

EBE 75

CATALOGO

TECNICO

TECHNICAL

CATALOGUE

The logo for the brand 'secco' is located in the bottom right corner. It consists of the word 'secco' in a white, lowercase, sans-serif font, set against a red background that is shaped like a right-angled triangle pointing towards the top right.

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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 poliuretana 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 la 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.

PRESTAZIONI

Sistema finestre

Trasmittanza termica (UNI EN 10077-2)

-Nodo tipo (acciaio inox) con $U_f=2,1 \text{ W/m}^2\text{K}$

-Finestra tipo (1230x1480 mm con $U_{g1,0}$) $U_w=1,5 \text{ W/m}^2\text{K}$

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 termico (EN14024)

-Classe CW / TC2

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.

PERFORMANCES

Windows system

Thermal transmittance (UNI EN 10077-2)

-Typical section (stainless steel) with $U_f=2,1 \text{ W/m}^2\text{K}$

-Typical window (1230x1480 mm with $U_{g1,0}$) $U_w=1,5 \text{ W/m}^2\text{K}$

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)

-Class 1 - < 100 N

Mechanical properties (UNI EN 13115)

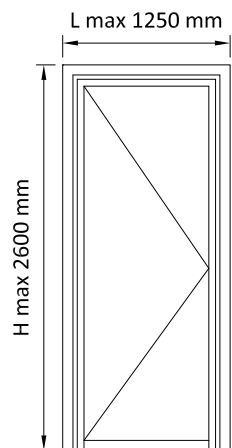
-Class 4 - 800 N / 350 N

Resistance to repeated opening and closing (UNI EN 12400)

-Class 2 - 10 000 opening and closing movements

Thermal break resistance of joint (EN12024)

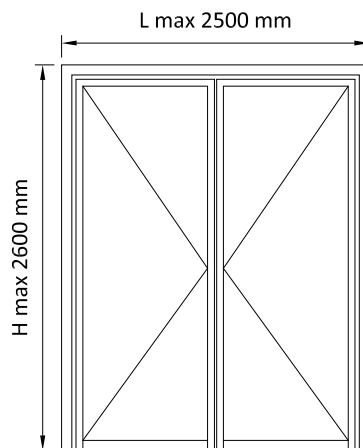
-Class CW / TC2

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

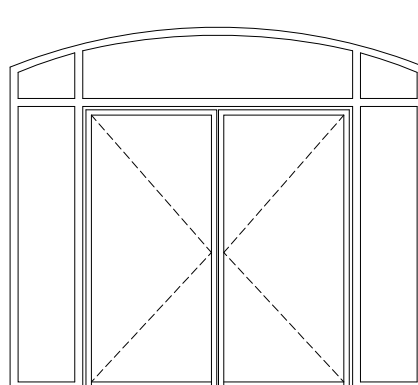
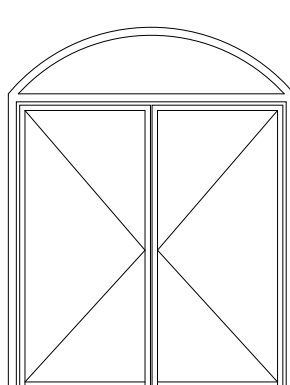
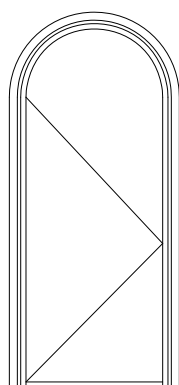
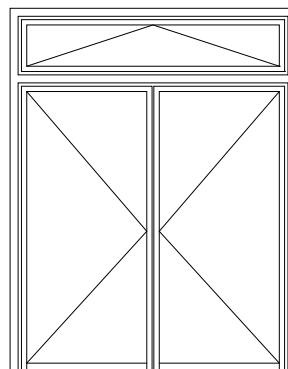
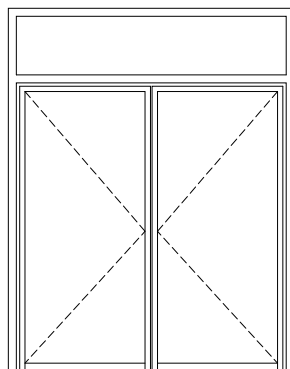
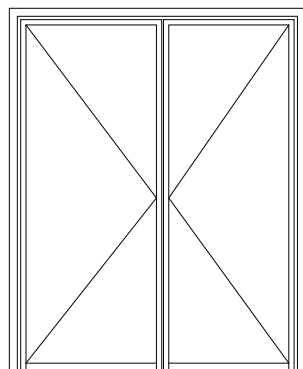
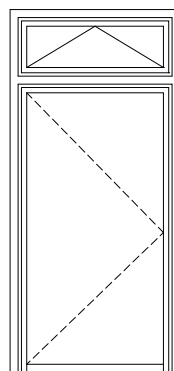
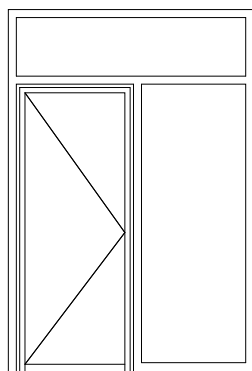
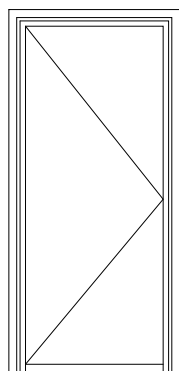


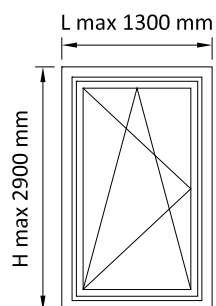
porta a due ante
two-leaf doors

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

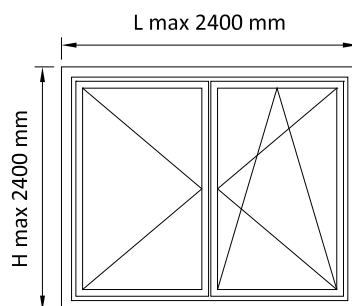
Limiti dimensionali - Maximum dimension

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

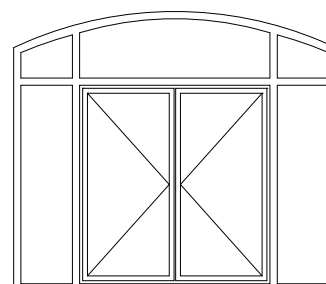
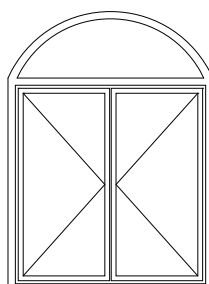
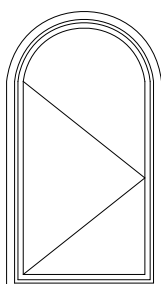
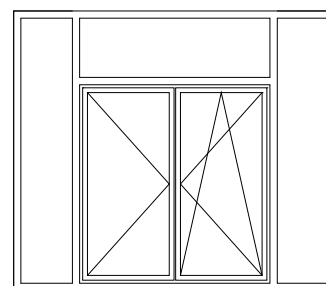
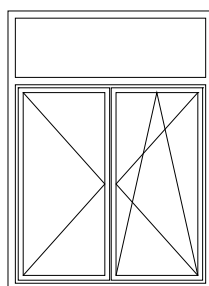
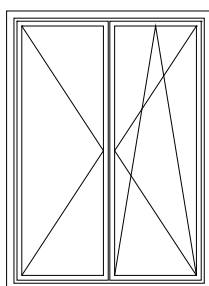
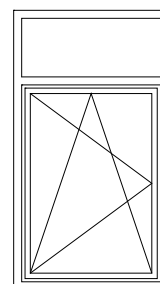
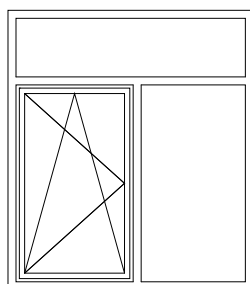
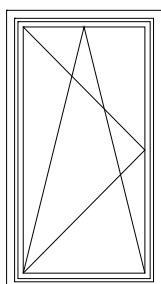
peso massimo anta
maximum leaf weight

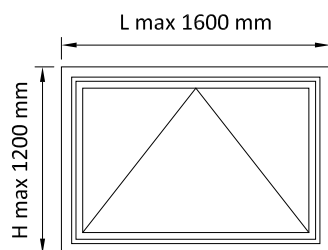
AGE281 - 130 kg

AGE282 - 130 kg

AGE785 - 130 kg

AGE786 - 130 kg

Esempi tipologie realizzabili - Types of window

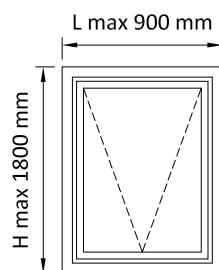
Limiti dimensionali - Maximum dimension

ferramenta e cremonese
hardware and cremone

finestra a vasistas
bottom-hung window

peso massimo anta
maximum leaf weight

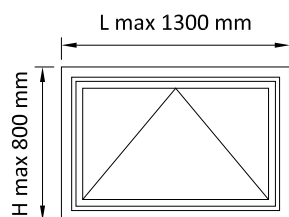
AG1264 - AG1274
AC2632/C - 100 kg



finestra a sporgere
awning window

peso massimo anta
maximum leaf weight

AC1046 - 75 kg
AC1046M - 120 kg

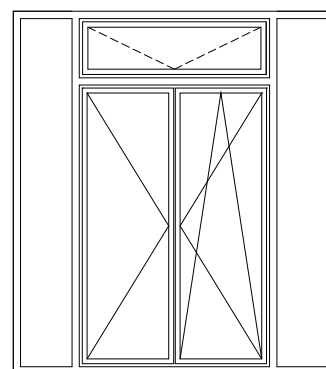
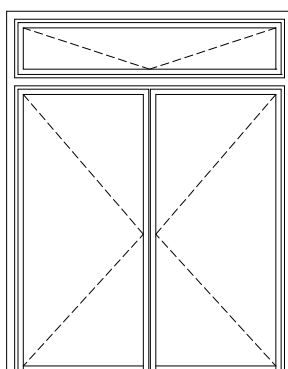
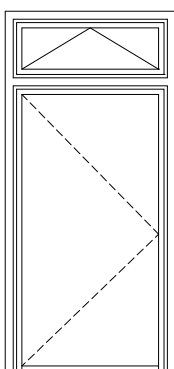
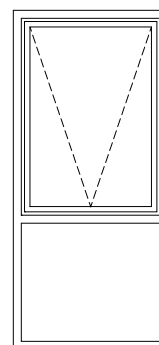
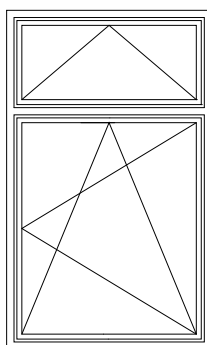
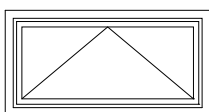


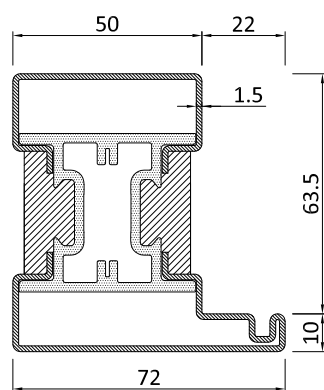
braccetti e cricchetto
stays and finger catch

finestra a vasistas
bottom-hung window

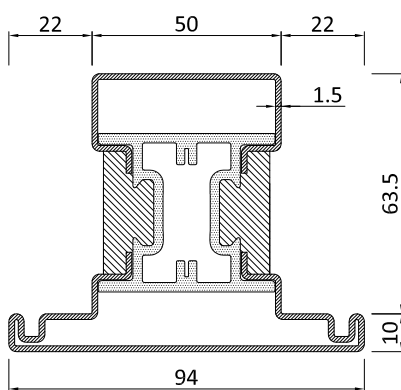
peso massimo anta
maximum leaf weight

AC1235
AC2632/C - 70 kg

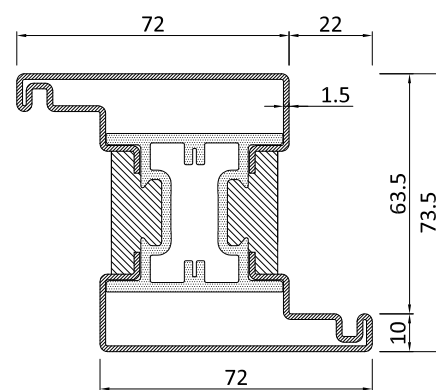
Esempi tipologie realizzabili - Types of window



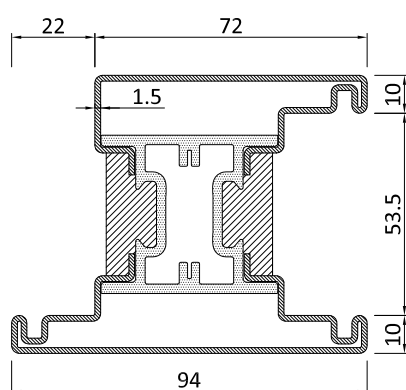
P.1601



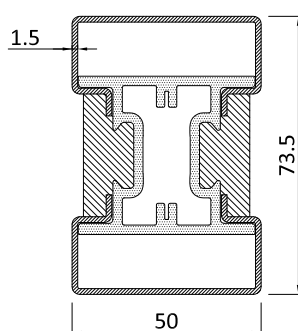
P.1602



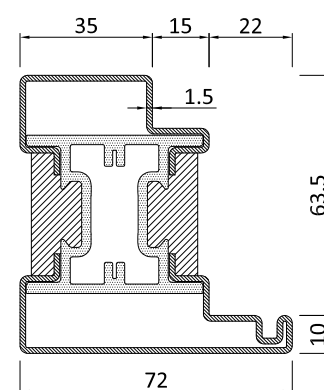
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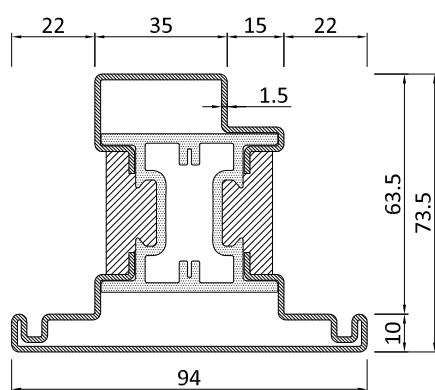
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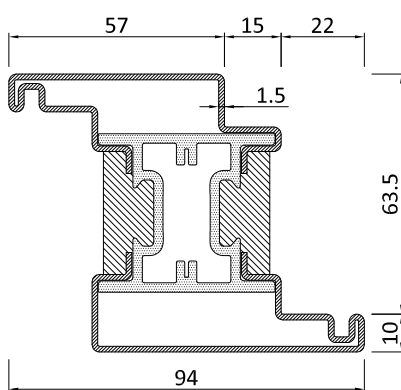
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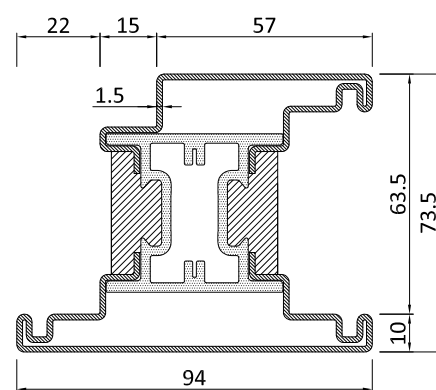
P.1611



P.1612

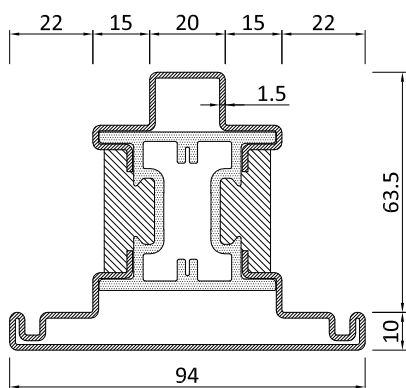


P.1613

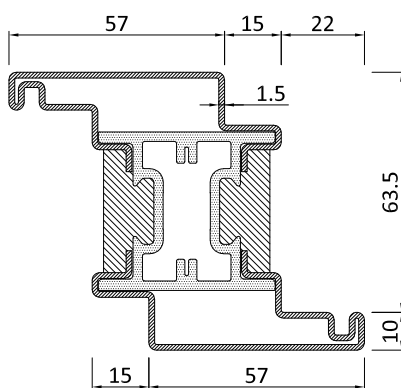


P.1615

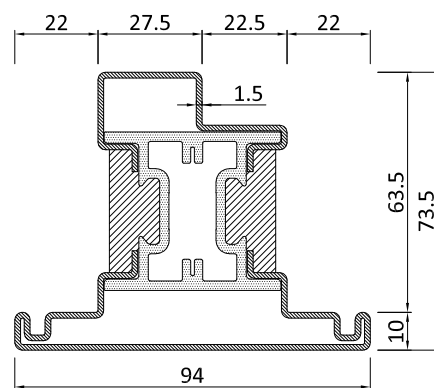
Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m	Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m
	ZN / I - CT	OT						ZN / I - CT	OT				
P.1601	4,59	4,50		25,24	21,92	6,0	P.1611	4,55	4,81		23,62	21,11	6,0
P.1602	5,13	5,43		27,63	37,36	6,0	P.1612	5,09	5,39		25,88	36,22	6,0
P.1603	5,16	5,48		30,04	34,49	6,0	P.1613	5,15	5,46		28,83	33,08	6,0
P.1605	5,70	6,06		33,18	47,37	6,0	P.1615	5,69	6,04		31,86	45,72	6,0
P.1610	4,02	4,22		21,49	12,17	6,0							



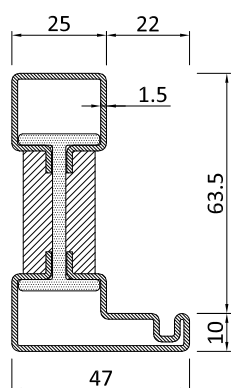
P.1622 Non fornito in acciaio zincato
Not in galvanized steel



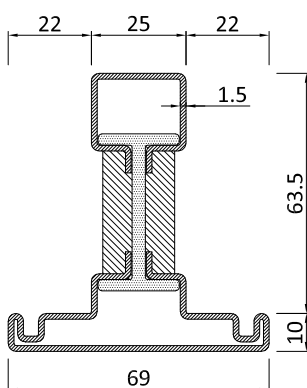
P.1623



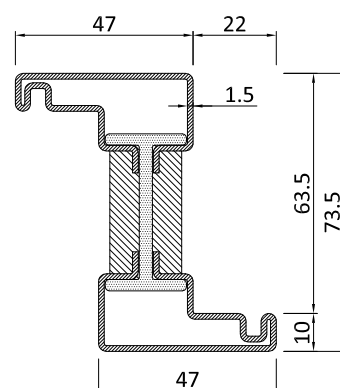
P.1627



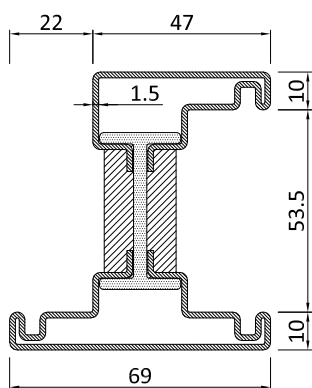
P.1701



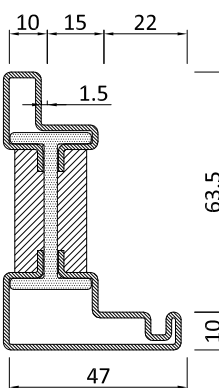
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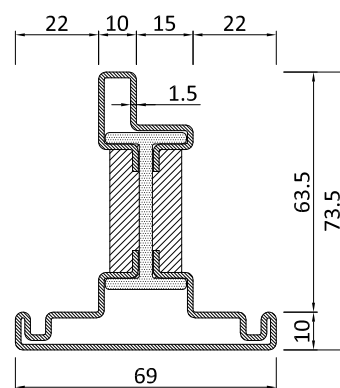
P.1703



P.1705

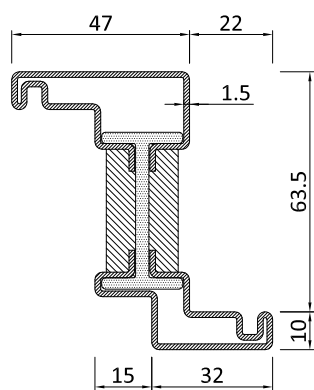


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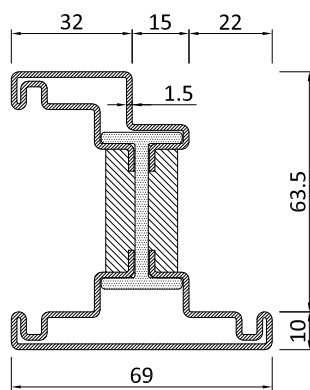


P.1712

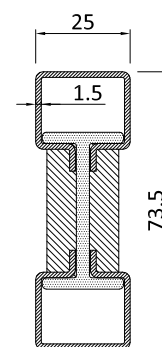
Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m	Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m
	ZN / I - CT	OT						ZN / I - CT	OT				
P.1622	5,15	5,46	0,38	24,05	35,22	3	P.1703	4,01	4,27	0,33	24,95	12,71	6
P.1623	5,14	5,44	0,38	27,65	31,70	6	P.1705	4,56	4,87	0,38	28,43	18,76	6
P.1627	5,13	5,43	0,38	25,00	36,05	3	P.1711	3,41	3,62	0,28	17,41	6,56	6
P.1701	3,43	3,64	0,28	19,26	6,59	6	P.1712	3,96	4,22	0,33	19,66	13,83	6
P.1702	3,98	4,24	0,33	19,28	14,14	6							



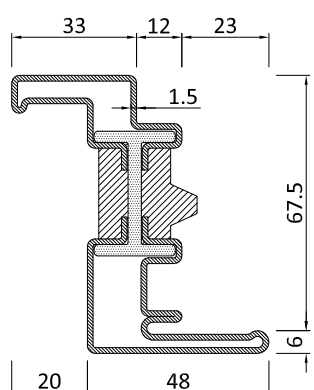
P.1713



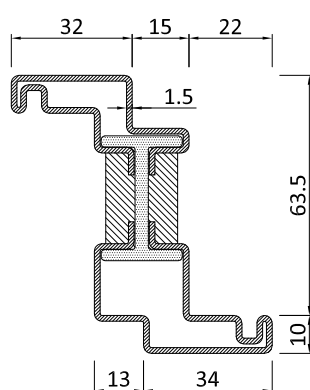
P.1715



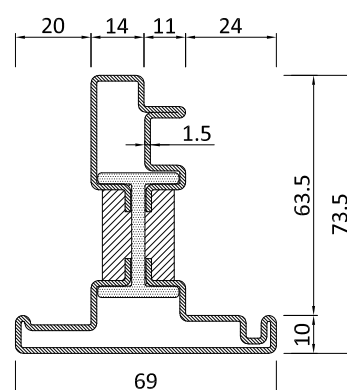
P.1720



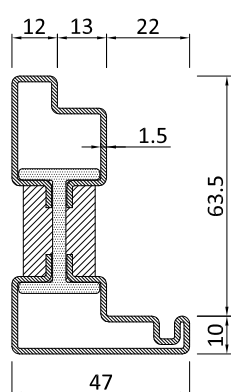
P.1233



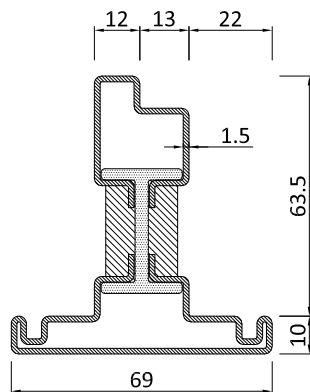
P.1723



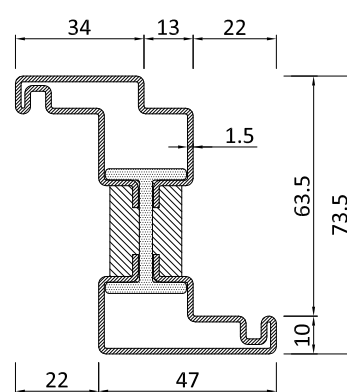
P.1724



P.1727

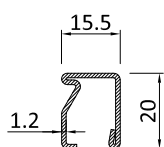


P.1728

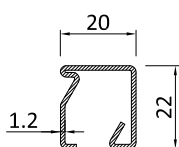


P.1729

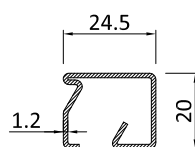
Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m	Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m
	ZN / I - CT	OT						ZN / I - CT	OT				
P.1713	3,96	4,22	0,33	23,64	12,21	6	P.1724	4,10	4,38	0,34	20,15	13,34	6
P.1715	4,51	4,82	0,38	26,96	18,06	6	P.1727	3,48	4,03	0,28	17,74	6,94	6
P.1720	2,85	3,01	0,23	15,15	2,16	6	P.1728	4,03	4,31	0,33	20,03	14,31	6
P.1233	4,21	4,50	0,35	24,52	9,86	6	P.1729	4,08	4,36	0,33	23,97	12,81	6
P.1723	4,03	4,31	0,33	22,71	12,31	6							



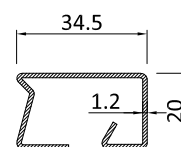
P.2007



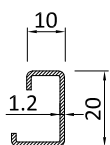
P.1007



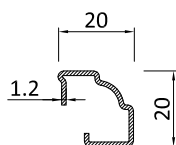
P.2008



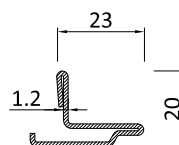
P.2009



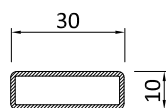
P.2015



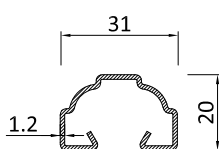
P.2028



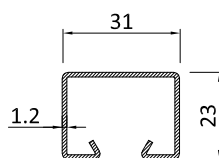
P.2038



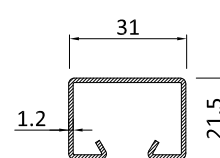
P.1234



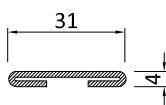
P.2030



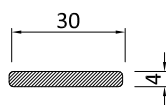
P.2031



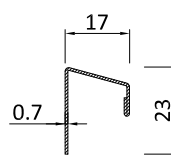
P.2032



P.2034



P.2035



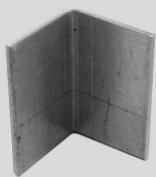
P.2027

MATERIALE | MATERIAL

PZ _ _ _ _ acciaio zincato | *galvanized steel*PC _ _ _ _ GZ acciaio corten grezzo | *untreated corten steel*PI _ _ _ _ ST acciaio inox satinato | *satined stainless steel*PI _ _ _ _ SB acciaio inox scotch brite | *scotch brite stainless steel*PI _ _ _ _ L3 acciaio inox lucido | *polished stainless steel*PB _ _ _ _ BR ottone grezzo | *untreated brass*

Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m
	ZN / I - CT	OT				
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		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m
	ZN / I - CT	OT				
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 | *satinated stainless steel*
AC1014SB inox scotch brite | *scotch brite st. steel*
AC1014L3 inox lucido | *polished stainless steel*
AC1014BR ottone naturale | *natural brass*

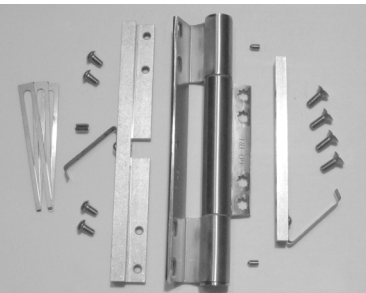
AC 1014

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



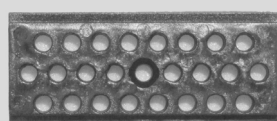
AC1037SB inox scotch brite | *scotch brite st. steel*
AC1037ST inox satinato | *satinated stainless steel*
AC1037L inox lucido | *polished stainless steel*
AC1037B inox brunito | *burnished stainless steel*

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

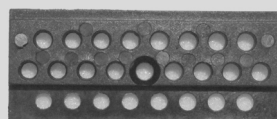
AISI 304



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

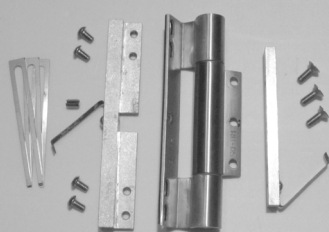
Glass spacer
Glass up to 22 mm



AC 1037/R

Rinforzo cerniera AC1037 su
profili ridotti

*Reinforcement for hinge AC1037
on reduced profiles*



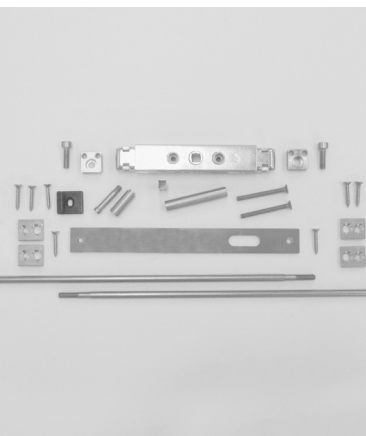
AC1033IZ inox verniciabile | *paintable stainless steel*
AC1033SB inox scotch brite | *scotch brite st. steel*
AC1033ST inox satinato | *satinated stainless steel*
AC1033L inox lucido | *polished stainless steel*
AC1033B inox brunito | *burnished stainless steel*
AC1033CZ corten grezzo | *untreated corten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

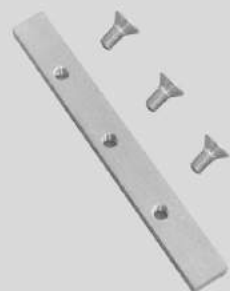
AISI 304



AC 1039

Kit cremone 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

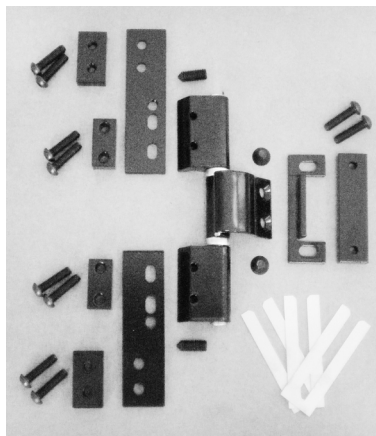
Second leaf door closing kit
Stainless steel



AC 1046

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

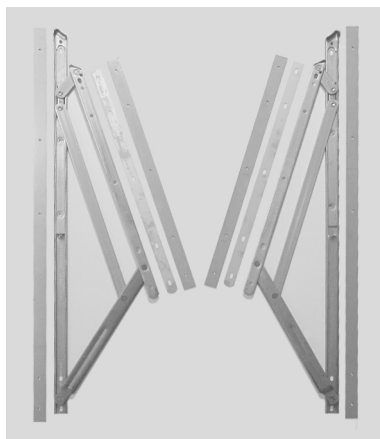
Pair of side arms for awning opening
Stainless steel
Maximum leaf weight: 75 kg



AC 1068

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

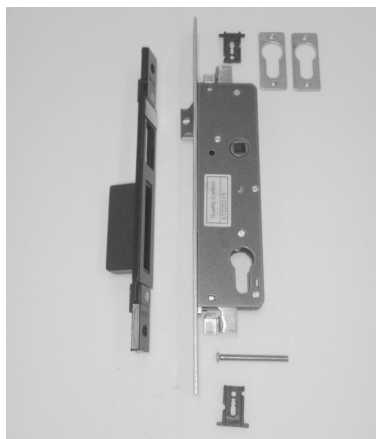
Concealed hinge for door
Maximum leaf weight: 180 kg
Maximum opening: 96°



AC 1046M

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

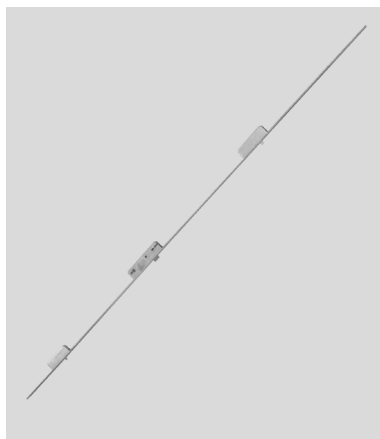
Pair of side arms for awning opening
Stainless steel
Maximum leaf weight: 120 kg



AC 1070

Serratura con scrocco e catenaccio

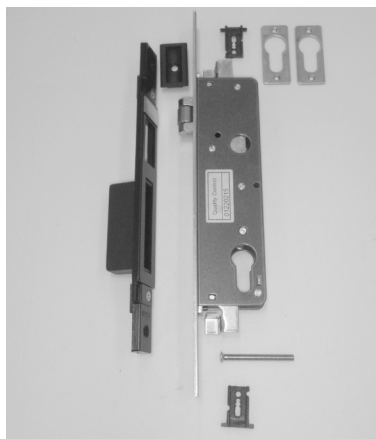
Lock with spring latch and bolt



AC 1065W D-S

Serratura multipunto
Altezza anta da 2000 a 2300 mm

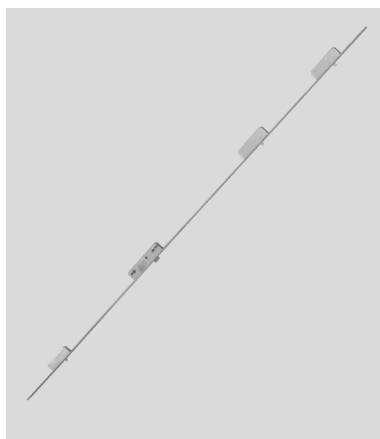
Multipoint lock
Leaf height from 2000 to 2300 mm



AC 1071

Serratura con rullo e catenaccio

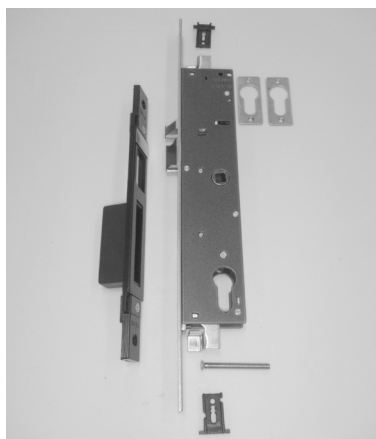
Lock with roller and bolt



AC 1067W D-S

Serratura multipunto
Altezza anta oltre 2900 mm

Multipoint lock
Leaf height over 2900 mm



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

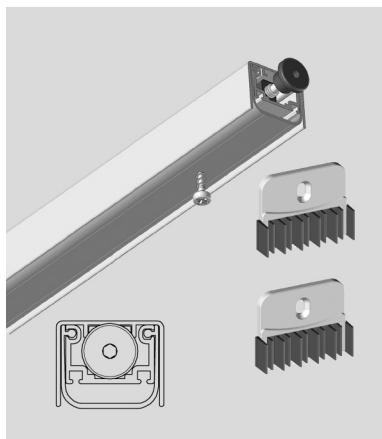
Friction stays for bottom-hung windows

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**mechanism for "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

**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

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

**AC 1219.**

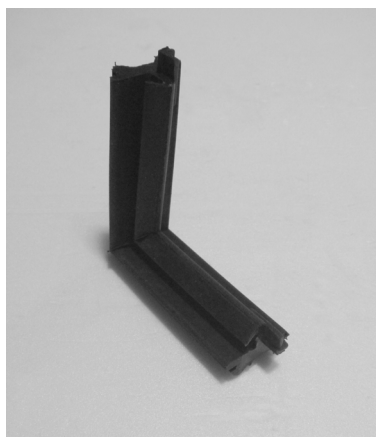
Scarico acqua per aperture interne in metallo

*Metal drip for inward openings***AC 1219NE**

Scarico acqua per aperture interne in plastica nera

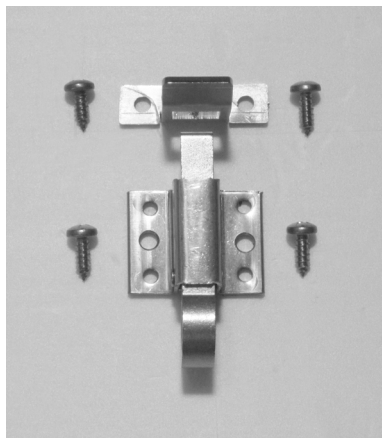
Black plastic drip for inward openings

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 1716**

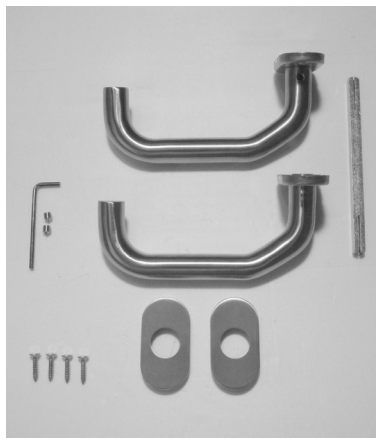
Guarnizione d'angolo vulcanizzata per GE1701

Vulcanised corner gasket for GE1701

**AC 1723I**

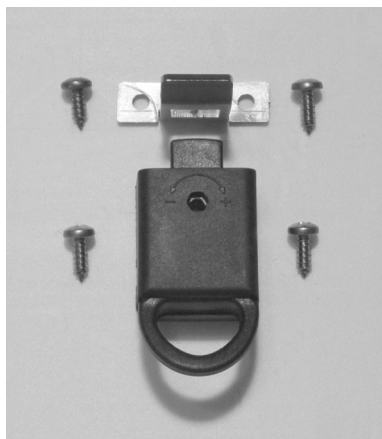
Cricchetto ed incontro da avvitare in acciaio inox, per vasistas

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**

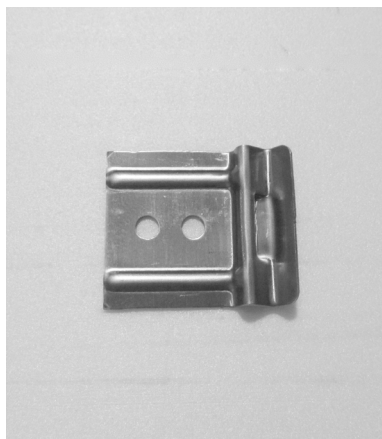
Cricchetto ed incontro da avvitare in nylon nero, per vasistas

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**

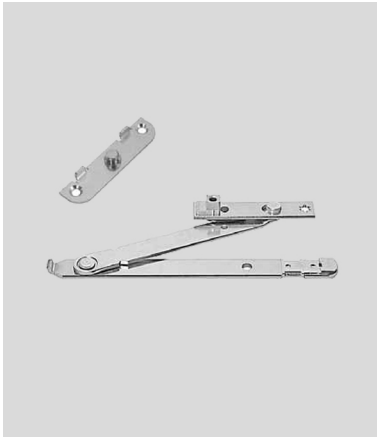
Cerniera registrabile a due ali in acciaio zincato a saldare | Ø 16
Peso massimo anta: 100 kg

*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*



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

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

CV 5001.

Vite per boccia fermavetri

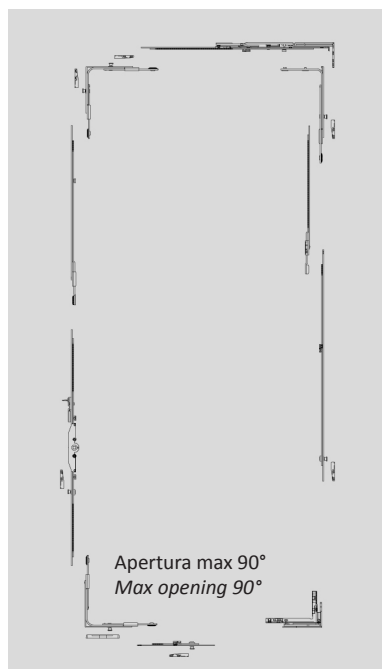
Screw for glazing bead bushing

TPS 4.2x16 mm

CV 5012.

Boccola per fermavetri

Bushing for glazing bead

**AGE 281**

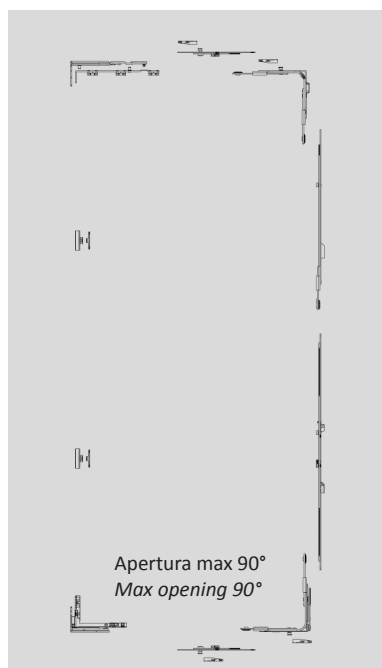
Meccanismo A/R prima anta Dx cerniere a scomparsa

*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								
		661 860	861 1000	1001 1200	1201 1400	1401 1600	1601 1800	1801 2000	2001 2200	2201 2400
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	F4	G4	H4	I4

Limiti dimensionali | LimitsPeso 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

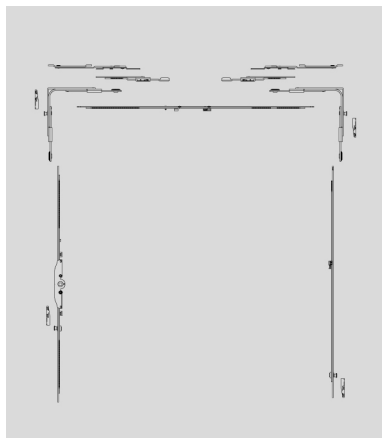
*Second leaf RH tilt-turn mechanism with concealed hinges***EASY****AGE 786**

Meccanismo A/R seconda anta Sx cerniere a scomparsa

*Second leaf LH tilt-turn mechanism with concealed hinges***EASY**

		altezza - height								
		661 860	861 1000	1001 1200	1201 1400	1401 1600	1601 1800	1801 2000	2001 2200	2201 2400
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	F4	G4	H4	I4

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

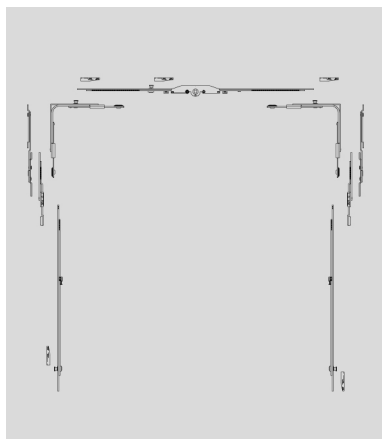
**AG 1264**

Meccanismo vasistas con cremonese su montante laterale

Bottom-hung window mechanism with lateral cremonese bolt set
EASY

altezza - height

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

Limiti dimensionali | LimitsPeso 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 cremonese bolt set
EASY

altezza - height

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

Limiti dimensionali | LimitsPeso 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 steel
Corner joint kit*

P.1611



AC 1008I

Kit per giunzione angolo
Acciaio inox

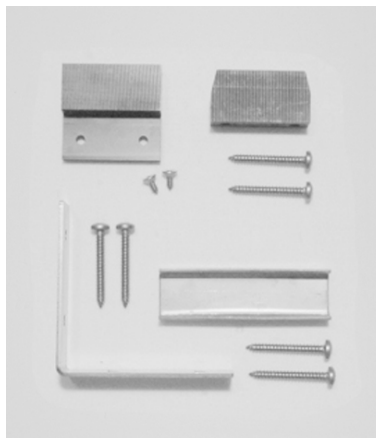
*Stainless steel
Corner joint kit*

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**

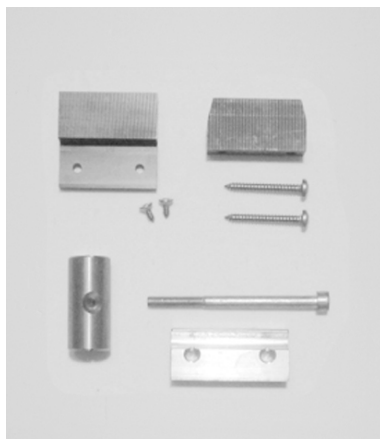
Kit per giunzione angolo
Acciaio inox

*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**

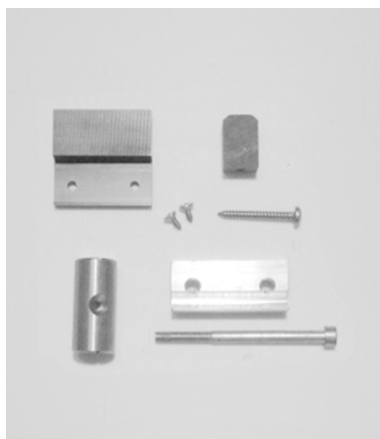
Kit per giunzione 90°
Acciaio inox

*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*

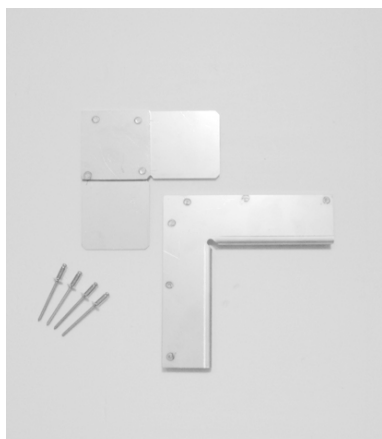
P.1233

**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

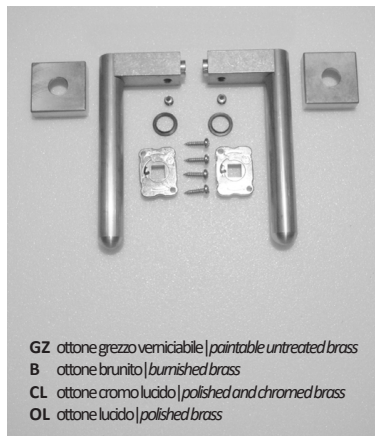
*Corner joint kit
Stainless steel*

P.1713 anta |leaf

**ACV 075**

Quadro per doppia maniglia

Spindle bar for double handle

**ACV 944**

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

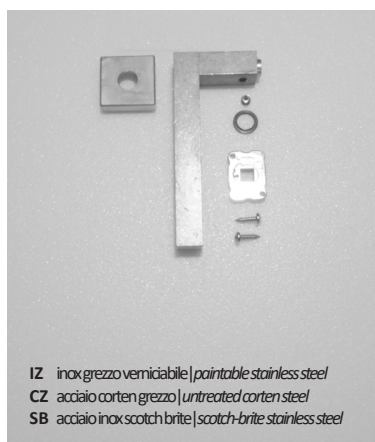
*Double door handlesets
"VITRUVIO" medium
square escutcheon
L | round | sphere*

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

**ACV 065/R**

Quadro per maniglia singola

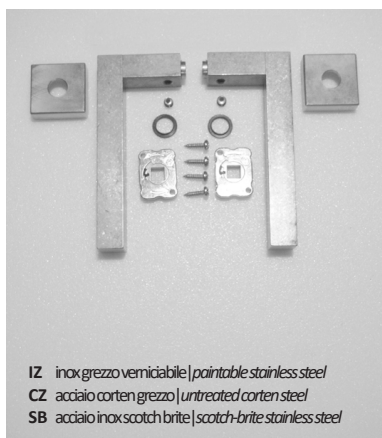
Spindle bar for single handle

**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*

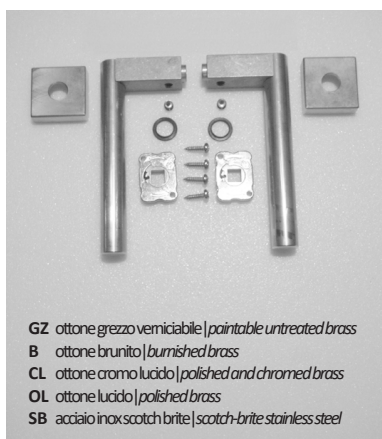
IZ inox grezzo verniciabile | paintable stainless steel
CZ acciaio corten grezzo | untreated corten steel
SB acciaio inox scotch brite | scotch-brite stainless steel

**ACV 948**

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

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

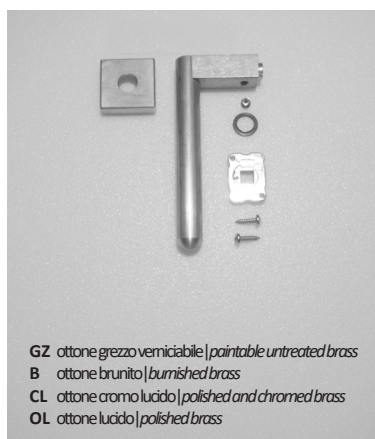
GZ ottone grezzo verniciabile | paintable untreated brass
B ottone brunito | burnished brass
CL ottone cromo lucido | polished and chromed brass
OL ottone lucido | polished brass
SB acciaio inox scotch brite | scotch-brite stainless steel

**ACV 943**

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

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

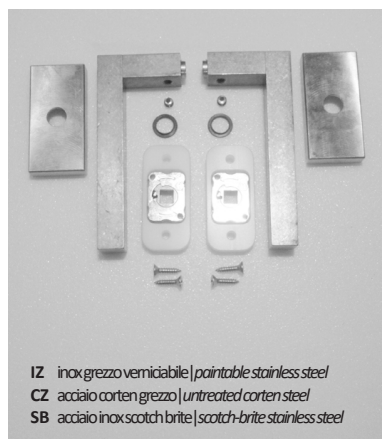
GZ ottone grezzo verniciabile | paintable untreated brass
B ottone brunito | burnished brass
CL ottone cromo lucido | polished and chromed brass
OL ottone lucido | polished brass
SB acciaio inox scotch brite | scotch-brite stainless steel

**ACV 949**

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

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

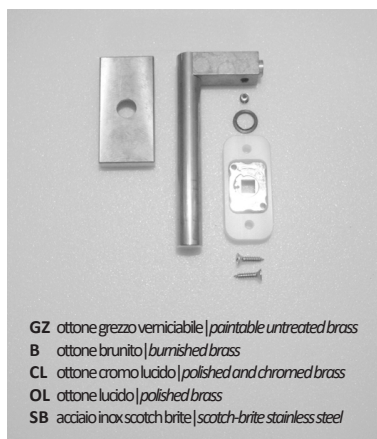
GZ ottone grezzo verniciabile | paintable untreated brass
B ottone brunito | burnished brass
CL ottone cromo lucido | polished and chromed brass
OL ottone lucido | polished brass

**ACV 952**

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

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

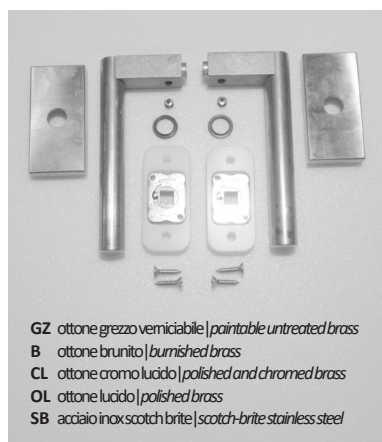
IZ inox grezzo verniciabile | paintable stainless steel
CZ acciaio corten grezzo | untreated corten steel
SB acciaio inox scotch brite | scotch-brite stainless steel

**ACV 958**

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

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

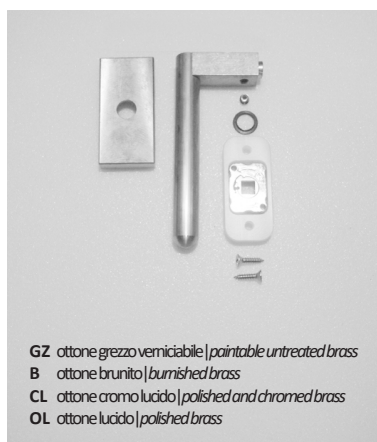
GZ ottone grezzo verniciabile | paintable untreated brass
B ottone brunito | burnished brass
CL ottone cromo lucido | polished and chromed brass
OL ottone lucido | polished brass
SB acciaio inox scotch brite | scotch-brite stainless steel

**ACV 953**

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

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

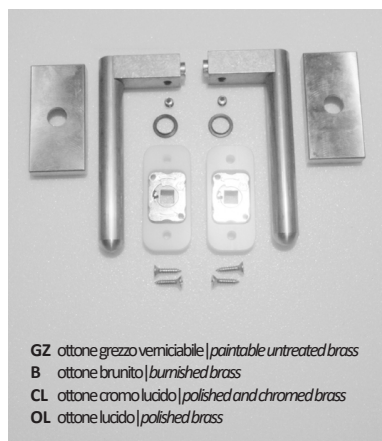
GZ ottone grezzo verniciabile | paintable untreated brass
B ottone brunito | burnished brass
CL ottone cromo lucido | polished and chromed brass
OL ottone lucido | polished brass
SB acciaio inox scotch brite | scotch-brite stainless steel

**ACV 959**

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

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

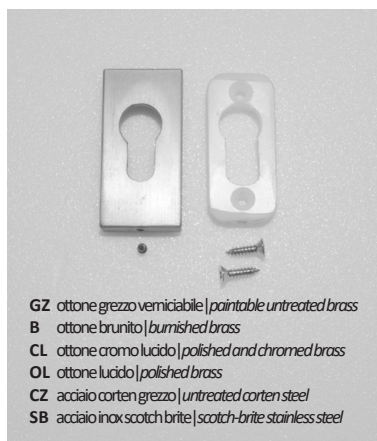
GZ ottone grezzo verniciabile | paintable untreated brass
B ottone brunito | burnished brass
CL ottone cromo lucido | polished and chromed brass
OL ottone lucido | polished brass

**ACV 954**

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

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

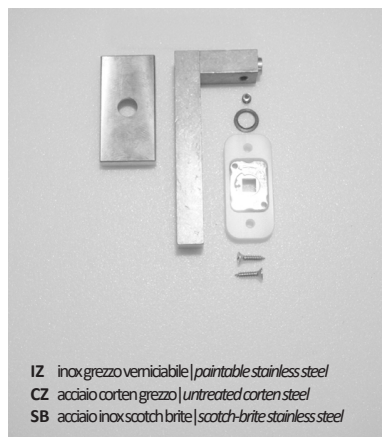
GZ ottone grezzo verniciabile | paintable untreated brass
B ottone brunito | burnished brass
CL ottone cromo lucido | polished and chromed brass
OL ottone lucido | polished brass

**ACV 964**

Bocchetta copri cilindro a profilo
europeo

*Euro profile cylinder escutcheon
plate*

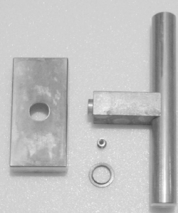
GZ ottone grezzo verniciabile | paintable untreated brass
B ottone brunito | burnished brass
CL ottone cromo lucido | polished and chromed brass
OL ottone lucido | polished brass
CZ acciaio corten grezzo | untreated corten steel
SB acciaio inox scotch brite | scotch-brite stainless steel

**ACV 957**

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

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

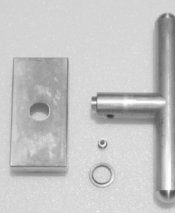
IZ inox grezzo verniciabile | paintable stainless steel
CZ acciaio corten grezzo | untreated corten steel
SB acciaio inox scotch brite | scotch-brite stainless steel

**ACV 971**

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

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

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 976**

Maniglia per DK finestra
"VITRUVIO" medium
KIDS

DK window handle
"VITRUVIO" medium
KIDS

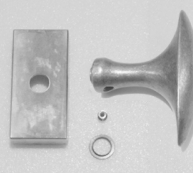
GZ ottone grezzo verniciabile | paintable untreated brass
B ottone brunito | burnished brass
CL ottone cromo lucido | polished and chromed brass
OL ottone lucido | polished brass

**ACV 972**

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

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

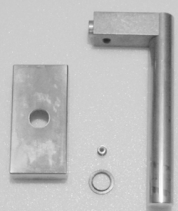
IZ inox grezzo verniciabile | paintable stainless steel
CZ acciaio corten grezzo | untreated corten steel
SB acciaio inox scotch brite | scotch-brite stainless steel

**ACV 977**

Maniglia per DK finestra
"VITRUVIO" medium
OVALE

DK window handle
"VITRUVIO" medium
OVALE

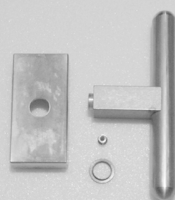
GZ ottone grezzo verniciabile | paintable untreated brass
B ottone brunito | burnished brass
CL ottone cromo lucido | polished and chromed brass
OL ottone lucido | polished brass

**ACV 973**

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

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

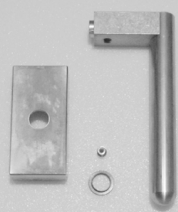
GZ ottone grezzo verniciabile | paintable untreated brass
B ottone brunito | burnished brass
CL ottone cromo lucido | polished and chromed brass
OL ottone lucido | polished brass
SB acciaio inox scotch brite | scotch-brite stainless steel

**ACV 979**

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

DK window handle
"VITRUVIO" medium
T | 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 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



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

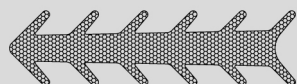
External gasket



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

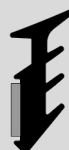
Internal gasket for windows



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

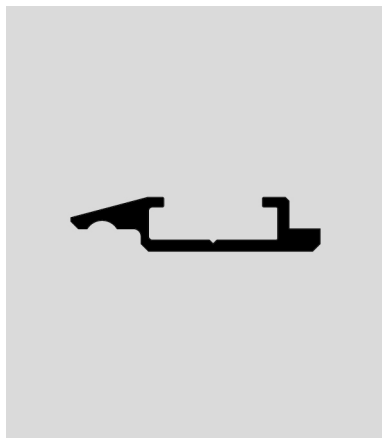
Gasket for glazing bead P.2028



GU 0120

Estruso in PVC porta spazzolino per porte

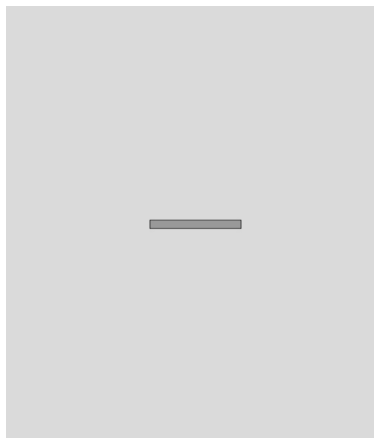
Extruded PVC brush holder for doors



GU 1702

Estruso rigido in PVC per
GE1701-GE1704

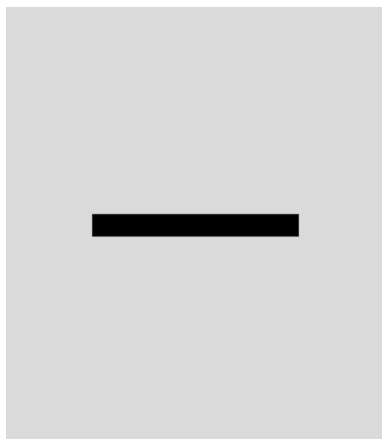
*Rigid extruded PVC section for
GE1701-GE1704*



GU 2032

Biadesivo per dividivetro
12x1 mm

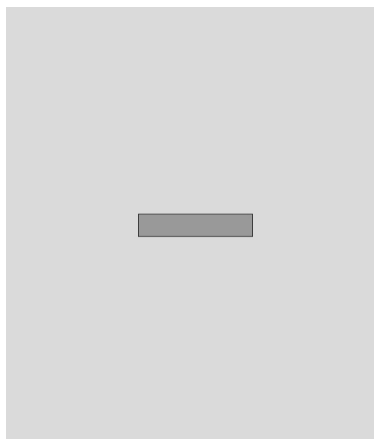
*Bi-adhesive tape for glass divider
12x1 mm*



GU 1711

Profilo in PVC per scarico acqua
aperture a sporgere

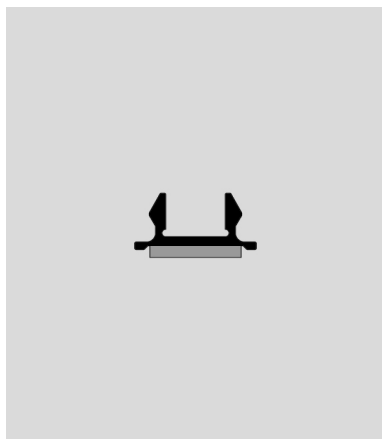
*PVC profile for water drain in
awning opening*



GU 2035

Piattina adesiva morbida per
fondo giunto esterno vetro
15x3 mm

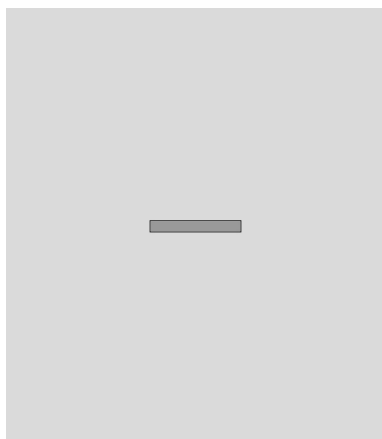
*Soft adhesive shim for external
window joint
15x3 mm*



GU 2030E

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

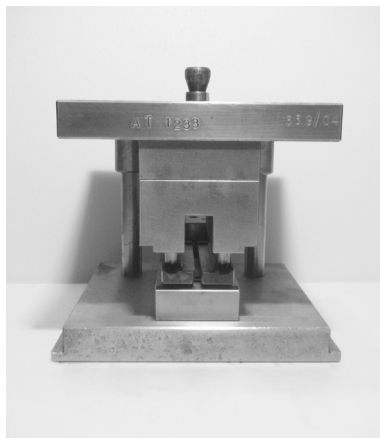
*PVC profile with double-sided
tape for fixing internal glass
divider on
P.2030 | P.2031 | P.2032*



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

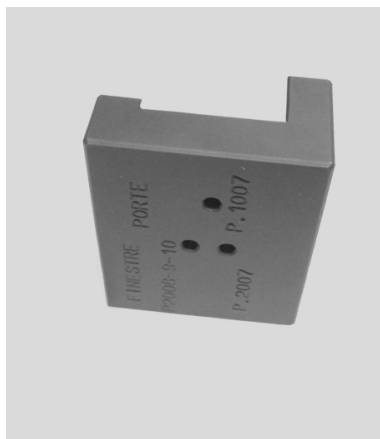
*Die for drilling holes for corner plate on profile
P.1233 | P.1724*



AT 1601

Maschera per esecuzione fori di fissaggio squadretta su profili maggiorati

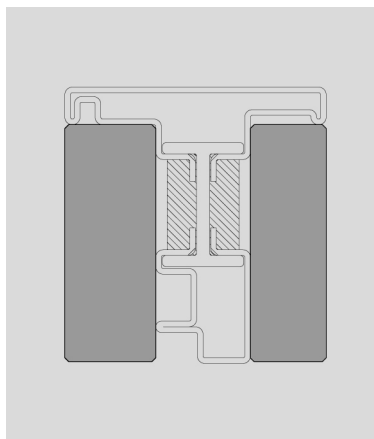
Jig for drilling holes for corner plate on oversize profiles



AT 1234

Maschera per esecuzione fori fissaggio fermavetri con boccole

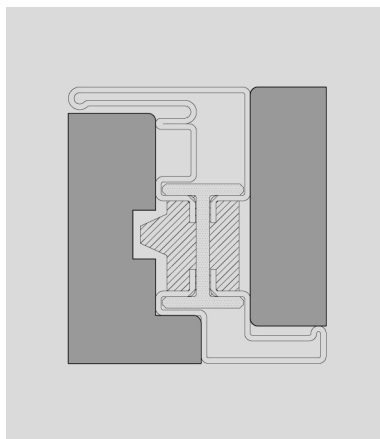
Jig for drilling holes for glazing bead with bushings



AT 1724

Ganasce di taglio per profilo
P.1724

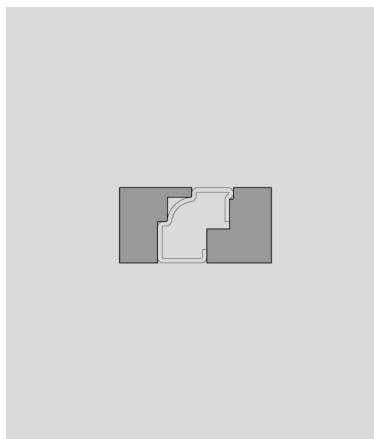
*Cutting jaws for
P.1724*



AT 1236

Ganasce di taglio per profilo
P.1233

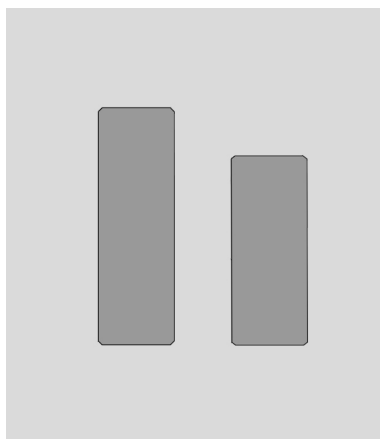
*Cutting jaws for
P.1233*



AT 2029

Ganasce di taglio per fermavetro
P.2028

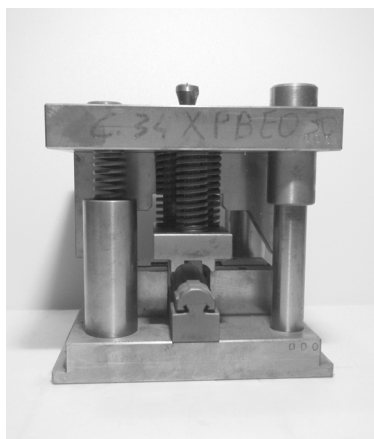
*Cutting jaws for glazing bead
P.2028*



AT 1600

Ganasce di taglio per profili
EBE 75

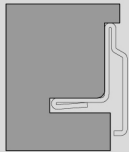
*Cutting jaws for profiles
EBE 75*



AT 2030

Stampo per intestatura
P.2030

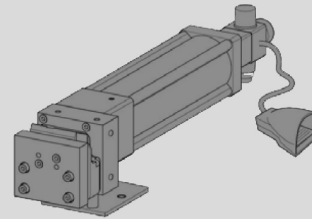
*Butt die for
P.2030*



AT 2038

Ganasce di taglio per
P.2038

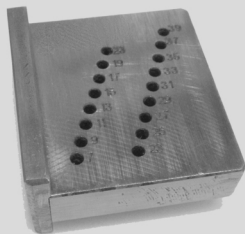
*Cutting jaws for
P.2038*



ATG 312

Trancia oleopneumatica

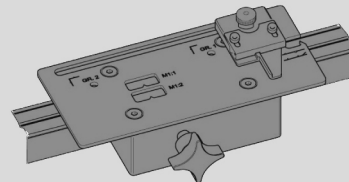
*Oil-pneumatic punching
machine*



AT 2828

Maschera per esecuzione fori
fissaggio fermavetri con clips

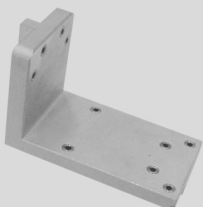
*Jig for drilling holes for glazing
bead with clips*



ATG 313

Asta millimetrata per trancia
oleopneumatica

*Rod divided into millimetres for
oil-pneumatic punching machine*

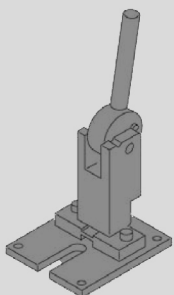


ATG 281

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

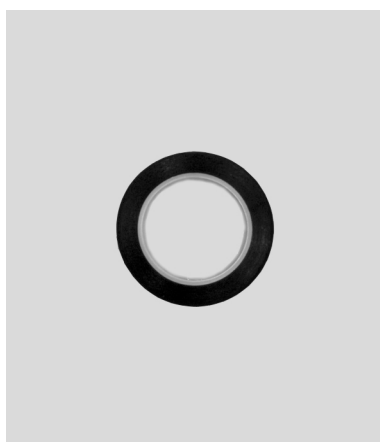
Liquido neritore per brunitura
10 Kg

*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**

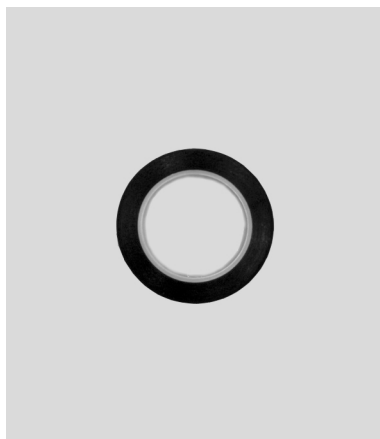
Nastro adesivo protettivo per
verniciatura
24 mm

*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

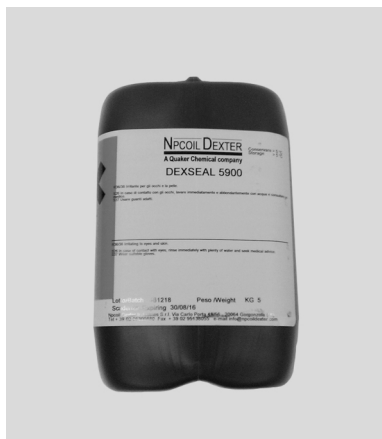
Oxidising acid for corten



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

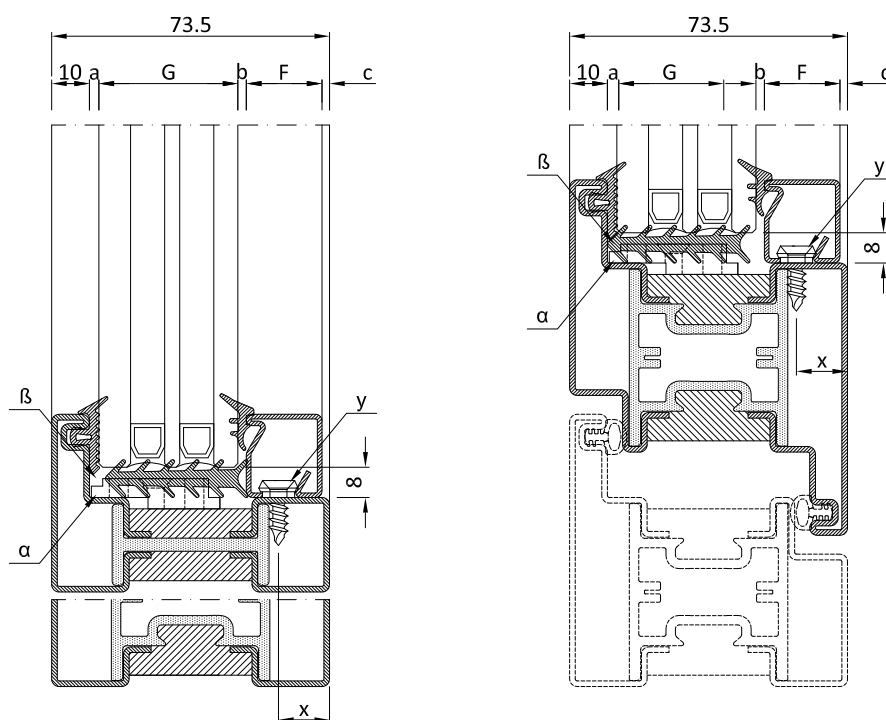


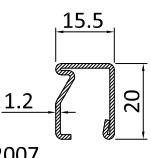
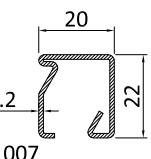
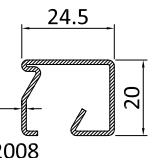
SL 0019

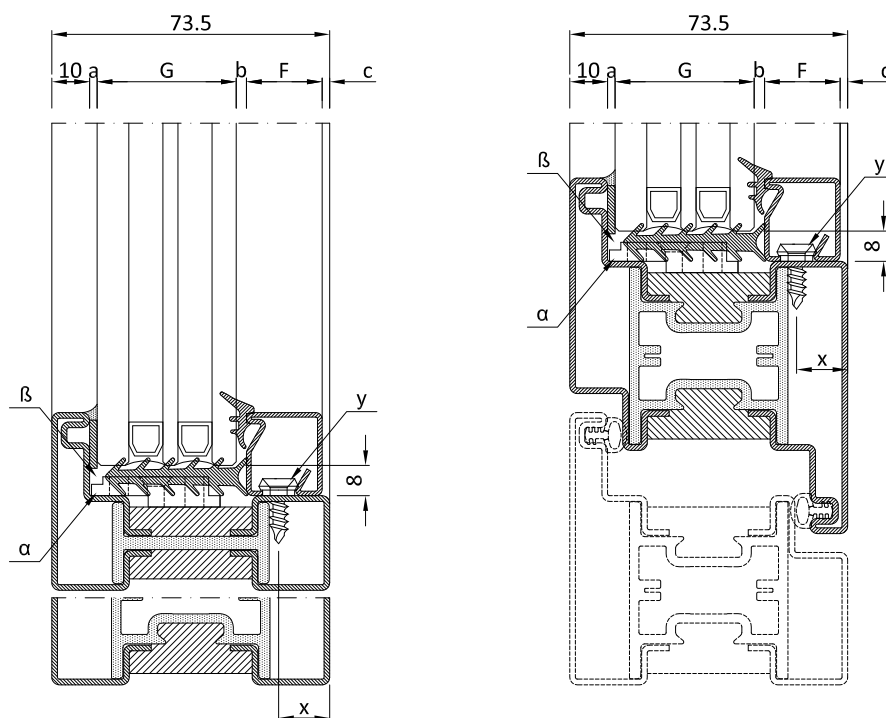
Sigillante a freddo per giunzione
angoli e trasversi

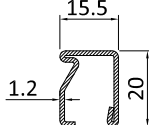
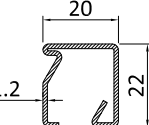
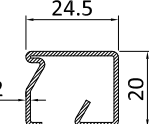
*Cold sealant for corner and
transom joints*

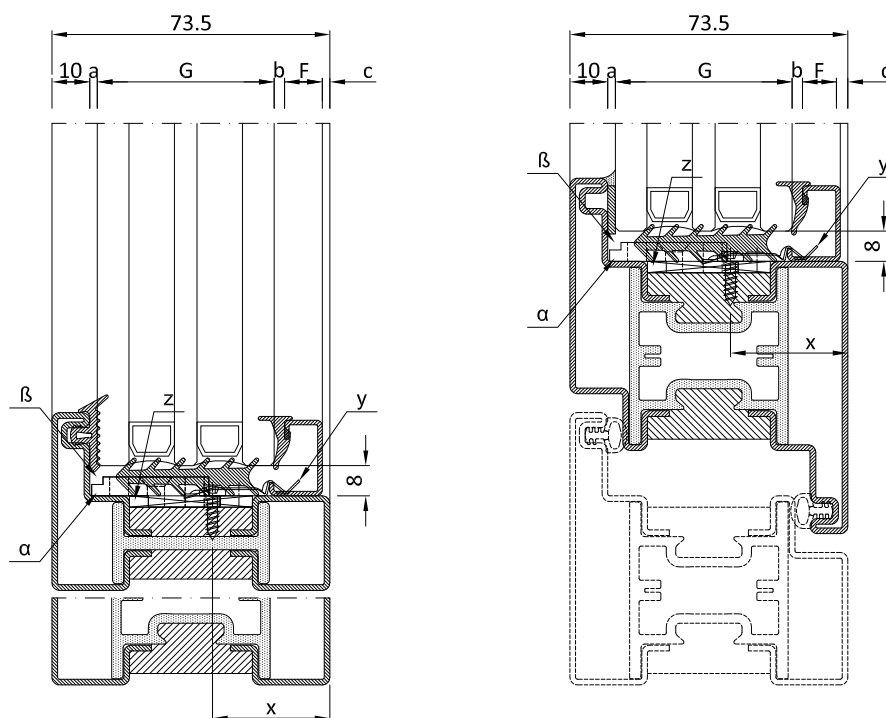
1 kg

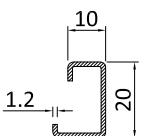


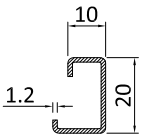
F	G	Guarnizioni - <i>gaskets</i>										
fermavetro <i>glazing bead</i>	range vetro <i>glass range</i>	GE1006 3 mm 	GP0095 2 / 3 mm 	GE1011 3 / 4 mm 	GE1012 6 / 8 mm 	GE1013 12 / 16 mm 	asse fissaggio viti fermavetro securing axis for screws for the glazing beads	rientro fermavetro glazing beads gap	boccole e viti fissaggio fermavetro Bushling 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	β	
 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 - <i>gaskets</i>										
fermavetro <i>glazing bead</i>	range vetro <i>glass range</i>	GU2035 2 mm  + sigillatura + <i>sealing</i>	GP0095 2 / 3 mm 	GE1011 3 / 4 mm 	GE1012 6 / 8 mm 	GE1013 12 / 16 mm 	asse fissaggio viti fermavetro <i>securing axis for screws for the glazing beads</i>	rientro fermavetro <i>glazing beads gap</i>	boccole e viti fissaggio fermavetro <i>Bushling and screws for glazing bead fixing</i>	spessore per vetro <i>glass shim</i>	guarnizione sotto vetro <i>under glass gasket</i>	
<i>Code</i>		a	b	b	b	b	x	c	y	α	β	
 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		-	-	-				-
34 - 35	33 - 34					29 - 31	21 - 25	16	0			

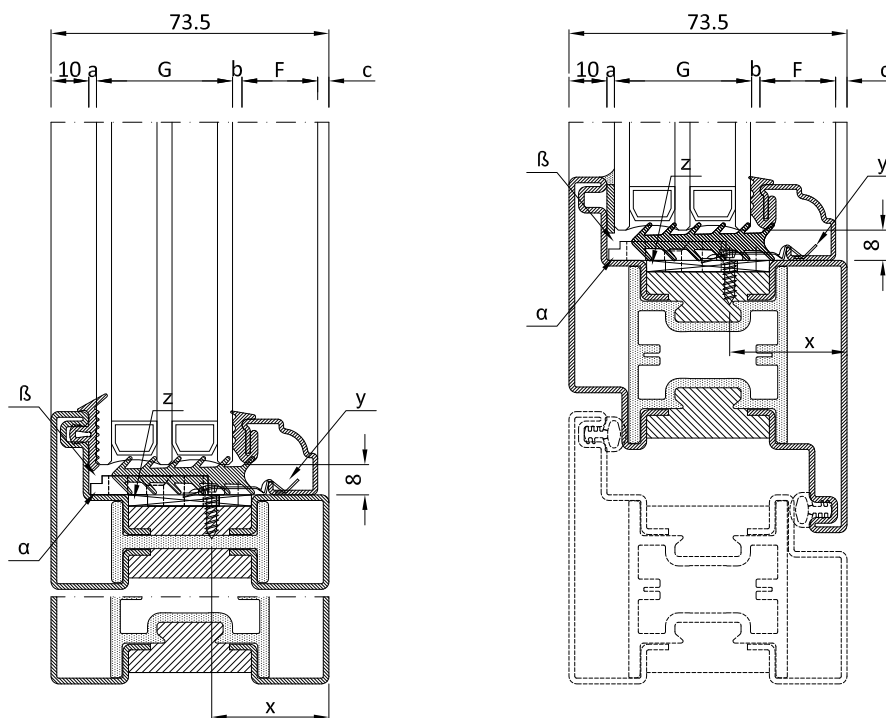


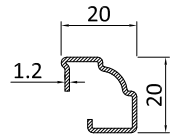
F		Guarnizioni - gaskets		G						
fermavetro glazing bead	range vetro glass range	GE1006 3 mm 	GP0095 3 mm 	spessore vetro glass thickness	asse fissaggio viti fermavetro securing axis for screws for the glazing beads	rientro fermavetro glazing beads gap	clips fissaggio fermavetro securing clips for glazing 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	β
 P.2015	45 - 47	3	3	45	31	2	AC2608	3 mm.	AC1020M	GE1007TT
				47	29	0				

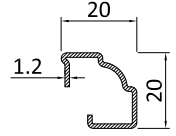
F		Guarnizioni - gaskets		G						
fermavetro glazing bead	range vetro glass range	GU2035 2 mm  + sigillatura + sealing	GP0095 3 mm 	spessore vetro glass thickness	asse fissaggio viti fermavetro securing axis for screws for the glazing beads	rientro fermavetro glazing beads gap	clips fissaggio fermavetro 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	β
 P.2015	46 - 48	2	3	46	31	2	AC2608	3 mm.	AC1020M	GE1007TT
				48	29	0				

*non fornito

*not included



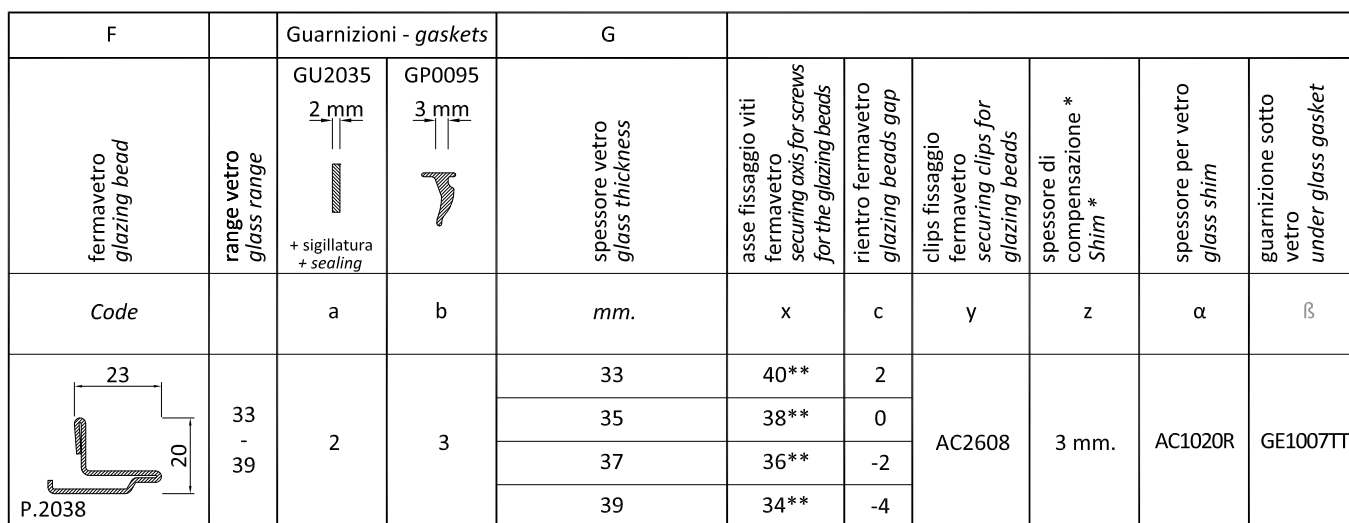
F		Guarnizioni - gaskets		G						
fermavetro glazing bead	range vetro glass range	GE1006 3 mm 	GE2028 2.5 mm 	spessore vetro glass thickness	asse fissaggio viti fermavetro securing axis for screws for the glazing beads	rientro fermavetro glazing beads gap	clips fissaggio fermavetro securing clips for 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	β
 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	β
 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

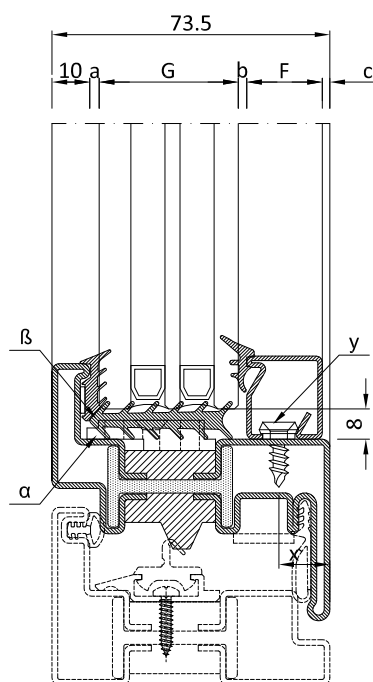
Taglio a 45° dei fermavetri effettuabile utilizzando la ganascia AT2029
45° cutting of the glazing beads done using the cutting jaw AT2029

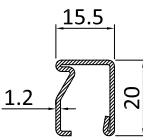
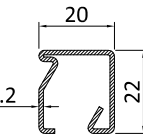
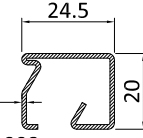
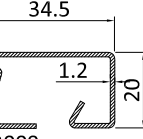


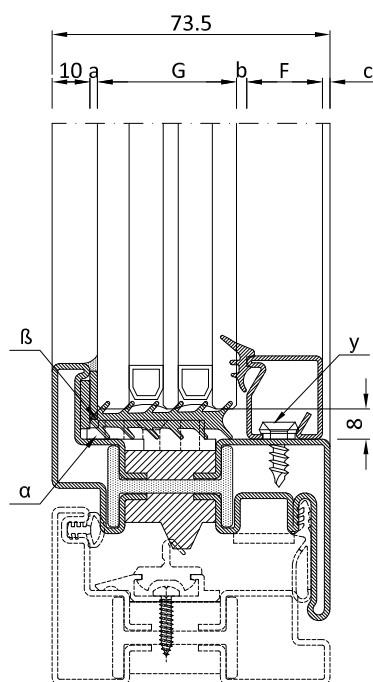
**** screw in the upper hole of the clip**

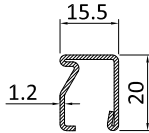
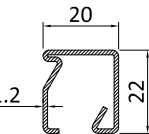
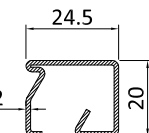
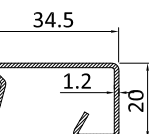


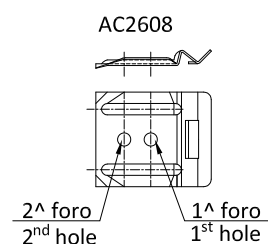
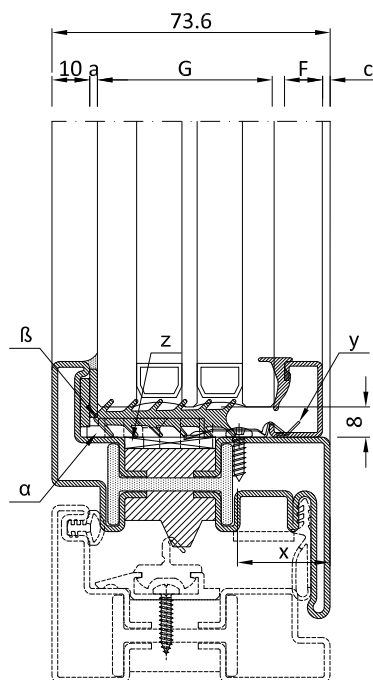
Applicazione fermavetri su sez. 73,5 mm - profili telaio / anta
Application of glazing beads on 73,5 mm section - frame / leaf profiles

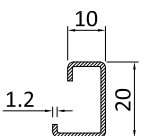


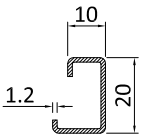
F	G	Guarnizioni - <i>gaskets</i>										
fermavetro glazing bead	range vetro glass range	GE1206 3 mm 	GP0095 2 / 3 mm 	GE1011 3 / 4 mm 	GE1012 6 / 8 mm 	GE1013 12 / 16 mm 	asse fissaggio viti fermavetro securing axis for screws for the glazing beads	rientro fermavetro glazing beads gap	boccole e viti fissaggio fermavetro Bushings 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	β	
 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 - <i>gaskets</i>												
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 Bushings 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	β			
 P.2007	28 - 44	2	41	40	36	28	9.5	2	CV5001(i) CV5012(i)	AC1020M	GE1007TT			
			-	-	-	-								
			42	41	38	32	7.5	0						
			-	-	-	-								
43	42		38	30	13.5	2	CV5001(i) CV5012(i)	AC1020M	GE1007TT					
-	-		-	-										
44	43		40	34	11.5	0				CV5001(i) CV5012(i)	AC1020M	GE1007TT		
-	-		-	-										
 P.1007	24 - 40		37	36	32	24	18	2	CV5001(i) CV5012(i)				AC1020M	GE1007TT
			-	-	-	-								
			38	37	34	28	16	0		CV5001(i) CV5012(i)	AC1020R	GE1007TT		
			-	-	-	-								
39	38		34	26	18	2	CV5001(i) CV5012(i)	AC1020M	GE1007TT					
-	-		-	-										
40	39		36	30	16	0				CV5001(i) CV5012(i)	AC1020R	GE1007TT		
-	-		-	-										
 P.2008	19 - 35	32	31	27	19	18	2	CV5001(i) CV5012(i)	AC1020M				GE1007TT	
		-	-	-	-									
		33	32	29	23	16	0			CV5001(i) CV5012(i)	AC1020R	GE1007TT		
		-	-	-	-									
34	33	29	21	18	2	CV5001(i) CV5012(i)	AC1020M	GE1007TT						
-	-	-	-											
35	34	31	25	16	0				CV5001(i) CV5012(i)	AC1020R	GE1007TT			
-	-	-	-											
 P.2009	18 - 25	22	21	18 min.	-	18	2	CV5001(i) CV5012(i)				AC1020R	GE1007TT	
		-	-	-	-									
		23	22	19	-	16	0		CV5001(i) CV5012(i)	AC1020R	GE1007TT			
		-	-	-	-									
24	23	21	-	16	0	CV5001(i) CV5012(i)	AC1020R	GE1007TT						
-	-	-	-											
25	24	-	-	16	0				CV5001(i) CV5012(i)	AC1020R	GE1007TT			
-	-	-	-											

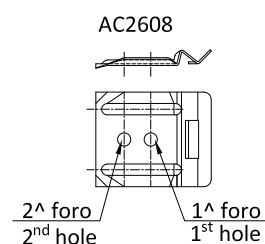
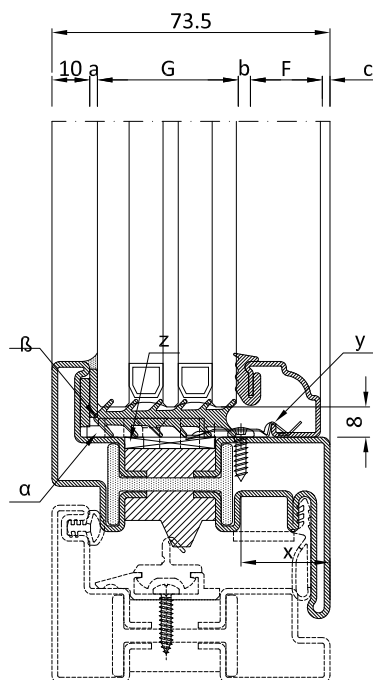


		Guarnizioni - gaskets		G						
fermavetro glazing bead	range vetro glass range	GE1206 3 mm 	GP0095 3 mm 	spessore vetro glass thickness	asse fissaggio viti fermavetro securing axis for screws for the glazing beads	rientro fermavetro glazing beads gap	clips fissaggio fermavetro securing clips for glazing 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	β
 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	β
 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	β
 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	β
 P.2028	33 - 39	2	2.5	33	34	6	AC2608	3 mm.	AC1020M	GE1007TT
				35	25**	4				
				37	23**	2				
				39	21**	0				

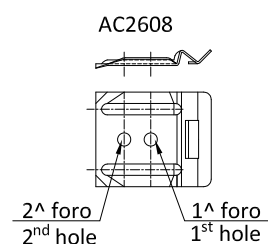
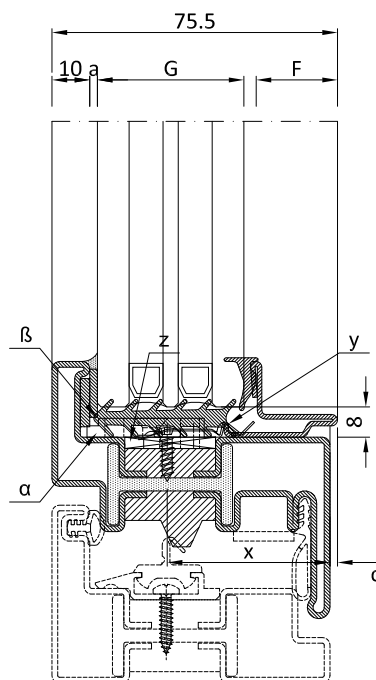
*non fornito

*not included

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

** 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 	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	β
 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	β
 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

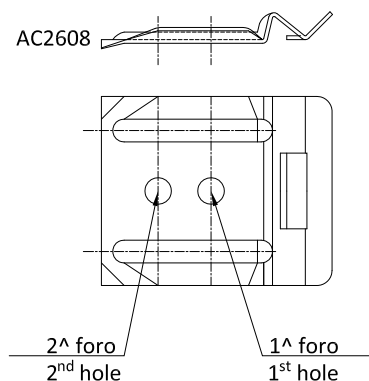
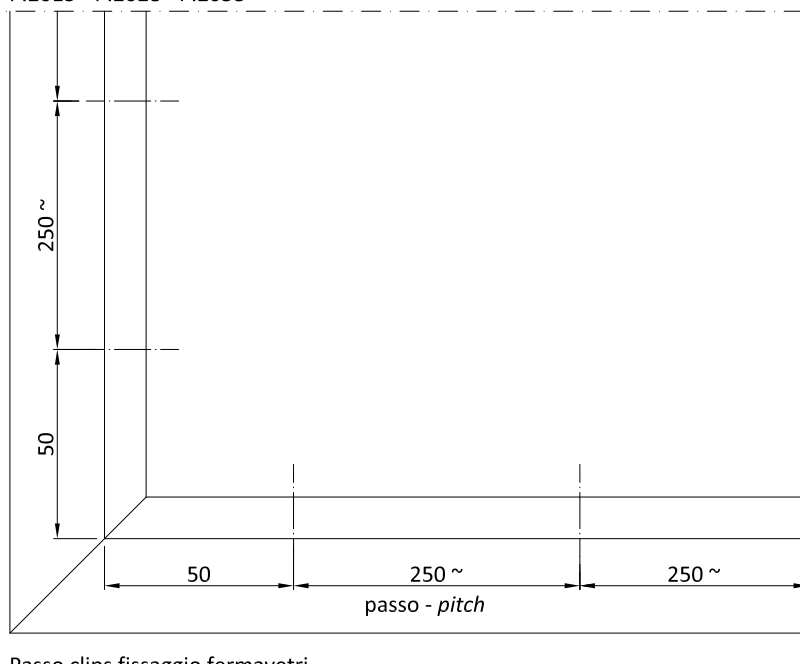
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Taglio a 45° dei fermavetri effettuabile utilizzando la ganascia AT2038
45° cutting of the glazing beads done using the cutting jaw AT2038

** fissare tramite il primo foro della clip

** screw in the upper hole of the clip

P.2015 - P.2028 - P.2038

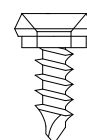
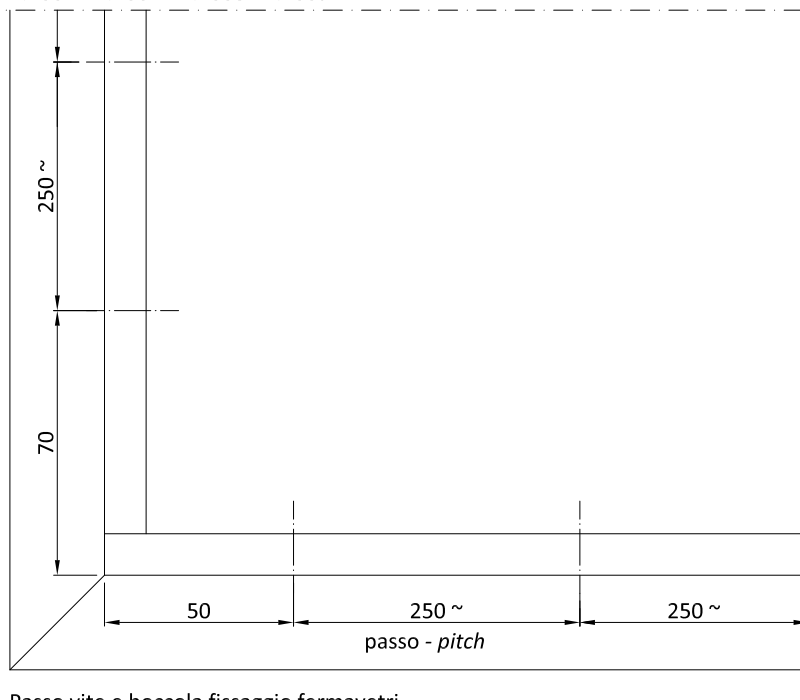


Passo clips fissaggio fermavetri
Clip pitch for fixing the glazing beads

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

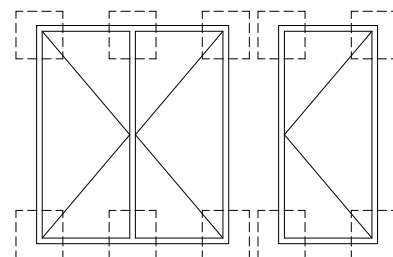
P.2007 - P.1007 - P.2008 - P.2009



CV5001 + CV5012
CV5001I + CV5012I

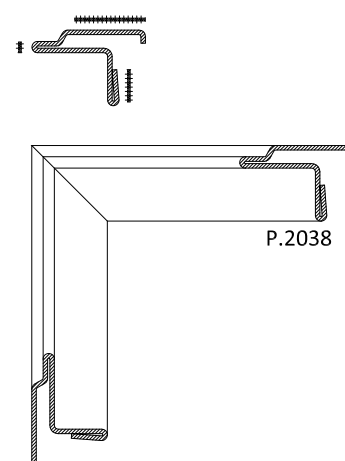
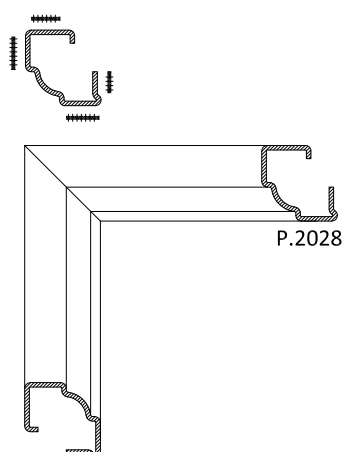
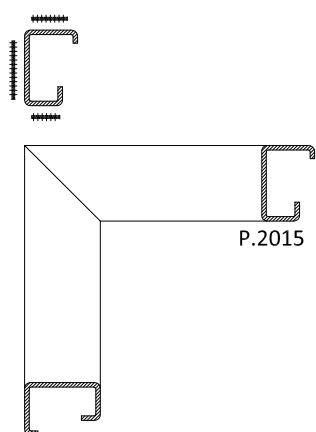
Passo vite e boccia fissaggio fermavetri
Clip pitch to fix glazing beads

Fori eseguibili con maschera AT1234
Holes to be done with AT1234



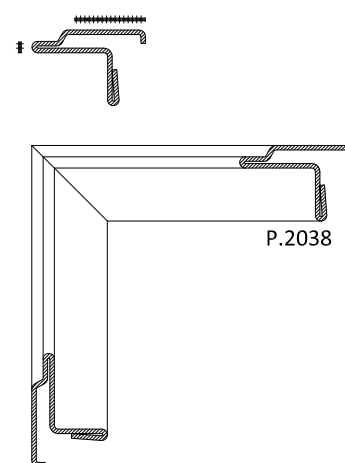
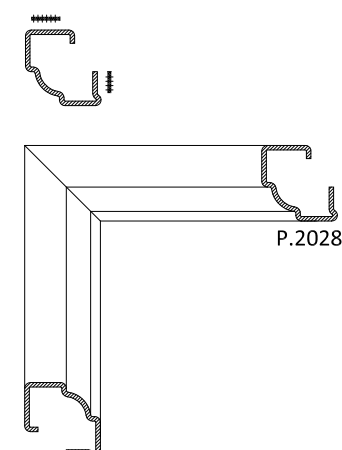
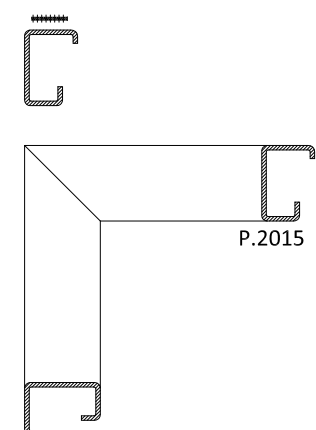
Acciaio zincato - Acciaio Corten - Acciaio inox
Saldare in continuo le superfici di contatto indicate

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



Ottone
Saldare a TIG a punti le zone indicate.

