 su profili ridotti

Reinforcement for hinge AC1037 on reduced profiles



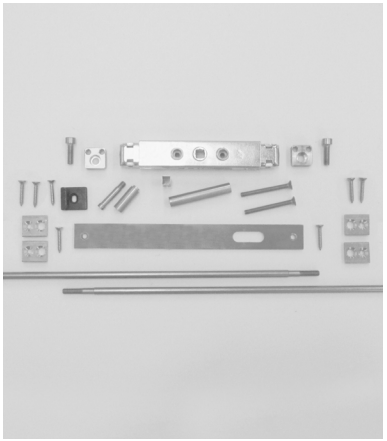
AC1033IZ inox verniciabile | *paintable stainless steel*
AC1033SB inox scotch brite | *scotch brite st. steel*
AC1033ST inox satinato | *satined stainless steel*
AC1033L inox lucido | *polished stainless steel*
AC1033B inox brunito | *burnished stainless steel*
AC1033CZ corten grezzo | *untreated corten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

AC1033.

Cerniera a stilo ad avvitare con viti e rinforzi
Peso massimo anta: 150 kg

Screw-on hinge with screws and strengtheners
Maximum leaf weight: 150 kg

AISI 304



AC 1039

Kit cremonese per chiusura orizzontale su sporgere

Cremone bolt set for horizontal awning closing



AC 1033/R

Rinforzo cerniera AC1033 su profili ridotti

Reinforcement for hinge AC1033 on reduced profiles



AC 1040

Kit chiusura porte seconda anta
Acciaio inox

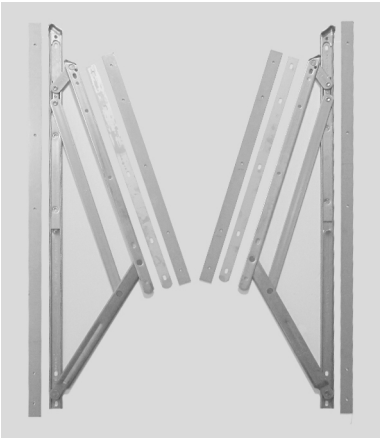
Second leaf door closing kit
Stainless steel



AC 1046

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

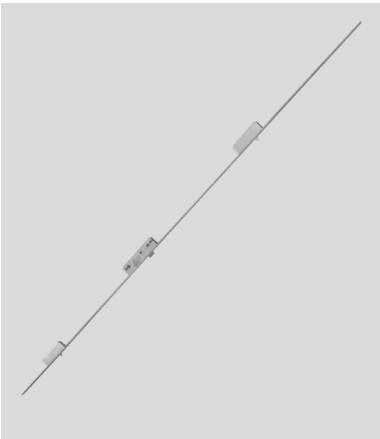
Pair of side arms for awning opening
Stainless steel
Maximum leaf weight: 75 kg



AC 1046M

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

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



AC 1065W D-S

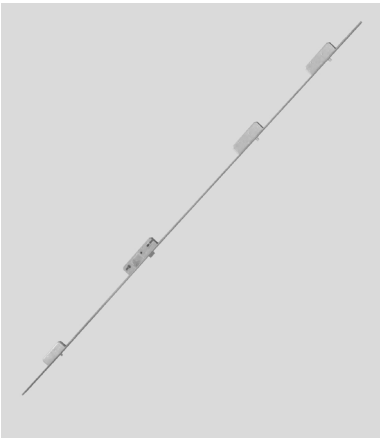
Serratura multipunto
Altezza anta da 2000 a 2300 mm

Multipoint lock
Leaf height from 2000 to 2300 mm

AC 1066W D-S

Serratura multipunto
Altezza anta da 2301 a 2900 mm

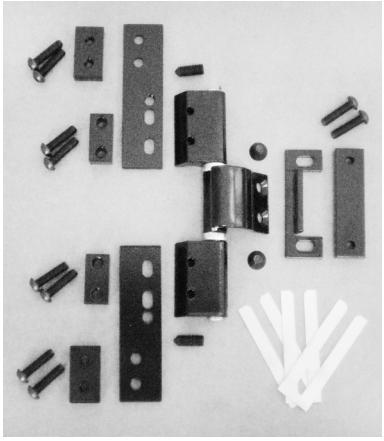
Multipoint lock
Leaf height from 2301 to 2900 mm



AC 1067W D-S

Serratura multipunto
Altezza anta oltre 2900 mm

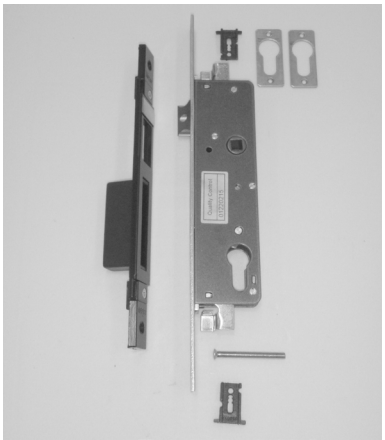
Multipoint lock
Leaf height over 2900 mm



AC 1068

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

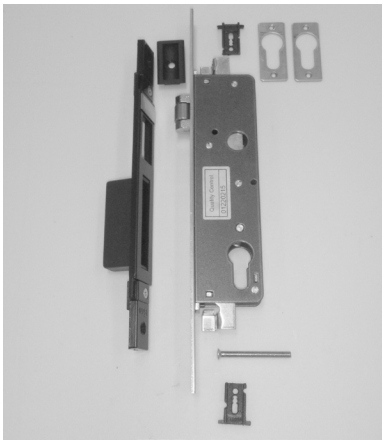
Concealed hinge for door
Maximum leaf weight: 180 kg
Maximum opening: 96°



AC 1070

Serratura con scrocco e catenaccio

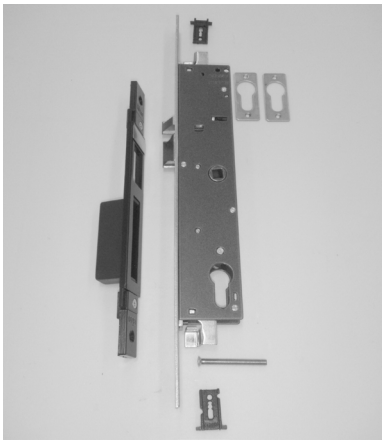
Lock with spring latch and bolt



AC 1071

Serratura con rullo e catenaccio

Lock with roller and bolt



AC 1072

Elettroserratura

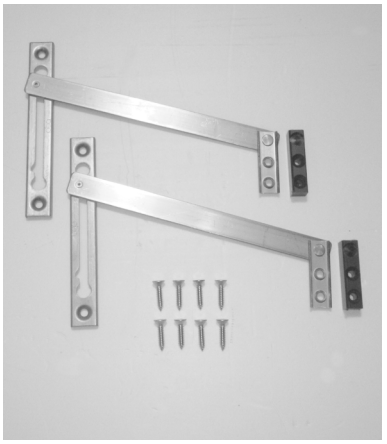
Electric lock



AC 1075

Deviatore per triplice chiusura

Deviator for three-point lock



AC 1235

Coppia limitatori per apertura a vasistas
H min = 360 mm
Peso massimo anta: 70 kg

Friction stays for bottom-hung windows
H min = 360 mm
Maximum leaf weight: 70 kg



AC 1080I

Rostro di sicurezza in acciaio inox
Completo di viti e rinforzi

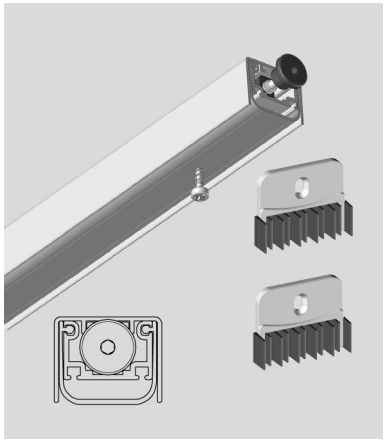
Stainless steel security pin
With screws and strengtheners



AC 1356

Meccanismo DK esterno per maniglie “Vitruvio”

External tilt and turn mechanismfor “Vitruvio” handles



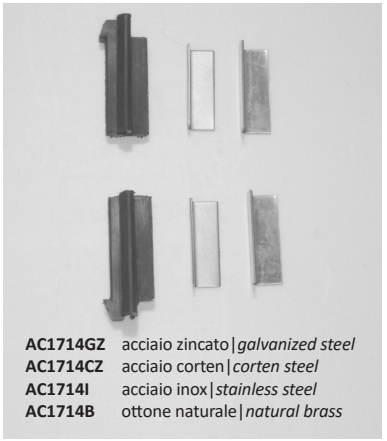
AC 1081

Paraspiffero automatico a ghigliottina

Guillotine type draught excluder

Dimensioni anta|*Leaf dimension*

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



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

AC 1714.

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

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



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

AC 1219.

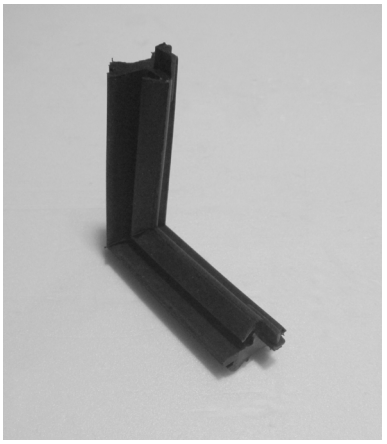
Scarico acqua per aperture interne in metallo

Metal drip for inward openings

AC 1219NE

Scarico acqua per aperture interne in plastica nera

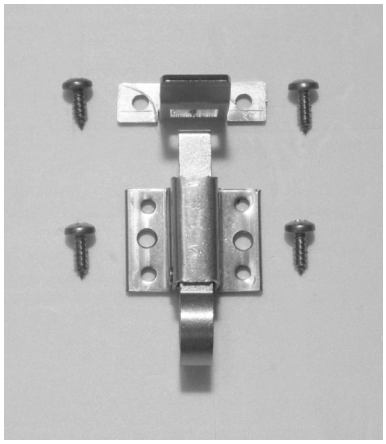
Black plastic drip for inward openings



AC 1716

Guarnizione d’angolo vulcanizzata per GE1701

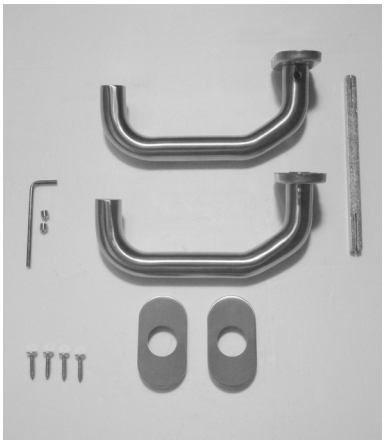
Vulcanised corner gasket for GE1701



AC 1723I

Cricchetto ed incontro da avvitare in acciaio inox, per vasistas

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



AC 5002

Coppia di maniglie per porta in acciaio inox completa di viti

Pair of stainless steel door handles with screws



AC 1731S

Cricchetto ed incontro da avvitare in nylon nero, per vasistas

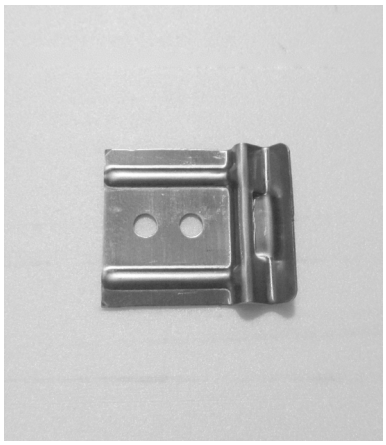
Screw-in latch and plate in black nylon, for bottom-hung windows



AC 5037

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

Handle with black alloy plate for projecting opening
With fixing screws



AC 2608

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

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



AC 5056

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

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



AC 2632/C

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

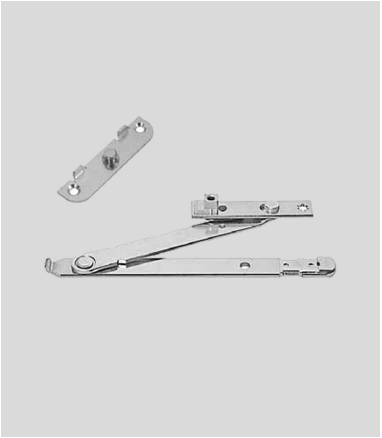
Adjustable weld-on hinge in galvanised steel | Ø 16
Maximum leaf weight: 100 kg



AC 6023

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

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



AG 1386

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

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



AG 6530

Limitatore di corsa per meccanismi A/R

Opening limiter on tilt&turn mechanism



CV 5001.

Vite per boccola fermavetri

Screw for glazing bead bushing

TPS 4.2x16 mm

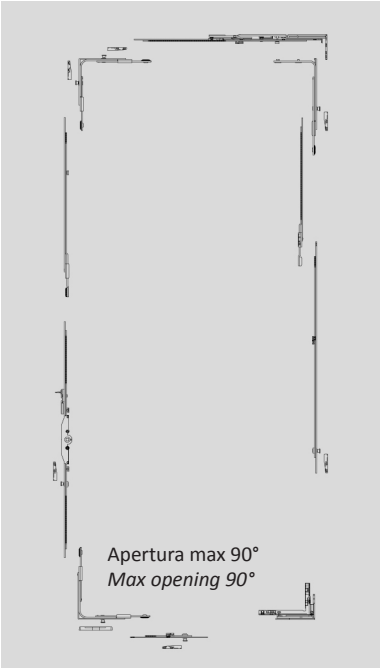
CV 5012.

Boccola per fermavetri

Bushing for glazing bead

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

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



AGE 281

Meccanismo A/R prima anta Dx cerniere a scomparsa

First leaf RH tilt-turn mechanism with concealed hinges

EASY

AGE 282

Meccanismo A/R prima anta Sx cerniere a scomparsa

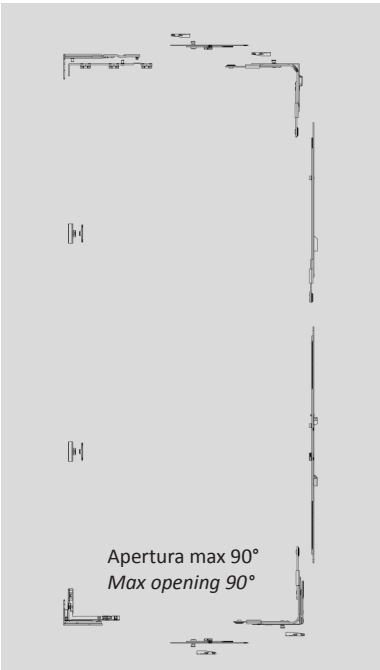
First leaf LH tilt-turn mechanism with concealed hinges

EASY

altezza - *height*

larghezza *width*	661 860	861 1000	1001 1200	1201 1400	1401 1600	1601 1800	1801 2000	2001 2200	2201 2400
601-800	A1	B1	C1	D1	E1	F1	G1	H1	I1
801-1000	-	B2	C2	D2	E2	F2	G2	H2	I2
1001-1200	-	-	C3	D3	E3	F3	G3	H3	I3
1201-1400	-	-	-	D4	E4	F4	G4	H4	I4

Limiti dimensionali | ***Limits***
Peso massimo anta | *Maximum leaf weight:* **130 kg**
misure cava ferramenta - H>L | *hardware measure - H>W*



AGE 785

Meccanismo A/R seconda anta Dx cerniere a scomparsa

Second leaf RH tilt-turn mechanism with concealed hinges

EASY

AGE 786

Meccanismo A/R seconda anta Sx cerniere a scomparsa

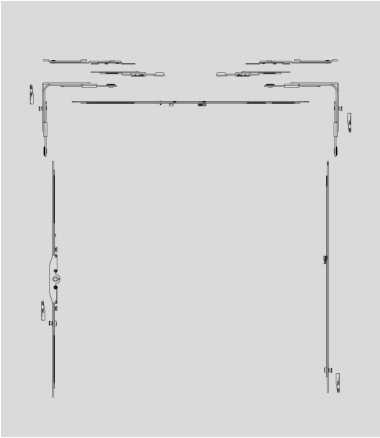
Second leaf LH tilt-turn mechanism with concealed hinges

EASY

altezza - *height*

larghezza *width*	661 860	861 1000	1001 1200	1201 1400	1401 1600	1601 1800	1801 2000	2001 2200	2201 2400
601-800	A1	B1	C1	D1	E1	F1	G1	H1	I1
801-1000	-	B2	C2	D2	E2	F2	G2	H2	I2
1001-1200	-	-	C3	D3	E3	F3	G3	H3	I3
1201-1400	-	-	-	D4	E4	F4	G4	H4	I4

Limiti dimensionali | ***Limits***
Peso massimo anta | *Maximum leaf weight:* **130 kg**
misure cava ferramenta - H>L | *hardware measure - H>W*



AG 1264

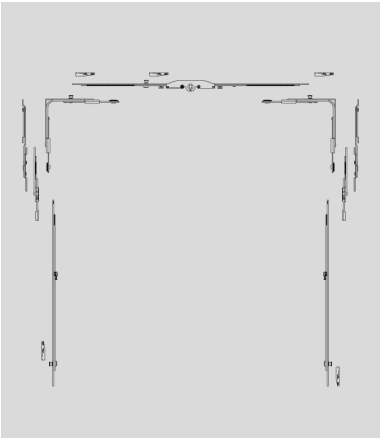
Meccanismo vasistas con cremonese su montante laterale

Bottom-hung window mechanism with lateral cremone bolt set
EASY

altezza - *height*

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

Limiti dimensionali | ***Limits***
Peso massimo anta | *Maximum leaf weight:* **100 kg** 3 cerniere | *3 hinges*
Peso massimo anta | *Maximum leaf weight:* **70 kg** 2 cerniere | *2 hinges*



AG 1274

Meccanismo vasistas con cremonese su traverso superiore

Bottom-hung window mechanism with top cremone bolt set
EASY

altezza - *height*

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

Limiti dimensionali | ***Limits***
Peso massimo anta | *Maximum leaf weight:* **100 kg** 3 cerniere | *3 hinges*
Peso massimo anta | *Maximum leaf weight:* **70 kg** 2 cerniere | *2 hinges*



AC 1001I

Kit per giunzione angolo
Acciaio inox

Corner joint kit
Stainless steel

P.1601



AC 1005I

Kit per giunzione angolo
Acciaio inox

Corner joint kit
Stainless steel

P.1612



AC 1002I

Kit per giunzione angolo
Acciaio inox

Corner joint kit
Stainless steel

P.1602



AC 1006I

Kit per giunzione angolo
Acciaio inox

Corner joint kit
Stainless steel

P.1613 cassa|*frame*



AC 1003I

Kit per giunzione angolo
Acciaio inox

Corner joint kit
Stainless steel

P.1603



AC 1007I

Kit per giunzione angolo
Acciaio inox

Corner joint kit
Stainless steel

P.1613 anta|*leaf*

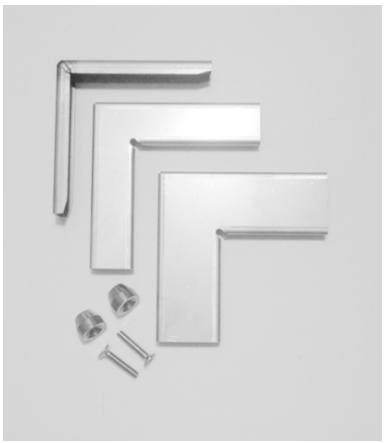


AC 1004I

Kit per giunzione angolo
Acciaio inox

Stainless steelCorner joint kit
Stainless steel

P.1611



AC 1008I

Kit per giunzione angolo
Acciaio inox

Stainless steel
Corner joint kit

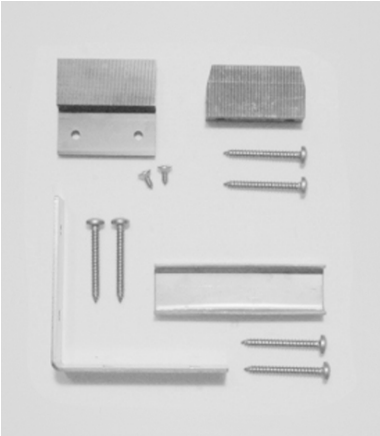
P.1612-P.1613



AC 1009I

Kit per giunzione angolo
Acciaio inox

Corner joint kit
Stainless steel
P.1605



AC 1023

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

Butt joint kit on corner section for oversize profiles
Stainless steel



AC 1013I

Kit per giunzione angolo
Acciaio inox

Corner joint kit
Stainless steel

P.1610

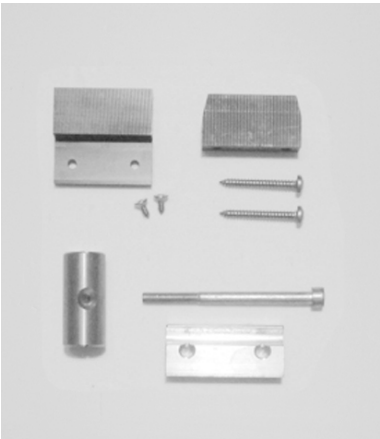


AC 1024ID

Kit per giunzione angolo destro
Acciaio inox

Right corner joint kit
Stainless steel

P.1627-P.1612



AC 1021

Kit per giunzione 90°
Acciaio inox

Butt joint kit
Stainless steel

P.1605
P.1601
P.1602



AC 1024IS

Kit per giunzione angolo sinistro
Acciaio inox

Left corner joint kit
Stainless steel

P.1627-P.1612

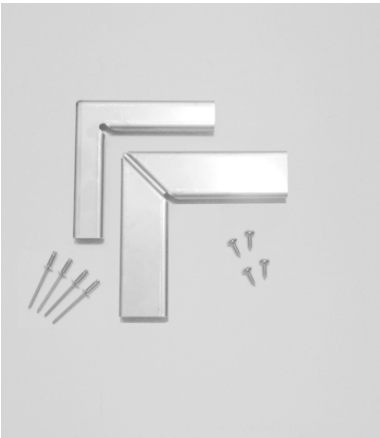


AC 1022

Kit per giunzione 90°
Acciaio inox

Butt joint kit
Stainless steel

P.1622



AC 1201I

Kit per giunzione angolo
Acciaio inox

Corner joint kit
Stainless steel

P.1701 | P.1727

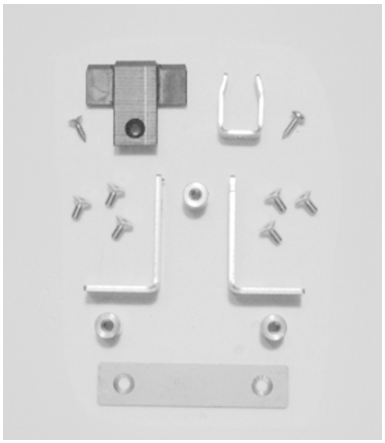


AC 1202I

Kit per giunzione angolo
Acciaio inox

Corner joint kit
Stainless steel

P.1702 | P.1728

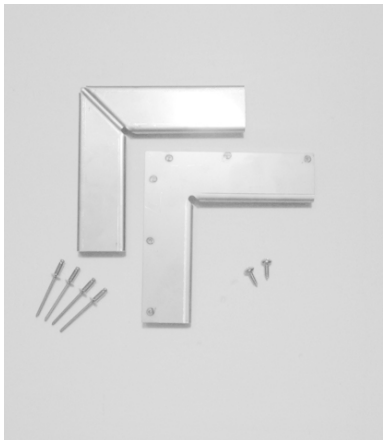


AC 1211I

Kit per giunzione 90°
Acciaio inox

Butt joint kit
Stainless steel

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



AC 1203I

Kit per giunzione angolo
Acciaio inox

Corner joint kit
Stainless steel

P.1703



AC 1211IA

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

Butt joint kit on corner section for reduced profiles
Stainless steel

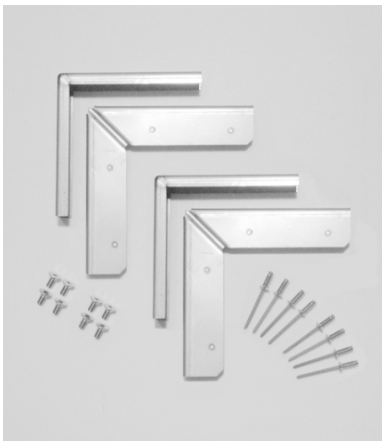


AC 1207I

Kit per giunzione angolo
Acciaio inox

Corner joint kit
Stainless steel

P.1233

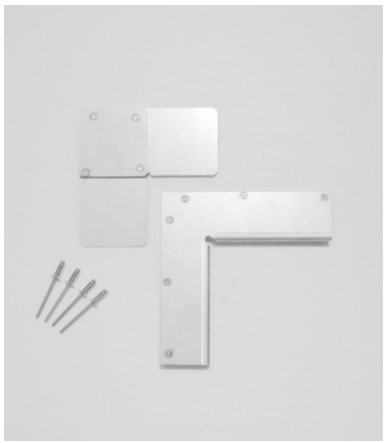


AC 1708I

Kit per giunzione angolo
Acciaio inox

Corner joint kit
Stainless steel

P.1724-P.1233

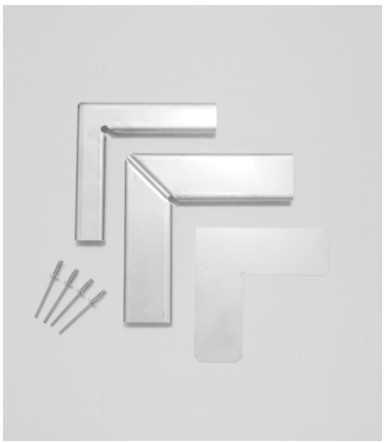


AC 1209I

Kit per giunzione angolo
Acciaio inox

Corner joint kit
Stainless steel

P.1705

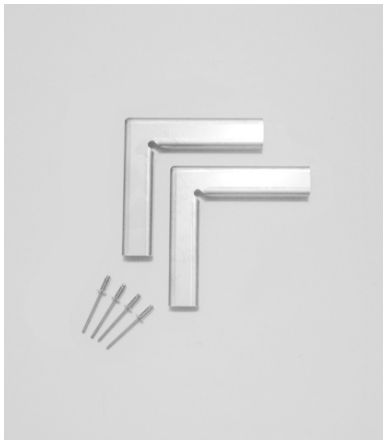


AC 1729I

Kit per giunzione angolo
Acciaio inox

Corner joint kit
Stainless steel

P.1729

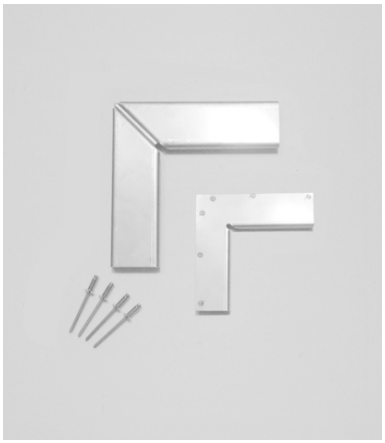


AC 1730I

Kit per giunzione angolo
Acciaio inox

Corner joint kit
Stainless steel

P.1720



AC 1733IE

Kit per giunzione angolo
Acciaio inox

Corner joint kit
Stainless steel

P.1713 cassa|*frame*



AC 1731I

Kit per giunzione angolo
Acciaio inox

Corner joint kit
Stainless steel

P.1711



AC 1735I

Kit per giunzione angolo
Acciaio inox

Corner joint kit
Stainless steel

P.1715



AC 1732I

Kit per giunzione angolo
Acciaio inox

Corner joint kit
Stainless steel

P.1712



AC 1733I

Kit per giunzione angolo
Acciaio inox

Corner joint kit
Stainless steel

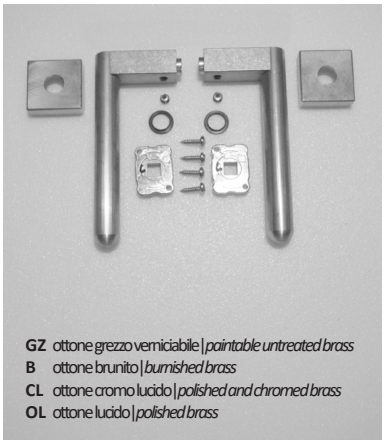
P.1713 anta|*leaf*



ACV 075

Quadro per doppia maniglia

Spindle bar for double handle



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

ACV 944

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

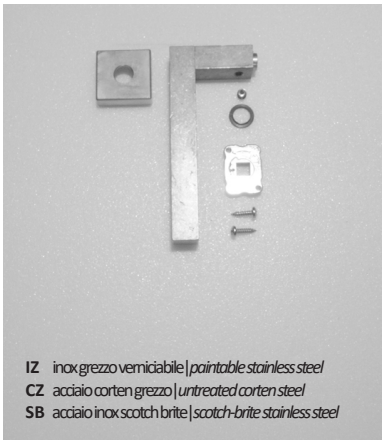
Double door handlesets
"VITRUVIO" medium
square escutcheon
L | round | sphere



ACV 065/R

Quadro per maniglia singola

Spindle bar for single handle

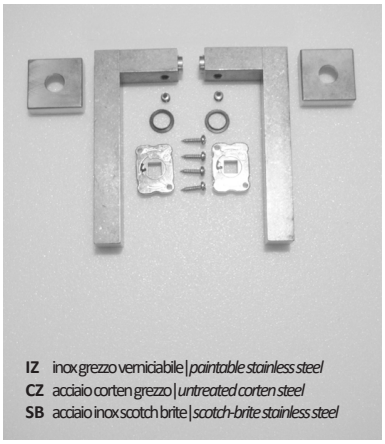


IZ inox grezzo verniciabile | *paintable stainless steel*
CZ acciaio corten grezzo | *untreated corten steel*
SB acciaio inox scotch brite | *scotch-brite stainless steel*

ACV 947

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

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

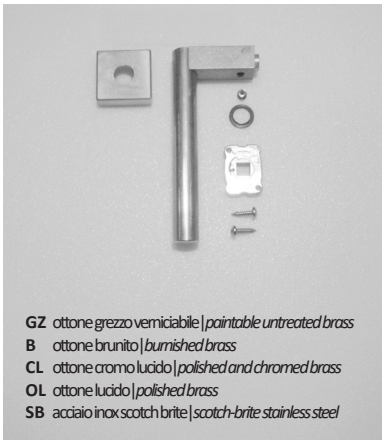


IZ inox grezzo verniciabile | *paintable stainless steel*
CZ acciaio corten grezzo | *untreated corten steel*
SB acciaio inox scotch brite | *scotch-brite stainless steel*

ACV 942

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

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

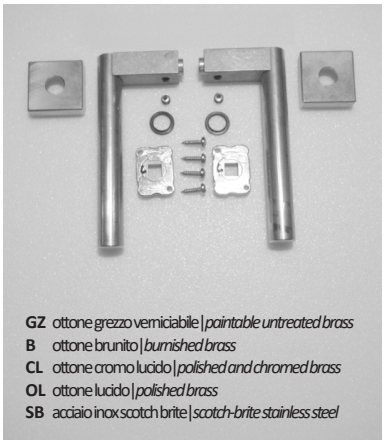


GZ ottone grezzo verniciabile | *paintable untreated brass*
B ottone brunito | *burnished brass*
CL ottone cromo lucido | *polished and chromed brass*
OL ottone lucido | *polished brass*
SB acciaio inox scotch brite | *scotch-brite stainless steel*

ACV 948

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

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

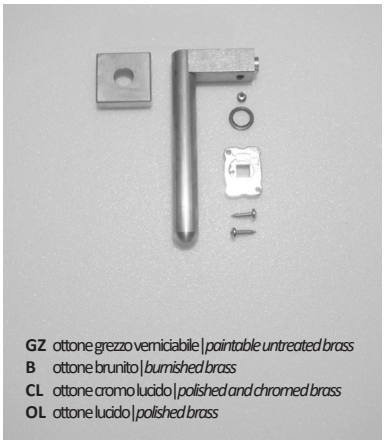


GZ ottone grezzo verniciabile | *paintable untreated brass*
B ottone brunito | *burnished brass*
CL ottone cromo lucido | *polished and chromed brass*
OL ottone lucido | *polished brass*
SB acciaio inox scotch brite | *scotch-brite stainless steel*

ACV 943

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

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

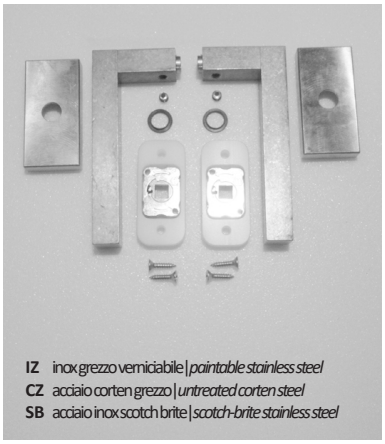


GZ ottone grezzo verniciabile | *paintable untreated brass*
B ottone brunito | *burnished brass*
CL ottone cromo lucido | *polished and chromed brass*
OL ottone lucido | *polished brass*

ACV 949

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

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

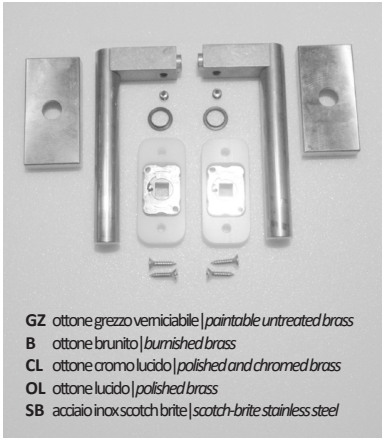


IZ inox grezzo verniciabile | *paintable stainless steel*
CZ acciaio corten grezzo | *untreated corten steel*
SB acciaio inox scotch brite | *scotch-brite stainless steel*

ACV 952

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

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

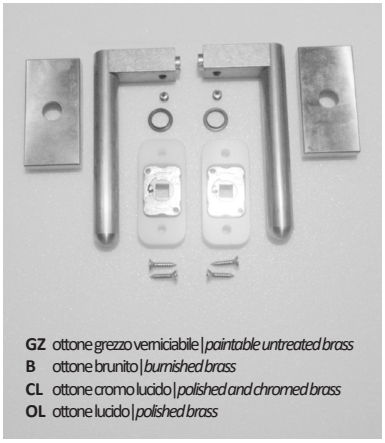


GZ ottone grezzo verniciabile | *paintable untreated brass*
B ottone brunito | *burnished brass*
CL ottone cromo lucido | *polished and chromed brass*
OL ottone lucido | *polished brass*
SB acciaio inox scotch brite | *scotch-brite stainless steel*

ACV 953

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

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

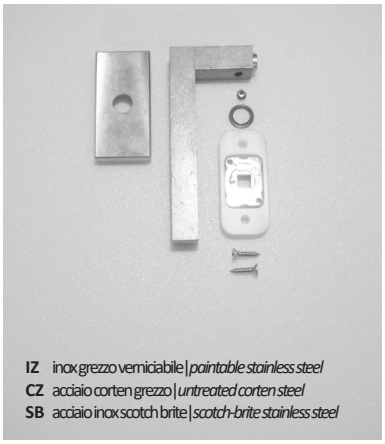


GZ ottone grezzo verniciabile | *paintable untreated brass*
B ottone brunito | *burnished brass*
CL ottone cromo lucido | *polished and chromed brass*
OL ottone lucido | *polished brass*

ACV 954

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

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

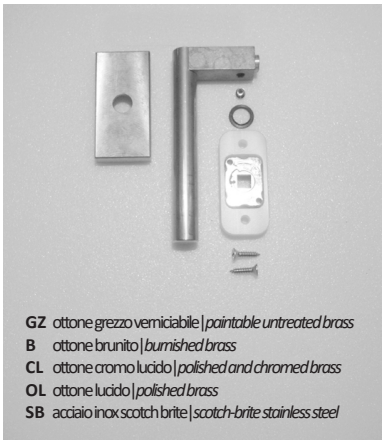


IZ inox grezzo verniciabile | *paintable stainless steel*
CZ acciaio corten grezzo | *untreated corten steel*
SB acciaio inox scotch brite | *scotch-brite stainless steel*

ACV 957

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

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

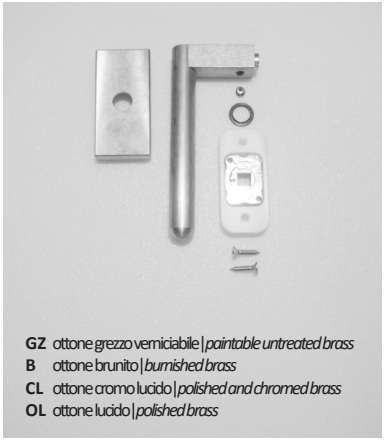


GZ ottone grezzo verniciabile | *paintable untreated brass*
B ottone brunito | *burnished brass*
CL ottone cromo lucido | *polished and chromed brass*
OL ottone lucido | *polished brass*
SB acciaio inox scotch brite | *scotch-brite stainless steel*

ACV 958

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

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

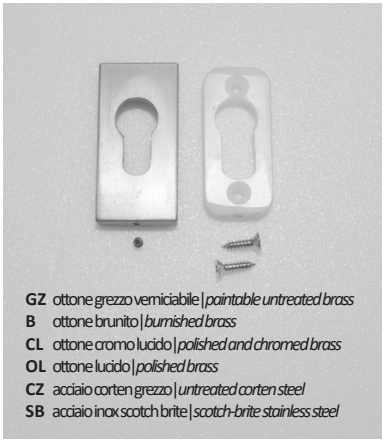


GZ ottone grezzo verniciabile | *paintable untreated brass*
B ottone brunito | *burnished brass*
CL ottone cromo lucido | *polished and chromed brass*
OL ottone lucido | *polished brass*

ACV 959

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

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

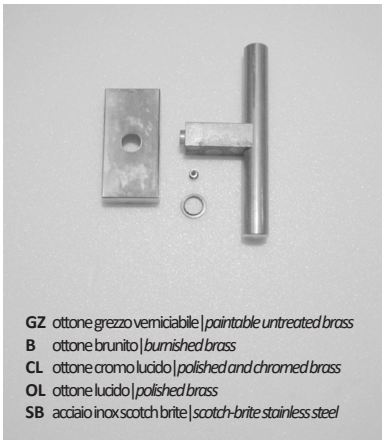


GZ ottone grezzo verniciabile | *paintable untreated brass*
B ottone brunito | *burnished brass*
CL ottone cromo lucido | *polished and chromed brass*
OL ottone lucido | *polished brass*
CZ acciaio corten grezzo | *untreated corten steel*
SB acciaio inox scotch brite | *scotch-brite stainless steel*

ACV 964

Bocchetta copri cilindro a profilo
europeo

Euro profile cylinder escutcheon
plate

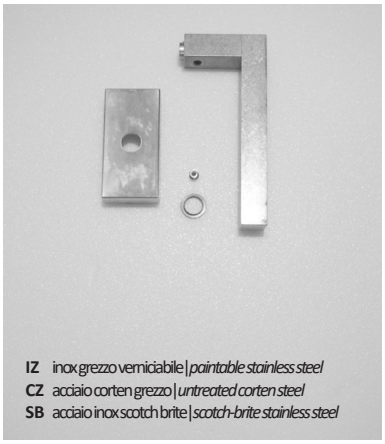


GZ ottone grezzo verniciabile | *paintable untreated brass*
B ottone brunito | *burnished brass*
CL ottone cromo lucido | *polished and chromed brass*
OL ottone lucido | *polished brass*
SB acciaio inox scotch brite | *scotch-brite stainless steel*

ACV 971

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

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

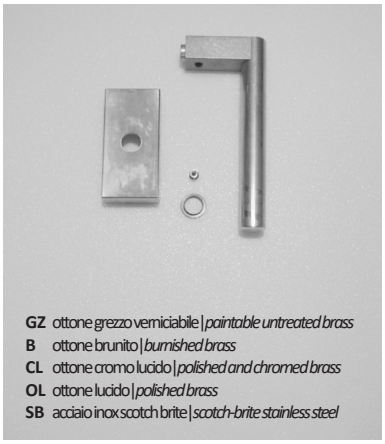


IZ inox grezzo verniciabile | *paintable stainless steel*
CZ acciaio corten grezzo | *untreated corten steel*
SB acciaio inox scotch brite | *scotch-brite stainless steel*

ACV 972

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

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

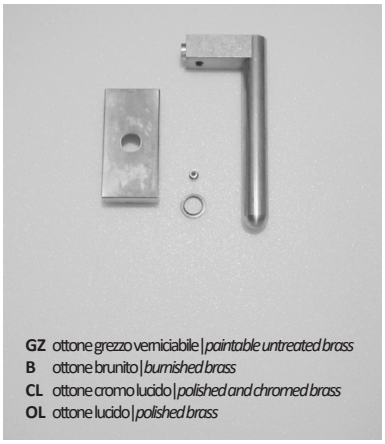


GZ ottone grezzo verniciabile | *paintable untreated brass*
B ottone brunito | *burnished brass*
CL ottone cromo lucido | *polished and chromed brass*
OL ottone lucido | *polished brass*
SB acciaio inox scotch brite | *scotch-brite stainless steel*

ACV 973

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

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

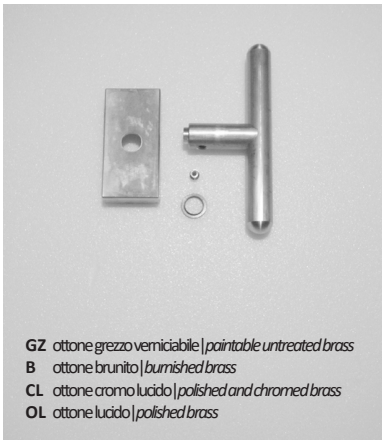


GZ ottone grezzo verniciabile | *paintable untreated brass*
B ottone brunito | *burnished brass*
CL ottone cromo lucido | *polished and chromed brass*
OL ottone lucido | *polished brass*

ACV 974

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

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

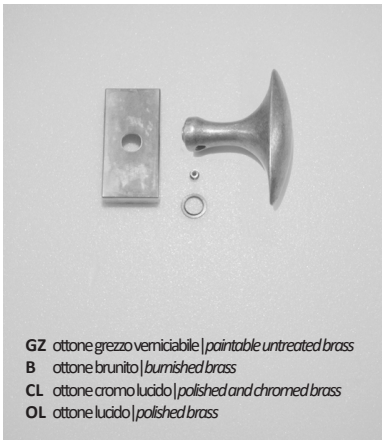


GZ ottone grezzo verniciabile | *paintable untreated brass*
B ottone brunito | *burnished brass*
CL ottone cromo lucido | *polished and chromed brass*
OL ottone lucido | *polished brass*

ACV 976

Maniglia per DK finestra
"VITRUVIO" medium
KIDS

DK window handle
"VITRUVIO" medium
KIDS

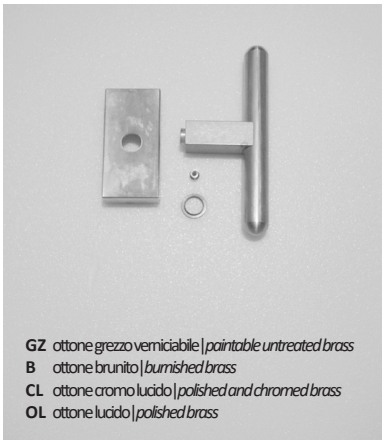


GZ ottone grezzo verniciabile | *paintable untreated brass*
B ottone brunito | *burnished brass*
CL ottone cromo lucido | *polished and chromed brass*
OL ottone lucido | *polished brass*

ACV 977

Maniglia per DK finestra
"VITRUVIO" medium
OVALE

DK window handle
"VITRUVIO" medium
OVALE

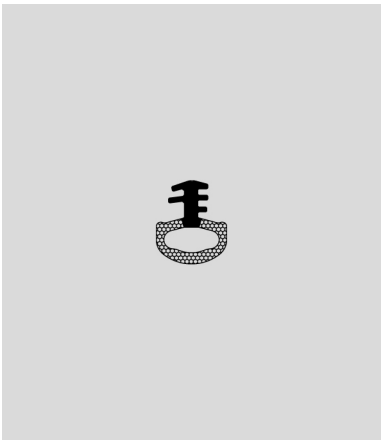


GZ ottone grezzo verniciabile | *paintable untreated brass*
B ottone brunito | *burnished brass*
CL ottone cromo lucido | *polished and chromed brass*
OL ottone lucido | *polished brass*

ACV 979

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

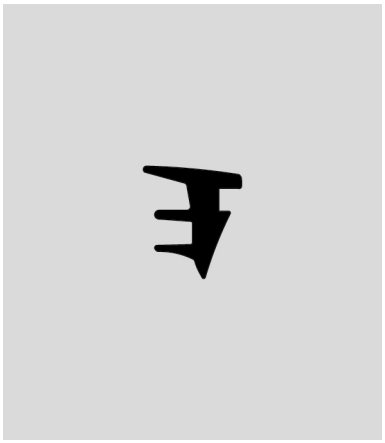
DK window handle
"VITRUVIO" medium
T | round | sphere



GE 1001TT

Guarnizione di battuta per porte

Gasket for doors



GE 1012

Guarnizione interna fermavetro spessore 6-8 mm

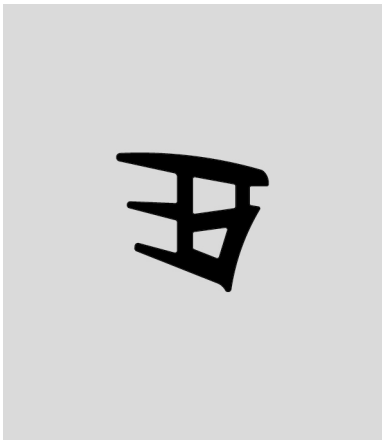
Internal gasket for 6-8 mm thick glazing bead



GE 1006

Guarnizione esterna vetro

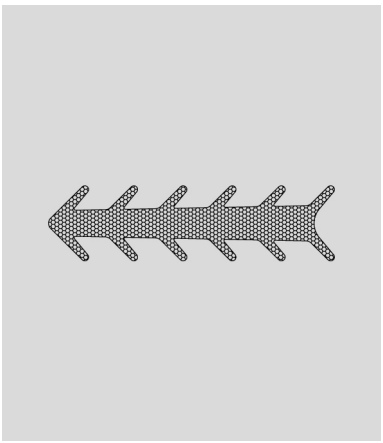
External gasket



GE 1013

Guarnizione interna fermavetro spessore 12-16 mm

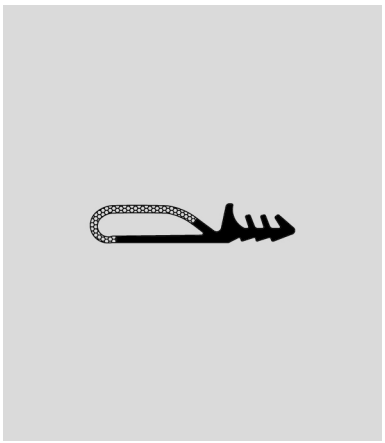
Internal gasket for 12-16 mm thick glazing bead



GE 1007TT

Guarnizione sotto vetro

Under glass gasket



GE 1200TT

Guarnizione di battuta interna per finestre

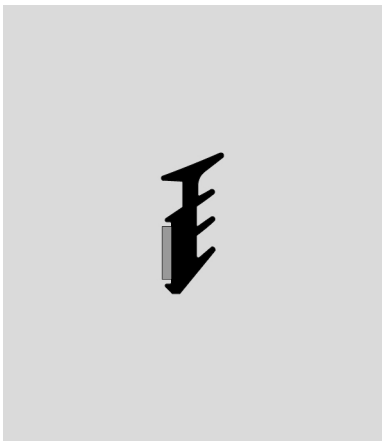
Internal gasket for windows



GE 1011

Guarnizione interna fermavetro spessore 3-4 mm

Internal gasket for 3-4 mm thick glazing bead



GE 1206

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

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



GE 1233TT

Guarnizione di battuta per finestre

Gasket for windows



GE 2029

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

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



GE 1701

Guarnizione centrale di battuta giunto aperto finestre telaio

Central open-joint gasket for windows frame



GP 0095

Guarnizione interna fermavetro spessore 3 mm

Internal gasket for glazing bead, 3mm thick



GE 1704

Guarnizione centrale di battuta giunto aperto finestre anta P.1724

Central open-joint gasket for windows leaf P.1724



GU 0087

Spazzolino per porte su GU0120 H=8 mm

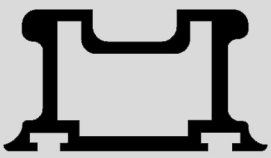
Brush for doors on GU0120 H=8 mm



GE 2028

Guarnizione interna per fermavetro P.2028

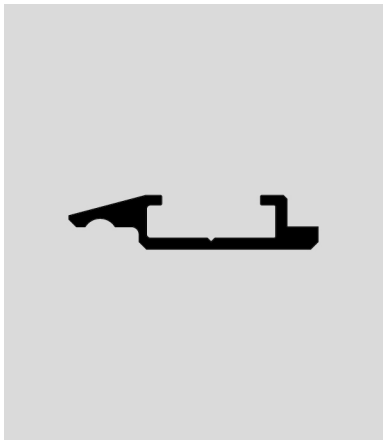
Gasket for glazing bead P,2028



GU 0120

Estruso in PVC porta spazzolino per porte

Extruded PVC brush holder for doors



GU 1702

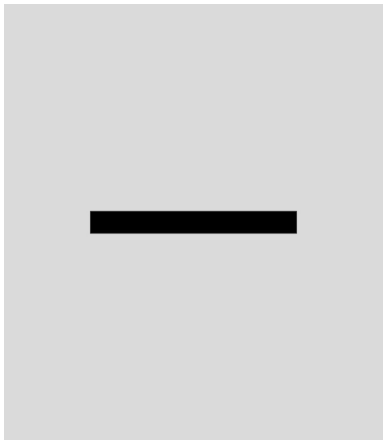
Estruso rigido in PVC per GE1701-GE1704

Rigid extruded PVC section for GE1701-GE1704

GU 2032

Biadesivo per dividivetro 12x1 mm

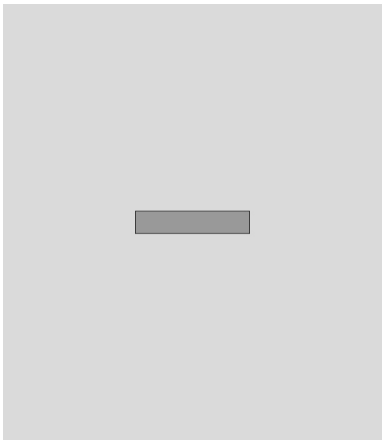
Bi-adhesive tape for glass divider 12x1 mm



GU 1711

Profilo in PVC per scarico acqua aperture a sporgere

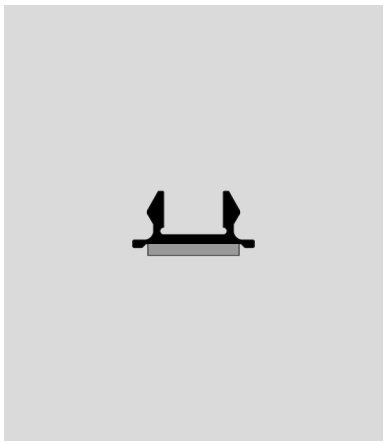
PVC profile for water drain in awning opening



GU 2035

Piattina adesiva morbida per fondo giunto esterno vetro 15x3 mm

Soft adhesive shim for external window joint 15x3 mm



GU 2030E

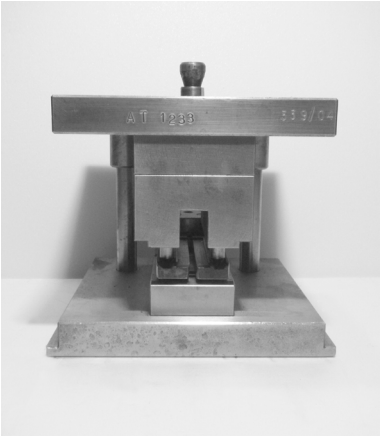
Profilo in PVC con biadesivo per fissaggio dividivetro interno P.2030 | P.2031 | P.2032

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

GU 2031

Biadesivo per dividivetro 12x1.5 mm

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



AT 1233

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

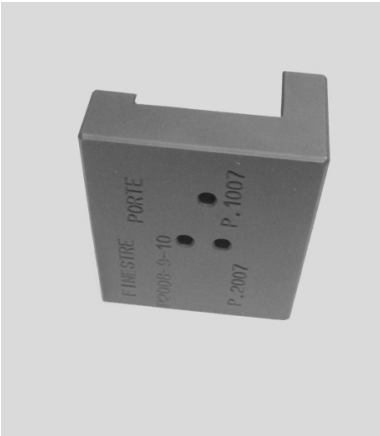
Die for drilling holes for corner plate on profile
P.1233 | P.1724



AT 1601

Maschera per esecuzione fori di fissaggio squadretta su profili maggiorati

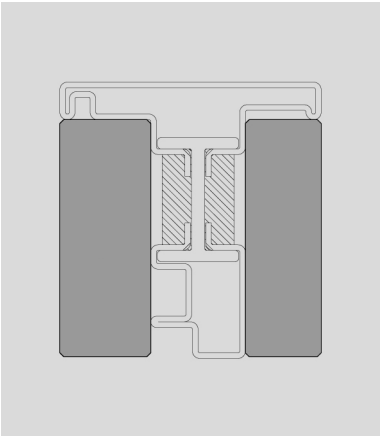
Jig for drilling holes for corner plate on oversize profiles



AT 1234

Maschera per esecuzione fori fissaggio fermavetri con boccole

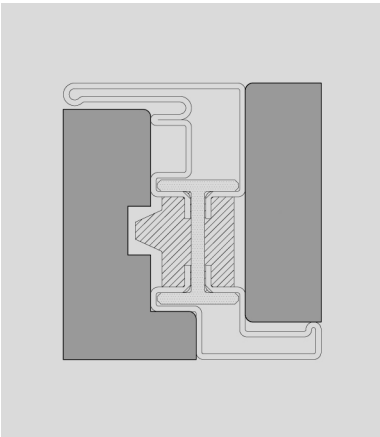
Jig for drilling holes for glazing bead with bushings



AT 1724

Ganasce di taglio per profilo
P.1724

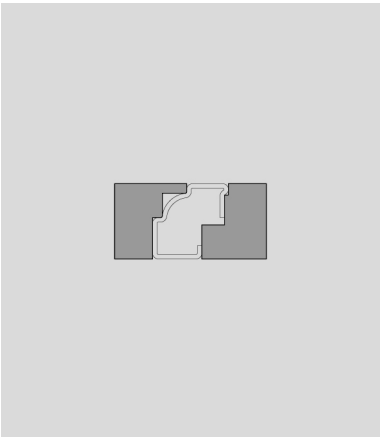
Cutting jaws for
P.1724



AT 1236

Ganasce di taglio per profilo
P.1233

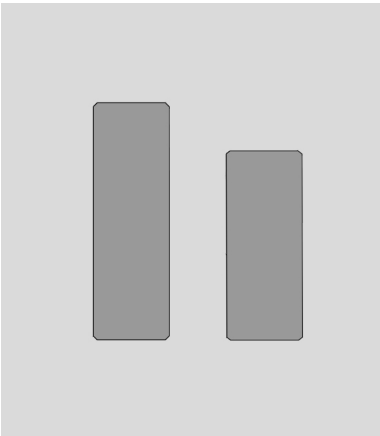
Cutting jaws for
P.1233



AT 2029

Ganasce di taglio per fermavetro
P.2028

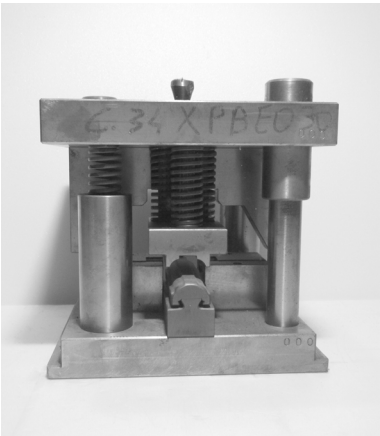
Cutting jaws for glazing bead
P.2028



AT 1600

Ganasce di taglio per profili
EBE 75

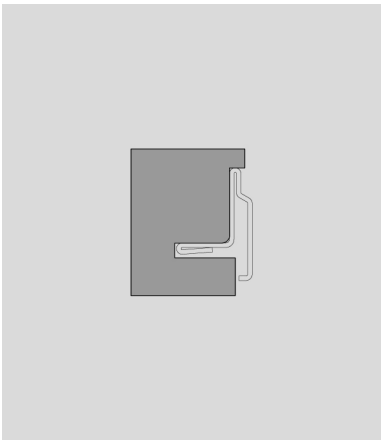
Cutting jaws for profiles
EBE 75



AT 2030

Stampo per intestatura
P.2030

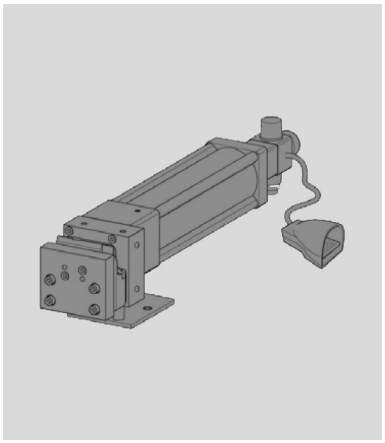
Butt die for
P.2030



AT 2038

Ganasce di taglio per P.2038

Cutting jaws for P.2038



ATG 312

Trancia oleopneumatica

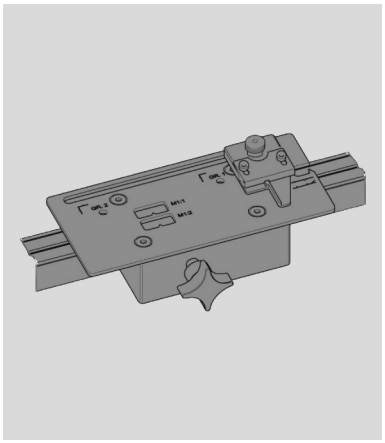
Oil-pneumatic punching machine



AT 2828

Maschera per esecuzione fori fissaggio fermavetri con clips

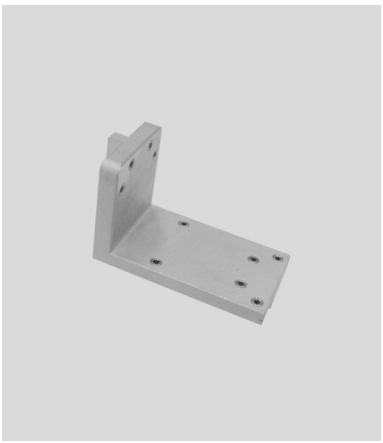
Jig for drilling holes for glazing bead with clips



ATG 313

Asta millimetrata per trancia oleopneumatica

Rod divided into millimetres for oil-pneumatic punching machine

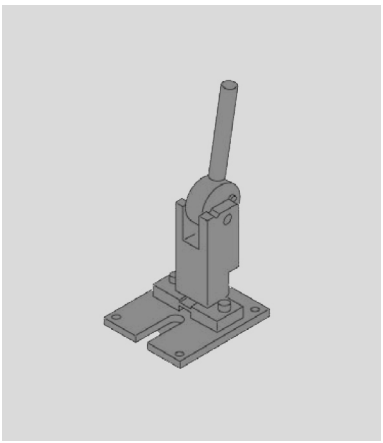


ATG 281

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

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

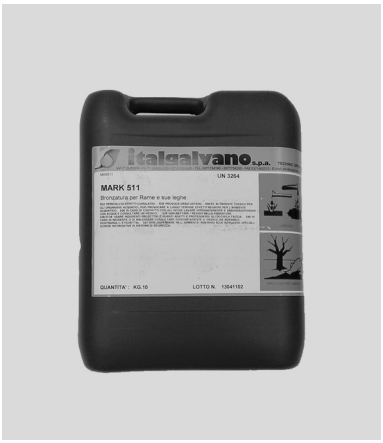
AGE 281-2-5-6



ATG 311

Trancia manuale

Manual punching machine



SA 005/01

Liquido neritore per brunitura
1 Kg

Burnishing liquid
1 Kg

SA 005/10

Liquido neritore per brunitura
10 Kg

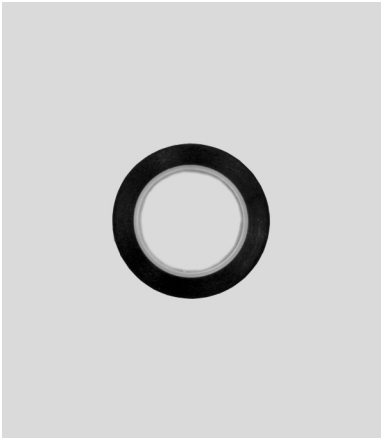
Burnishing liquid
10 Kg



SA 2002

Spray solvente per rimozione collanti su superfici in acciaio inox

Solvent adhesive remover spray for stainless steel surfaces



SA 1024

Nastro adesivo protettivo per verniciatura
24 mm

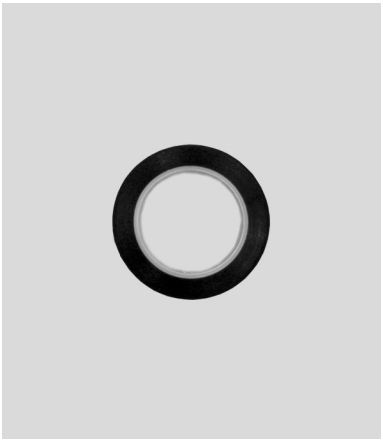
Adhesive tape for painting
24 mm



SA 2031

Liquido deumidificante vetri

Glass dehumidifying liquid



SA 1033

Nastro adesivo protettivo per verniciatura
33 mm

Sticky tape for painting
33 mm



SA 2032

Primer di adesione per profili verniciati

Adhesion primer for painted profiles



SA 2001

Spray detergente antimpronta per superfici in acciaio inox

Anti-fingerprint detergent spray for stainless steel surfaces



SA 2033

Liquido di adesione per materiale plastico

Adhesion liquid for plastic



SA 3001

Acido per ossidazione corten

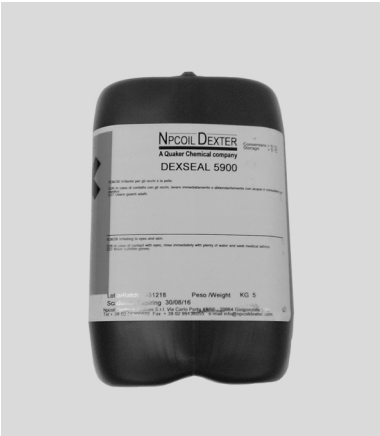
Oxidising acid for corten



SL 0021

Silicone nero per guarnizioni

Black silicone for gaskets



SA 3002

Passivante per ossidazione corten
25 Kg

Passivating agent for corten
25 Kg

SA 3002/5

Passivante per ossidazione corten
5 Kg

Passivating agent for corten
5 Kg



SA 3003

Cera d'api per finitura corten

Beeswax for Corten finishing

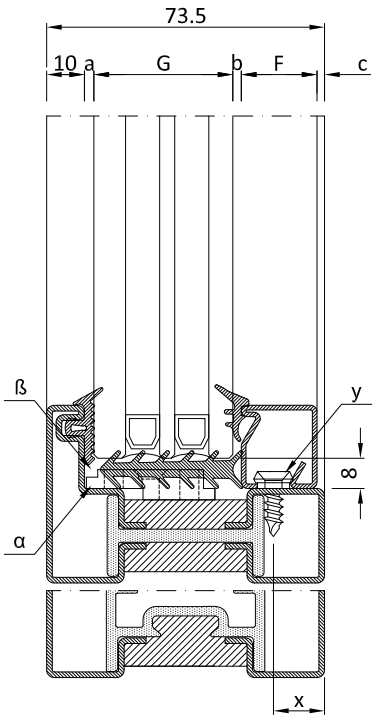


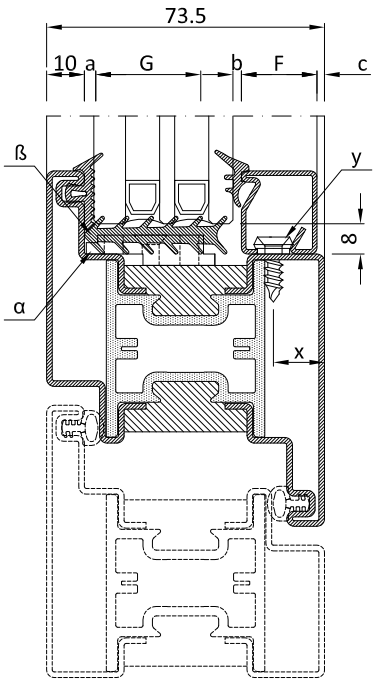
SL 0019

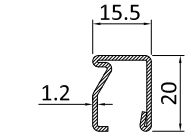
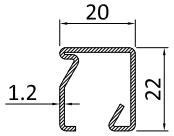
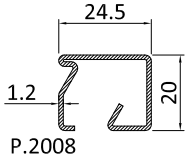
Sigillante a freddo per giunzione angoli e traversi

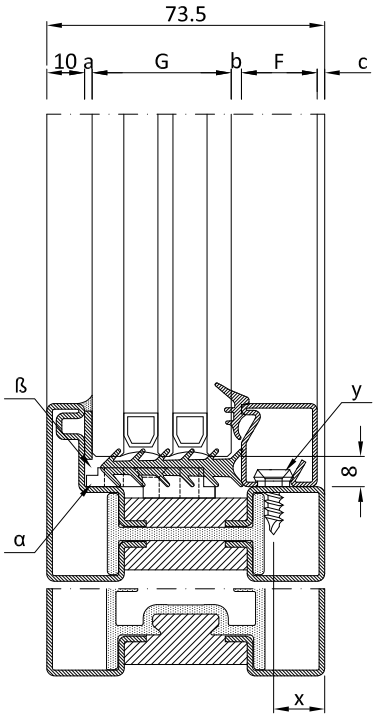
Cold sealant for corner and transom joints

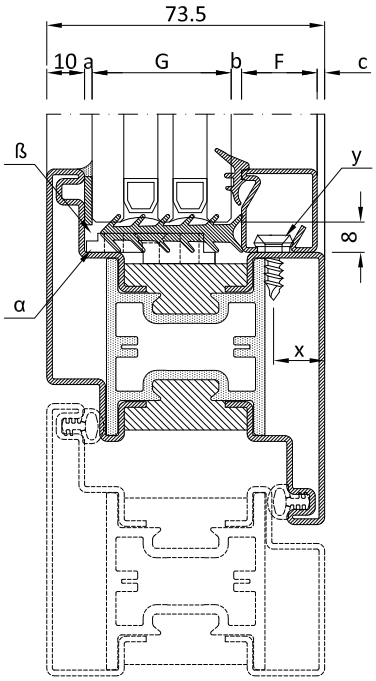
1 kg

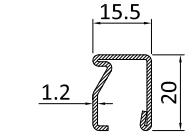
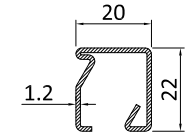
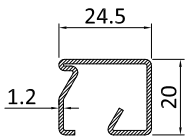


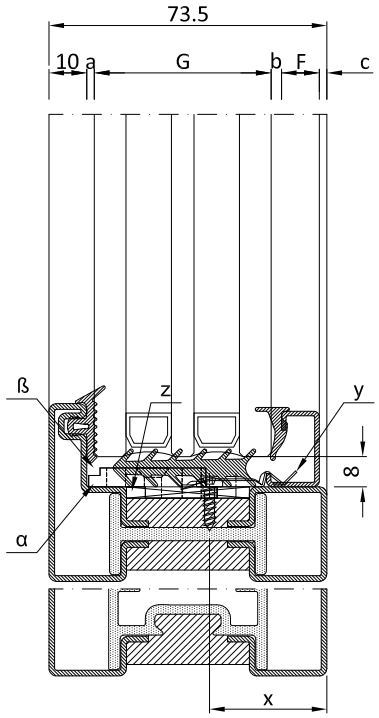


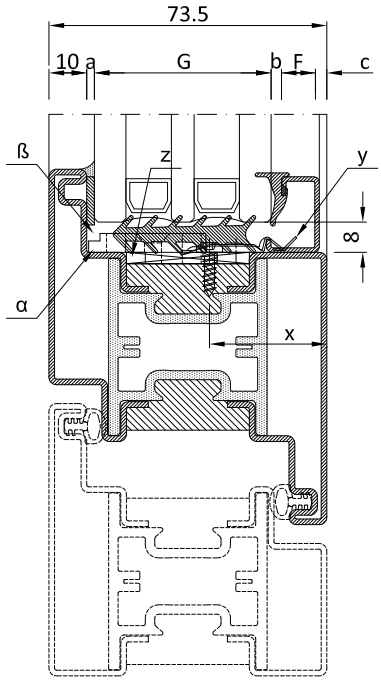
F	G	Guarnizioni - *gaskets*										
fermavetro *glazing bead*	range vetro *glass range*	GE1006 3 mm	GP0095 2 / 3 mm	GE1011 3 / 4 mm	GE1012 6 / 8 mm	GE1013 12 / 16 mm	asse fissaggio viti fermavetro *securing axis for screws for the glazing beads*	rientro fermavetro *glazing beads gap*	boccole e viti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

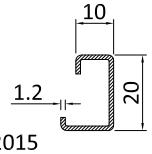


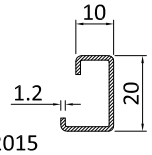


F	G	Guarnizioni - *gaskets*										
fermavetro *glazing bead*	range vetro *glass range*	GU2035 2 mm + sigillatura *+ sealing*	GP0095 2 / 3 mm	GE1011 3 / 4 mm	GE1012 6 / 8 mm	GE1013 12 / 16 mm	asse fissaggio viti fermavetro *securing axis for screws for the glazing beads*	rientro fermavetro *glazing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

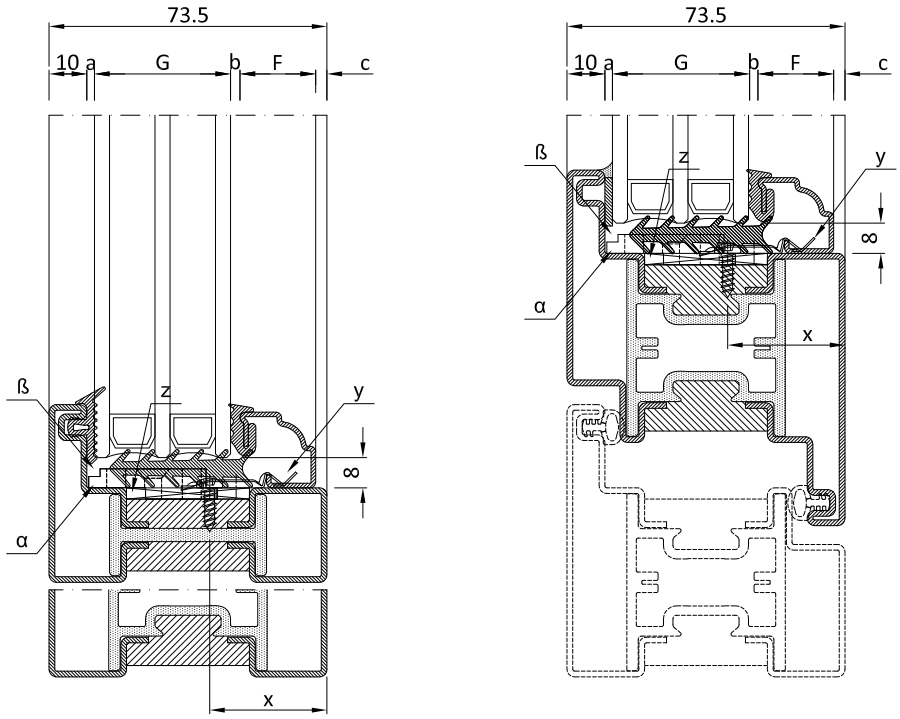


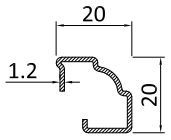


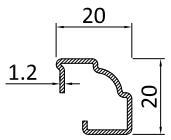
F		Guarnizioni - *gaskets*		G						
fermavetro *glazing bead*	range vetro *glass range*	GE1006 3 mm	GP0095 3 mm	spessore vetro *glass thickness*	asse fissaggio viti fermavetro *securing axis for screws for the glazing beads*	rientro fermavetro *glazing beads gap*	clips fissaggio fermavetro *securing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

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

*non fornito
**not included*

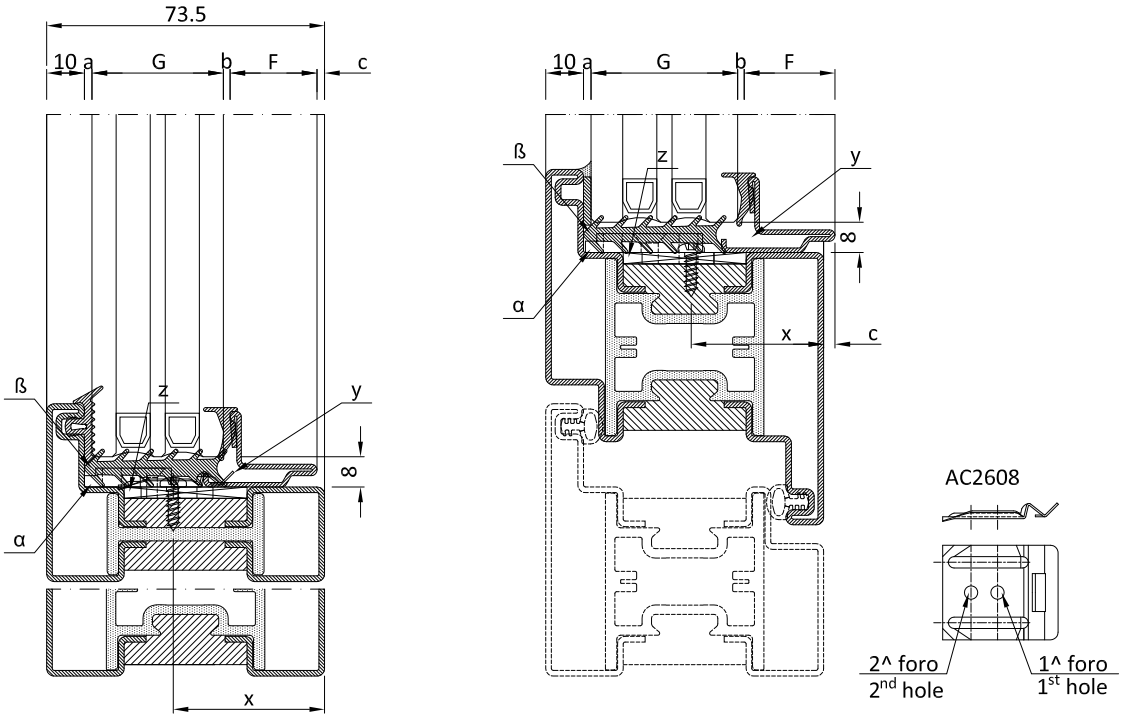


F		Guarnizioni - *gaskets*		G						
fermavetro *glazing bead*	range vetro *glass range*	GE1006 3 mm	GE2028 2.5 mm	spessore vetro *glass thickness*	asse fissaggio viti fermavetro *securing axis for screws for the glazing beads*	rientro fermavetro *glazing beads gap*	clips fissaggio fermavetro *securing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

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

*non fornito
**not included*

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



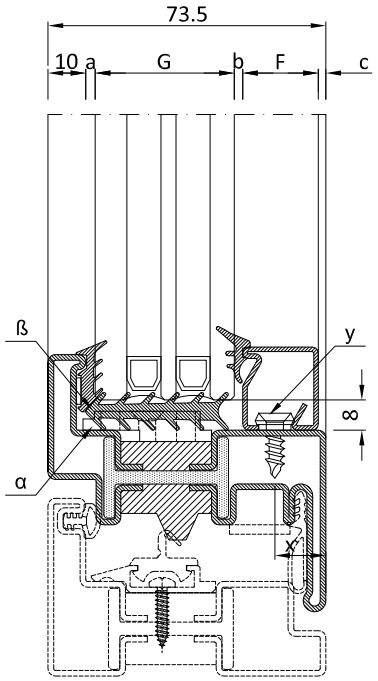
F		Guarnizioni - *gaskets*		G						
fermavetro *glazing bead*	range vetro *glass range*	GE1006 3 mm	GP0095 3 mm	spessore vetro *glass thickness*	asse fissaggio viti fermavetro *securing axis for screws for the glazing beads*	rientro fermavetro *glazing beads gap*	clips fissaggio fermavetro *securing clips for glazing beads*	spessore di compensazione * *Shim* *	spessore per vetro *glass shim*	guarnizione sotto vetro *under glass gasket*
Code		a	b	*mm.*	x	c	y	z	α	ß
23 / 20 P.2038	32 - 38	3	3	32	40**	2	AC2608	3 mm.	AC1020R	GE1007TT
				34	38**	0				
				36	36**	-2				
				38	34**	-4				

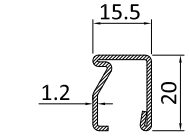
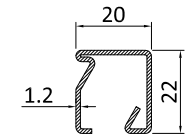
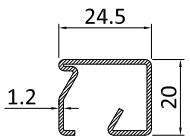
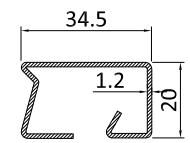
F		Guarnizioni - *gaskets*		G						
fermavetro *glazing bead*	range vetro *glass range*	GU2035 2 mm + sigillatura *+ sealing*	GP0095 3 mm	spessore vetro *glass thickness*	asse fissaggio viti fermavetro *securing axis for screws for the glazing beads*	rientro fermavetro *glazing beads gap*	clips fissaggio fermavetro *securing clips for glazing beads*	spessore di compensazione * *Shim* *	spessore per vetro *glass shim*	guarnizione sotto vetro *under glass gasket*
Code		a	b	*mm.*	x	c	y	z	α	ß
23 / 20 P.2038	33 - 39	2	3	33	40**	2	AC2608	3 mm.	AC1020R	GE1007TT
				35	38**	0				
				37	36**	-2				
				39	34**	-4				

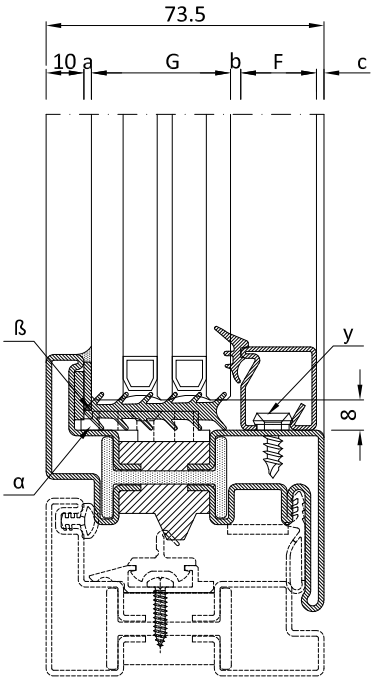
*non fornito
**not included*

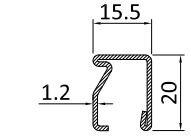
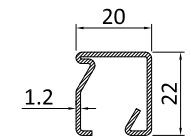
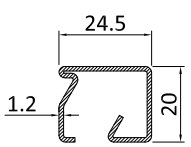
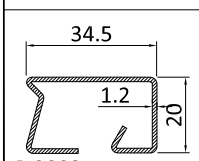
** fissare tramite il primo foro della clip
*** screw in the upper hole of the clip*

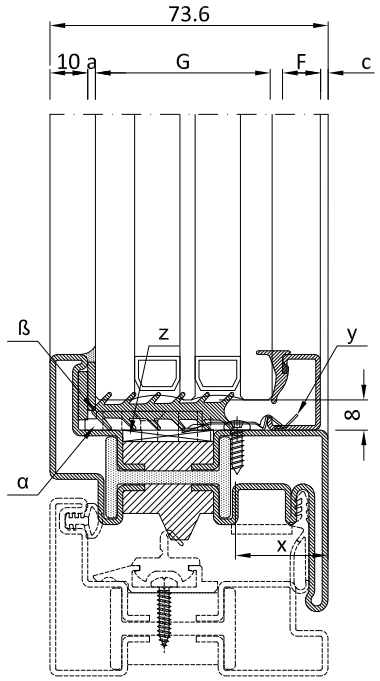
Taglio a 45° dei fermavetri effettuabile utilizzando la ganascia AT2038
45° cutting of the glazing beads done using the cutting jaw AT2038

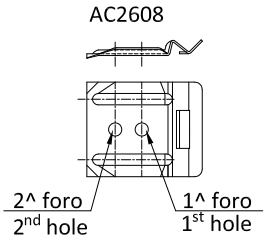


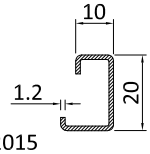
F	G	Guarnizioni - *gaskets*										
fermavetro *glazing bead*	range vetro *glass range*	GE1206 3 mm	GP0095 2 / 3 mm	GE1011 3 / 4 mm	GE1012 6 / 8 mm	GE1013 12 / 16 mm	asse fissaggio viti fermavetro *securing axis for screws for the glazing beads*	rientro fermavetro *glazing beads gap*	boccole e viti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

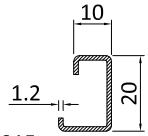


F	G	Guarnizioni - *gaskets*										
fermavetro *glazing bead*	range vetro *glass range*	GU2035 2 mm + sigillatura *+ sealing*	GP0095 2 / 3 mm	GE1011 3 / 4 mm	GE1012 6 / 8 mm	GE1013 12 / 16 mm	asse fissaggio viti fermavetro *securing axis for screws for the glazing beads*	rientro fermavetro *glazing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



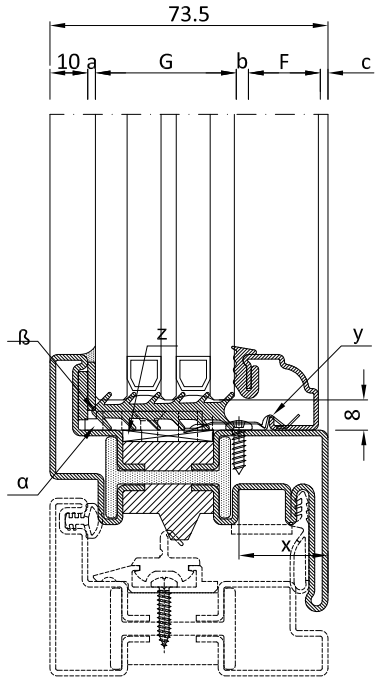


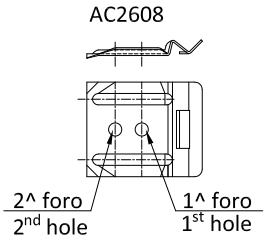
		Guarnizioni - *gaskets*		G						
fermavetro *glazing bead*	range vetro *glass range*	GE1206 3 mm	GP0095 3 mm	spessore vetro *glass thickness*	asse fissaggio viti fermavetro *securing axis for screws for the glazing beads*	rientro fermavetro *glazing beads gap*	clips fissaggio fermavetro *securing clips for glazing beads*	spessore di compensazione * *Shim* *	spessore per vetro *glass shim*	guarnizione sotto vetro *under glass gasket*
Code		a	b	*mm.*	x	c	y	z	α	ß
 P.2015	43 - 45	3	3	43	26**	2	AC2608	3 mm.	AC1020M	GE1007TT
				45	24**	0				

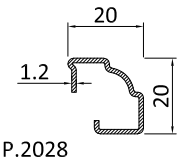
F		Guarnizioni - *gaskets*		G						
fermavetro *glazing bead*	range vetro *glass range*	GU2035 2 mm + sigillatura *+ sealing*	GP0095 3 mm	spessore vetro *glass thickness*	asse fissaggio viti fermavetro *securing axis for screws for the glazing beads*	rientro fermavetro *glazing beads gap*	clips fissaggio fermavetro *securing clips for glazing beads*	spessore di compensazione * *Shim* *	spessore per vetro *glass shim*	guarnizione sotto vetro *under glass gasket*
Code		a	b	*mm.*	x	c	y	z	α	ß
 P.2015	44 - 46	2	3	44	26**	2	AC2608	3 mm.	AC1020M	GE1007TT
				46	24**	0				

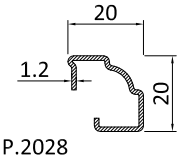
*non fornito
**not included*

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





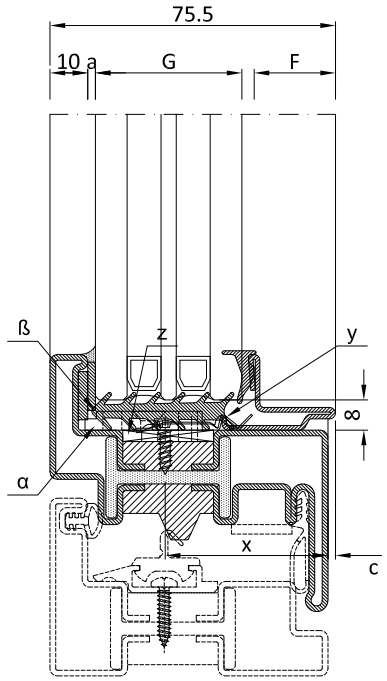
F		Guarnizioni - *gaskets*		G						
fermavetro *glazing bead*	range vetro *glass range*	GE1206 3 mm	GE2028 2.5 mm	spessore vetro *glass thickness*	asse fissaggio viti fermavetro *securing axis for screws for the glazing beads*	rientro fermavetro *glazing beads gap*	clips fissaggio fermavetro *securing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

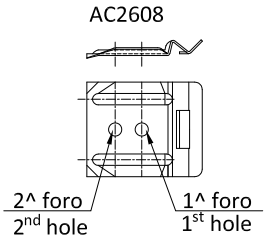
F				G						
fermavetro *glazing bead*	range vetro *glass range*	GU2035 2 mm + sigillatura *+ sealing*	GE2028 2.5 mm	spessore vetro *glass thickness*	asse fissaggio viti fermavetro *securing axis for screws for the glazing beads*	rientro fermavetro *glazing beads gap*	clips fissaggio fermavetro *securing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

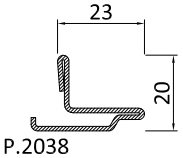
*non fornito
**not included*

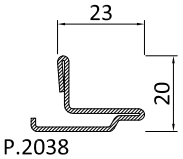
** fissare tramite il primo foro della clip
*** screw in the upper hole of the clip*

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





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

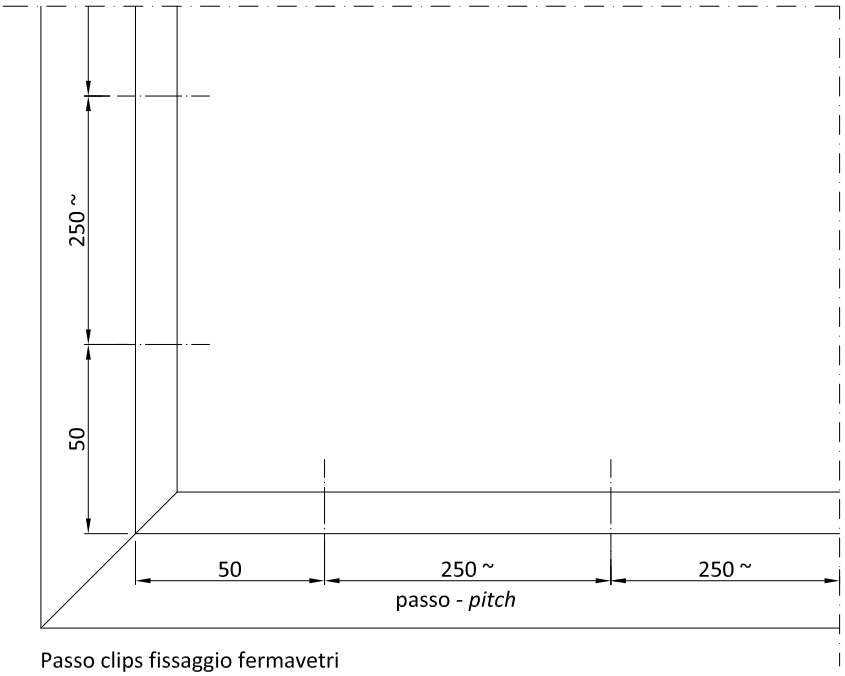
F		Guarnizioni - *gaskets*		G						
fermavetro *glazing bead*	range vetro *glass range*	GU2035 2 mm + sigillatura *+ sealing*	GP0095 3 mm	spessore vetro *glass thickness*	asse fissaggio viti fermavetro *securing axis for screws for the glazing beads*	rientro fermavetro *glazing beads gap*	clips fissaggio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

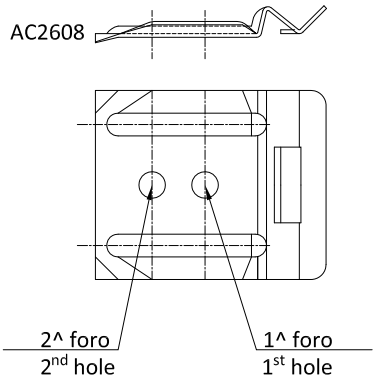
*non fornito
**not included*

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

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

P.2015 - P.2028 - P.2038



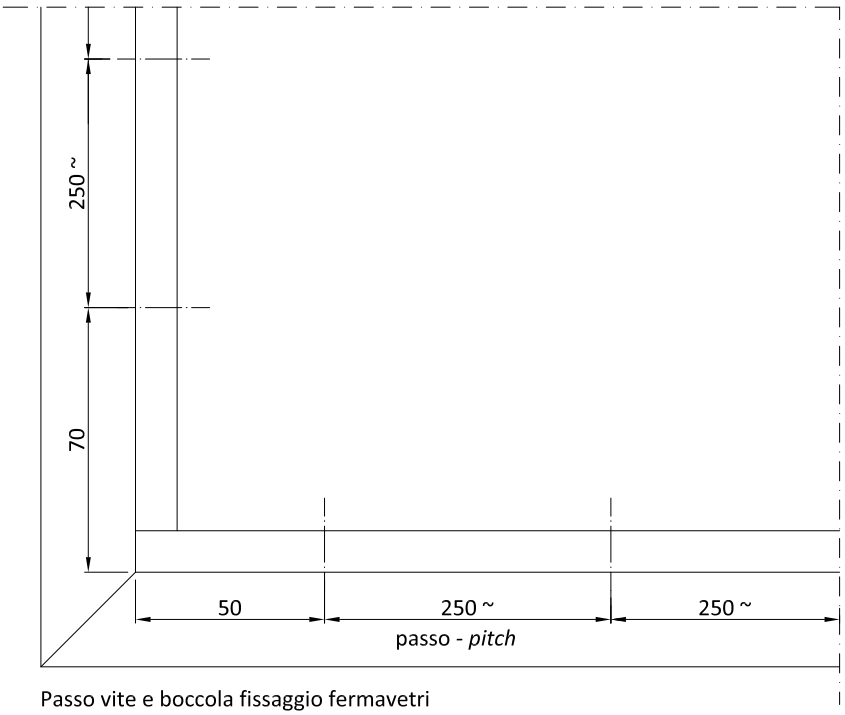


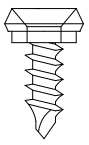
Passo clips fissaggio fermavetri
Clip pitch for fixing the glazing beads

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

Fori eseguibili con maschera AT2828
Holes to be done with AT2828

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

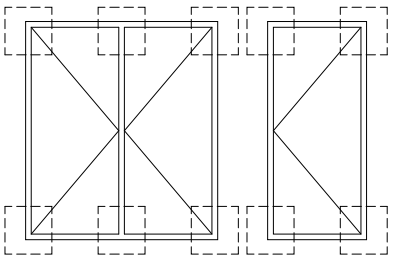




CV5001 + CV5012
CV5001I + CV5012I

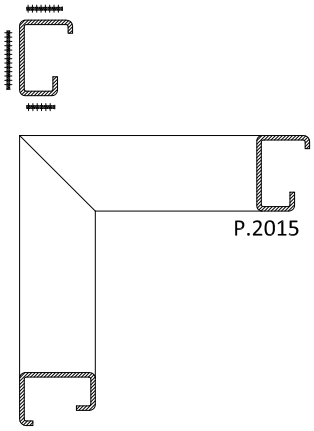
Passo vite e boccola fissaggio fermavetri
Clip pitch to fix glazing beads

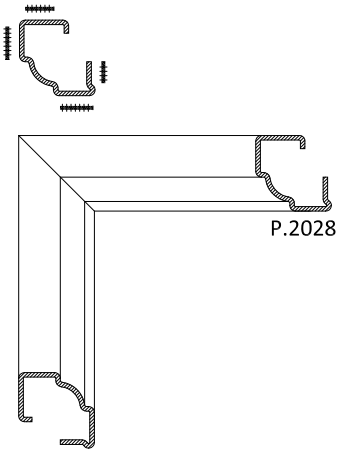
Fori eseguibili con maschera AT1234
Holes to be done with AT1234

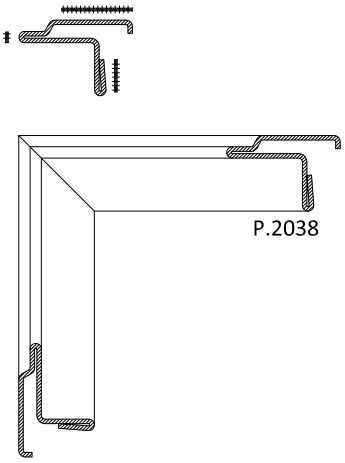


Acciaio zincato - Acciaio Corten - Acciaio inox
Saldare in continuo le superfici di contatto indicate

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

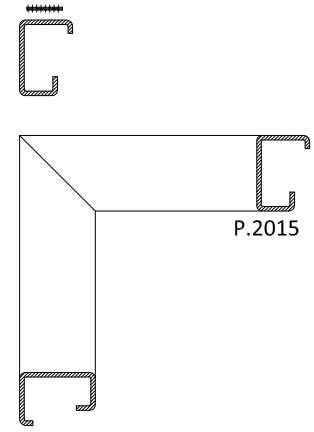


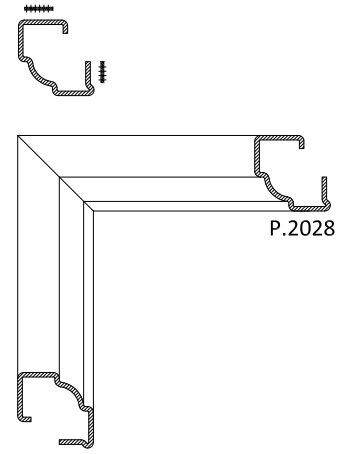


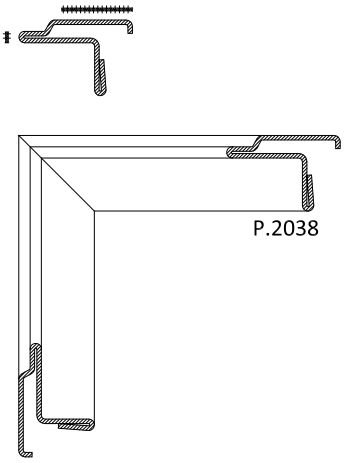


Ottone
Saldare a TIG a punti le zone indicate.

Brass
Spot weld (TIG) the marked areas.



