

OS2 65
CATALOGO
TECNICO
TECHNICAL
CATALOGUE

METALFORM™



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Sistema integrato di profili, accessori e guarnizioni a taglio termico con profili aventi sezione in vista 47 mm (nodo laterale) e 62 mm (nodo centrale), idoneo per la realizzazione di porte e finestre a 2 ante, rettangolari, sagomate o curve con o senza fissi laterali e superiori.

I profili in metallo componenti il sistema sono dello spessore di 15/10 mm e sono ottenuti tramite profilatura a freddo di nastri nei vari materiali previsti dal sistema.

Il taglio termico dei profili è realizzato tramite un estruso in poliammide rinforzato con fibra di vetro reso solidale alle parti in metallo esterne da una resina poliuretanica ad alta densità, iniettata ad alta pressione. Il collegamento che si ottiene è continuo, privo di interruzioni e garantisce la massima resistenza torsionale e flettente.

La costruzione dei telai prevede l'unione tra i profili tramite saldatura in continuo delle sezioni in contatto e la successiva ripresa delle superfici in vista, o l'utilizzo di un sistema misto ad assiemaggio meccanico a saldatura interna che non necessita di riprese di finitura.

Il sistema prevede la possibilità di alloggiare **vetri singoli o stratificati** (di sicurezza) a una o più camere.

Caratteristiche del sistema:

Sormonto interno ed esterno delle ante;

Sistema di guarnizioni a giunto aperto con guarnizione centrale di tenuta e guarnizione interna di battuta;

Cerniere ad avvitare negli stessi materiali del profilo per porte e per finestre;

Sistema integrato completo di accessori per lo scarico acqua;

Kit completo per l'apertura ad anta con ferramenta a scomparsa;

Kit per l'alloggiamento di serrature completo di scatole di copertura nei diversi materiali;

Paraspifferi inferiore con guarnizione a pinna.

Thermally insulated integrated system of profiles, accessories and gaskets with visible section of 47 mm (lateral section) and 62 mm (central section) suitable for rectangular, trapezoidal, arched shaped double leafed doors and windows for door and window 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).

Features of the system:

Surmounted internal and external design of the sections ;

Central and rebate gasket placed for the best water, wind, air tightness and acoustic performances ;

High capacity to be screwed in the same material of the profile ;

Integrated system complete of accessories for water drain ;

Concealed hardware for side-hung windows ;

Complete kit for lock with coverings in the same material of the profile ;

Special drop down seal with fin.

PRESTAZIONI

Sistema finestre

Trasmittanza termica (EN ISO 10077-2)

-Nodo tipo (acciaio inox) con $U_f = 3,10 \text{ W/m}^2\text{K}$

Isolamento acustico (DIN 52210 / DIN EN ISO 717-1)

-Fino a 43 dB

Resistenza all'aria (DIN EN 12207)

-Classe 4

Resistenza all'acqua (DIN EN 12208)

-Classe 8A

Resistenza al vento (DIN EN 12210)

-Classe C4

Prova di durata a cicli di apertura (DIN EN 1197-12400)

-Classe 2 - 10.000 cicli

PERFORMANCES

Windows system

Thermal transmittance (EN ISO 10077-2)

-Typical section (stainless steel) with $U_f = 3,10 \text{ W/m}^2\text{K}$

Acoustic performance (DIN 52210 / DIN EN ISO 717-1)

-Up to 43 dB

Air permeability (DIN EN 12207)

-Class 4

Watertightness (DIN EN 12208)

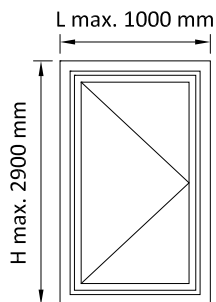
-Class 8A

Resistance to wind load (DIN EN 12210)

-Class C4

Resistance to repeated opening and closing (DIN EN 1197-12400)

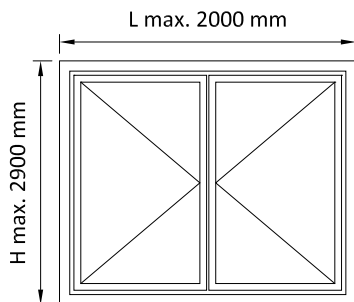
-Class 2 - 10 000 opening and closing

Limiti dimensionali - Maximum dimension

finestra ad un anta apertura INTERNA
one-leaf INWARD opening windows

peso massimo anta*
maximum leaf weight*

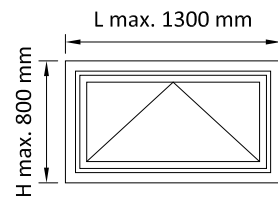
AC2628	- 100 kg
AC2629-30	- 50 kg
AC2631/A	- 40 kg
AC2631/B	- 70 kg
AC2632/B	- 70 kg



finestra a due ante apertura INTERNA
two-leaf INWARD opening windows

peso massimo anta*
maximum leaf weight*

AC2628	- 100 kg
AC2629-30	- 50 kg
AC2631/A	- 40 kg
AC2631/B	- 70 kg
AC2632/B	- 70 kg



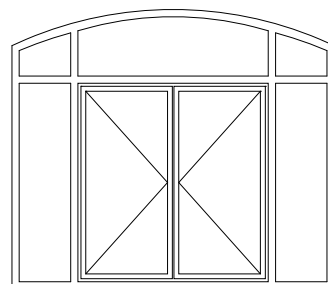
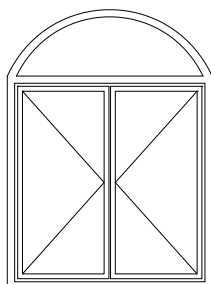
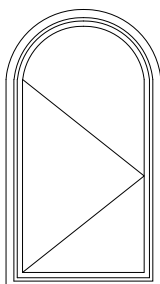
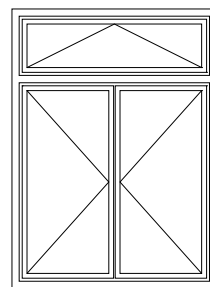
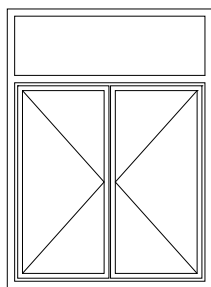
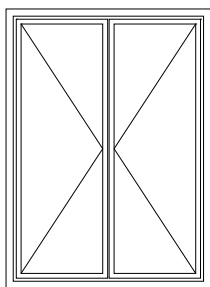
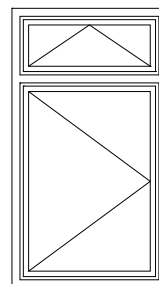
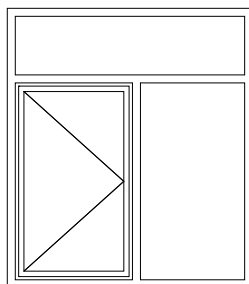
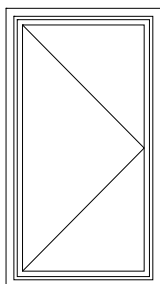
finestra vasistas apertura INTERNA
bottom-hung window

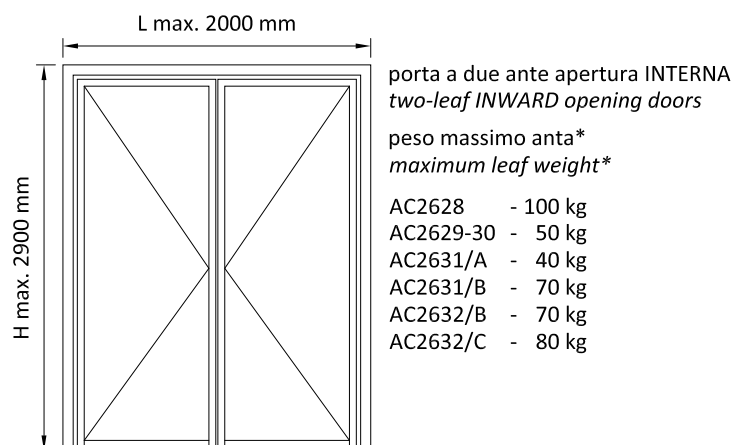
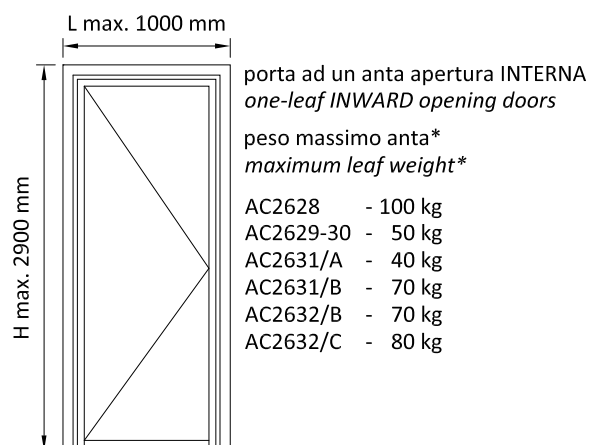
peso massimo anta*
maximum leaf weight*

AC2628	- 40 kg
AC2629-30	- 40 kg
AC2631/A	- 40 kg
AC2631/B	- 40 kg
AC2632/B	- 40 kg
AC2639	- 40 kg

* cerniera aggiuntiva per H serramento > 1300 mm - vedi distinte di taglio capitolo 4.2

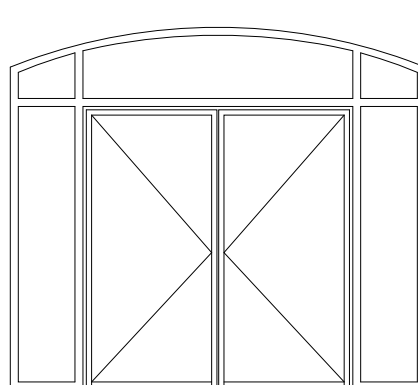
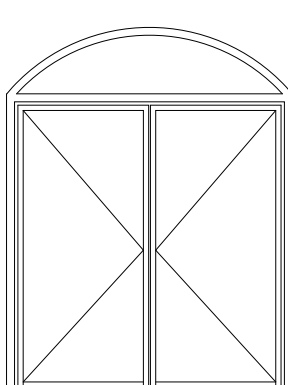
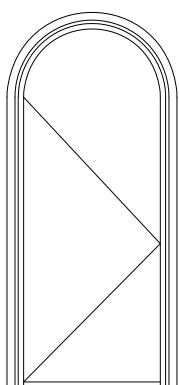
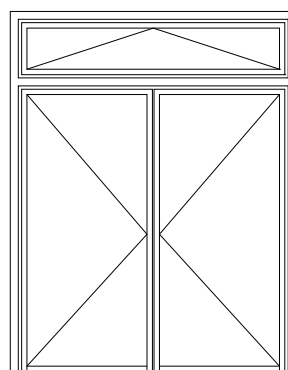
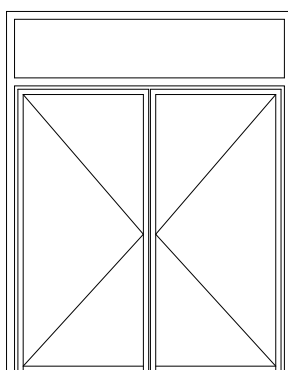
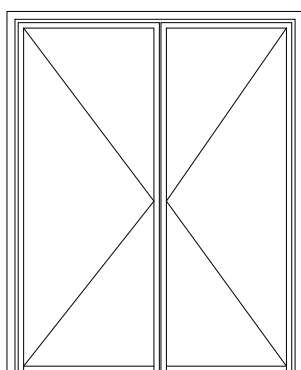
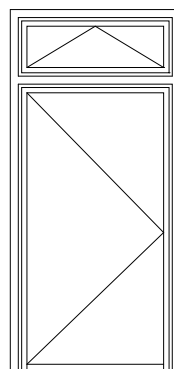
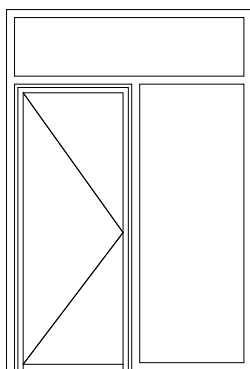
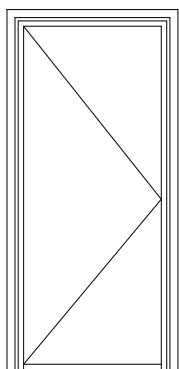
* additional hinge for windows with height > 1300 mm - see cutting list chapter 4.2

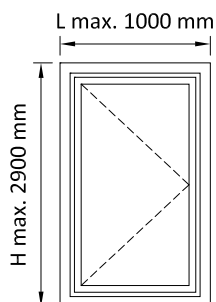
Esempi tipologie realizzabili - Types of windows

Limiti dimensionali - Maximum dimension

* cerniera aggiuntiva per H serramento > 2300 mm - vedi distinte di taglio capitolo 4.2

* additional hinge for doors with height > 2300 mm - See cutting list chapter 4.2

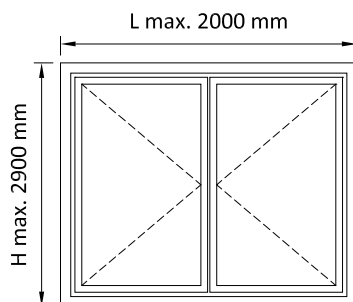
Esempi tipologie realizzabili - Types of door

Limiti dimensionali - Maximum dimension

finestra ad un anta apertura ESTERNA
one-leaf OUTWARD opening windows

peso massimo anta*
maximum leaf weight*

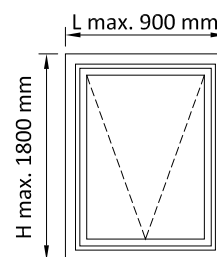
AC2631/A	- 40 kg
AC2631/B	- 70 kg
AC2632/B	- 70 kg
AC2648	- 100 kg
AC2649-50	- 50 kg



finestra a due ante apertura ESTERNA
two-leaf OUTWARD opening windows

peso massimo anta*
maximum leaf weight*

AC2631/A	- 40 kg
AC2631/B	- 70 kg
AC2632/B	- 70 kg
AC2648	- 100 kg
AC2649-50	- 50 kg



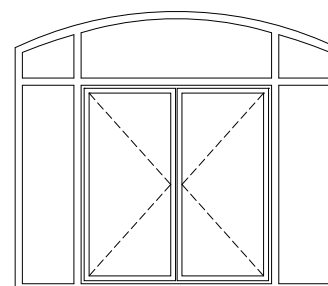
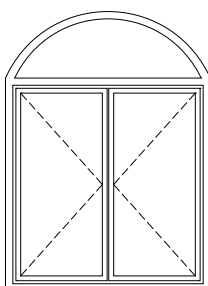
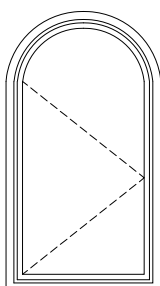
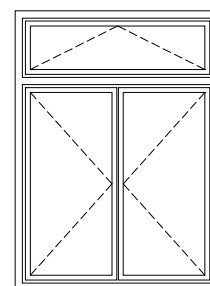
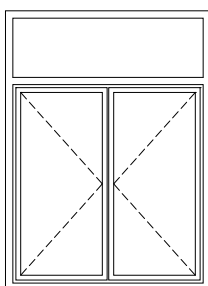
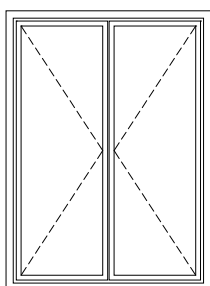
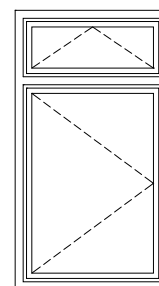
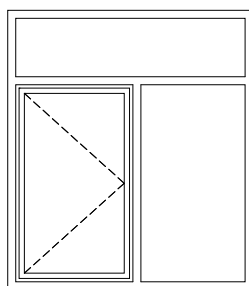
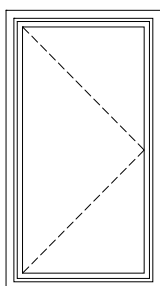
finestra a sporgere apertura ESTERNA
awning window

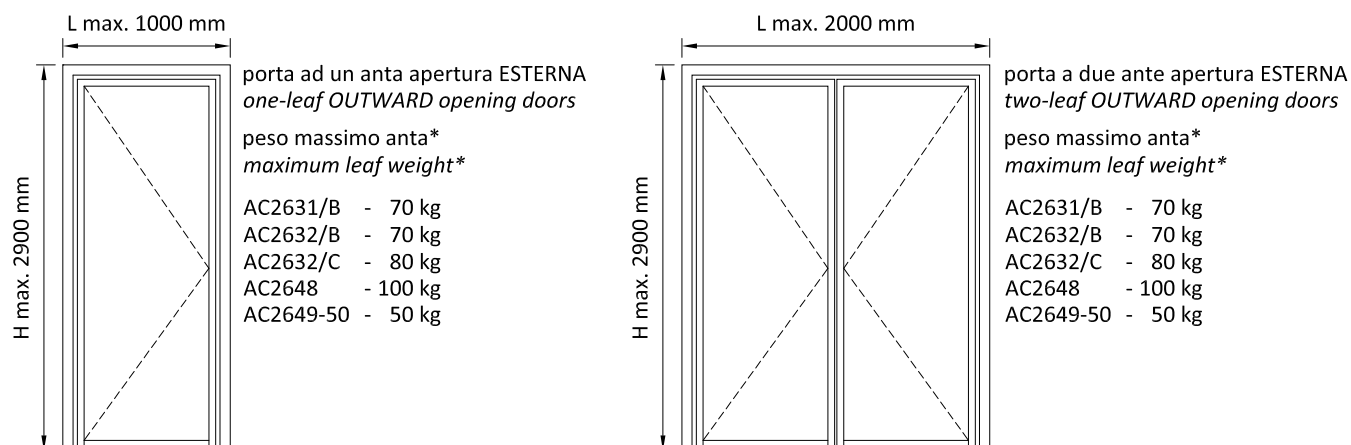
peso massimo anta*
maximum leaf weight*

AC2631/A	- 40 kg
AC2631/B	- 40 kg
AC2632/B	- 40 kg
AC2648	- 40 kg
AC2649-50	- 40 kg
AC2688	- 100 kg
AC2689	- 40 kg

* cerniera aggiuntiva per H serramento > 1300 mm - vedi distinte di taglio capitolo 4.2

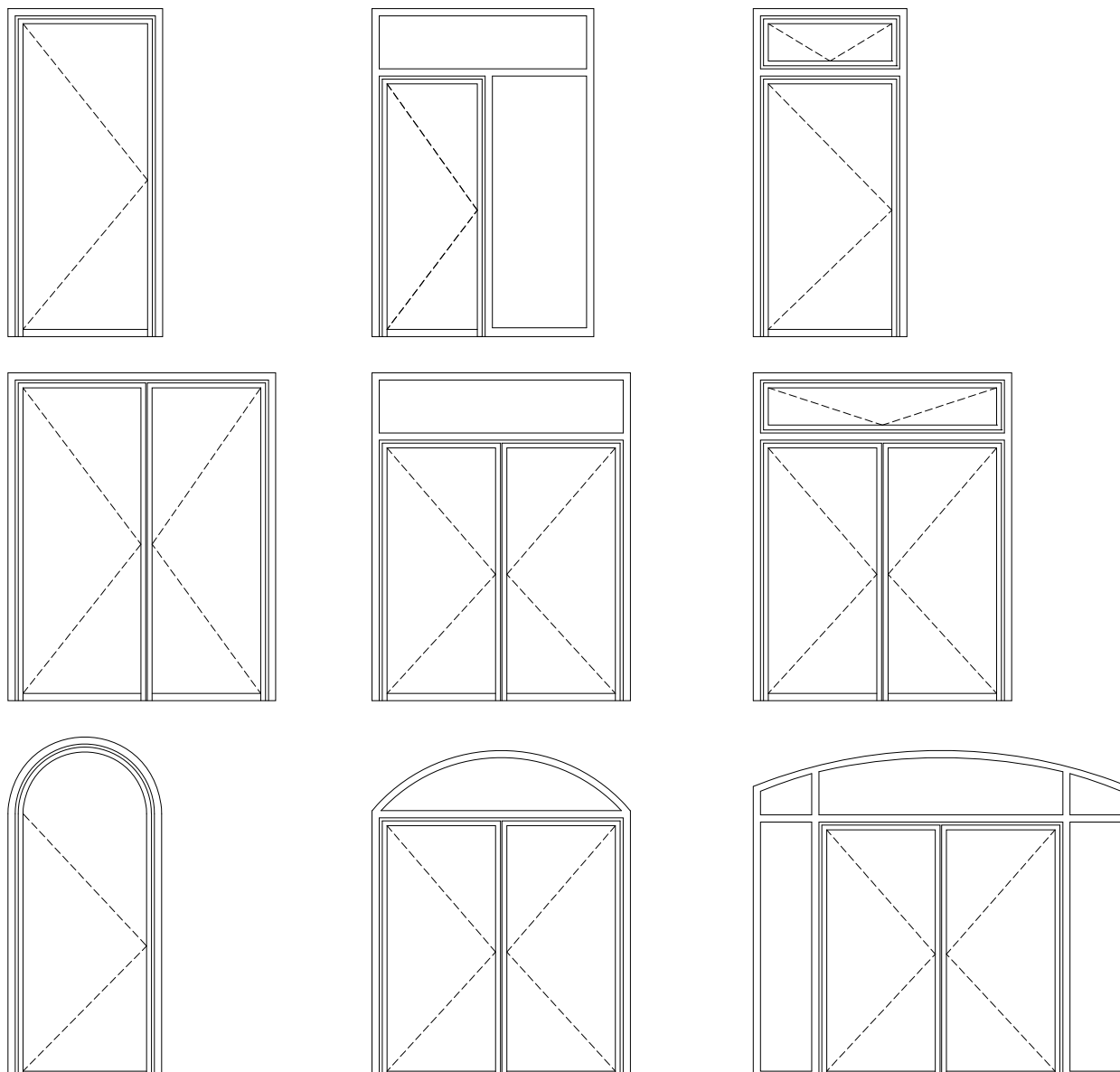
* additional hinge for windows with height > 1300 mm - see cutting list chapter 4.2

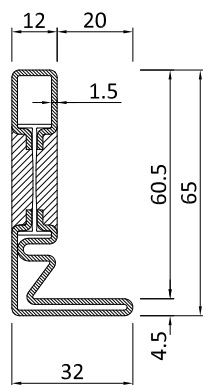
Esempi tipologie realizzabili - Types of windows

Limiti dimensionali - Maximum dimension

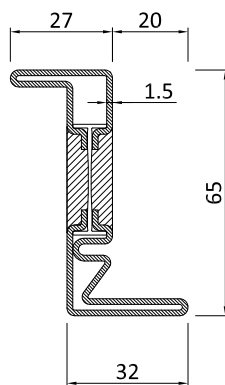
* cerniera aggiuntiva per H serramento > 2300 mm - vedi distinte di taglio capitolo 4.2

* additional hinge for doors with height > 2300 mm - See cutting list chapter 4.2

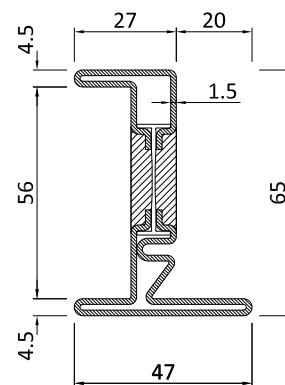
Esempi tipologie realizzabili - Types of door



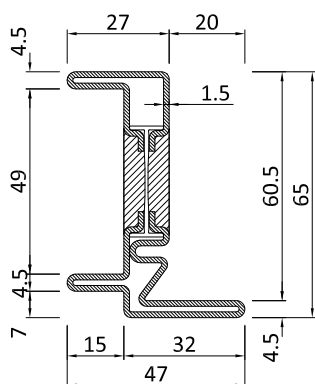
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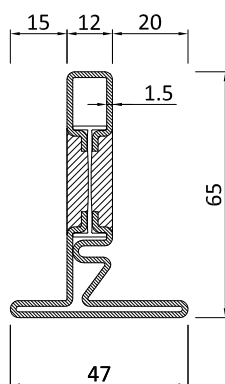
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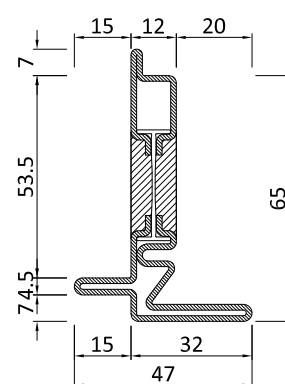
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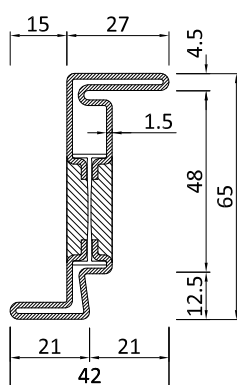
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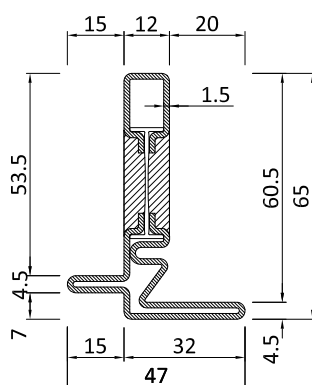
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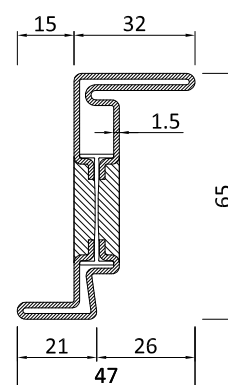
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P.2833

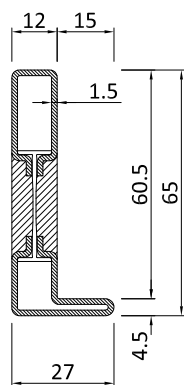


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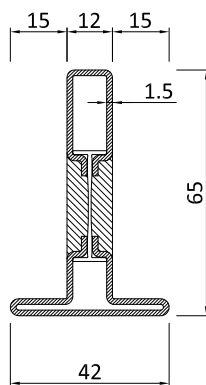