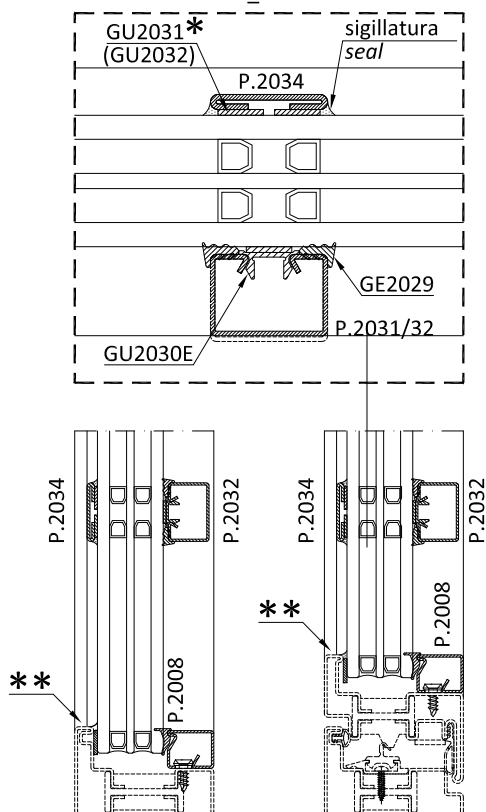
Brass
Spot weld (TIG) the marked areas.



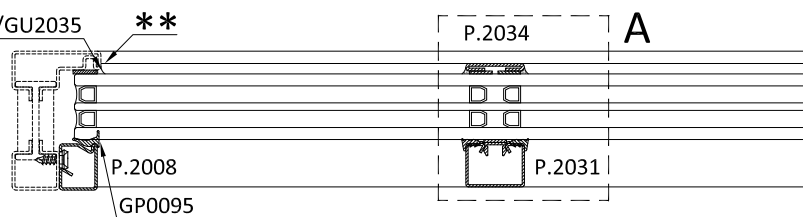
P.2028
Taglio a 45° dei fermavetri effettuabile utilizzando la ganascia AT2029
45° cutting of the glazing beads done using the cutting jaw AT2029

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

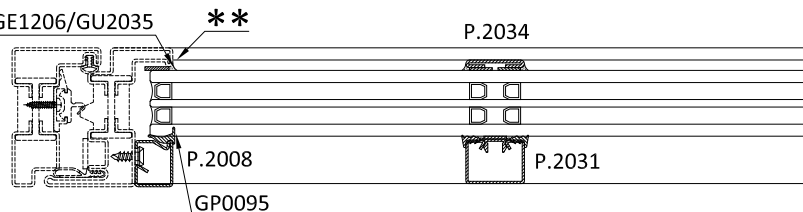
PARTICOLARE "A" _ DETAIL "A"



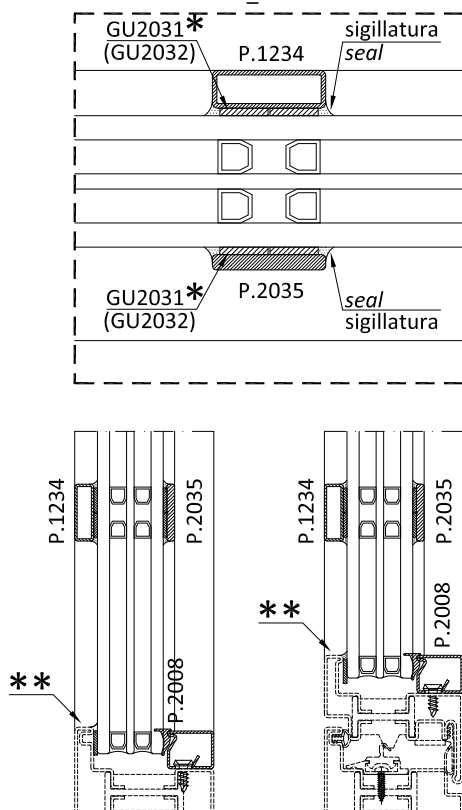
GE1006/GU2035 **



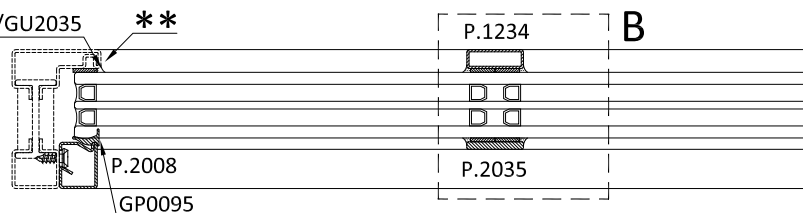
GE1206/GU2035 **



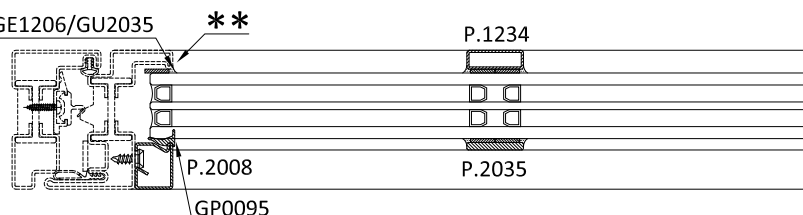
PARTICOLARE "B" _ DETAIL "B"



GE1006/GU2035 **



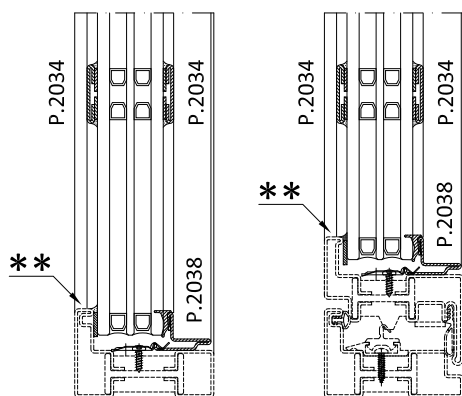
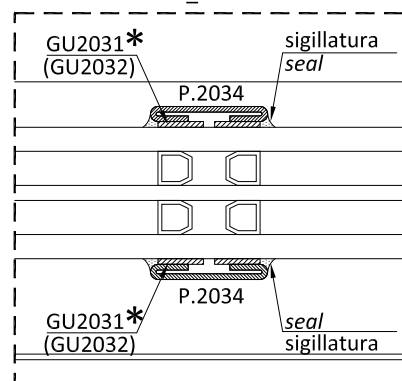
GE1206/GU2035 **



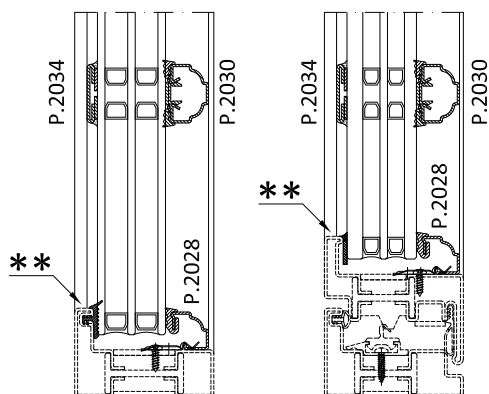
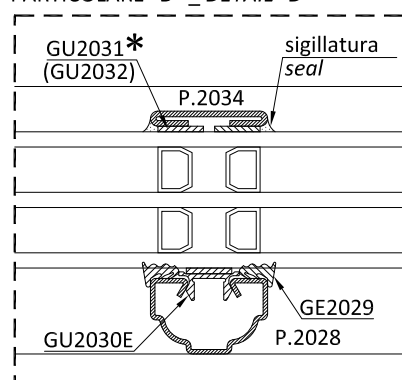
* Per utilizzo dividivetro SOLO orizzontali o SOLO verticali GU2031
Per utilizzo dividivetro orizzontali e verticali GU2031 verticalmente GU2032 orizzontalmente
For ONLY horizontal or ONLY vertical glazing beads use GU2031
For horizontal and vertical glazing beads use GU2031 vertically and GU2032 horizontally

** Saldare o sigillare
Weld or seal

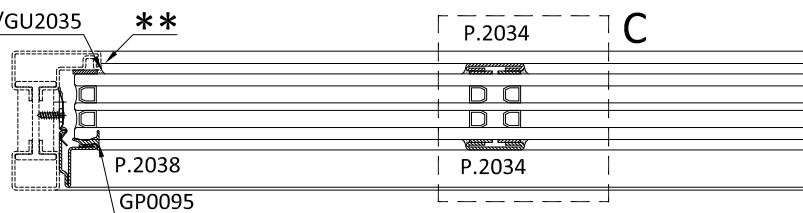
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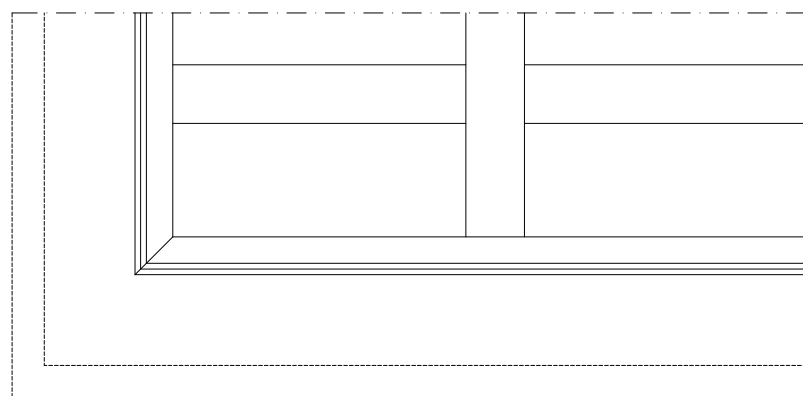
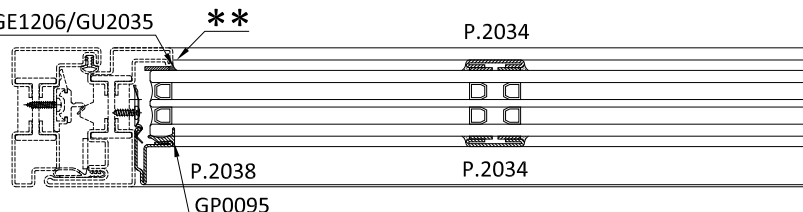
PARTICOLARE "D" _ DETAIL "D"



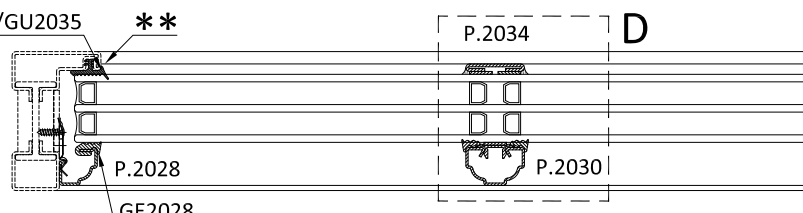
GE1006/GU2035 **



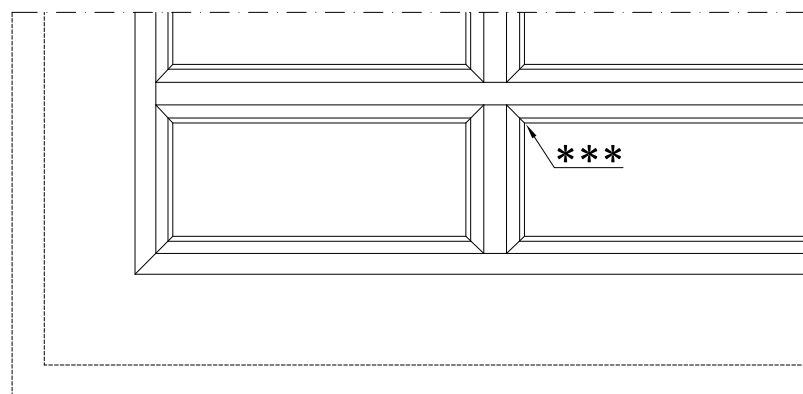
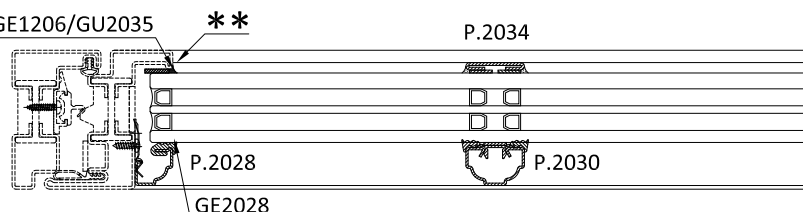
GE1206/GU2035 **



GE1006/GU2035 **



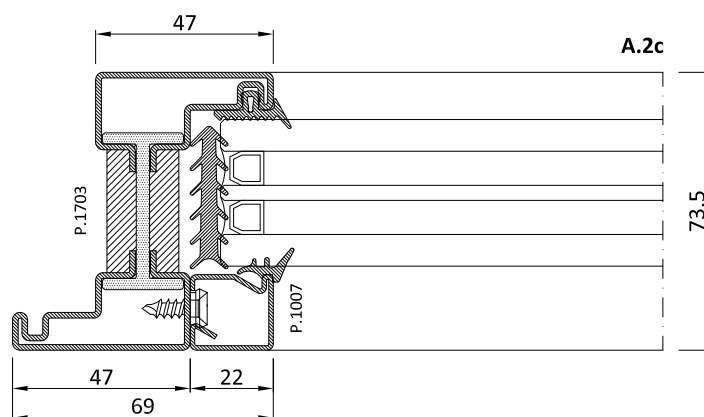
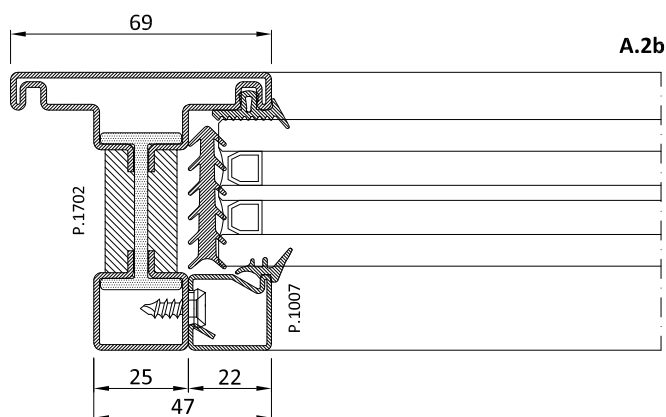
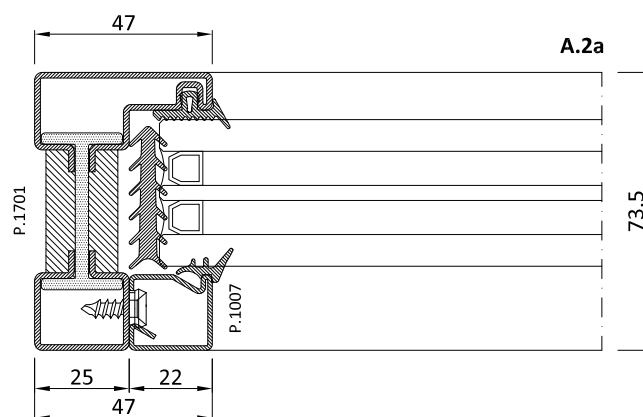
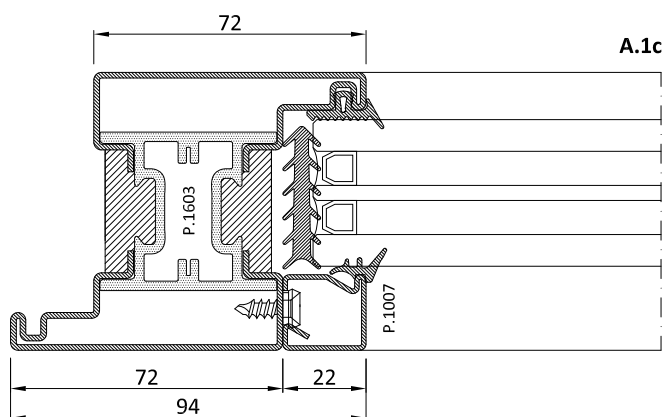
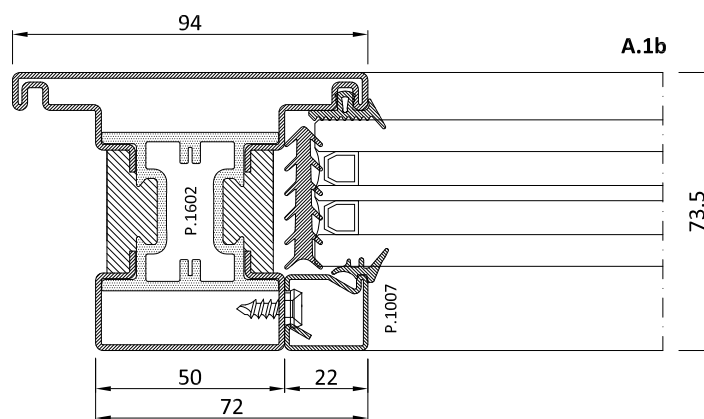
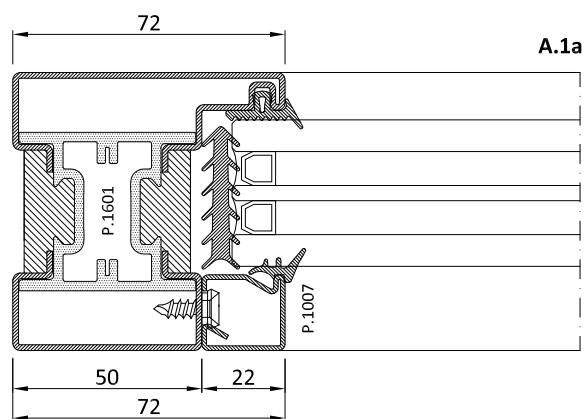
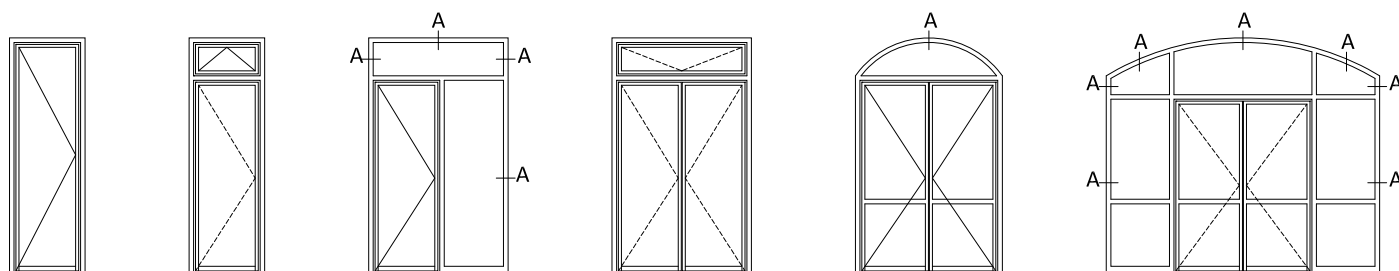
GE1206/GU2035 **

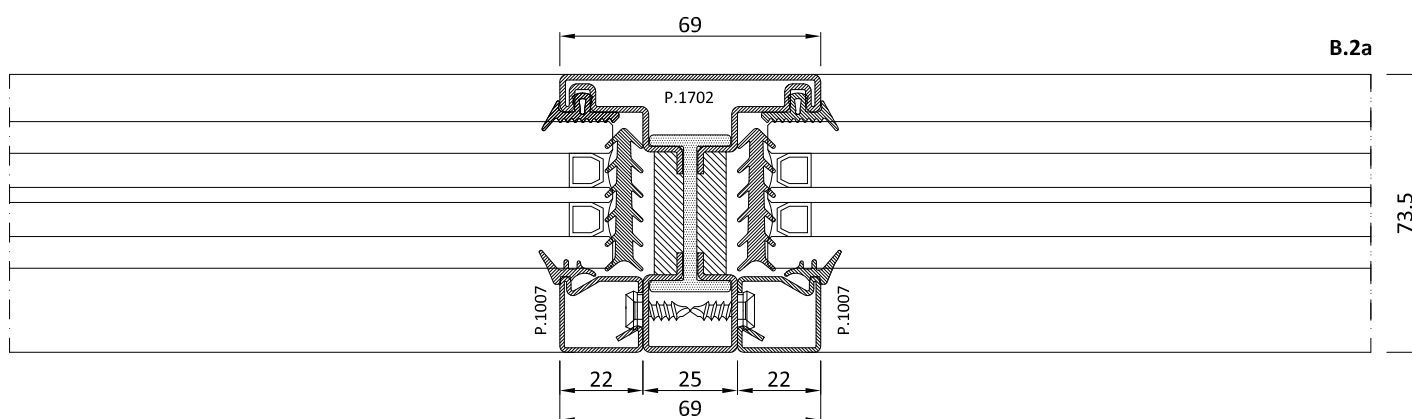
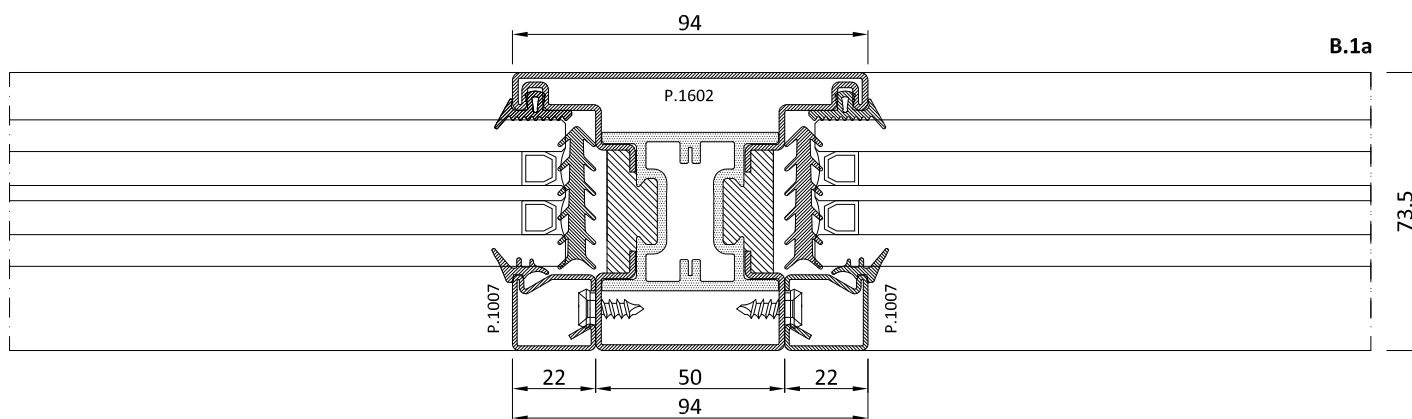
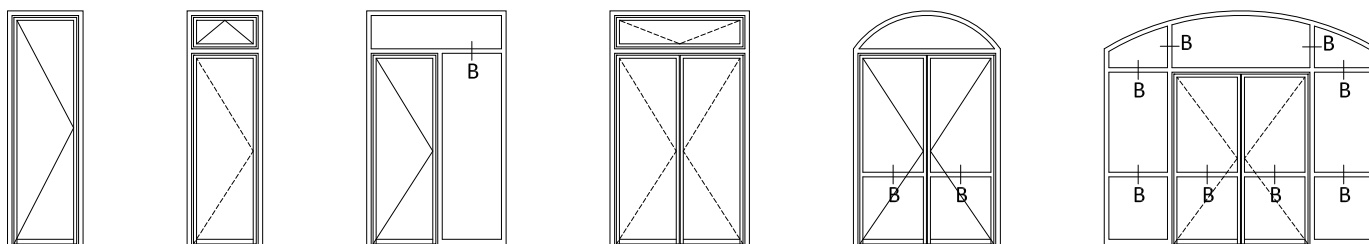


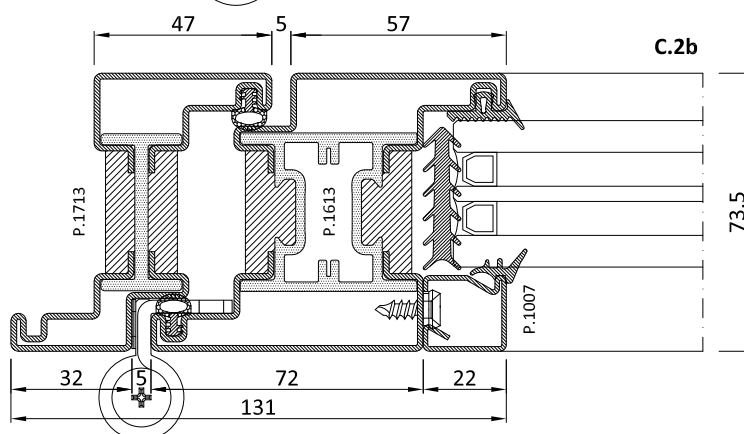
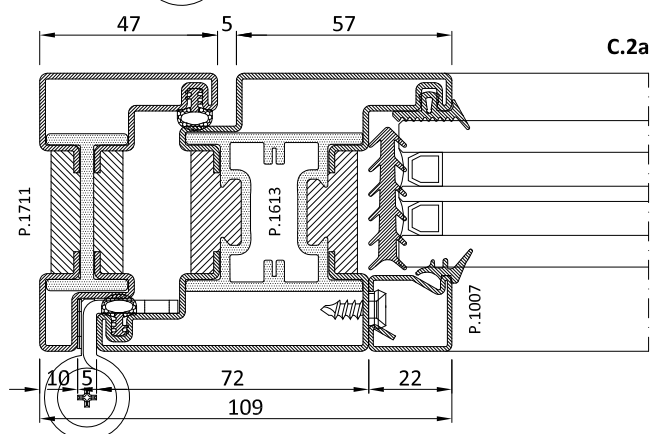
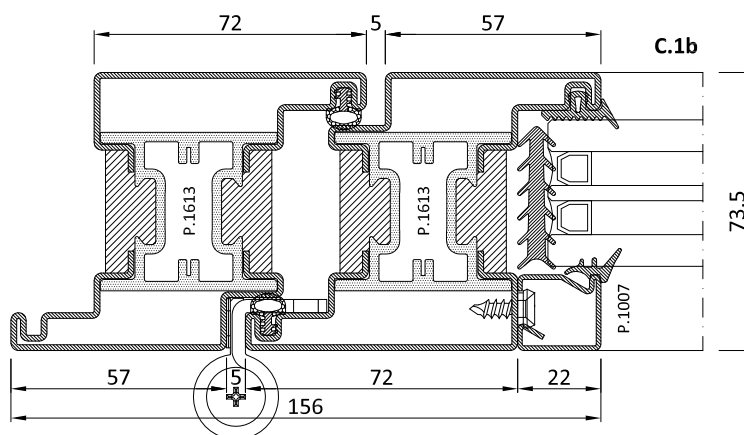
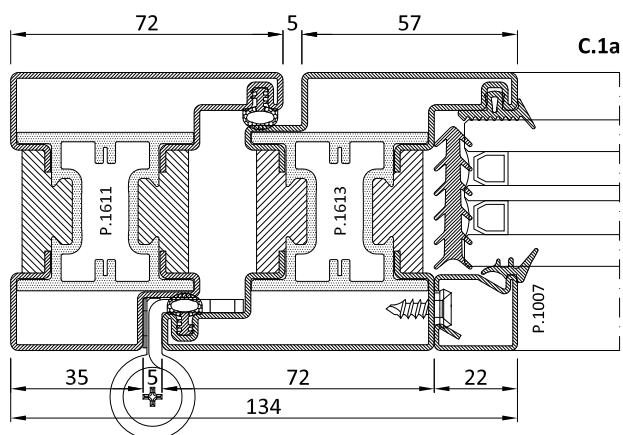
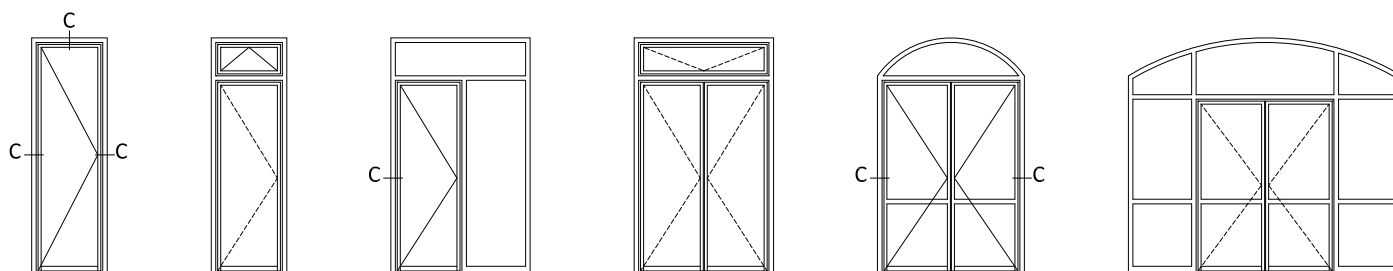
* Per utilizzo dividivetro SOLO orizzontali o SOLO verticali GU2031
Per utilizzo dividivetro orizzontali e verticali GU2031 verticalmente GU2032 orizzontalmente
For ONLY horizontal or ONLY vertical glazing beads use GU2031
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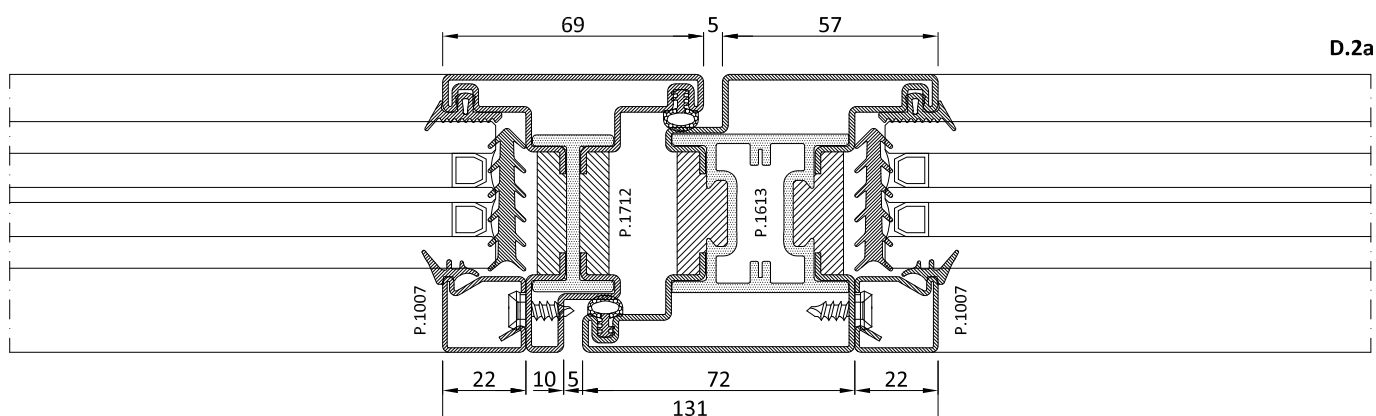
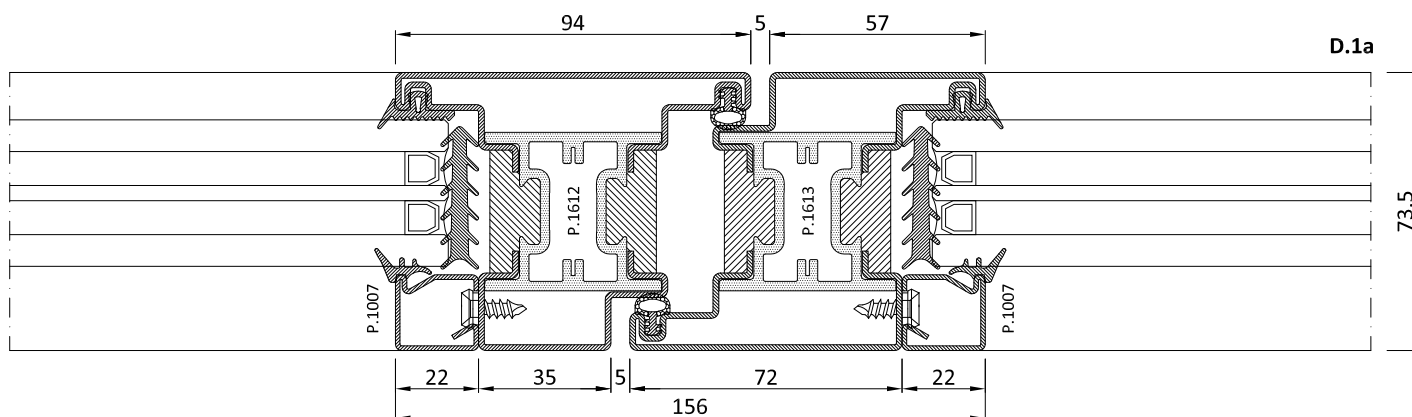
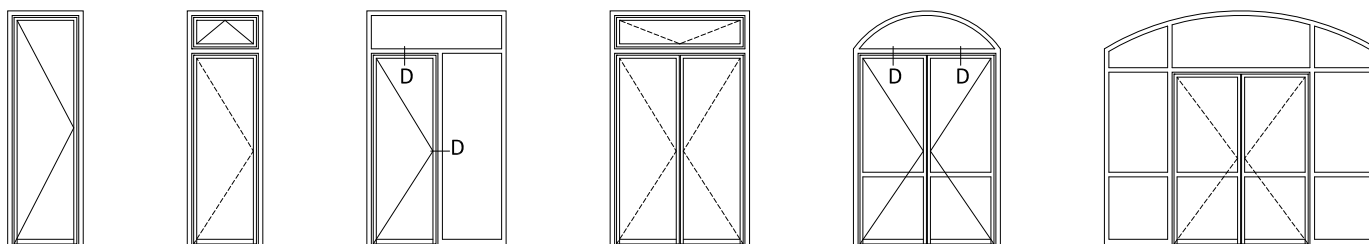
** Saldare o sigillare
Weld or seal

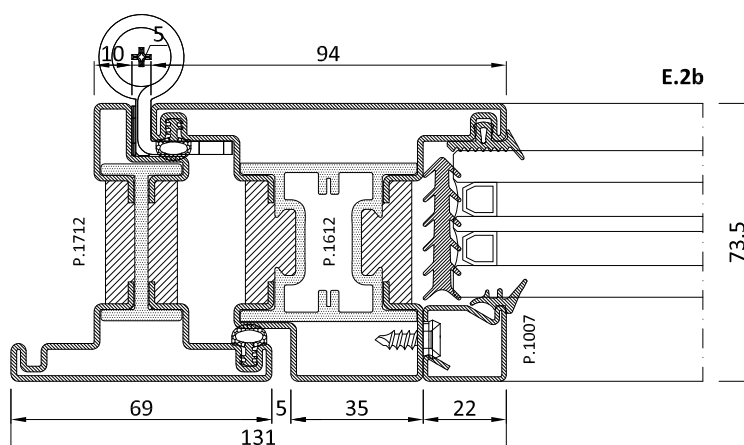
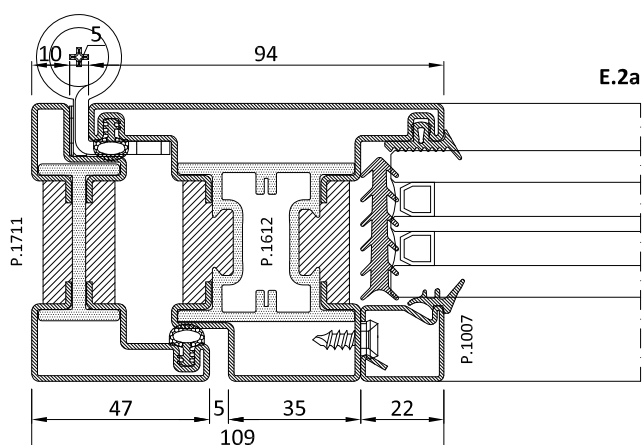
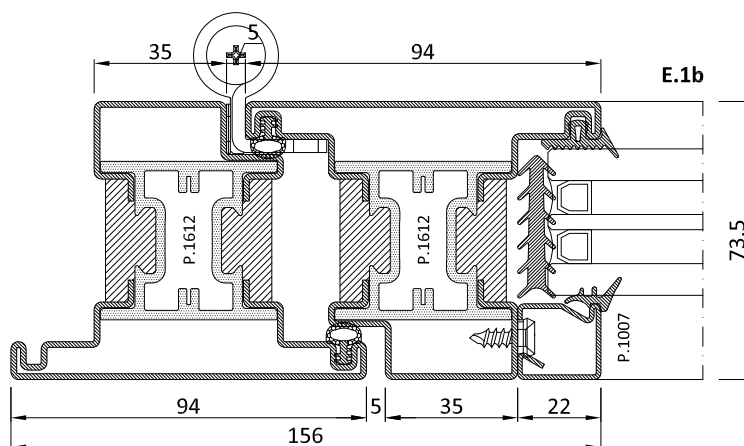
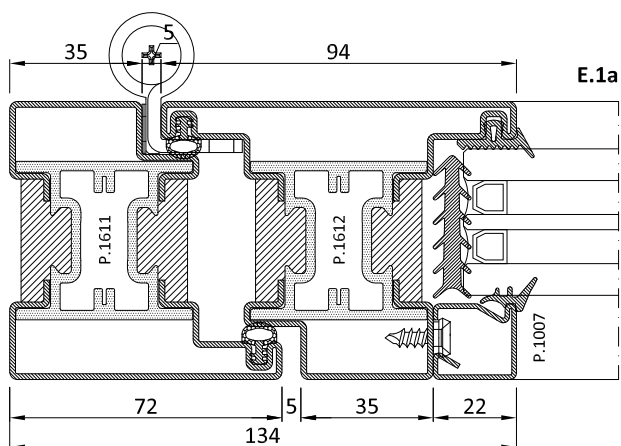
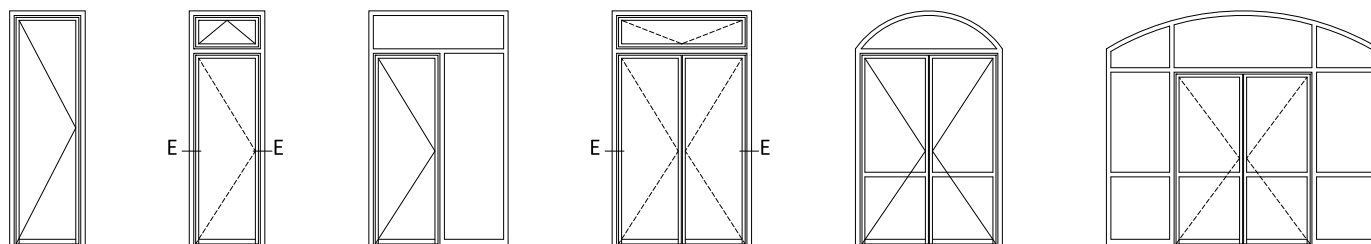
*** Lavorazione di intestatura effettuabile con stampo AT2030
Processing of butt jointing carried out with a mould

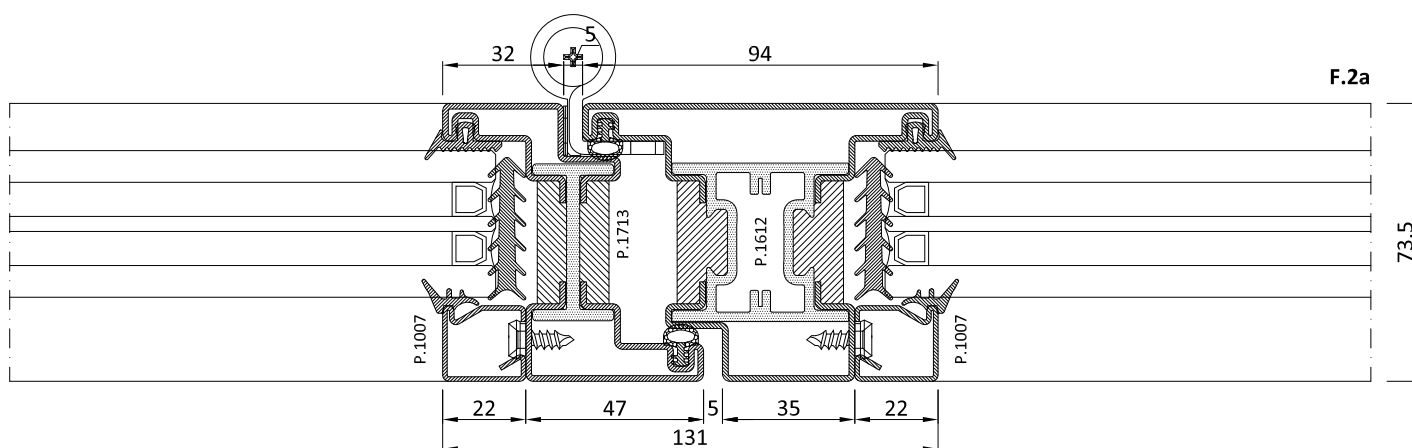
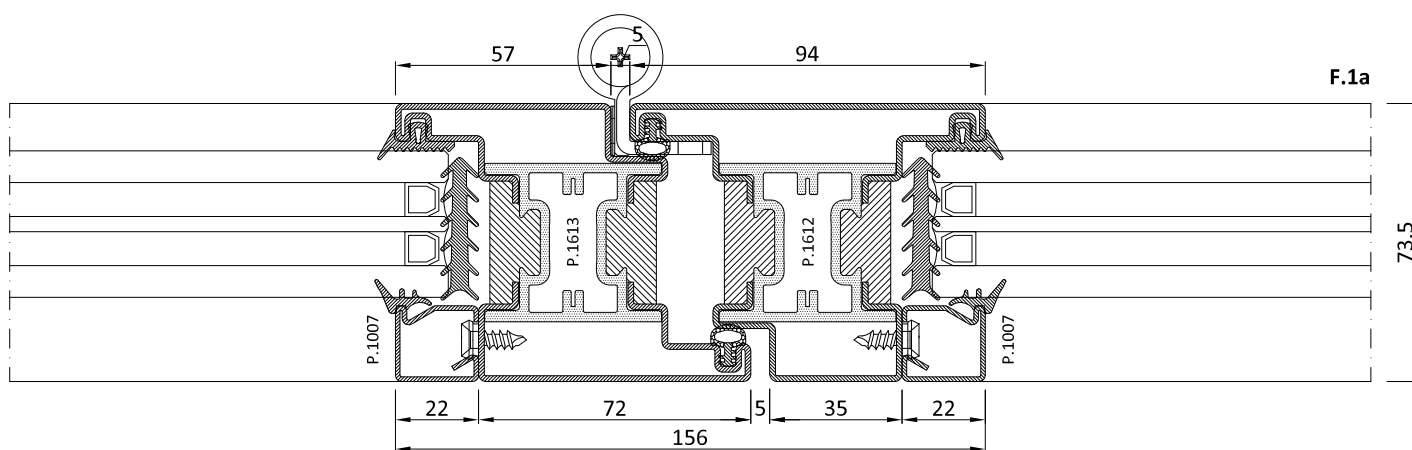
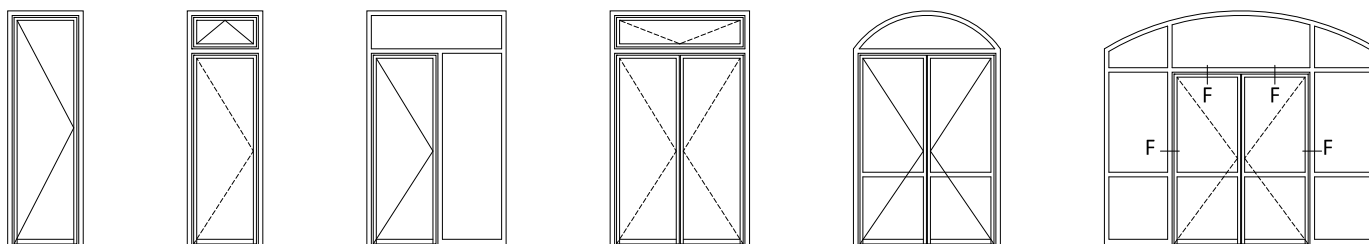


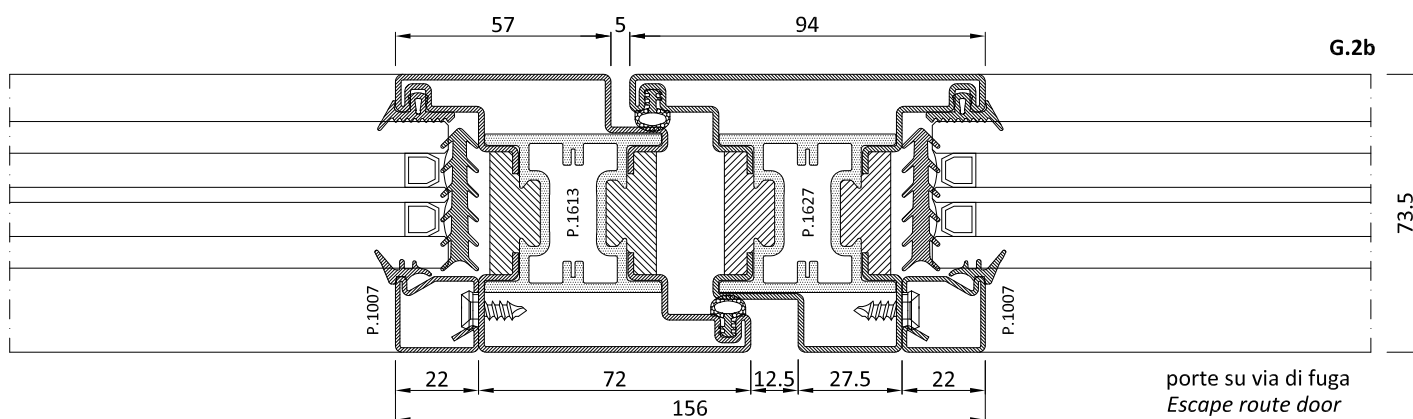
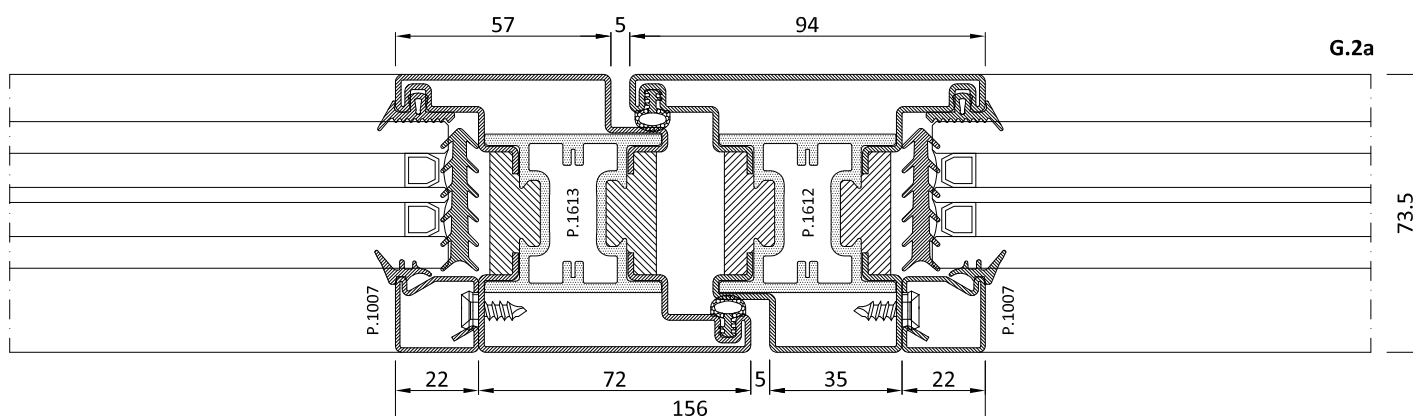
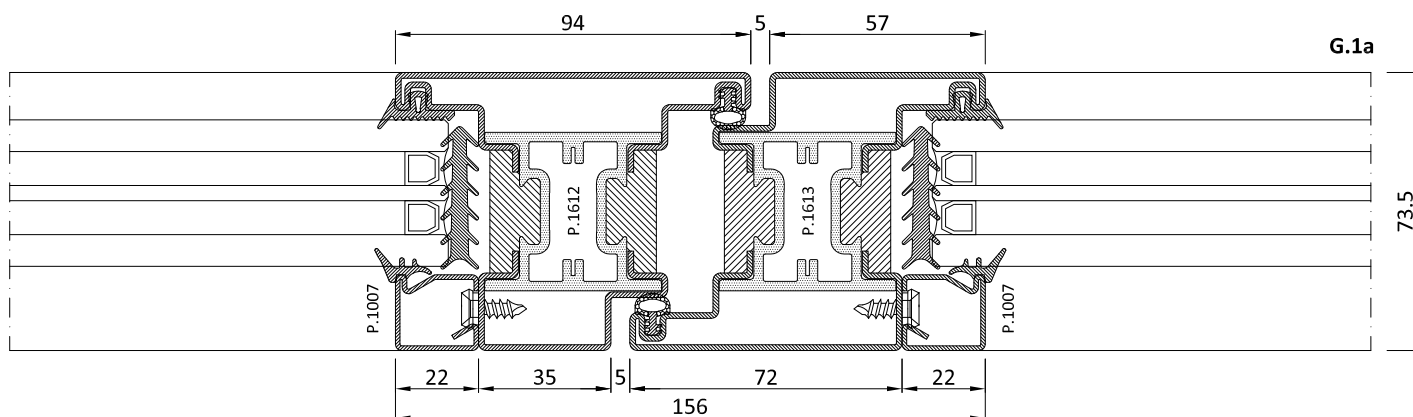
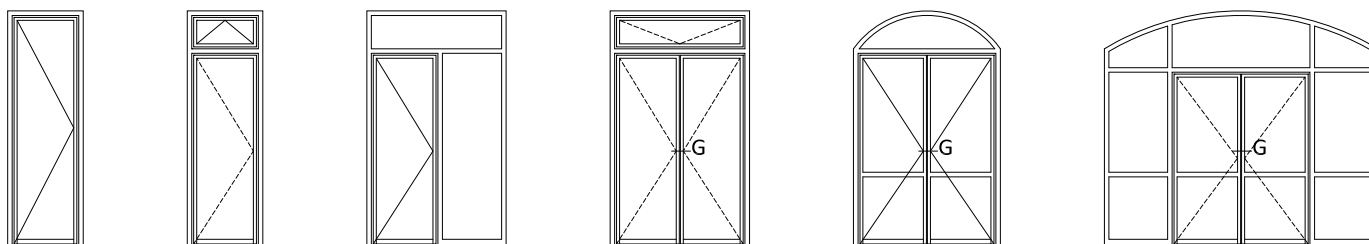


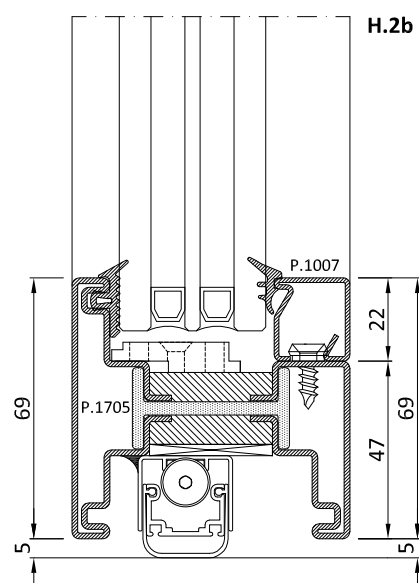
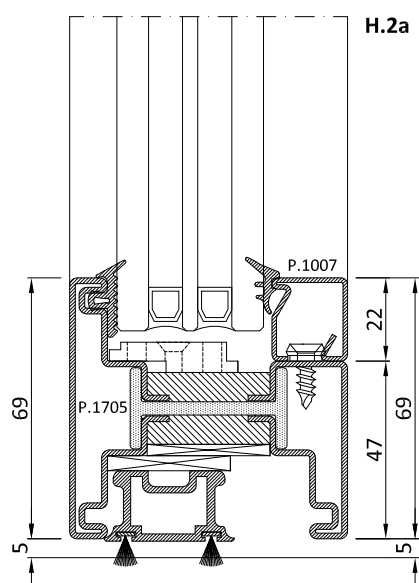
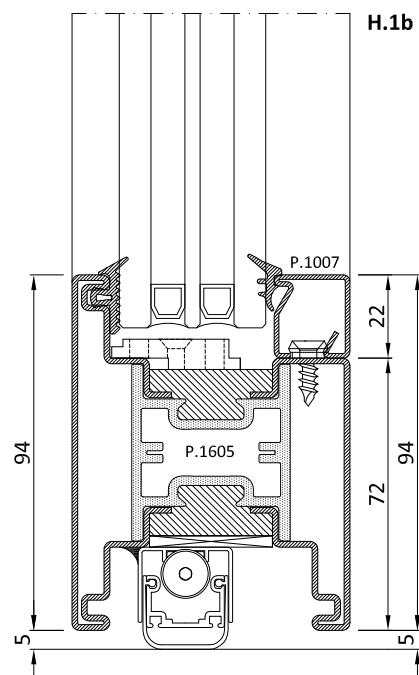
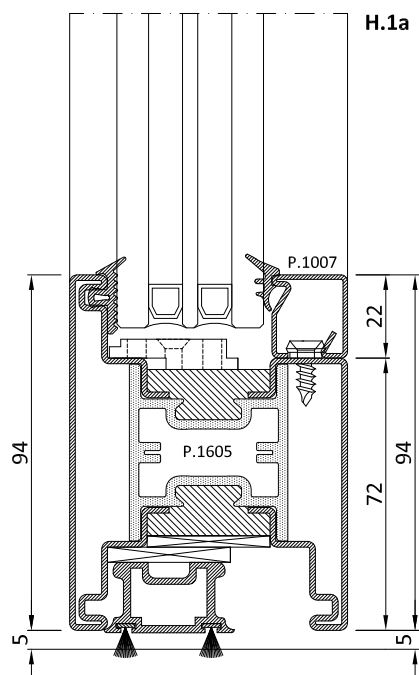
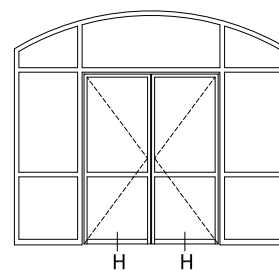
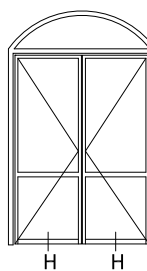
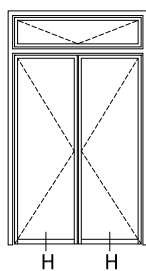
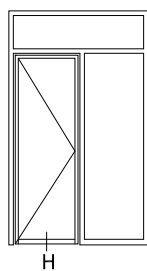
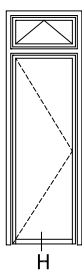
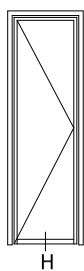


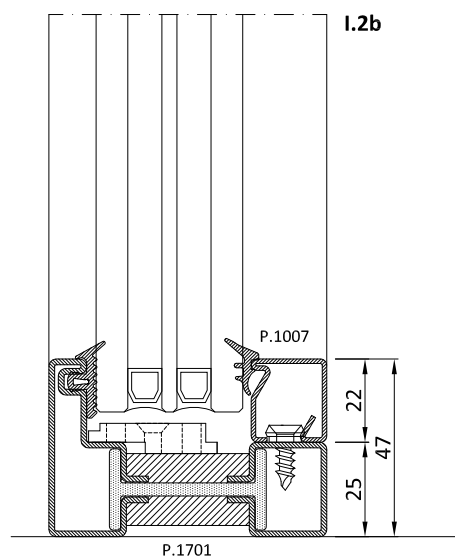
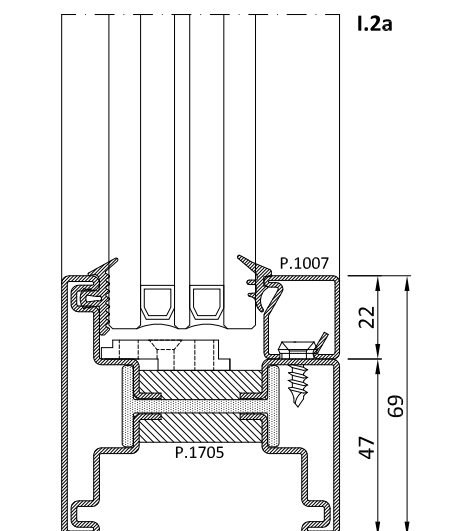
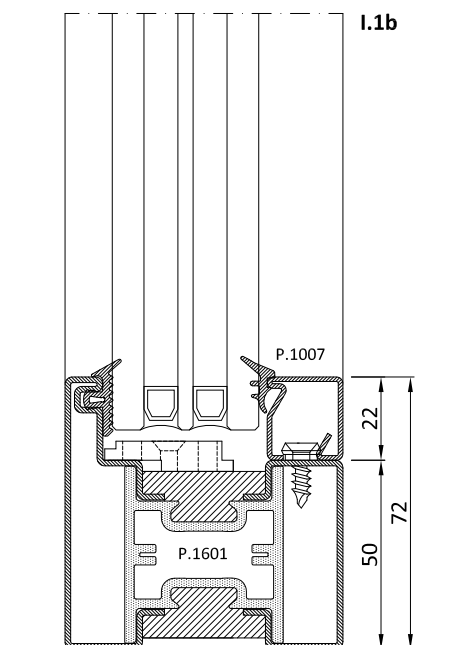
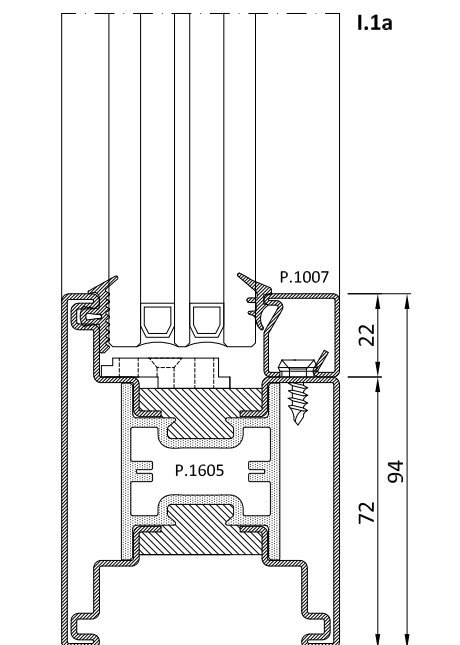
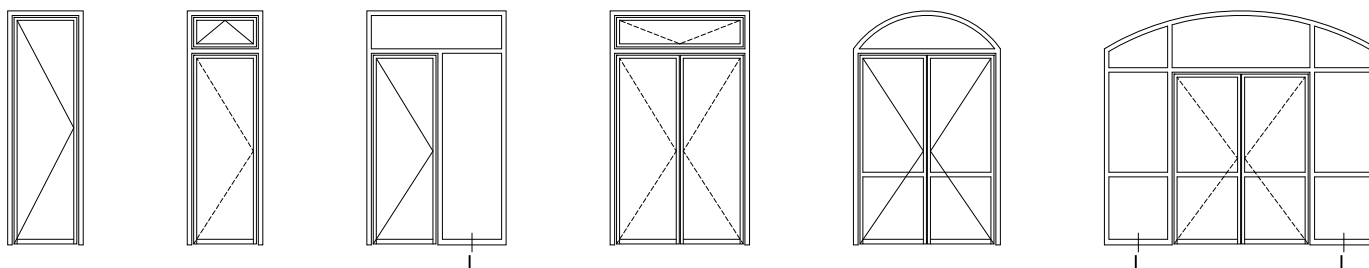


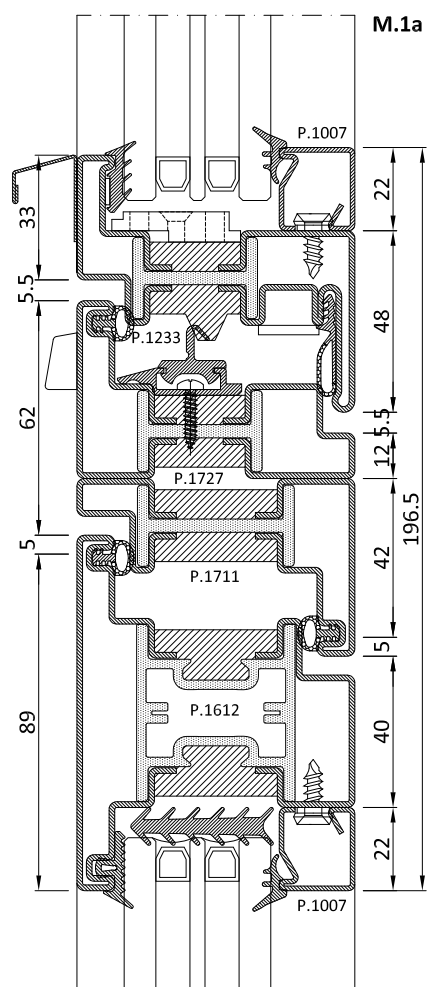
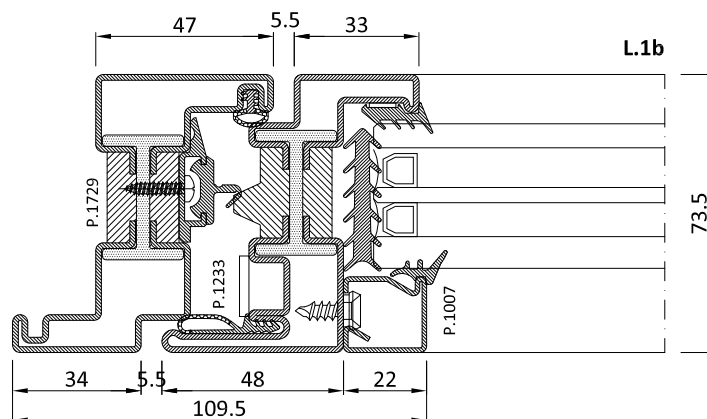
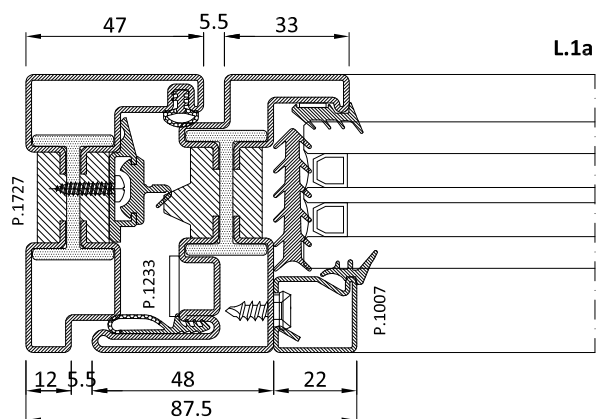
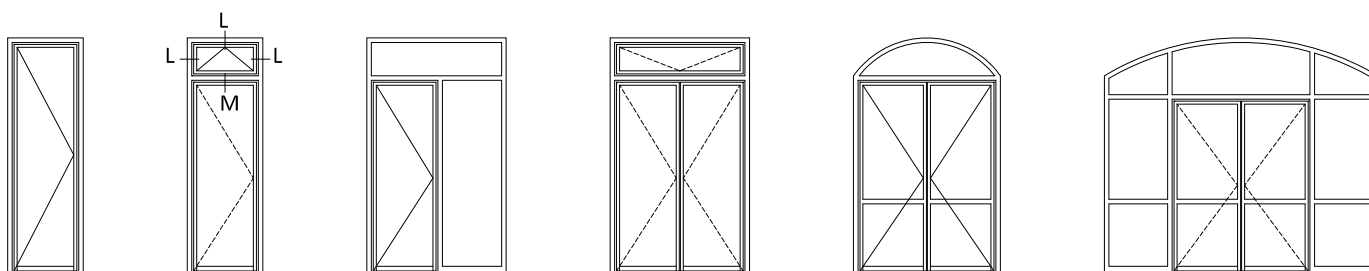


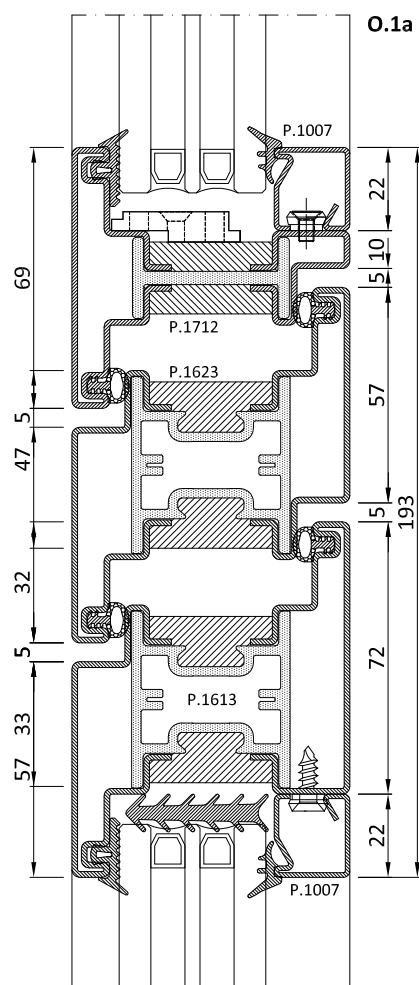
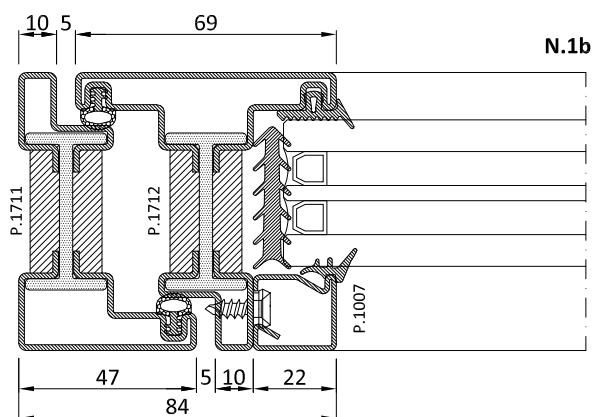
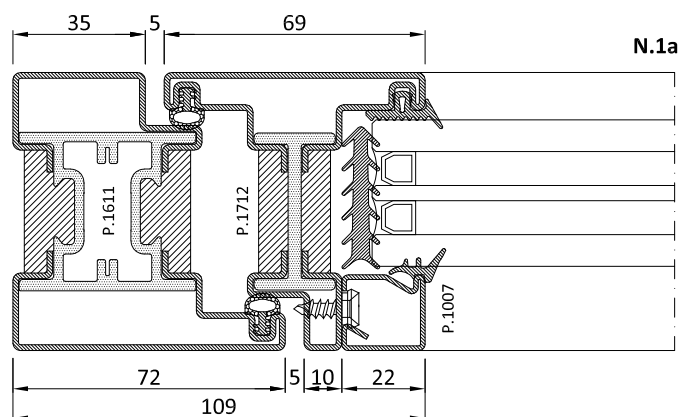
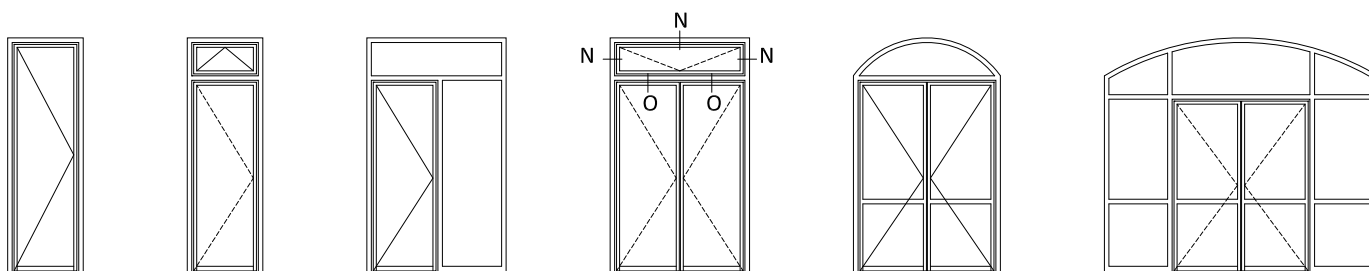


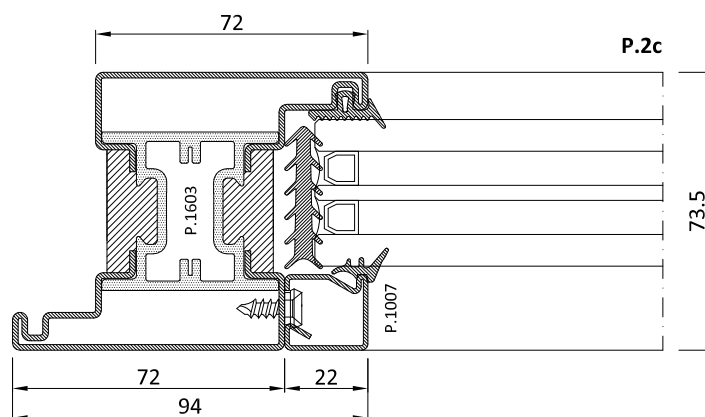
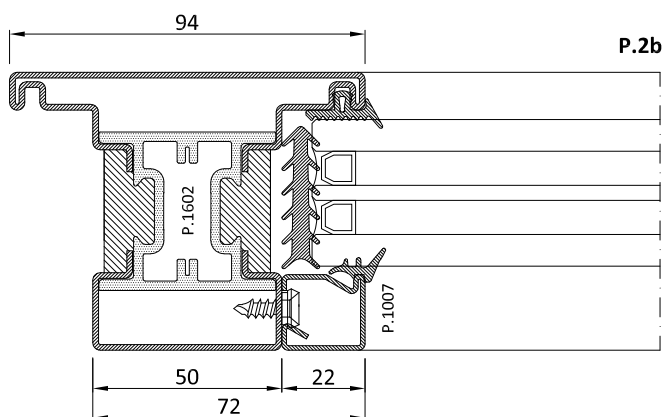
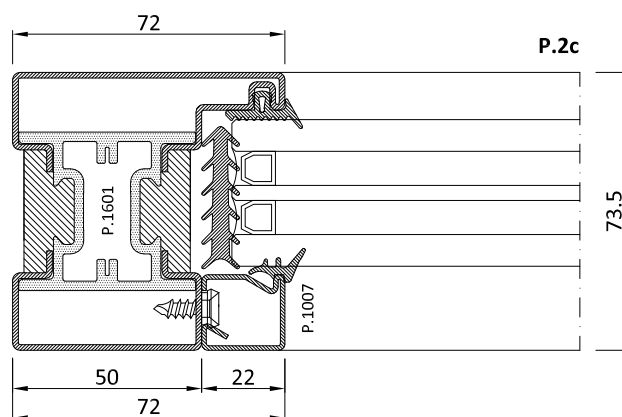
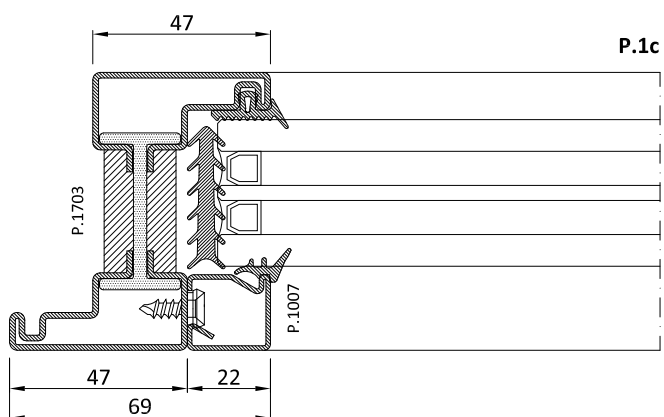
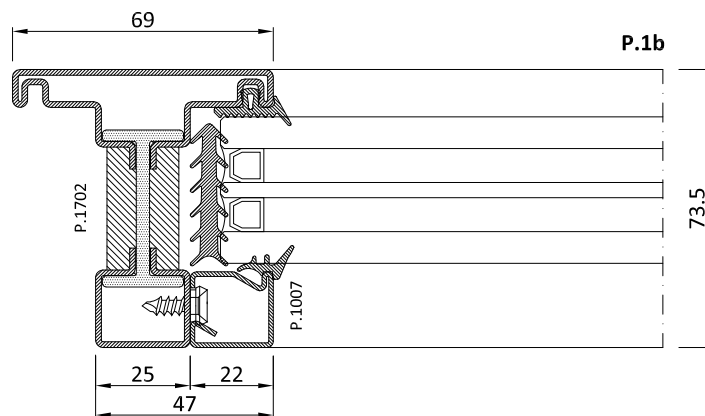
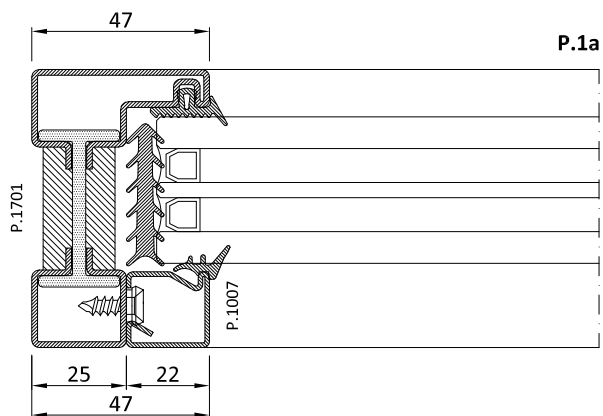
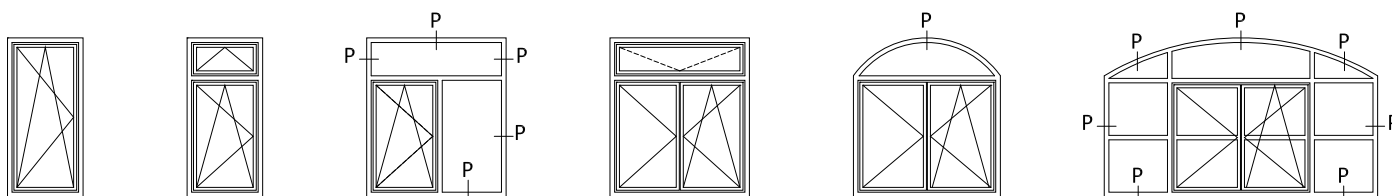


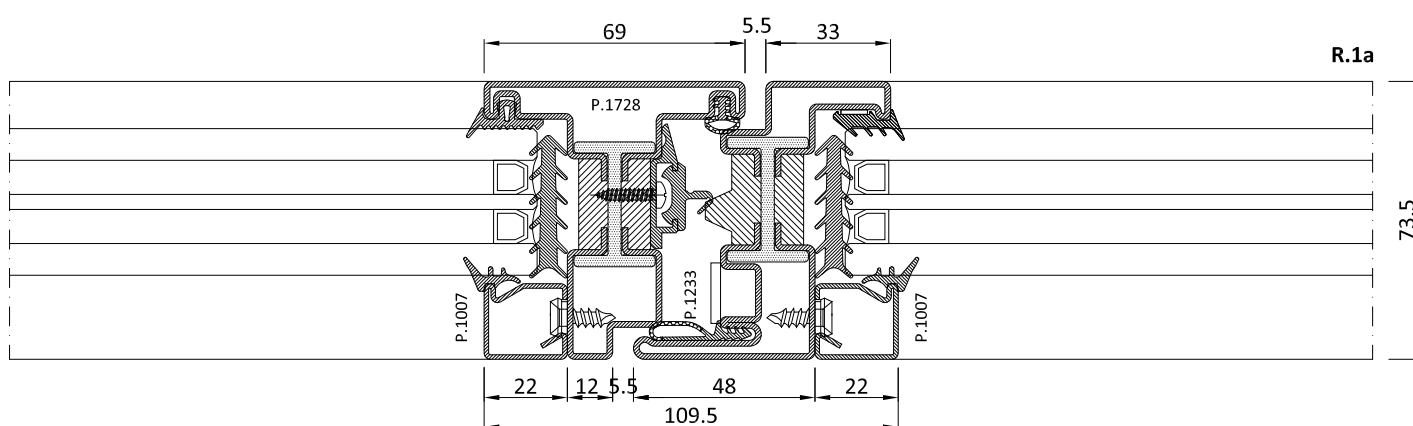
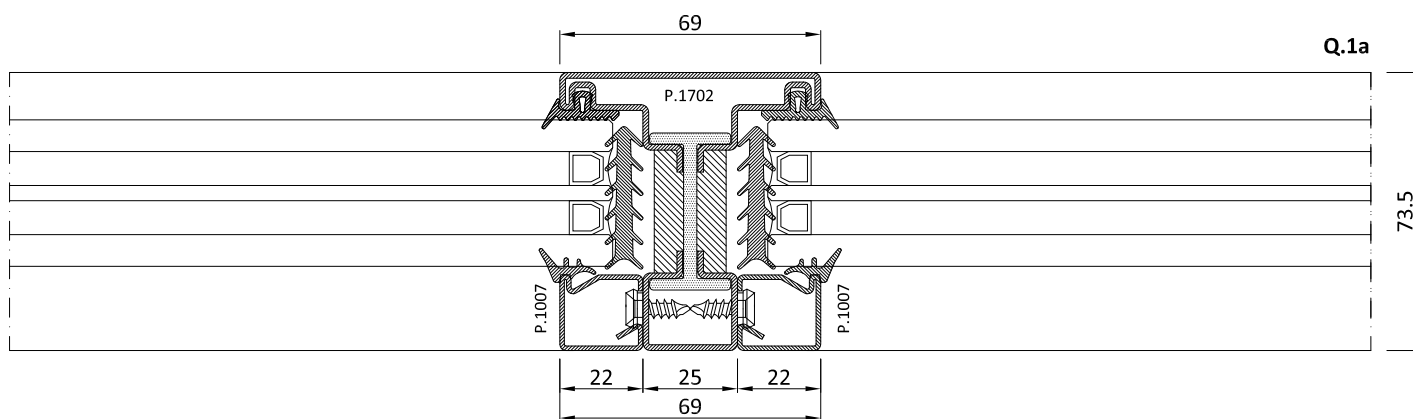
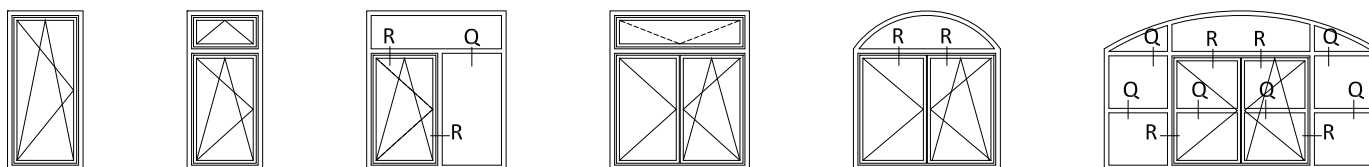


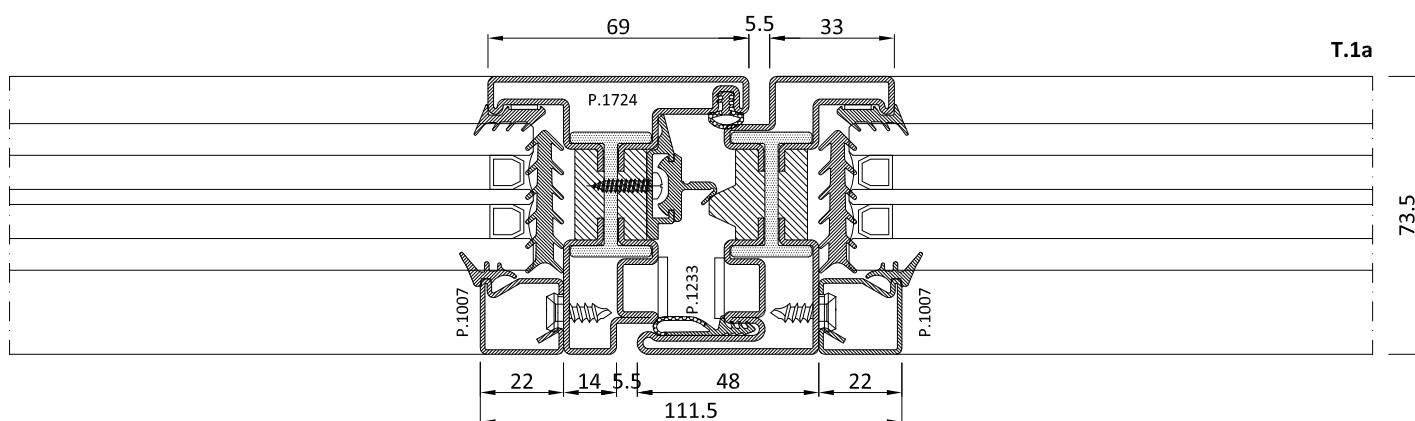
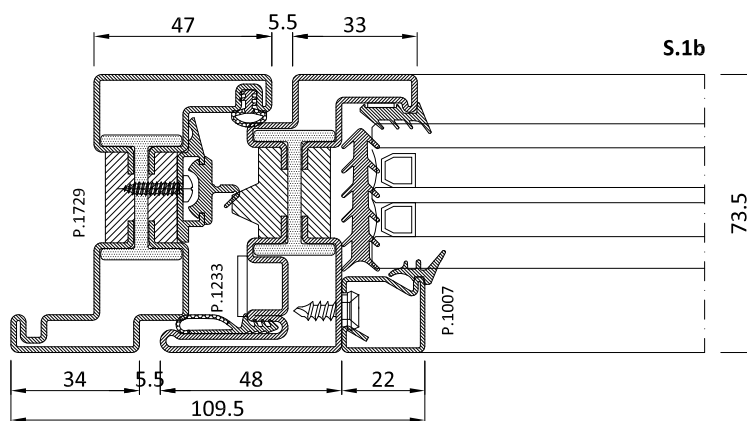
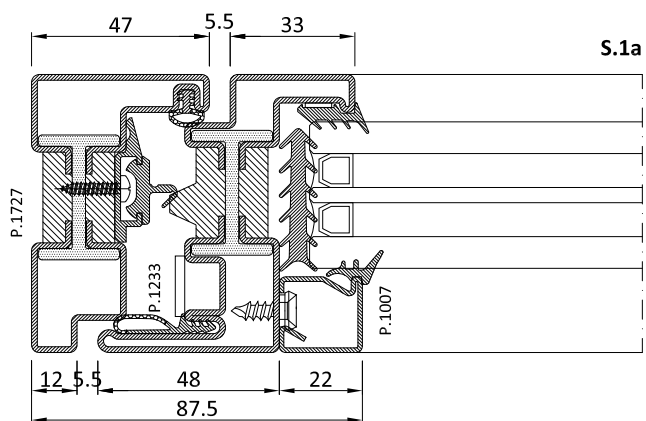
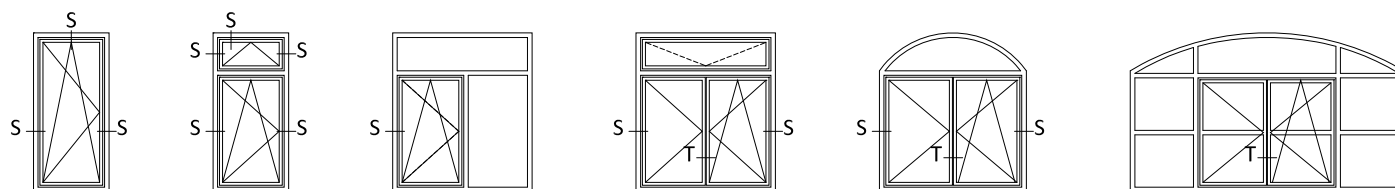