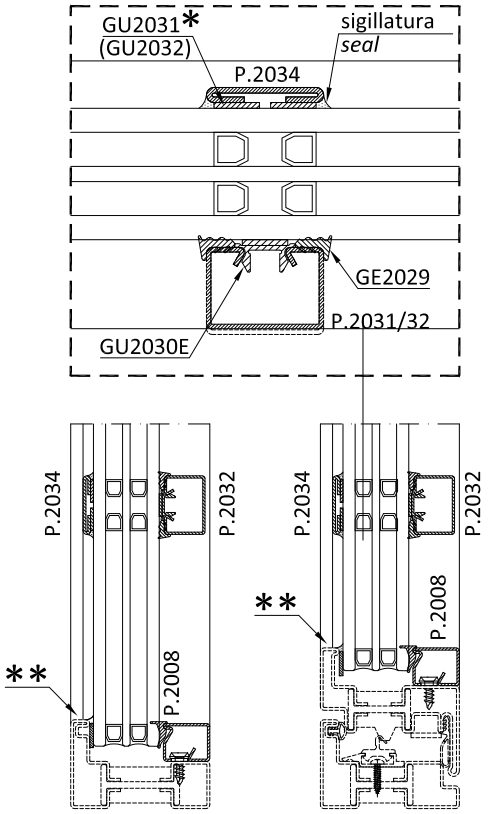


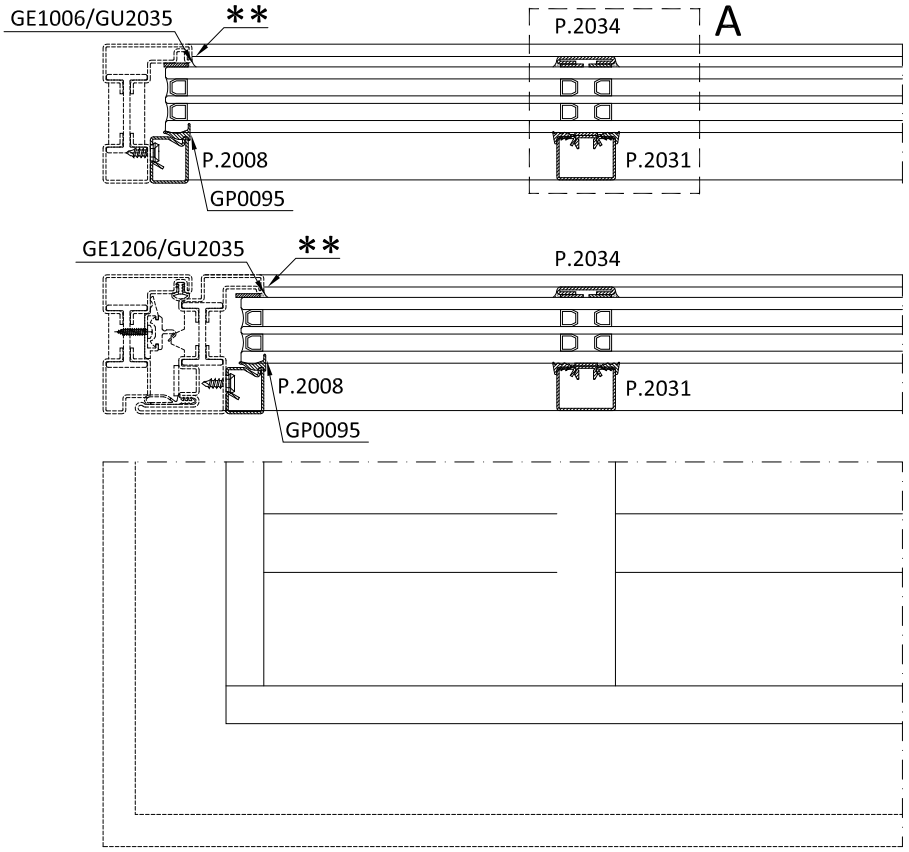


P.2028
Taglio a 45° dei fermavetri effettuabile utilizzando la ganascia AT2029
45° cutting of the glazing beads done using the cutting jaw AT2029

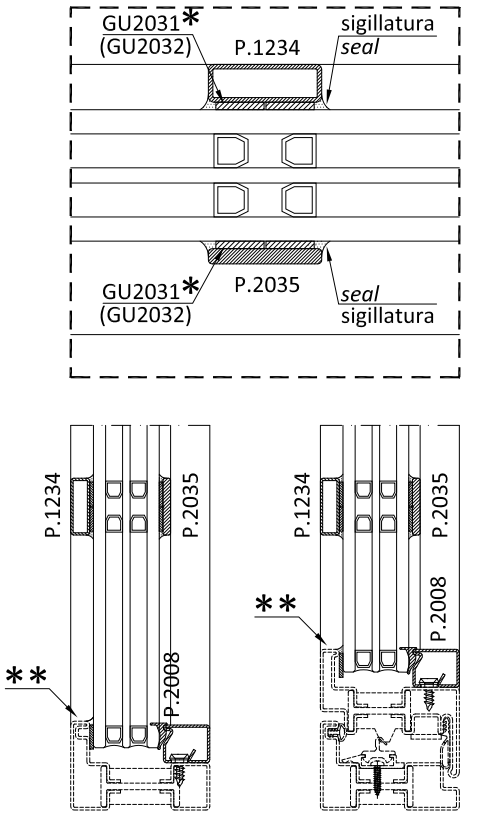
P.2038
Taglio a 45° dei fermavetri effettuabile utilizzando la ganascia AT2038
45° cutting of the glazing beads done using the cutting jaw AT2038

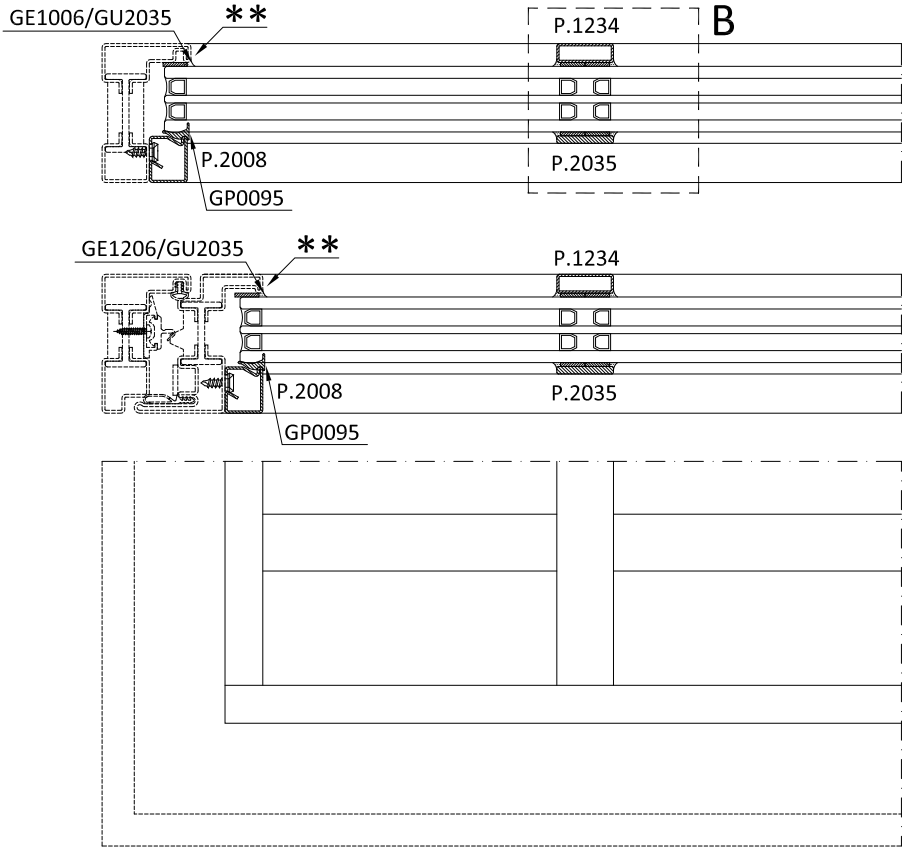
PARTICOLARE "A" _ *DETAIL "A"*





PARTICOLARE "B" _ *DETAIL "B"*

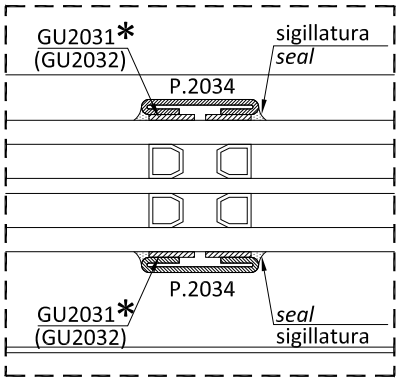


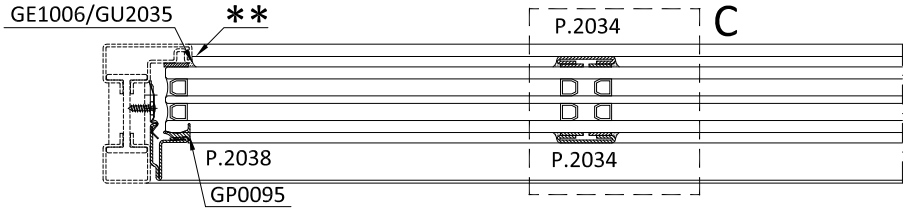


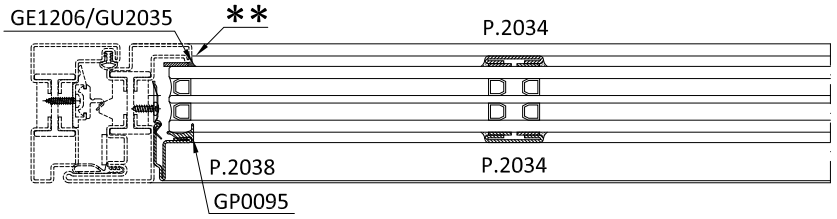
* Per utilizzo dividivetro SOLO orizzontali o SOLO verticali GU2031
Per utilizzo dividivetro orizzontali e verticali GU2031 verticalmente GU2032 orizzontalmente
For ONLY horizontal or ONLY vertical glazing beads use GU2031
For horizontal and vertical glazing beads use GU2031 vertically and GU2032 horizontally

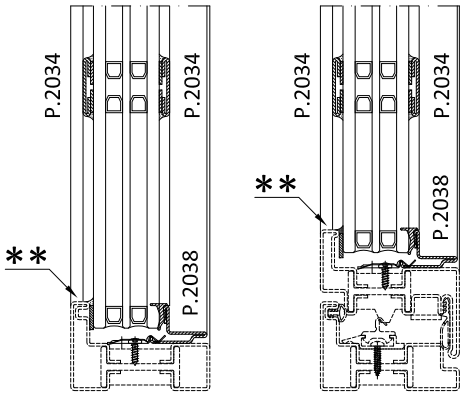
** Saldare o sigillare
Weld or seal

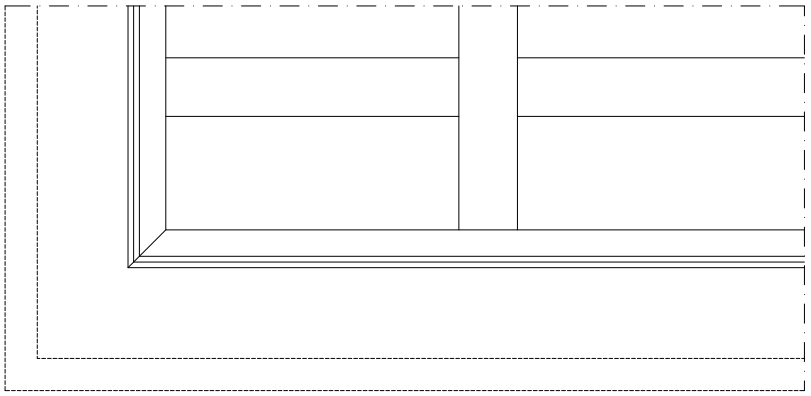
PARTICOLARE "C" _ *DETAIL "C"*



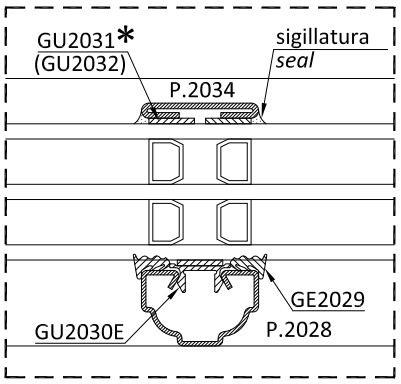


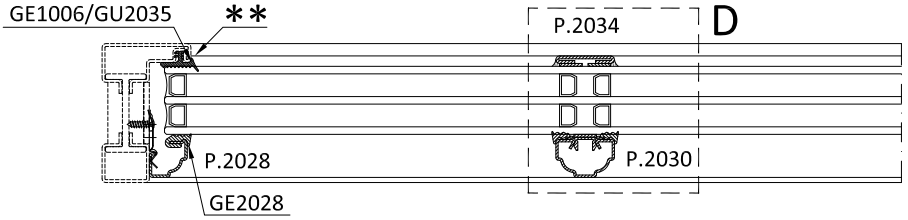


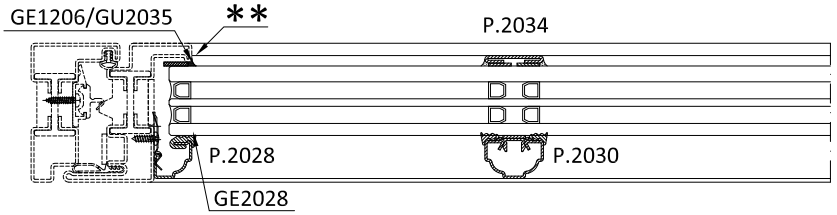


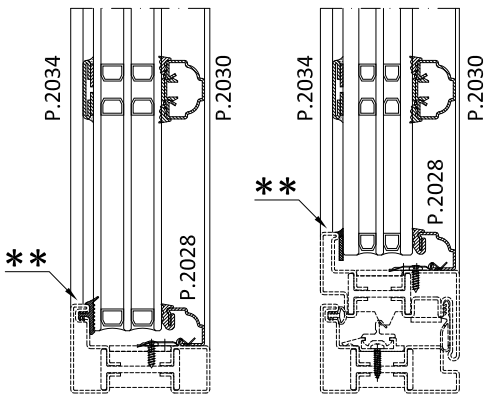


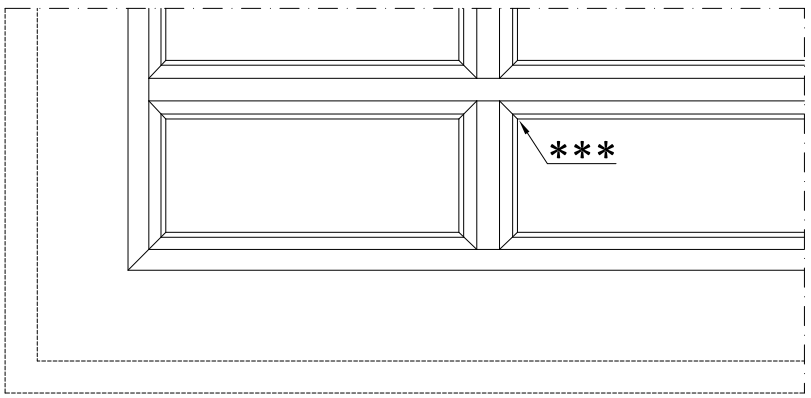
PARTICOLARE "D" _ *DETAIL "D"*







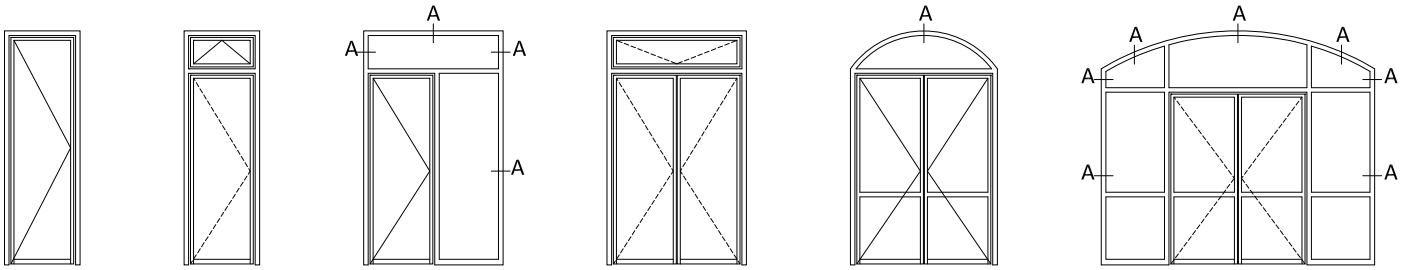




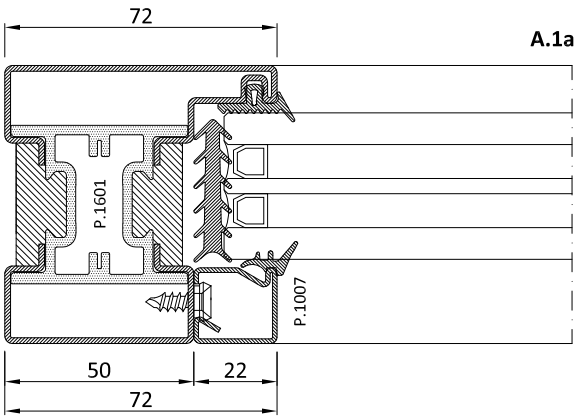
* Per utilizzo dividivetro SOLO orizzontali o SOLO verticali GU2031
Per utilizzo dividivetro orizzontali e verticali GU2031 verticalmente GU2032 orizzontalmente
For ONLY horizontal or ONLY vertical glazing beads use GU2031
For horizontal and vertical glazing beads use GU2031 vertically and GU2032 horizontally

** Saldare o sigillare
Weld or seal

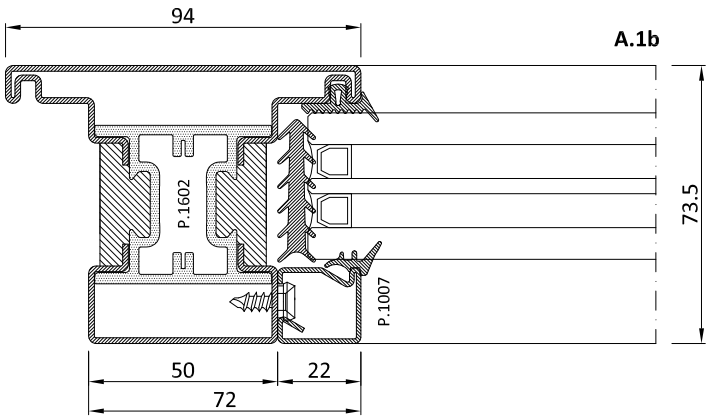
*** Lavorazione di intestatura effettuabile con stampo AT2030
Processing of butt jointing carried out with a mould



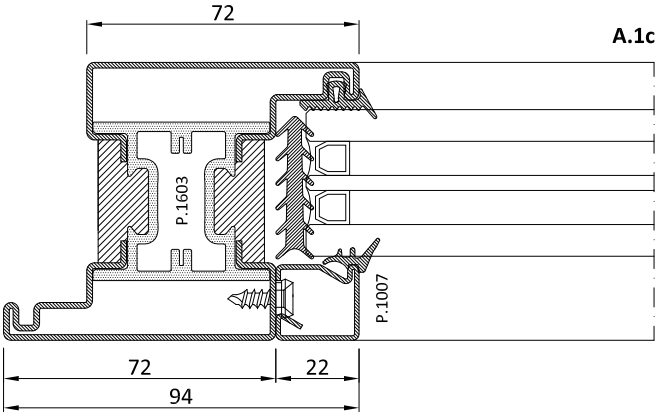
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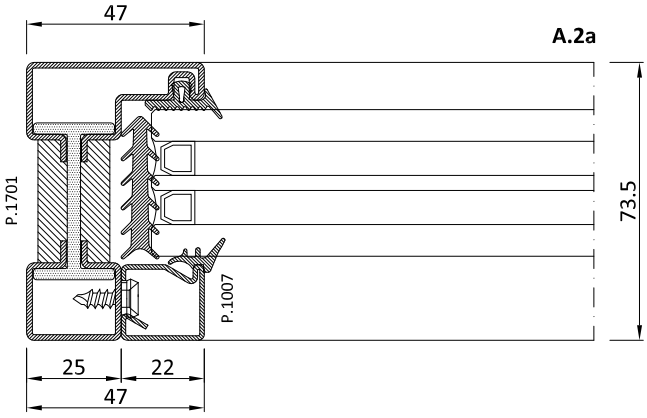
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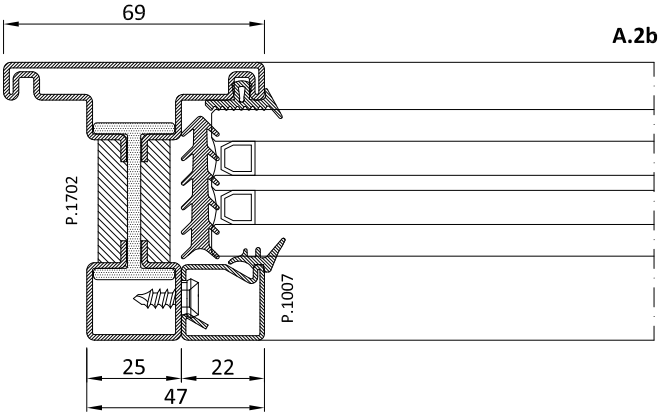
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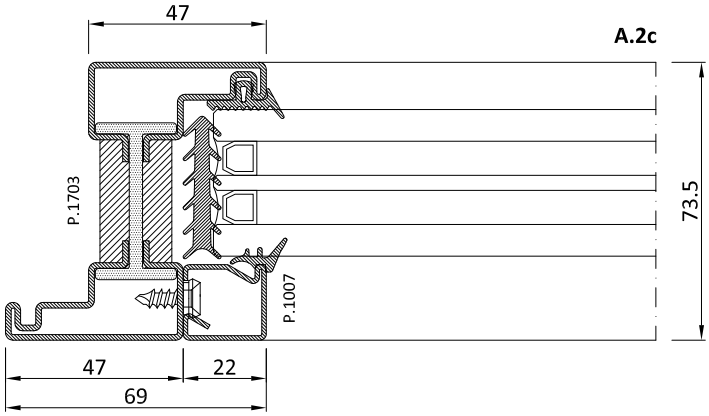
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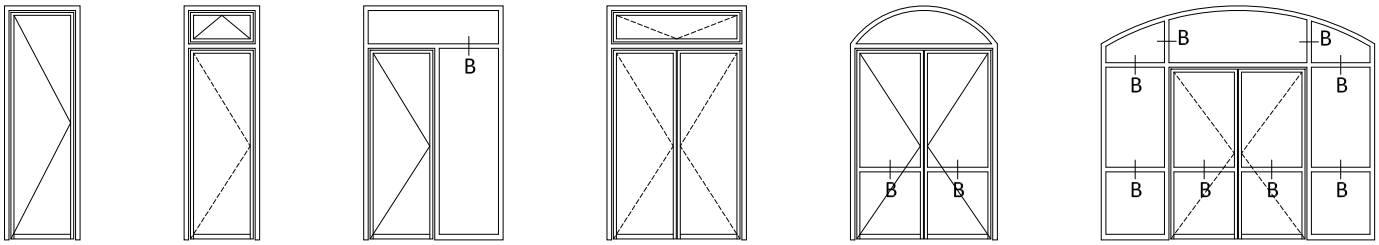


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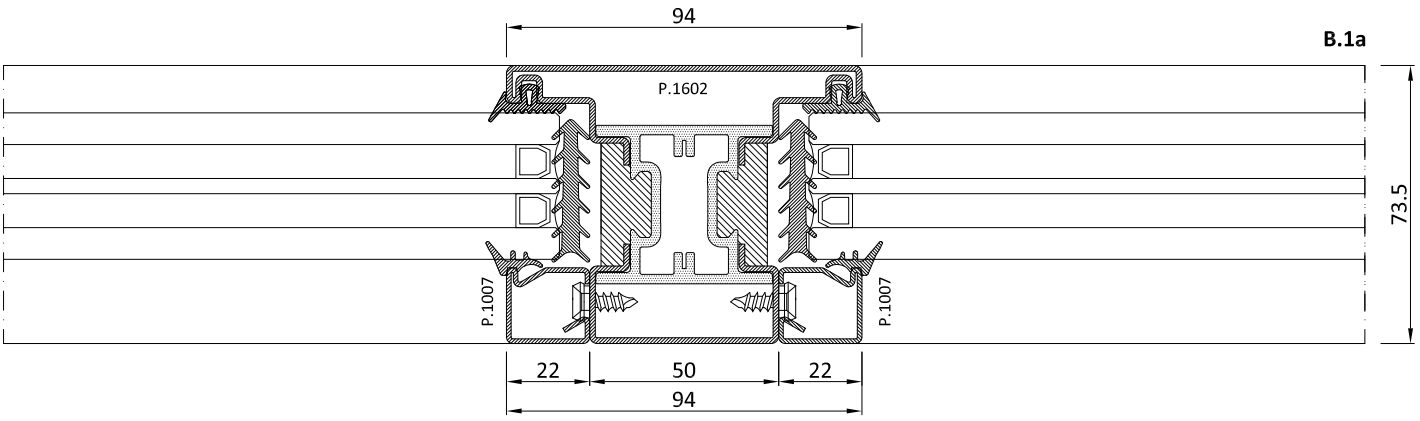


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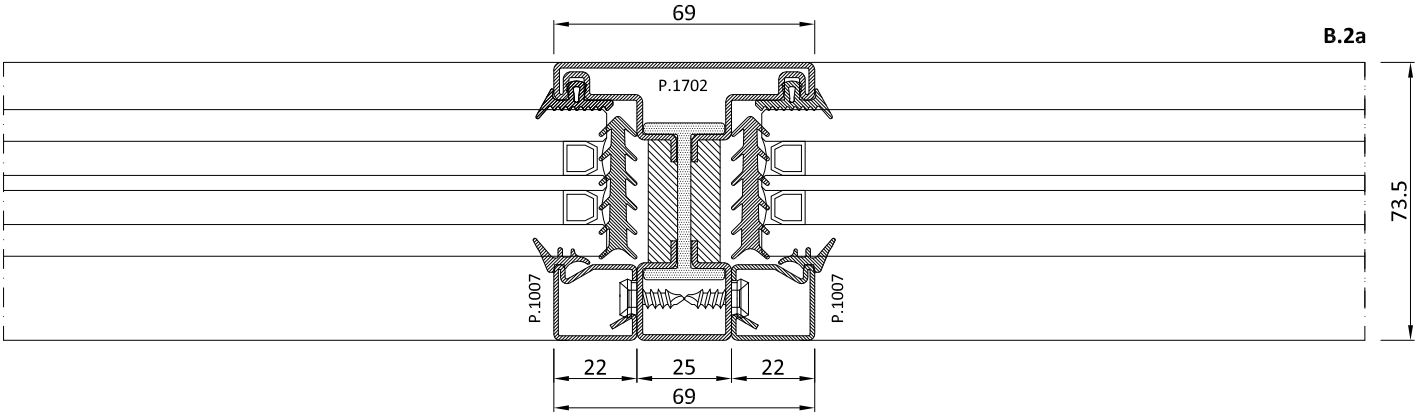


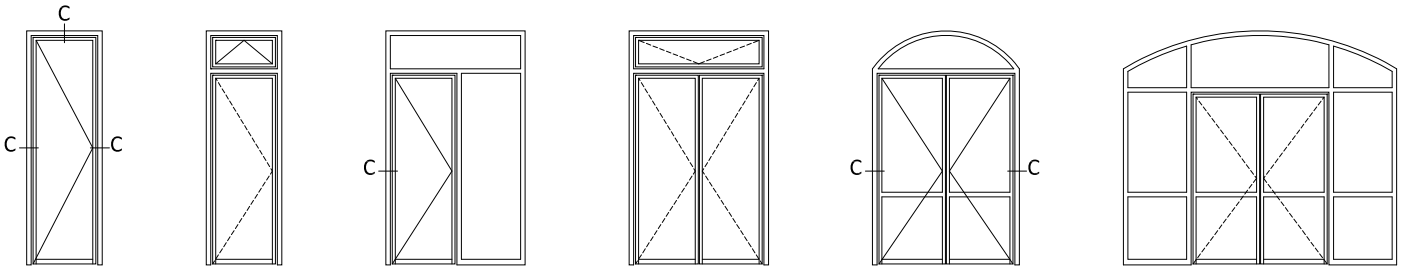

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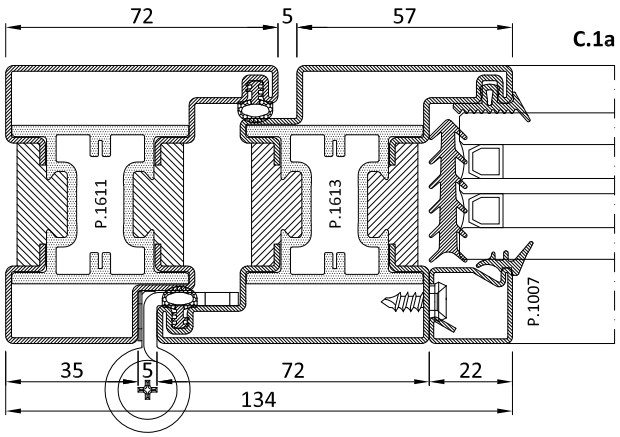
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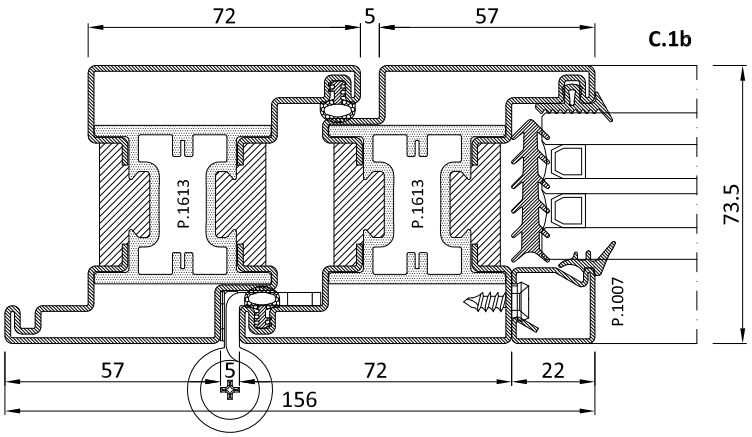

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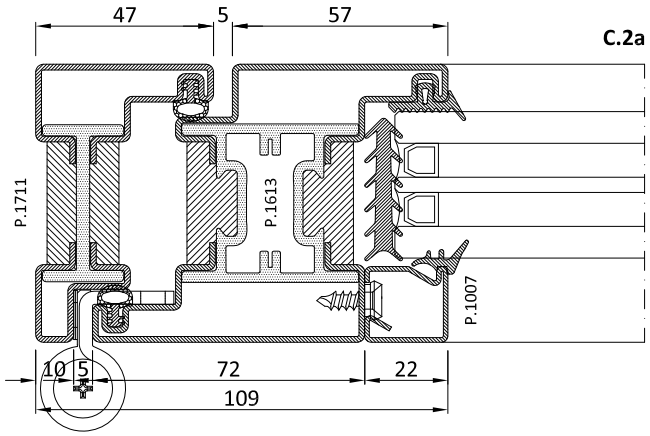
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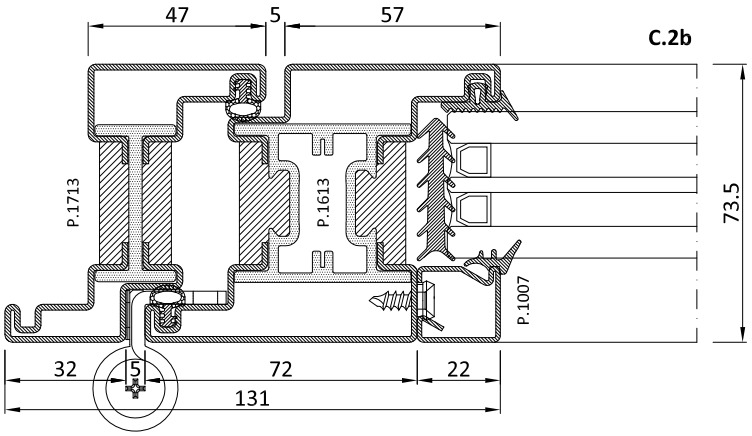

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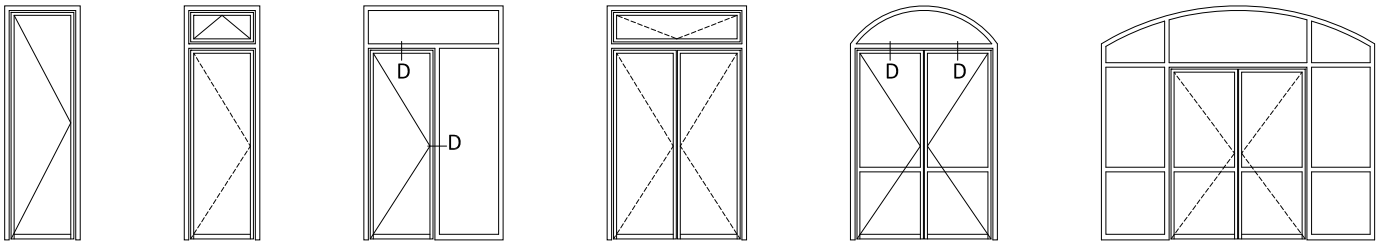

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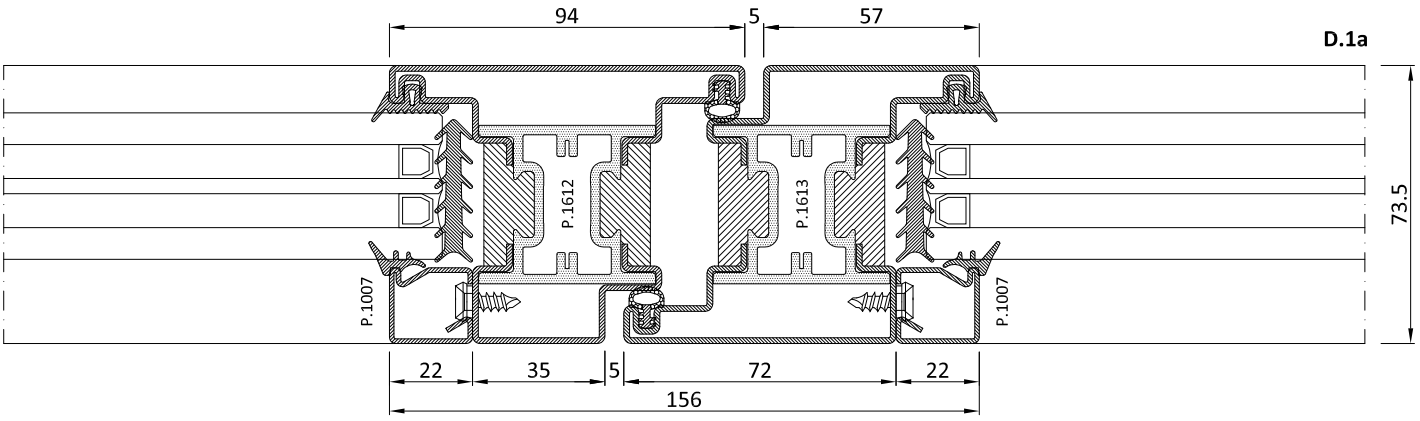

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P.1007
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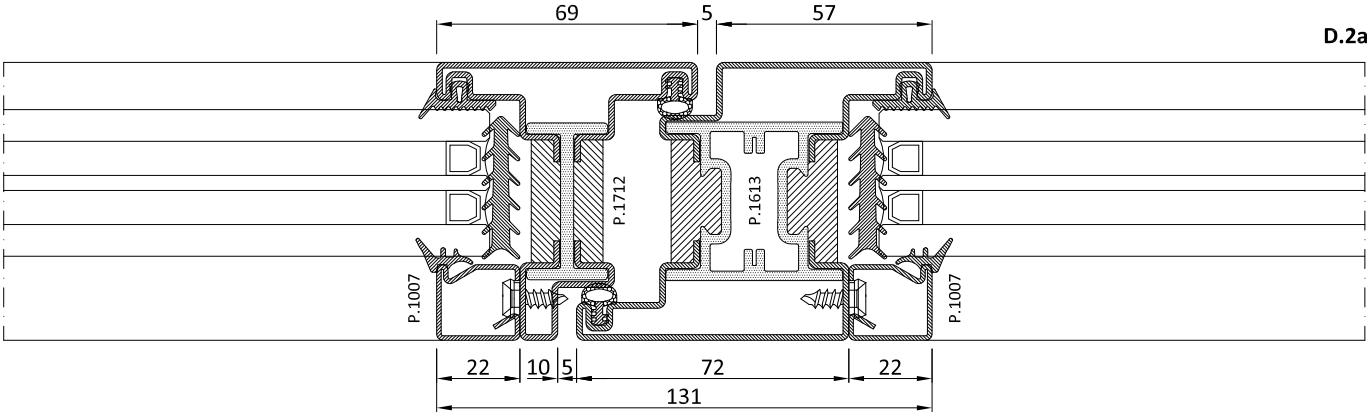

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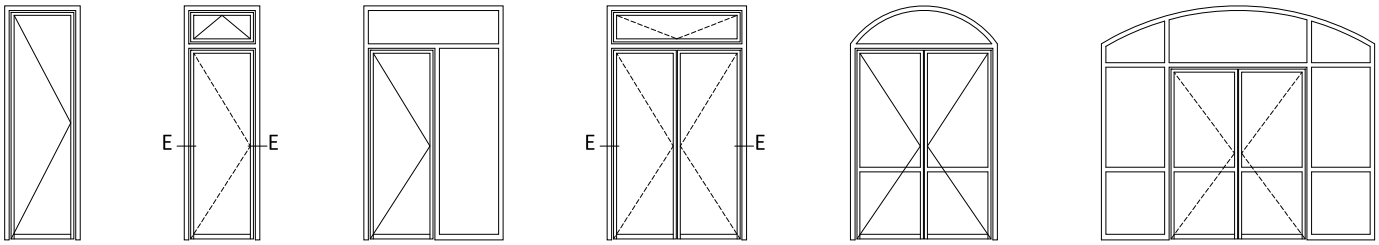

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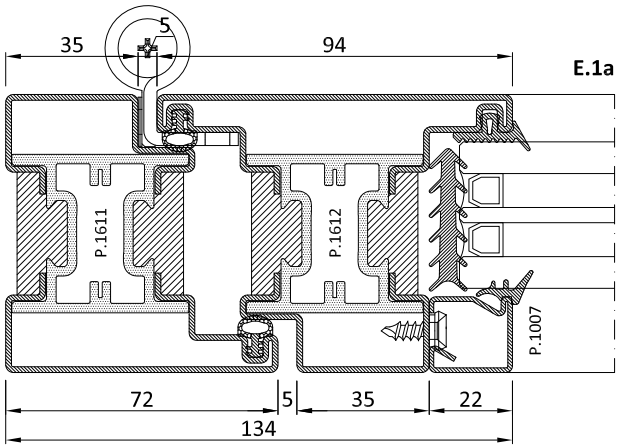
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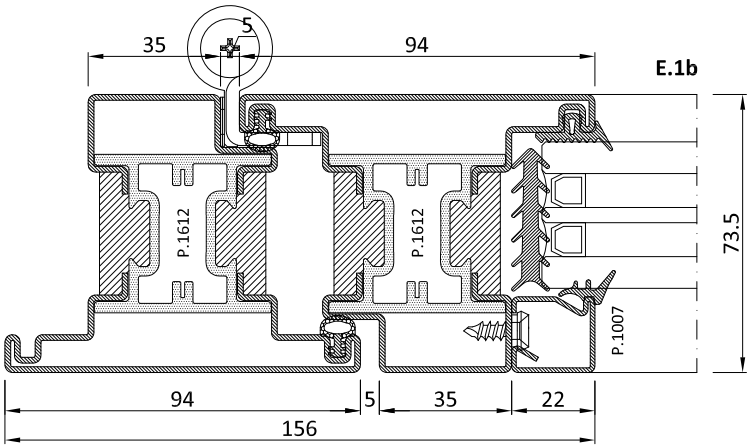

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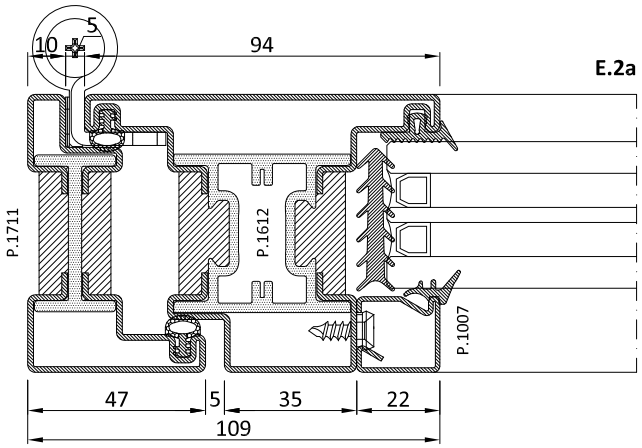
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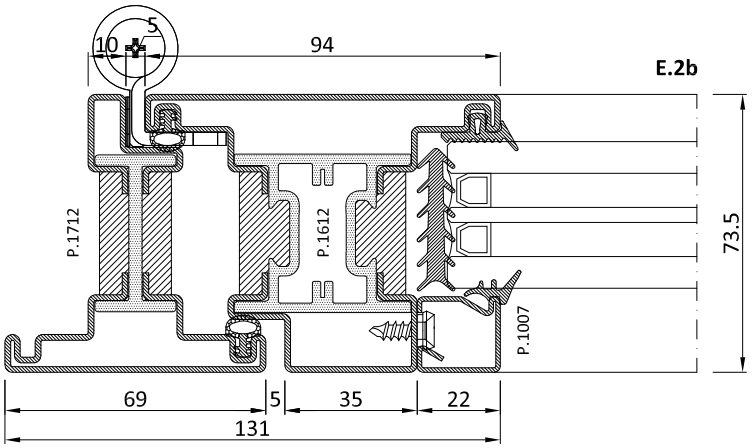

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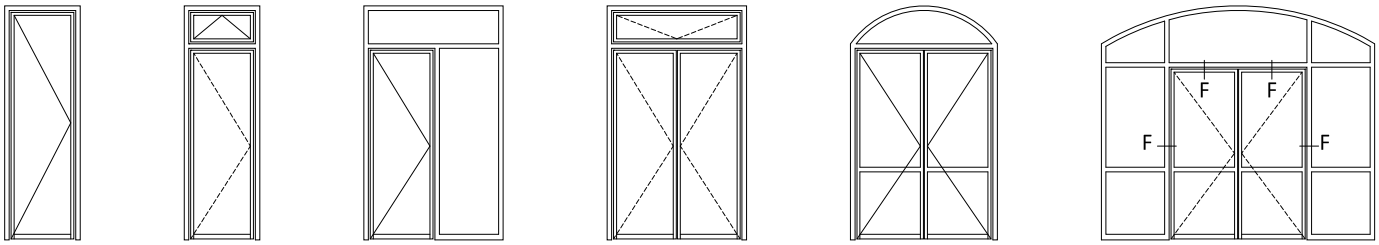

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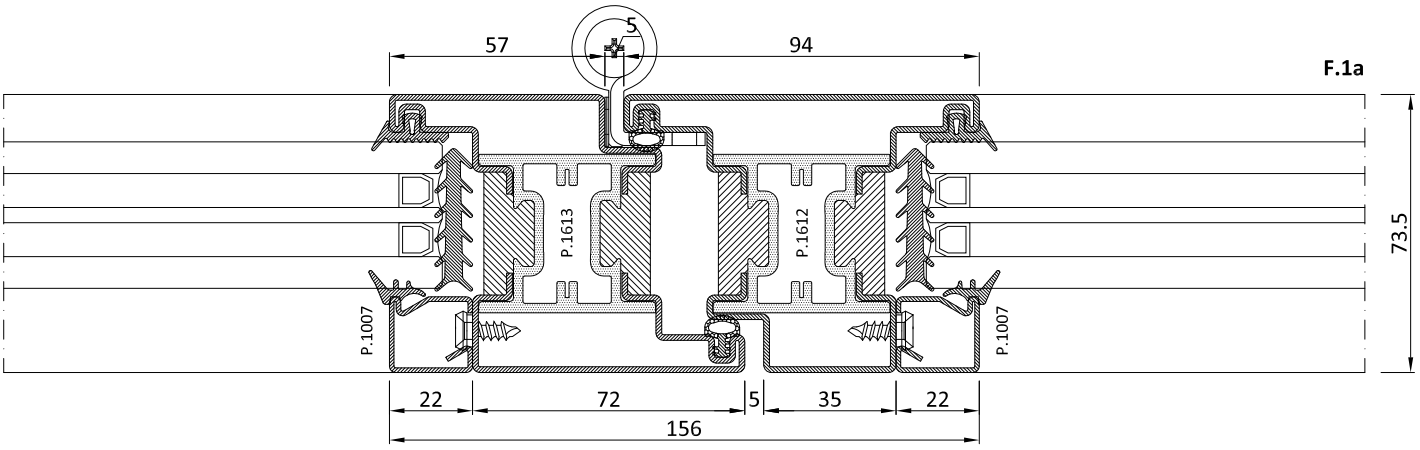

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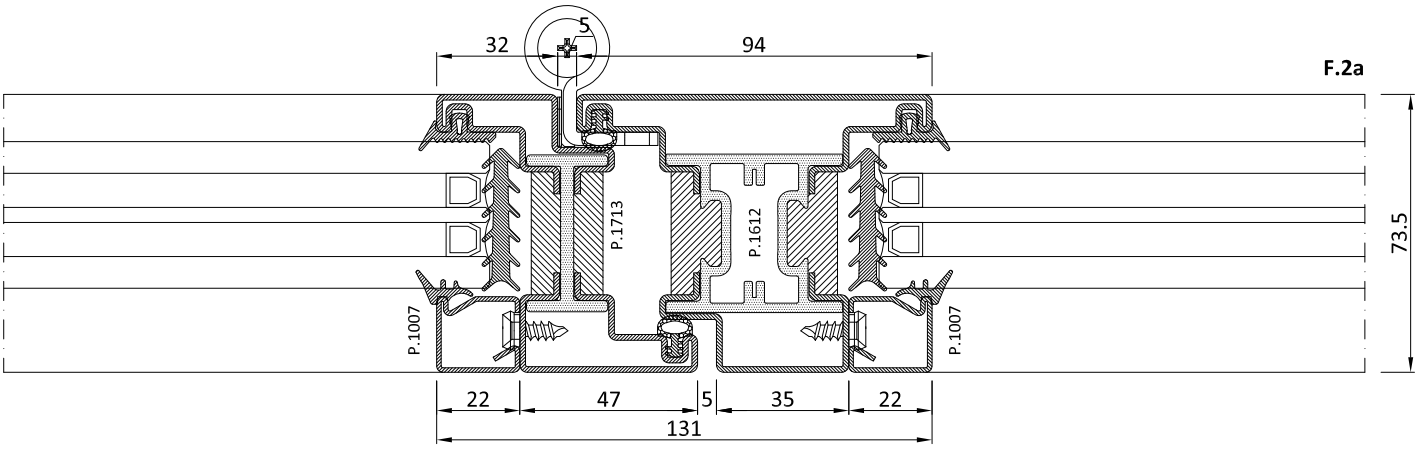

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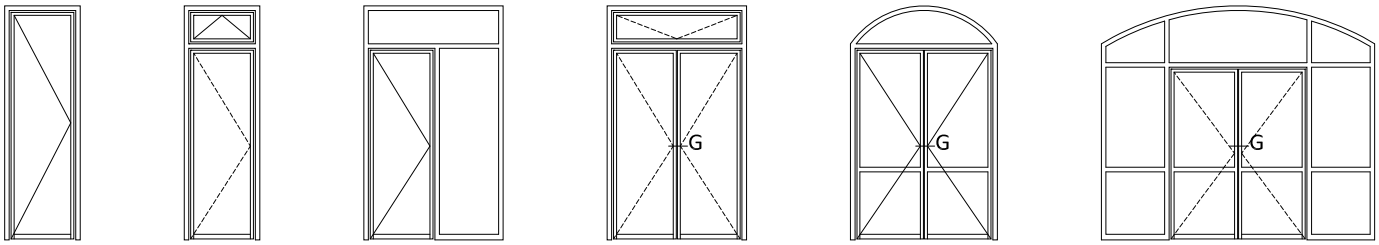

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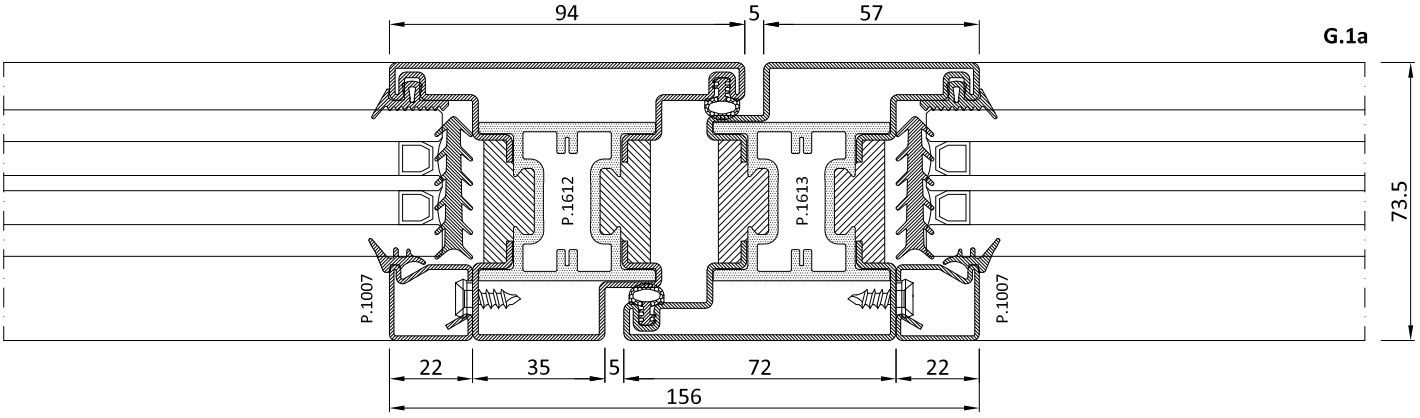

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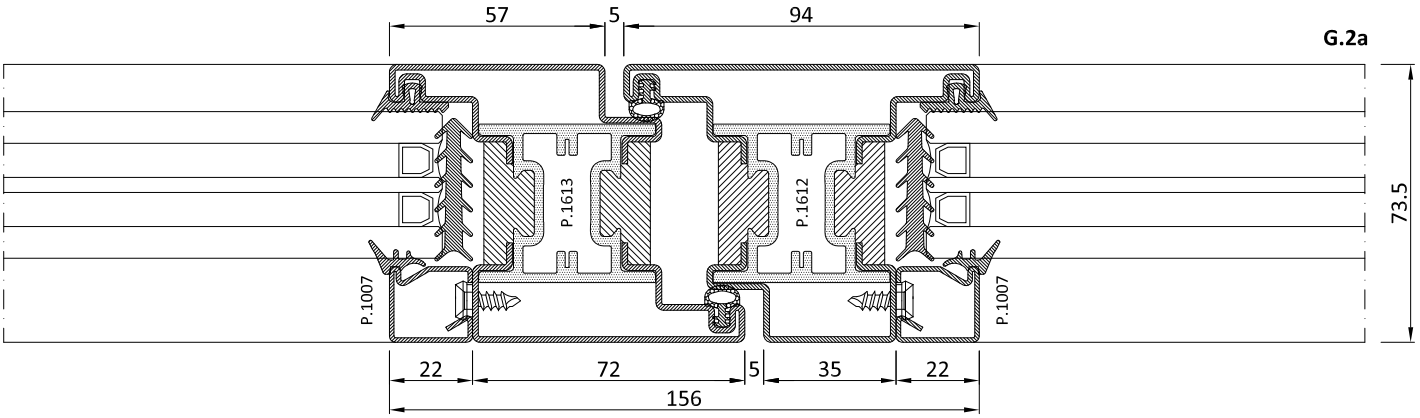

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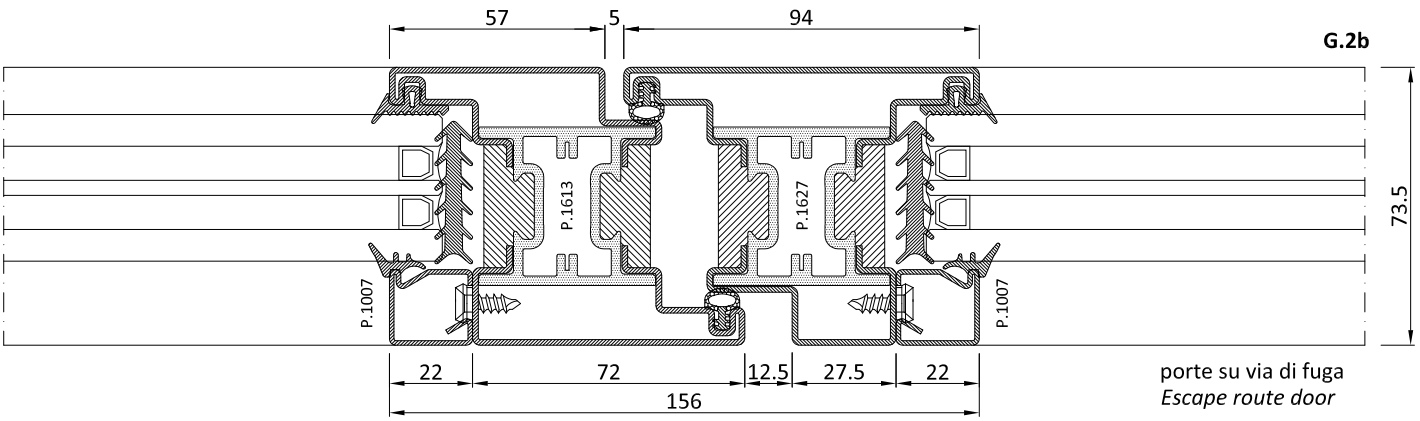
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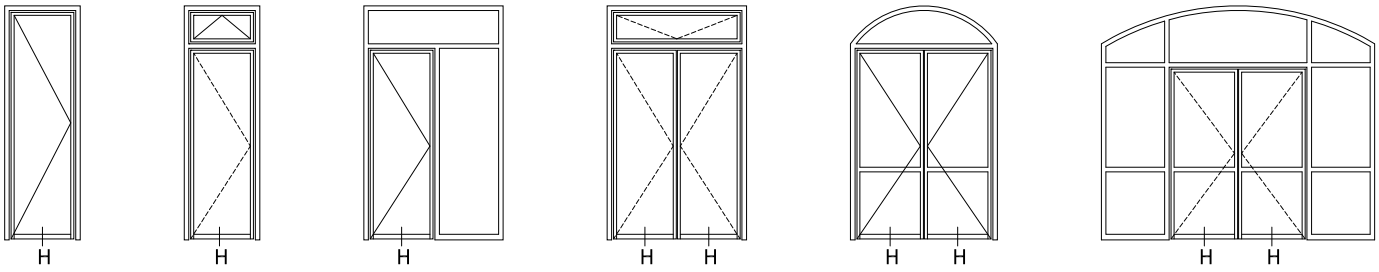
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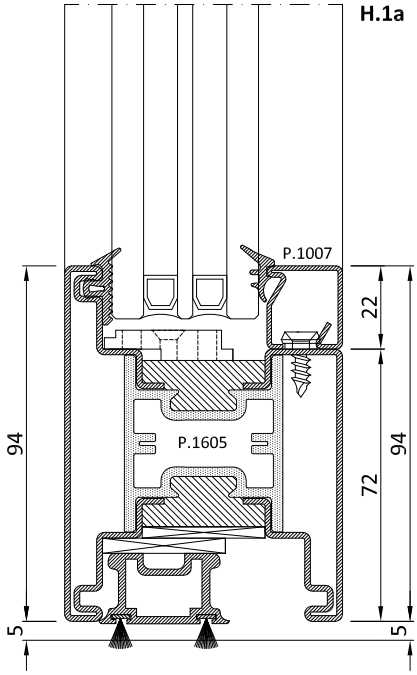
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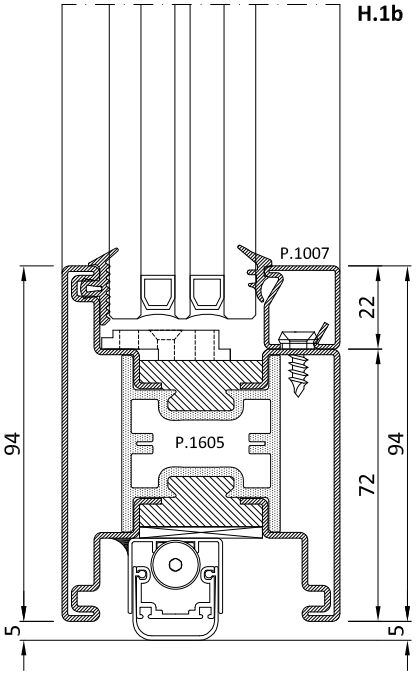
porte su via di fuga
Escape route door



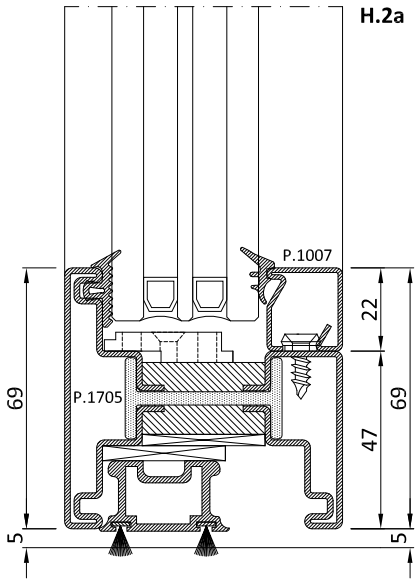
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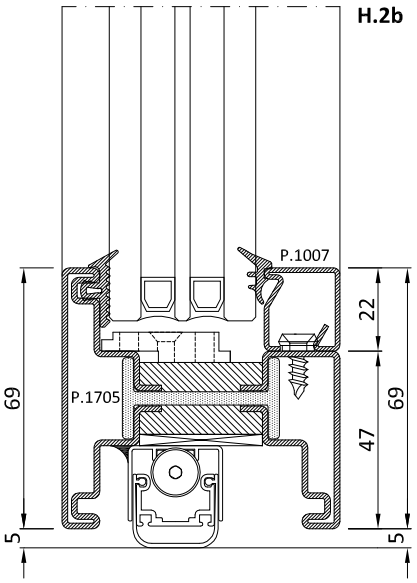
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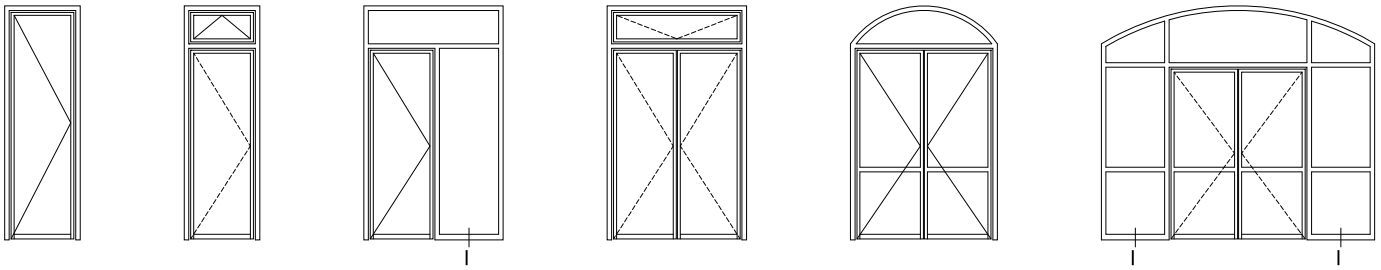


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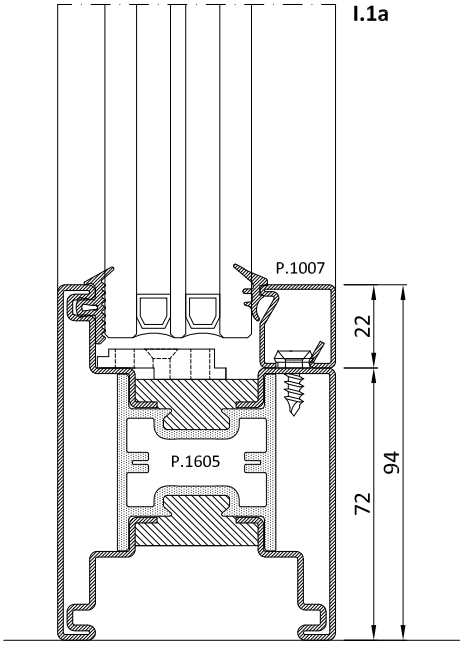


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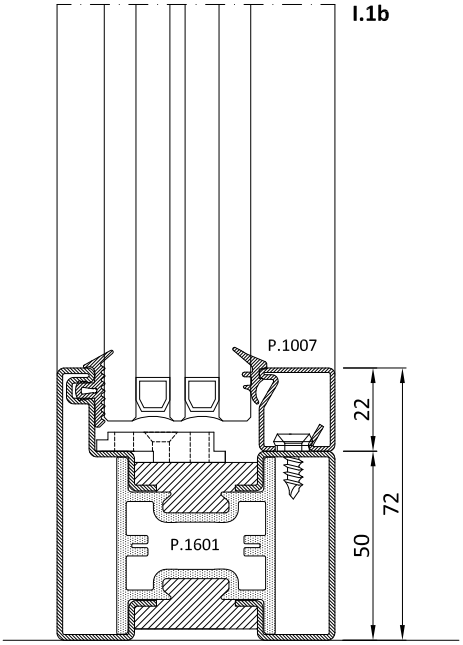




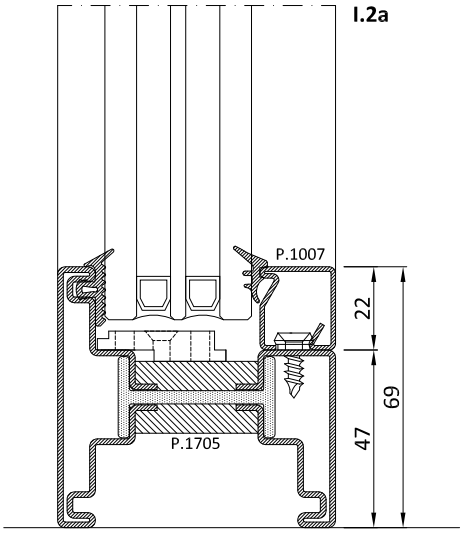
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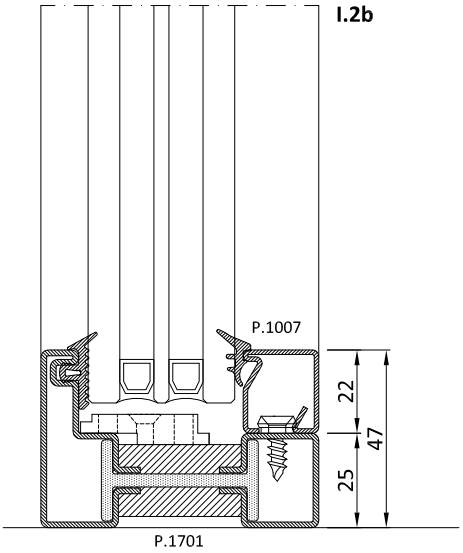
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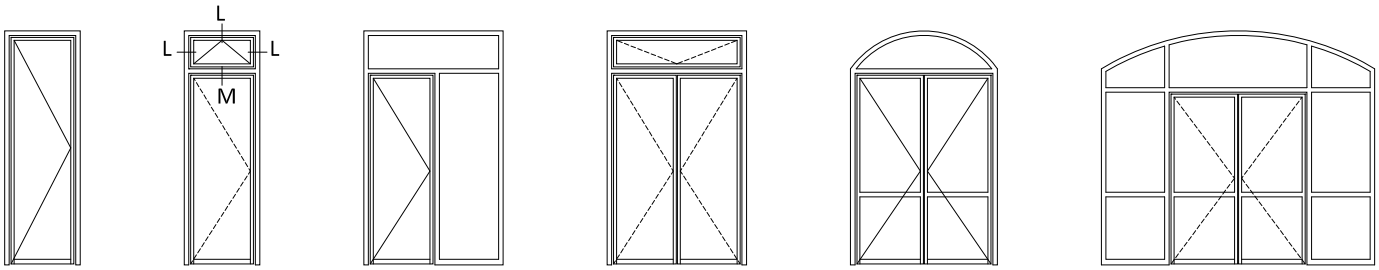


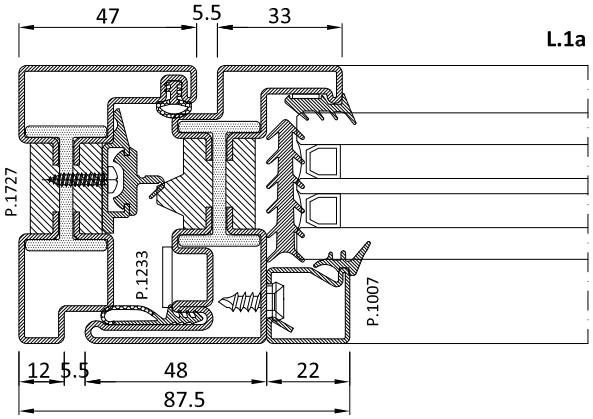
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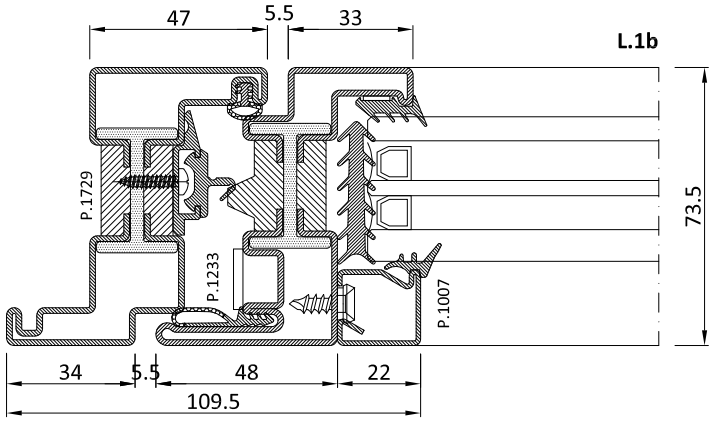


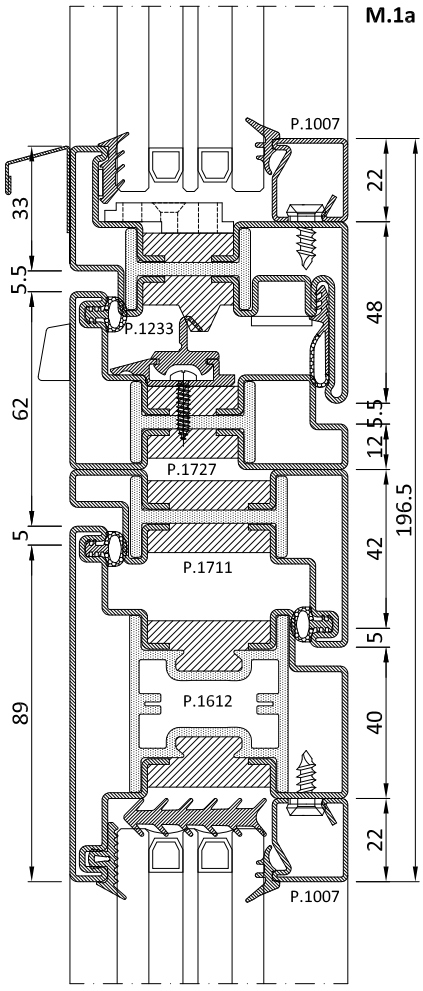
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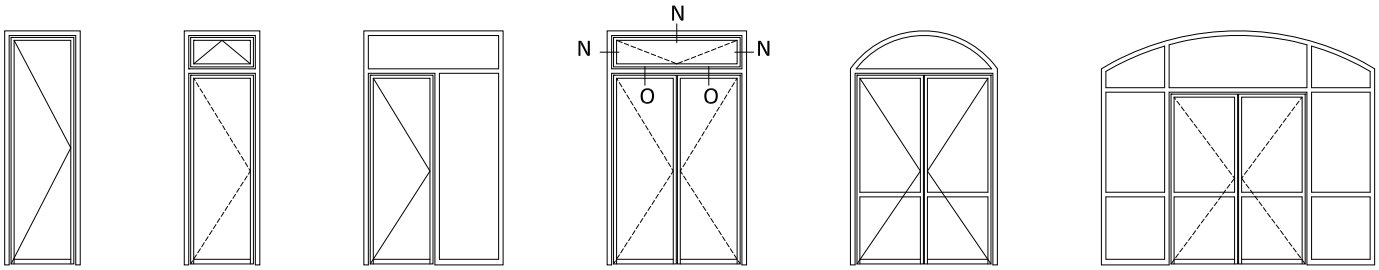


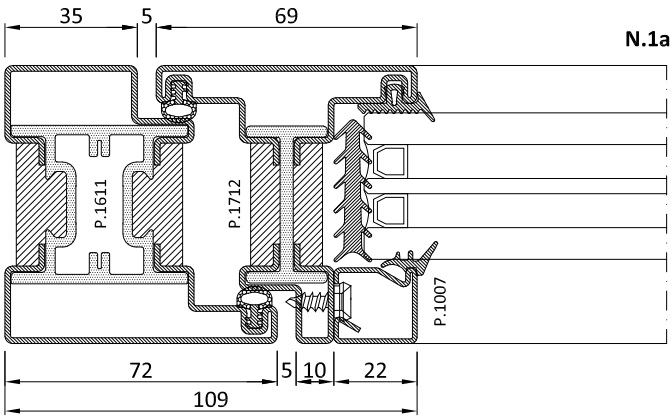

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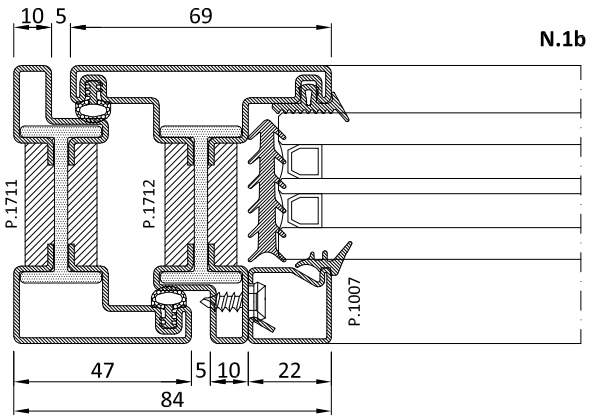

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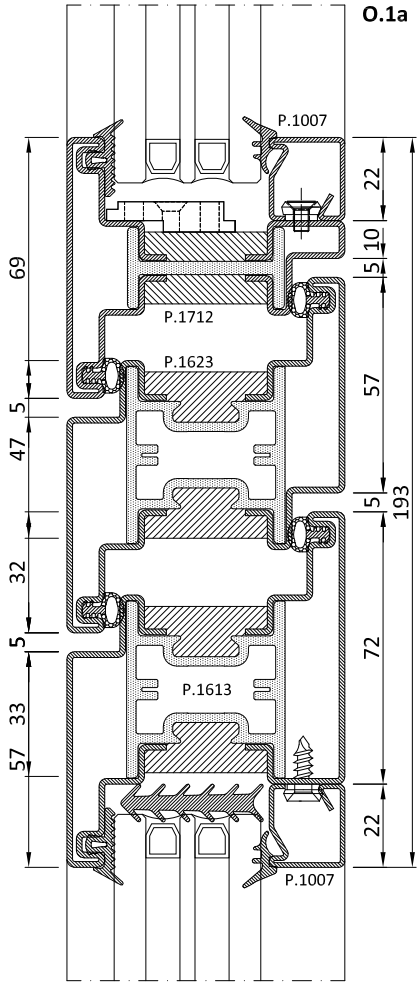

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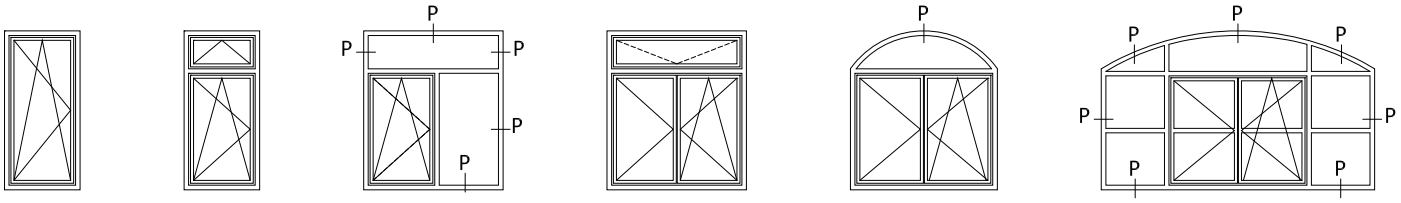

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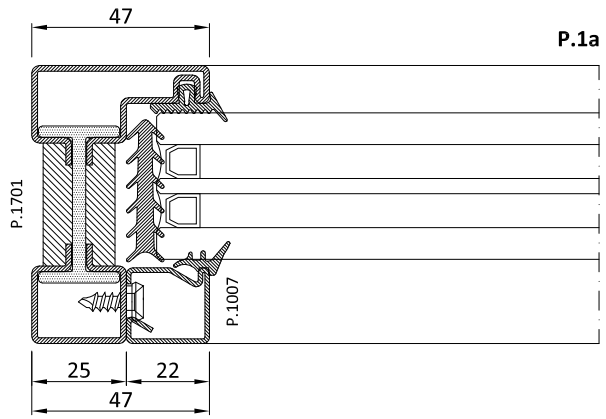

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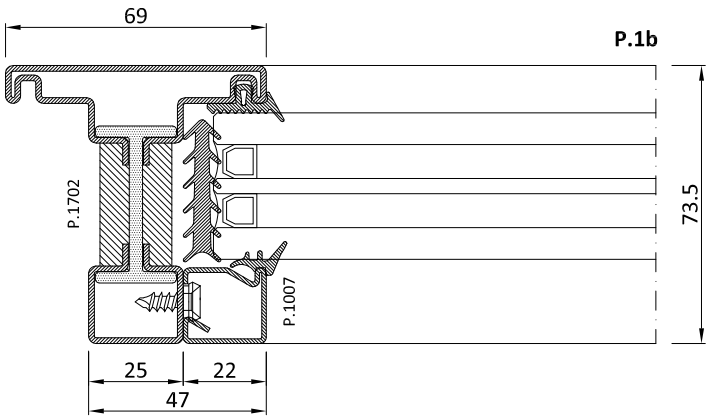

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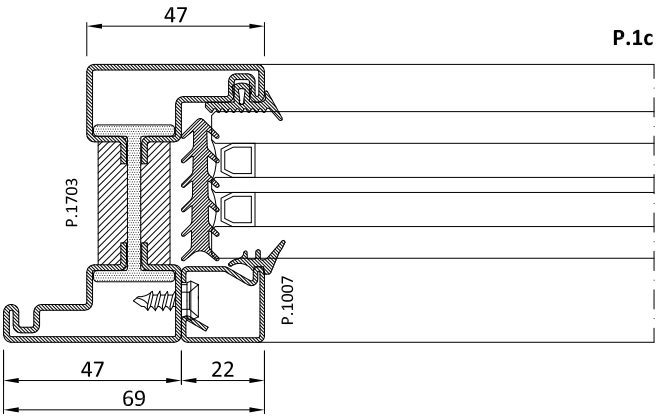

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P.1711
P.1712
P.1007
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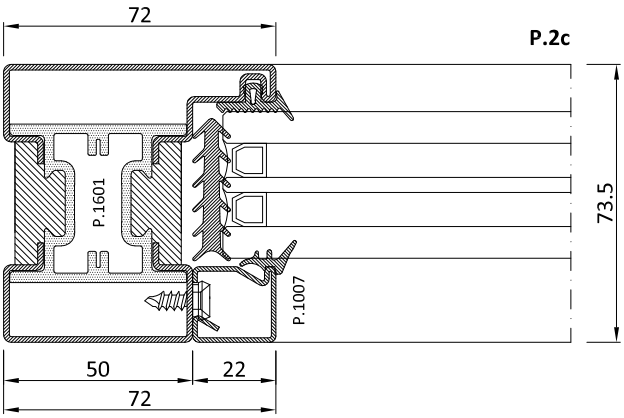

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P.1712
P.1623
P.1613
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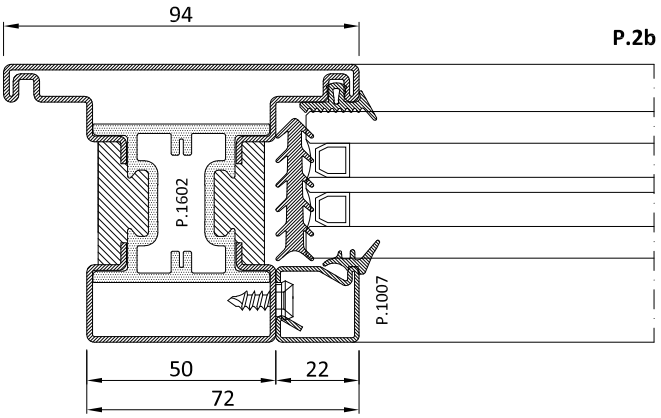

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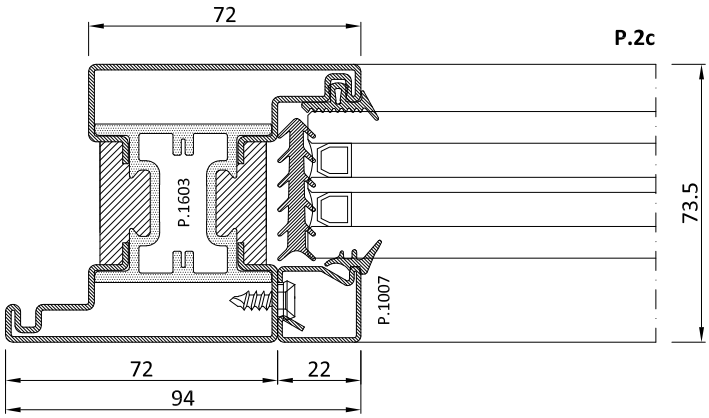

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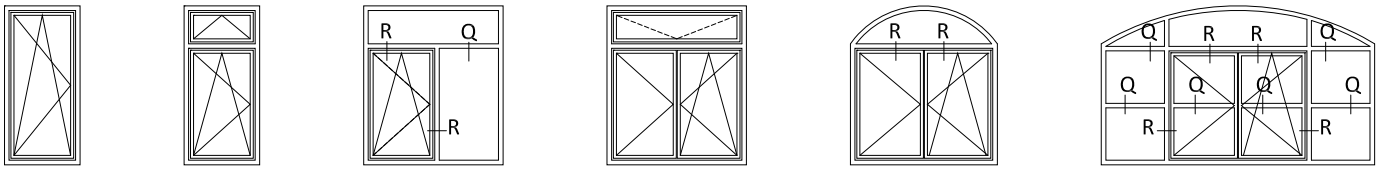

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P.1702
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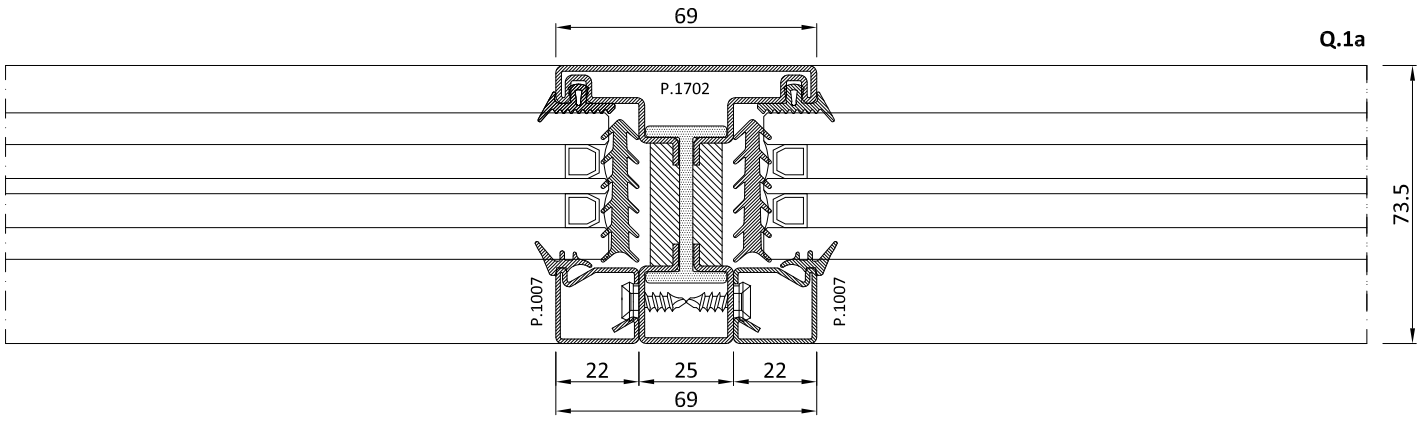

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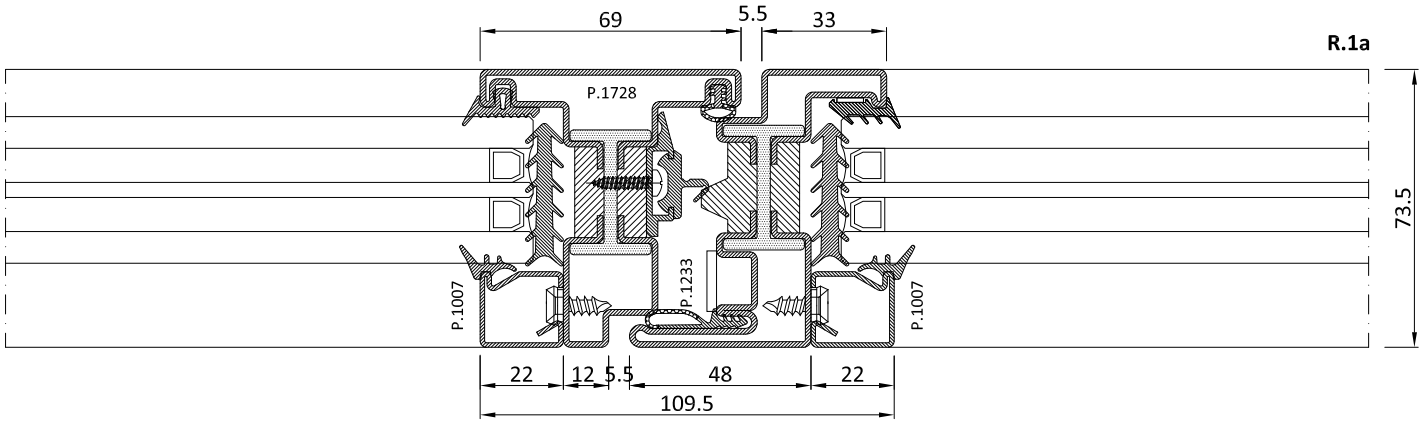

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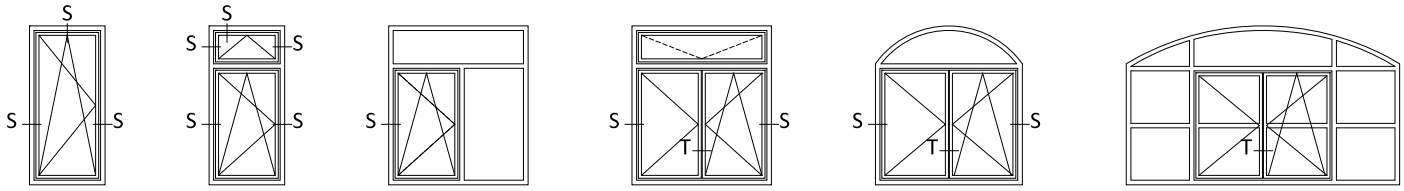

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P.1602
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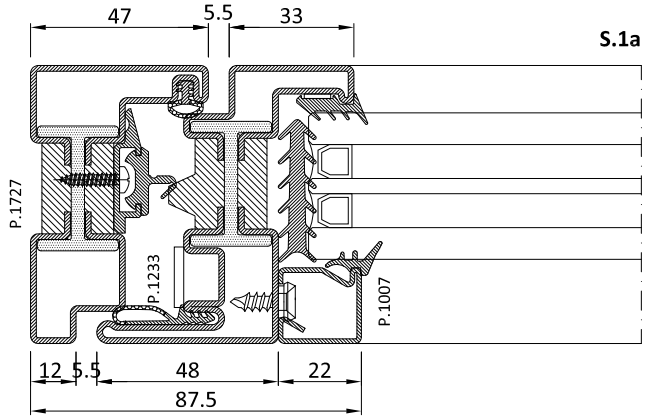

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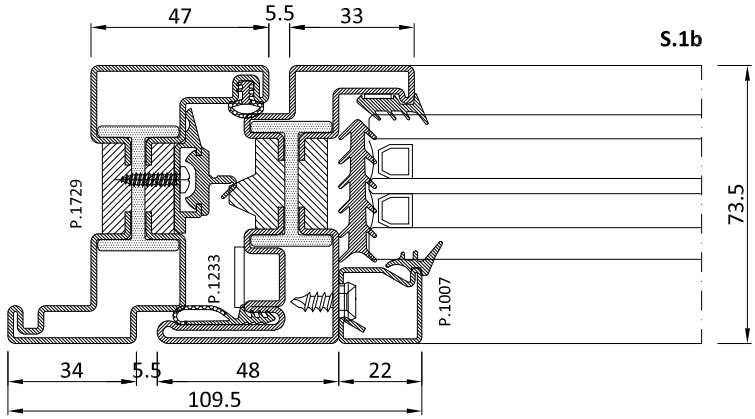

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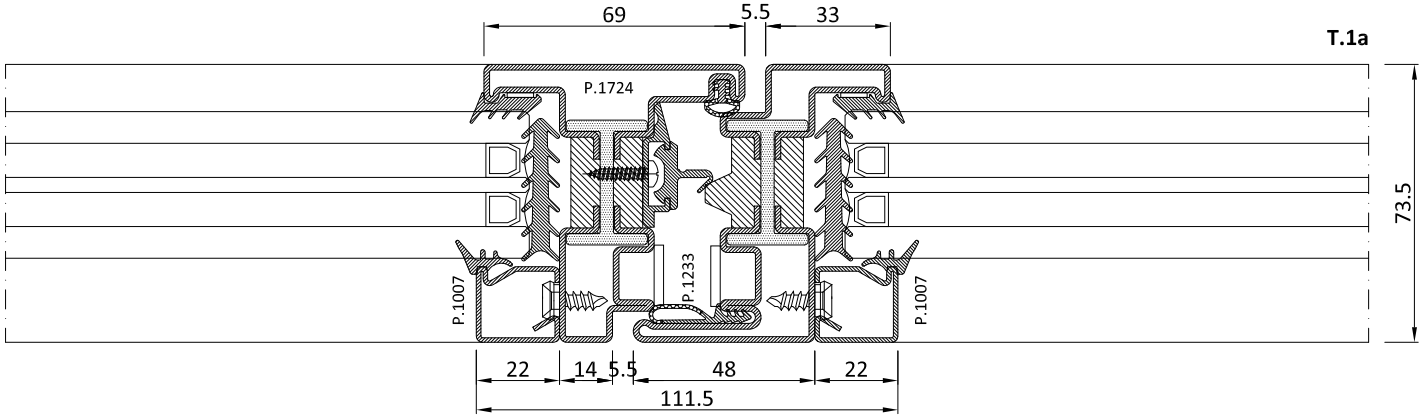

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P.1702
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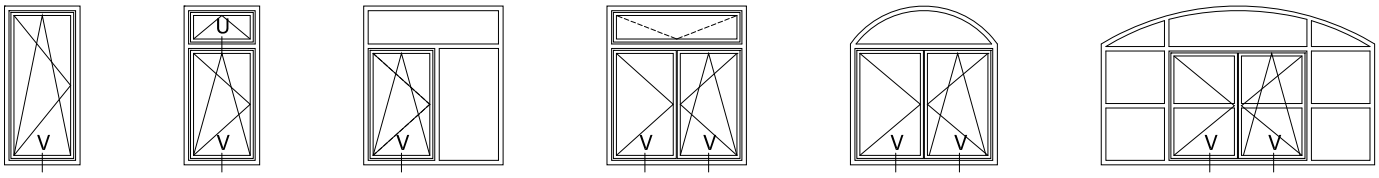

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P.1233
P.1007
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5.5
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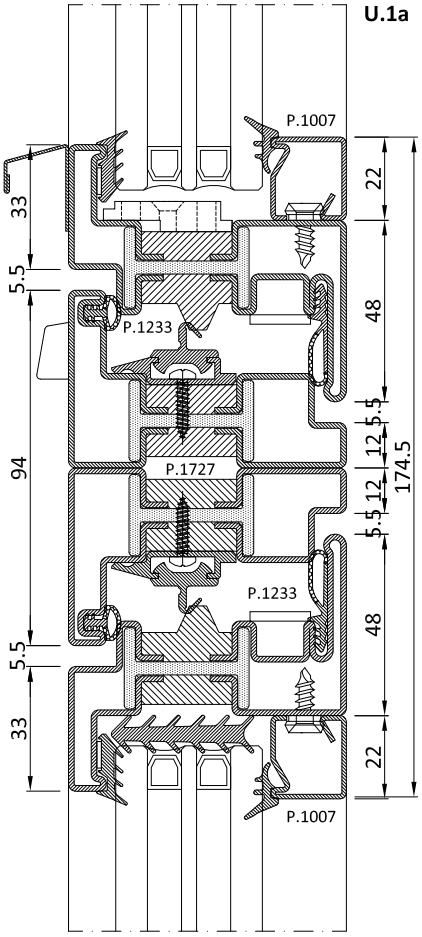

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S.1a
P.1727
P.1233
P.1007
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S.1b
P.1729
P.1233
P.1007
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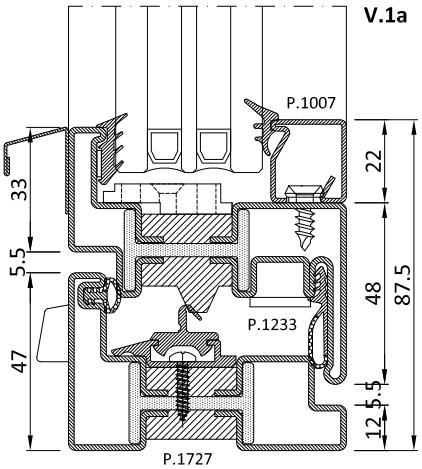

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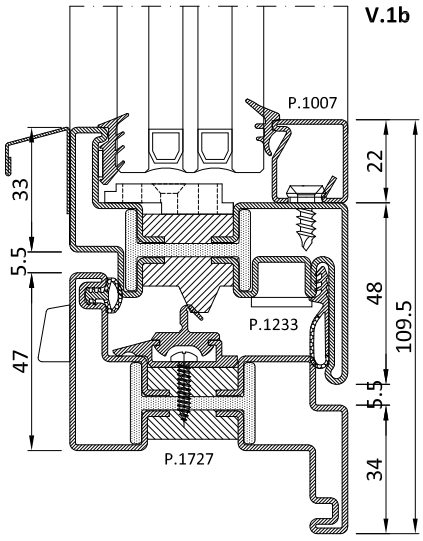
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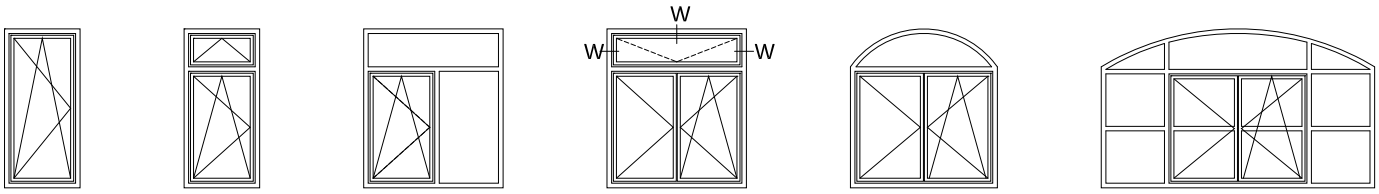

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P.1233
P.1727
P.1233
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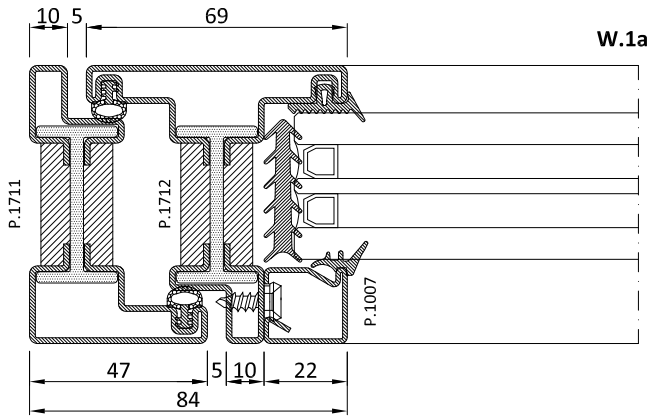
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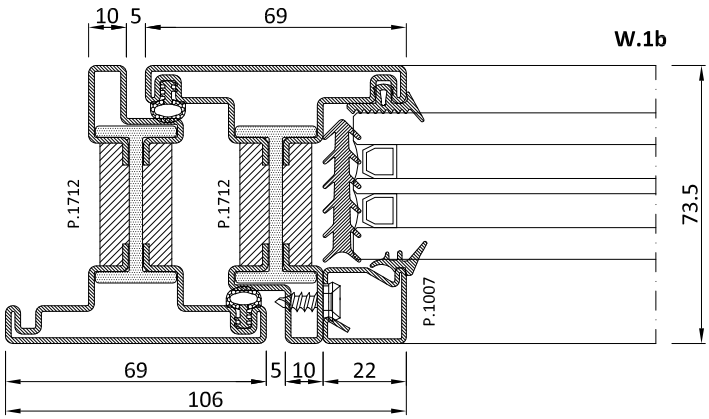

P.1007
P.1233
P.1727
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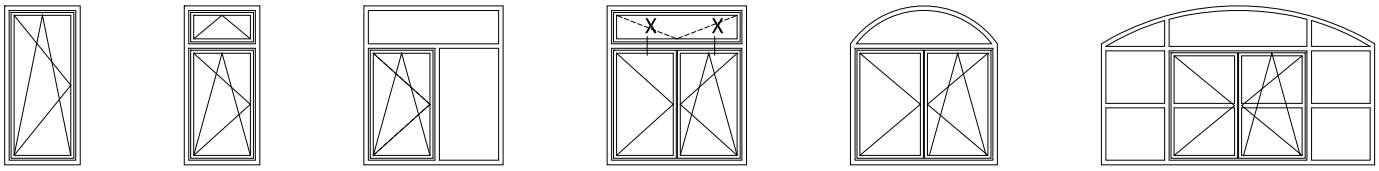
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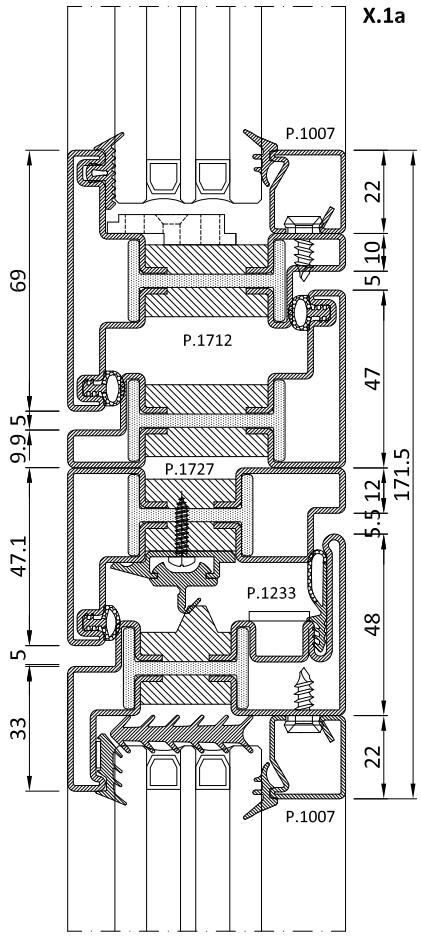

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P.1727
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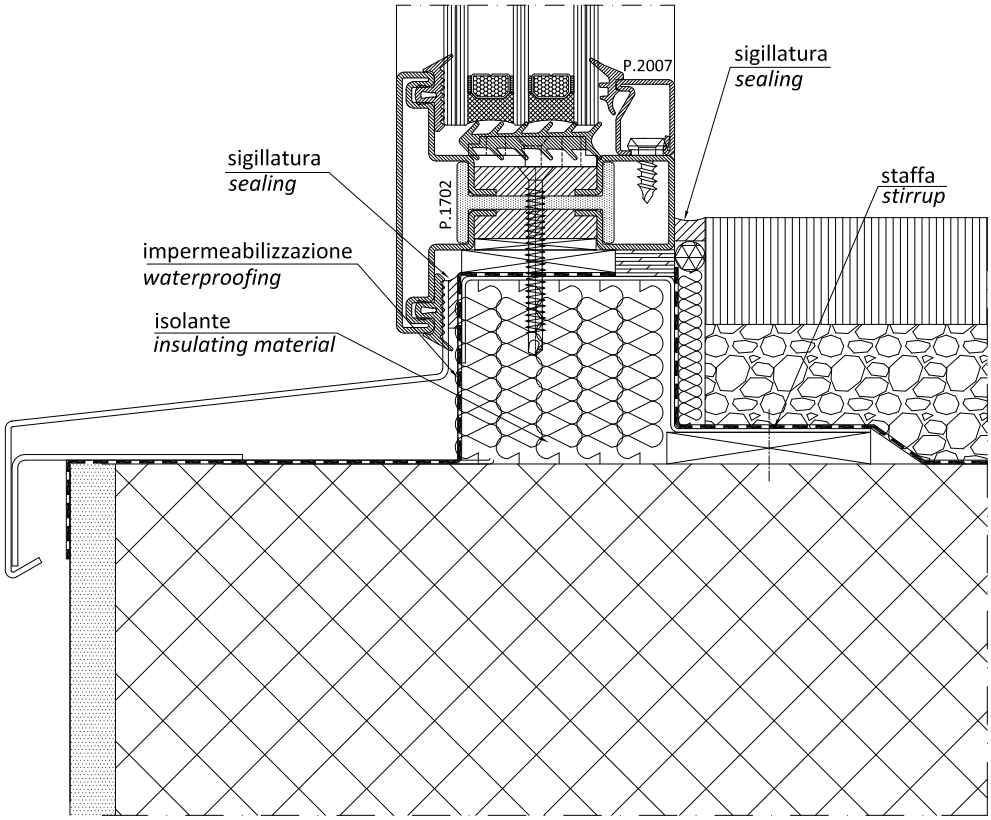

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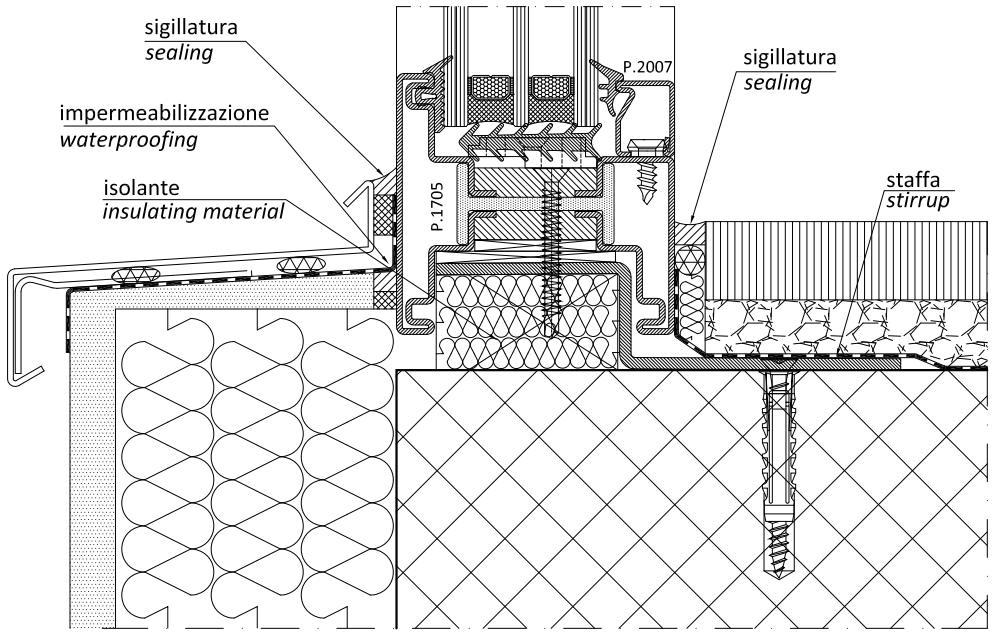

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W.1a
P.1711
P.1712
P.1007
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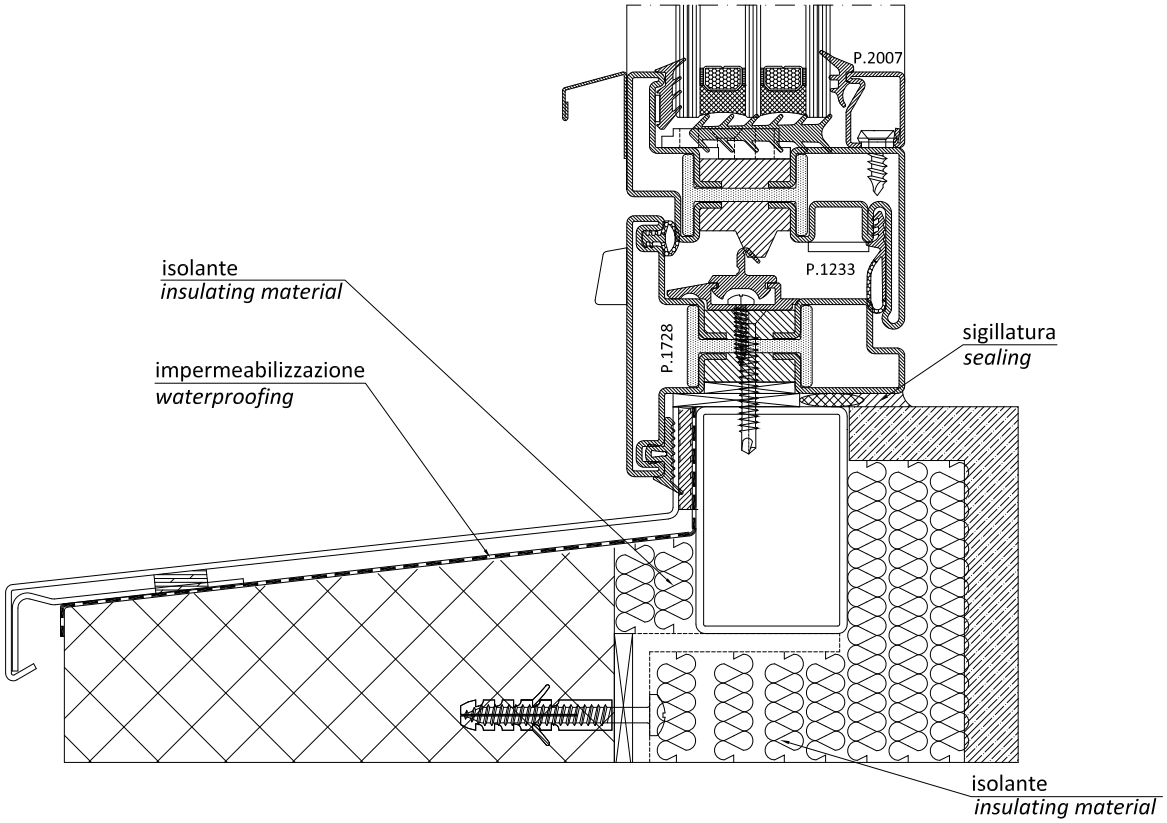

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P.1712
P.1007
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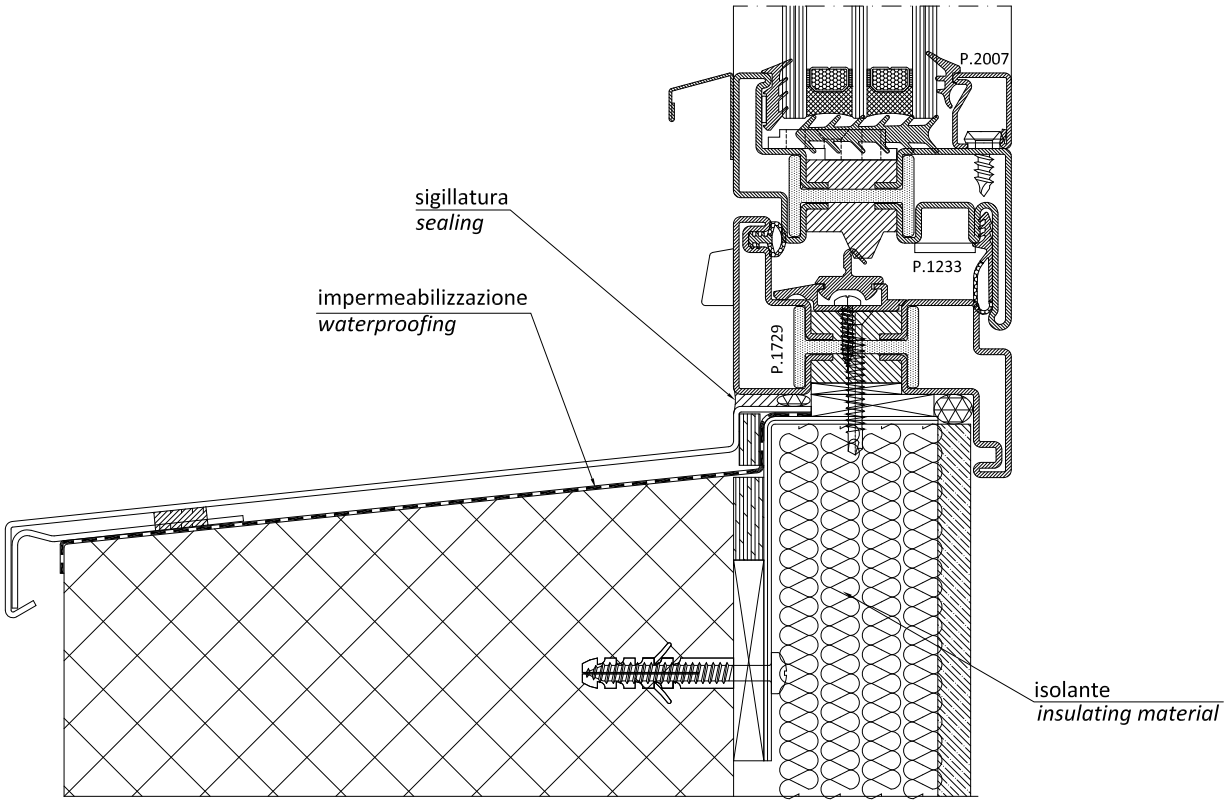