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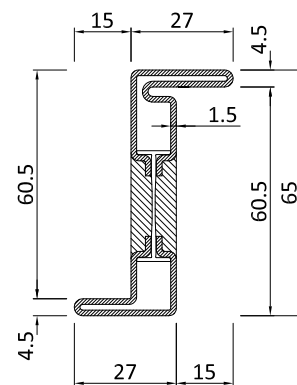
Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m	Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m
	ZN / I - CT	OT						ZN / I - CT	OT				
P.2801	2,37	2,54	0,22	11,33	1,78	6,0	P.2832	2,82	3,03	0,26	15,07	2,89	6,0
P.2803	2,71	2,91	0,24	15,05	2,80	6,0	P.2833	2,51	2,68	0,23	13,98	1,97	6,0
P.2805	3,03	3,26	0,27	16,80	3,80	6,0	P.2842	2,65	2,85	0,24	11,85	2,86	6,0
P.2815	2,99	3,22	0,27	15,83	3,70	6,0	P.2843	2,63	2,80	0,24	14,70	2,72	6,0
P.2822	2,69	2,89	0,25	12,60	2,97	6,0							



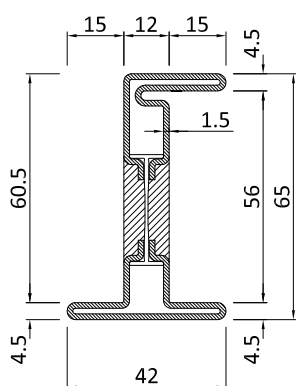
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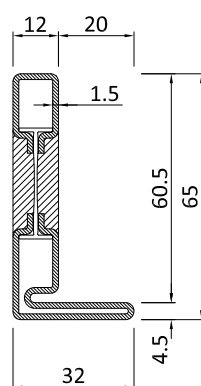
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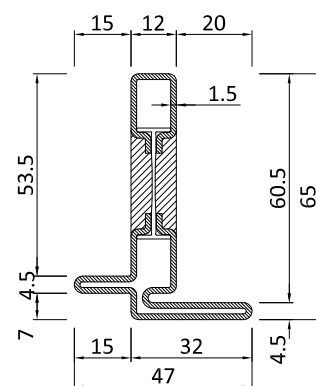
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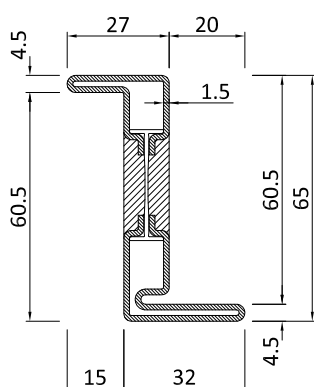
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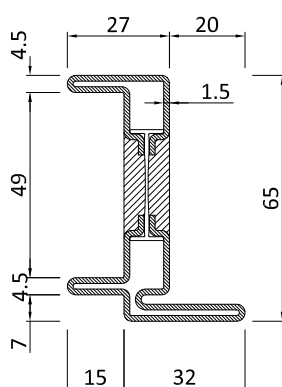
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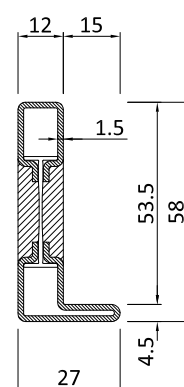
P.2862



P.2863

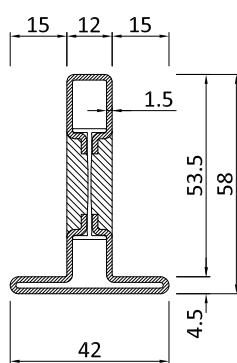


P.2865

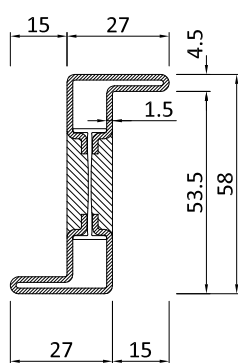


P.2871

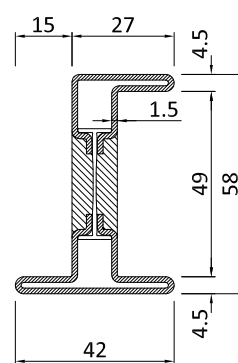
Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m	Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m
	ZN / I - CT	OT						ZN / I - CT	OT				
P.2851	2,02	2,16	0,18	10,39	1,09	6,0	P.2862	2,57	2,76	0,24	11,90	2,97	6,0
P.2852	2,35	2,52	0,21	11,95	2,18	6,0	P.2863	2,64	2,83	0,24	15,19	2,79	6,0
P.2853	2,52	2,71	0,23	14,47	2,06	6,0	P.2865	2,95	3,13	0,26	15,96	3,82	6,0
P.2855	2,85	3,07	0,25	16,82	2,95	6,0	P.2871	1,85	1,98	0,17	7,82	1,02	6,0
P.2861	2,30	2,46	0,21	11,45	1,74	6,0							



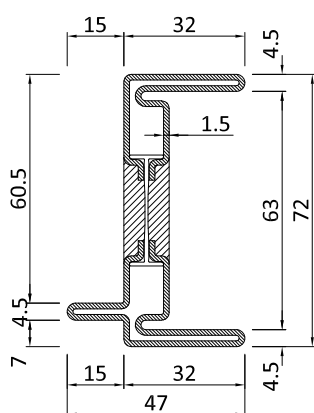
P.2872



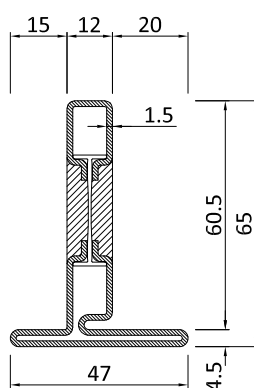
P.2873



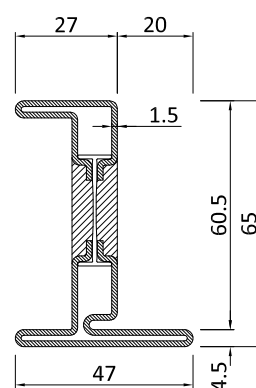
P.2874



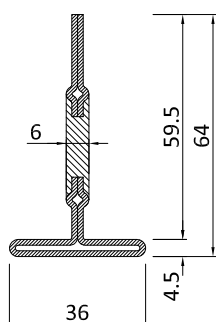
P.2875



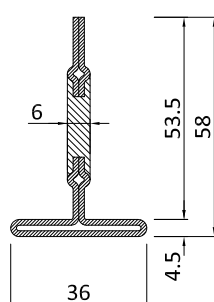
P.2882



P.2885



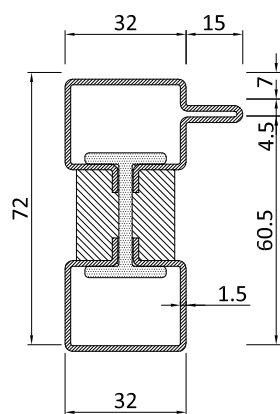
P.2654

Non fornito in Inox
Not in Inox

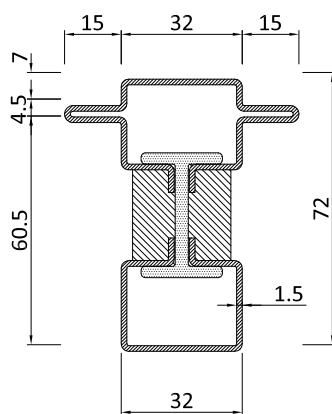
P.2664

Non fornito in Inox
Not in Inox

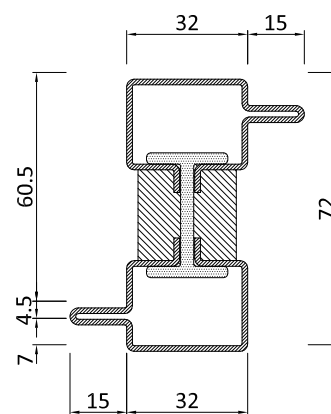
Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m
	ZN / I - CT	OT				
P.2872	2,18	2,34	0,20	9,00	2,12	6,0
P.2873	2,19	2,35	0,20	10,44	3,32	6,0
P.2874	2,52	2,71	0,23	12,17	2,87	6,0
P.2875	3,36	3,61	,030	22,81	4,36	6,0
P.2882	2,62	2,81	0,24	12,68	2,98	6,0
P.2885	2,96	3,18	0,26	16,03	4,41	6,0
P.2654	2,42	2,62	0,20	12,28	1,20	6,0
P.2664	2,28	2,47	0,19	9,23	1,20	6,0



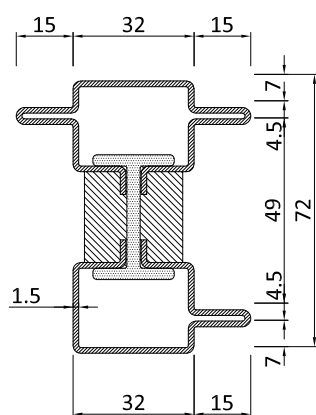
P.2891



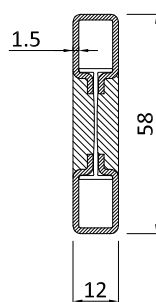
P.2892



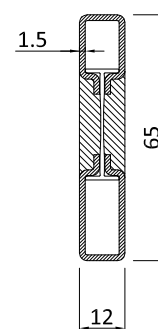
P.2893



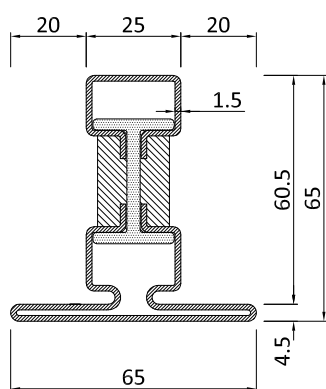
P.2895



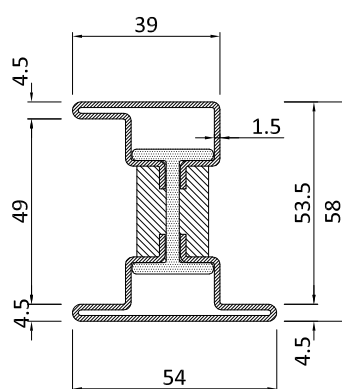
P.2830



P.2831

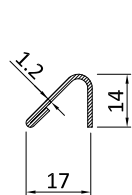


P.2652

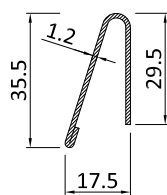


P.2655

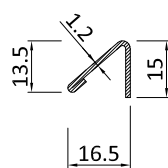
Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m
	ZN / I - CT	OT				
P.2891	4,14	4,41	0,23	13,58	6,59	3,0
P.2892	4,37	4,66	0,26	14,44	9,44	3,0
P.2893	4,37	4,66	0,26	14,93	10,56	3,0
P.2895	4,60	4,91	0,28	15,96	11,62	3,0
P.2830	1,51	1,61	0,14	8,16	0,30	6,0
P.2831	1,68	1,79	0,16	7,95	0,36	6,0
P.2652	3,97	4,24	0,29	22,02	9,37	3,0
P.2655	3,43	3,66	0,25	14,00	6,82	3,0



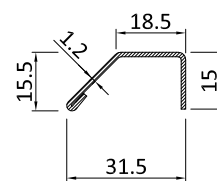
P.2620



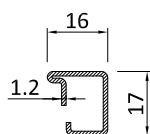
P.2660



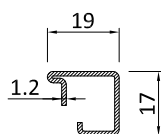
P.2670



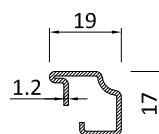
P.2671



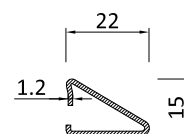
P.2606



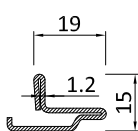
P.2607



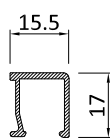
P.2627



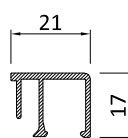
P.2629



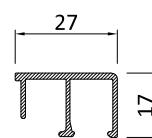
P.2638



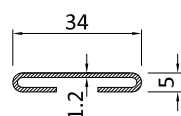
PA2606



PA2607



PA2608



P.2610

MATERIALE | MATERIAL

PZ _ _ _ _ acciaio zincato | *galvanized steel*PC _ _ _ _ GZ acciaio corten grezzo | *untreated corten steel*PI _ _ _ _ SB acciaio inox scotch brite | *stainless steel scotch brite*PB _ _ _ _ BR ottone grezzo | *untreated brass*

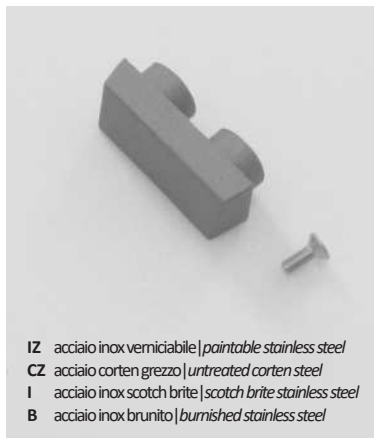
Profilo / Profile n°	P Kg/m		A m²/m	Jx cm⁴	Jy cm⁴	L m	Profilo / Profile n°	P Kg/m		A m²/m	Jx cm⁴	Jy cm⁴	L m
	ZN / I - CT	OT						ZN / I - CT	OT				
P.2620	0,24	0,27				4,0	P.2629	0,49	0,53				6,0
P.2660	0,73	0,79				4,0	P.2638	0,60	0,65				6,0
P.2670	0,40	0,43				4,0	PA2606	0,17	Alluminio				6,0
P.2671	0,50	0,59				4,0	PA2607	0,23	Alluminio				6,0
P.2606	0,48	0,52				6,0	PA2608	0,26	Alluminio				6,0
P.2607	0,51	0,55				6,0	P.2610	0,53	0,57				4,0
P.2627	0,47	0,51				6,0							

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.

**AC 2608**

Clips per fissaggio fermavetri
P2606 - P2607 - P2627
P2629 - P2638

*Clips for securing
P2606 - P2607 - P2627
P2629 - P2638
glazing beads*

**AC 2618**

Scarico acqua per aperture
interne in metallo

Metal drip for inward openings

ACB 219.BR

Scarico acqua per aperture
interne in ottone naturale

*Natural brass drip for inward
openings*

**AC 2609**

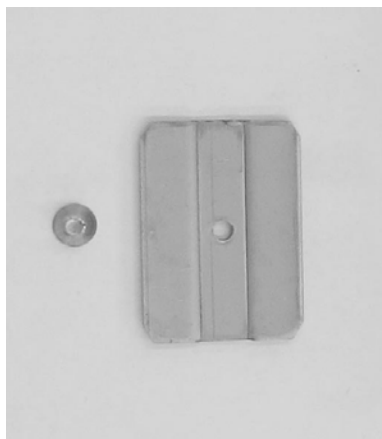
Clips per fissaggio fermavetri
su profilo P.2654 - P.2664

*Clips for securing glazing beads
on P.2654 - P.2664 profile*

**AC 2618NE**

Scarico acqua per aperture
interne in plastica nera
Non verniciabile

*Black plastic drip for inward
openings
Non paintable*

**AC 2610I**

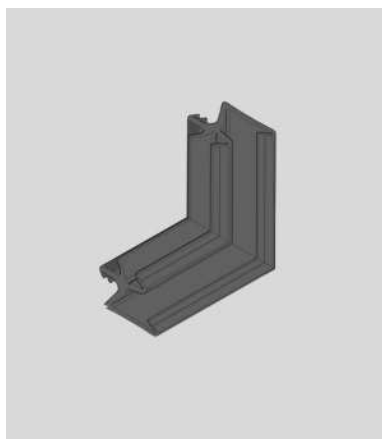
Accessorio fissaggio P.2610

Securing fitting for P.2610

**AC 2621GA**

Catenaccio 2^ anta per
porte/finestre L = 140 mm

*Second leaf flush bolt for
doors/windows L = 140 mm*

**AC 2617N**

Guarnizione d'angolo
vulcanizzata per GE 2603

*Vulcanised corner gasket
for GE 2603*

**AC 2621GC**

Catenaccio 2^ anta per porta
L = 650 mm

*Second leaf flush bolt for doors
L = 650 mm*

**AC 2622**

Fermo a scatto chiusura 2^a anta per finestra

Snapper for 2nd window leaf

**AC 2624E D**

Kit cremonese dx per finestre a due ante
Gratz con maniglia removibile
RH cremone bolt set for double leaf windows

Gratz mechanism with removable handle

AC 2624E S

Kit cremonese sx per finestre a due ante
Gratz con maniglia removibile
LH cremone bolt set for double leaf windows
Gratz mechanism with removable handle

**AC 2623D**

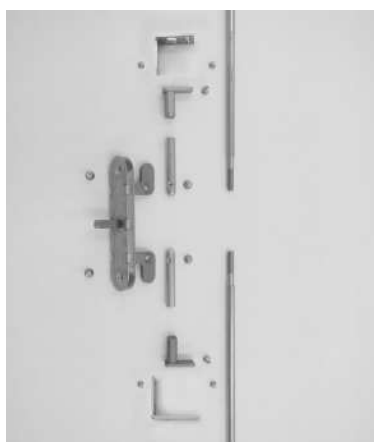
Kit cremonese dx per finestre ad un anta | P.2833

RH cremone bolt set for single leaf windows | P.2833

AC 2623S

Kit cremonese sx per finestre ad un anta | P.2833

LH cremone bolt set for single leaf windows | P.2833

**AC 2625D**

Kit cremonese dx per finestre ad un anta | P.2843

RH cremone bolt set for single leaf windows | P.2843

AC 2625S

Kit cremonese sx per finestre ad un anta | P.2843

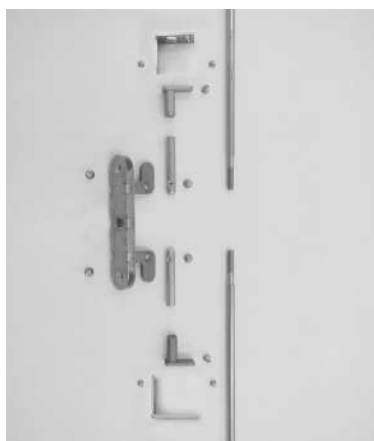
LH cremone bolt set for single leaf windows | P.2843

**AC 2623E D**

Kit cremonese dx per finestre ad un anta | P.2833
Gratz con maniglia removibile
RH cremone bolt set for single leaf windows | P.2833
Gratz mechanism with removable handle

AC 2623E S

Kit cremonese sx per finestre ad un anta | P.2833
Gratz con maniglia removibile
LH cremone bolt set for single leaf windows | P.2833
Gratz mechanism with removable handle

**AC 2625E D**

Kit cremonese dx per finestre ad un anta | P.2843
Gratz con maniglia removibile
RH cremone bolt set for single leaf windows | P.2843
Gratz mechanism with removable handle

AC 2625E S

Kit cremonese sx per finestre ad un anta | P.2843
Gratz con maniglia removibile
LH cremone bolt set for single leaf windows | P.2843
Gratz mechanism with removable handle

**AC 2624D**

Kit cremonese dx per finestre a due ante

RH cremone bolt set for double leaf windows

AC 2624S

Kit cremonese sx per finestre a due ante

LH cremone bolt set for double leaf windows

**AC 2626R**

Punto di chiusura aggiuntivo per finestra

Additional locking point for windows

**AC 2627**

Chiusura mediana lato cerniere

Hinge-side middle closing**AC 2631/A**Cerniera a due ali in acciaio
zincato a saldare | Ø 10
Peso max anta 40 kg*Weld-on hinge in galvanised
steel | Ø 10
Max leaf weight 40 kg*

AISI 304

AC 2628Cerniera a tre ali da avvitare
P.2833
Peso max anta 100 kg*Three-wing screw-on hinge
P.2833
Max leaf weight 100 kg*

GZ acciaio zincato
galvanized steel
CZ acciaio corten
corten steel
I acciaio inox scotch brite
scotch brite stainless steel
B acciaio inox brunito
burnished stainless steel

**AC 2631/B**Cerniera a due ali in acciaio
zincato a saldare | Ø 13
Peso max anta 70 kg*Weld-on hinge in galvanised
steel | Ø 13
Max leaf weight 70 kg*

AISI 304

AC 2629Cerniera dx a due ali da avvitare
P.2833
Peso max anta 50 kg*RH two-wing screw-on hinge
P.2833
Max leaf weight 50 kg*

IZ acciaio inox verniciabile | paintable stainless steel
CZ acciaio corten grezzo | untreated corten steel
I acciaio inox scotch brite | scotch brite stainless steel
B acciaio inox brunito | burnished stainless steel

**AC 2632/B**Cerniera registrabile a due ali
in acciaio zincato a saldare | Ø 13
Peso max anta 70 kg*Adjustable weld-on hinge
in galvanised steel | Ø 13
Max leaf weight 70 kg*

AISI 304

AC 2630Cerniera sx a due ali da avvitare
P.2833
Peso max anta 50 kg*LH two-wing screw-on hinge
P.2833
Max leaf weight 50 kg*

IZ acciaio inox verniciabile | paintable stainless steel
CZ acciaio corten grezzo | untreated corten steel
I acciaio inox scotch brite | scotch brite stainless steel
B acciaio inox brunito | burnished stainless steel

**AC 2632/C**Cerniera registrabile a due ali
in acciaio zincato a saldare | Ø 16
Peso max anta 80 kg*Adjustable weld-on hinge
in galvanised steel | Ø 16
Max leaf weight 80 kg*

**AC 2636**

Guarnizione automatica di tenuta sotto porta

Automatic bottom seal

AC2636/Z lunghezza/length 315 - 430 mm
 AC2636/A lunghezza/length 380 - 530 mm
 AC2636/B lunghezza/length 480 - 630 mm
 AC2636/C lunghezza/length 580 - 730 mm
 AC2636/D lunghezza/length 680 - 830 mm
 AC2636/E lunghezza/length 780 - 930 mm
 AC2636/F lunghezza/length 880 - 1030 mm
 AC2636/G lunghezza/length 980 - 1130 mm
 AC2636/H lunghezza/length 1080 - 1230 mm

**AC 2648**

Cerniera a tre ali da avvitare su P.2843 (apertura interna) su P.2862 (apertura esterna) Peso max anta 100 kg

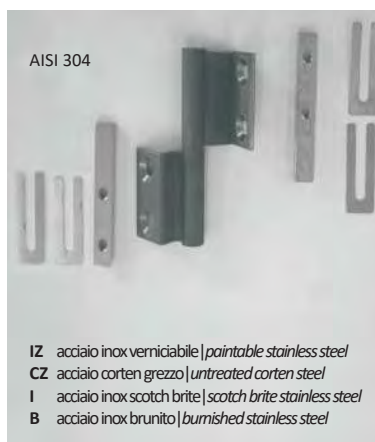
Three-wing screw-on hinge on P.2843 (inward opening) on P.2862 (outward opening) Max leaf weight 100 kg

**AC 2639**

Kit cerniere a scomparsa per vasistas "ochette" Solo per profilo P.2833

Concealed hinges for bottom-hung windows Only for P.2833 profile

IZ acciaio inox verniciabile | paintable stainless steel
 CZ acciaio corten grezzo | untreated corten steel
 I acciaio inox scotch brite | scotch brite stainless steel
 B acciaio inox brunito | burnished stainless steel

**AC 2649**

Cerniera a due ali da avvitare Sx su P.2843 (apertura interna) Dx su P.2862 (apertura esterna) Peso max anta 50 kg

Two-wing screw-on hinge LH on P.2843 (inward opening) RH on P.2862 (outward opening) Max leaf weight 50 kg

IZ acciaio inox verniciabile | paintable stainless steel
 CZ acciaio corten grezzo | untreated corten steel
 I acciaio inox scotch brite | scotch brite stainless steel
 B acciaio inox brunito | burnished stainless steel

**AC 2640**

Cricchetto per vasistas

Finger catch for bottom-hung windows

GZ ottone grezzo verniciabile paintable untreated brass
 B ottone brunito burnished brass

**AC 2650**

Cerniera a due ali da avvitare Dx su P.2843 (apertura interna) Sx su P.2862 (apertura esterna) Peso max anta 50 kg

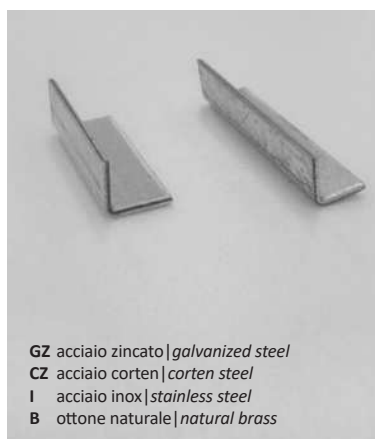
Two-wing screw-on hinge RH on P.2843 (inward opening) LH on P.2862 (outward opening) Max leaf weight 50 kg

IZ acciaio inox verniciabile | paintable stainless steel
 CZ acciaio corten grezzo | untreated corten steel
 I acciaio inox scotch brite | scotch brite stainless steel
 B acciaio inox brunito | burnished stainless steel

**AC 2641**

Braccetti per vasistas Peso max anta 40 Kg

Stays for bottom-hung windows Max leaf weight 40 kg

**AC 2651**

Kit fondini per profili P.2832 - P.2833

Fittings kit for profiles P.2832 - P.2833

GZ acciaio zincato | galvanized steel
 CZ acciaio corten | corten steel
 I acciaio inox | stainless steel
 B ottone naturale | natural brass



GZ acciaio zincato | *galvanized steel*
CZ acciaio corten | *corten steel*
I acciaio inox | *stainless steel*
B ottone naturale | *natural brass*

AC 2652

Kit fondini per profili
 P.2842 - P.2843

Fittings kit for profiles
 P.2842 - P.2843



GZ acciaio zincato | *galvanized steel*
CZ acciaio corten | *corten steel*
I acciaio inox | *stainless steel*
B ottone naturale | *natural brass*

AC 2659

Fondino per profili
 P.2875 | P.2891 | P.2892
 P.2893 | P.2895
 (apertura esterna)

Fittings for profiles
 P.2875 | P.2891 | P.2892
 P.2893 | P.2895
 (outward opening)



GZ acciaio zincato | *galvanized steel*
CZ acciaio corten | *corten steel*
I acciaio inox | *stainless steel*
B ottone naturale | *natural brass*