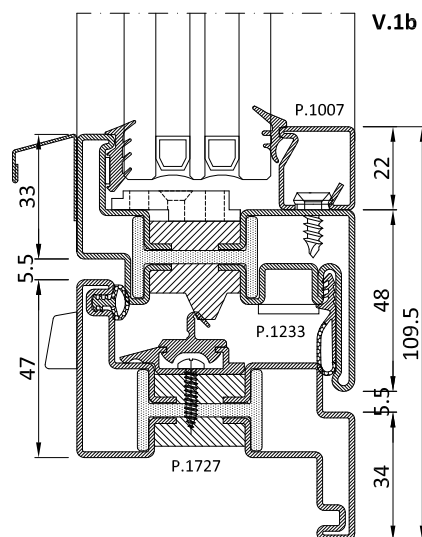
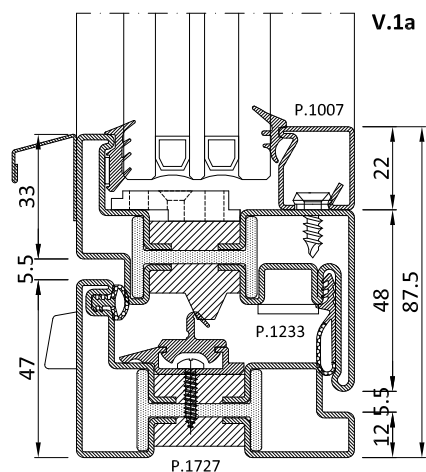
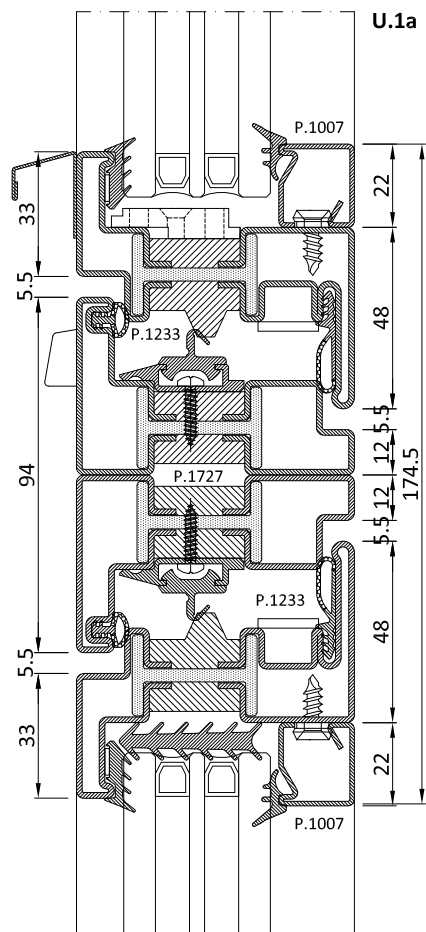
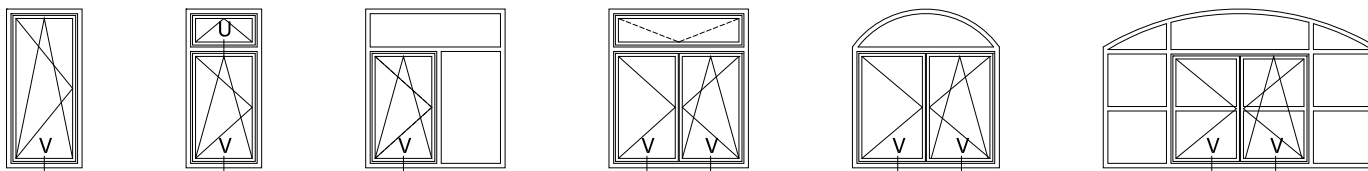


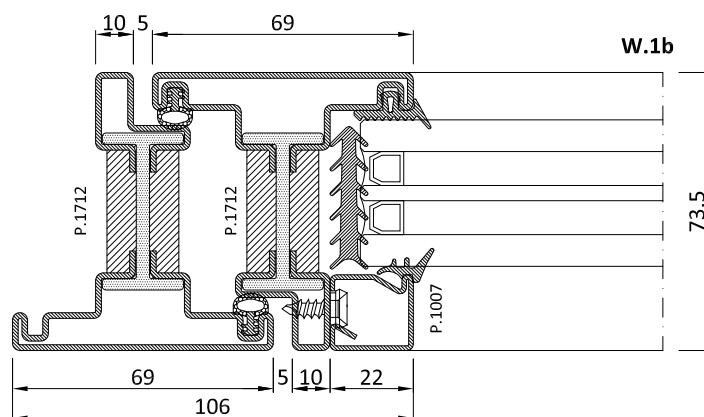
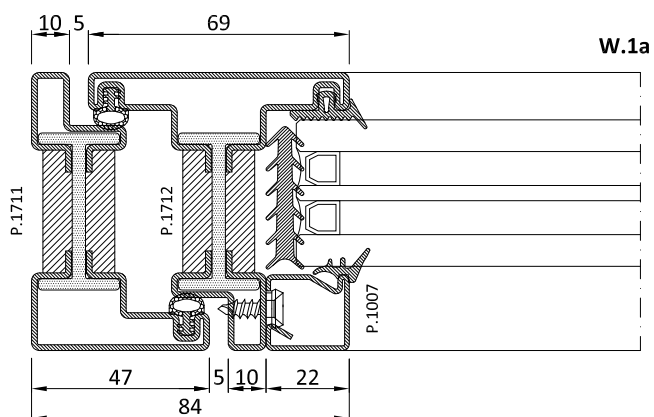
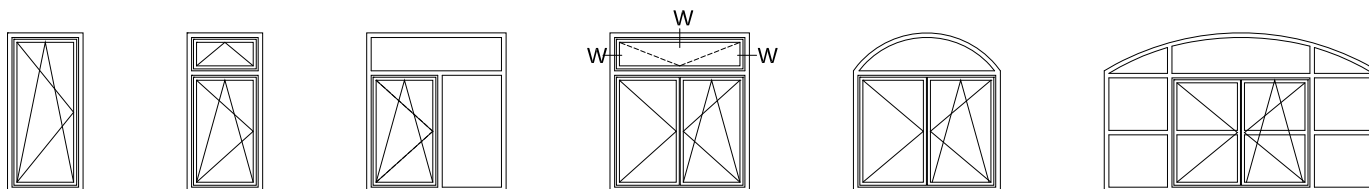


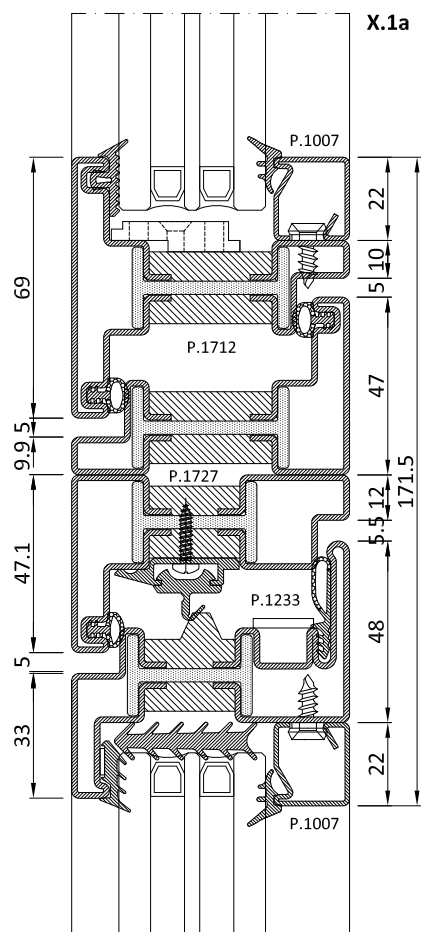
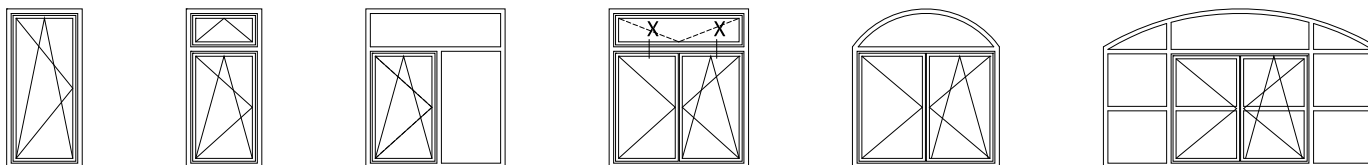


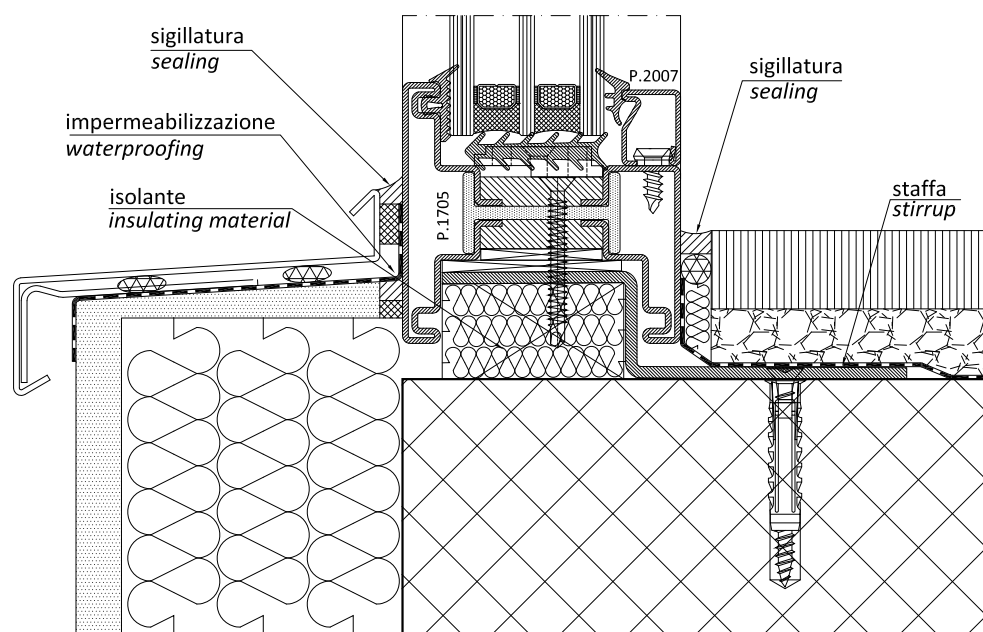
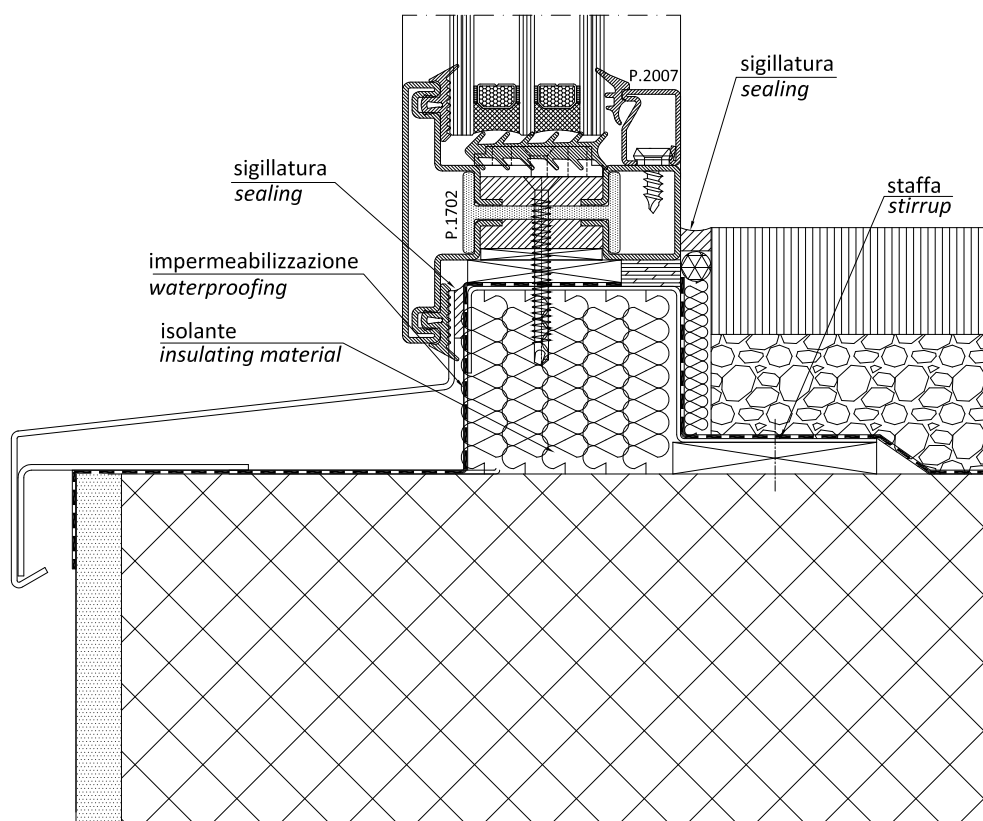


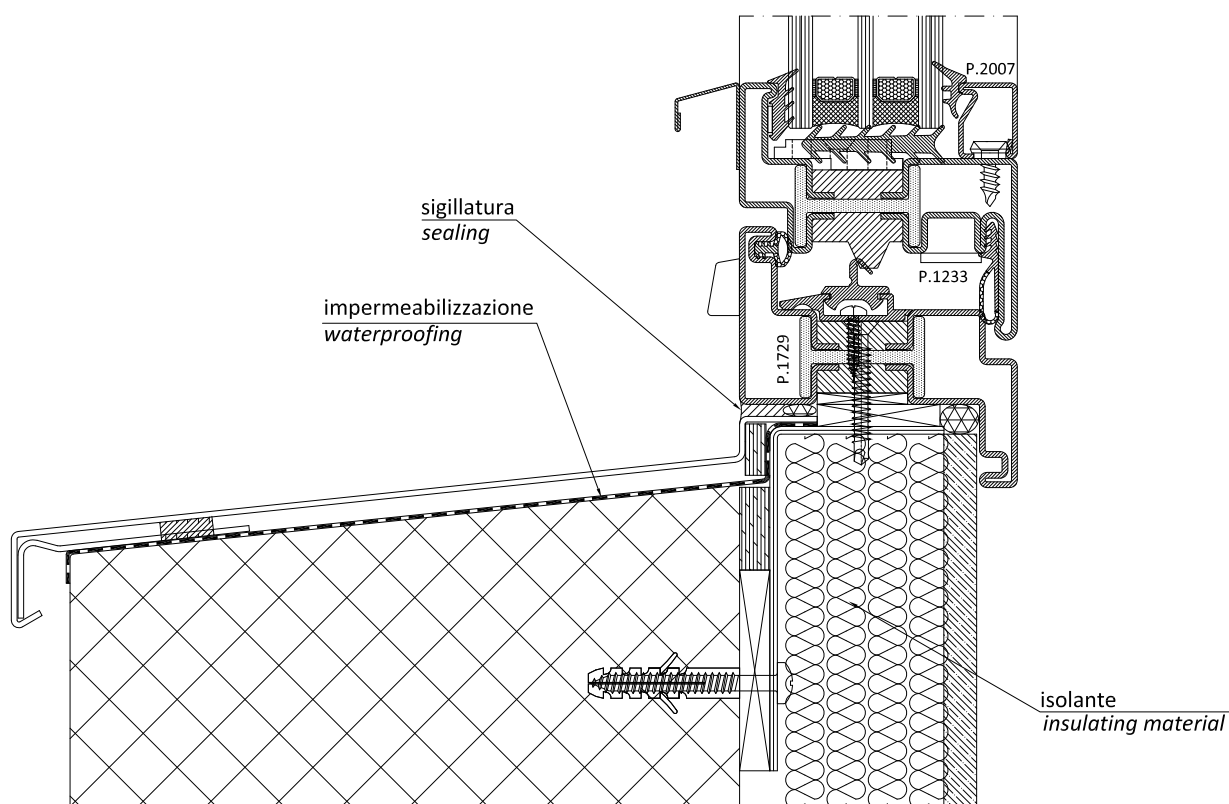
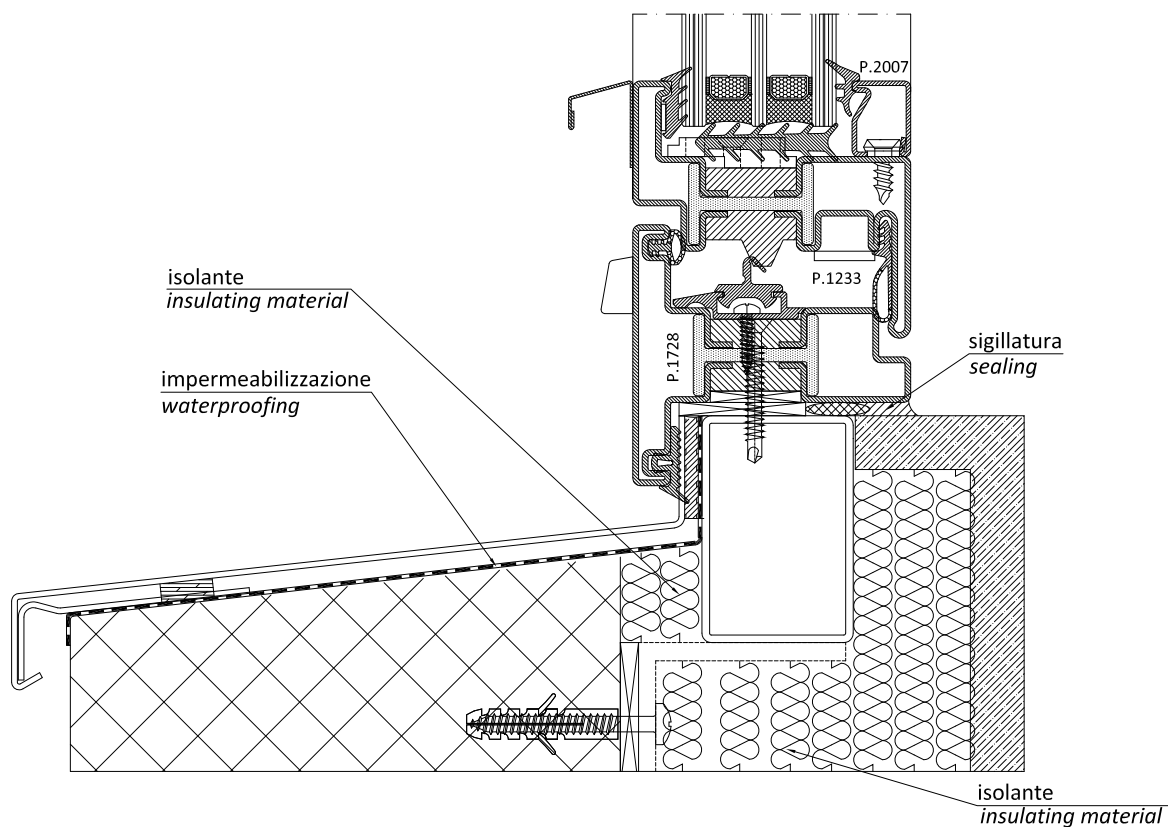


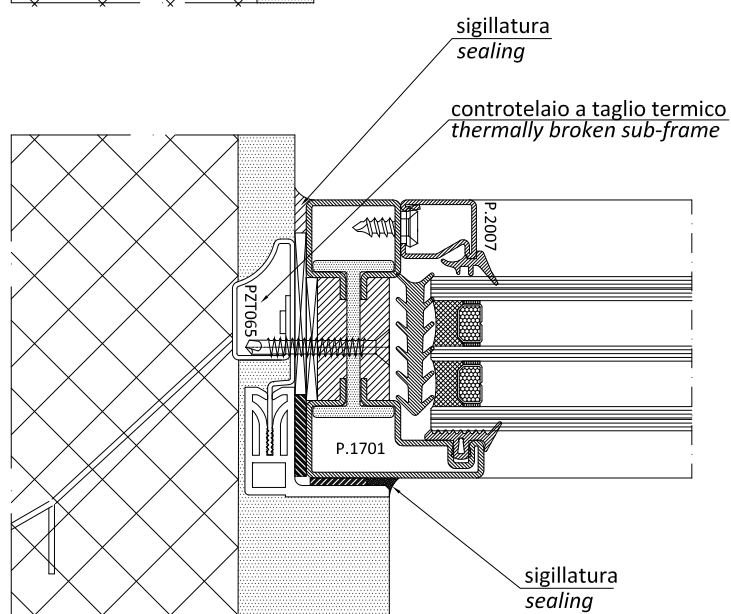
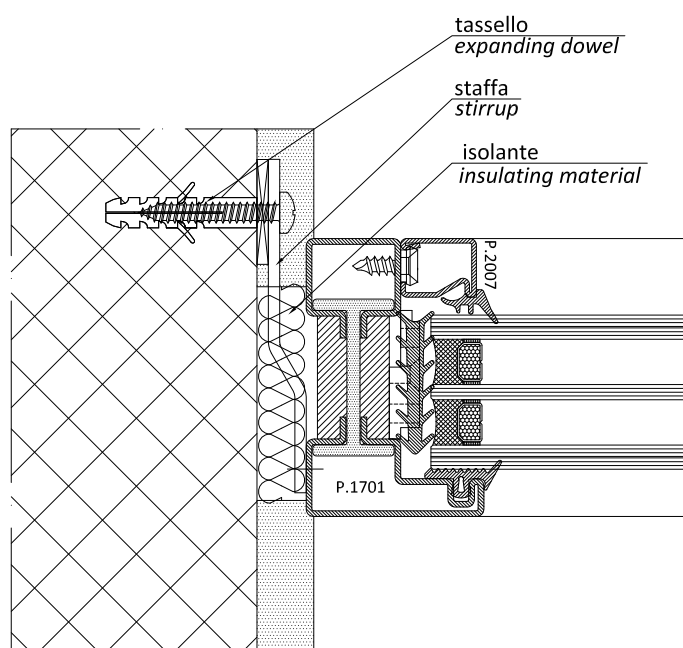
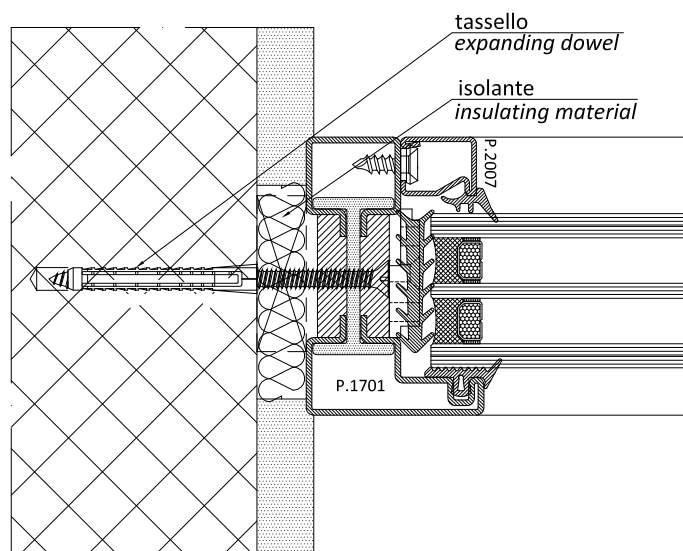


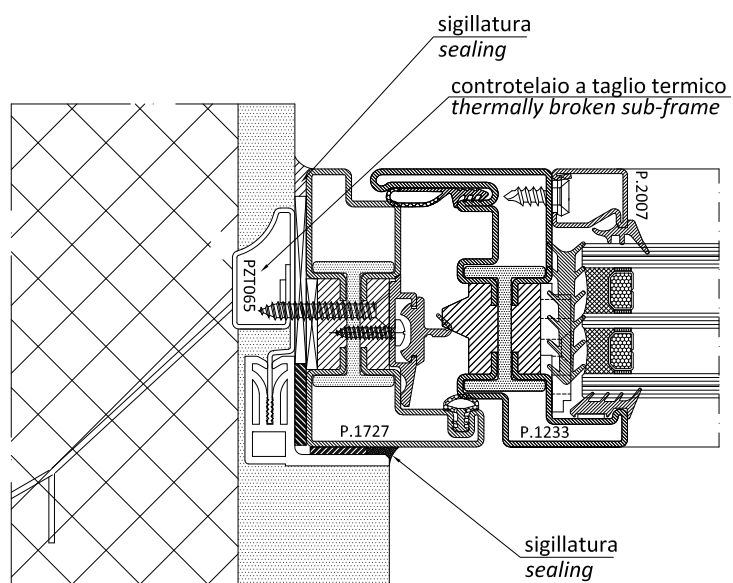
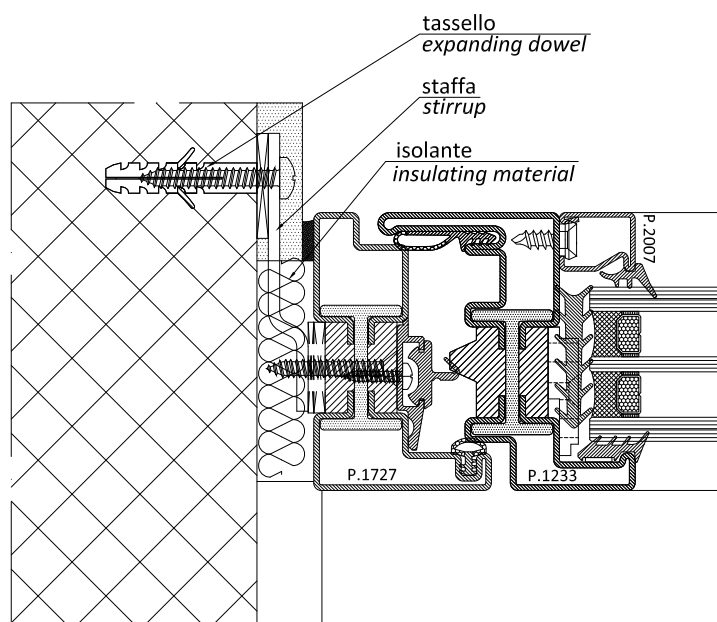
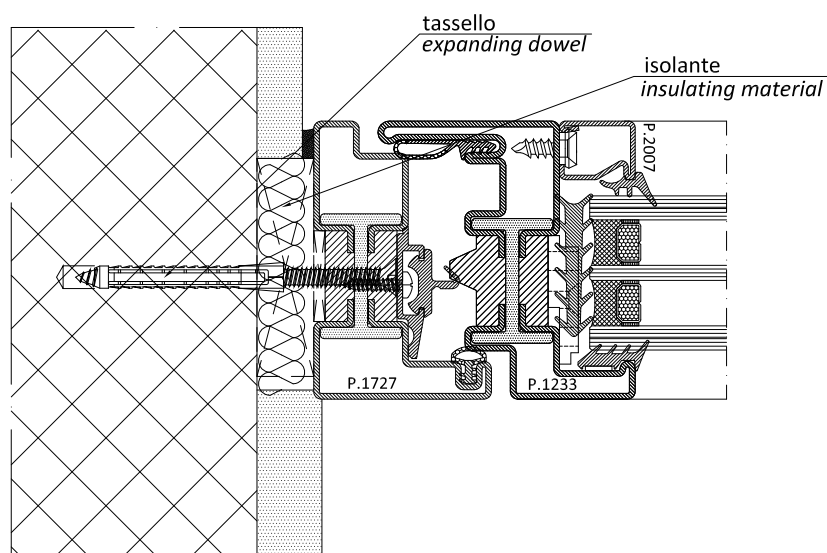




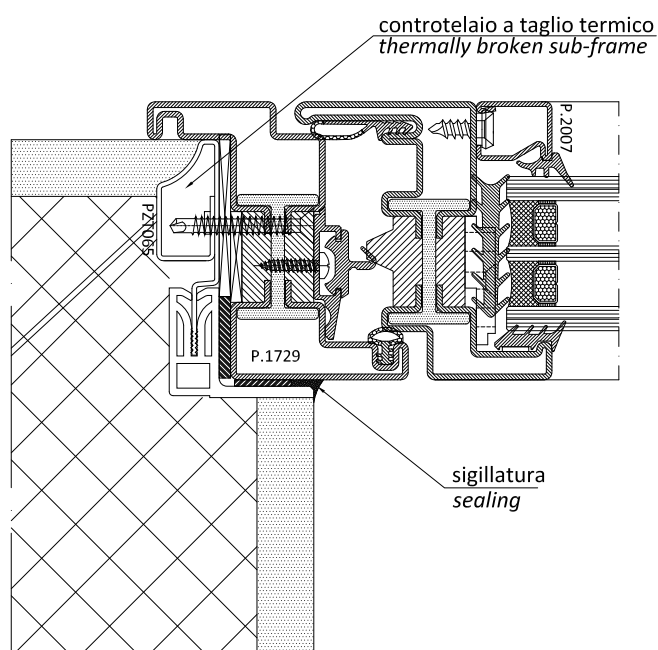
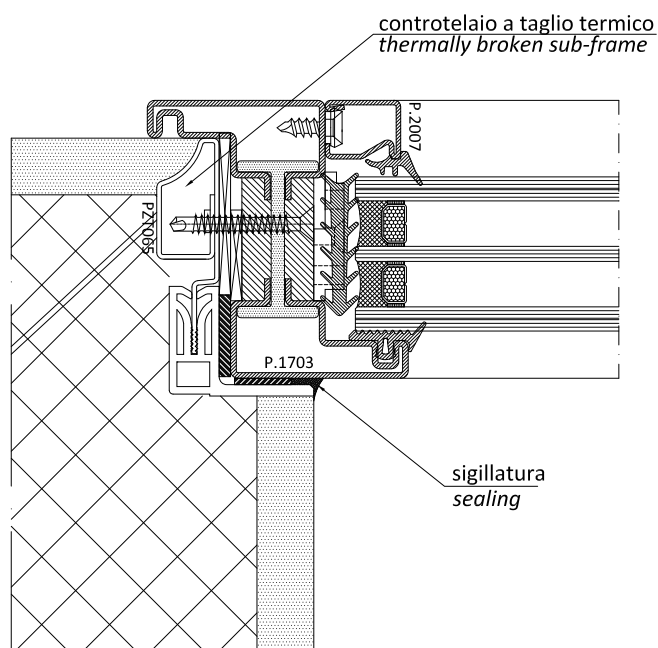








Applicare viti di fissaggio profilo a muro in corrispondenza dell'asse cerniere
 Apply anchoring screws to the hinge axis



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

This image shows a full page of blank graph paper. The grid consists of small, equal-sized squares formed by thin, light gray dashed lines. There are 20 columns and 20 rows of these squares, creating a total of 400 square units. The background is white, and the lines are evenly spaced across the entire area.

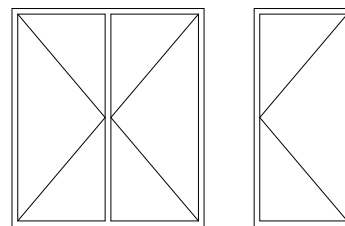
Distinta di taglio e lista componenti | Cutting list and components list

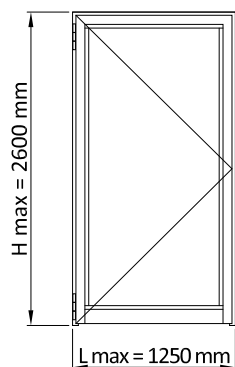
Le distinte di taglio e le liste accessori individuate per le diverse tipologie sono state redatte per un serramento tipo.

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.



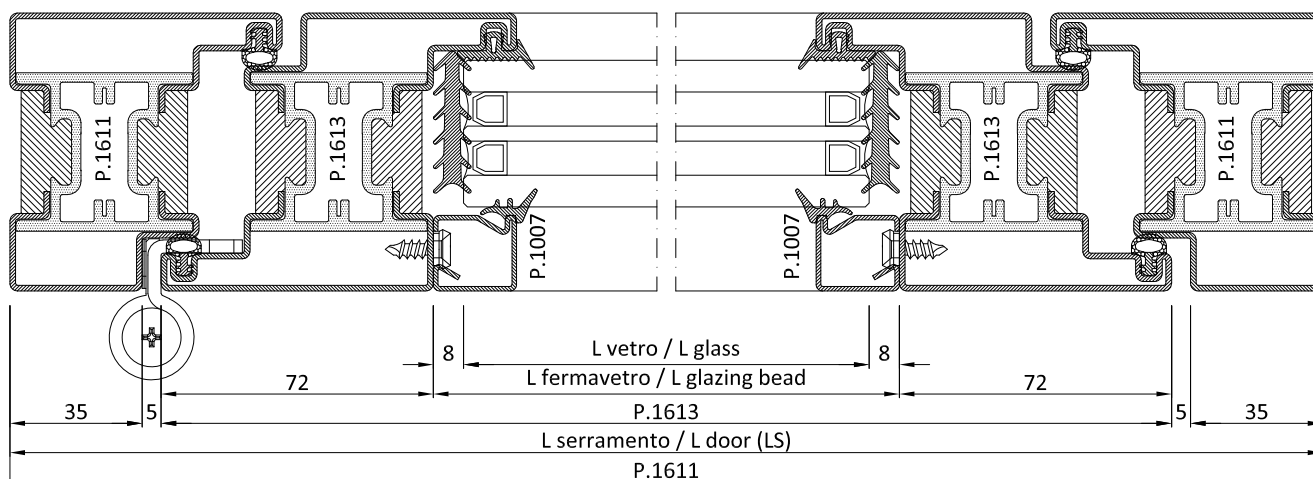
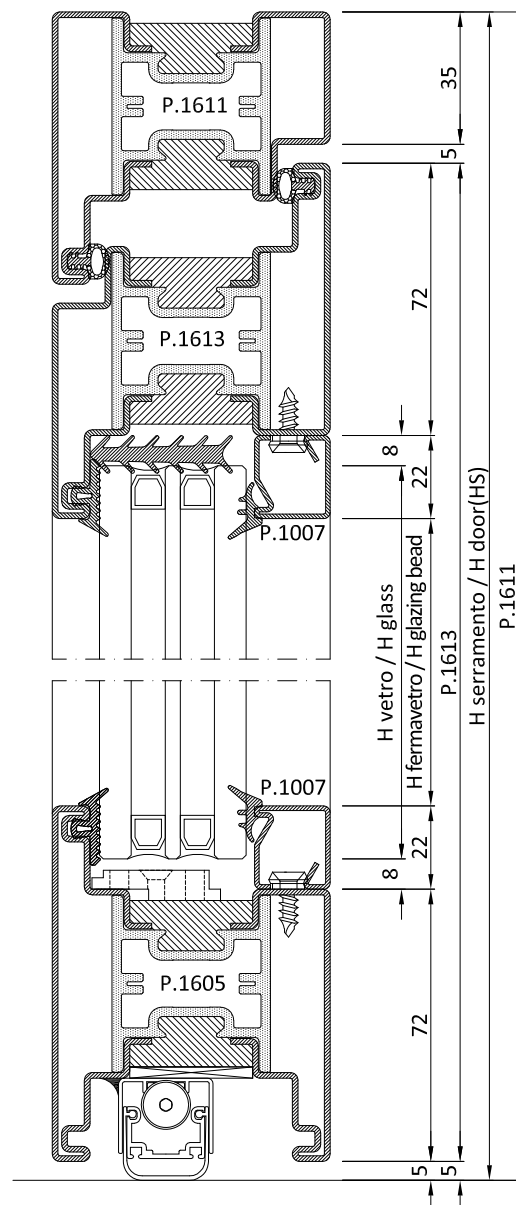


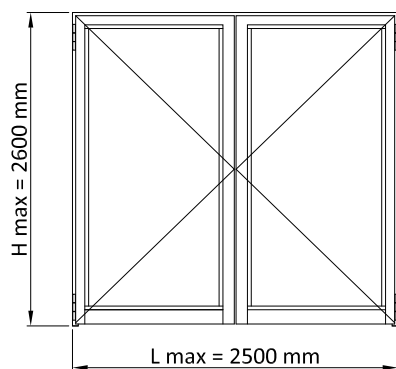
PROFILI		PROFILES				
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
Telaio		Frame				
P.1611	Profilo a "L" telaio	"L" profile frame	1	LS	45°	45°
P.1611	Profilo a "L" telaio	"L" profile frame	1	HS	45°	90°
P.1611	Profilo a "L" telaio	"L" profile frame	1	HS	90°	45°
Anta		Leaf				
P.1613	Profilo a "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.

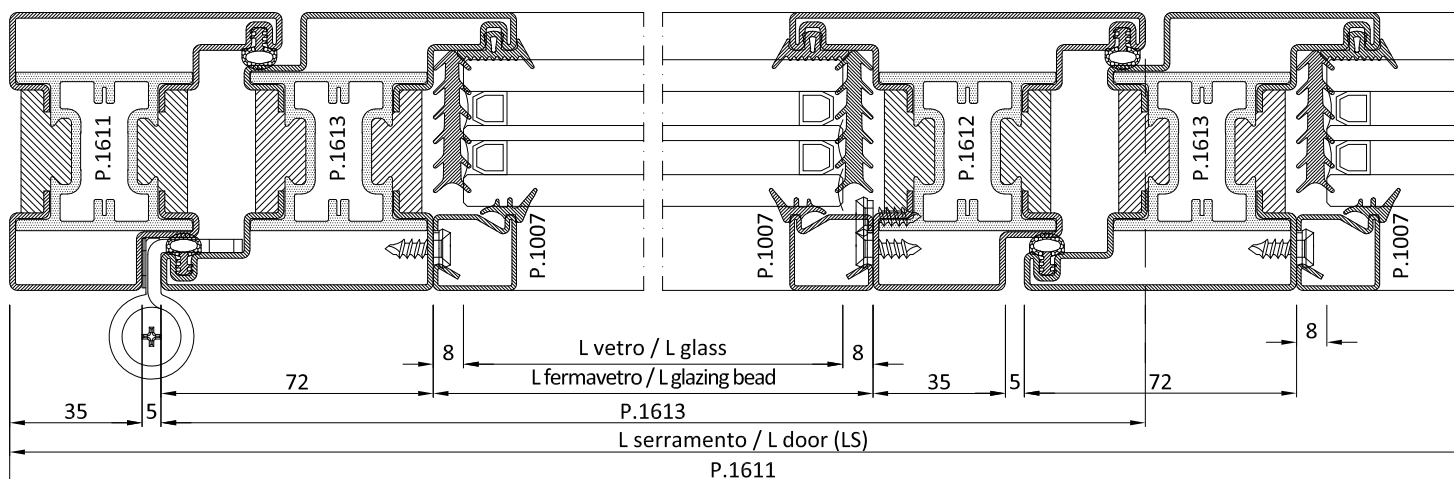
GUARNIZIONI		GASKETS		
Cod.	Descrizione	Description	n°	Dim.
GE1001TT	Guarnizione esterna di battuta	Rebating gasket	1	2xLS+4xHS
GE1006	Guarnizione esterna vetro	External gasket	1	2xLS+2xHS
GE1007TT	Guarnizione sottovetro	Gasket to put under the glass	1	2xLS+2xHS
GE..	Guarnizione interna vetro	Internal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

* solo con profili ottone
only with brass profiles





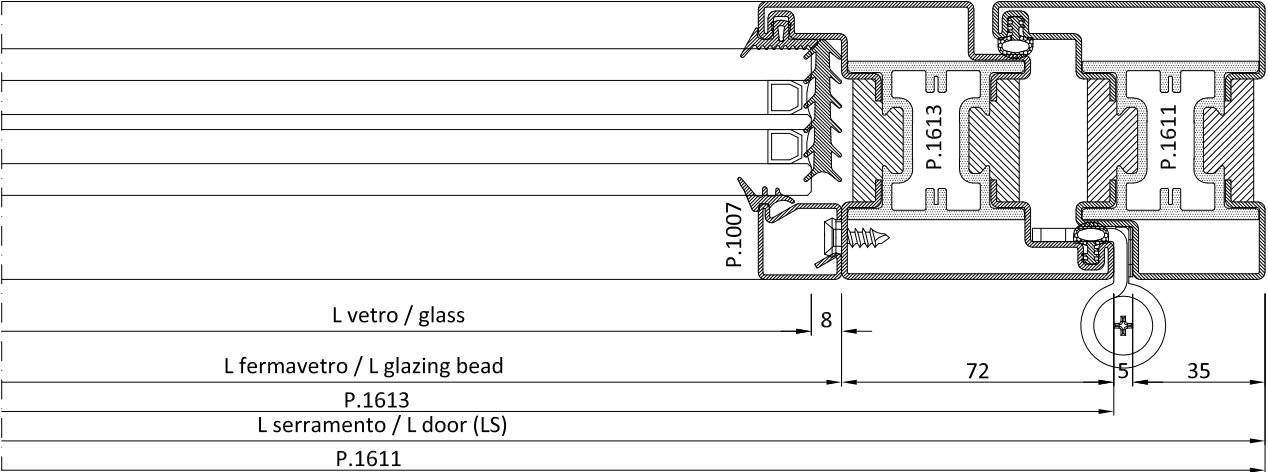
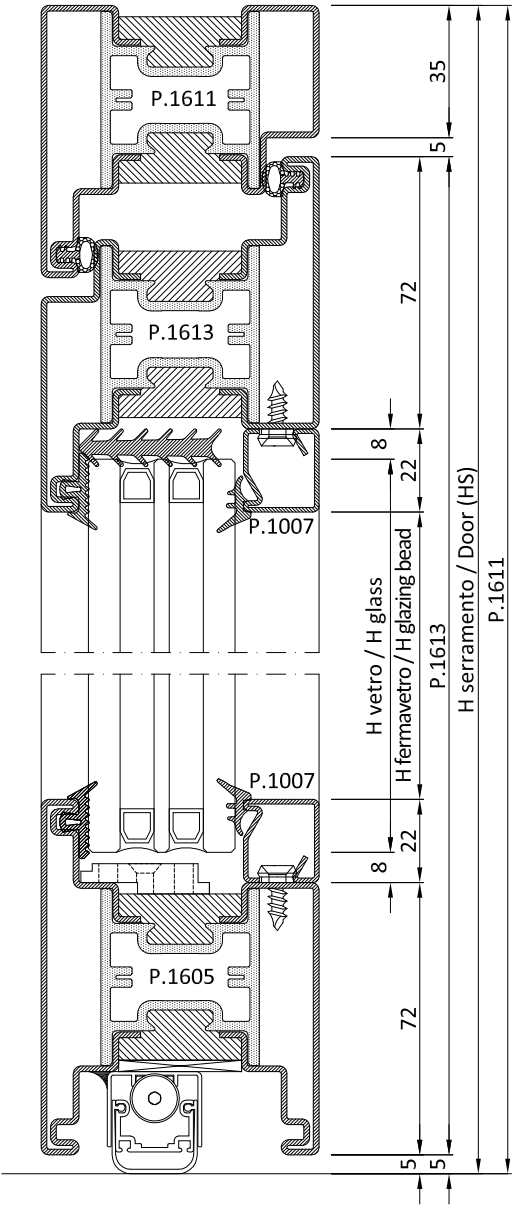
PROFILI		PROFILES				
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
Telaio		Frame				
P.1611	Profilo a "L" telaio	"L" profile frame	1	LS	45°	45°
P.1611	Profilo a "L" telaio	"L" profile frame	1	HS	45°	90°
P.1611	Profilo a "L" telaio	"L" profile frame	1	HS	90°	45°
Anta		Leaf				
P.1613	Profilo a "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



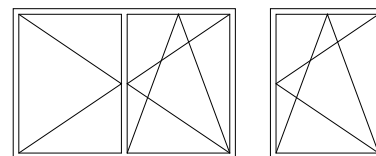
Distinta di taglio e lista componenti | Cutting list and components list

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.

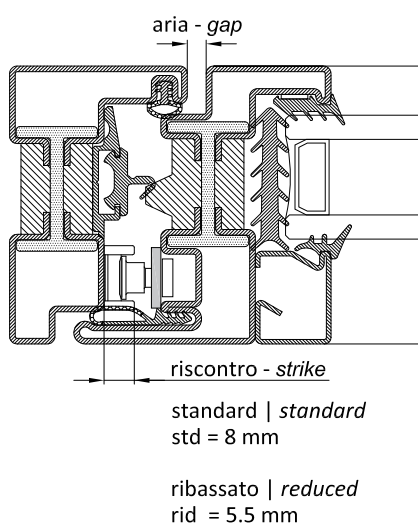
**La tabella seguente va attentamente letta prima del taglio dei profili | The following table should be carefully read before the profiles cutting**

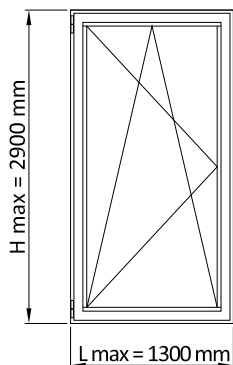
In essa è riportata la misura da considerare nella distanza tra telaio anta e telaio fisso nella produzione di finestre in funzione della tipologia, del tipo di cerniera e della larghezza delle ante da produrre.

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.

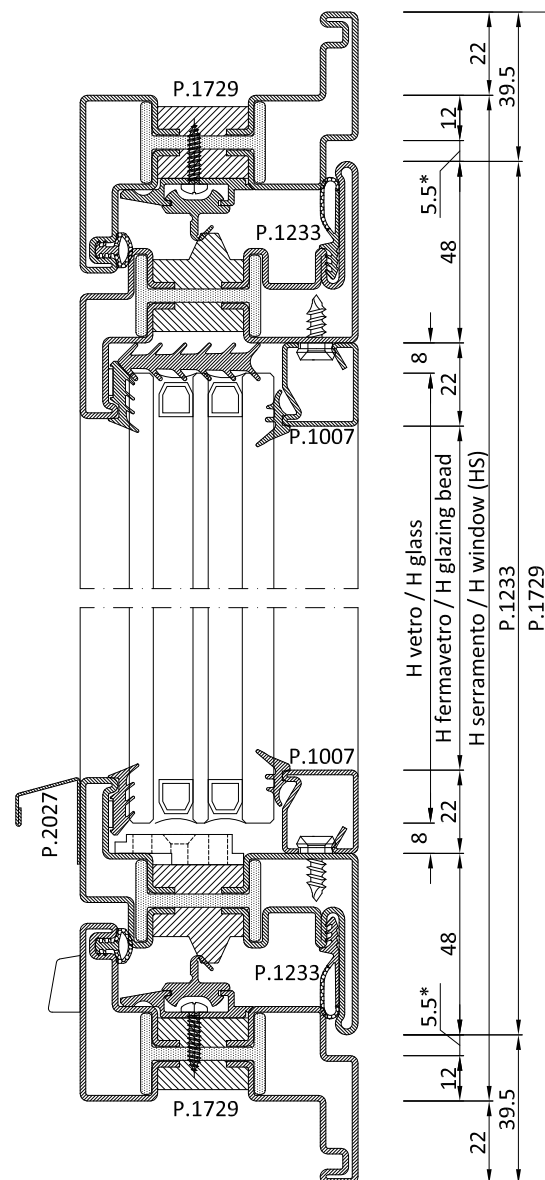
			larghezza anta (cava ferramenta in mm) leaf width (hardware slot in mm)				
			280 360	361 480	481 600	601 800	> 800
AR Easy DK Easy	AGE 281(2)	aria - gap	-	5,5	5,5	5,5	5,5
	AGE 281(2)-286(5) AGE 281(2)-786(5)	riscontro - strike	-	std	std	std	std

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



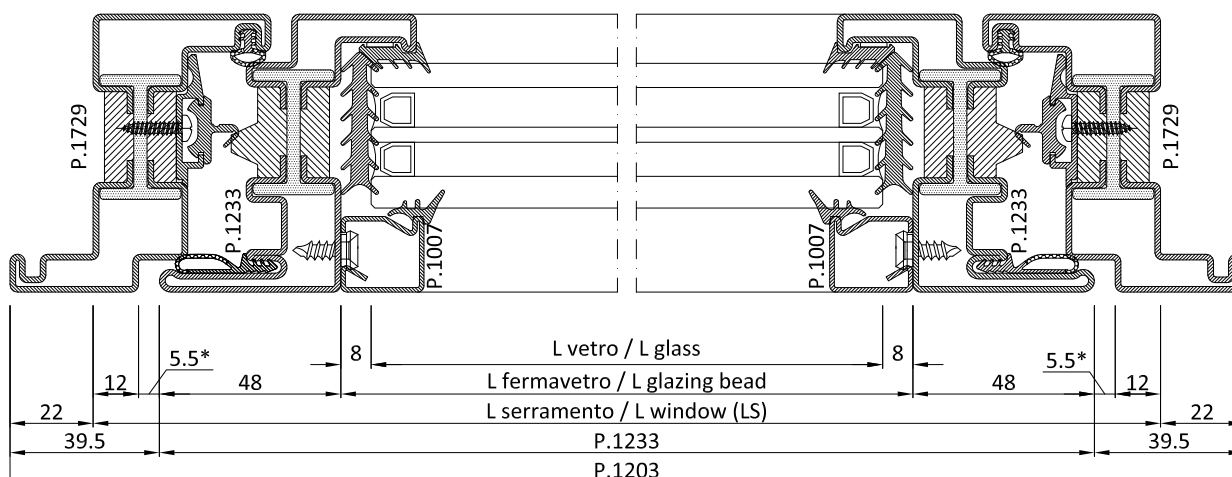


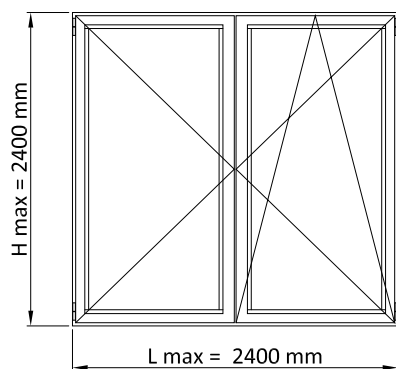
PROFILI		PROFILES			
Cod.	Descrizione	Description	n°	Dim.	Taglio Cutting
Telaio		Frame			
P.1729	Profilo a "Z" telaio	"Z" profile frame	2	LS+44	45° 45°
P.1729	Profilo a "Z" telaio	"Z" profile frame	2	HS+44	45° 45°
Anta		Leaf			
P.1233	Profilo a "Z" anta	"Z" profile frame	2	LS-35	45° 45°
P.1233	Profilo 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 boccia fermavetro	Screw for glazing bead bushing	Var.		
CV5012(i)	Boccia 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 system PVC 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	



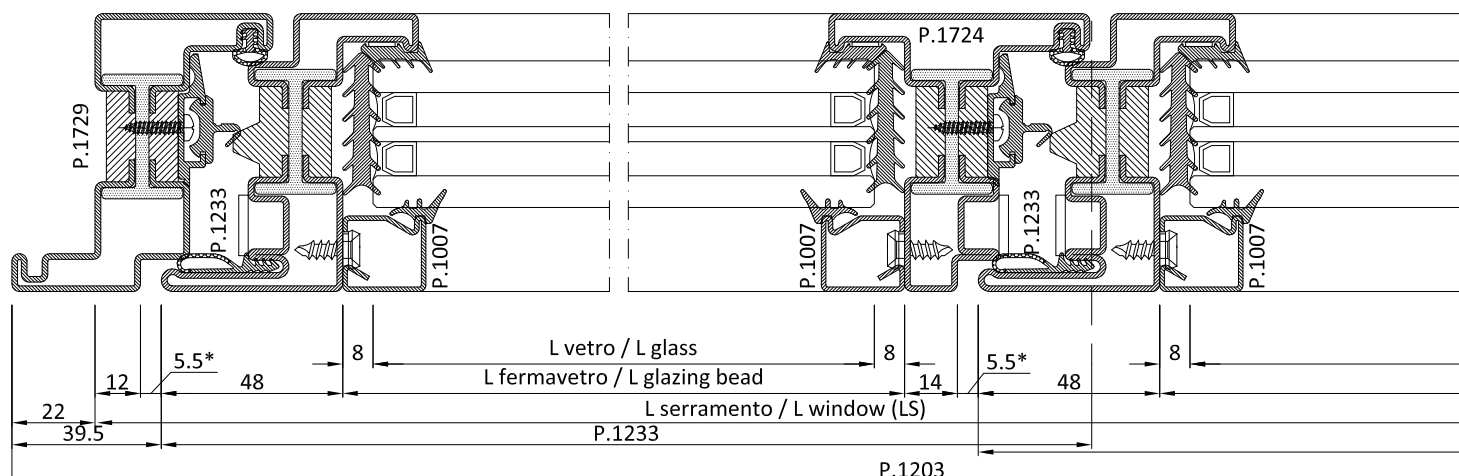
* vedi tabella 4.1.5
see chart 4.1.5

* 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		

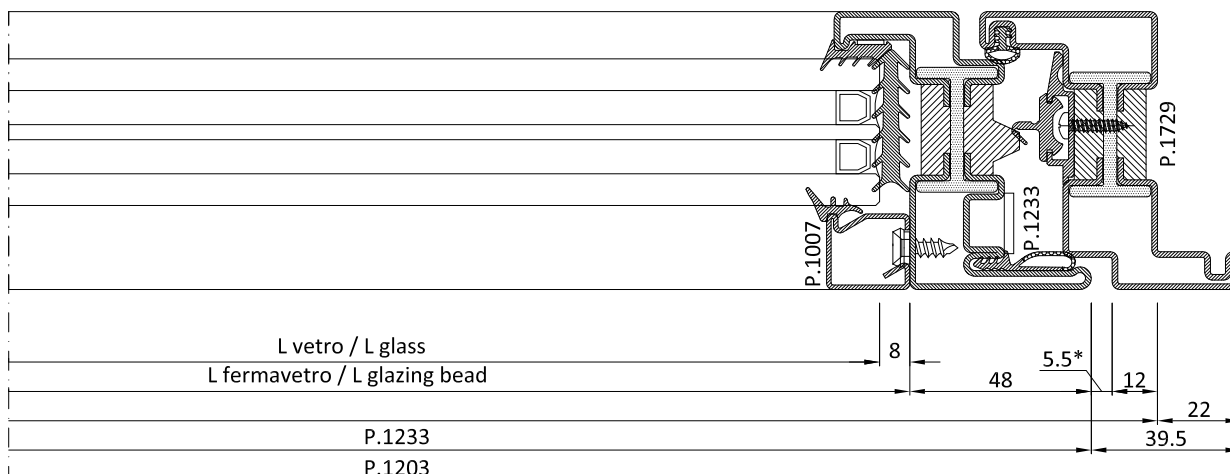
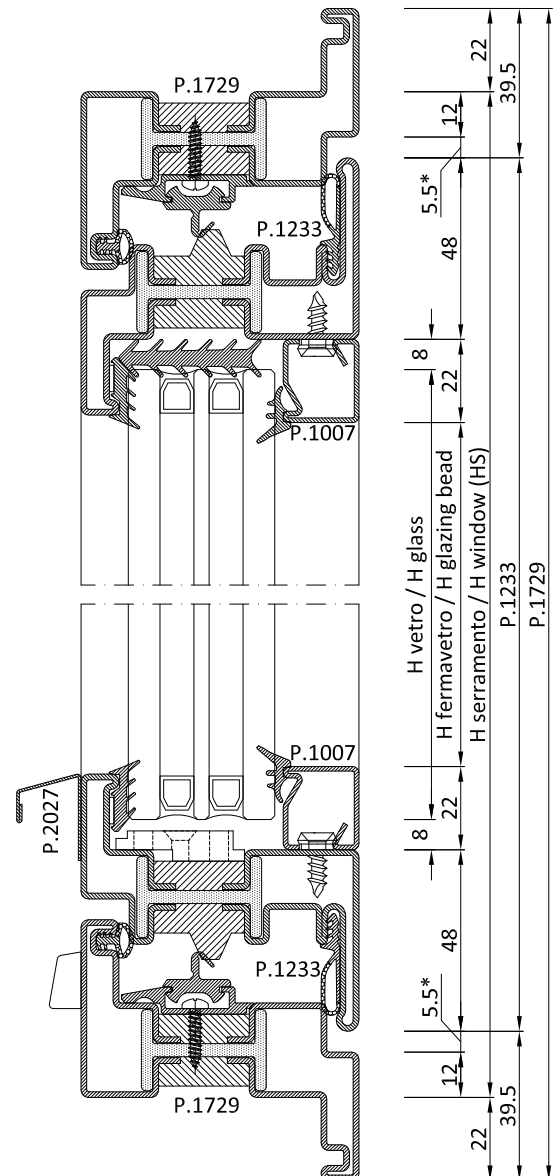


ACCESSORI		HARDWARE
Cod.	Descrizione	Description
AC1729I*	Kit squadrette per P.1729	Corner joint kit for P.1729
AC1207I*	Kit squadrette per P.1233	Corner joint kit for P.1233
AC1708I*	Kit squadrette per P.1233-1724	Corner joint kit for P.1233-1724
AC1716	Guarnizione d'angolo	Vulcanised corner gasket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

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 system PVC 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



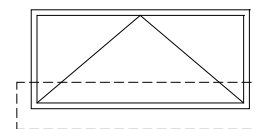
Distinta di taglio e lista componenti | Cutting list and components list

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.

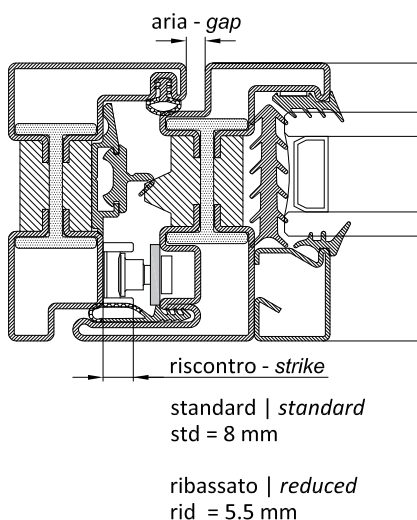
**La tabella seguente va attentamente letta prima del taglio dei profili | The following table should be carefully read before the profiles cutting**

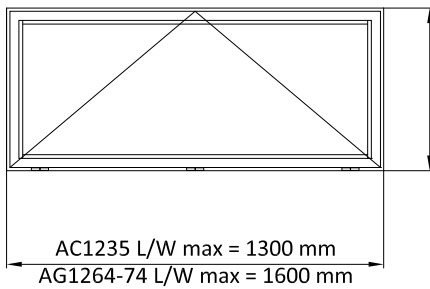
In essa è riportata la misura da considerare nella distanza tra telaio anta e telaio fisso nella produzione di finestre in funzione della tipologia, del tipo di cerniera e della larghezza delle ante da produrre.

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	AG 1264	aria - gap	6	5
Bottom hung	AG 1274	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*



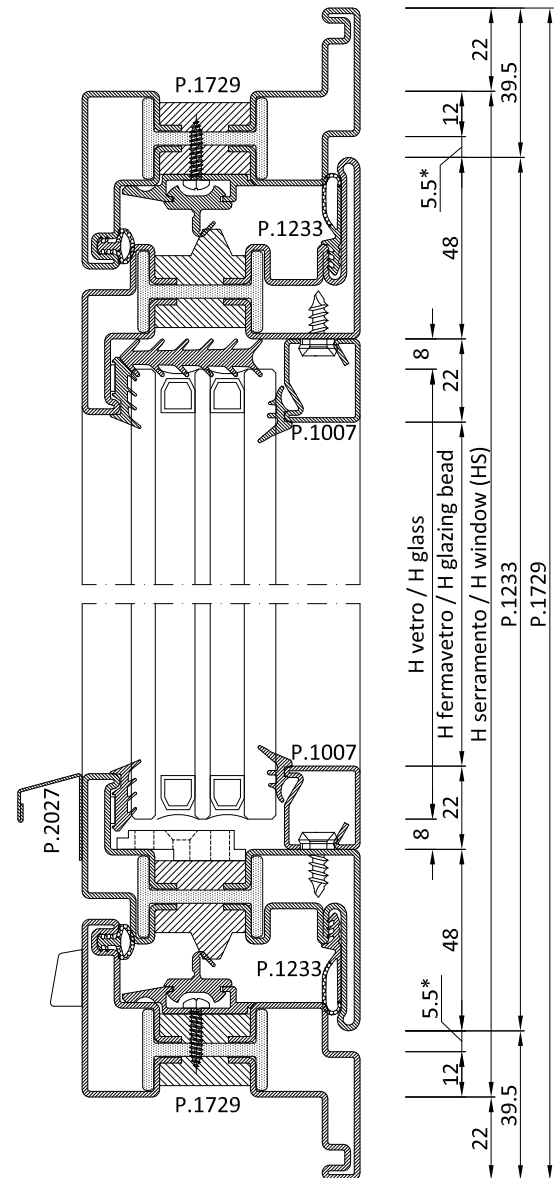


AC1235	H max = 800 mm
AG1264-74	H max = 1200 mm

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		

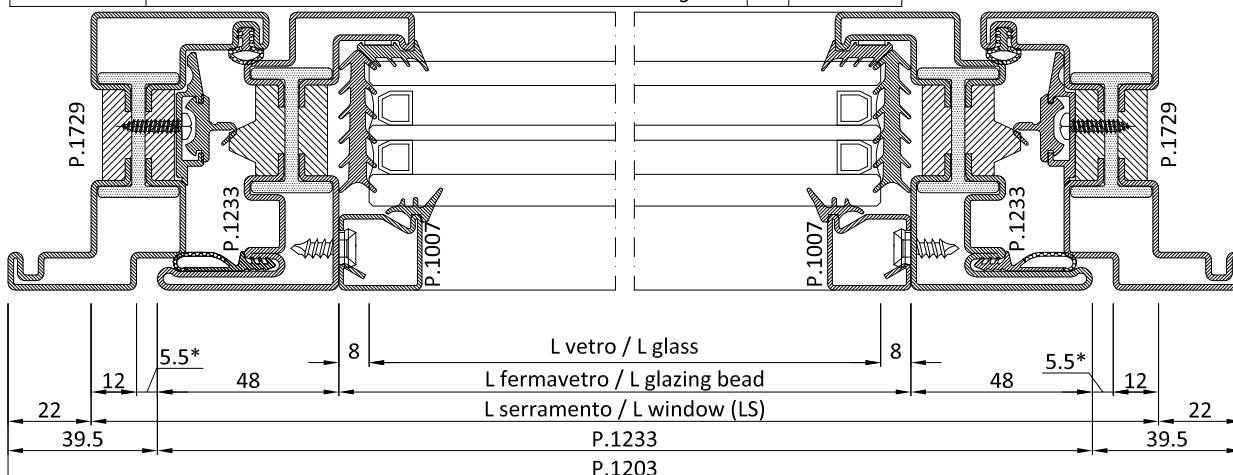
	ACCESSORI	HARDWARE	
Cod.	Descrizione	Description	n°
AC1729I*	Kit squadrette per P.1729	Corner joint kit for P.1729	4
AC1207I*	Kit squadrette per P.1233	Corner joint kit for P.1233	4
AC1716	Guarnizione d'angolo	Vulcanised corner gasket	4
AC1219	Scarico acqua	Water drip	Var.
AC2632/C	Cerniera a saldare	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.

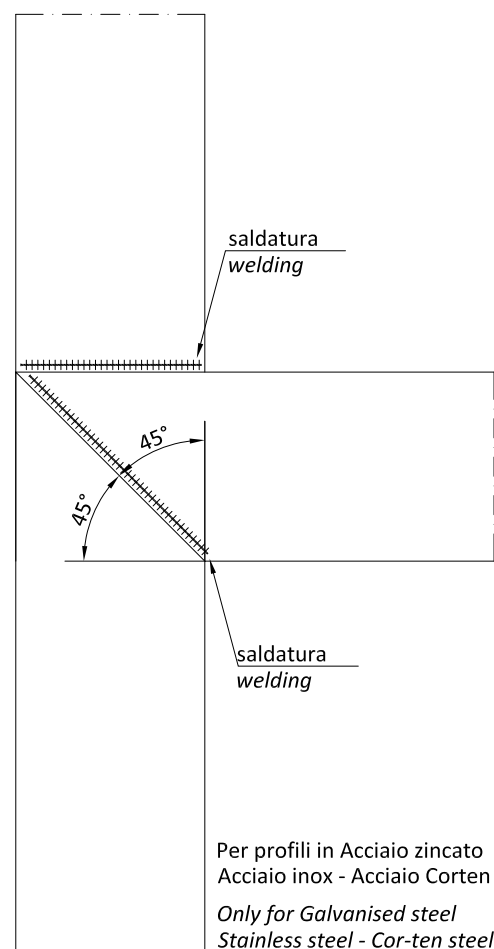
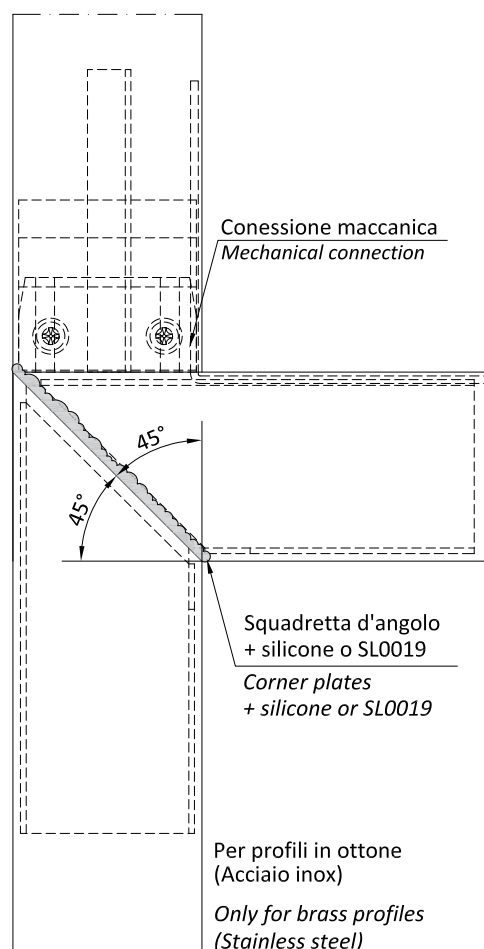
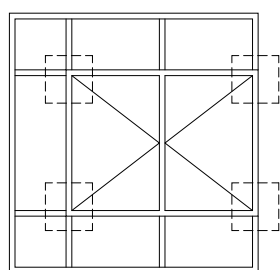
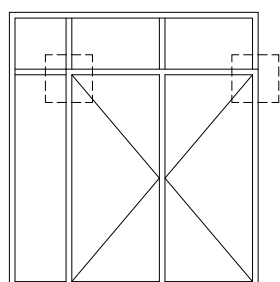
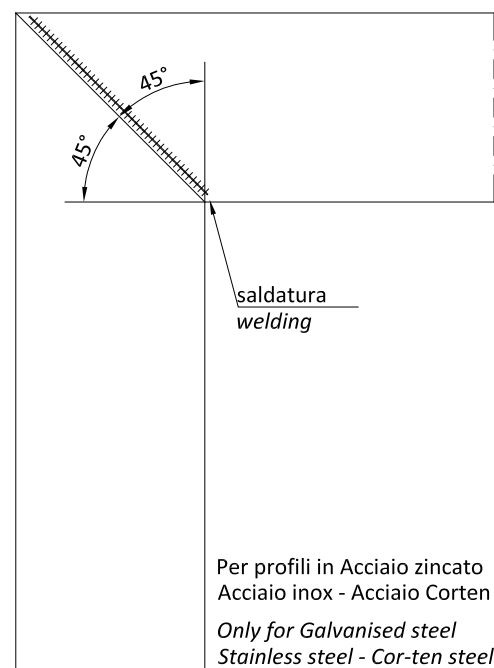
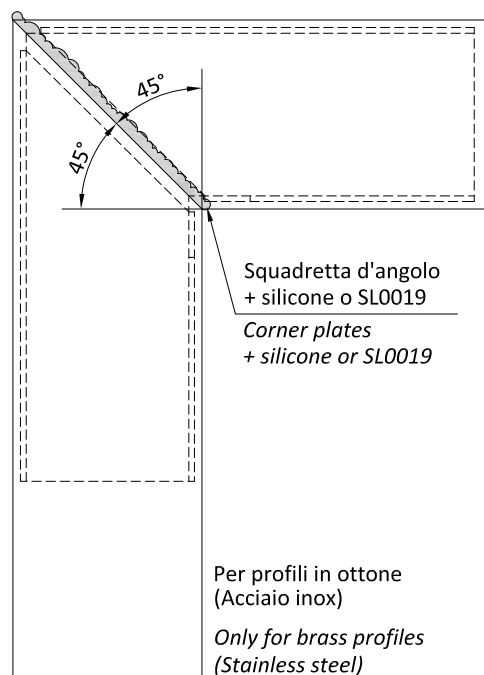
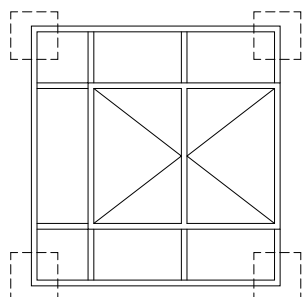
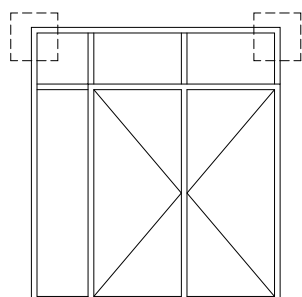
GUARNIZIONI		GASKETS	
Cod.	Descrizione	Description	n° Dim.
GE1233TT	Guarnizione esterna di battuta	External rebating gasket	1 2xLS+2xHS
GE1701	Guarnizione giunto aperto	Open joint system gasket	1 2xLS+2xHS
GU1702	Estruso PVC giunto aperto	Open joint systemPVC profile	1 2xLS+2xHS
GE1200TT	Guarnizione 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

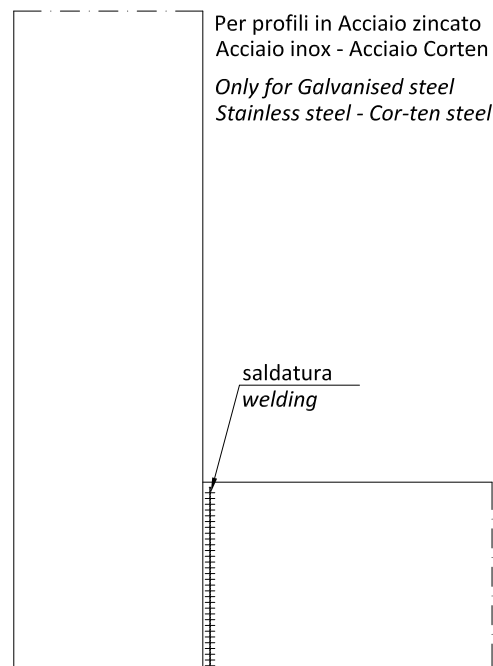
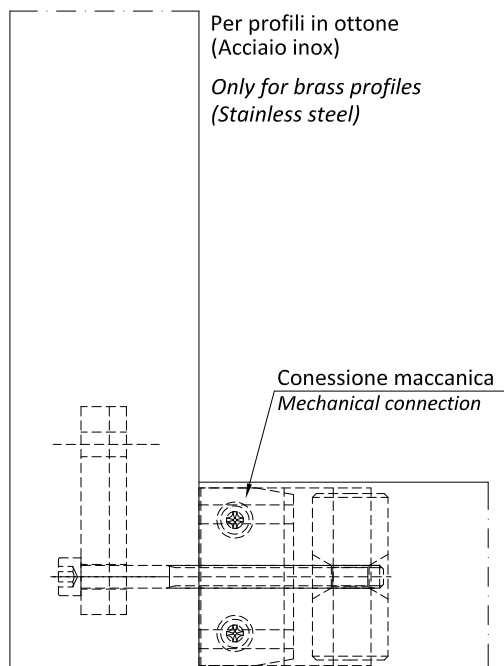
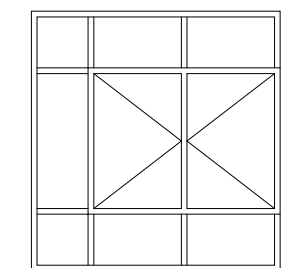
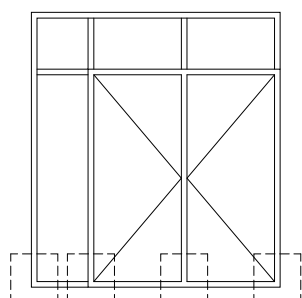
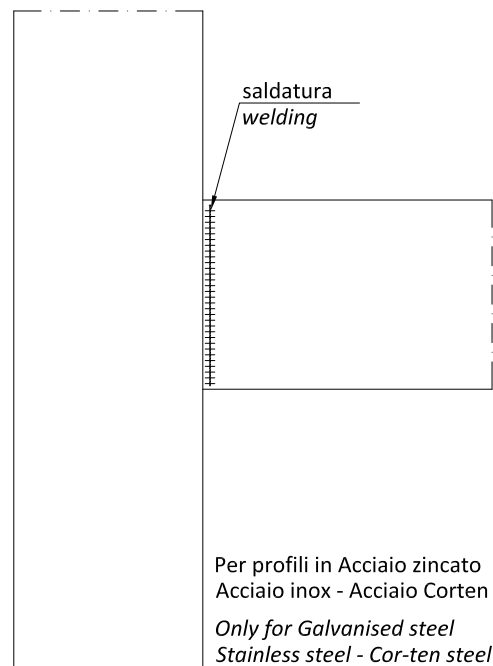
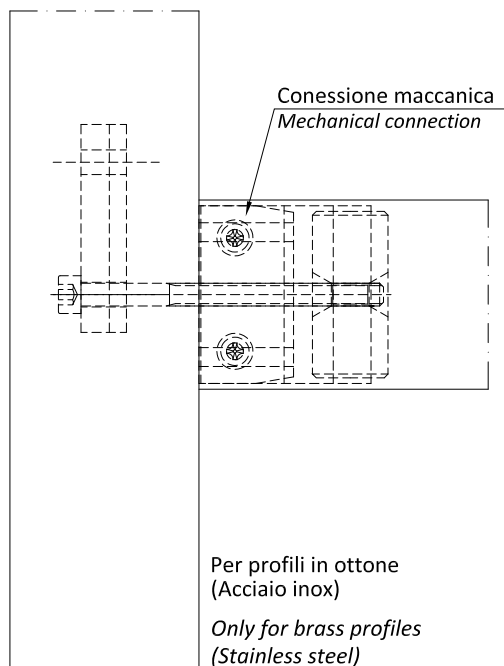
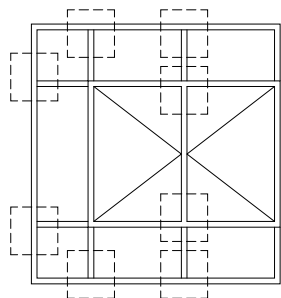
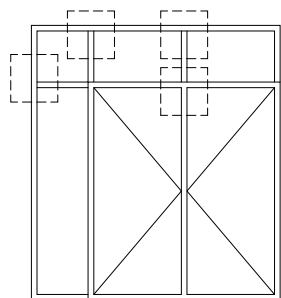


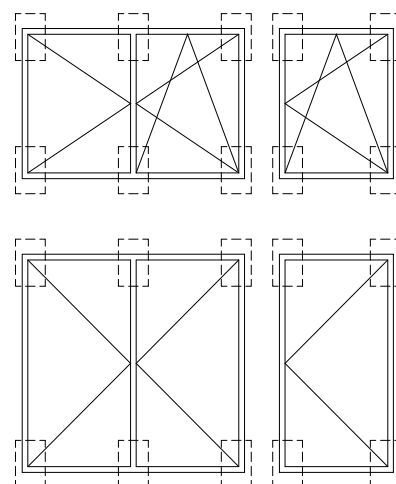
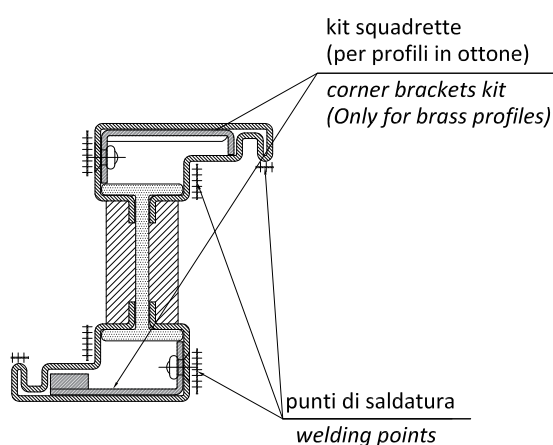
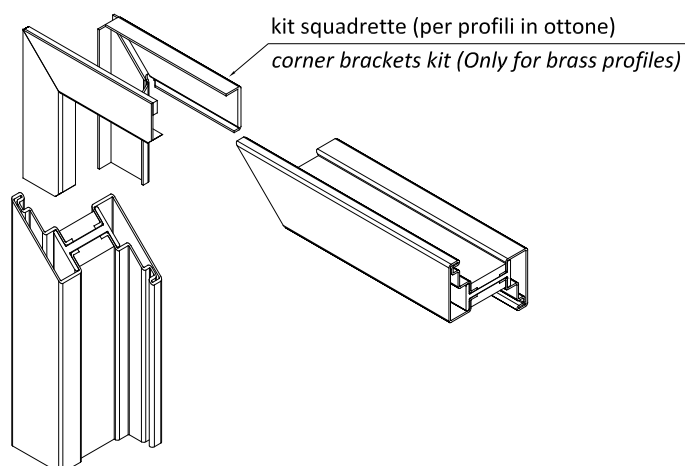
* vedi tabella 4.1.9
see chart 4.1.9

* solo con profili ottone
only with brass profiles









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

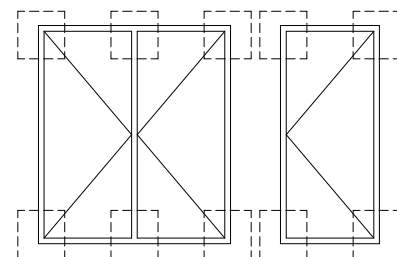
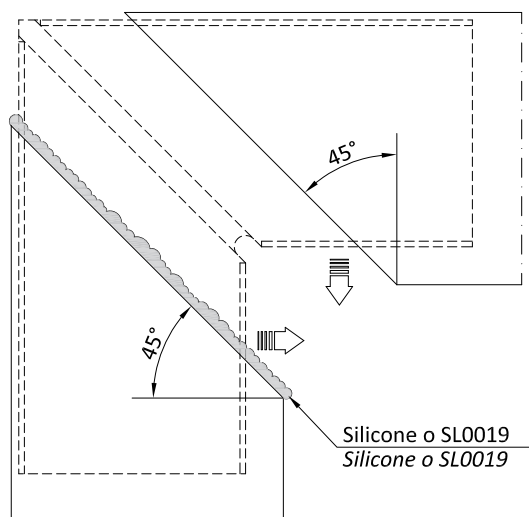
Saldare in continuo le superfici di contatto.

Galvanised steel - Cor-ten steel - Stainless steel

Seam-weld all contact surfaces.