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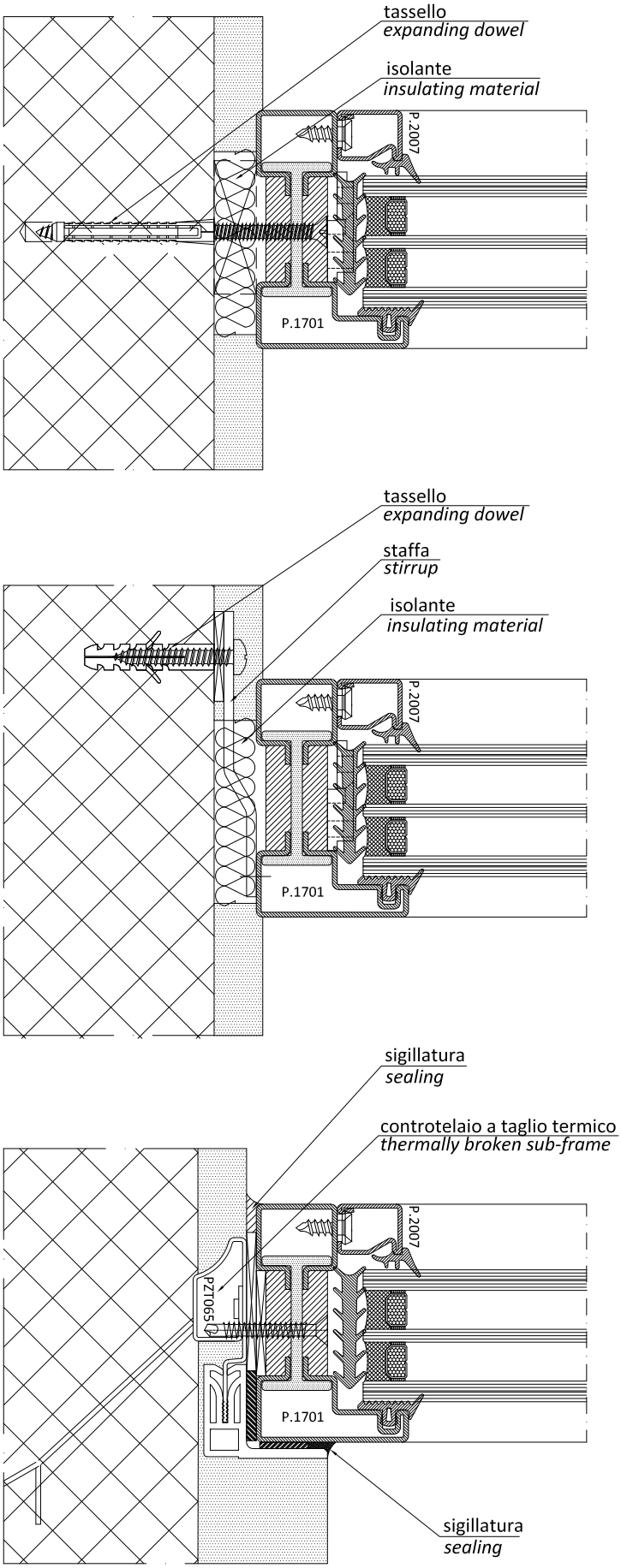

X.1a
P.1007
P.1712
P.1727
P.1233
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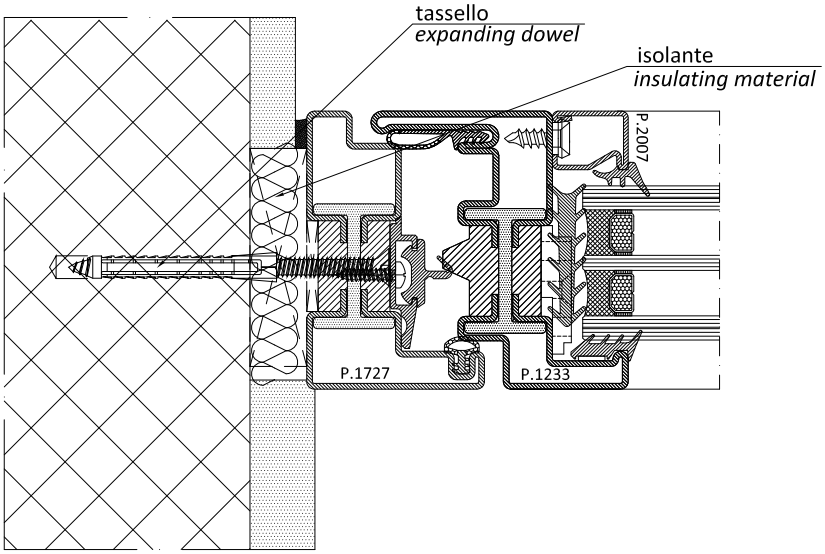

P.2007
sigillatura
sealing
sigillatura
sealing
staffa
stirrup
P.1702
impermeabilizzazione
waterproofing
isolante
insulating material

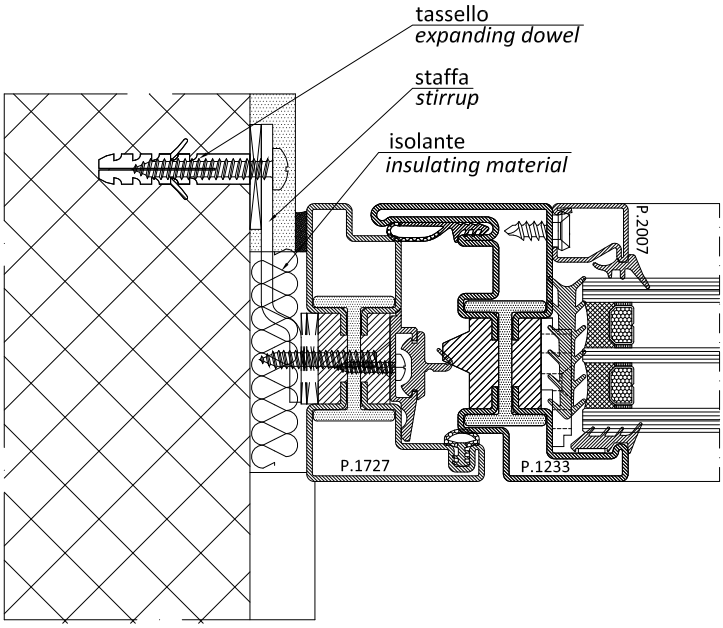

sigillatura
sealing
P.2007
sigillatura
sealing
impermeabilizzazione
waterproofing
isolante
insulating material
P.1705
staffa
stirrup

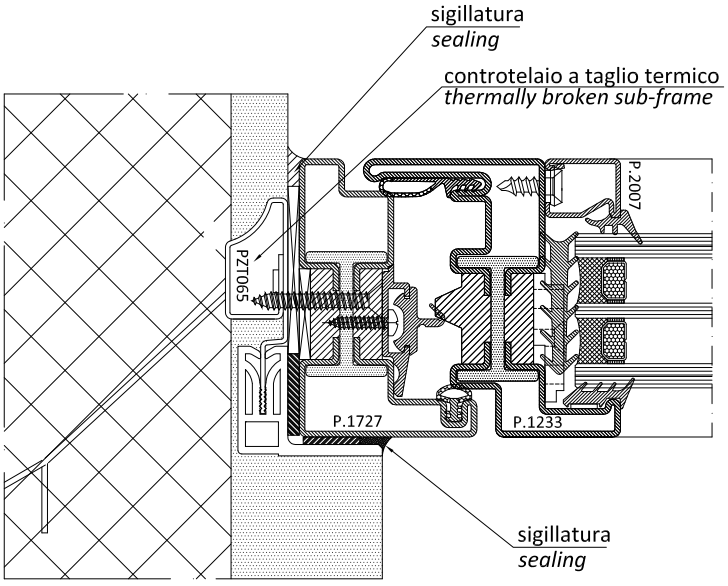

P.2007
P.1233
P.1728
isolante
insulating material
impermeabilizzazione
waterproofing
sigillatura
sealing
isolante
insulating material


P.2007
sigillatura
sealing
P.1233
impermeabilizzazione
waterproofing
P.1729
isolante
insulating material

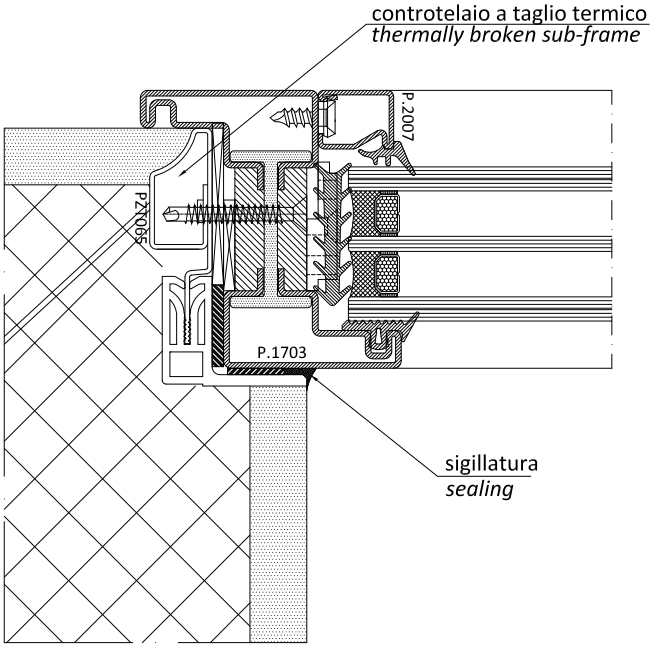

tassello
expanding dowel
isolante
insulating material
P.2007
P.1701
tassello
expanding dowel
staffa
stirrup
isolante
insulating material
P.2007
P.1701
sigillatura
sealing
controtelaio a taglio termico
thermally broken sub-frame
P.2007
PZT065
P.1701
sigillatura
sealing

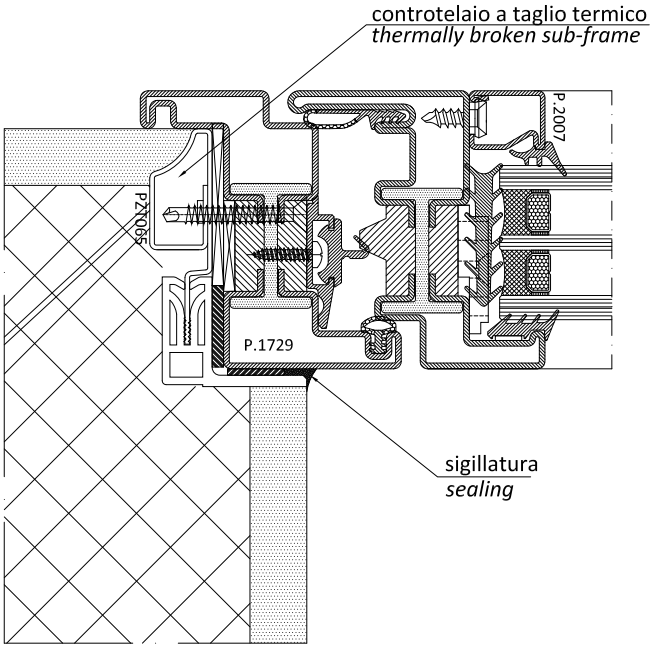




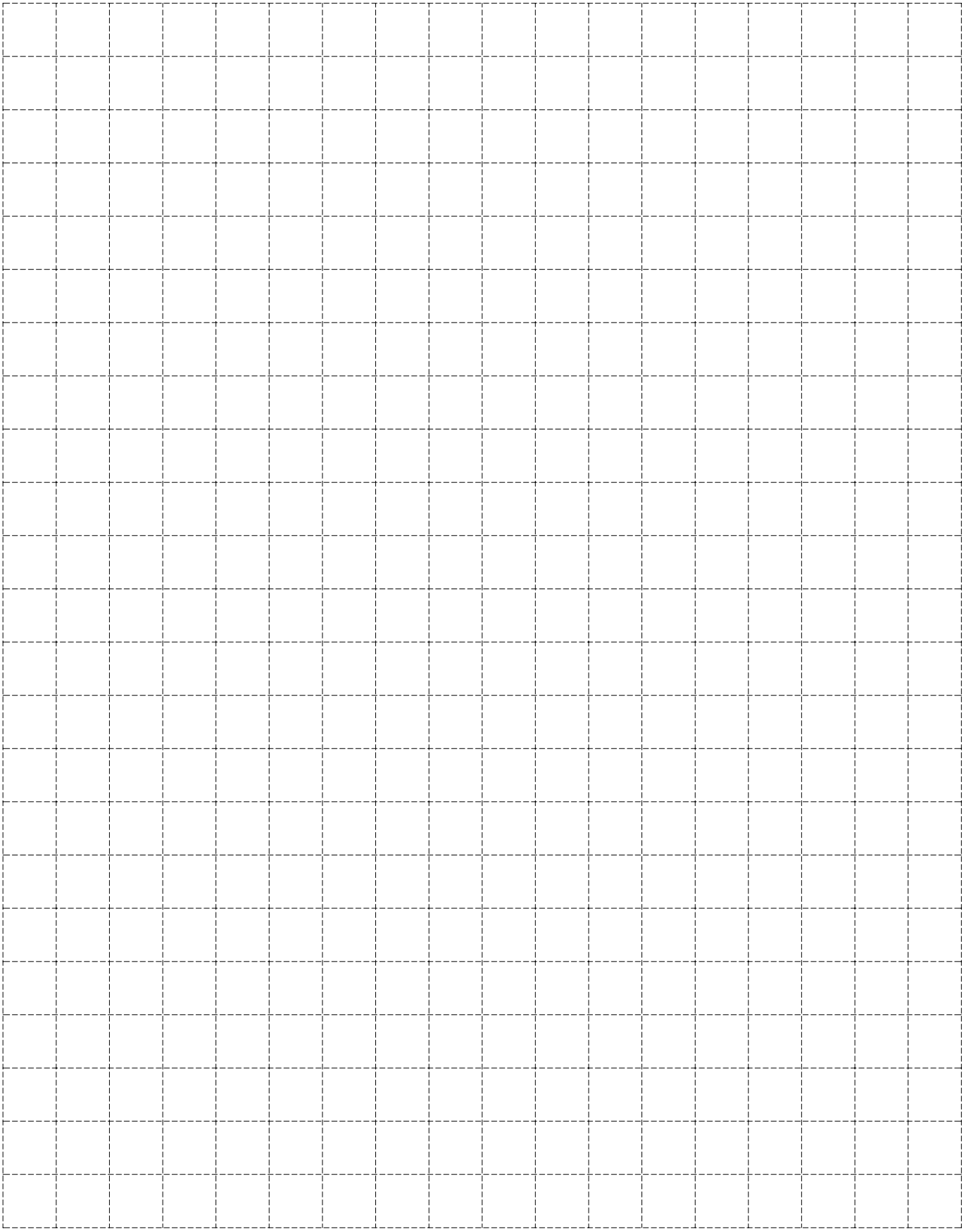


Applicare viti di fissaggio profilo a muro in corrispondenza dell'asse cerniere
Apply anchoring screws to the hinge axis

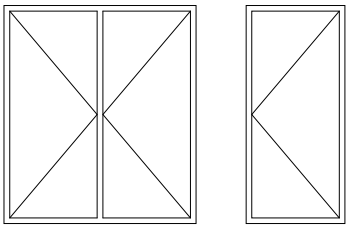




Applicare viti di fissaggio profilo a muro in corrispondenza dell'asse cerniere
Apply anchoring screws to the hinge axis

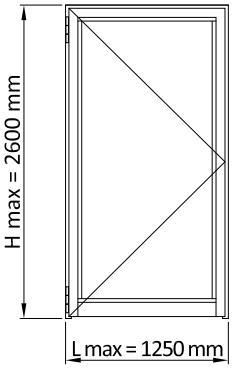


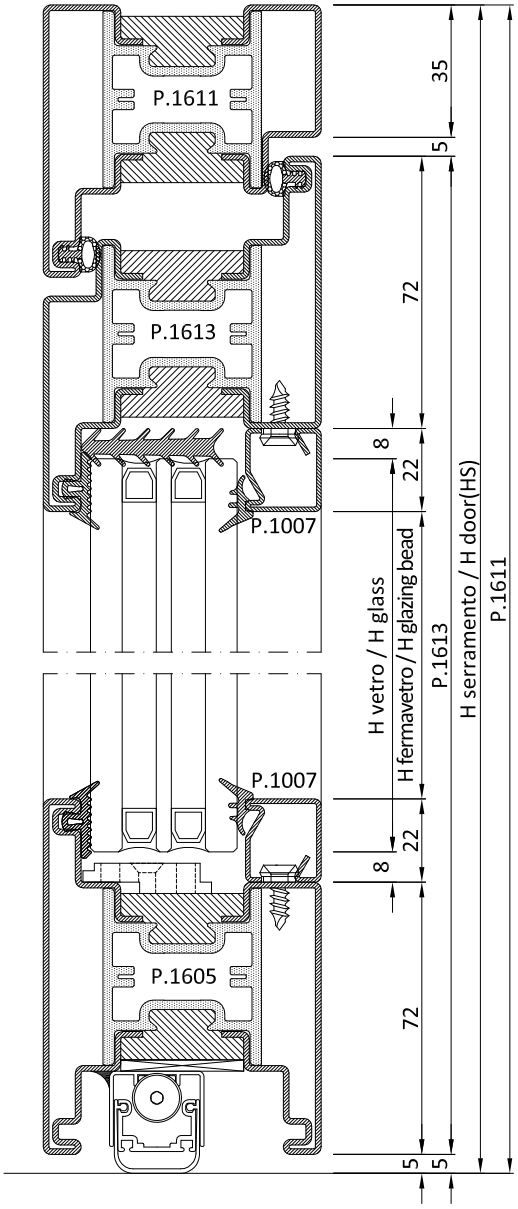
Distinta di taglio e lista componenti | *Cutting list and components list*



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

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



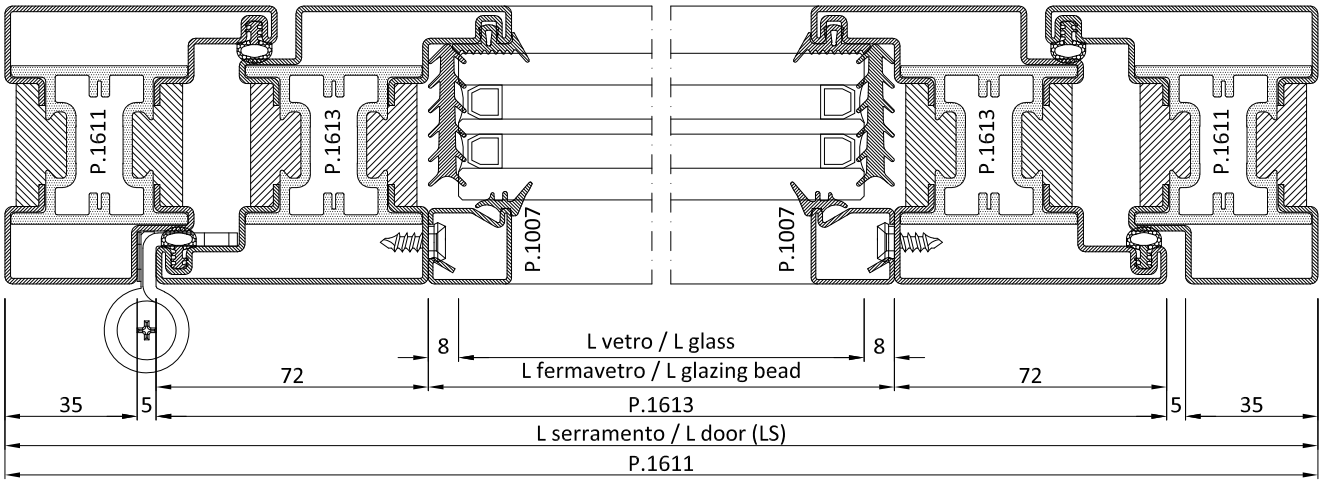


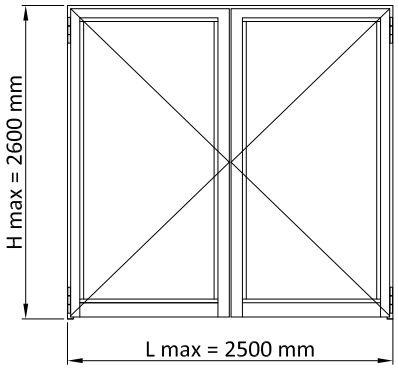
	PROFILI	***PROFILES***				
Cod.	Descrizione	*Description*	n°	Dim.	Taglio	*Cutting*
	Telaio	***Frame***				
P.1611	Profilo a "L" telaio	*"L" profile frame*	1	LS	45°	45°
P.1611	Profilo a "L" telaio	*"L" profile frame*	1	HS	45°	90°
P.1611	Profilo a "L" telaio	*"L" profile frame*	1	HS	90°	45°
	Anta	***Leaf***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

	ACCESSORI	***HARDWARE***	
Cod.	Descrizione	*Description*	n°
AC1004I*	Kit squadrette per P.1611	*Corner joint kit for P.1611*	2
AC1007I*	Kit squadrette per P.1613	*Corner joint kit for P.1613*	2
AC1021*	Cavallotto per P.1605	*Butt joint kit P.1605*	2
AC1020 ..	Supporto spessore vetro	*Glass support*	6
AC1033 ..	Cerniera a stilo	*Road hinges*	Var.
AC1065/6/7..	Serratura multipunto	*Multi-point lock*	1
AC1081/..	Paraspiffero automatico	*Authomatic door seal*	1
ACV9...	Maniglia "Vitruvio"	*"Vitruvio" handle*	1
CV5001(i)	Vite per boccola fermavetro	*Screw for glazing bead bushing*	Var.
CV5012(i)	Boccola per fermavetro	*Bushing for glazing bead*	Var.

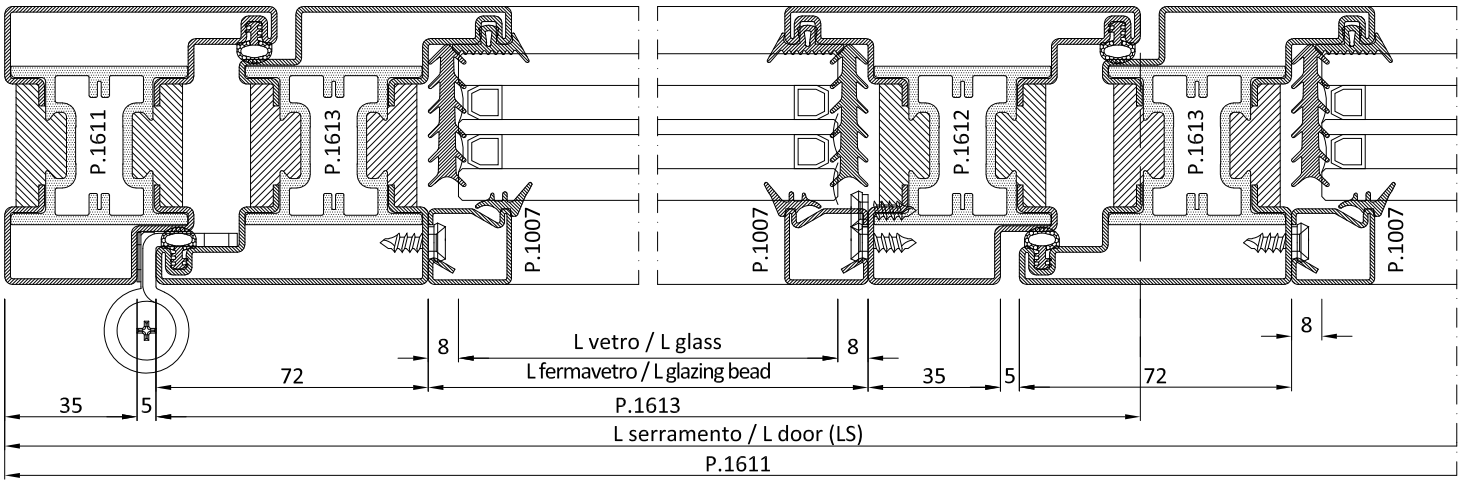
	GUARNIZIONI	***GASKETS***		
Cod.	Descrizione	*Description*	n°	Dim.
GE1001TT	Guarnizione esterna di battuta	*Rebating gasket*	1	2xLS+4xHS
GE1006	Guarnizione esterna vetro	*External gasket*	1	2xLS+2xHS
GE1007TT	Guarnizione sottovetro	*Gasket to put under the glass*	1	2xLS+2xHS
GE..	Guarnizione interna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

* solo con profili ottone
only with brass profiles





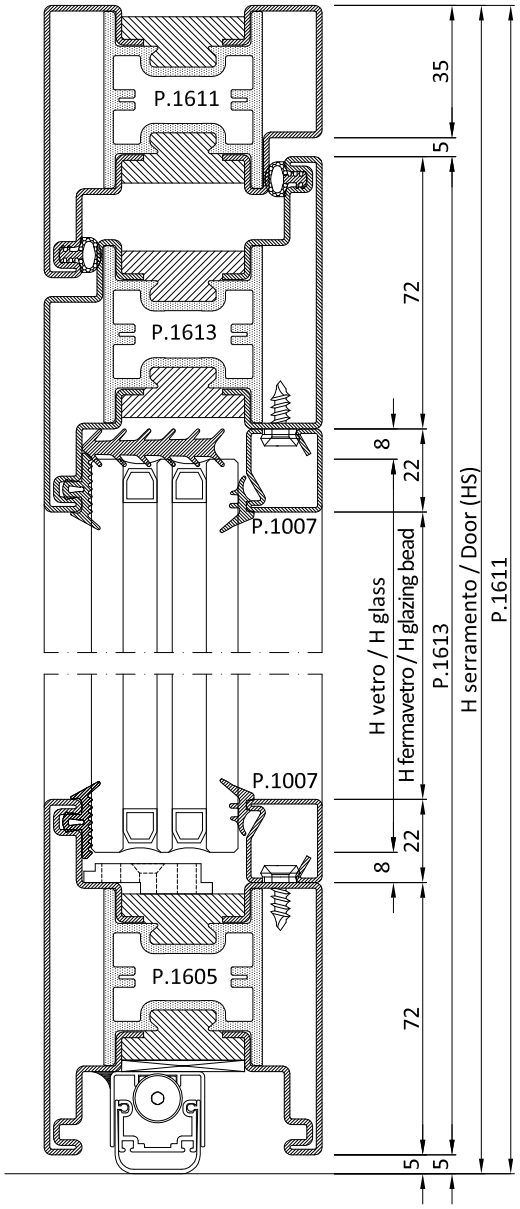
	PROFILI	***PROFILES***				
Cod.	Descrizione	*Description*	n°	Dim.	Taglio	*Cutting*
	Telaio	***Frame***				
P.1611	Profilo a "L" telaio	*"L" profile frame*	1	LS	45°	45°
P.1611	Profilo a "L" telaio	*"L" profile frame*	1	HS	45°	90°
P.1611	Profilo a "L" telaio	*"L" profile frame*	1	HS	90°	45°
	Anta	***Leaf***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

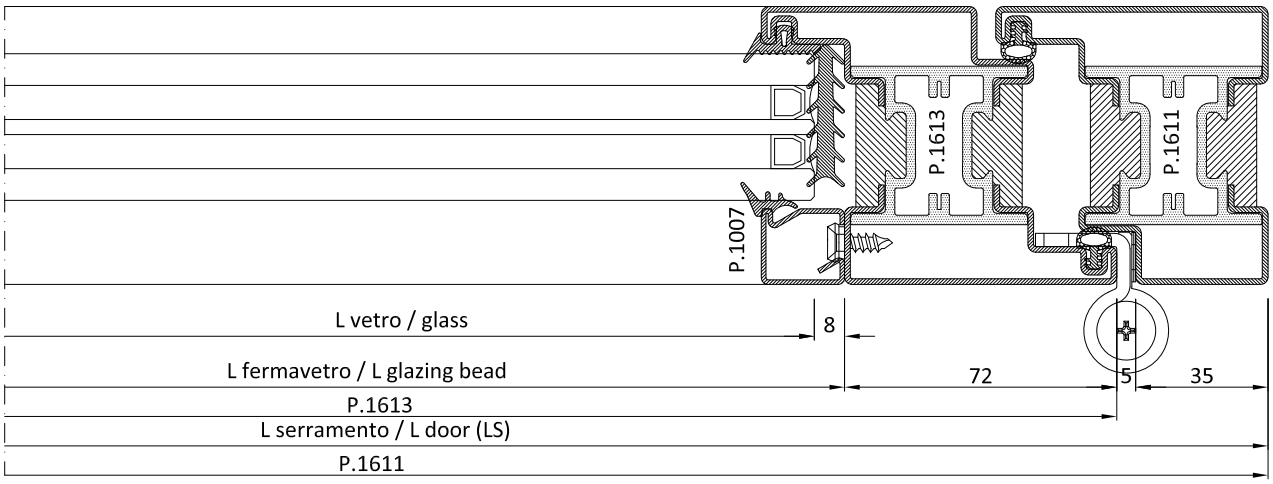


	ACCESSORI	***HARDWARE***	
Cod.	Descrizione	*Description*	n°
AC1004I*	Kit squadrette per P.1611	*Corner joint kit for P.1611*	2
AC1007I*	Kit squadrette per P.1613	*Corner joint kit for P.1613*	3
AC1008I*	Kit squadrette per P.1612-13		1
AC1021*	Cavallotto per P.1605	*Butt joint kit P.1605*	4
AC1014	Fondino inversione battuta	*Steel ending cap for reverting rebate*	2
AC1020 ..	Supporto spessore vetro	*Glass support*	12
AC1033 ..	Cerniera a stilo	*Road hinges*	Var.
AC1040	Kit catenaccio 2^ anta	*Kit for closing second leaf*	1
AC1065/6/7..	Serratura multipunto	*Multi-point lock*	1
AC1081/..	Paraspiffero automatico	*Authomatic door seal*	2
ACV9...	Maniglia "Vitruvio"	*"Vitruvio" handle*	1
CV5001(i)	Vite per boccola fermavetro	*Screw for glazing bead bushing*	Var.
CV5012(i)	Boccola per fermavetro	*Bushing for glazing bead*	Var.

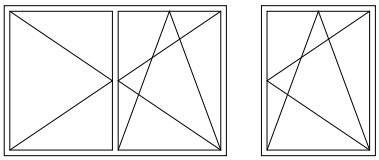
	GUARNIZIONI	***GASKETS***		
Cod.	Descrizione	*Description*	n°	Dim.
GE1001TT	Guarnizione esterna di battuta	*Rebating gasket*	1	2xLS+6xHS
GE1006	Guarnizione esterna vetro	*External gasket*	1	2xLS+4xHS
GE1007TT	Guarnizione sottovetro	*Gasket to put under the glass*	1	2xLS+4xHS
GE..	Guarnizione interna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

* solo con profili ottone
only with brass profiles





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



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

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

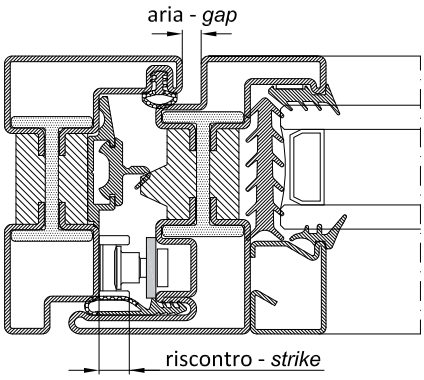
La tabella seguente va attentamente letta prima del taglio dei profili | *The following table should be carefully read before the profiles cutting*

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

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

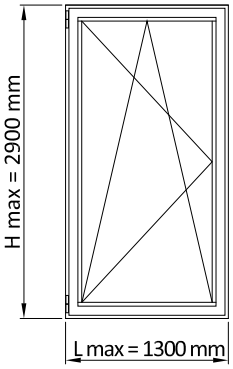
			larghezza anta (cava ferramenta in mm) *leaf width (hardware slot in mm)*				
			280 360	361 480	481 600	601 800	> 800
AR Easy *DK* Easy	AGE 281(2) AGE 281(2)-286(5) AGE 281(2)-786(5)	aria - *gap*	-	5,5	5,5	5,5	5,5
		riscontro - *strike*	-	std	std	std	std

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



standard | *standard*
std = 8 mm

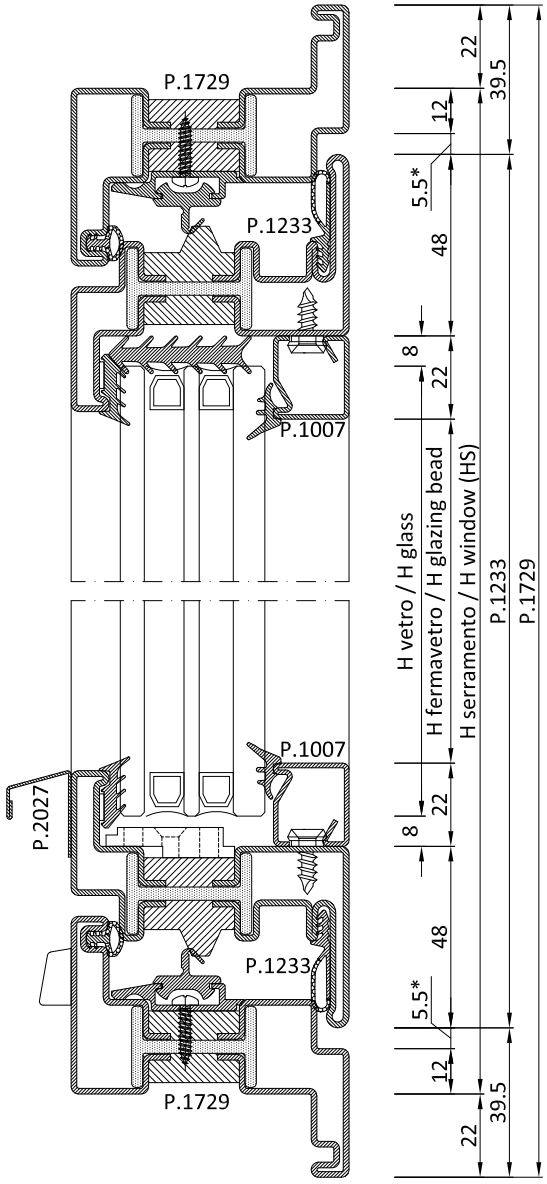
ribassato | *reduced*
rid = 5.5 mm



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

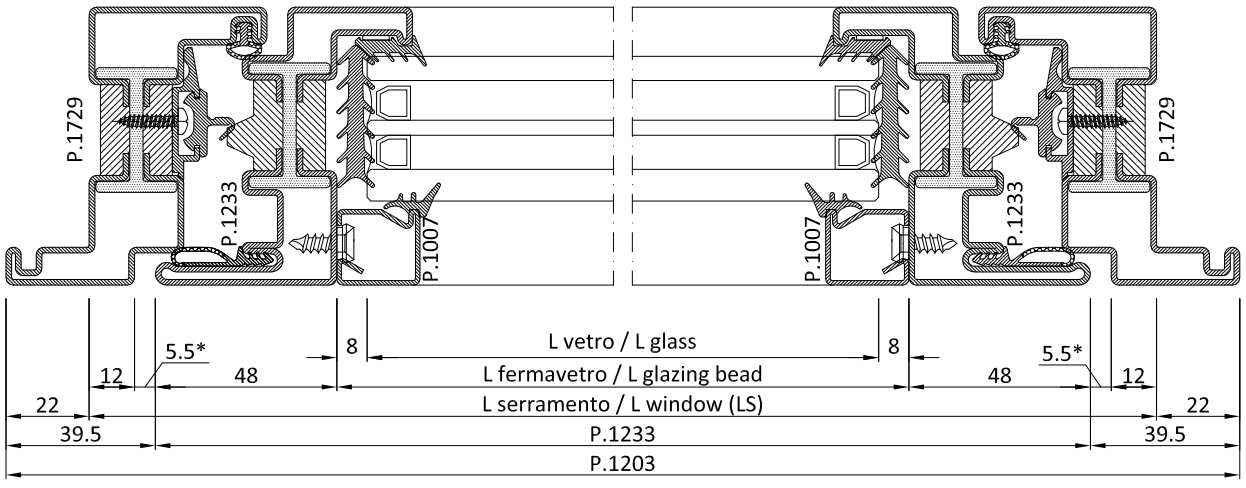
	ACCESSORI	*HARDWARE*	
Cod.	Descrizione	*Description*	n°
AC1729I*	Kit squadrette per P.1729	*Corner joint kit for P.1729*	4
AC1207I*	Kit squadrette per P.1233	*Corner joint kit for P.1233*	4
AC1716	Guarnizione d'angolo	*Vulcanised corner gasket*	4
AC1219	Scarico acqua	*Water drip*	Var.
AGE281/2..	Meccanismo Anta Ribalta	*Tilt and Turn mechanism*	1
ACV97..	Maniglia "Vitruvio"	*"Vitruvio" handle*	1
AC1356	Meccanismo DK	*External tilt & turn mechanism*	1
AC1020	Supporto spessore vetro	*Glass support*	6
CV5001(i)	Vite per boccola fermavetro	*Screw for glazing bead bushing*	Var.
CV5012(i)	Boccola per fermavetro	*Bushing for glazing bead*	Var.

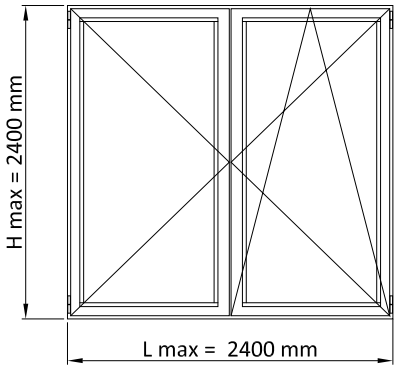
	GUARNIZIONI	*GASKETS*		
Cod.	Descrizione	*Description*	n°	Dim.
GE1233TT	Guarnizione esterna di battuta	*External rebating gasket*	1	2xLS+2xHS
GE1701	Guarnizione giunto aperto	*Open joint system gasket*	1	2xLS+2xHS
GU1702	Estruso PVC giunto aperto	*Open joint systemPVC profile*	1	2xLS+2xHS
GE1200TT	Guarnizione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



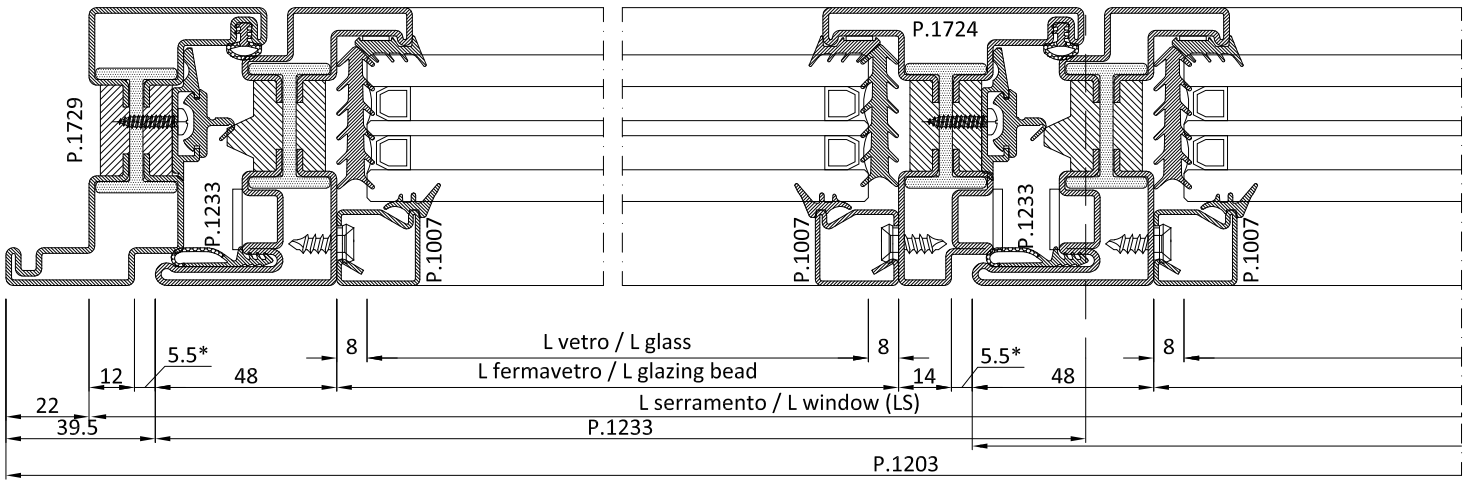
* vedi tabella 4.1.5
see chart 4.1.5

* solo con profili ottone
only with brass profiles



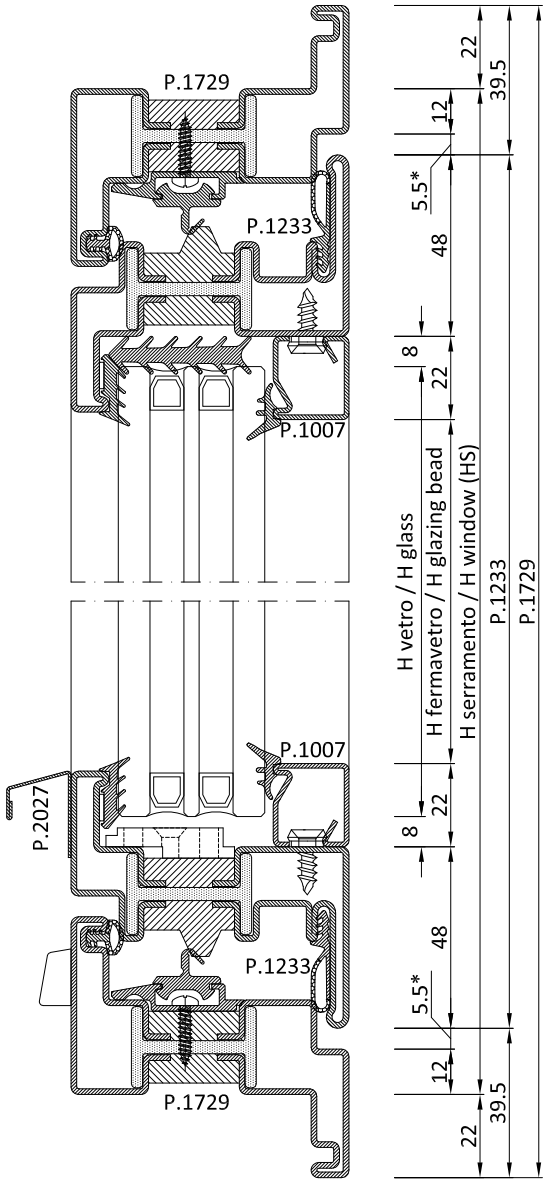


	PROFILI	***PROFILES***				
Cod.	Descrizione	*Description*	n°	Dim.	Taglio	*Cutting*
	Telaio	***Frame***				
P.1729	Profilo a "Z" telaio	*"Z" profile frame*	2	LS+44	45°	45°
P.1729	Profilo a "Z" telaio	*"Z" profile frame*	2	HS+44	45°	45°
	Anta	***Leaf***				
P.1233	Profilo a "Z" anta	*"Z" profile frame*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



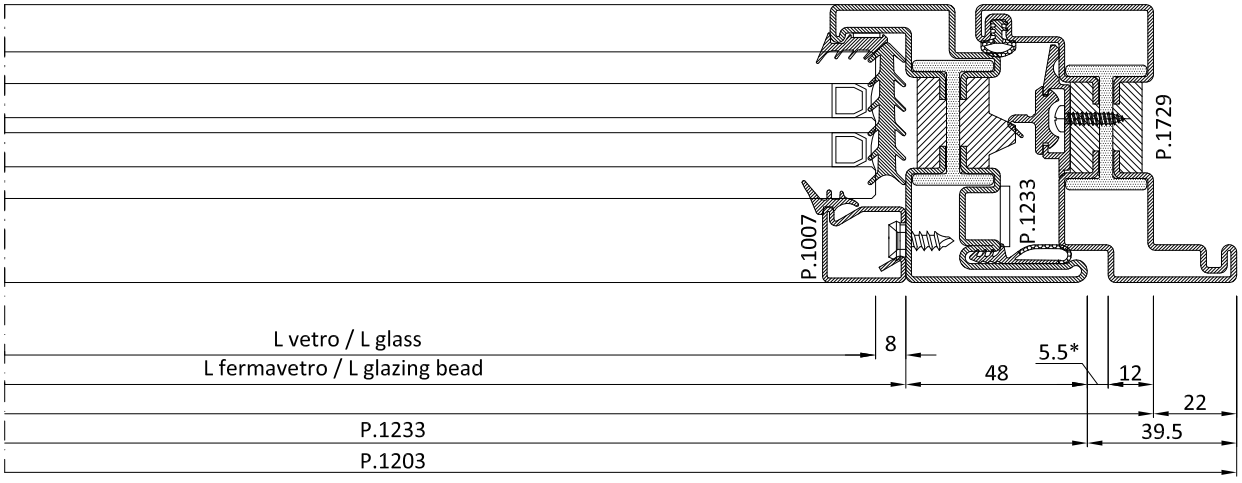
	ACCESSORI	*HARDWARE*	
Cod.	Descrizione	*Description*	n°
AC1729I*	Kit squadrette per P.1729	*Corner joint kit for P.1729*	4
AC1207I*	Kit squadrette per P.1233	*Corner joint kit for P.1233*	6
AC1708I*	Kit squadrette per P.1233-1724	*Corner joint kit for P.1233-1724*	2
AC1716	Guarnizione d'angolo	*Vulcanised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

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

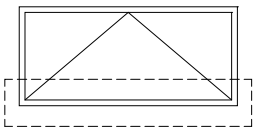


* vedi tabella 4.1.5
see chart 4.1.5

** solo con profili ottone
only with brass profiles



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



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

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

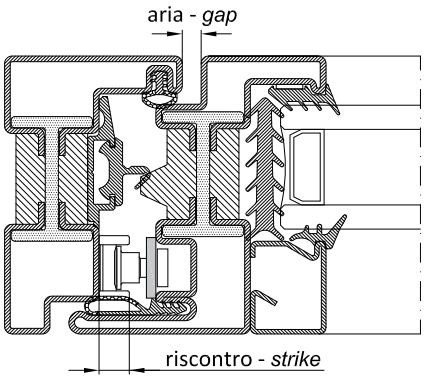
La tabella seguente va attentamente letta prima del taglio dei profili | *The following table should be carefully read before the profiles cutting*

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

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

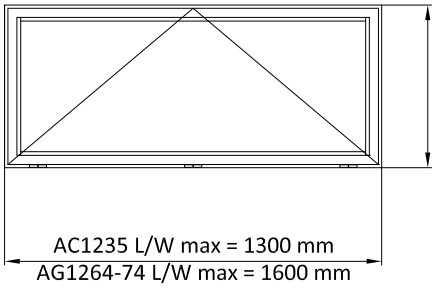
			larghezza anta (cava ferramenta in mm) *leaf width (hardware slot in mm)*	
			< 480	> 480
Vasistas *Bottom hung*	AG 1264 AG 1274	aria - *gap*	6	5
		riscontro - *strike*	std	std

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



standard | *standard*
std = 8 mm

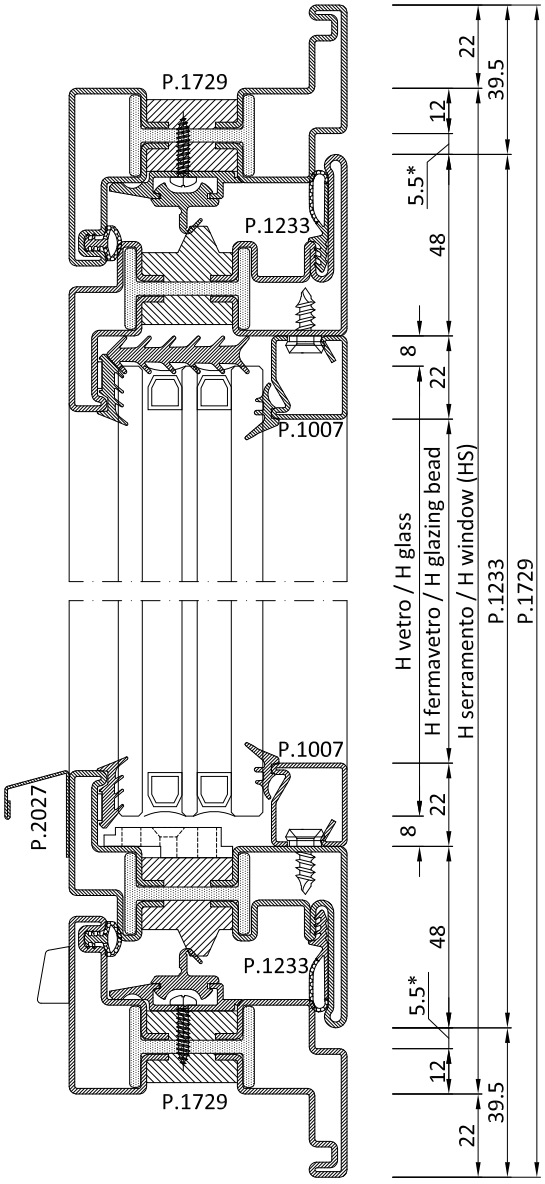
ribassato | *reduced*
rid = 5.5 mm



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

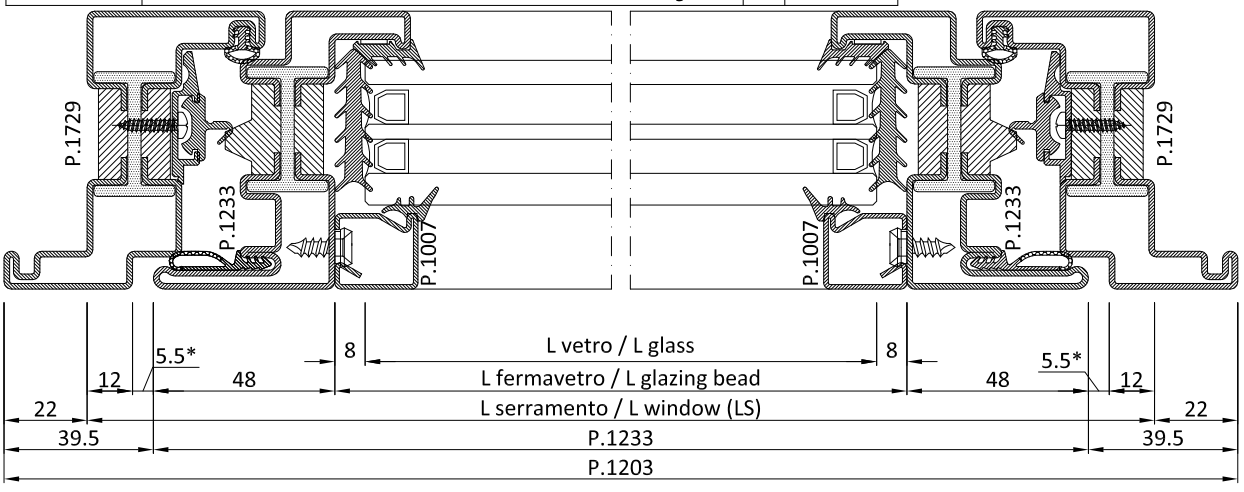
	ACCESSORI	***HARDWARE***	
Cod.	Descrizione	*Description*	n°
AC1729I*	Kit squadrette per P.1729	*Corner joint kit for P.1729*	4
AC1207I*	Kit squadrette per P.1233	*Corner joint kit for P.1233*	4
AC1716	Guarnizione d'angolo	*Vulcanised corner gasket*	4
AC1219	Scarico acqua	*Water drip*	Var.
AC2632/C	Cerniera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

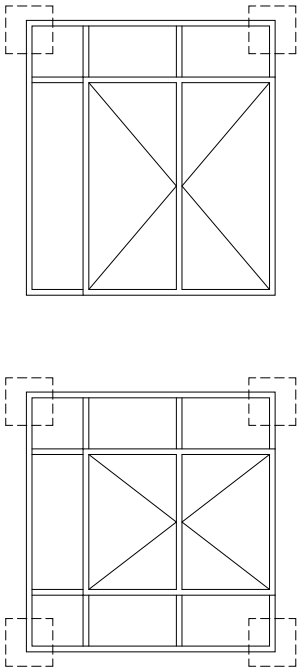
	GUARNIZIONI	***GASKETS***		
Cod.	Descrizione	*Description*	n°	Dim.
GE1233TT	Guarnizione esterna di battuta	*External rebating gasket*	1	2xLS+2xHS
GE1701	Guarnizione giunto aperto	*Open joint system gasket*	1	2xLS+2xHS
GU1702	Estruso PVC giunto aperto	*Open joint systemPVC profile*	1	2xLS+2xHS
GE1200TT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

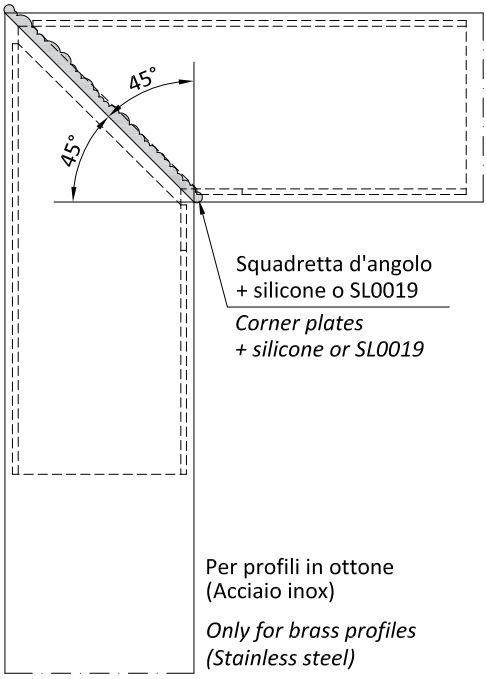


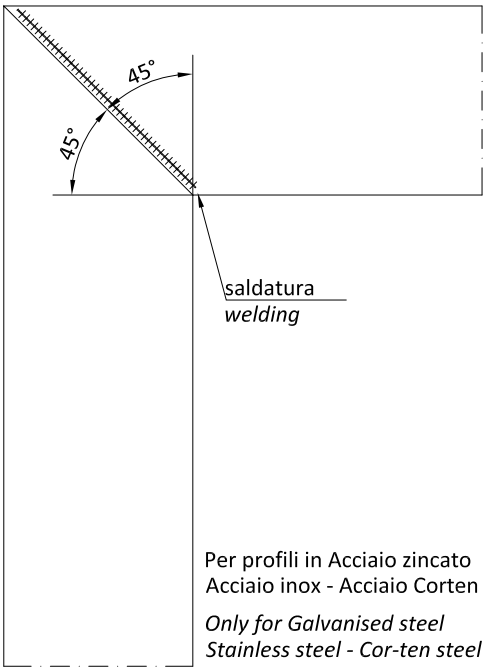
* vedi tabella 4.1.9
see chart 4.1.9

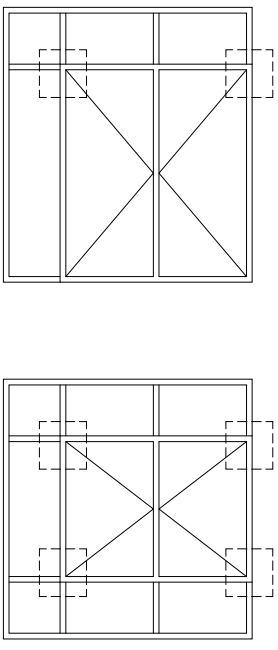
* solo con profili ottone
only with brass profiles

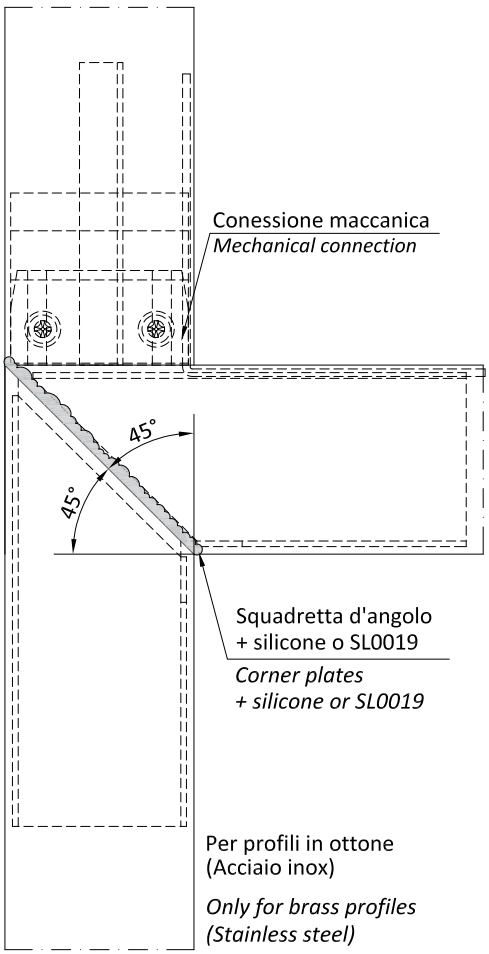


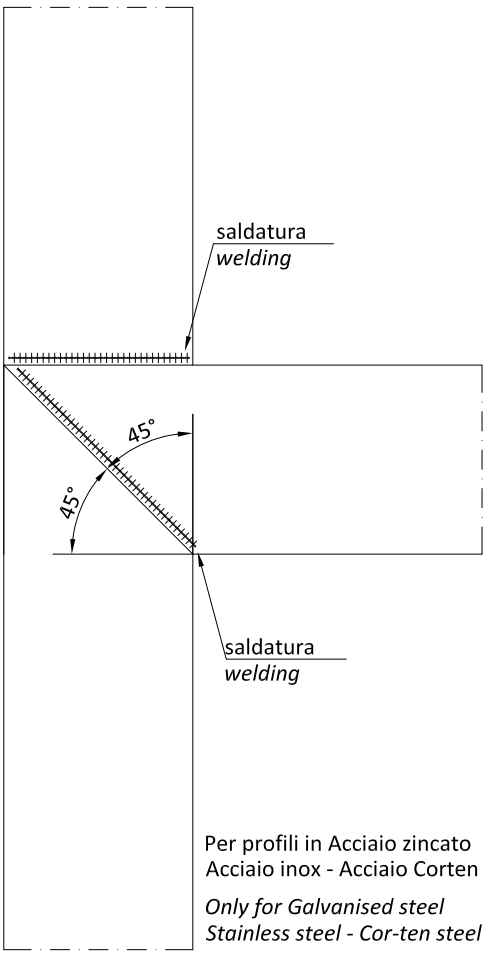


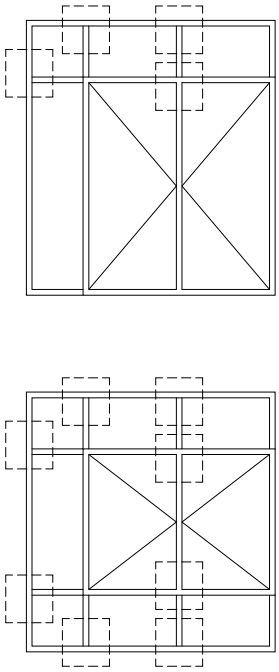

45°
45°
Squadretta d'angolo
+ silicone o SL0019
Corner plates
+ silicone or SL0019
Per profili in ottone
(Acciaio inox)
Only for brass profiles
(Stainless steel)

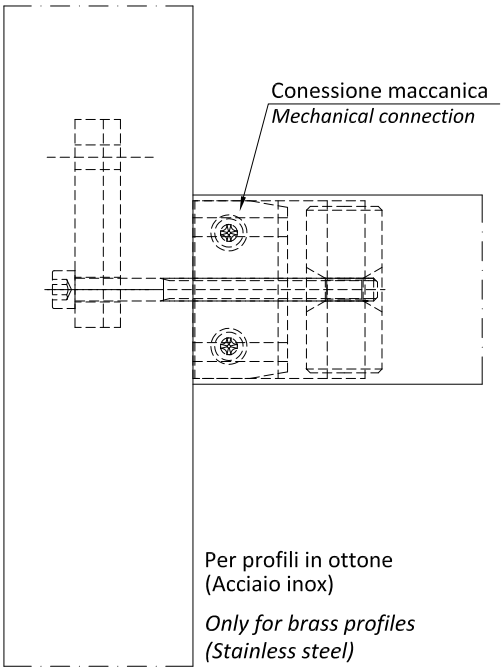

45°
45°
saldatura
welding
Per profili in Acciaio zincato
Acciaio inox - Acciaio Corten
Only for Galvanised steel
Stainless steel - Cor-ten steel




Conessione maccanica
Mechanical connection
45°
45°
Squadretta d'angolo
+ silicone o SL0019
Corner plates
+ silicone or SL0019
Per profili in ottone
(Acciaio inox)
Only for brass profiles
(Stainless steel)

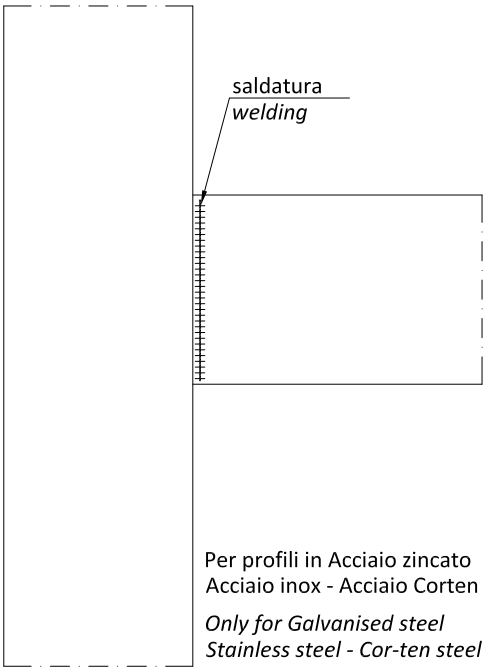

saldatura
welding
45°
45°
saldatura
welding
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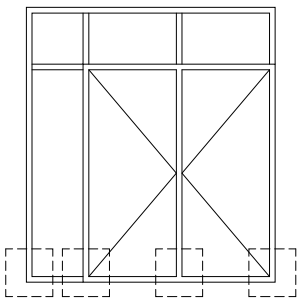
Per profili in ottone
(Acciaio inox)

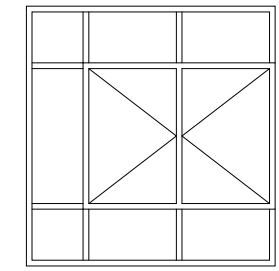
Only for brass profiles
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Per profili in Acciaio zincato
Acciaio inox - Acciaio Corten

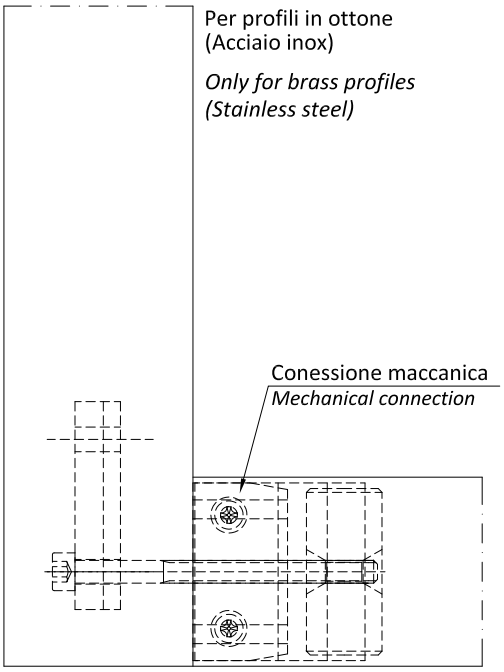
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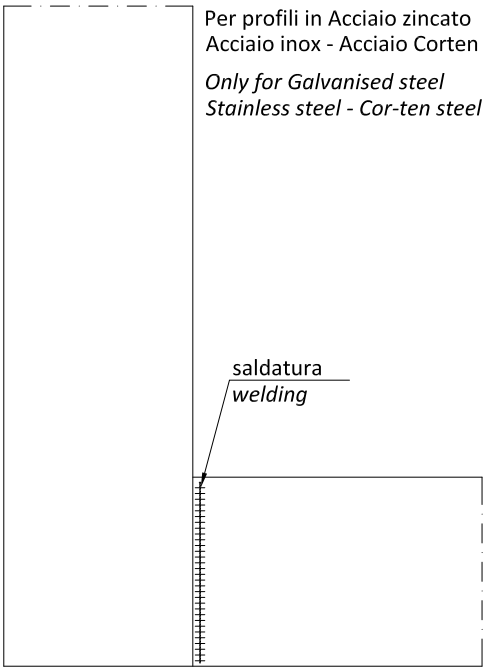
Per profili in ottone
(Acciaio inox)

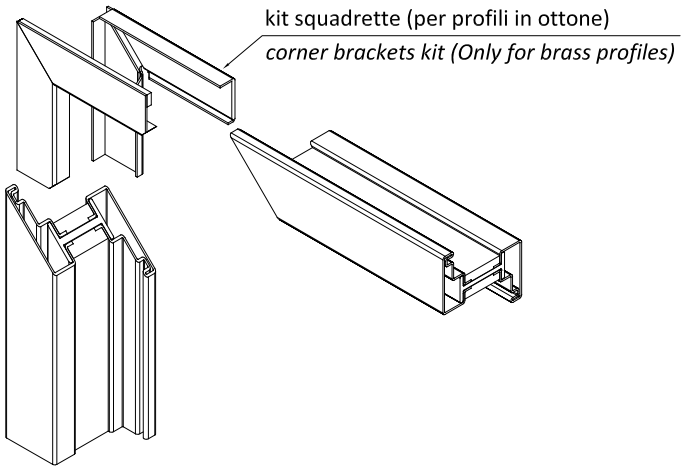
Only for brass profiles
(Stainless steel)

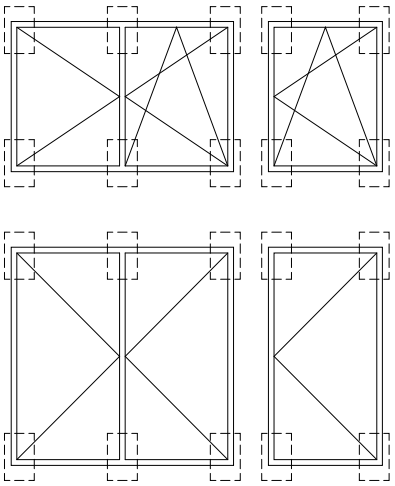


Per profili in Acciaio zincato
Acciaio inox - Acciaio Corten

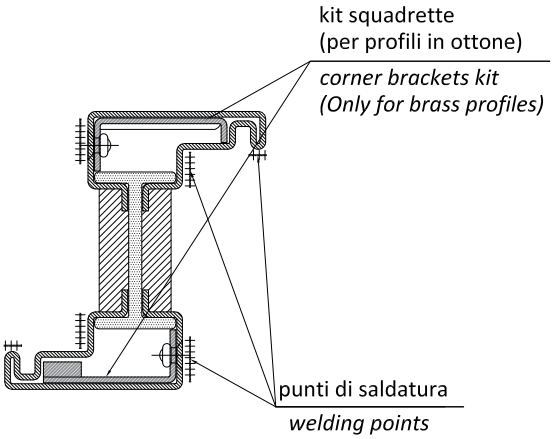
Only for Galvanised steel
Stainless steel - Cor-ten steel







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



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

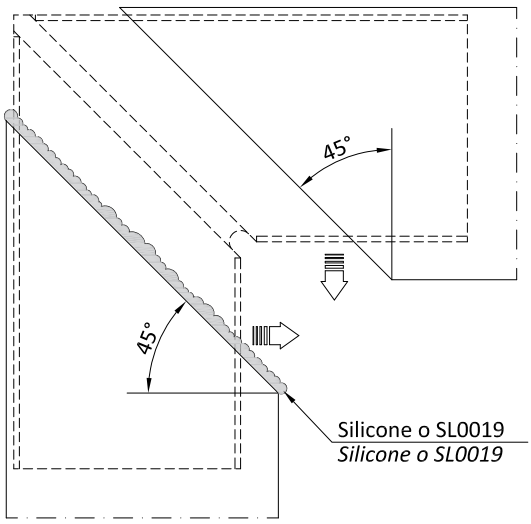
Brass
Use corner brackets, seal all surfaces in touch with profiles that are not to be seam-welded. Spot weld (TIG) the marked areas.

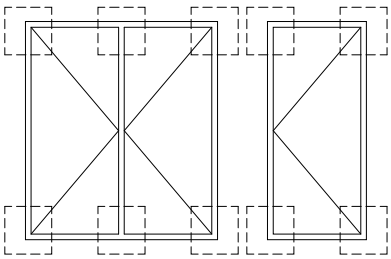
Acciaio zincato - Acciaio Corten - Acciaio inox
Saldare in continuo le superfici di contatto.

Galvanised steel - Cor-ten steel - Stainless steel
Seam-weld all contact surfaces.

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

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





1) inserire la squadretta

2) siliconare nelle zone indicate

3) accostare i profili

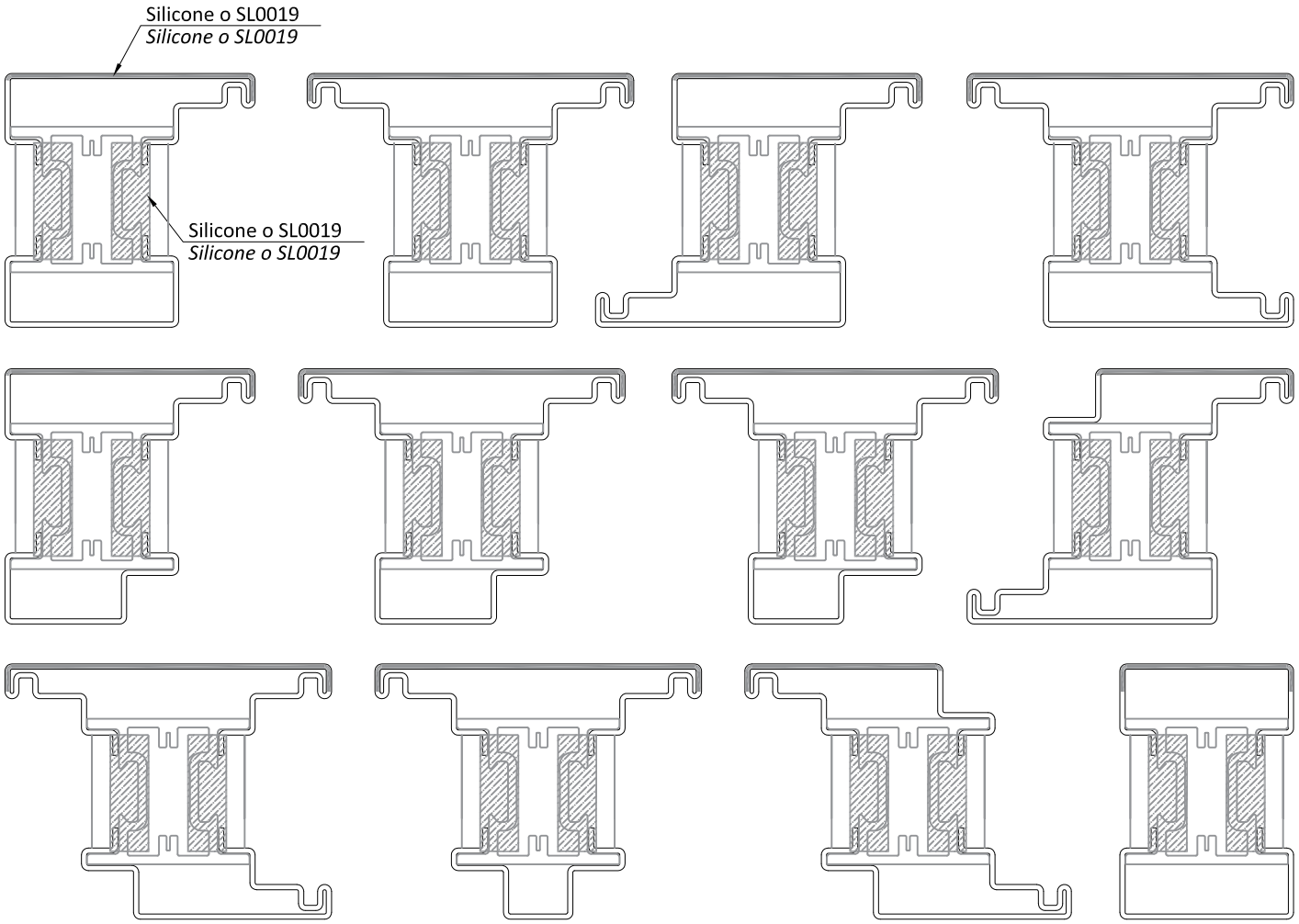
4) procedere con la saldatura (vedasi pagine successive)

1) insert the bracket

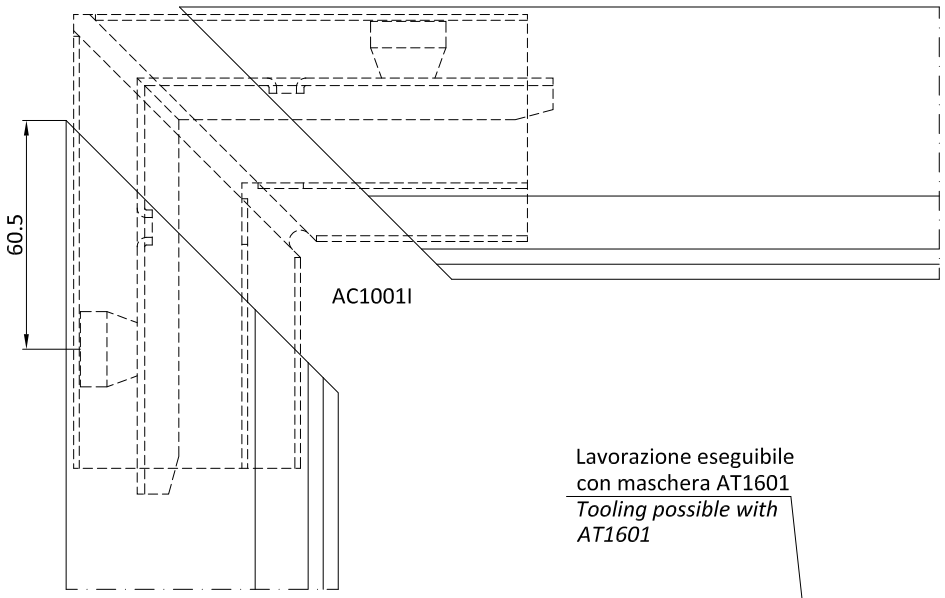
2) seal in the specified areas

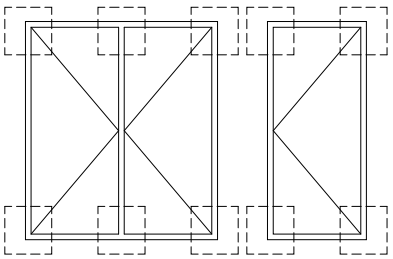
3) align the profiles

4) weld (see following pages)



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





Saldare a TIG con materiale di riporto nelle zone indicate con

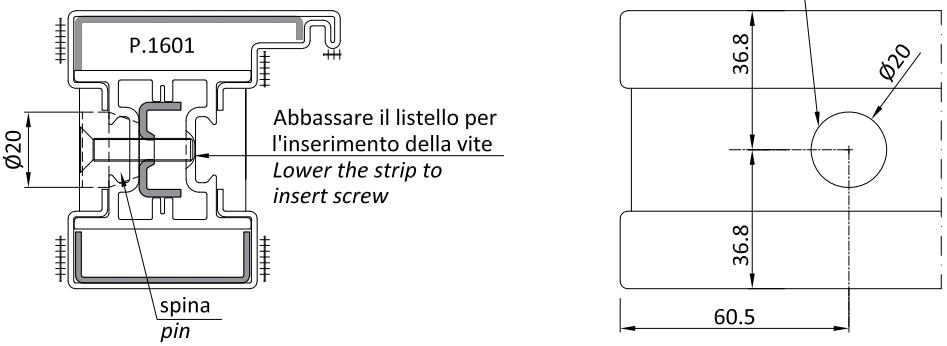
Sigillare tutte le superfici di contatto esterne con silicone o SL0019

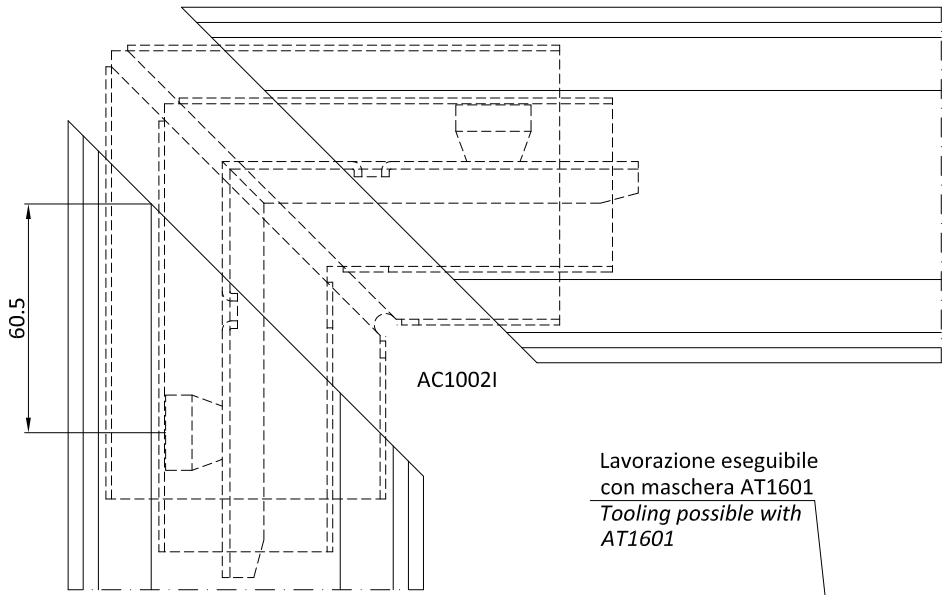
vite TSPEI M6x30 inox

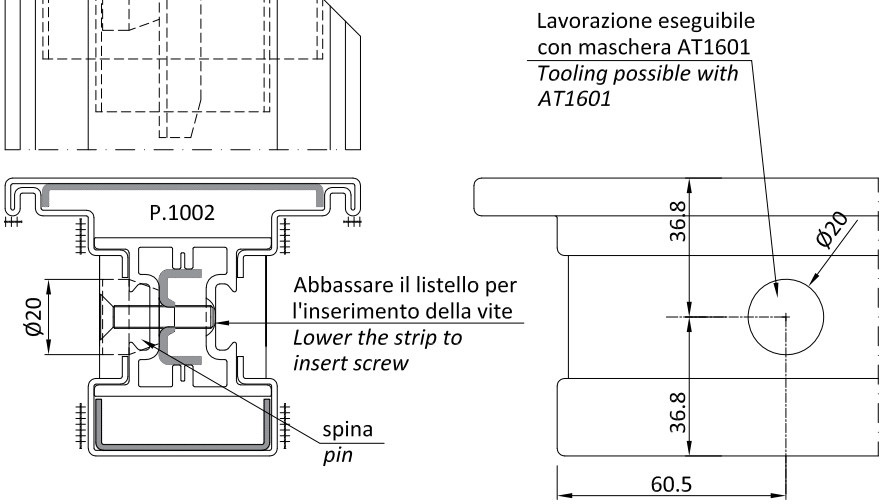
TIG welding with filler material in the areas indicated with

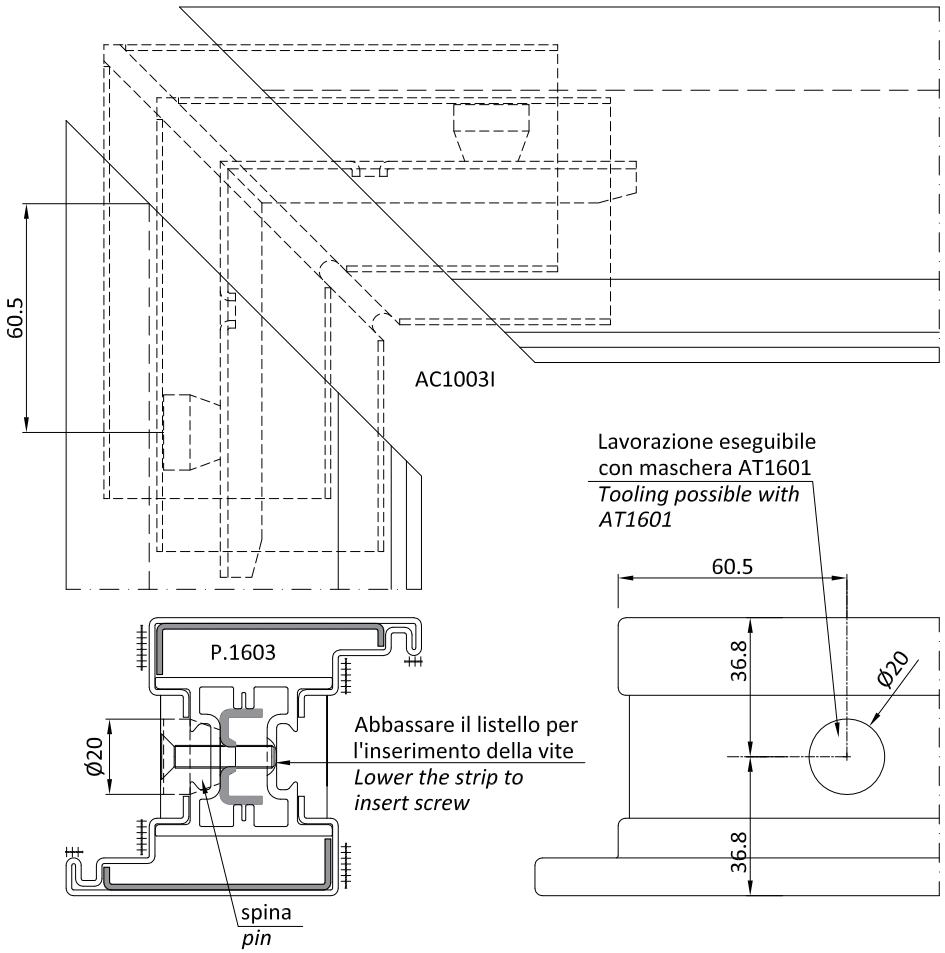
Seal all the external contact surfaces with silicone our SL0019

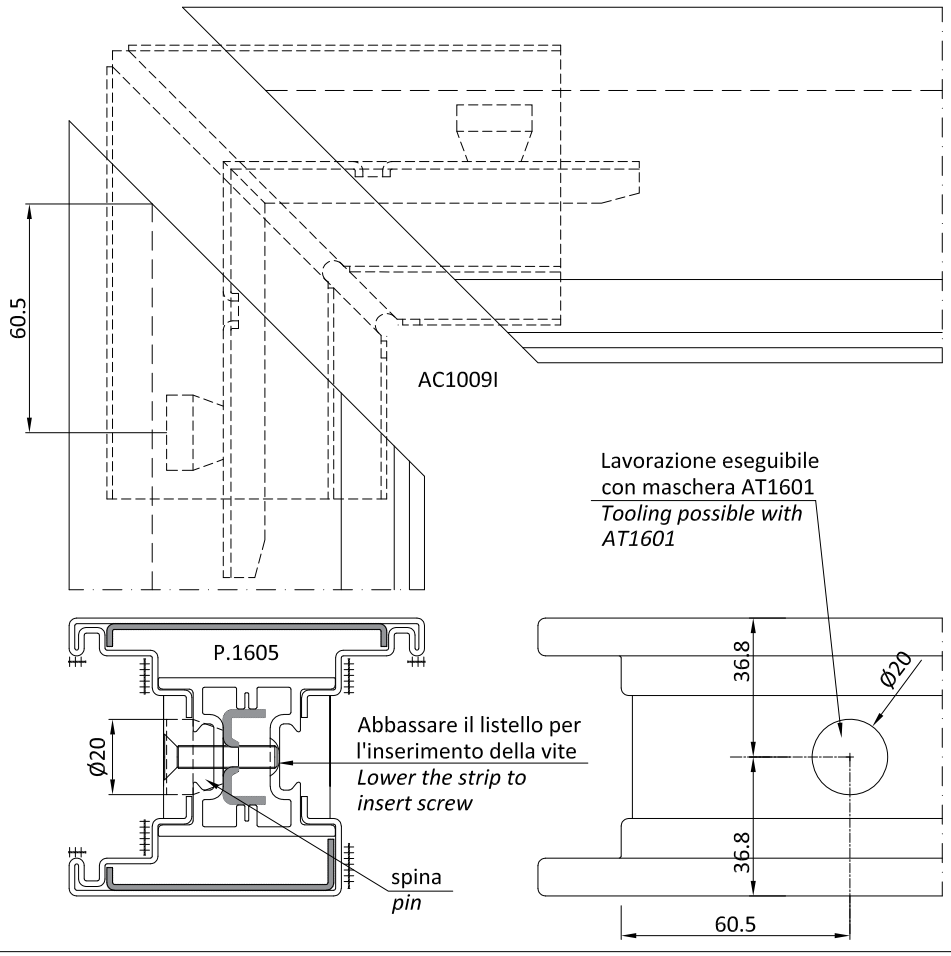
stainless steel screws TSPEI M6x30

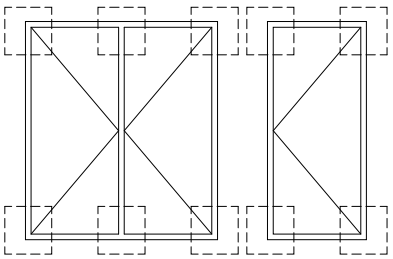












Saldare a TIG con materiale di riporto nelle zone indicate con

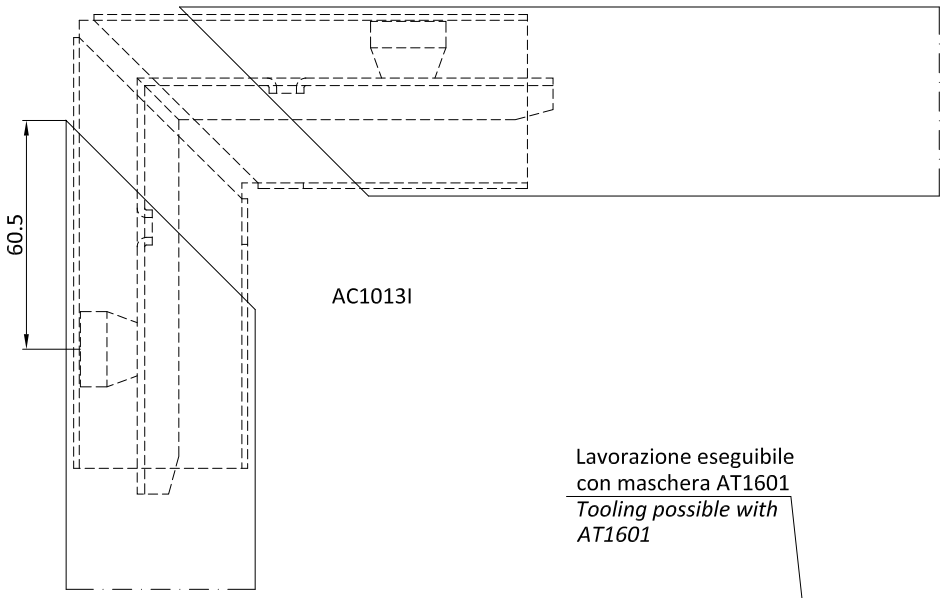
Sigillare tutte le superfici di contatto esterne con silicone o SL0019

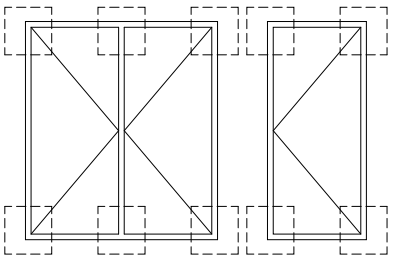
vite TSPEI M6x30 inox

TIG welding with filler material in the areas indicated with

Seal all the external contact surfaces with silicone our SL0019

stainless steel screws TSPEI M6x30





Saldare a TIG con materiale di riporto nelle zone indicate con

Sigillare tutte le superfici di contatto esterne con silicone o SL0019

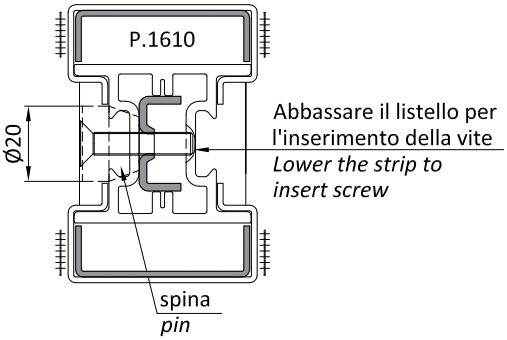
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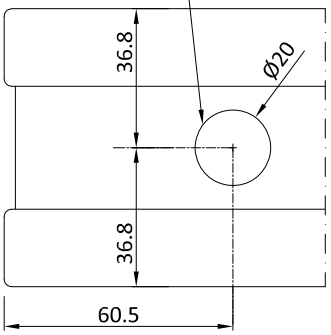
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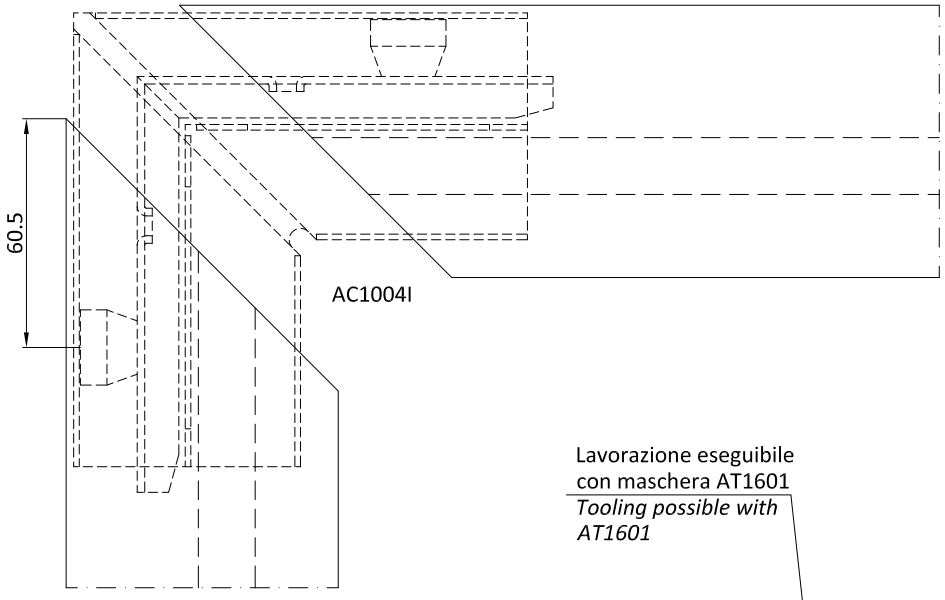
Seal all the external contact surfaces with silicone our SL0019

stainless steel screws TSPEI M6x30

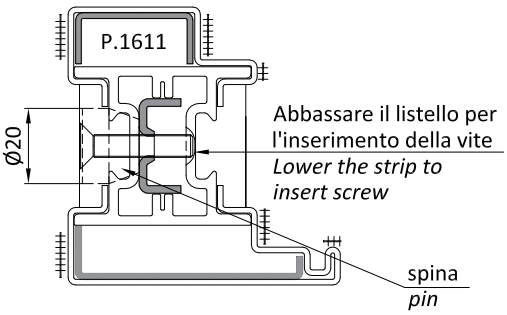
Lavorazione eseguibile con maschera AT1601
Tooling possible with AT1601

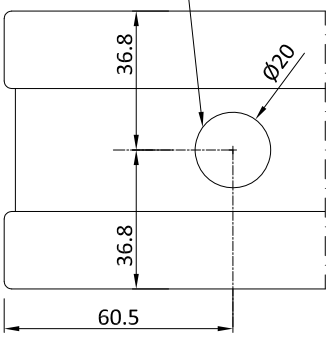


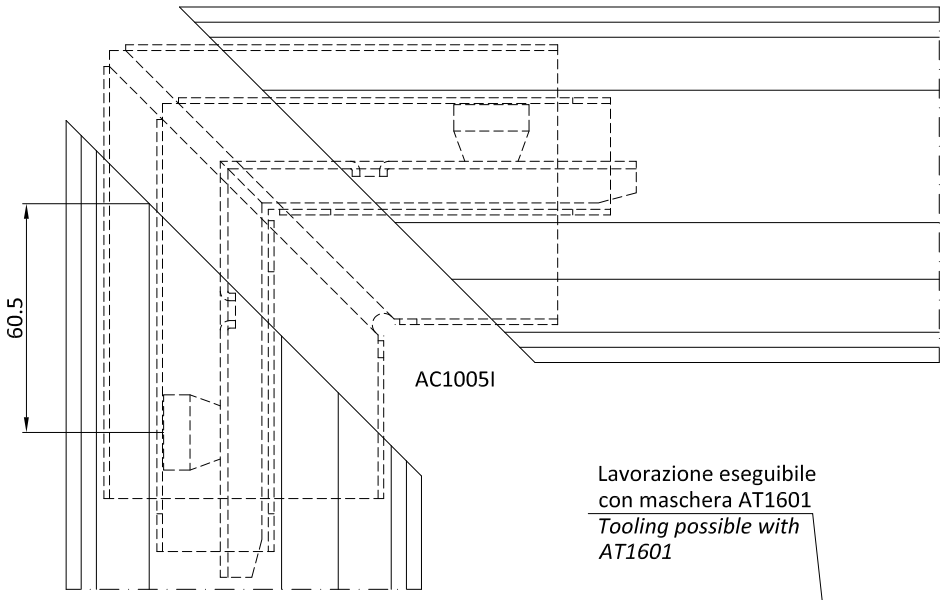


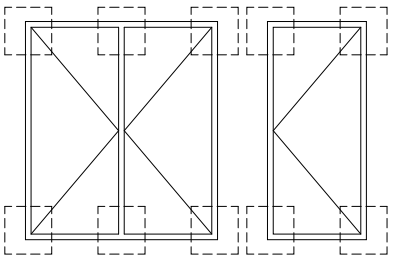


Lavorazione eseguibile con maschera AT1601
Tooling possible with AT1601









Saldare a TIG con materiale di riporto nelle zone indicate con

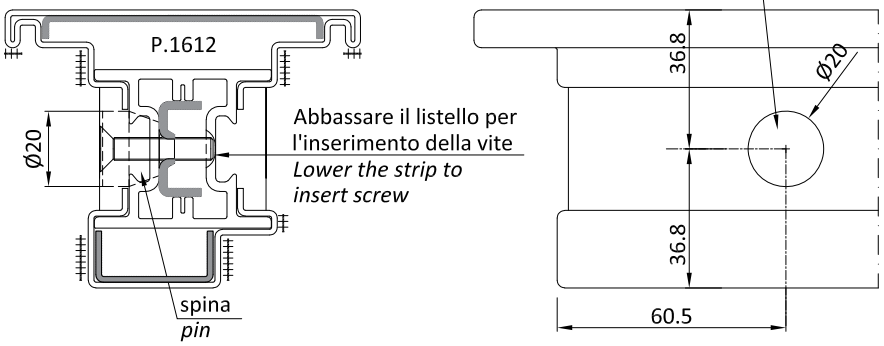
Sigillare tutte le superfici di contatto esterne con silicone o SL0019

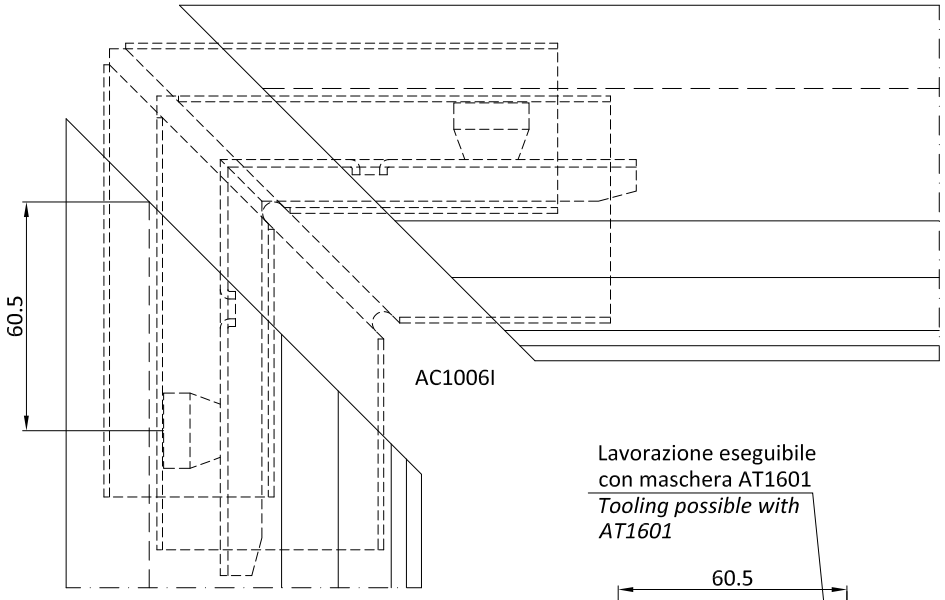
vite TSPEI M6x30 inox

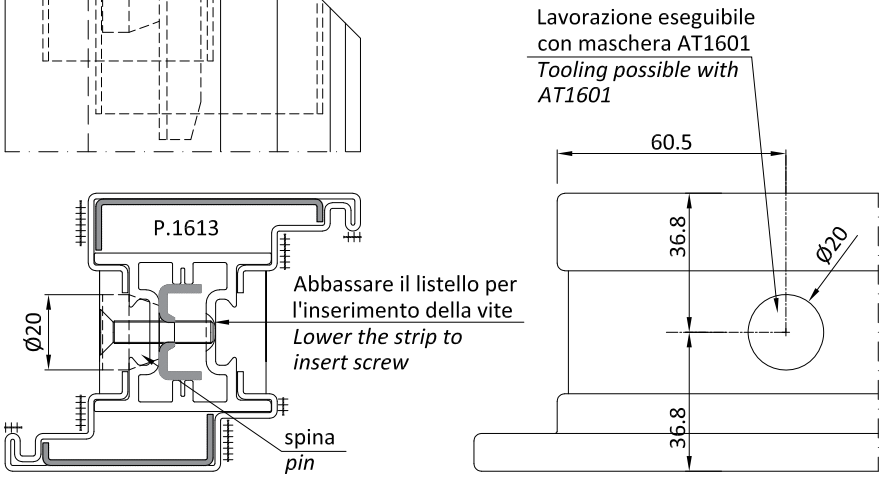
TIG welding with filler material in the areas indicated with

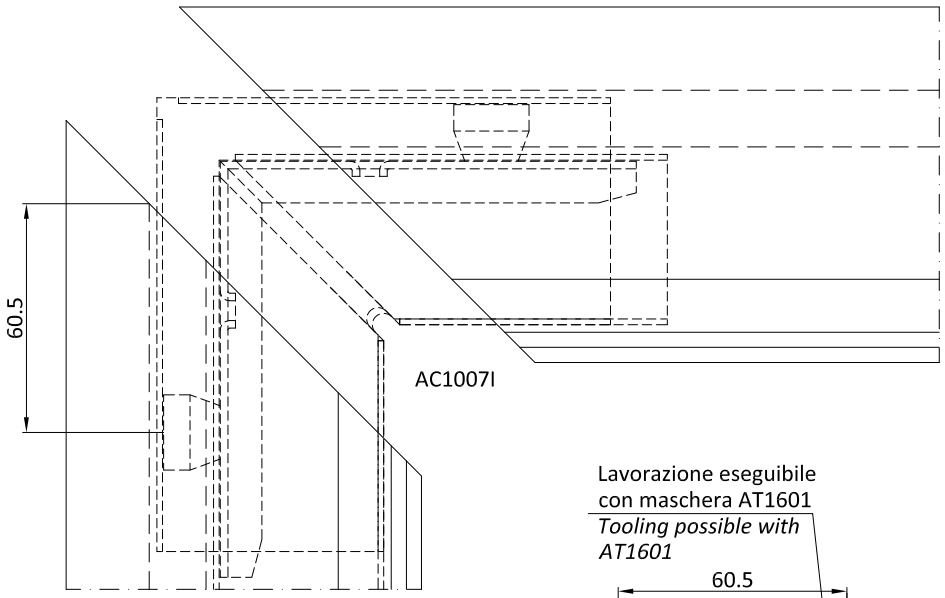
Seal all the external contact surfaces with silicone our SL0019