AC 2653

Kit fondini per profili
 P.2862 - P.2863

Fittings kit for profiles
 P.2862 - P.2863



GZ ottone grezzo verniciabile | *paintable untreated brass*
B ottone brunito | *burnished brass*
CZ acciaio corten grezzo | *untreated corten steel*
SB acciaio inox scotch brite | *scotch-brite stainless steel*

AC 2680

Maniglia di trascinamento
 per aperture esterne

*Pulling handle for outward
 opening*



GZ acciaio zincato | *galvanized steel*
CZ acciaio corten | *corten steel*
I acciaio inox | *stainless steel*
B ottone naturale | *natural brass*

AC 2654

Fondini per profili
 P.2842 - P.2805 (P.2855)

Fittings for profiles
 P.2842 - P.2805 (P.2855)

**AC 2683D**

Kit cremonese dx per finestre
 ad un anta - apertura esterna

*RH cremone bolt set for single leaf
 windows - outward opening*

AC 2683S

Kit cremonese sx per finestre
 ad un anta - apertura esterna

*LH cremone bolt set for single leaf
 windows - outward opening*



GZ acciaio zincato | *galvanized steel*
CZ acciaio corten | *corten steel*
I acciaio inox | *stainless steel*
B ottone naturale | *natural brass*

AC 2658

Fondino per profili
 P.2875 | P.2891 | P.2892
 P.2893 | P.2895
 (apertura interna)

Fittings for profiles
 P.2875 | P.2891 | P.2892
 P.2893 | P.2895
 (inward opening)

**AC 2683E D**

Kit cremonese dx per finestre
 ad un anta - apertura esterna
 Gratz con maniglia removibile
*RH cremone bolt set for single leaf
 windows - outward opening
 Gratz mechanism with removable handle*

AC 2683E S

Kit cremonese sx per finestre
 ad un anta - apertura esterna
 Gratz con maniglia removibile
*LH cremone bolt set for single leaf
 windows - outward opening
 Gratz mechanism with removable handle*

**AC 2684D**

Kit cremonese dx per finestre
a due ante - apertura esterna

*RH cremone bolt set for double
leaf windows - outward opening*

AC 2684S

Kit cremonese sx per finestre
a due ante - apertura esterna

*LH cremone bolt set for double leaf
windows - outward opening*

**AC 2687**

Braccetto limitatore di apertura
esterna finestra con blocco

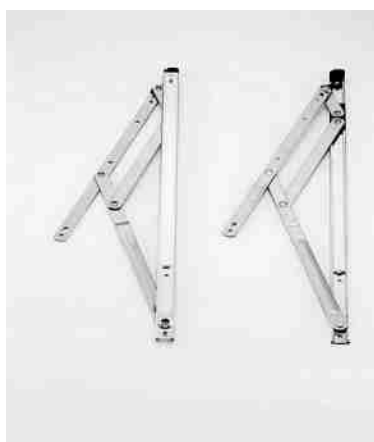
*Casement stay
outward opening*

**AC 2684E D**

Kit cremonese dx per finestre
a due ante - apertura esterna
Gratz con maniglia removibile
*RH cremone bolt set for double
leaf windows - outward opening
Gratz mechanism with removable handle*

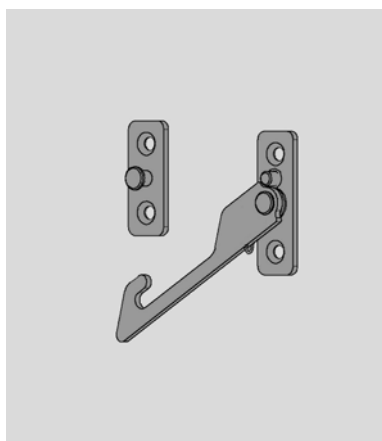
AC 2684E S

Kit cremonese sx per finestre
a due ante - apertura esterna
Gratz con maniglia removibile
*LH cremone bolt set for double leaf
windows - outward opening
Gratz mechanism with removable handle*

**AC 2688**

Coppia compassi
apertura a sporgere
Peso massimo anta 100 kg

*Pair of side arms for
awning opening
Max leaf weight 100 kg*

**AC 2685D**

Limitatore di apertura per aereazione
Ap. interna dx | Ap. esterna sx

*Window ventilation restrictor
RH inward op. | LH outward op.*

AC 2685S

Limitatore di apertura per aereazione
Ap. interna sx | Ap. esterna dx

*Window ventilation restrictor
LH inward op. | RH outward op.*

**AC 2689**

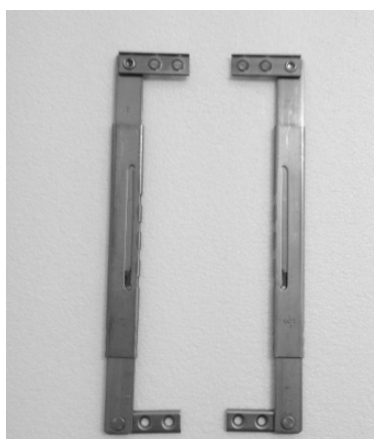
Coppia compassi
apertura a sporgere
Peso massimo anta 40 kg

*Pair of side arms for
awning opening
Max leaf weight 40 kg*

**AC 2686**

Braccetto limitatore di apertura
senza blocco

Window restrictor

**AC 2690**

Braccetti limitatori
apertura a sporgere

*Casement stays for
awning opening*

**AC 2693**

Serratura con scrocco e
catenaccio

Latch and bolt lock



AISI 304

AC 2697

Scatola copri serratura
Sinistra

LH lock cover box

GZ acciaio zincato | *galvanized steel*
CZ acciaio corten | *corten steel*
IZ acciaio inox | *stainless steel*
B ottone naturale | *natural brass*

Vedi pg. 4.5.25 per la scelta
For the choice see pg. 4.5.25

**AC 2694D**

Kit serratura multipunto dx
per porta

RH Multi-lock set for door

AC 2694S

Kit serratura multipunto sx
per porta

LH Multi-lock set for door

Vedi pg. 4.5.25 per la scelta
For the choice see pg. 4.5.25

**CV 1023.**

Vite per boccola fermavetri
in alluminio, TPS 4.2x13

Screw for aluminium glazing
bead bushing, TPS 4.2x13

CV1023 acciaio zincato | *galvanized steel*
CV1023I acciaio inox | *stainless steel*

**AC 2695D**

Punto di chiusura aggiuntivo
dx per porta

RH additional locking point for door

AC 2695S

Punto di chiusura aggiuntivo
sx per porta

LH additional locking point for door

Vedi pg. 4.5.27 per la scelta
For the choice see pg. 4.5.27

**CV 1243.**

Vite trilobata per boccola ferma-
vetri in alluminio, TPS M4x8

*Thread cutting machine screw
for aluminium glazing
bead bushing, TPS M4x8*

CV1243 acciaio zincato | *galvanized steel*
CV1243I acciaio inox | *stainless steel*



AISI 304

AC 2696

Scatola copri serratura
Destra

RH lock cover box

GZ acciaio zincato | *galvanized steel*
CZ acciaio corten | *corten steel*
IZ acciaio inox | *stainless steel*
B ottone naturale | *natural brass*

Vedi pg. 4.5.25 per la scelta
For the choice see pg. 4.5.25

**CV 5012.**

Boccola per fermavetri in
alluminio

*Bushing for aluminium
glazing bead*

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

**AC 2801I**

Kit squadrette allineamento

Alignment bracket set

Profili | Profiles
 P.2801 | P.2801 - P.2822
 P.2801 - P.2803 | P.2801 - P.2805
 P.2803 - P.2822 | P.2801 - P.2842
 P.2803 - P.2842 | P.2805 - P.2842
 P.2842 | P.2815 - P.2842
 P.2861 | P.2861 - P.2863
 P.2862 - P.2863 telaio | frame

**AC 2832I**

Kit squadrette allineamento

Alignment bracket set

Profili | Profiles
 P.2832 - P.2833
 P.2842 - P.2843
 P.2862 - P.2863

**AC 2803I**

Kit squadrette allineamento

Alignment bracket set

Profili | Profiles
 P.2803
 P.2815
 P.2863
 P.2865 - P.2863

**AC 2833I**

Kit squadrette allineamento

Alignment bracket set

Profili | Profiles
 P.2833

**AC 2805I**

Kit squadrette allineamento

Alignment bracket set

Profili | Profiles
 P.2805
 P.2885

**AC 2843I**

Kit squadrette allineamento

Alignment bracket set

Profili | Profiles
 P.2843

**AC 2822I**

Kit squadrette allineamento

Alignment bracket set

Profili | Profiles
 P.2822
 P.2805 - P.2822
 P.2882
 P.2885 - P.2882

**AC 2851I**

Kit squadrette allineamento

Alignment bracket set

Profili | Profiles
 P.2851

**AC 2852I**

Kit squadrette allineamento

*Alignment bracket set*Profili | Profiles
P.2852**AC 2865I**

Kit squadrette allineamento

*Alignment bracket set*Profili | Profiles
P.2865**AC 2853I**

Kit squadrette allineamento

*Alignment bracket set*Profili | Profiles
P.2853
P.2873**AC 2871I**

Kit squadrette allineamento

*Alignment bracket set*Profili | Profiles
P.2871**AC 2855I**

Kit squadrette allineamento

*Alignment bracket set*Profili | Profiles
P.2855
P.2874**AC 2872I**

Kit squadrette allineamento

*Alignment bracket set*Profili | Profiles
P.2872**AC 2862I**

Kit squadrette allineamento

*Alignment bracket set*Profili | Profiles
P.2862**AC 2875I**

Kit squadrette allineamento

*Alignment bracket set*Profili | Profiles
P.2875

**AC 2891I**

Kit squadrette allineamento

*Alignment bracket set*Profili | *Profiles*
P.2891**AC 2892I**

Kit squadrette allineamento

*Alignment bracket set*Profili | *Profiles*
P.2892
P.2893**AC 2895I**

Kit squadrette allineamento

*Alignment bracket set*Profili | *Profiles*
P.2895

**ACV 771**

Martellina cremonese
"VITRUVIO" small
per finestra
T | tonda | tronca

*Cremone handle
small "VITRUVIO"
for window
T | cut | round*

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 776**

Martellina cremonese
"VITRUVIO"
per finestra
KIDS

*Cremone handle
small "VITRUVIO"
for window
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 772**

Martellina cremonese
"VITRUVIO" small
per finestra
L | quadra | tronca

*Cremone handle
small "VITRUVIO"
for window
L | cut | square*

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

**ACV 777**

Martellina cremonese
"VITRUVIO"
per finestra
OVALE

*Cremone handle
small "VITRUVIO"
for window
OVAL*

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 773**

Martellina cremonese
"VITRUVIO" small
per finestra
L | tonda | tronca

*Cremone handle
small "VITRUVIO"
for window
L | cut | round*

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 779**

Martellina cremonese
"VITRUVIO" small
per finestra
T | tonda | sfera

*Cremone handle
small "VITRUVIO"
for window
T | sphere | round*

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 774**

Martellina cremonese
"VITRUVIO" small
per finestra
L | tonda | sfera

*Cremone handle
small "VITRUVIO"
for window
L | sphere | round*

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



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 781

Martellina cremonese
"VITRUVIO" small
per finestra ad un anta
P.2833

T | tonda | tronca

*Cremone handle
small "VITRUVIO"
for single leaf window
P.2833*

T | cut | round



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 786

Martellina cremonese
"VITRUVIO" small
per finestra a un anta
P.2833

KIDS

*Cremone handle
small "VITRUVIO"
for single leaf window
P.2833*

KIDS



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

ACV 782

Martellina cremonese
"VITRUVIO" small
per finestra a un anta
P.2833

L | quadra | tronca

*Cremone handle
small "VITRUVIO"
for single leaf window
P.2833*

L | cut | square



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 787

Martellina cremonese
"VITRUVIO" small
per finestra a un anta
P.2833

OVALE

*Cremone handle
small "VITRUVIO"
for single leaf window
P.2833*

OVAL



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 783

Martellina cremonese
"VITRUVIO" small
per finestra a un anta
P.2833

L | tonda | tronca

*Cremone handle
small "VITRUVIO"
for single leaf window
P.2833*

L | cut | round



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 789

Martellina cremonese
"VITRUVIO" small
per finestra a un anta
P.2833

T | tonda | sfera

*Cremone handle
small "VITRUVIO"
for single leaf window
P.2833*

T | sphere | round



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 784

Martellina cremonese
"VITRUVIO" small
per finestra a un anta
P.2833

L | tonda | sfera

*Cremone handle
small "VITRUVIO"
for single leaf window
P.2833*

L | sphere | round

**AC 2775/1**

Quadro maniglia

Handle spindle bar**ACV 952**Coppia maniglie per porta
"VITRUVIO" medium
bocchetta rettangolare
L | quadra | tronca*Double door handlesets
"VITRUVIO" medium
rectangular escutcheon
L | square | cut***ACV 658**Copertina per gratz con maniglia
removibile su kit
AC2623E*Cover for gratz mechanism
on kit
AC2623E*

GZ ottone grezzo verniciabile | paintable untreated brass
B ottone brunito | burnished brass
CZ acciaio corten grezzo | untreated corten steel
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 673**Copertina per gratz con maniglia
removibile su kit
AC2624E | AC2625E
AC2683E | AC2684E*Cover for gratz mechanism
on kit
AC2624E | AC2625E
AC2683E | AC2684E*

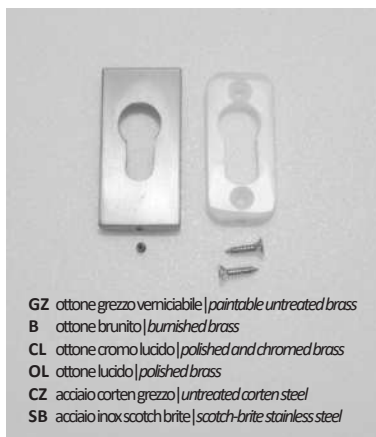
GZ ottone grezzo verniciabile | paintable untreated brass
B ottone brunito | burnished brass
CZ acciaio corten grezzo | untreated corten steel
SB acciaio inox scotch brite | scotch-brite stainless steel

**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 793 D**Martellina per sporgere dx
"VITRUVIO" small
L | tonda | tronca
RH Cockspur handle
"VITRUVIO" small
L | round | cut**ACV 793 S**Martellina per sporgere sx
"VITRUVIO" small
L | tonda | tronca
LH Cockspur handle
"VITRUVIO" small
L | round | cut

Z ottone grezzo verniciabile | paintable untreated brass
B ottone brunito | burnished brass
I acciaio inox scotch brite | scotch-brite stainless steel

**ACV 964**Bocchetta copri cilindro a profilo
europeo*Euro 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

**GE 1011**

Guarnizione interna vetro
spessore 4 mm

*Internal weather strip for
glazing bead
4 mm thick*

**GE 2645TT**

Guarnizione di battuta
interna | esterna su profili
P.2843 | P.2863 | P.2862

*Internal/external weather
strip with
P.2843 | P.2862 | P.2863
profiles*

**GE 2600TT**

Guarnizione di battuta
interna su profilo P.2833

*Internal weather strip
with P.2833 profile*

**GP 0095**

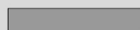
Guarnizione interna vetro
spessore 3mm

*Internal weather strip for
glazing bead
3 mm thick*

**GE 2603**

Guarnizione per giunto aperto
Apertura interna

*Weather strip for open joint
Inward opening*

**GU 2036**

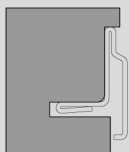
Piattina adesiva morbida
per fondo giunto esterno vetro
12x4 mm

*Soft adhesive shim for
external window joint
12x4 mm*

**GE 2606**

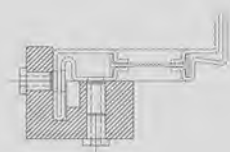
Guarnizione adesiva esterno
vetro
vedi pg. 5.1.1

*Adhesive weather strip outer
window
see pg. 5.1.2*

**AT 2038**

Ganasce di taglio per
P.2638

*Cutting jaws for
P.2638*

**AT 2823**

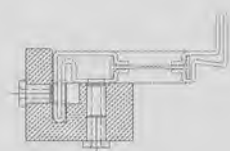
Maschera per applicazione
cremonese AC2623
Profilo P.2833

*Jig for AC2623 cremone bolt
installation
P.2833 profile*

**AT 2629**

Maschera per esecuzione
fori fissaggio cerniere
AC2629-AC2630
AC2649-AC2650

*Drill jig for
AC2629-AC2630 hinges
AC2649-AC2650 hinges*

**AT 2824**

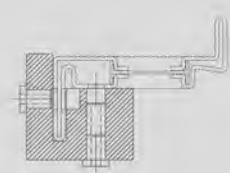
Maschera per applicazione
cremonese AC2624
Profilo P.2833

*Jig for AC2624 cremone bolt
installation
P.2833 profile*

**AT 2800**

Kit ganasce di taglio

Kit of cutting jaws for profiles

**AT 2825**

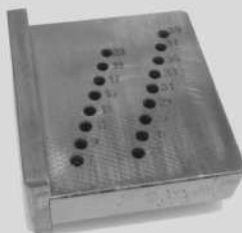
Maschera per applicazione
cremonese AC2624-AC2625
Profilo P.2843
e aperture esterne

*Jig for AC2624-AC2625
cremone bolt installation
P.2843 profile
and outward opening*

**AT 2818**

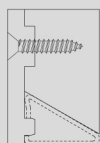
Maschera per esecuzione fori
per applicazione scarico acqua
AC2618 - AC2618NE

*Drill jig for AC2618 - AC2618NE
water drip installation*

**AT 2828**

Maschera per esecuzione fori
fissaggio fermavetri

*Drill jig for glazing beads
securing*

**AT 2829**

Ganasce di taglio per
fermavetro P.2629

*Kit of cutting jaws
for glazing bead P.2629*

**SA 005/01**

Liquido neritore per brunitura
1 Kg

Burnishing liquid
1 Kg

SA 005/10

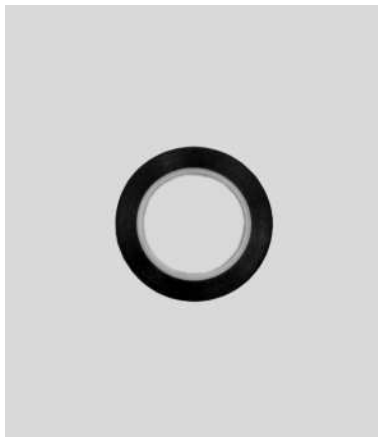
Liquido neritore per brunitura
10 Kg

Burnishing liquid
10 Kg

**SA 2031**

Liquido deumidificante vetri

Glass dehumidifying liquid

**SA 1024**

Nastro adesivo protettivo per
verniciatura
24 mm

Adhesive tape for painting
24 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 2002**

Spray solvente per rimozione
collanti su superfici in acciaio
inox

*Solvent adhesive remover spray
for stainless steel surfaces*

**SA 3001**

Acido per ossidazione corten

Oxidising acid for corten

**SA 3002**

Passivante per ossidazione corten
25 Kg

Passivating agent for corten
25 Kg

SA 3002/5

Passivante per ossidazione corten
5 Kg

Passivating agent for corten
5 Kg

**SA 3003**

Cera d'api per finitura corten

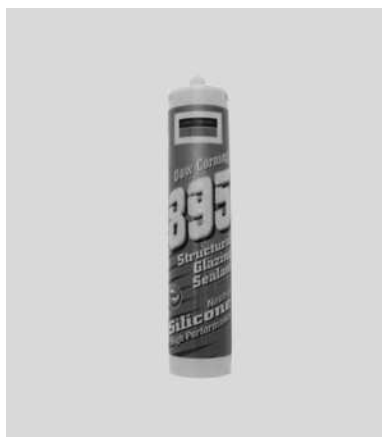
Beeswax for Corten finishing

**SL 0019**

Sigillante a freddo per giunzione
angoli e traversi

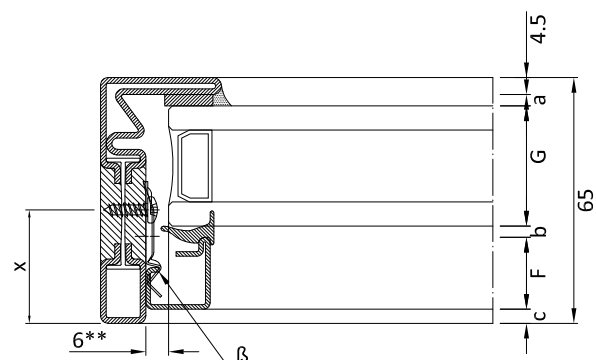
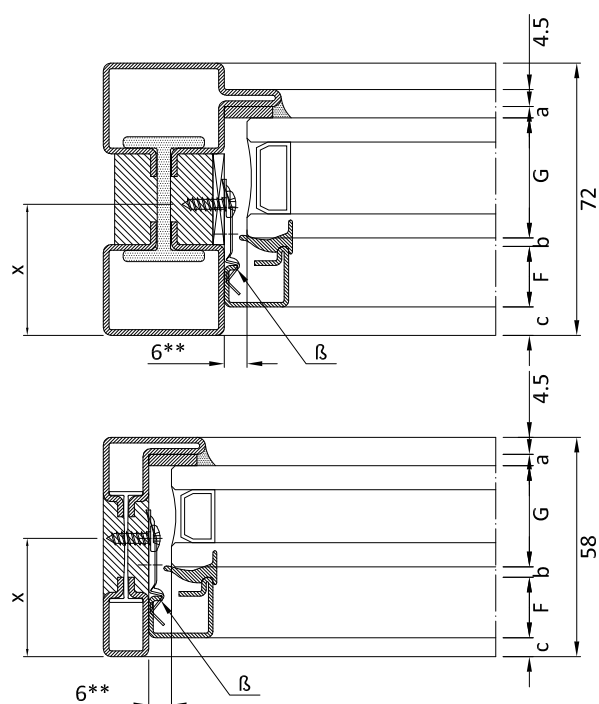
*Cold sealant for corner and
transom joints*

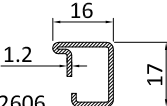
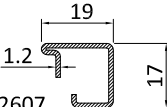
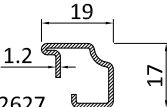
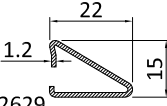
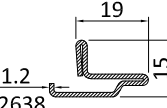
1 kg

**SL 0021**

Silicone nero per guarnizioni

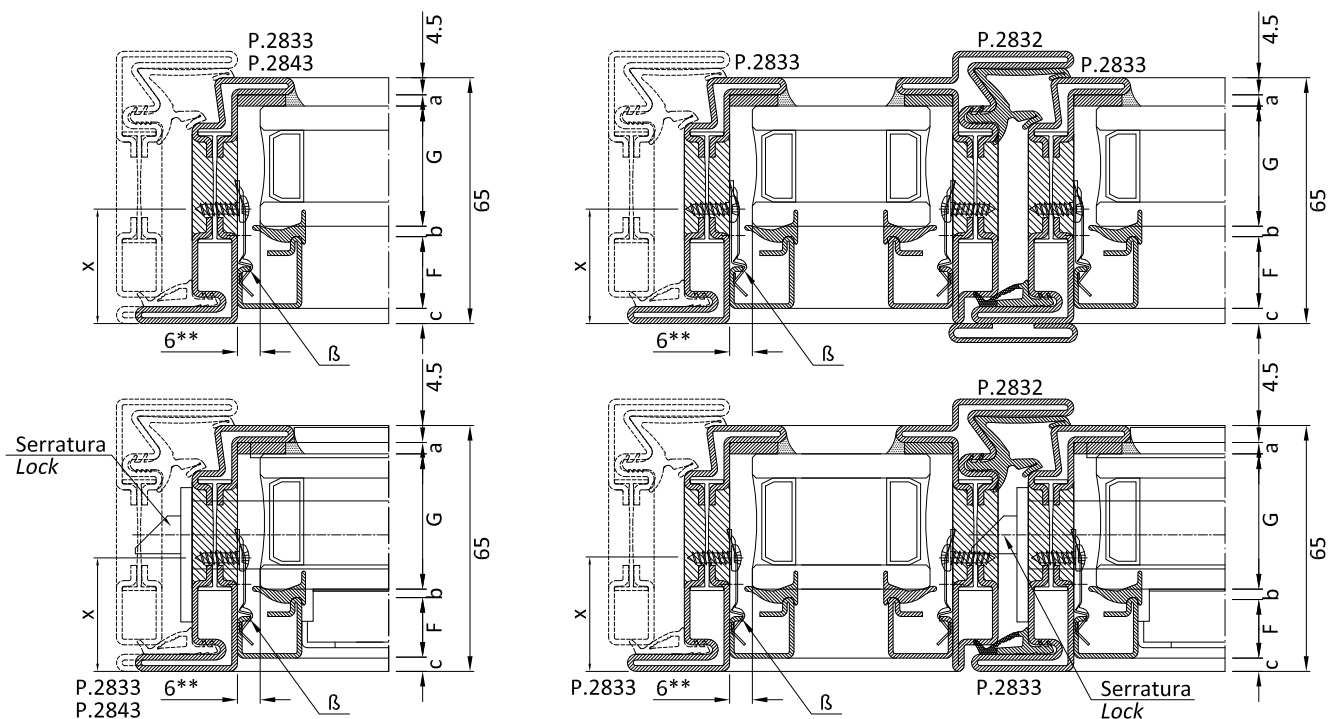
Black silicone for gaskets

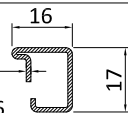
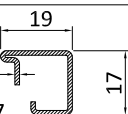
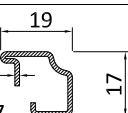
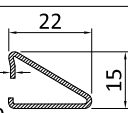
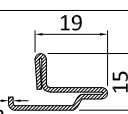