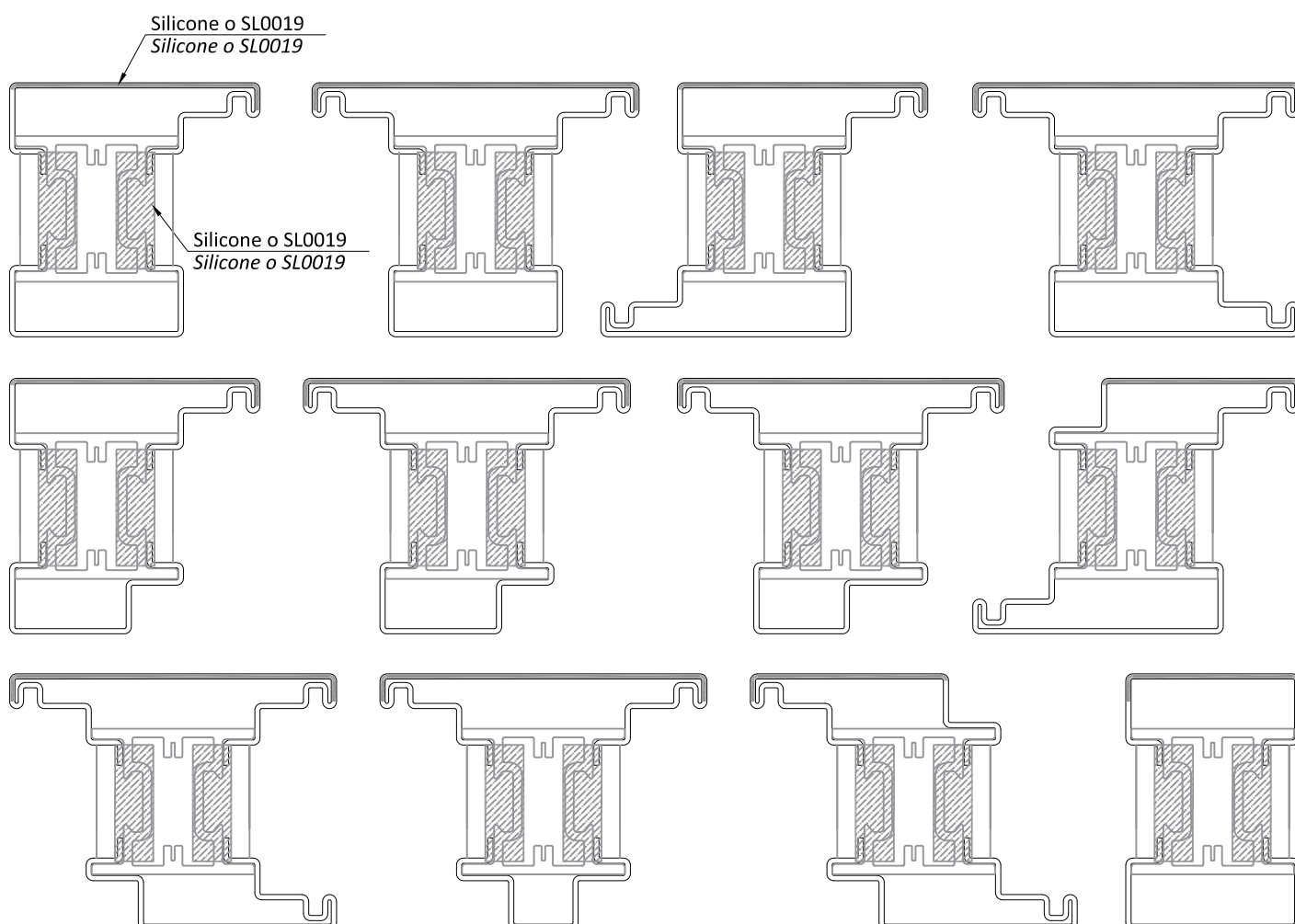
Profilo	Profile	Kit squadrette	Corner brackets set
Codice	Code	Codice	Code
P.1601-P.1601		AC 1001I	
P.1602-P.1602		AC 1002I	
P.1603-P.1603		AC 1003I	
P.1611-P.1611		AC 1004I	
P.1612-P.1612		AC 1005I	
P.1613-P.1613		AC 1006I	anta / leaf
P.1613-P.1613		AC 1007I	telaio / frame
P.1612-P.1613		AC 1008I	
P.1605-P.1605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

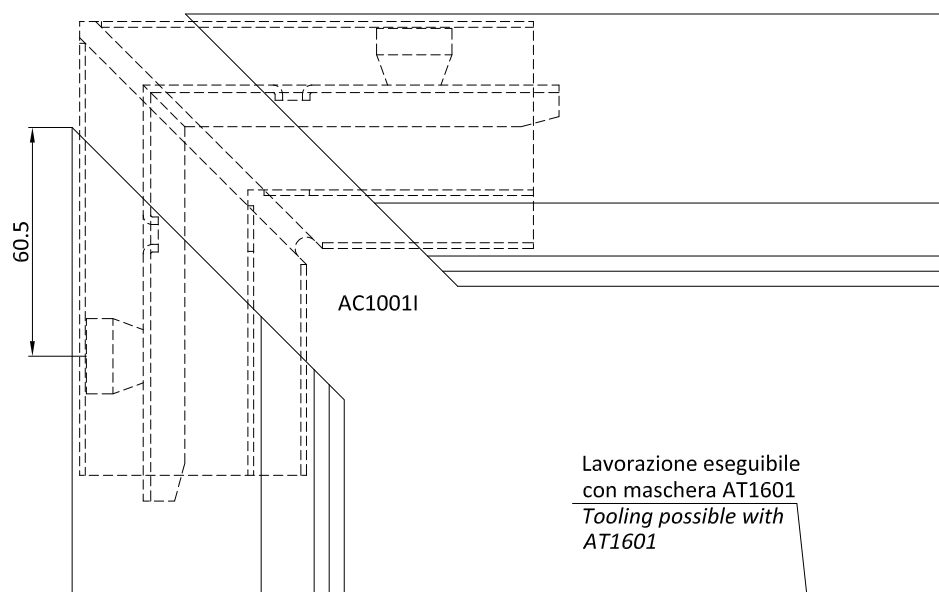


- 1) inserire la squadretta
- 2) siliconare nelle zone indicate
- 3) accostare i profili
- 4) procedere con la saldatura (vedasi pagine successive)

- 1) insert the bracket
- 2) seal in the specified areas
- 3) align the profiles
- 4) weld (see following pages)

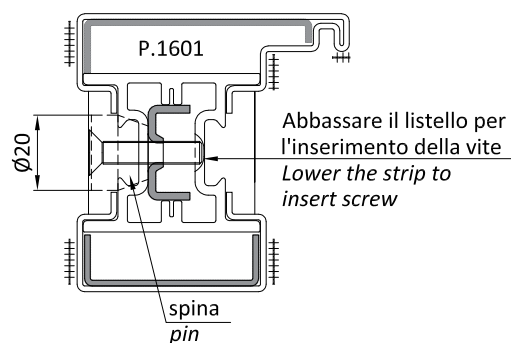


■ Sigillare con silicone o sigillante a freddo SL0019 nelle zone evidenziate (sempre lato esterno profilo)
 ■ Seal with silicone or cold-working sealant SL0019 in the areas marked (always on the outer side of the profile)



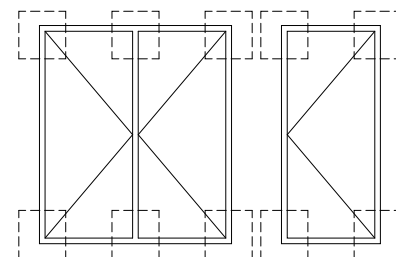
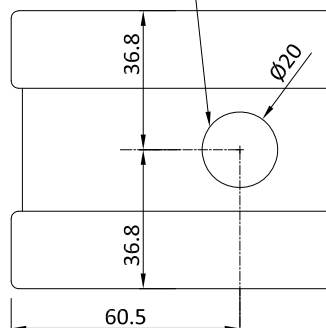
AC1001I

Lavorazione eseguibile
con maschera AT1601
Tooling possible with
AT1601



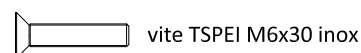
Abbassare il listello per
l'inserimento della vite
Lower the strip to
insert screw

spina
pin



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

Sigillare tutte le superfici di contatto
esterne con silicone o SL0019



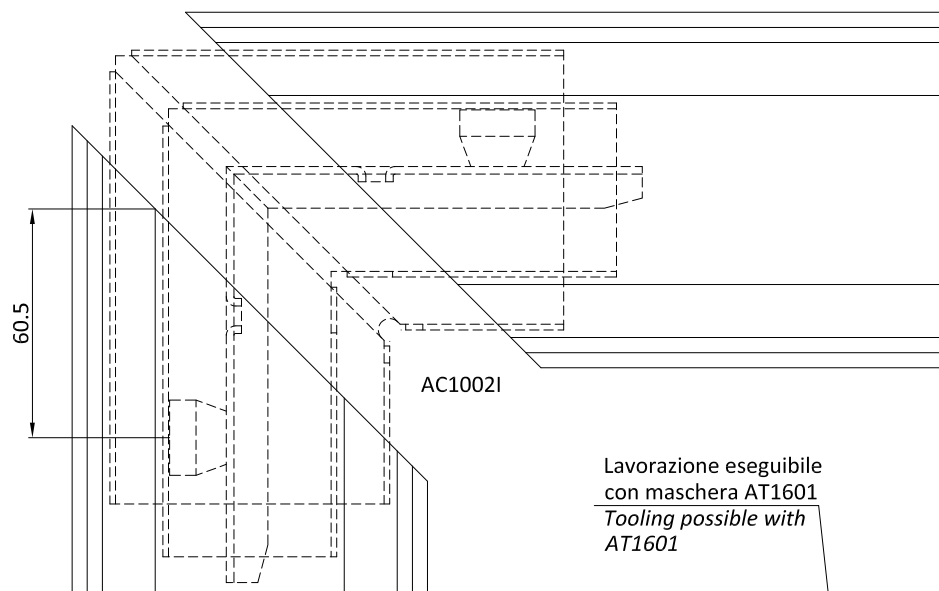
vite TSPEI M6x30 inox

TIG welding with filler material in the
areas indicated with +++++

Seal all the external contact surfaces
with silicone our SL0019

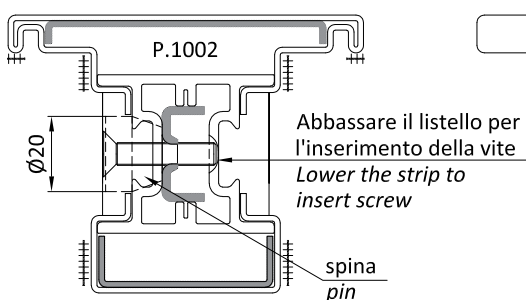


stainless steel screws
TSPEI M6x30



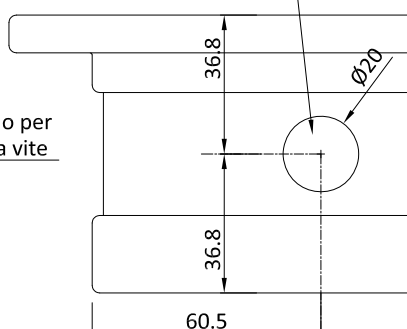
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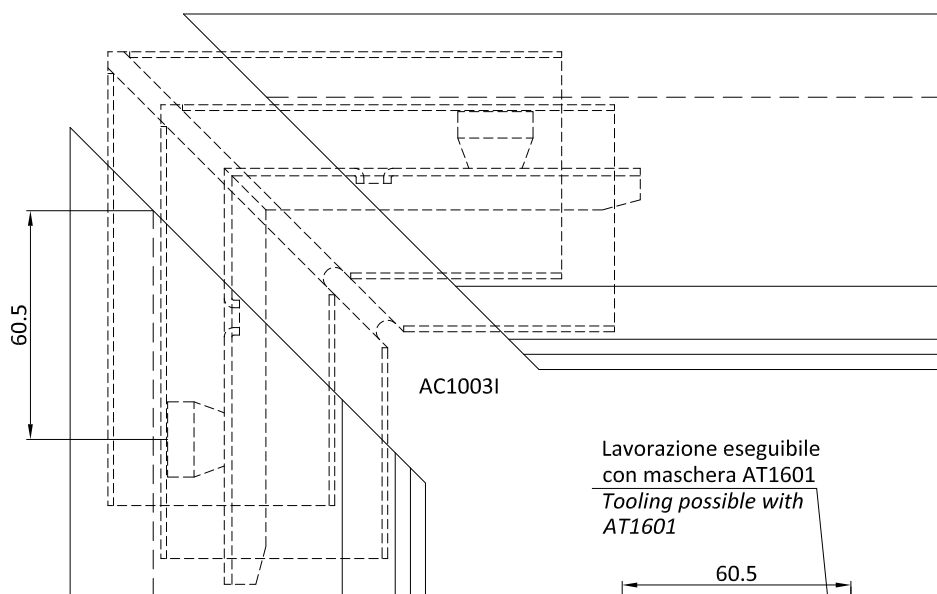
Lavorazione eseguibile
con maschera AT1601
Tooling possible with
AT1601



Abbassare il listello per
l'inserimento della vite
Lower the strip to
insert screw

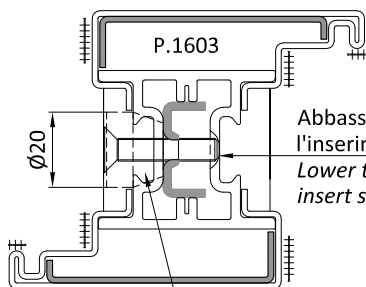
spina
pin





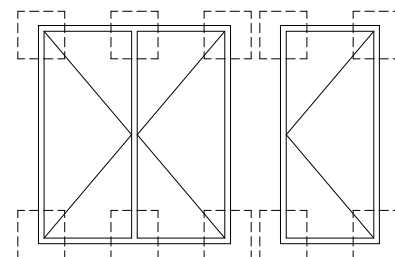
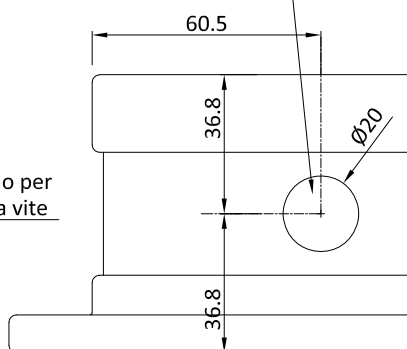
AC1003I

Lavorazione eseguibile
con maschera AT1601
*Tooling possible with
AT1601*



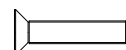
Abbassare il listello per
l'inserimento della vite
*Lower the strip to
insert screw*

spina
pin



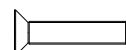
Saldare a TIG con materiale di riporto
nelle zone indicate con +++++

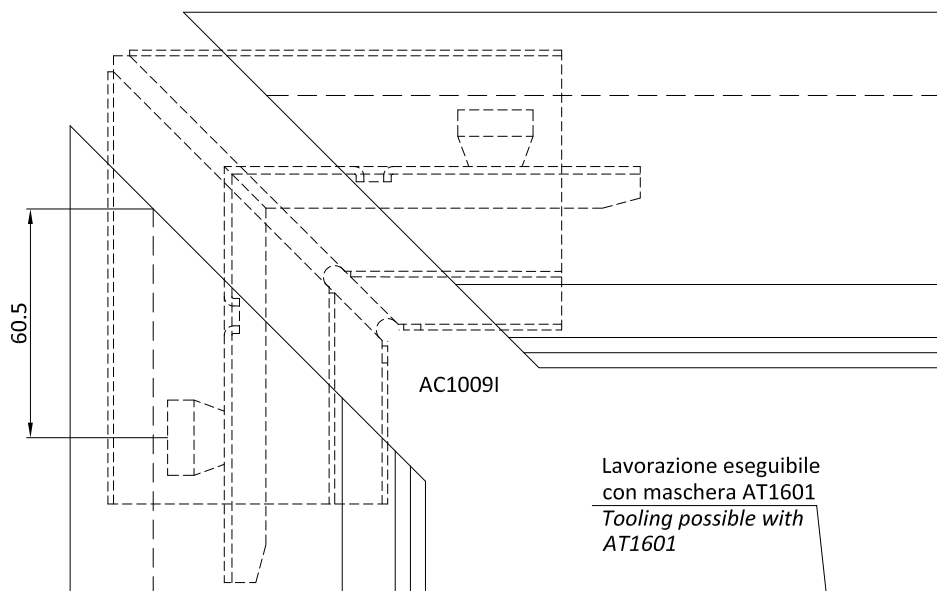
Sigillare tutte le superfici di contatto
esterne con silicone o SL0019

 vite TSPEI M6x30 inox

TIG welding with filler material in the
areas indicated with +++++

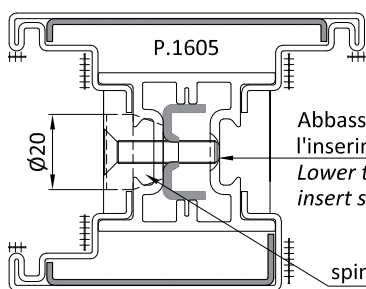
Seal all the external contact surfaces
with silicone or SL0019

 stainless steel screws
TSPEI M6x30



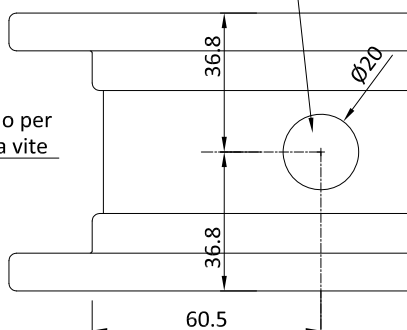
AC1009I

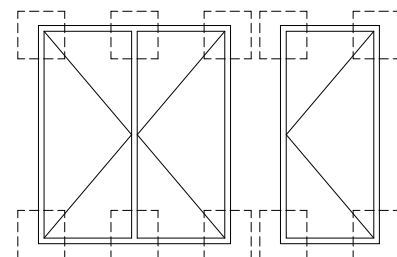
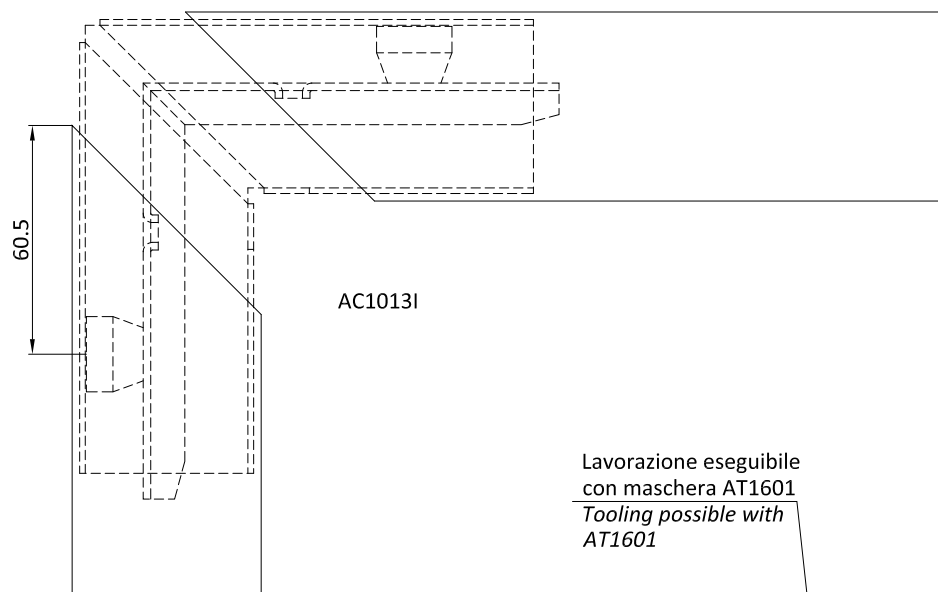
Lavorazione eseguibile
con maschera AT1601
*Tooling possible with
AT1601*



Abbassare il listello per
l'inserimento della vite
*Lower the strip to
insert screw*

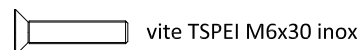
spina
pin





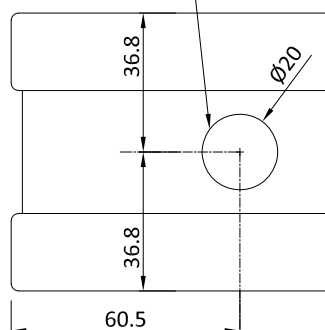
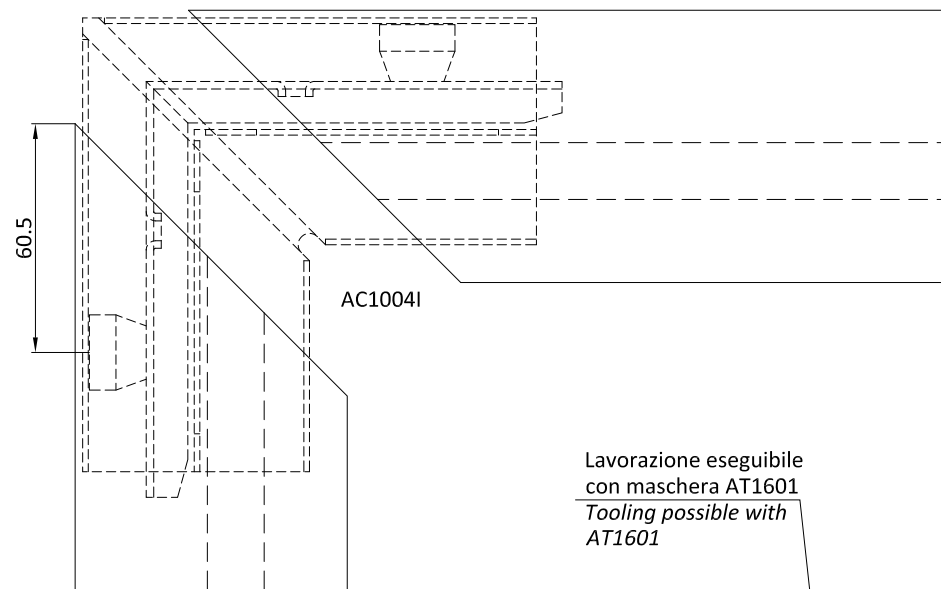
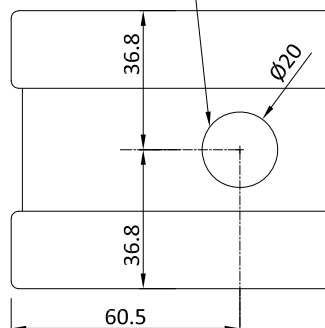
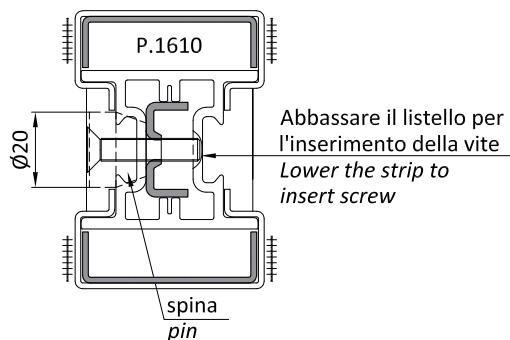
Saldare a TIG con materiale di riporto nelle zone indicate con +++++

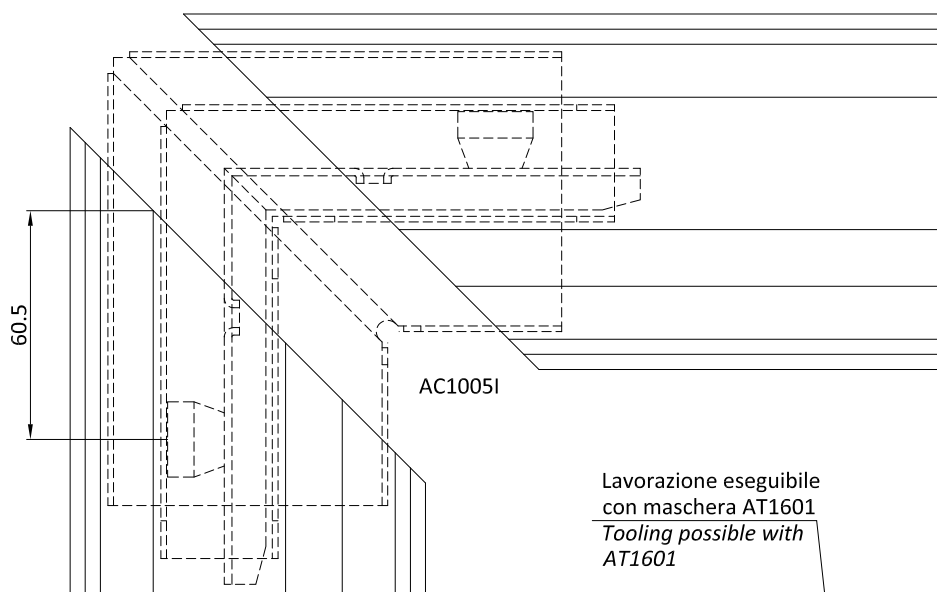
Sigillare tutte le superfici di contatto esterne con silicone o SL0019



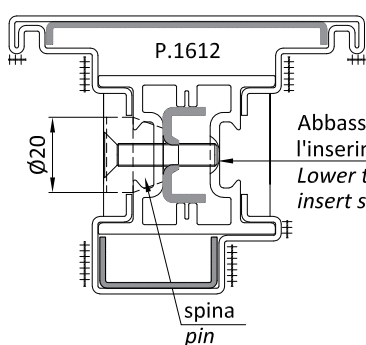
TIG welding with filler material in the areas indicated with +++++

Seal all the external contact surfaces with silicone or SL0019

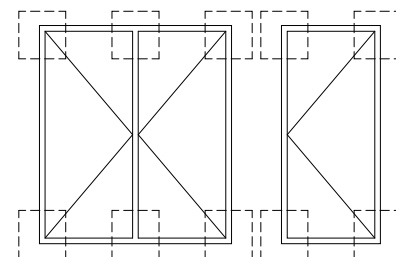
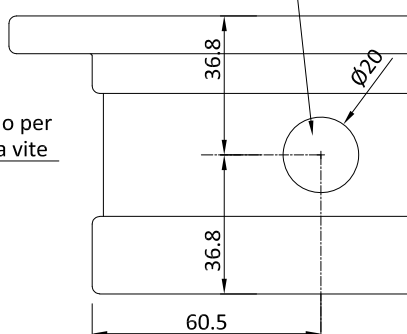




Lavorazione eseguibile
con maschera AT1601
Tooling possible with
AT1601

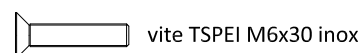


Abbassare il listello per
l'inserimento della vite
Lower the strip to
insert screw



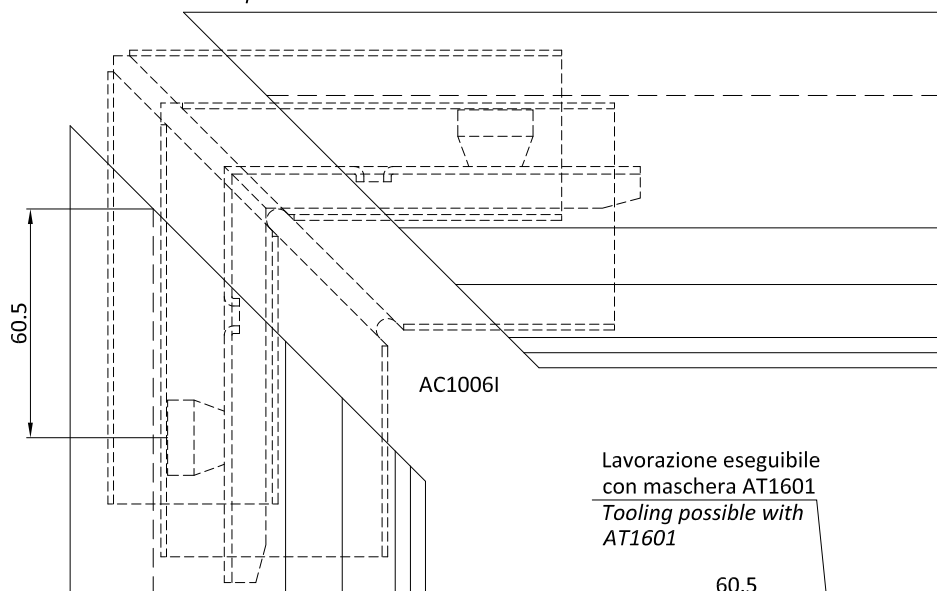
Saldare a TIG con materiale di riporto
nelle zone indicate con +++++

Sigillare tutte le superfici di contatto
esterne con silicone o SL0019

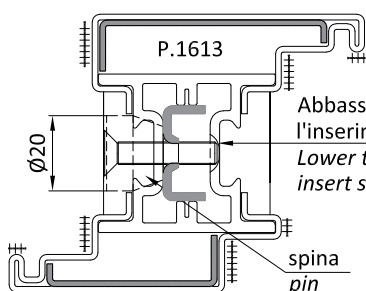


TIG welding with filler material in the
areas indicated with +++++

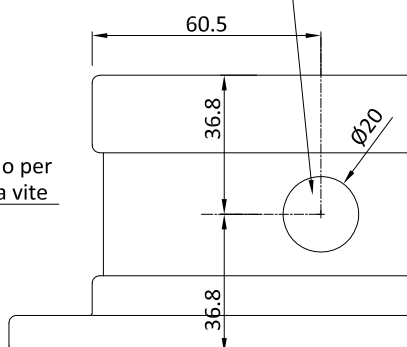
Seal all the external contact surfaces
with silicone or SL0019

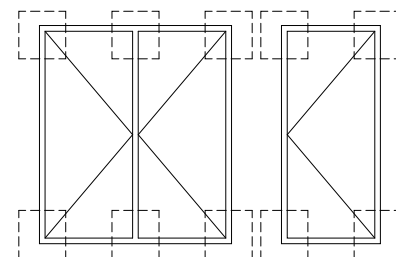
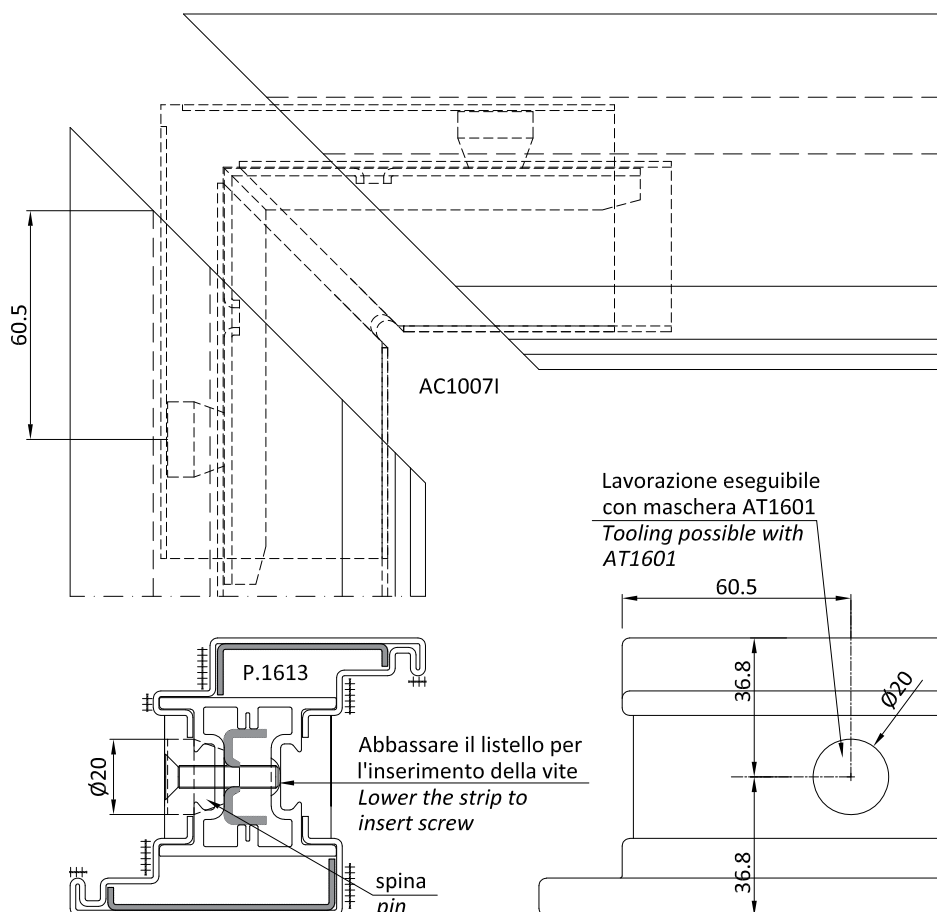


Lavorazione eseguibile
con maschera AT1601
Tooling possible with
AT1601



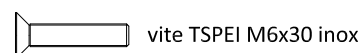
Abbassare il listello per
l'inserimento della vite
Lower the strip to
insert screw





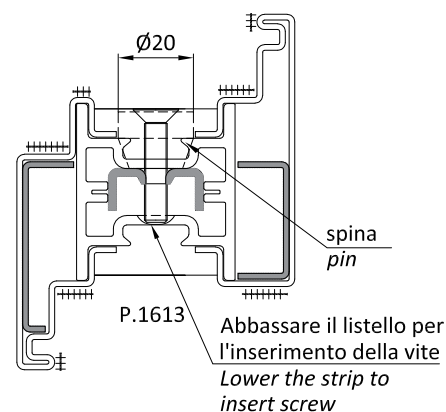
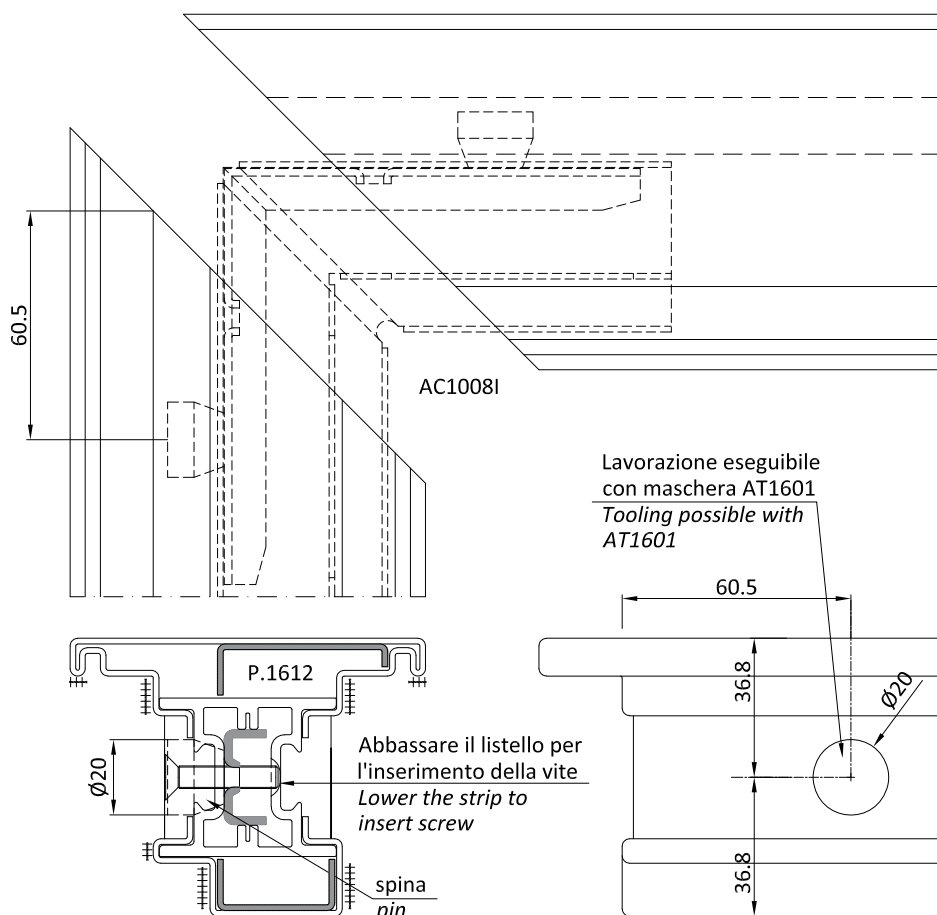
Saldare a TIG con materiale di riporto nelle zone indicate con +++++

Sigillare tutte le superfici di contatto esterne con silicone o SL0019

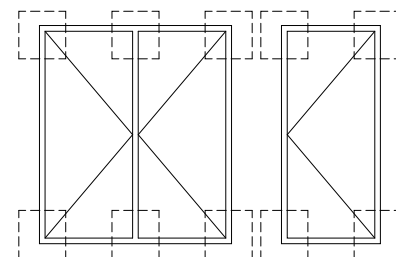
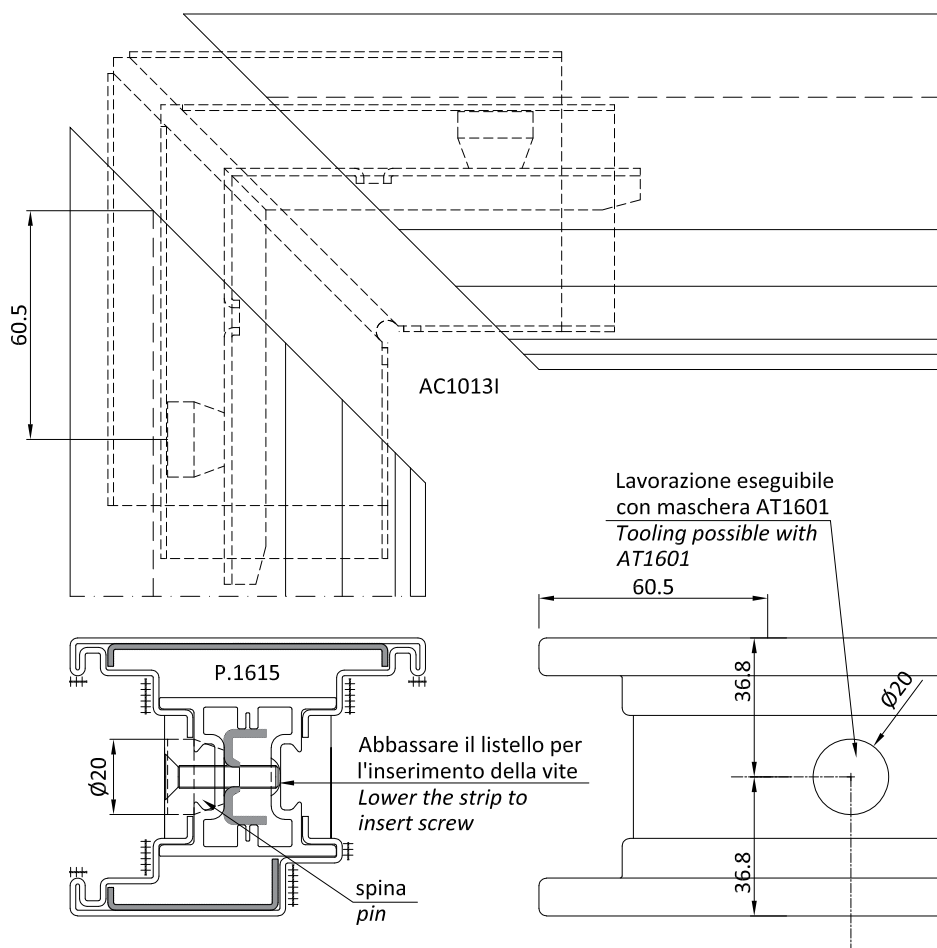


TIG welding with filler material in the areas indicated with +++++

Seal all the external contact surfaces with silicone or SL0019

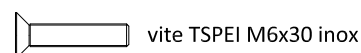


Abbassare il listello per l'inserimento della vite
Lower the strip to insert screw



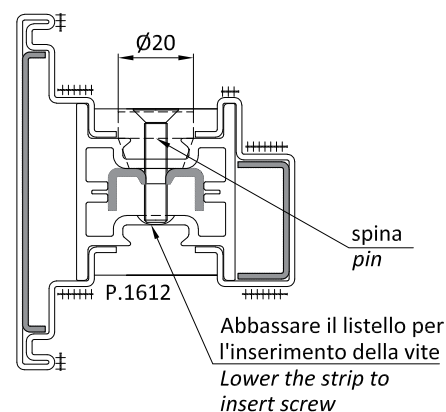
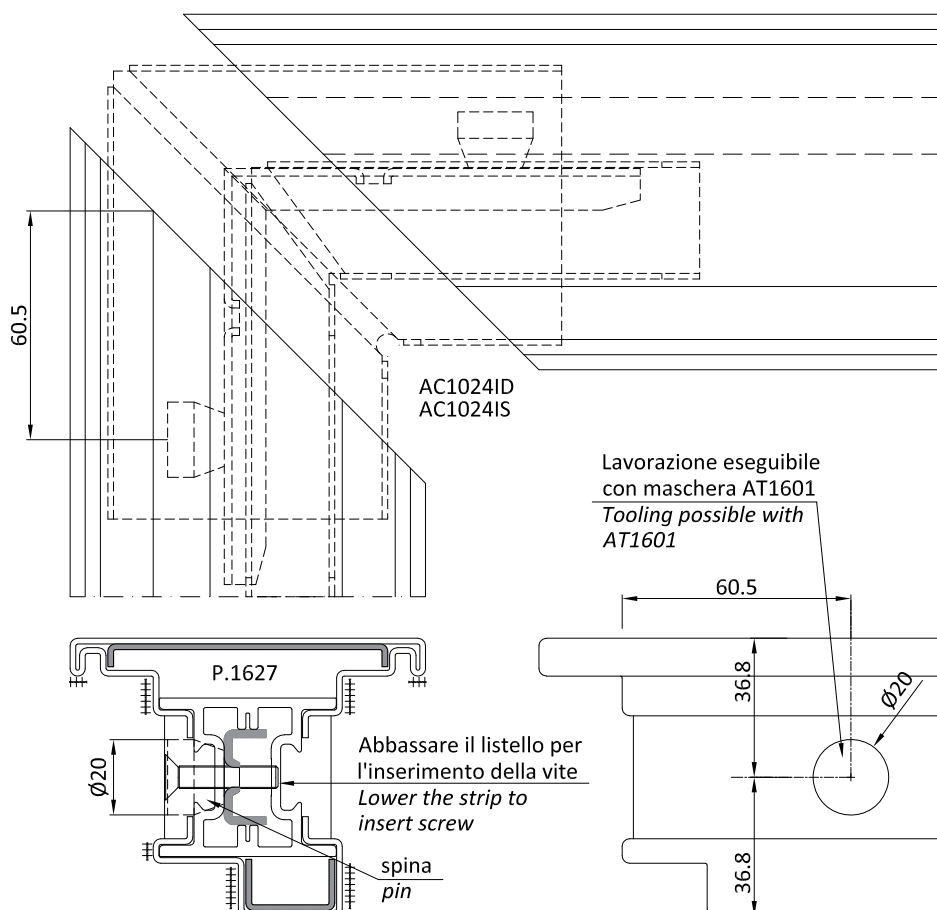
Saldare a TIG con materiale di riporto nelle zone indicate con +++++

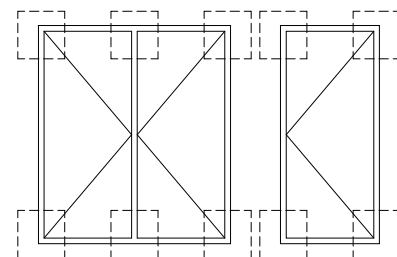
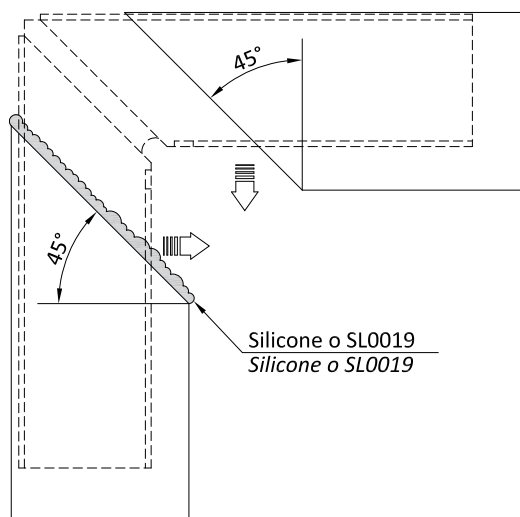
Sigillare tutte le superfici di contatto esterne con silicone o SL0019



TIG welding with filler material in the areas indicated with +++++

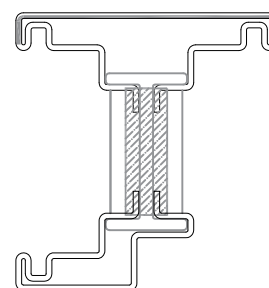
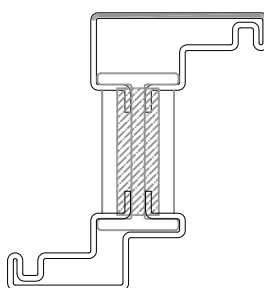
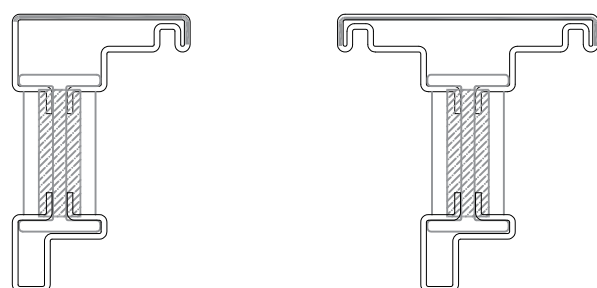
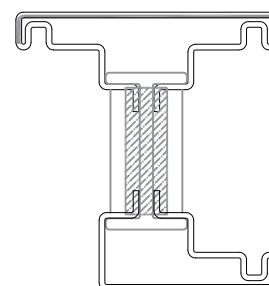
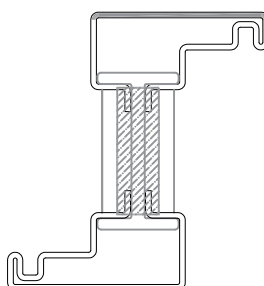
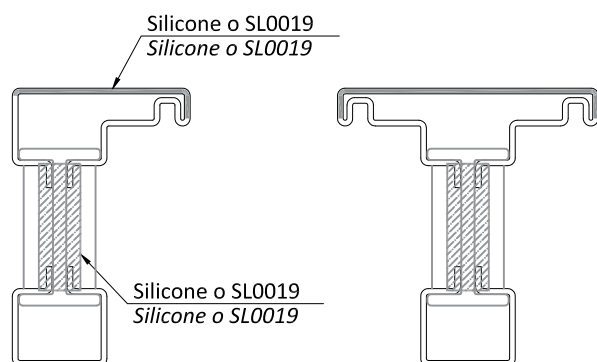
Seal all the external contact surfaces with silicone our SL0019



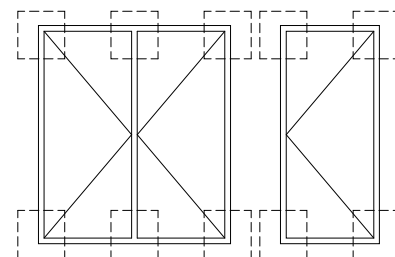
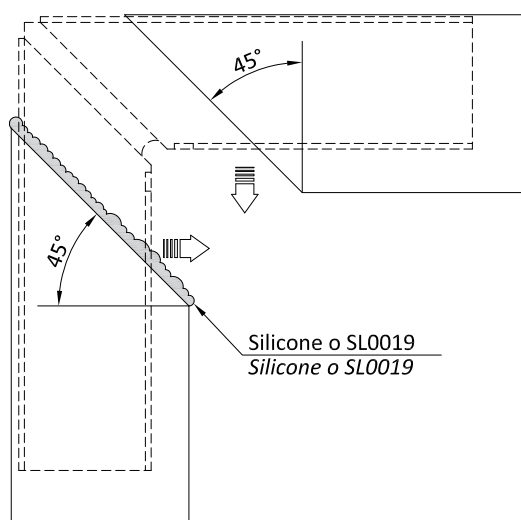


- 1) inserire la squadretta
- 2) siliconare nelle zone indicate
- 3) accostare i profili
- 4) procedere con la saldatura (vedasi pagine successive)

- 1) insert the bracket
- 2) seal in the specified areas
- 3) align the profiles
- 4) weld (see following pages)

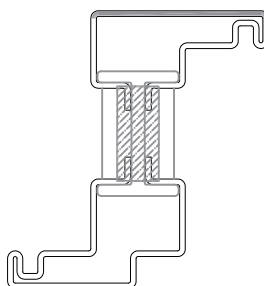
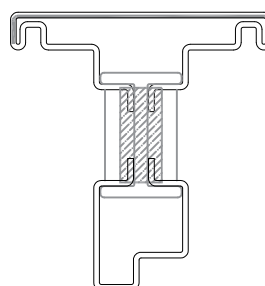
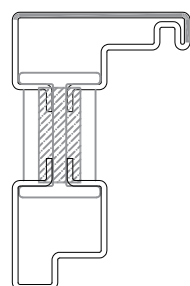
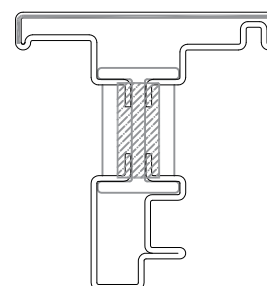
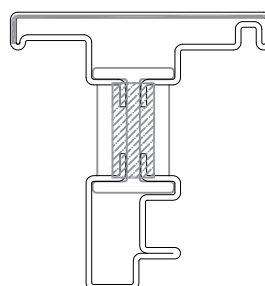
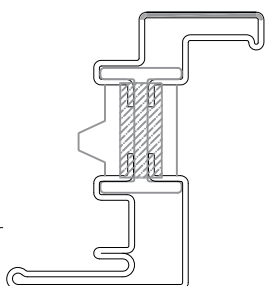
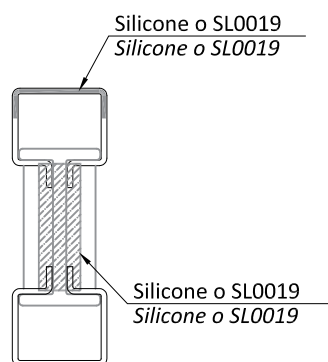


 Sigillare con silicone o sigillante a freddo SL0019 nelle zone evidenziate (sempre lato esterno profilo)
 Seal with silicone or cold-working sealant SL0019 in the areas marked (always on the outer side of the profile)

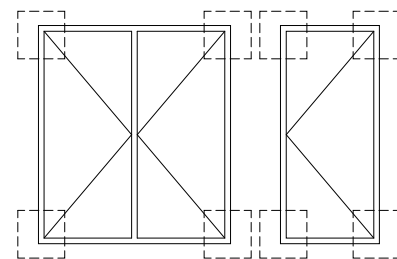
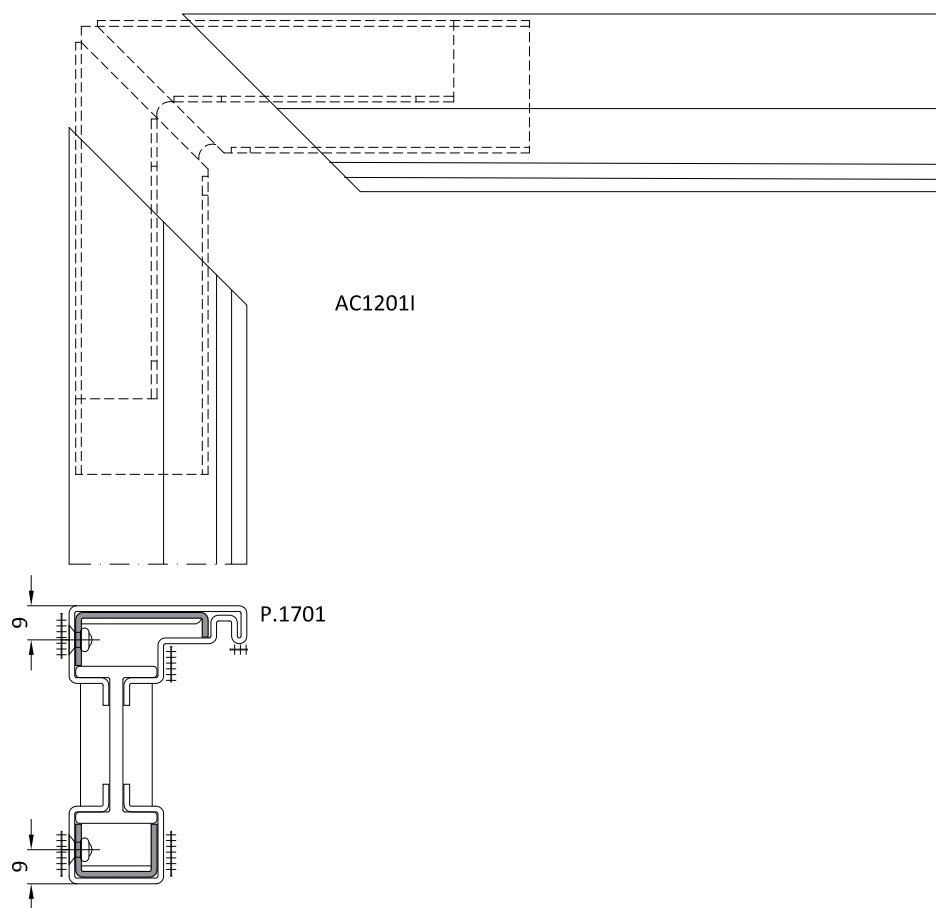


- 1) inserire la squadretta
- 2) siliconare nelle zone indicate
- 3) accostare i profili
- 4) procedere con la saldatura (vedasi pagine successive)

- 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)



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

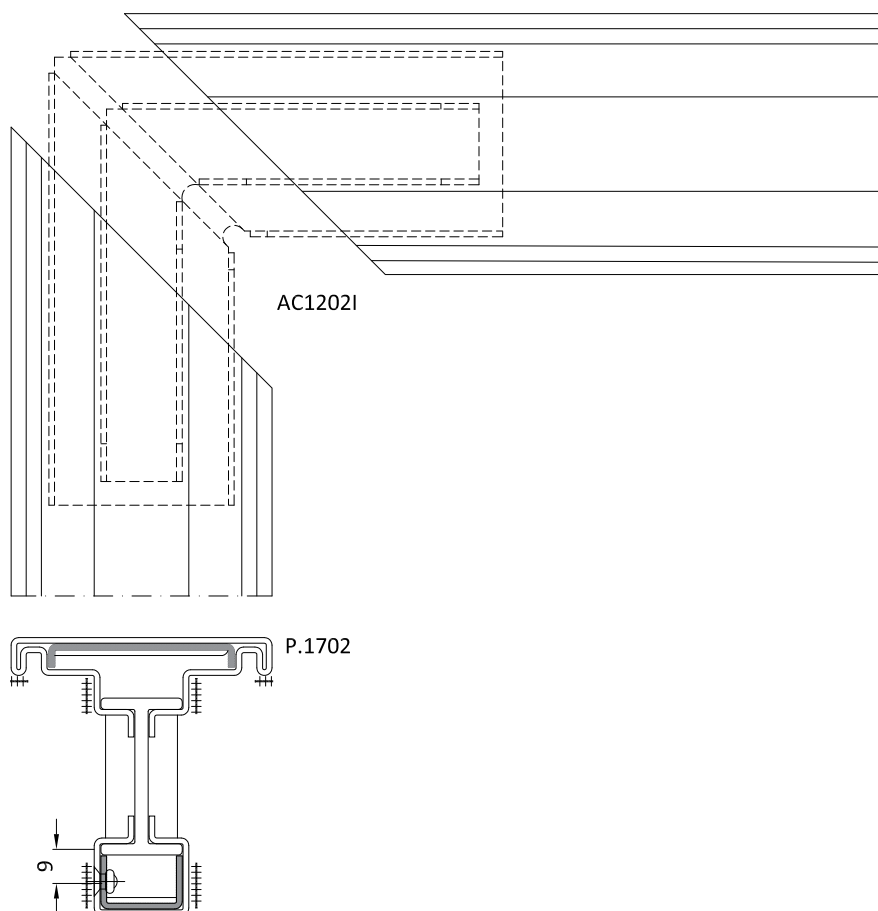
Sigillare tutte le superfici di contatto esterne con silicone o SL0019

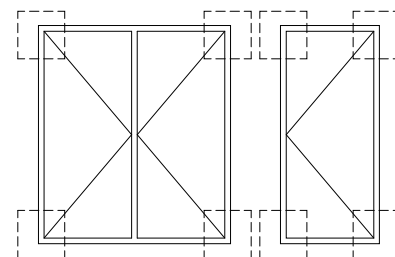
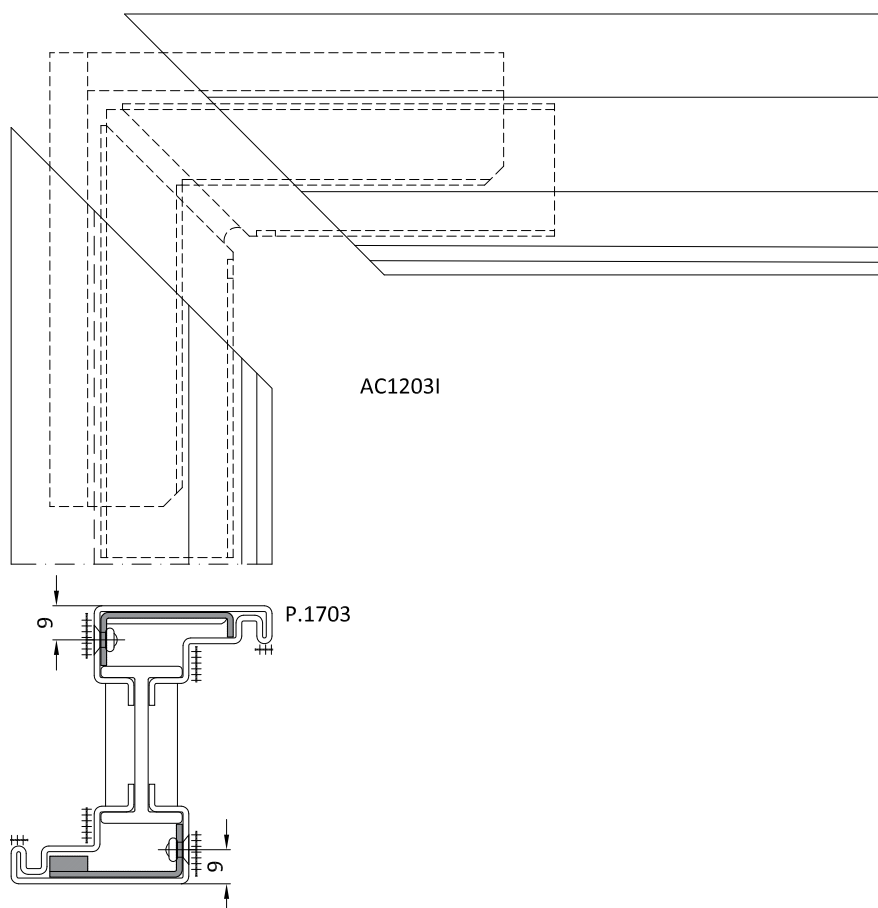
 Rivetti svasati Ø 4

TIG welding with filler material in the areas indicated with +++++

Seal all the external contact surfaces with silicone or SL0019

 Countersunk rivets Ø 4





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

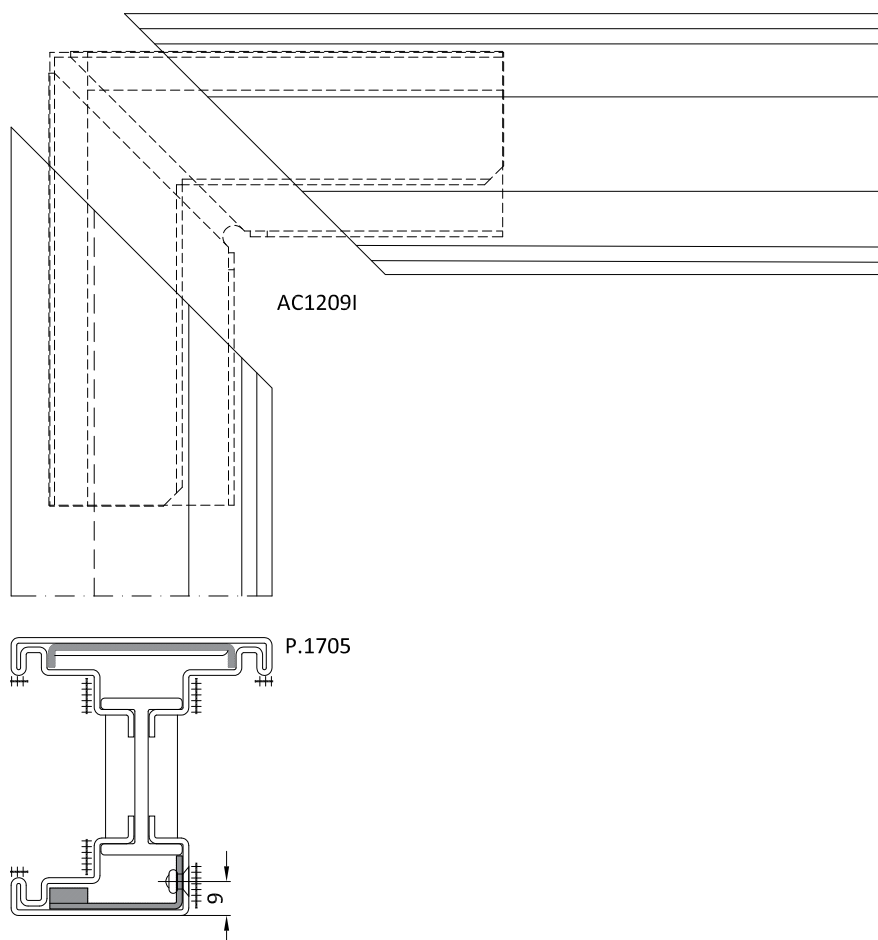
Sigillare tutte le superfici di contatto esterne con silicone o SL0019

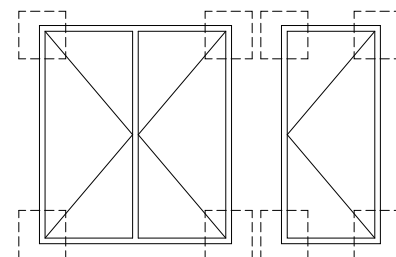
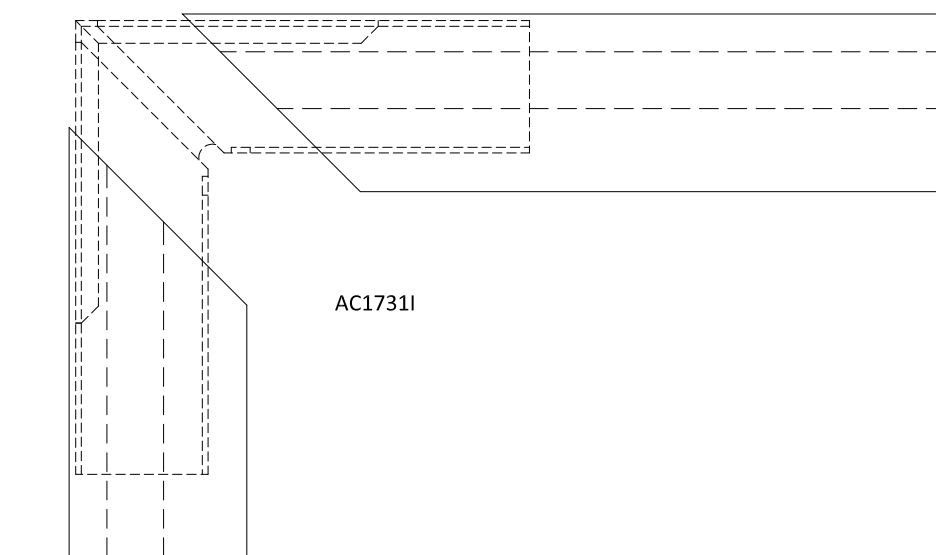
 Rivetti svasati Ø 4

TIG welding with filler material in the areas indicated with +++++

Seal all the external contact surfaces with silicone or SL0019

 Countersunk rivets Ø 4





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

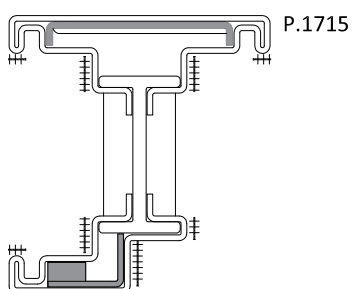
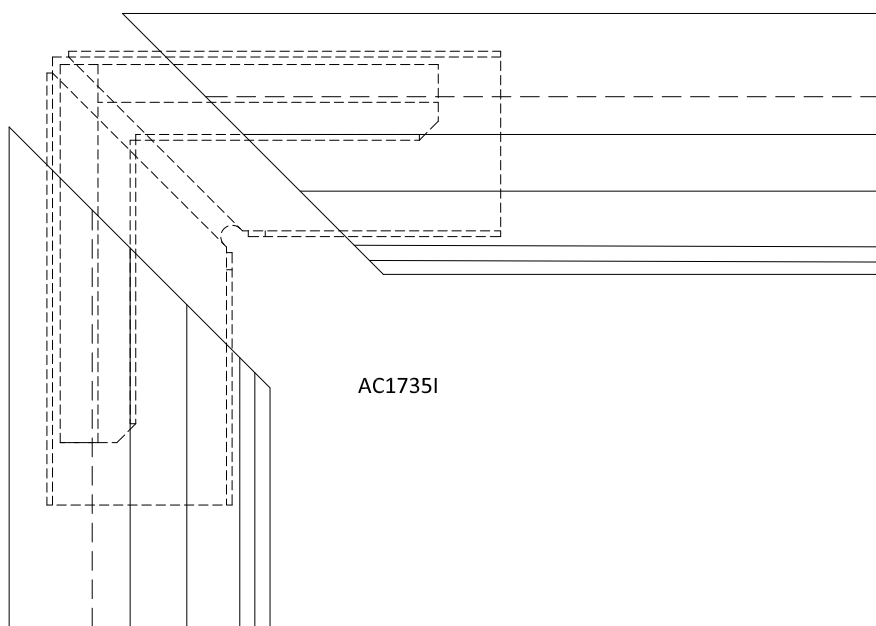
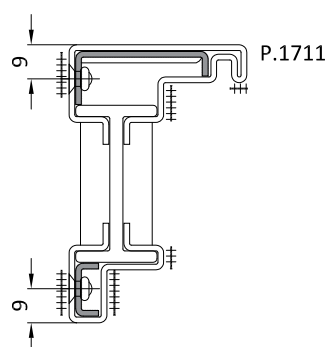
Sigillare tutte le superfici di contatto esterne con silicone o SL0019

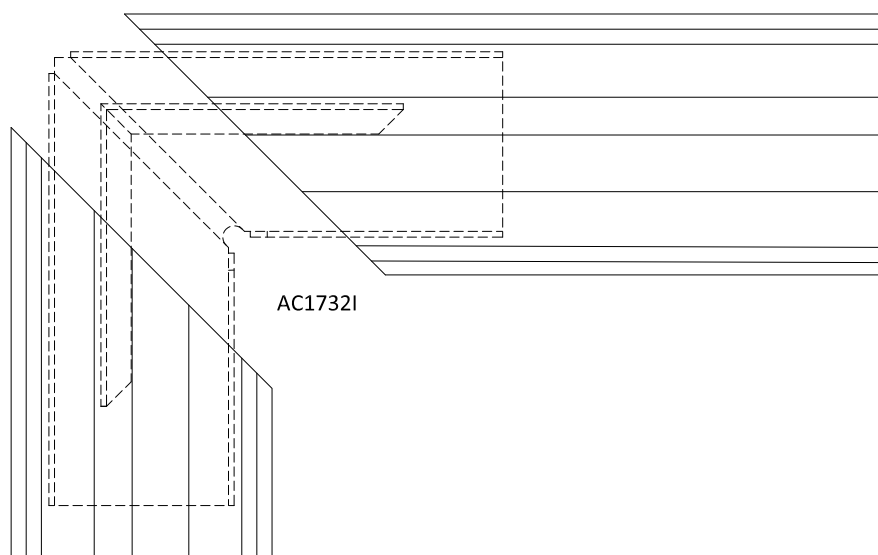
 Rivetti svasati Ø 4

TIG welding with filler material in the areas indicated with +++++

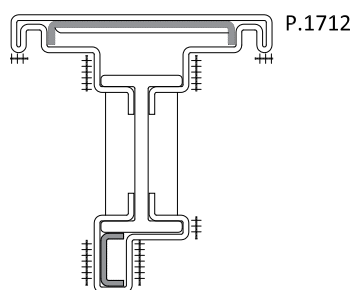
Seal all the external contact surfaces with silicone or SL0019

 Countersunk rivets Ø 4

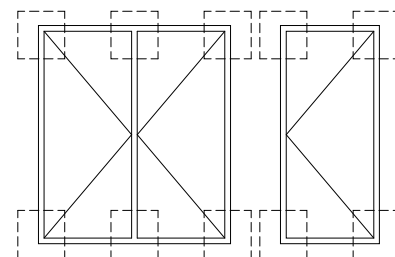




AC1732I



P.1712



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

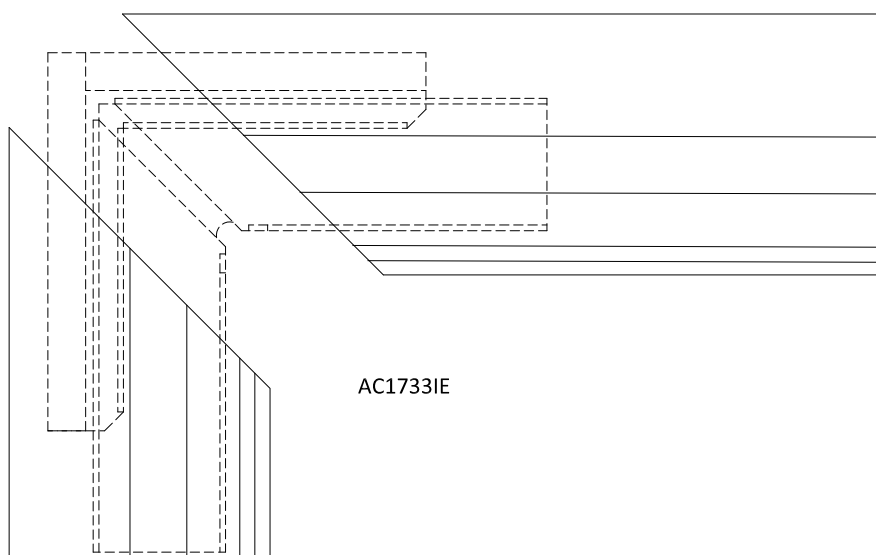
Sigillare tutte le superfici di contatto
esterne con silicone o SL0019

 Rivetti svasati Ø 4

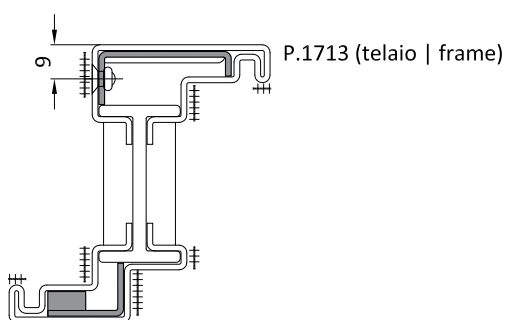
*TIG welding with filler material in the
areas indicated with +++++*

*Seal all the external contact surfaces
with silicone our SL0019*

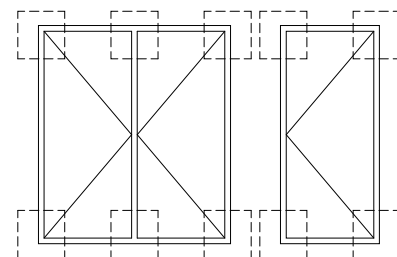
 Countersunk rivets Ø 4



AC1733IE



P.1713 (telaio | frame)



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

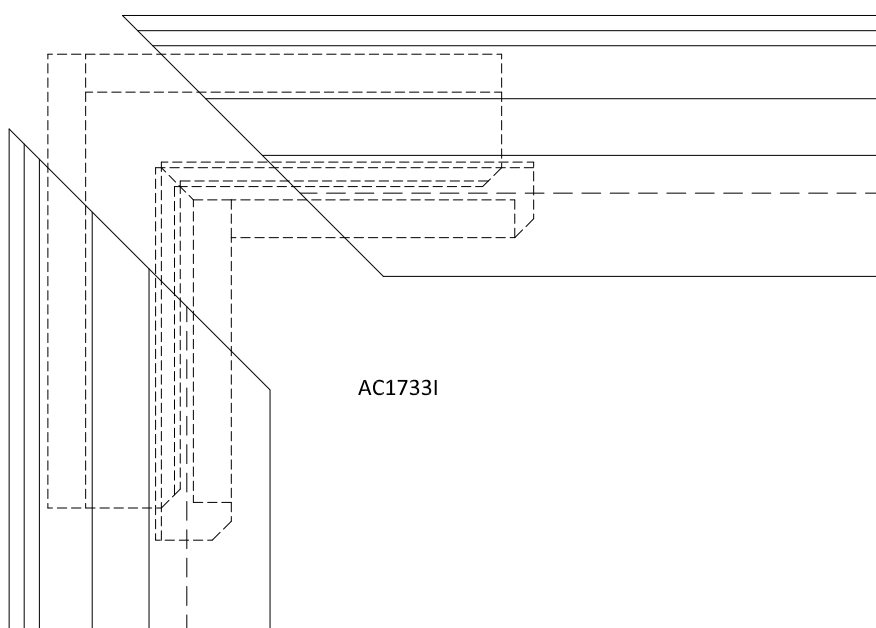
Sigillare tutte le superfici di contatto esterne con silicone o SL0019

 Rivetti svasati Ø 4

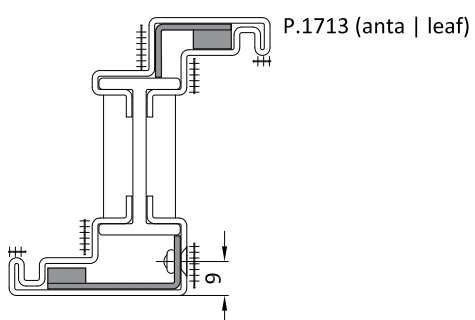
TIG welding with filler material in the areas indicated with +++++

Seal all the external contact surfaces with silicone or SL0019

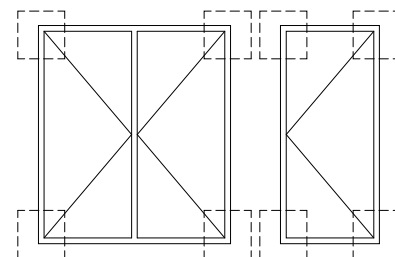
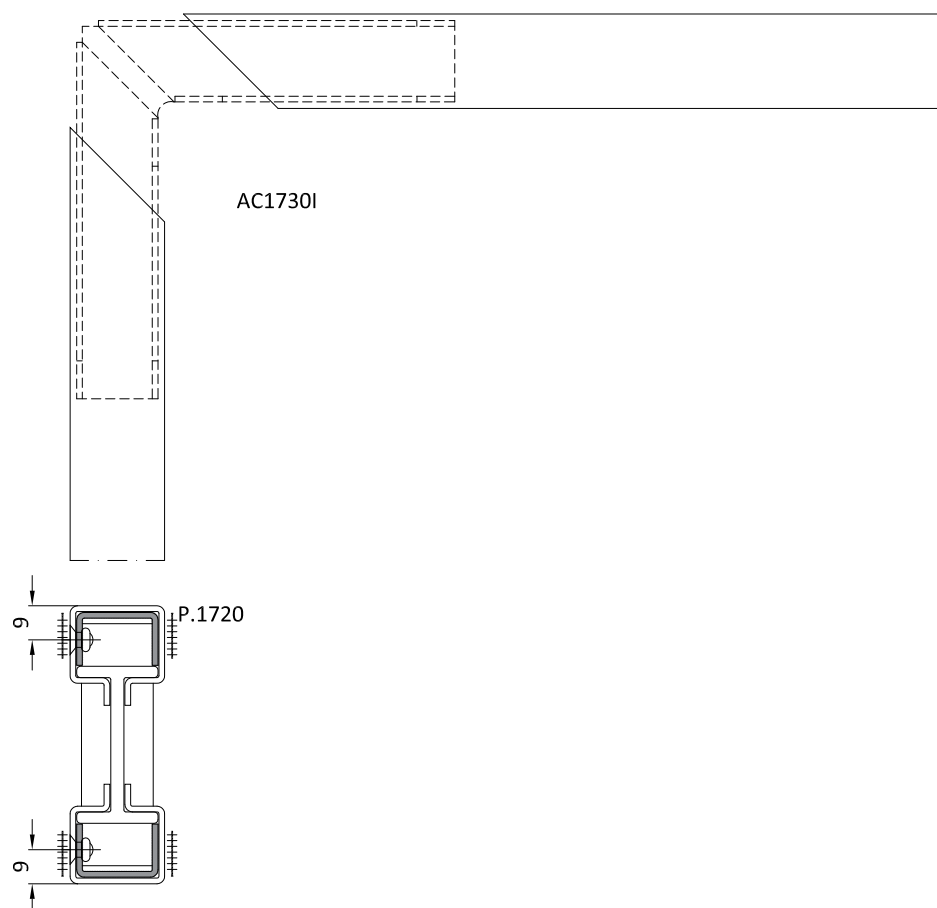
 Countersunk rivets Ø 4



AC1733I



P.1713 (anta | leaf)



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

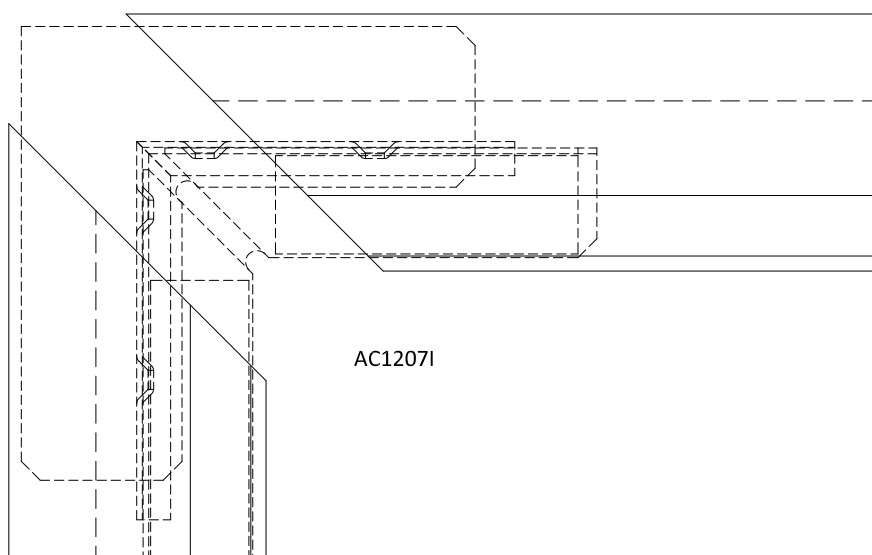
Sigillare tutte le superfici di contatto esterne con silicone o SL0019

 Rivetti svasati Ø 4

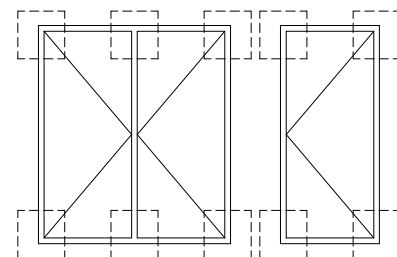
TIG welding with filler material in the areas indicated with +++++

Seal all the external contact surfaces with silicone or SL0019

 Countersunk rivets Ø 4



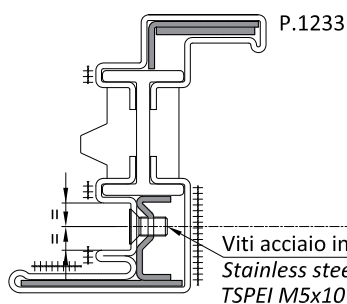
AC1207I



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

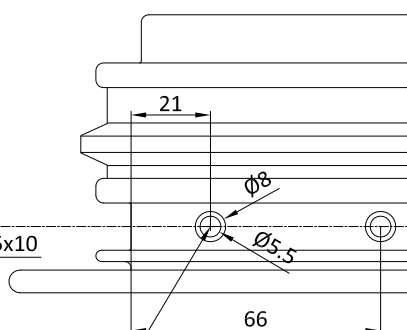
Sigillare tutte le superfici di contatto esterne con silicone o SL0019

 Rivetti svasati Ø 4



P.1233

Viti acciaio inox TSPEI M5x10
Stainless steel screws
TSPEI M5x10



TIG welding with filler material in the areas indicated with +++++

Seal all the external contact surfaces with silicone or SL0019

 Countersunk rivets Ø 4

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

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

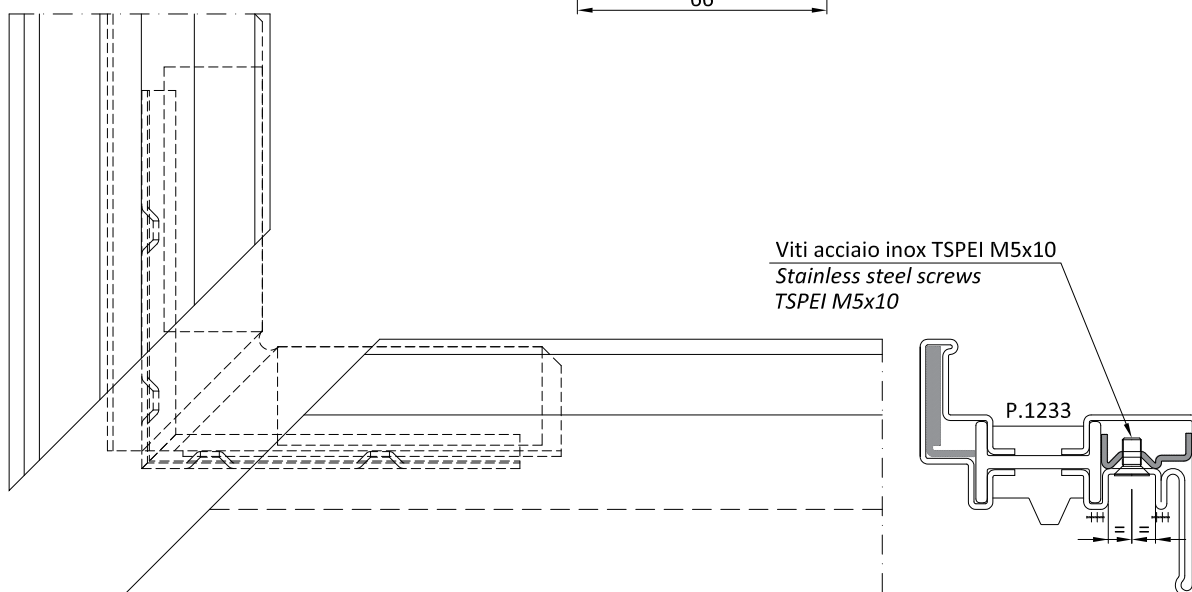
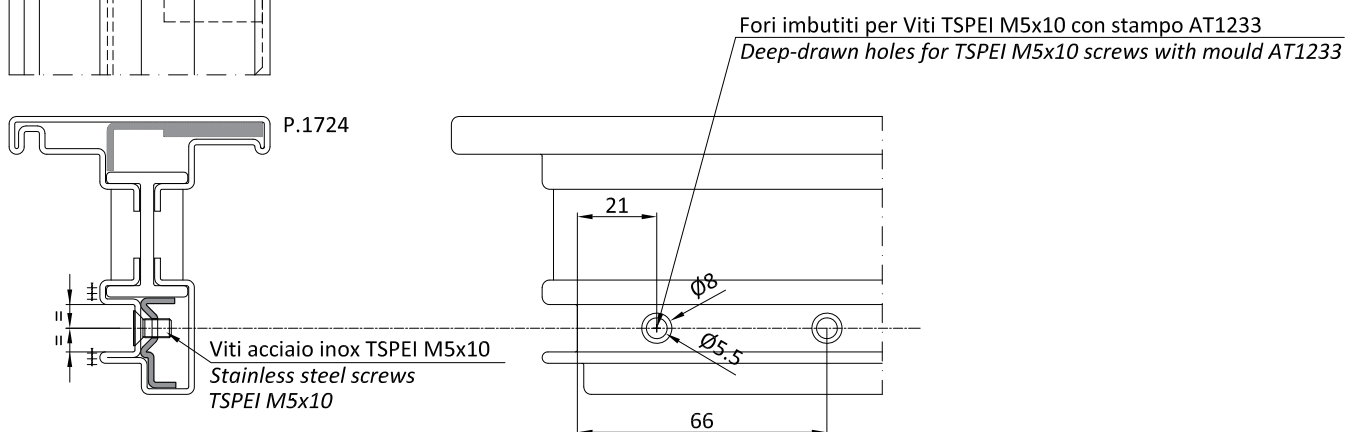
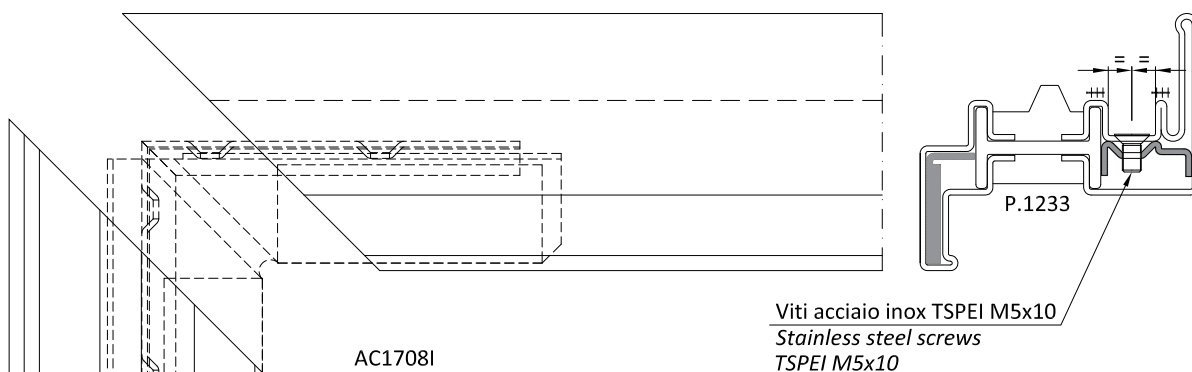
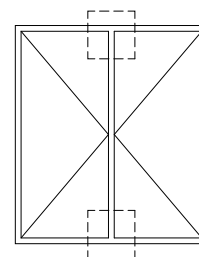
TIG welding with filler material in the
areas indicated with +++++

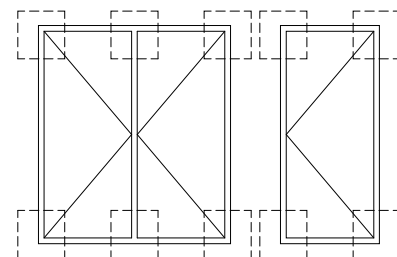
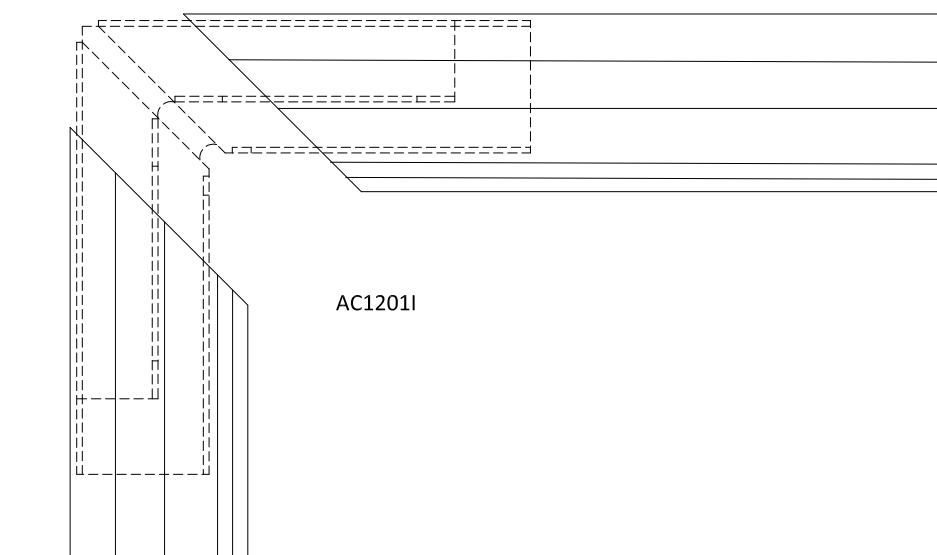
Sigillare tutte le superfici di contatto
esterne con silicone o SL0019

Seal all the external contact surfaces
with silicone or SL0019

 Rivetti svasati Ø 4

 Countersunk rivets Ø 4

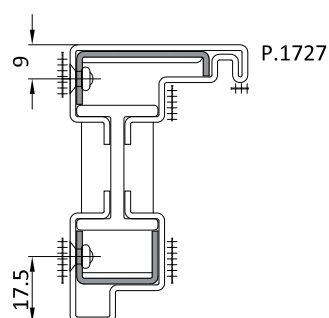




Saldare a TIG con materiale di riporto nelle zone indicate con +++++

Sigillare tutte le superfici di contatto esterne con silicone o SL0019

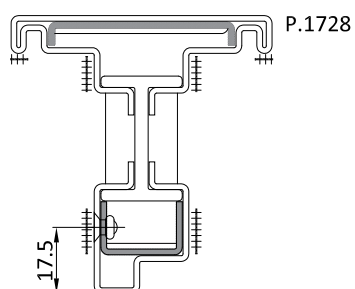
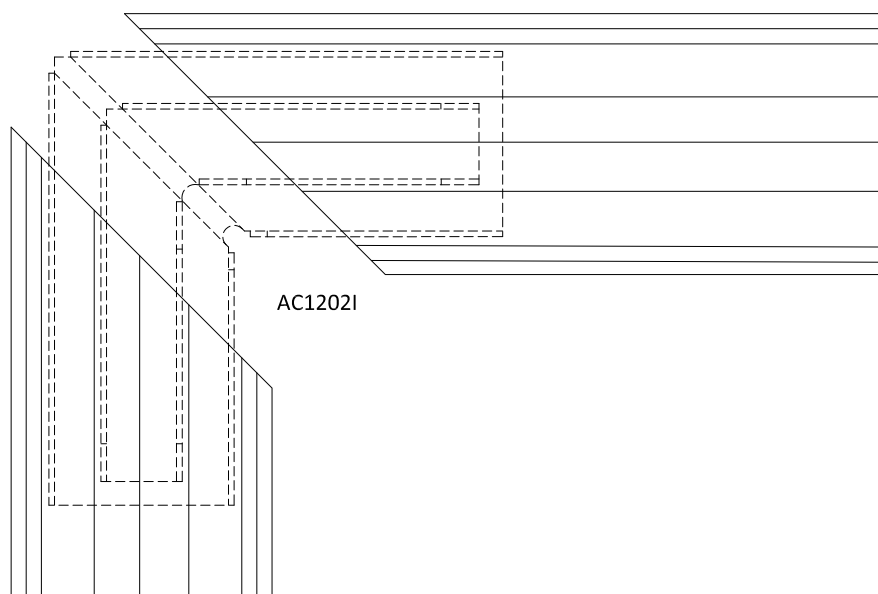
 Rivetti svasati Ø 4

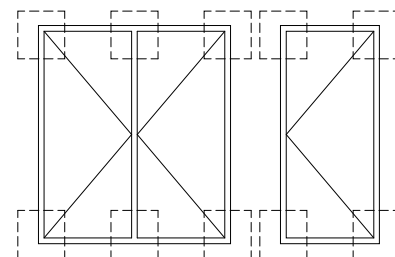
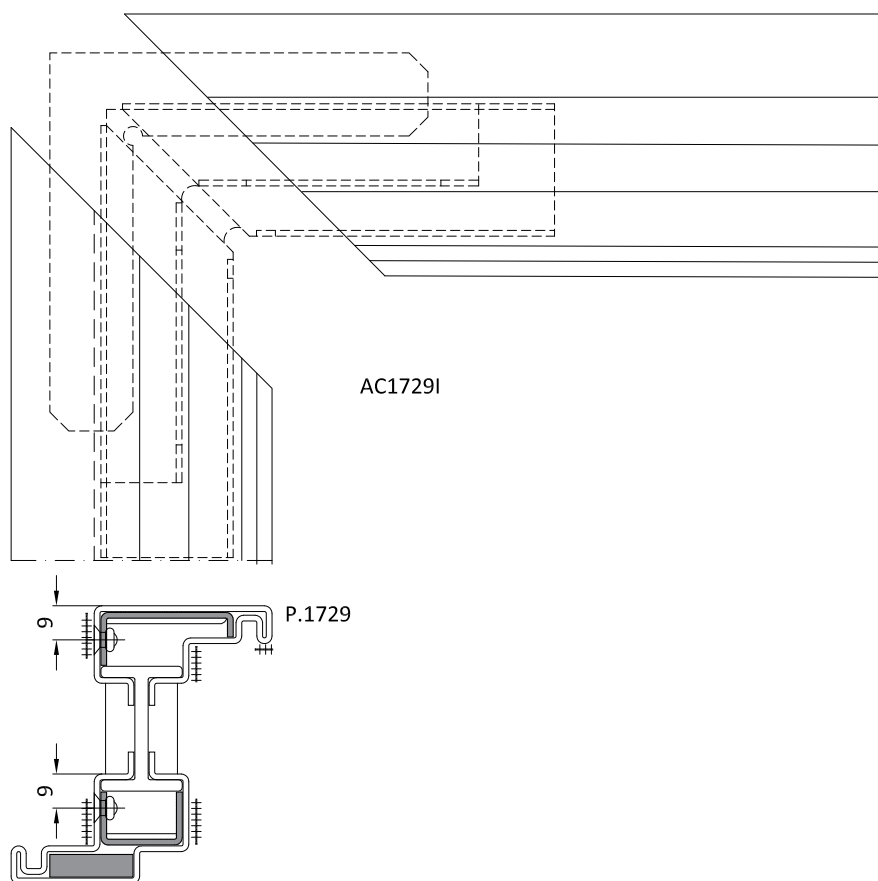


TIG welding with filler material in the areas indicated with +++++

Seal all the external contact surfaces with silicone or SL0019

 Countersunk rivets Ø 4





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

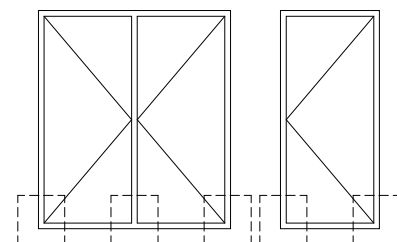
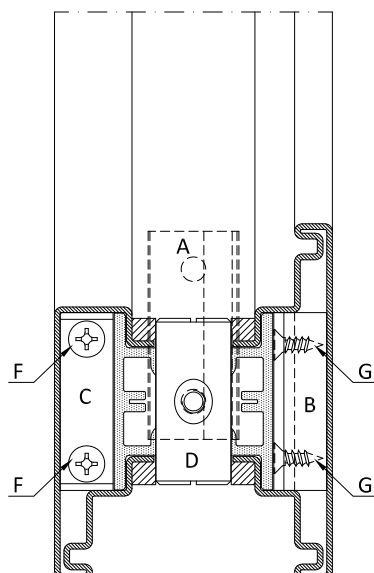
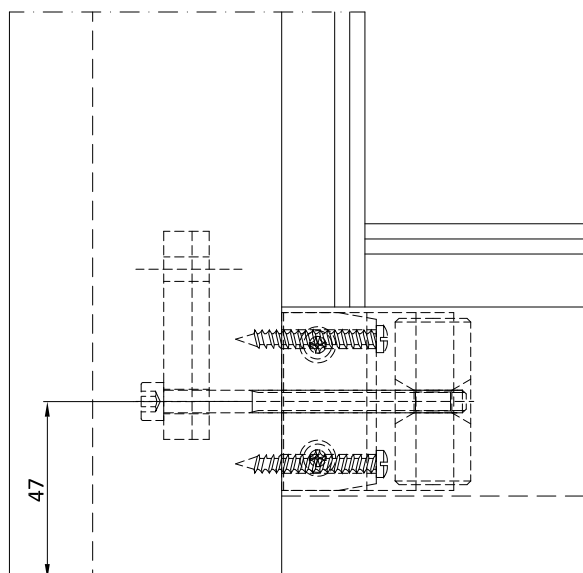
Sigillare tutte le superfici di contatto esterne con silicone o SL0019

 Rivetti svasati Ø 4

TIG welding with filler material in the areas indicated with +++++

Seal all the external contact surfaces with silicone or SL0019

 Countersunk rivets Ø 4



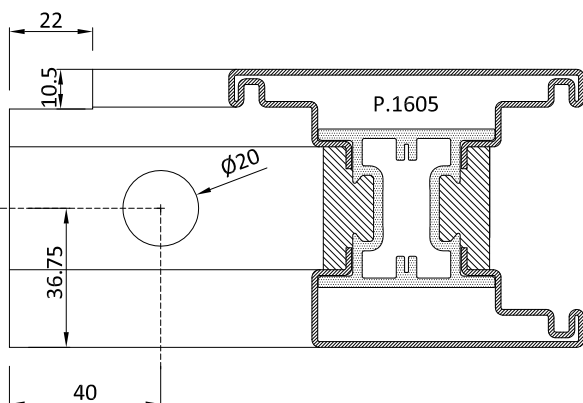
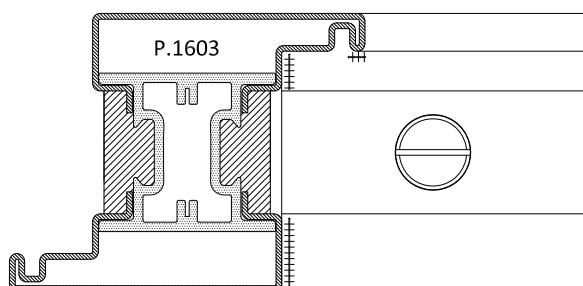
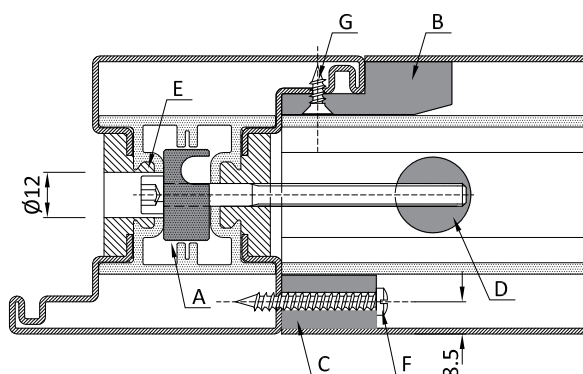
Saldare a TIG con materiale di riporto nelle zone indicate con ++++++

Sigillare tutte le superfici di contatto con silicone o SL0019

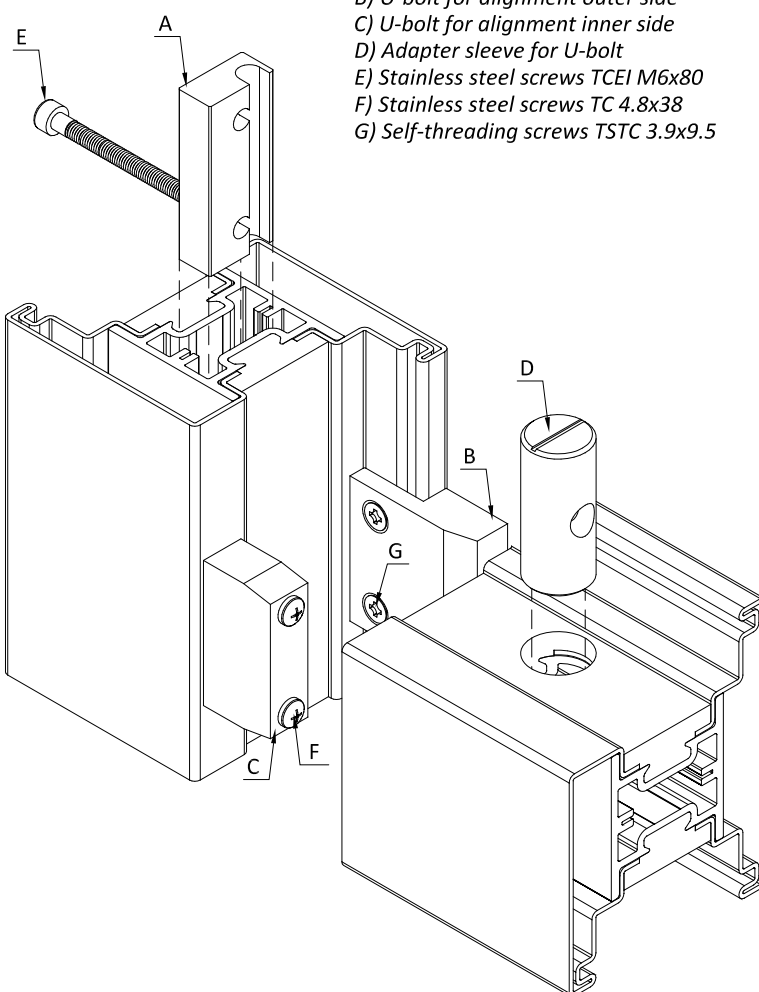
- A) Inserto di fissaggio
- B) Cavallotto di allineamento lato esterno
- C) Cavallotto di allineamento lato interno
- D) Tirante per cavallotto
- E) Vite acciaio inox TCEI M6x80
- F) Vite acciaio inox TC 4.8x38
- G) Vite autofilettante TSTC 3.9x9.5

TIG welding with filler material in the areas indicated with ++++++

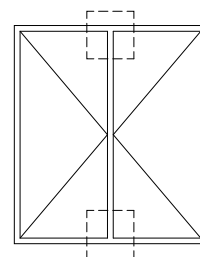
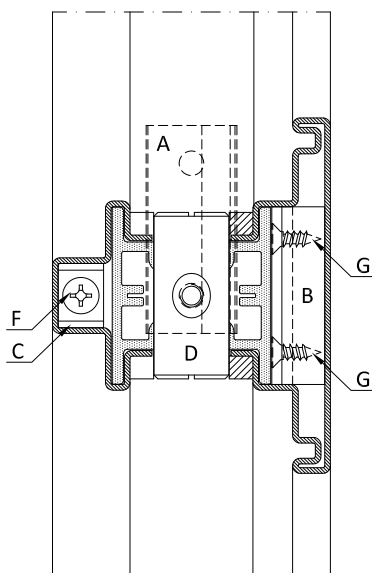
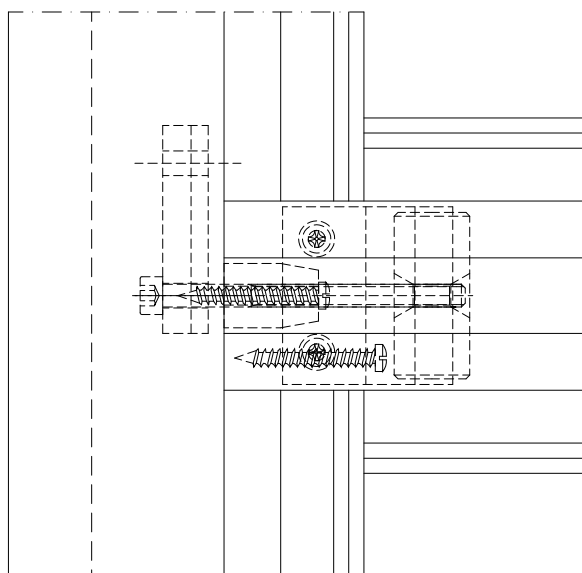
Seal all the external contact surfaces with silicone or SL0019