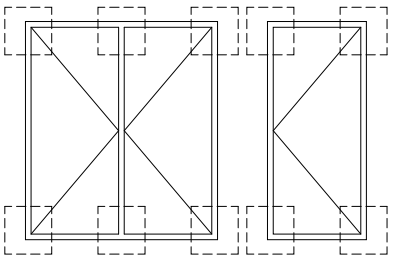
stainless steel screws TSPEI M6x30











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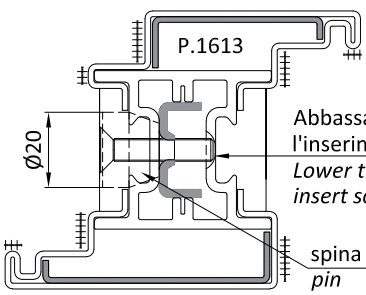
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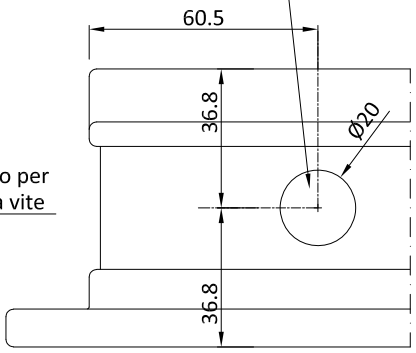
vite TSPEI M6x30 inox

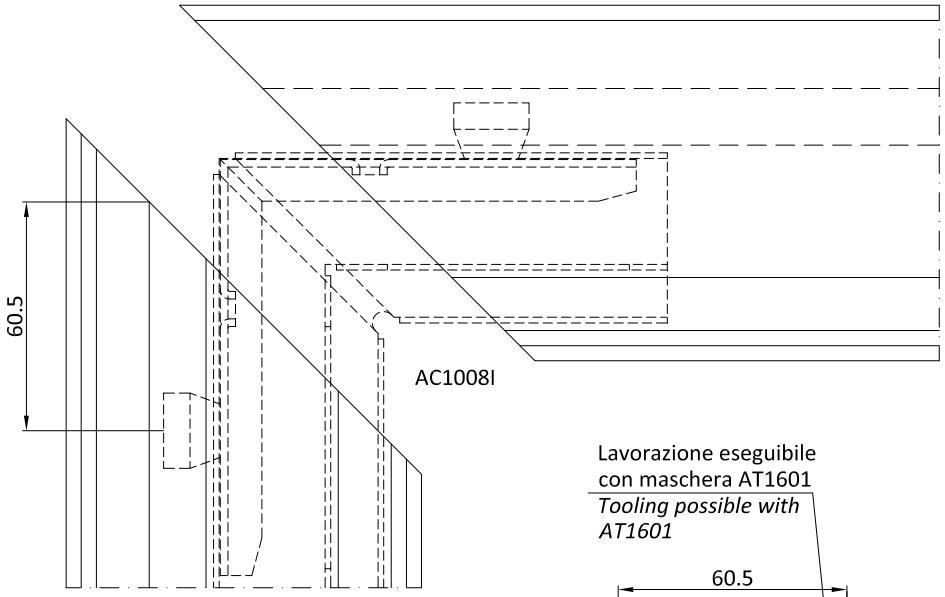
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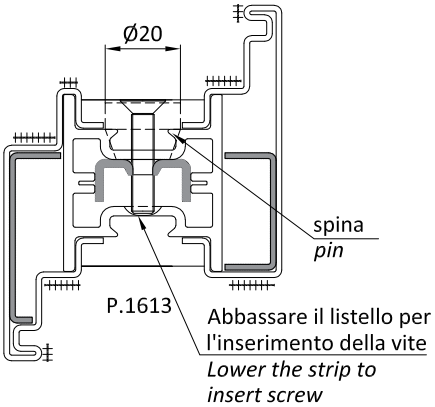
Seal all the external contact surfaces with silicone our SL0019

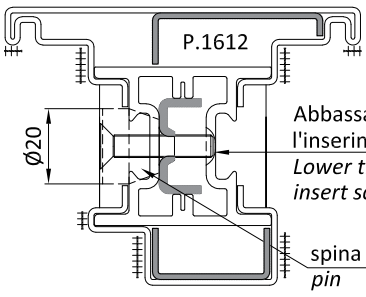
stainless steel screws TSPEI M6x30

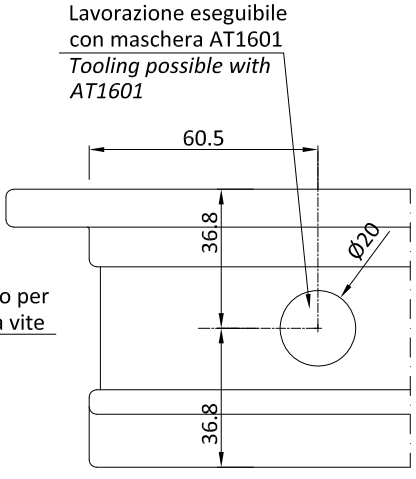


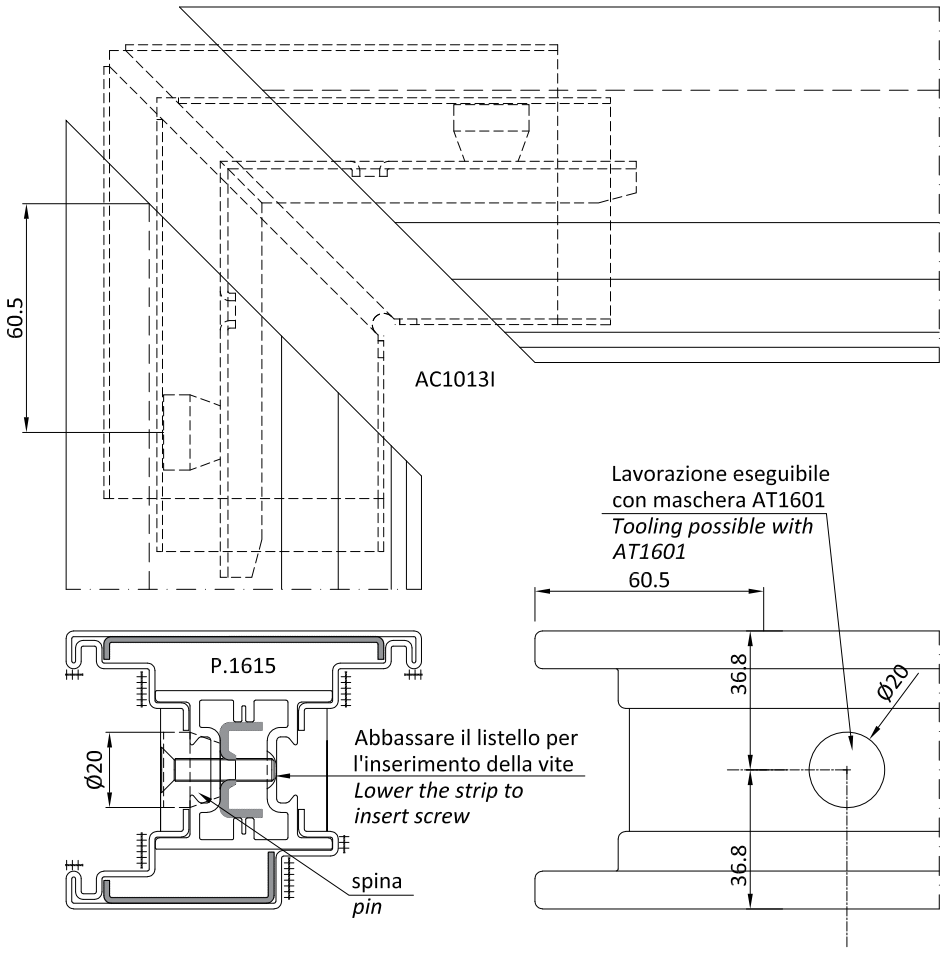


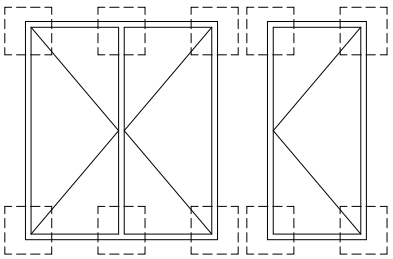












Saldare a TIG con materiale di riporto nelle zone indicate con

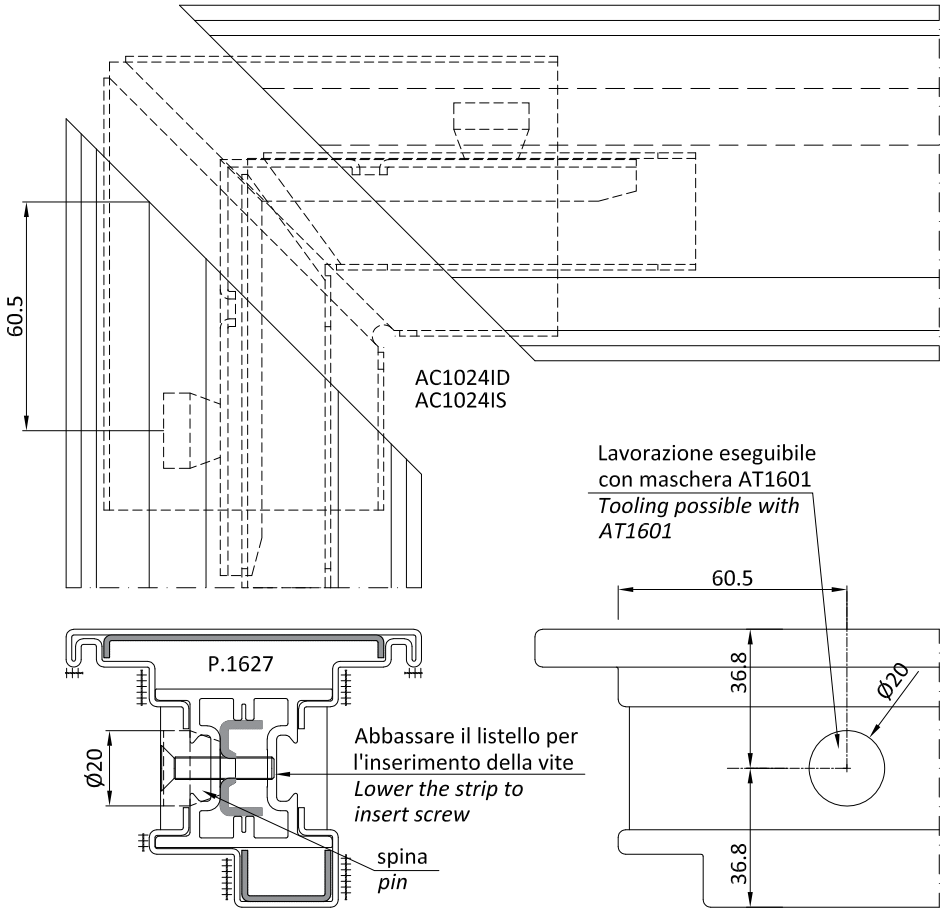
Sigillare tutte le superfici di contatto esterne con silicone o SL0019

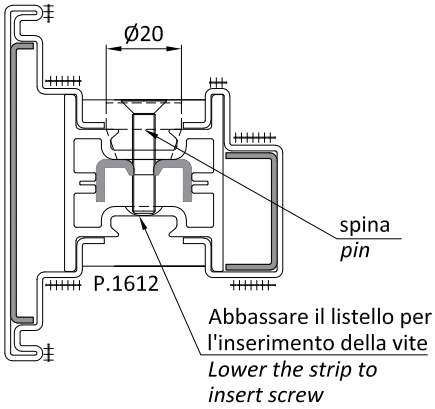
vite TSPEI M6x30 inox

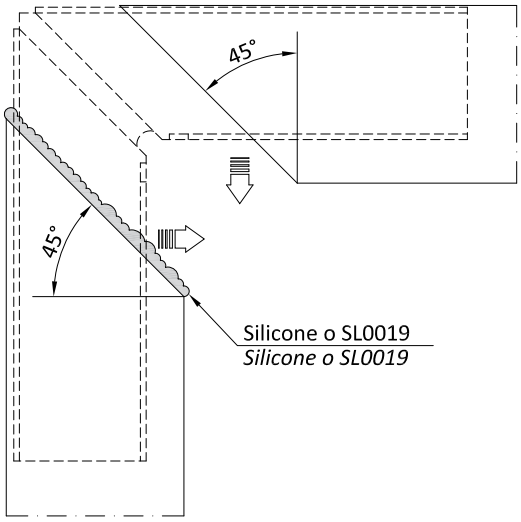
TIG welding with filler material in the areas indicated with

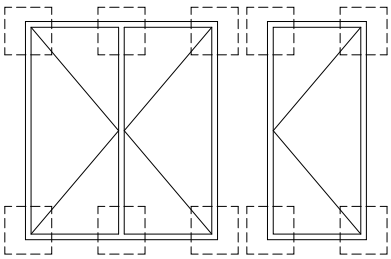
Seal all the external contact surfaces with silicone our SL0019

stainless steel screws TSPEI M6x30









1) inserire la squadretta

2) siliconare nelle zone indicate

3) accostare i profili

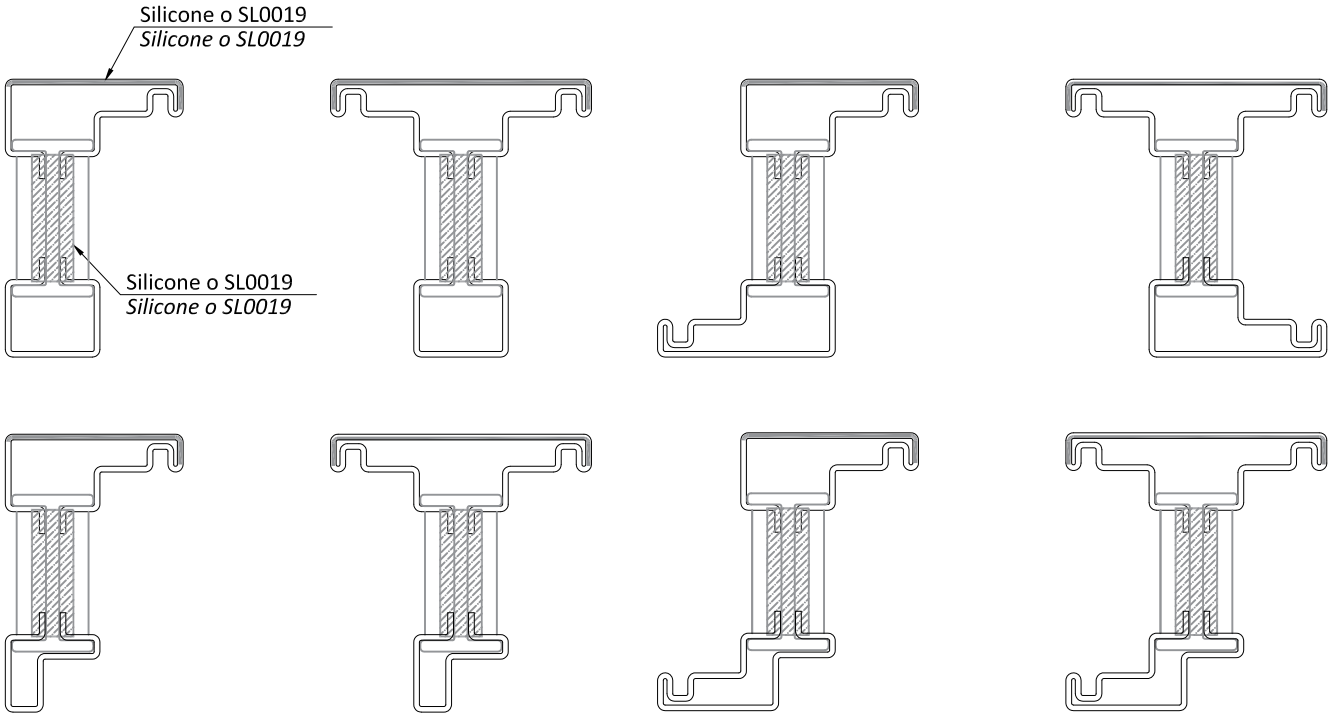
4) procedere con la saldatura (vedasi pagine successive)

1) insert the bracket

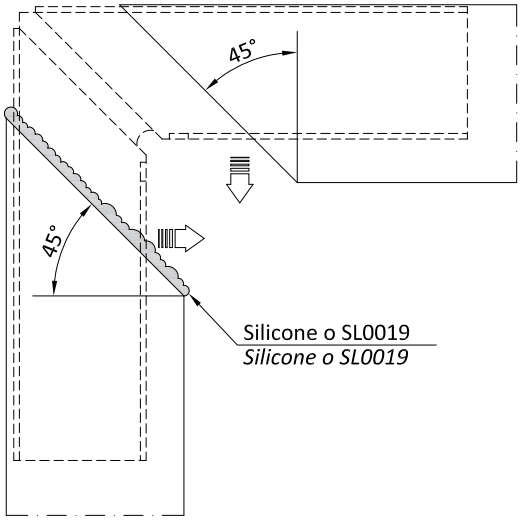
2) seal in the specified areas

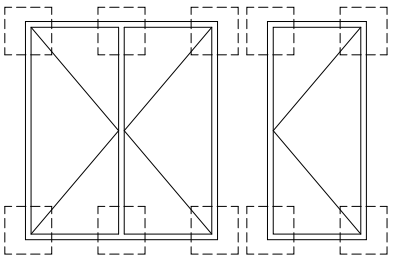
3) align the profiles

4) weld (see following pages)



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





1) inserire la squadretta

2) siliconare nelle zone indicate

3) accostare i profili

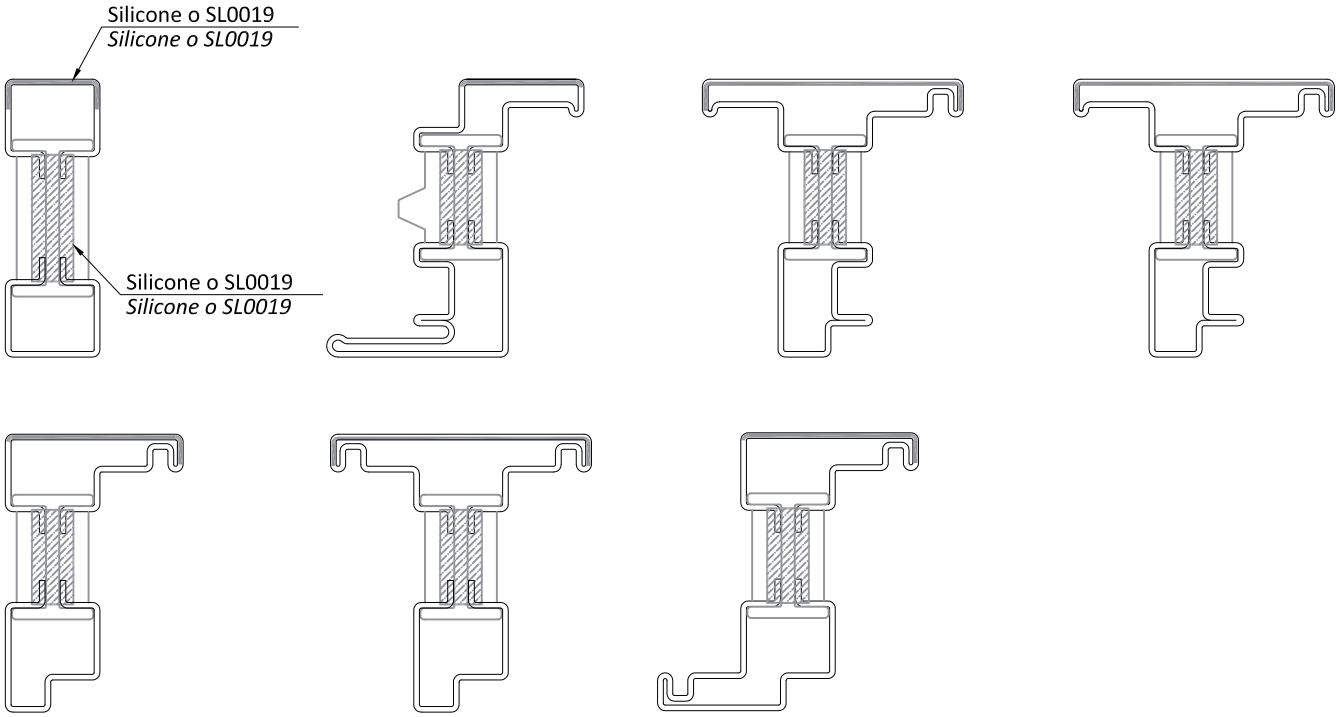
4) procedere con la saldatura (vedasi pagine successive)

1) insert the bracket

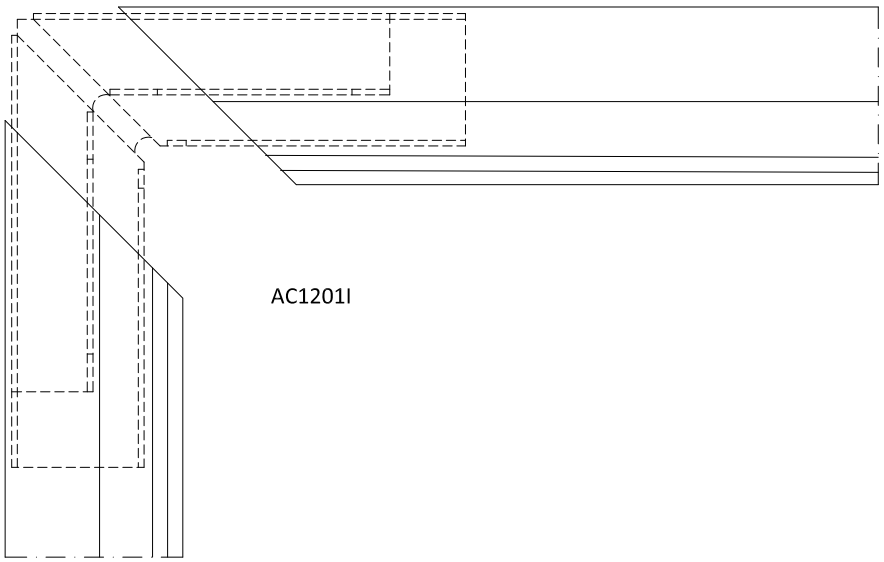
2) seal in the specified areas

3) align the profiles

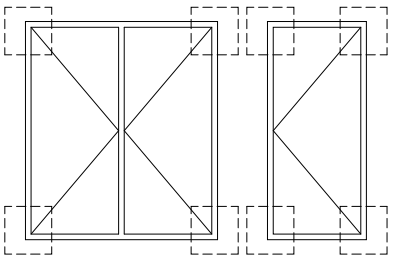
4) weld (see following pages)



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



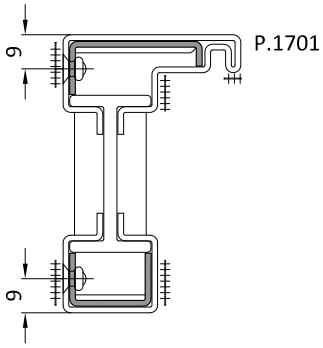
AC1201I



Saldare a TIG con materiale di riporto nelle zone indicate con

Sigillare tutte le superfici di contatto esterne con silicone o SL0019

Rivetti svasati Ø 4

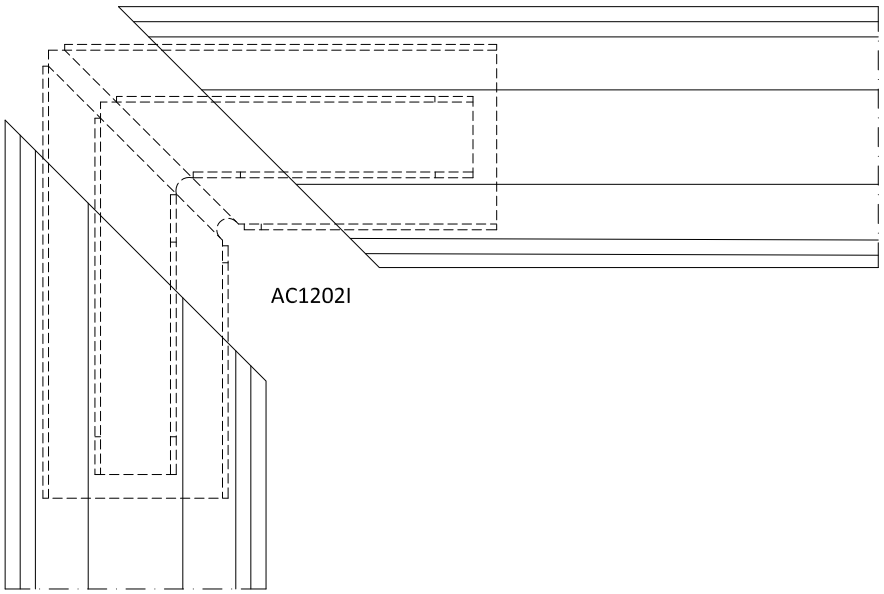


P.1701

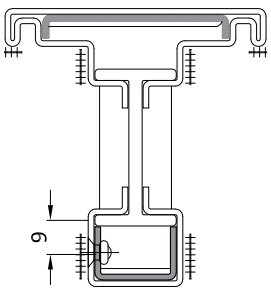
TIG welding with filler material in the areas indicated with

Seal all the external contact surfaces with silicone our SL0019

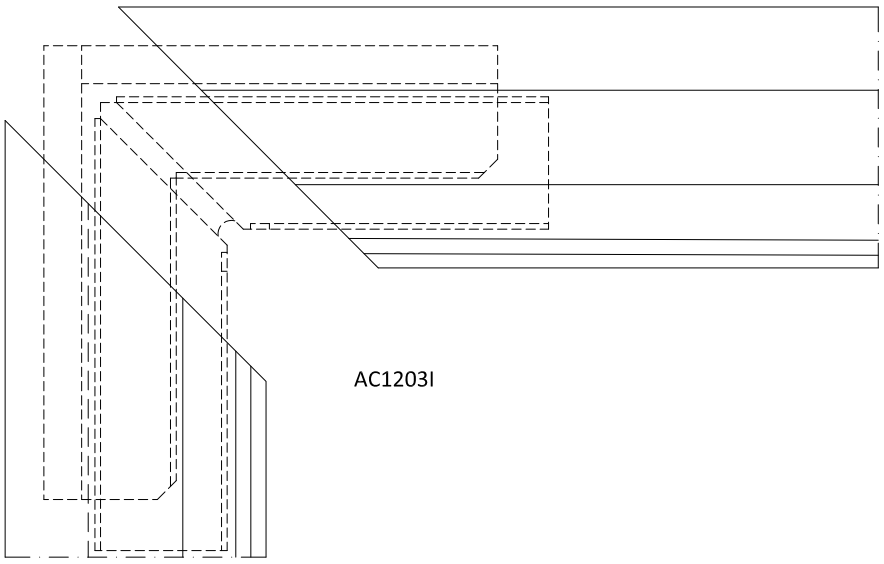
Countersunk rivets Ø 4



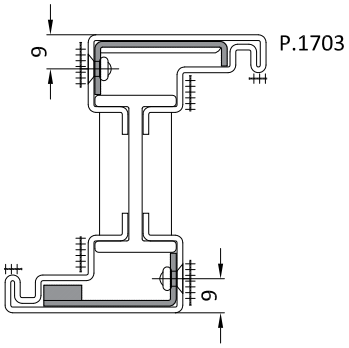
AC1202I



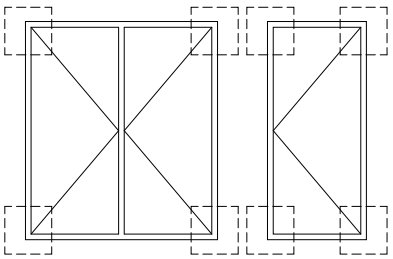
P.1702



AC1203I



P.1703



Saldare a TIG con materiale di riporto nelle zone indicate con

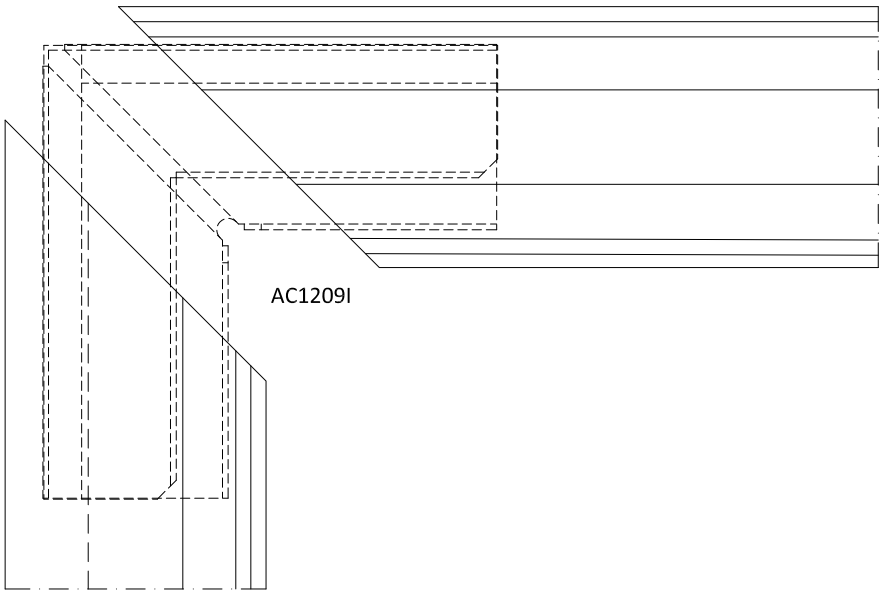
Sigillare tutte le superfici di contatto esterne con silicone o SL0019

Rivetti svasati Ø 4

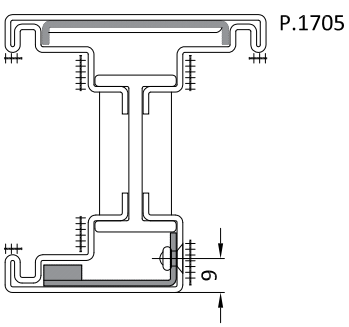
TIG welding with filler material in the areas indicated with

Seal all the external contact surfaces with silicone our SL0019

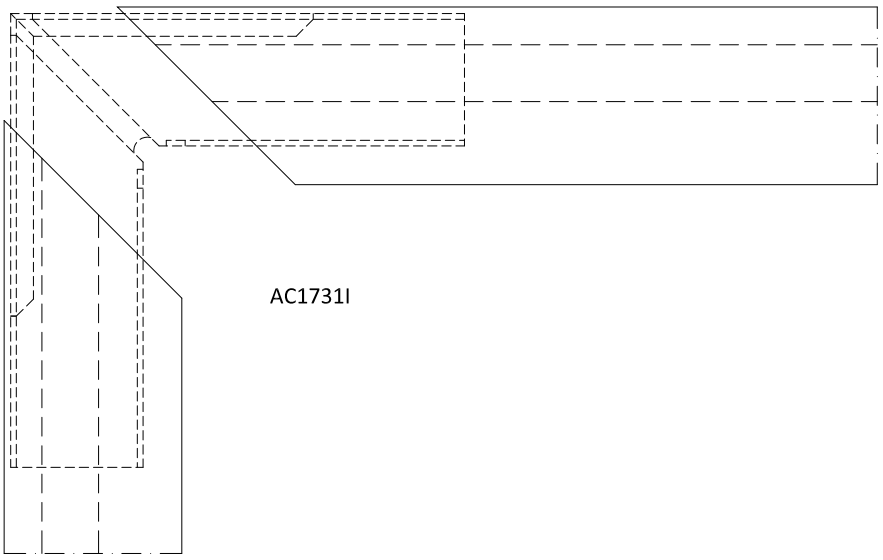
Countersunk rivets Ø 4



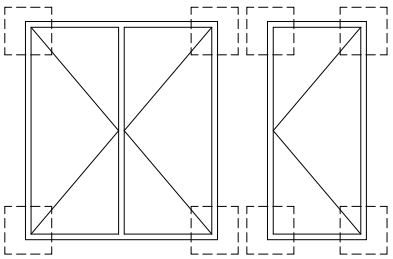
AC1209I



P.1705



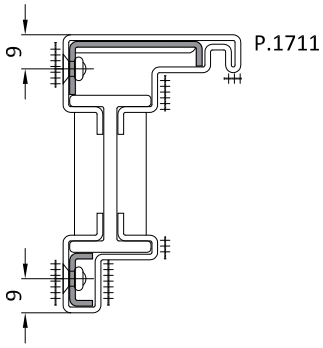
AC1731I



Saldare a TIG con materiale di riporto nelle zone indicate con

Sigillare tutte le superfici di contatto esterne con silicone o SL0019

Rivetti svasati Ø 4

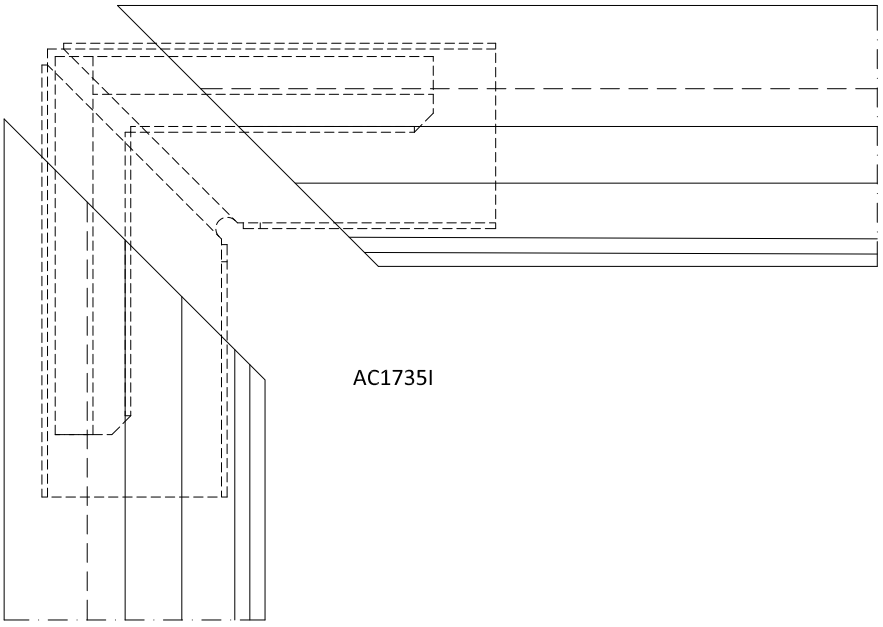


P.1711

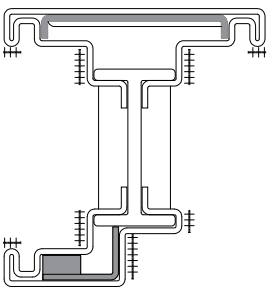
TIG welding with filler material in the areas indicated with

Seal all the external contact surfaces with silicone our SL0019

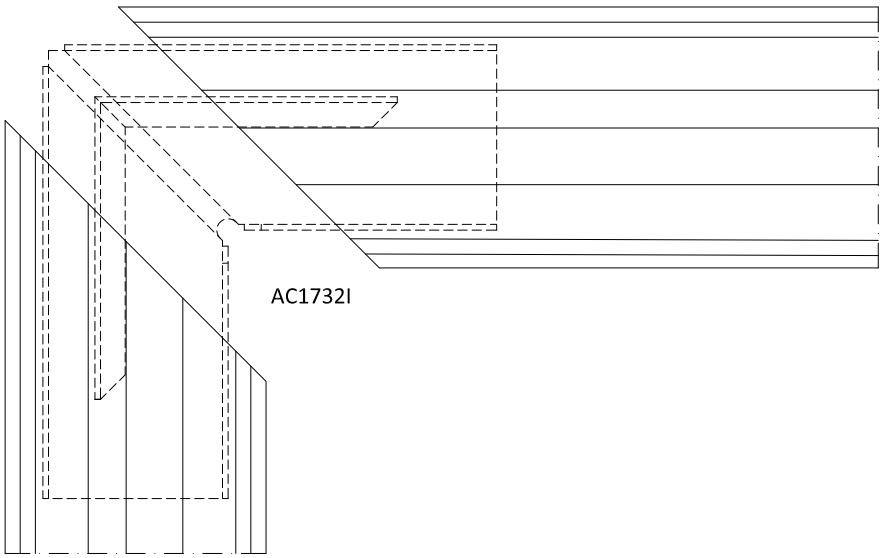
Countersunk rivets Ø 4

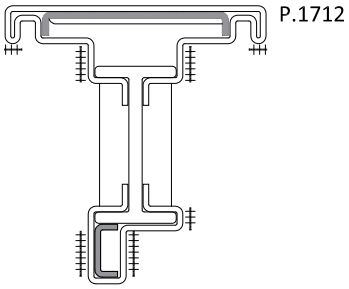


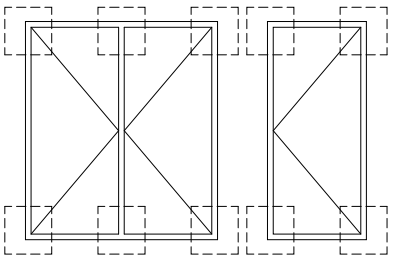
AC1735I



P.1715







Saldare a TIG con materiale di riporto nelle zone indicate con

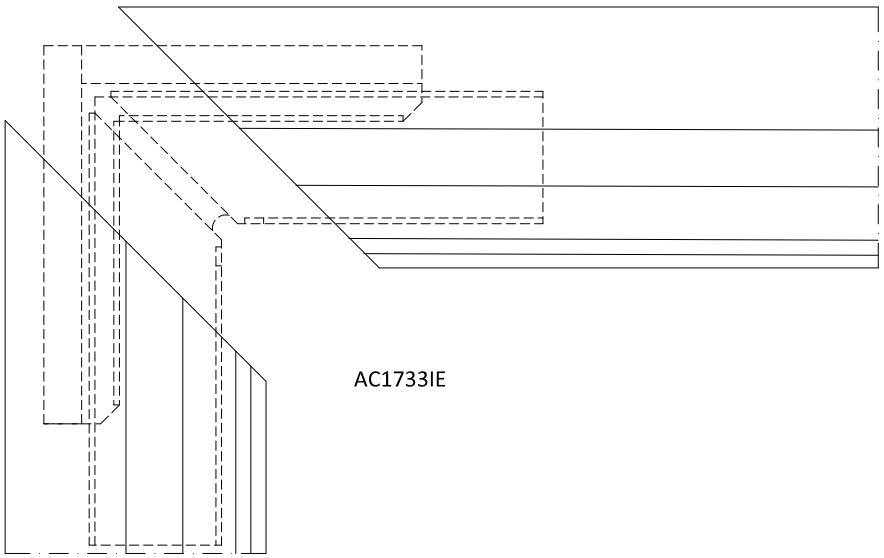
Sigillare tutte le superfici di contatto esterne con silicone o SL0019

Rivetti svasati Ø 4

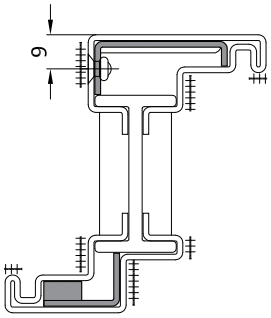
TIG welding with filler material in the areas indicated with

Seal all the external contact surfaces with silicone our SL0019

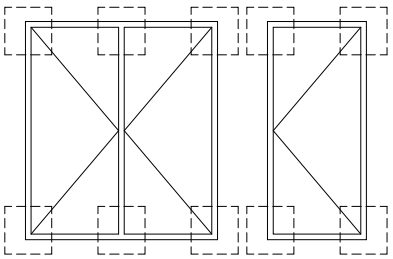
Countersunk rivets Ø 4



AC1733IE



P.1713 (telaio | frame)



Saldare a TIG con materiale di riporto nelle zone indicate con

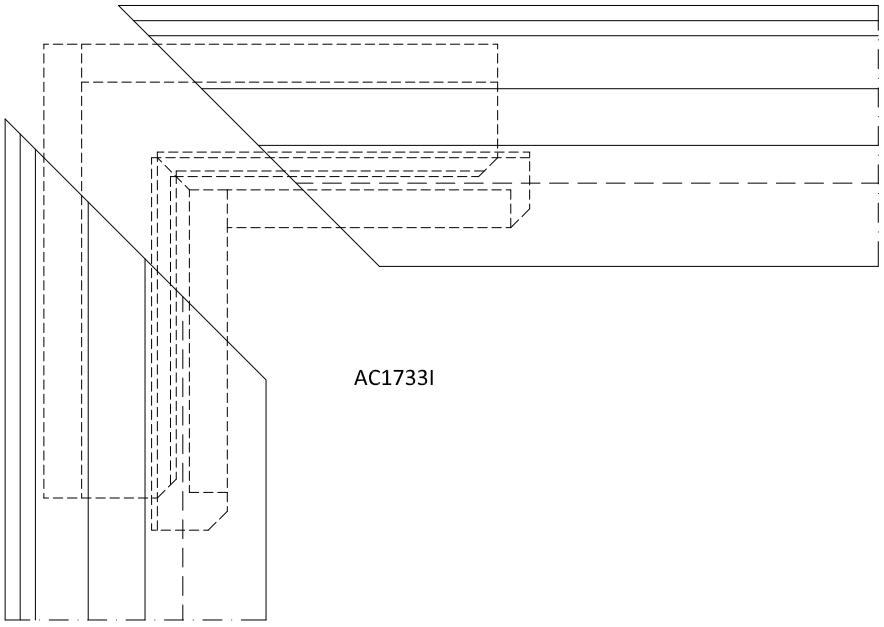
Sigillare tutte le superfici di contatto esterne con silicone o SL0019

Rivetti svasati Ø 4

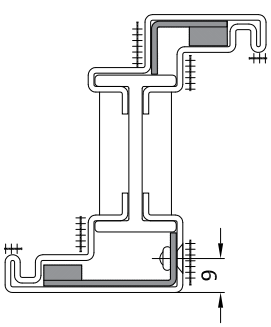
TIG welding with filler material in the areas indicated with

Seal all the external contact surfaces with silicone our SL0019

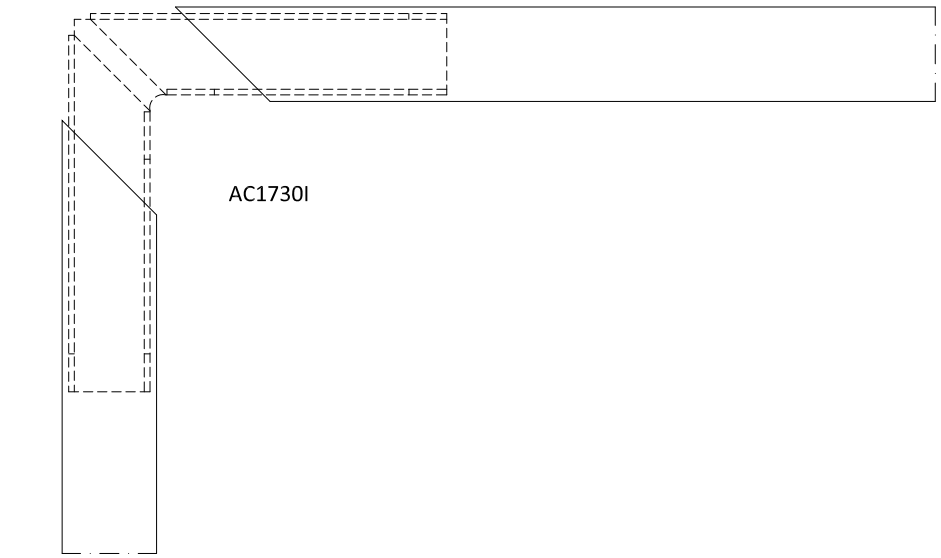
Countersunk rivets Ø 4

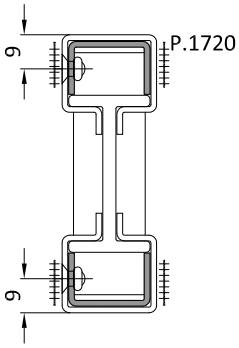


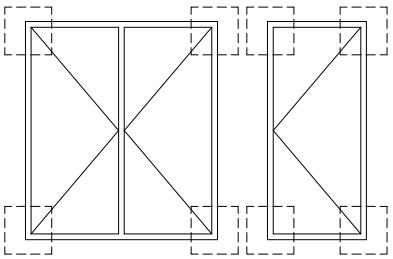
AC1733I



P.1713 (anta | leaf)







Saldare a TIG con materiale di riporto nelle zone indicate con

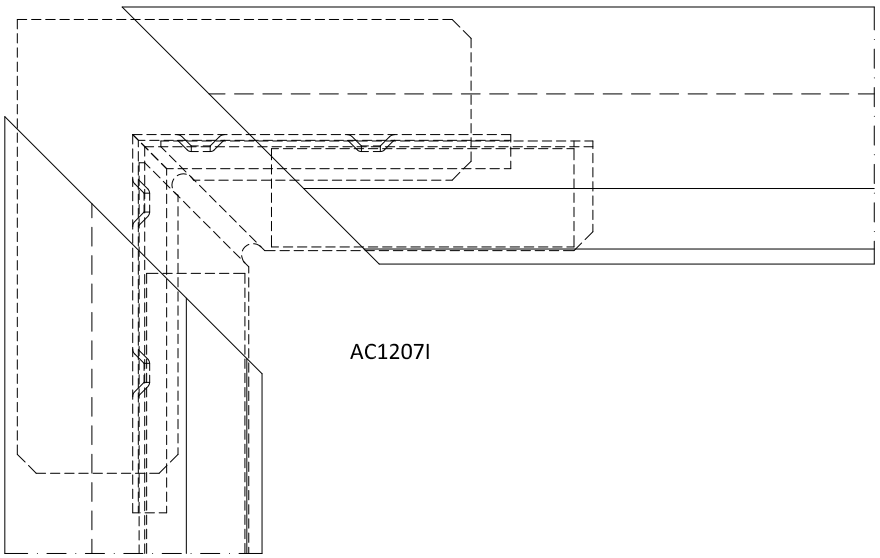
Sigillare tutte le superfici di contatto esterne con silicone o SL0019

Rivetti svasati Ø 4

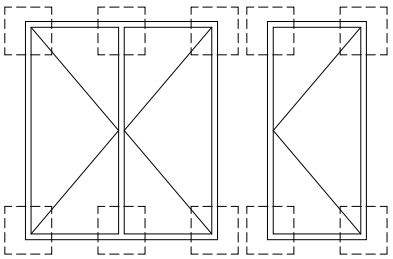
TIG welding with filler material in the areas indicated with

Seal all the external contact surfaces with silicone our SL0019

Countersunk rivets Ø 4



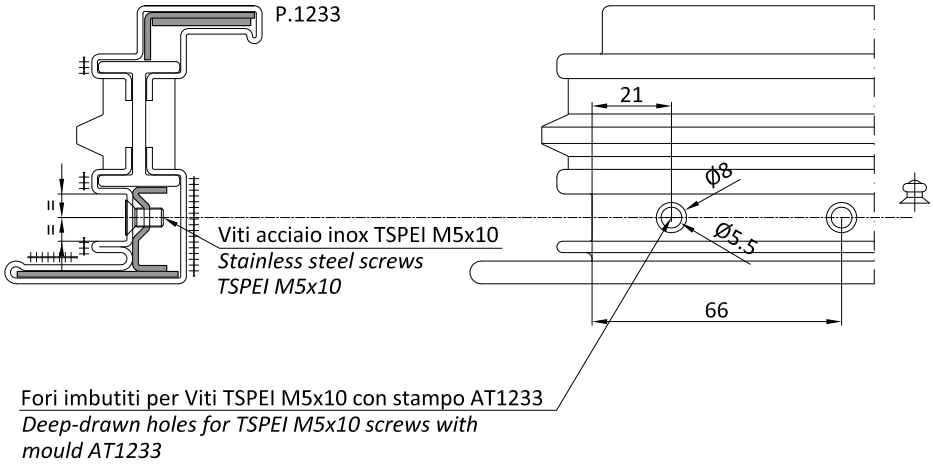
AC1207I



Saldare a TIG con materiale di riporto nelle zone indicate con

Sigillare tutte le superfici di contatto esterne con silicone o SL0019

Rivetti svasati Ø 4



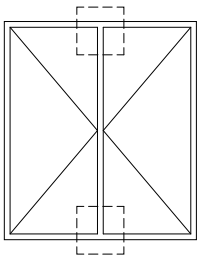
Viti acciaio inox TSPEI M5x10
Stainless steel screws TSPEI M5x10

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

TIG welding with filler material in the areas indicated with

Seal all the external contact surfaces with silicone our SL0019

Countersunk rivets Ø 4



Saldare a TIG con materiale di riporto nelle zone indicate con

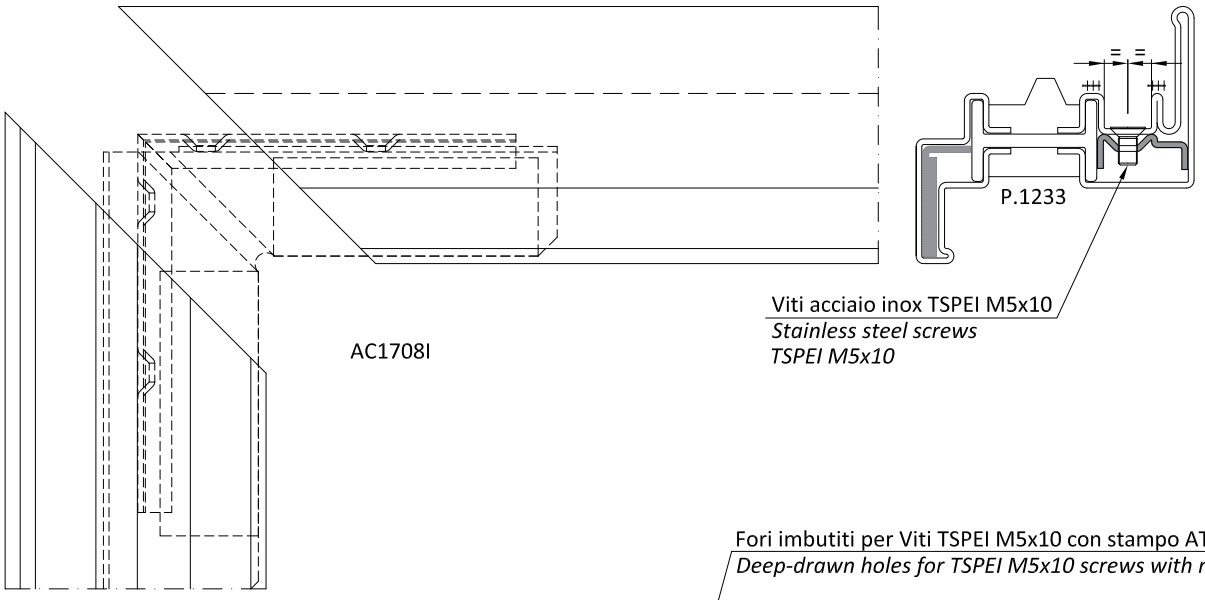
TIG welding with filler material in the areas indicated with

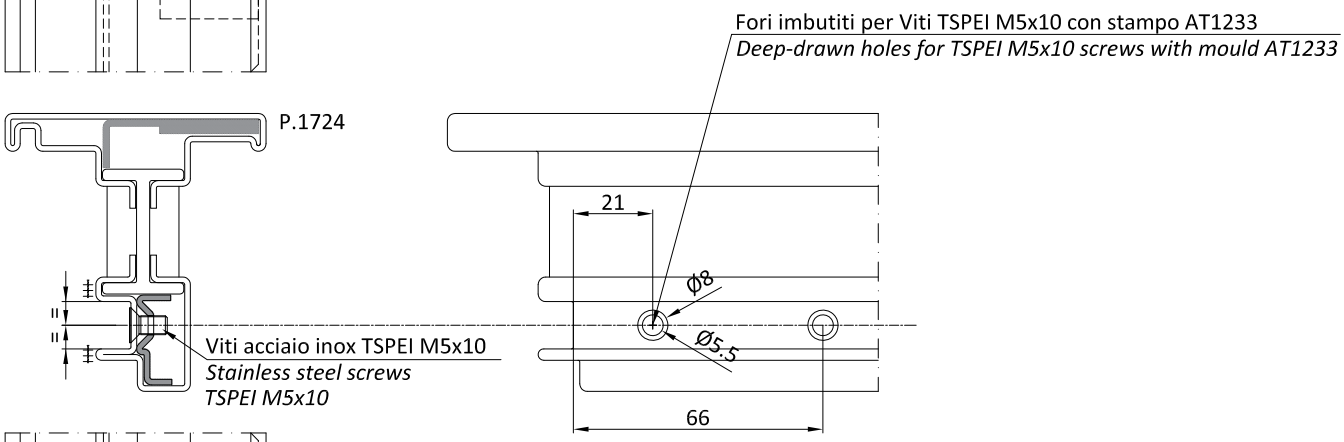
Sigillare tutte le superfici di contatto esterne con silicone o SL0019

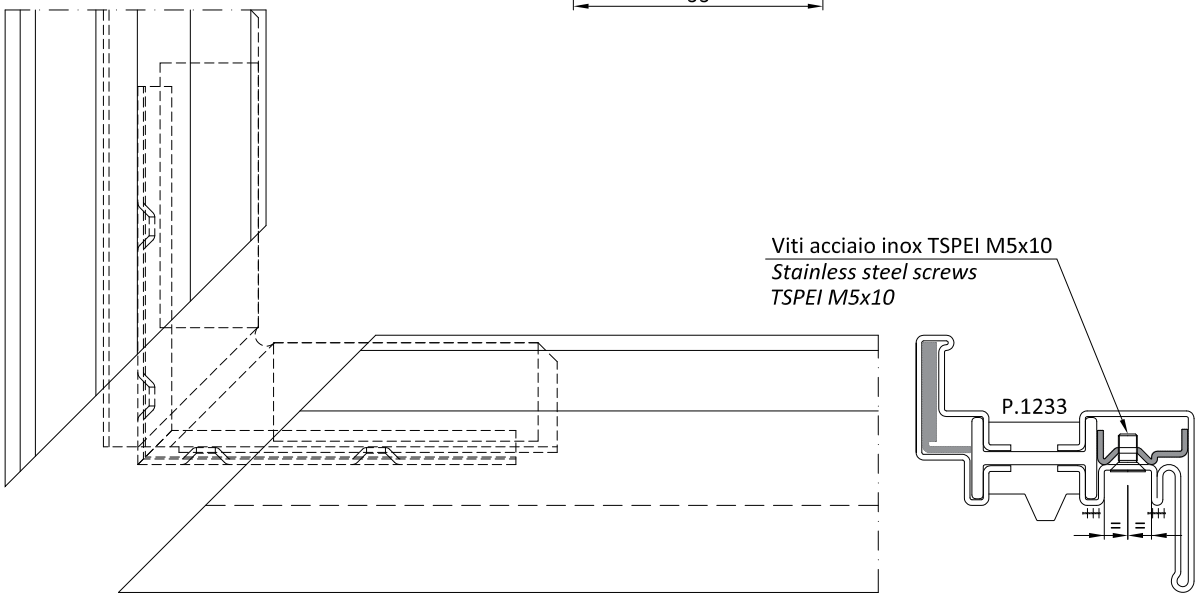
Seal all the external contact surfaces with silicone our SL0019

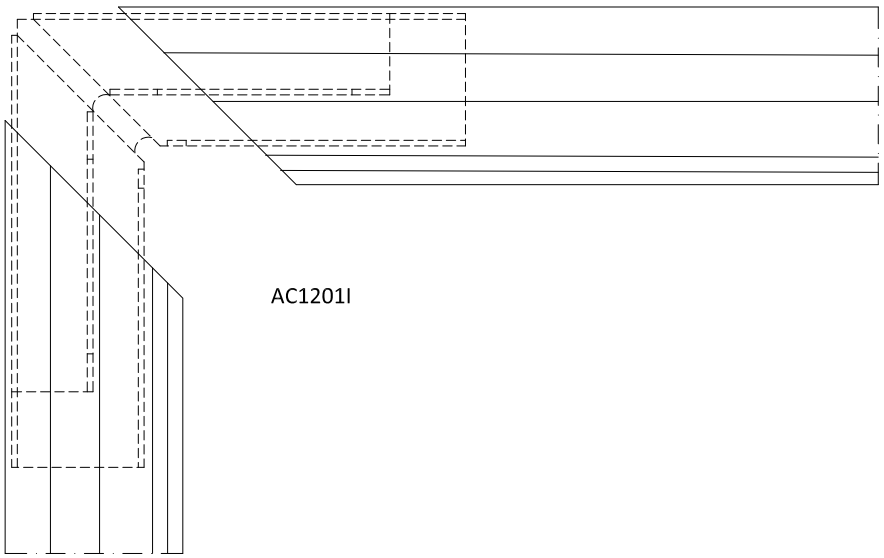
Rivetti svasati Ø 4

Countersunk rivets Ø 4

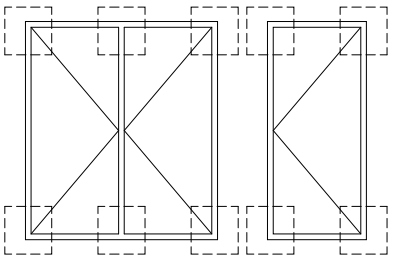








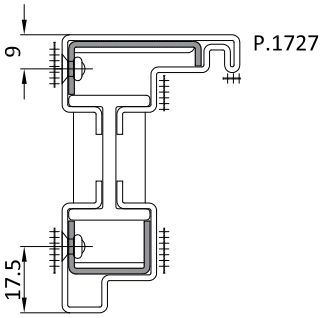
AC1201I



Saldare a TIG con materiale di riporto nelle zone indicate con

Sigillare tutte le superfici di contatto esterne con silicone o SL0019

Rivetti svasati Ø 4

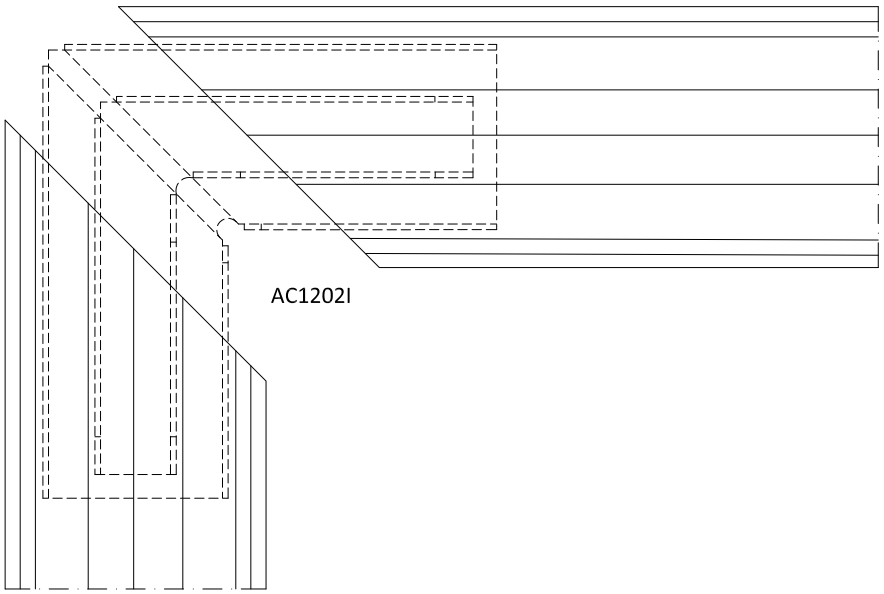


P.1727

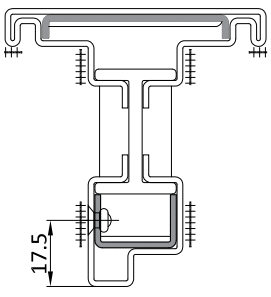
TIG welding with filler material in the areas indicated with

Seal all the external contact surfaces with silicone our SL0019

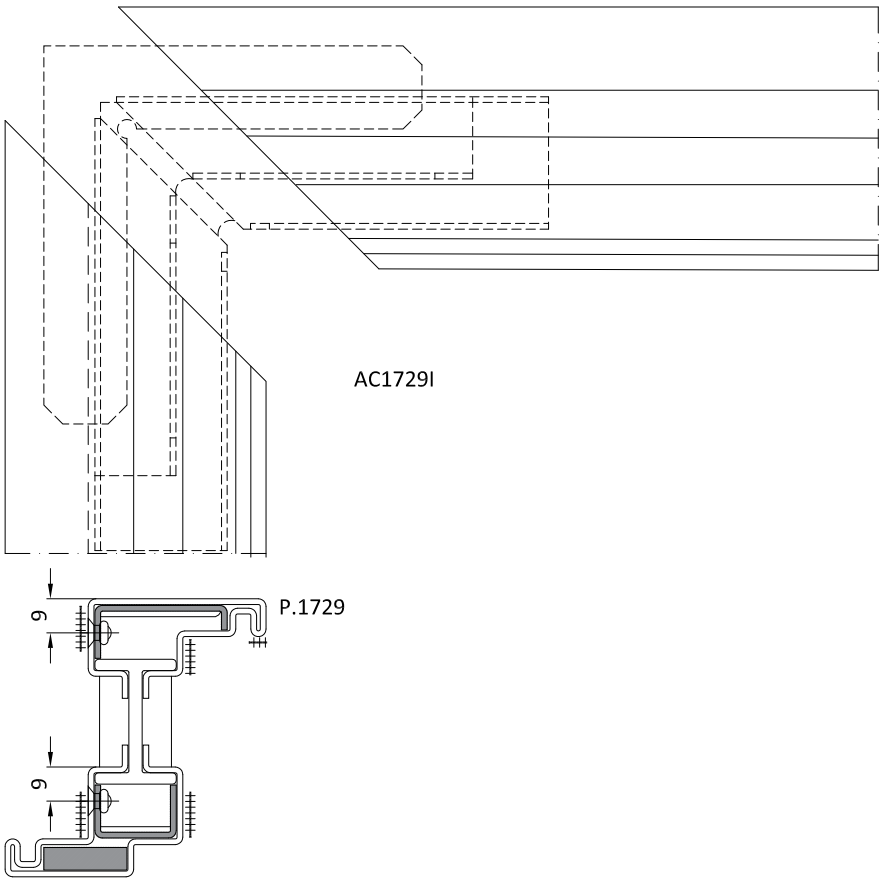
Countersunk rivets Ø 4

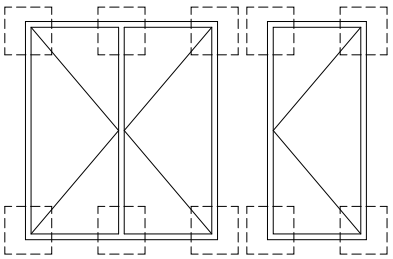


AC1202I



P.1728





Saldare a TIG con materiale di riporto nelle zone indicate con

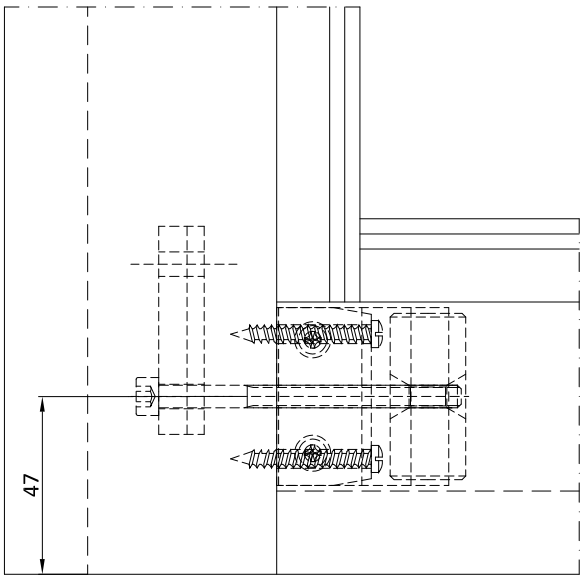
Sigillare tutte le superfici di contatto esterne con silicone o SL0019

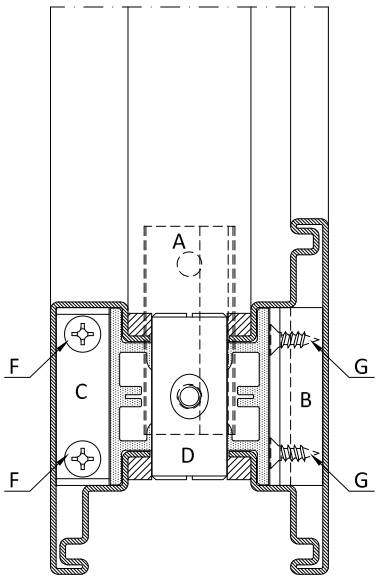
Rivetti svasati Ø 4

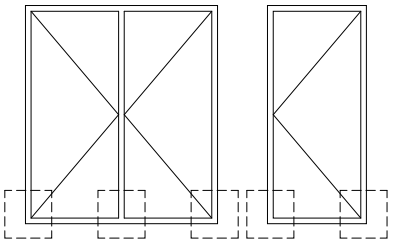
TIG welding with filler material in the areas indicated with

Seal all the external contact surfaces with silicone our SL0019

Countersunk rivets Ø 4







Saldare a TIG con materiale di riporto nelle zone indicate con

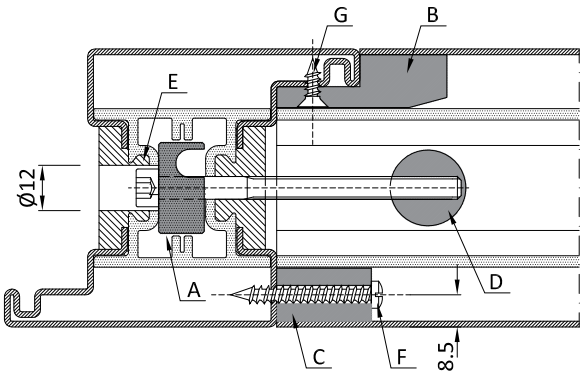
Sigillare tutte le superfici di contatto con silicone o SL0019

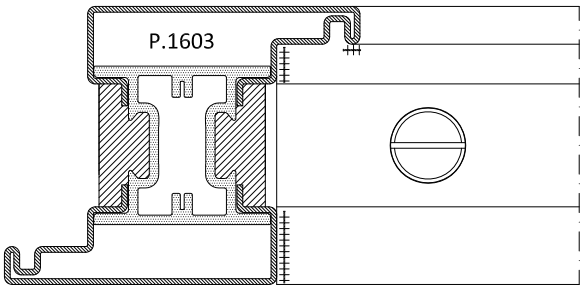
A) Inserto di fissaggio
B) Cavallotto di allineamento lato esterno
C) Cavallotto di allineamento lato interno
D) Tirante per cavallotto
E) Vite acciaio inox TCEI M6x80
F) Vite acciaio inox TC 4.8x38
G) Vite autofilettante TSTC 3.9x9.5

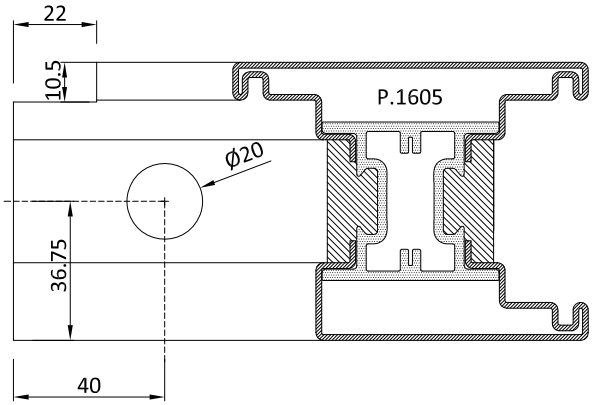
TIG welding with filler material in the areas indicated with

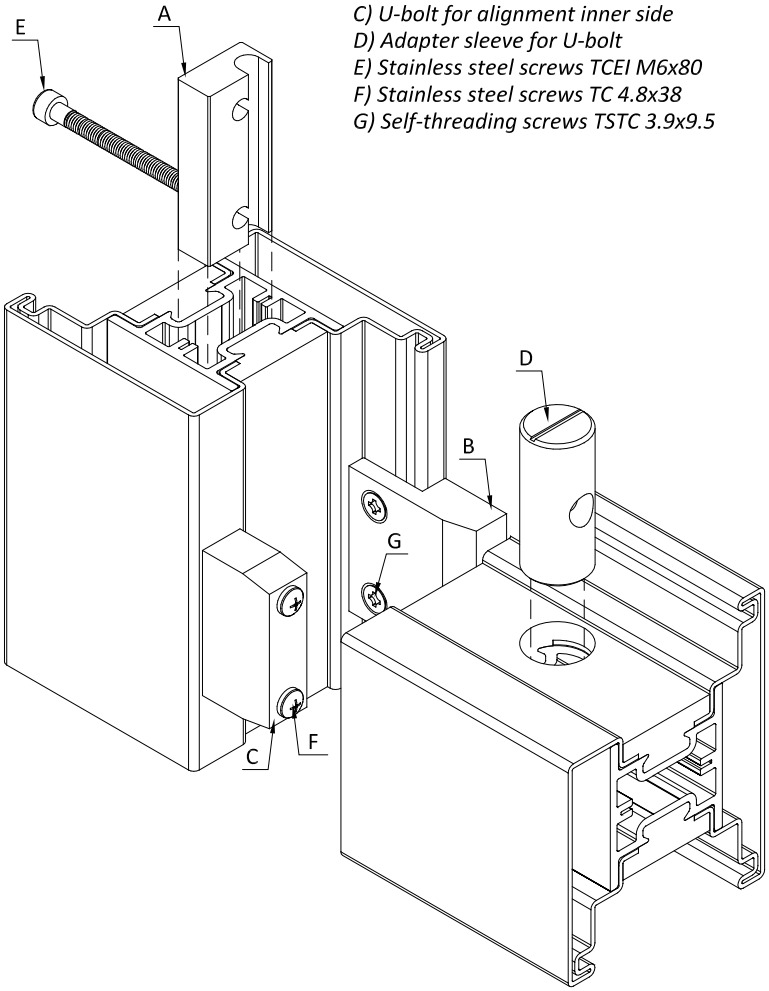
Seal all the external contact surfaces with silicone or SL0019

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

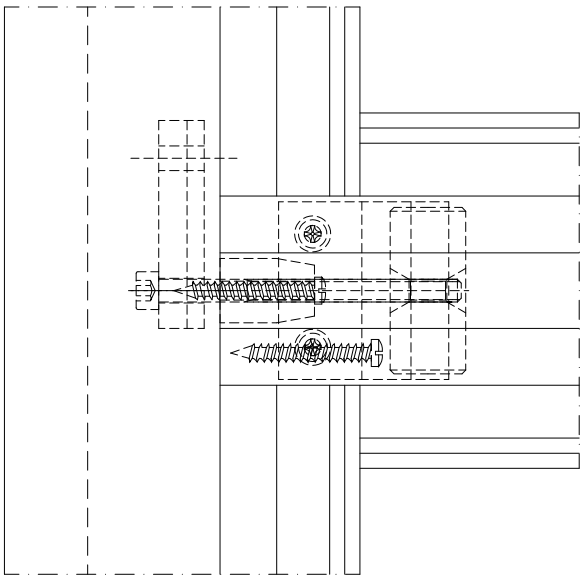


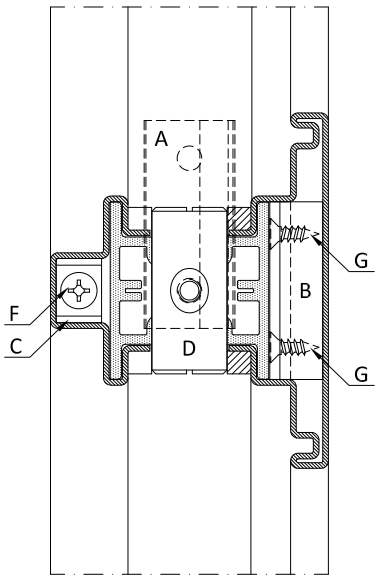


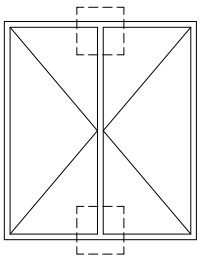




Lavorazione valida per profili P.1601 - P.1602 - 1605
Tooling valid for profiles P.1601 - P.1602 - P.1605







Saldare a TIG con materiale di riporto nelle zone indicate con

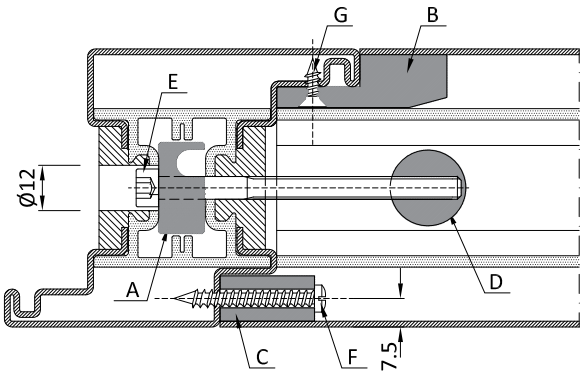
Sigillare tutte le superfici di contatto con silicone o SL0019

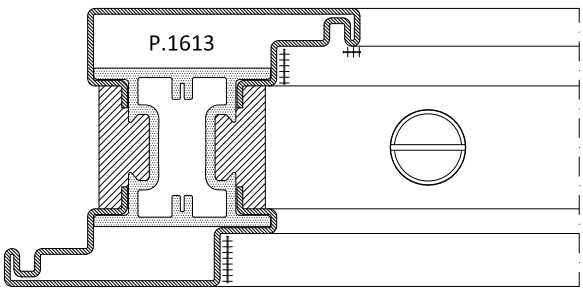
A) Inserto di fissaggio
B) Cavallotto di allineamento lato esterno
C) Cavallotto di allineamento lato interno
D) Tirante per cavallotto
E) Vite acciaio inox TCEI M6x80
F) Vite acciaio inox TC 4.8x38
G) Vite autofilettante TSTC 3.9x9.5

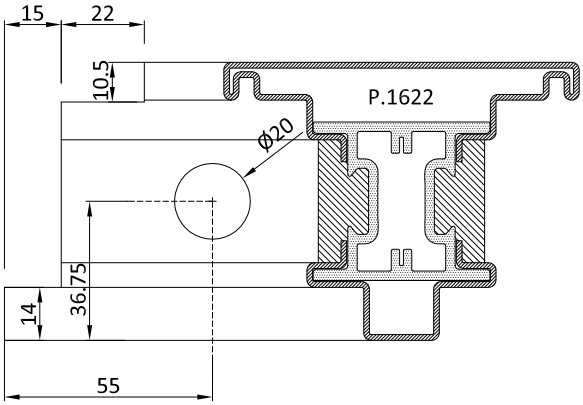
TIG welding with filler material in the areas indicated with

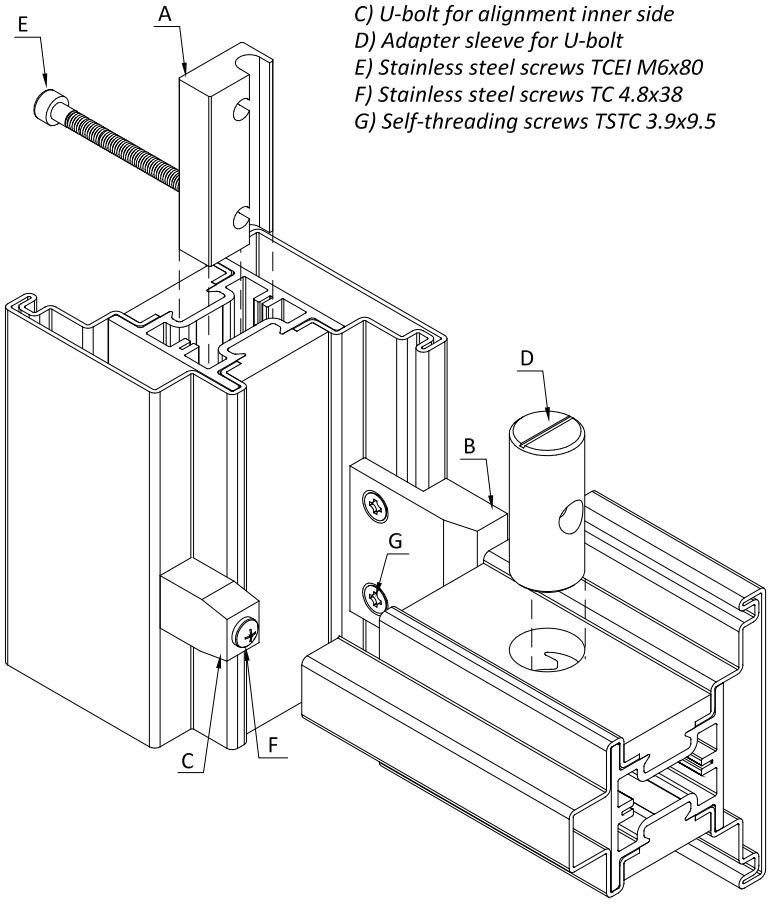
Seal all the external contact surfaces with silicone or SL0019

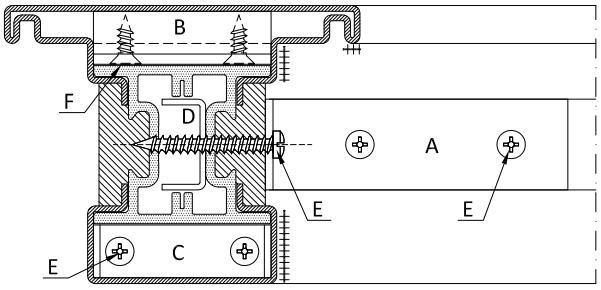
A) Anchoring insert
B) U-bolt for alignment outer side
C) U-bolt for alignment inner side
D) Adapter sleeve for U-bolt
E) Stainless steel screws TCEI M6x80
F) Stainless steel screws TC 4.8x38
G) Self-threading screws TSTC 3.9x9.5

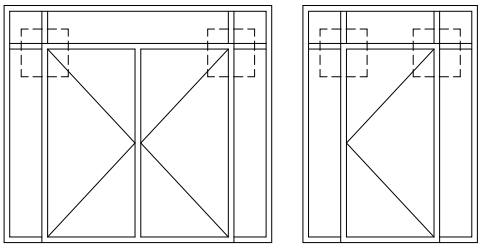


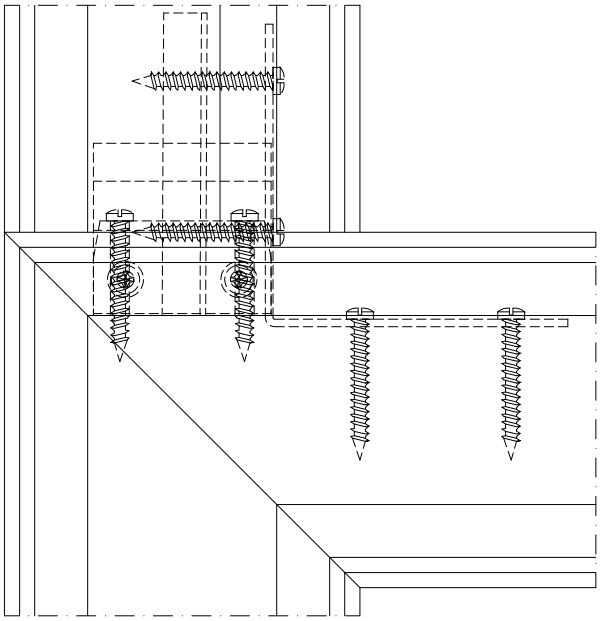


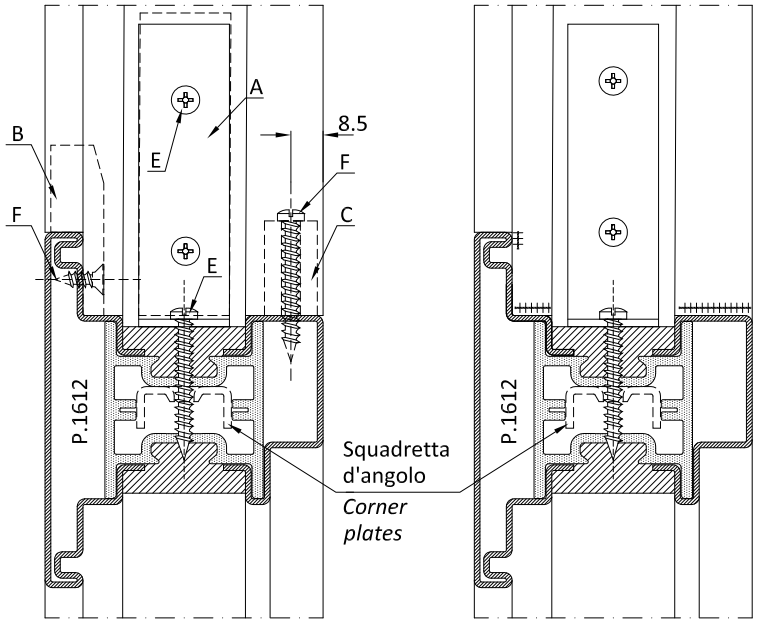


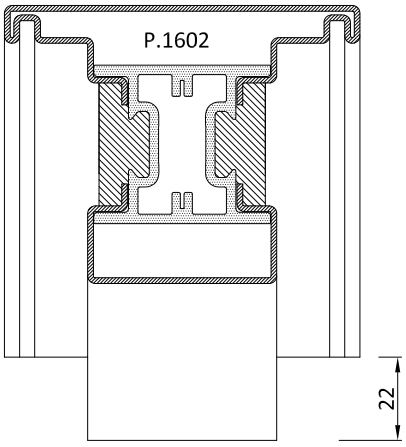


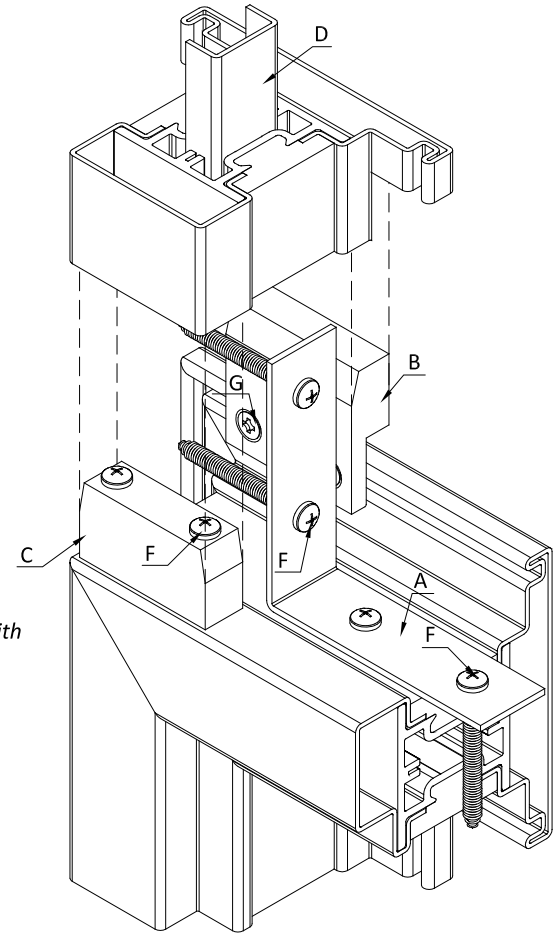












Saldare a TIG con materiale di riporto nelle zone indicate con

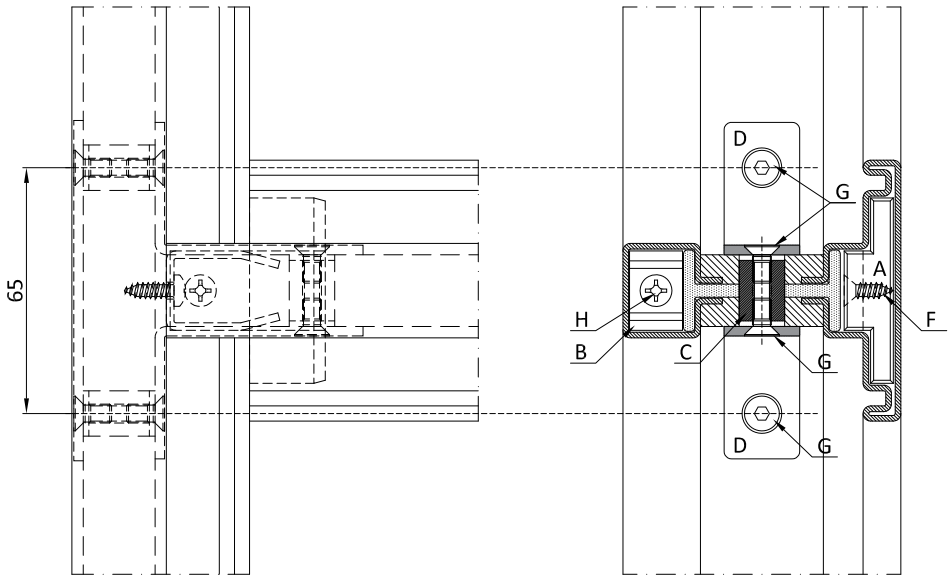
Sigillare tutte le superfici di contatto con silicone o SL0019

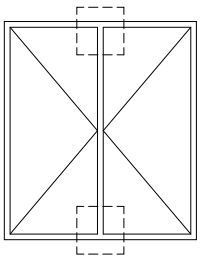
A) Squadretta giunzione 90°
B) Cavallotto di allineamento lato esterno
C) Cavallotto di allineamento lato interno
D) Rinforzo interno
E) Vite acciaio inox TC 4.8x38
F) Vite autofilettante TSTC 3.9x9.5

TIG welding with filler material in the areas indicated with

Seal all the external contact surfaces with silicone or SL0019

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





Saldare a TIG con materiale di riporto nelle zone indicate con

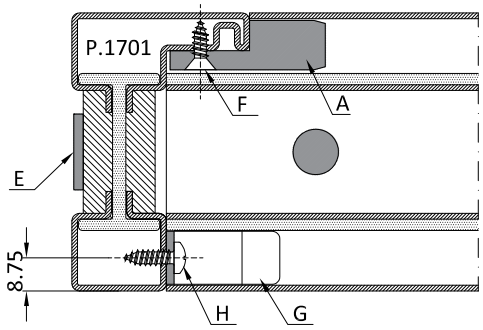
Sigillare tutte le superfici di contatto con silicone o SL0019

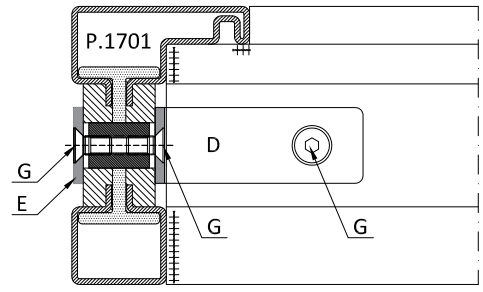
A) Cavallotto di allineamento lato interno
B) Cavallotto di allineamento lato esterno
C) Bussola filettata
D) Squadretta di tiraggio
E) Piastrina di fissaggio
F) Vite acciaio inox TPS 4.2x13
G) Vite acciaio inox TSPEI M5x10
H) Vite autofilettante TC 4.2x13

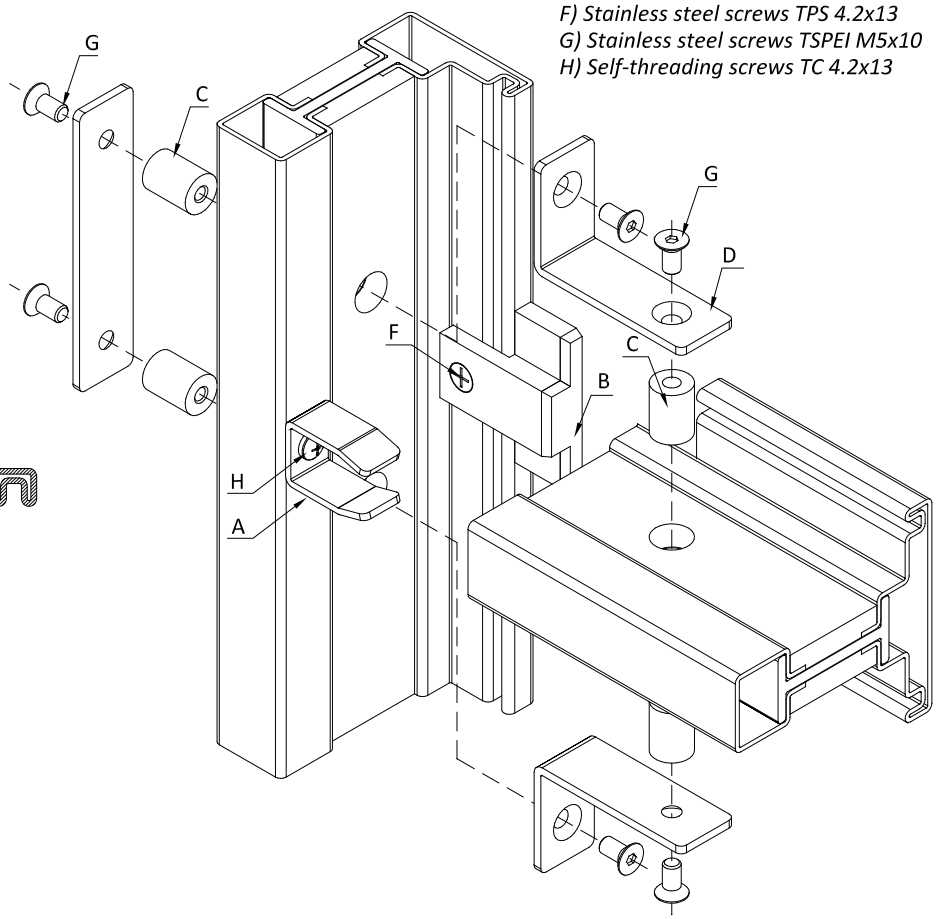
TIG welding with filler material in the areas indicated with

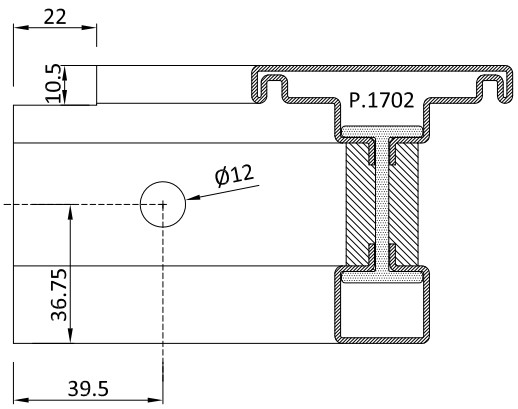
Seal all the external contact surfaces with silicone or SL0019

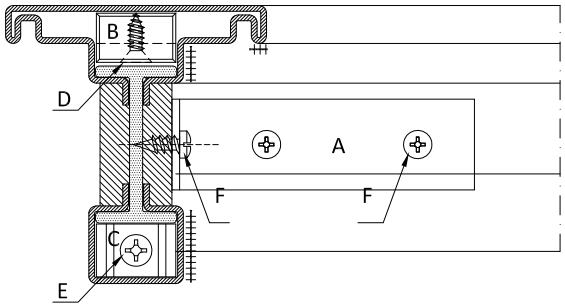
A) U-bolt for alignment inner side
B) U-bolt for alignment outer side
C) Threaded bush
D) Corner bracket
E) Fixing plate
F) Stainless steel screws TPS 4.2x13
G) Stainless steel screws TSPEI M5x10
H) Self-threading screws TC 4.2x13

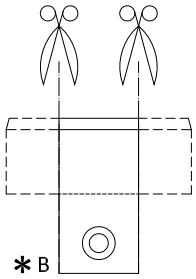


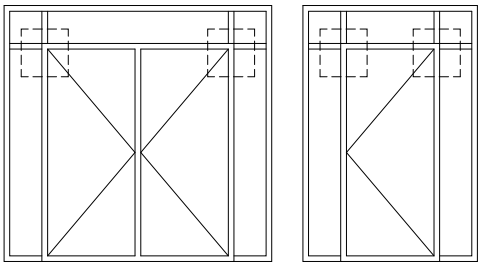


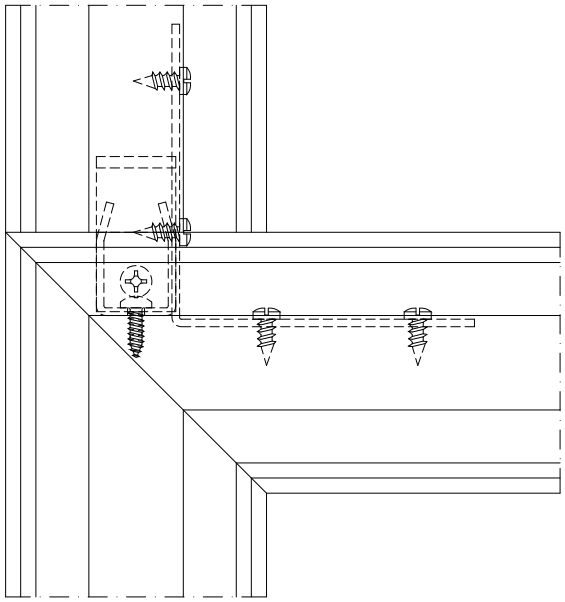


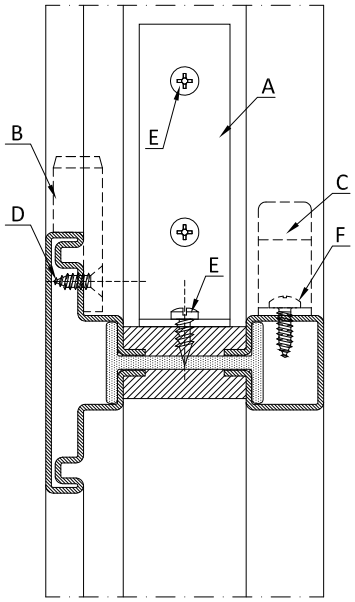


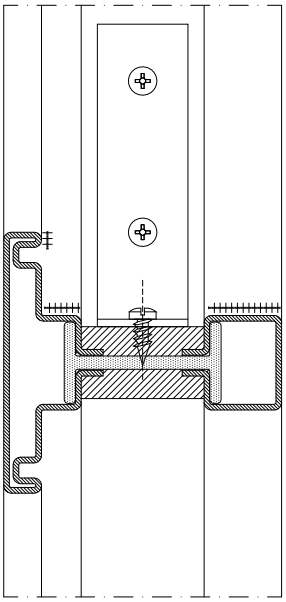


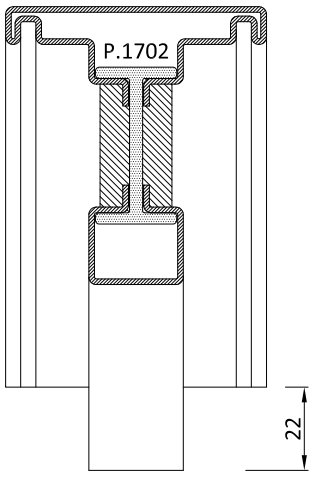


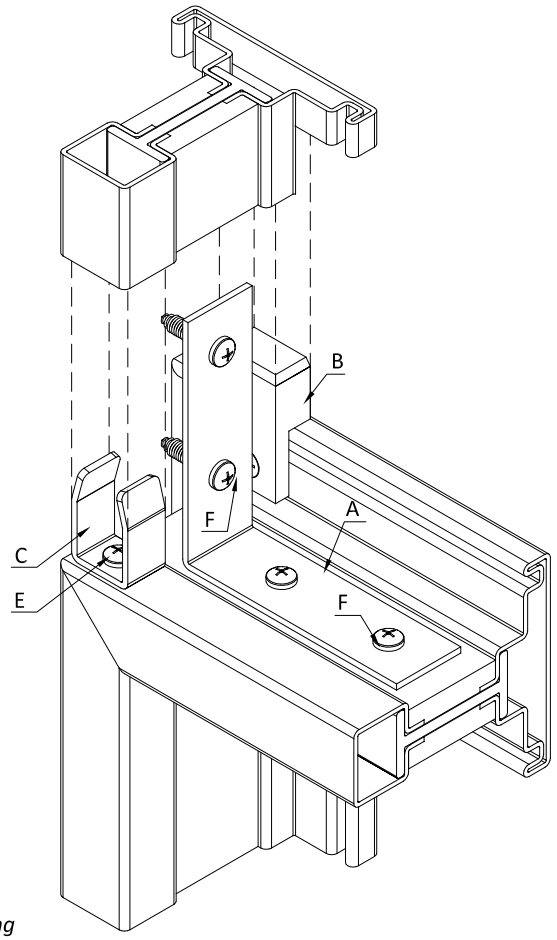












Saldare a TIG con materiale di riporto nelle zone indicate con ++++++

Sigillare tutte le superfici di contatto con silicone o SL0019

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

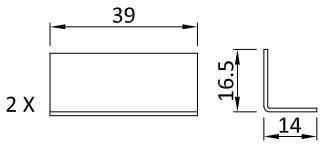
* Tagliare le alette del cavallotto B come da disegno

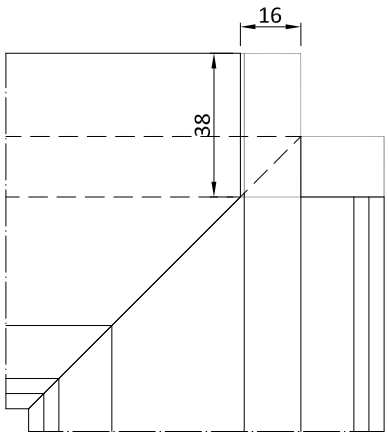
TIG welding with filler material in the areas indicated with

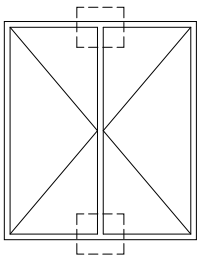
Seal all the external contact surfaces with silicone or SL0019

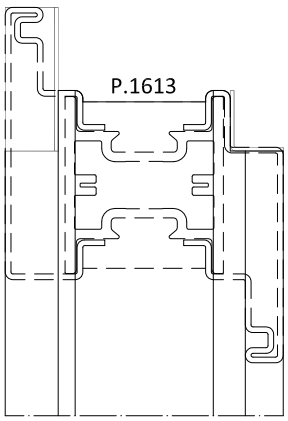
A) Corner bracket 90°
B) U-bolt for alignment outer side
C) U-bolt for alignment inner side
D) Stainless steel screws TPS 4.2x13
E) Self-threading screws TC 4.2x12.7
F) Self-threading screws TE 4.8x20

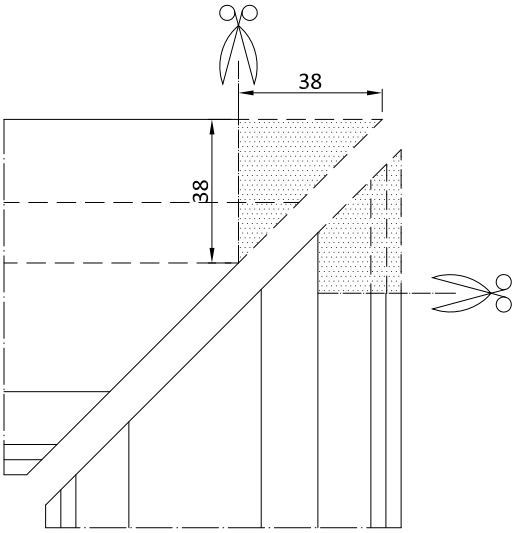
* *Angles of U-connection piece B have to be cut according the drawing*