F	G			Guarnizioni - <i>gasket</i>								
fermavetro <i>glazing beads</i>	spessore vetro <i>glass thickness</i>			GU2036 3 mm  + sigillatura + <i>seal</i>	GP0095 2 / 3 mm 	asse fissaggio viti fermavetro <i>glazing beads</i> <i>securing axis</i>	rientro fermavetro <i>glazing beads</i> <i>gap</i>			clips fissaggio fermavetro <i>glazing beads</i> <i>securing clips</i>		
codice <i>code</i>	mm			a	b	x			c			β
	Fisso 72 <i>Fix 72</i>	Fisso 65 <i>Fix 65</i>	Fisso 58 <i>Fix 58</i>			Fisso 72 <i>Fix 72</i>	Fisso 65 <i>Fix 65</i>	Fisso 58 <i>Fix 58</i>	Fisso 72 <i>Fix 72</i>	Fisso 65 <i>Fix 65</i>	Fisso 58 <i>Fix 58</i>	
 P.2606	24 - 39	24 - 39	24 - 32	3	3	34 * - 26	34 * - 26	27 * - 26	15 - 0	15 - 0	8 - 0	AC2608
 P.2607	24 - 36	24 - 36	24 - 29			31 * - 26	31 * - 26	24 * - 26	12 - 0	12 - 0	5 - 0	AC2608
 P.2627	24 - 36	24 - 36	24 - 29			31 * - 26	31 * - 26	24 * - 26	12 - 0	12 - 0	5 - 0	AC2608
 P.2629	24 - 33	28 - 33	24 - 25			39 * - 37	35 * - 30 *	32 * - 30 *	9 - 0	5 - 0	2 - 0	AC2608
 P.2638	24 - 35	31 - 35	24 - 28			45 * - 34 *	38 * - 34 *	45 - 34 *	11 - 0	2 - 0	4 - 0	AC2608

** 7 mm per P.2638
** 7 mm for P.2638

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

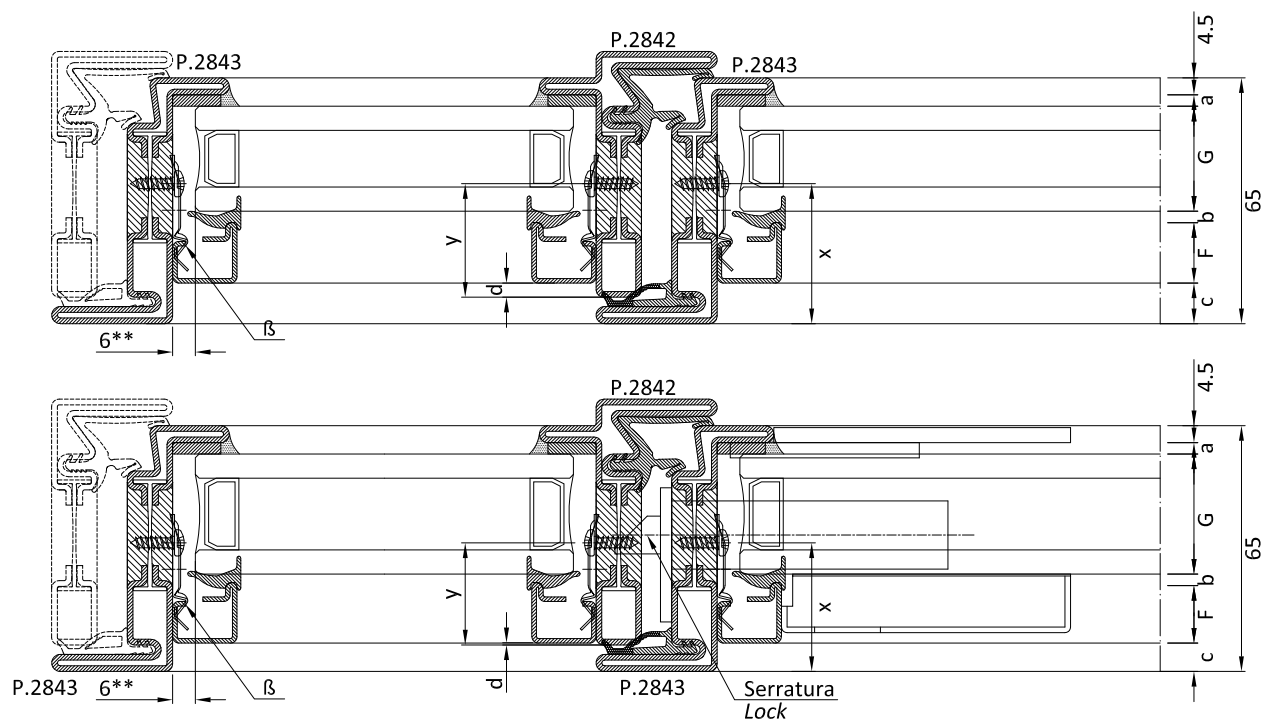


F	G	Guarnizioni - gasket				
fermavetro glazing beads	spessore vetro glass thickness	GU2036 3 mm  + sigillatura + seal	GP0095 2 / 3 mm 	asse fissaggio viti fermavetro glazing beads securing axis	rientro fermavetro glazing beads gap	clips fissaggio fermavetro glazing beads securing clips
codice code	mm	a	b	x	c	β
 P.2606	24 - 35	3	3	34 * - 30	15 - 4	AC2608
 P.2607	24 - 32			31 * - 30	12 - 4	AC2608
 P.2627	24 - 32			31 * - 30	12 - 4	AC2608
 P.2629	24 - 33			39 * - 37	9 - 0	AC2608
 P.2638	27 - 35			42 * - 34 *	8 - 0	AC2608

NOTA: Con serrature AC2693-AC2694
non utilizzare vetri con spessore inferiore a 32 mm
ATTN: With locks AC2693 - AC2694
do not use glass thickness < 32 mm

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

** 7 mm per P.2638
** 7 mm for P.2638

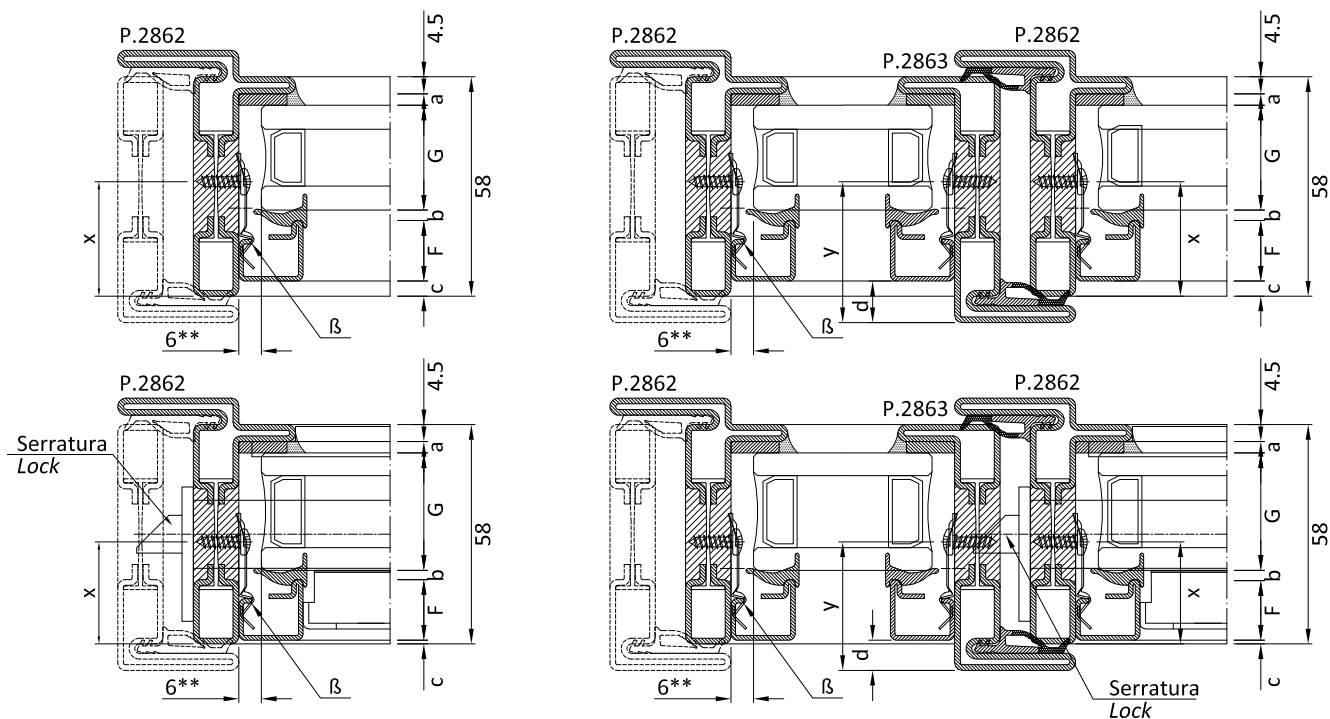


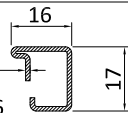
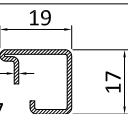
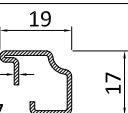
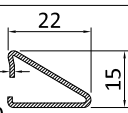
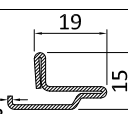
F	G	Guarnizioni - gasket		asse fissaggio viti fermavetro glazing beads securing axis		rientro fermavetro glazing beads gap		clips fissaggio fermavetro glazing beads securing clips
fermavetro glazing beads	spessore vetro glass thickness	GU2036 3 mm + sigillatura + seal	GP0095 2 / 3 mm					
codice code	mm	a	b	x	y	c	d	β
P.2606 	24 - 32	3	3	34 *	27 *	15	8	AC2608
P.2607 	24 - 29			38 - 33	31 - 26	12 - 7	5 - 0	AC2608
P.2627 	24 - 29			38 - 33	31 - 26	12 - 7	5 - 0	AC2608
P.2629 	24 - 25			39 * - 37 *	32 * - 30 *	9 - 7	2 - 0	AC2608
P.2638 	27 - 28			42 * - 41 *	35 * - 34 *	8 - 7	1 - 0	AC2608

NOTA: Con serrature AC2693-AC2694
non utilizzare vetri con spessore inferiore a 32 mm
ATTN: With locks AC2693 - AC2694
do not use glass thickness < 32 mm

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

** 7 mm per P.2638
** 7 mm for P.2638

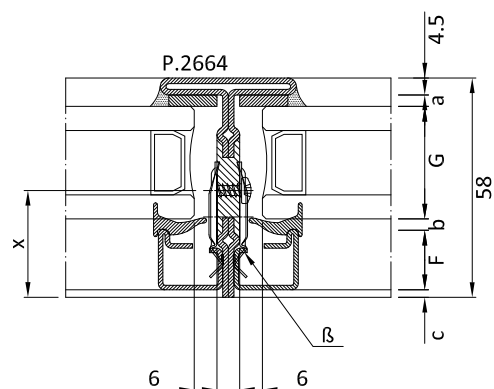
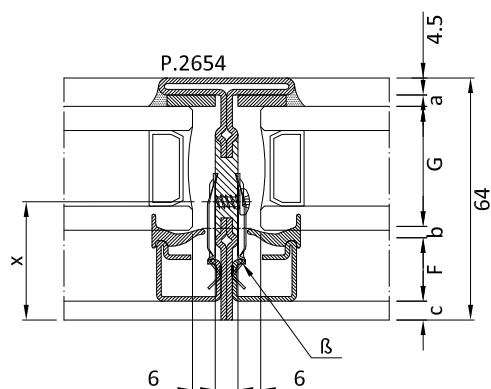


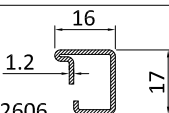
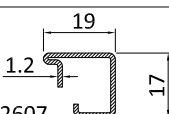
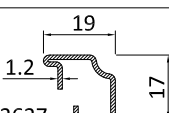
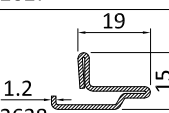
F	G	Guarnizioni - gasket						
fermavetro glazing beads	spessore vetro glass thickness	GU2036 3 mm  + sigillatura + seal	GP0095 2 / 3 mm 	asse fissaggio viti fermavetro glazing beads securing axis		rientro fermavetro glazing beads gap		clips fissaggio fermavetro glazing beads securing clips
codice code	mm	a	b	x	y	c	d	β
 1.2 P.2606	24 - 32	3	3	27 *	34 *	8	15	AC2608
				-	-	-	-	
				26	33	0	7	
 1.2 P.2607	24 - 29			31	38	5	12	AC2608
				-	-	-	-	
				26	33	0	7	
 1.2 P.2627	24 - 29			31	38	5	12	AC2608
				-	-	-	-	
				26	33	0	7	
 1.2 P.2629	24 - 25			32 *	39 *	2	9	AC2608
				-	-	-	-	
				30 *	37 *	0	7	
 1.2 P.2638	27 - 28			35 *	42 *	1	8	AC2608
				-	-	-	-	
				34 *	41 *	0	7	

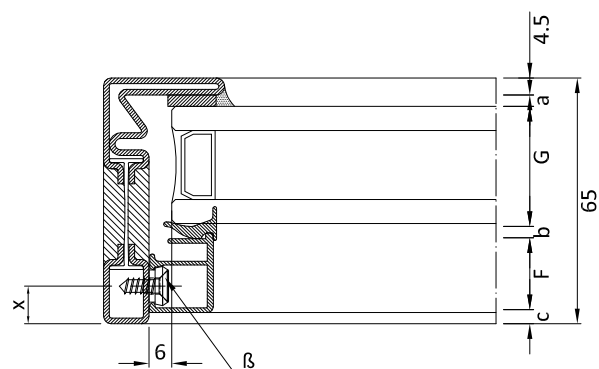
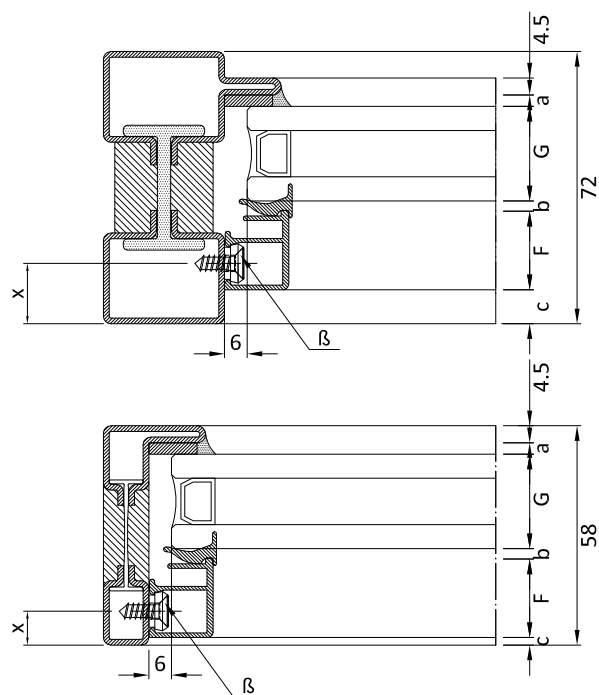
NOTA: Con serrature AC2693-AC2694
non utilizzare vetri con spessore inferiore a 32 mm
ATTN: With locks AC2693 - AC2694
do not use glass thickness < 32 mm

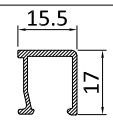
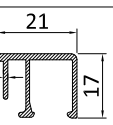
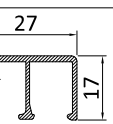
* fissare tramite il primo foro della clip
* screw in the upper hole of the clip

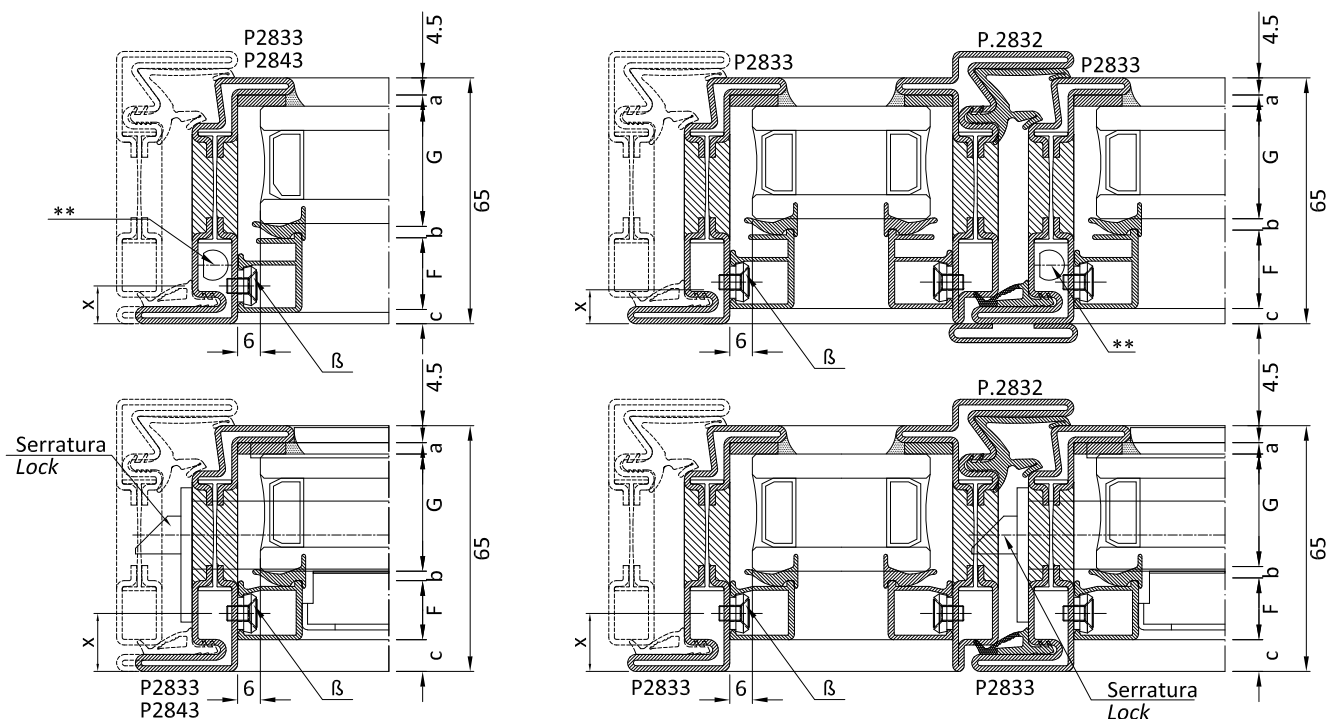
** 7 mm per P.2638
** 7 mm for P.2638

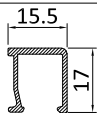
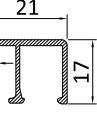
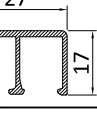


F	G		Guarnizioni - <i>gasket</i>						
fermavetro <i>glazing beads</i>	spessore vetro <i>glass thickness</i>		GU2036 3 mm  + sigillatura + <i>seal</i>	GP0095 2 / 3 mm 	asse fissaggio viti fermavetro <i>glazing beads</i> <i>securing axis</i>	rientro fermavetro <i>glazing beads</i> <i>gap</i>		clips fissaggio fermavetro <i>glazing beads</i> <i>securing clips</i>	
codice <i>code</i>	mm		a	b	x		c		β
	P2654	P2664			P2654	P2664	P2654	P2664	
 1.2 P.2606	30 - 35	35 - 32	3	3	34 - 29	28 - 26	8 - 3	2 - 0	AC2609
 1.2 P.2607	27 - 32	27 - 29			34 - 29	28 - 26	8 - 3	2 - 0	AC2609
 1.2 P.2627	27 - 32	27 - 29			34 - 29	28 - 26	8 - 3	2 - 0	AC2609
 1.2 P.2638	27 - 34	28 - -			41 * - 41	35 * -	7 0	0	AC2608



F	G	Guarnizioni - gasket										
fermavetro glazing beads	spessore vetro glass thickness	GU2036 3 mm  + sigillatura + seal	GP0095 2 / 3 mm 	asse fissaggio viti fermavetro glazing beads securing axis			rientro fermavetro glazing beads gap			boccole e viti fissaggio fermavetro Bushings and screws for fixing of glazing bead		
codice <i>code</i>	mm			a	b	x			c			β
	Fisso 72 <i>Fix 72</i>	Fisso 65 <i>Fix 65</i>	Fisso 58 <i>Fix 58</i>			Fisso 72 <i>Fix 72</i>	Fisso 65 <i>Fix 65</i>	Fisso 58 <i>Fix 58</i>	Fisso 72 <i>Fix 72</i>	Fisso 65 <i>Fix 65</i>	Fisso 58 <i>Fix 58</i>	
PA2606 	26 - 39	33 - 39	26 - 32	3	3	20 - 7	13 - 7	13 - 7	13 - 0	6 - 0	6 - 0	CV1023(ii) CV5012(ii)
PA2607 	23 - 34	28 - 34	22 - 27			18 - 7	13 - 7	13 - 7	11 - 0	6 - 0	6 - 0	CV1023(ii) CV5012(ii)
PA2608 	22 - 28	22 - 28	--			13 - 7	13 - 7	--	11 - 0	6 - 0	--	CV1023(ii) CV5012(ii)

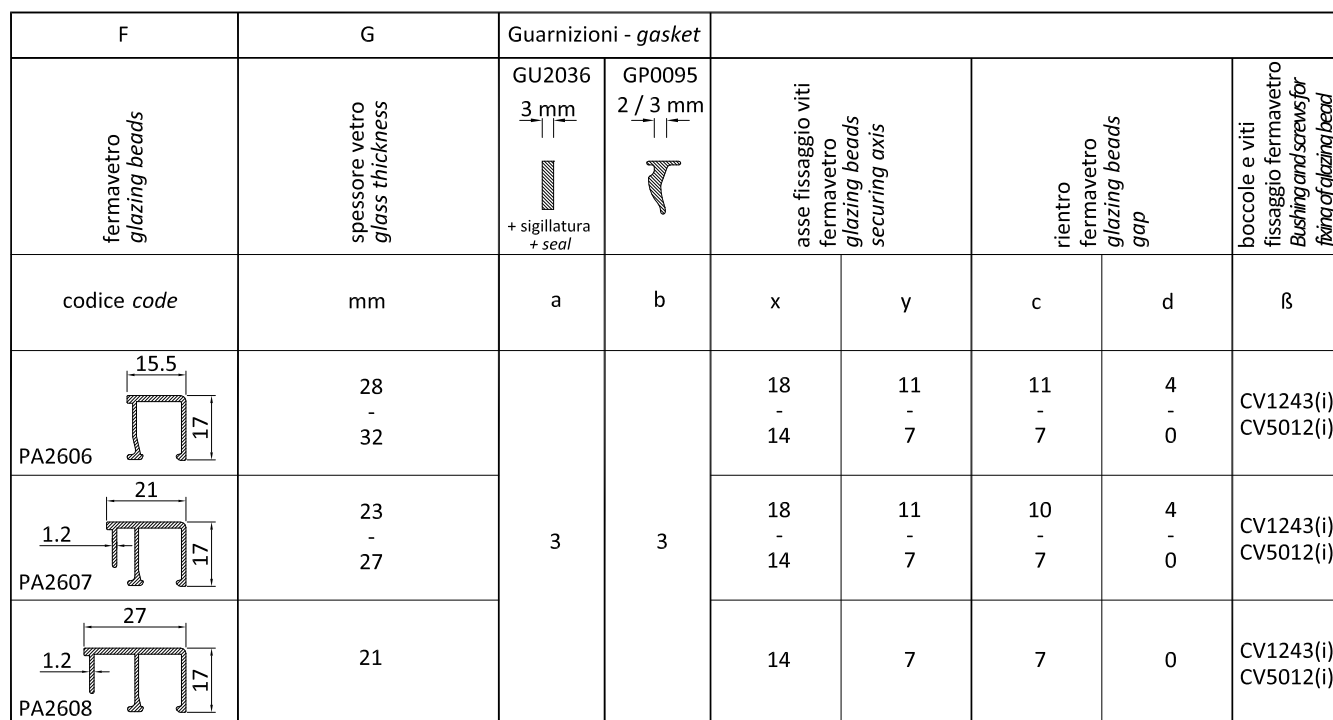


F	G	Guarnizioni - gasket				
fermavetro glazing beads	spessore vetro glass thickness	GU2036 3 mm  + sigillatura + seal	GP0095 2 / 3 mm 	asse fissaggio viti fermavetro glazing beads securing axis	rientro fermavetro glazing beads gap	boccole e viti fissaggio fermavetro Bushings and screws for fixing of glazing bead
codice code	mm	a	b	x	c	β
PA2606 	27 - 35	3	3	19 - 11	12 - 4	CV1243(i) CV5012(i)
PA2607 	22 - 30			19 - 11	12 - 4	CV1243(i) CV5012(i)
PA2608 	22 - 24			13 - 11	6 - 4	CV1243(i) CV5012(i)

** Fare attenzione al fissaggio fermavetro in prossimità kit cremonese - vedi pg. 2.8.11

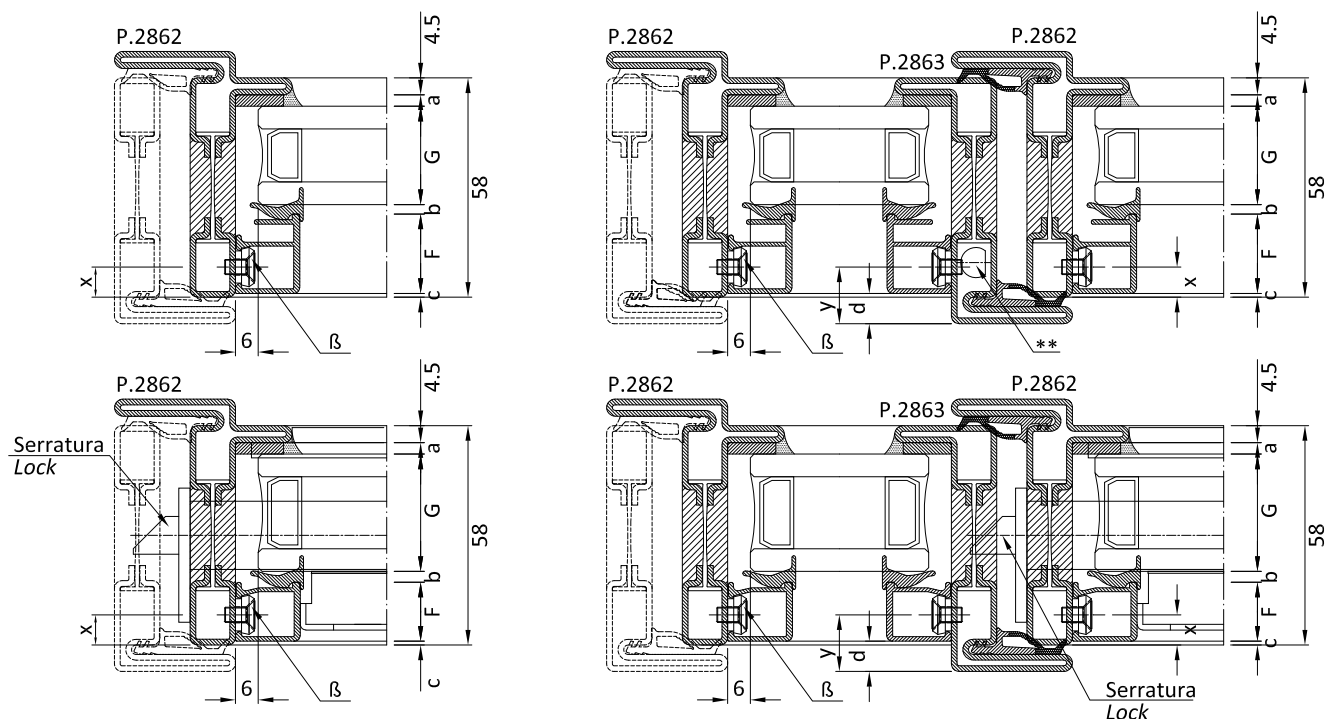
** Pay attention fixing the screw near cremone set - see pg. 2.8.11