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



- 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 ++++++

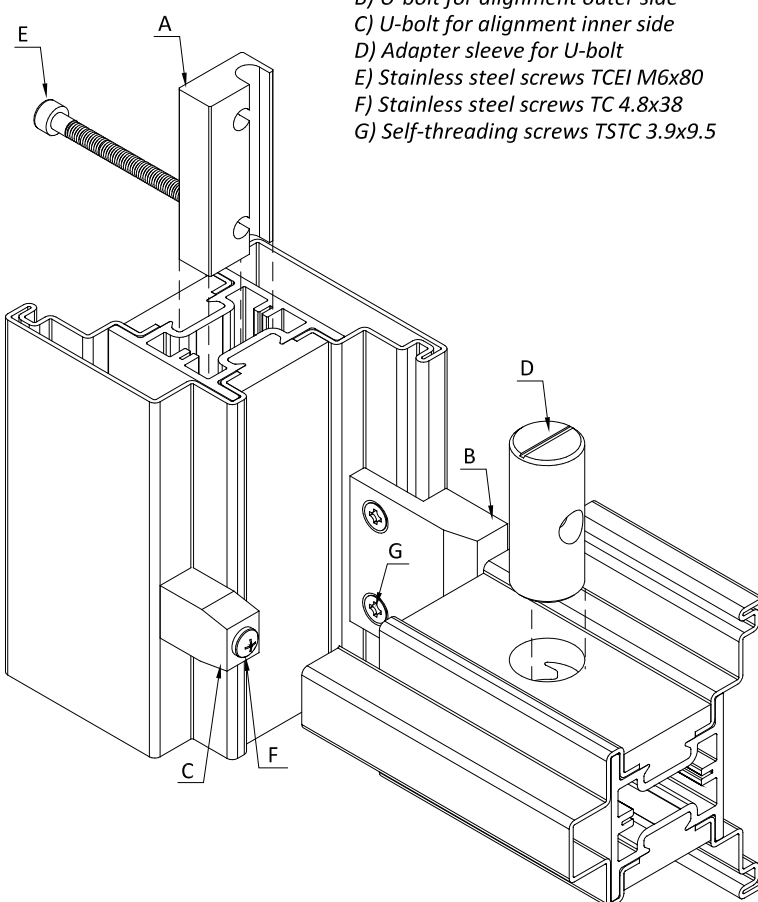
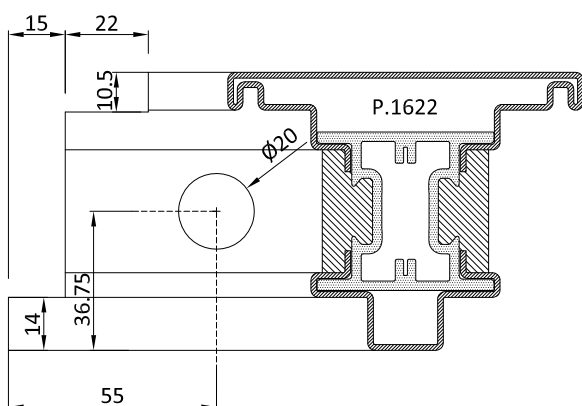
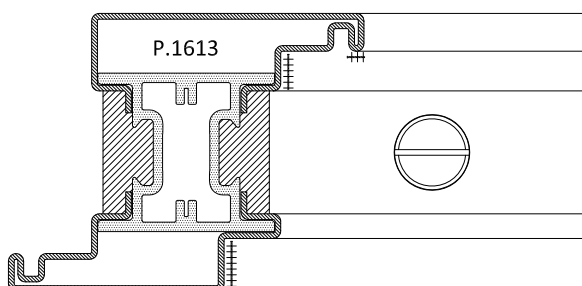
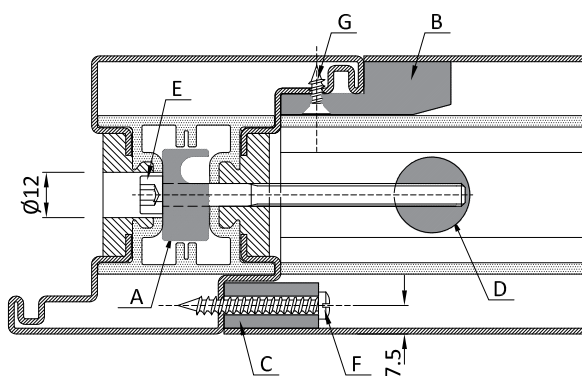
Sigillare tutte le superfici di contatto con silicone o SL0019

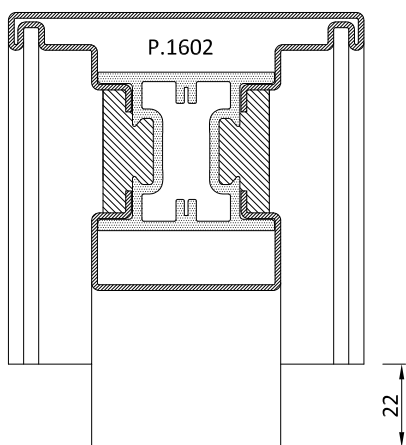
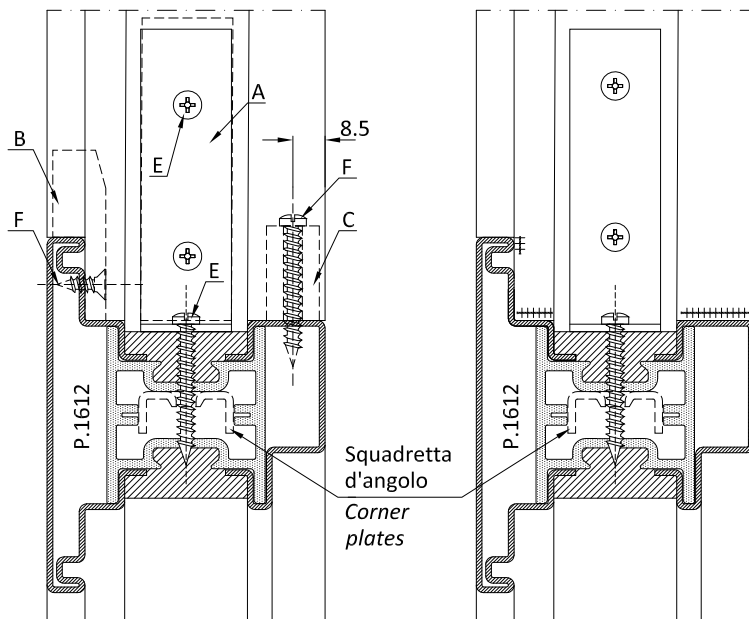
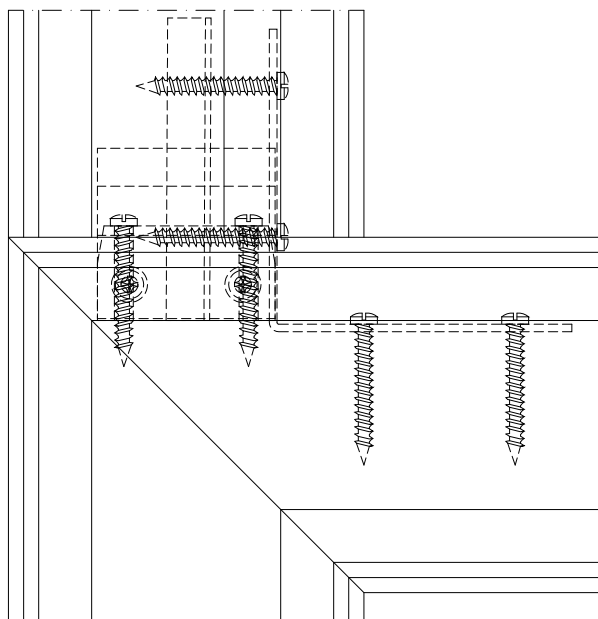
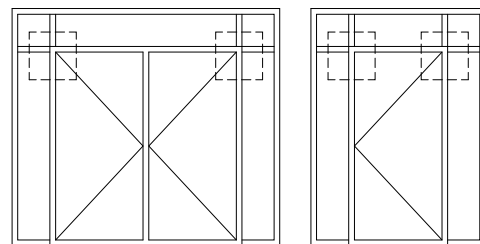
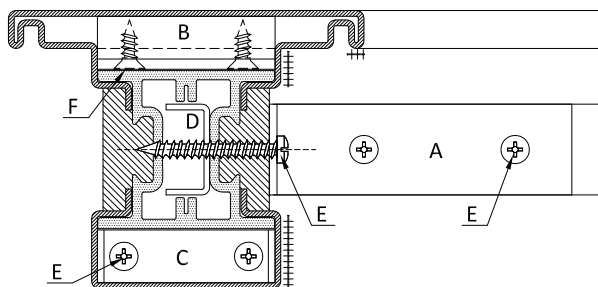
- A) Inserto di fissaggio
- B) Cavallotto di allineamento lato esterno
- C) Cavallotto di allineamento lato interno
- D) Tirante per cavallotto
- E) Vite acciaio inox TCEI M6x80
- F) Vite acciaio inox TC 4.8x38
- G) Vite autofilettante TSTC 3.9x9.5

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 +++++

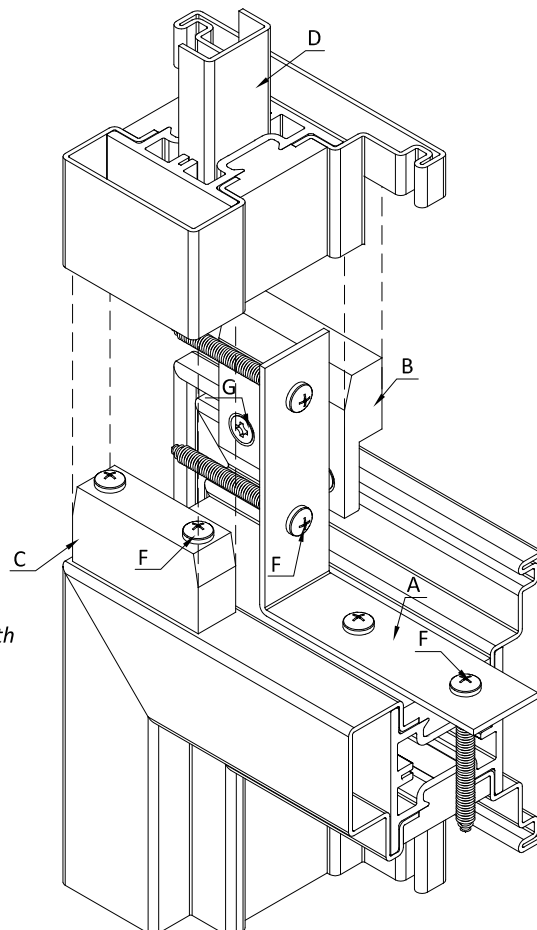
Sigillare tutte le superfici di contatto con silicone o SL0019

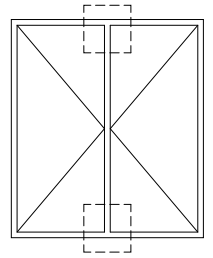
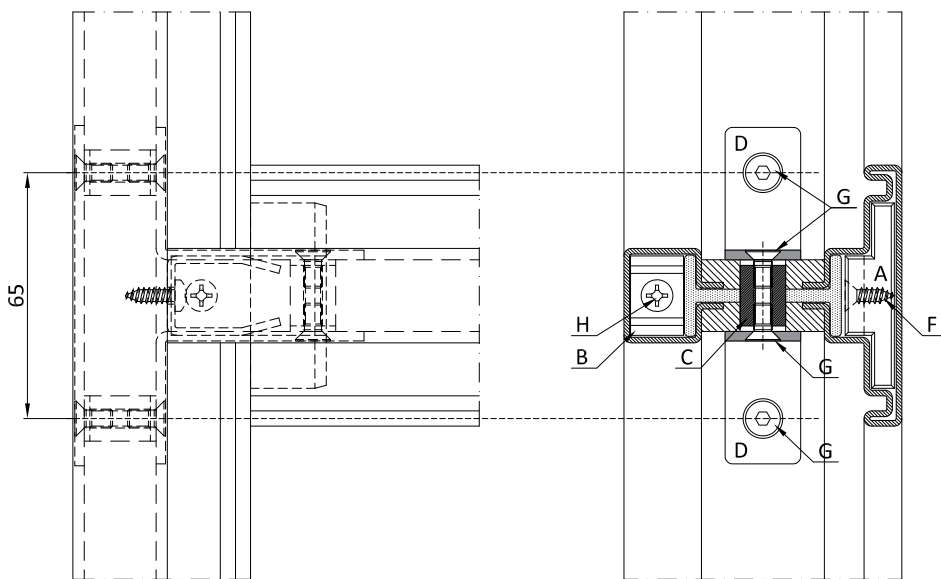
- A) Squadretta giunzione 90°
- B) Cavallotto di allineamento lato esterno
- C) Cavallotto di allineamento lato interno
- D) Rinforzo interno
- E) Vite acciaio inox TC 4.8x38
- F) Vite autofilettante TSTC 3.9x9.5

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 +++++

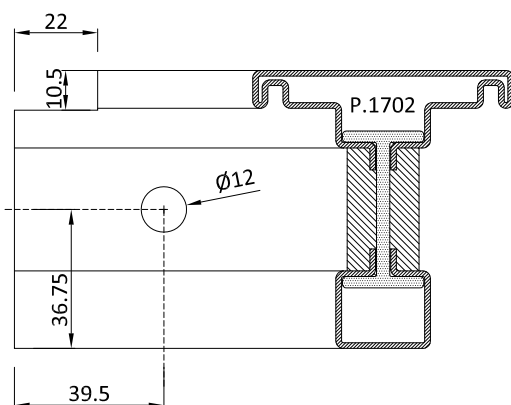
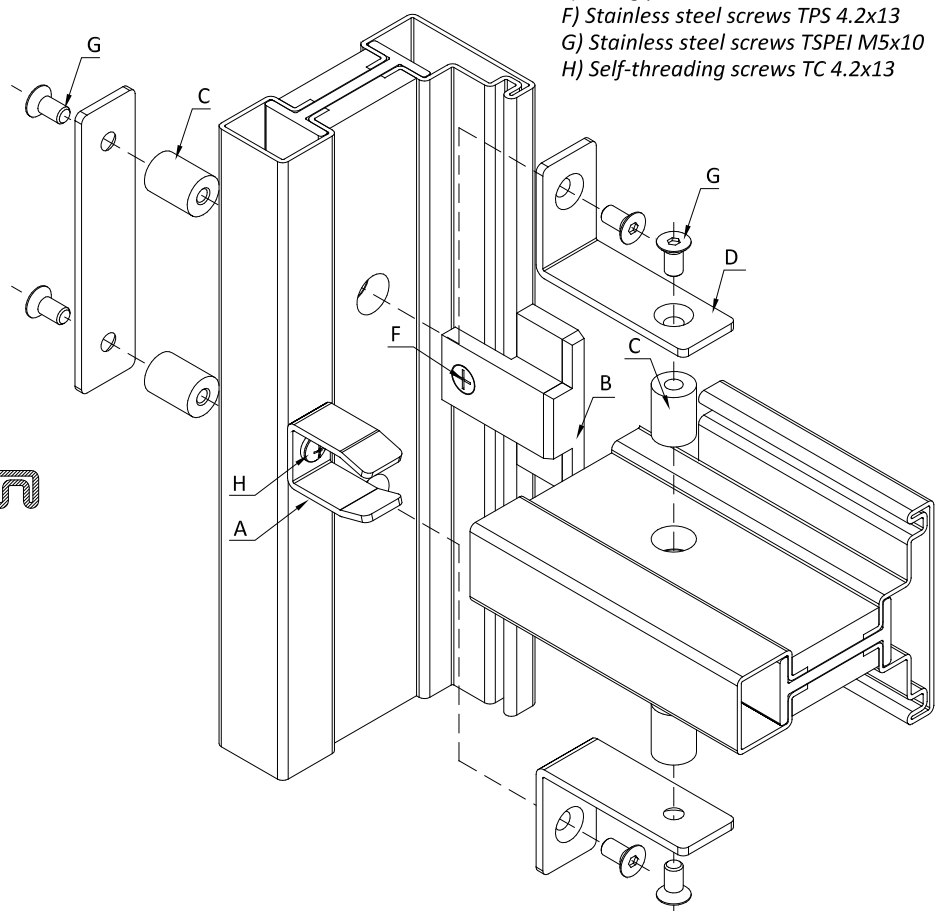
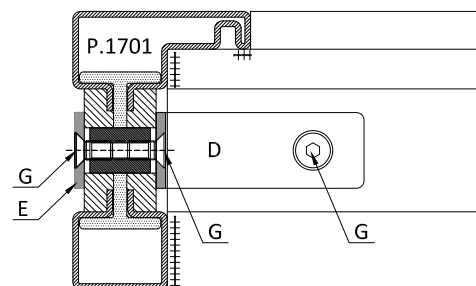
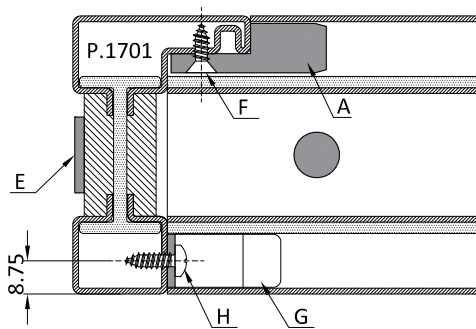
Sigillare tutte le superfici di contatto con silicone o SL0019

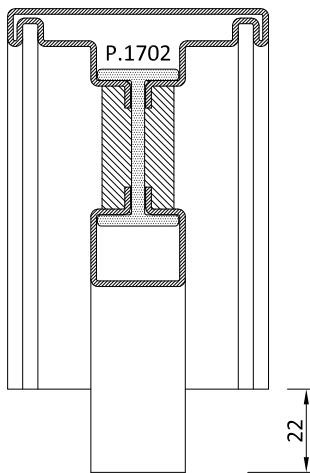
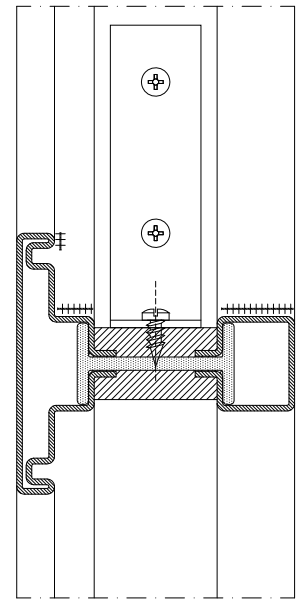
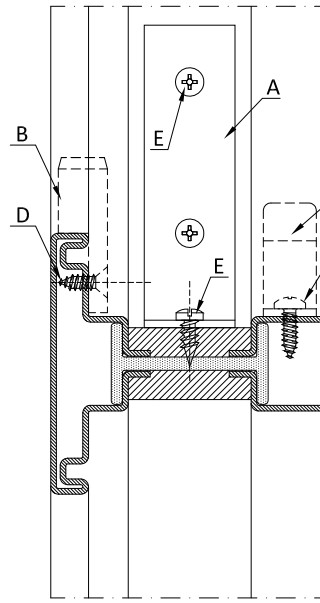
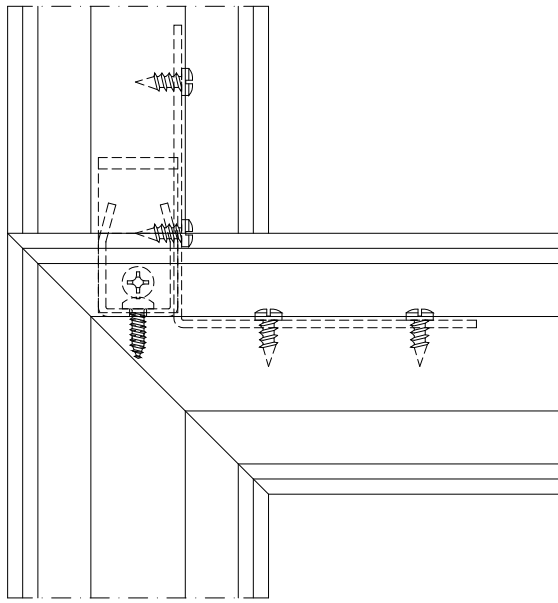
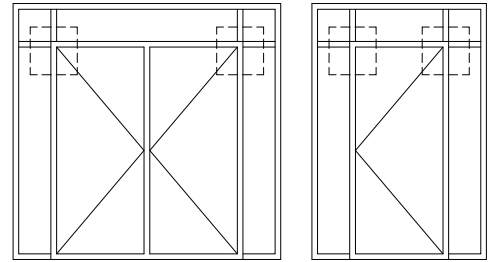
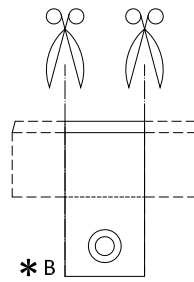
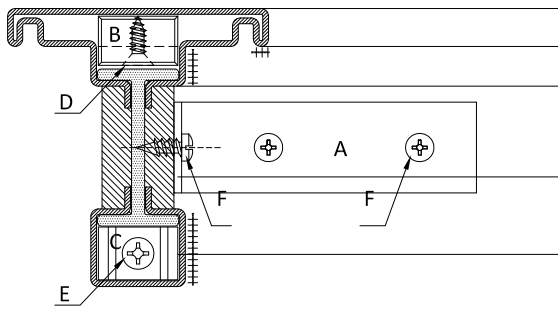
- A) Cavallotto di allineamento lato interno
- B) Cavallotto di allineamento lato esterno
- C) Bussola filettata
- D) Squadretta di tiraggio
- E) Piastrina di fissaggio
- F) Vite acciaio inox TPS 4.2x13
- G) Vite acciaio inox TSPEI M5x10
- H) Vite autofilettante TC 4.2x13

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

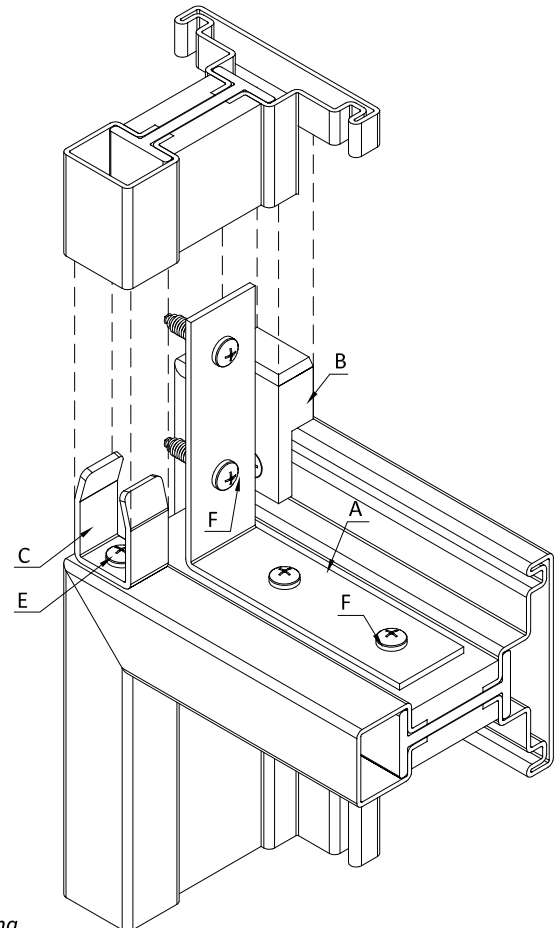
* Tagliare le alette del cavallotto B come da disegno

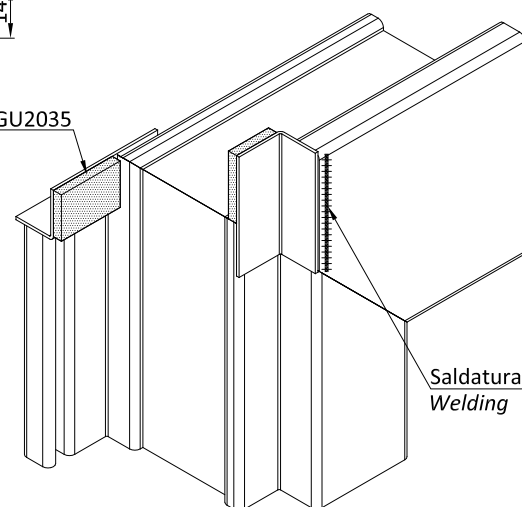
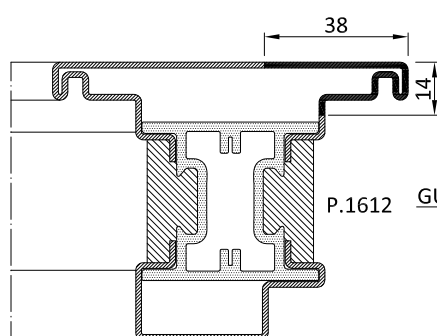
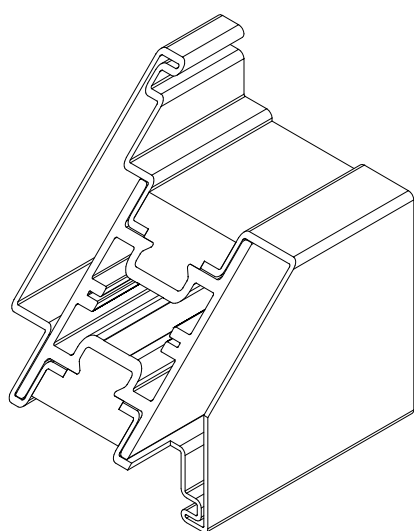
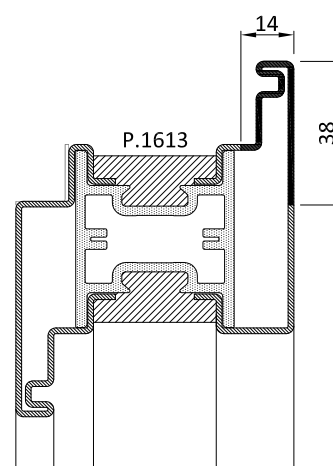
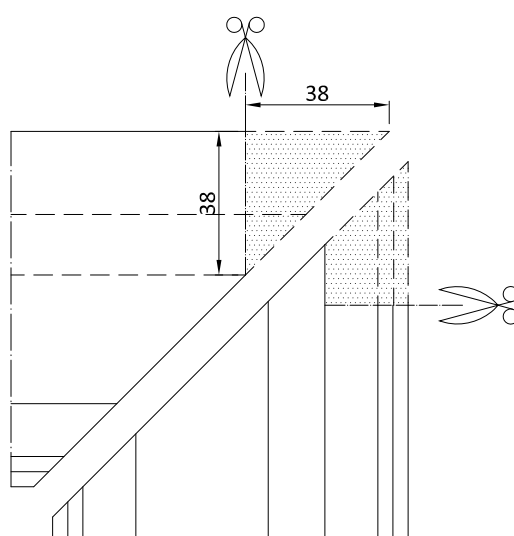
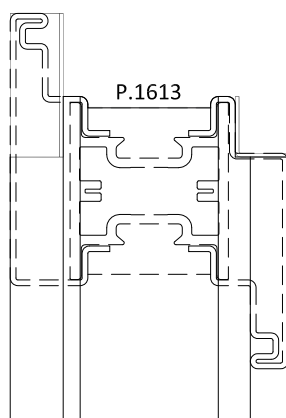
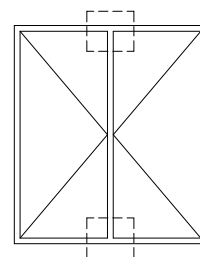
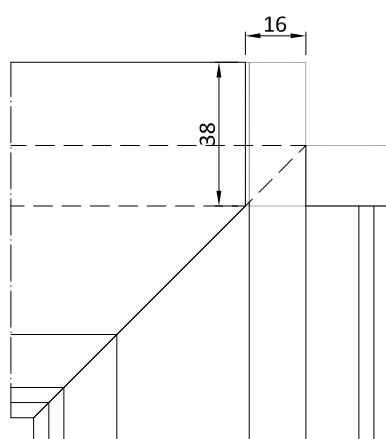
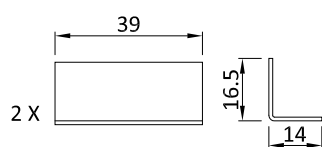
TIG welding with filler material in the areas indicated with +++++

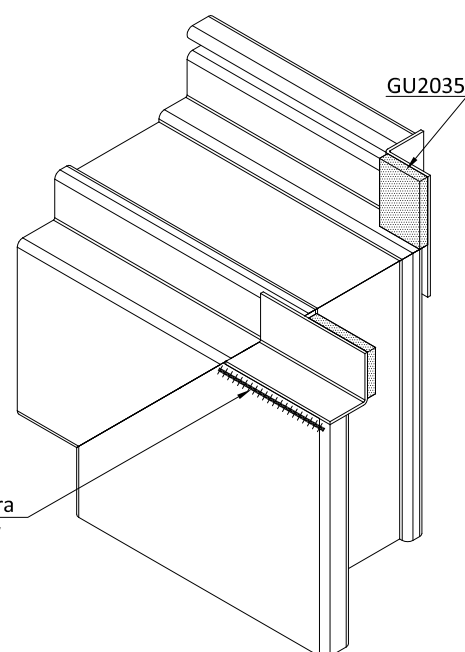
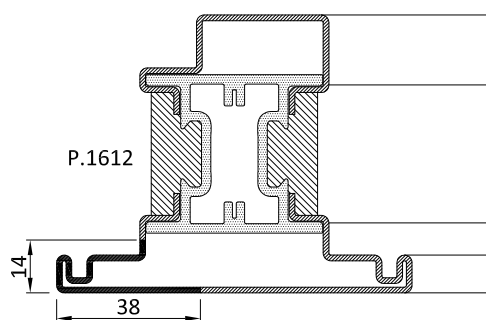
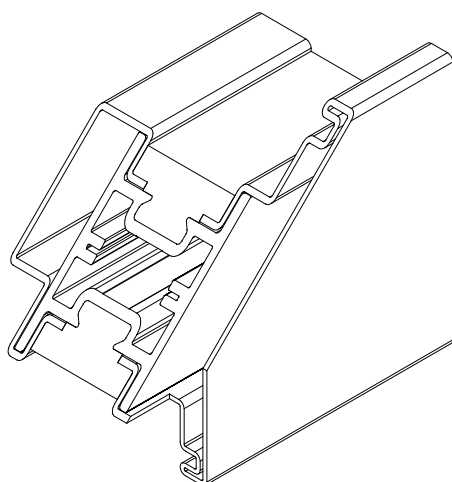
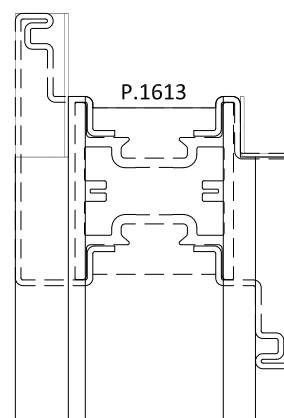
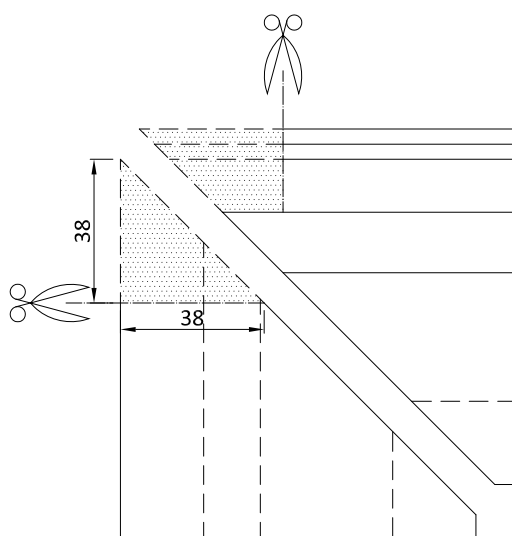
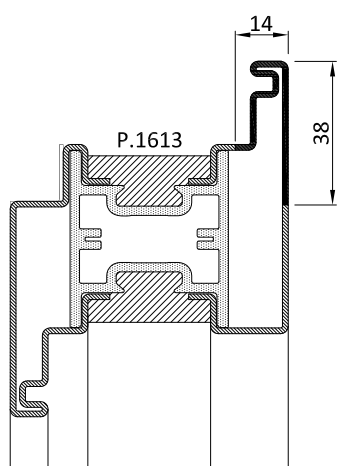
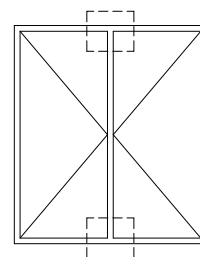
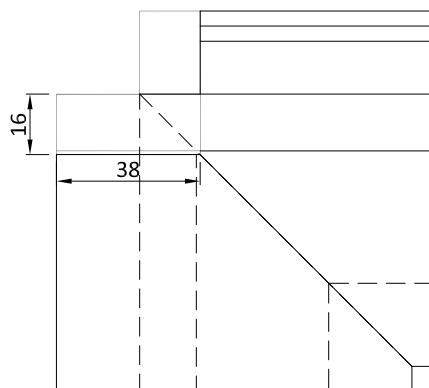
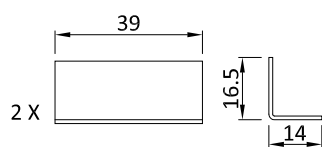
Seal all the external contact surfaces with silicone or SL0019

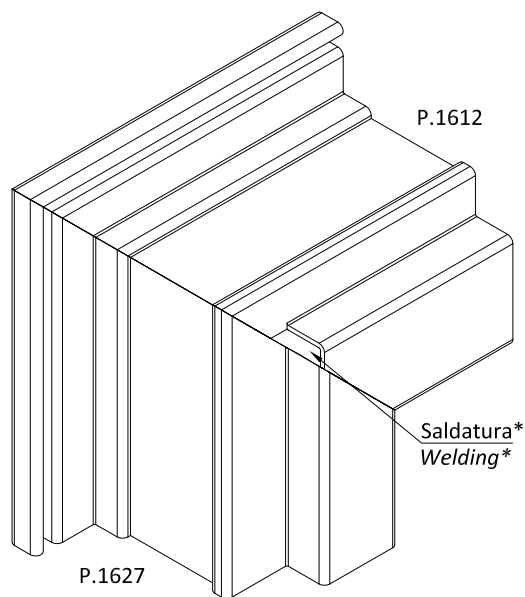
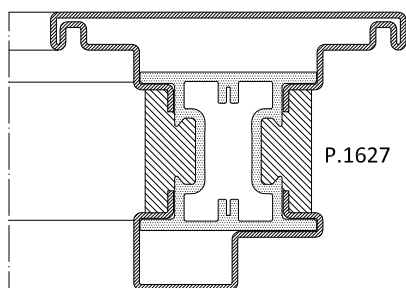
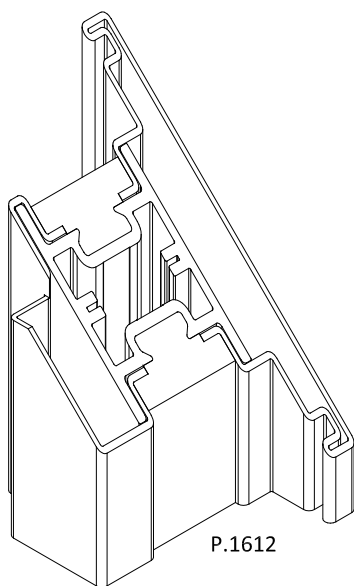
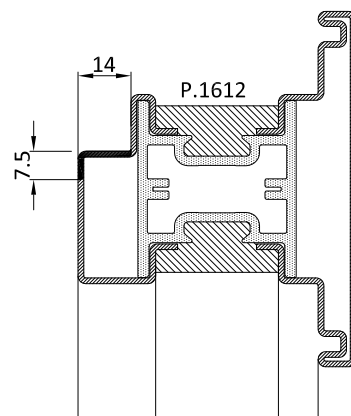
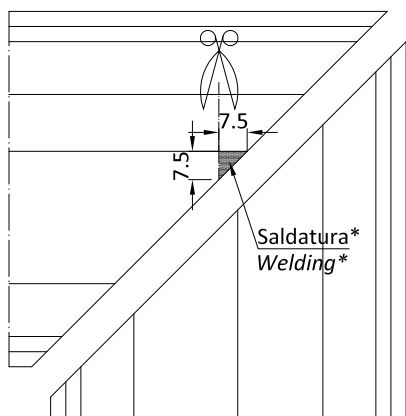
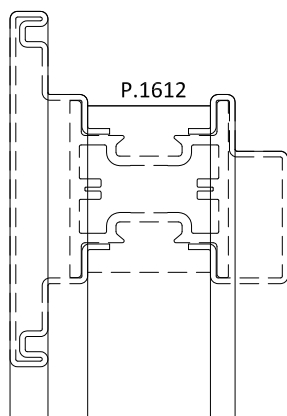
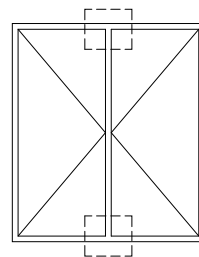
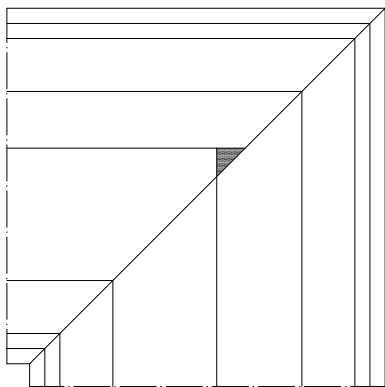
- A) Corner bracket 90°
- B) U-bolt for alignment outer side
- C) U-bolt for alignment inner side
- D) Stainless steel screws TPS 4.2x13
- E) Self-threading screws TC 4.2x12.7
- F) Self-threading screws TE 4.8x20

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

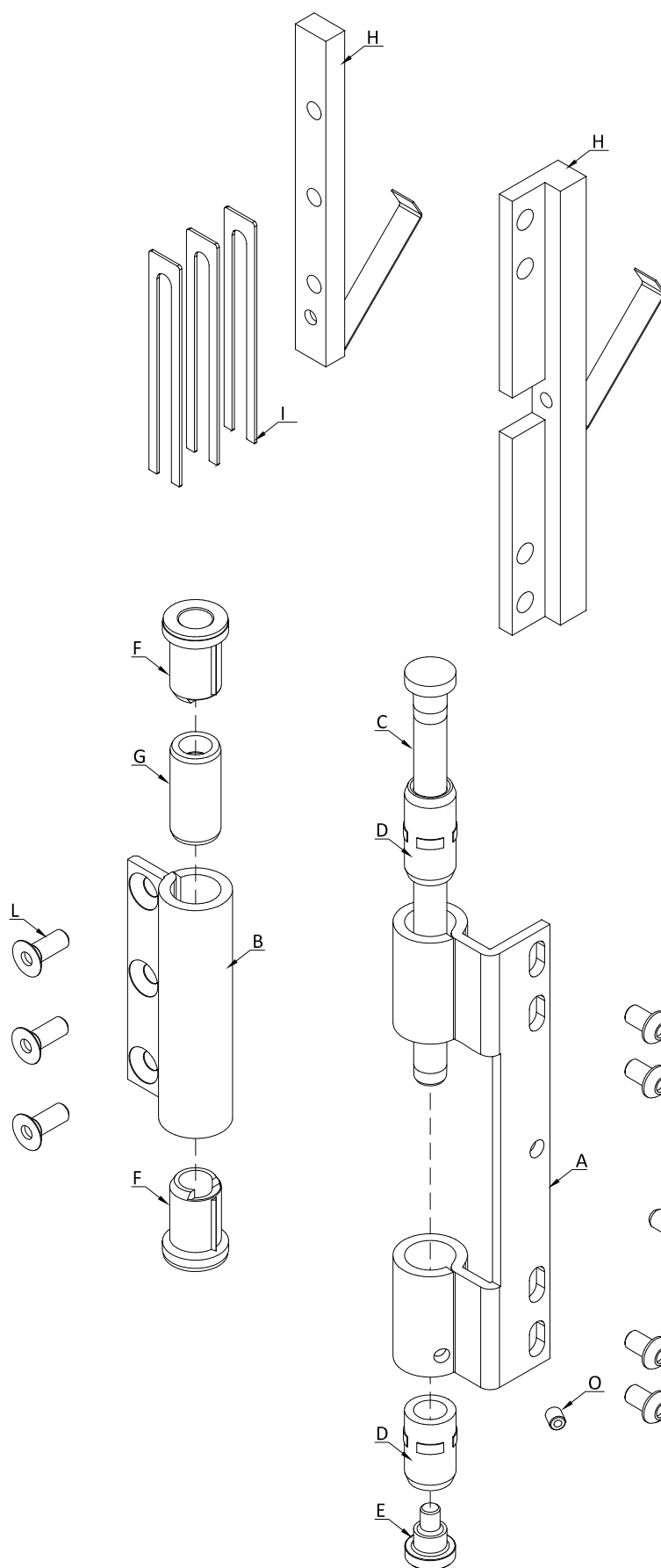






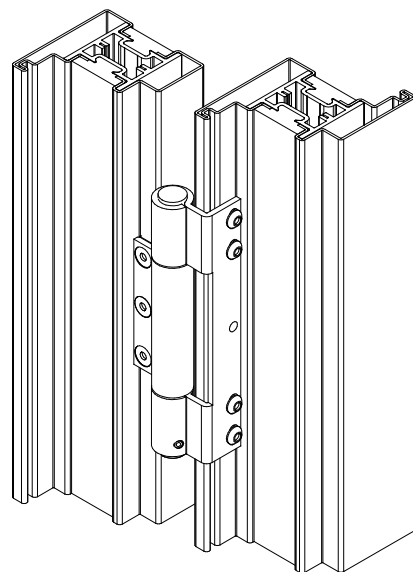


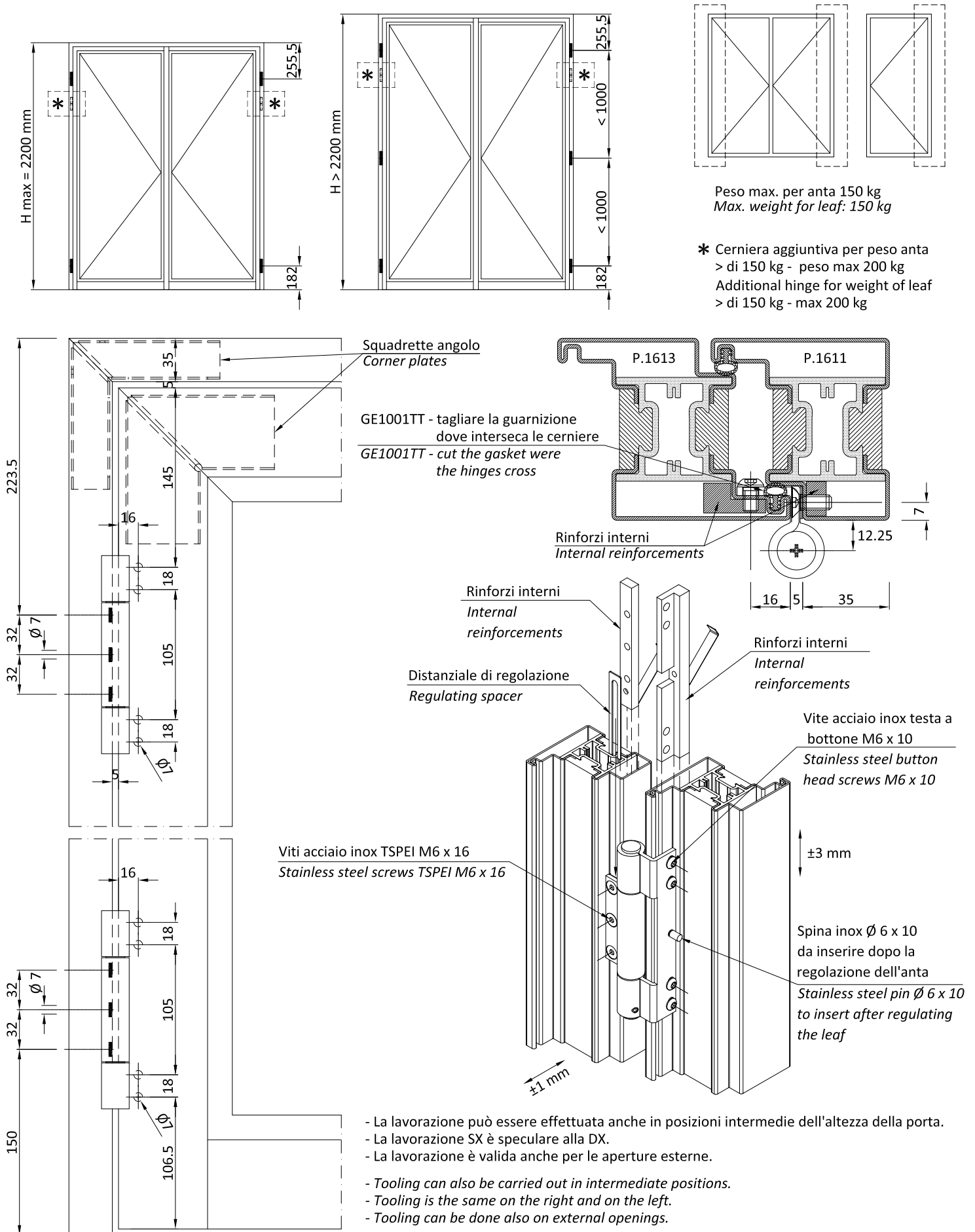
* Saldare con materiale di riporto
* Welding with filler material

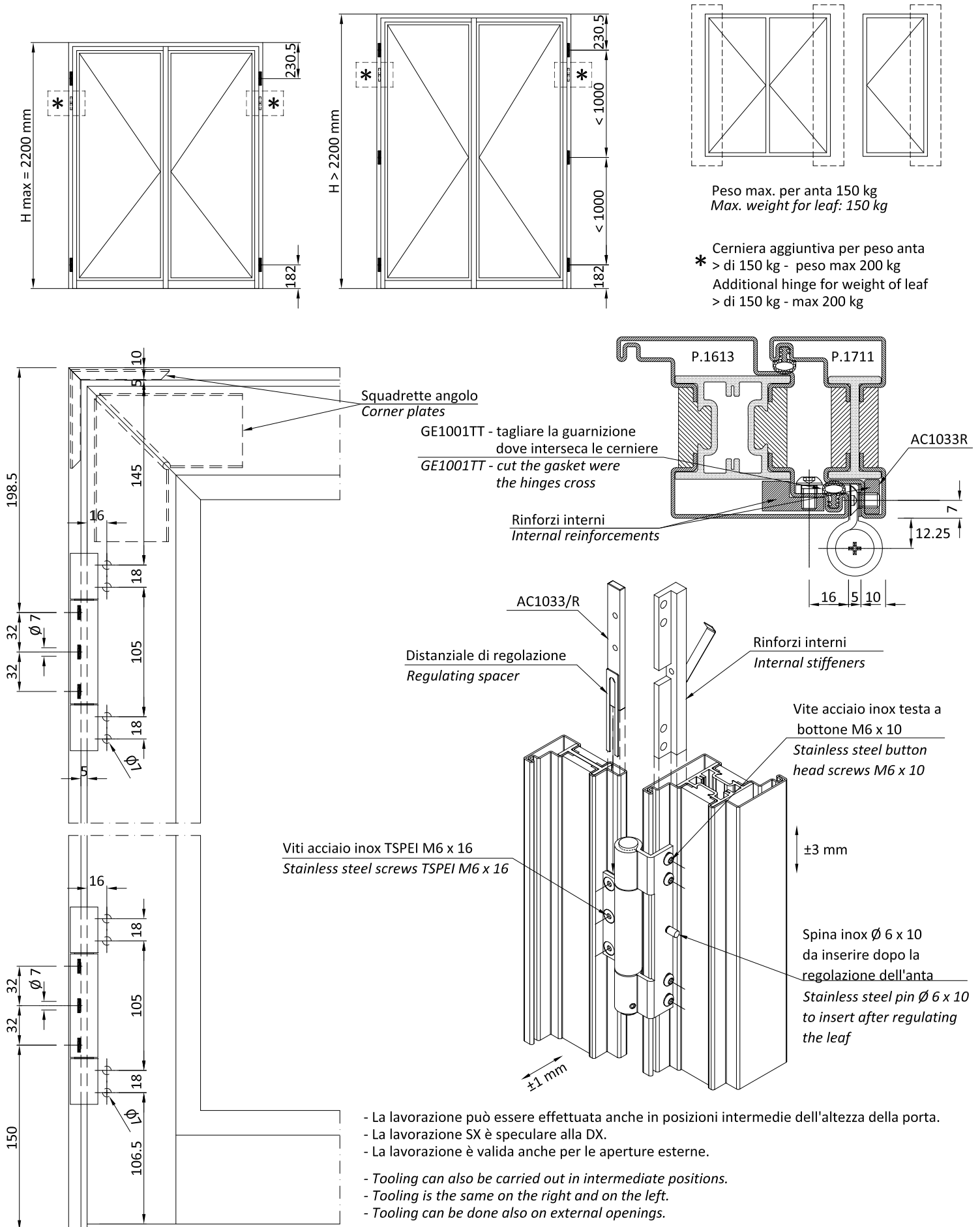


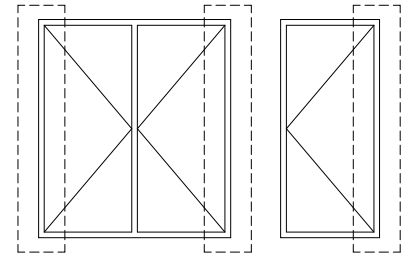
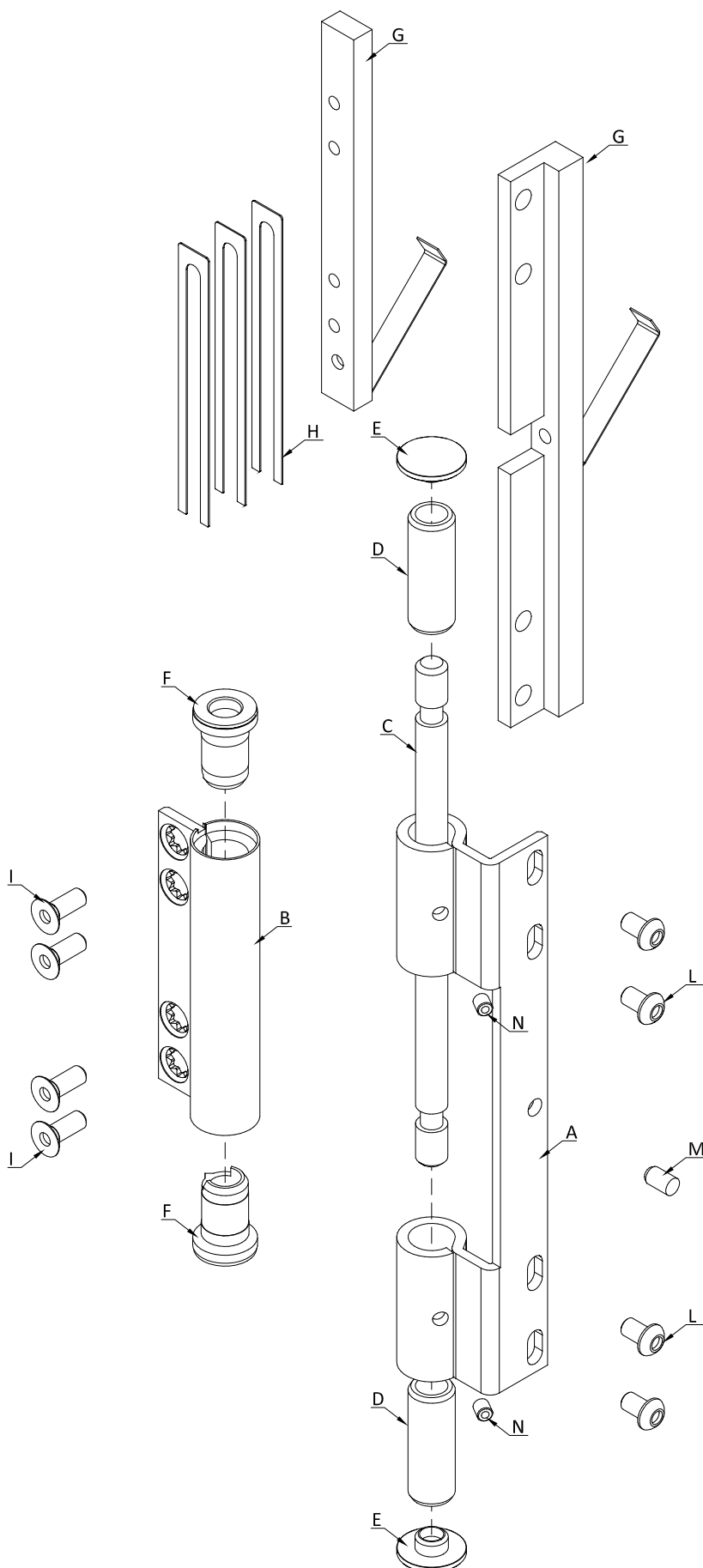
- A) Corpo cerniera A
B) Corpo cerniera B
C) Perno
D) Distanziatore
E) Tappo a vite
F) Boccola antifrizione
G) Distanziatore
H) Rinforzi interni
I) Distanziale di regolazione
L) Viti acciaio inox TSPEI M6 x 16
M) Vite acciaio inox testa a bottone M6 x 10
N) Spina inox Ø 6 x 10 da inserire dopo la regolazione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



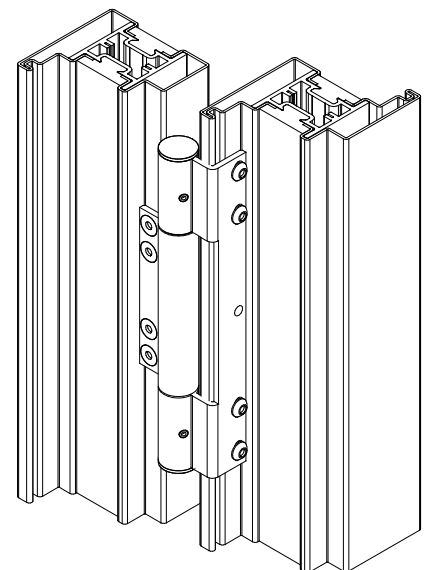


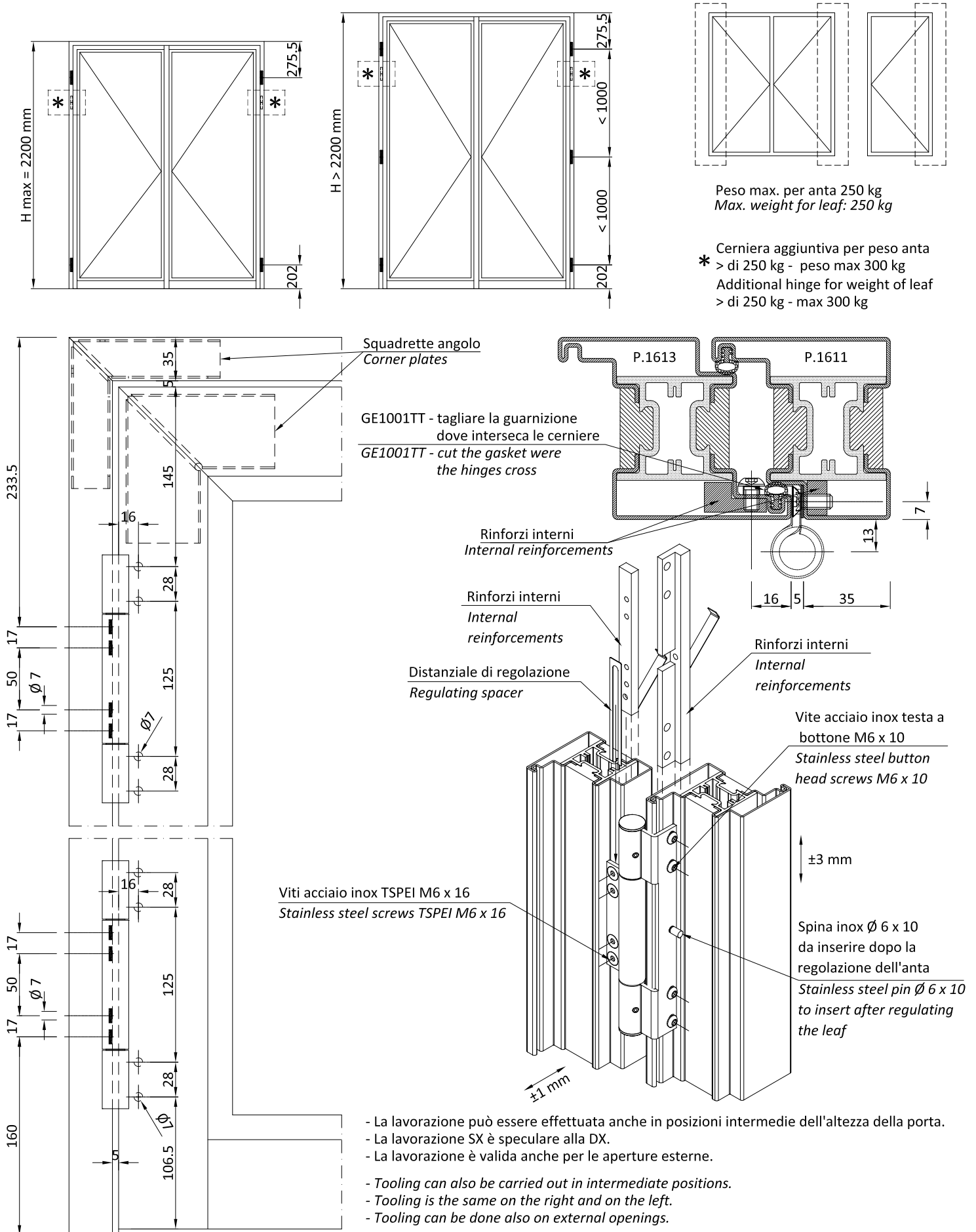


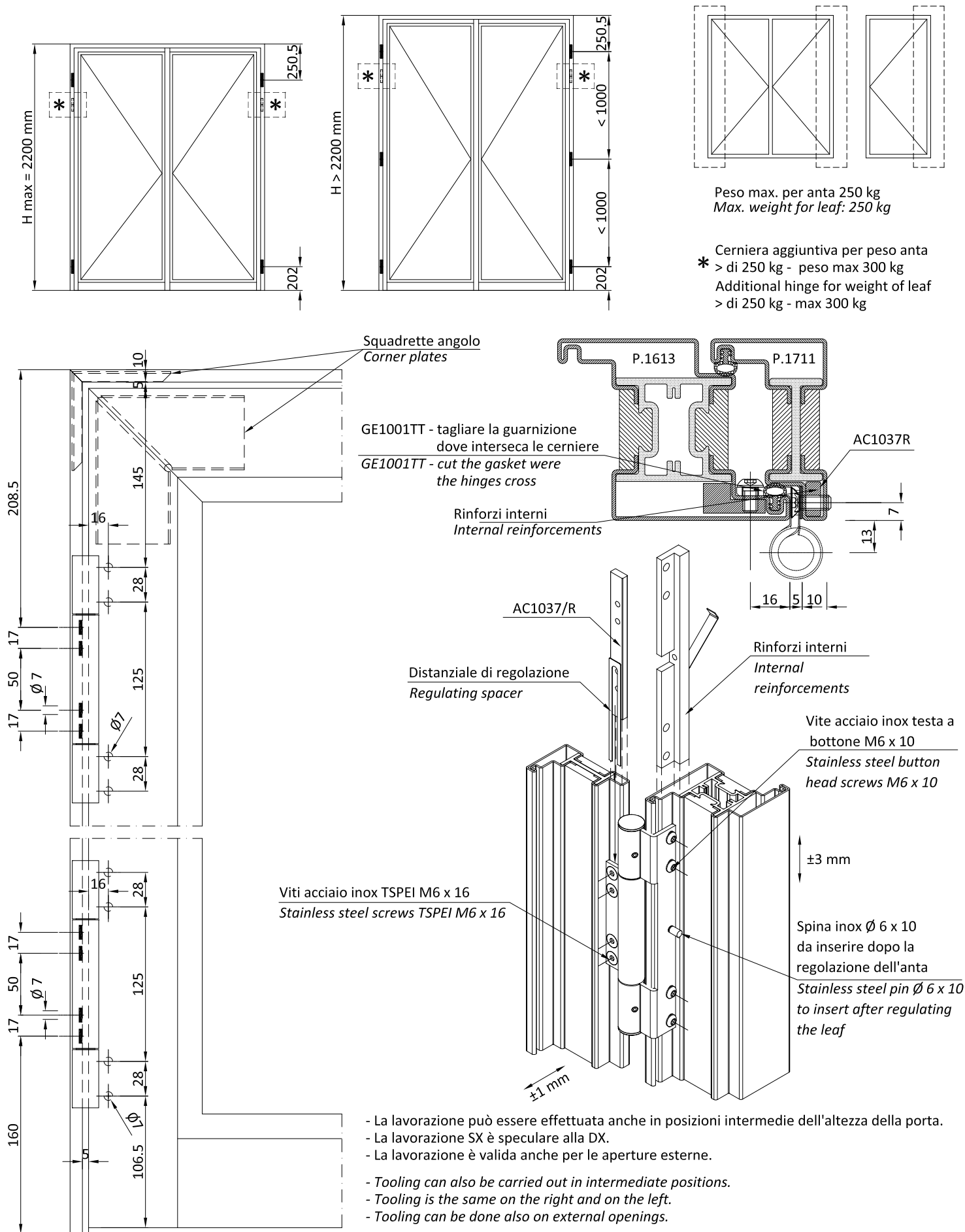


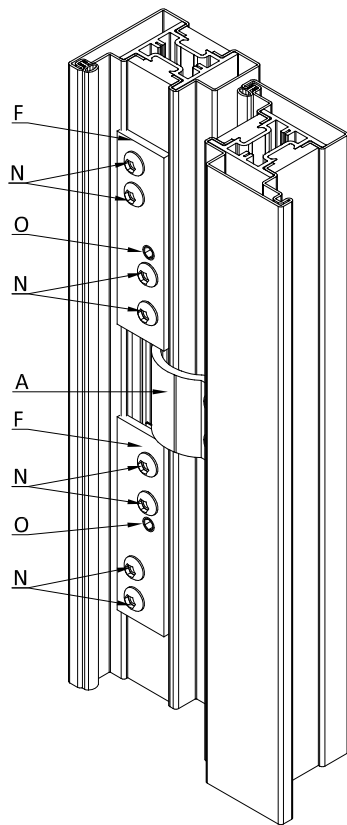
- A) Corpo cerniera A
- B) Corpo cerniera B
- C) Perno
- D) Distanziatore
- E) Tappo di finitura
- F) Boccola antifrizione
- G) Rinforzi interni
- H) Distanziale di regolazione
- I) Viti acciaio inox TSPEI M6 x 16
- L) Vite acciaio inox testa a bottone M6 x 10
- M) Spina inox $\varnothing 6 \times 10$ 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 $\varnothing 6 \times 10$ to insert after regulating the leaf
- N) Dowel M5x6

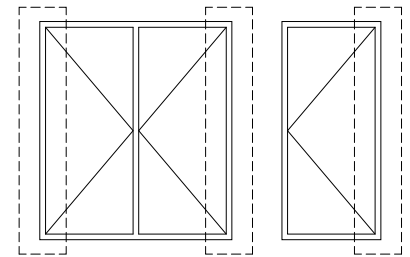




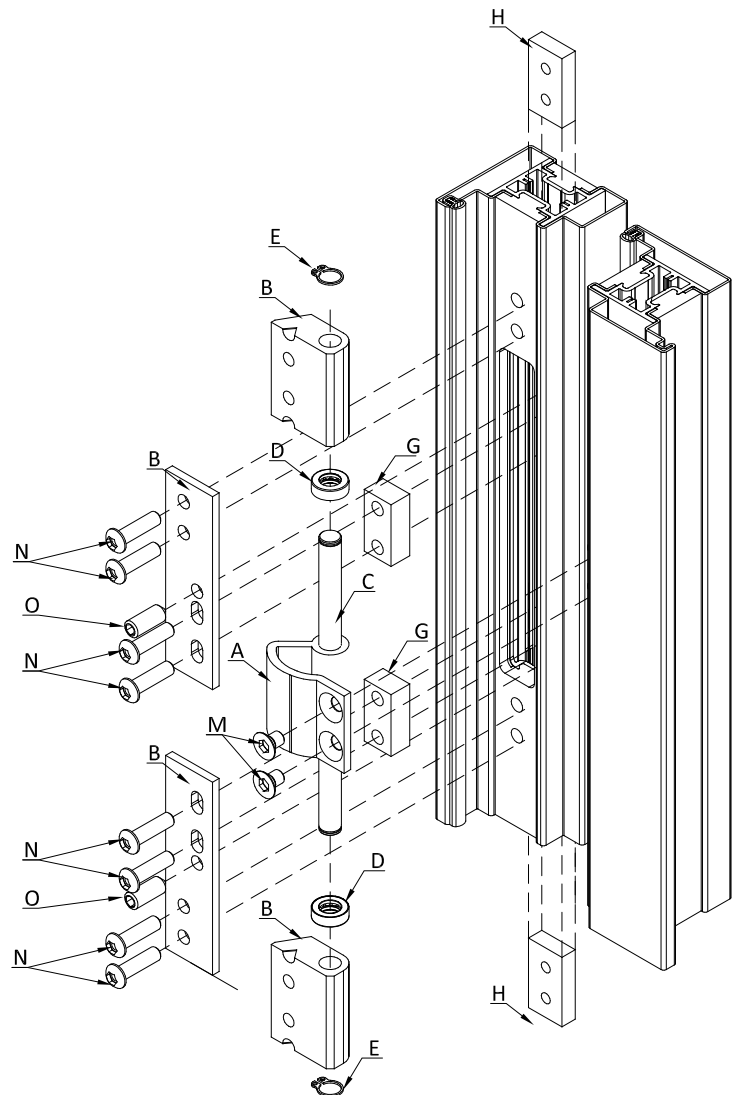
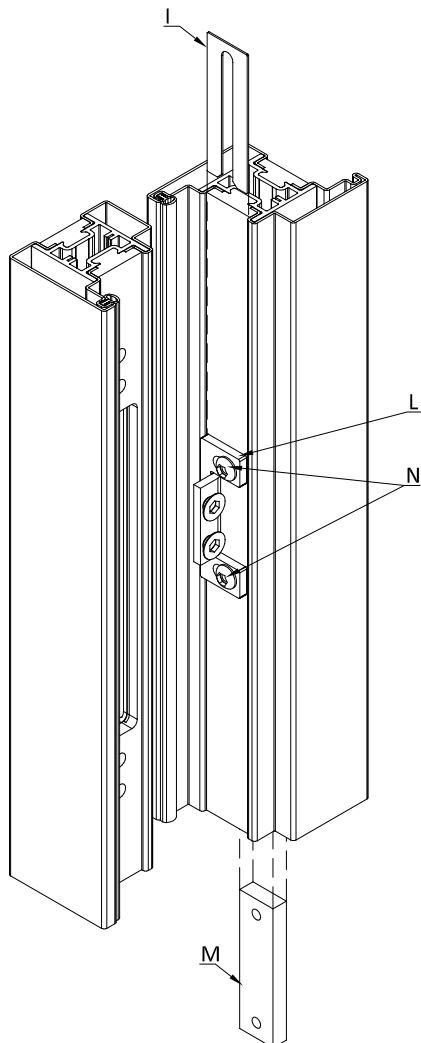


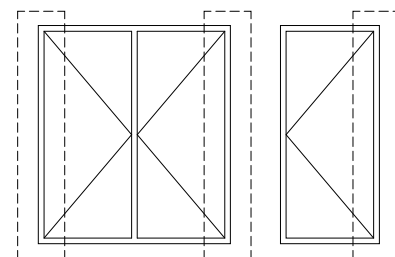
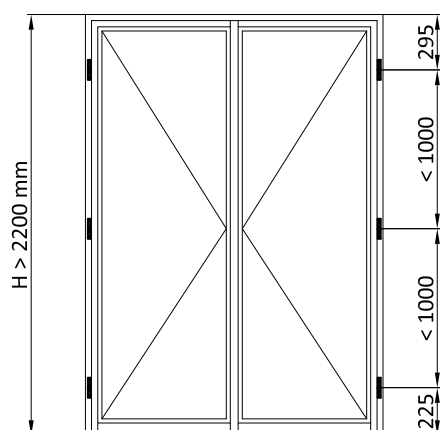


- A) Corpo cerniera A
- B) Corpo cerniera B
- C) Perno
- D) Cuscinetto
- E) Seger
- F) Piastra
- G) Contro-piastra A
- H) Contro-piastra B
- I) Spessore
- L) Staffa di fissaggio
- M) Contropiastra C
- N) n°2 x Vite TPEI M8 x 16 mm
- O) n°2 x Vite TPEI M8 x 35mm
- P) Grano M10 x 25 mm punta conica

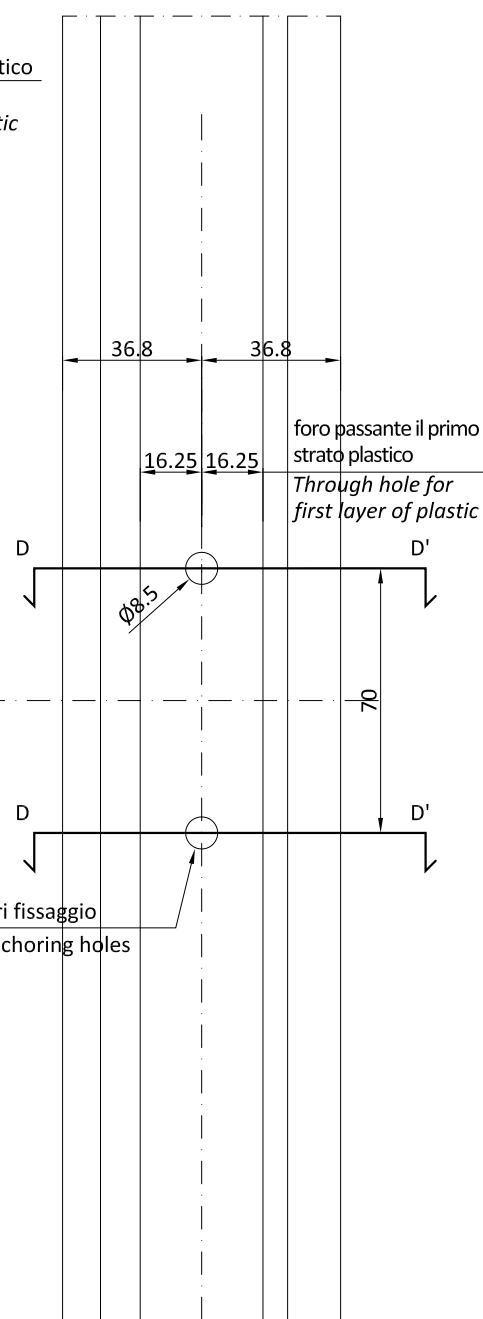
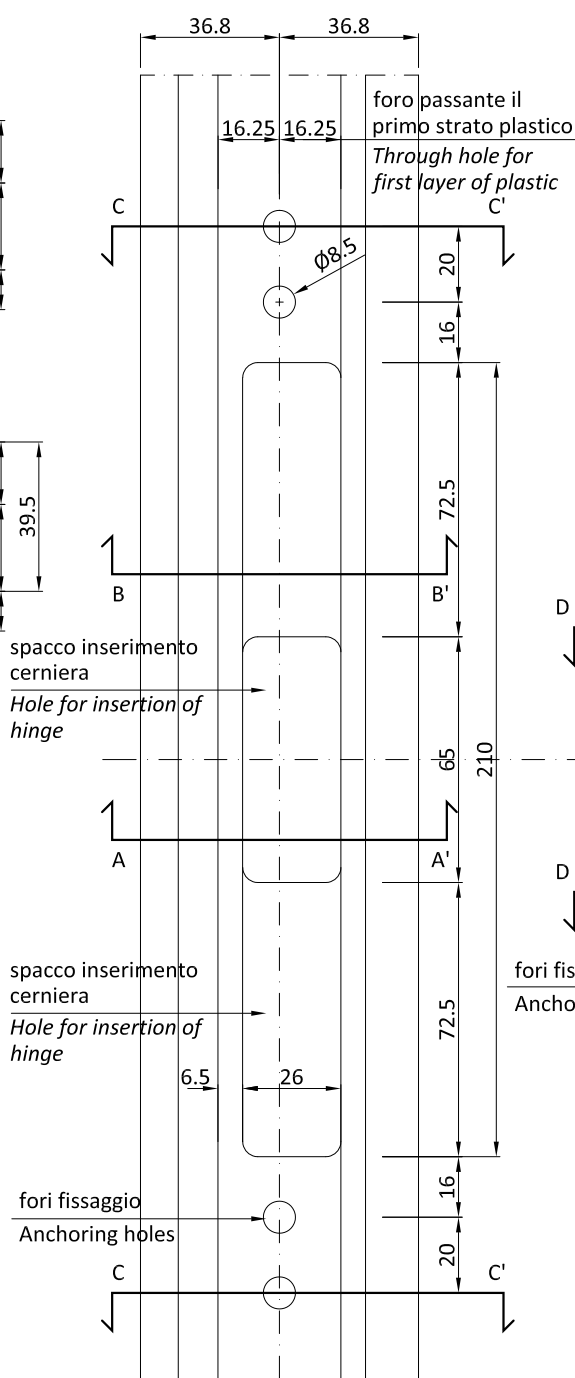
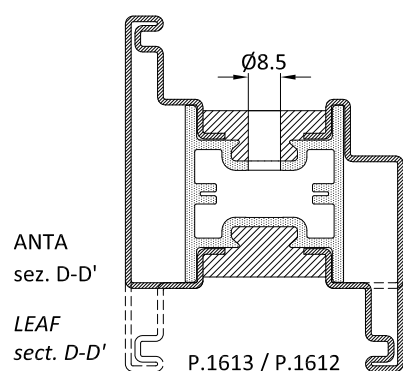


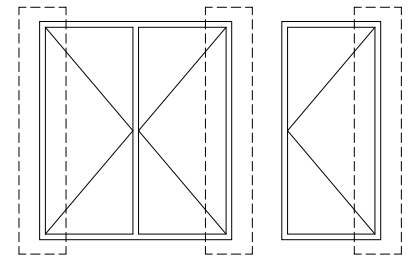
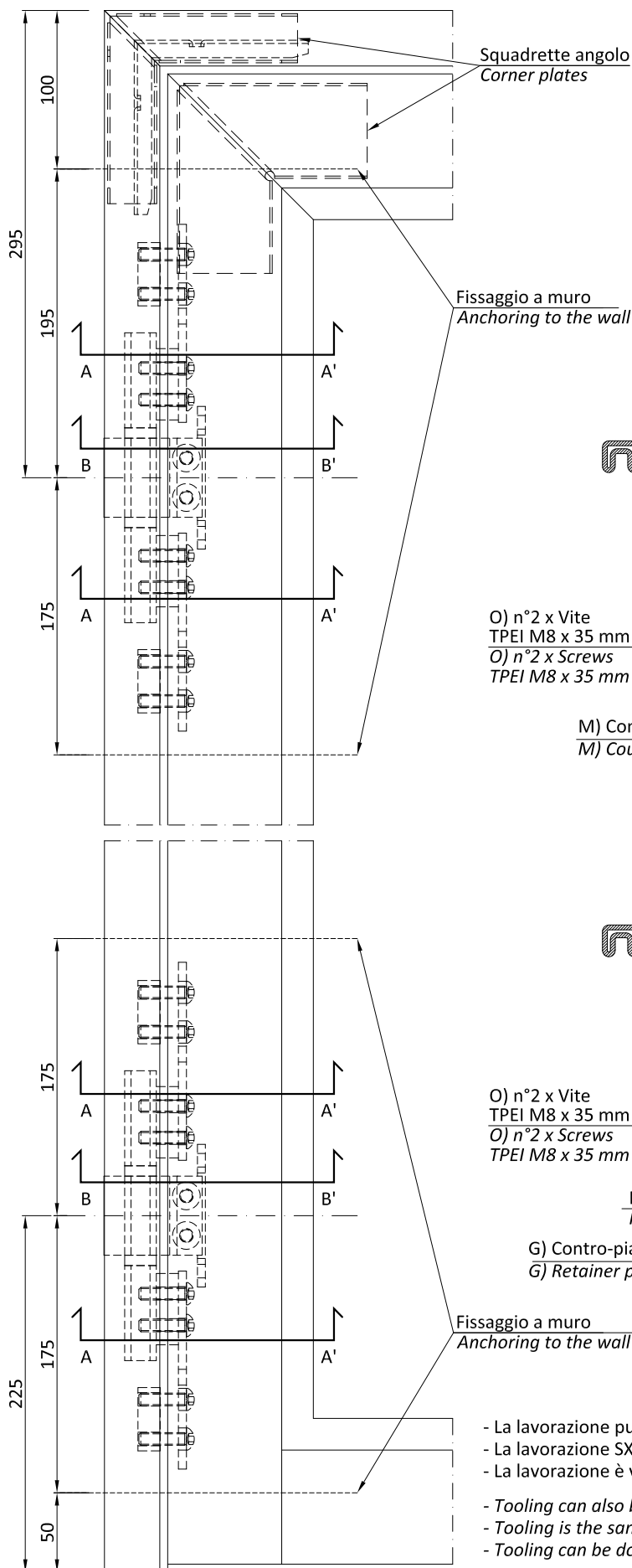
- A) Body hinge A
- B) Body hinge B
- C) Pin
- D) Bearing
- E) Seger
- F) Plate
- G) Retainer plate A
- H) Retainer plate B
- I) Shim
- L) Anchoring bracket
- M) Counter-plate C
- N) n° 2 x Screws TPEI M8x16 mm
- O) n°2 x Screws TPEI M8x3 5mm
- P) Dowel M10 x 25 mm, cone point



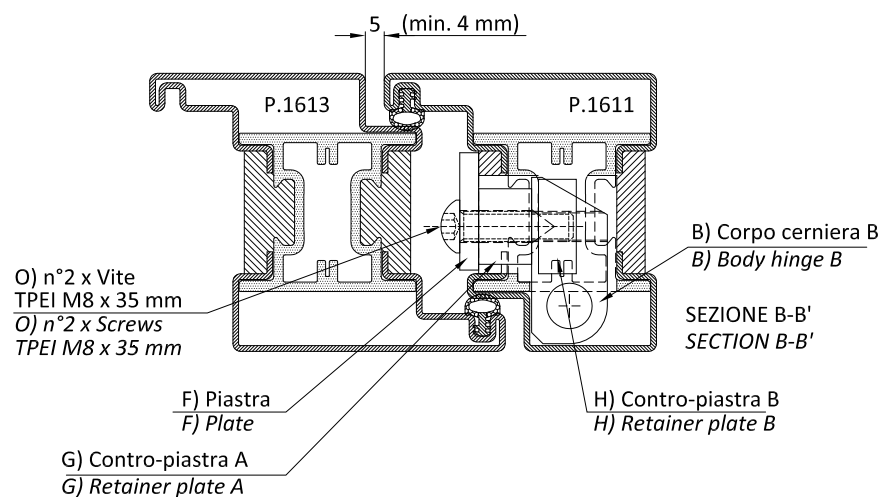
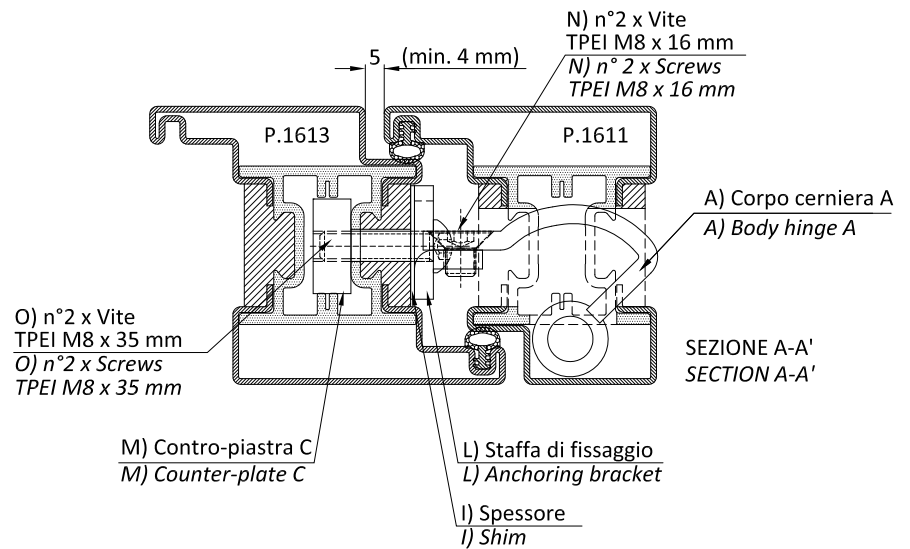


Peso max. per anta 180 kg
Massima apertura 96°
Max. weight for leaf: 180 kg
Maximum opening 96°

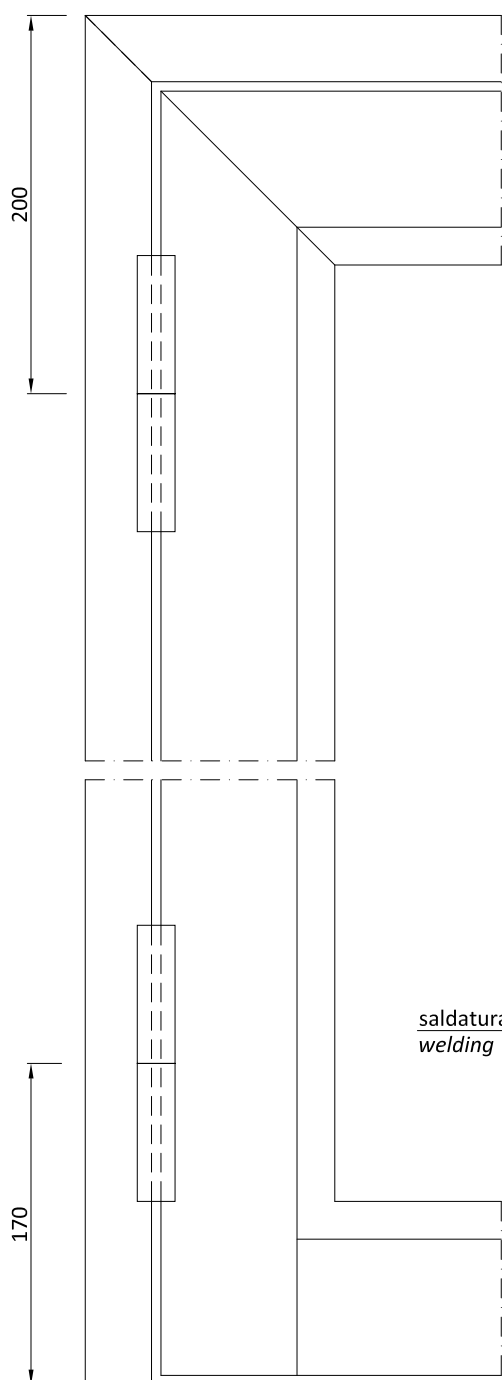
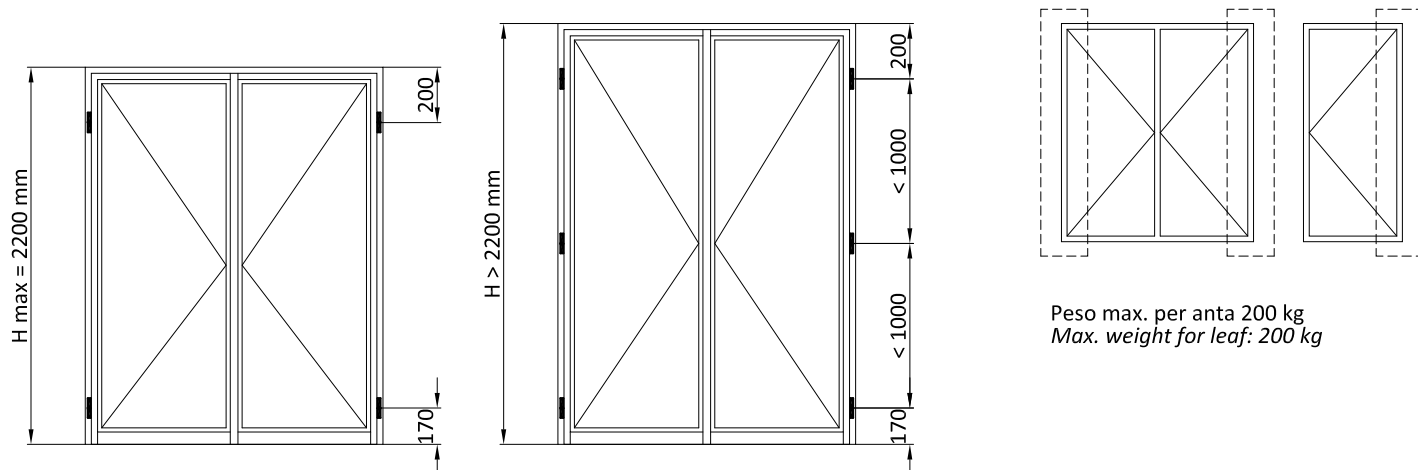




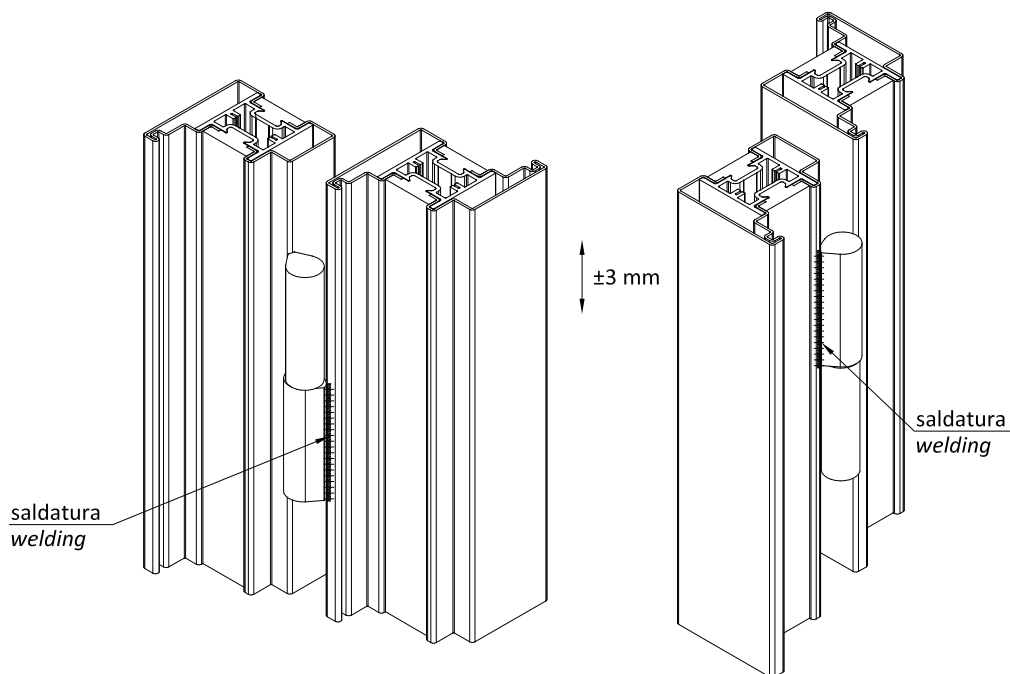
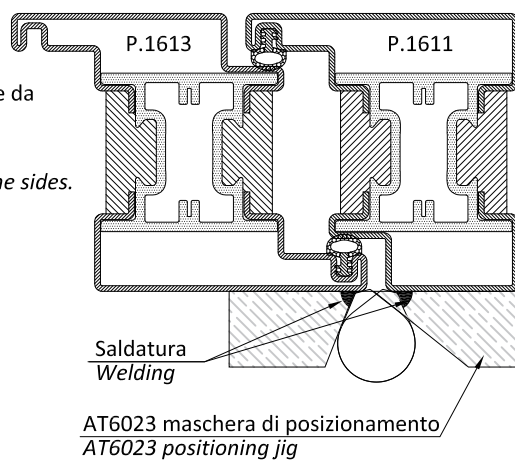
Peso max. per anta 180 kg
Massima apertura 96°
Max. weight for leaf: 180 kg
Maximum opening 96°



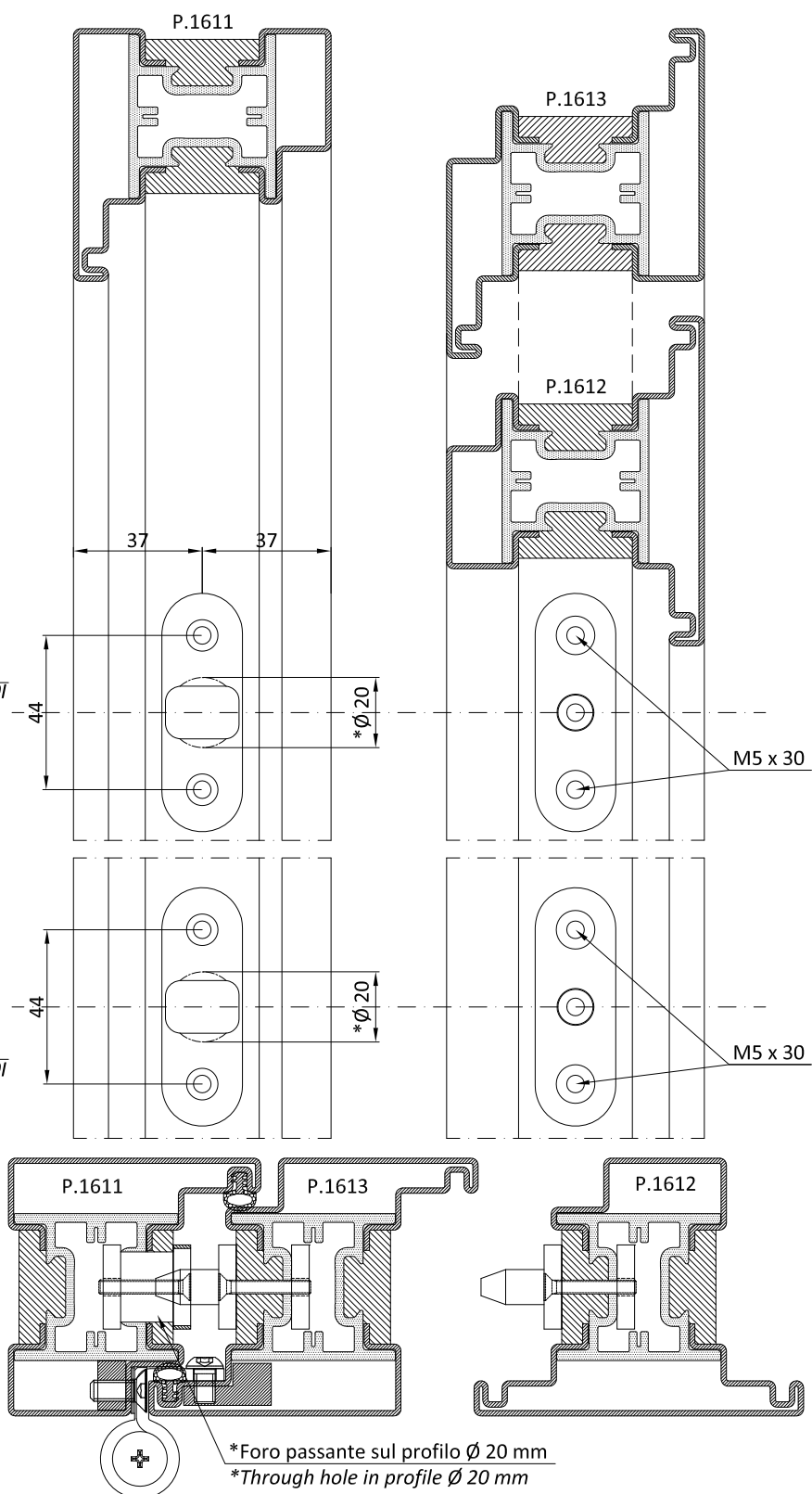
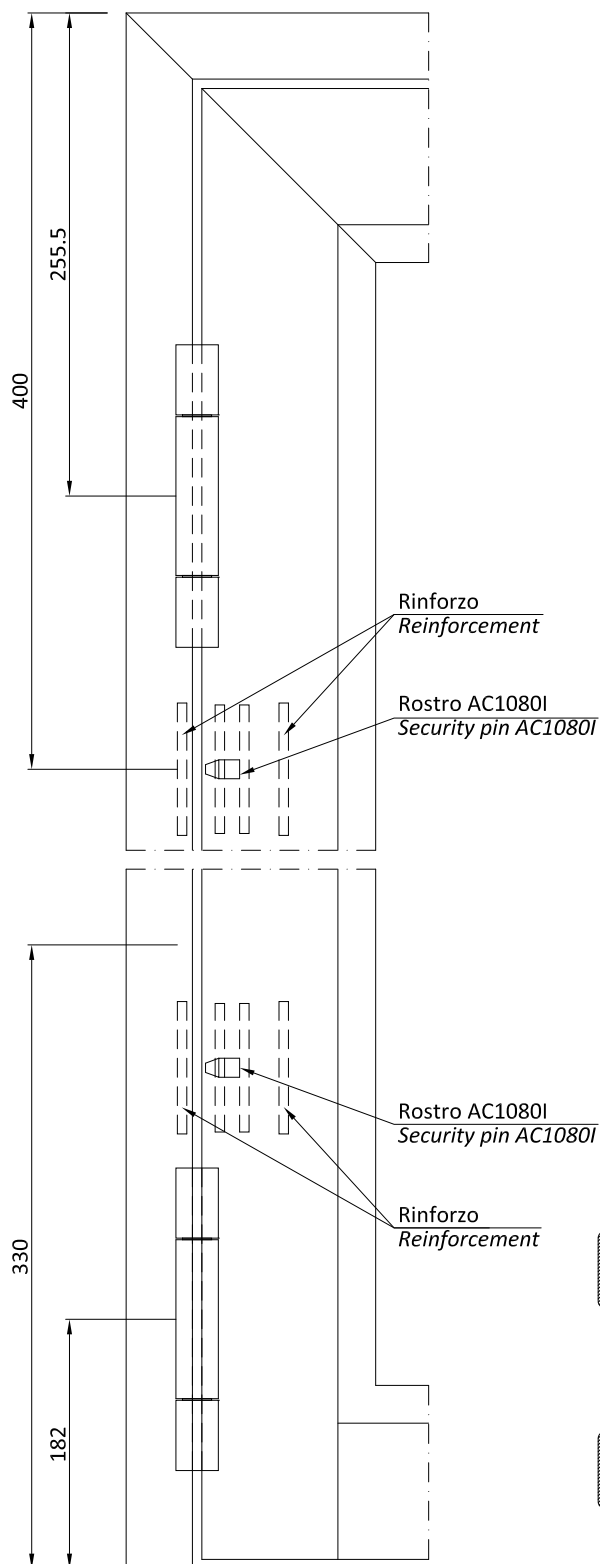
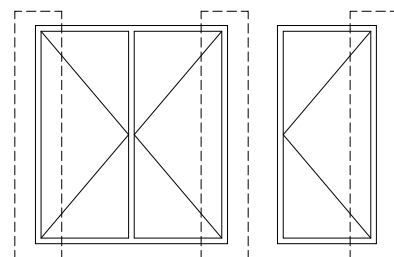
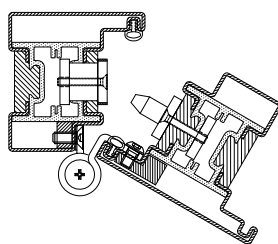
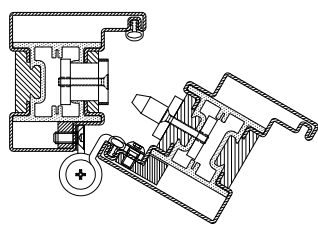
- La lavorazione può essere effettuata anche in posizioni intermedie dell'altezza della porta.
- La lavorazione SX è speculare alla DX.
- La lavorazione è valida anche per le aperture esterne.
- Tooling can also be carried out in intermediate positions.
- Tooling is the same on the right and on the left.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

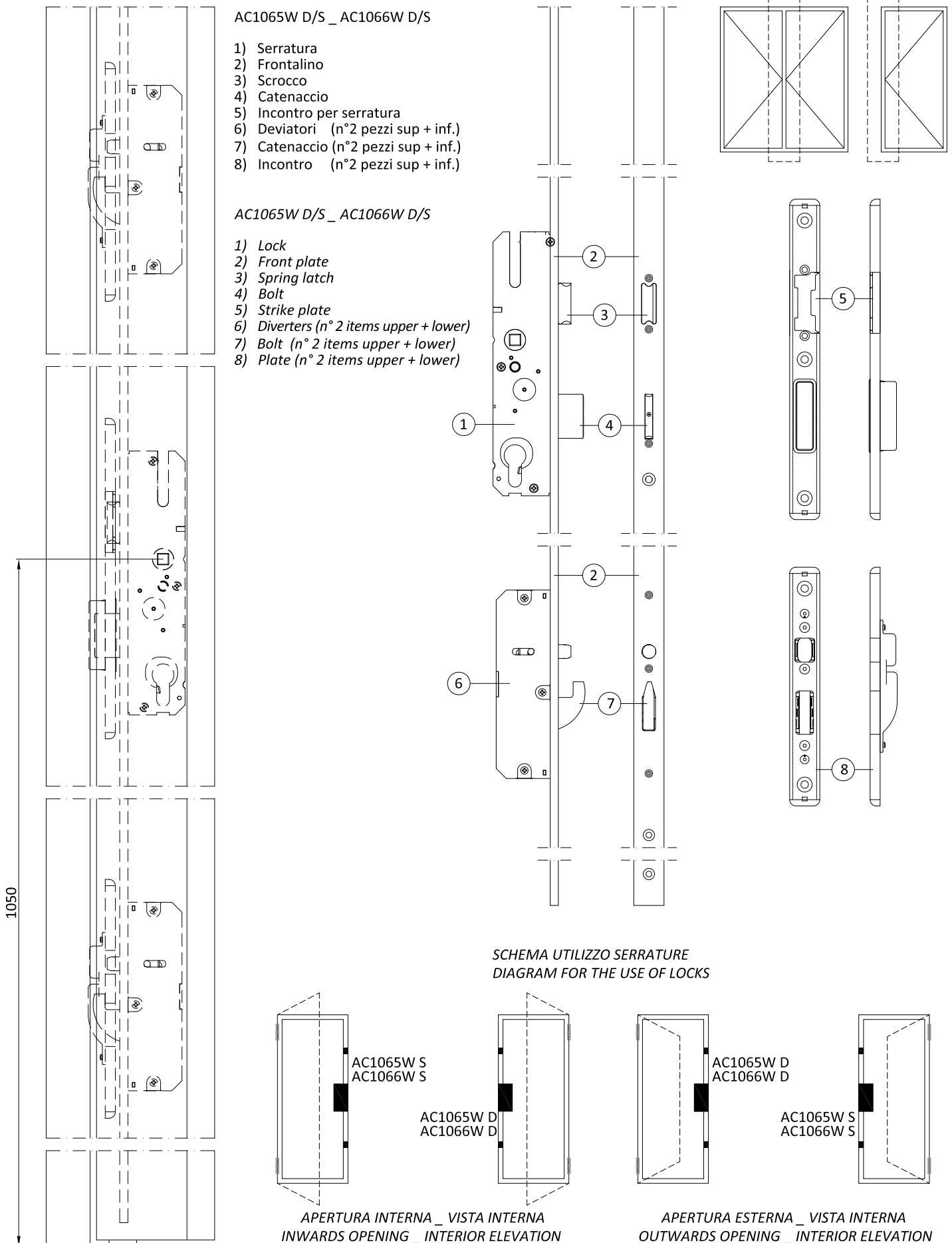


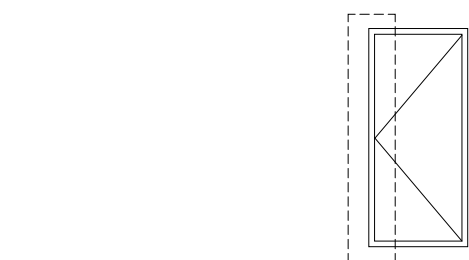
Posizionare le cerniere come da disegno saldandole sui lati.
Position the hinges as in the drawing, welding them on the sides.