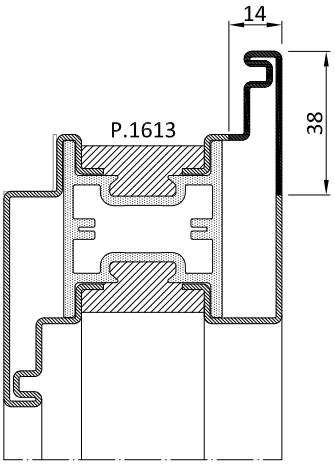

39
2 X
16.5
14

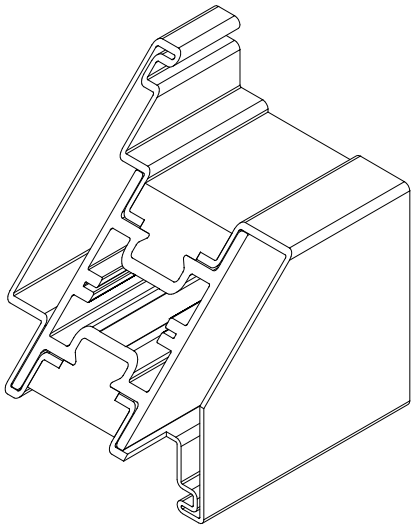

16
38

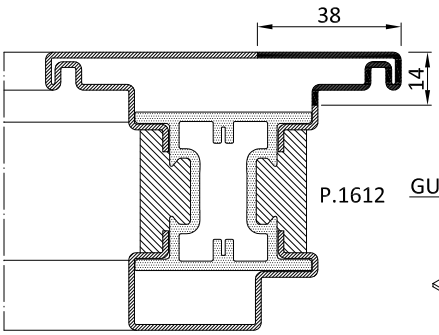


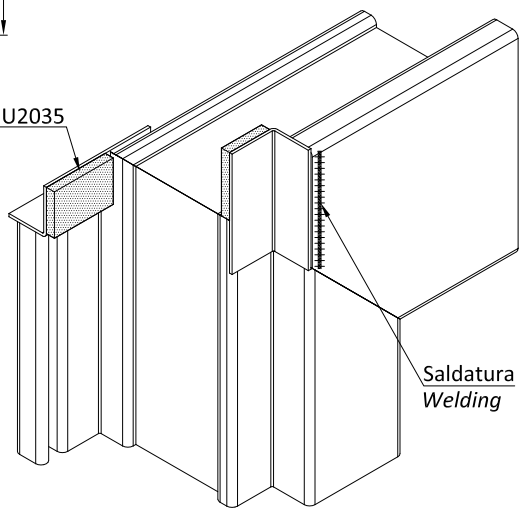

P.1613

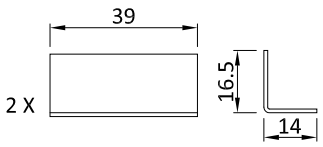

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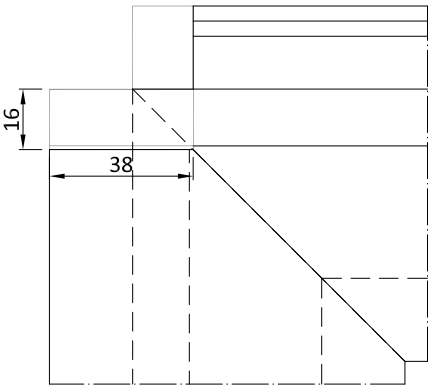

14
P.1613
38

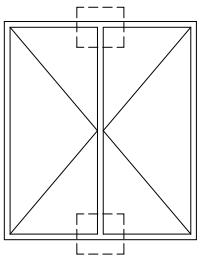


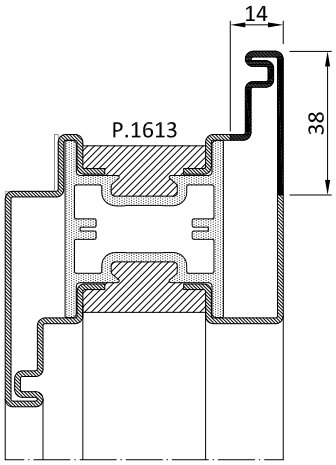

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14
P.1612

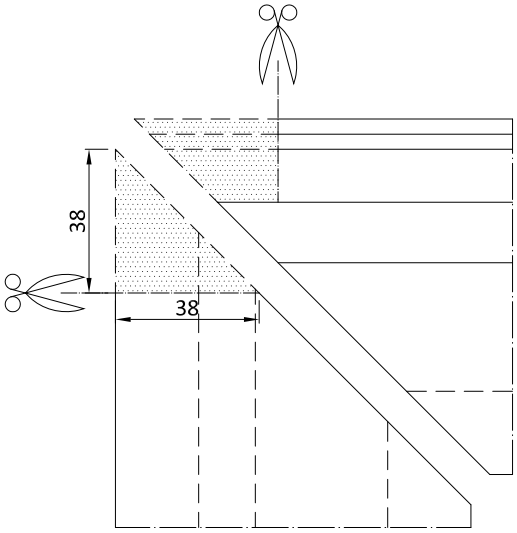

GU2035
Saldatura
Welding

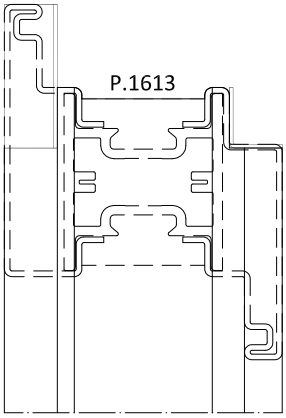

39
2 X
16.5
14

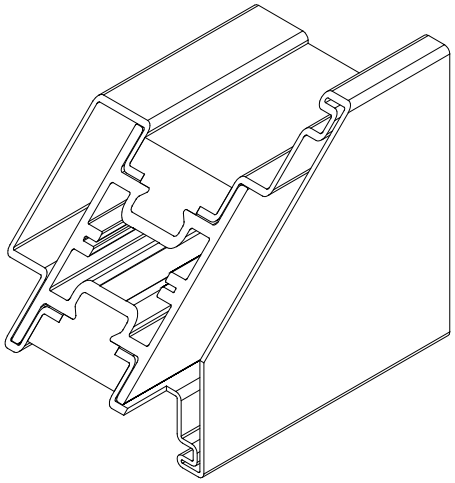

16
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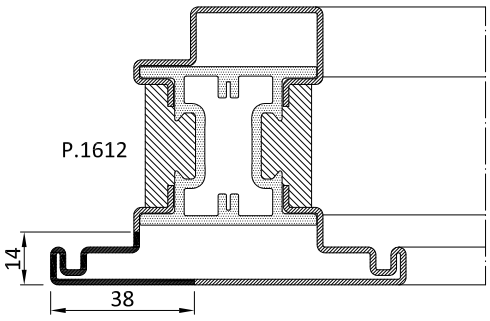


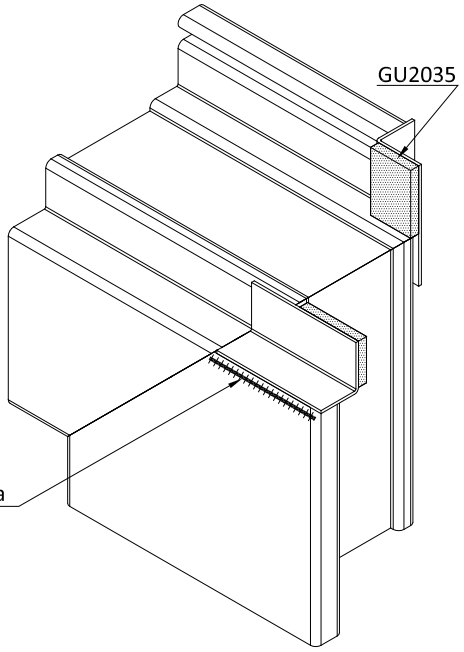

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P.1613
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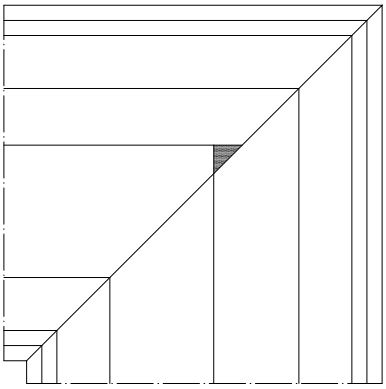

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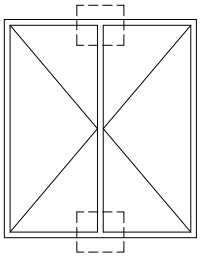

P.1613

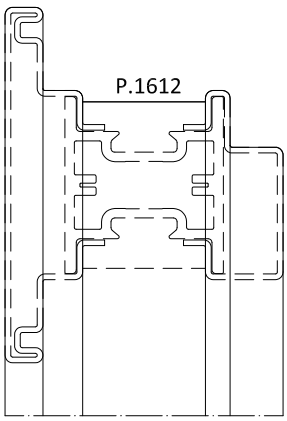


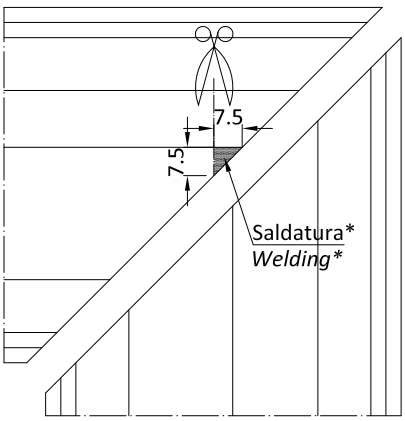

P.1612
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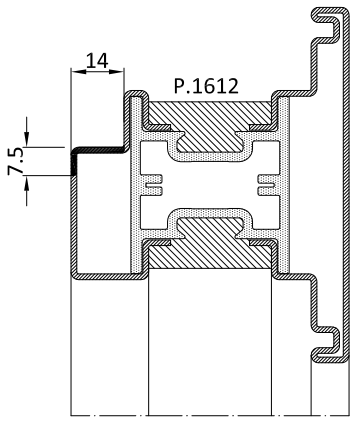

GU2035
Saldatura
Welding

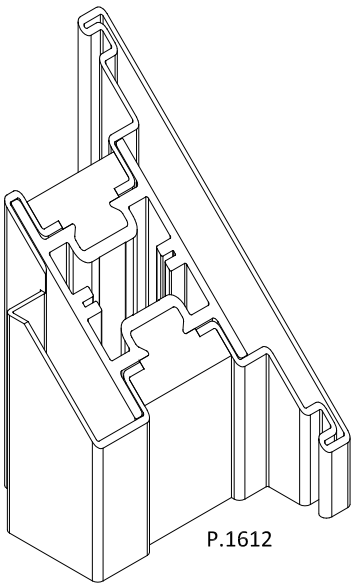


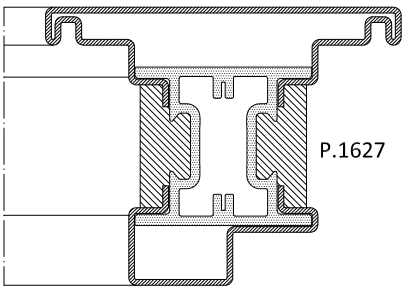


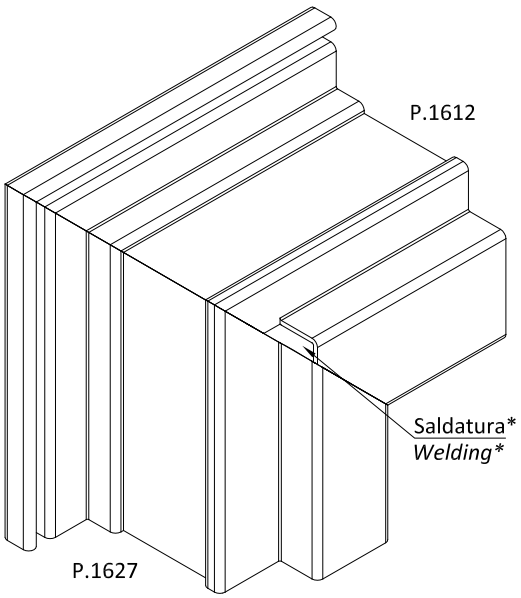




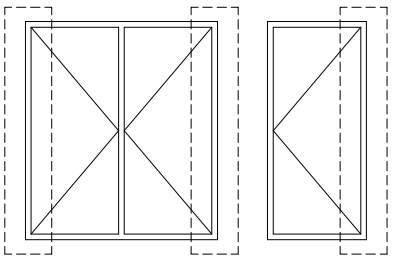


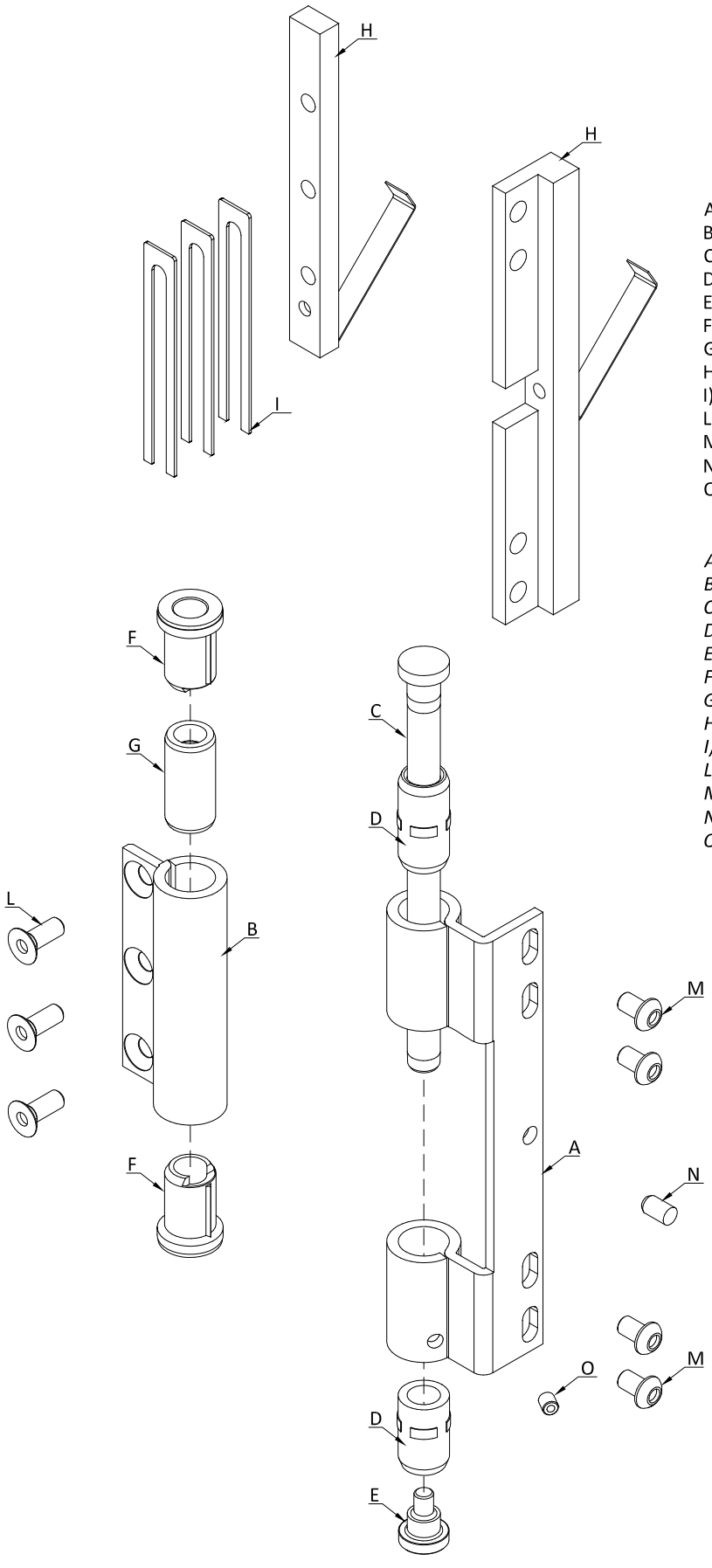






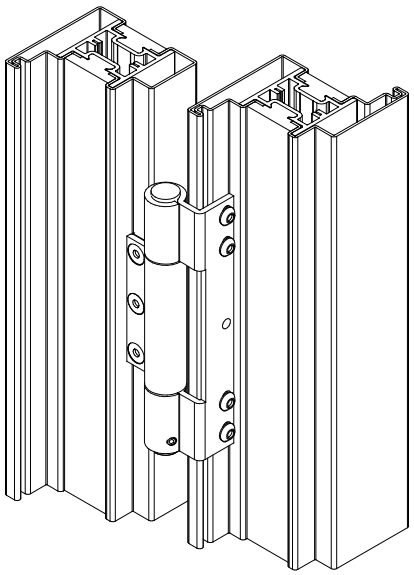
* Saldare con materiale di riporto
** Welding with filler material*

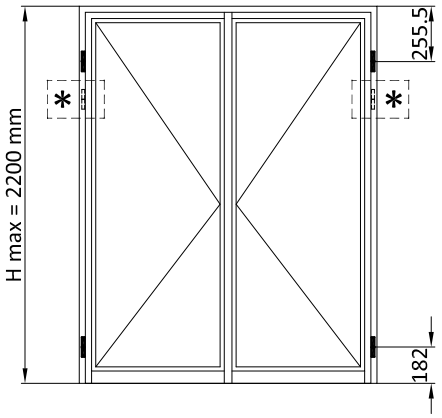


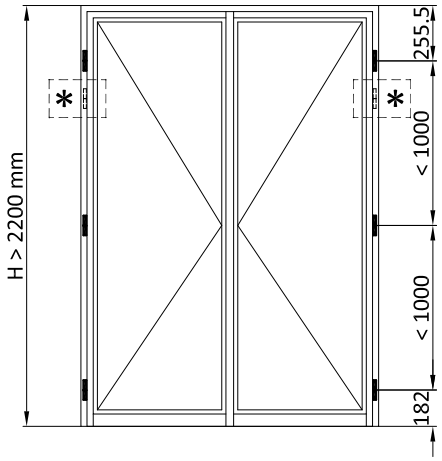


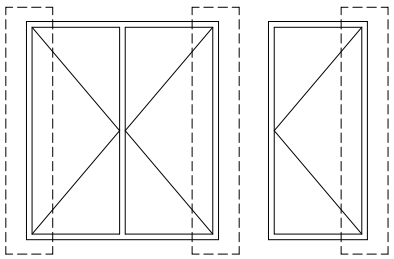
A) Corpo cerniera A
B) Corpo cerniera B
C) Perno
D) Distanziatore
E) Tappo a vite
F) Boccola antifrizione
G) Distanziatore
H) Rinforzi interni
I) Distanziale di regolazione
L) Viti acciaio inox TSPEI M6 x 16
M) Vite acciaio inox testa a bottone M6 x 10
N) Spina inox Ø 6 x 10 da inserire dopo la regolazione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

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



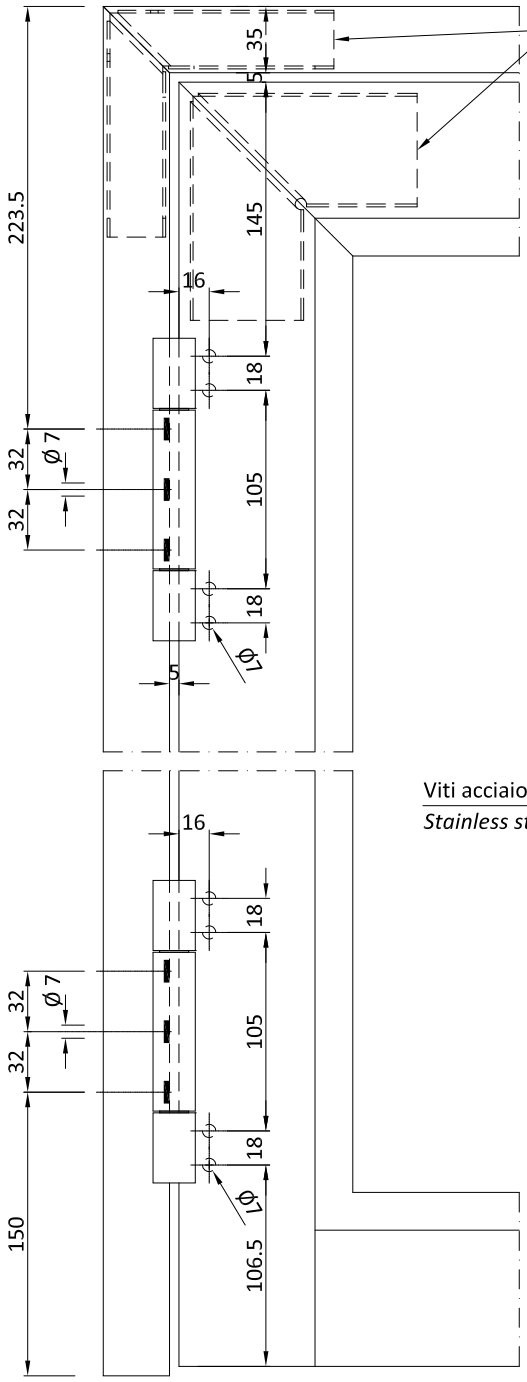






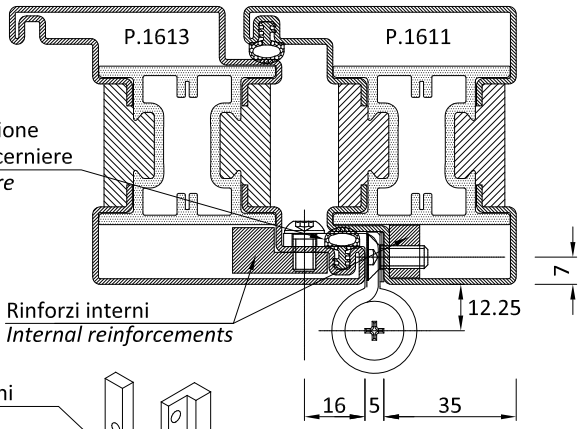
Peso max. per anta 150 kg
Max. weight for leaf: 150 kg

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

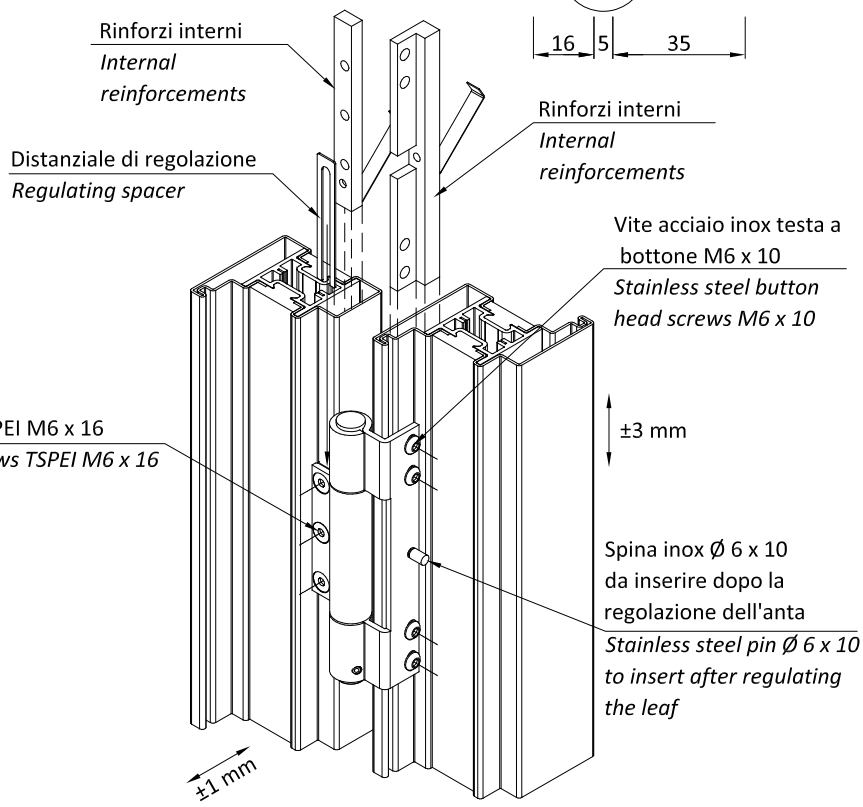


Squadrette angolo
Corner plates

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

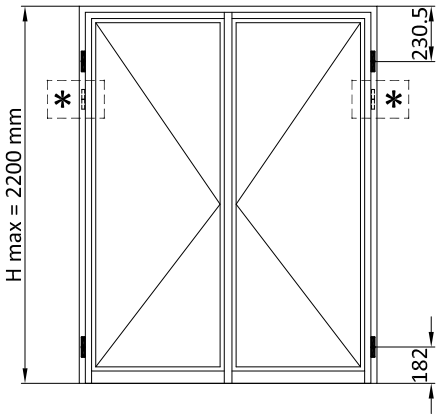


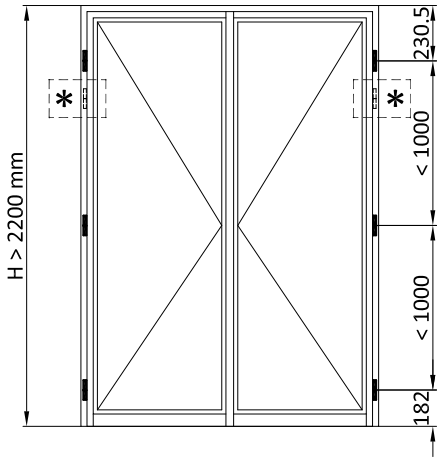
Rinforzi interni
Internal reinforcements

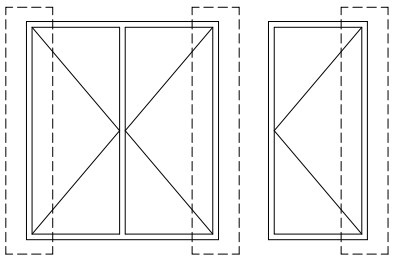


- La lavorazione può essere effettuata anche in posizioni intermedie dell'altezza della porta.
- La lavorazione SX è speculare alla DX.
- La lavorazione è valida anche per le aperture esterne.

- *Tooling can also be carried out in intermediate positions.*
- *Tooling is the same on the right and on the left.*
- *Tooling can be done also on external openings.*

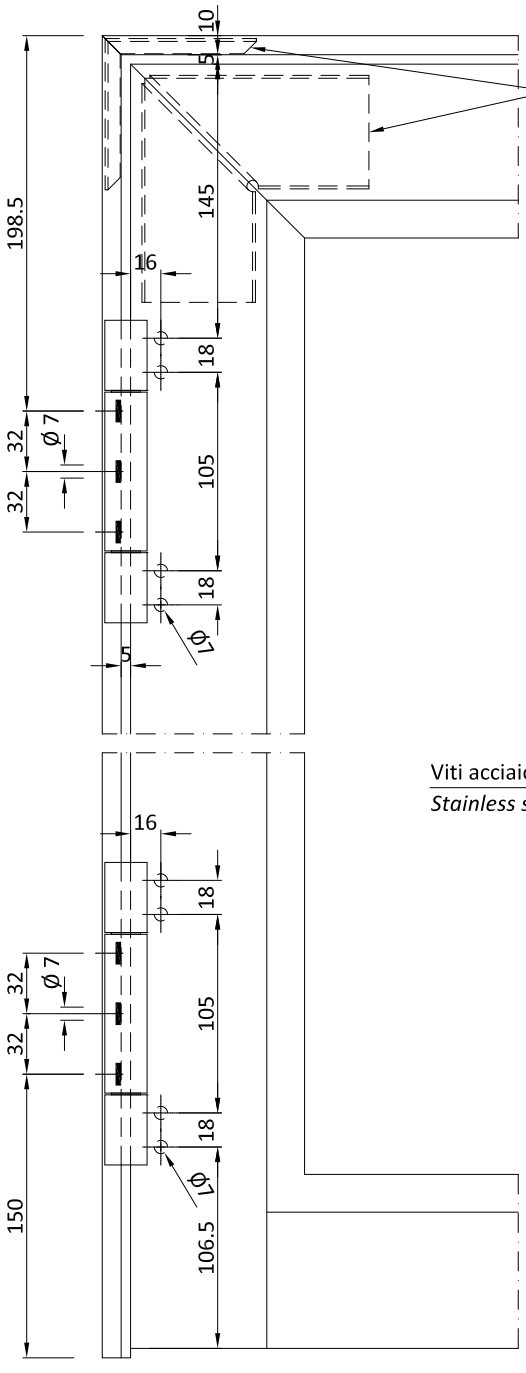






Peso max. per anta 150 kg
Max. weight for leaf: 150 kg

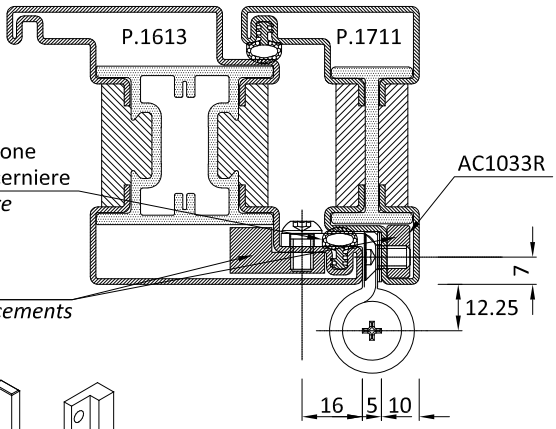
* Cerniera aggiuntiva per peso anta > di 150 kg - peso max 200 kg
Additional hinge for weight of leaf > di 150 kg - max 200 kg

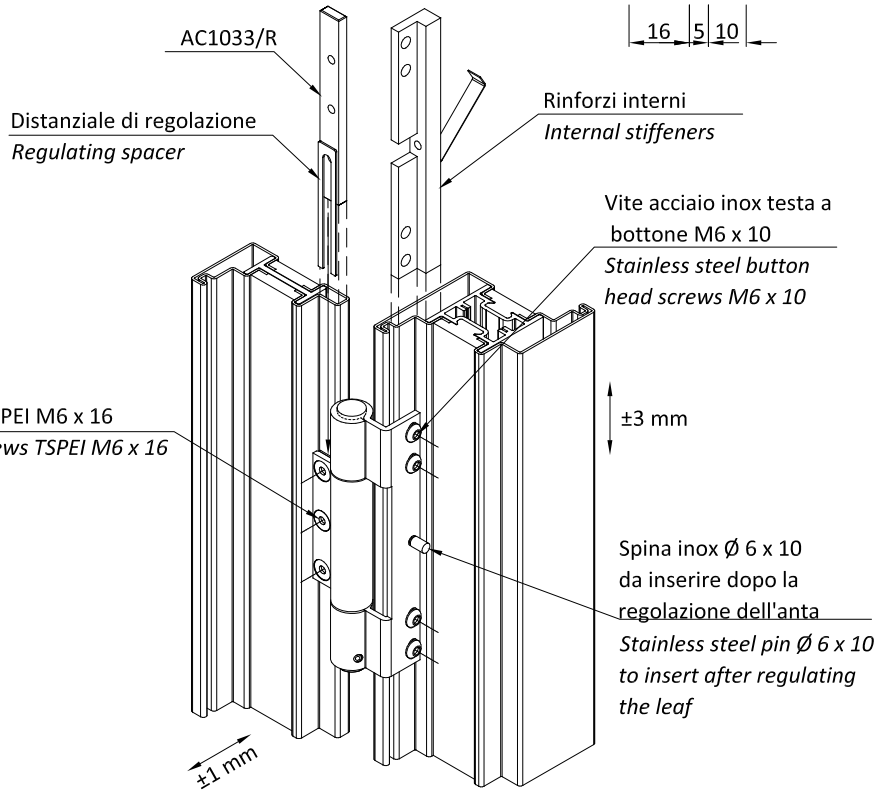


Squadrette angolo
Corner plates

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

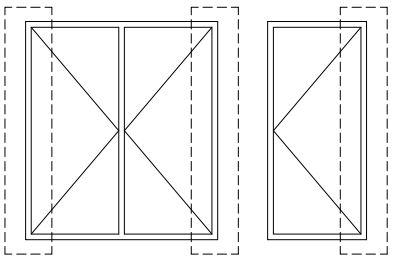
Rinforzi interni
Internal reinforcements

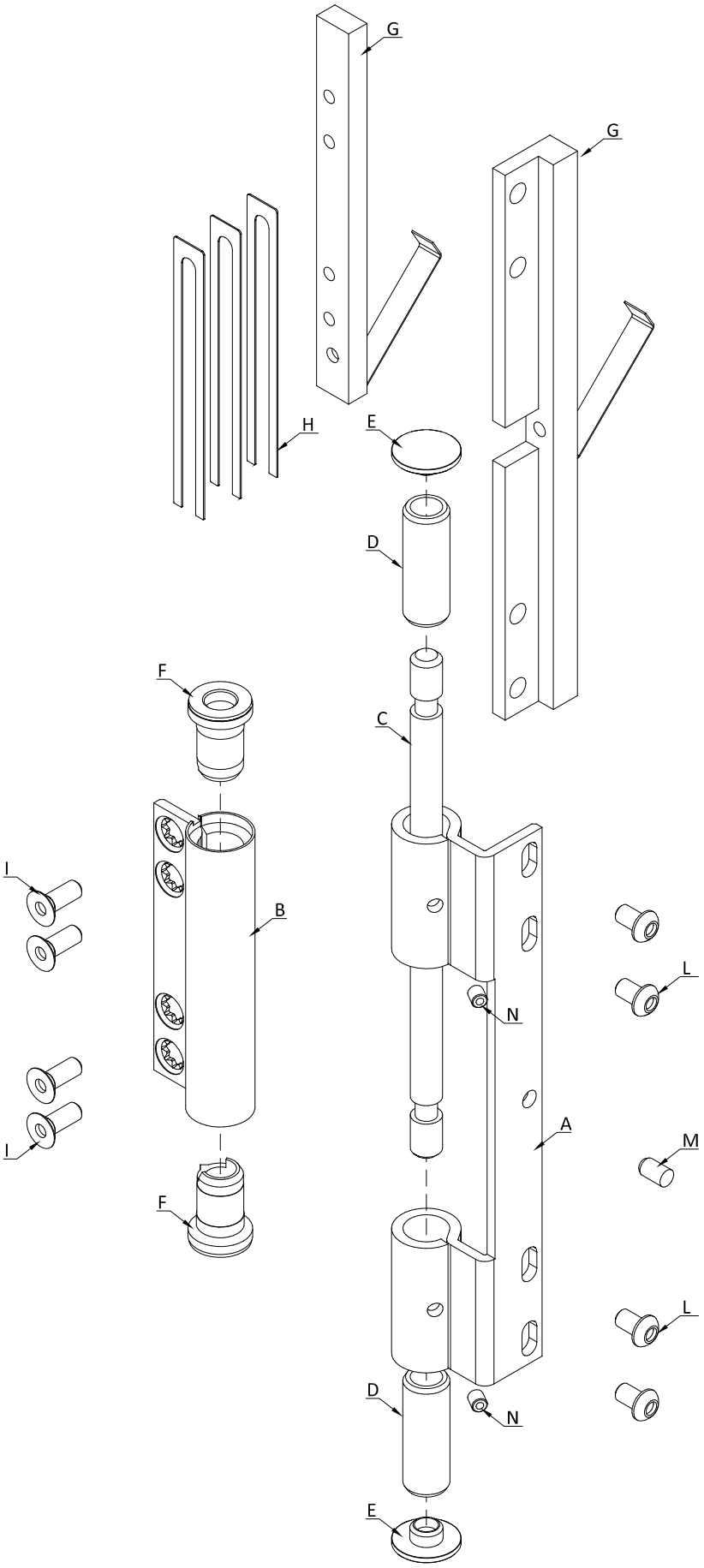




- La lavorazione può essere effettuata anche in posizioni intermedie dell'altezza della porta.
- La lavorazione SX è speculare alla DX.
- La lavorazione è valida anche per le aperture esterne.

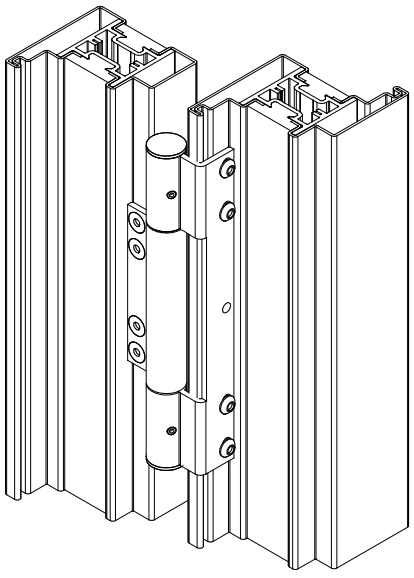
- *Tooling can also be carried out in intermediate positions.*
- *Tooling is the same on the right and on the left.*
- *Tooling can be done also on external openings.*

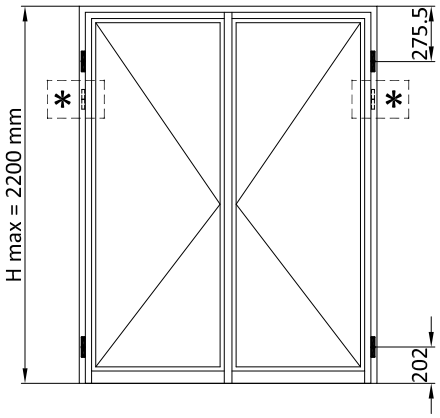


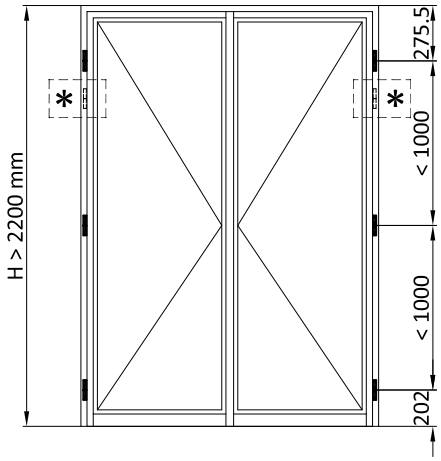


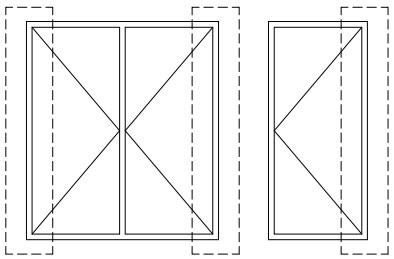
A) Corpo cerniera A
B) Corpo cerniera B
C) Perno
D) Distanziatore
E) Tappo di finitura
F) Boccola antifrizione
G) Rinforzi interni
H) Distanziale di regolazione
I) Viti acciaio inox TSPEI M6 x 16
L) Vite acciaio inox testa a bottone M6 x 10
M) Spina inox Ø 6 x 10 da inserire dopo la regolazione dell'anta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

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



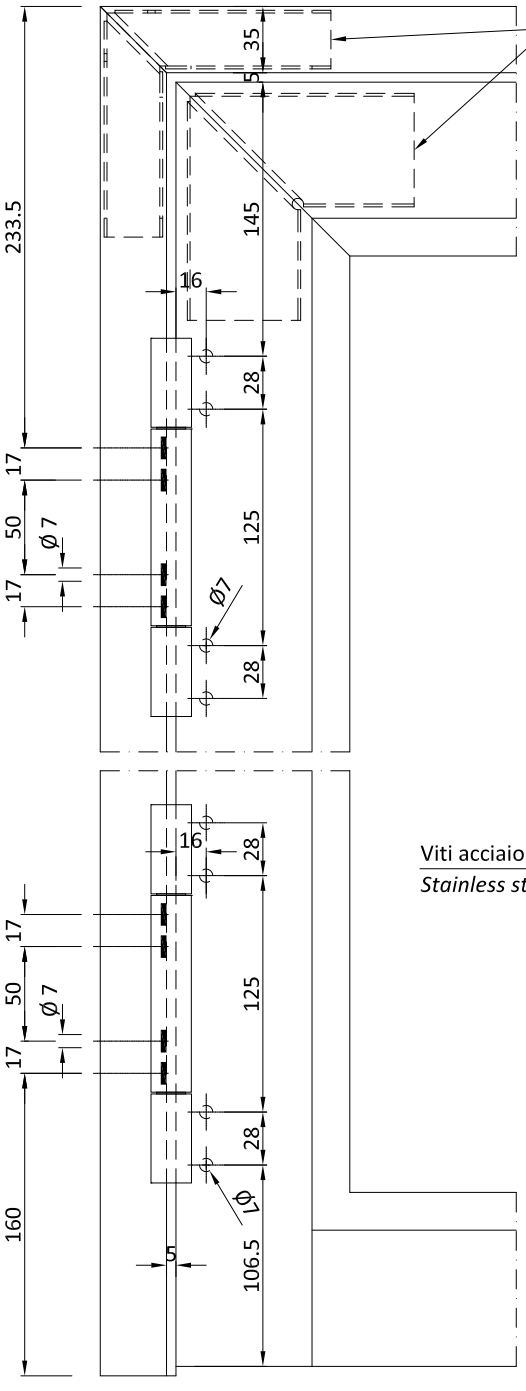






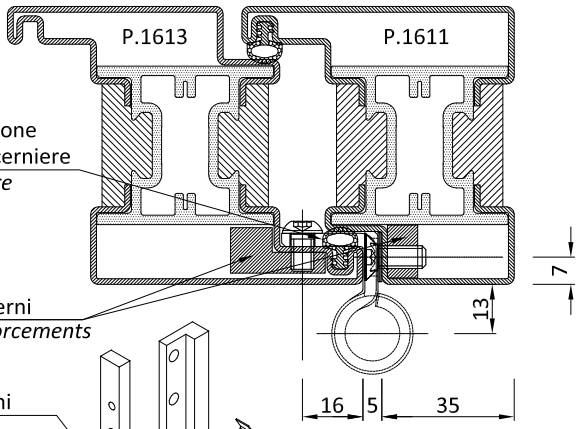
Peso max. per anta 250 kg
Max. weight for leaf: 250 kg

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



Squadrette angolo
Corner plates

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



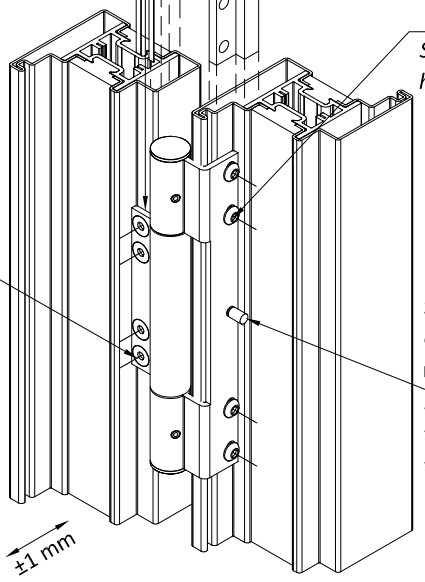
Rinforzi interni
Internal reinforcements

Rinforzi interni
Internal reinforcements

Distanziale di regolazione
Regulating spacer

Rinforzi interni
Internal reinforcements

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

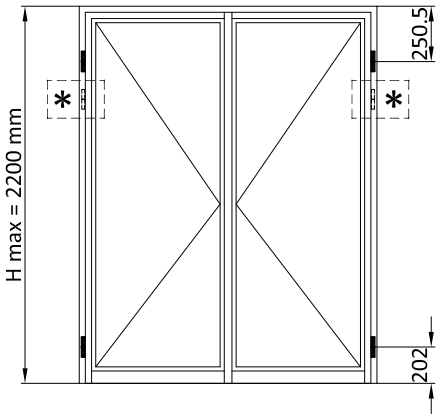


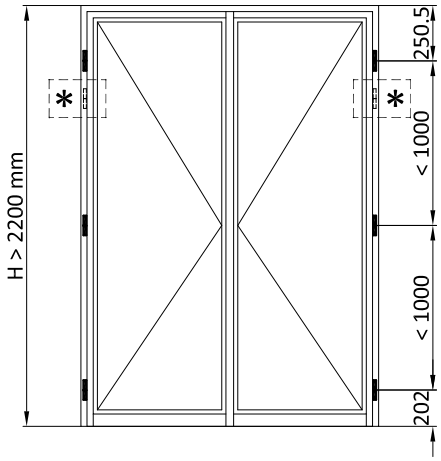
Viti acciaio inox TSPEI M6 x 16
Stainless steel screws TSPEI M6 x 16

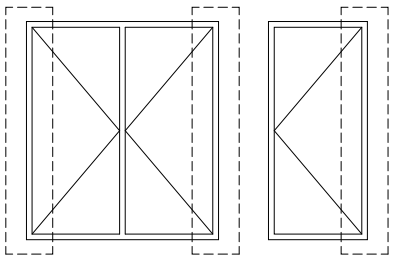
Spina inox Ø 6 x 10 da inserire dopo la regolazione dell'anta
Stainless steel pin Ø 6 x 10 to insert after regulating the leaf

- La lavorazione può essere effettuata anche in posizioni intermedie dell'altezza della porta.
- La lavorazione SX è speculare alla DX.
- La lavorazione è valida anche per le aperture esterne.

- *Tooling can also be carried out in intermediate positions.*
- *Tooling is the same on the right and on the left.*
- *Tooling can be done also on external openings.*

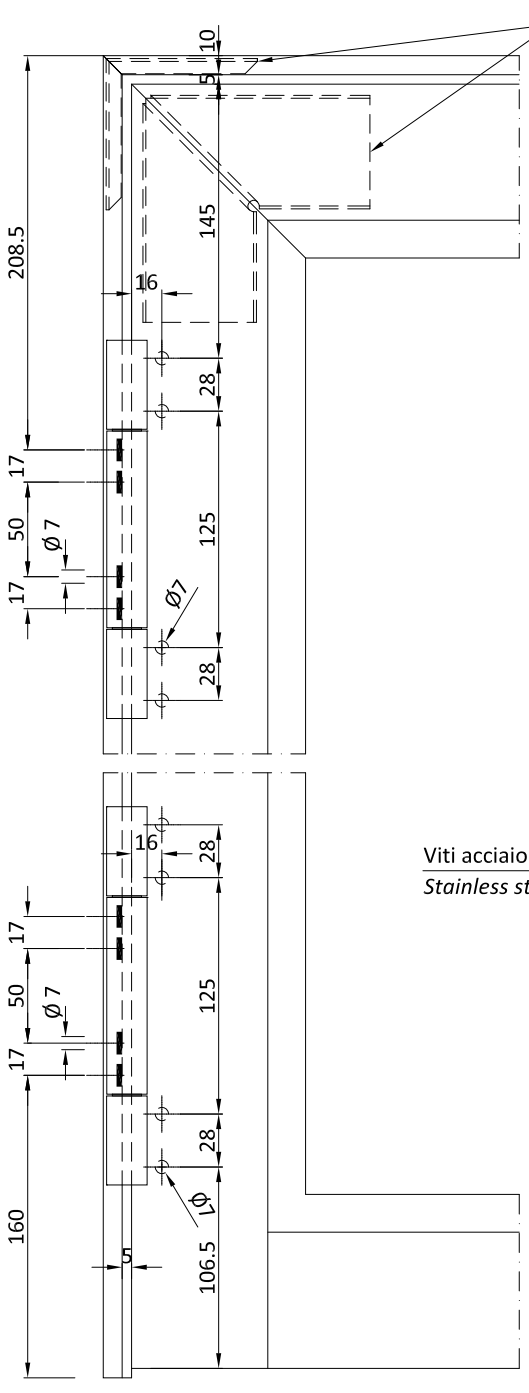


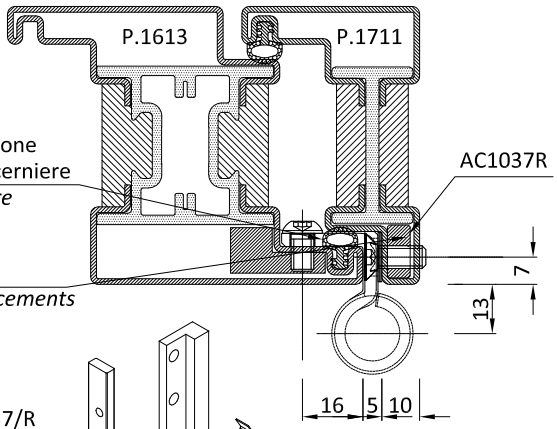


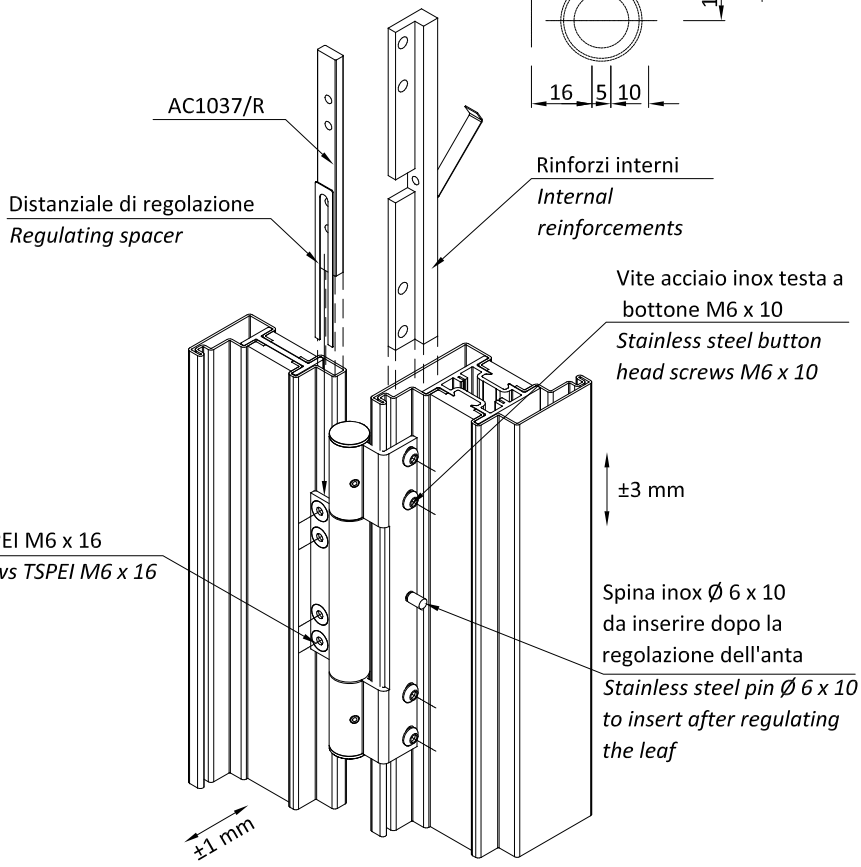


Peso max. per anta 250 kg
Max. weight for leaf: 250 kg

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

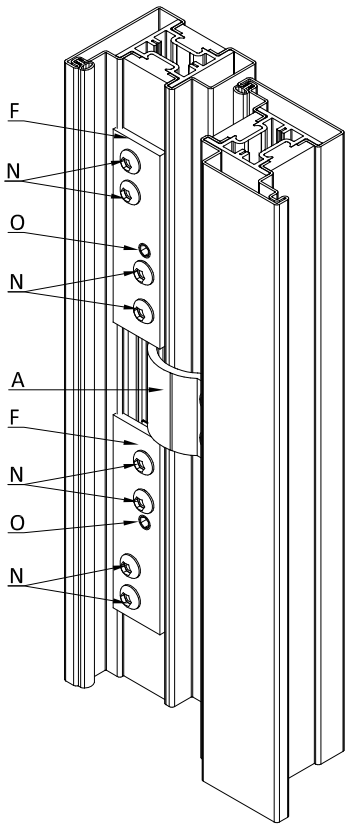


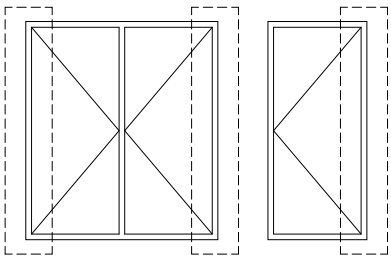




- La lavorazione può essere effettuata anche in posizioni intermedie dell'altezza della porta.
- La lavorazione SX è speculare alla DX.
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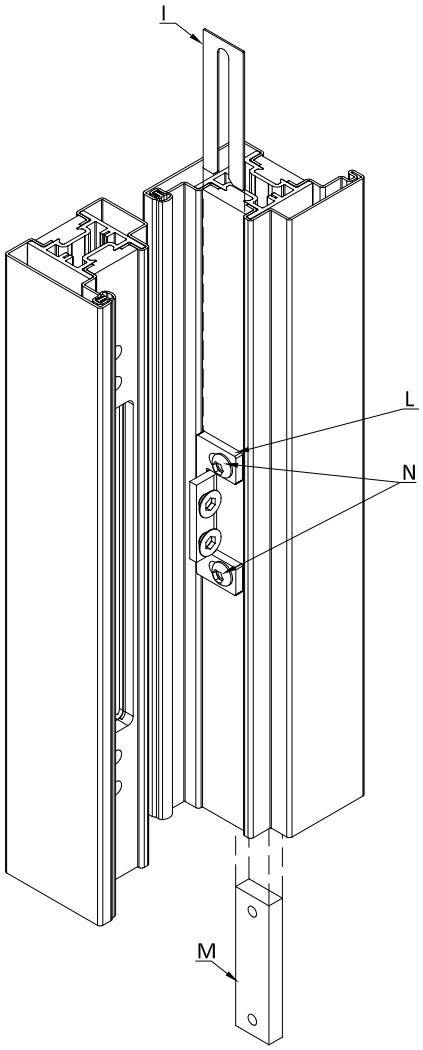
- *Tooling can also be carried out in intermediate positions.*
- *Tooling is the same on the right and on the left.*
- *Tooling can be done also on external openings.*

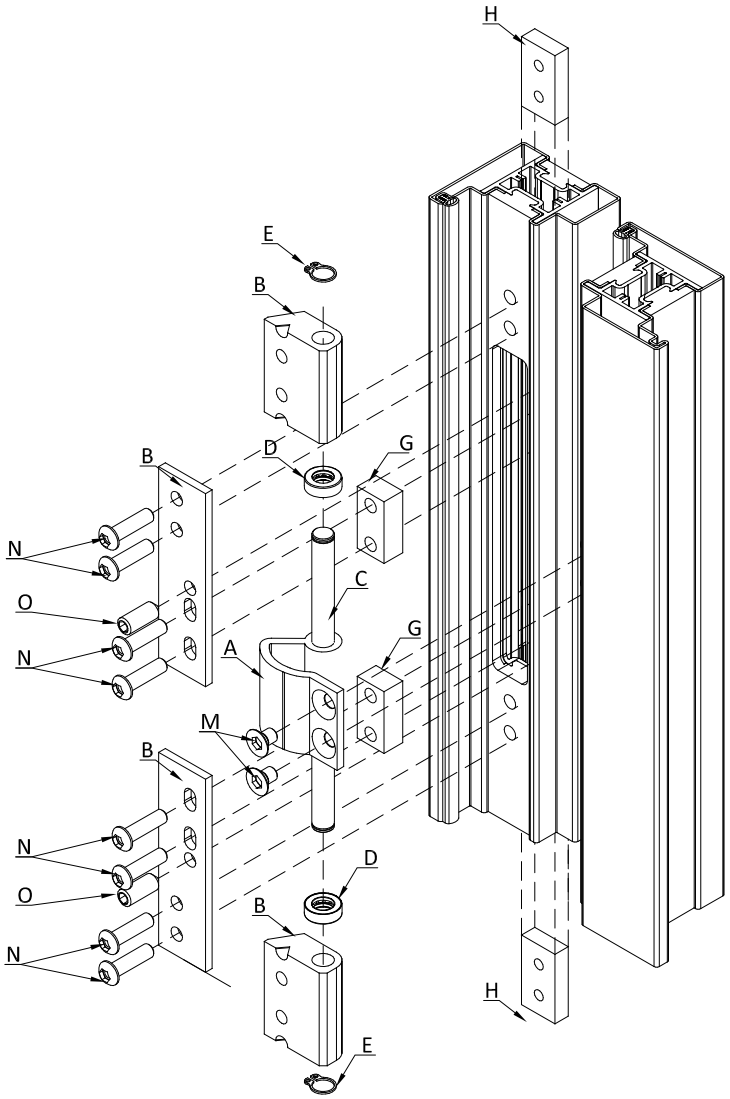


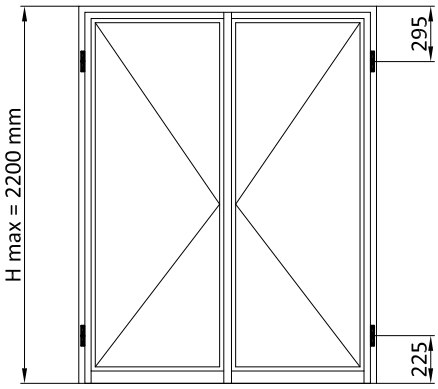


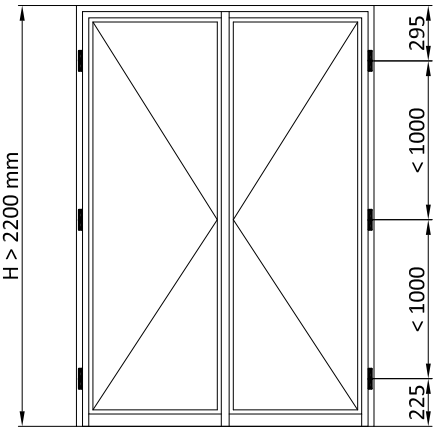
A) Corpo cerniera A
B) Corpo cerniera B
C) Perno
D) Cuscinetto
E) Seger
F) Piastra
G) Contro-piastra A
H) Contro-piastra B
I) Spessore
L) Staffa di fissaggio
M) Contropiastra C
N) n°2 x Vite TPEI M8 x 16 mm
O) n°2 x Vite TPEI M8 x 35mm
P) Grano M10 x 25 mm punta conica

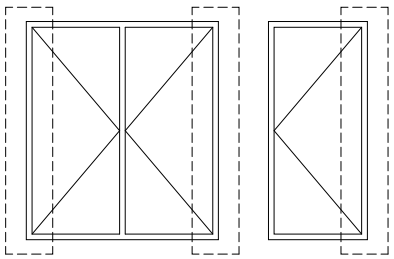
A) Body hinge A
B) Body hinge B
C) Pin
D) Bearing
E) Seger
F) Plate
G) Retainer plate A
H) Retainer plate B
I) Shim
L) Anchoring bracket
M) Counter-plate C
N) n° 2 x Screws TPEI M8x16 mm
O) n°2 x Screws TPEI M8x3 5mm
P) Dowel M10 x 25 mm, cone point





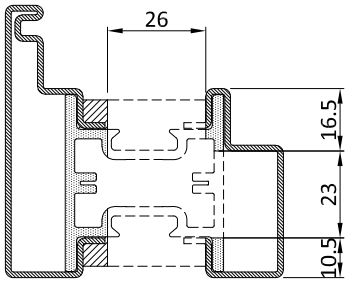






Peso max. per anta 180 kg
Massima apertura 96°

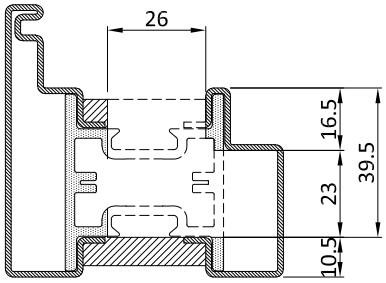
Max. weight for leaf: 180 kg
Maximum opening 96°



TELAIO
sez. A-A'

FRAME
sect. A-A'

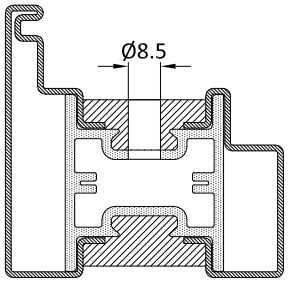
P.1611



TELAIO
sez. B-B'

FRAME
sect. B-B'

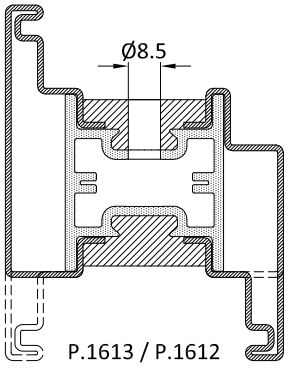
P.1611



TELAIO
sez. C-C'

FRAME
sect. C-C'

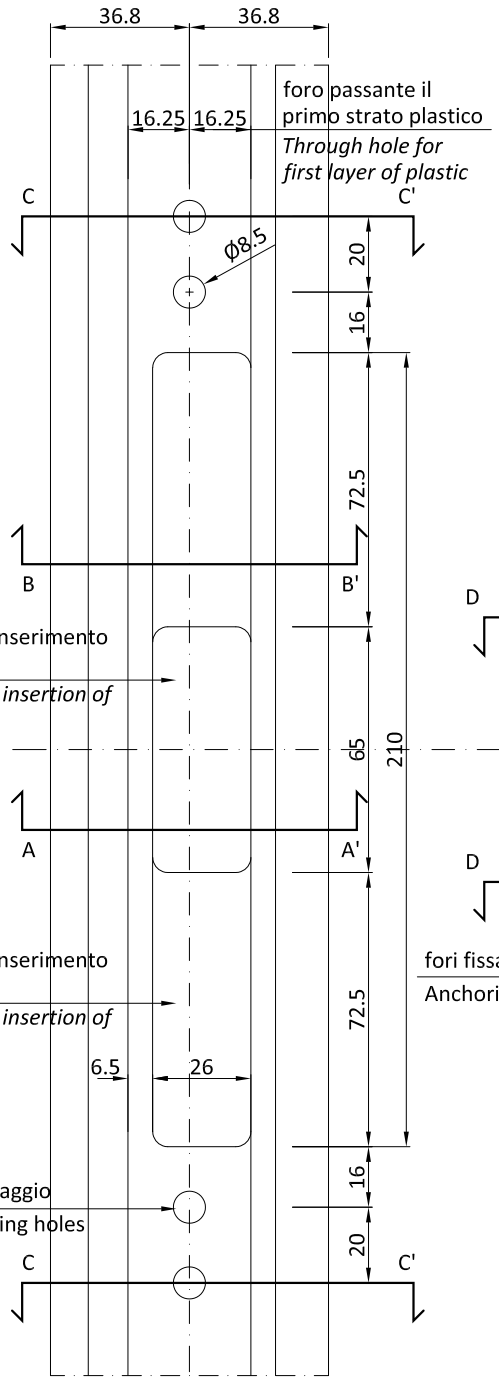
P.1611

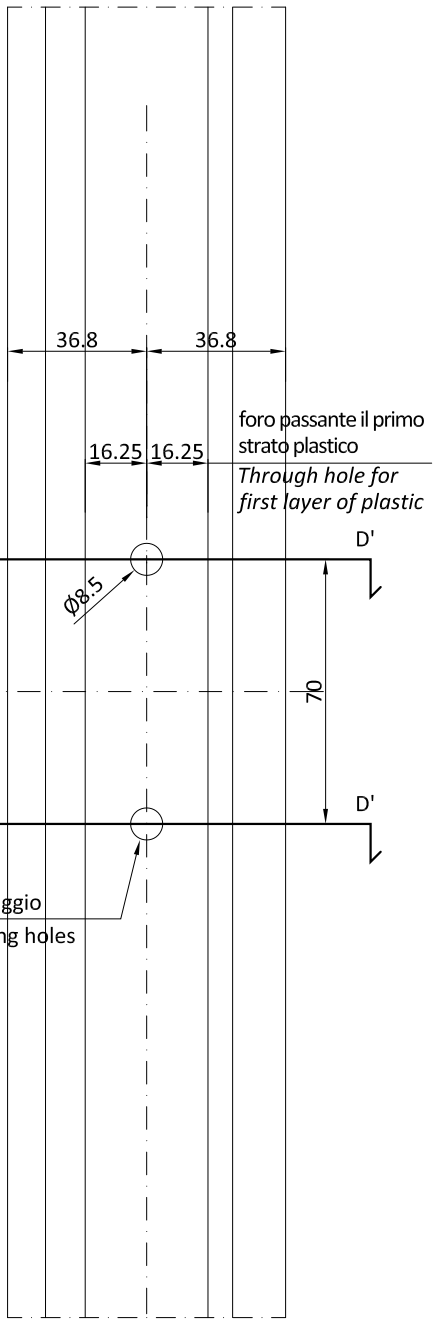


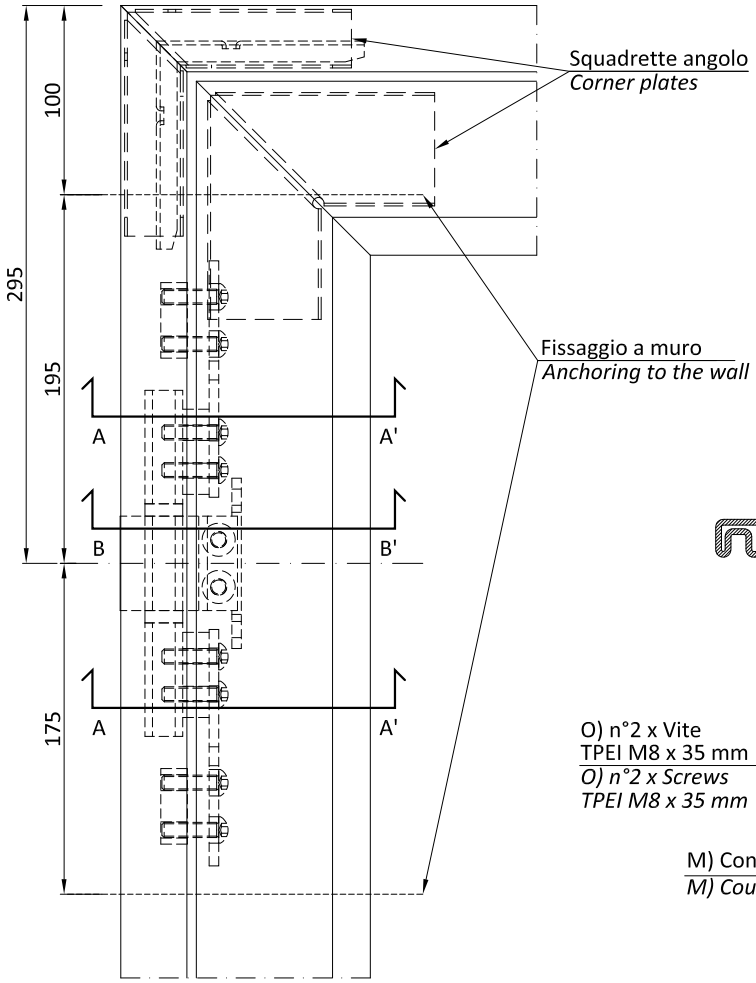
ANTA
sez. D-D'

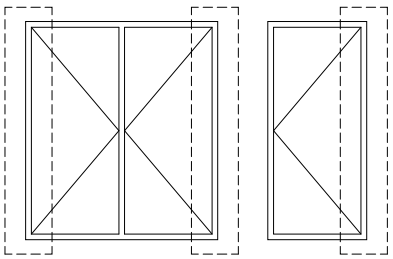
LEAF
sect. D-D'

P.1613 / P.1612



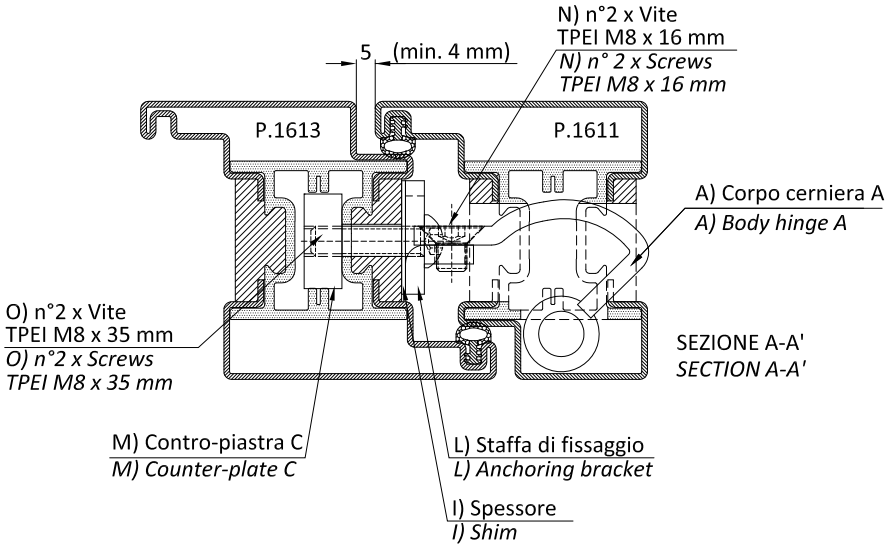


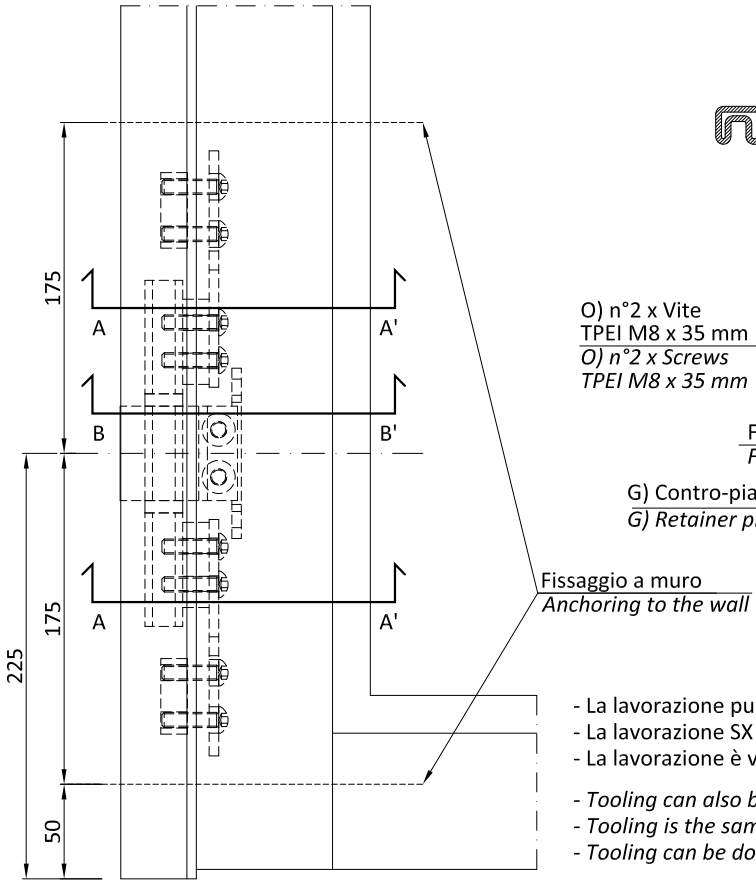


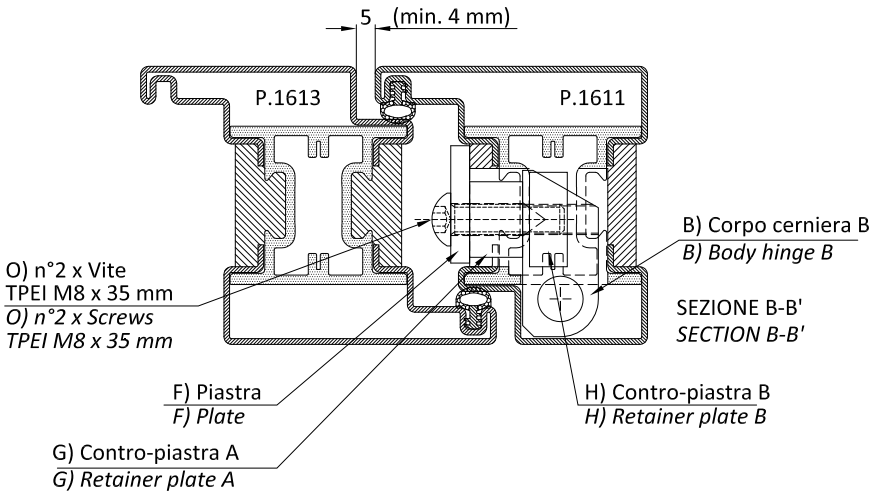


Peso max. per anta 180 kg
Massima apertura 96°

Max. weight for leaf: 180 kg
Maximum opening 96°

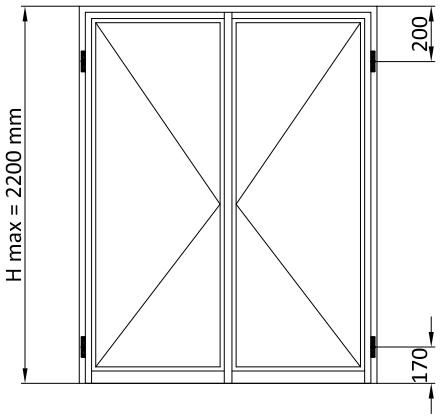


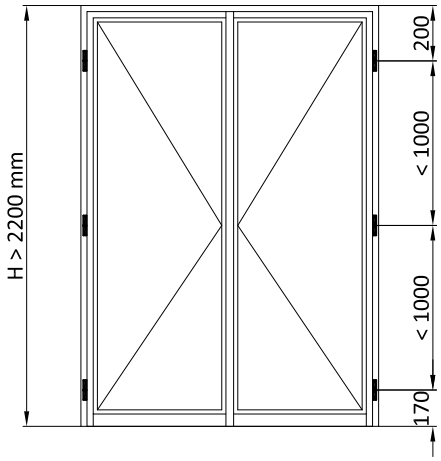


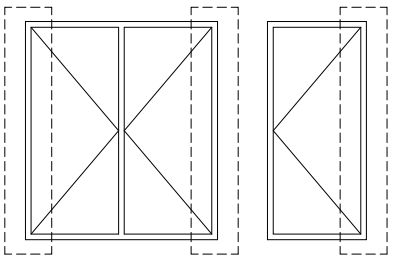


- La lavorazione può essere effettuata anche in posizioni intermedie dell'altezza della porta.
- La lavorazione SX è speculare alla DX.
- La lavorazione è valida anche per le aperture esterne.

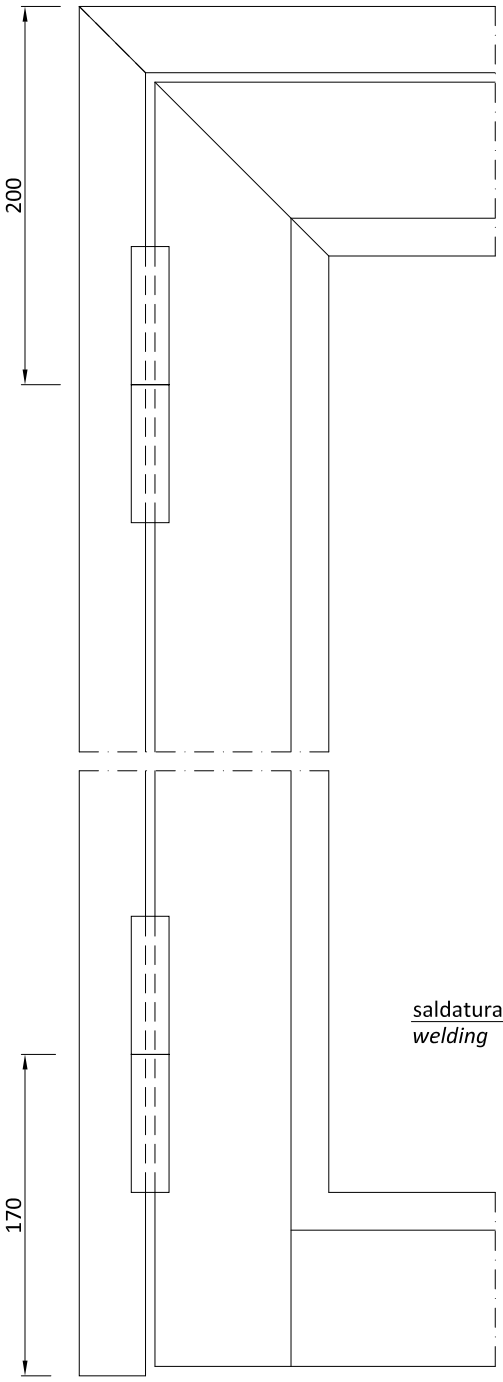
- *Tooling can also be carried out in intermediate positions.*
- *Tooling is the same on the right and on the left.*
- *Tooling can be done also on external openings.*





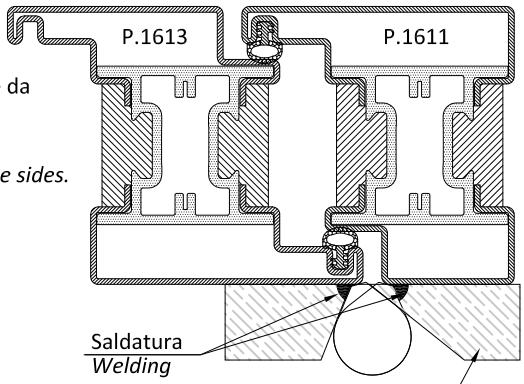


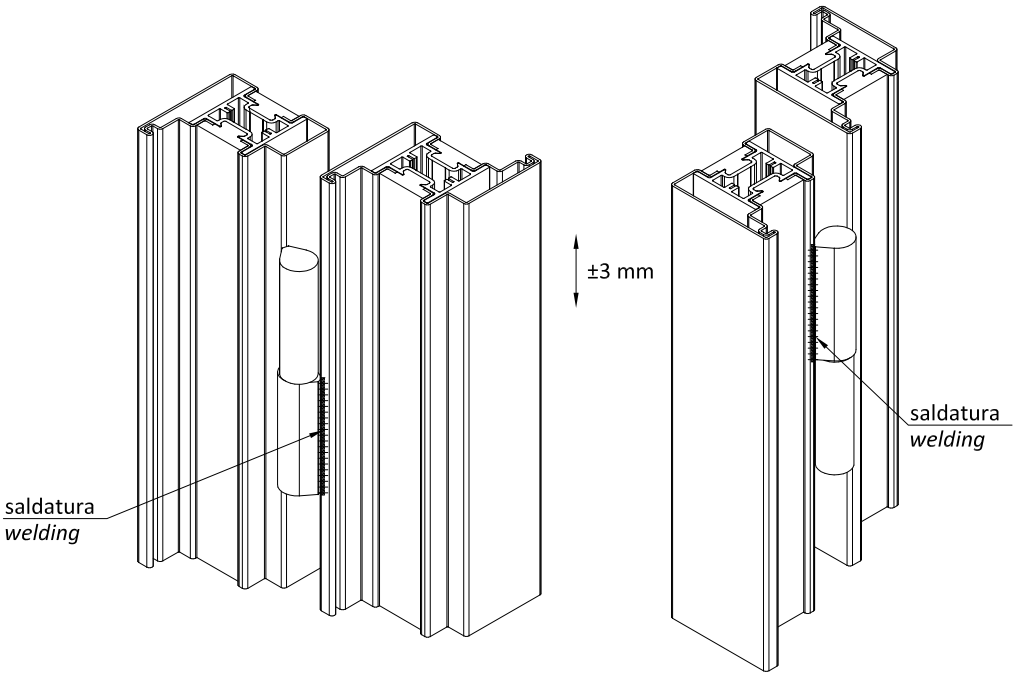
Peso max. per anta 200 kg
Max. weight for leaf: 200 kg



Posizionare le cerniere come da disegno saldandole sui alti.

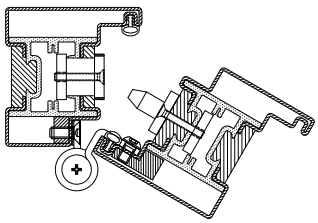
Position the hinges as in the drawing, welding them on the sides.

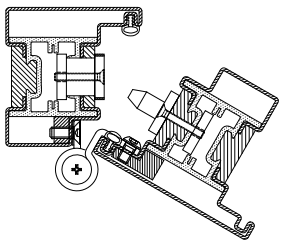


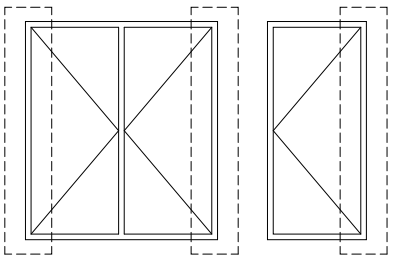


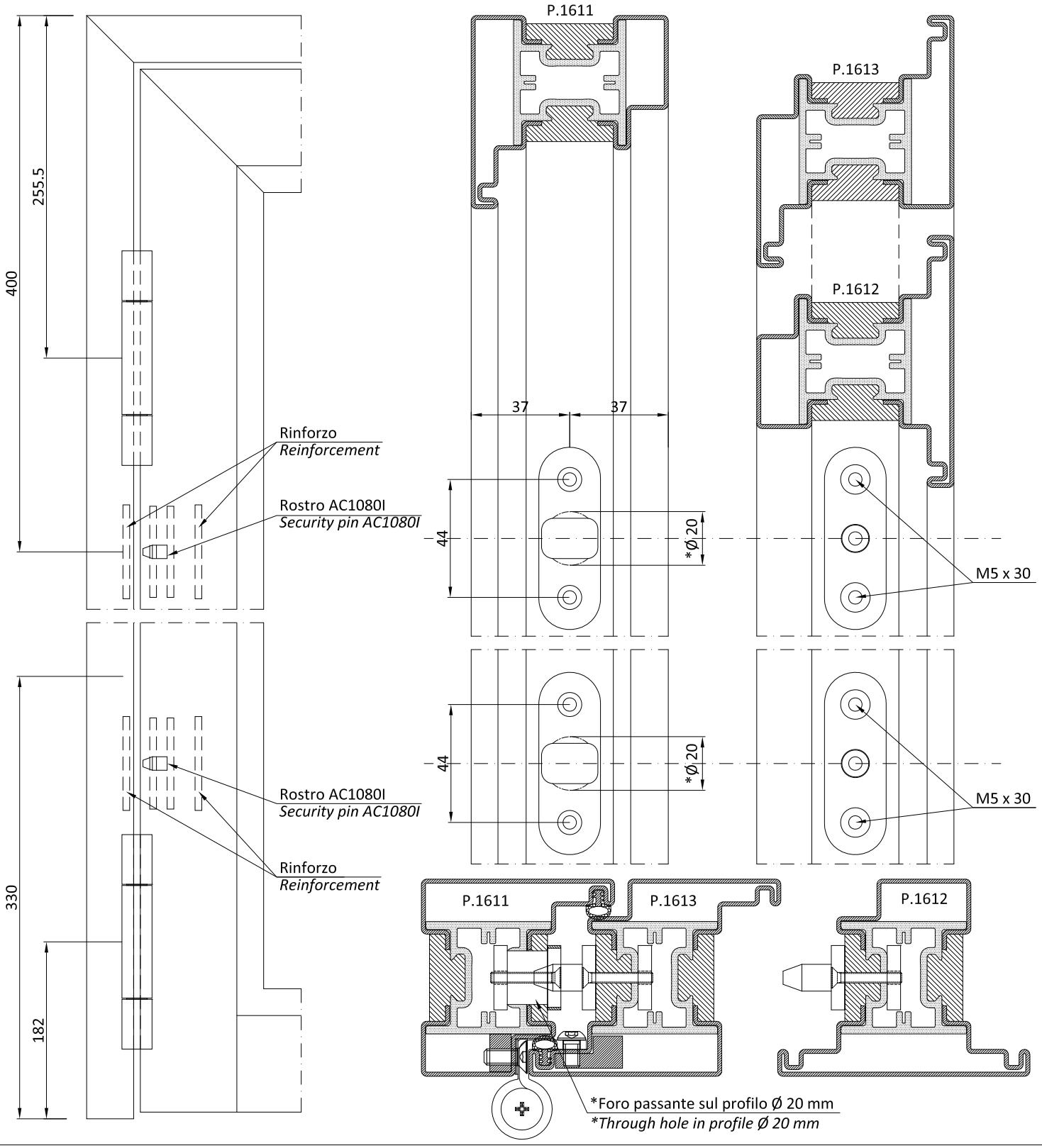
- La lavorazione può essere effettuata anche in posizioni intermedie dell'altezza della porta.
- La lavorazione SX è speculare alla DX.
- La lavorazione è valida anche per le aperture esterne.

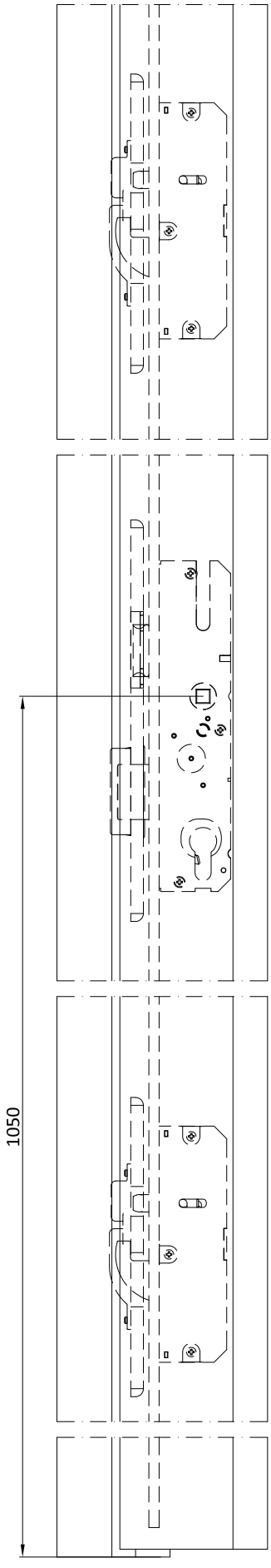
- *Tooling can be carried out also in intermediate positions regarding the height of the door.*
- *Tooling on left is the same as that on the right.*
- *Tooling can be done also on external openings.*








P.1611
P.1613
P.1612
255.5
400
37
37
Rinforzo
Reinforcement
Rostro AC1080I
Security pin AC1080I
44
*Ø 20
M5 x 30
Rostro AC1080I
Security pin AC1080I
Rinforzo
Reinforcement
330
182
P.1611
P.1613
P.1612
*Foro passante sul profilo Ø 20 mm
*Through hole in profile Ø 20 mm

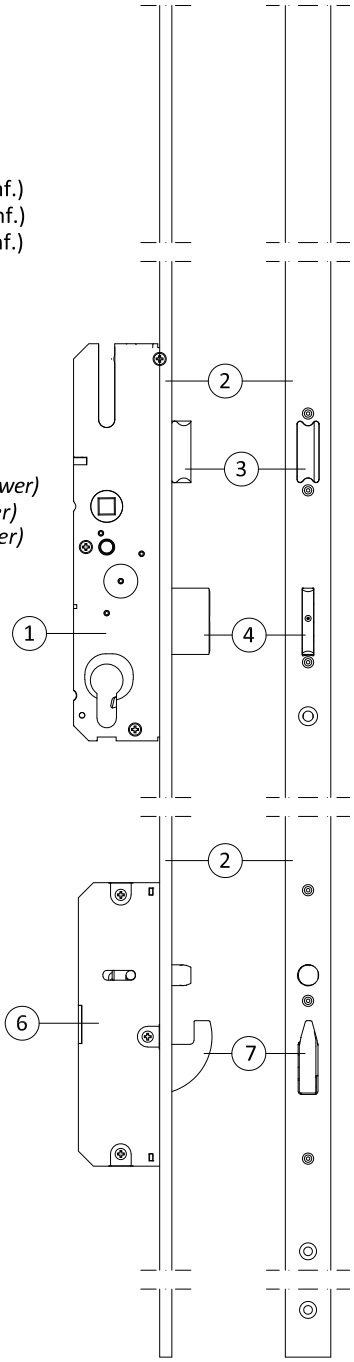


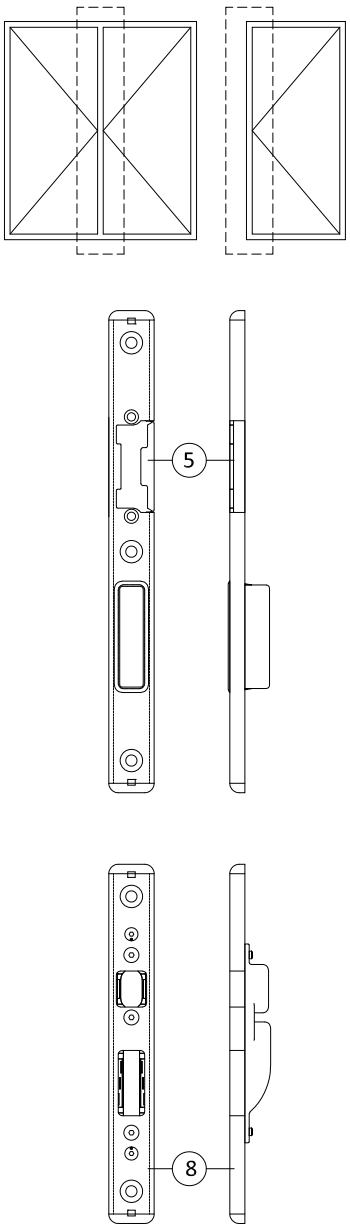
AC1065W D/S _ AC1066W D/S

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

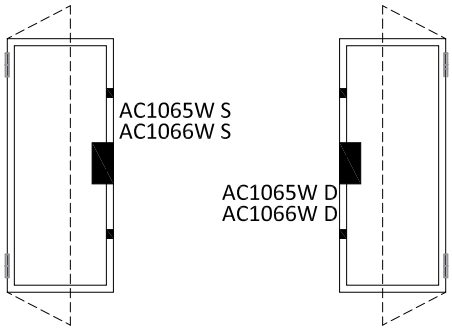
AC1065W D/S _ AC1066W D/S

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

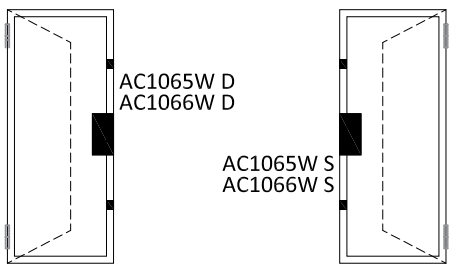




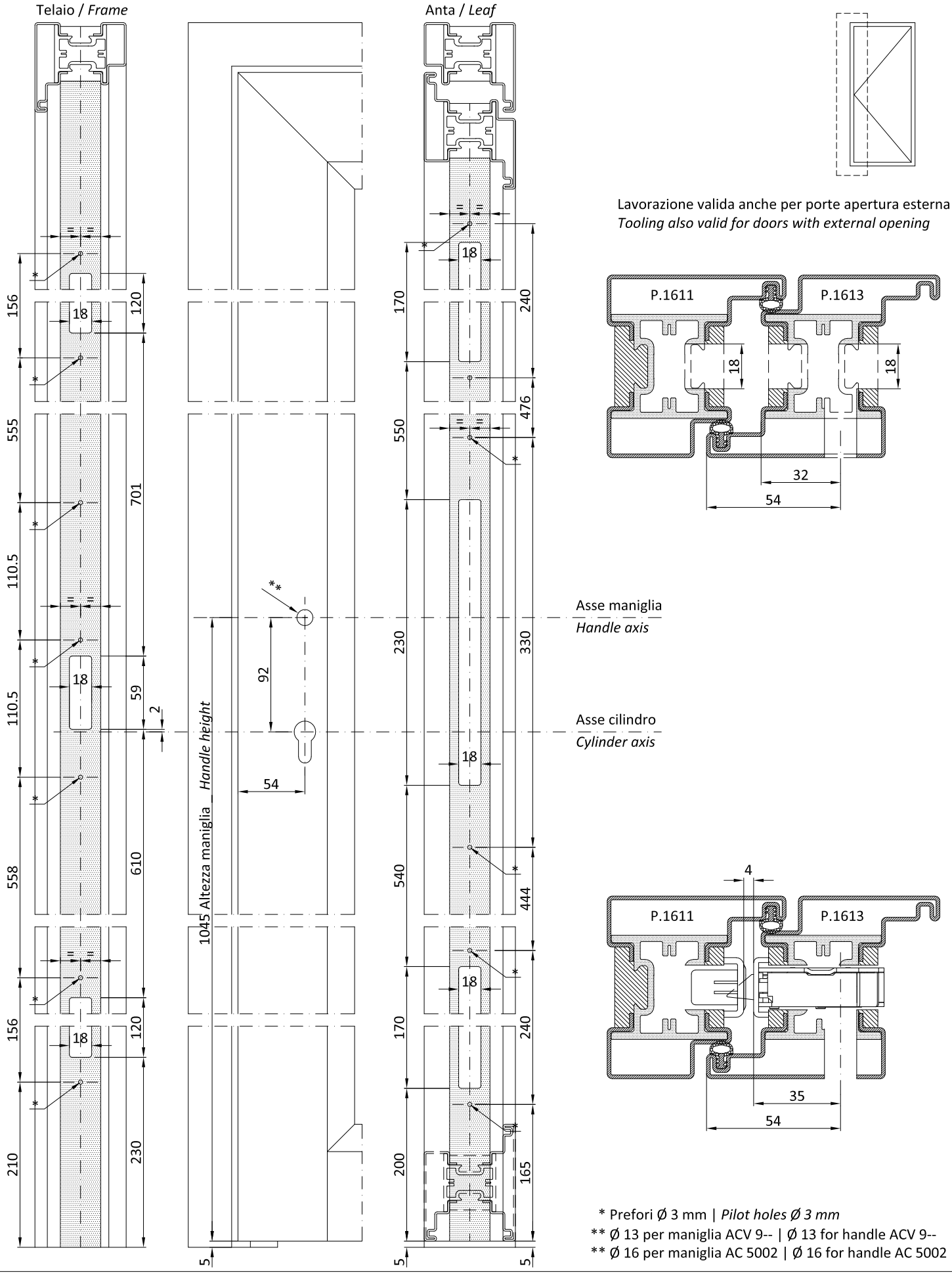
SCHEMA UTILIZZO SERRATURE
DIAGRAM FOR THE USE OF LOCKS

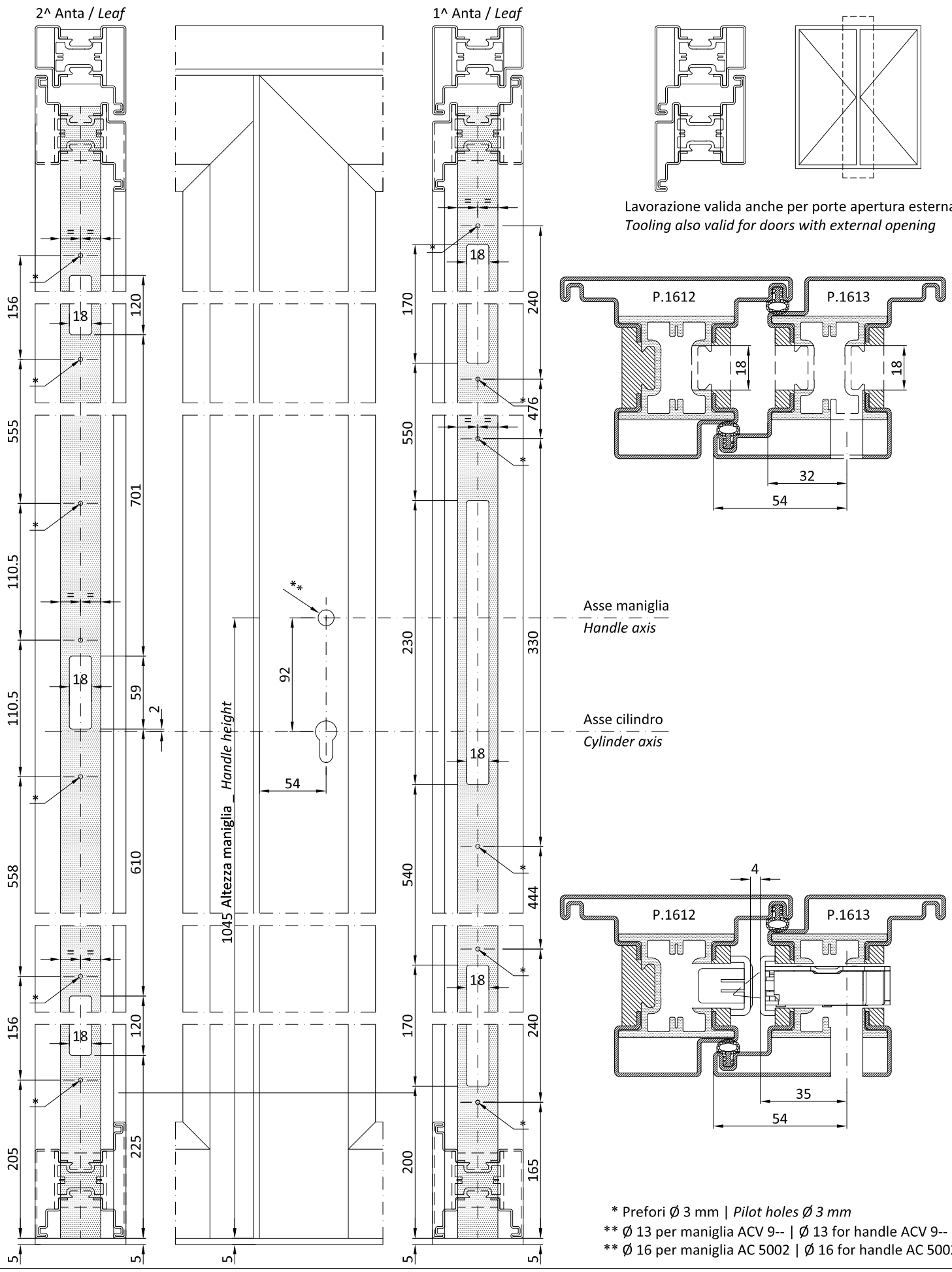


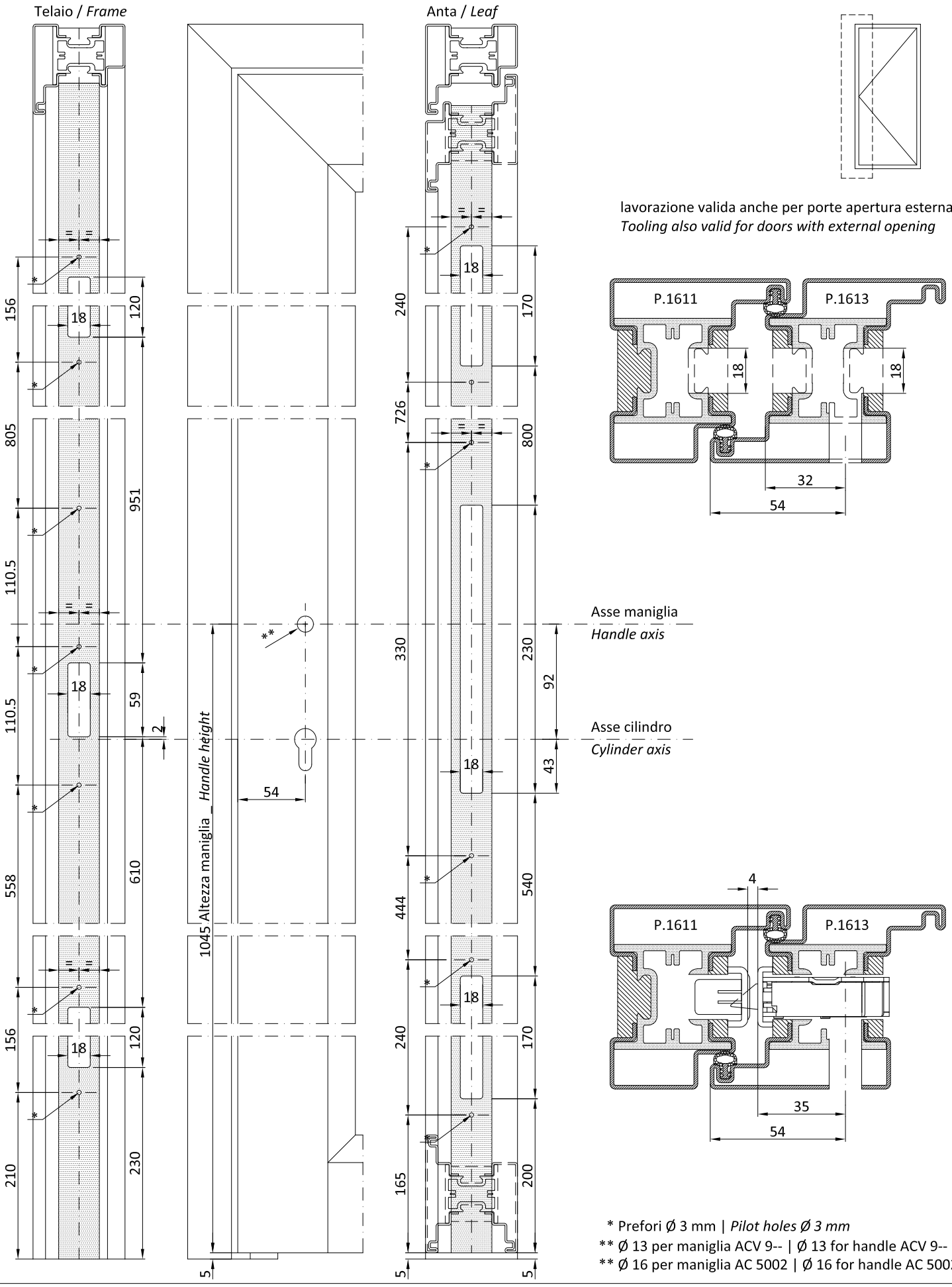
APERTURA INTERNA _ VISTA INTERNA
INWARDS OPENING _ INTERIOR ELEVATION

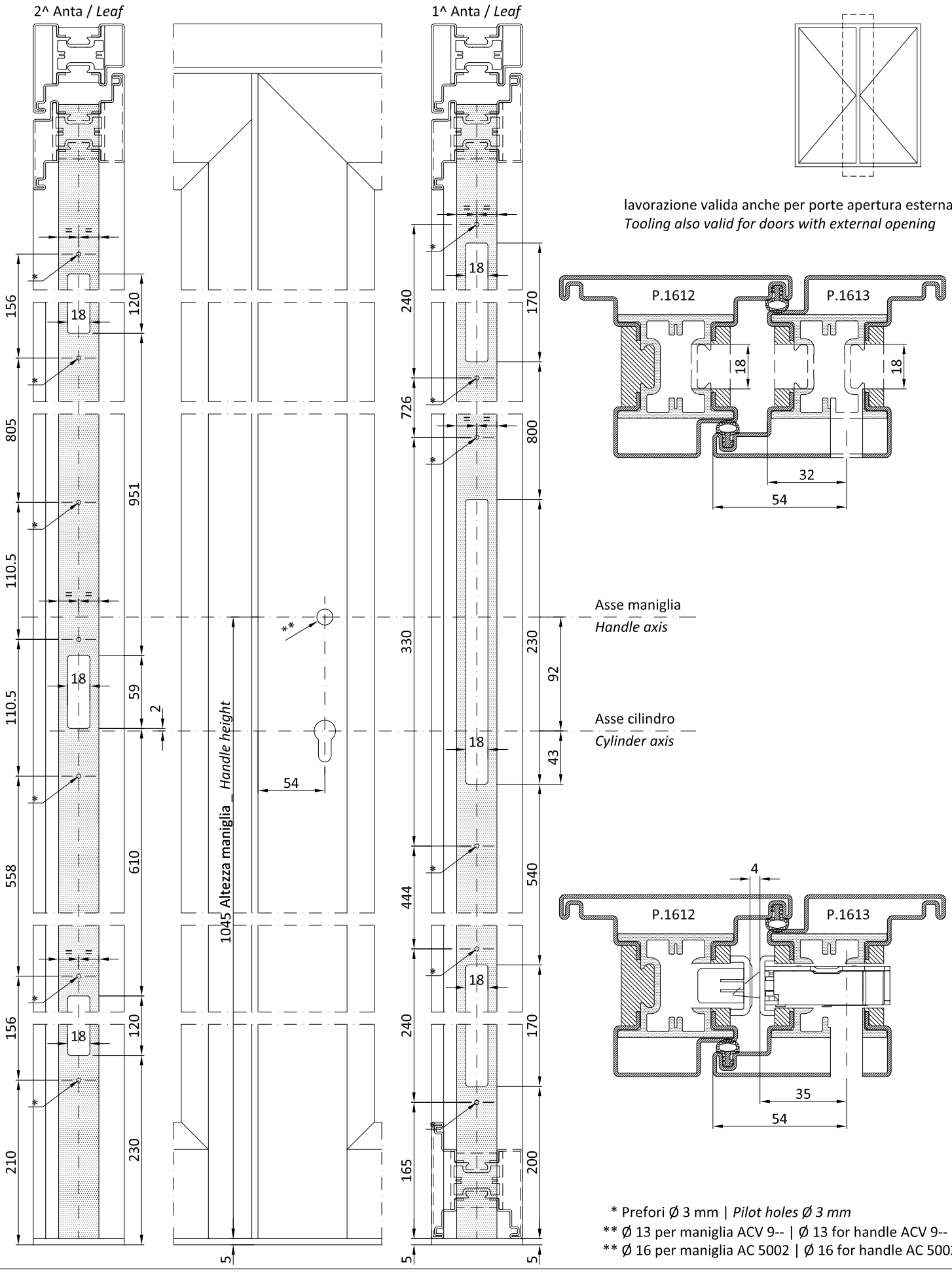


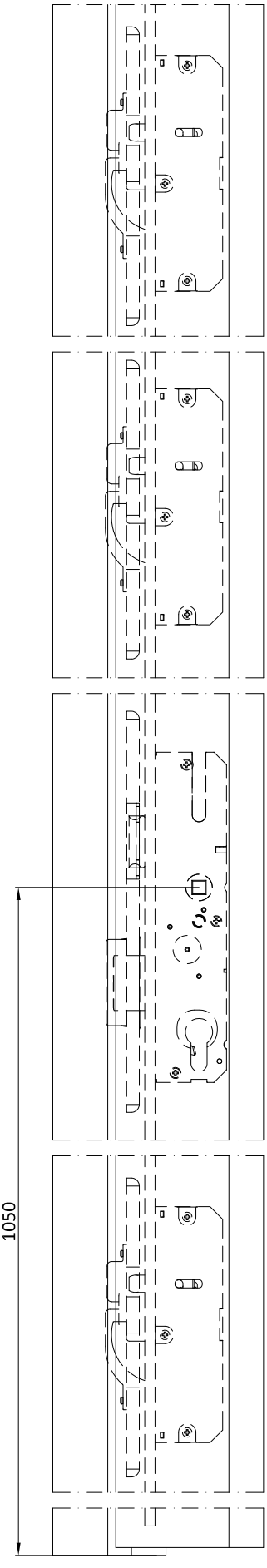
APERTURA ESTERNA _ VISTA INTERNA
OUTWARDS OPENING _ INTERIOR ELEVATION


Telaio / *Frame*
Anta / *Leaf*
156
555
110.5
110.5
558
156
210
120
701
59
2
610
120
230
18
92
54
1045 Altezza maniglia _ *Handle height*
5
170
550
230
540
170
200
240
476
330
444
240
165
Asse maniglia
Handle axis
Asse cilindro
Cylinder axis
Lavorazione valida anche per porte apertura esterna
Tooling also valid for doors with external opening
P.1611
P.1613
32
54
4
35
* Prefori Ø 3 mm | *Pilot holes Ø 3 mm*
** Ø 13 per maniglia ACV 9-- | Ø 13 for handle ACV 9--
** Ø 16 per maniglia AC 5002 | Ø 16 for handle AC 5002


2^ Anta / Leaf
1^ Anta / Leaf
156
120
555
701
110.5
59
2
558
610
205
225
170
240
550
476
540
444
200
165
18
92
54
1045 Altezza maniglia _ Handle height
Asse maniglia
Handle axis
230
330
Asse cilindro
Cylinder axis
5
Lavorazione valida anche per porte apertura esterna
Tooling also valid for doors with external opening
P.1612
P.1613
32
54
4
35
* Prefori Ø 3 mm | Pilot holes Ø 3 mm
** Ø 13 per maniglia ACV 9-- | Ø 13 for handle ACV 9--
** Ø 16 per maniglia AC 5002 | Ø 16 for handle AC 5002


Telaio / *Frame*
Anta / *Leaf*
156
120
805
951
110.5
110.5
59
2
558
610
156
120
210
230
18
240
170
726
800
330
230
92
43
444
540
240
170
165
200
1045 Altezza maniglia _ *Handle height*
54
5
Asse maniglia
Handle axis
Asse cilindro
Cylinder axis
lavorazione valida anche per porte apertura esterna
Tooling also valid for doors with external opening
P.1611
P.1613
32
54
4
35
* Prefori Ø 3 mm | *Pilot holes Ø 3 mm*
** Ø 13 per maniglia ACV 9-- | Ø 13 for handle ACV 9--
** Ø 16 per maniglia AC 5002 | Ø 16 for handle AC 5002


2^ Anta / *Leaf*
1^ Anta / *Leaf*
156
120
18
805
951
110.5
59
2
610
558
210
230
1045 Altezza maniglia _ *Handle height*
54
330
230
92
43
444
540
240
170
726
800
165
200
5
Asse maniglia
Handle axis
Asse cilindro
Cylinder axis
lavorazione valida anche per porte apertura esterna
Tooling also valid for doors with external opening
P.1612
P.1613
32
54
4
35
* Prefori Ø 3 mm | *Pilot holes Ø 3 mm*
** Ø 13 per maniglia ACV 9-- | Ø 13 for handle ACV 9--
** Ø 16 per maniglia AC 5002 | Ø 16 for handle AC 5002

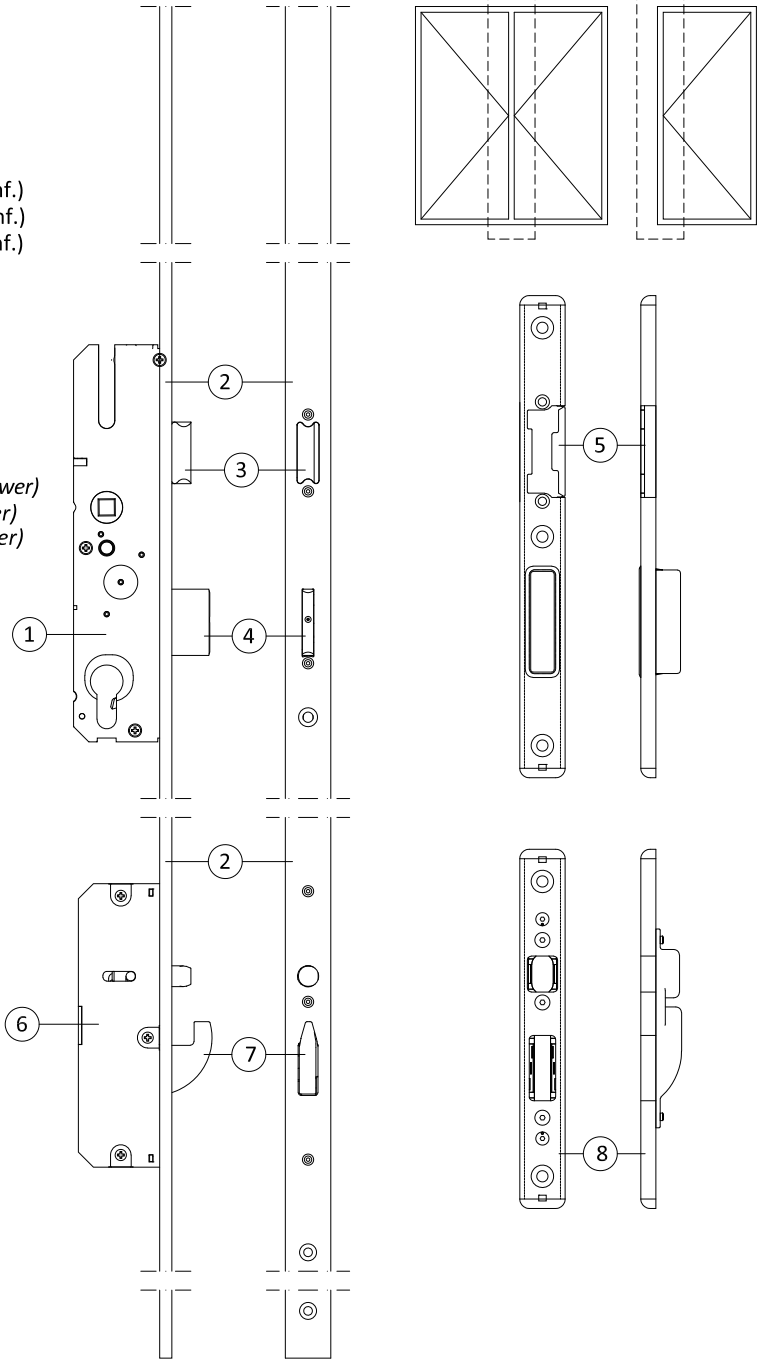


AC1067W D/S

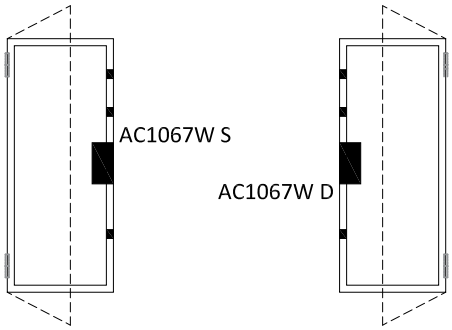
1) Serratura
2) Frontalino
3) Scrocco
4) Catenaccio
5) Incontro per serratura
6) Deviatori (n°3 pezzi sup + inf.)
7) Catenaccio (n°3 pezzi sup + inf.)
8) Incontro (n°3 pezzi sup + inf.)