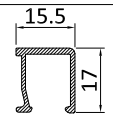
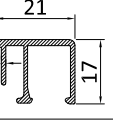
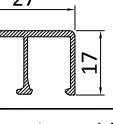
NOTA: Con serrature AC2693-AC2694
non utilizzare vetri con spessore inferiore a 32 mm
ATTN: With locks AC2693 - AC2694
do not use glass thickness < 32 mm



**** Pay attention fixing the screw near cremone set - see pg. 2.8.11**

NOTA: Con serrature AC2693-AC2694
non utilizzare vetri con spessore inferiore a 32 mm
ATTN: With locks AC2693 - AC2694
do not use glass thickness < 32 mm



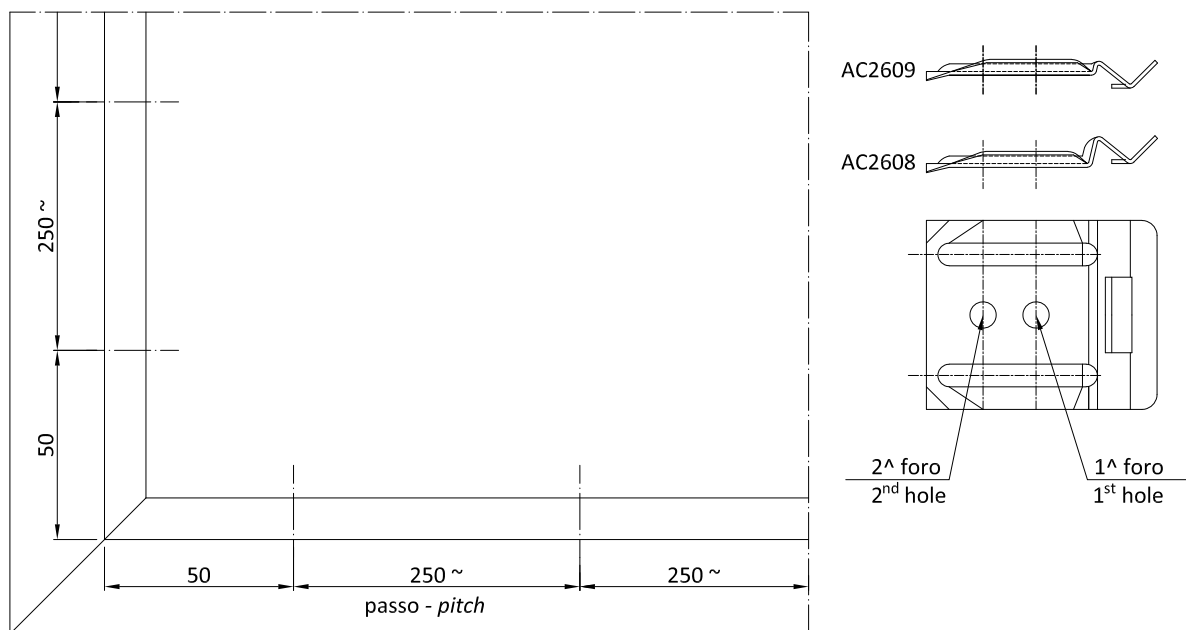
F	G	Guarnizioni - gasket		asse fissaggio viti fermavetro glazing beads securing axis		rientro fermavetro glazing beads gap		boccole e viti fissaggio fermavetro Bushings and screws for fixing of glazing bead
fermavetro glazing beads	spessore vetro glass thickness	GU2036 3 mm  + sigillatura + seal	GP0095 2 / 3 mm 	x	y	c	d	β
codice code	mm	a	b					
PA2606 	28 - 32	3	3	11 - 7	18 - 14	4 - 0	11 - 7	CV1243(i) CV5012(i)
PA2607 	23 - 27			11 - 7	18 - 14	4 - 0	11 - 7	CV1243(i) CV5012(i)
PA2608 	21			7	14	0	7	CV1243(i) CV5012(i)

** Fare attenzione al fissaggio fermavetro in prossimità kit cremonese - vedi pg. 2.8.11

** Pay attention fixing the screw near cremone set - see pg. 2.8.11

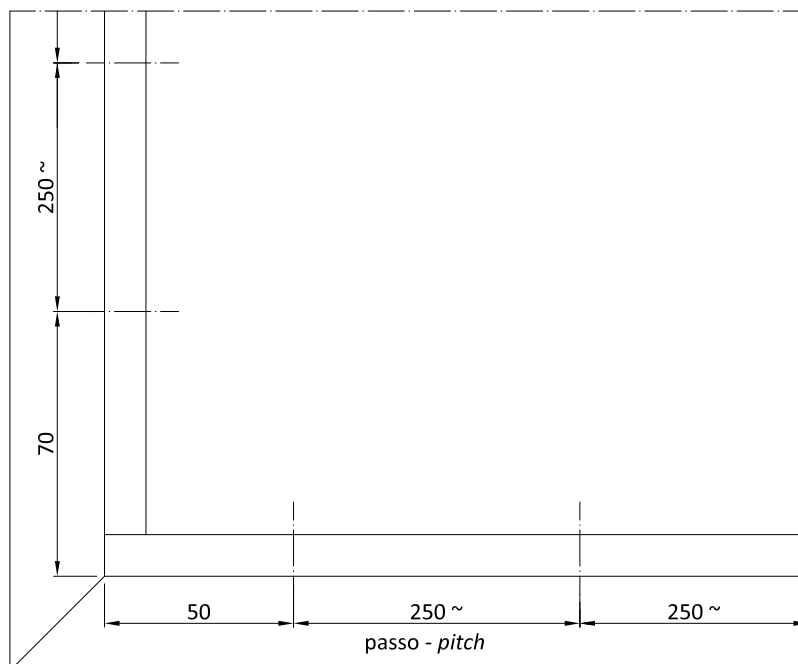
NOTA: Con serrature AC2693-AC2694
non utilizzare vetri con spessore inferiore a 32 mm
ATTN: With locks AC2693 - AC2694
do not use glass thickness < 32 mm

Fissaggio fermavetri P.2606 - P.2607 - P.2627 - P.2629: clip AC2608/AC2609 con vite TC 3.5 x 9.5 (non fornite)
 Glazing beads fixing P.2606 - P.2607 - P.2627 - P.2629: clip AC2608 /AC2609 with screw TC 3.5 x 9.5 (not included)



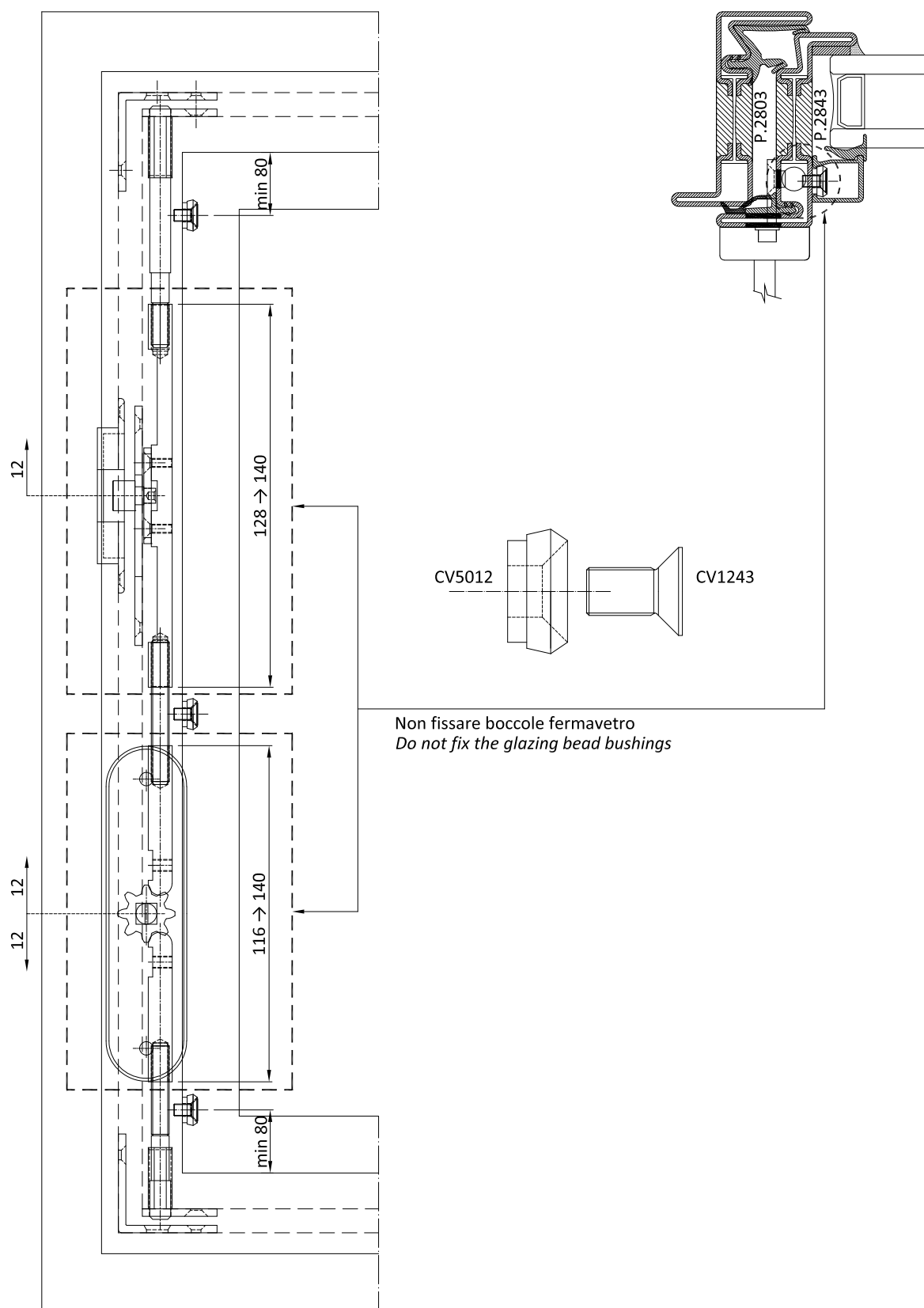
Passo clips fissaggio fermavetri
 Clip pitch for glazing beads securing

Fissaggio fermavetri PA2607 - PA2608: profili telaio vite CV1023(I) TPS 4,2 x 13 e boccola CV5012(I)
 Profili anta vite CV1243(I) TPS M4 x 8 e boccola CV5012(I).
 Glazing bead fixing PA2607 - PA2608: frame profile screw CV1023(I) TPS 4,2 x 13 and bushing CV5012(I)
 Leaf profile screw CV1243(I) TPS M4 x 8 M4 x 8 and bushing CV5012(I).

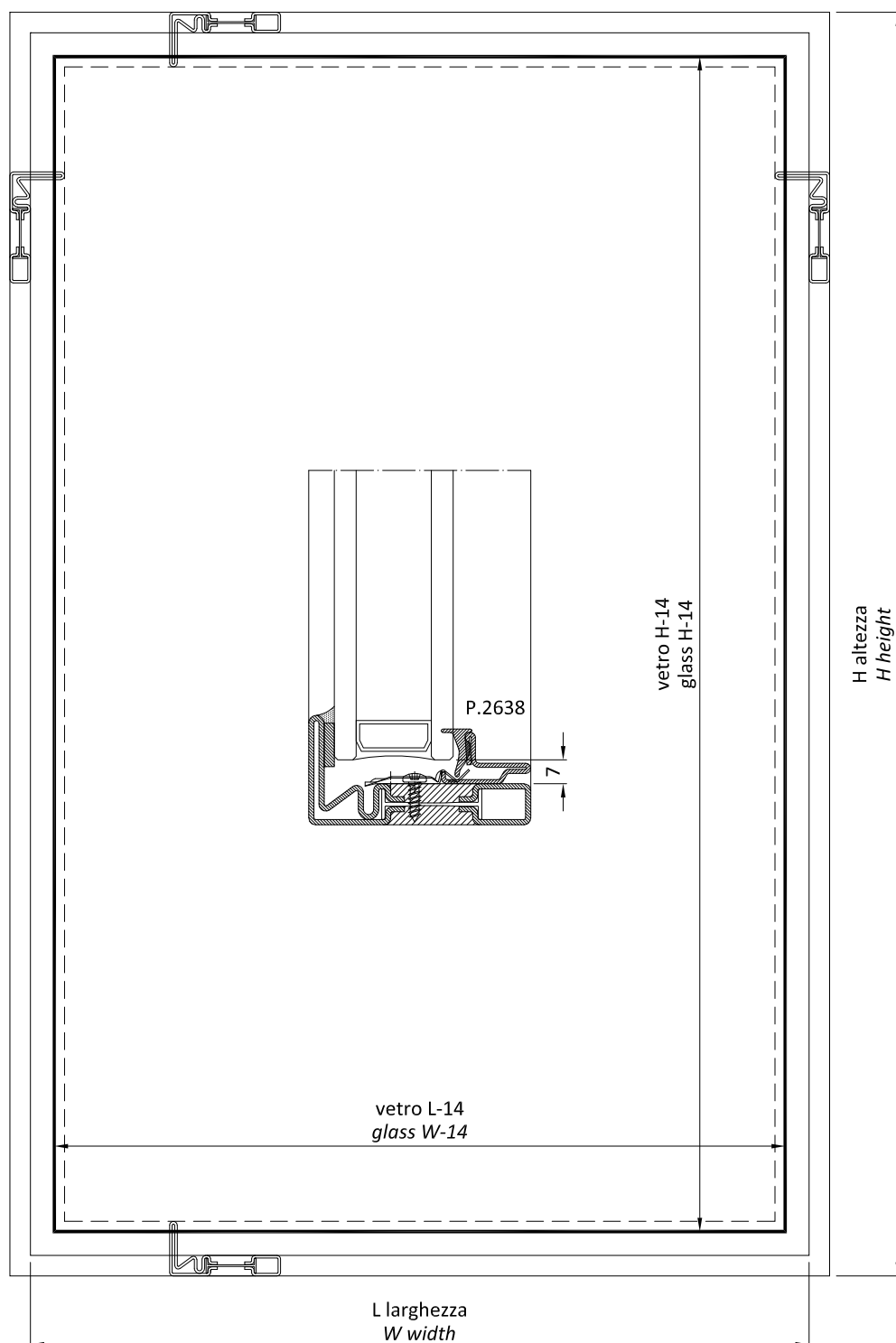
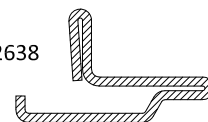


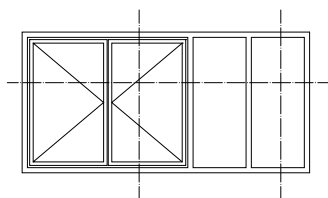
Passo vite e boccola fissaggio fermavetri
 Screw and bushing pitch for glazing beads fixing

Boccole fissaggio fermavetri in alluminio
Bushing fixing for aluminium glazing beads



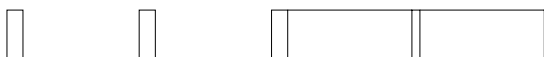
P.2638





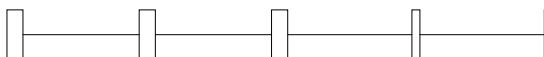
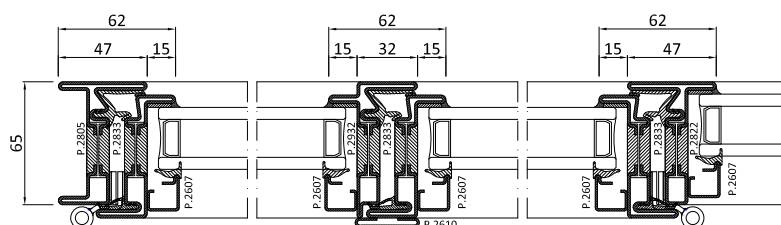
Tipologia
apribile a due ante con fissi laterali
apertura interna
posa in luce

Type
double leaf window with fixed light
inward opening
laying middle wall



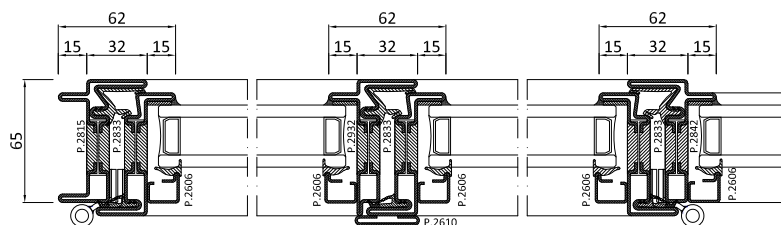
Sistema 1
sezioni minimizzate
vetri non complanari
aperture in evidenza nel prospetto

System 1
minimised sections
non-flush glasses
visible openings on the facade



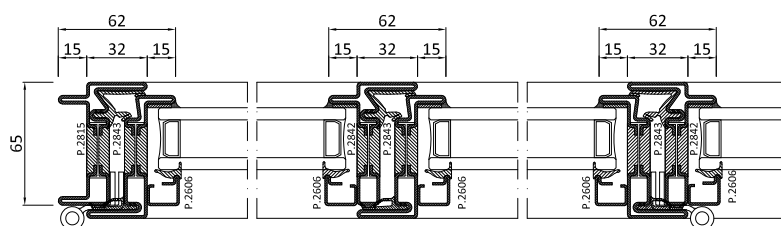
Sistema 1.1
sezioni minimizzate
vetri complanari
aperture in evidenza nel prospetto

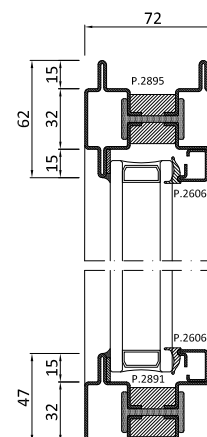
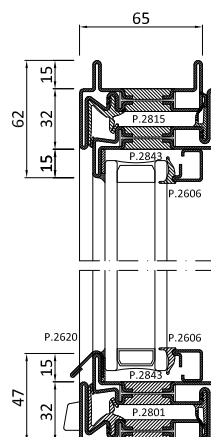
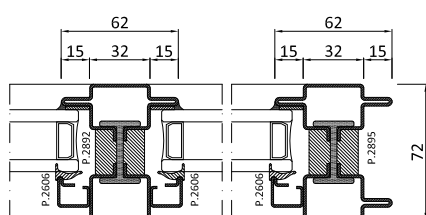
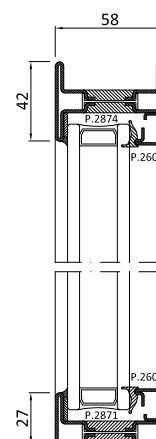
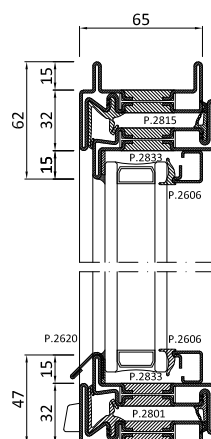
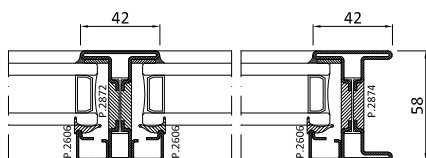
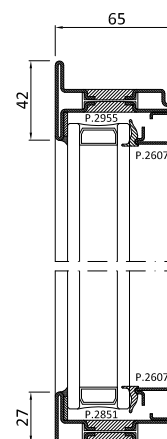
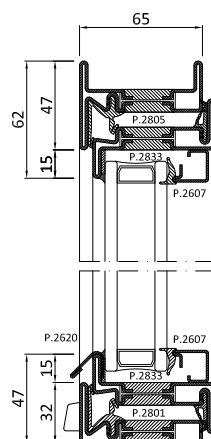
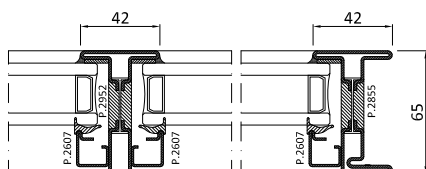
System 1.1
minimised sections
flush glasses
visible openings on the facade

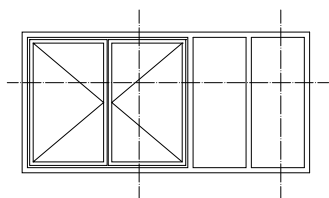


Sistema 2
sezioni congruenti
vetri complanari
aperture non distinguibili nel prospetto

System 2
congruent sections
flush glasses
invisible openings on the facade

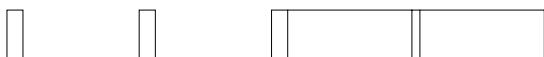






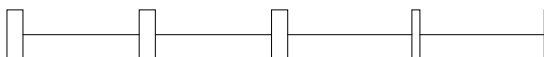
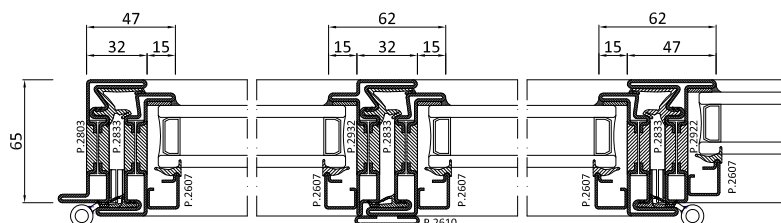
Tipologia
apribile a due ante con fissi laterali
apertura interna
posa interno muro

Type
double leaf window with fixed light
inward opening
laying internal wall



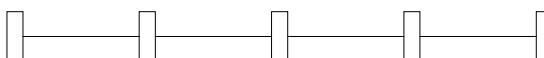
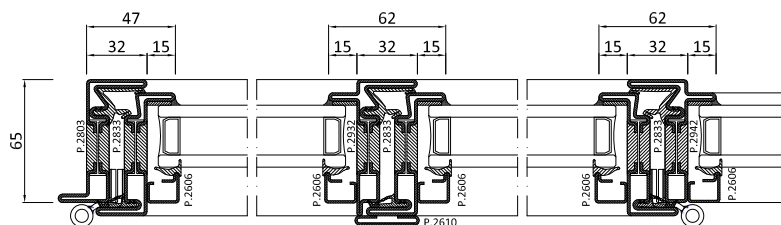
Sistema 1
sezioni minimizzate
vetri non complanari
aperture in evidenza nel prospetto

System 1
minimised sections
non-flush glasses
visible openings on the facade



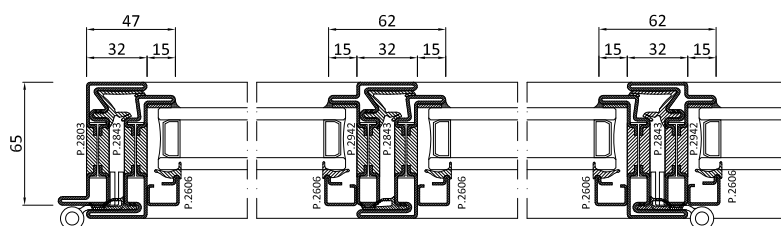
Sistema 1.1
sezioni minimizzate
vetri complanari
aperture in evidenza nel prospetto

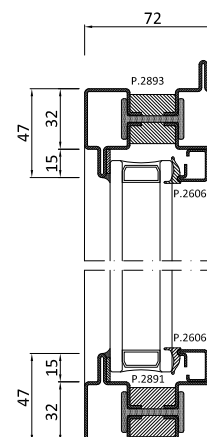
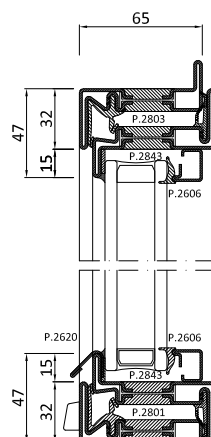
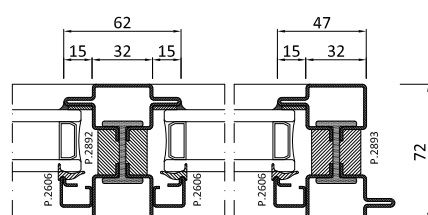
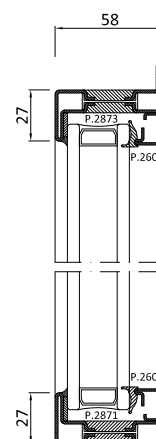
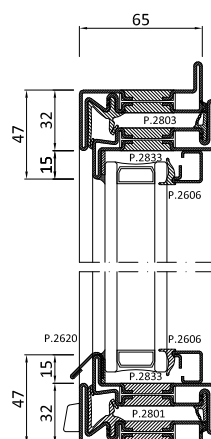
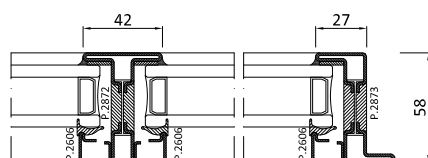
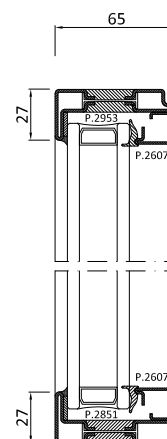
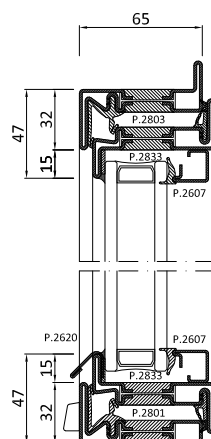
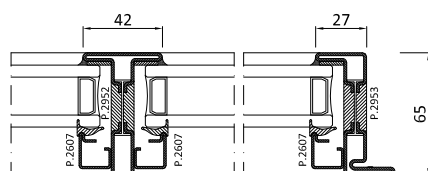
System 1.1
minimised sections
flush glasses
visible openings on the facade