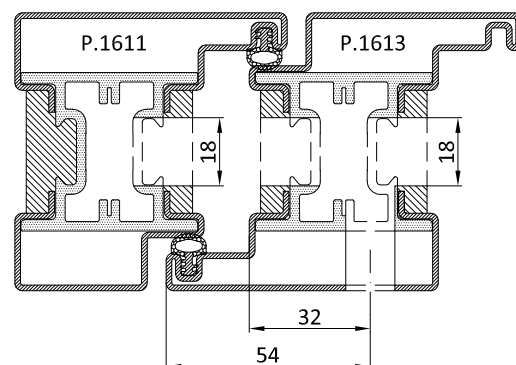
- La lavorazione può essere effettuata anche in posizioni intermedie dell'altezza della porta.
- La lavorazione SX è speculare alla DX.
- La lavorazione è valida anche per le aperture esterne.
- Tooling can be carried out also in intermediate positions regarding the height of the door.
- Tooling on left is the same as that on the right.
- Tooling can be done also on external openings.





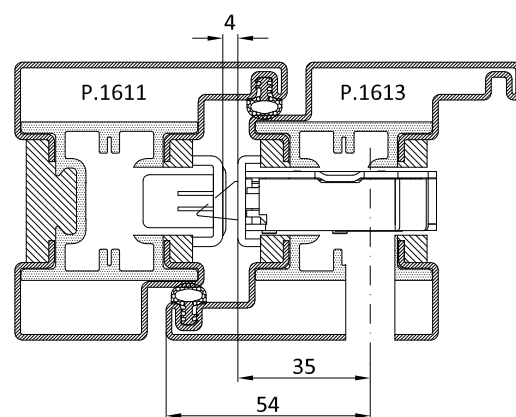


Lavorazione valida anche per porte apertura esterna
Tooling also valid for doors with external opening

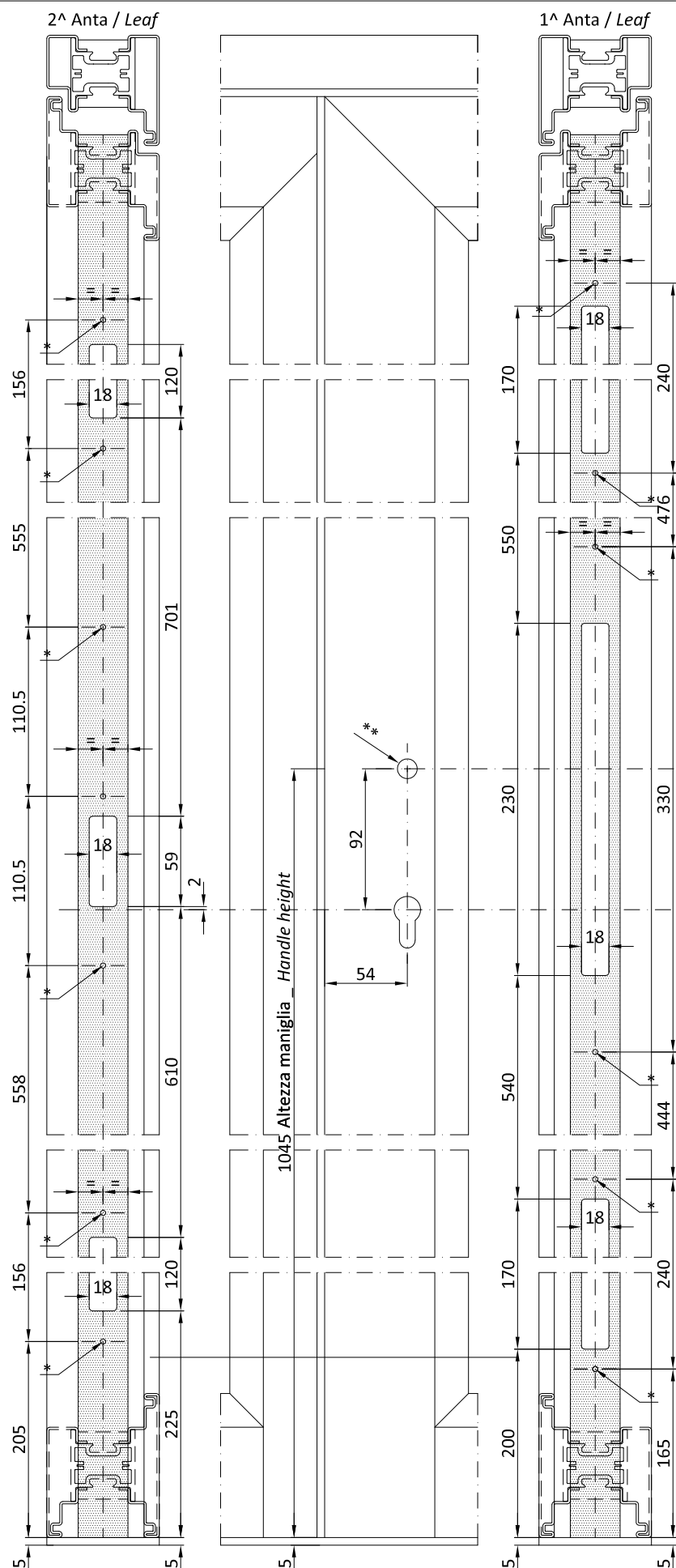


Asse maniglia
Handle axis

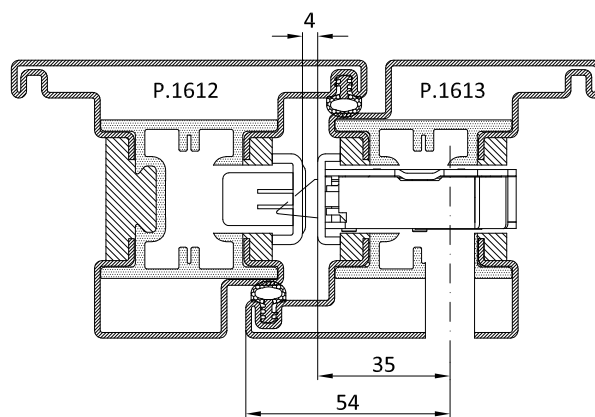
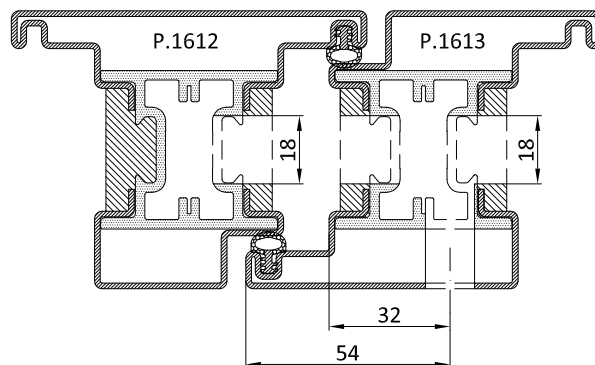
Asse cilindro
Cylinder axis



** Ø 13 per maniglia ACV 9-- | Ø 13 for handle ACV 9--
 ** Ø 16 per maniglia AC 5002 | Ø 16 for handle AC 5002



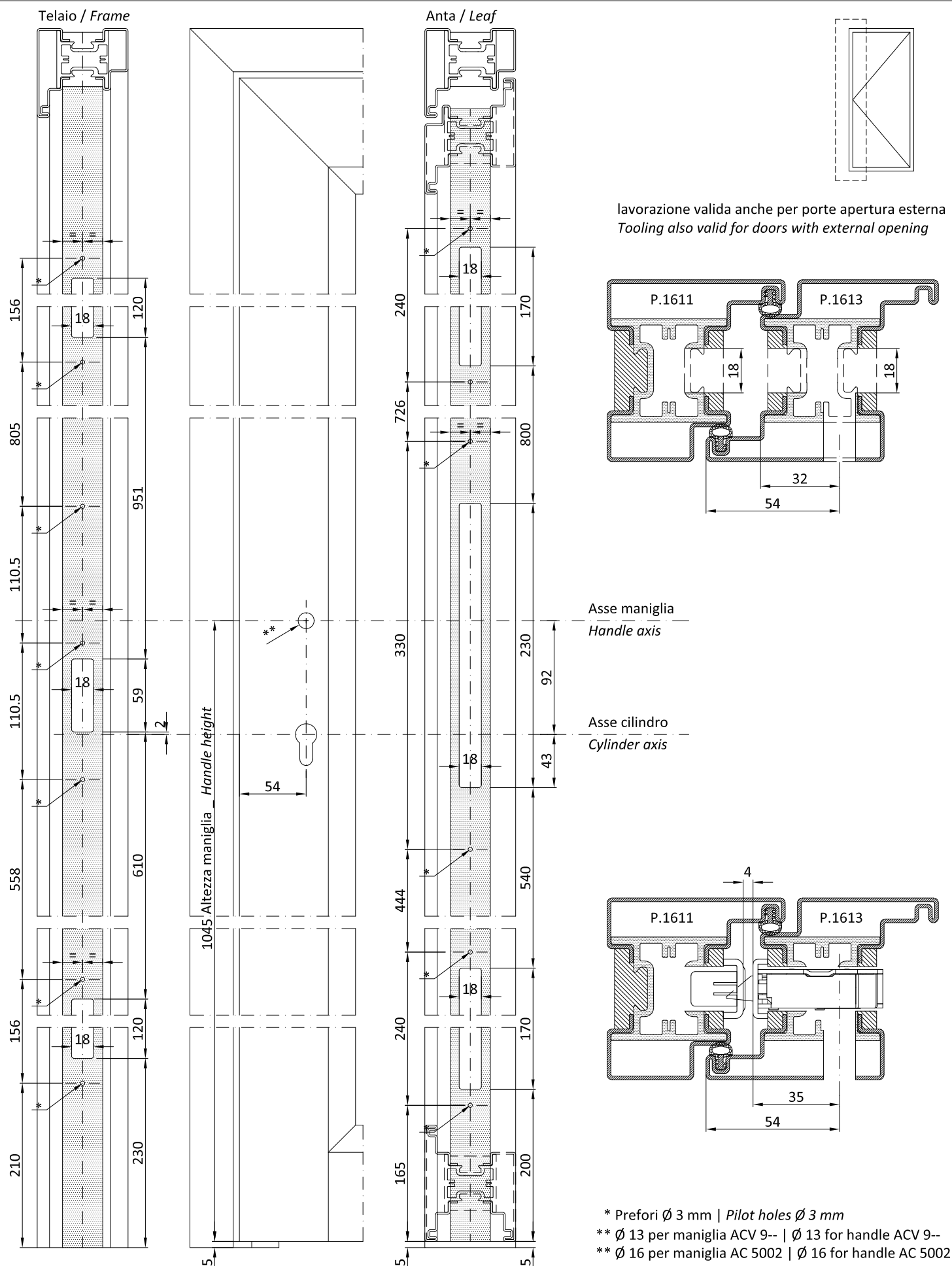
Lavorazione valida anche per porte apertura esterna
Tooling also valid for doors with external opening

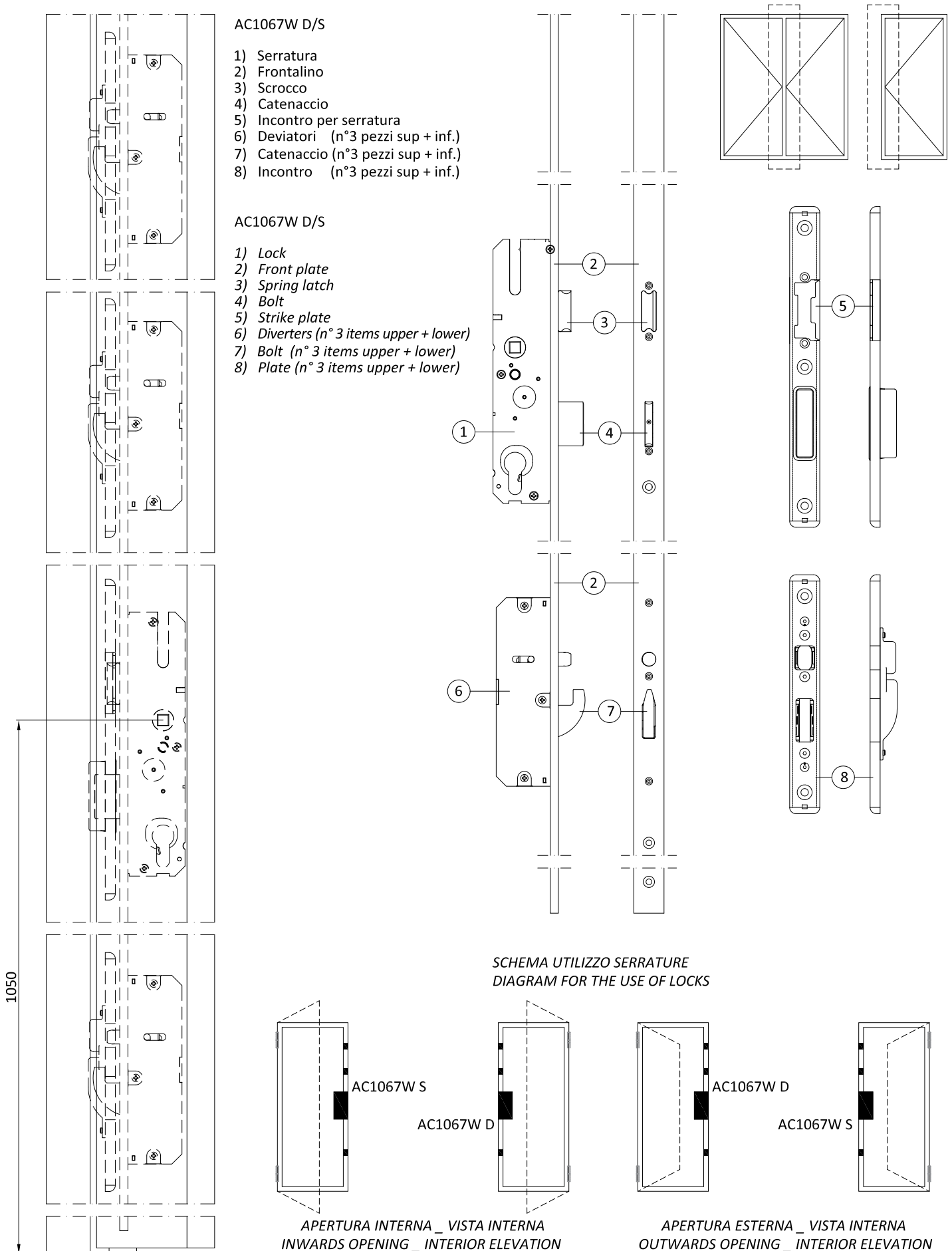


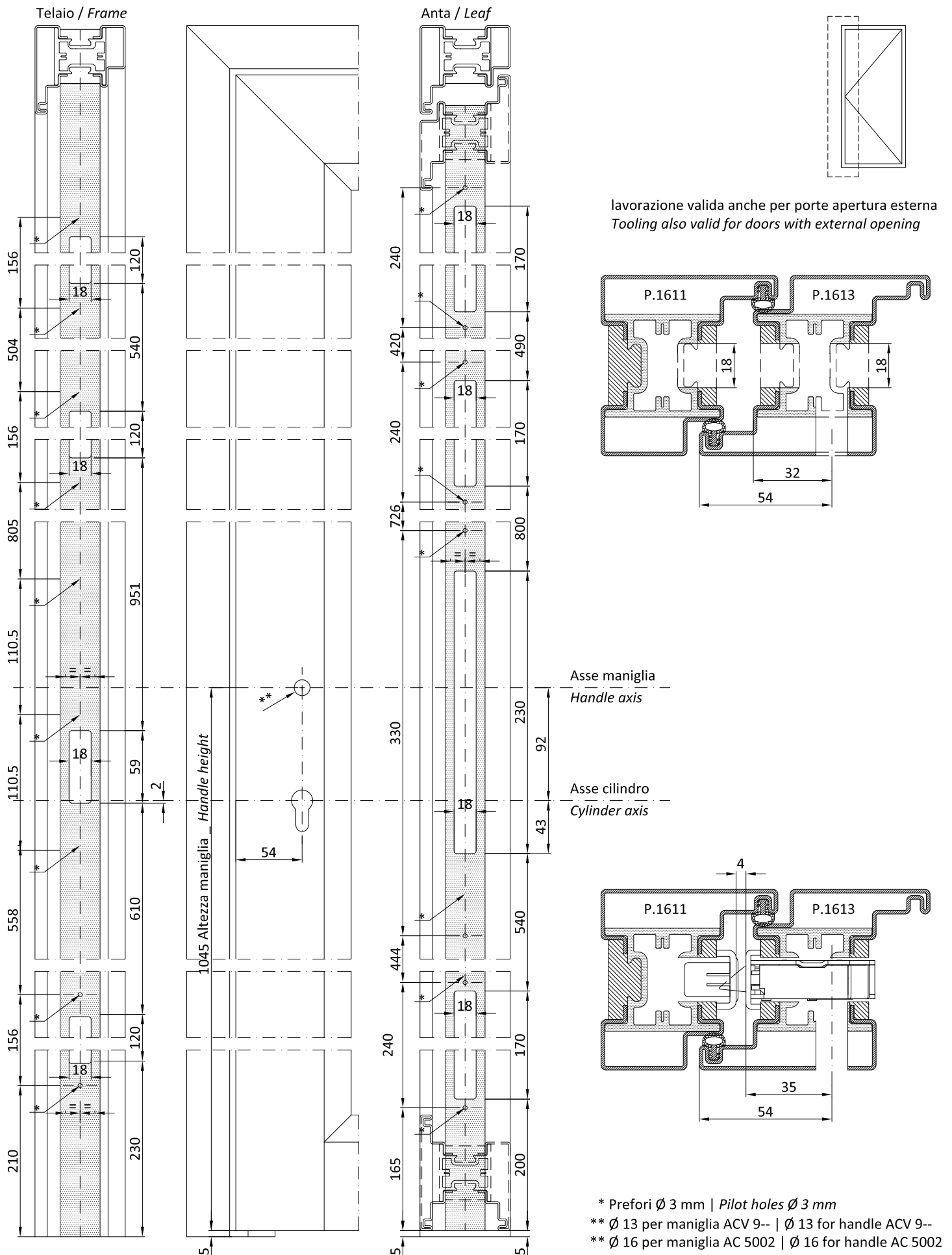
* Prefori Ø 3 mm | Pilot holes Ø 3 mm

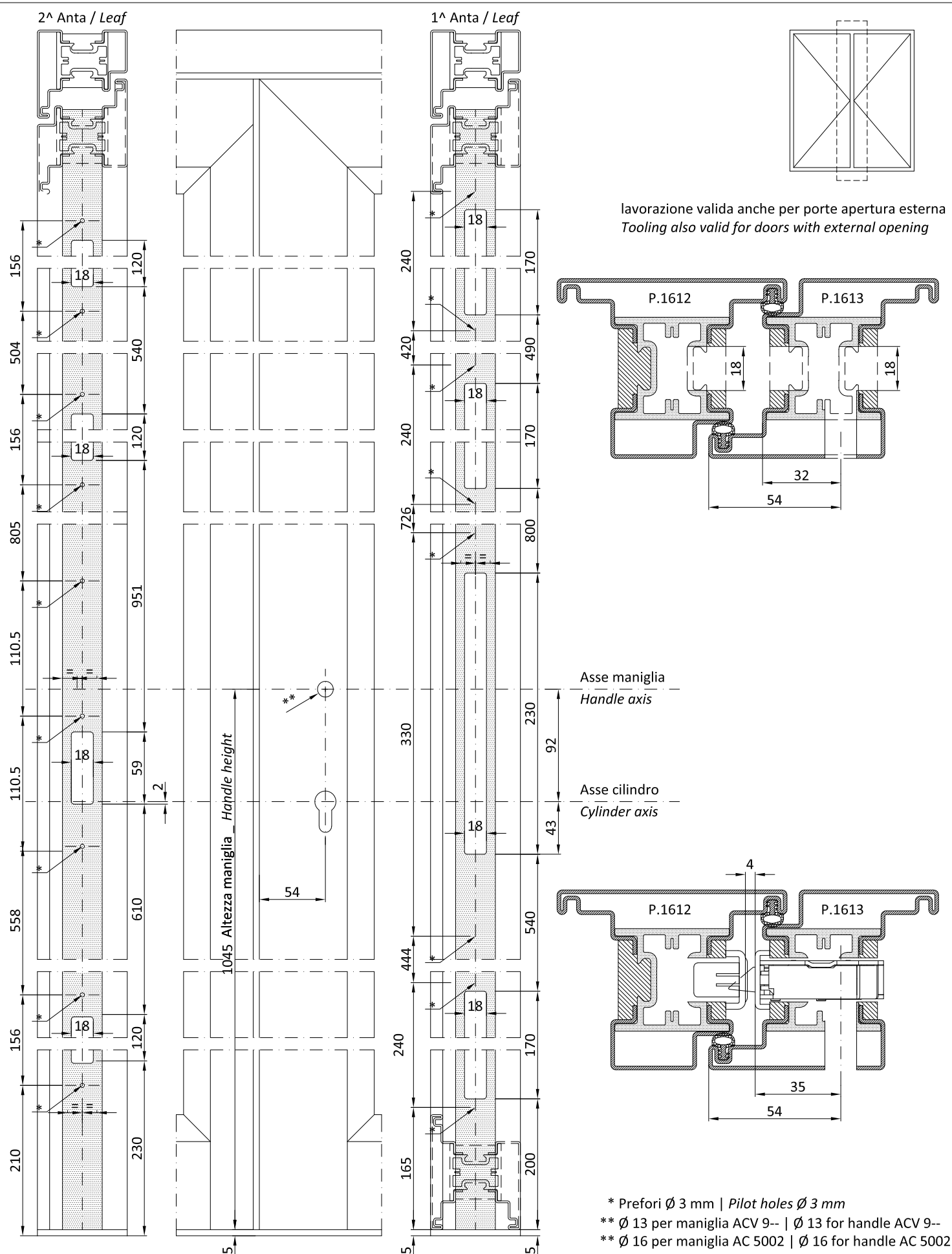
** Ø 13 per maniglia ACV 9-- | Ø 13 for handle ACV 9--

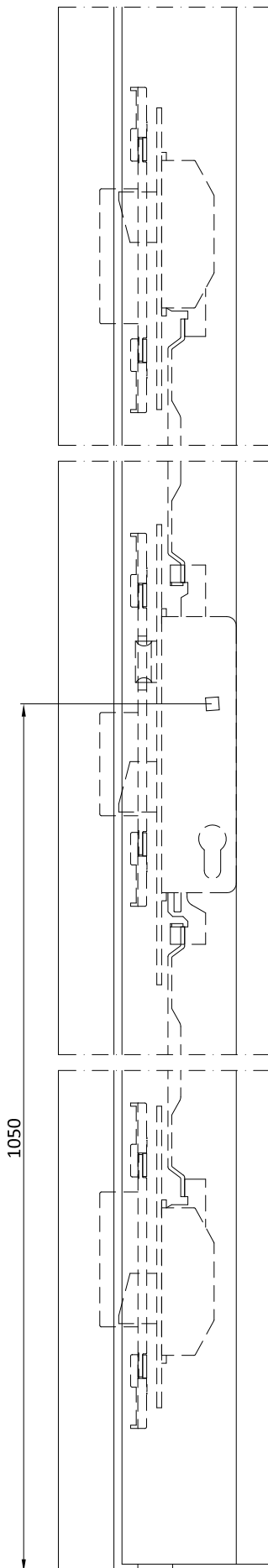
** Ø 16 per maniglia AC 5002 | Ø 16 for handle AC 5002





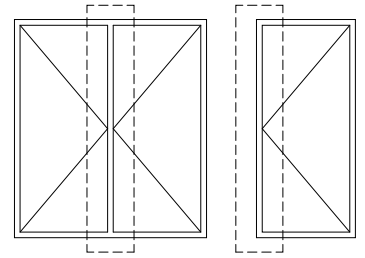






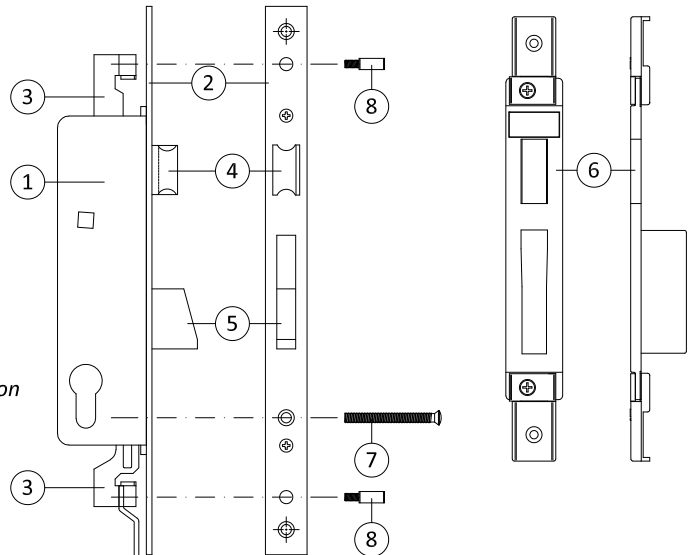
AC1070

- 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.)

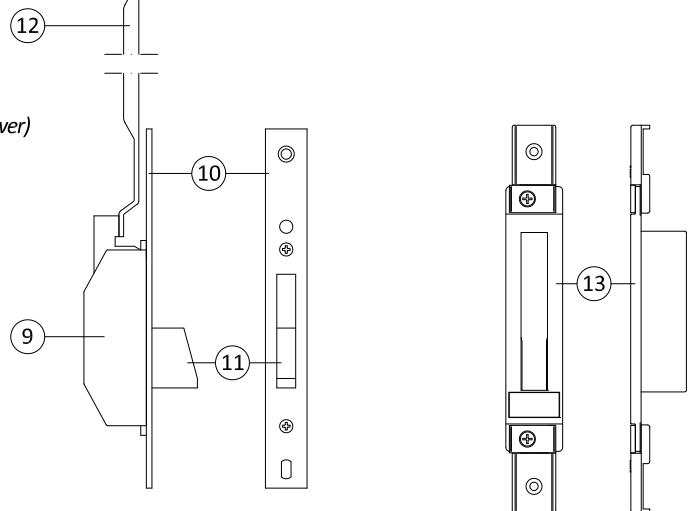
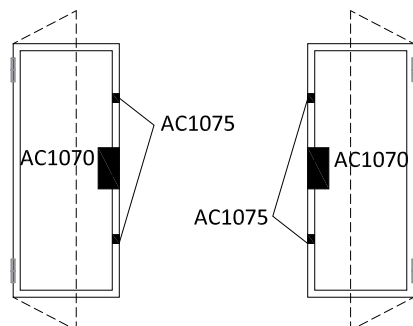
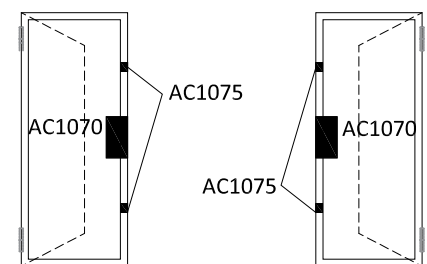


AC1070

- 1) Lock
- 2) Front plate
- 3) Reduction unit/adaptor 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 LOCKSAPERTURA INTERNA _ VISTA INTERNA
INWARDS OPENING _ INTERIOR ELEVATIONAPERTURA 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

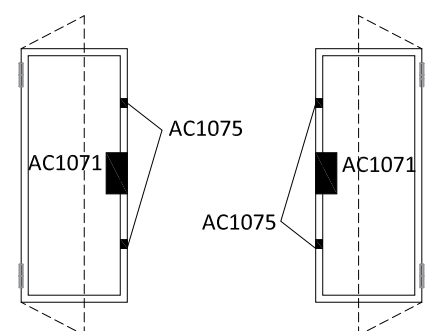
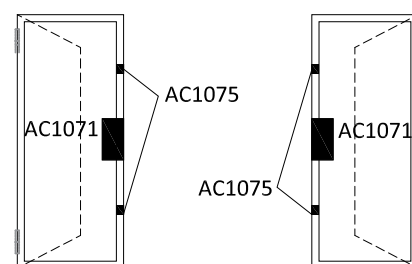
- 10) Deviatori (n°2 pezzi sup + inf.)
- 11) Frontalino (n°2 pezzi sup + inf.)
- 12) Catenaccio (n°2 pezzi sup + inf.)
- 13) Aste inox (n°2 pezzi sup + inf.)
- 14) Incontro (n°2 pezzi sup + inf.)

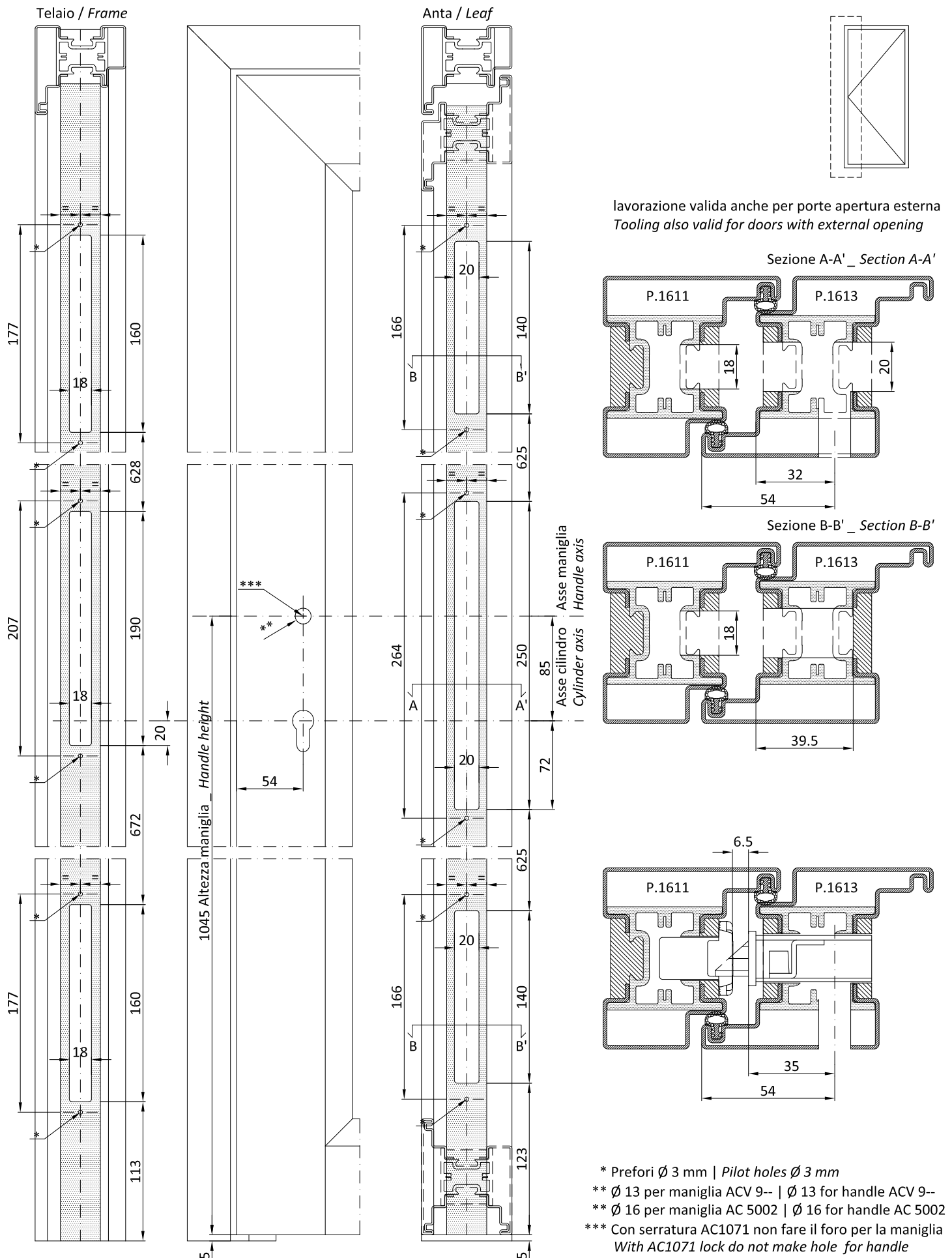
AC1071

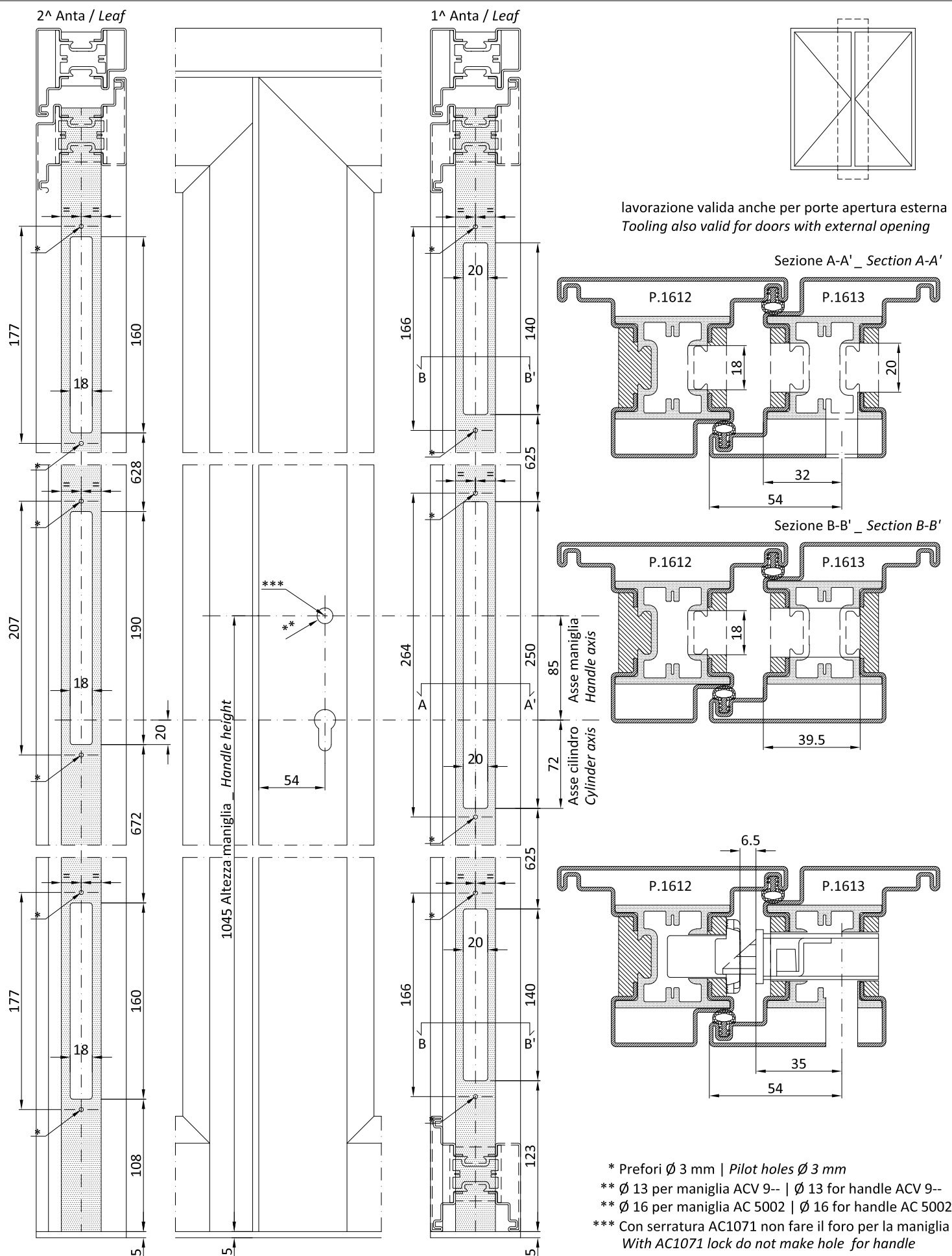
- 1) Lock
- 2) Front plate
- 3) Reduction unit/adaptor for connection
- 4) Roller
- 5) Bolt
- 6) Strike plate
- 7) Compartment for roller
- 8) Stainless steel screws TS M5x50
- 9) Pin for anchoring the rod

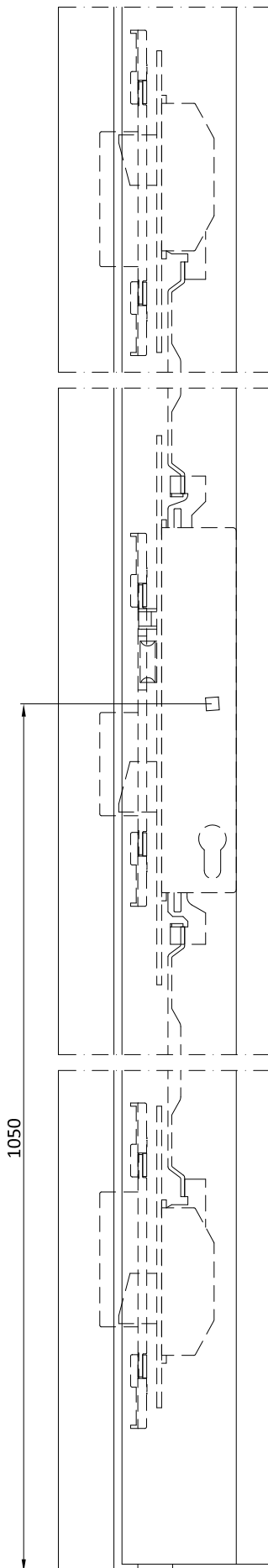
AC1075

- 10) Diverters (n° 2 items upper + lower)
- 11) Apron lining (n° 2 items upper + lower)
- 12) 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 LOCKSAPERTURA INTERNA _ VISTA INTERNA
INWARDS OPENING _ INTERIOR ELEVATIONAPERTURA ESTERNA _ VISTA INTERNA
OUTWARDS OPENING _ INTERIOR ELEVATION







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

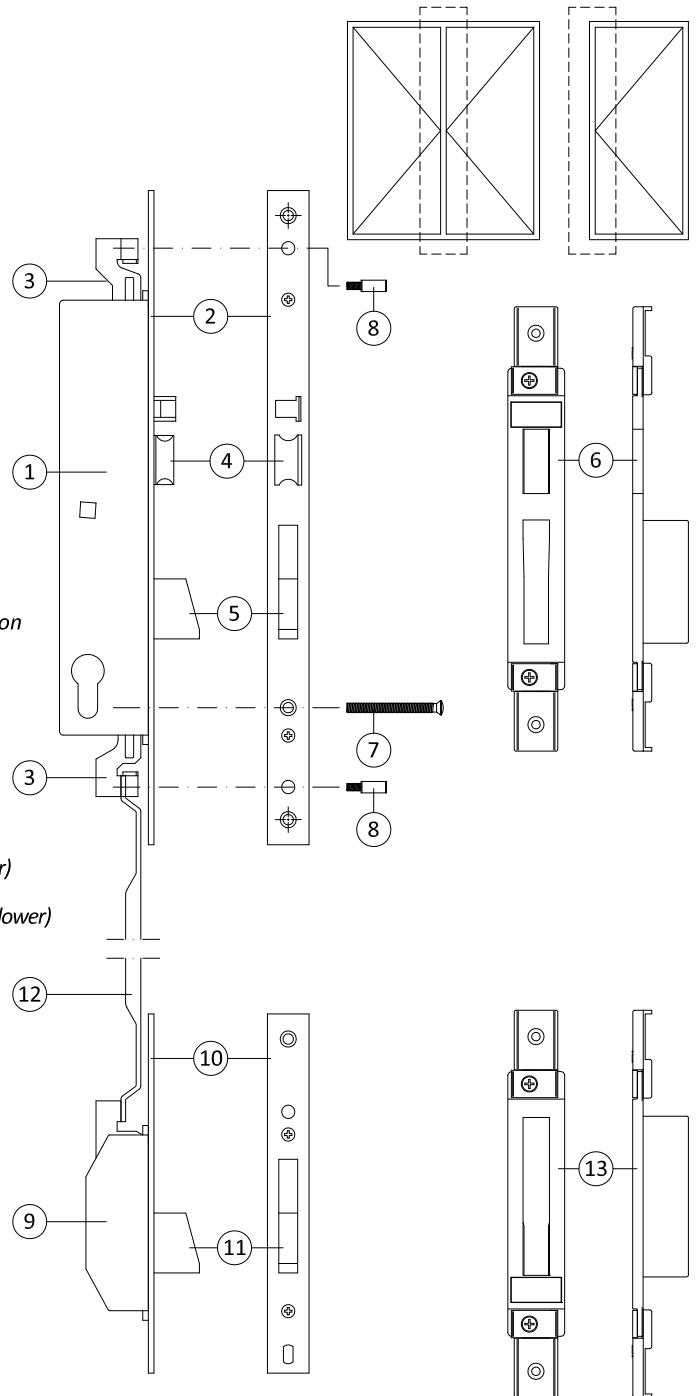
- 9) Deviatori (n°2 pezzi sup + inf.)
- 10) Frontalino (n°2 pezzi sup + inf.)
- 11) Catenaccio (n°2 pezzi sup + inf.)
- 12) Aste inox (n°2 pezzi sup + inf.)
- 13) Incontro (n°2 pezzi sup + inf.)

AC1072

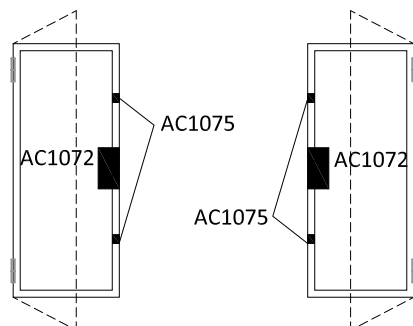
- 1) Lock
- 2) Front plate
- 3) Reduction unit/adaptor for connection
- 4) Spring latch
- 5) Bolt
- 6) Strike plate
- 7) Stainless steel screws TS M5x50
- 8) Pin for anchoring the rod

AC1075

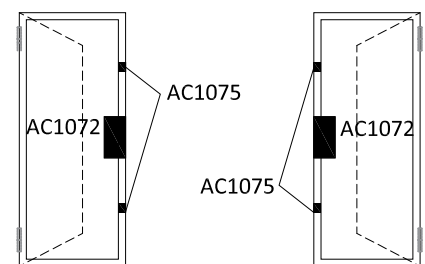
- 9) Diverters (n° 2 items upper + lower)
- 10) Apron lining (n° 2 items upper + lower)
- 11) Bolt (n° 2 items upper + lower)
- 12) Stainless steel rods (n° 2 items upper + lower)
- 13) Plate (no. 2 items upper + lower)



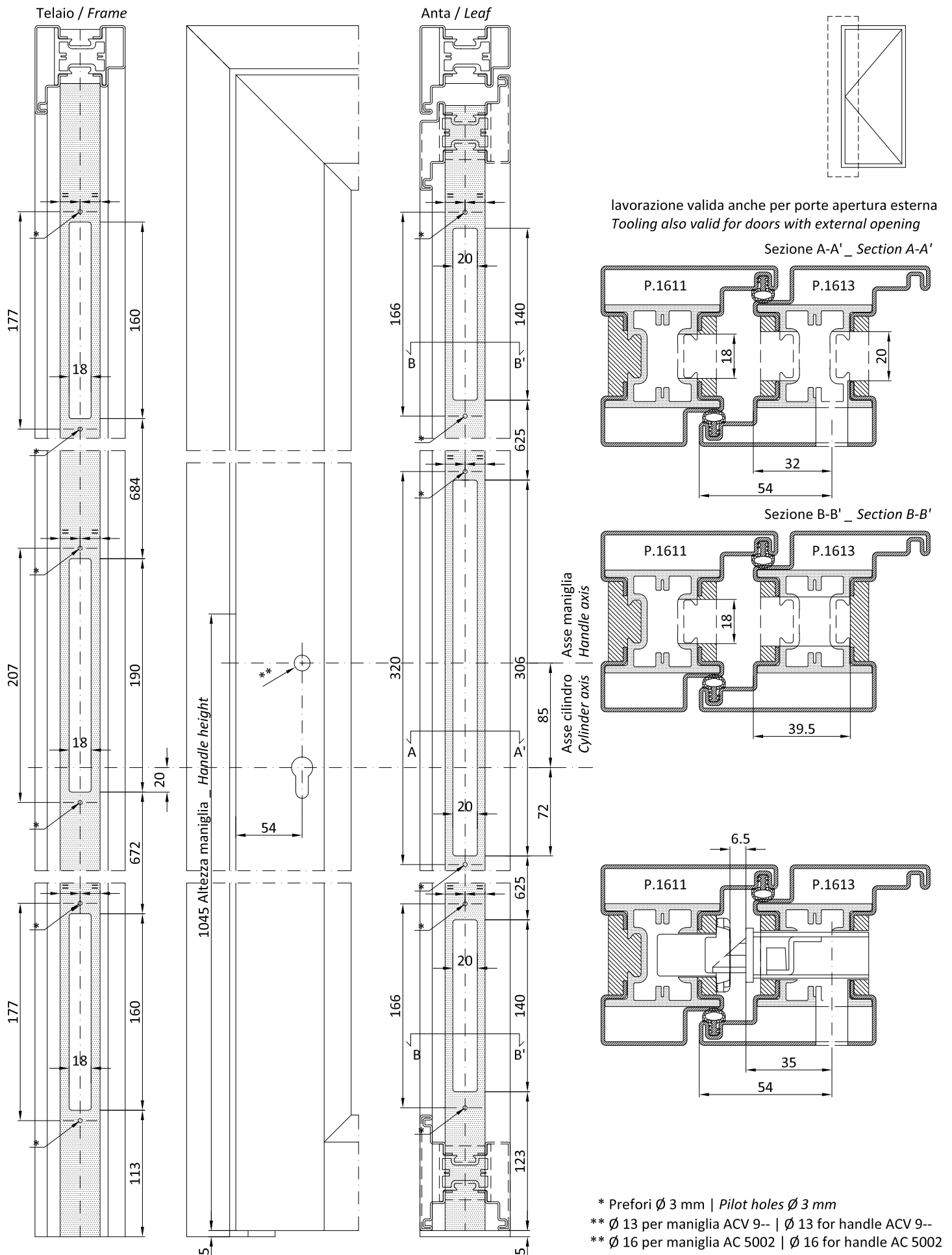
SCHEMA UTILIZZO SERRATURE E TERZE CHIUSURE
DIAGRAM FOR THE USE OF LOCKS AND THIRD LOCKS

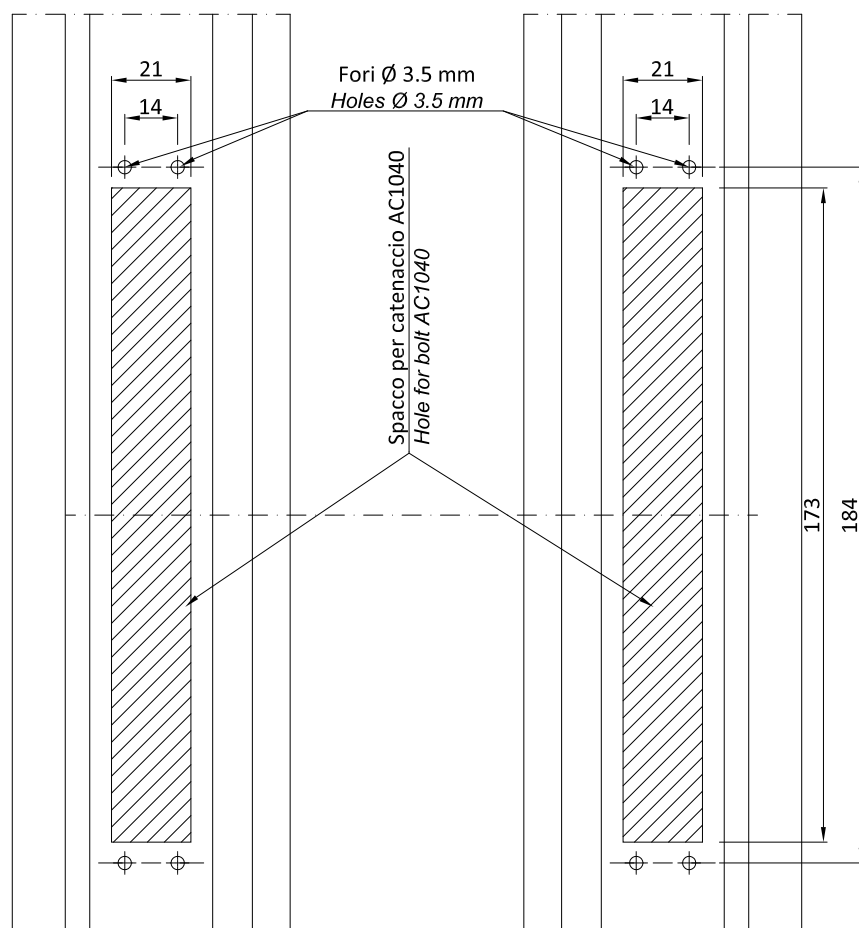
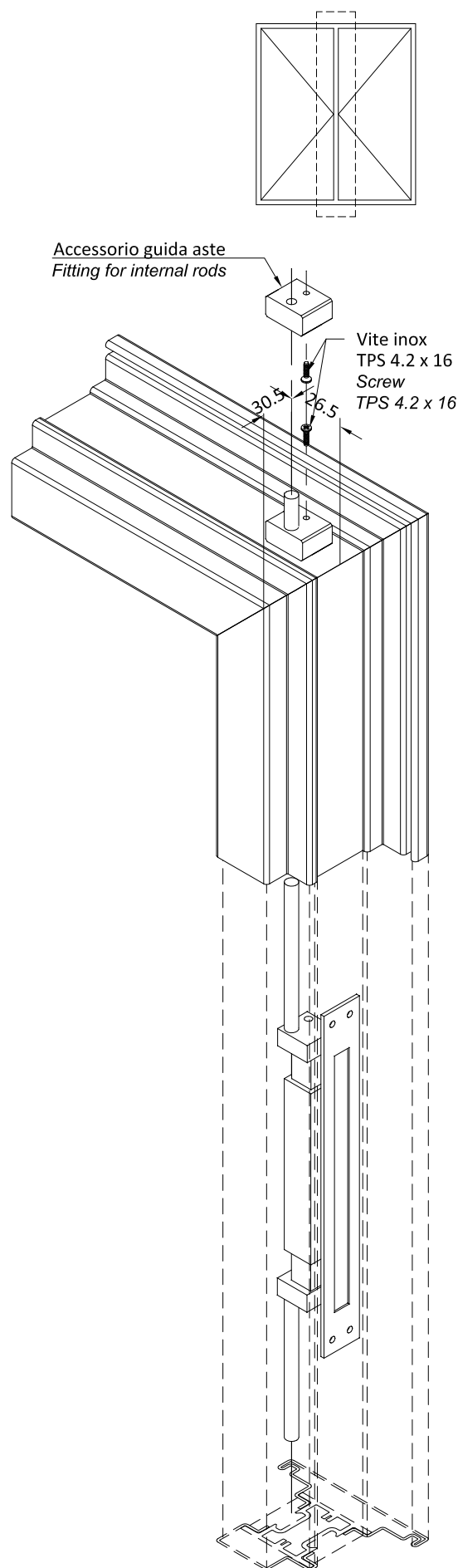
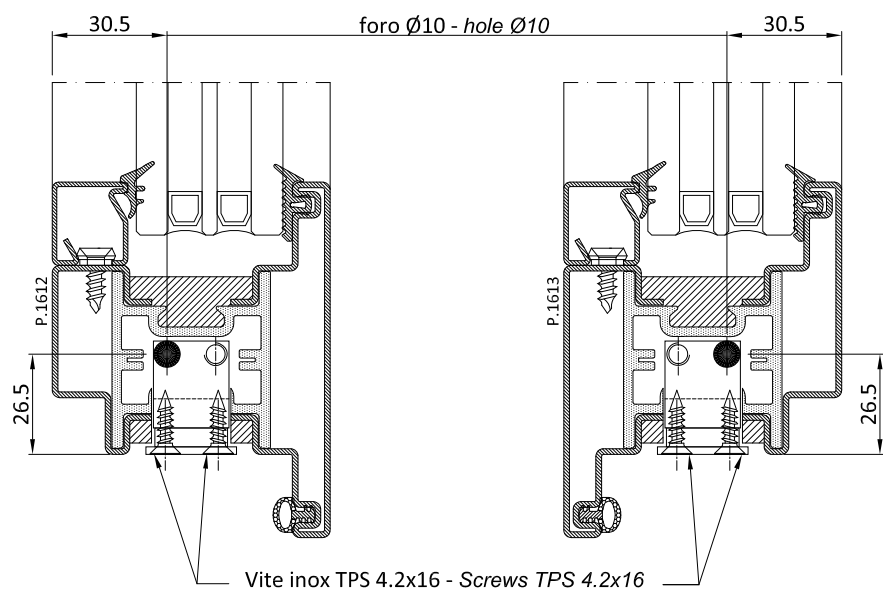


APERTURA INTERNA _ VISTA INTERNA
INWARDS OPENING _ INTERIOR ELEVATION



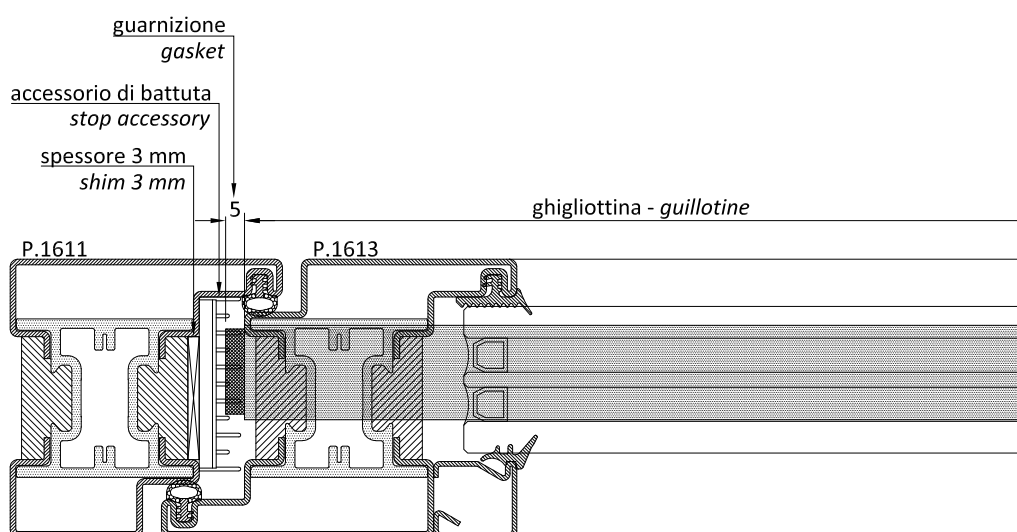
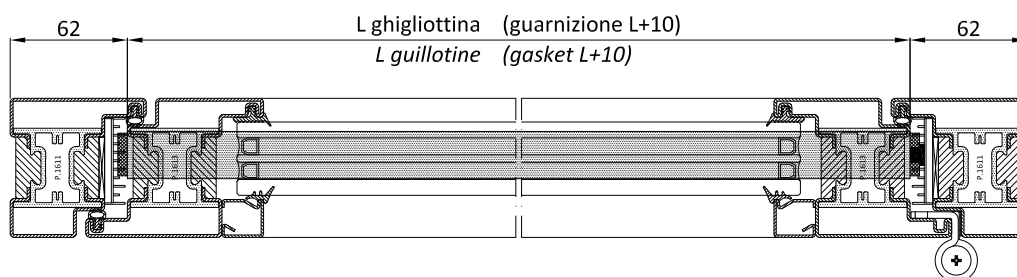
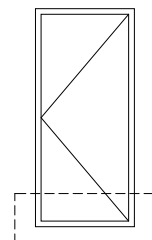
APERTURA ESTERNA _ VISTA INTERNA
OUTWARDS OPENING _ INTERIOR ELEVATION



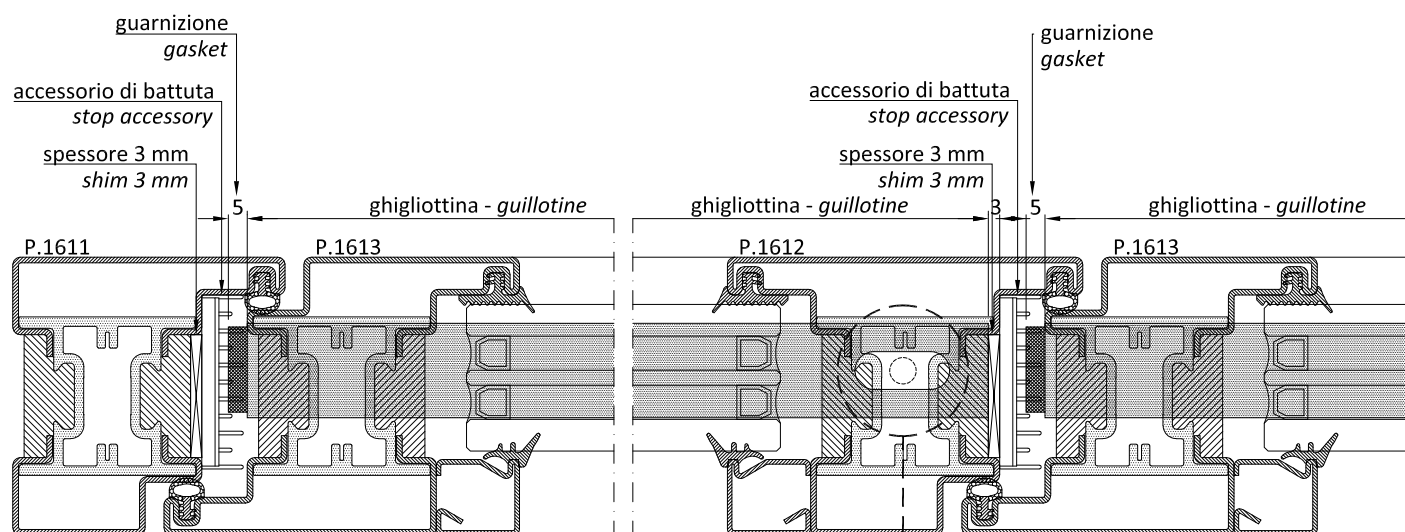
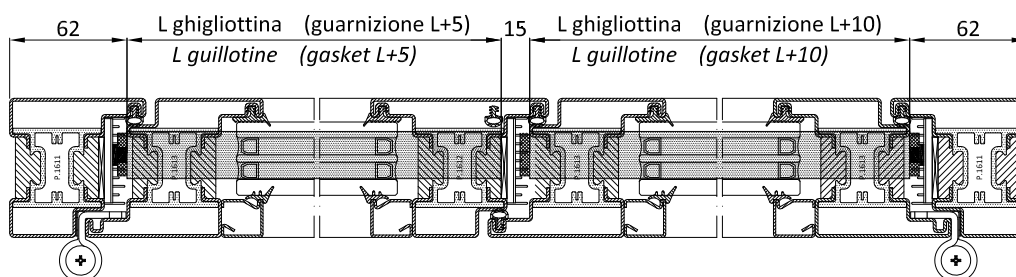
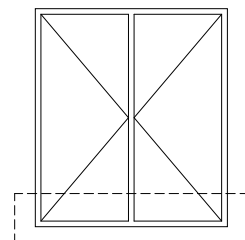


Aste $\varnothing 7$ mm L. mm 1500
 $\varnothing 7$ mm L. mm 1500 rods

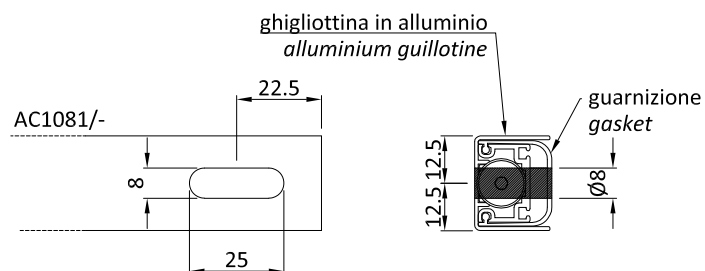
cod.	dimensioni dimensions [mm]
AC1081/A	615 → 730
AC1081/B	715 → 830
AC1081/C	815 → 930
AC1081/D	915 → 1030
AC1081/E	1015 → 1130
AC1081/F	1115 → 1230

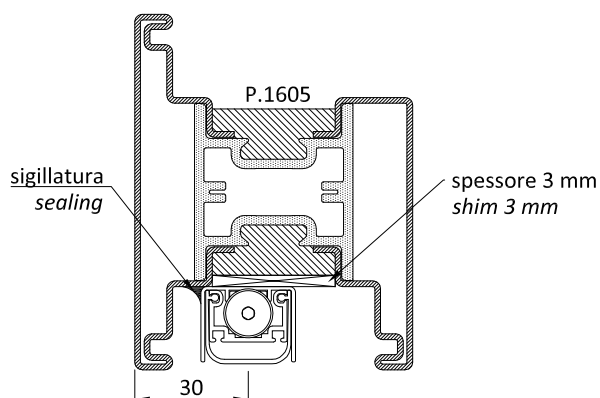
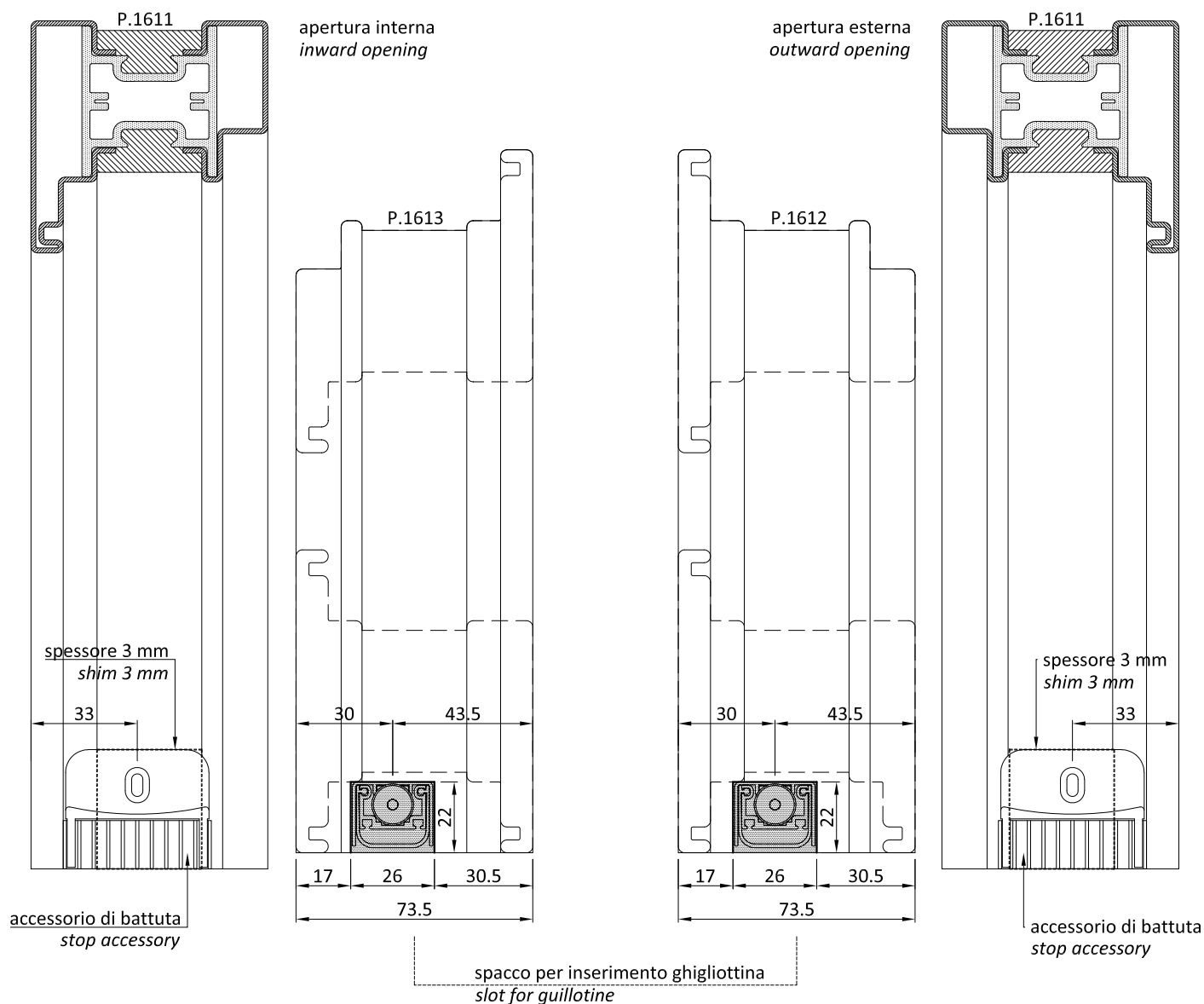
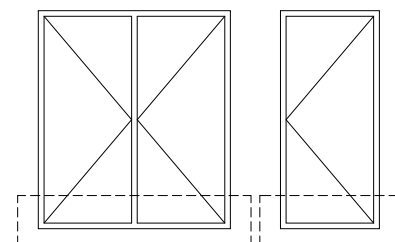


cod.	dimensioni dimensions [mm]
AC1081/A	615 → 730
AC1081/B	715 → 830
AC1081/C	815 → 930
AC1081/D	915 → 1030
AC1081/E	1015 → 1130
AC1081/F	1115 → 1230

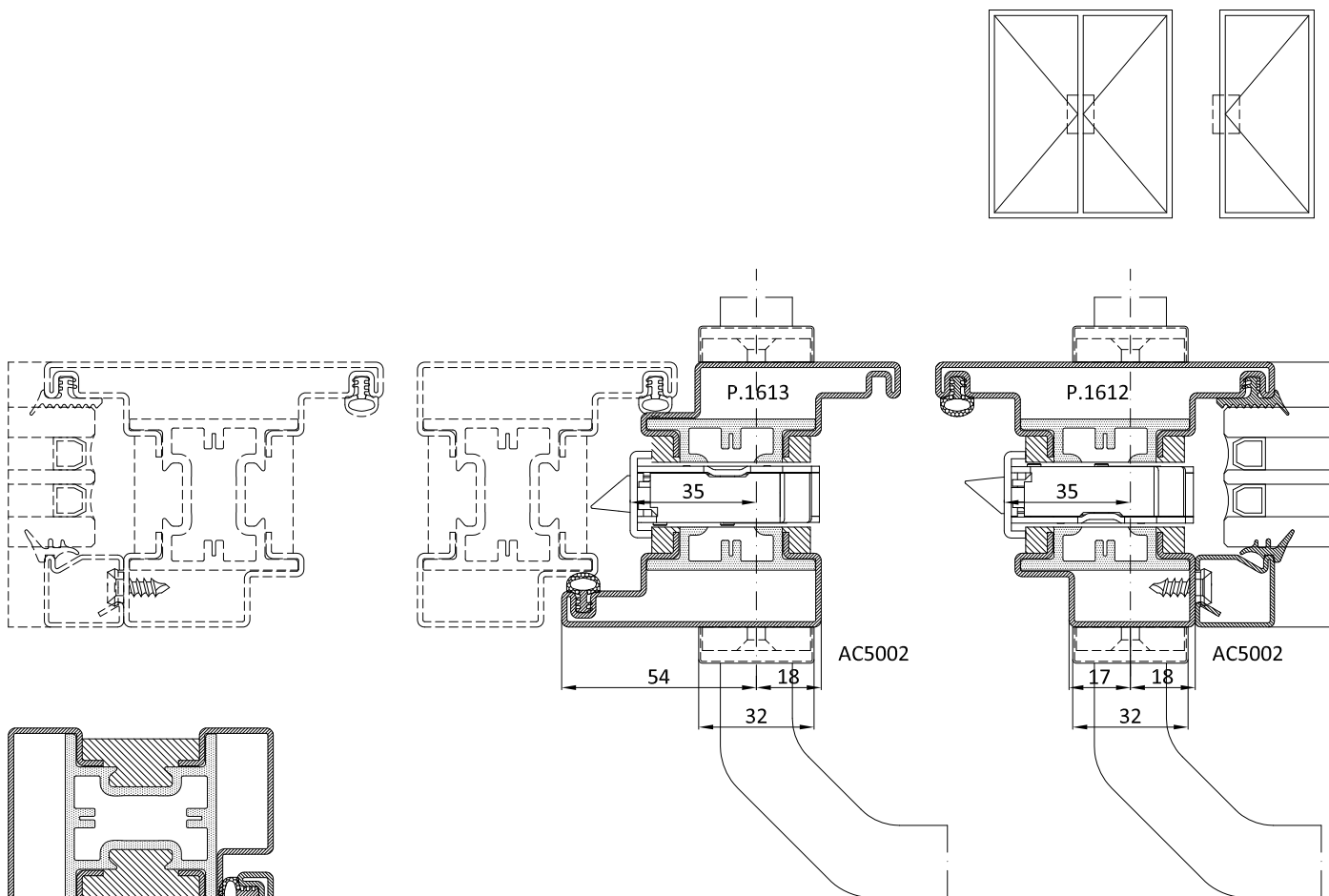


Lavorazione per porta a due ante con AC1040
Working for two leaf door with AC1040





viti in dotazione
supplied screws

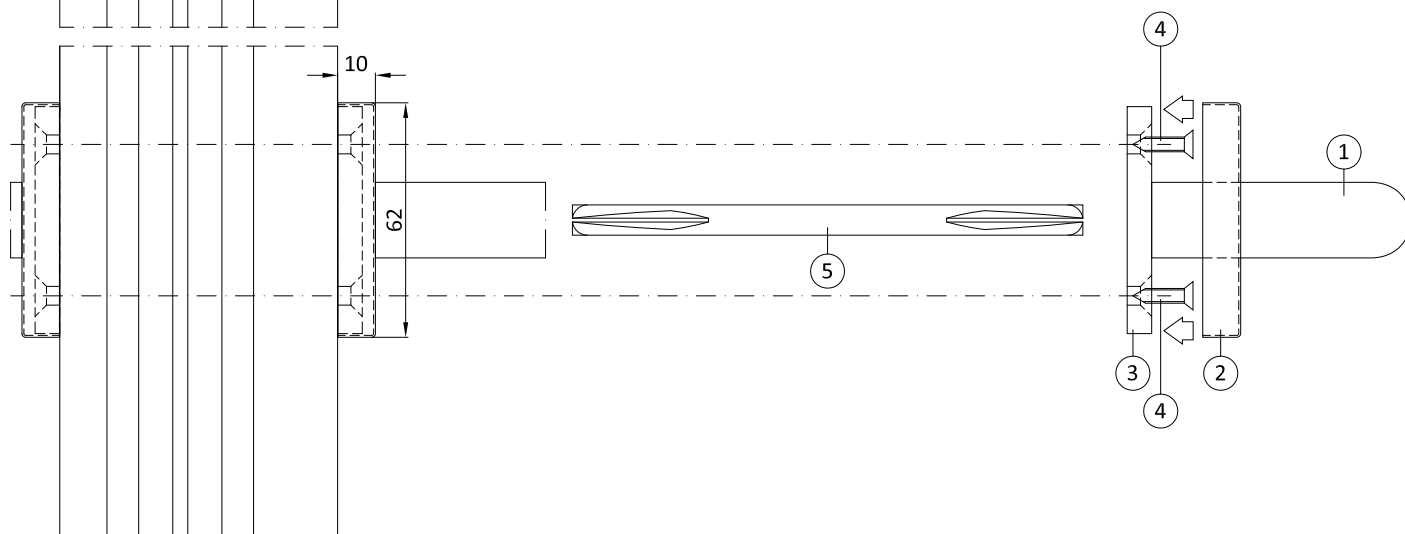


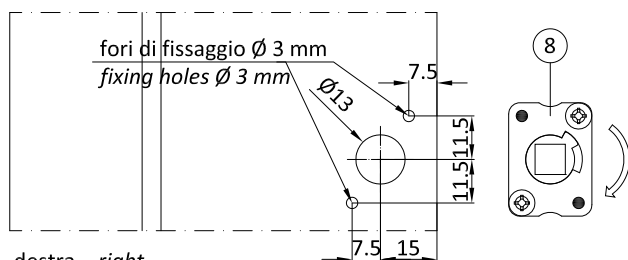
AC5002 :

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

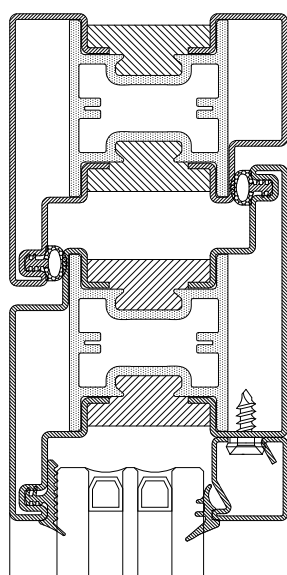
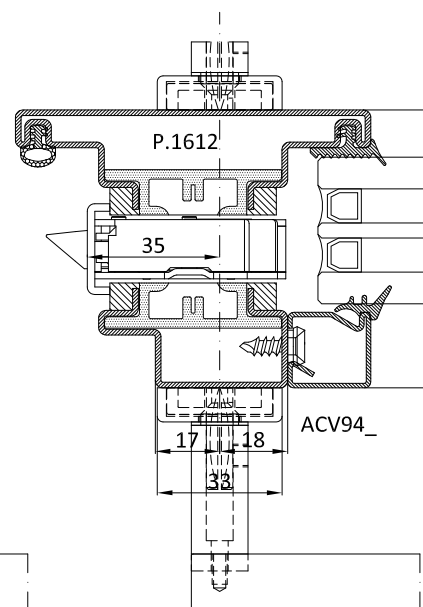
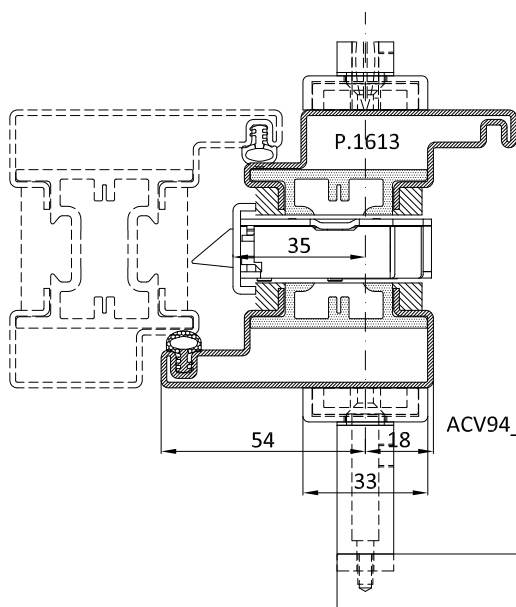
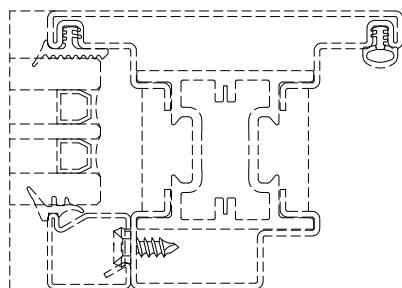
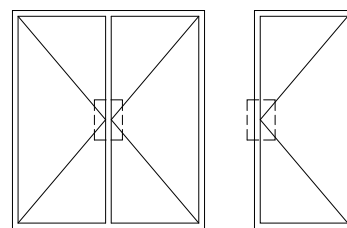
AC5002 :

- 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

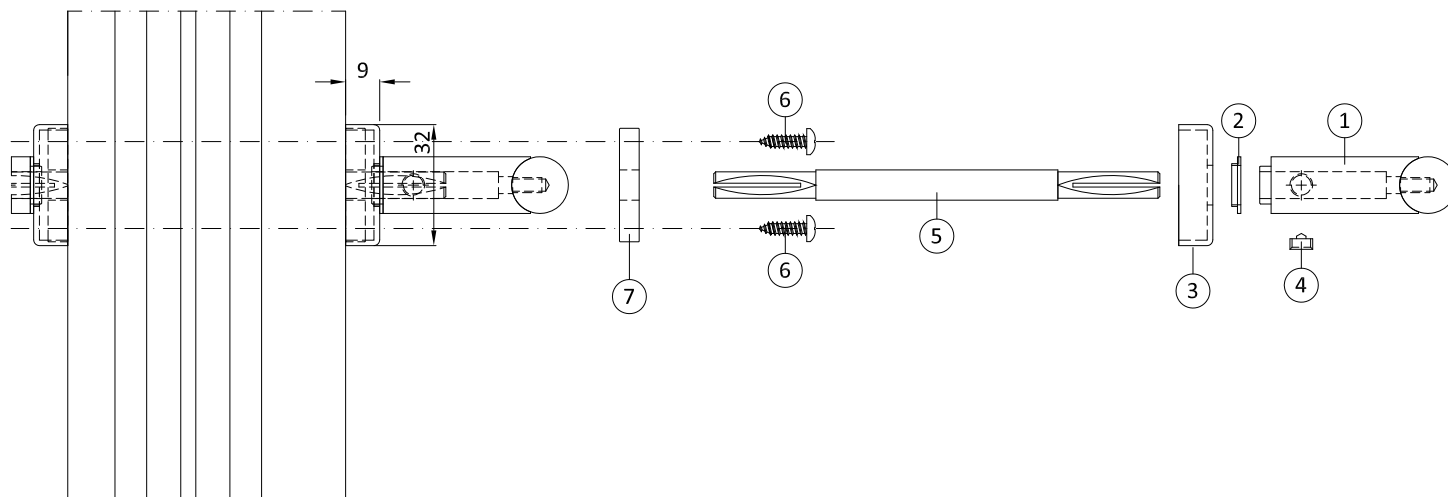


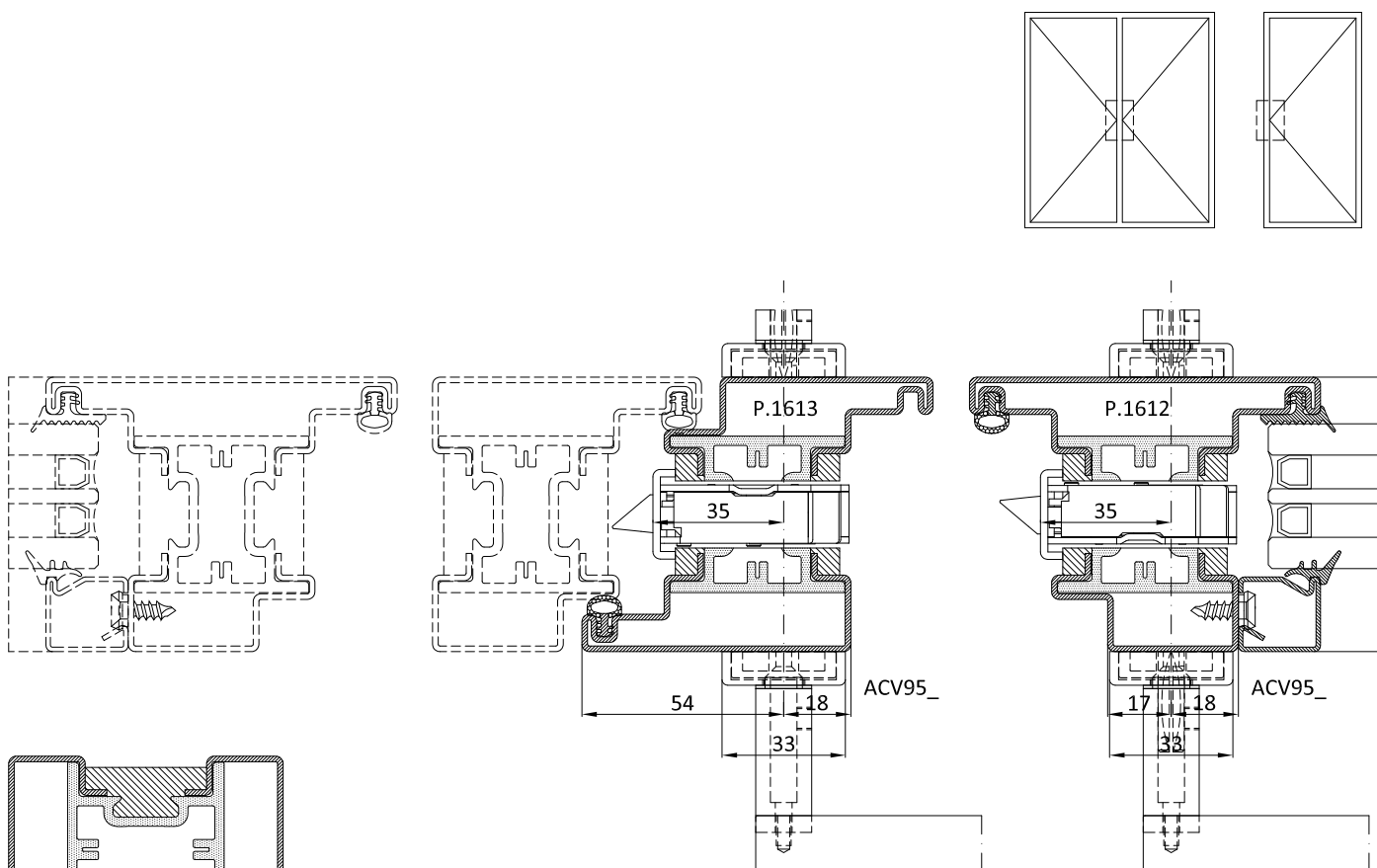
ACV94- :

- 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



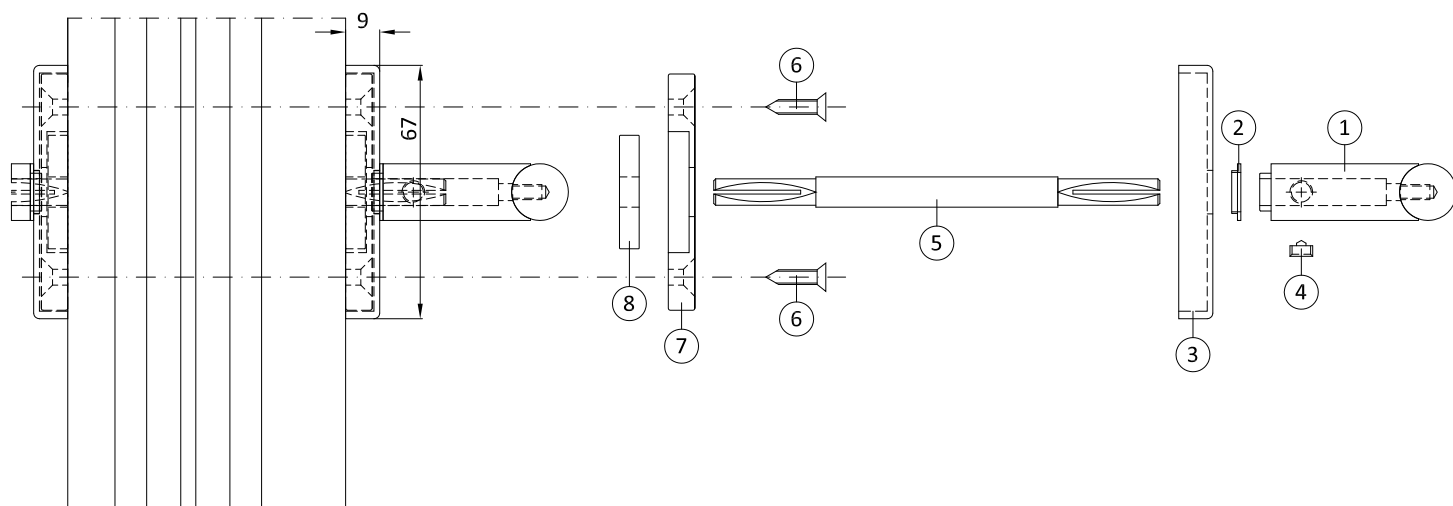


ACV95- :

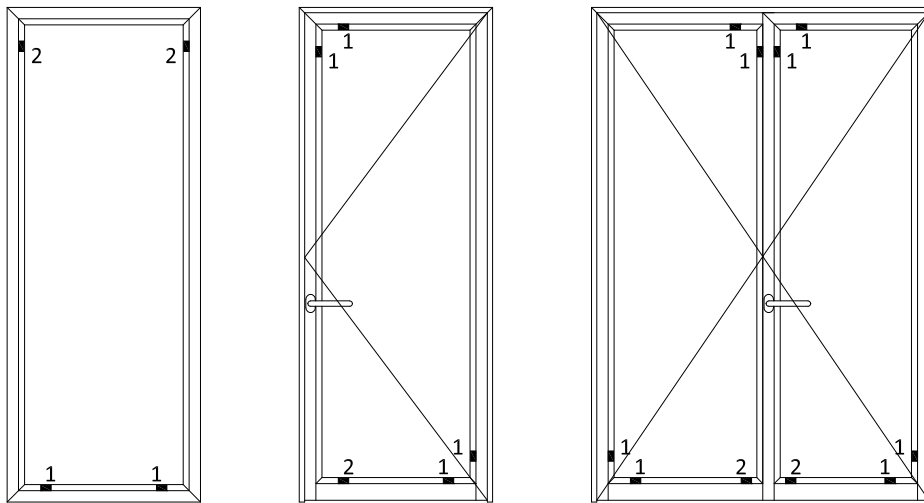
- 1) Impugnatura
- 2) Rondella
- 3) Rosetta
- 4) Grano M6x6
- 5) Quadro
- 6) Vite TPS 3.9x15.9
- 7) Adattatore per molla
- 8) Molla

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

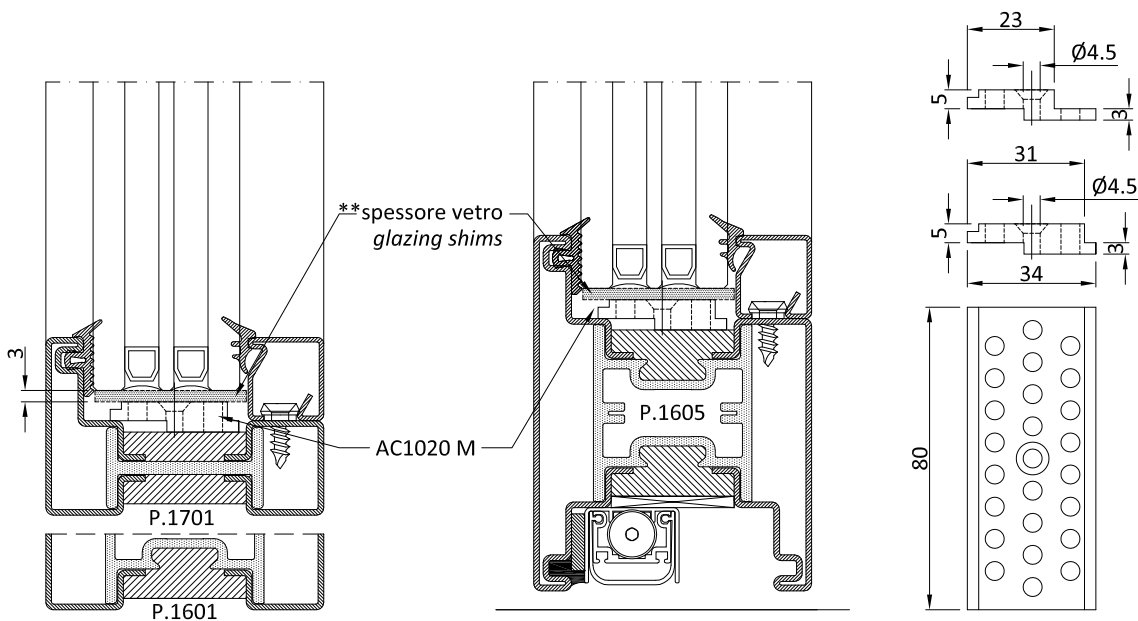


Porta | Door



1) spessore portante | *carry shim*

2) spessore distanziatore | *compensation shim*

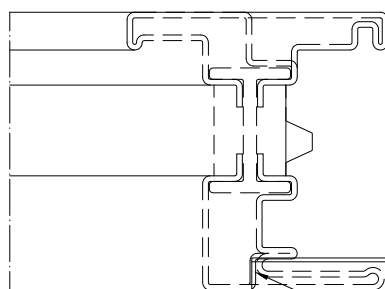
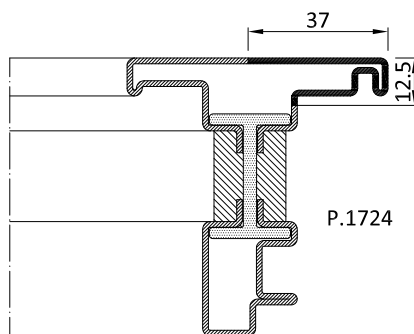
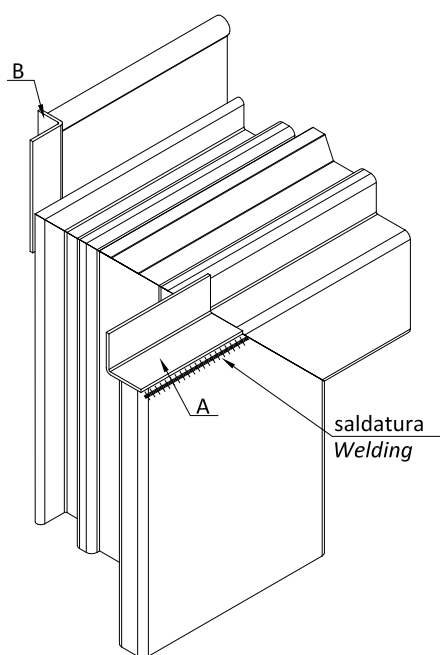
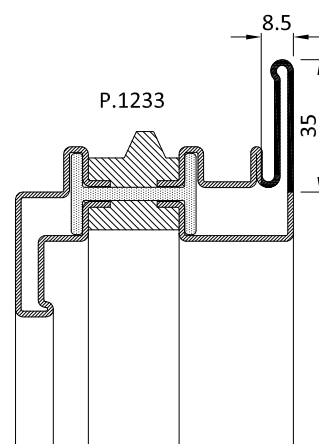
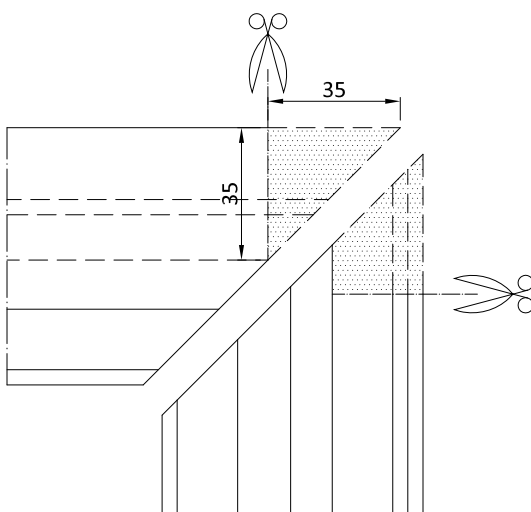
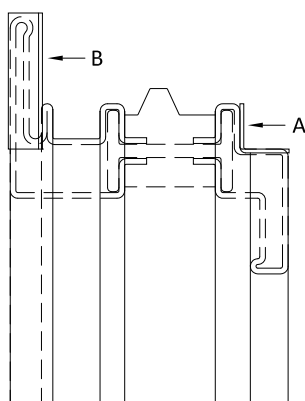
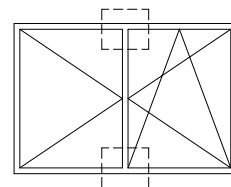
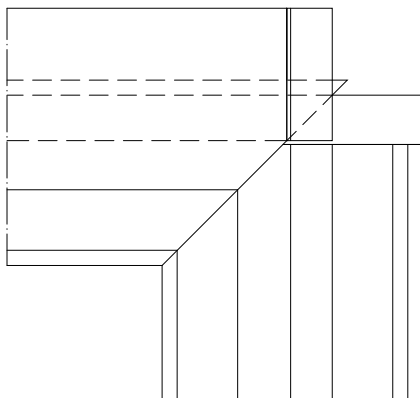
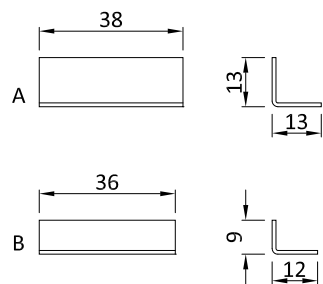


* verticalmente fissare supporto
spessore vetro AC 1020M-R
con vite TSP 4.2x16
* fix glass spacer AC 1020M-R
vertically with screw TSP 4.2x16

Note / Note

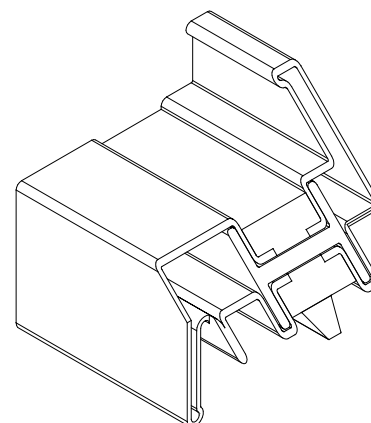
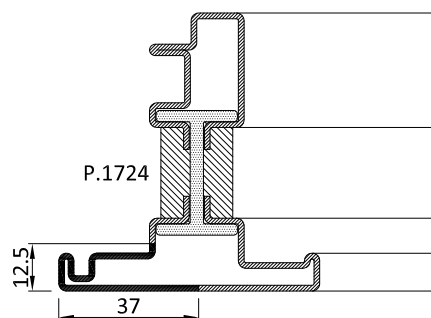
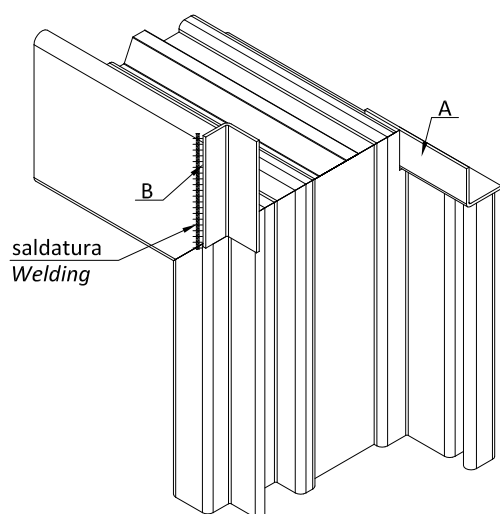
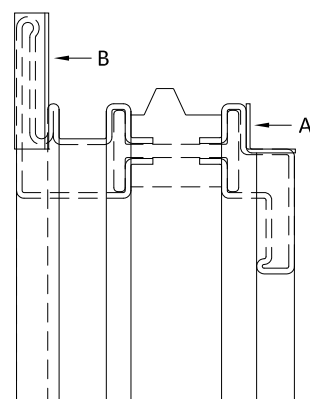
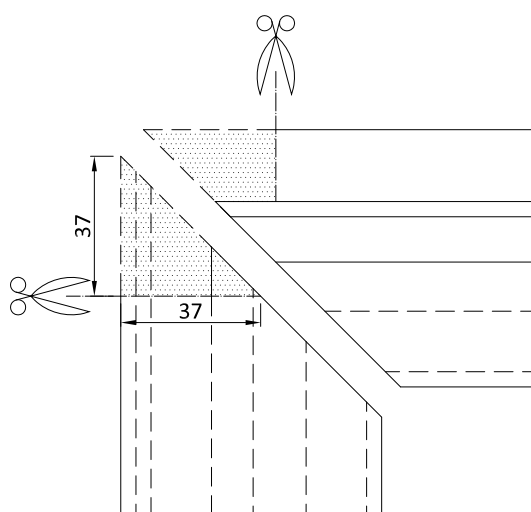
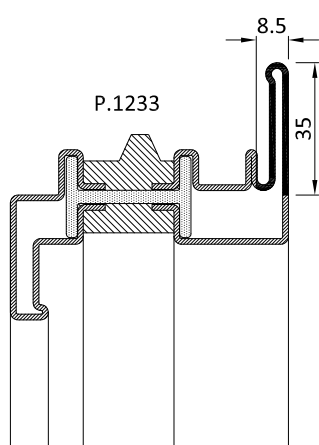
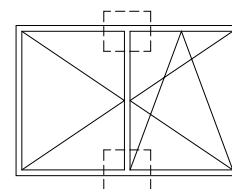
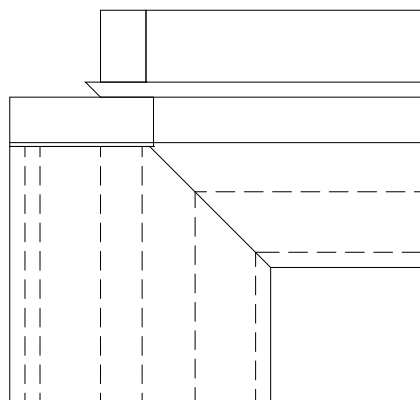
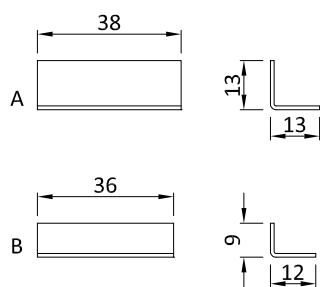
- La larghezza degli spessori è almeno pari o maggiore (+2 mm) dello spessore del vetro installato.
- La posizione degli spessori deve essere garantita dall'utilizzo di materiale adeguato che ne eviti lo spostamento.
- The shims' width is the same or greater (+2 mm) than the thickness of the glass installed.
- 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



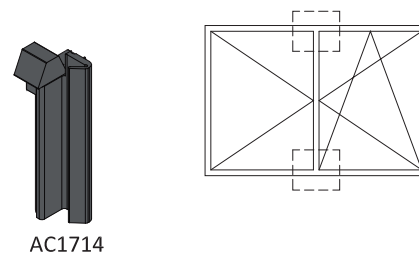
porzione da rifilare e saldare dopo
l'assieme dell'angolo
area to cut and weld after the corner joint

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.