AC1067W D/S

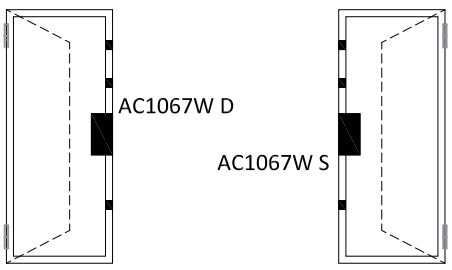
1) Lock
2) Front plate
3) Spring latch
4) Bolt
5) Strike plate
6) Diverters (n° 3 items upper + lower)
7) Bolt (n° 3 items upper + lower)
8) Plate (n° 3 items upper + lower)



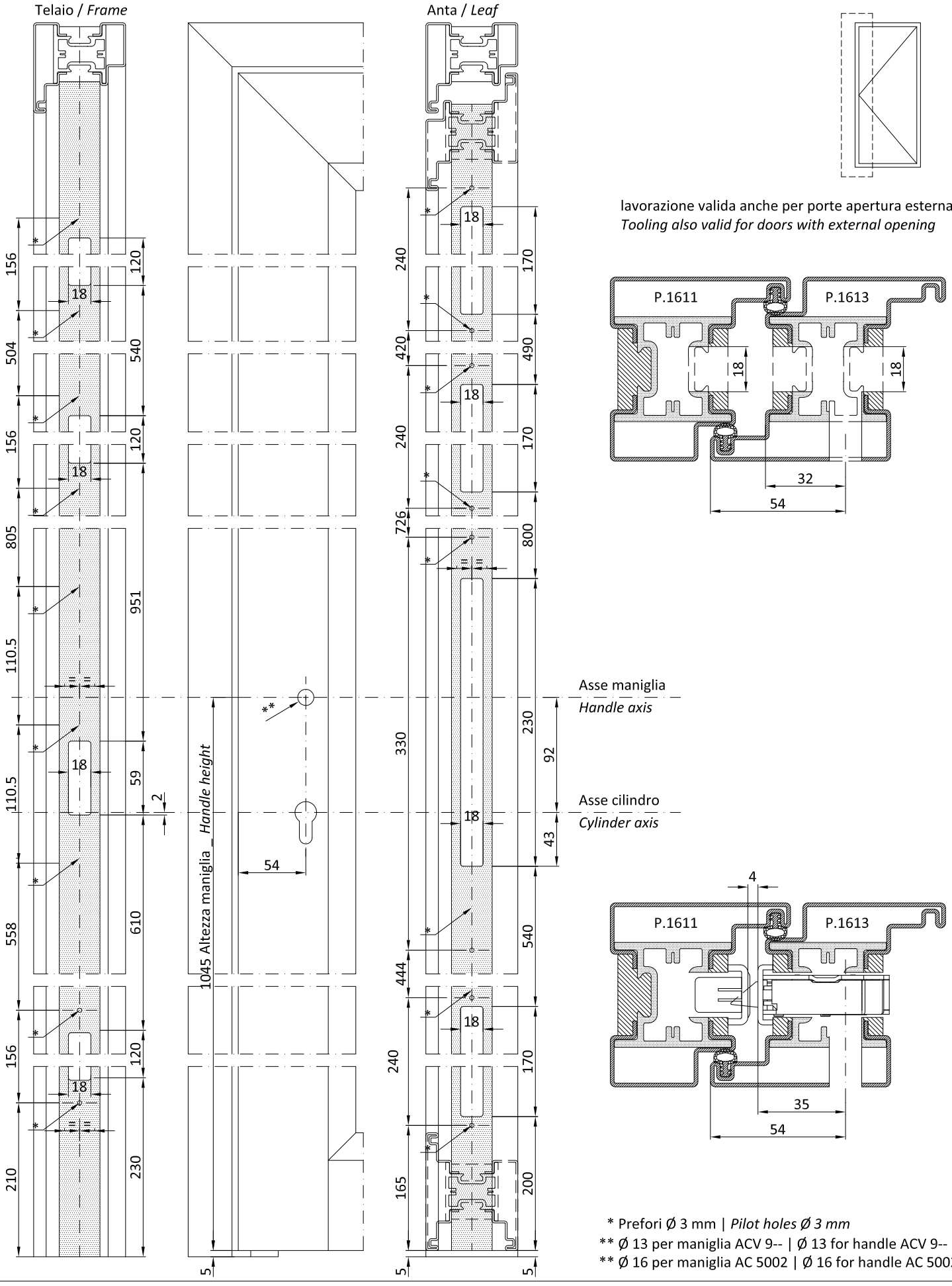
SCHEMA UTILIZZO SERRATURE
DIAGRAM FOR THE USE OF LOCKS



APERTURA INTERNA _ VISTA INTERNA
INWARDS OPENING _ INTERIOR ELEVATION

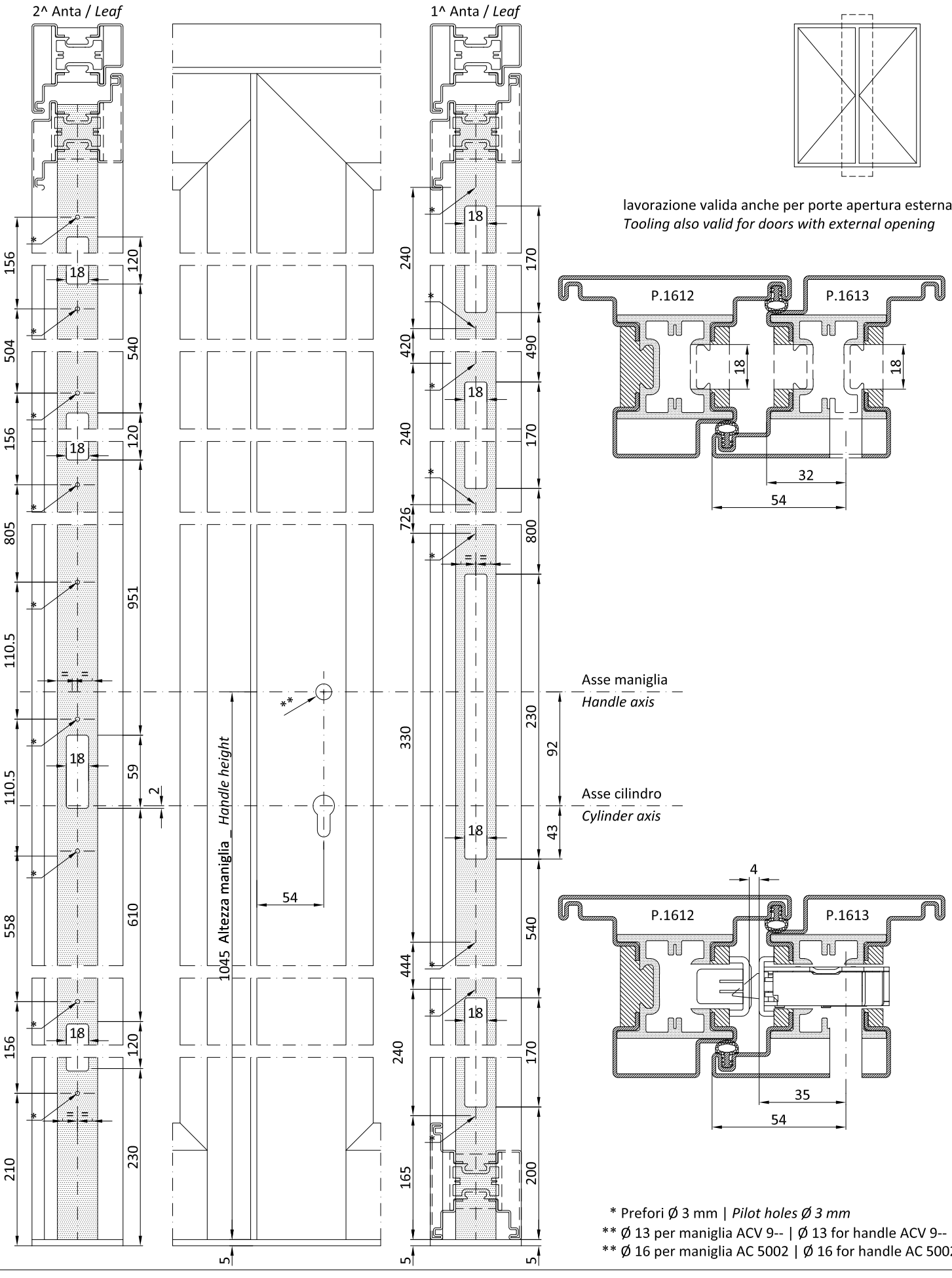


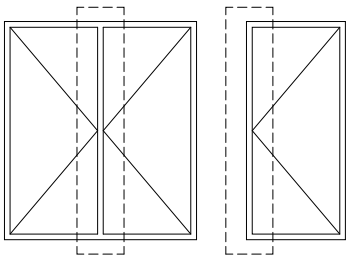
APERTURA ESTERNA _ VISTA INTERNA
OUTWARDS OPENING _ INTERIOR ELEVATION

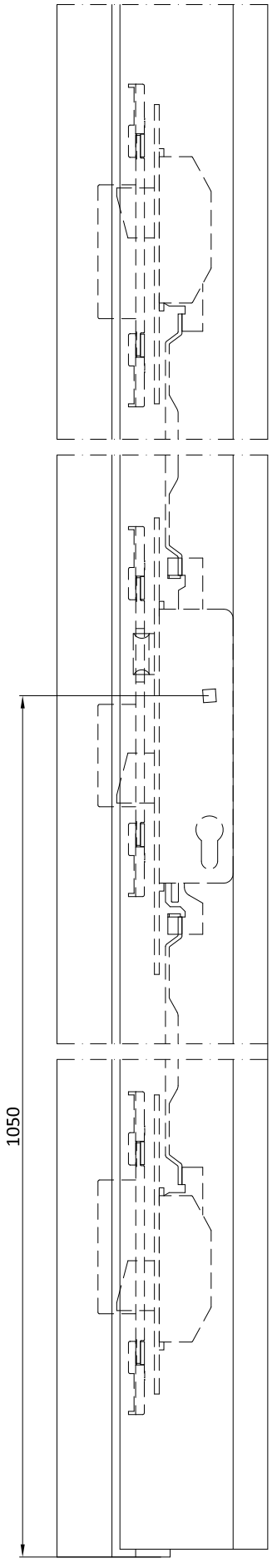


lavorazione valida anche per porte apertura esterna
Tooling also valid for doors with external opening

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


2^ Anta / Leaf
1^ Anta / Leaf
lavorazione valida anche per porte apertura esterna
Tooling also valid for doors with external opening
P.1612
P.1613
32
54
Asse maniglia
Handle axis
Asse cilindro
Cylinder axis
Altezza maniglia _ Handle height
1045
54
4
35
54
* Prefori Ø 3 mm | Pilot holes Ø 3 mm
** Ø 13 per maniglia ACV 9-- | Ø 13 for handle ACV 9--
** Ø 16 per maniglia AC 5002 | Ø 16 for handle AC 5002



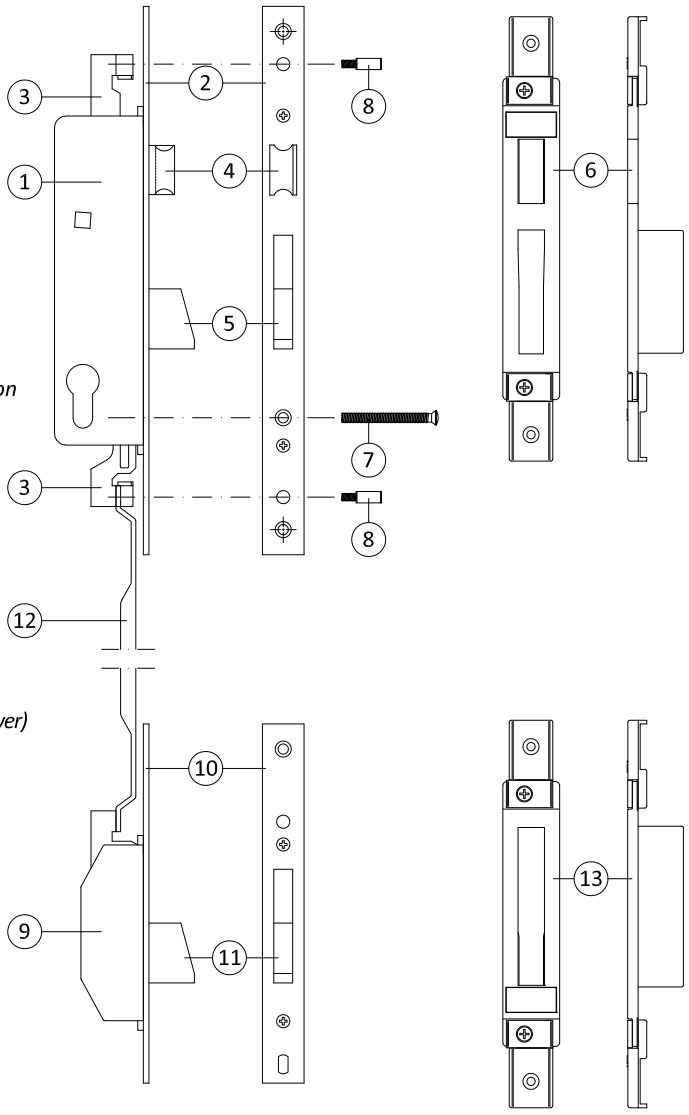


AC1070

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

AC1075

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



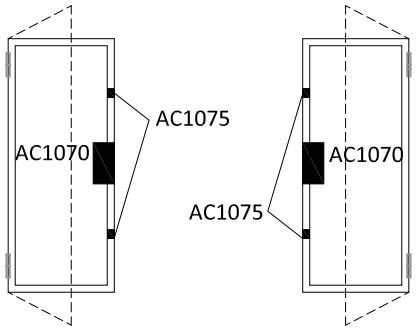
AC1070

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

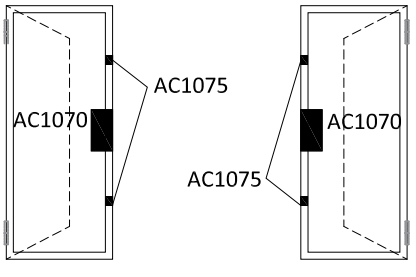
AC1075

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

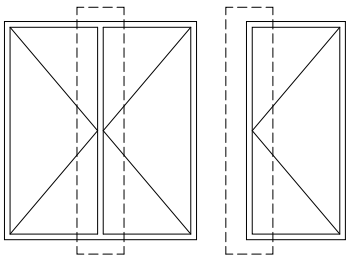
SCHEMA UTILIZZO SERRATURE E TERZE CHIUSURE
DIAGRAM FOR THE USE OF LOCKS AND THIRD LOCKS

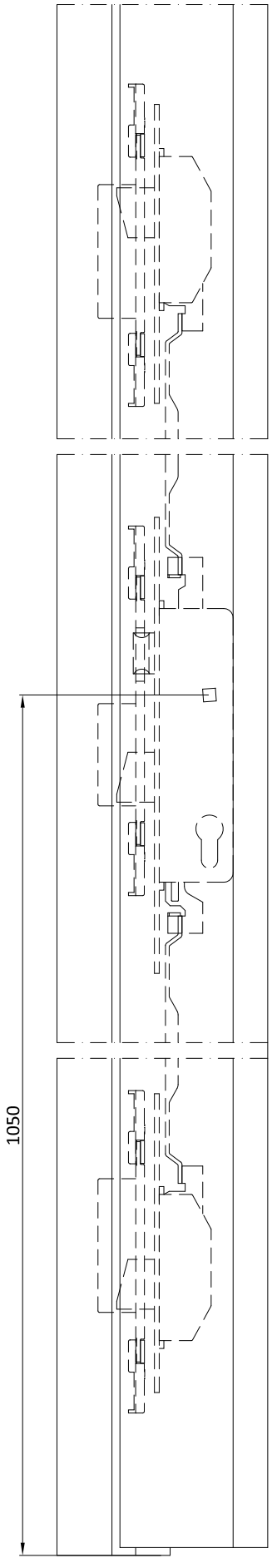


APERTURA INTERNA _ VISTA INTERNA
INWARDS OPENING _ INTERIOR ELEVATION



APERTURA ESTERNA _ VISTA INTERNA
OUTWARDS OPENING _ INTERIOR ELEVATION





AC1071

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

AC1075

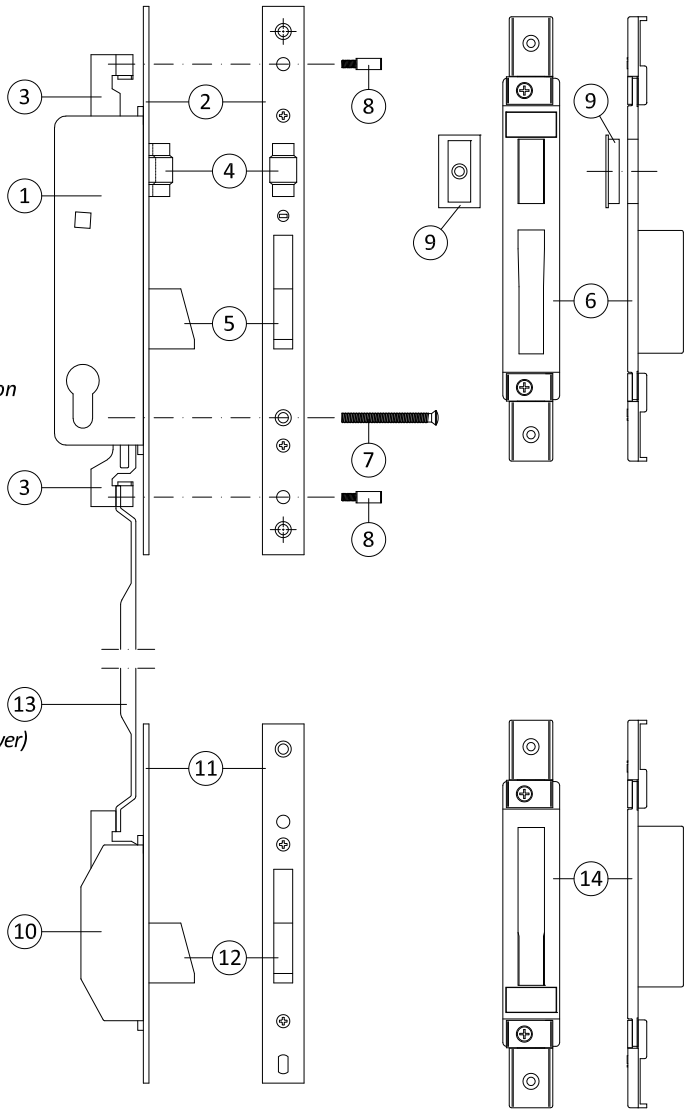
10) Deviatori (n°2 pezzi sup + inf.)
11) Frontalino (n°2 pezzi sup + inf.)
12) Catenaccio (n°2 pezzi sup + inf.)
13) Aste inox (n°2 pezzi sup + inf.)
14) Incontro (n°2 pezzi sup + inf.)

AC1071

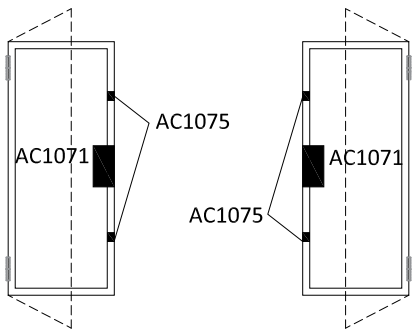
1) Lock
2) Front plate
3) Reduction unit/adapter for connection
4) Roller
5) Bolt
6) Strike plate
7) Compartment for roller
8) Stainless steel screws TS M5x50
9) Pin for anchoring the rod

AC1075

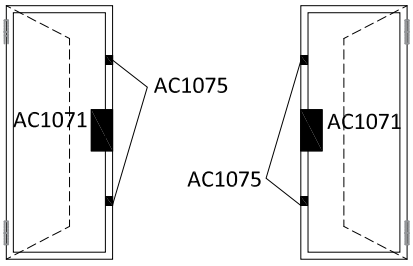
10) Diverters (n° 2 items upper + lower)
11) Apron lining (n° 2 items upper + lower)
11) Bolt (n° 2 items upper + lower)
13) Stainless steel rods (n° 2 items upper + lower)
14) Plate (n° 2 items upper + lower)



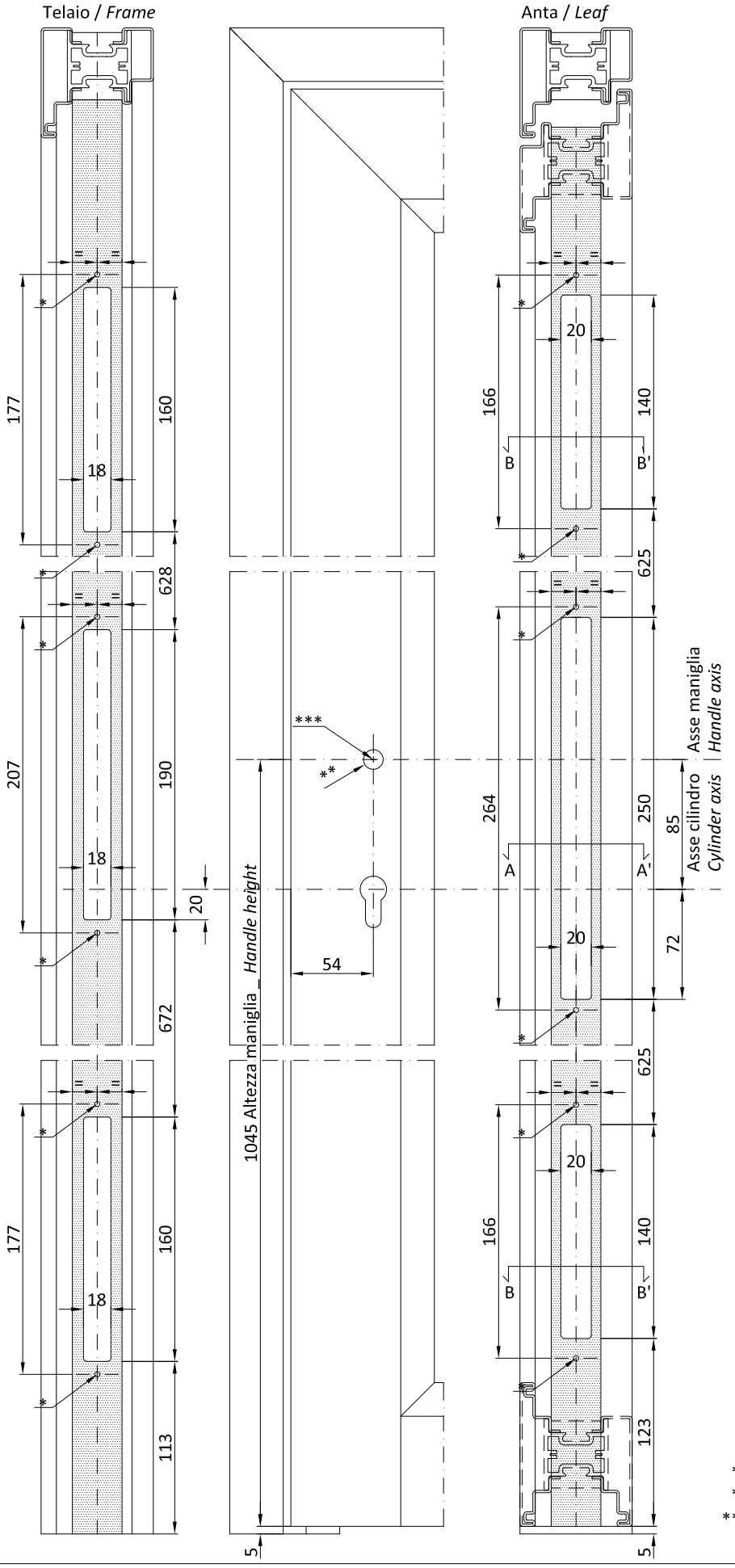
SCHEMA UTILIZZO SERRATURE E TERZE CHIUSURE
DIAGRAM FOR THE USE OF LOCKS AND THIRD LOCKS

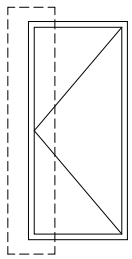


APERTURA INTERNA _ VISTA INTERNA
INWARDS OPENING _ INTERIOR ELEVATION



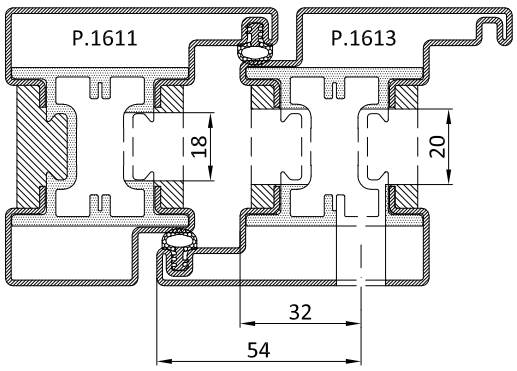
APERTURA ESTERNA _ VISTA INTERNA
OUTWARDS OPENING _ INTERIOR ELEVATION



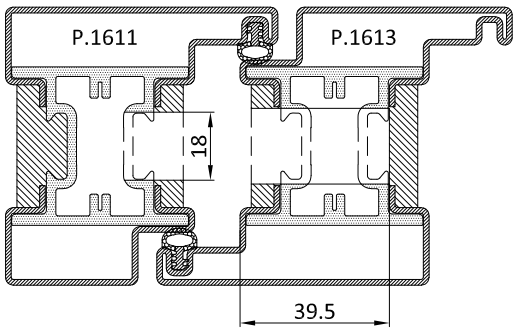


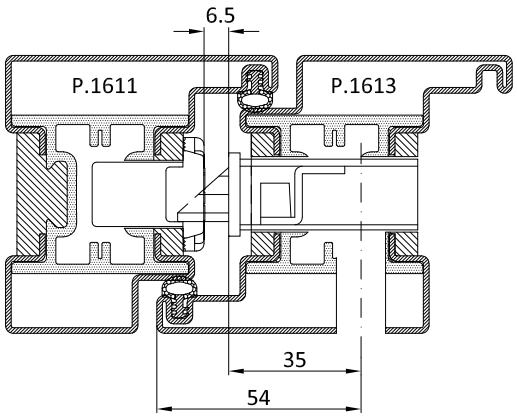
lavorazione valida anche per porte apertura esterna
Tooling also valid for doors with external opening

Sezione A-A' _ *Section A-A'*

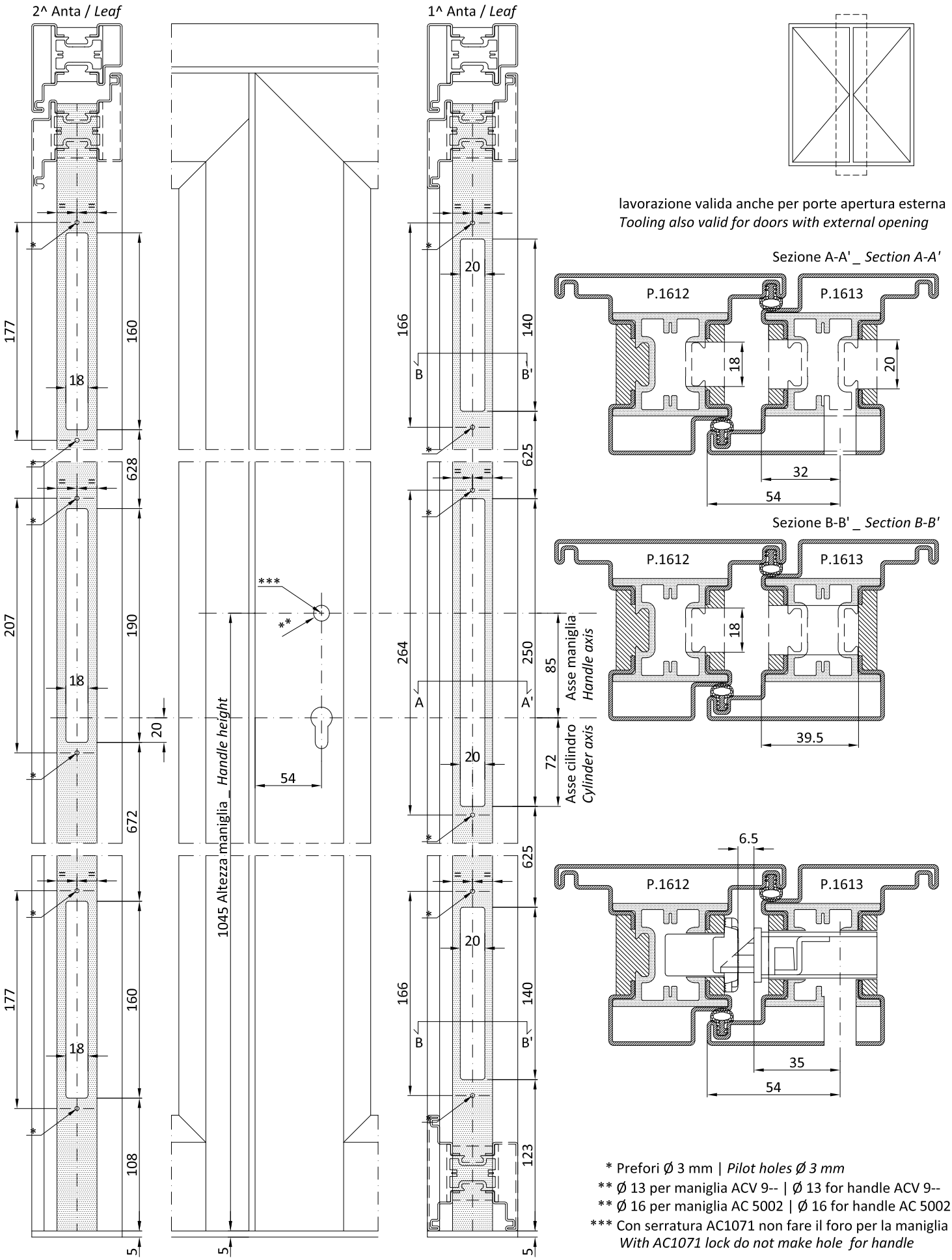


Sezione B-B' _ *Section B-B'*





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

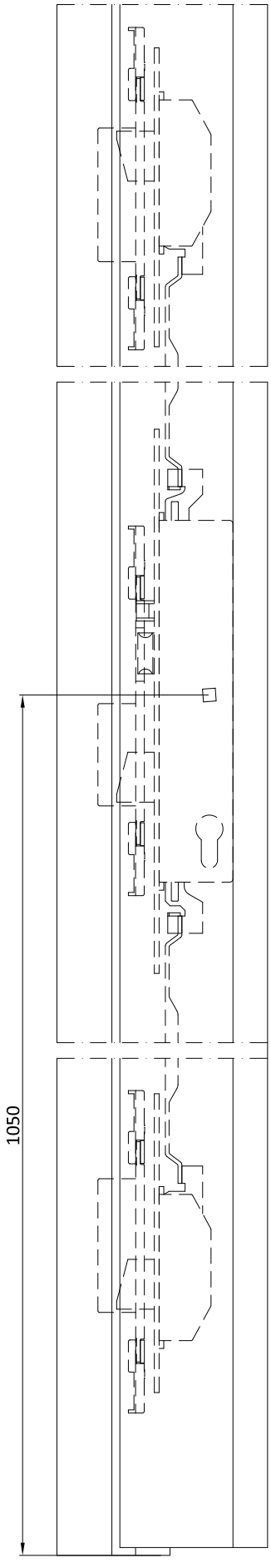


lavorazione valida anche per porte apertura esterna
Tooling also valid for doors with external opening

Sezione A-A' _ *Section A-A'*

Sezione B-B' _ *Section B-B'*

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



AC1072

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

AC1075

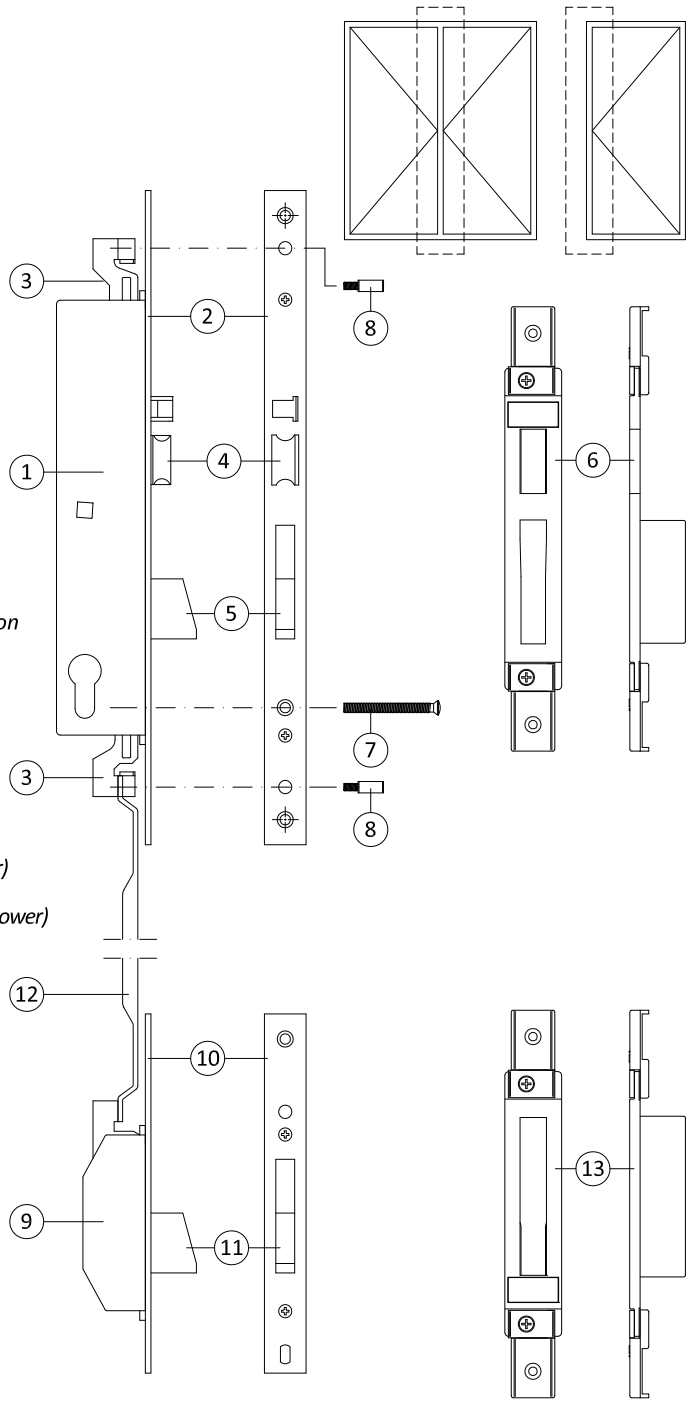
9) Deviatori (n°2 pezzi sup + inf.)
10) Frontalino (n°2 pezzi sup + inf.)
11) Catenaccio (n°2 pezzi sup + inf.)
12) Aste inox (n°2 pezzi sup + inf.)
13) Incontro (n°2 pezzi sup + inf.)

AC1072

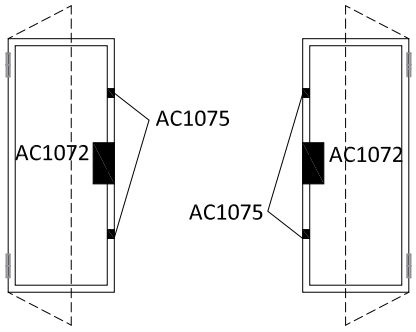
1) Lock
2) Front plate
3) Reduction unit/adapter for connection
4) Spring latch
5) Bolt
6) Strike plate
7) Stainless steel screws TS M5x50
8) Pin for anchoring the rod

AC1075

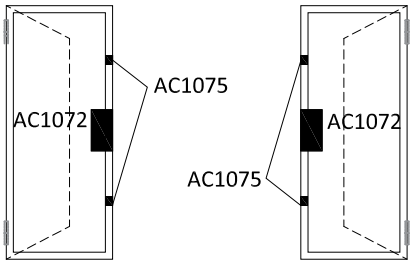
9) Diverters (n° 2 items upper + lower)
10) Apron lining (n° 2 items upper + lower)
11) Bolt (n° 2 items upper + lower)
12) Stainless steel rods (n° 2 items upper + lower)
13) Plate (no. 2 items upper + lower)



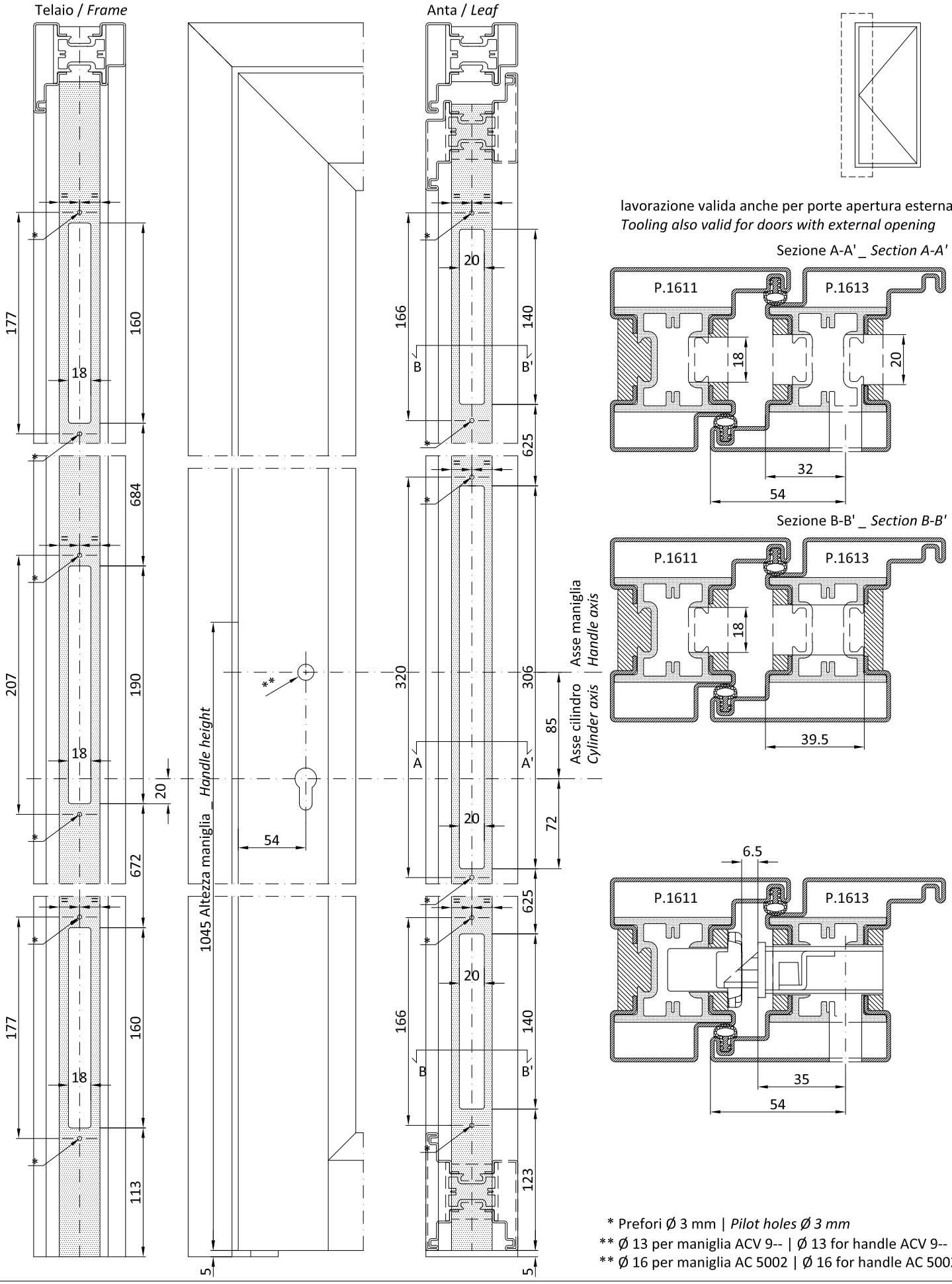
SCHEMA UTILIZZO SERRATURE E TERZE CHIUSURE
DIAGRAM FOR THE USE OF LOCKS AND THIRD LOCKS



APERTURA INTERNA _ VISTA INTERNA
INWARDS OPENING _ INTERIOR ELEVATION



APERTURA ESTERNA _ VISTA INTERNA
OUTWARDS OPENING _ INTERIOR ELEVATION

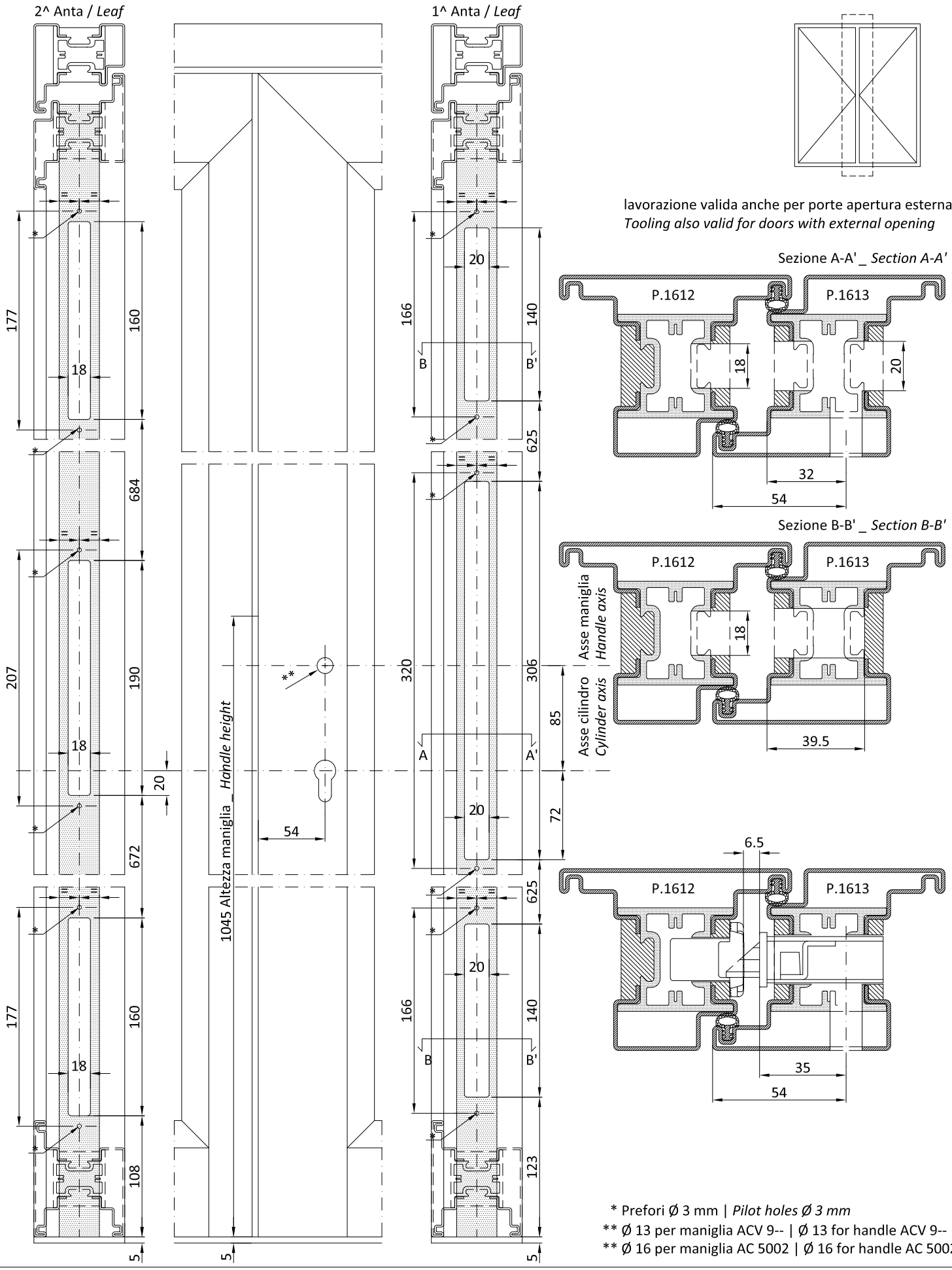


lavorazione valida anche per porte apertura esterna
Tooling also valid for doors with external opening

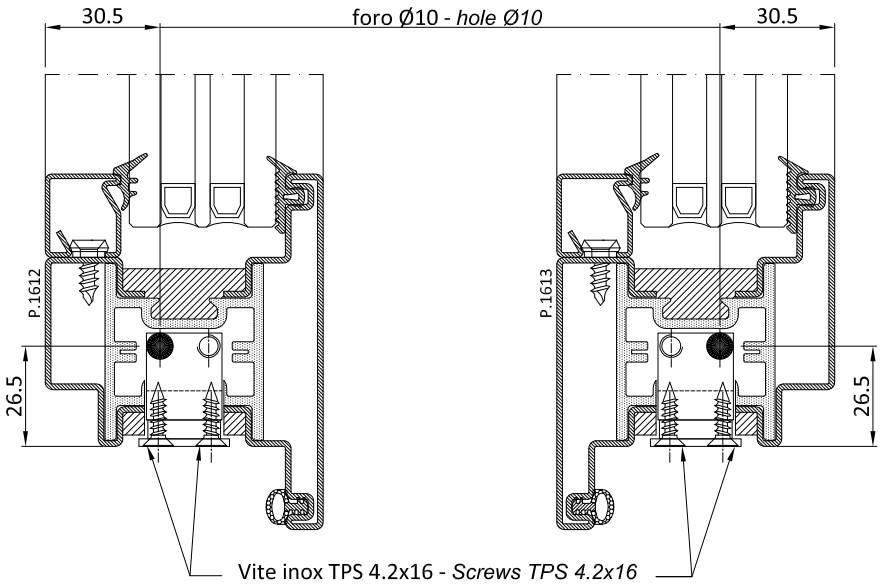
Sezione A-A' _ *Section A-A'*

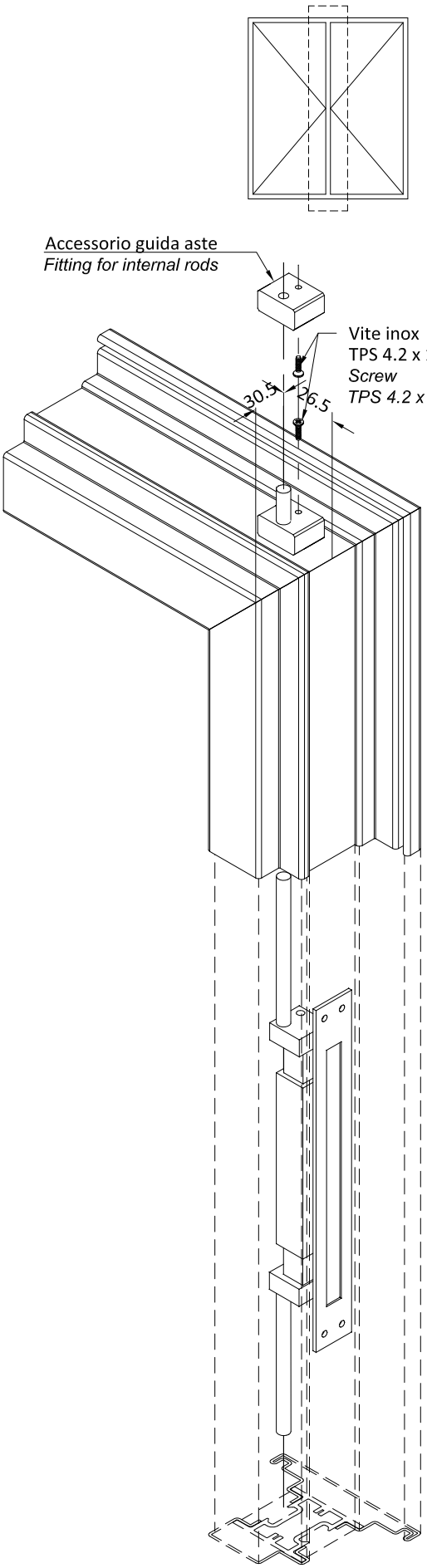
Sezione B-B' _ *Section B-B'*

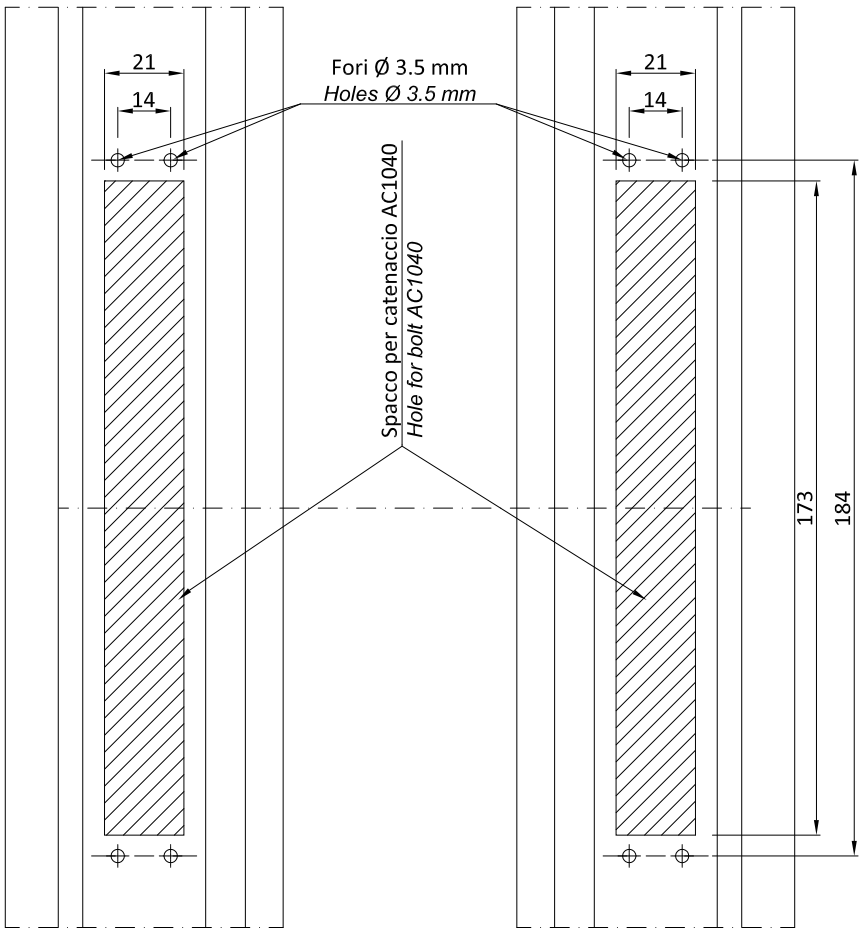
* Prefori Ø 3 mm | *Pilot holes Ø 3 mm*
** Ø 13 per maniglia ACV 9-- | Ø 13 for handle ACV 9--
** Ø 16 per maniglia AC 5002 | Ø 16 for handle AC 5002



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

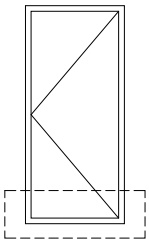


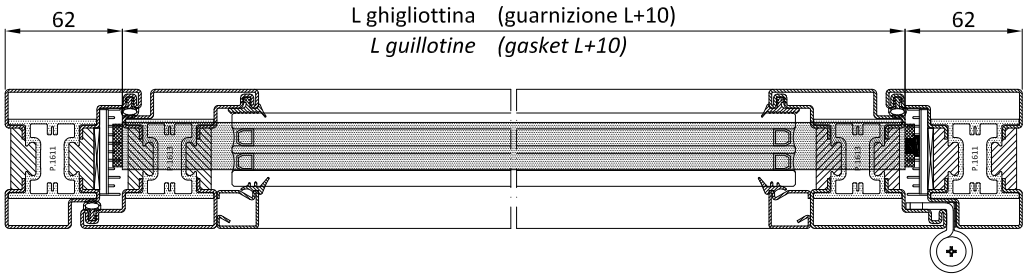


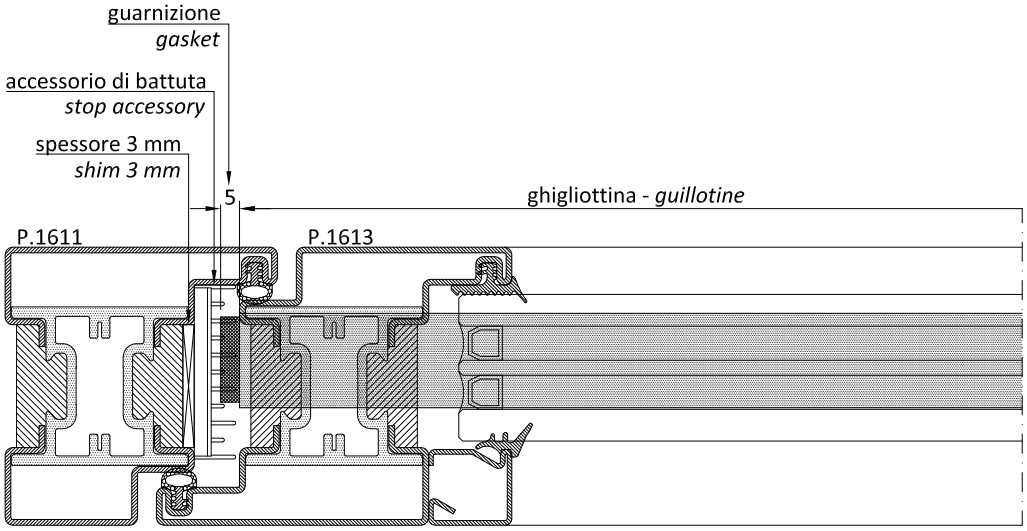


Aste Ø 7 mm L. mm 1500
Ø 7 mm L. mm 1500 rods

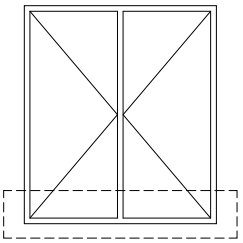
cod.	dimensioni *dimensions* [mm]
AC1081/A	615 → 730
AC1081/B	715 → 830
AC1081/C	815 → 930
AC1081/D	915 → 1030
AC1081/E	1015 → 1130
AC1081/F	1115 → 1230

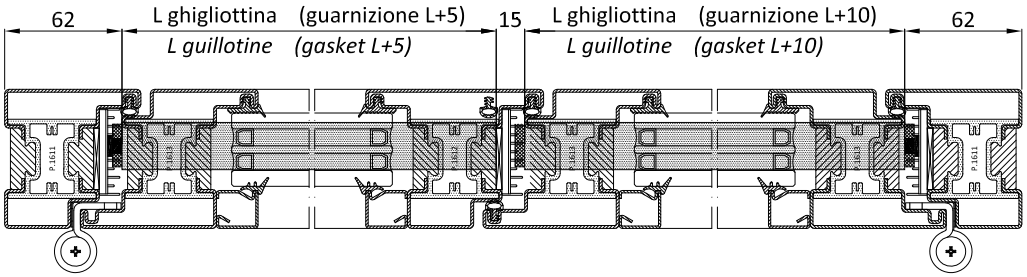


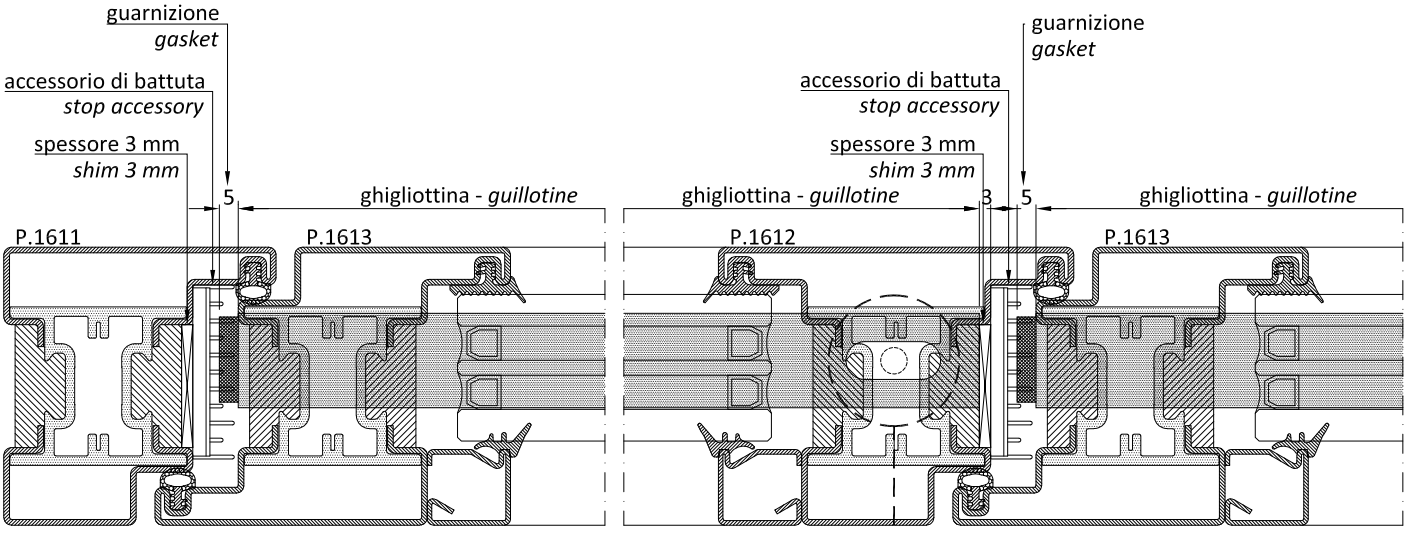


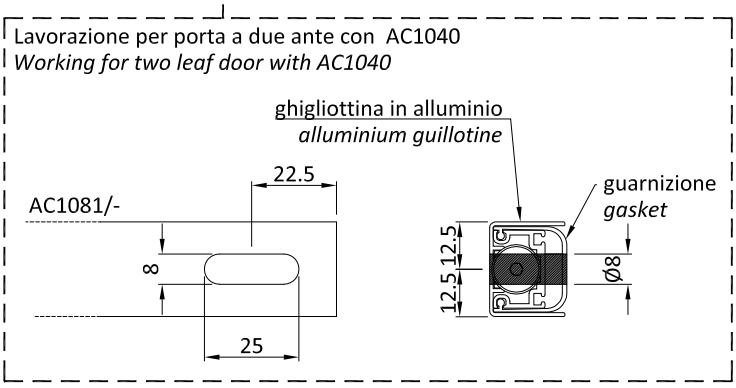


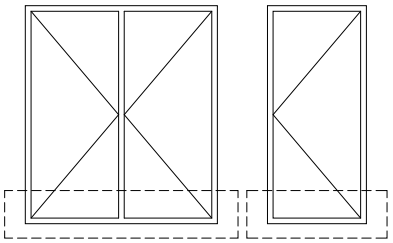
cod.	dimensioni *dimensions* [mm]
AC1081/A	615 → 730
AC1081/B	715 → 830
AC1081/C	815 → 930
AC1081/D	915 → 1030
AC1081/E	1015 → 1130
AC1081/F	1115 → 1230

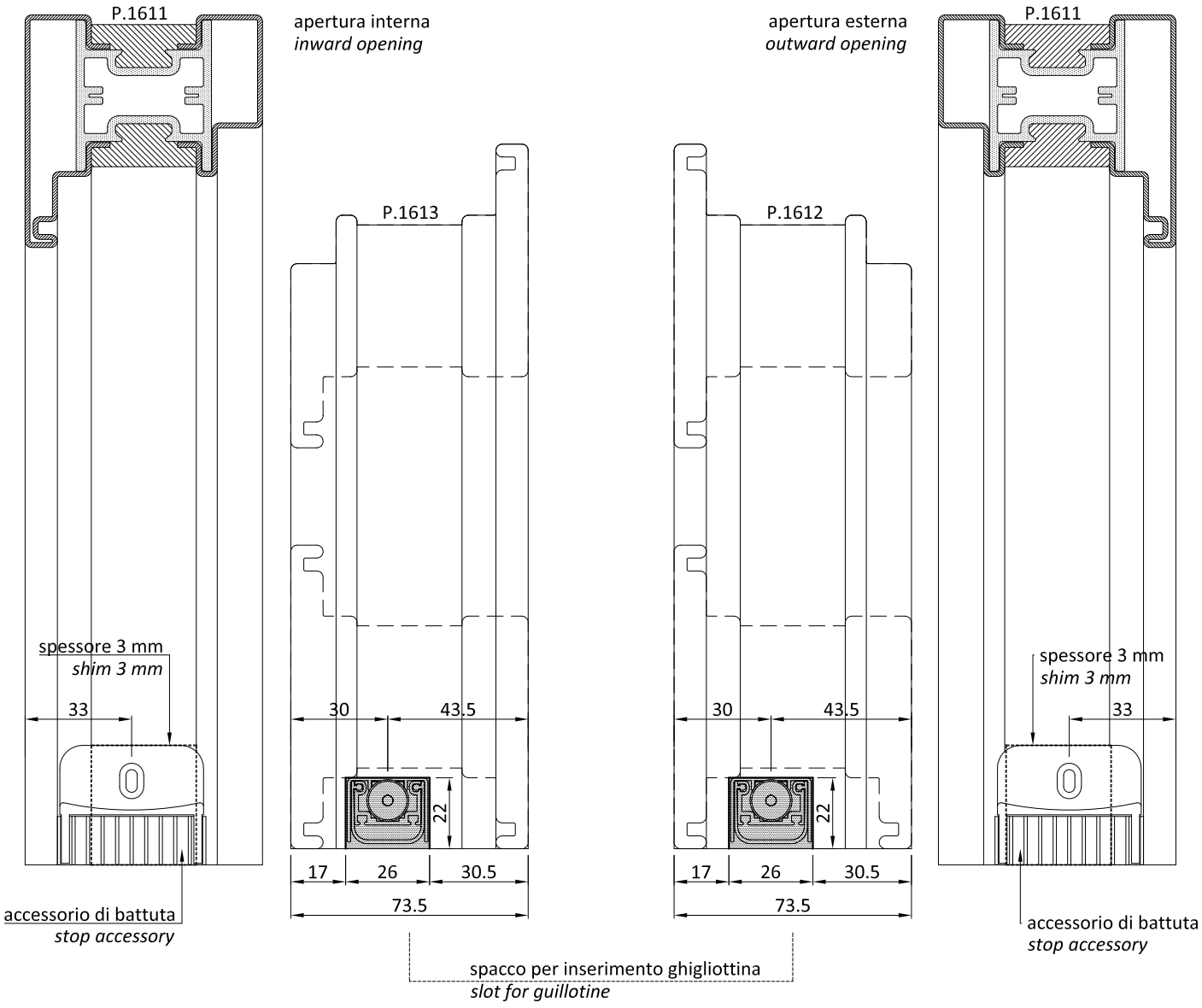


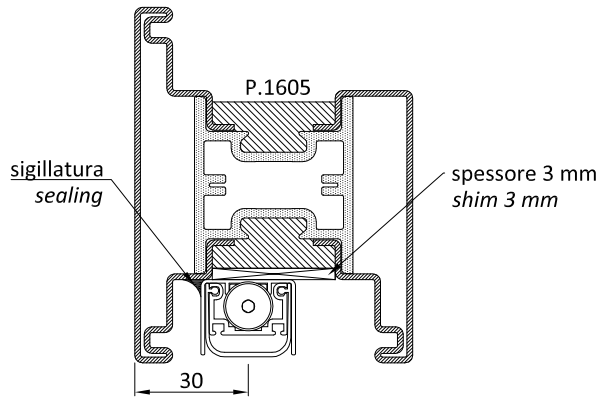




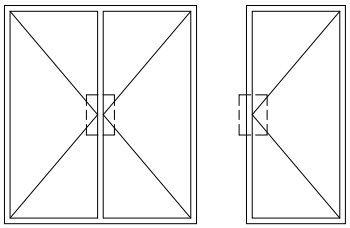


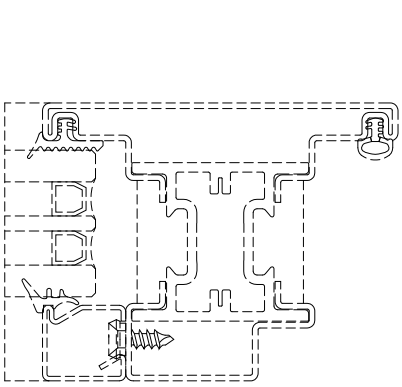


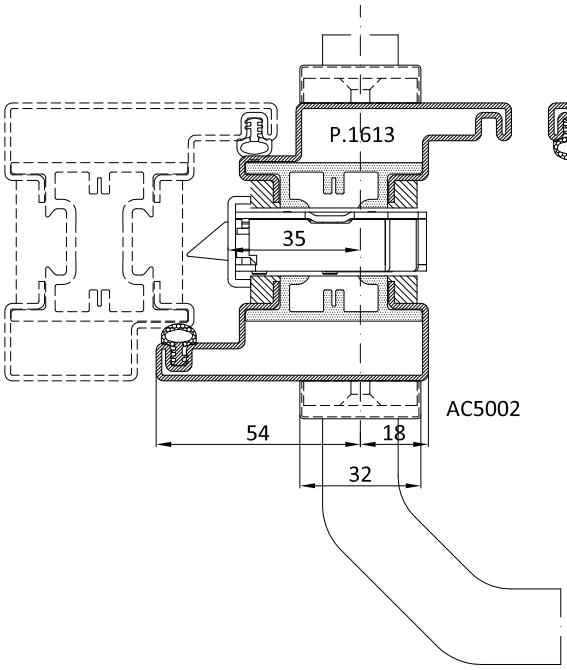


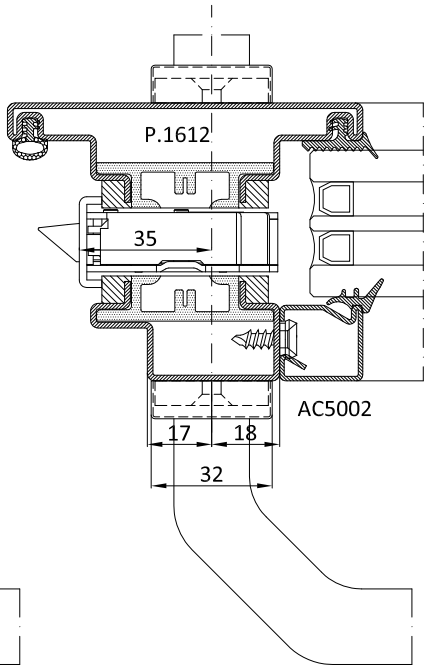


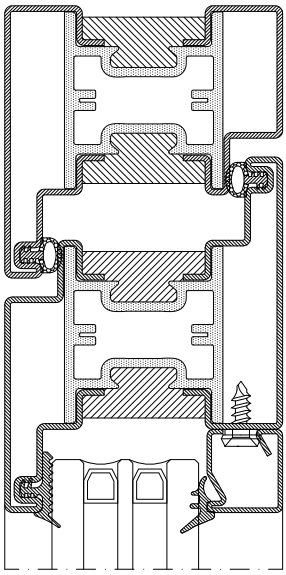
viti in dotazione
supplied screws









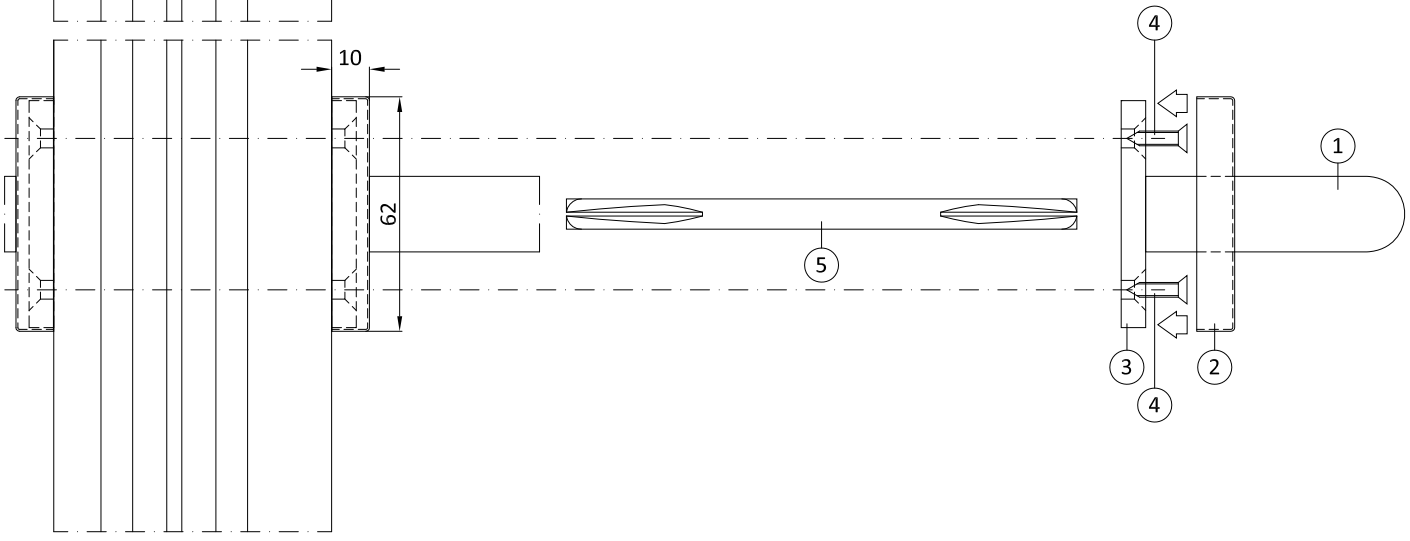


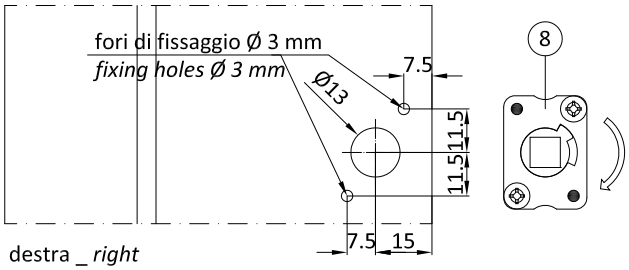
AC5002 :

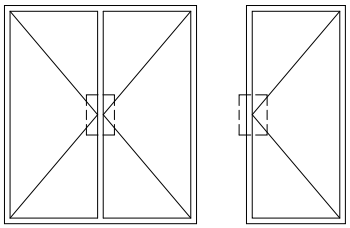
1) Impugnatura
2) Rosetta
3) Corpo maniglia
4) Vite TPS 3.9x15.9
5) Quadro

AC5002 :

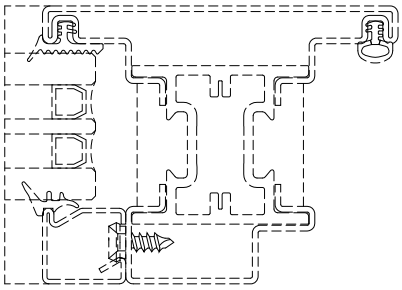
1) Handle grip
2) Rose
3) Handle body
4) Countersunk head screws 3.9x15.9
5) Spindle bar

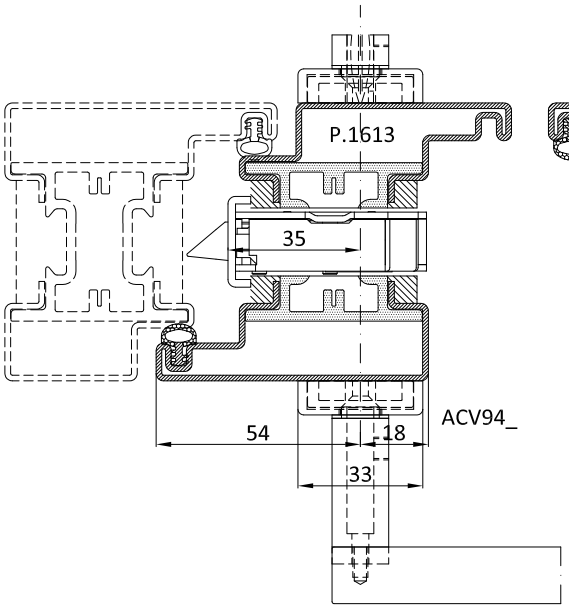


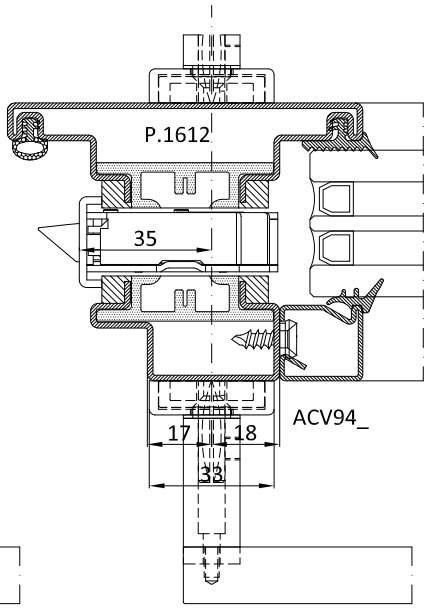


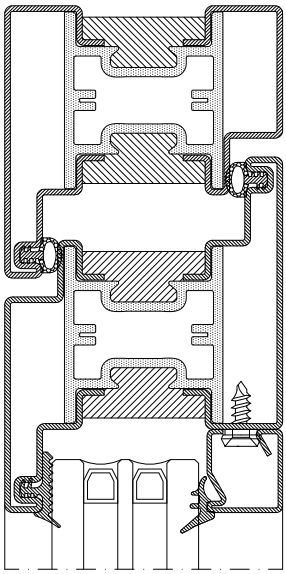


destra _ *right*
Lavorazione speculare per anta SX
Same working for left hand







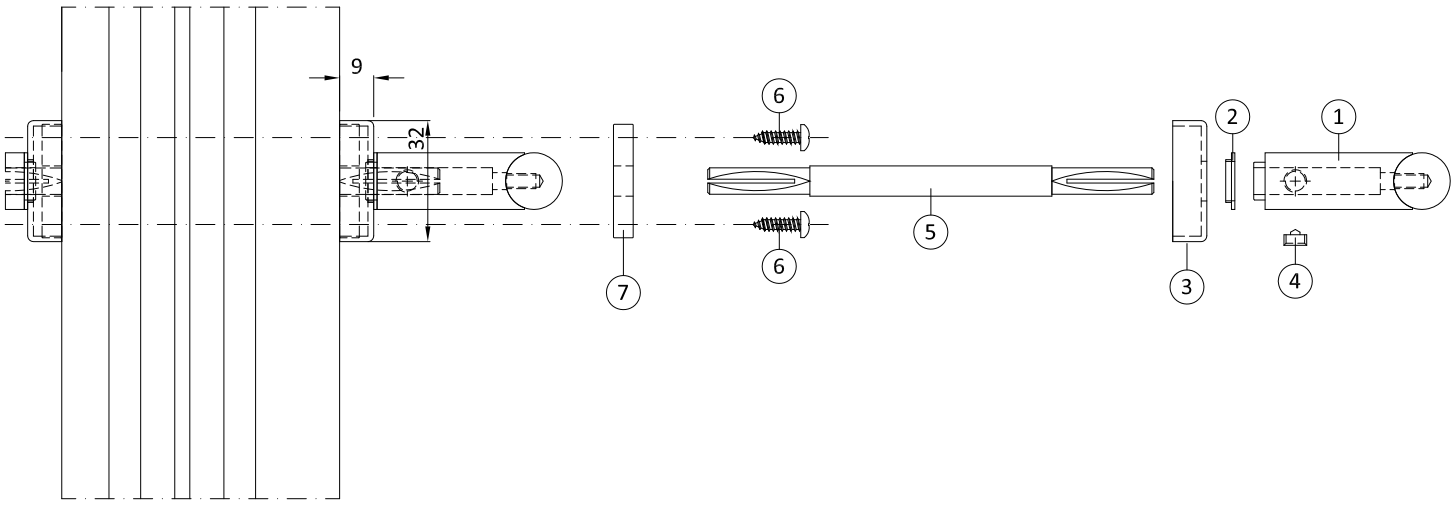


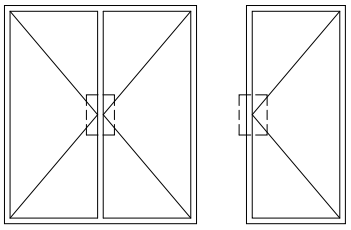
ACV94- :

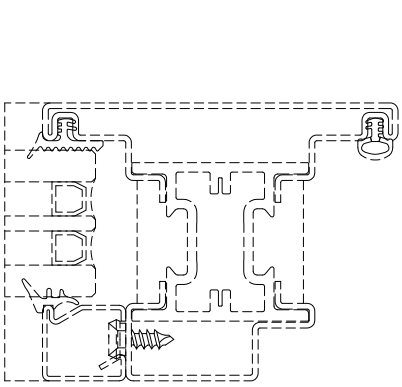
1) Impugnatura
2) Rondella
3) Rosetta
4) Grano M6x6
5) Quadro
6) Vite TC 3.5x12.7
7) Molla

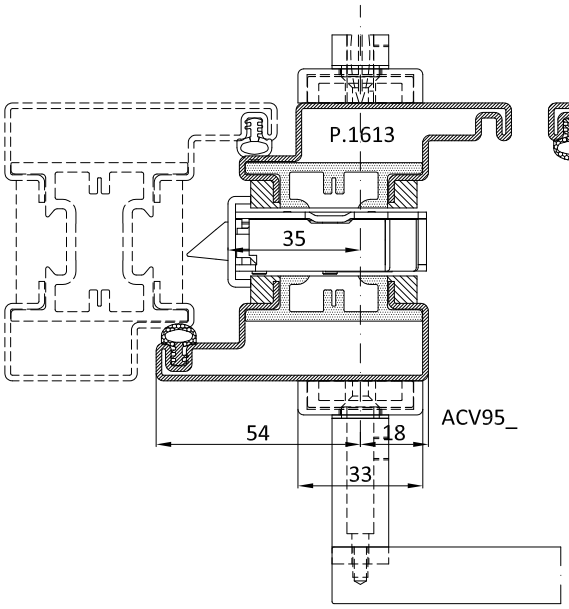
ACV94- :

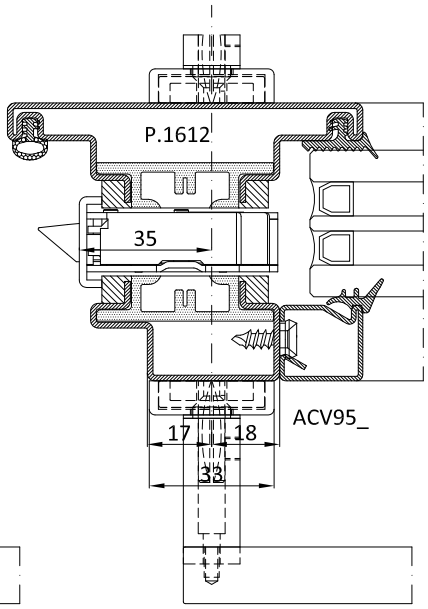
1) Handle grip
2) Ring
3) Rose
4) Dowel M6x6
5) Spindle bar
6) Flat head screws 3.5x12.7
7) Spring

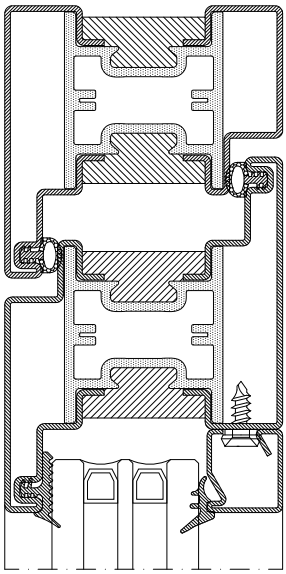










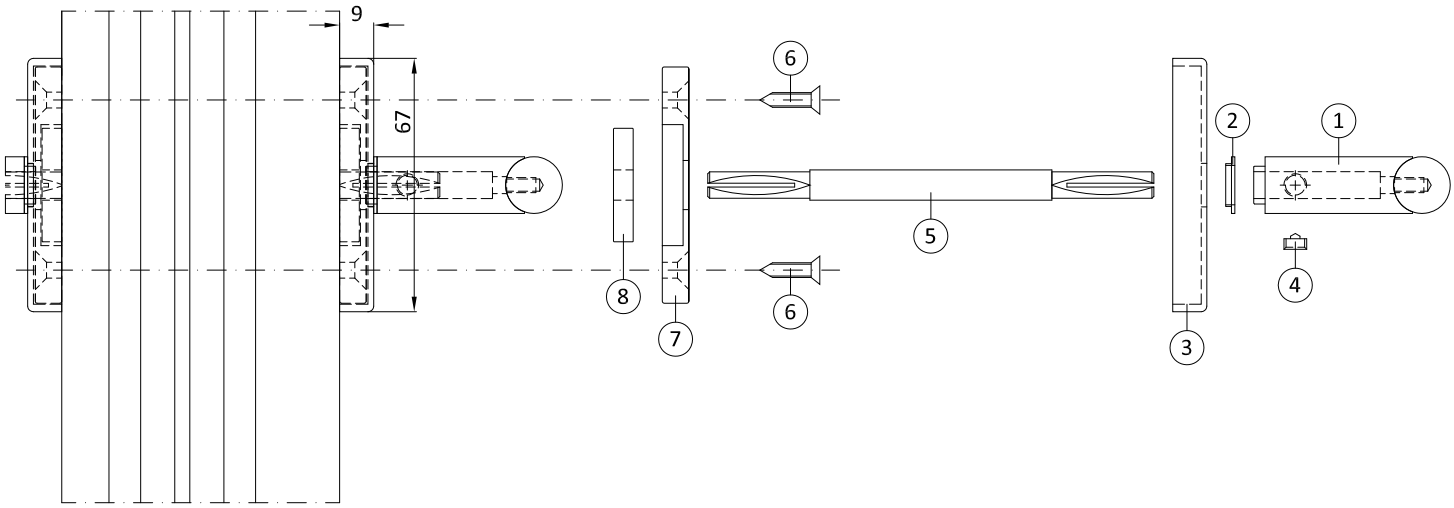


ACV95- :

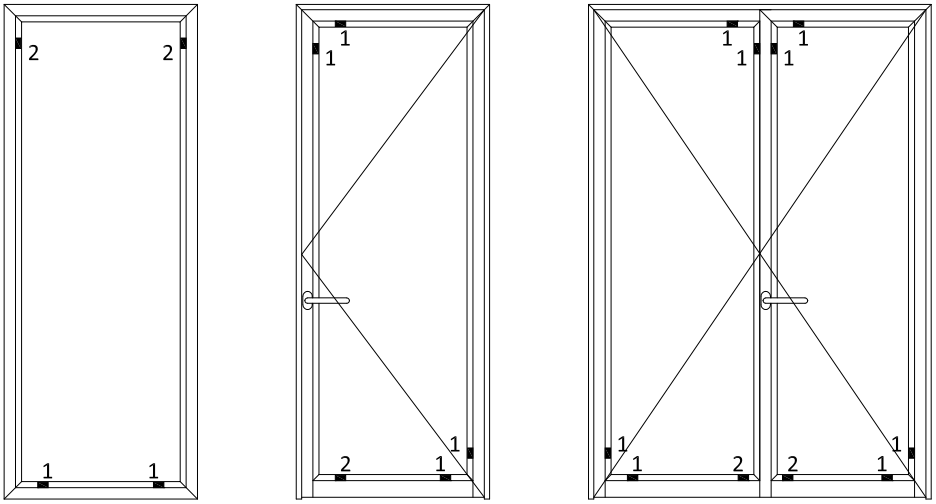
1) Impugnatura
2) Rondella
3) Rosetta
4) Grano M6x6
5) Quadro
6) Vite TPS 3.9x15.9
7) Adattatore per molla
8) Molla

ACV95- :

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

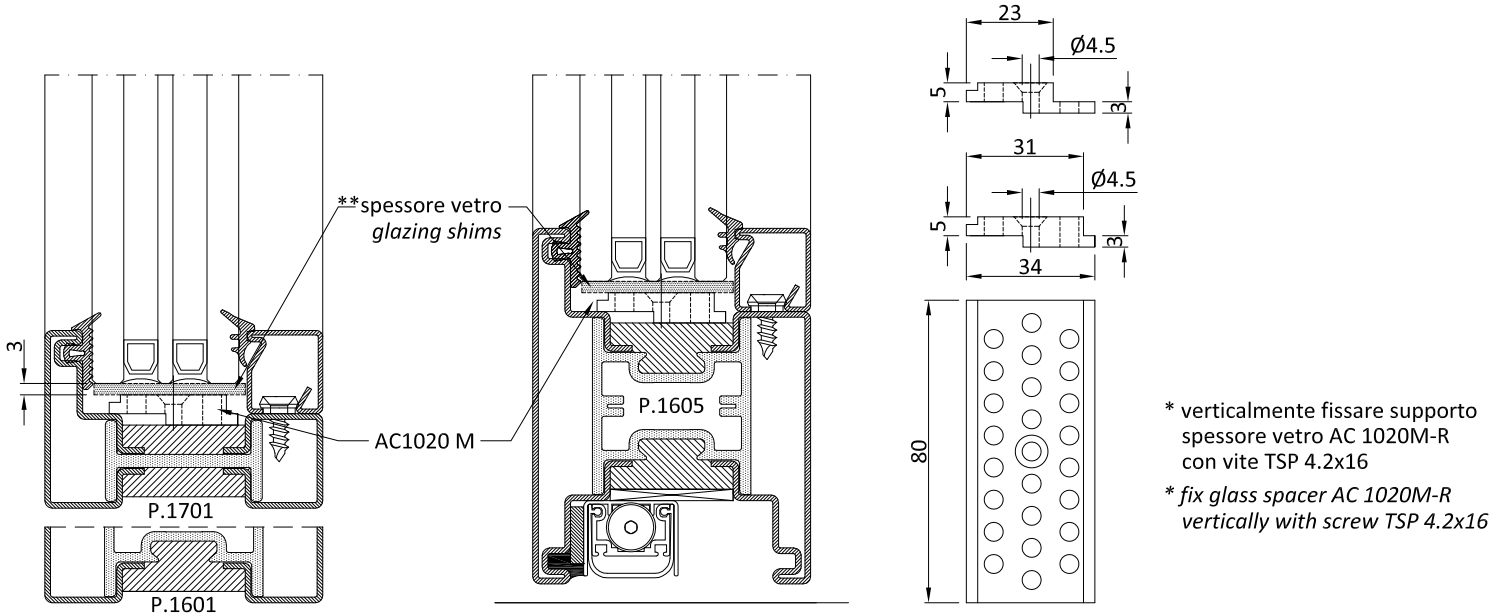


Porta | Door



1) spessore portante | *carry shim*

2) spessore distanziatore | *compensation shim*



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

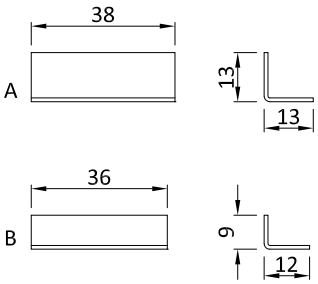
** fix glass spacer AC 1020M-R vertically with screw TSP 4.2x16*

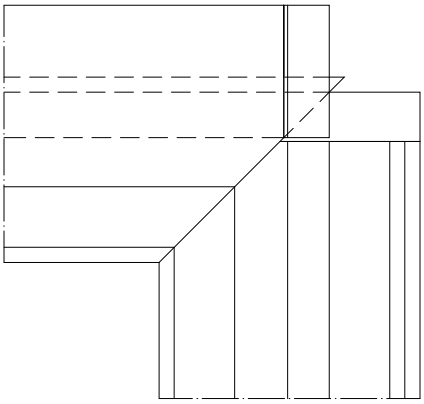
Note / *Note*

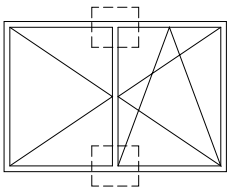
- La larghezza degli spessori è almeno pari o maggiore (+2 mm) dello spessore del vetro installato.
- La posizione degli spessori deve essere garantita dall'utilizzo di materiale adeguato che ne eviti lo spostamento.

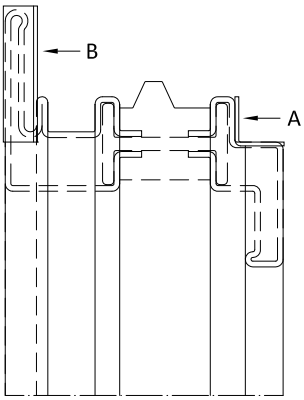
- The shims' width is the same or greater (+2 mm) than the thickness of the glass installed.
- The position of the shims has to be ensured by using appropriate material that avoids creeping.