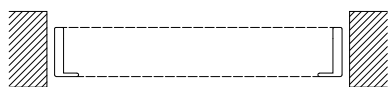
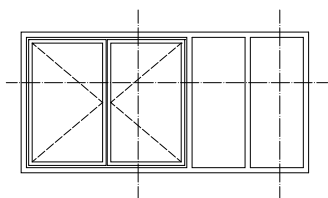


Sistema 2
sezioni congruenti
vetri complanari
aperture non distinguibili nel prospetto

System 2
congruent sections
flush glasses
invisible openings on the facade







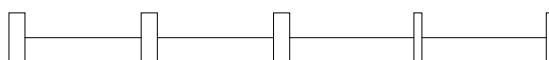
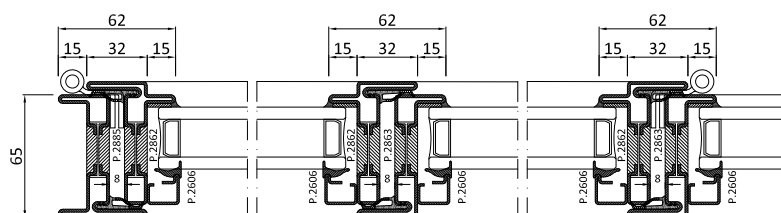
Tipologia
apribile a due ante con fissi laterali
apertura esterna
posa in luce

Type
double leaf window with fixed light
outward opening
laying middle wall



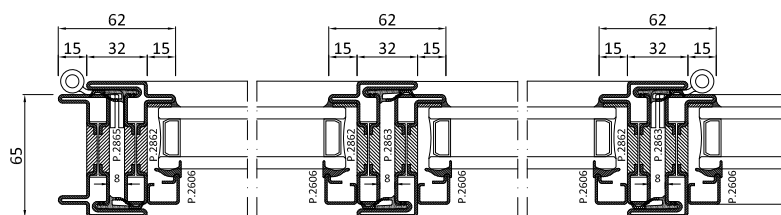
Sistema 1
sezioni minimizzate
vetri complanari
aperture in evidenza nel prospetto

System 1
minimised sections
flush glasses
visible openings on the facade



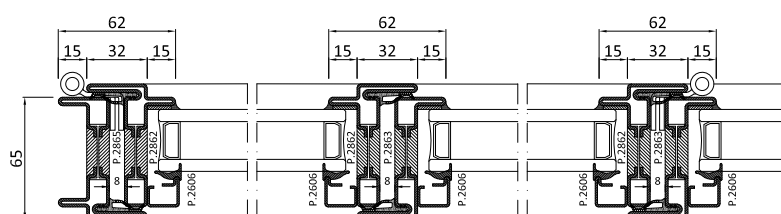
Sistema 1.1
sezioni minimizzate
vetri complanari
aperture in evidenza nel prospetto

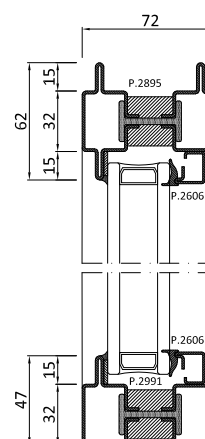
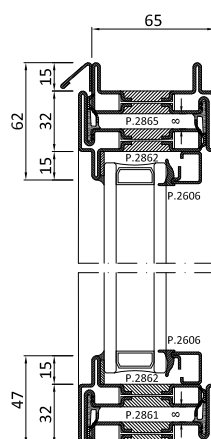
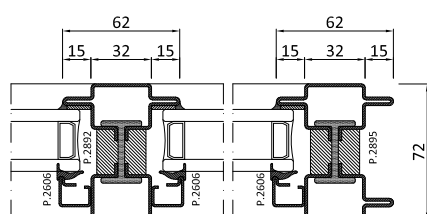
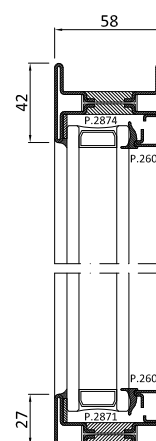
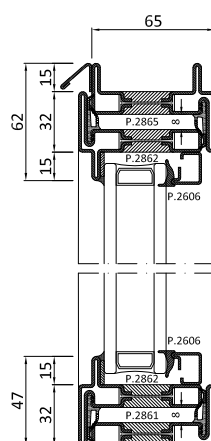
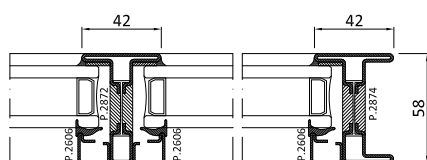
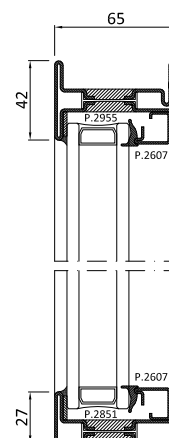
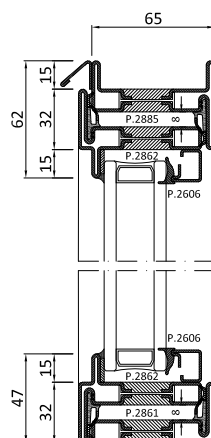
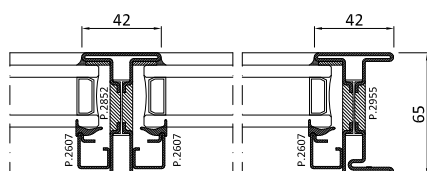
System 1.1
minimised sections
flush glasses
visible openings on the facade

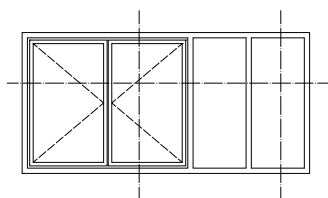


Sistema 2
sezioni congruenti
vetri complanari
aperture non distinguibili nel prospetto

System 2
congruent sections
flush glasses
invisible openings on the facade







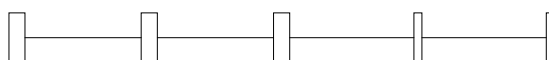
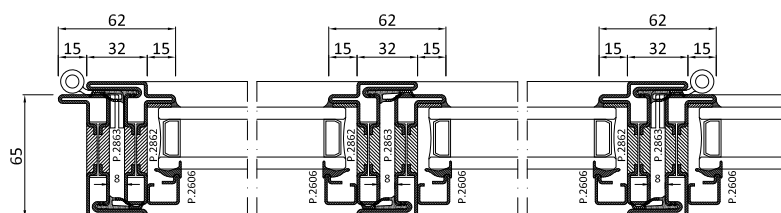
Tipologia
apribile a due ante con fissi laterali
apertura esterna
posa esterno muro

Type
double leaf window with fixed light
external opening
laying external wall



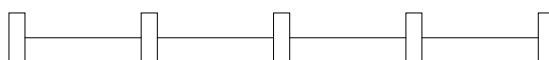
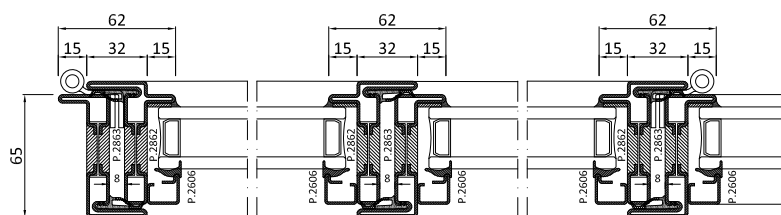
Sistema 1
sezioni minimizzate
vetri complanari
aperture in evidenza nel prospetto

System 1
minimised sections
flush glasses
visible openings on the facade



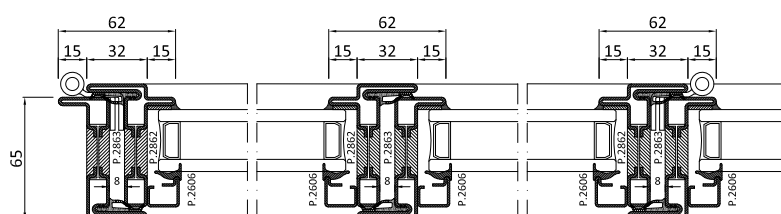
Sistema 1.1
sezioni minimizzate
vetri complanari
aperture in evidenza nel prospetto

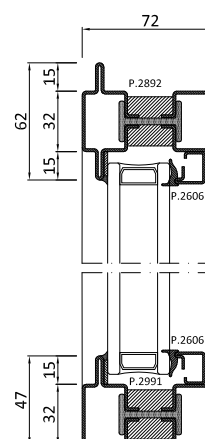
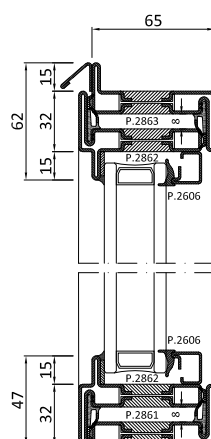
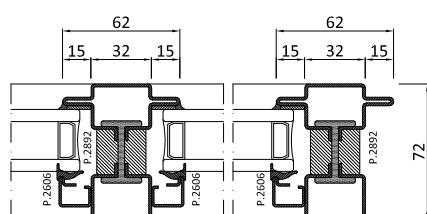
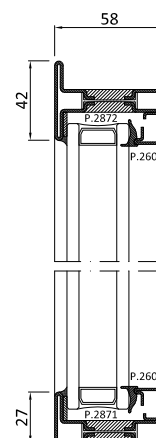
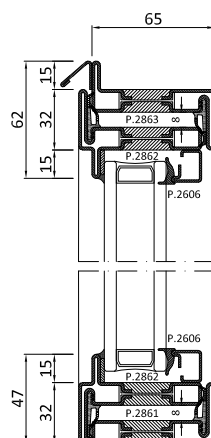
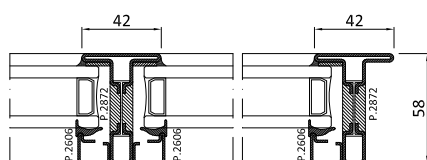
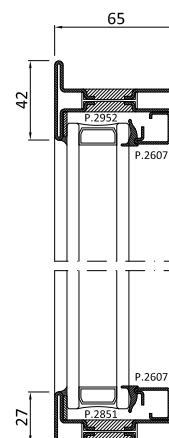
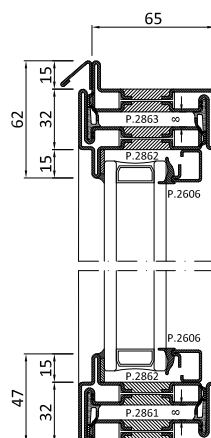
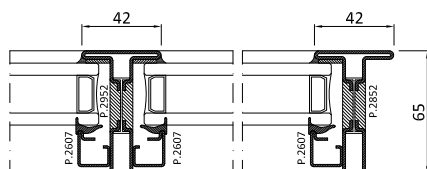
System 1.1
minimised sections
flush glasses
visible openings on the facade

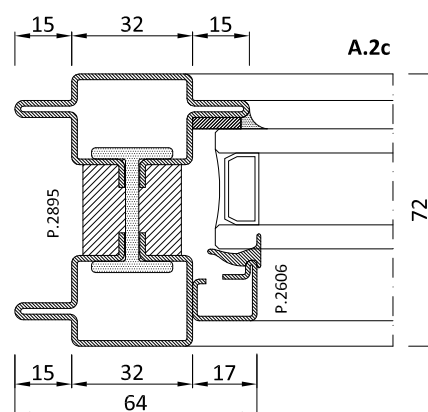
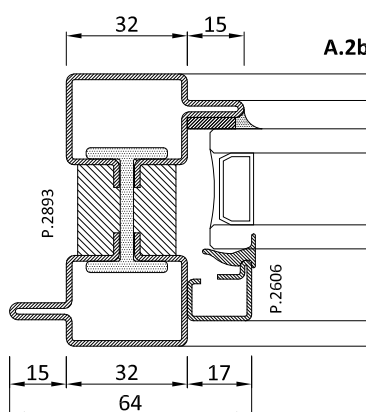
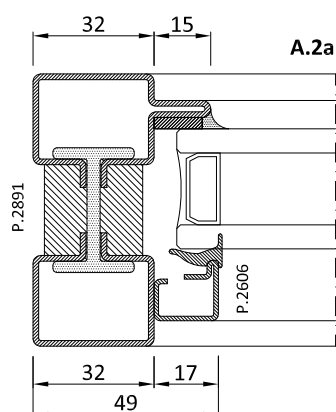
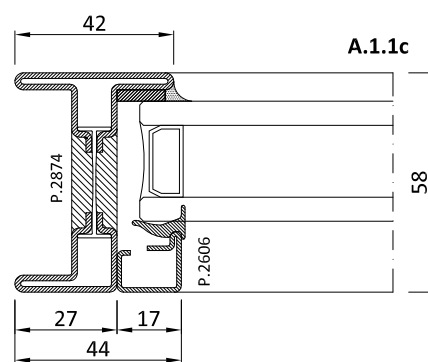
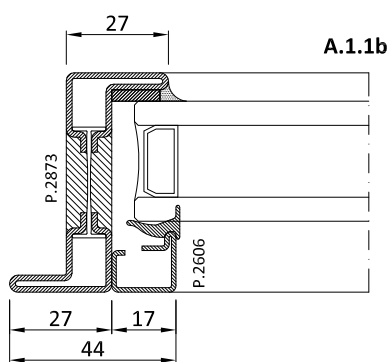
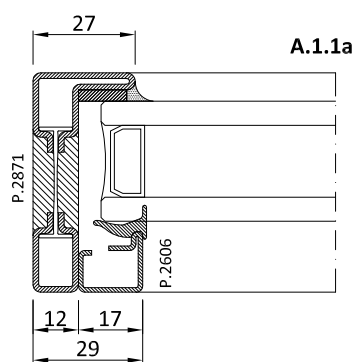
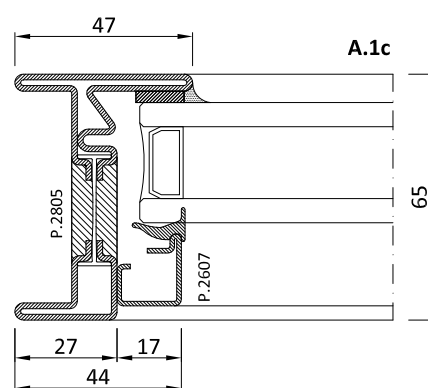
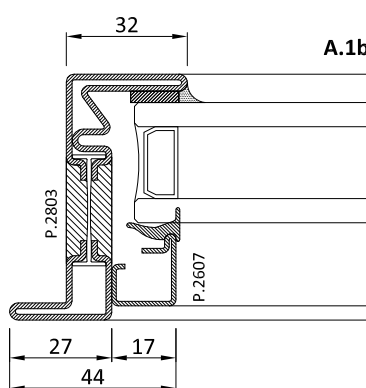
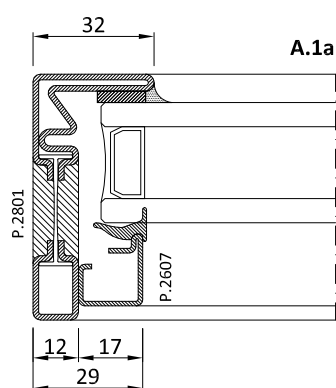
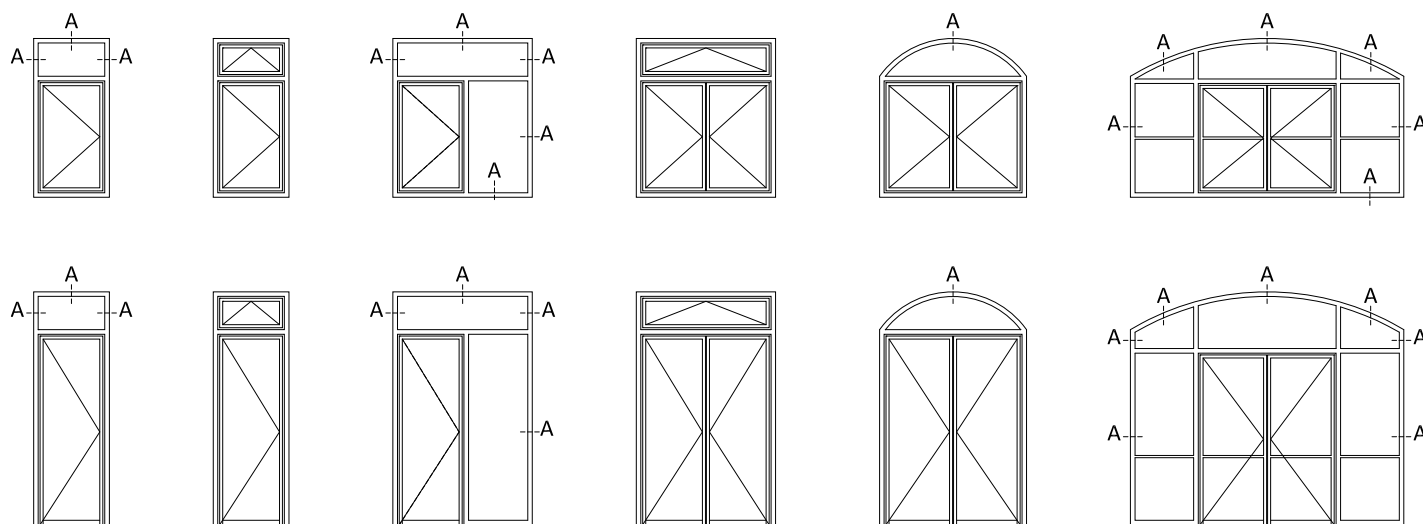


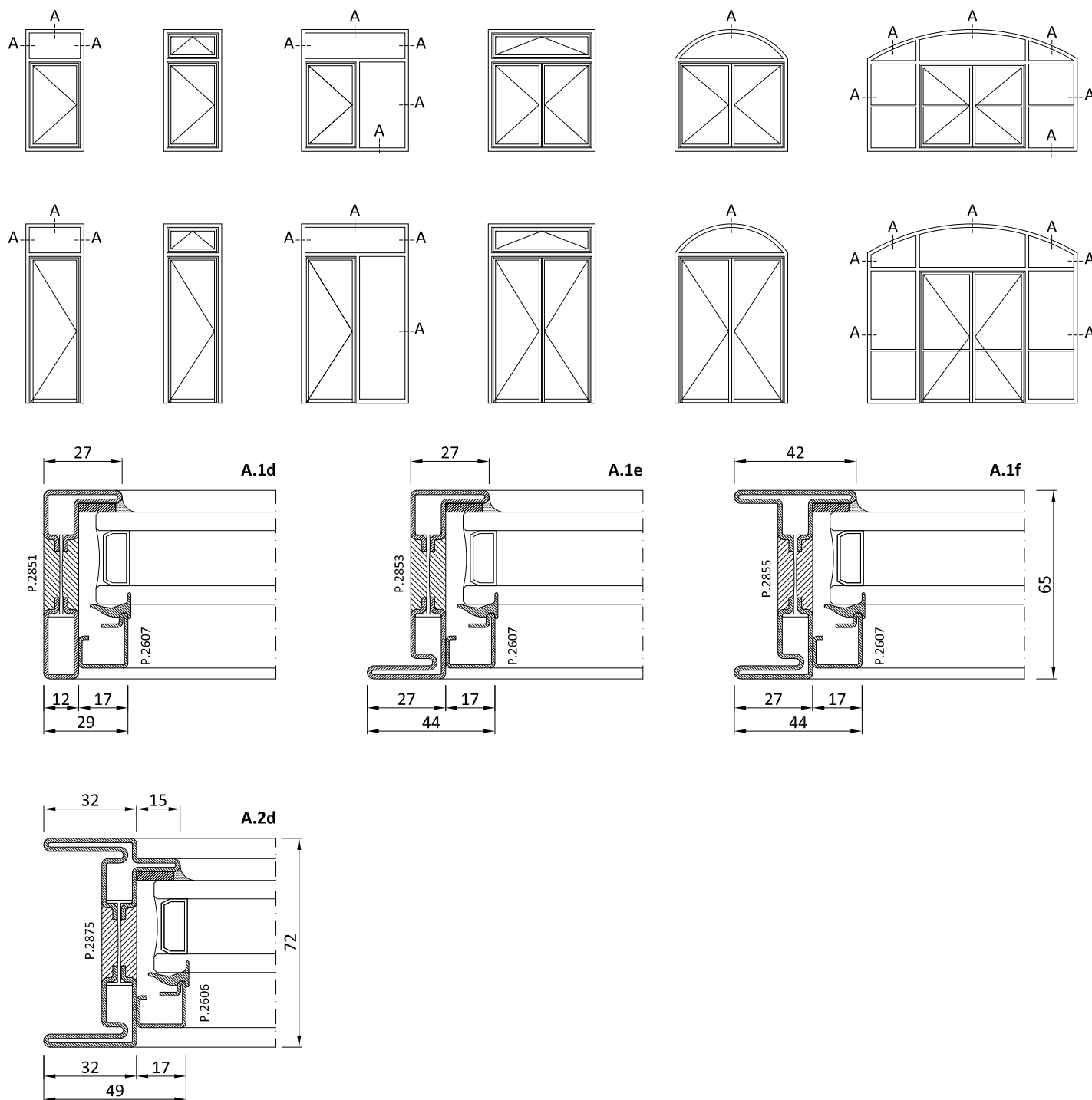
Sistema 2
sezioni congruenti
vetri complanari
aperture non distinguibili nel prospetto

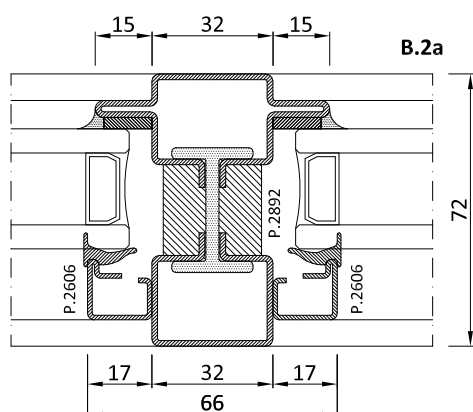
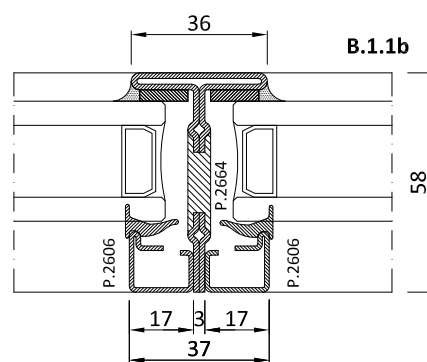
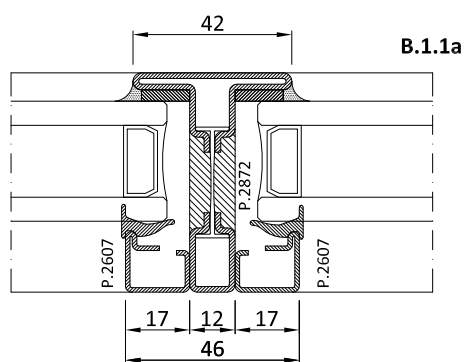
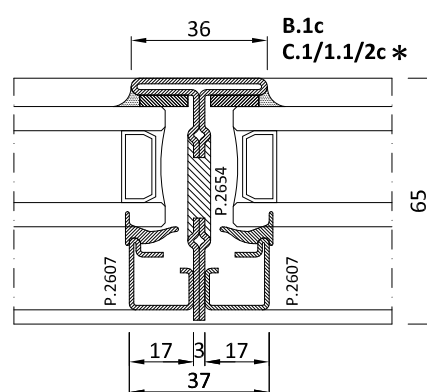
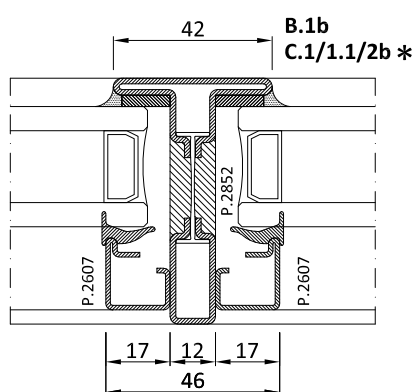
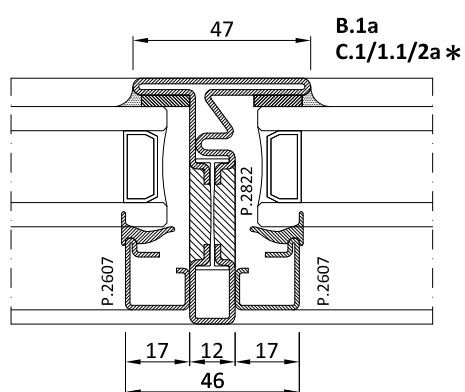
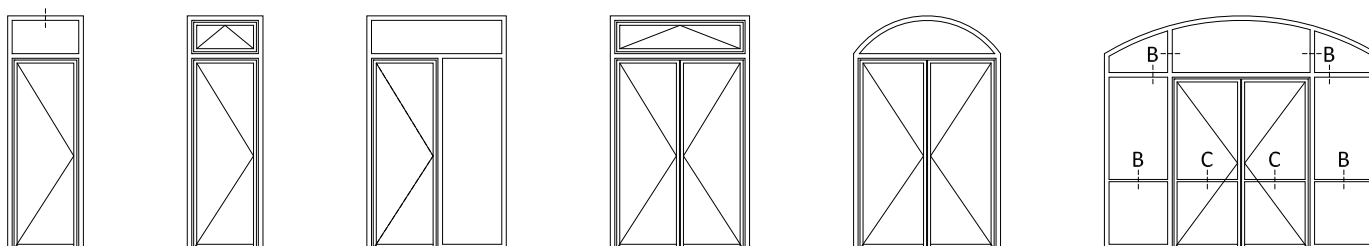
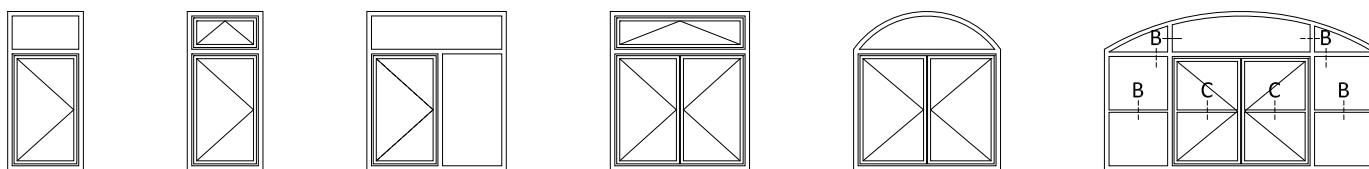
System 2
congruent sections
flush glasses
invisible openings on the facade