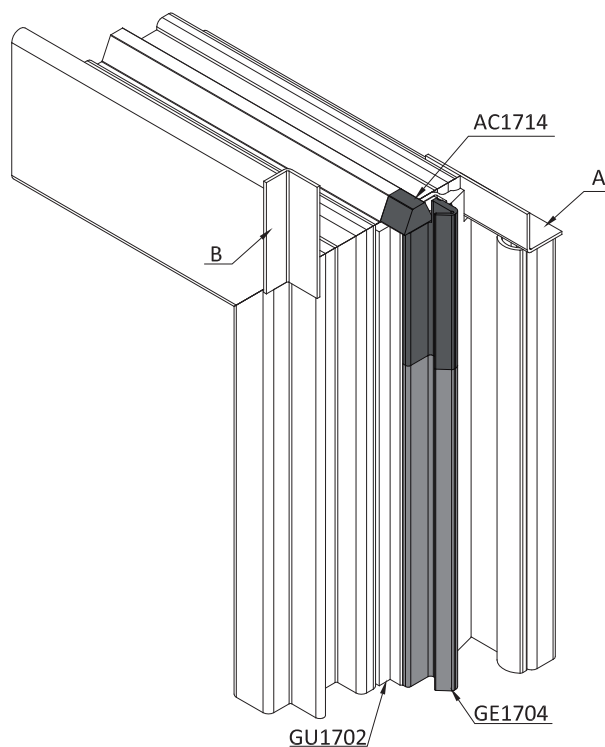
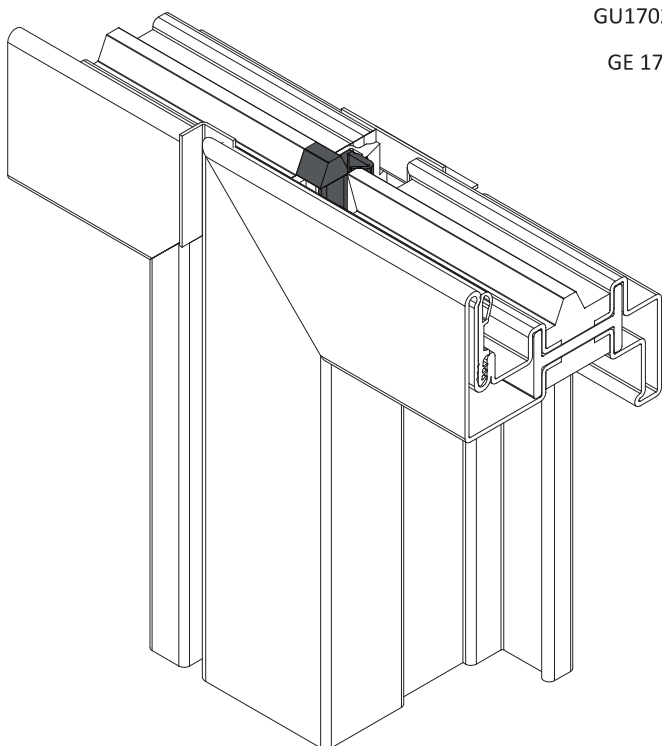
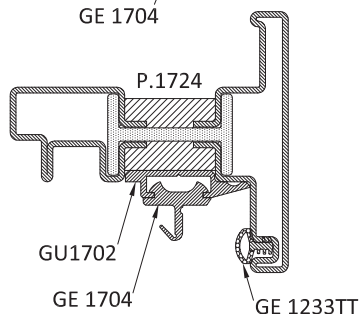
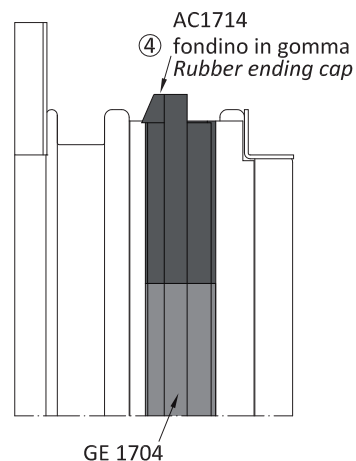
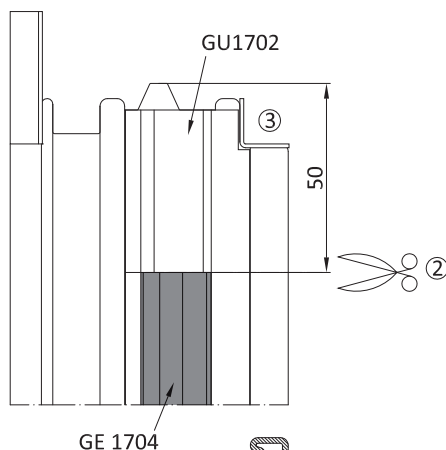
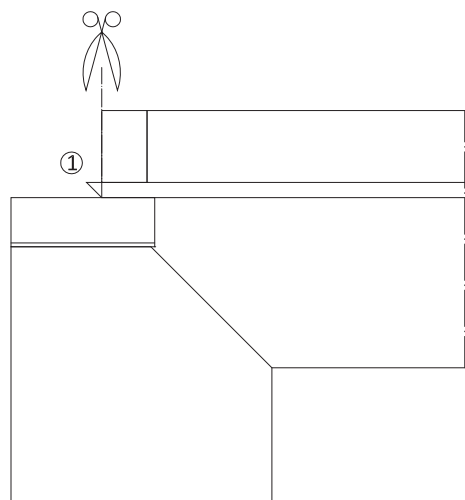


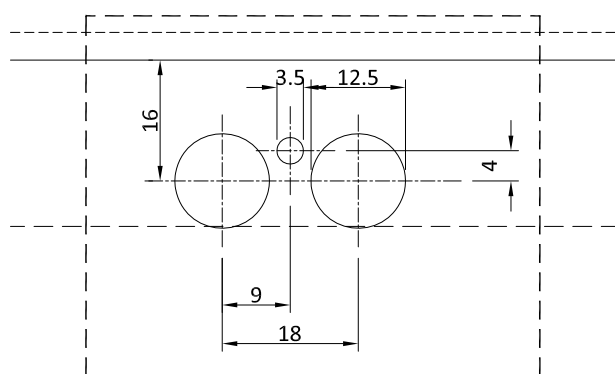
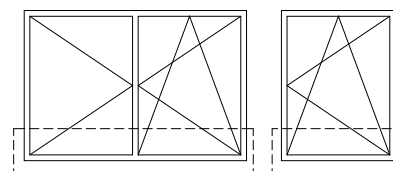
Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura.
Note: the ending caps for T-Z joint are furnished in larger dimensions and should be trimmed down after welding.

- 1) Asportare il poliammide.
1) Remove the polyamide.
- 2) Tagliare la guarnizione GE1704 a 50 mm. dal filo esterno del poliamide.
2) Cut the gasket GE1704 at 50 mm from the end thread of polyamide.
- 3) Asportare la parte dell'estruso GU1702 che interferisce con il fondino A.
3) Remove the part of the extrudate GU1702 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

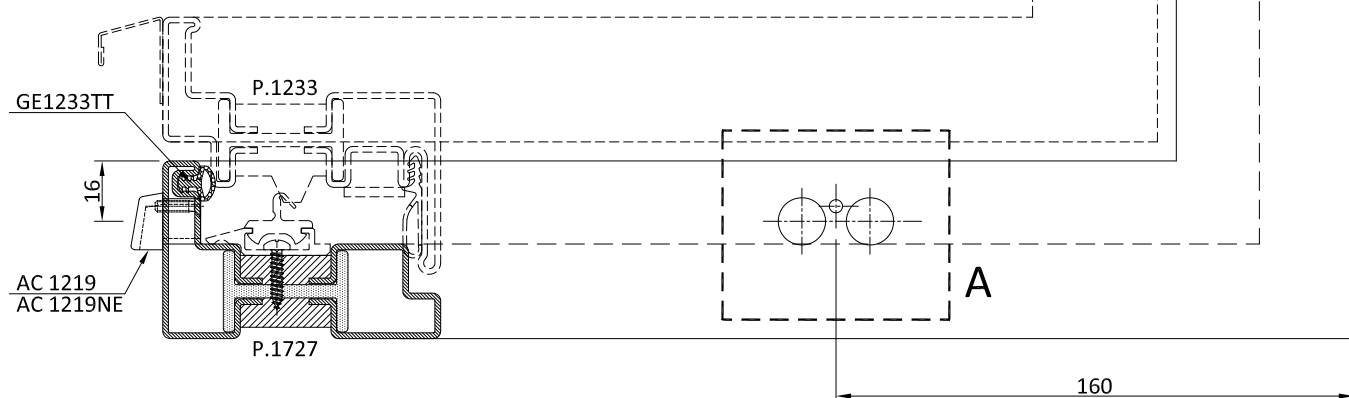


AC1714

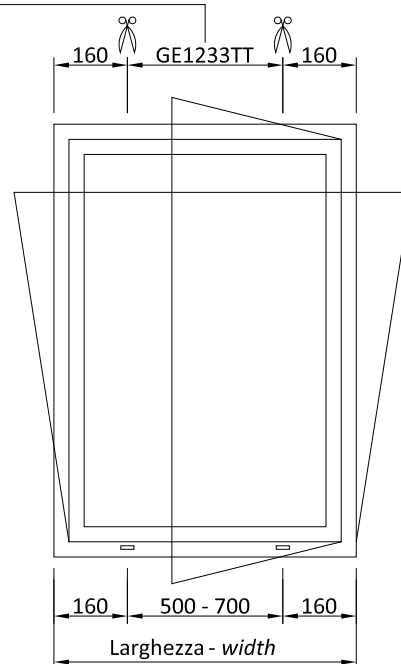
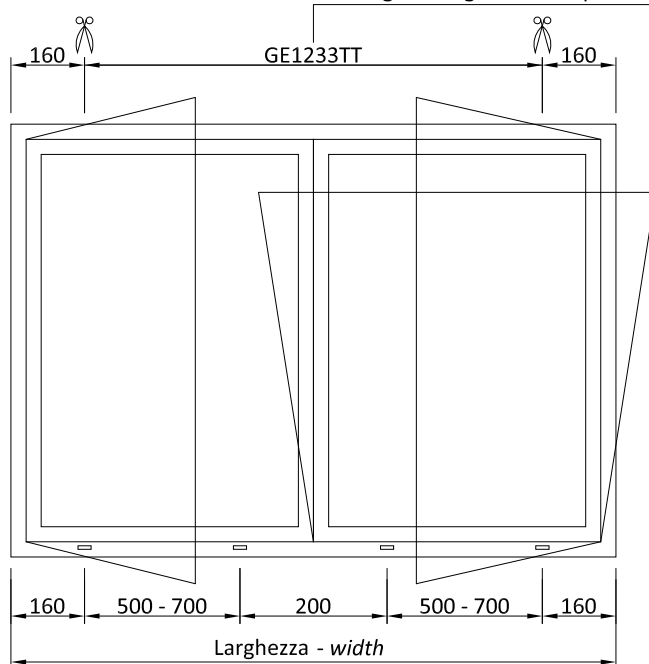




Particolare A - Detail "A"

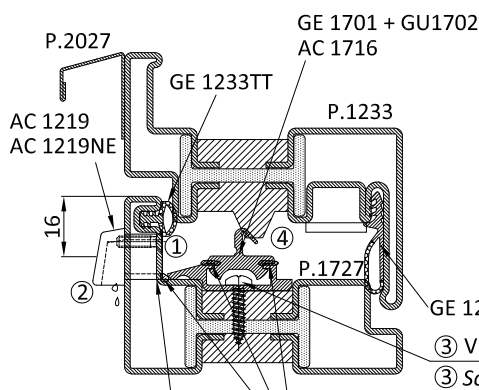
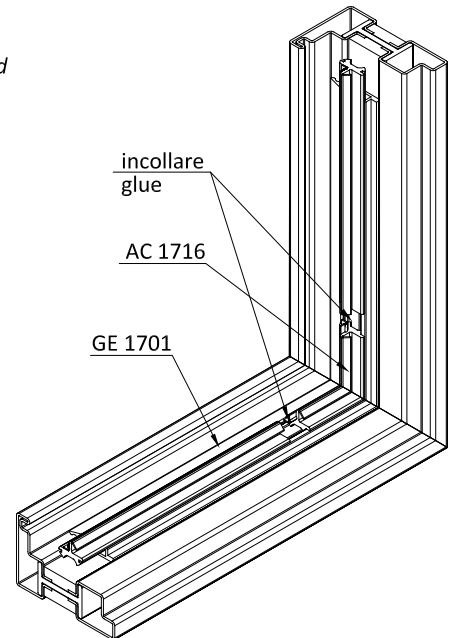
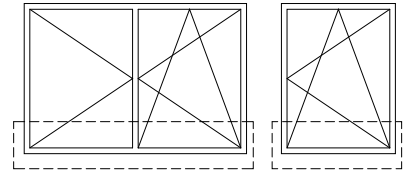


Tagliare la guarnizione per 20 mm | Cut the gasket to 20 mm



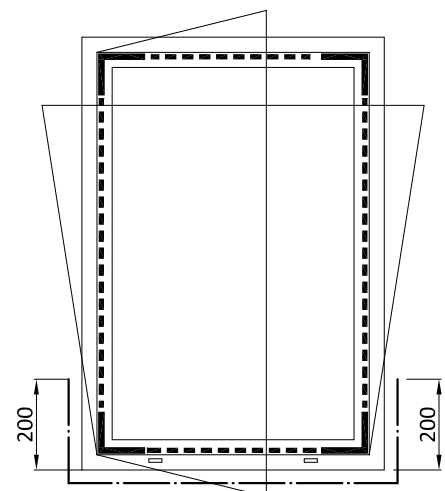
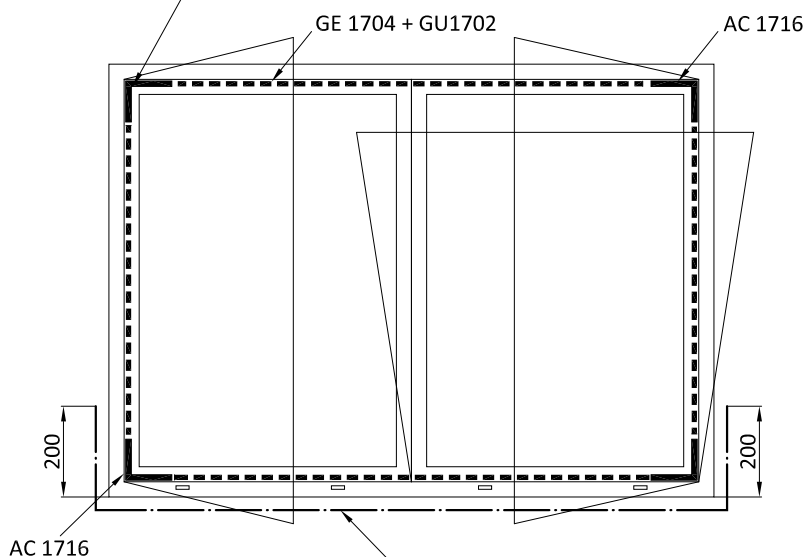
- 1) Eseguire i fori come da disegno .
- 2) Posizionare lo scarico acqua e sigillare fissare con viti in dotazione M3x12.
- 3) Posizionare il supporto della guarnizione di giunto GU1702 e fissarlo con vite TC 3.5x13 (non fornita).
- 4) Sigillare la guarnizione di giunto GE1701 con il supporto GU1702 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.

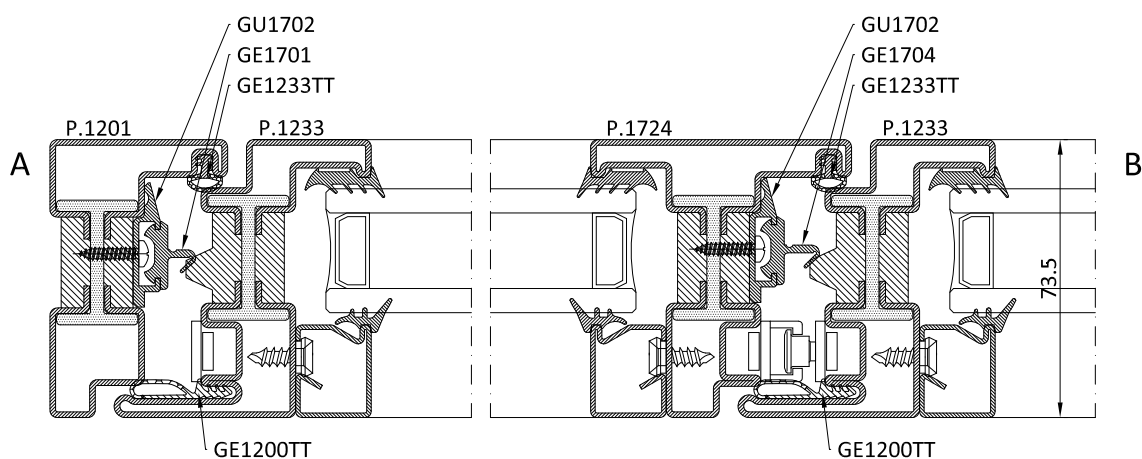
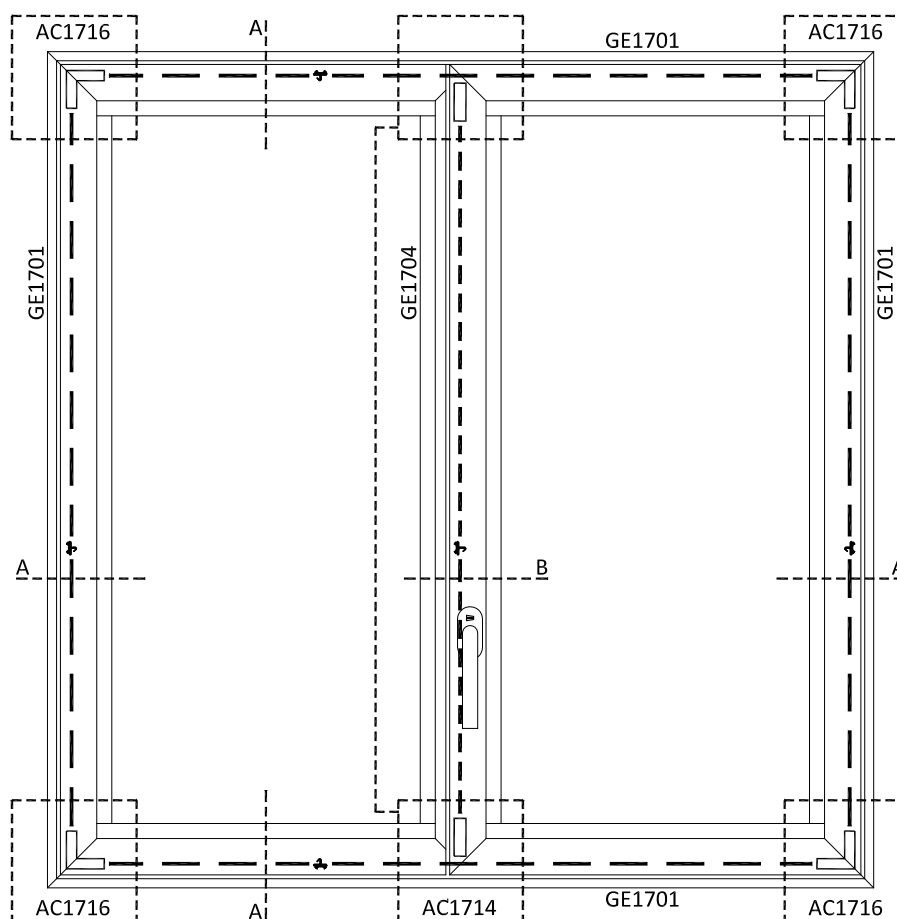
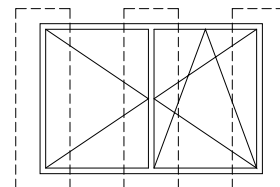


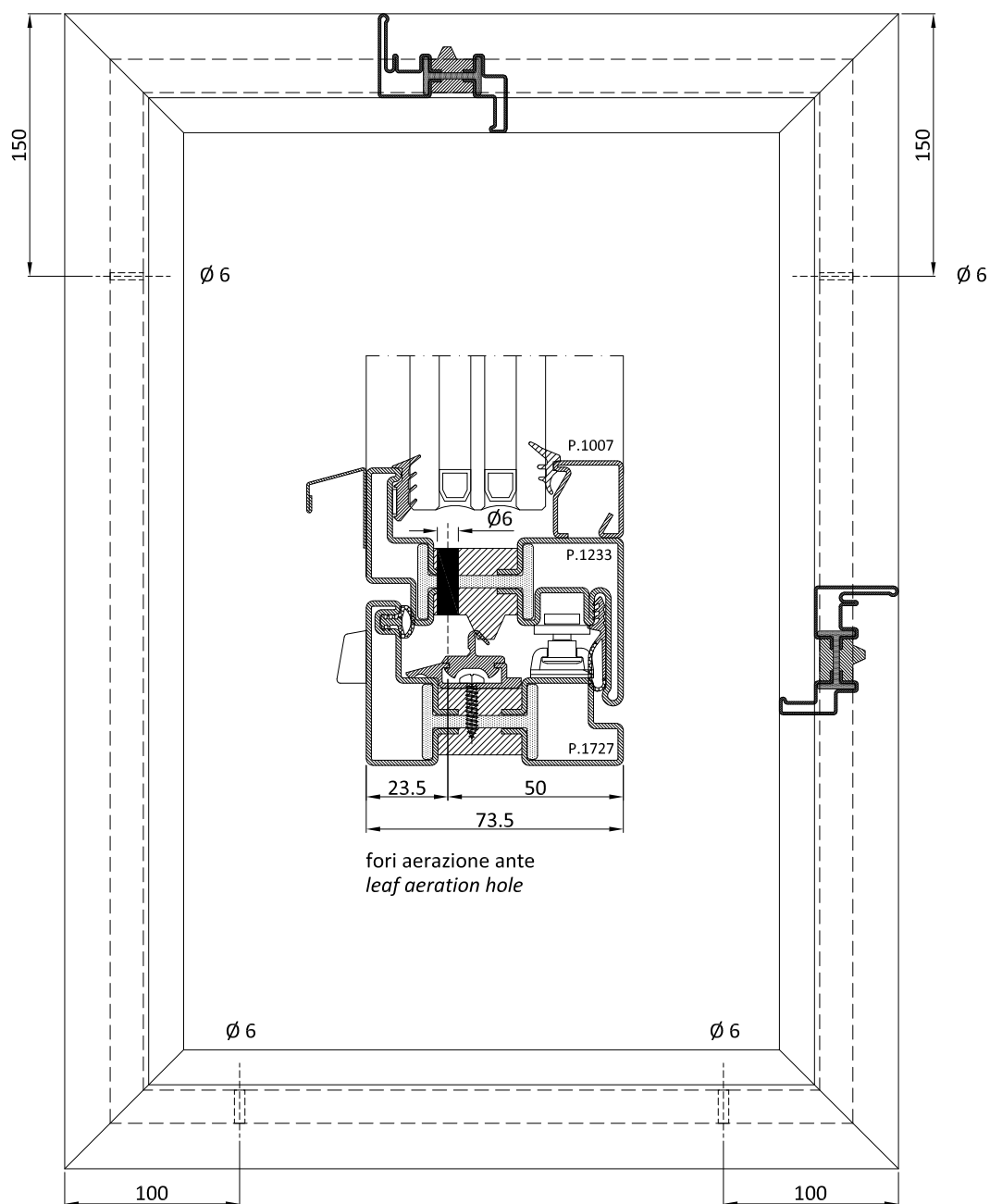
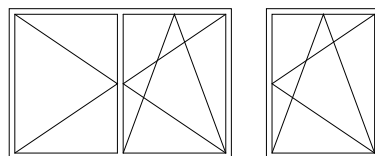
- ③ Vite TC 3.5x13 (non fornita)
③ Screw TC 3.5x13 (not provided)
- ④ sigillare per tutta la lunghezza la base inferiore e per 200 mm in altezza il telaio.
④ Seal the lower frame for its whole length and for 200 mm vertically.
- sigillare il perimetro dello scarico acqua
seal the perimeter of water drip

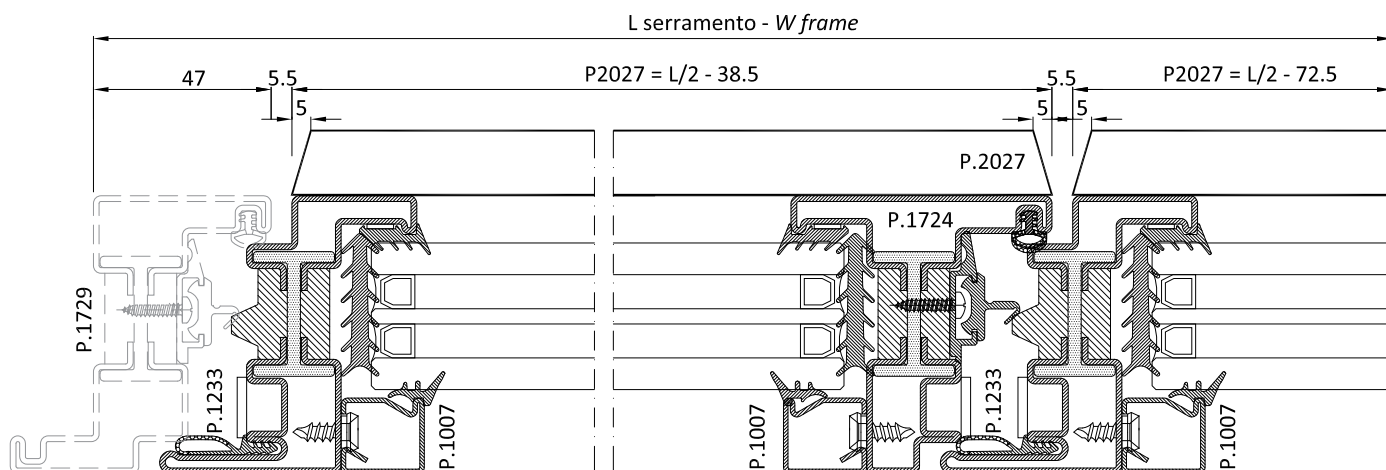
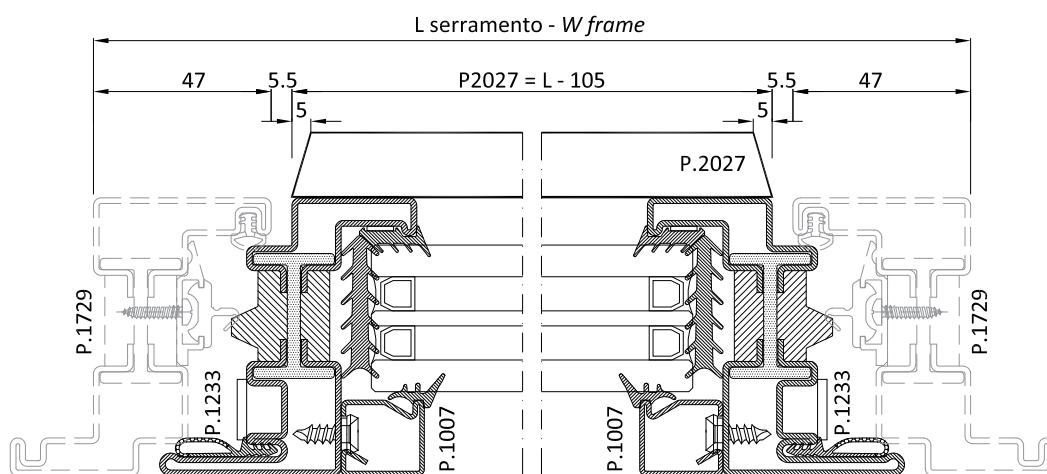
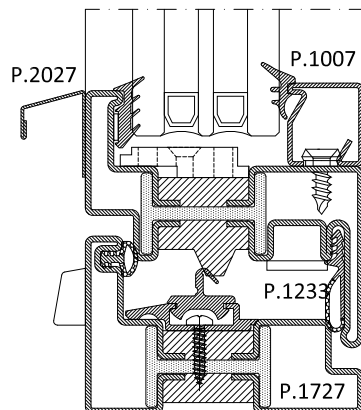
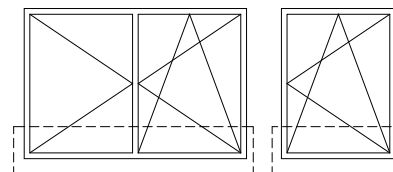
incollare gli angoli vulcanizzati AC1716 alla guarnizione con colla cianoacrilica
Glue the vulcanised corner AC1716 to the gasket using cyanoacrylate glue

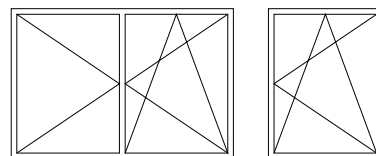


- ④ sigillare per tutta la lunghezza la base inferiore e per 200 mm in altezza il telaio.
④ Seal the lower frame for its whole length and for 200 mm vertically.



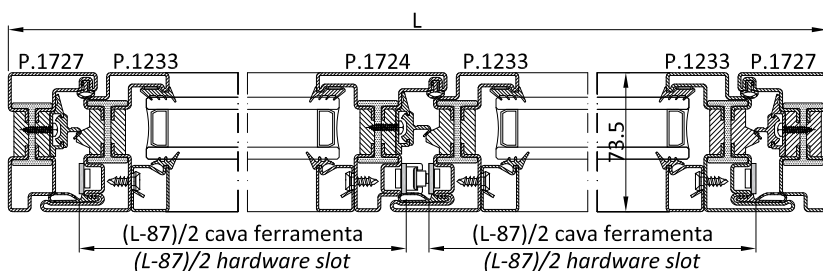
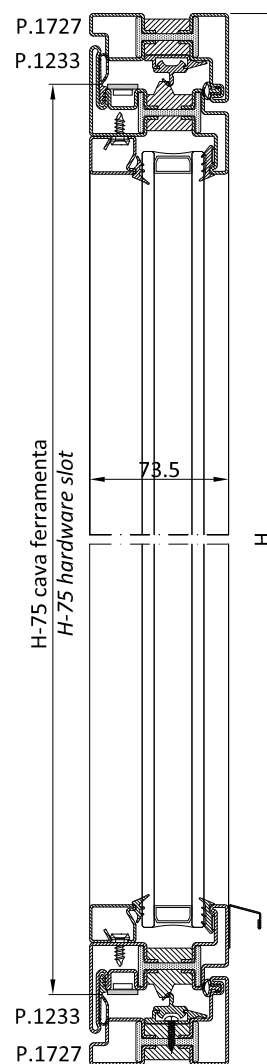
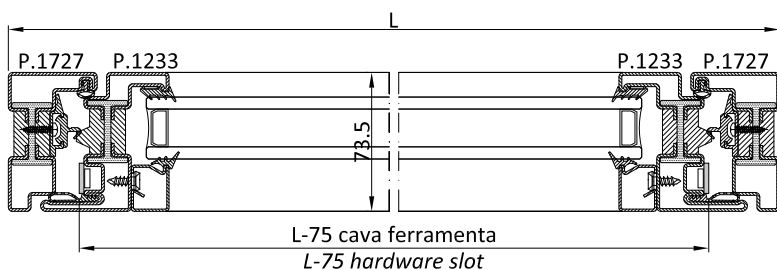


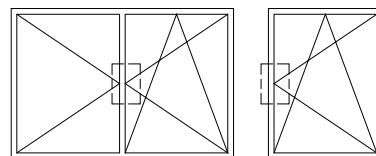




Standard		H altezza - Height								
		661 860	861 1000	1001 1200	1201 1400	1401 1600	1601 1800	1801 2000	2001 2200	2201 2400
L W larghezza width	601-800	A1	B1	C1	D1	E1	F1	G1	H1	I1
	801-1000	-	B2	C2	D2	E2	F2	G2	H2	I2
	1001-1200	-	-	C3	D3	E3	F3	G3	H3	I3
	1201-1400	-	-	-	D4	E4	-	-	-	-

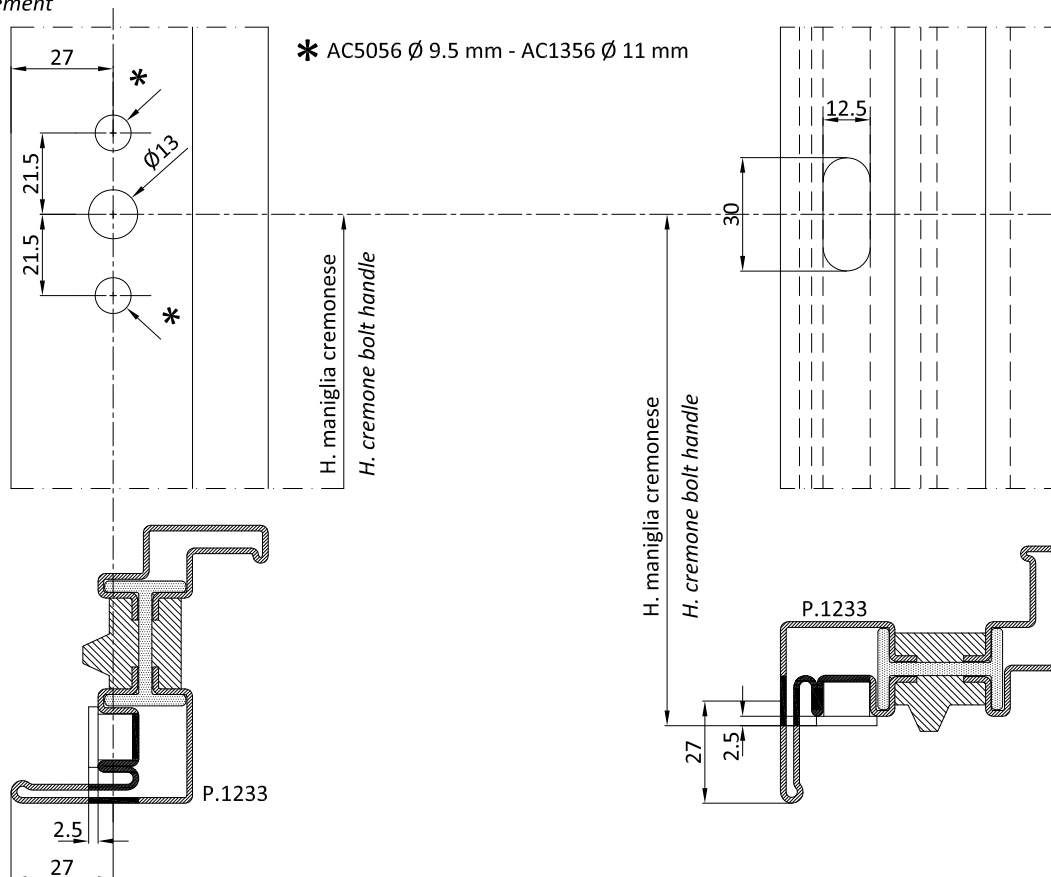
AGE281-2 130 kg Easy
AGE785-6 130 kg Easy



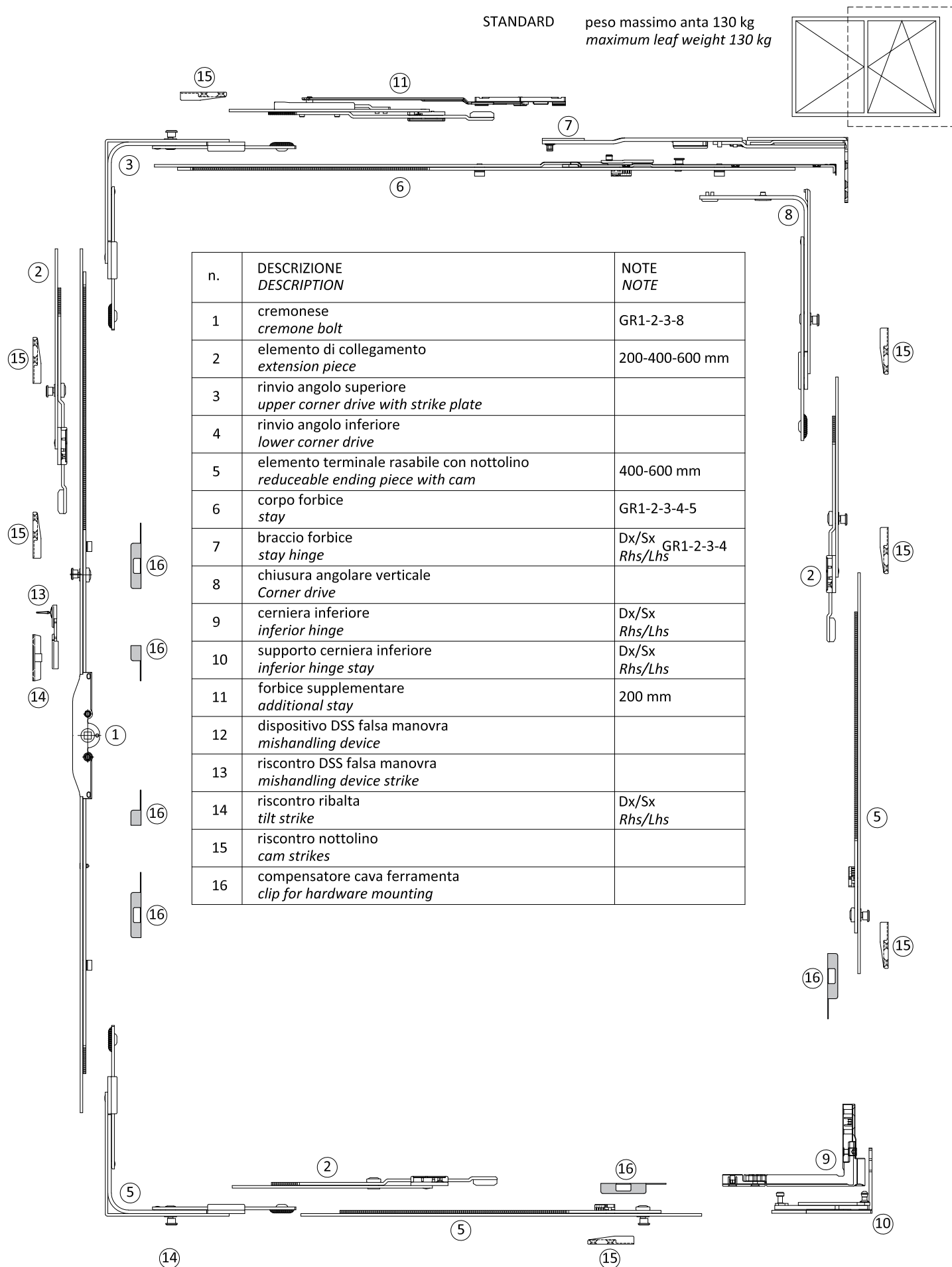


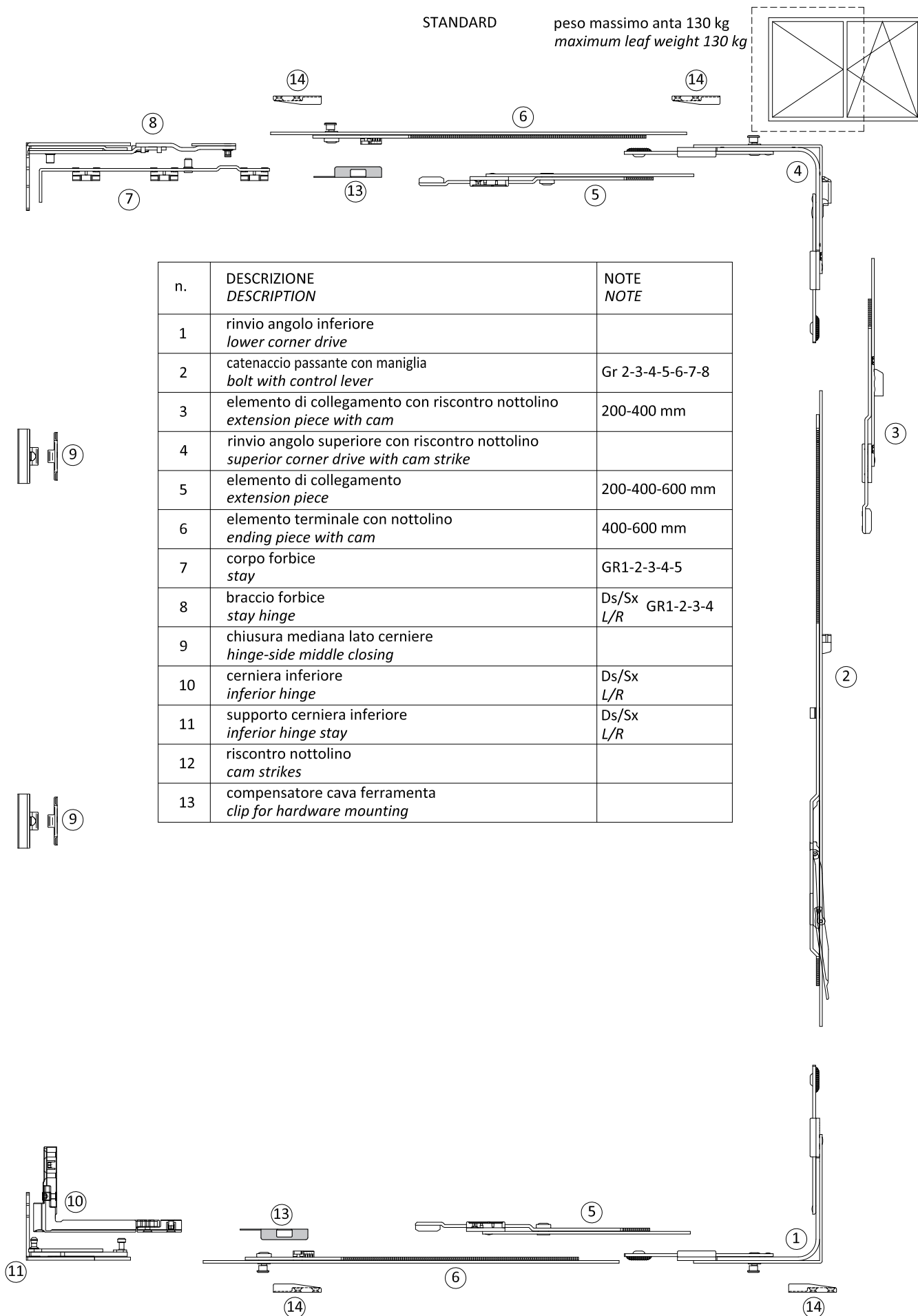
Fori per inserimento quadro comando
e fissaggio maniglia / movimento DK
*Holes for inserting control panel and
anchoring of handle / TT (tilt and turn)
movement*

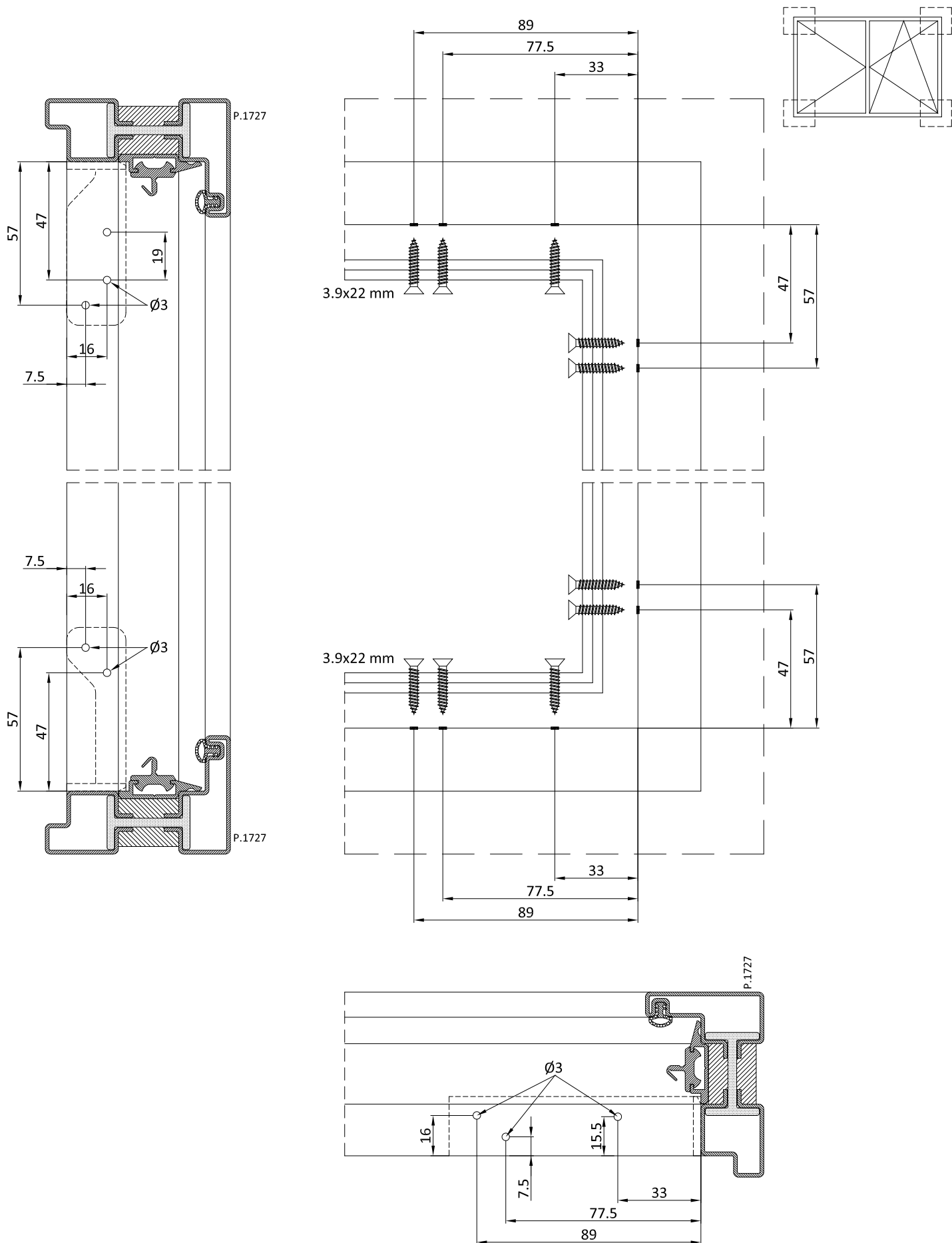
Asola per inserimento meccanismo
cremonese
*Slot for insertion of cremone
mechanism*



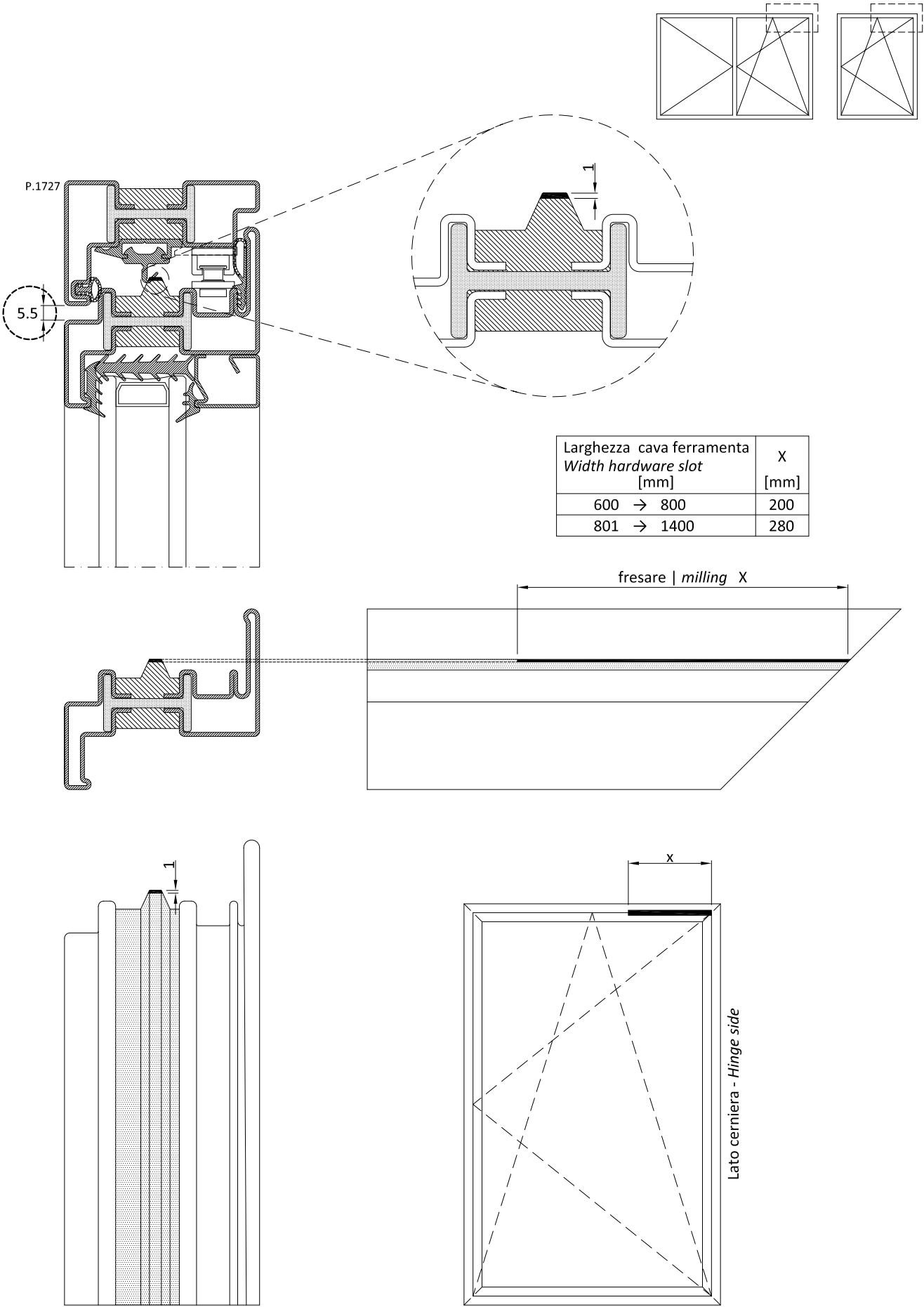
ALTEZZA MANIGLIA CREMONESE - CREMONE BOLT HANDLE HEIGHT			
Tipo Type	H cava ferramenta - H hardware slot std		H maniglia cremonese H cremone bolt handle
Finestre Windows	Y	370 → 520	H/2
	Z	521 → 660	H/2
	A	661 → 860	H/2
	B	861 → 1000	H/2
	C	1001 → 1200	500
	D	1201 → 1400	500
	E	1401 → 1600	500
	F	1601 → 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

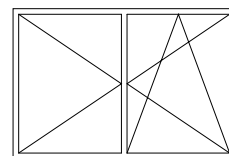






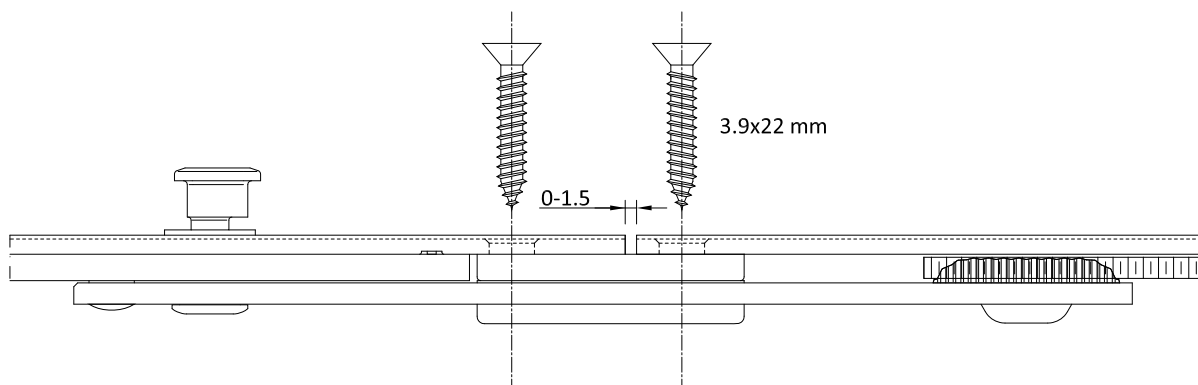
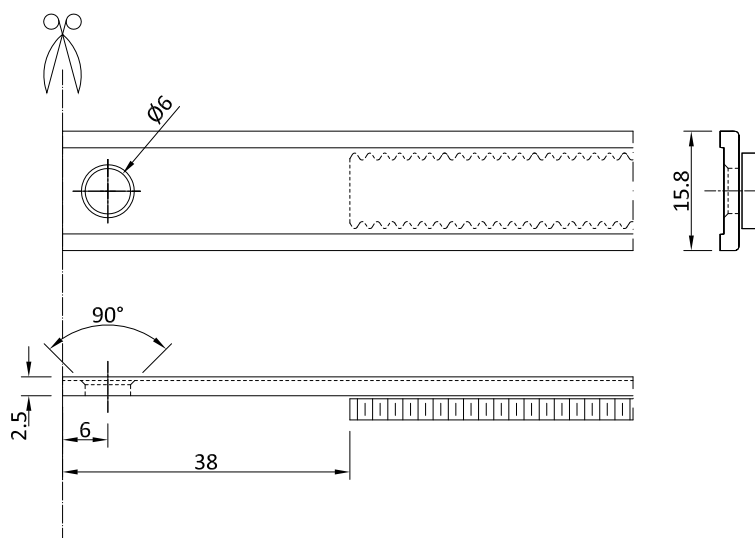
Fori eseguibili con maschera ATG281
Holes to be done with ATG281



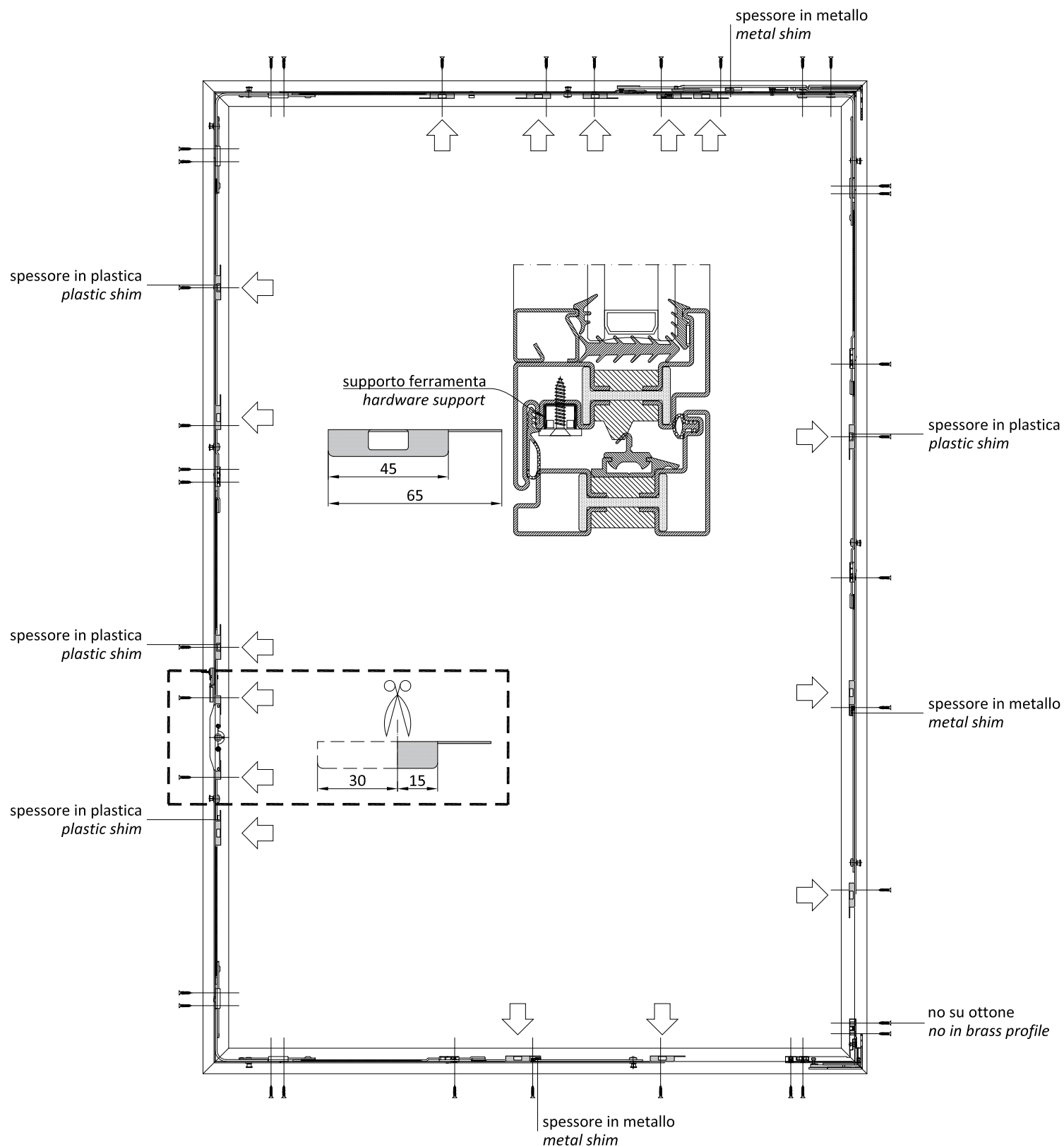
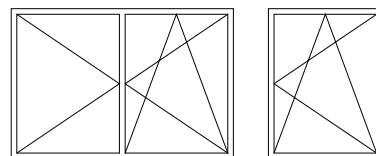


Lavorazione da eseguire sui componenti rasabili della ferramenta
Working on the cuttable pieces of the hardware

- 1 - Eseguire taglio della ferramenta sfalsato
 - 2 - Eseguire foro e svasatura
-
- 1 - Cutting of the hardware
 - 2 - Hole drilling and countersink



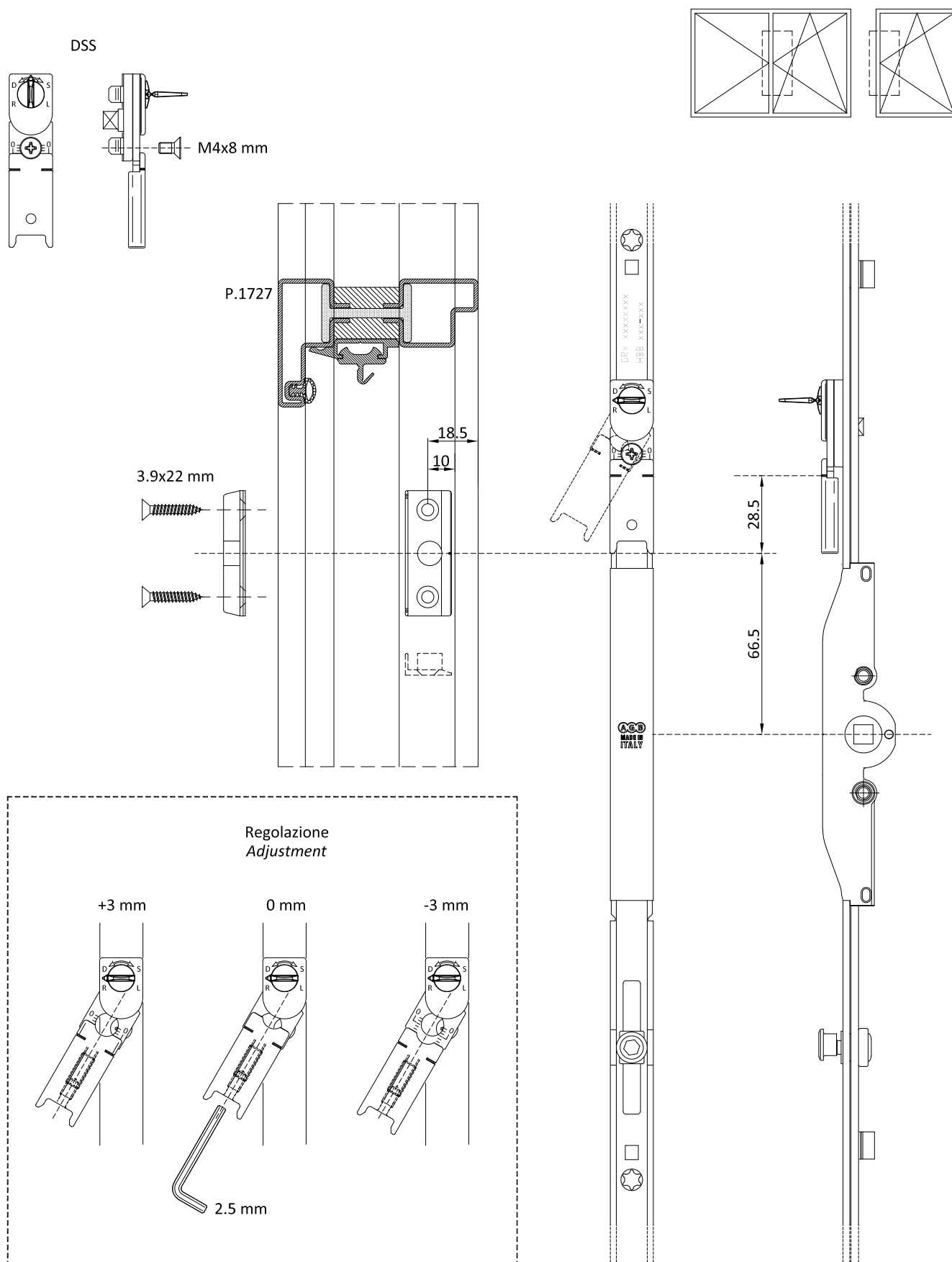
Lavorazione eseguibile con trancia ATG 311 o ATG 312
Tooling possible with punching machine ATG 311 or ATG 312

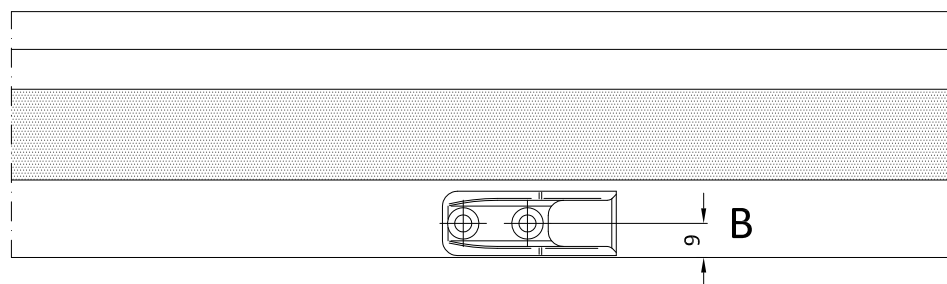
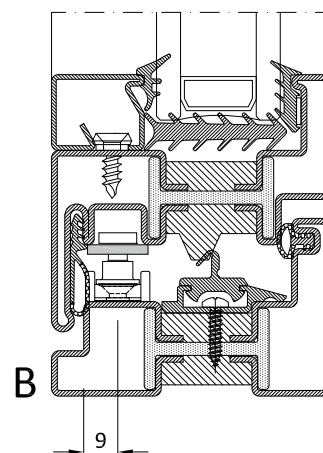
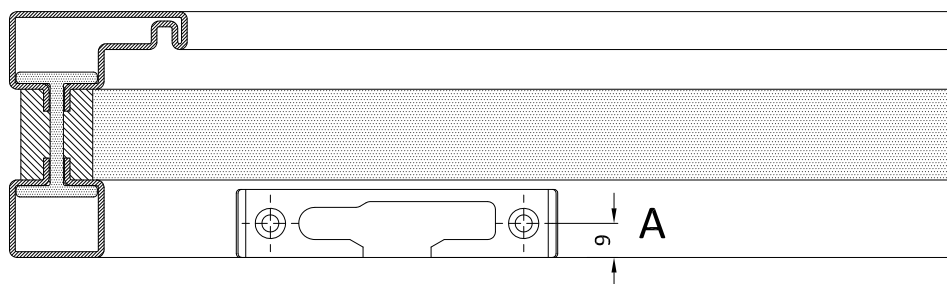
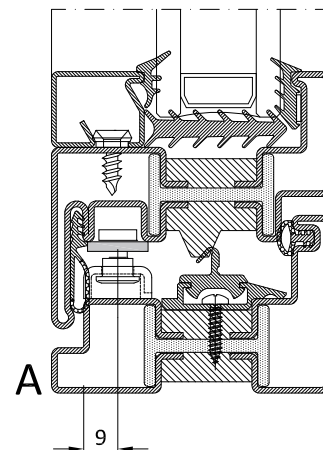
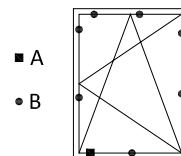
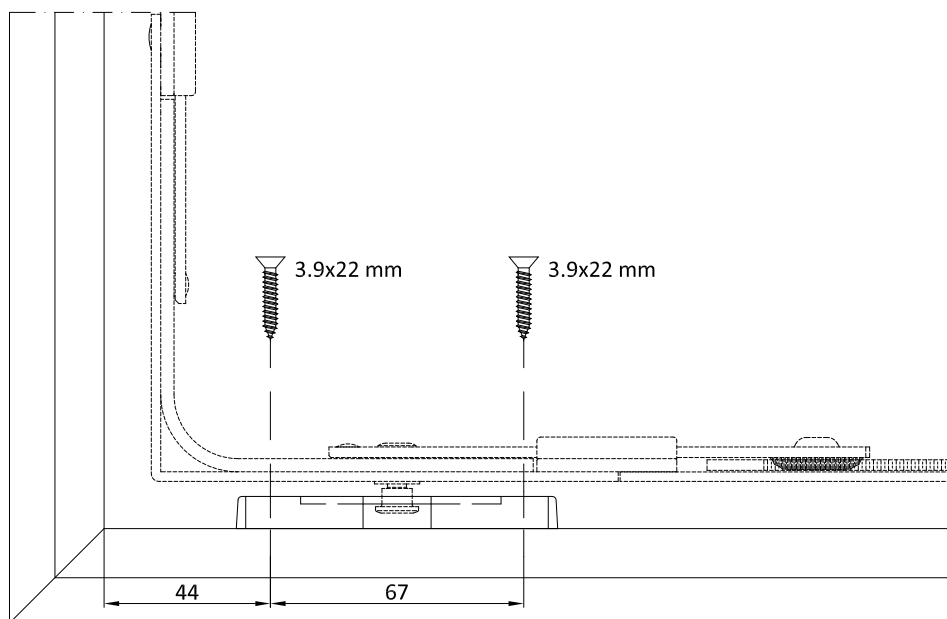


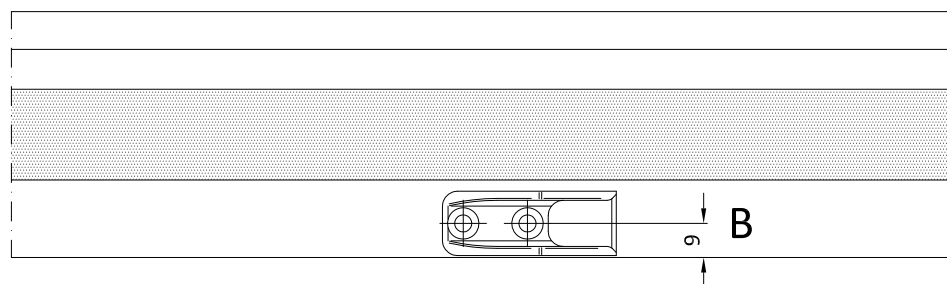
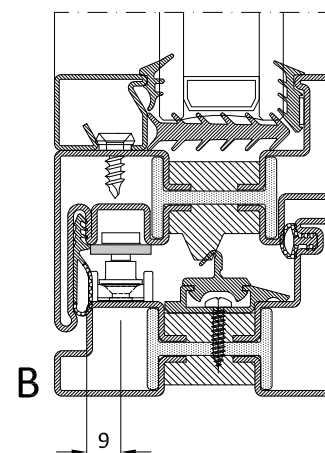
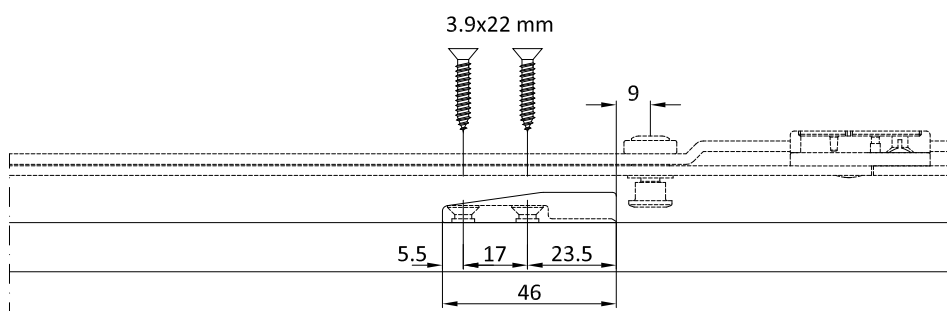
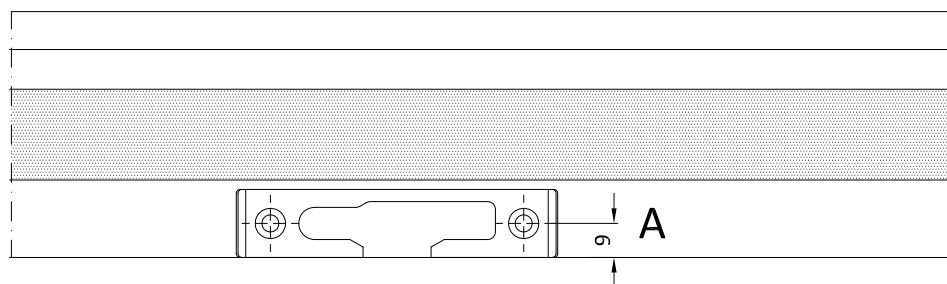
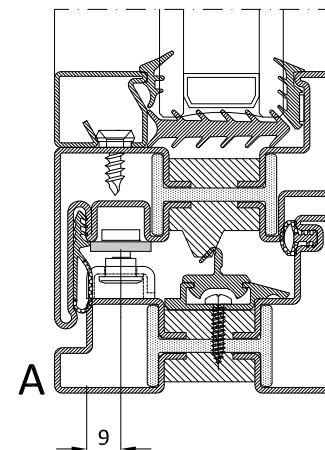
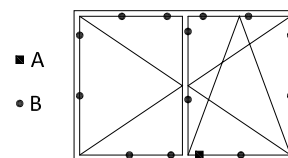
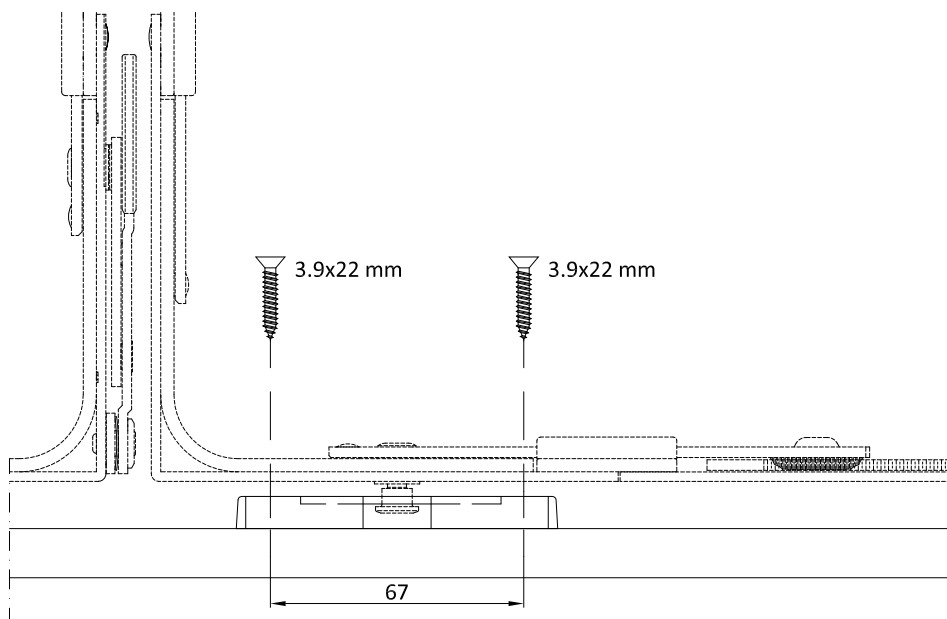
viti | screws TPS 3.9x22 mm



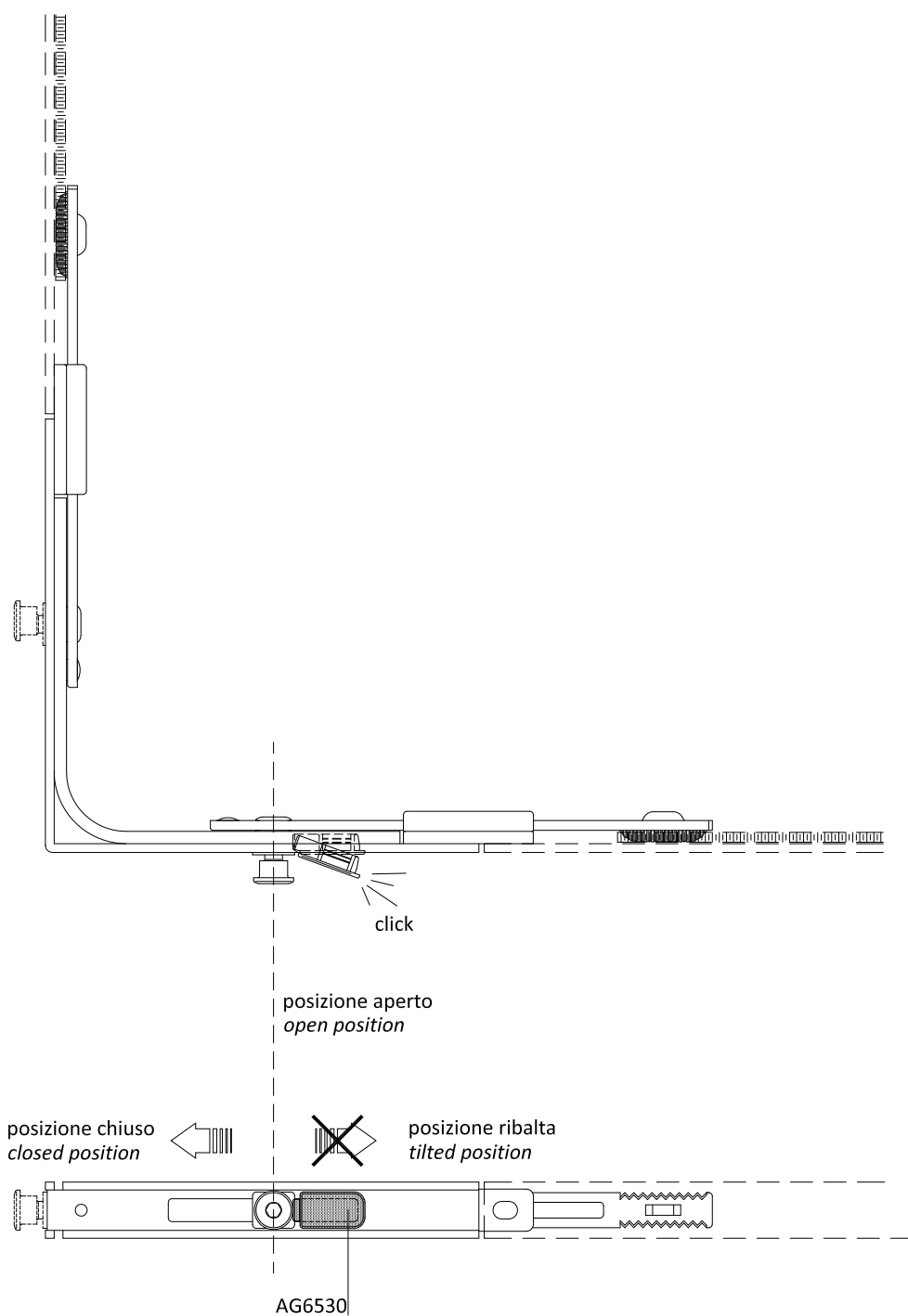
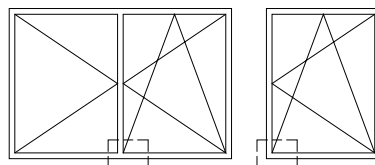
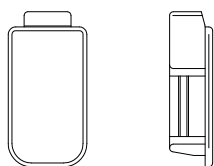
Applicazione ferramenta
Hardware installation



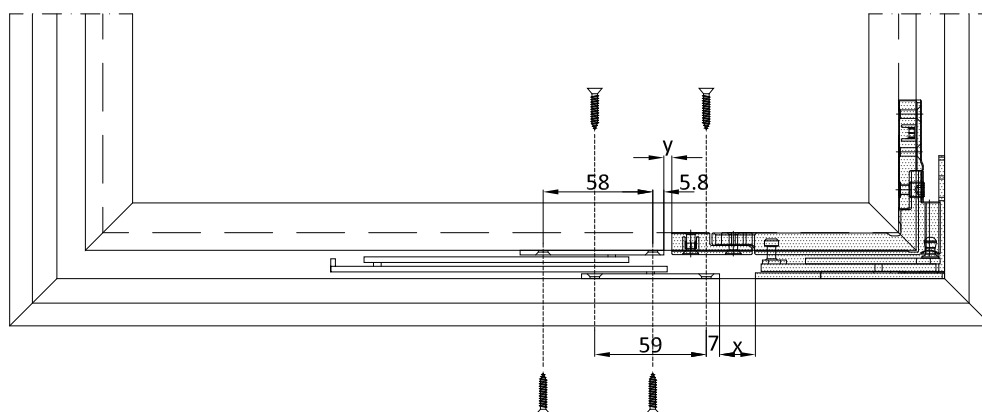
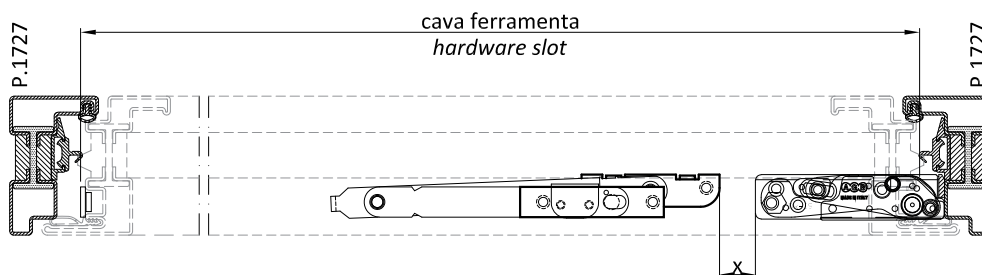
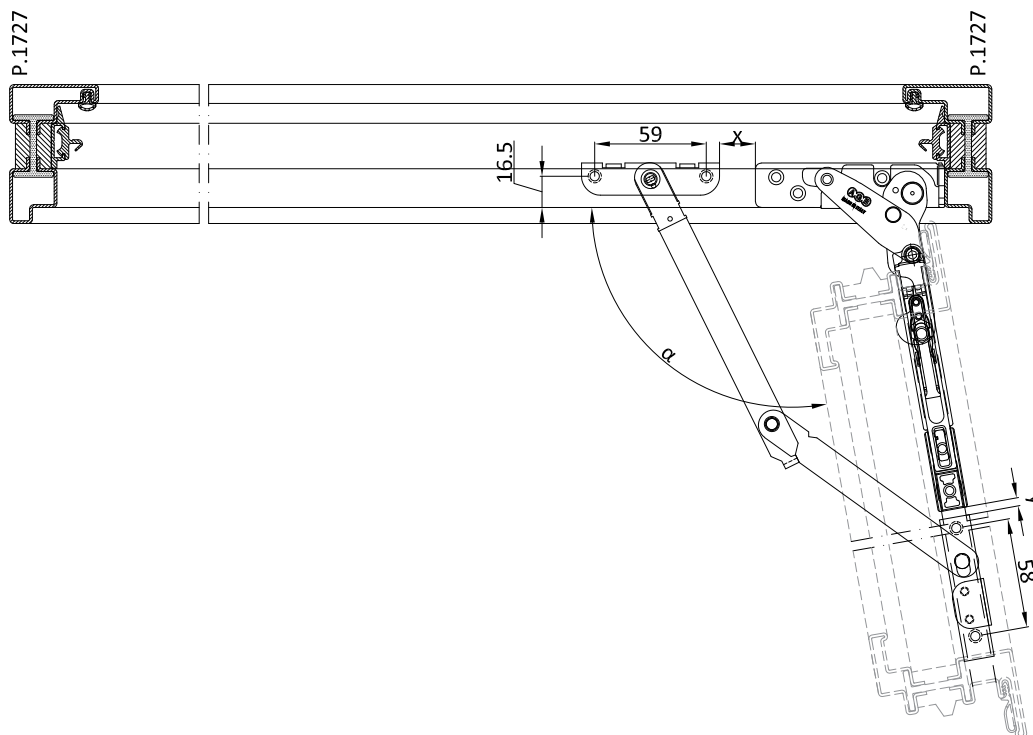
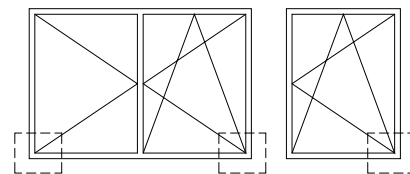