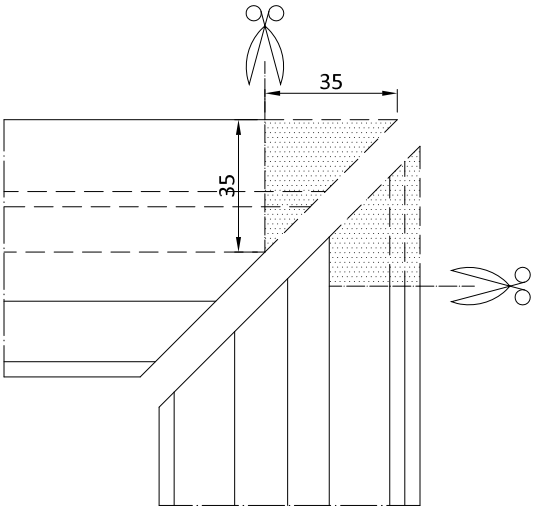
* vite TSP 4.2 x 16 mm non inclusa - *screw TSP 4.2 x 16 mm not included*

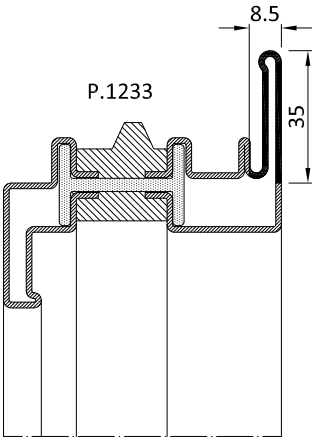


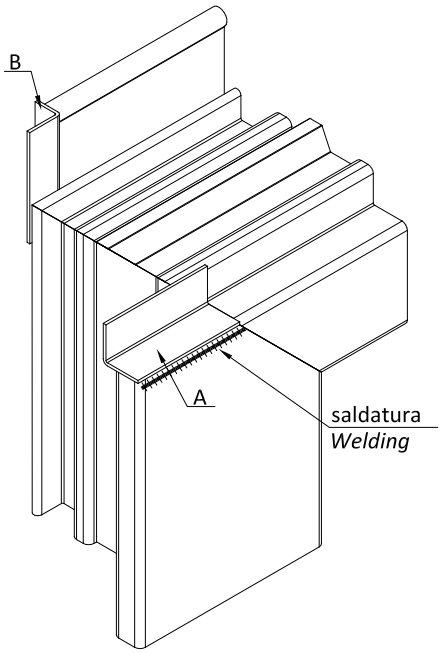


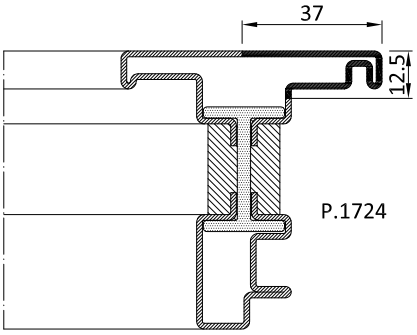


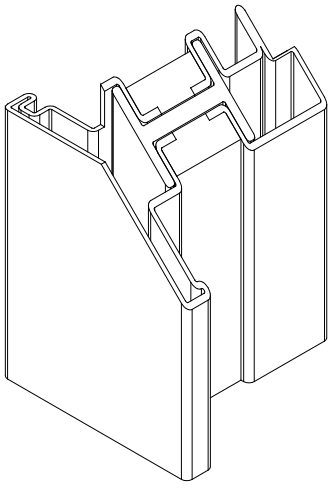


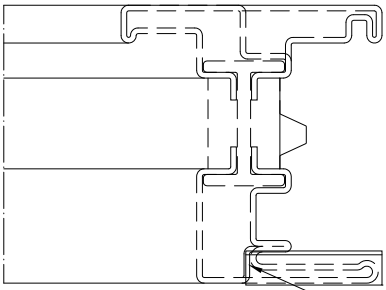




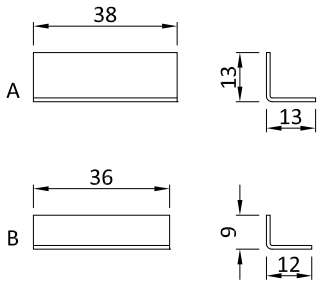


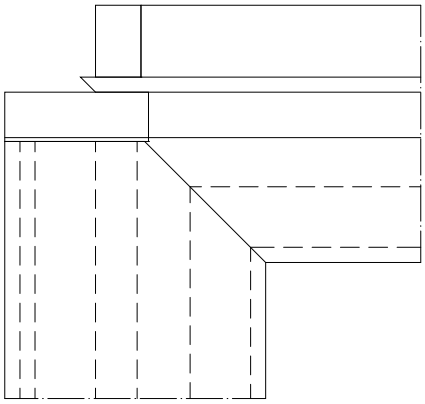


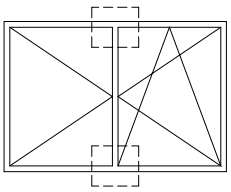


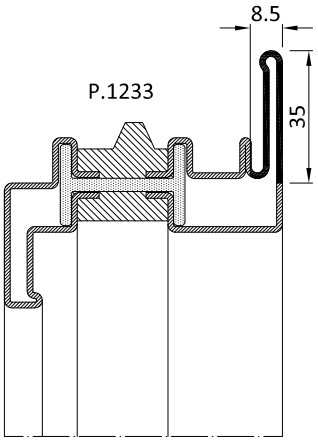


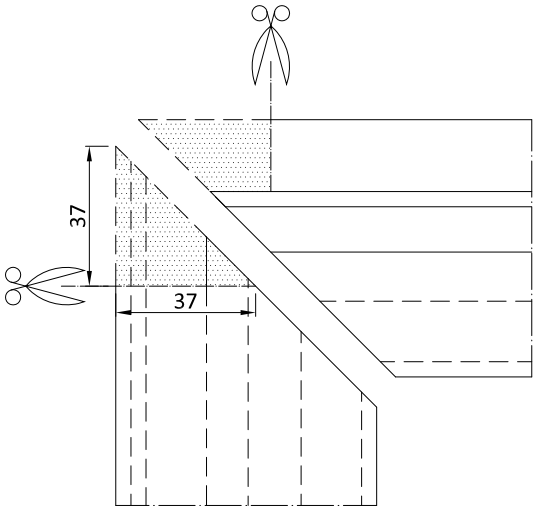
Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura.
Note: the ending caps for T-Z joint are furnished in larger dimensions and should be trimmed down after welding.

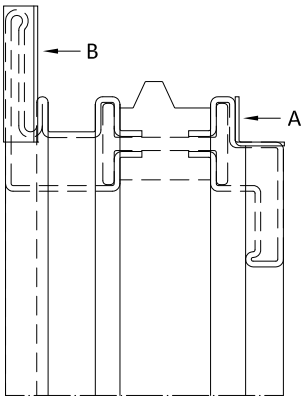


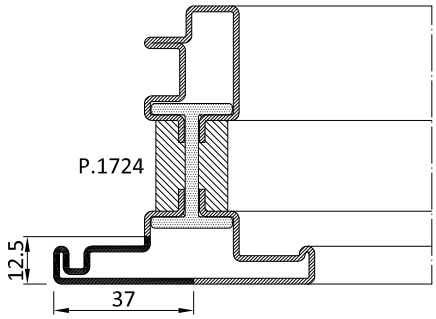


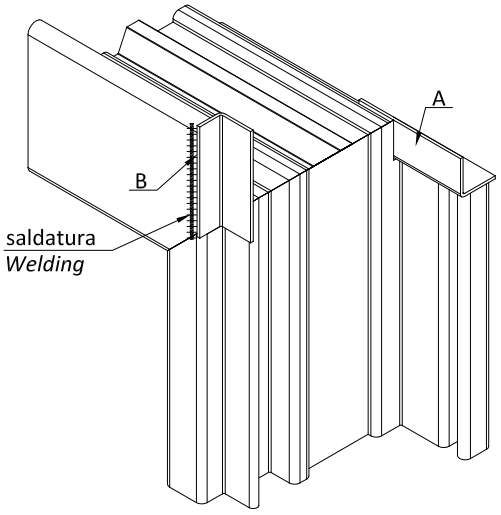


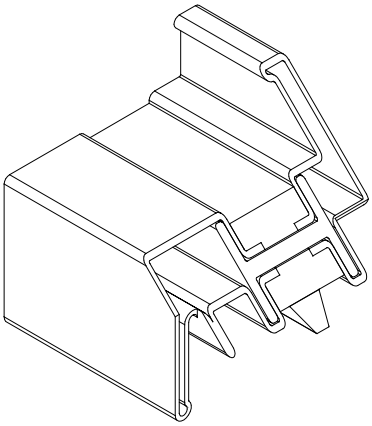






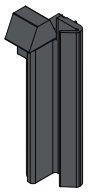




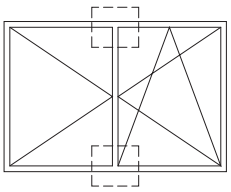


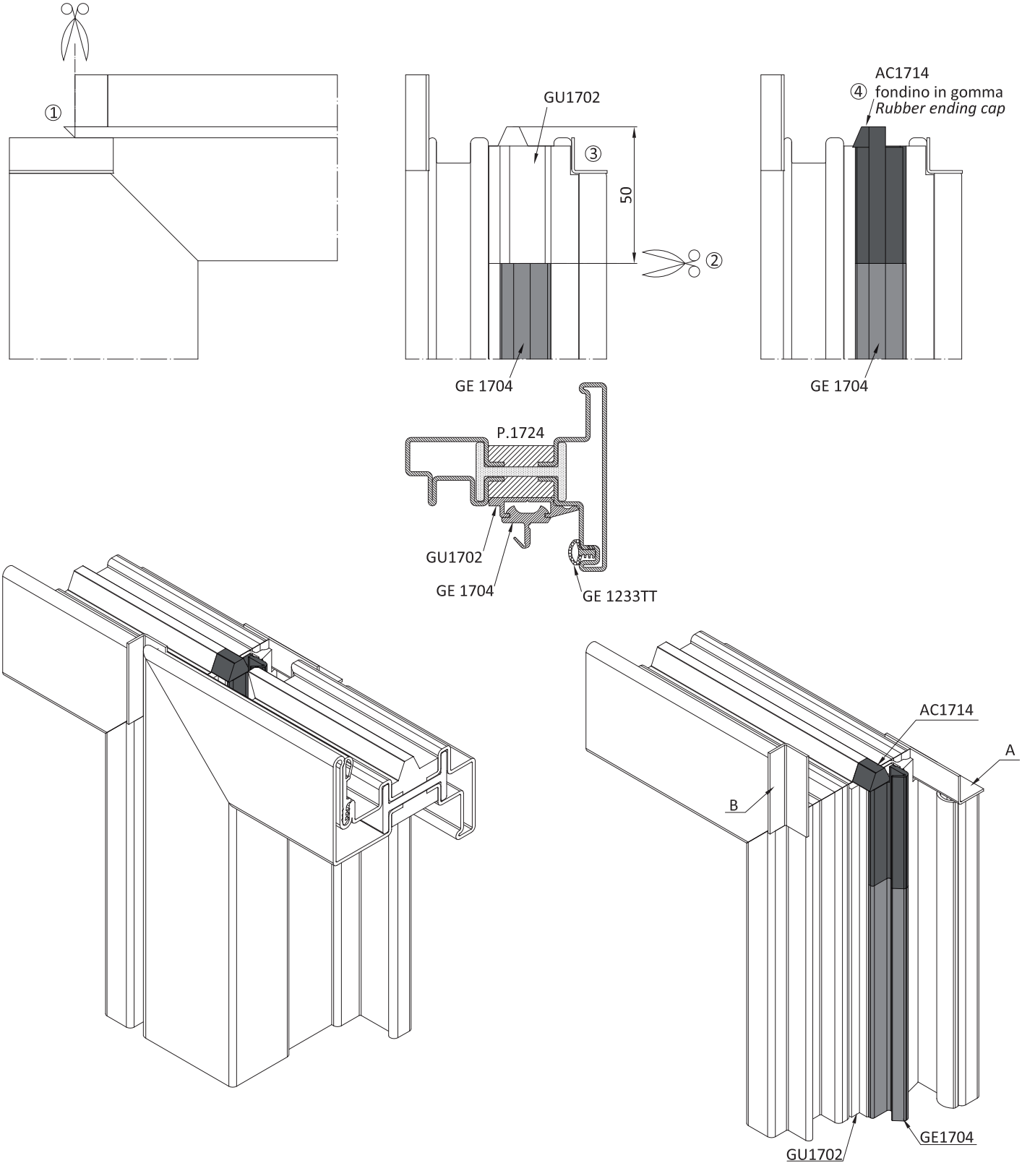
Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura.
Note: the ending caps for T-Z joint are furnished in larger dimensions and should be trimmed down after welding.

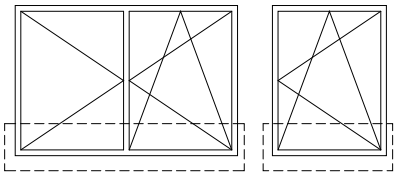
1) Asportare il poliammide.
1) Remove the polyamide.
2) Tagliare la guarnizione GE1704 a 50 mm. dal filo esterno del polliamide.
2) Cut the gasket GE1702 at 50 mm from the end thread of polyamide.
3) Asportare la la parte dell'estruso GU1702 che interferisce con il fondino A.
3) Remove the part of the extrudate GU17021 that interferes with the rubber ending cap A.
4) Posizionare il fondino di gomma ed incollarlo alla guarnizione GE1701 a mezzo di colla ciano-acrilica.
4) Position the rubber ending cap and stick it to the gasket GE1701 with cyano-acrylic glue

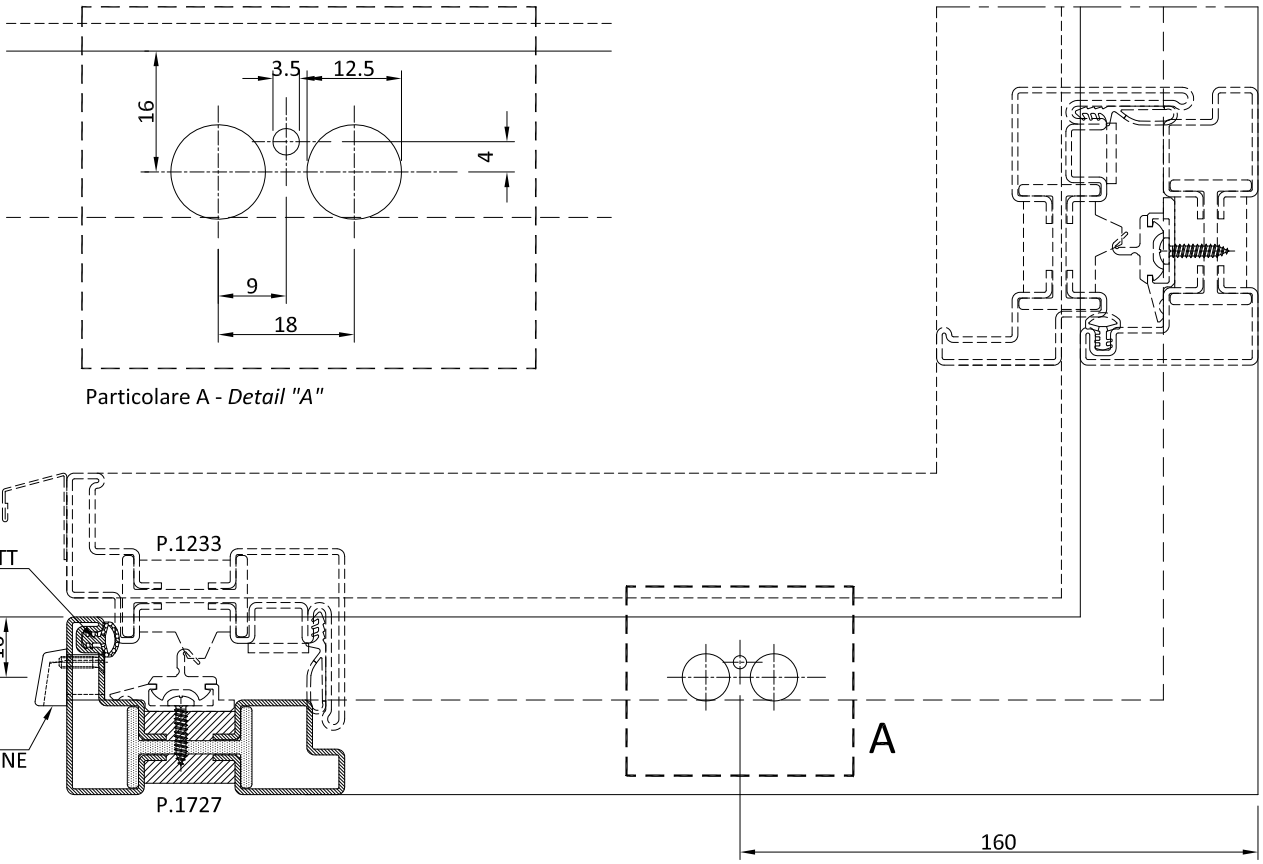


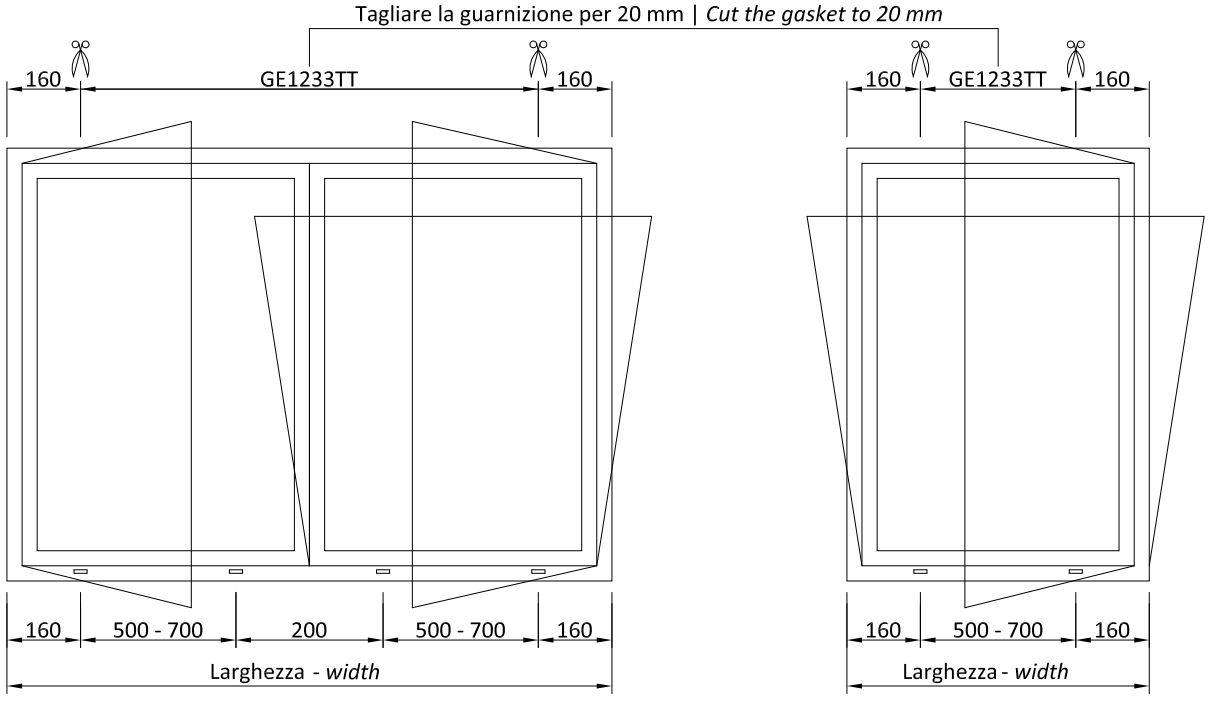
AC1714








3.5
12.5
16
4
9
18
Particolare A - *Detail "A"*
GE1233TT
P.1233
16
AC 1219
AC 1219NE
P.1727
A
160


Tagliare la guarnizione per 20 mm | *Cut the gasket to 20 mm*
160
GE1233TT
160
160
500 - 700
200
500 - 700
160
Larghezza - *width*
160
GE1233TT
160
160
500 - 700
160
Larghezza - *width*

1) Eseguire i fori come da disegno .

2) Posizionare lo scarico acqua e sigillare fissare con viti in dotazione M3x12.

3) Posizionare il supporto della guarnizione di giunto GU1702 e fissarlo con vite TC 3.5x13 (non fornita).

4) Sigillare la guarnizione di giunto GE1701 con il supporto GU1702 per tutta lunghezza e per 200 mm in altezza sul telaio.

5) Posizionare la guarnizione di giunto centrale GE1701 e gli angoli vulcanizzati AC1716, incollare gli angoli alla guarnizione a mezzo di colla ciano-acrilica.

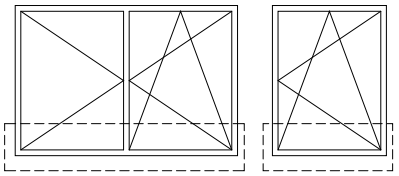
1) Drill the holes according to drawing .

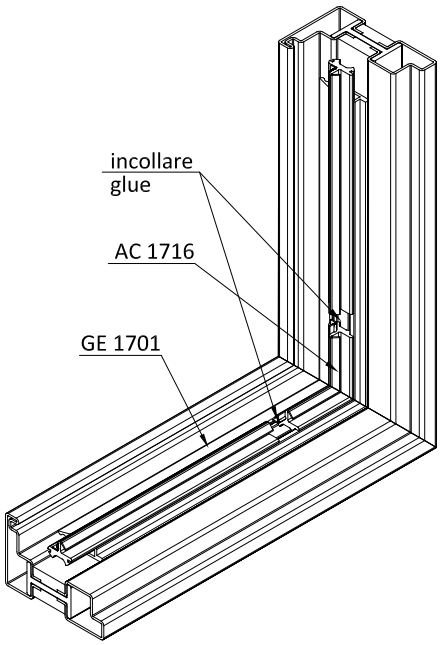
2) Install the water drip accessory, seal and secure with the supplied M3x12 screw.

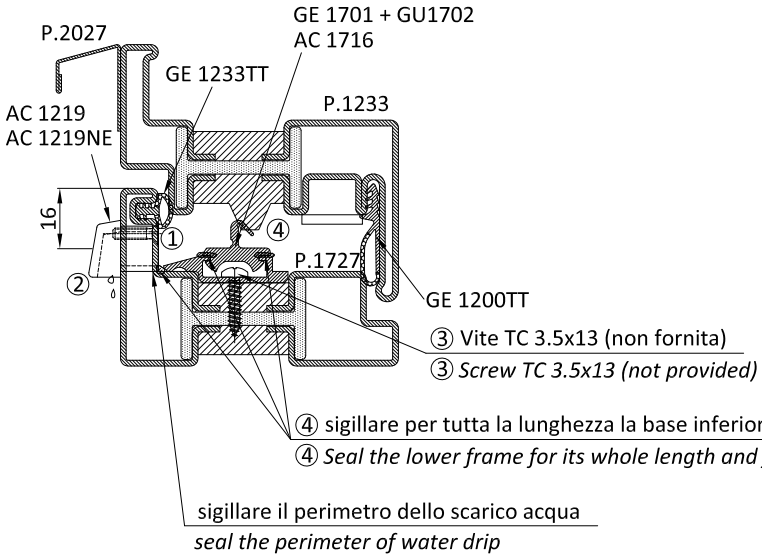
3) Position the support of the weather strip GU1702 and anchor it with the double-sided adhesive tape provided and screws TC 3.5x13 *(not provided).*

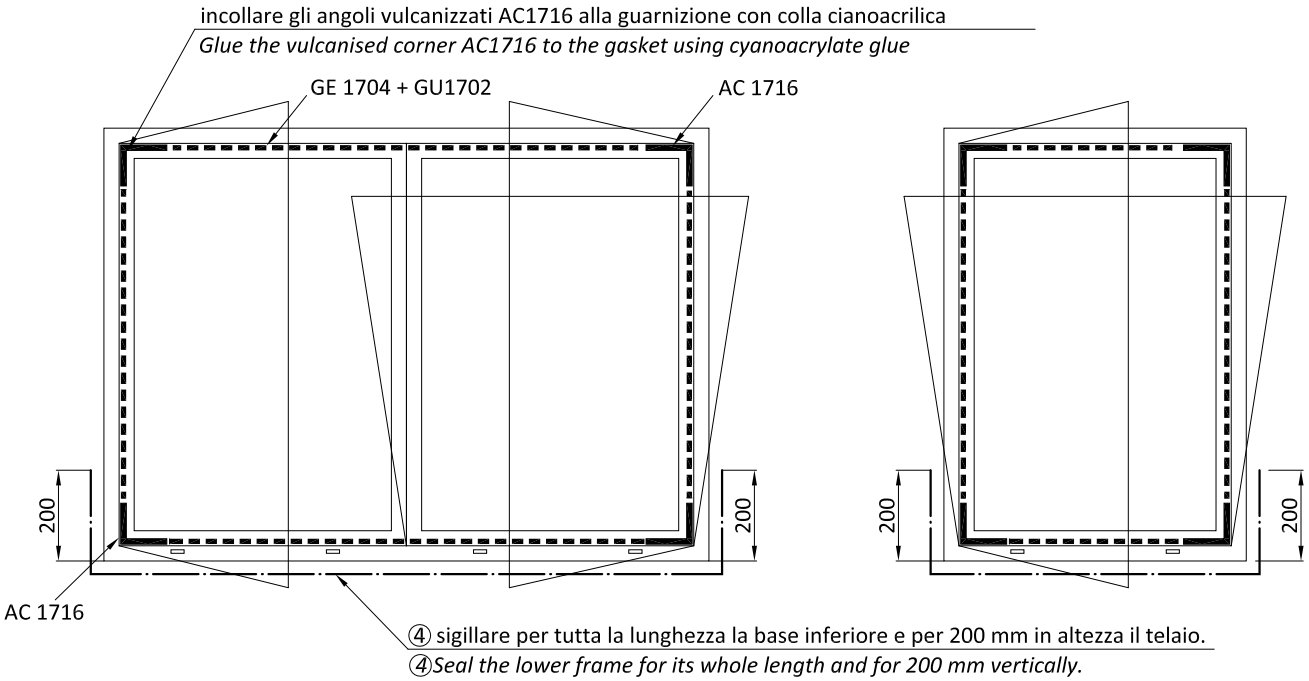
4) Seal the weather strip GE1701 with the support GU1702 for the whole length and for 200 mm vertically on the frame.

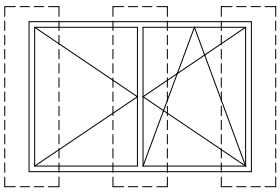
5) Install the central weather strip GE1701 and the vulcanised corners AC1716, glue the corners to the weather strip using cyanoacrylate glue.

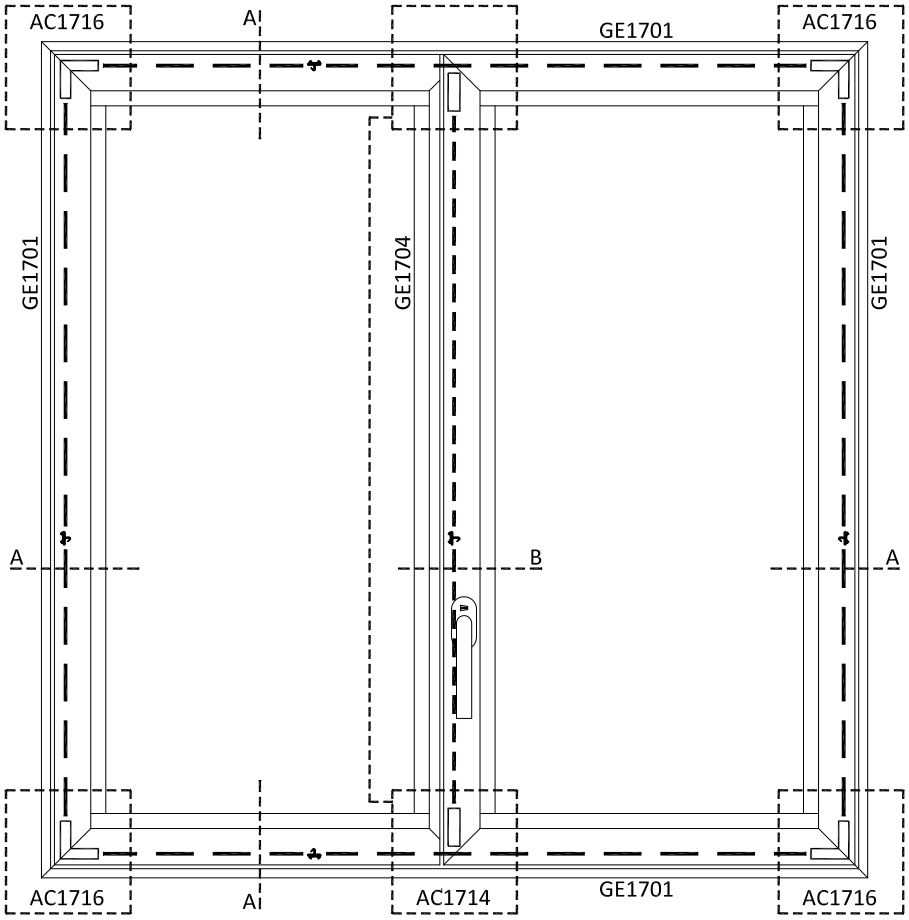


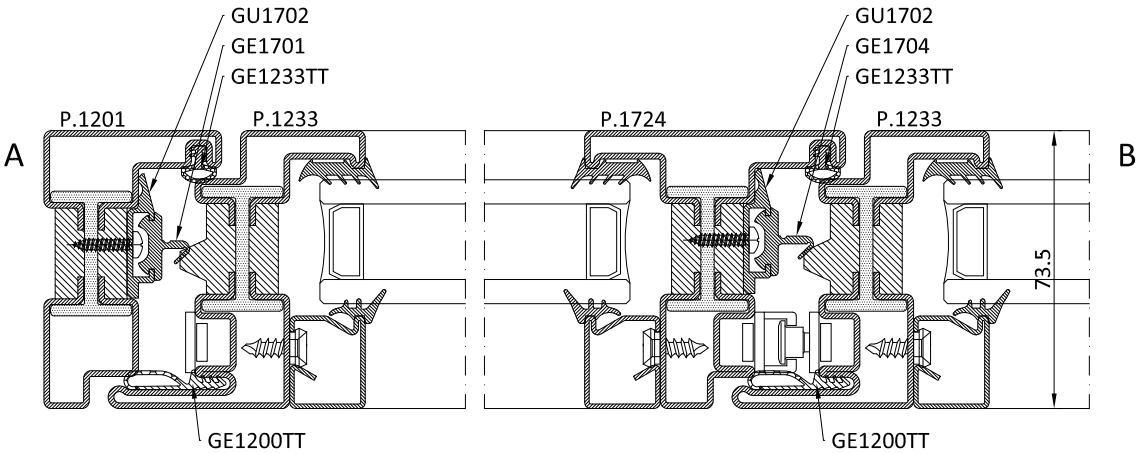


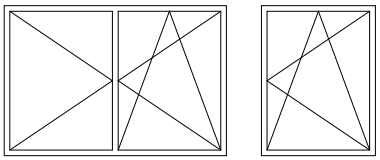


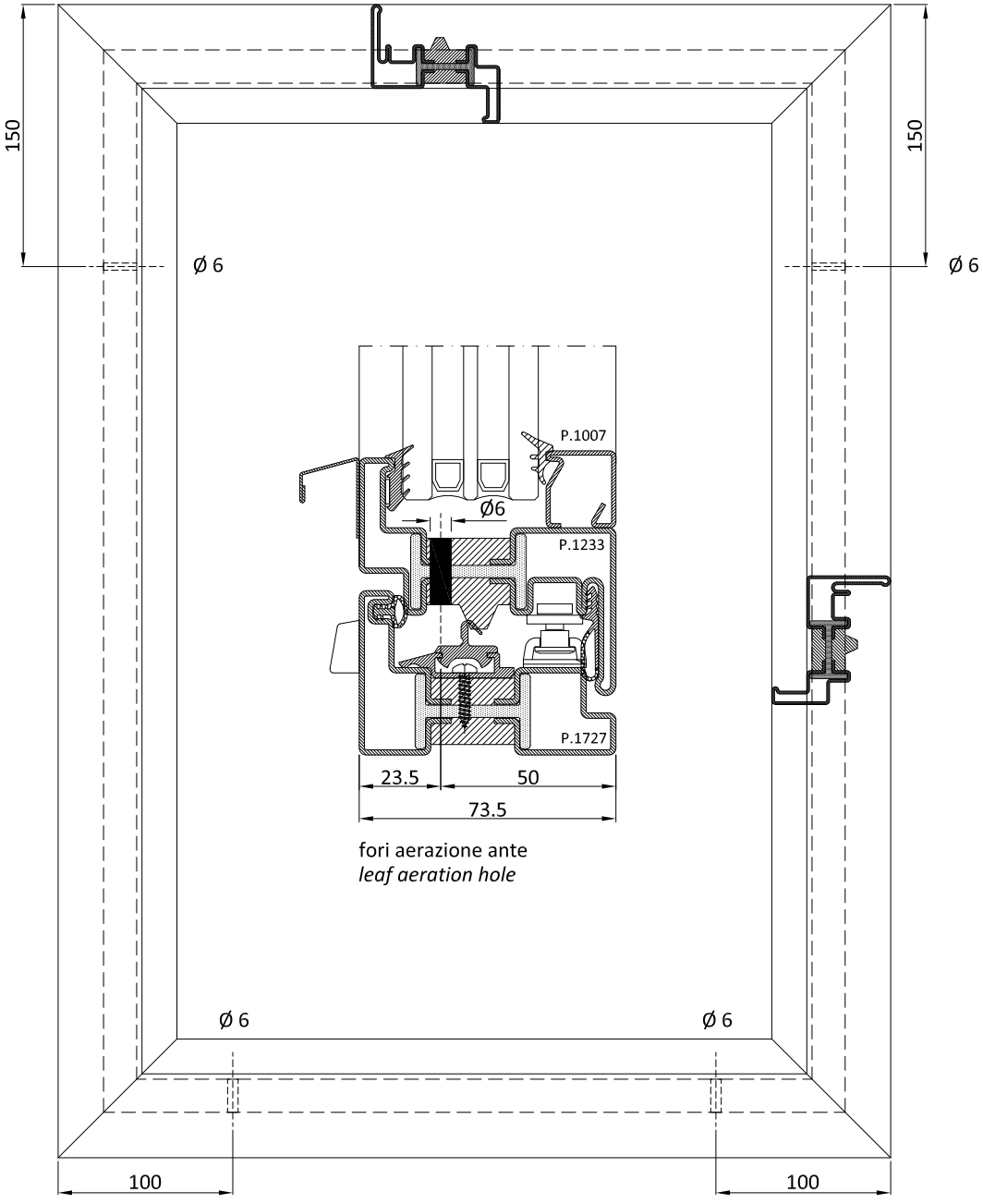




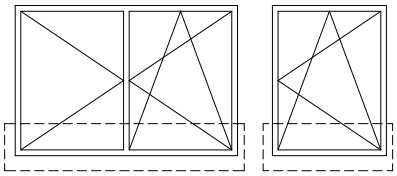

AC1716
A
GE1701
AC1716
GE1701
GE1704
GE1701
A
B
A
AC1716
A
AC1714
GE1701
AC1716

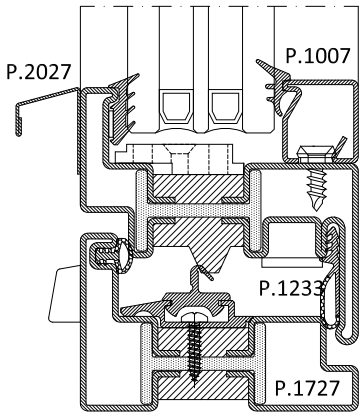

GU1702
GE1701
GE1233TT
P.1201
P.1233
A
GE1200TT
GU1702
GE1704
GE1233TT
P.1724
P.1233
B
73.5
GE1200TT

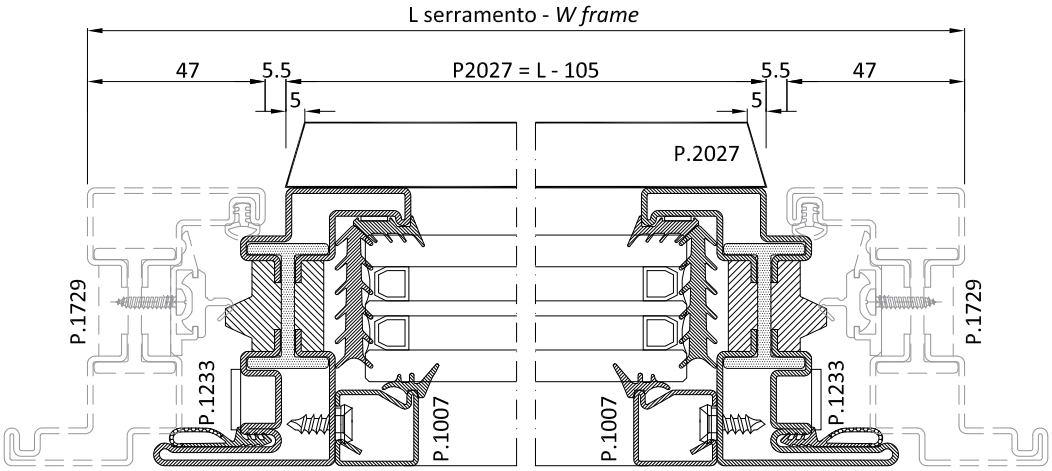


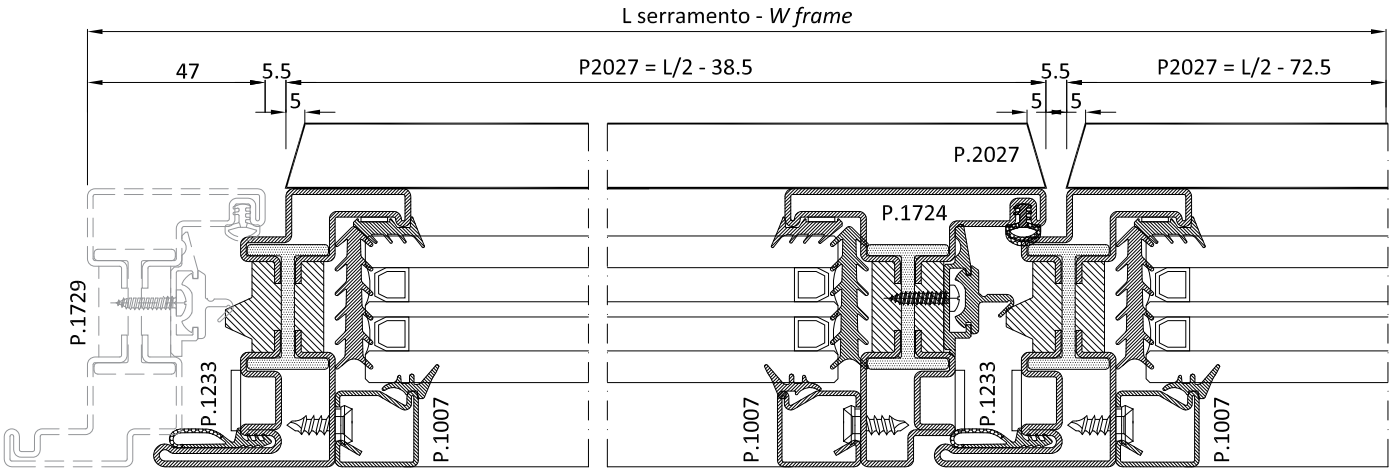


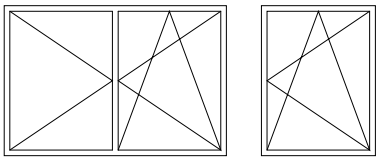
fori aerazione ante
leaf aeration hole




P.2027
P.1007
P.1233
P.1727

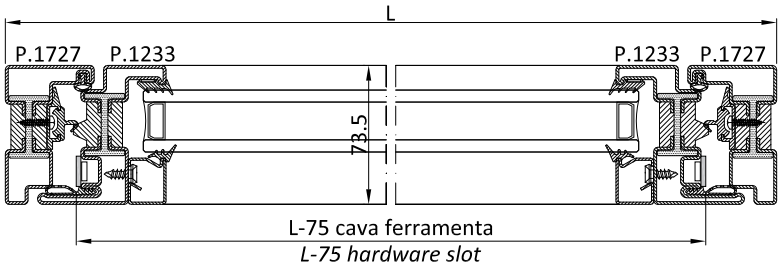

L serramento - *W frame*
47
5.5
5
P2027 = L - 105
5.5
5
47
P.2027
P.1729
P.1729
P.1233
P.1233
P.1007
P.1007

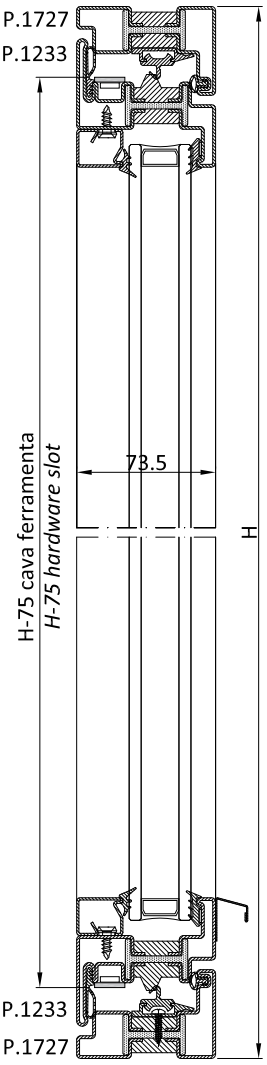

L serramento - *W frame*
47
5.5
5
P2027 = L/2 - 38.5
5.5
5
5
P2027 = L/2 - 72.5
P.2027
P.1724
P.1729
P.1233
P.1007
P.1007
P.1233
P.1007

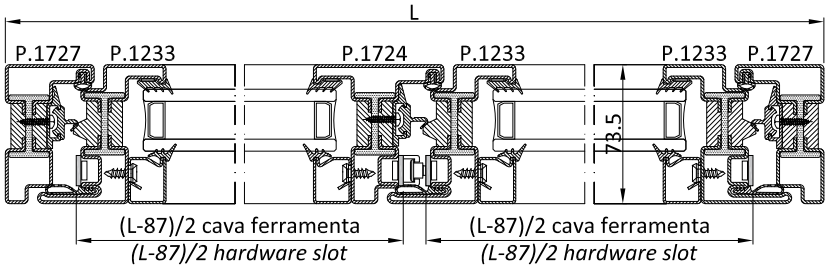


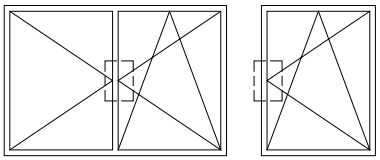
Standard		H altezza - *Height*								
		661 860	861 1000	1001 1200	1201 1400	1401 1600	1601 1800	1801 2000	2001 2200	2201 2400
L|W larghezza *width*	601-800	A1	B1	C1	D1	E1	F1	G1	H1	I1
	801-1000	-	B2	C2	D2	E2	F2	G2	H2	I2
	1001-1200	-	-	C3	D3	E3	F3	G3	H3	I3
	1201-1400	-	-	-	D4	E4	-	-	-	-

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



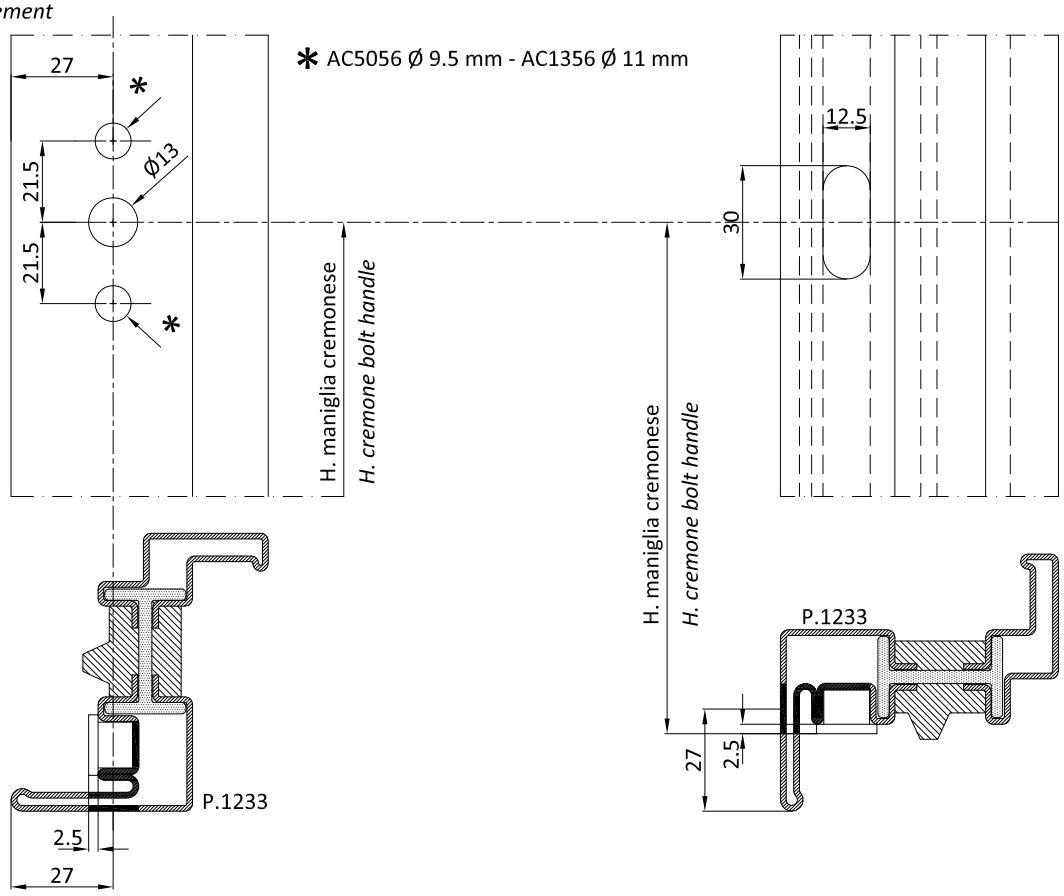






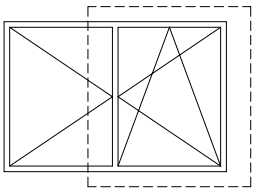
Fori per inserimento quadro comando e fissaggio maniglia / movimento DK
Holes for inserting control panel and anchoring of handle / TT (tilt and turn) movement

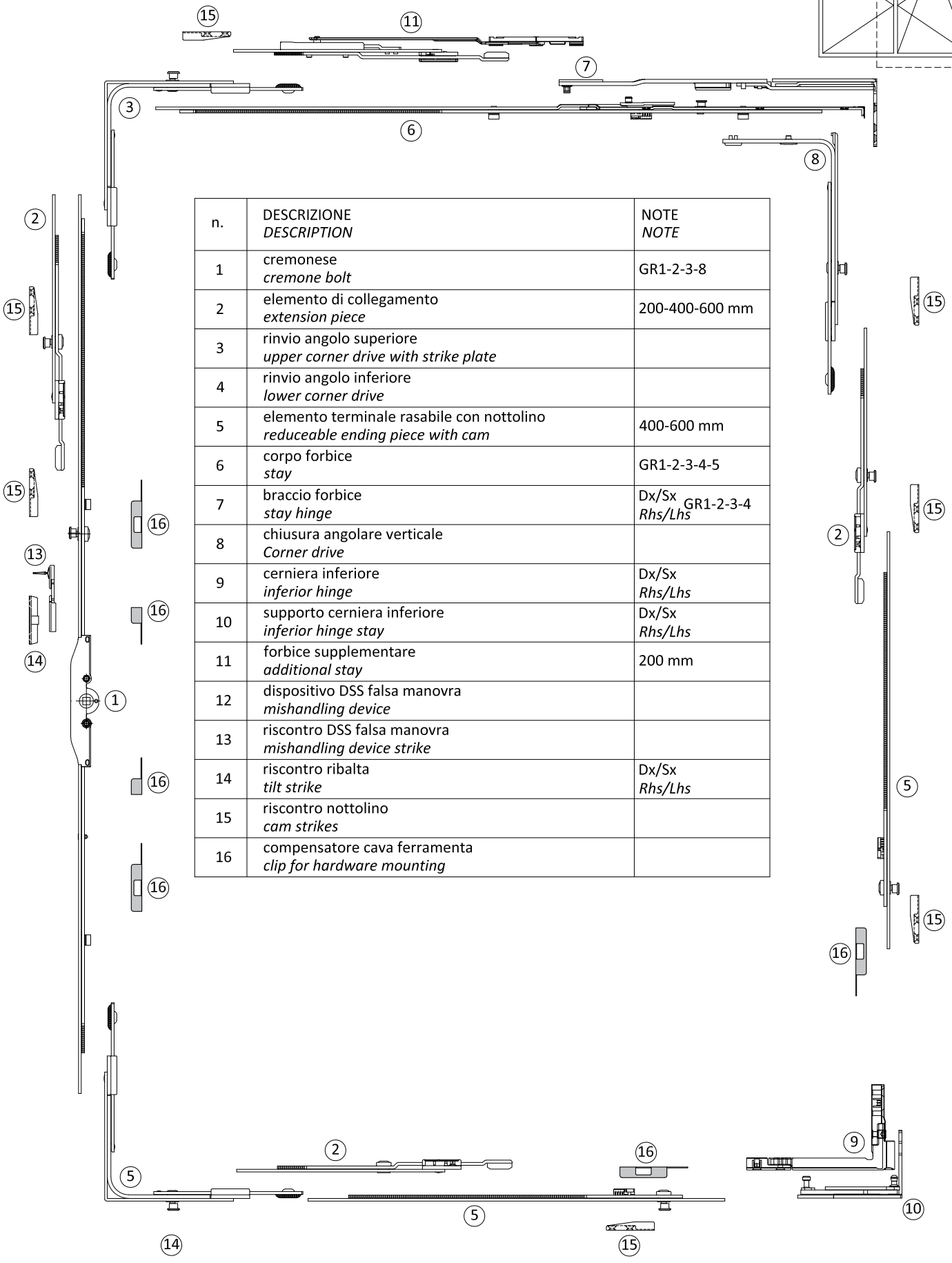
Asola per inserimento meccanismo cremonese
Slot for insertion of cremone mechanism



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

STANDARD peso massimo anta 130 kg
maximum leaf weight 130 kg

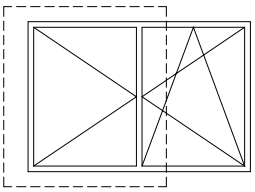


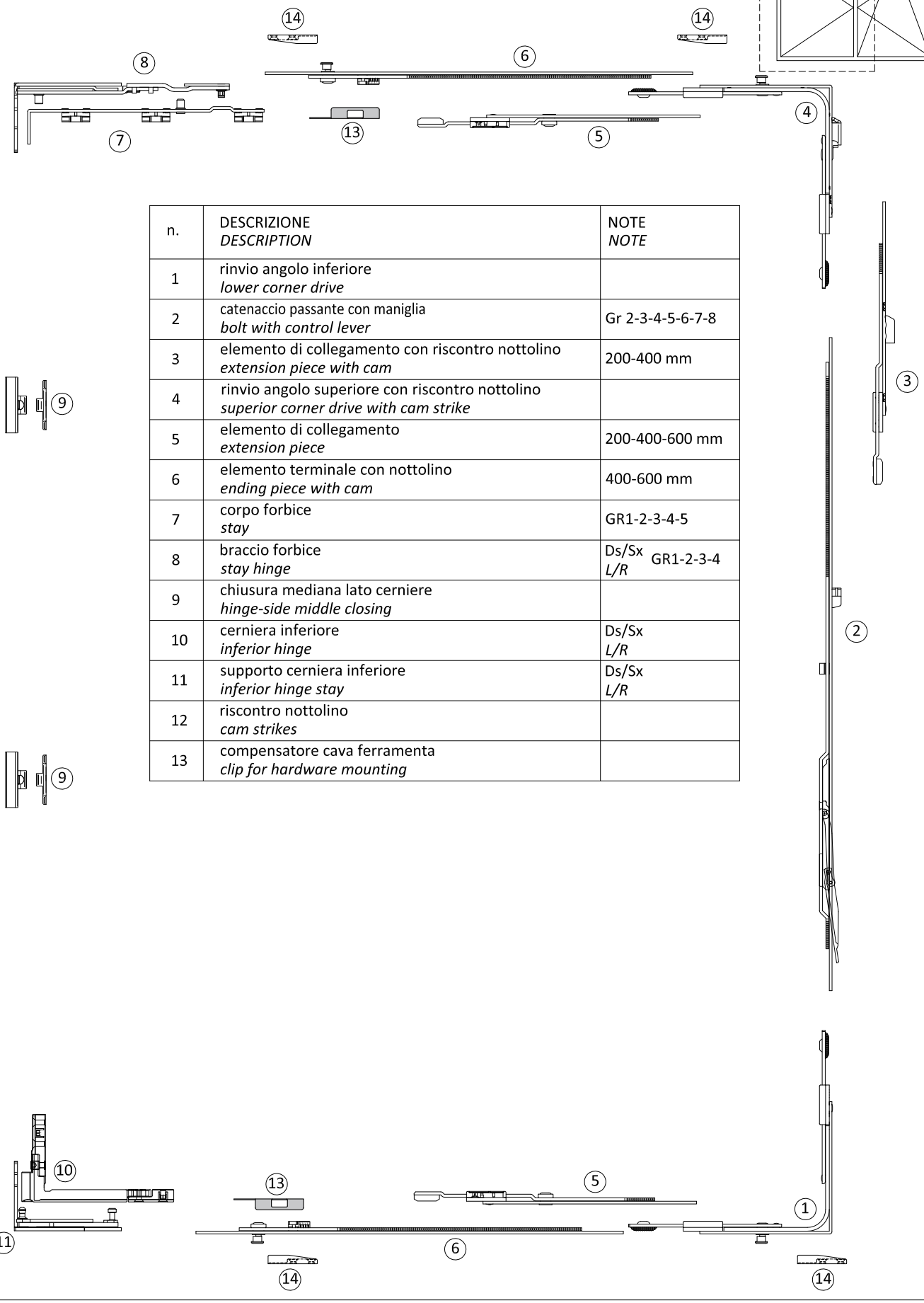


n.	DESCRIZIONE *DESCRIPTION*	NOTE *NOTE*
1	cremonese *cremone bolt*	GR1-2-3-8
2	elemento di collegamento *extension piece*	200-400-600 mm
3	rinvio angolo superiore *upper corner drive with strike plate*	
4	rinvio angolo inferiore *lower corner drive*	
5	elemento terminale rasabile con nottolino *reduceable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

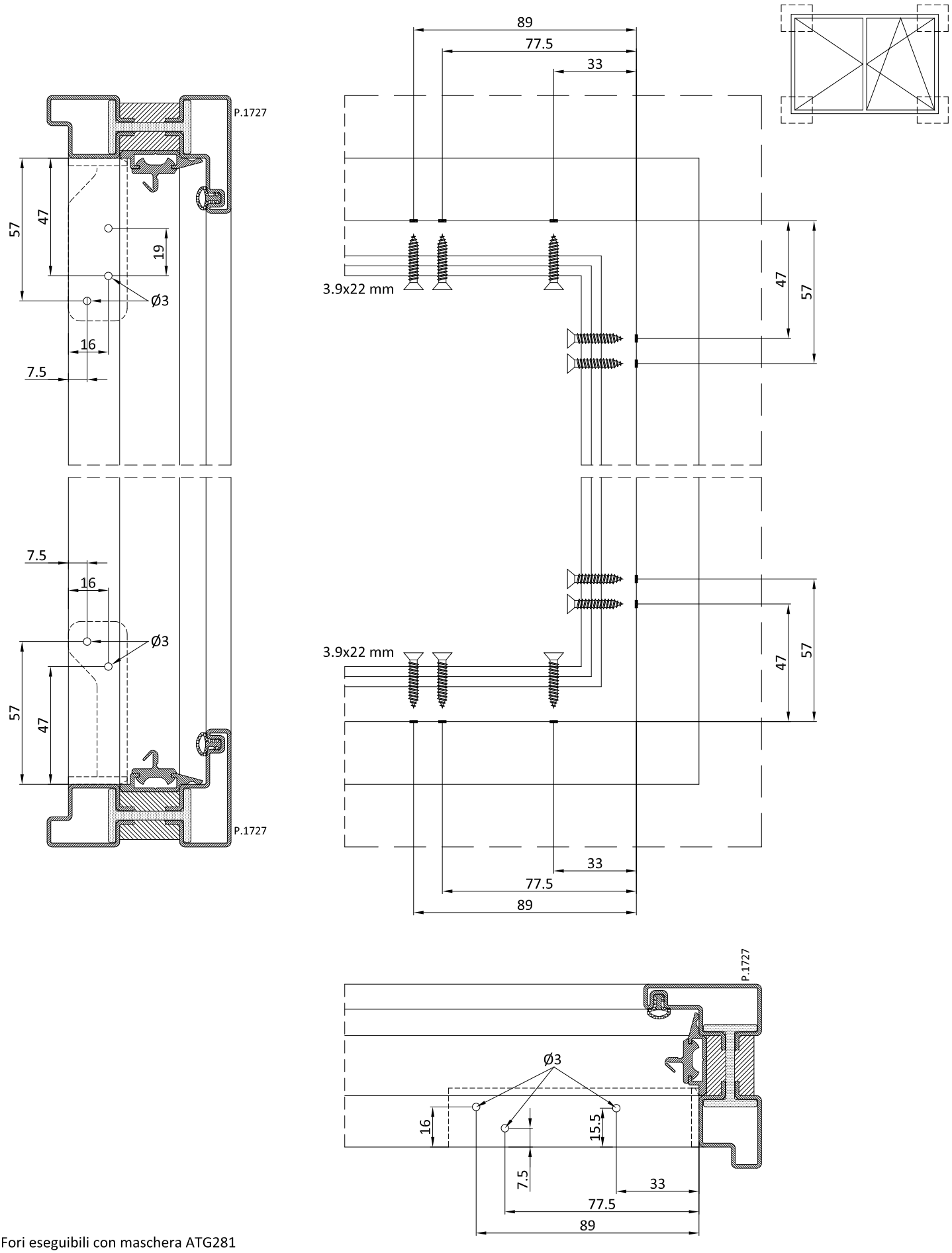
STANDARD

peso massimo anta 130 kg
maximum leaf weight 130 kg

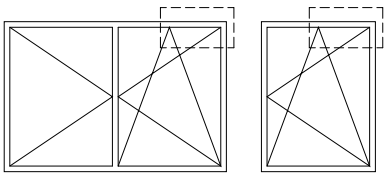


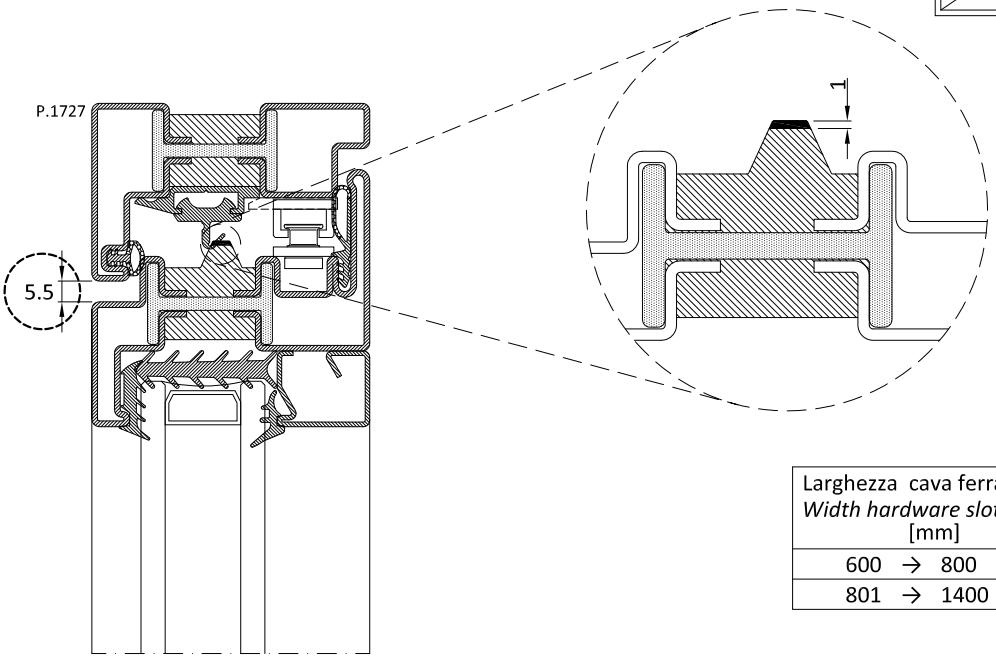


n.	DESCRIZIONE *DESCRIPTION*	NOTE *NOTE*
1	rinvio angolo inferiore *lower corner drive*	
2	catenaccio passante con maniglia *bolt with control lever*	Gr 2-3-4-5-6-7-8
3	elemento di collegamento con riscontro nottolino *extension piece with cam*	200-400 mm
4	rinvio angolo superiore con riscontro nottolino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

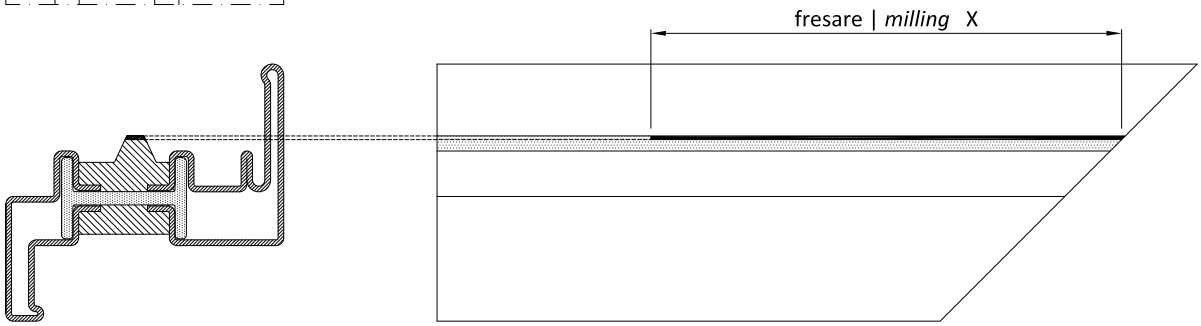


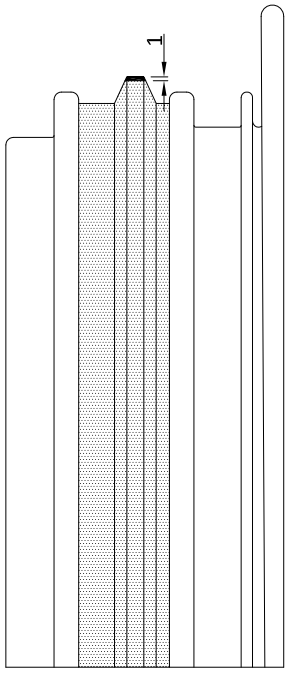
Fori eseguibili con maschera ATG281
Holes to be done with ATG281

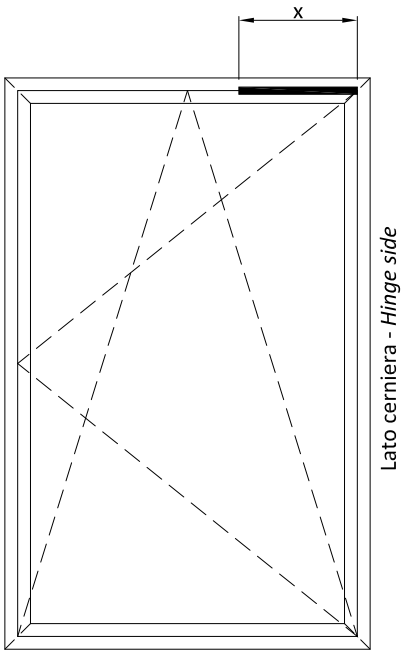


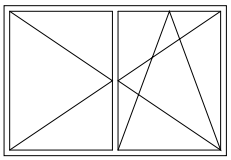


Larghezza cava ferramenta *Width hardware slot* [mm]	X [mm]
600 → 800	200
801 → 1400	280





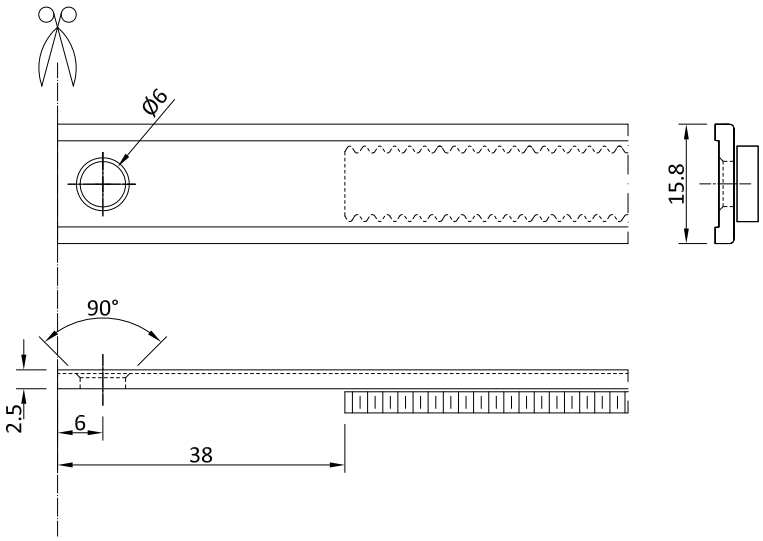


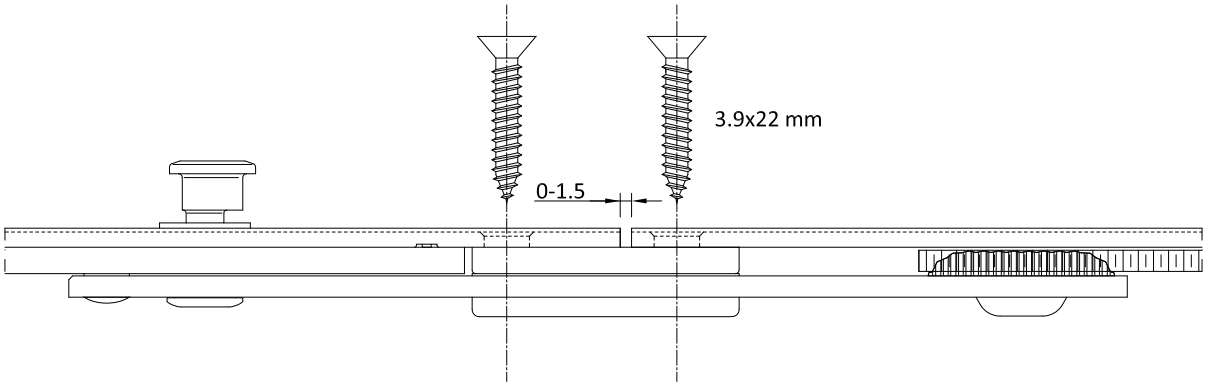


Lavorazione da eseguire sui componenti rasabili della ferramenta
Working on the cuttable pieces of the hardware

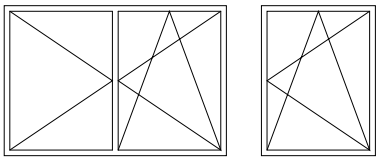
1 - Eseguire taglio della ferramenta sfalsato
2 - Eseguire foro e svasatura

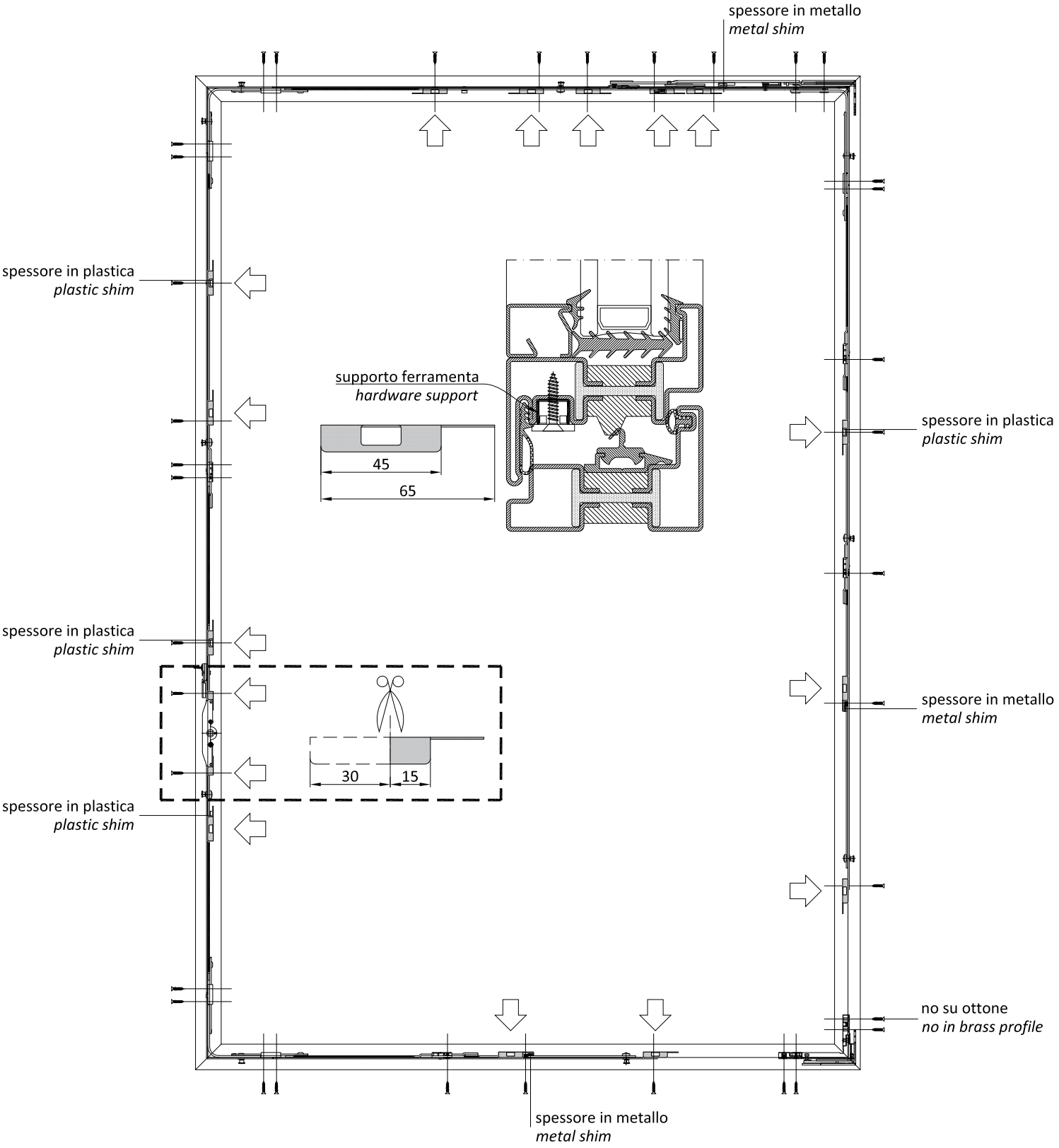
1 - Cutting of the hardware
2 - Hole drilling and countersink



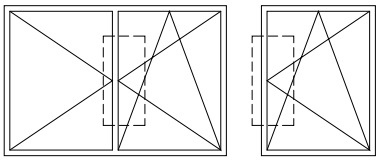


Lavorazione eseguibile con trancia ATG 311 o ATG 312
Tooling possible with punching machine ATG 311 or ATG 312

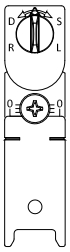


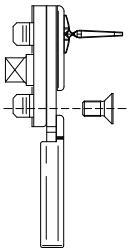


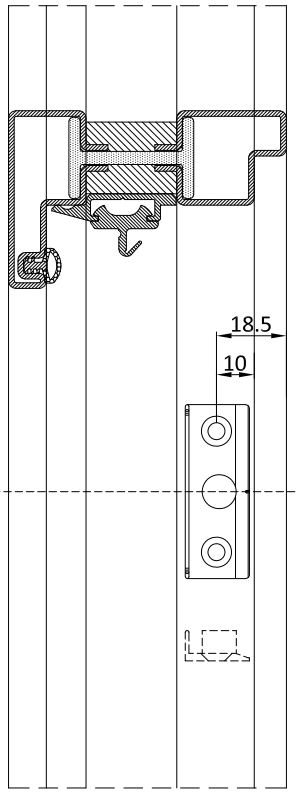
viti | *screws* TPS 3.9x22 mm

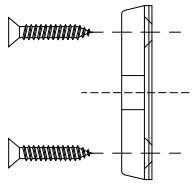


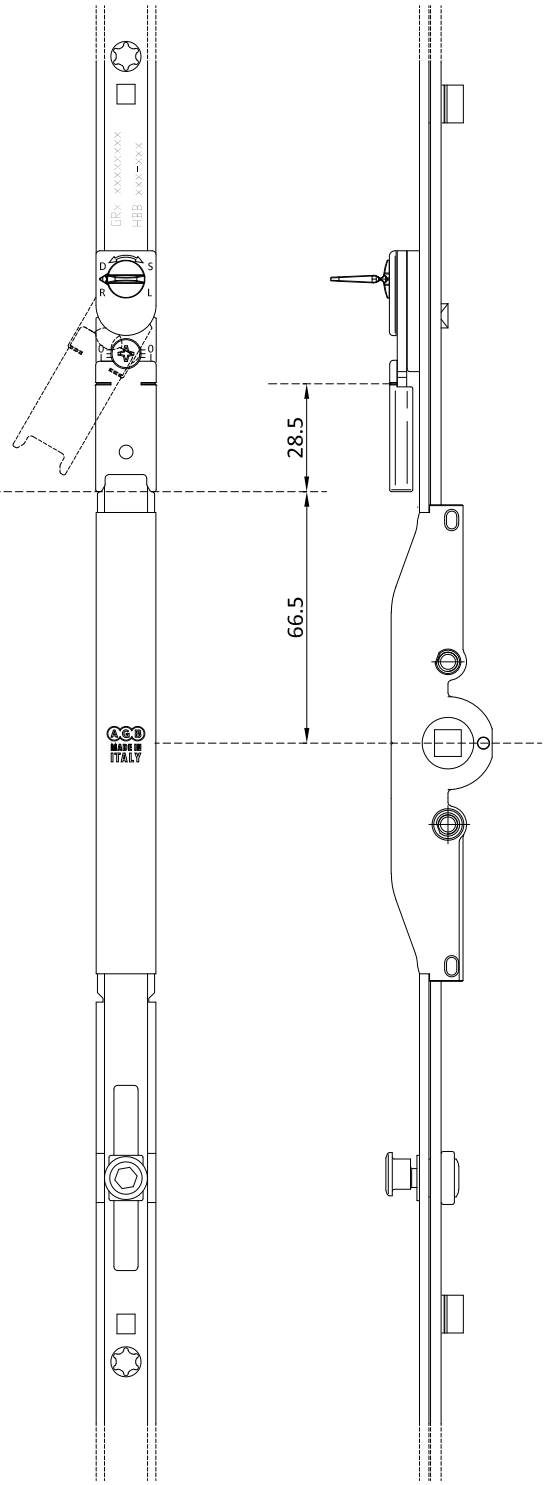
DSS



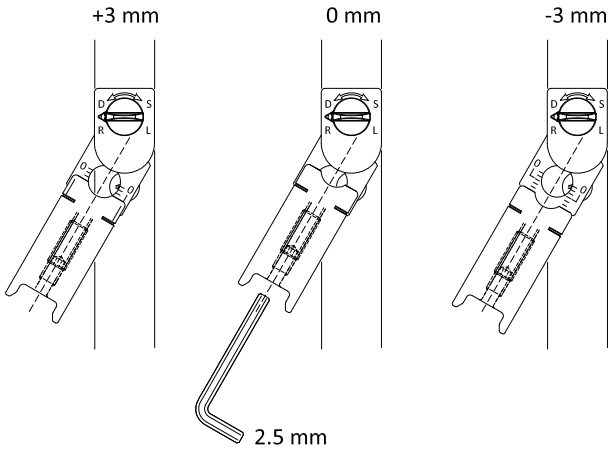


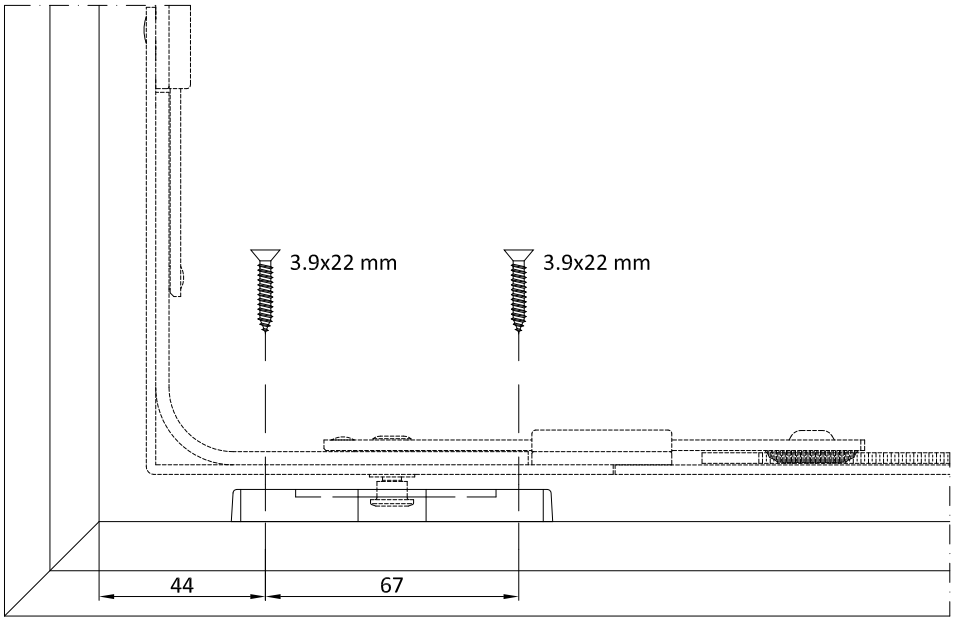


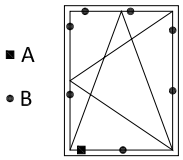


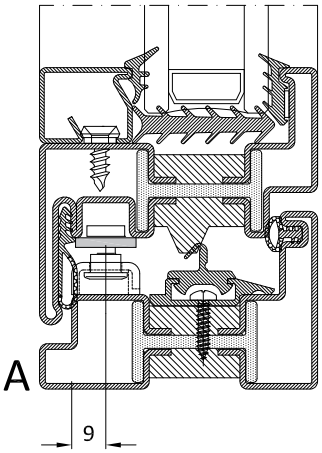


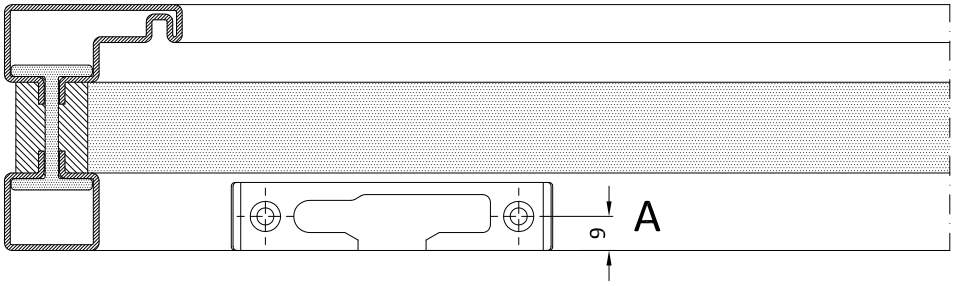
Regolazione
Adjustment

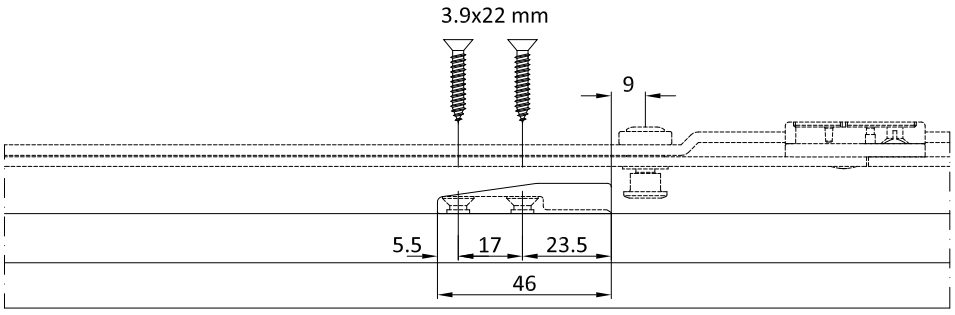


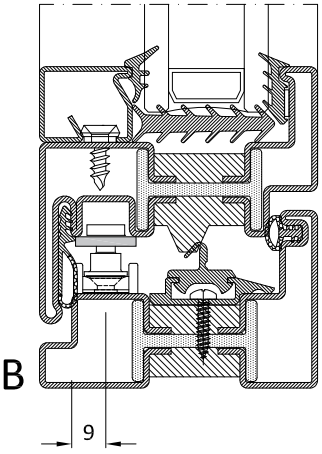

3.9x22 mm
3.9x22 mm
44
67

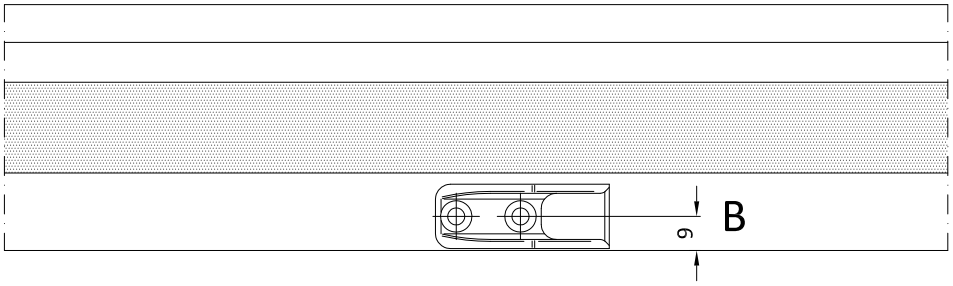

A
B

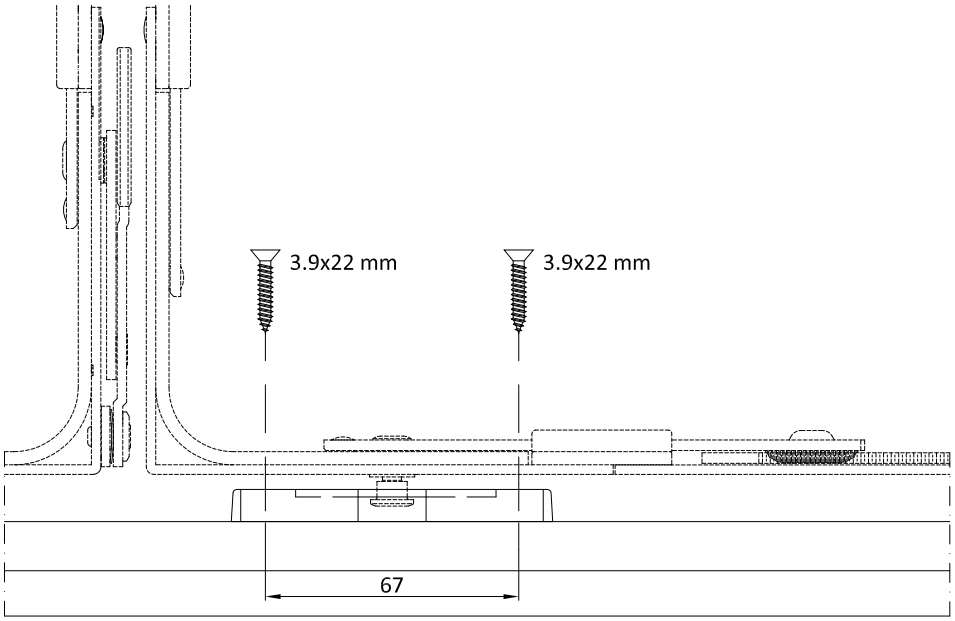

A
9

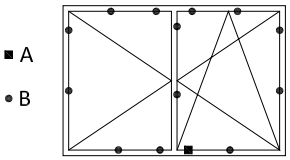

9
A

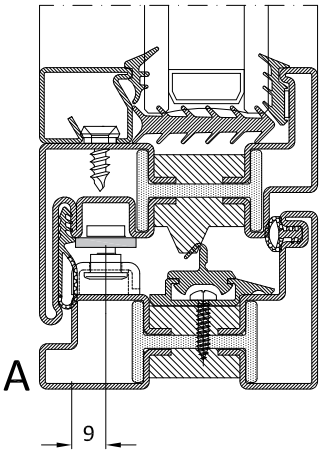

3.9x22 mm
9
5.5
17
23.5
46

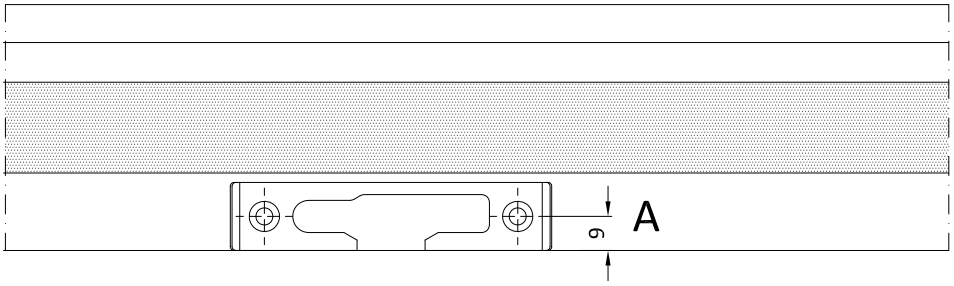

B
9

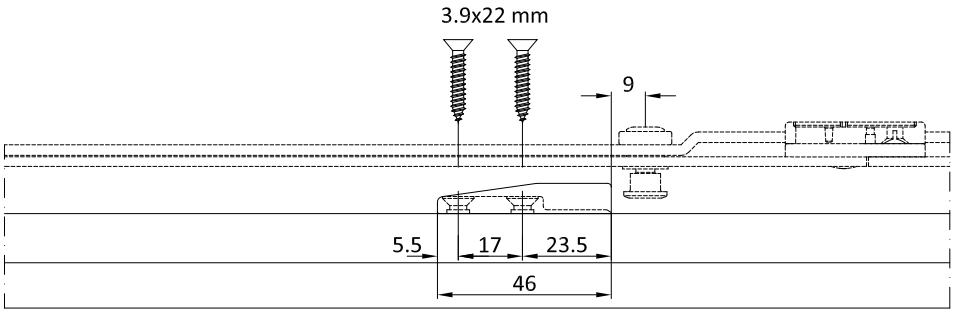

9
B

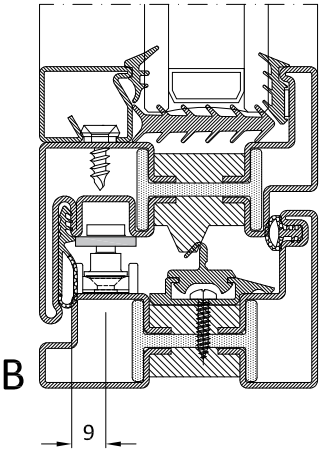

3.9x22 mm
3.9x22 mm
67

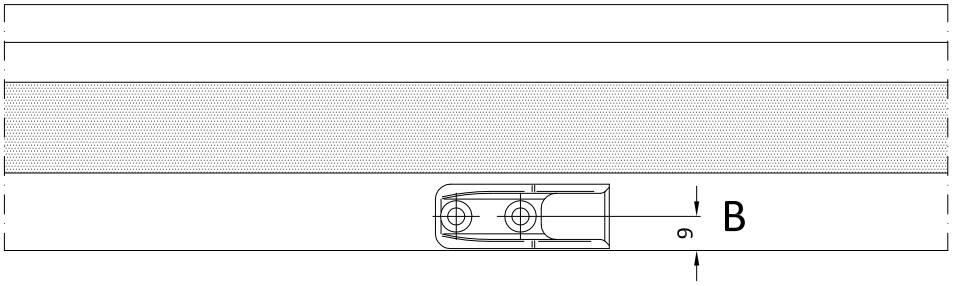

A
B


A
9

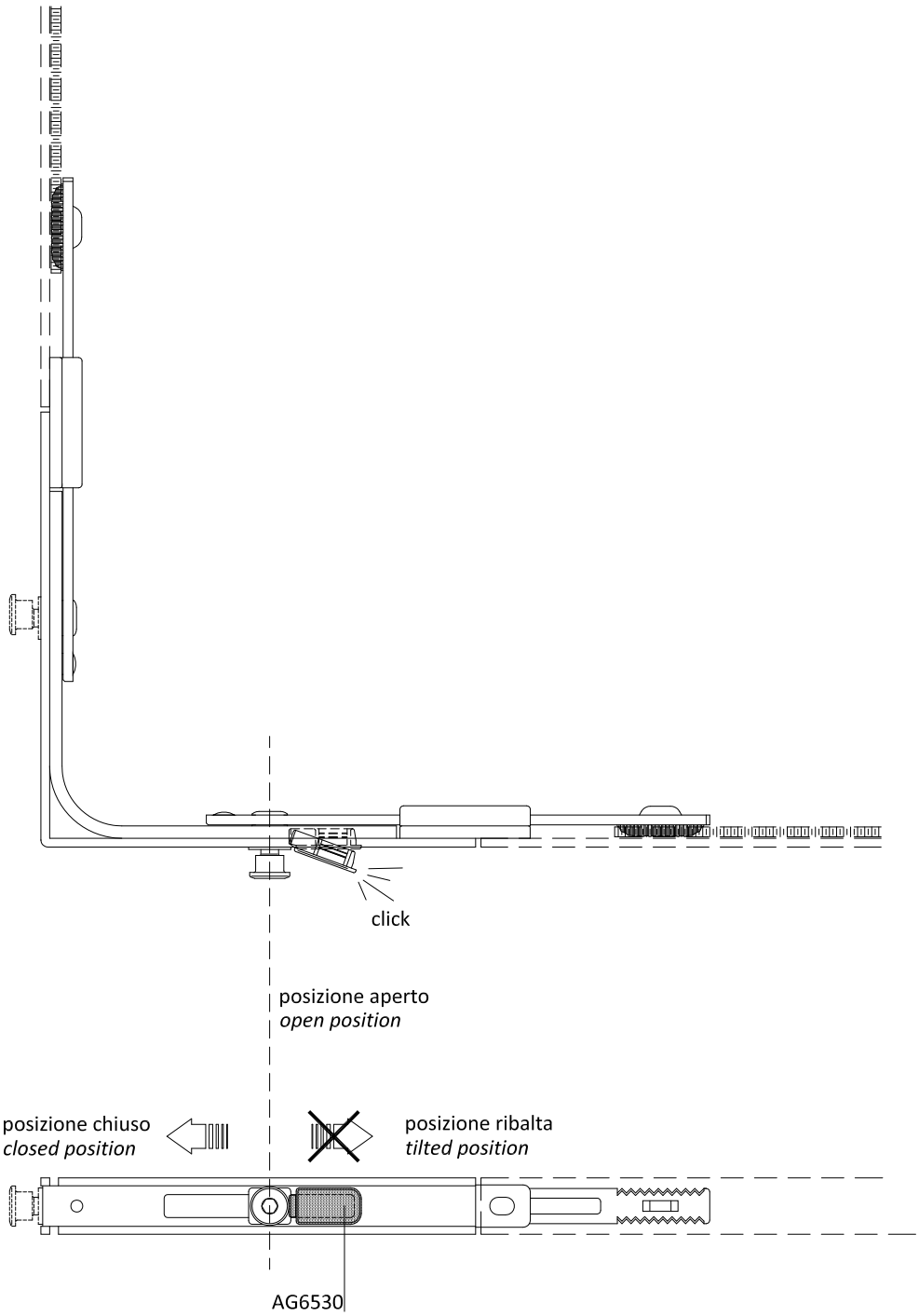

9
A


3.9x22 mm
9
5.5
17
23.5
46

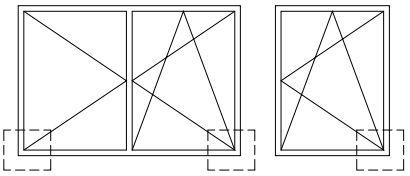

B
9

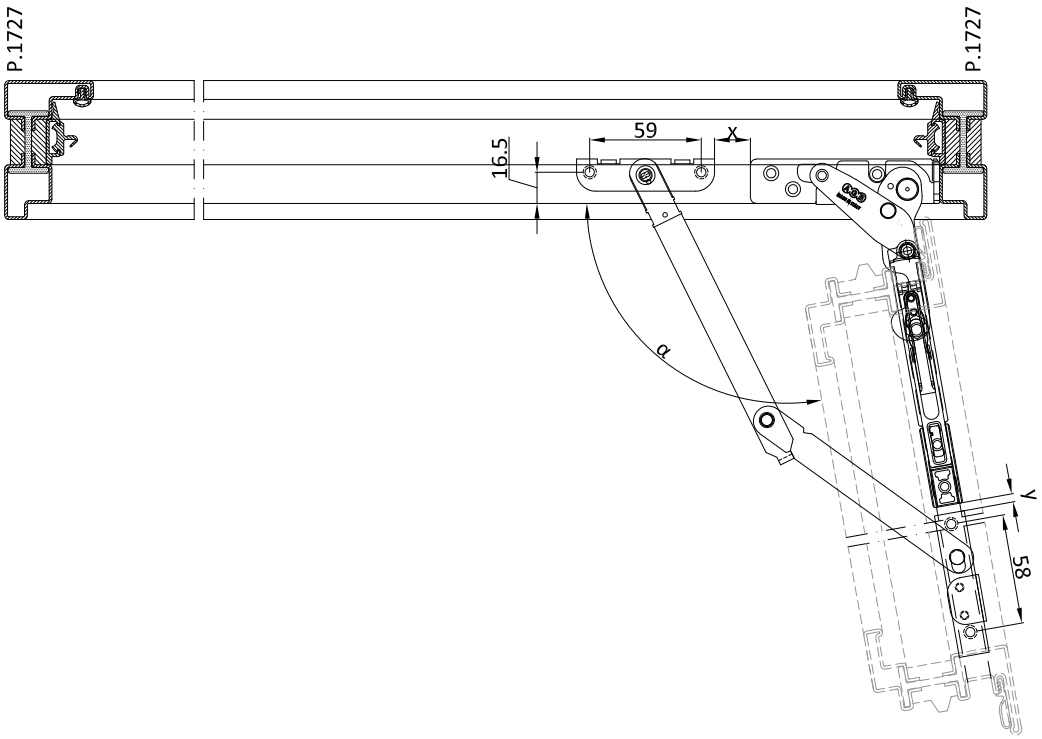

9
B

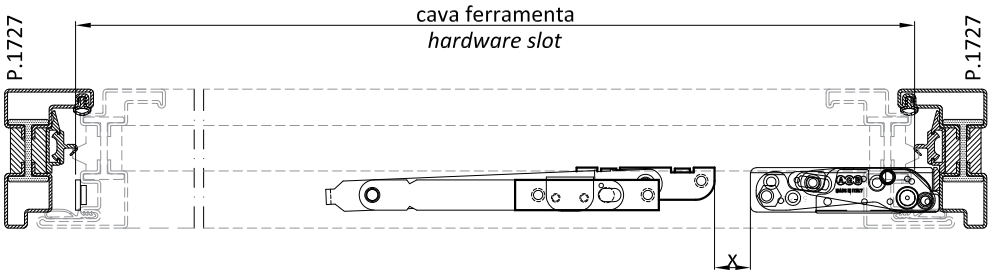

AG6530

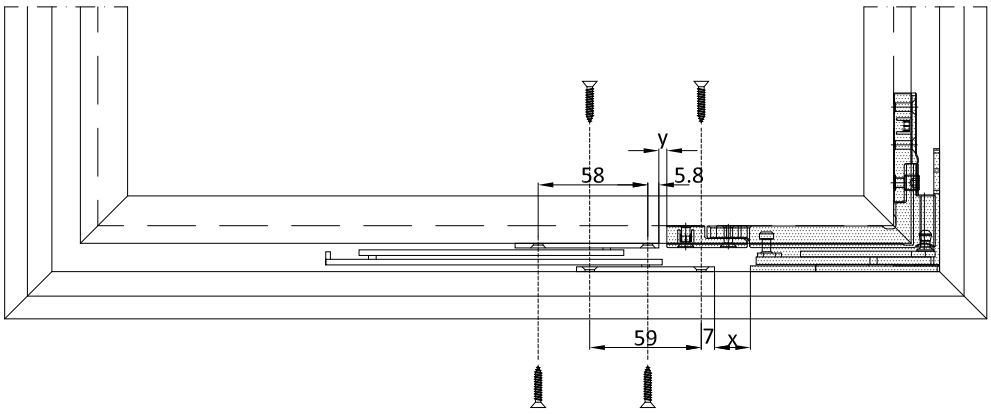

click
posizione aperto
open position
posizione chiuso
closed position
posizione ribalta
tilted position
AG6530

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

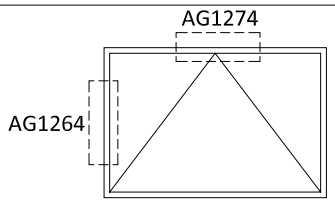








non installabile su kit AG1281-2-5-6
not possible to install on kit AG1281-2-5-6



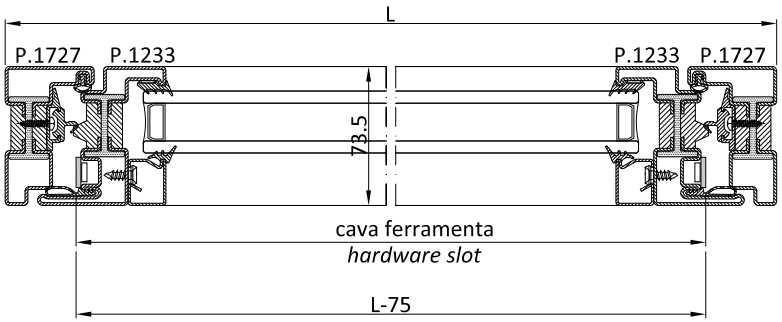
	AG1264	H altezza - *Height* 560 660	661 860	861 1200	1201 1600
L|W larghezza *width*	600-910	A1	B1	C1	D1
	911-1110	A2	B2	C2	D2
	1111-1470	A3	B3	C3	D3
	1471-1860	A4	B4	C4	D4

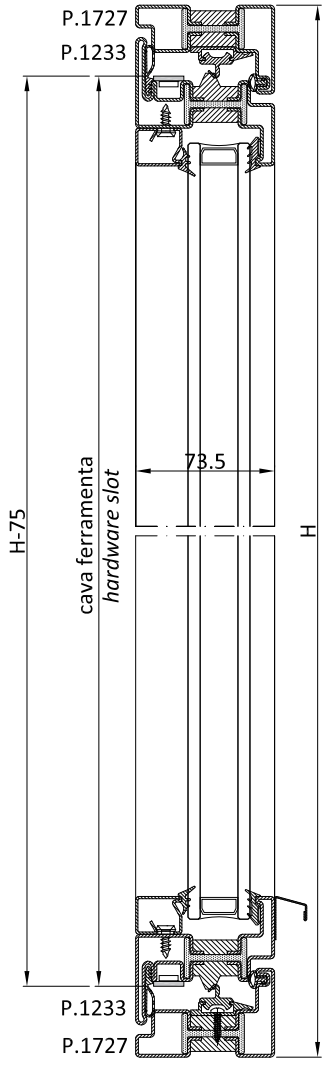
2 cerniere - peso massimo anta 70 kg
3 cerniere - peso massimo anta 100 kg

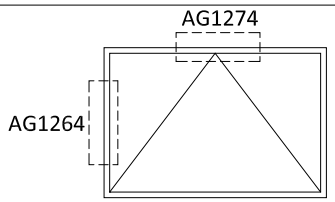
2 hinges - maximum leaf weight 70 kg
3 hinges - maximum leaf weight 100 kg

Specificare all'ordine misure cava ferramenta
Specify hardware slot size

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

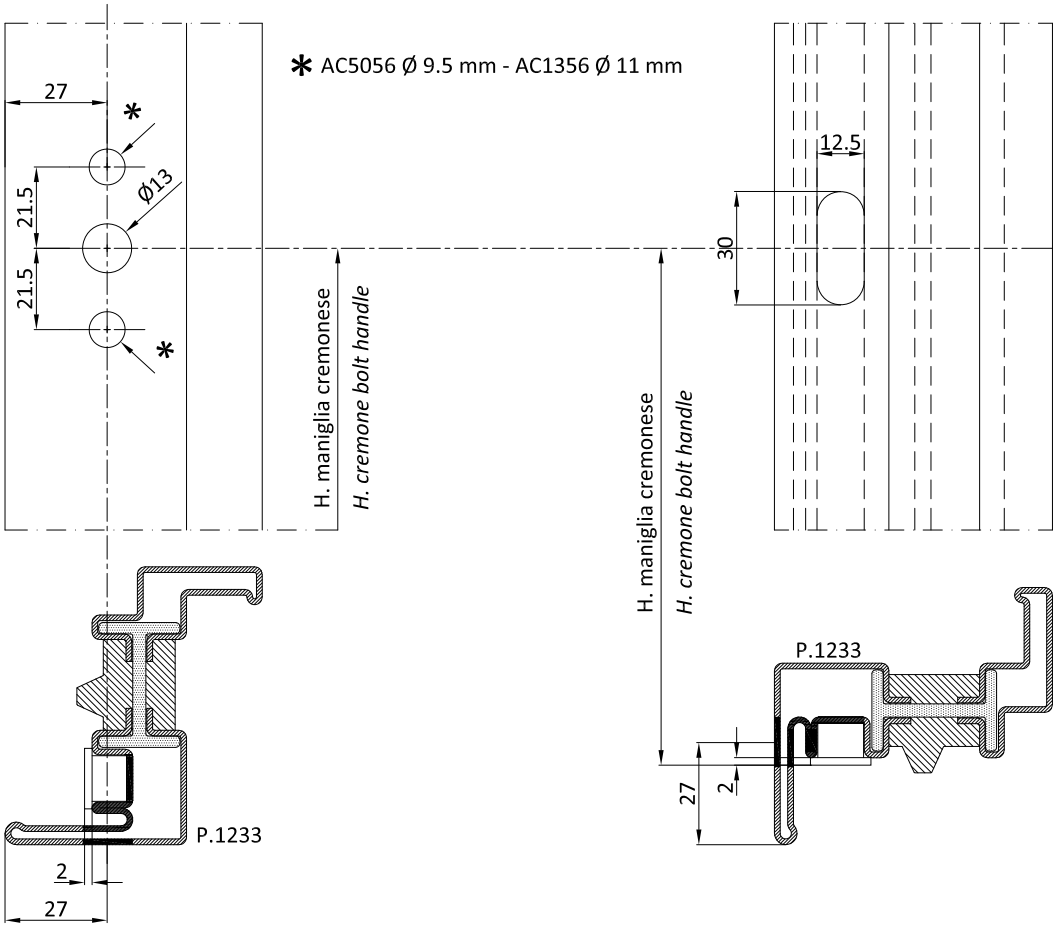






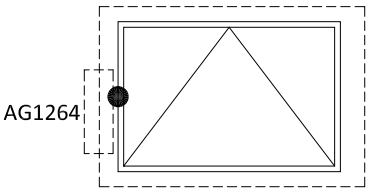
Fori per inserimento quadro comando e fissaggio maniglia / movimento DK
holes for inserting control panel and anchoring of handle / TT (tilt and turn) movement