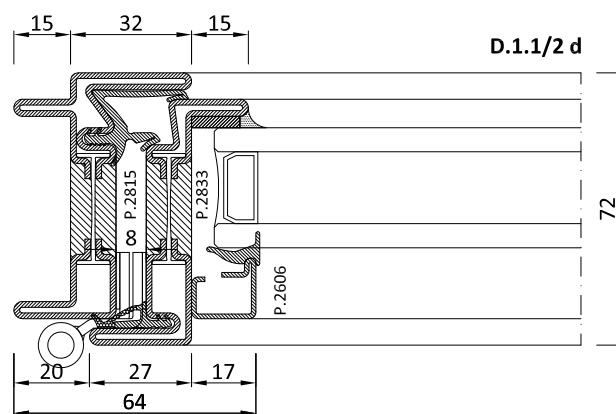
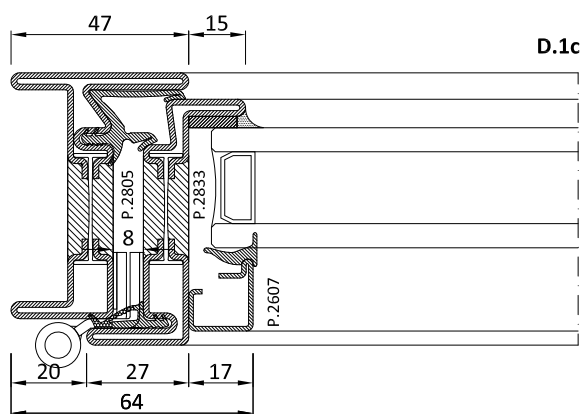
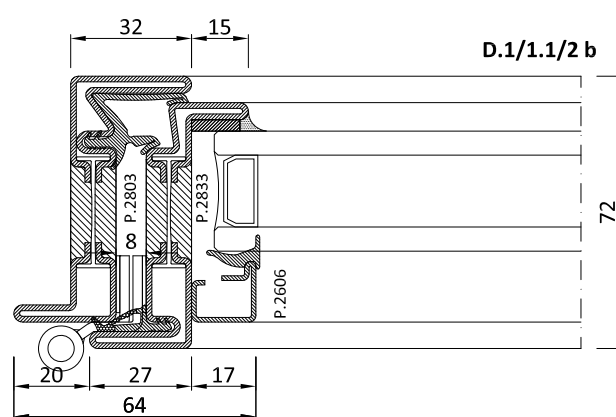
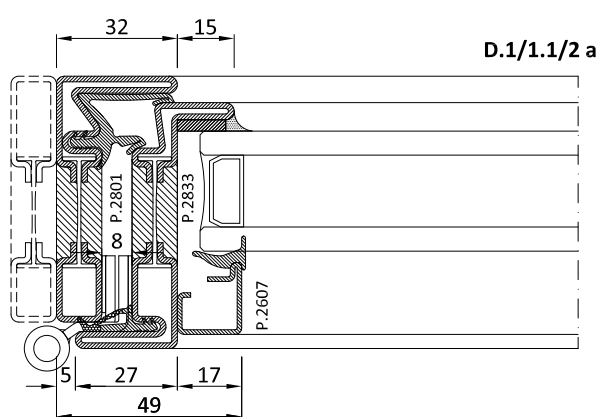
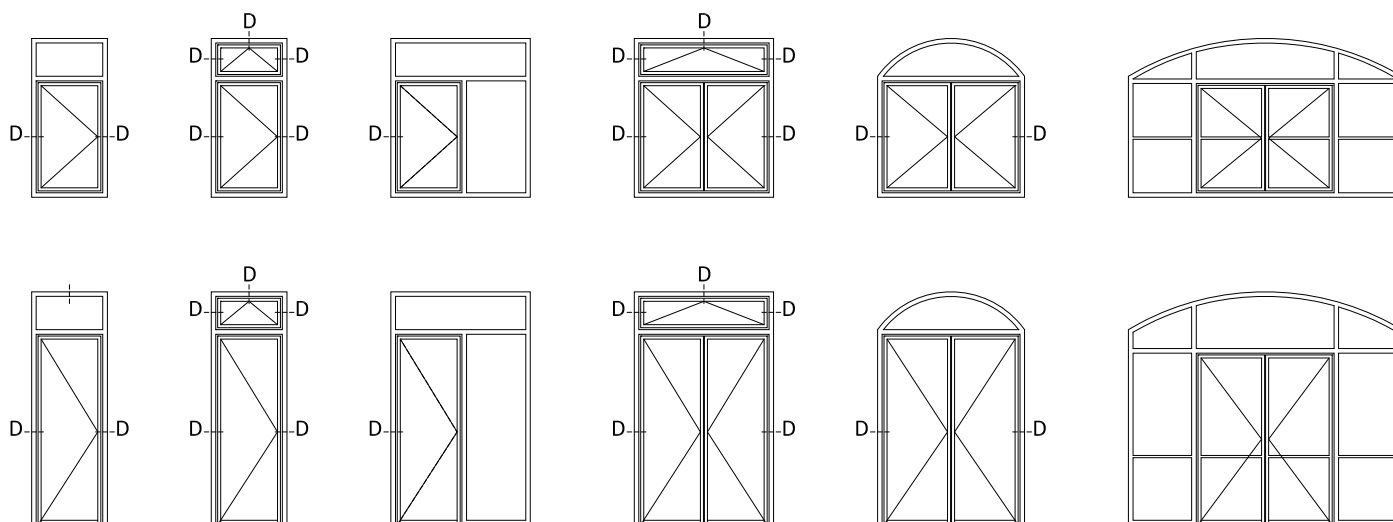


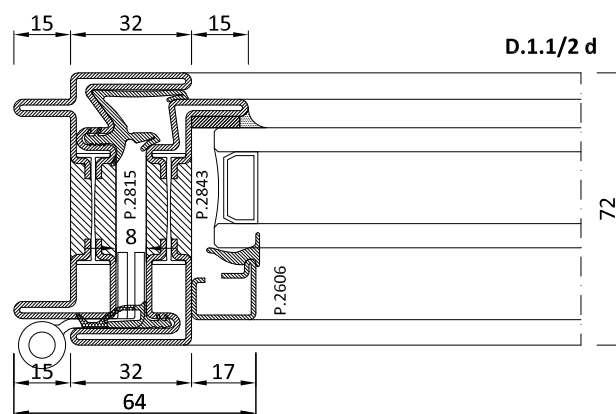
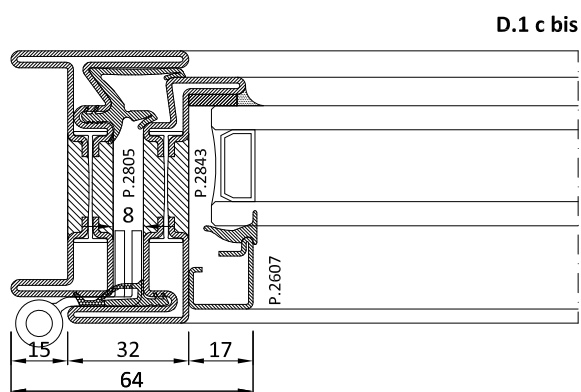
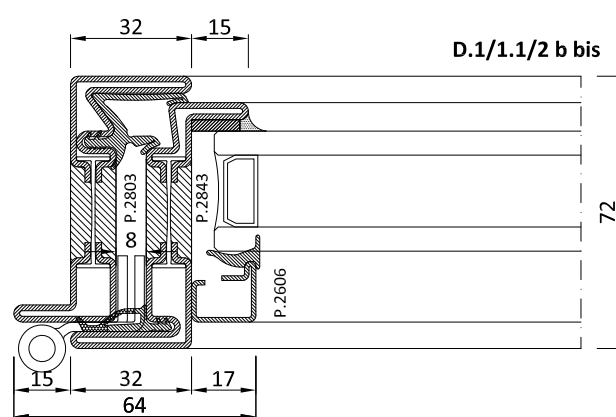
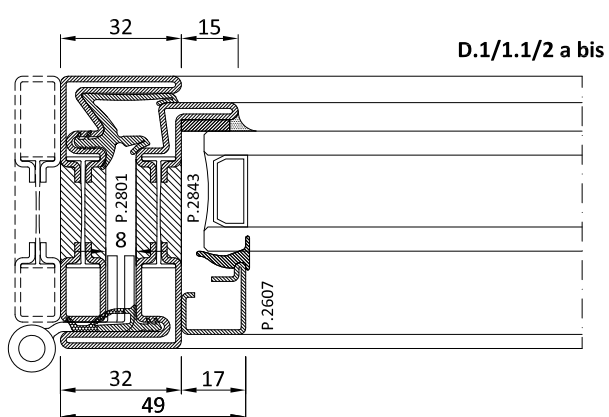
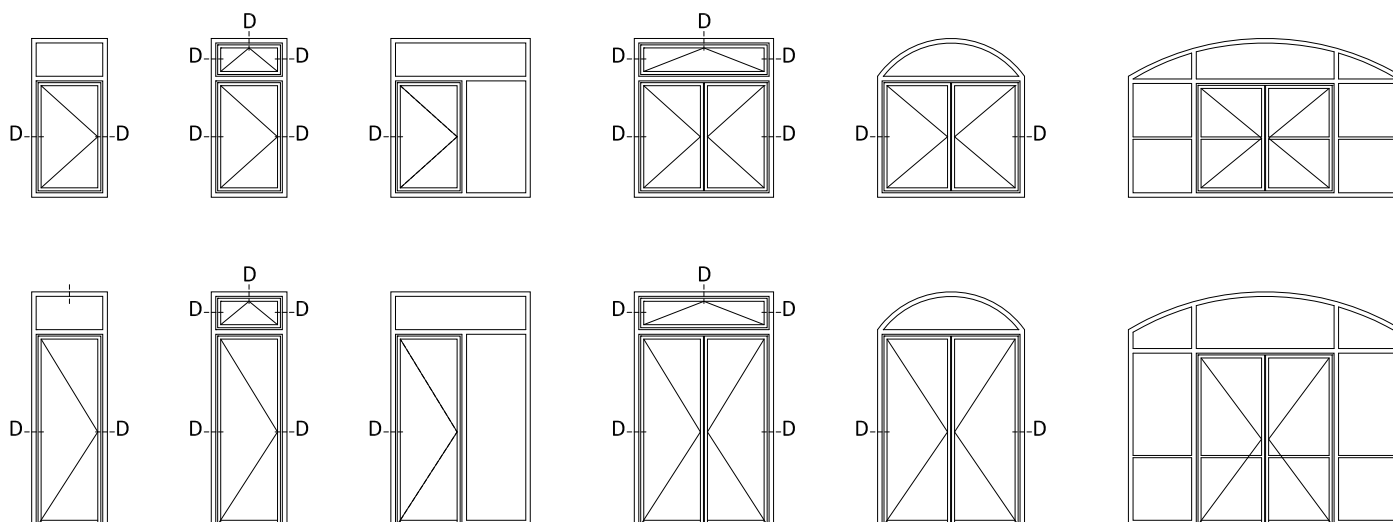


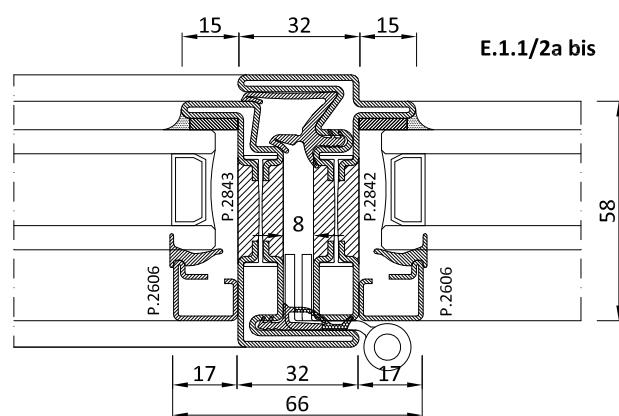
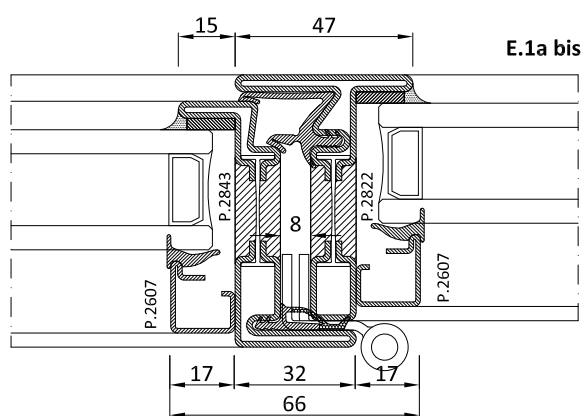
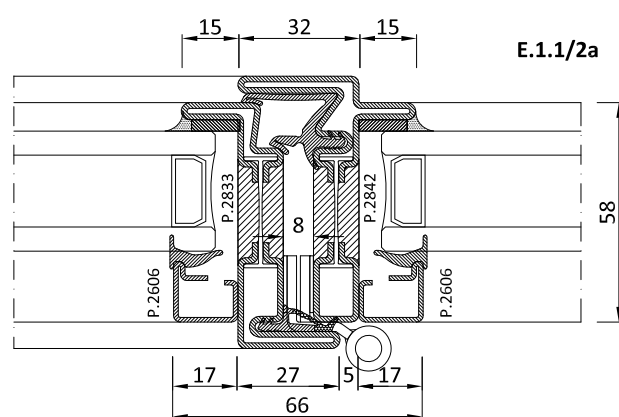
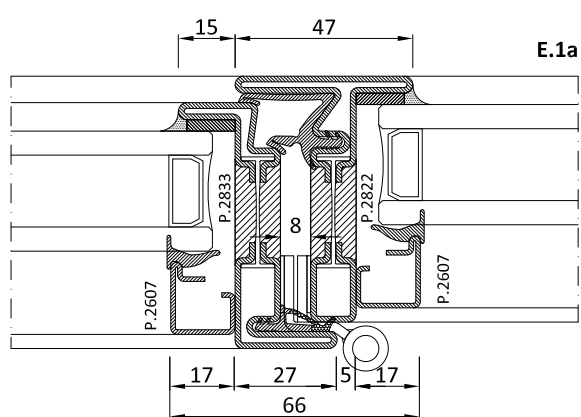
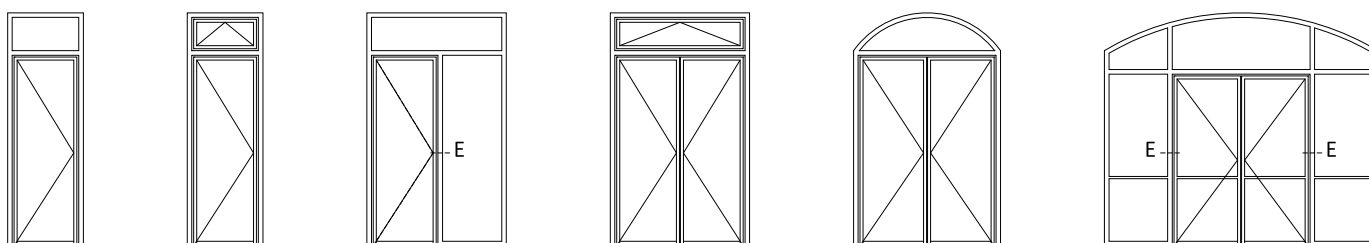
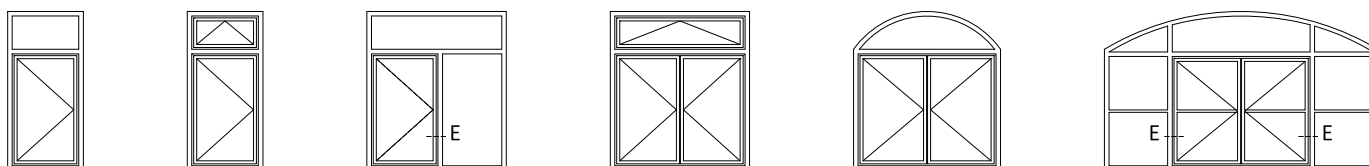


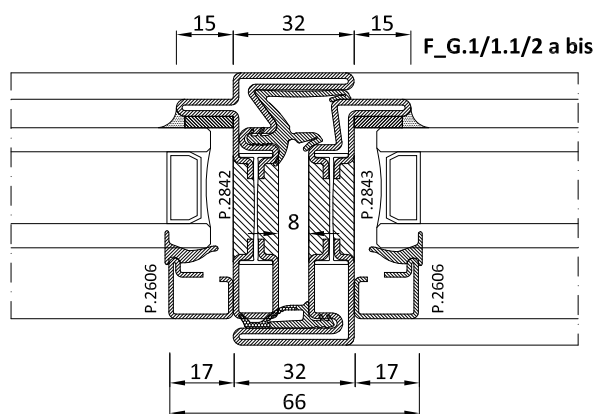
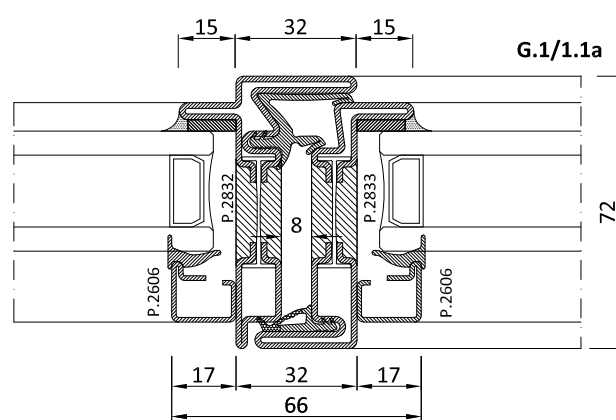
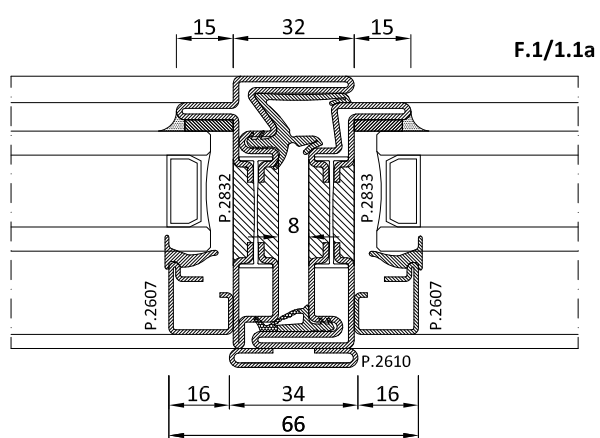
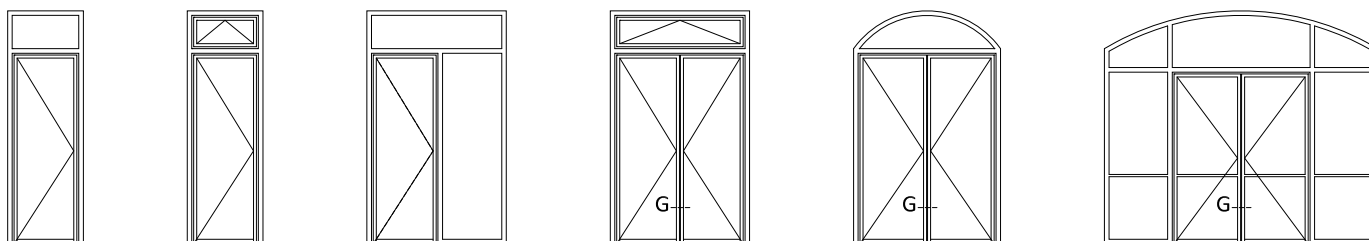
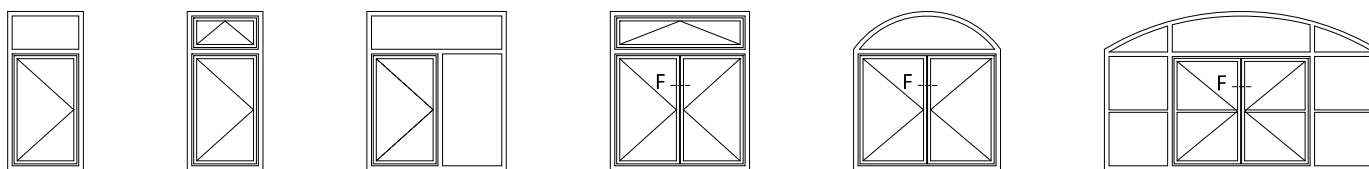


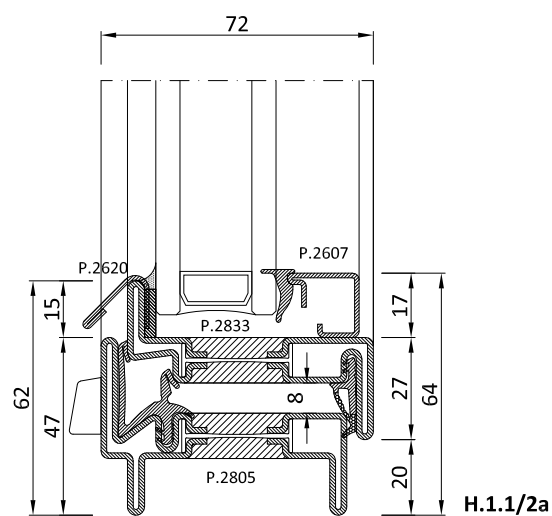
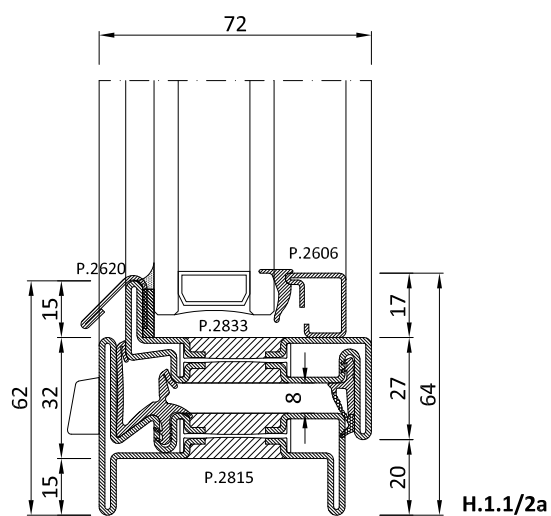
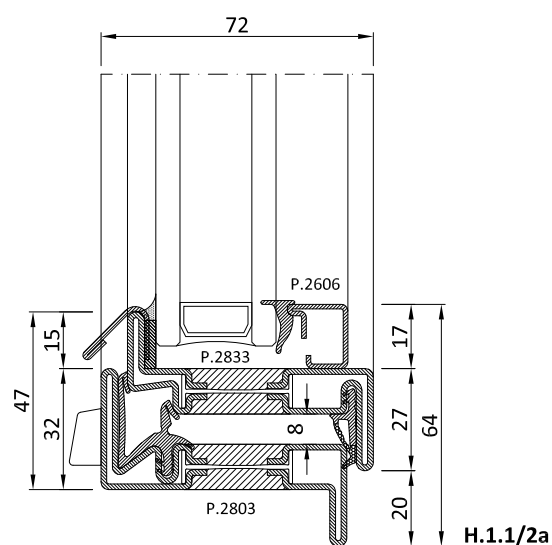
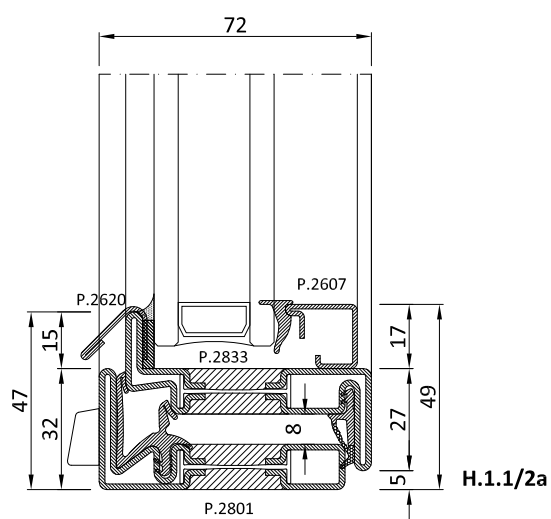
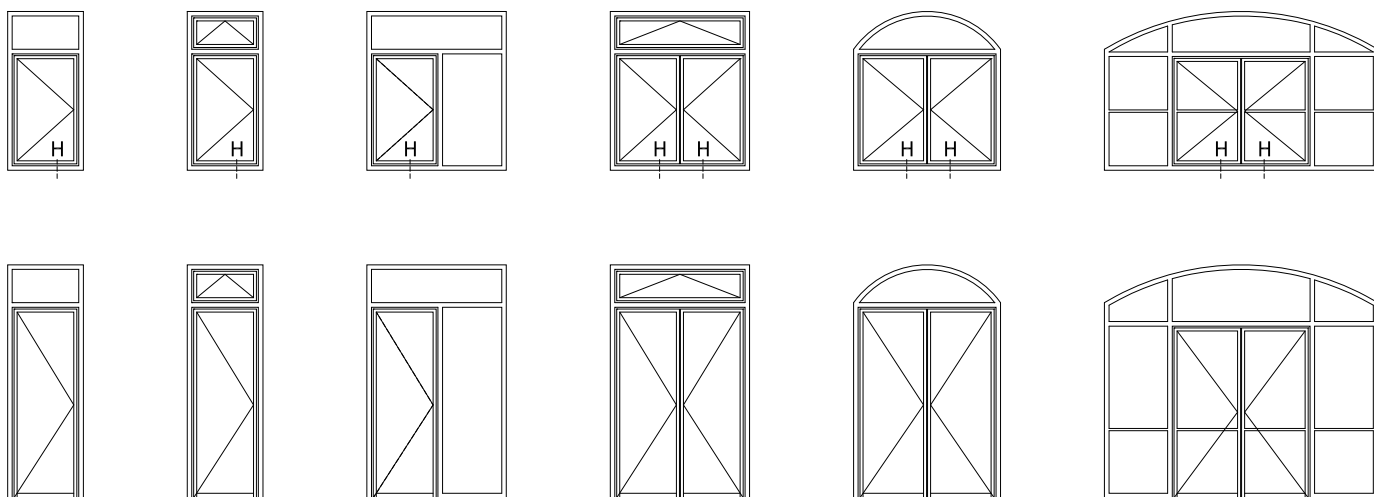
* Attenzione non utilizzabile con profilo P.2842
* Unable to use with P.2842 profile