AG6530



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

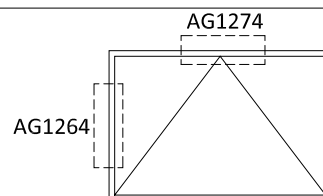
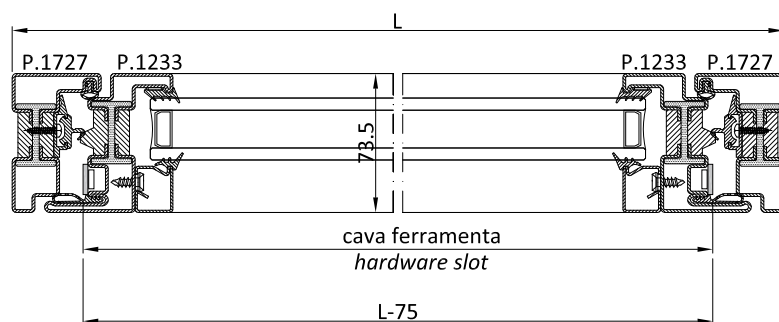


non installabile su kit AG1281-2-5-6
not possible to install on kit AG1281-2-5-6

	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

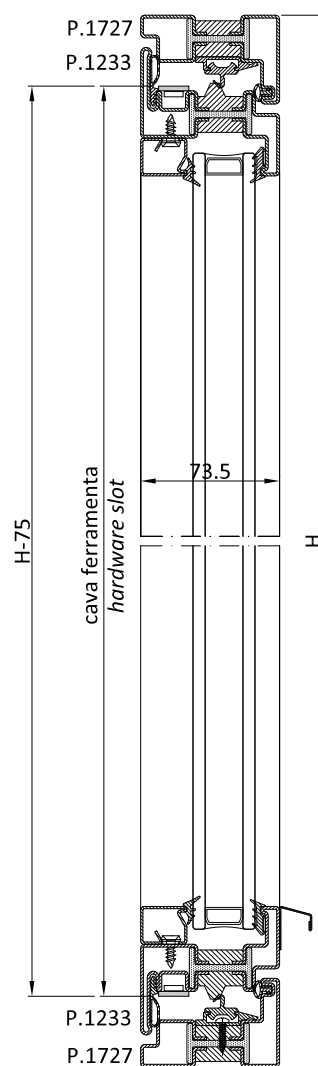
Specificare all'ordine misure cava ferramenta
Specify hardware slot size

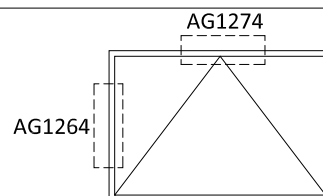
	AG1274	H altezza - Height			
		350 660	661 860	861 1200	1201 1400
L W larghezza width	560-660	A1	B1	C1	D1
	661-860	A2	B2	C2	D2
	861-1200	A3	B3	C3	D3
	1201-1600	A4	B4	C4	D4



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

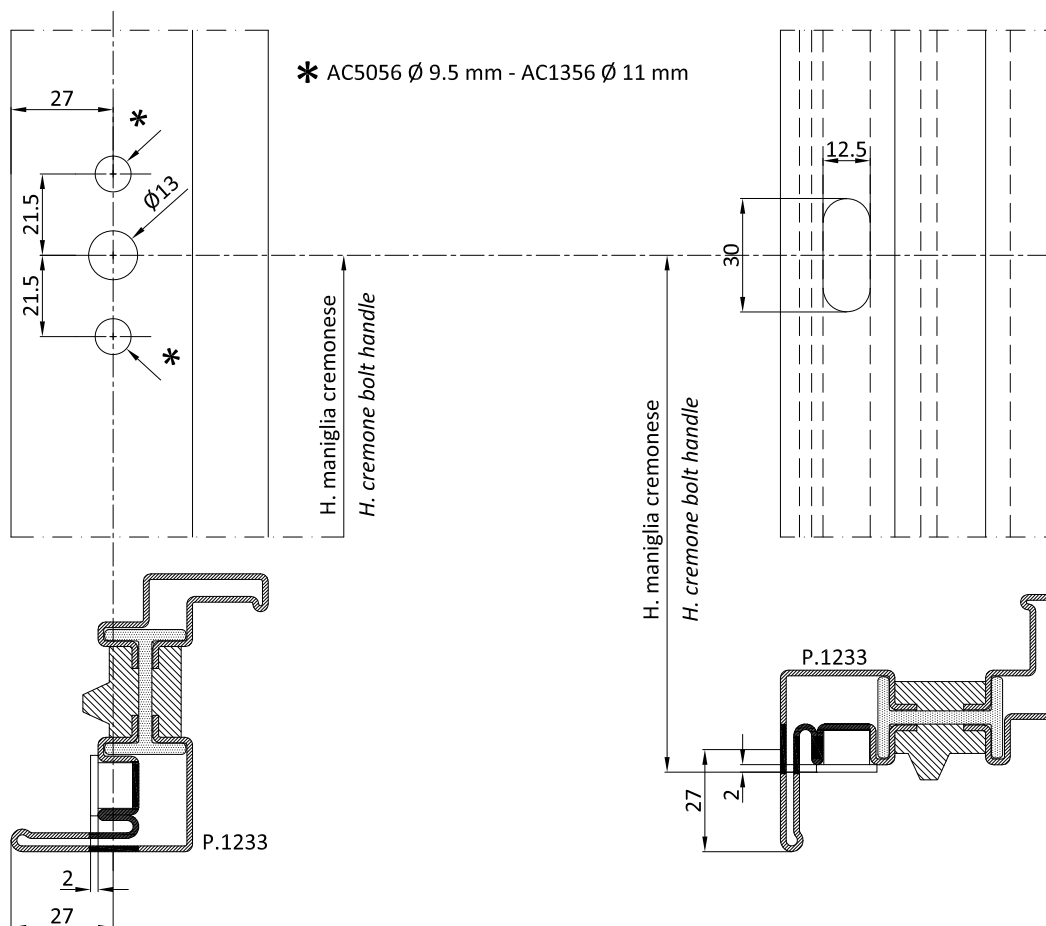
2 hinges - maximum leaf weight 70 kg
3 hinges - maximum leaf weight 100 kg





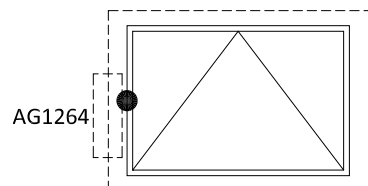
Fori per inserimento quadro comando
e fissaggio maniglia / movimento DK
holes for inserting control panel and
anchoring of handle / TT (tilt and turn)
movement

Asola per inserimento meccanismo
cremonese
Slot for insertion of cremone
mechanism



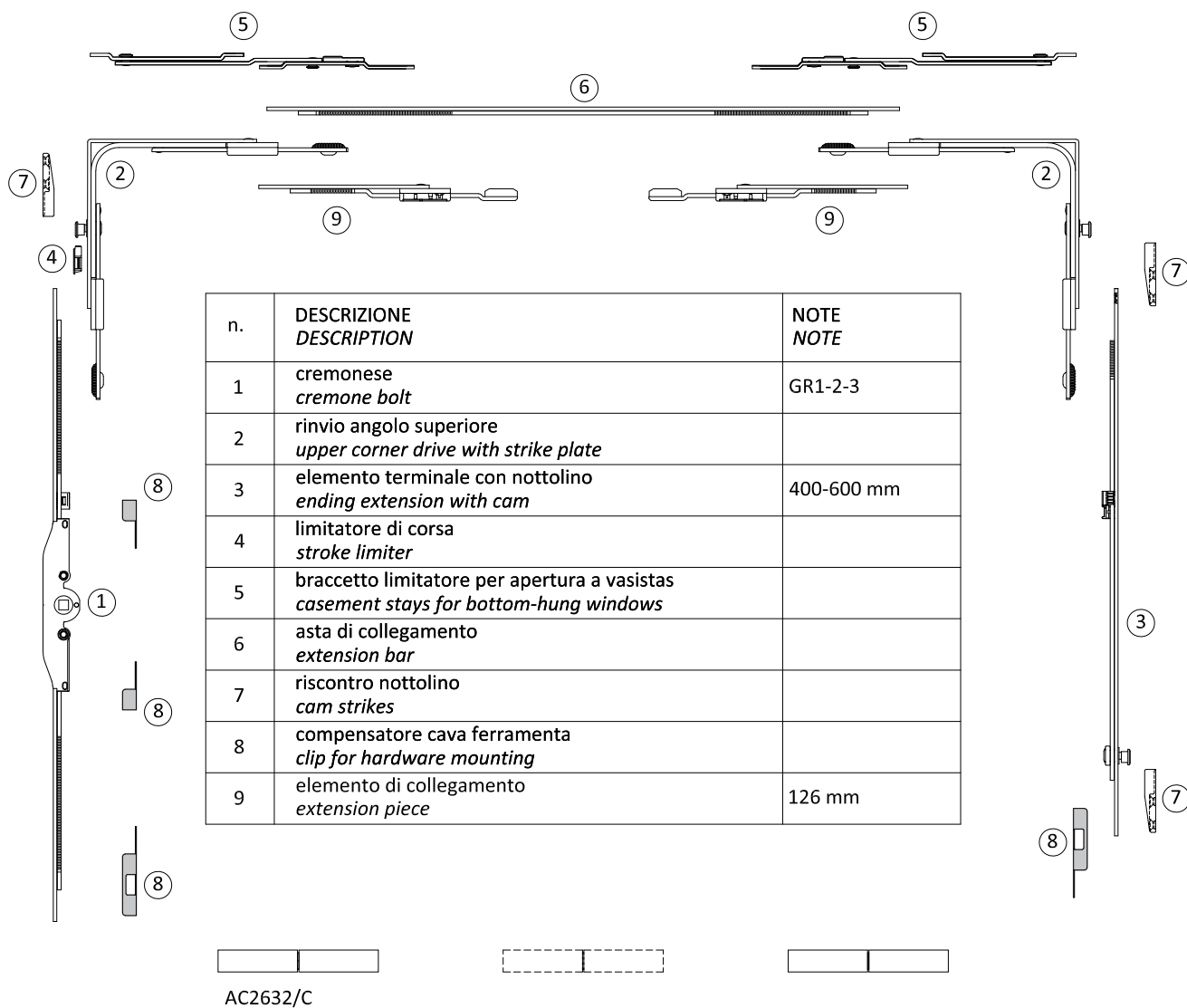
AG1264 ALTEZZA MANIGLIA CREMONESE - CREMONE BOLT HANDLE HEIGHT		
Tipo Type	cava ferramenta hardware slot	H maniglia cremone H cremone bolt handle
Vasistas Bottom-hung	560 → 660	H/2
	661 → 860	H/2
	861 → 1200	H/2
	1201 → 1600	H/2

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



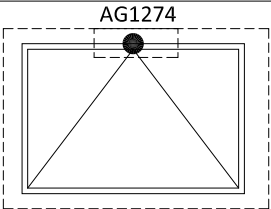
2 cerniere - peso massimo anta 70 kg
3 cerniere - peso massimo anta 100 kg

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



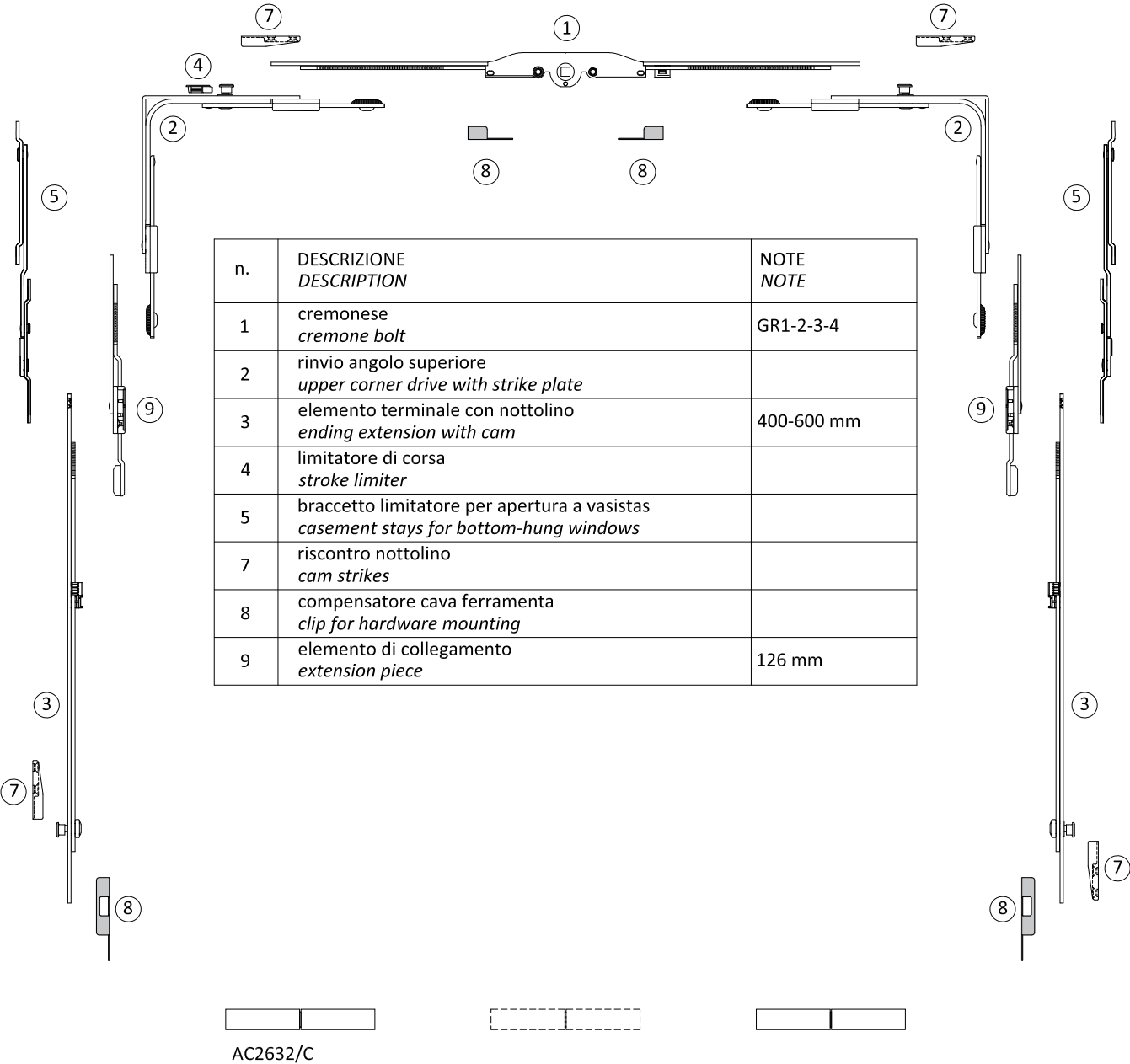
cerniere non incluse nel kit
hinges not included in the kit

Specificare all'ordine misure cava ferramenta
Specify hardware slot size



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

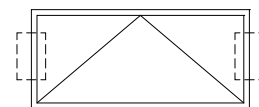
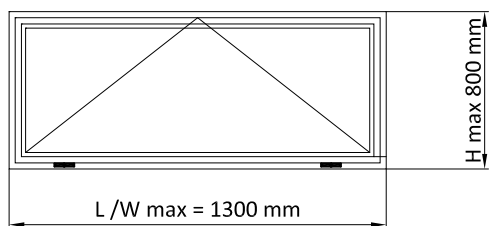
2 hinges - maximum leaf weight 70 kg
3 hinges - maximum leaf weight 100 kg



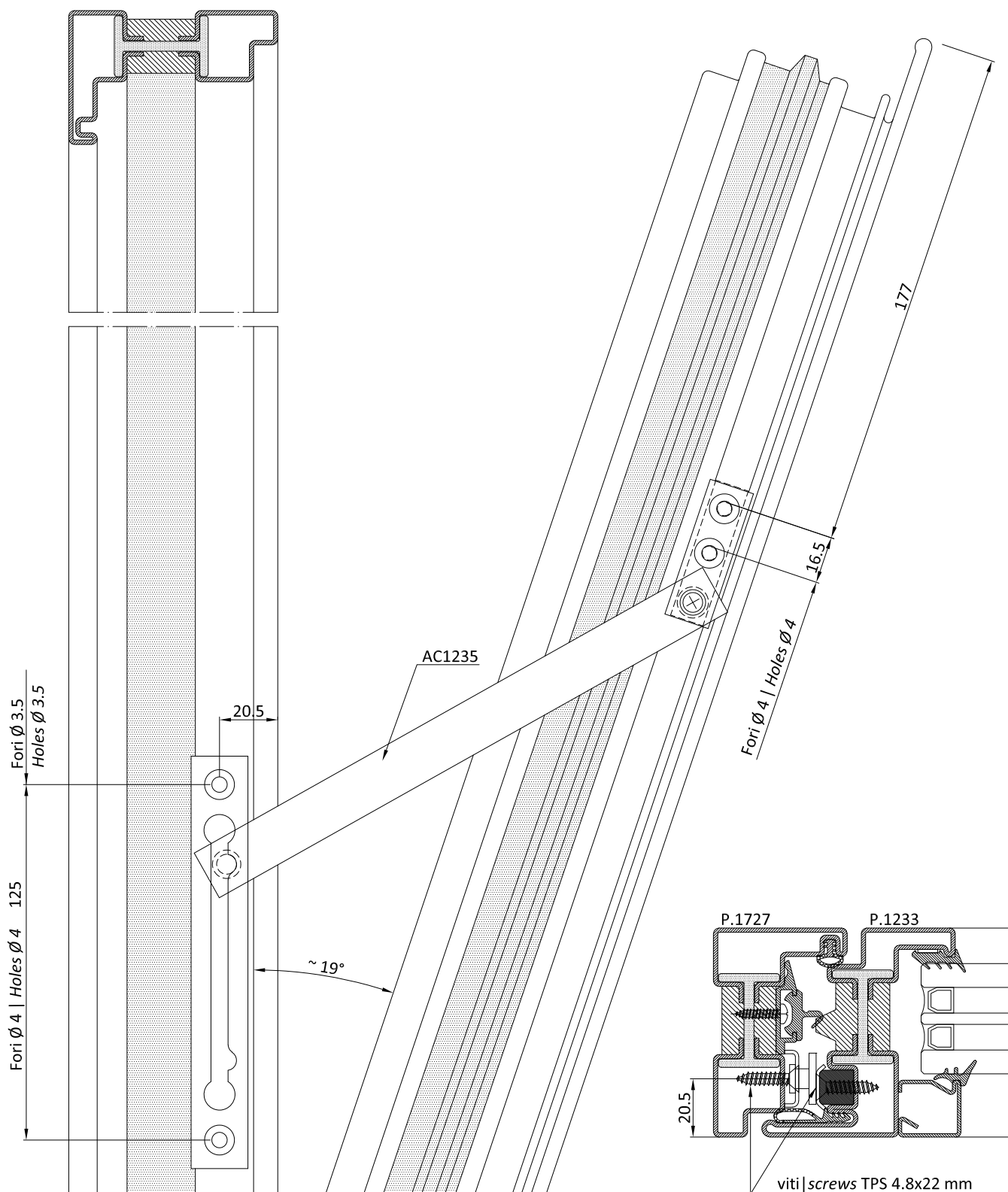
n.	DESCRIZIONE DESCRIPTION	NOTE NOTE
1	cremonese cremone bolt	GR1-2-3-4
2	rinvio angolo superiore upper corner drive with strike plate	
3	elemento terminale con nottolino ending extension with cam	400-600 mm
4	limitatore di corsa stroke limiter	
5	braccetto limitatore per apertura a vasistas casement 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

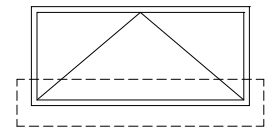
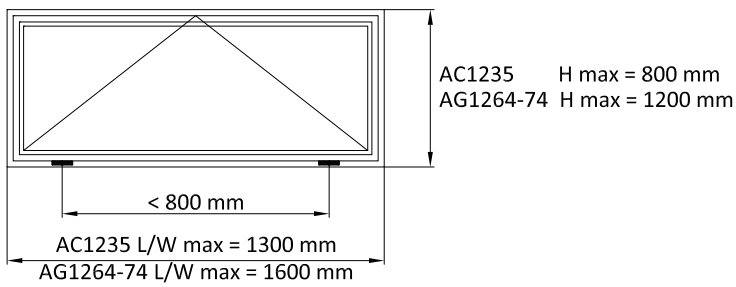
cerniere non incluse nel kit
hinges not included in the kit





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

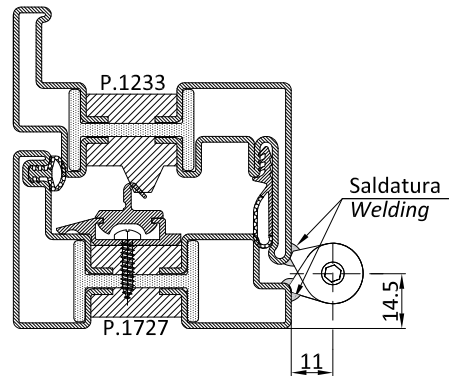




AC1235
Peso max. per anta 70 kg
Max. weight for leaf: 70 kg

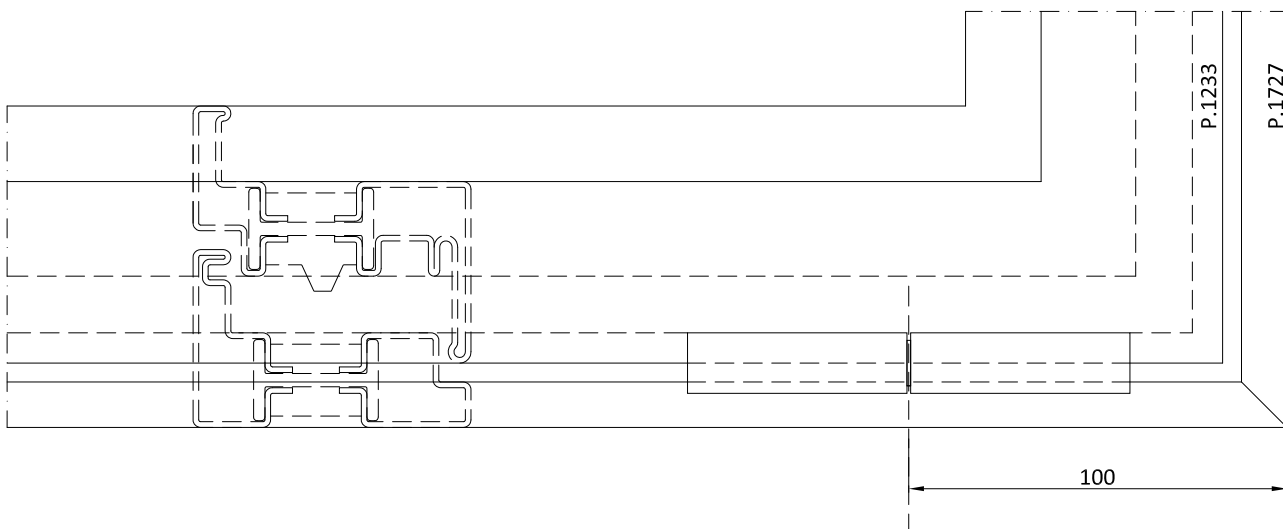
AG1264 - AG1274
2 cerniere
peso massimo anta 70 kg
3 cerniere
peso massimo anta 100 kg

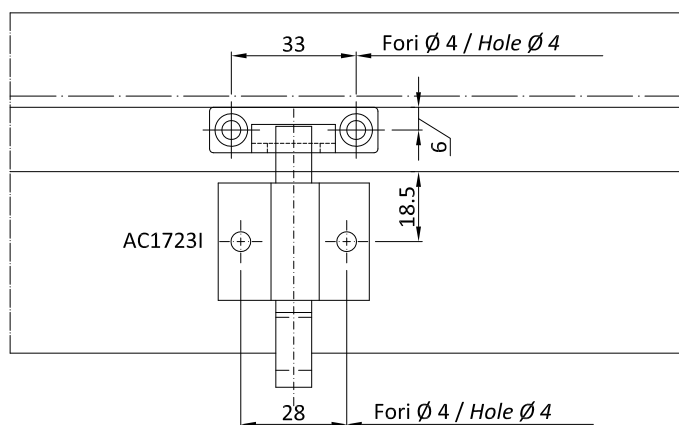
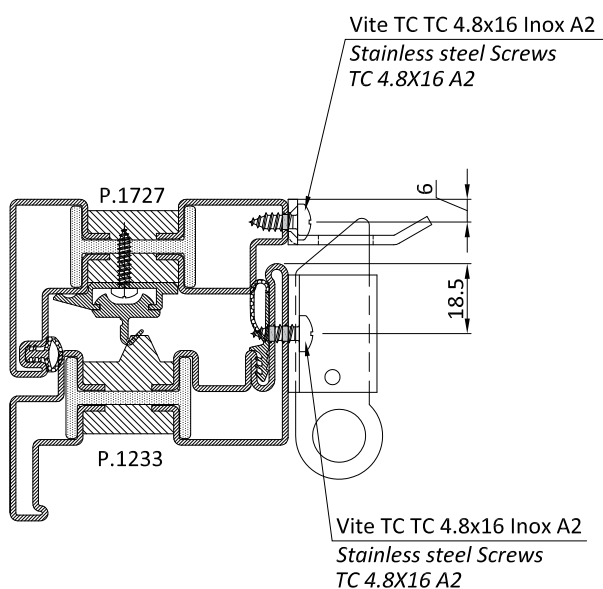
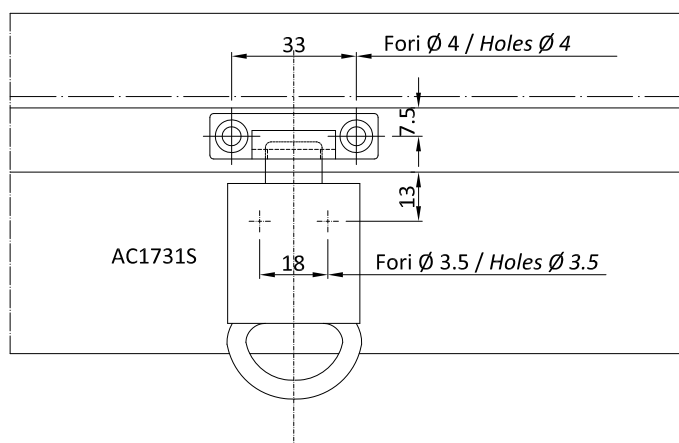
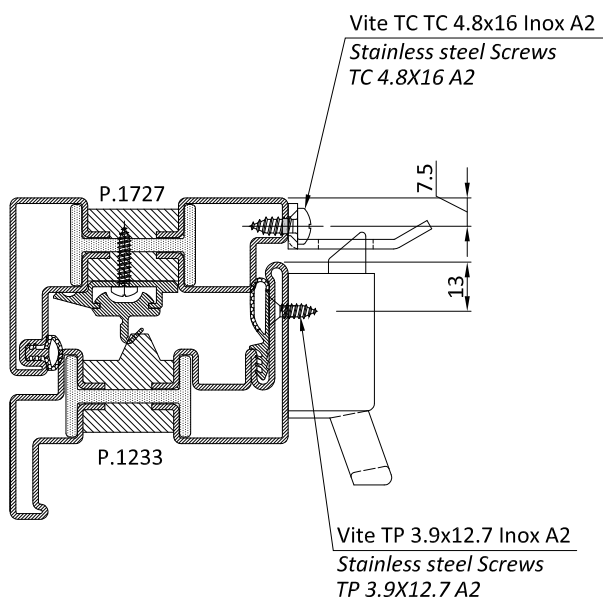
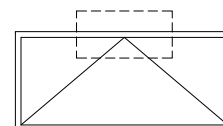
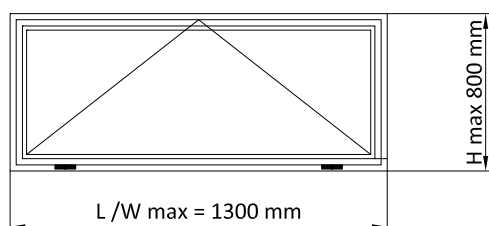
2 hinges
maximum leaf weight 70 kg
3 hinges
maximum leaf weight 100 kg

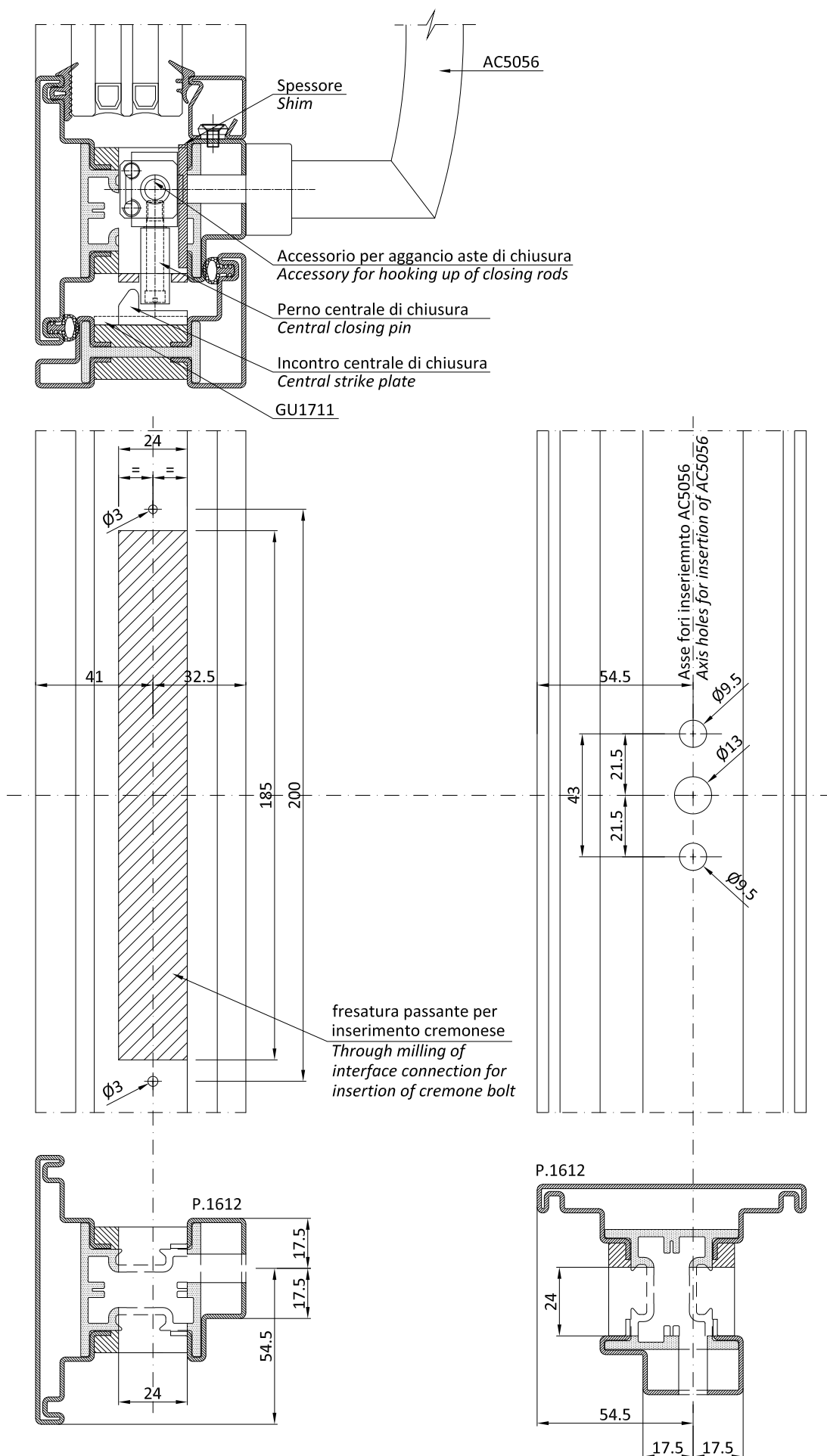


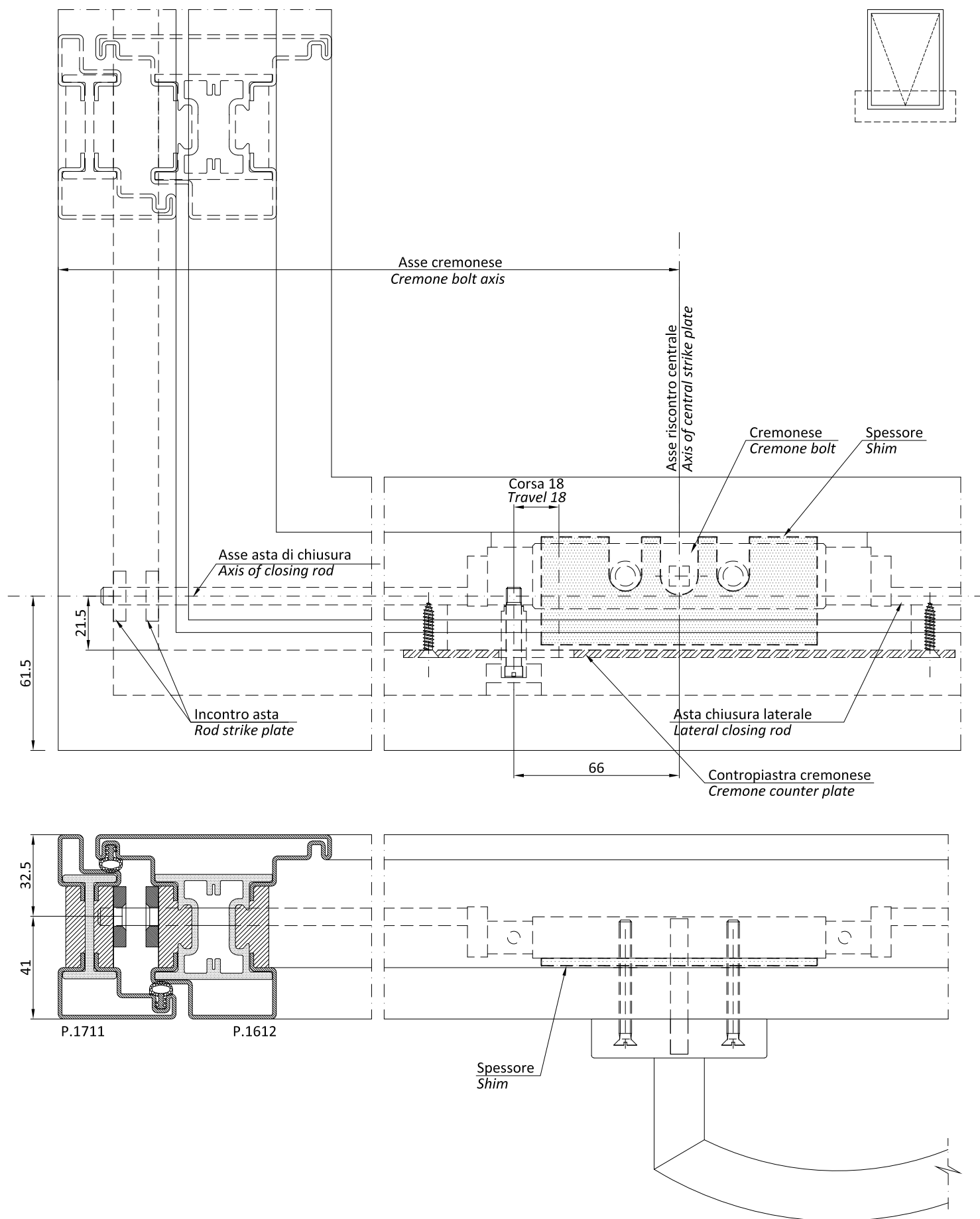
Posizionare le cerniere come da disegno saldandole sui lati.
Position the hinges as in the drawing, welding them on the sides.

- 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.

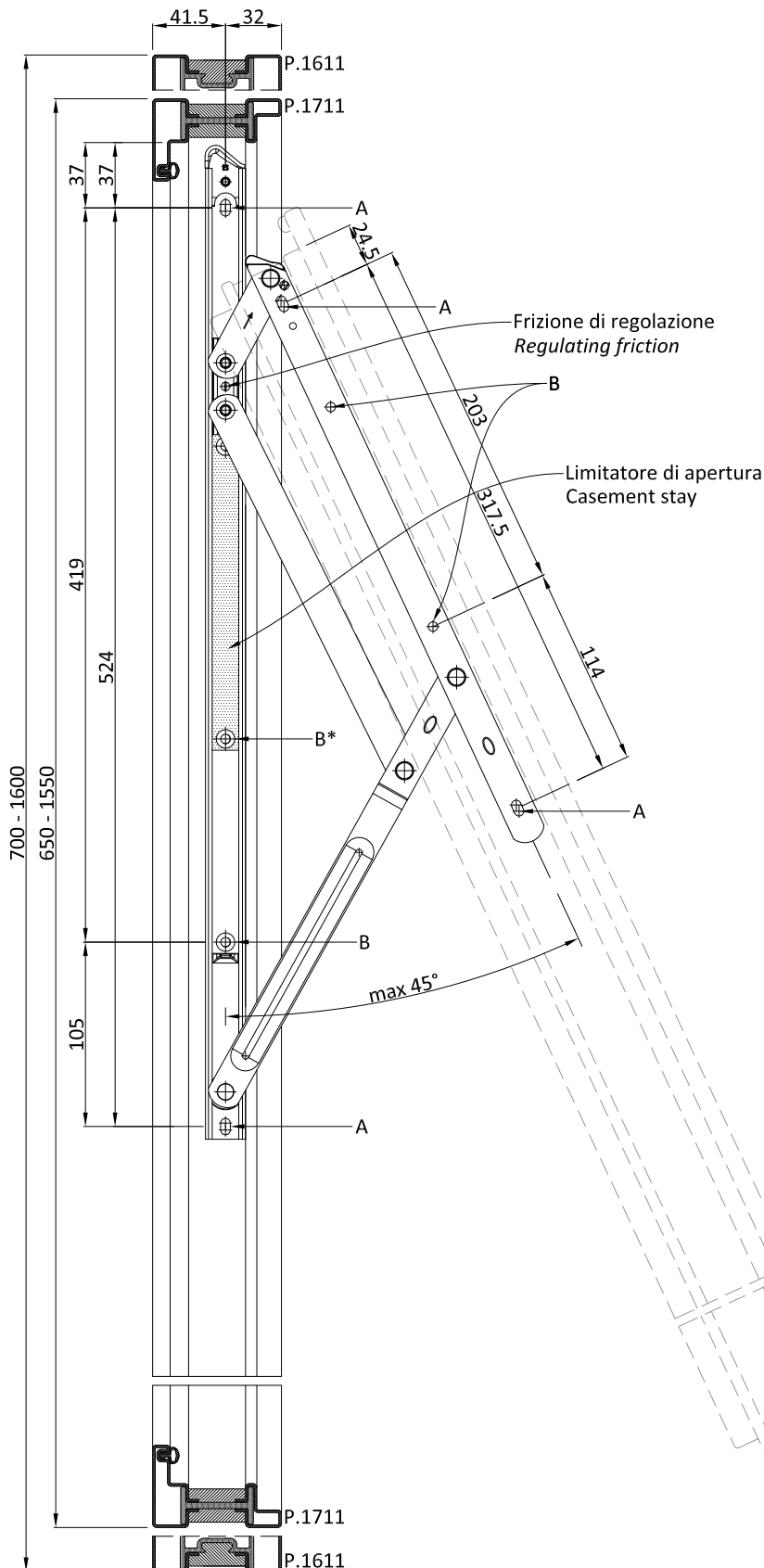
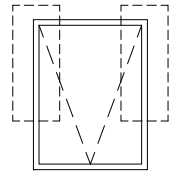








Peso massimo anta 75 kg
Maximum vent weight 75 kg

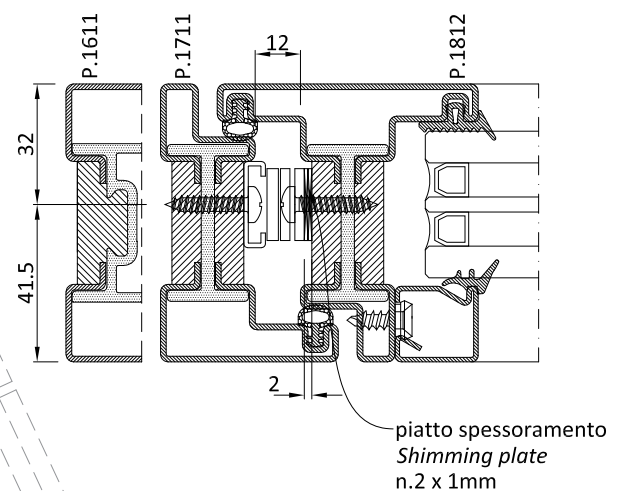


- Fissare i compassi in corrispondenza dei fori asolati A foro su profilo Ø 4 per viti TC 4.8x22 mm;
- Verificare il funzionamento dei compassi;
- Fissare l'apertura massima desiderata mediante il limitatore di apertura;
- Completare l'operazione di fissaggio nei rimanenti fori B.

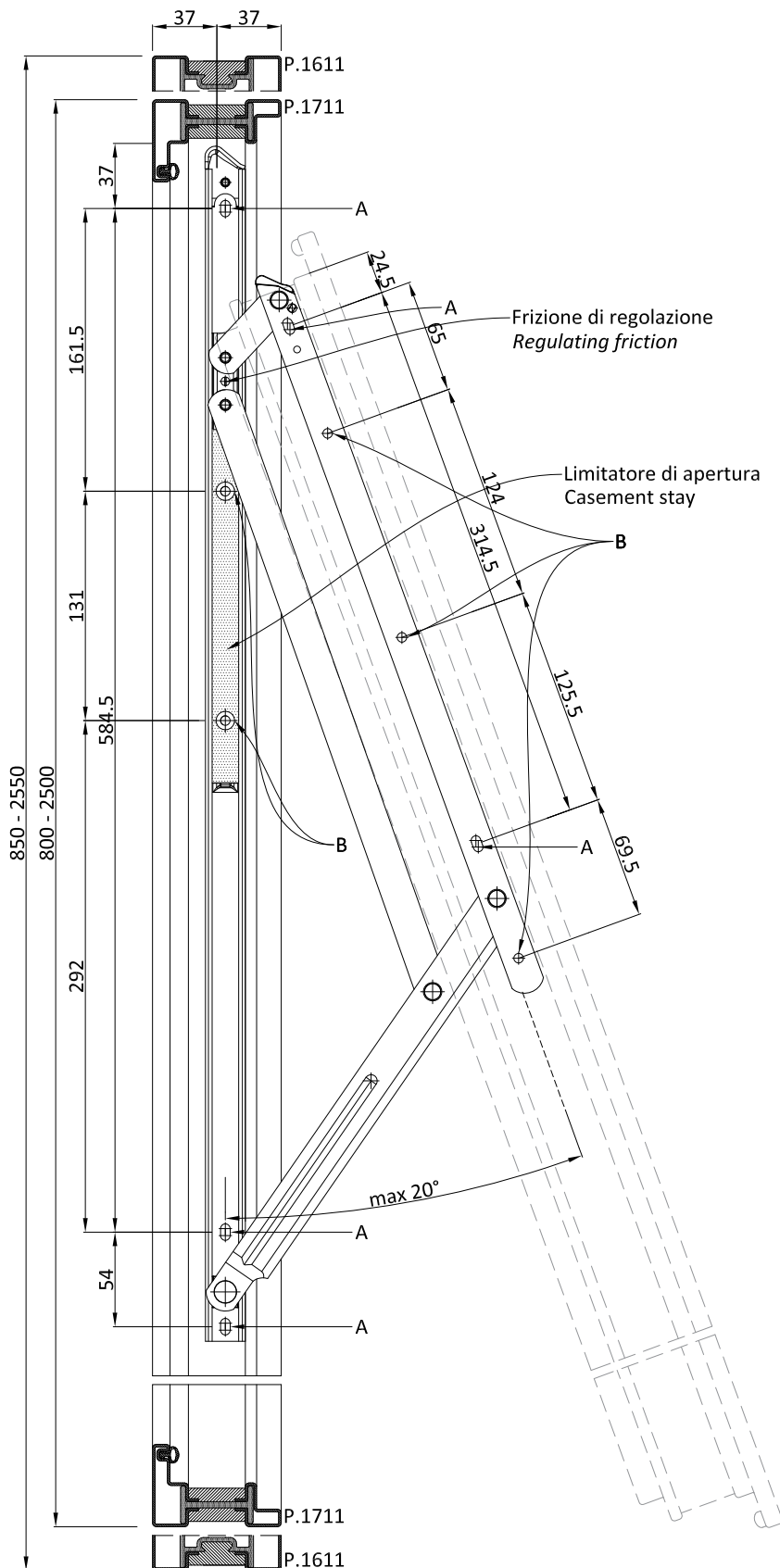
* posizione determinata dalla apertura massima desiderata - foro da eseguire in opera

- 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

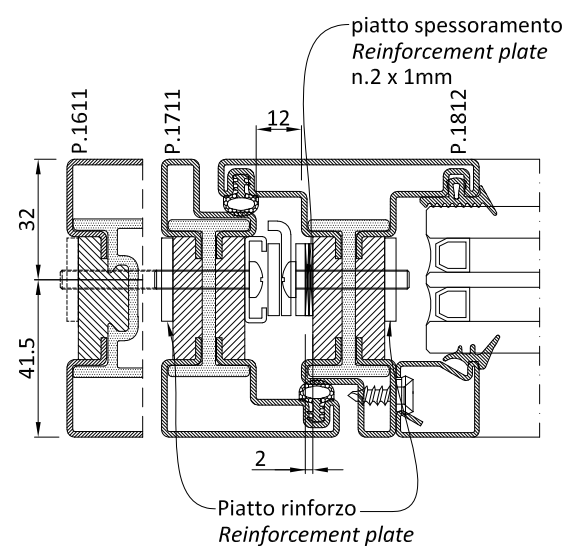


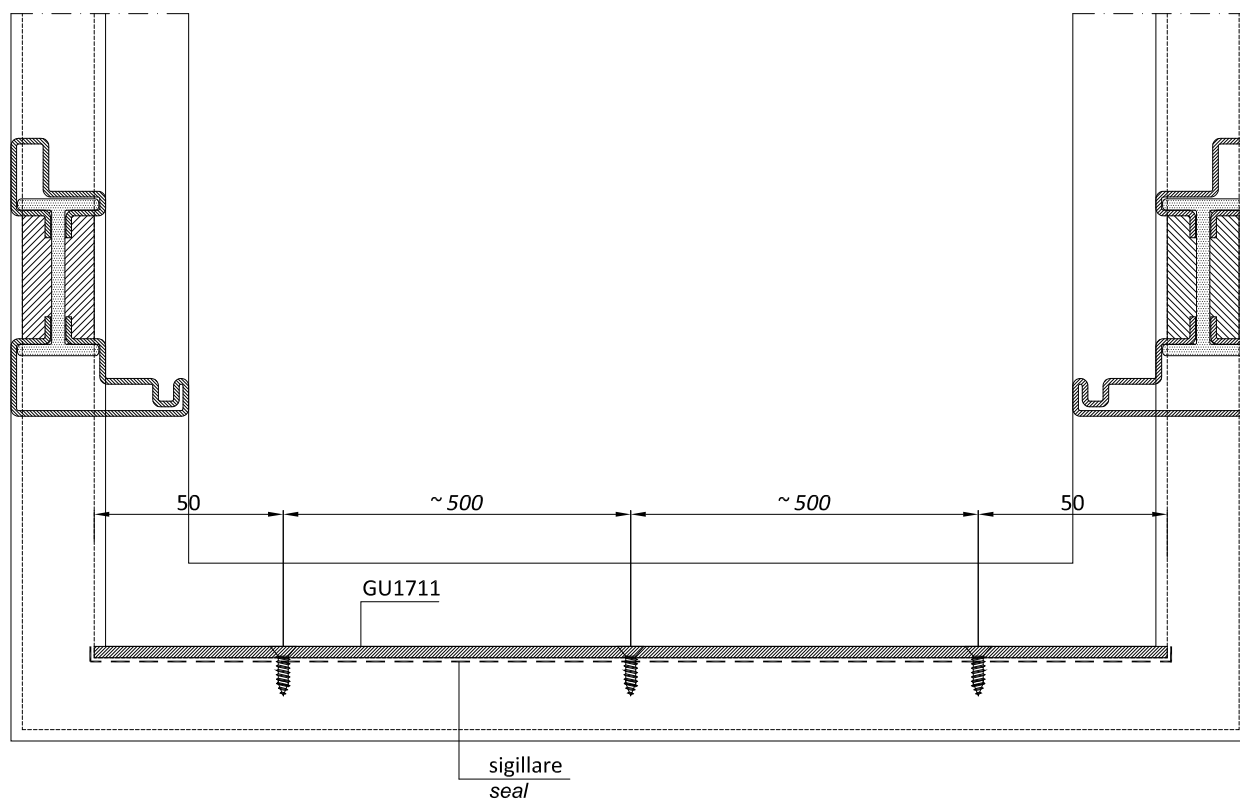
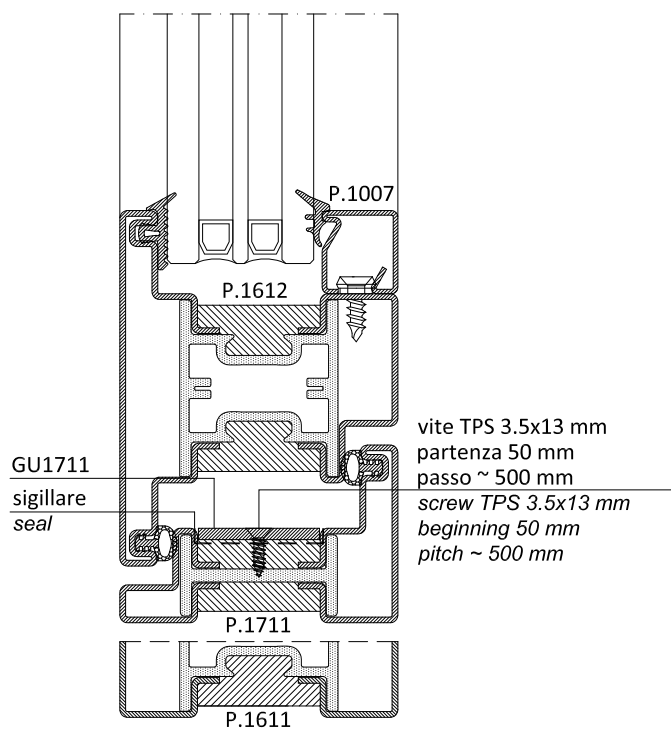
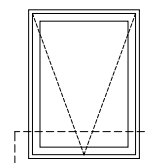
- Fissare i compassi in corrispondenza dei fori asolati A foro su profilo Ø 4 per viti TC 4.8x22 mm;
- Verificare il funzionamento dei compassi;
- Fissare l'apertura massima desiderata mediante il limitatore di apertura;
- Completare l'operazione di fissaggio nei rimanenti fori B.

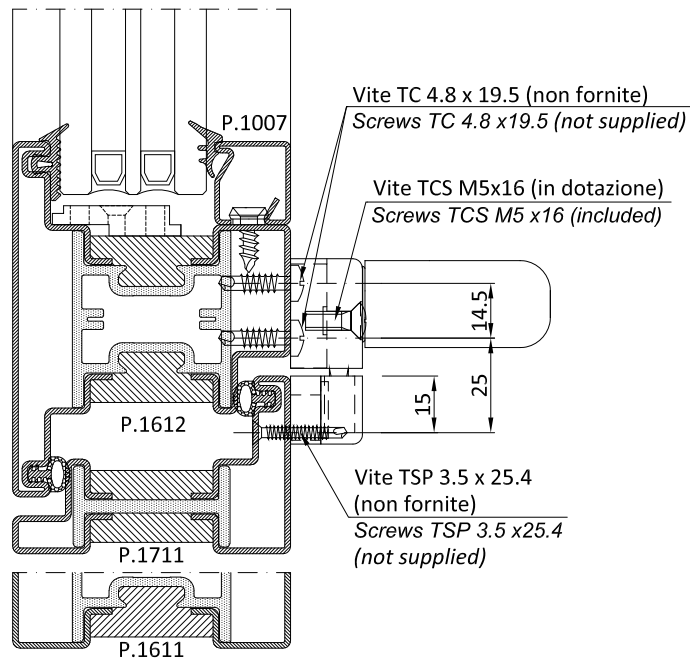
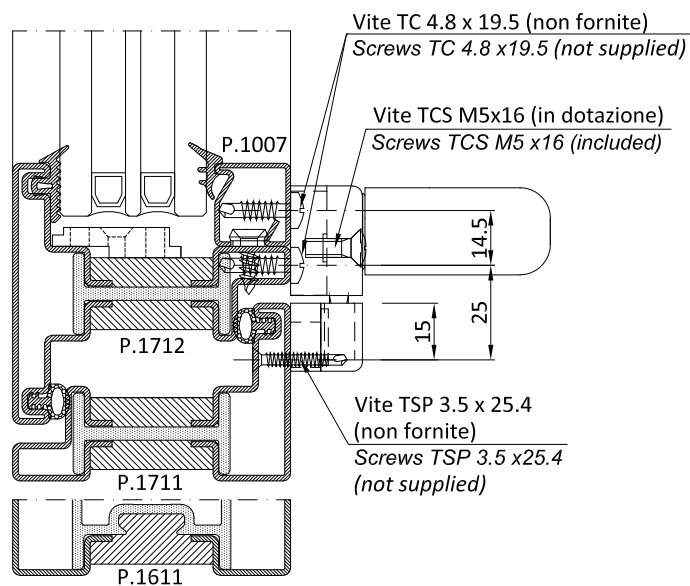
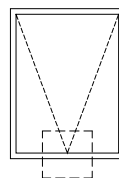
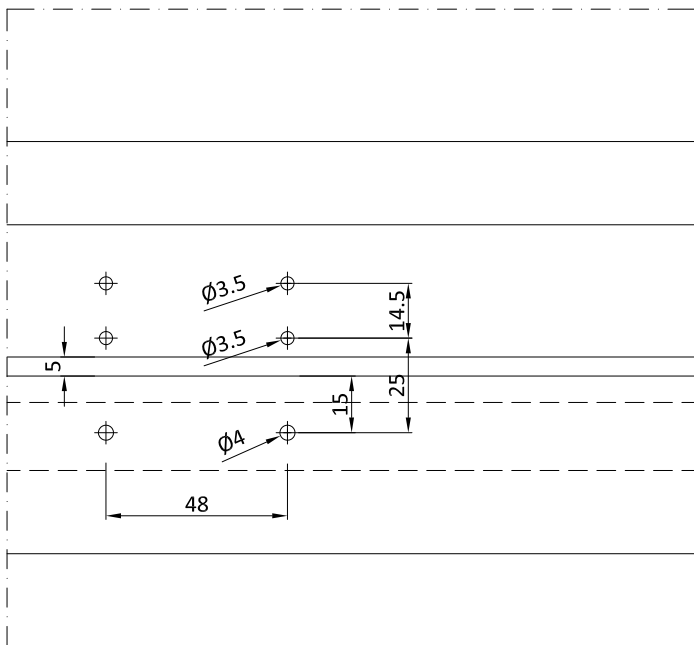
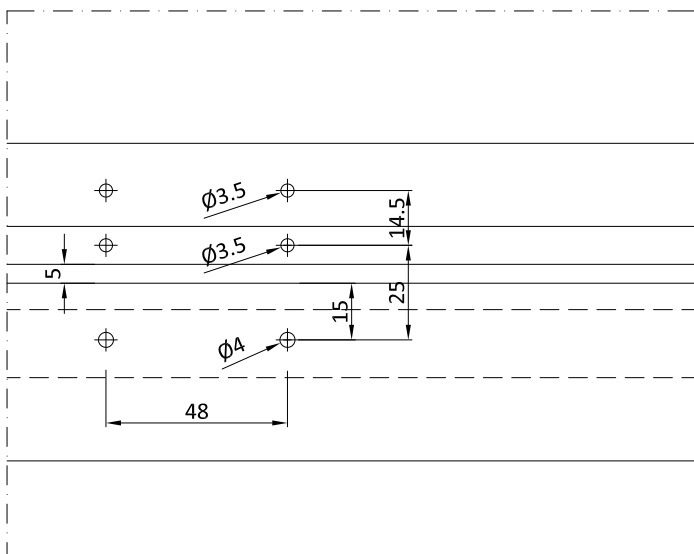
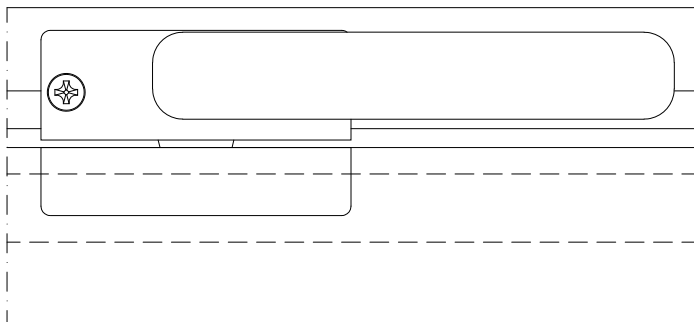
* posizione determinata dalla apertura massima desiderata - foro da eseguire in opera

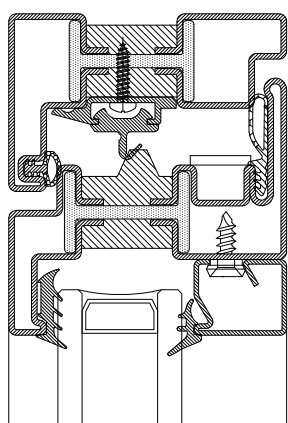
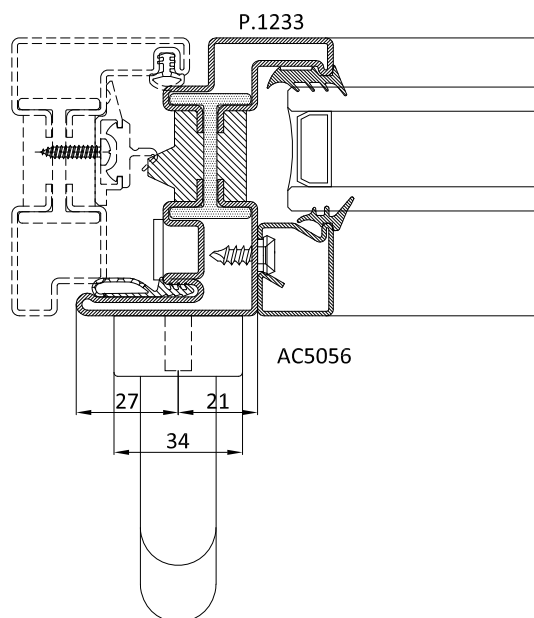
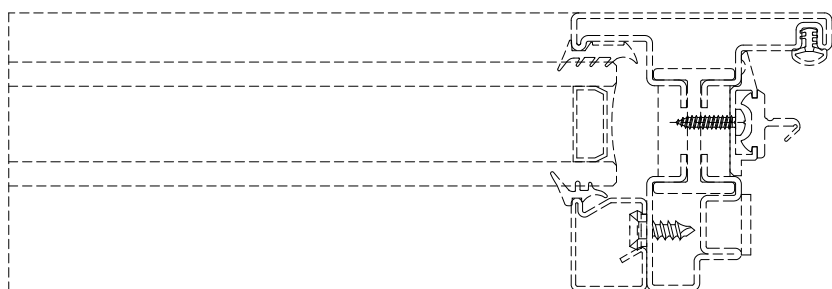
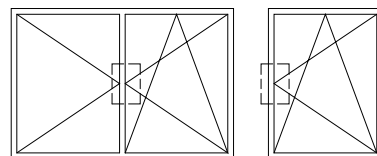
- Fit the side arms into the slotted holes A - hole on profile Ø 4 for TC 4.8x22 mm screws;
- Check the side arms move properly;
- Set the desired maximum opening using the casement stay;
- Complete the anchoring operation in the remaining B holes.

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







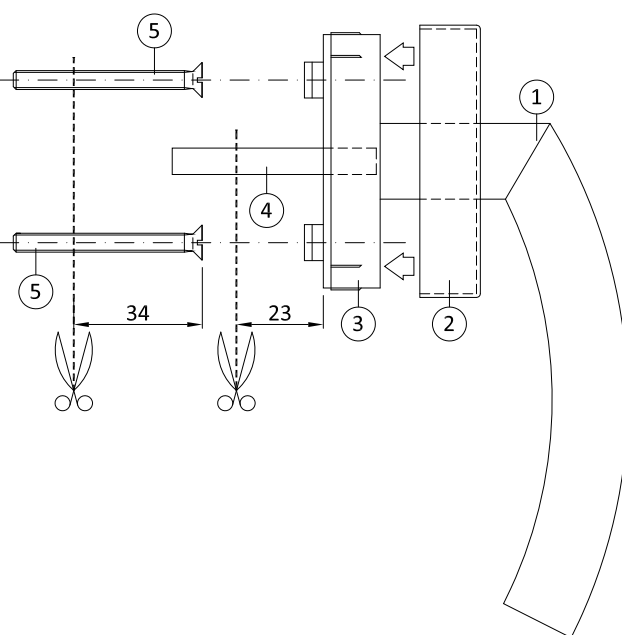
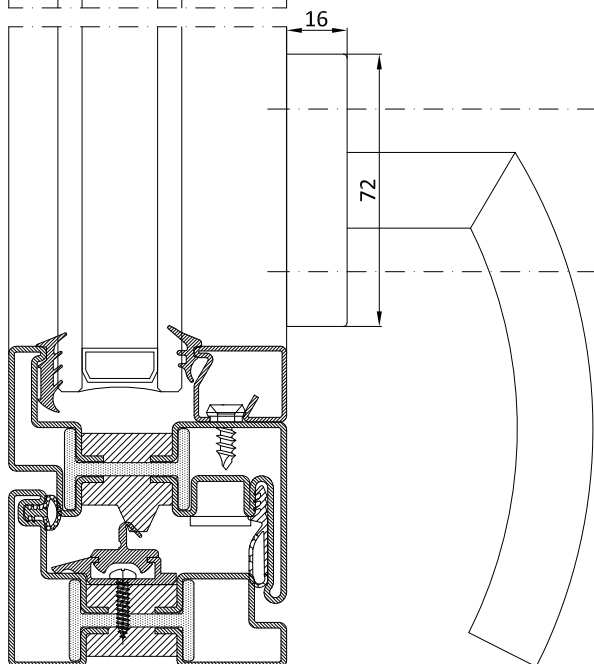


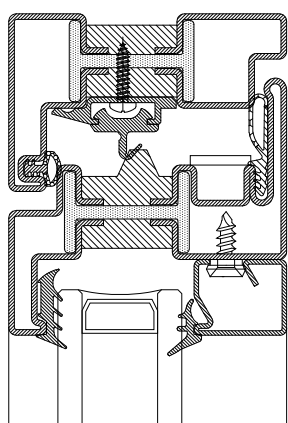
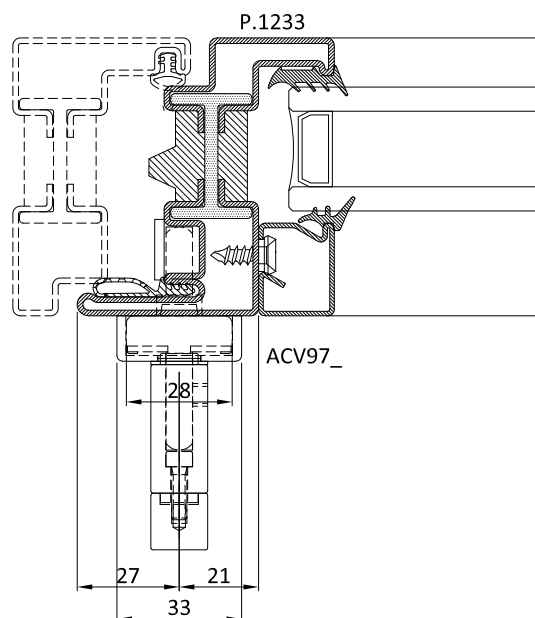
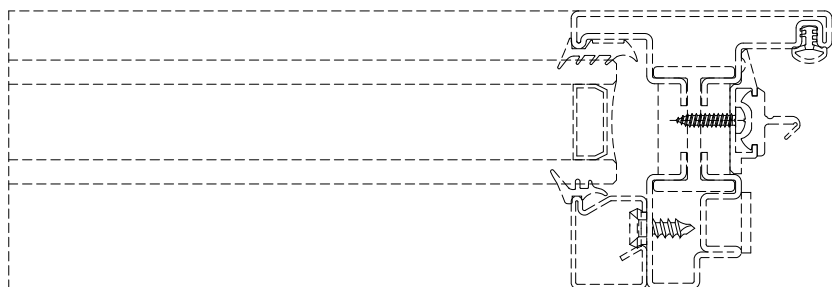
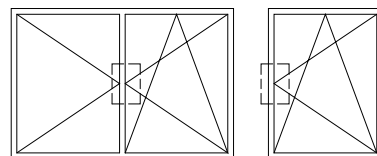
AC5056 :

- 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)



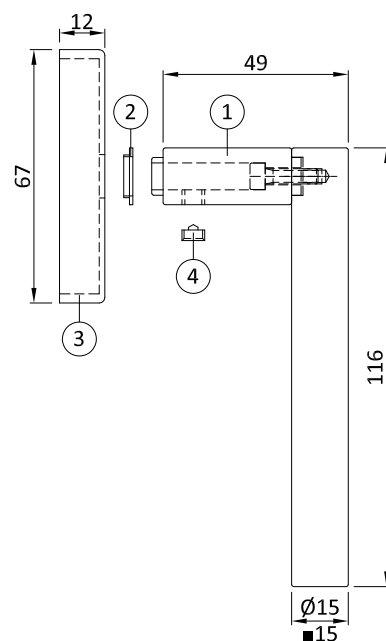
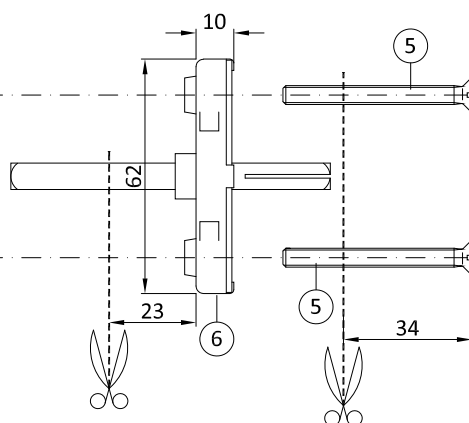
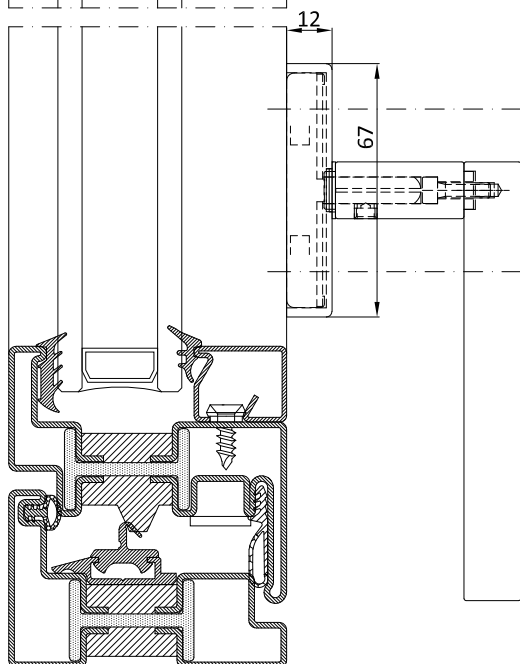


ACV97- :

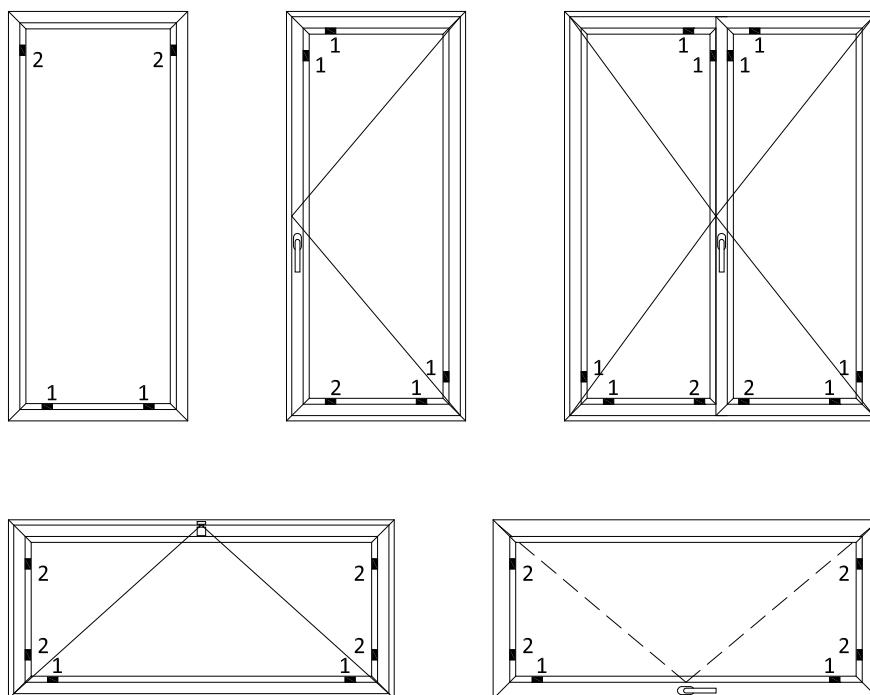
- 1) Impugnatura
- 2) Rondella
- 3) Rosetta
- 4) Grano M6x6
- 5) Vite TP M5x50 (non fornite)
- 6) AC1356 Movimento DK

ACV97- :

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

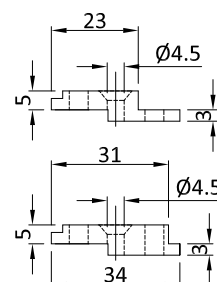
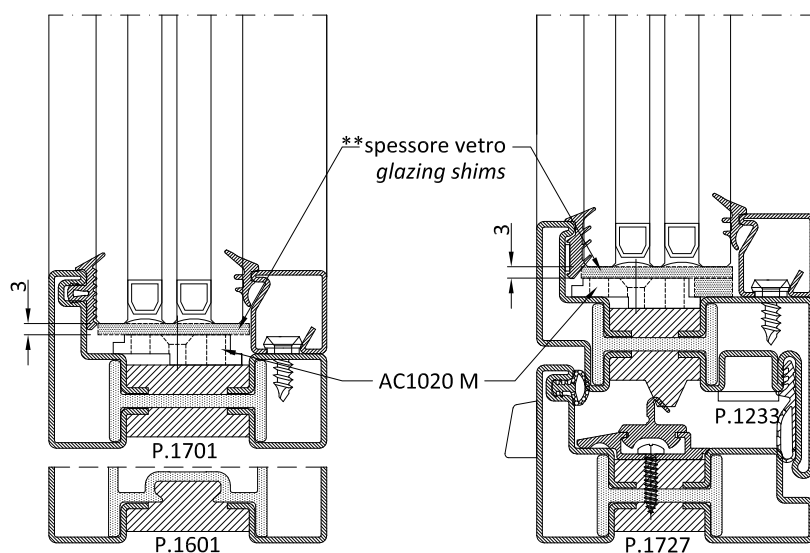
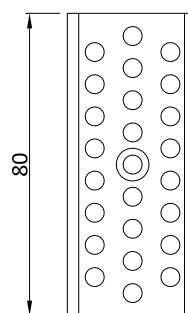


Finestra | Window



1) spessore portante | carry shim

2) spessore distanziatore | compensation shim

AC1020 R
per vetri fino a 22 mm
for glass up to 22 mmAC1020 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 $-1^\circ/+1^\circ$. 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'installazione 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 telaio 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 $+0/+0.5$ mm 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 $-1^\circ/+1^\circ$. 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.

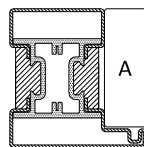
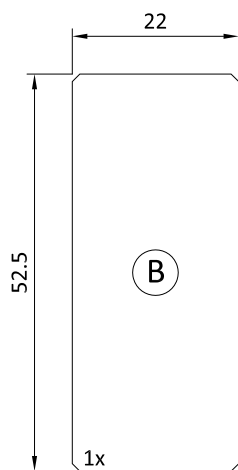
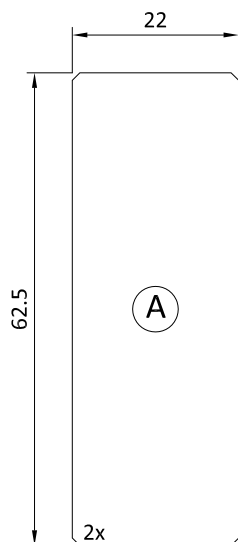
Glass application

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.

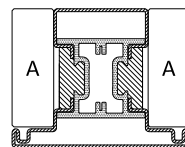
Installation

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.

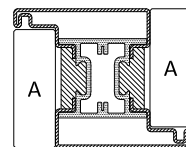
AT1600



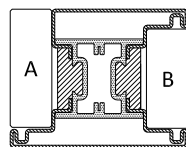
P.1601



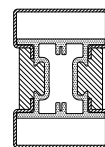
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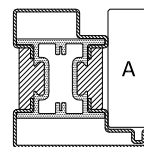
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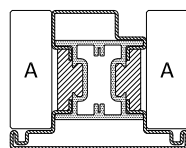
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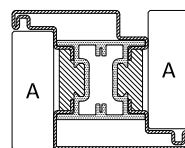
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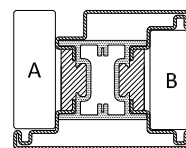
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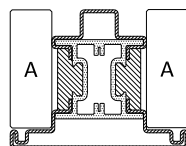
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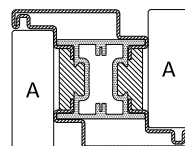
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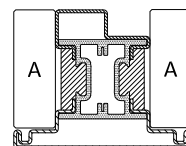
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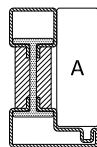
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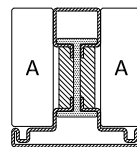
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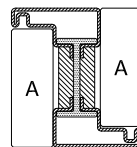
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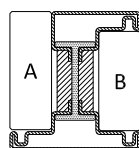
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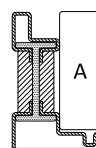
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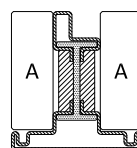
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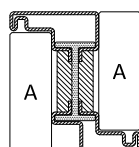
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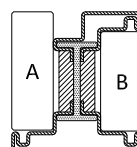
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P.1712



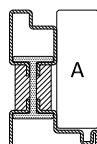
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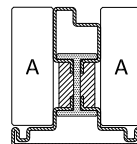
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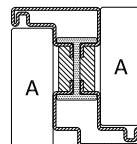
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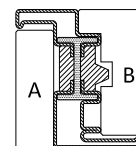
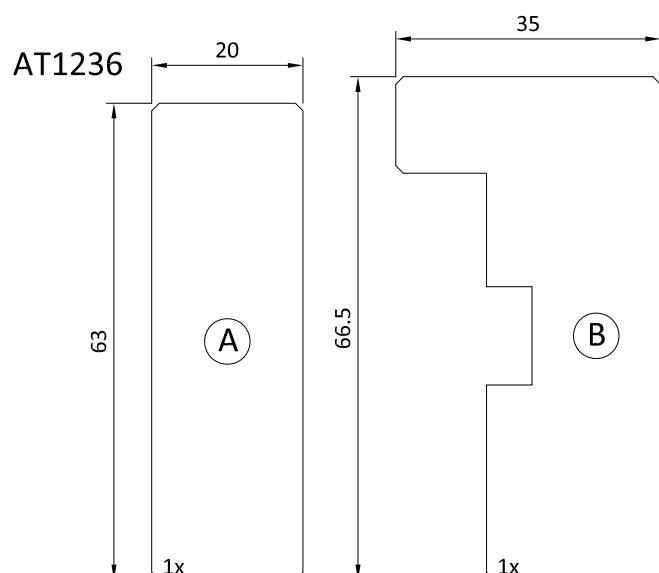
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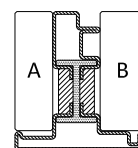
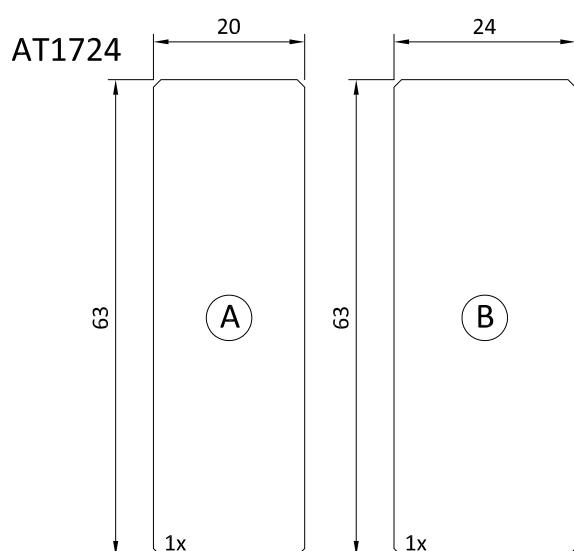
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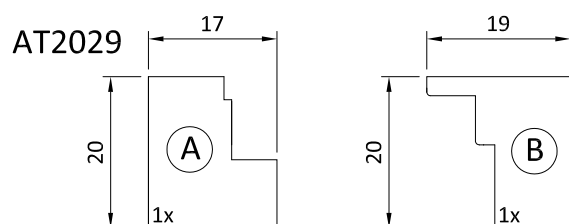
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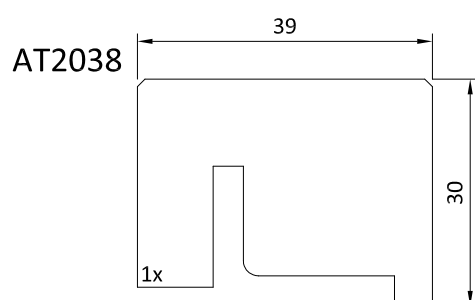
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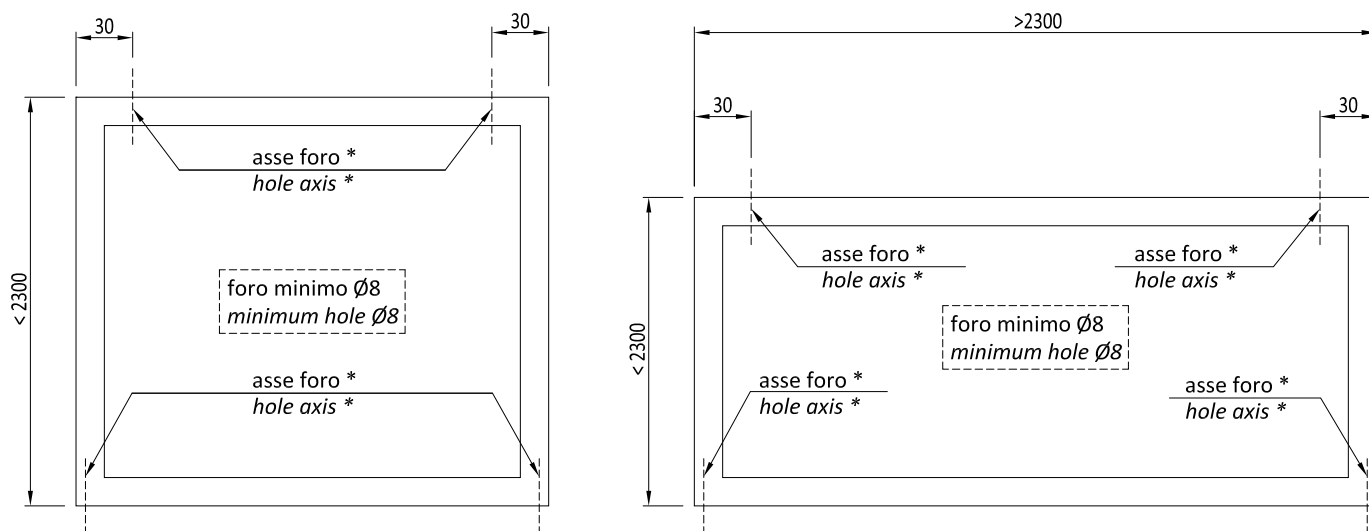
P.1724



P.2028



P.2038



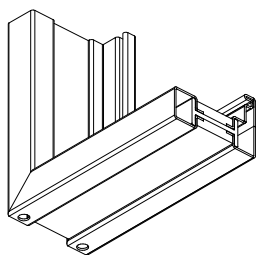
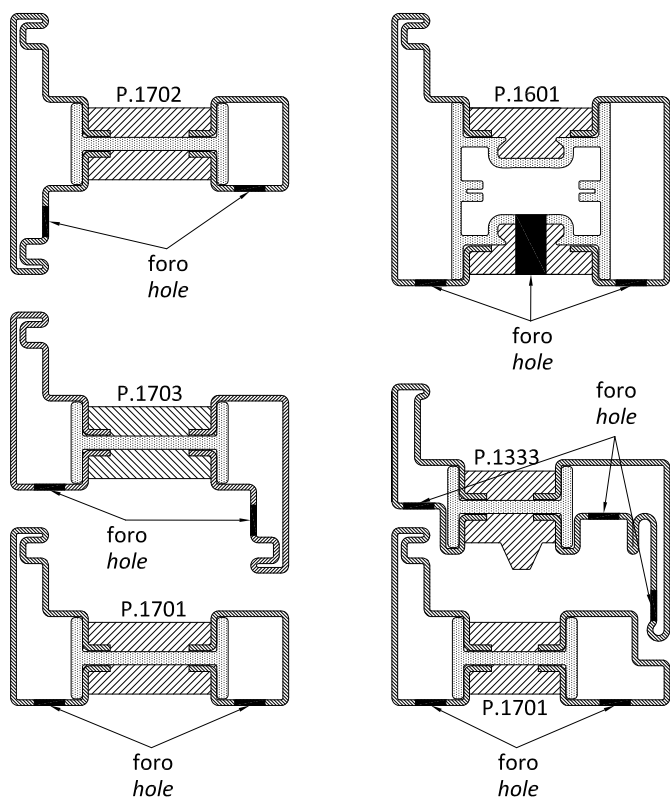
* forare alla massima estremità

* to be drilled on the extremity

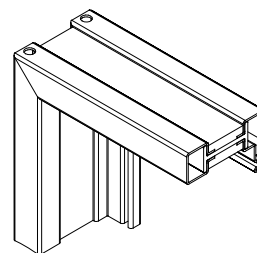
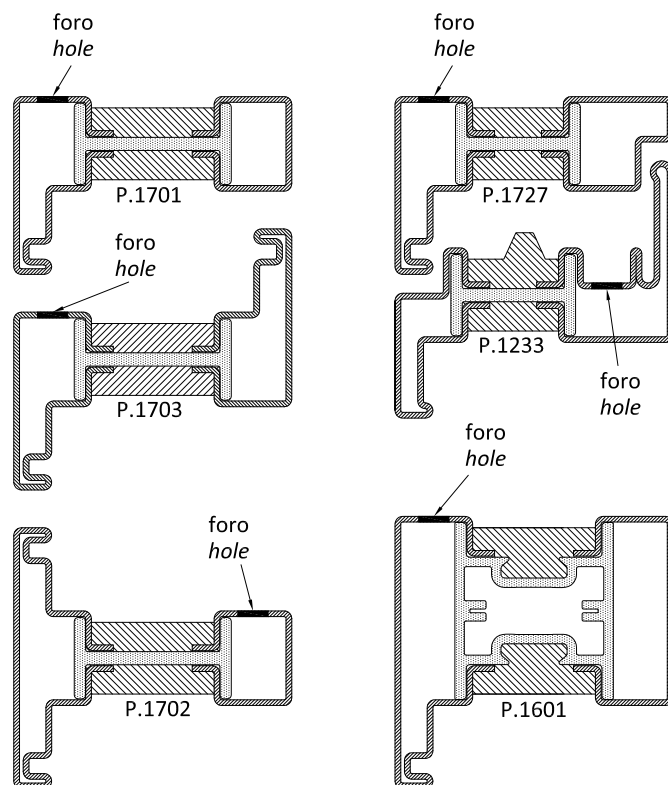
N.B. dimensioni orientamento telai indicative - da verificare con l'impianto di verniciatura/brunitura scelto

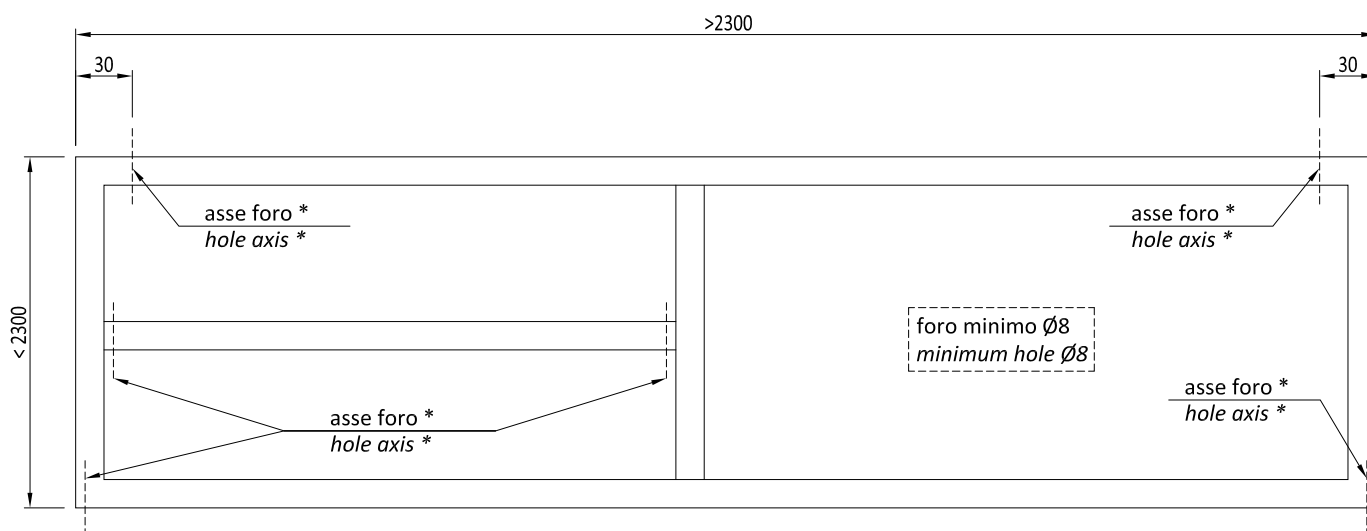
N.B. frame dimensions are indicative - they have to be checked with the powder painting / burnishing plant

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



FORATURA LATO SUPERIORE PER APPENDERE DRILLING UPPER FRAME FOR FRAME HANGING





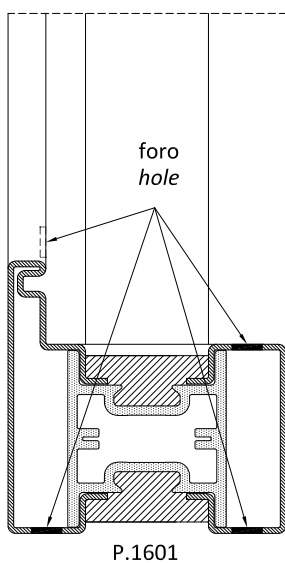
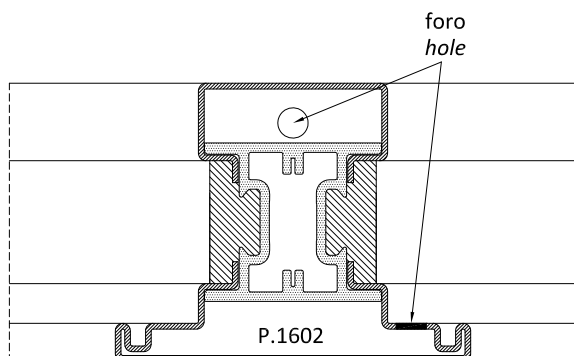
* forare alla massima estremità

* to be drilled on the extremity

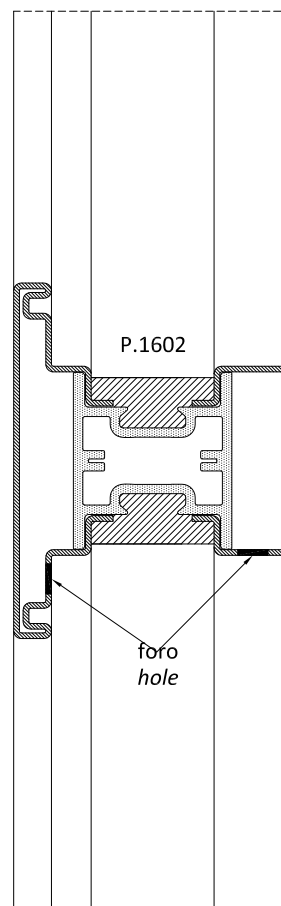
N.B. dimensioni orientamento telai indicative - da verificare con l'impianto di verniciatura/brunitura scelto

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



Troncatricecaratteristiche 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);
- Capacità 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.

Pantografocaratteristiche 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.

Foraturemontaggio 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.

CutterMinimum 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.

PhantographMinimum 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.

DrillingHow 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 Scotch 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/m² 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 is made through several processes: degreasing, pickling and washing. A coating of zinc is then applied through a phosphatising process followed by rinses in demineralised water. A final coat is 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 relieving and then mirror-like polished.

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Secco Sistemi spa
via Terraglio 195
31022 Preganziol TV - Italy
tel. +39 0422 497700
fax +39 0422 497705
info@seccosistemi.it
www.seccosistemi.it