Asola per inserimento meccanismo cremonese
Slot for insertion of cremone mechanism



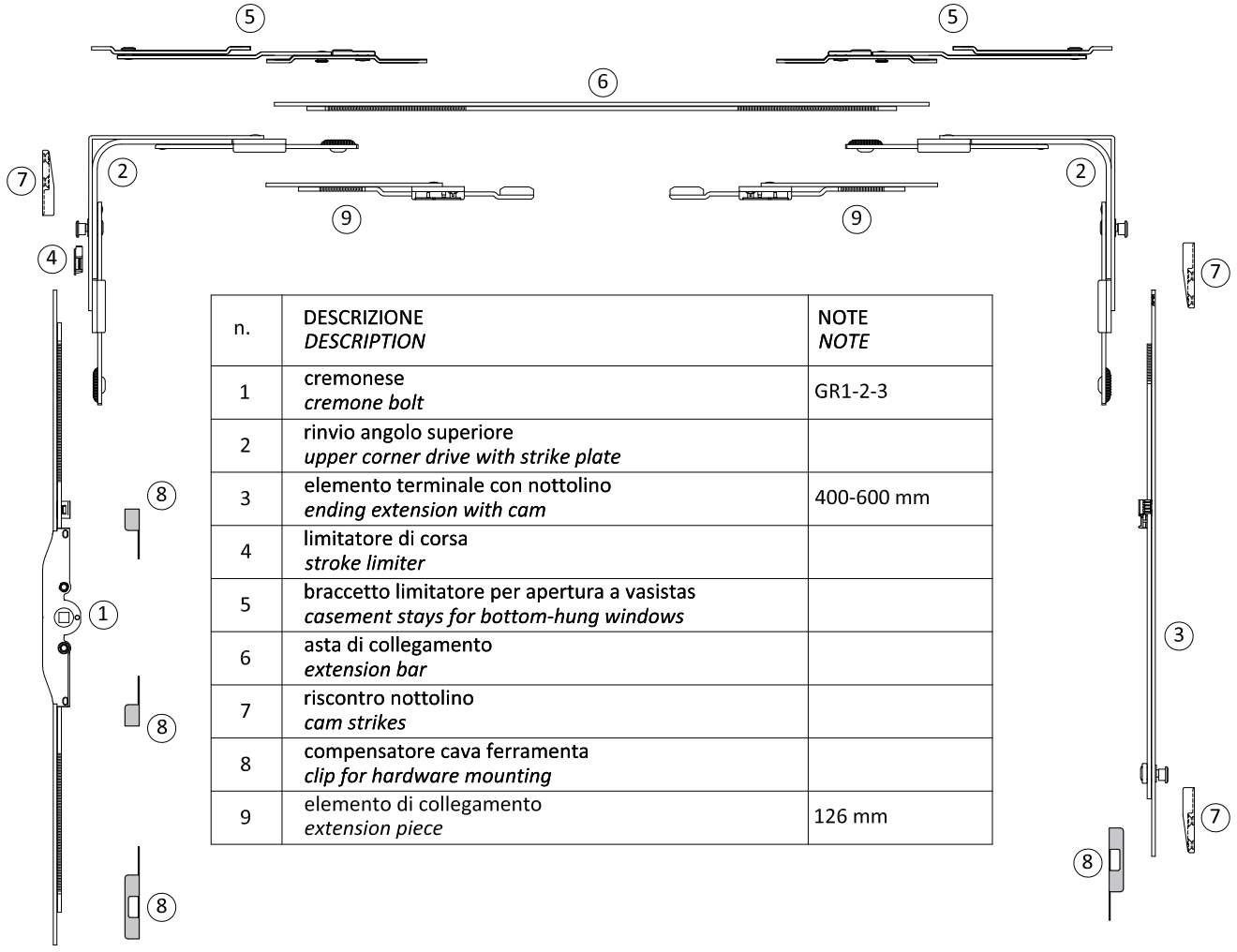
AG1264	ALTEZZA MANIGLIA CREMONESE - *CREMONE BOLT HANDLE HEIGHT*	
Tipo *Type*	cava ferramenta *hardware slot*	H maniglia cremonese *H cremone bolt handle*
Vasistas *Bottom-hung*	560 → 660	H/2
	661 → 860	H/2
	861 → 1200	H/2
	1201 → 1600	H/2

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

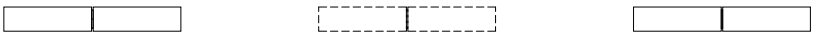


2 cerniere - peso massimo anta 70 kg
3 cerniere - peso massimo anta 100 kg

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



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

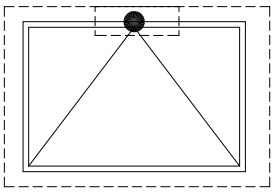


AC2632/C

cerniere non incluse nel kit
hinges not included in the kit

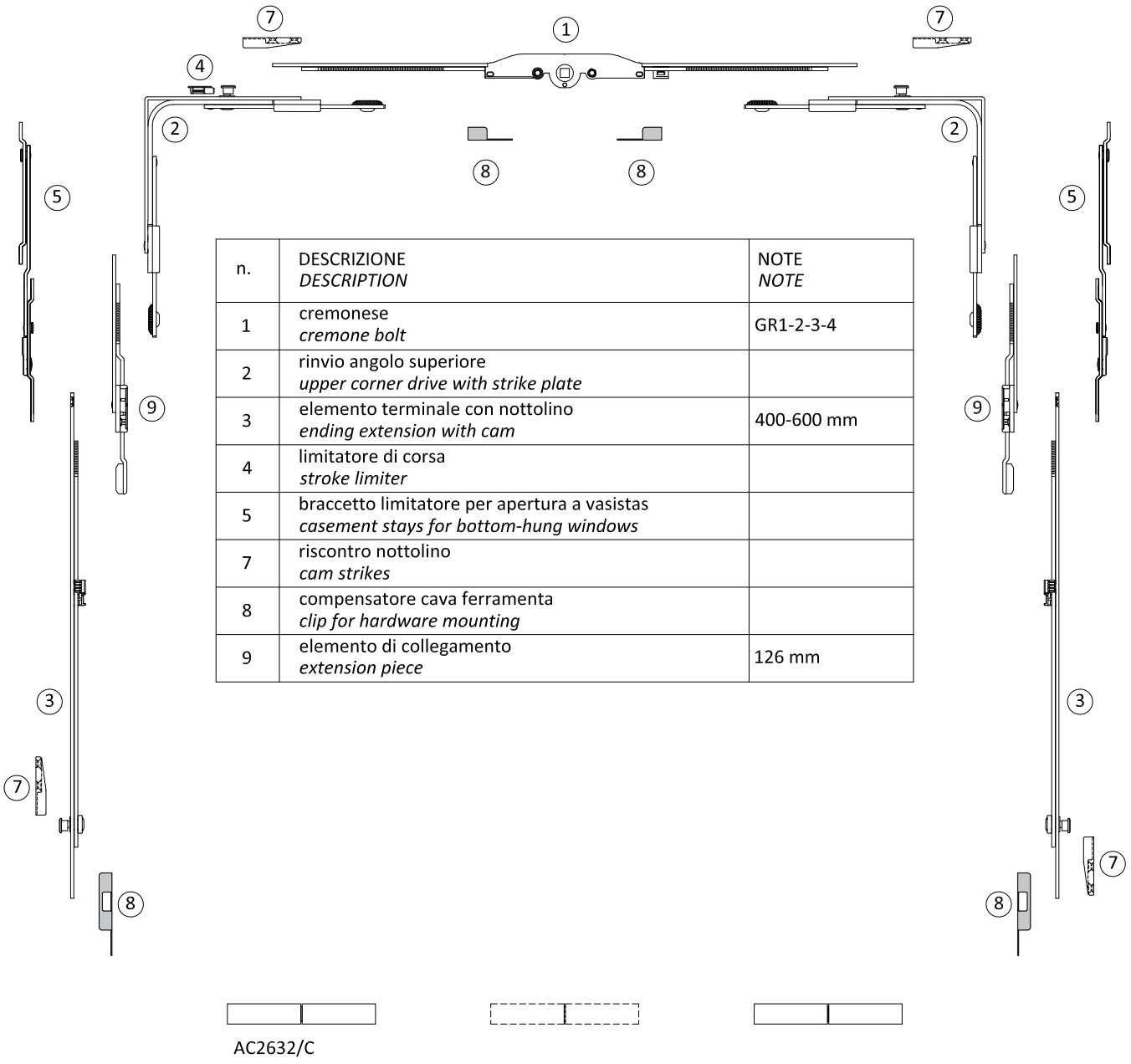
Specificare all'ordine misure cava ferramenta
Specify hardware slot size

AG1274



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

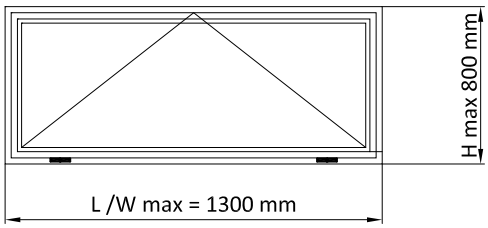
2 hinges - maximum leaf weight 70 kg
3 hinges - maximum leaf weight 100 kg

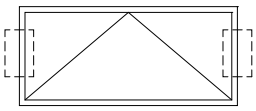


n.	DESCRIZIONE *DESCRIPTION*	NOTE *NOTE*
1	cremonese *cremone bolt*	GR1-2-3-4
2	rinvio angolo superiore *upper corner drive with strike plate*	
3	elemento terminale con nottolino *ending extension with cam*	400-600 mm
4	limitatore di corsa *stroke limiter*	
5	braccetto limitatore per apertura a vasistas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

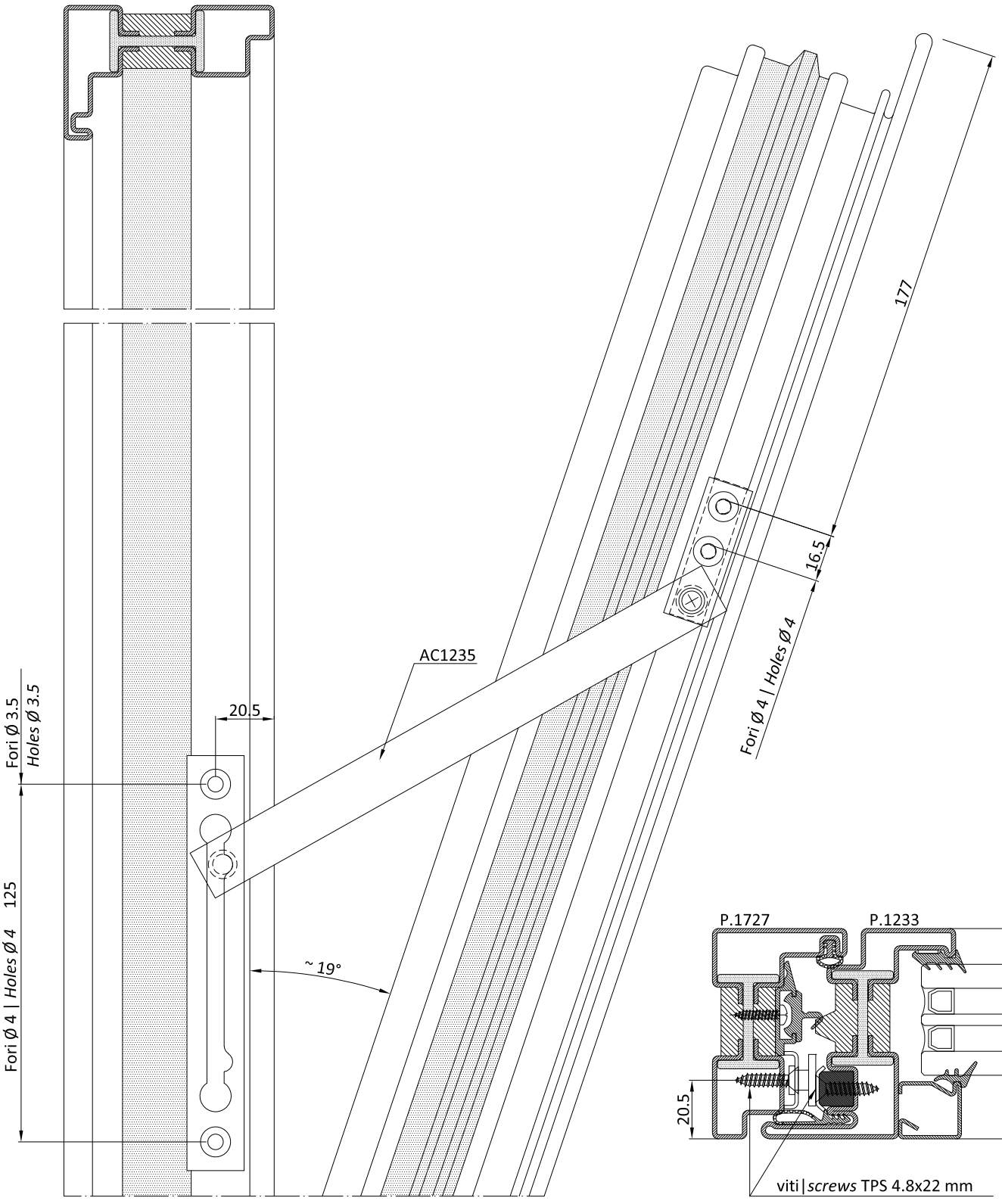
AC2632/C

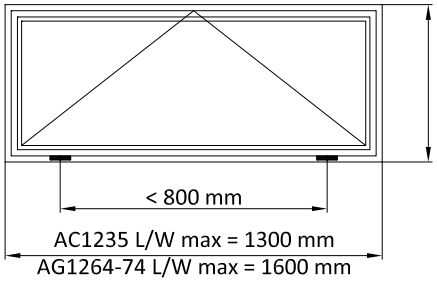
cerniere non incluse nel kit
hinges not included in the kit

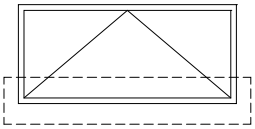




Peso max. per anta 70 kg
H min anta 300 mm
Max. weight for leaf: 70 kg
W min leaf 300 mm



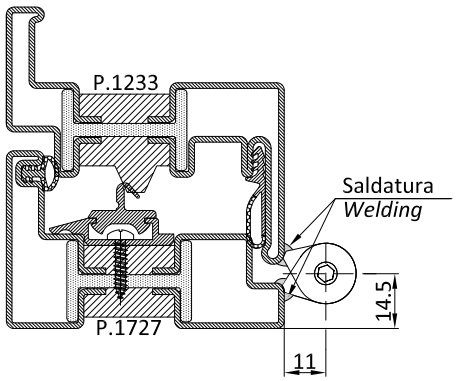




AC1235
Peso max. per anta 70 kg
Max. weight for leaf: 70 kg

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

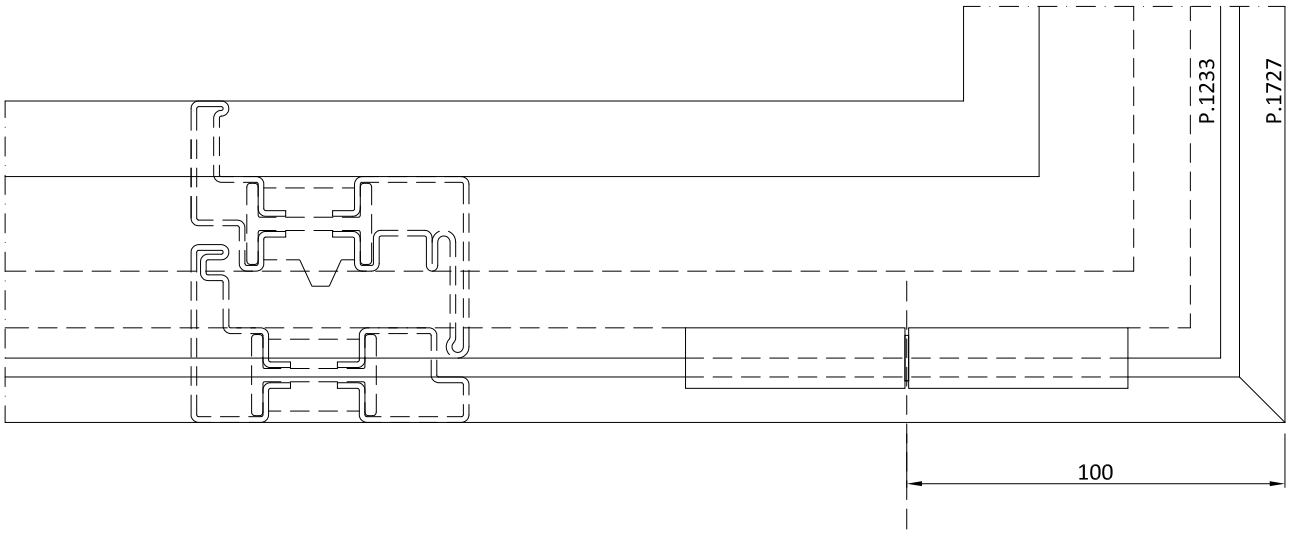
2 hinges
maximum leaf weight 70 kg
3 hinges
maximum leaf weight 100 kg

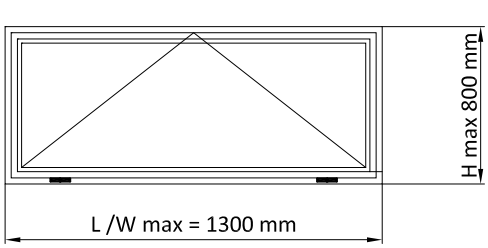


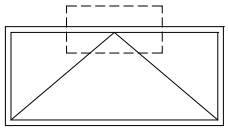
Posizionare le cerniere come da disegno saldandole sui lati.
Position the hinges as in the drawing, welding them on the sides.

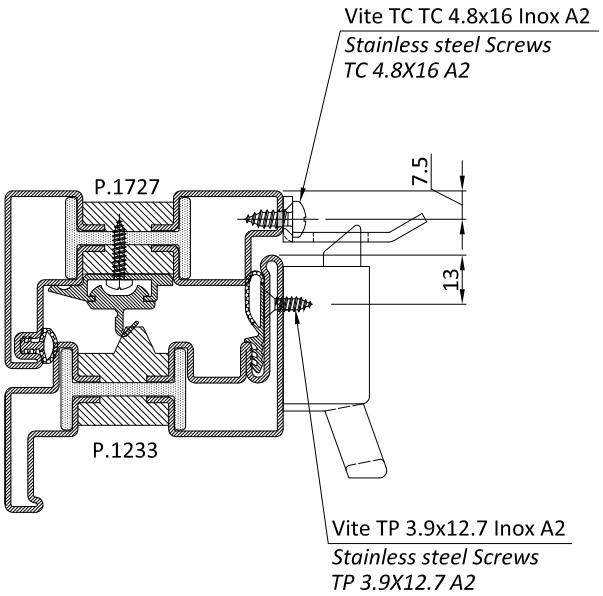
- La lavorazione può essere effettuata anche in posizioni intermedie alla larghezza del vasistas.
- La lavorazione SX è speculare alla DX.

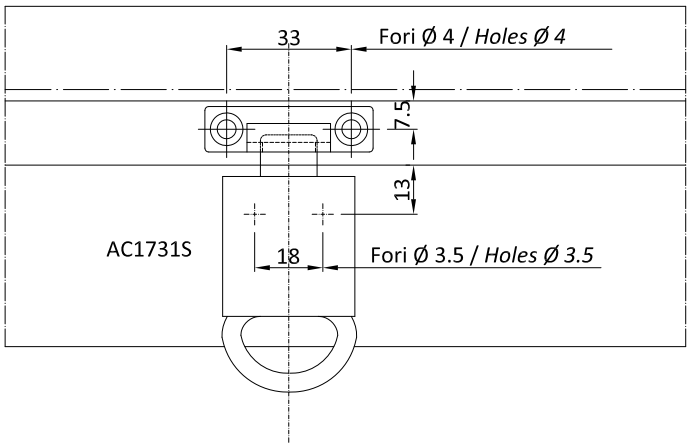
- *Tooling can be carried out also in intermediate positions regarding the width of the hopper or bottom-hung window.*
- *Tooling on left is the same as that on the right.*

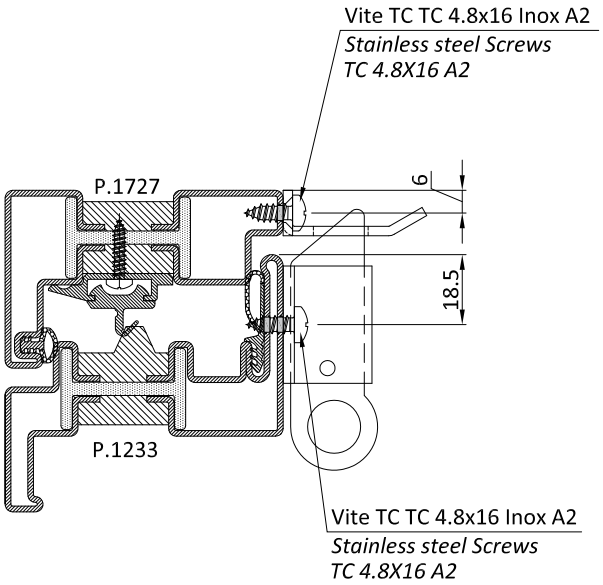


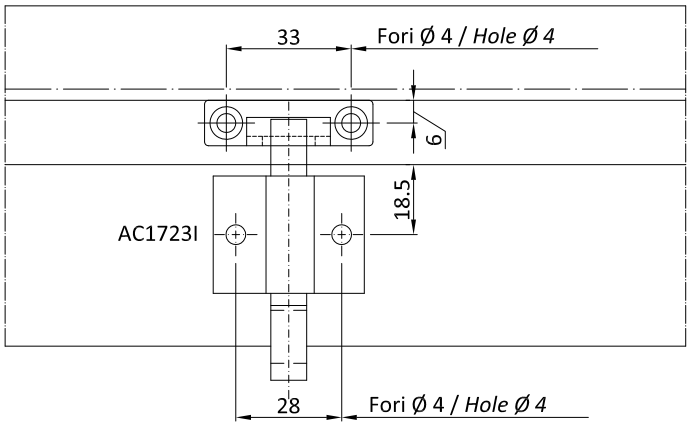

H max 800 mm
L /W max = 1300 mm

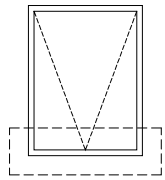


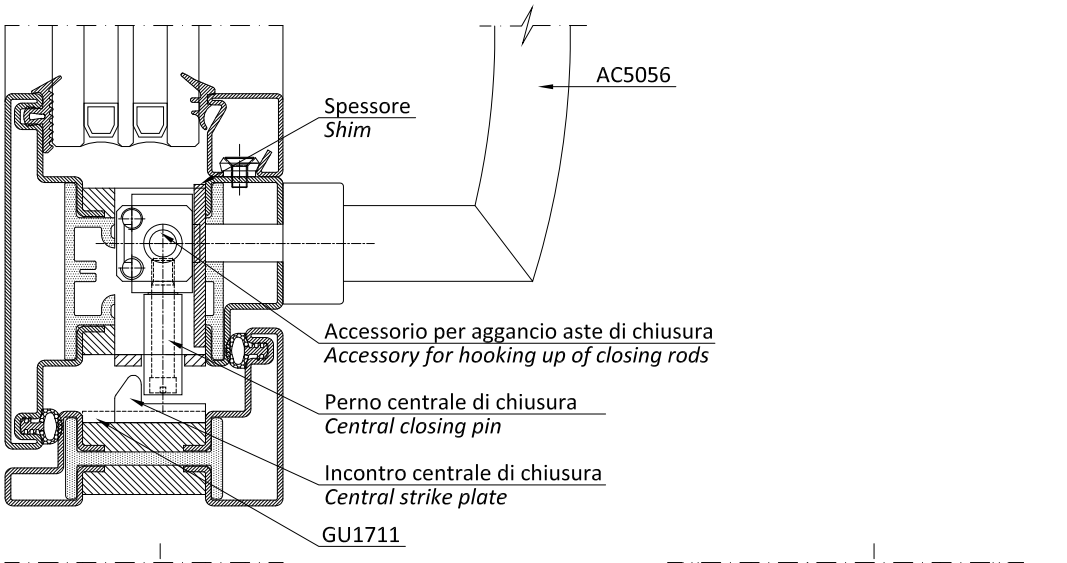

Vite TC TC 4.8x16 Inox A2
Stainless steel Screws
TC 4.8X16 A2
P.1727
7.5
13
P.1233
Vite TP 3.9x12.7 Inox A2
Stainless steel Screws
TP 3.9X12.7 A2

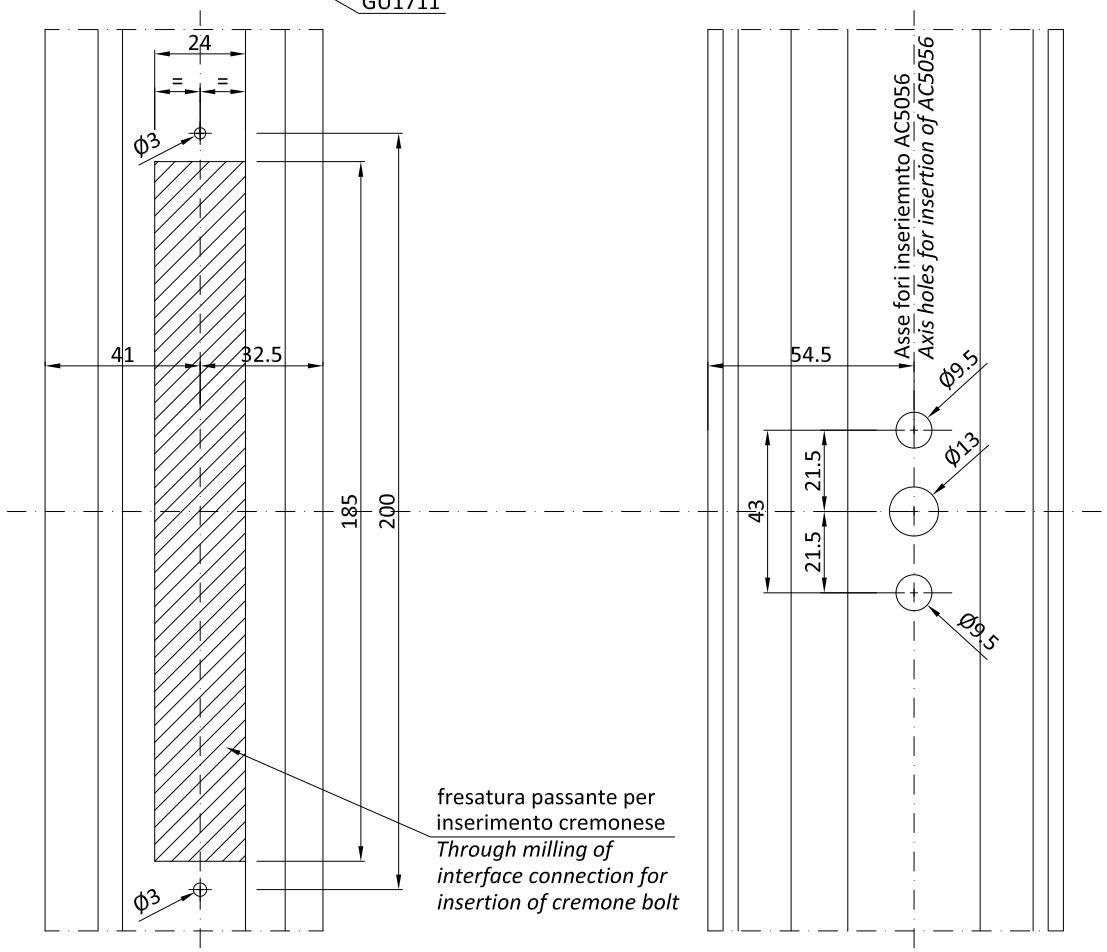

33
Fori Ø 4 / *Holes Ø 4*
7.5
13
AC1731S
18
Fori Ø 3.5 / *Holes Ø 3.5*

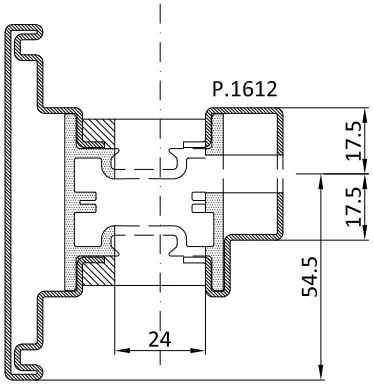

Vite TC TC 4.8x16 Inox A2
Stainless steel Screws
TC 4.8X16 A2
P.1727
6
18.5
P.1233
Vite TC TC 4.8x16 Inox A2
Stainless steel Screws
TC 4.8X16 A2

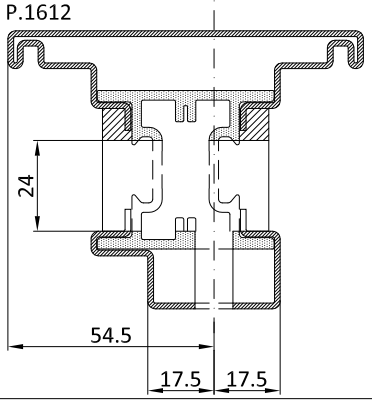

33
Fori Ø 4 / *Hole Ø 4*
6
18.5
AC1723I
28
Fori Ø 4 / *Hole Ø 4*

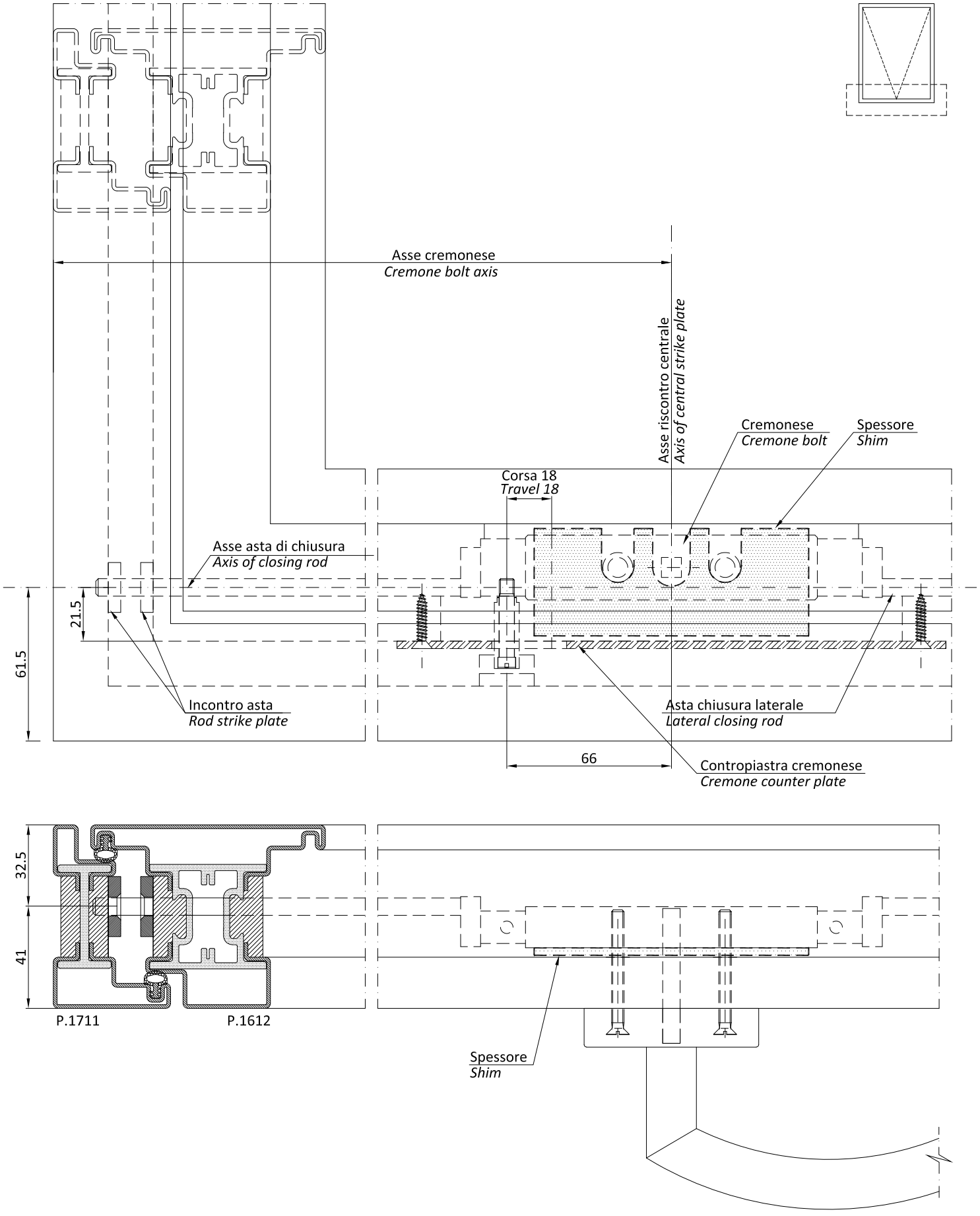



AC5056
Spessore
Shim
Accessorio per aggancio aste di chiusura
Accessory for hooking up of closing rods
Perno centrale di chiusura
Central closing pin
Incontro centrale di chiusura
Central strike plate
GU1711

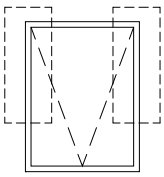

24
ϕ3
41
32.5
185
200
fresatura passante per
inserimento cremonese
Through milling of
interface connection for
insertion of cremone bolt
Asse fori inseriemnto AC5056
Axis holes for insertion of AC5056
54.5
Ø9.5
Ø13
43
21.5
21.5
Ø9.5

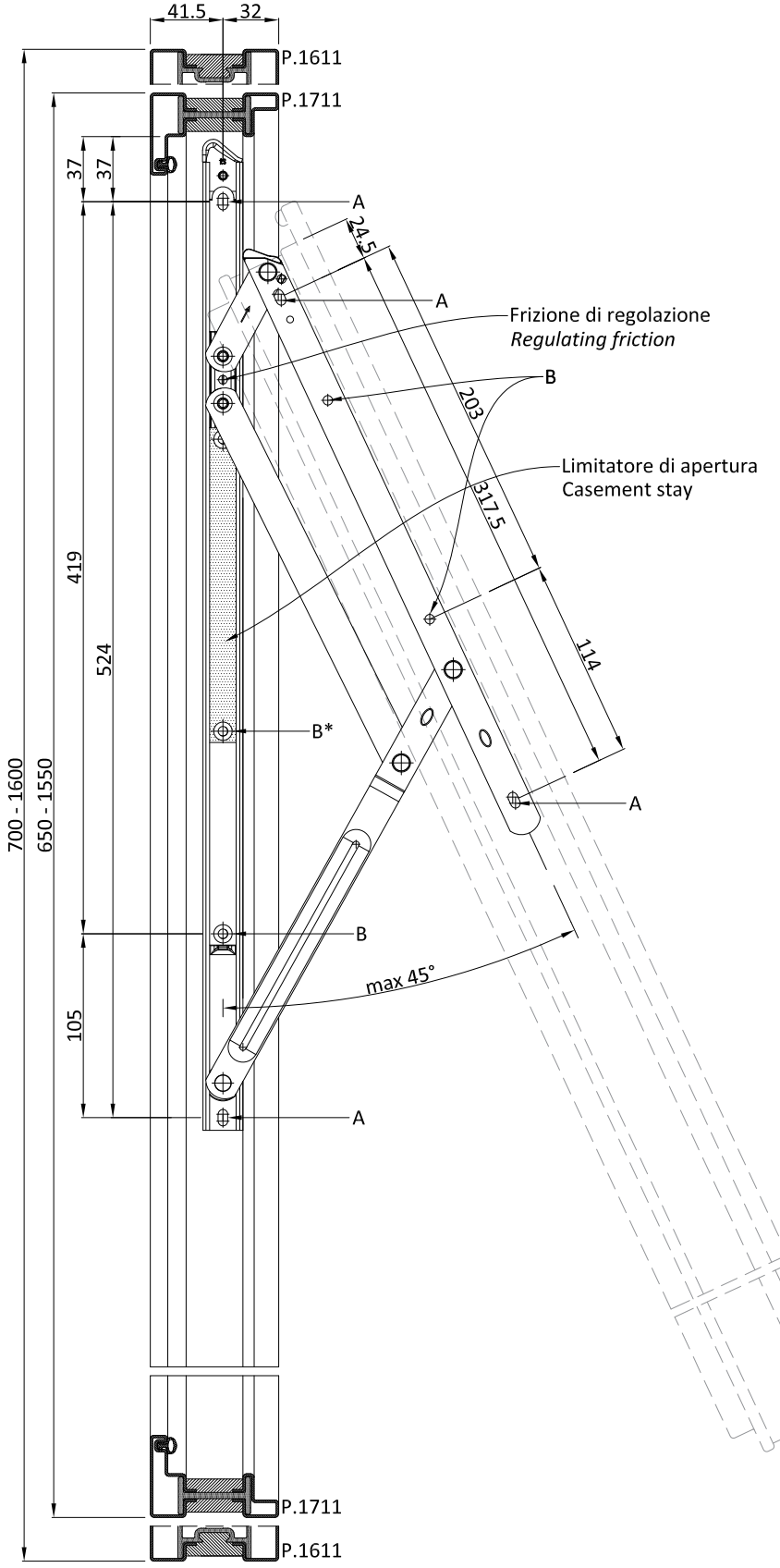

P.1612
17.5
17.5
54.5
24


P.1612
24
54.5
17.5
17.5


Asse cremonese
Cremone bolt axis
Asse riscontro centrale
Axis of central strike plate
Cremonese
Cremone bolt
Spessore
Shim
Corsa 18
Travel 18
Asse asta di chiusura
Axis of closing rod
21.5
61.5
Incontro asta
Rod strike plate
Asta chiusura laterale
Lateral closing rod
66
Contropiastra cremonese
Cremone counter plate
32.5
41
P.1711
P.1612
Spessore
Shim

Peso massimo anta 75 kg
Maximum vent weight 75 kg



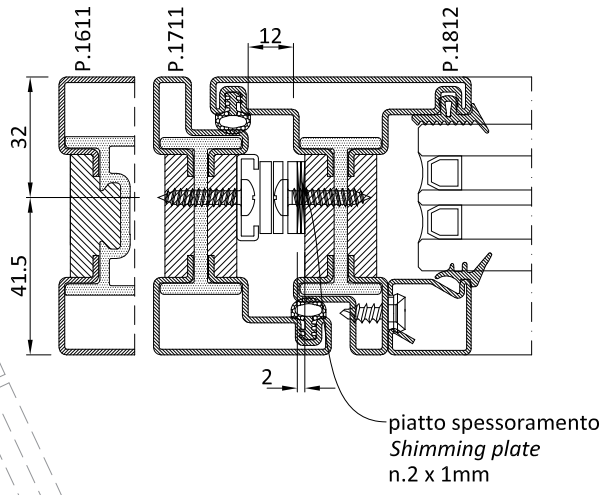


- Fissare i compassi in corrispondenza dei fori asolati A foro su profilo Ø 4 per viti TC 4.8x22 mm;
- Verificare il funzionamento dei compassi;
- Fissare l'apertura massima desiderata mediante il limitatore di apertura;
- Completare l'operazione di fissaggio nei rimanenti fori B.

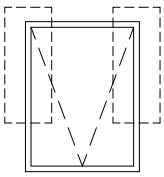
* posizione determinata dalla apertura massima desiderata - foro da eseguire in opera

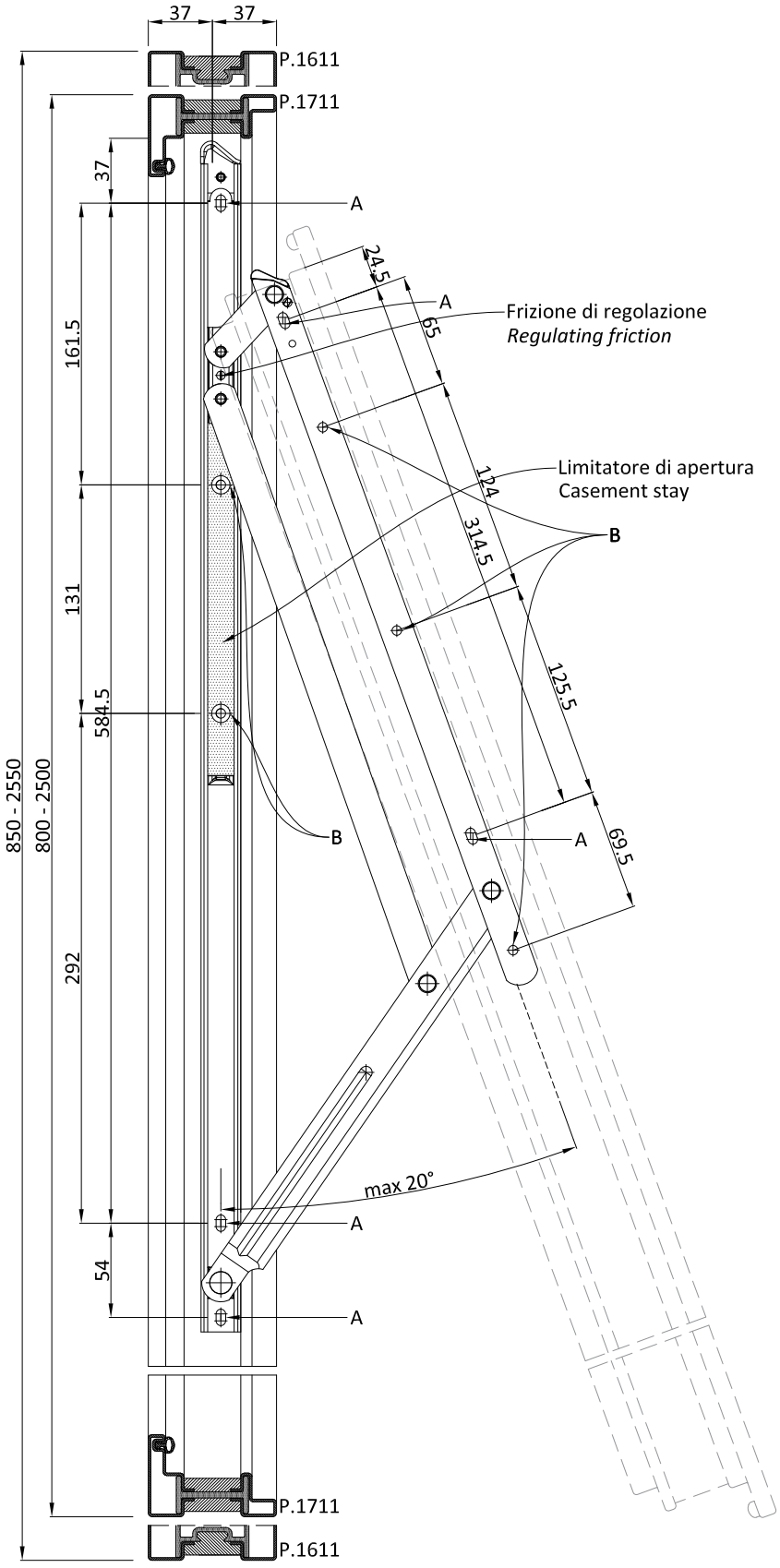
- Fit the side arms into the slotted holes A - hole on profile Ø 4 for TC 4.8x22 mm screws;
- Check the side arms move properly;
- Set the desired maximum opening using the casement stay;
- Complete the anchoring operation in the remaining B holes.

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



Peso massimo anta 120 kg
Maximum vent weight 120 kg



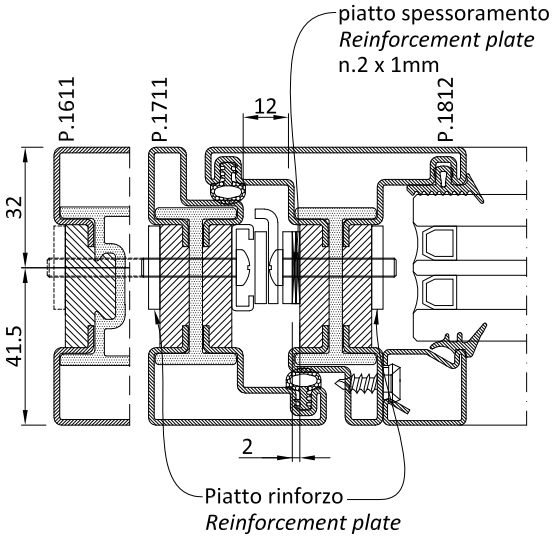


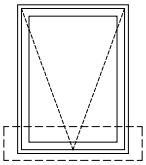
- Fissare i compassi in corrispondenza dei fori asolati A foro su profilo Ø 4 per viti TC 4.8x22 mm;
- Verificare il funzionamento dei compassi;
- Fissare l'apertura massima desiderata mediante il limitatore di apertura;
- Completare l'operazione di fissaggio nei rimanenti fori B.

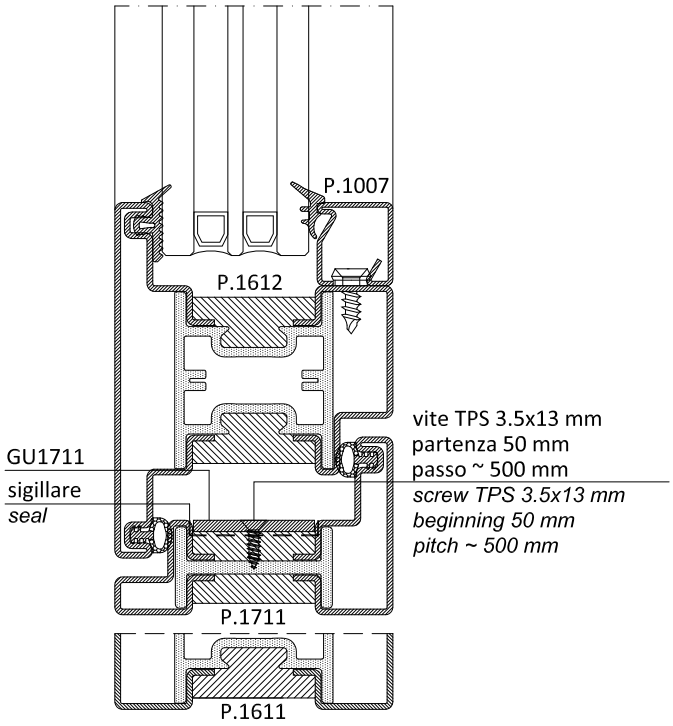
* posizione determinata dalla apertura massima desiderata - foro da eseguire in opera

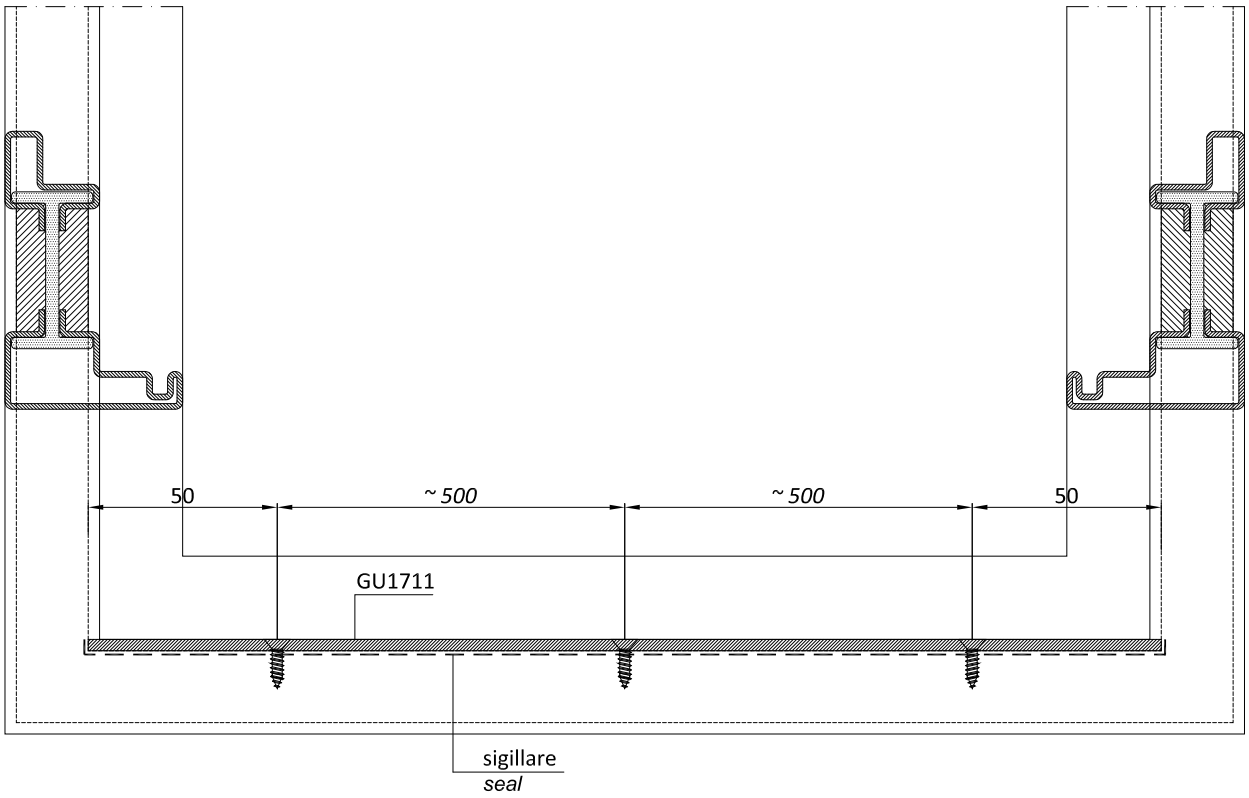
- Fit the side arms into the slotted holes A - hole on profile Ø 4 for TC 4.8x22 mm screws;
- Check the side arms move properly;
- Set the desired maximum opening using the casement stay;
- Complete the anchoring operation in the remaining B holes.

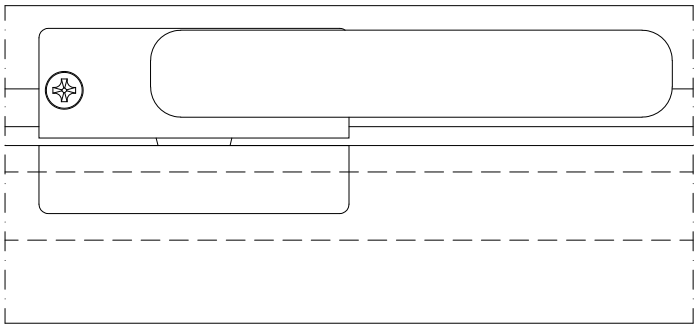
* Position determined by the maximum opening desired - hole to be made during installation

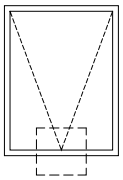


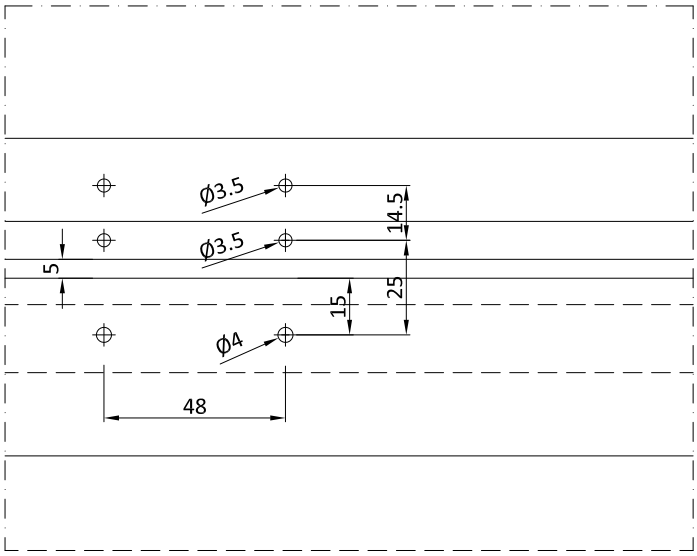


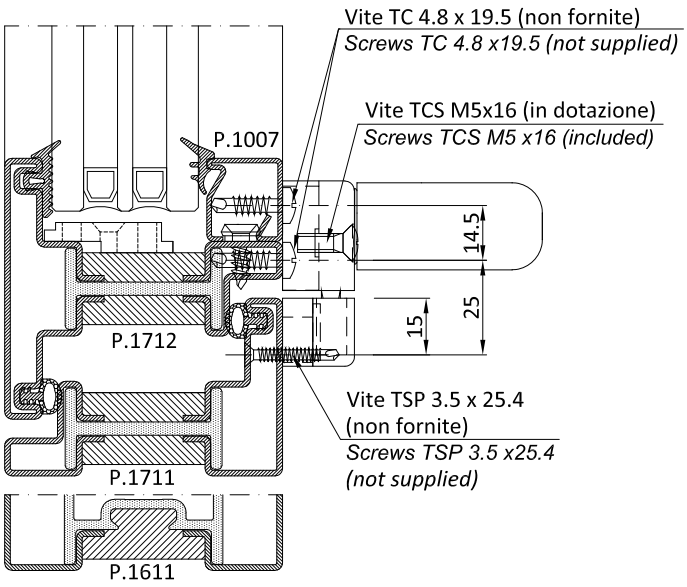

P.1007
P.1612
vite TPS 3.5x13 mm
partenza 50 mm
passo ~ 500 mm
screw TPS 3.5x13 mm
beginning 50 mm
pitch ~ 500 mm
GU1711
sigillare
seal
P.1711
P.1611

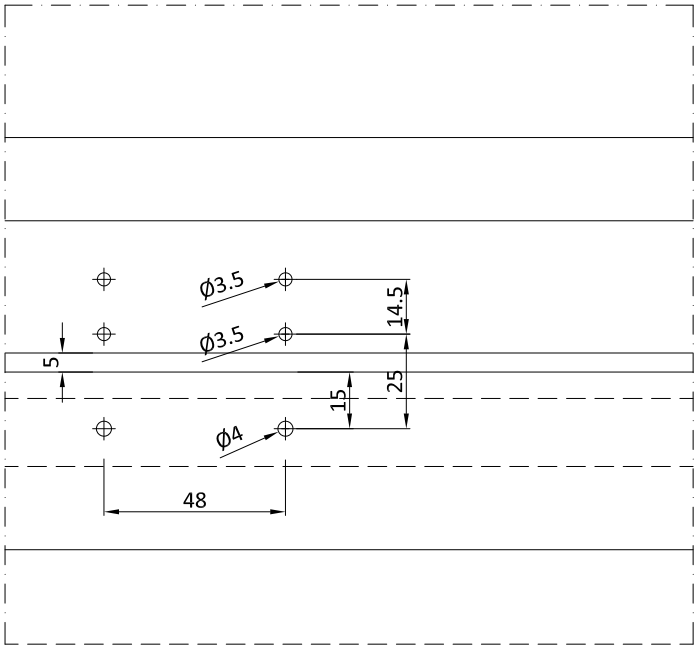

50
~ 500
~ 500
50
GU1711
sigillare
seal

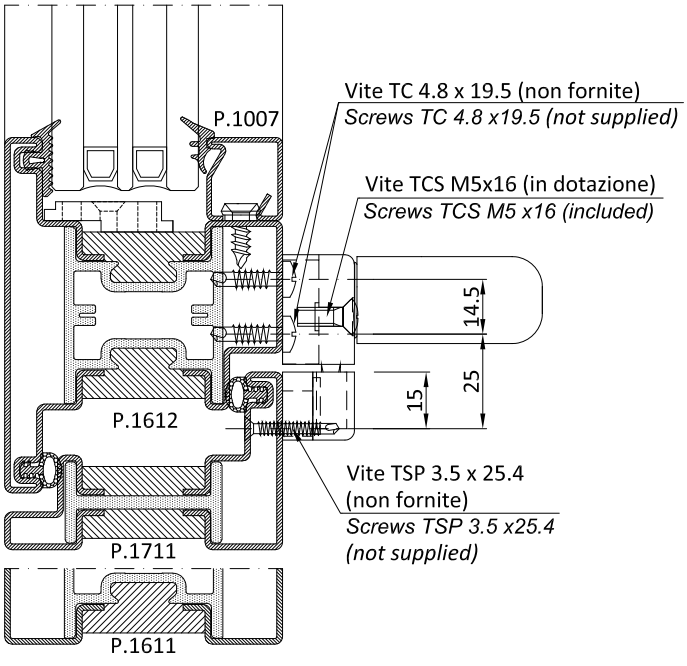


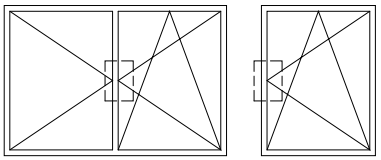


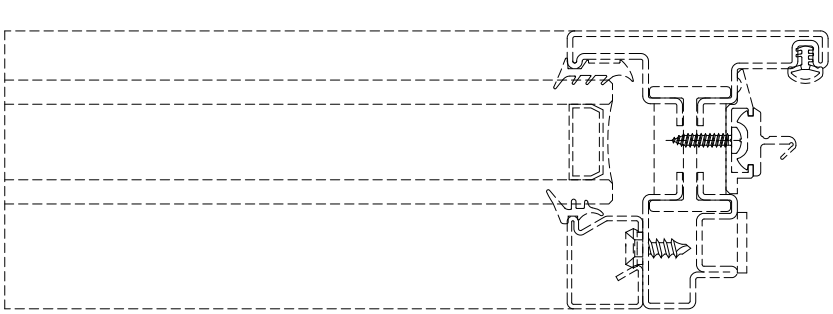

ϕ3.5
ϕ3.5
ϕ4
14.5
25
15
5
48

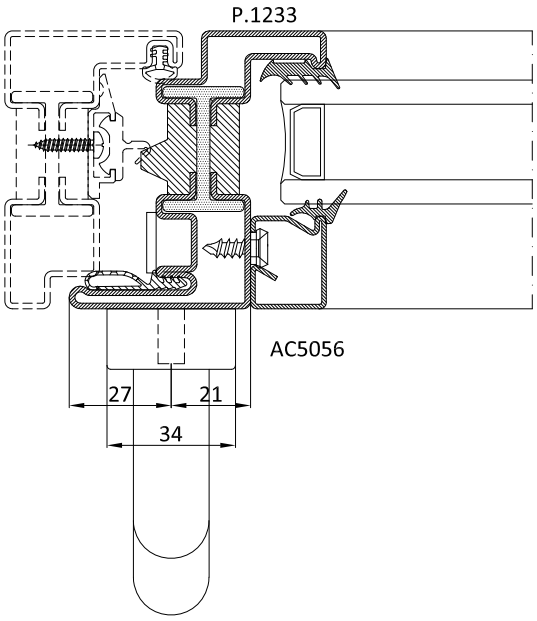

Vite TC 4.8 x 19.5 (non fornite)
Screws TC 4.8 x19.5 (not supplied)
Vite TCS M5x16 (in dotazione)
Screws TCS M5 x16 (included)
P.1007
P.1712
P.1711
P.1611
14.5
25
15
Vite TSP 3.5 x 25.4
(non fornite)
Screws TSP 3.5 x25.4
(not supplied)

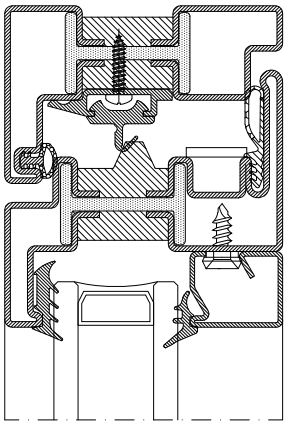

ϕ3.5
ϕ3.5
ϕ4
14.5
25
15
5
48


Vite TC 4.8 x 19.5 (non fornite)
Screws TC 4.8 x19.5 (not supplied)
Vite TCS M5x16 (in dotazione)
Screws TCS M5 x16 (included)
P.1007
P.1612
P.1711
P.1611
14.5
25
15
Vite TSP 3.5 x 25.4
(non fornite)
Screws TSP 3.5 x25.4
(not supplied)







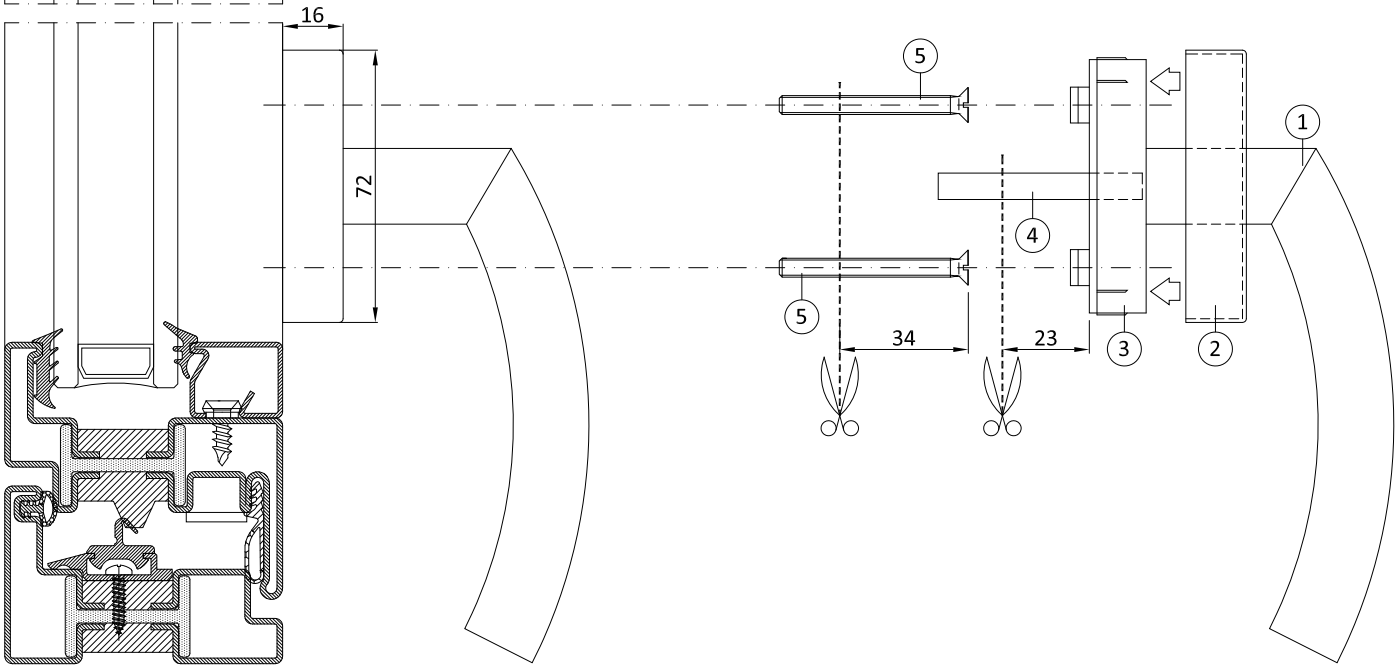


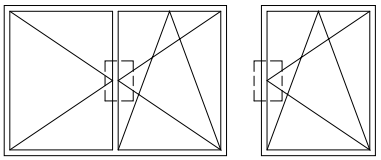
AC5056 :

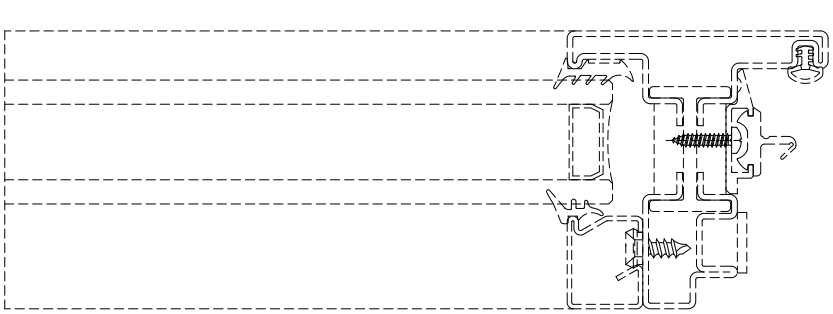
1) Impugnatura
2) Rosetta
3) Corpo maniglia
4) Quadro
5) Vite TP M5x50 (non fornite)

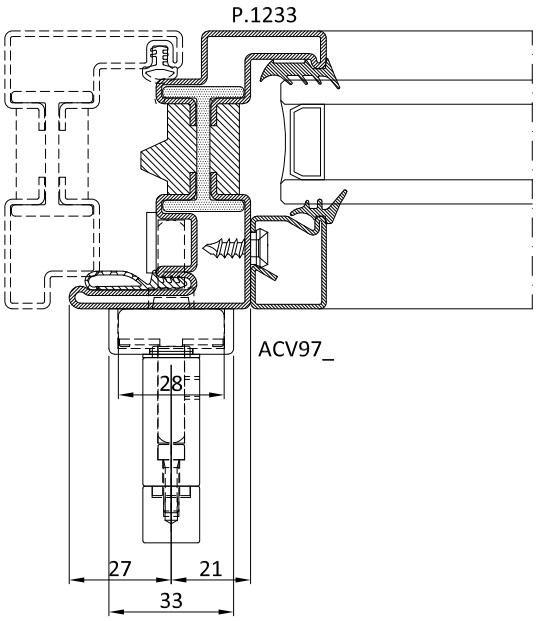
AC5056 :

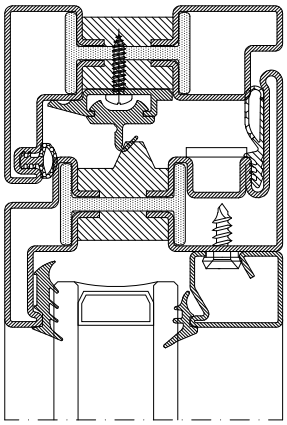
1) Handle grip
2) Rose
3) Handle body
4) Spindle bar
5) Flat head screws M5x50 (not supplied)









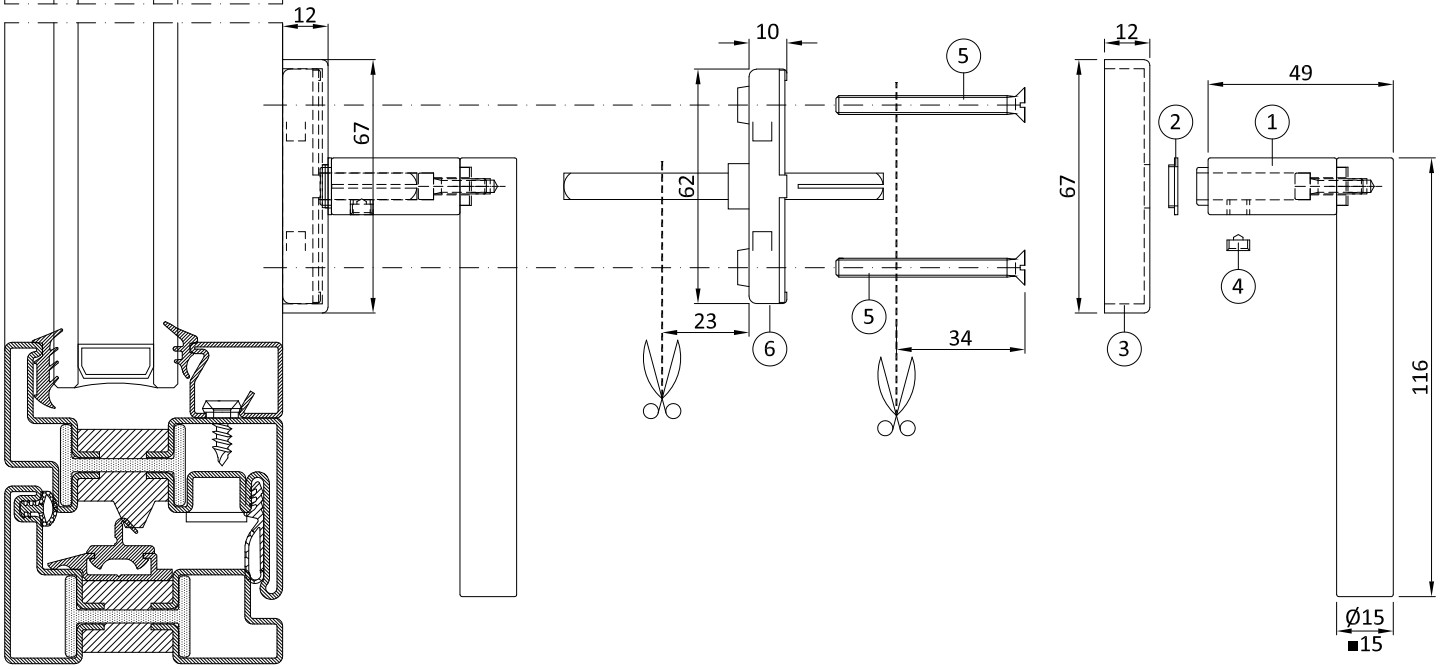


ACV97- :

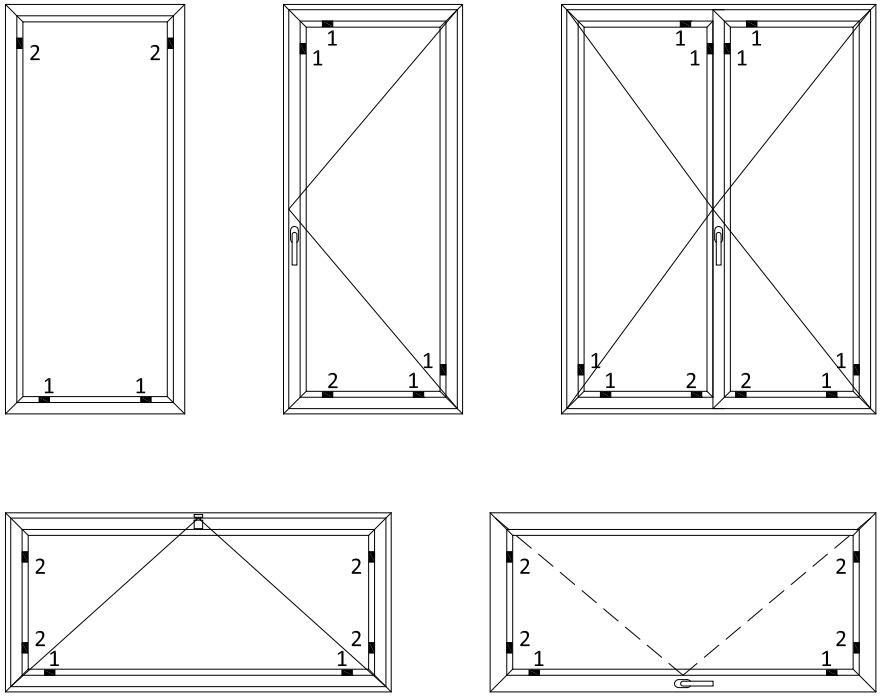
1) Impugnatura
2) Rondella
3) Rosetta
4) Grano M6x6
5) Vite TP M5x50 (non fornite)
6) AC1356 Movimento DK

ACV97- :

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

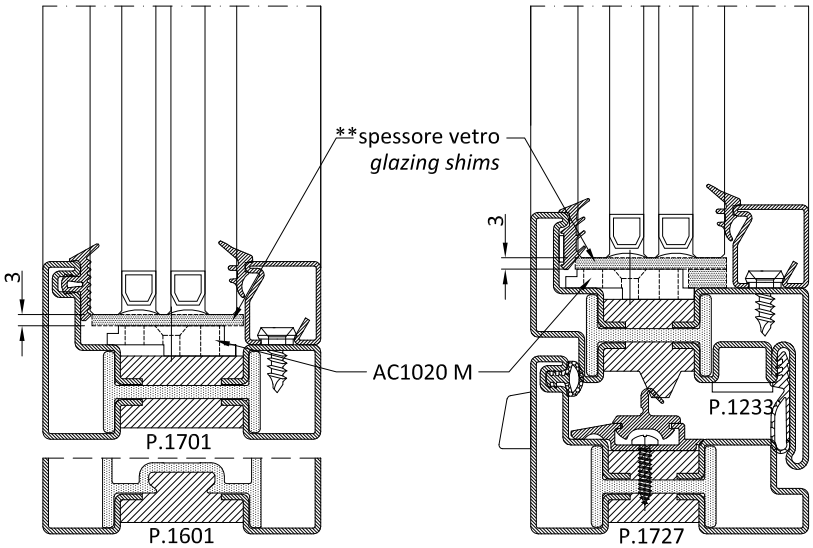


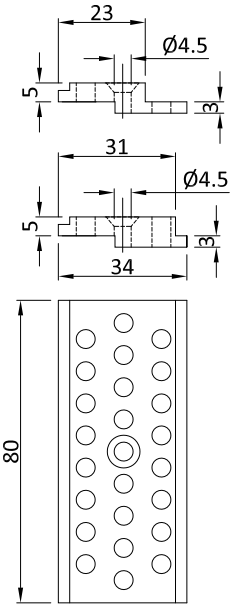
Finestra | *Window*



1) spessore portante | *carry shim*

2) spessore distanziatore | *compensation shim*





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

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

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

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

Note / *Note*

- La larghezza degli spessori è almeno pari o maggiore (+2 mm) dello spessore del vetro installato.
- La posizione degli spessori deve essere garantita dall'utilizzo di materiale adeguato che ne eviti lo spostamento.

- The shims' width is the same or greater (+2 mm) than the thickness of the glass installed.
- The position of the shims has to be ensured by using appropriate material that avoids creeping.

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

** spessori vetro non inclusi - *glass thickness not included*

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

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

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

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

Verniciatura/Brunitura
I profili EBE 75 sono stati progettati per essere verniciati a polveri in forni con temperature di 180°C per 25 minuti. La zona a taglio termico in poliuretano non è in grado di accogliere con sufficiente adesione le polveri poliesteri e perciò si consiglia di ricoprire tali zone, nelle sole parti destinate ad essere in vista, con apposite pellicole adesive idonee al passaggio in forno.
I telai prima della verniciatura o della brunitura devono essere forati come da istruzioni presenti in questa nota tecnica per permettere la fuoriuscita dei liquidi utilizzati durante il pretrattamento delle superfici. All'uscita del forno di polimerizzazione della polvere i telai vanno rimossi accuratamente e adagiati in posizione piana sino al loro completo raffreddamento.
Si consiglia di seguire il ciclo di pretrattamenti e verniciatura presente nella documentazione Secco Sistemi.

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

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

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

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

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

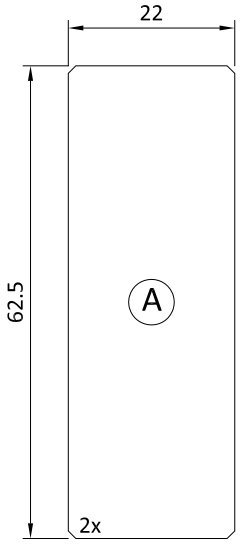
Welding
EBE 75 profiles can be welded with the traditional systems (MIG/MAG, TIG), with an appropriate lubricating/cooling system and according to the instructions as per this technical note. Avoid welding near the thermal break joint. Heating any polyurethane items releases gaseous substances containing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

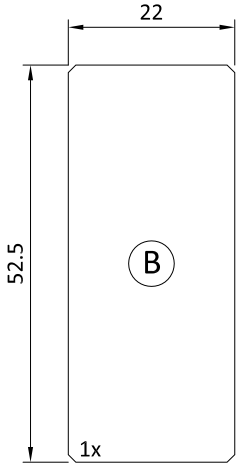
Painting/Burnishing
EBE 75 profiles have been designed to be painted with the powder coating technique in industrial ovens at temperatures of 180°C for 25 minutes. The thermal break area is not designed to absorb polyester powders and therefore it's advised to cover the visible areas with appropriate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

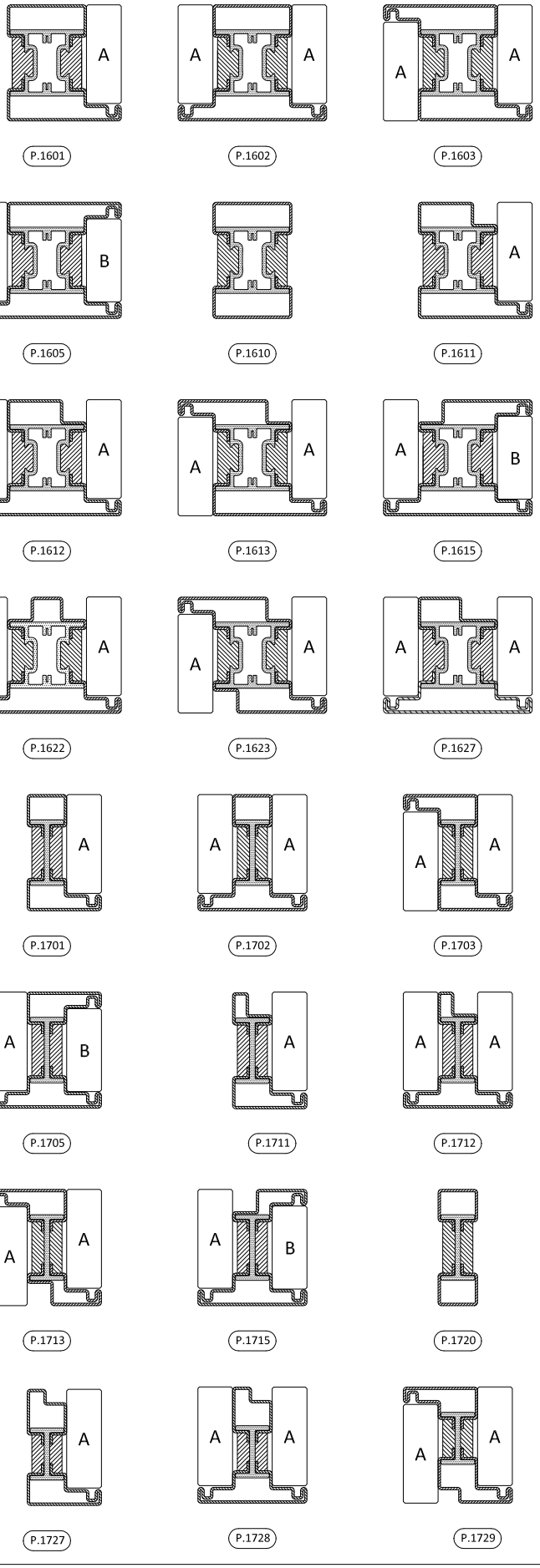
Glass application
Glass needs to be secured internally and externally. Internally, glazing beads must be used together with clips or bushings and then secured by pressure with the appropriate gasket; externally a continuous perimetrical gasket should be applied, jointed and sealed in a top corner or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

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

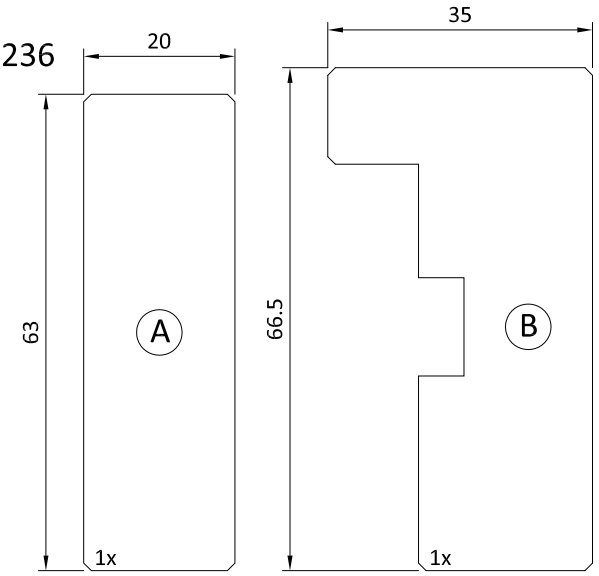
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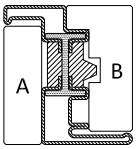

22
62.5
A
2x


22
52.5
B
1x


A
P.1601
A A
P.1602
A A
P.1603
A B
P.1605
P.1610
A
P.1611
A A
P.1612
A A
P.1613
A B
P.1615
A A
P.1622
A A
P.1623
A A
P.1627
A
P.1701
A A
P.1702
A A
P.1703
A B
P.1705
A
P.1711
A A
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A A
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A B
P.1715
P.1720
A
P.1727
A A
P.1728
A A
P.1729

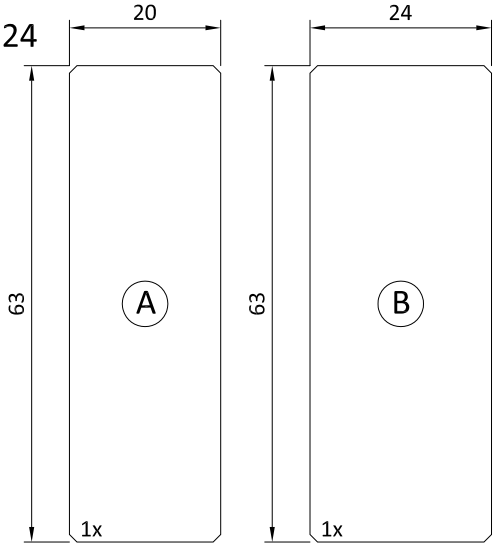
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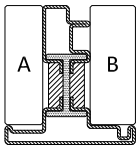




P.1233

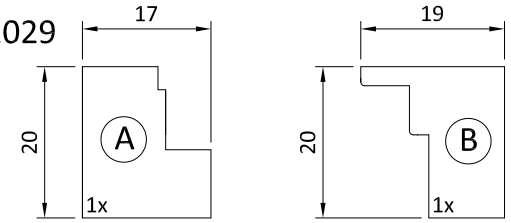
AT1724





P.1724

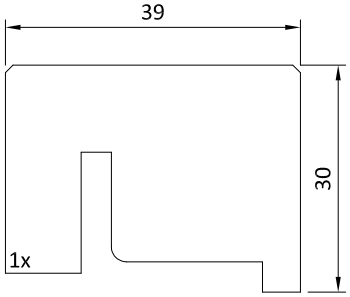
AT2029





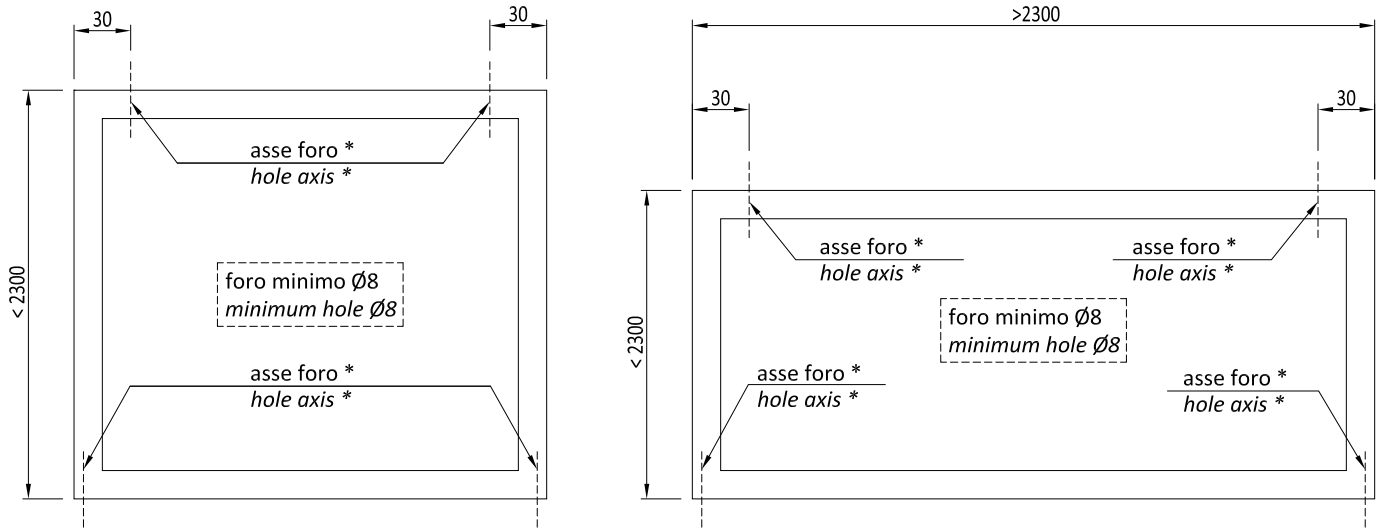
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AT2038





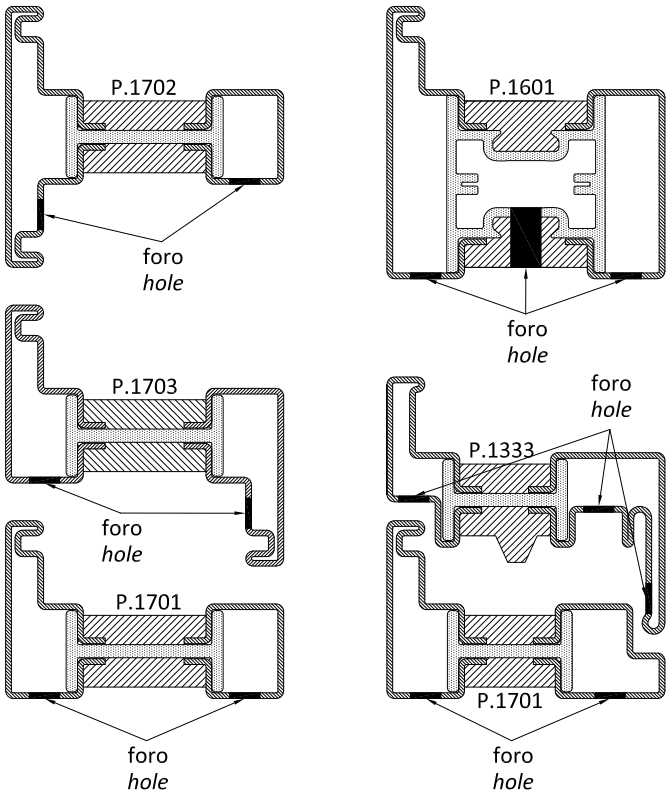
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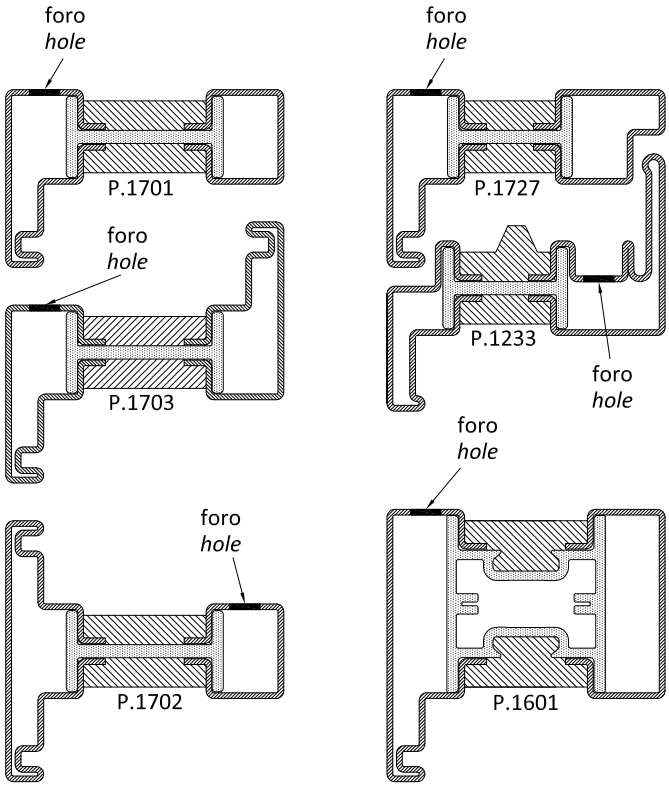
* forare alla massima estremità
** to be drilled on the extremity*

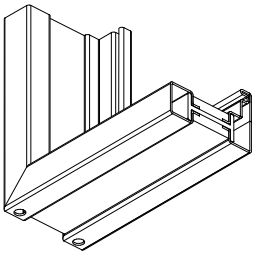
N.B. dimensioni orientamento telai indicative - da verificare con l'impianto di verniciatura/brunitura scelto
N.B. frame dimensions are indicative - they have to be checked with the powder painting / burnishing plant

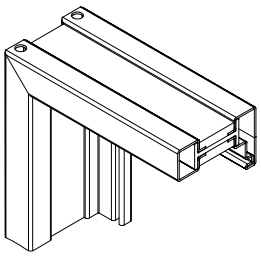
FORATURA LATO INFERIORE PER SCOLO LIQUIDI
DRILLING BOTTOM FRAME FOR LIQUID DRAINAGE

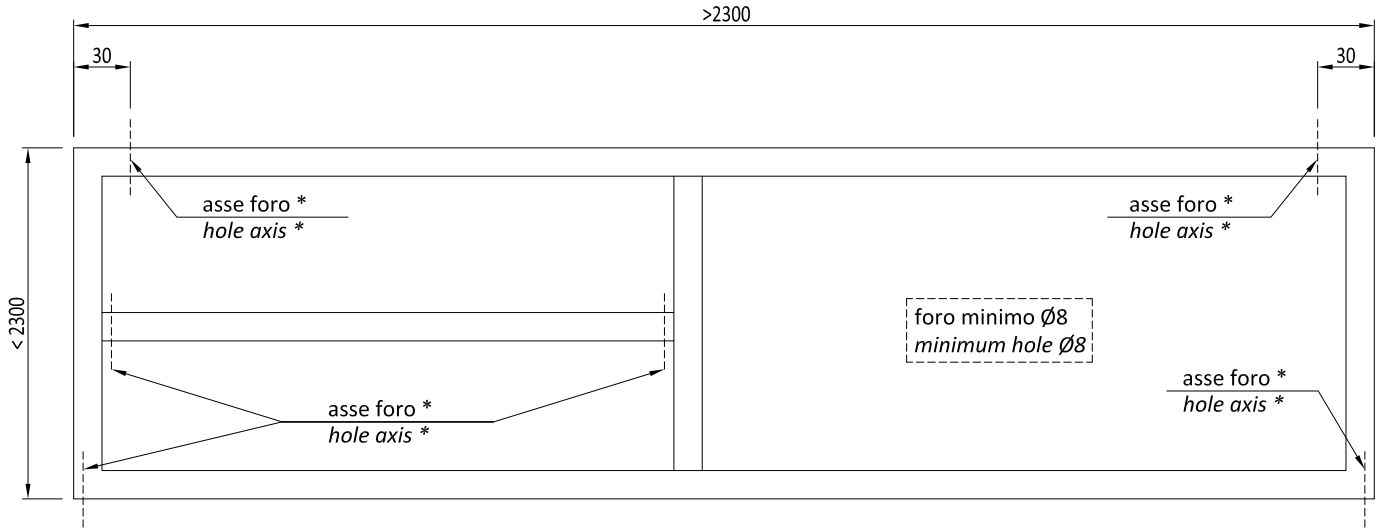


FORATURA LATO SUPERIORE PER APPENDERE
DRILLING UPPER FRAME FOR FRAME HANGING





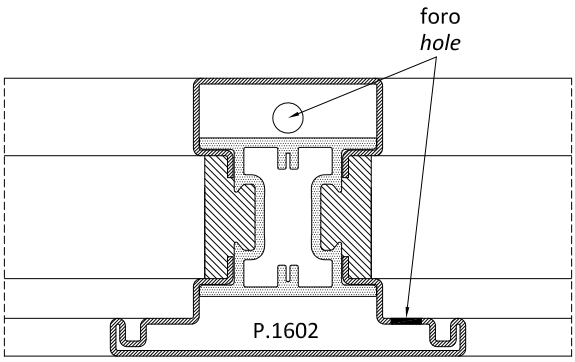


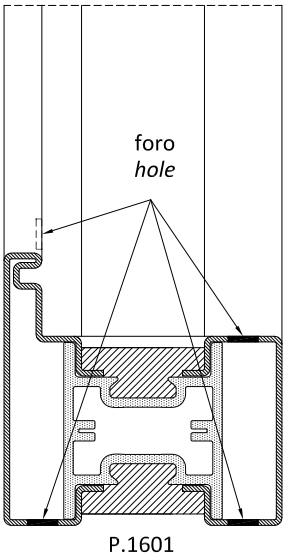


* forare alla massima estremità
** to be drilled on the extremity*

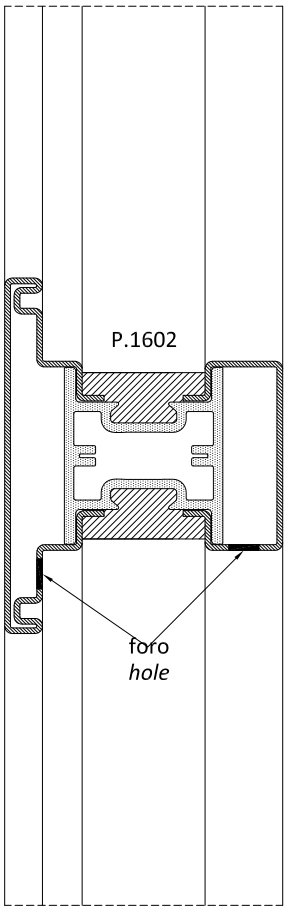
N.B. dimensioni orientamento telai indicative - da verificare con l'impianto di verniciatura/brunitura scelto
N.B. frame dimensions are indicative - they have to be checked with the powder painting / burnishing plant

FORATURA MONTANTI
DRILLING MULLION





FORATURA TRAVERSI
DRILLING TRANSOM



Troncatrice

caratteristiche minime della macchina

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

caratteristiche della lama

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

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

Pantografo

caratteristiche minime della macchina

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

caratteristiche minime delle frese

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

Forature

montaggio componenti di chiusura e movimentazione sui profilati in acciaio inox

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

fresatura di cave e asole sui profili inox

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

Cutter

Minimum requirements for the use of the machine

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

Blade specifications

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

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

Phantograph

Minimum requirements for the use of the machine

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

Minimum requirements for the use of a milling machine

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

Drilling

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

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

Milling slots and loops in the profiles

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

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

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

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

2. Taglio barre e controllo barre / *Cut and Control of profiles*
   - Misura lunghezza / *Length measurement* — ±0.5 mm
   - Verifica 45° / *45° Control* — ± 1°
   - Verifica 90° / *90° Control* — ± 1°

MATERIALI

ACCIAIO INOX
Materiale
Profilati ricavati da nastro di lamiera di acciaio inox laminato a freddo pre-trattato industrialmente per garantire la massima qualità e uniformità.
Caratteristiche fisiche
AISI 316L Marino (X2 CrNiMo 17-12-2)
Norme di riferimento
EN 10088-2; EU 114
Trattamenti superficiali
Finitura satinata: ottenuta su nastro AISI 304 con finitura superficiale 2B con successiva satinatura con abrasivi a grana 240-280.
Finitura lucida: ottenuta su nastro AISI 316L (marino) con finitura superficiale 2R, riflettività 53% e successiva lucidatura a specchio.
Finitura Scotch Brite: ottenuta su nastro AISI 316L (marino) con finitura superficiale 2B con successiva spazzolatura Scoth Brite.

ACCIAIO COR-TEN
Materiale
Profilati ottenuti da nastro in acciaio altoresistenziale, autopassivante (che un tempo veniva commercializzato con il nome Cor-Ten) tale da formare, se esposto all'aria, uno strato di ossido uniforme e stabile che, ricoprendo la lamiera, ne arresta la corrosione atmosferica.
Caratteristiche fisiche
Fe 510 X (C max % 0,12: Si % 0,25-0,75: Mn % 0,20-0,50: P % 0,07-0,15: Cu % 0,25-0,55: Cr % 0,30-1,25: Ni max % 0,65)
Norme di riferimento
EN 10149
Trattamenti superficiali
Dopo la profilatura il materiale viene immerso in speciali bagni ossidanti tali da accelerare la formazione dello strato protettivo. Raggiunta la tonalità desiderata della superficie si procede ad una ceratura di stabilizzazione del materiale.

ACCIAIO ZINCATO VERNICIATO
Materiale
Profilati ottenuti da nastro in lamiera di acciaio zincato a caldo sistema Sendzimir finitura skinpassata
Caratteristiche fisiche
FeP02 GZ 200 (copertura di zinco pari a 200gr/m^2 per faccia)
Norme di riferimento
UNI EN 10142/3/7; EURONORM 143
Trattamenti superficiali per la verniciatura
La preparazione del supporto zincato si effettua tramite i processi di sgrassaggio, decapaggio e lavaggio in acqua. Segue l'applicazione di uno strato di zinco per fosfatazione seguito da lavaggi in acqua demineralizzata. Infine applicazione della mano a finire con polveri poliestere cotte in forno a 180 °C per 25 minuti.

LEGA DI RAME OT67
Materiale
Profilati ottenuti da nastro di Lega di Rame OT67 laminato a freddo rincrudito allo stato grezzo.
Caratteristiche fisiche
Cu Zn 33 CW 506L (OT 67, 67% rame)
Norme di riferimento
EN 1652:1999
Trattamenti superficiali
Finitura brunita: dopo la profilatura viene eseguita una ricottura di distensione, quindi la pulitura meccanica con abrasivo e la successiva brunitura per immersione con liquido brunitore; il profilo viene poi lavato e asciugato ed infine protetto mediante trattamento con olio di vaselina.
Finitura lucida: dopo la profilatura viene eseguita una ricottura di distensione e successivamente la lucidatura a specchio.

MATERIALS

STAINLESS STEEL
Materials
Sections processed out of the cold-rolled coils, industrially pre-treated for utmost quality and uniformity.
Physical features
AISI 316L Marino (X2 CrNiMo 17-12-2)
Norms of reference
EN 10088-2; EU 114
Surface treatment
Satined: obtained on AISI 304 coil 2B pre-finish with post-treatment by means of abrasive 240-280 in grain size.
Polished: obtained on AISI 316L (marine) coil pre-finish with 2R surface finish, 53% reflectivity, and mirror post-polish.
Scotch Brite: obtained on AISI 316L (marine) coil 2B pre-finish with Scotch-Brite post-scrubbing.

CORTEN STEEL
Materials
Sections processed out of highly resistant self-oxidising steel coils – once traded under the name Cor-Ten. If exposed to the open air, it produces a uniform protective layer that reduces weather corrosion.
Physical features
Fe 510 X (C max % 0,12: Si % 0,25-0,75: Mn % 0,20-0,50: P % 0,07-0,15: Cu % 0,25-0,55: Cr % 0,30-1,25: Ni max % 0,65)
Norms of reference
EN 10149
Surface treatment
After forming, sections are plunged into a special oxydising bath to catalyze formation of the protective coating. Once the desired tone obtained, sections are stabilized by a wax coating.

GALVANIZED AND PAINTED STEEL
Materials
Sections processed out of hot galvanized steel coils, band "Sendzimir, skinpassed finishing.
Physical features
FeP02 GZ 200 (*with zinc coating of 200 gr/sq x m on both faces*)
Norms of reference
UNI EN 10142/3/7; EURONORM 143
Pre-painted surface treatment
The preparation of a galvanised surface in made through several processes: degreasing, pickling an washing. A coating of zinc is then applied through a phosphatising process followed by rinses in demineralised water. A final coat in then applied with polyester powders baked at 180 °C for 25 minutes.

COPPER ALLOY OT67
Materials
Sections processed out of copper alloy coils, industrially cold-rolled.
Physical features
Cu Zn 33 CW 506L (OT 67, 67% *copper* e 33% *zinc*)
Norms of reference
EN 1652:1999
Surface treatment
Burnished finish: after forming, the product is submitted to stress relieving, then to mechanical cleaning with abrasive products and ultimately to burnishing by plunging into a burnishing solution. It is then washed and dried and protected with a vaseline coating.
Glossy finish: after forming, the product is submitted to stress relieveing and then mirror-like polished.

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