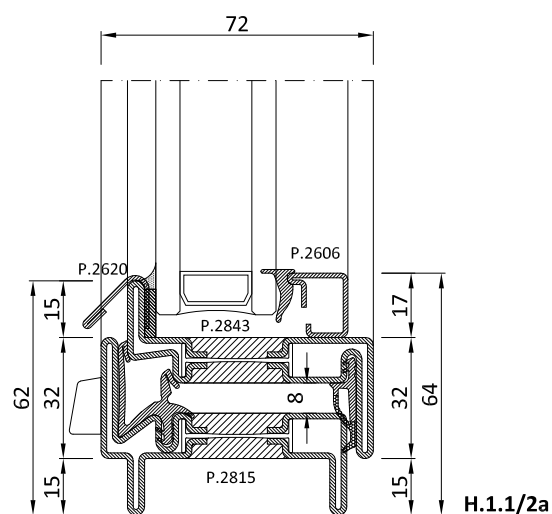
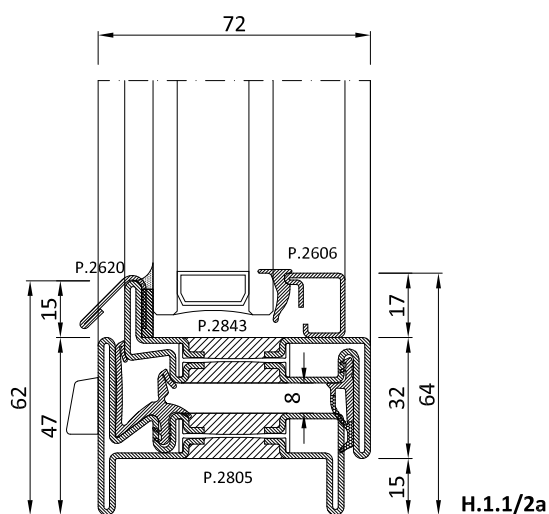
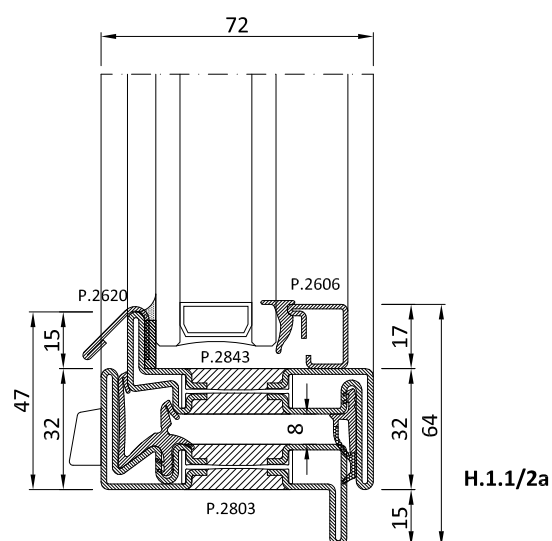
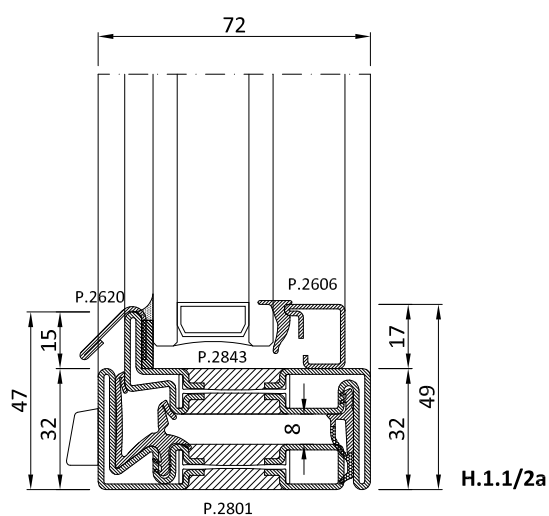
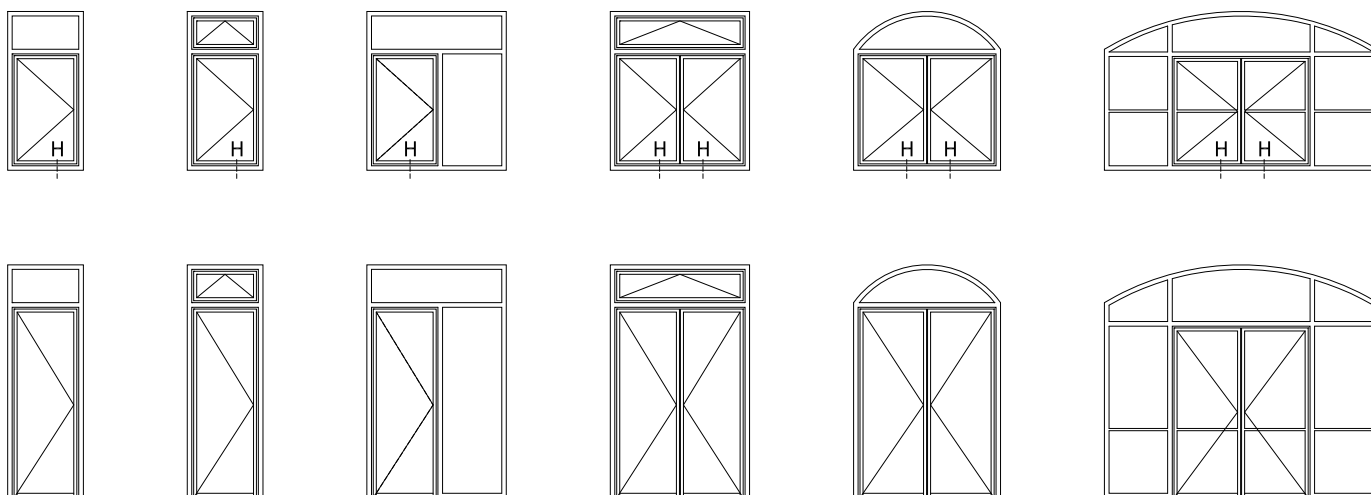


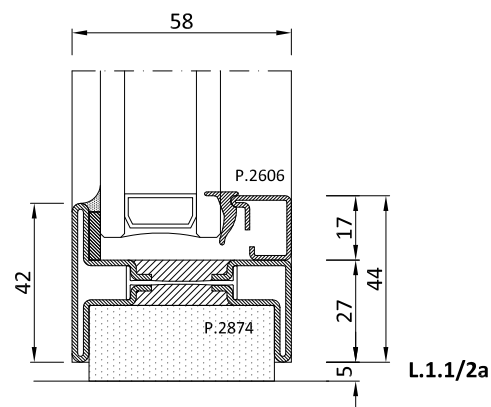
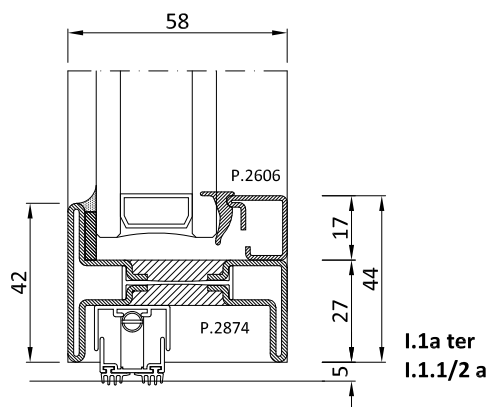
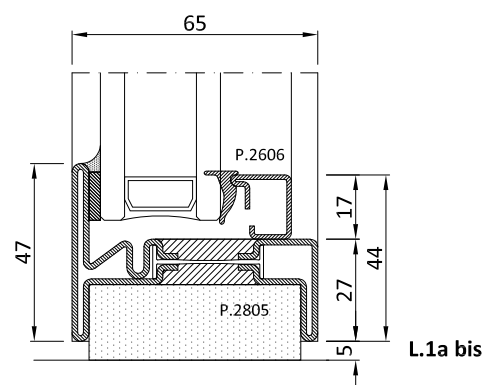
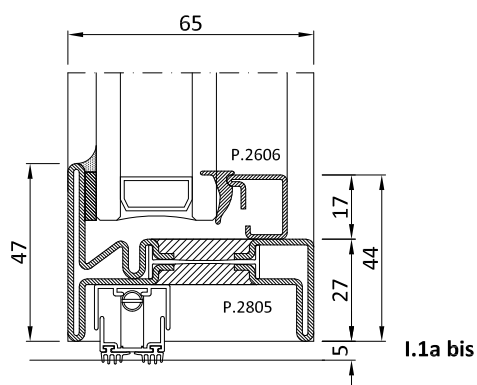
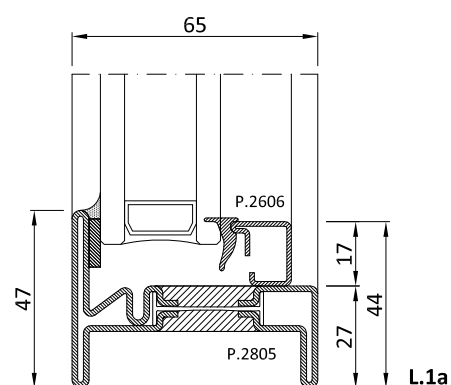
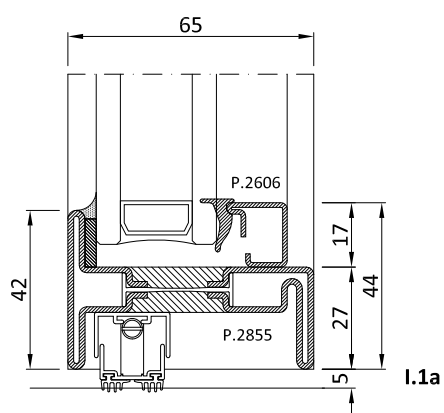
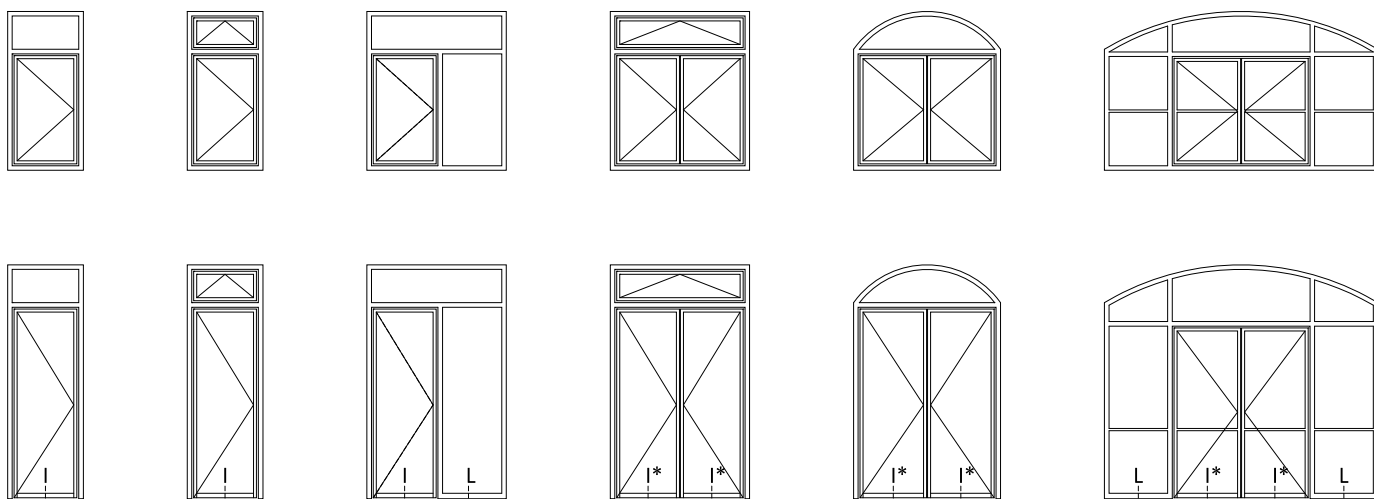






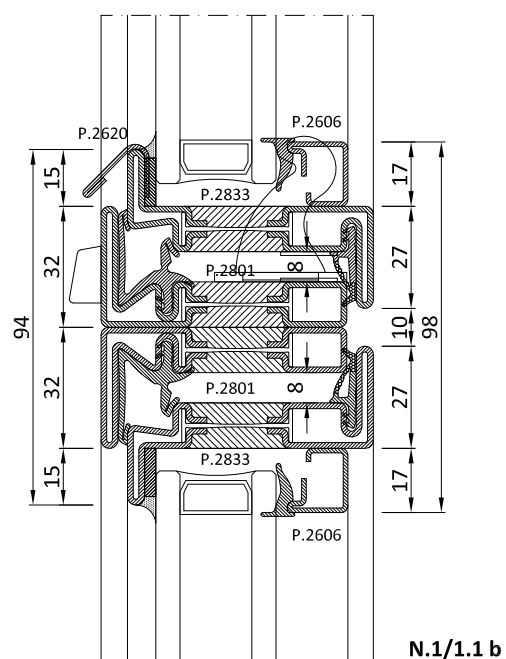
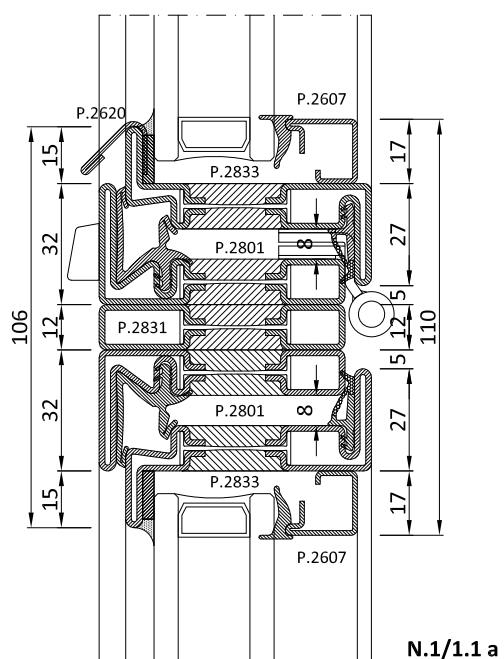
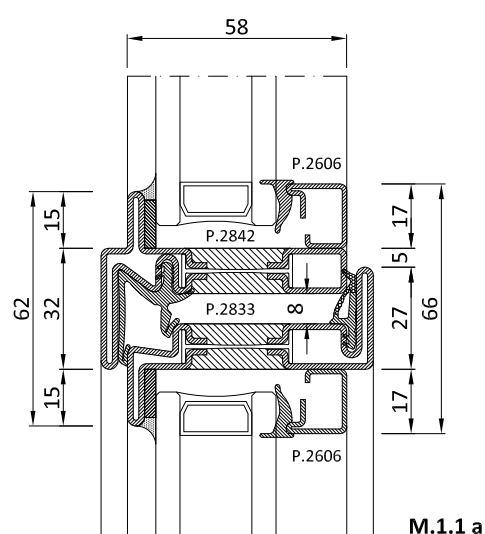
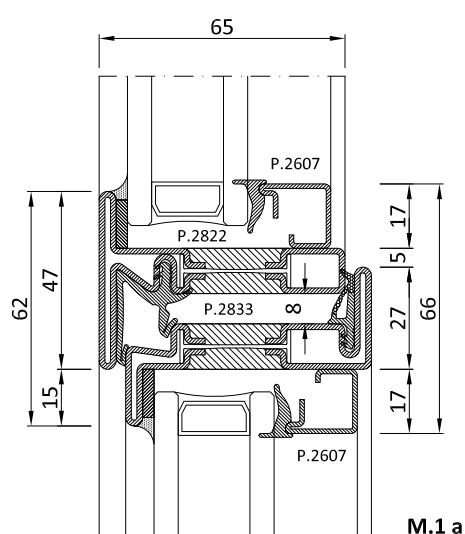
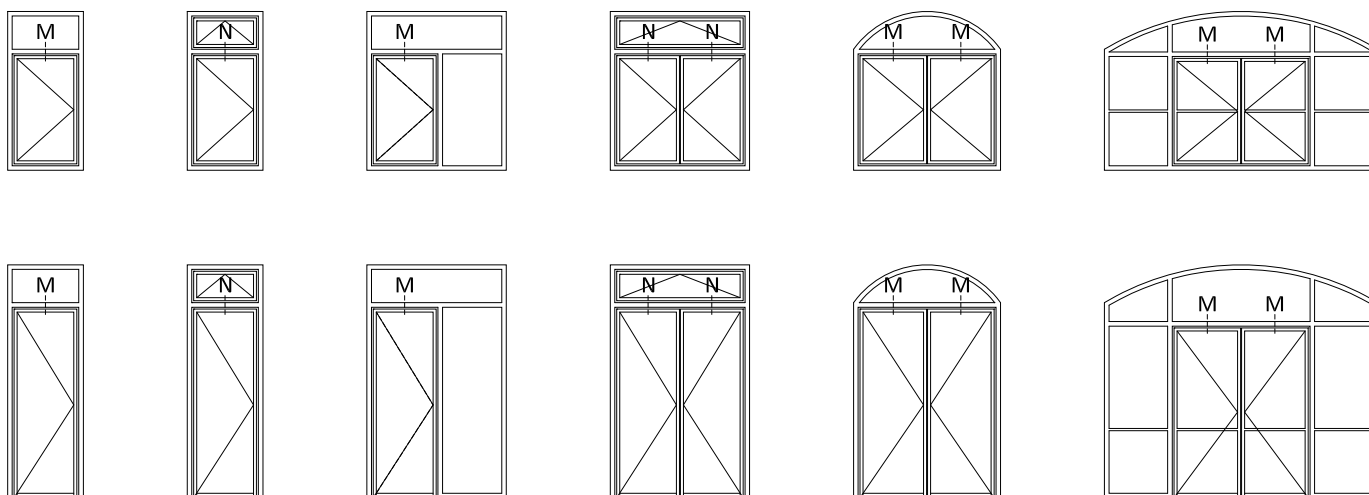


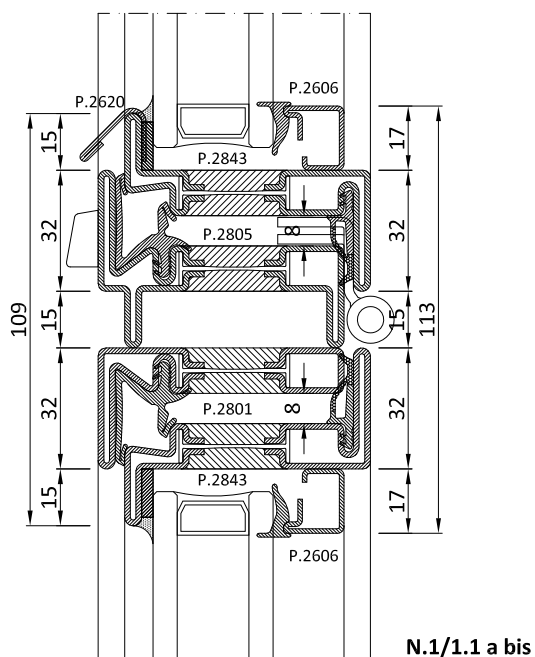
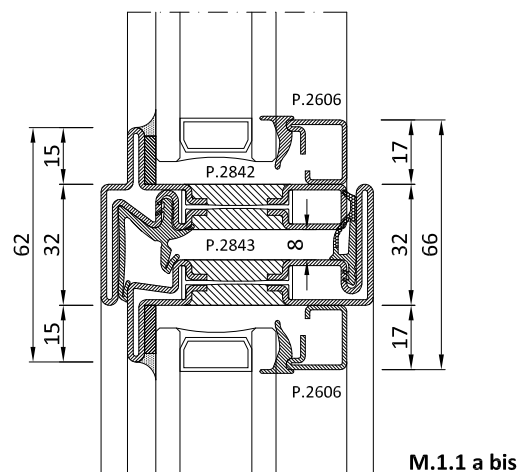
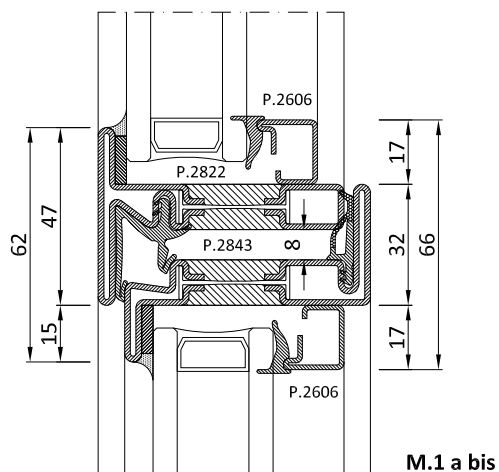
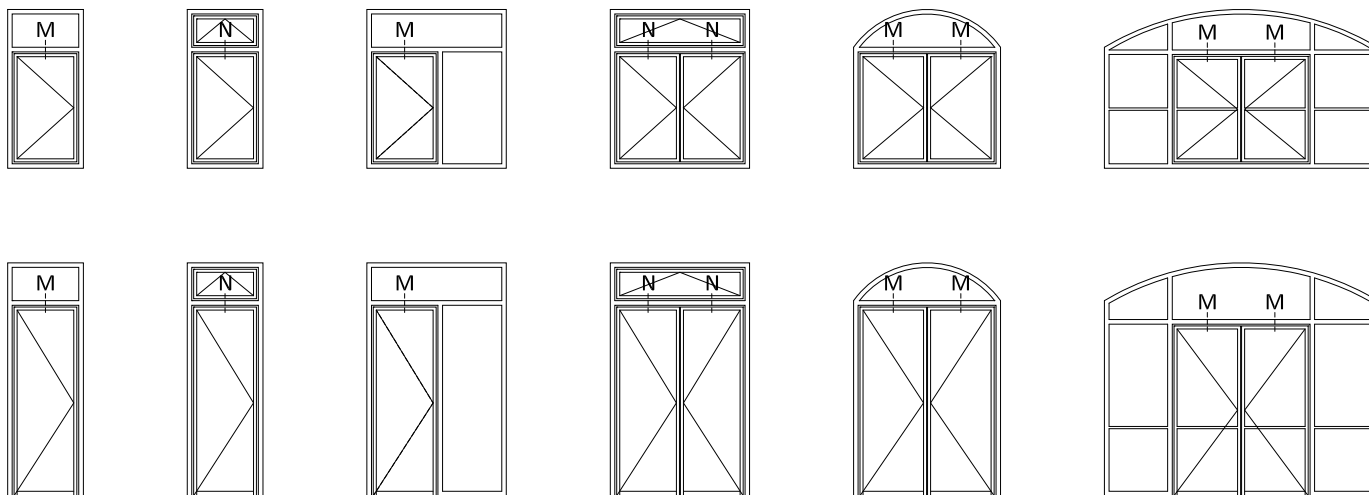


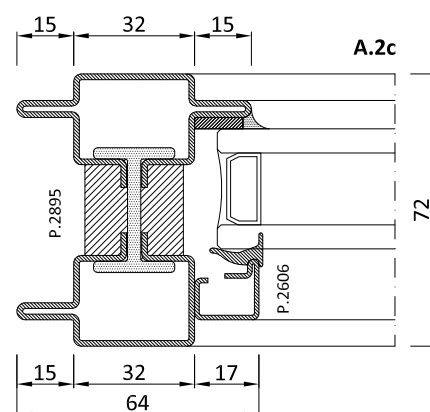
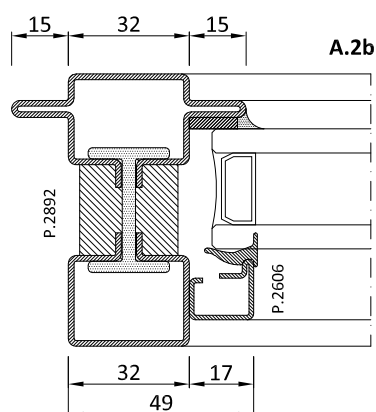
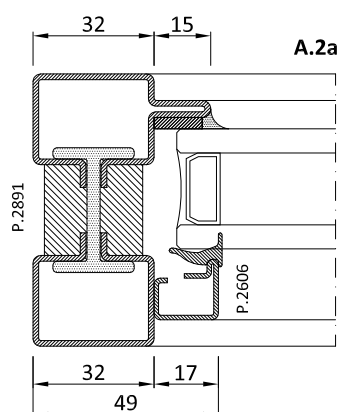
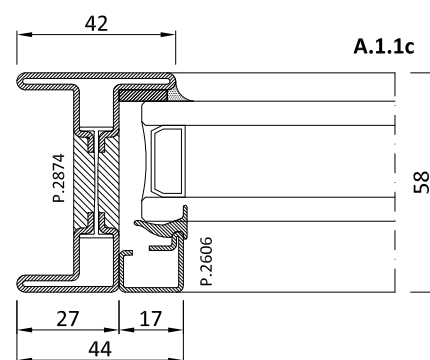
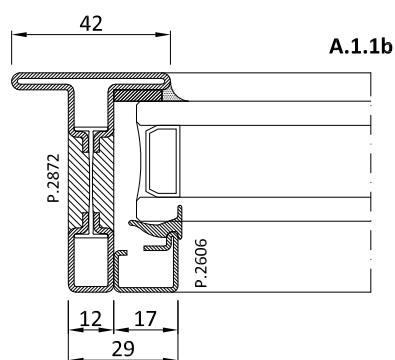
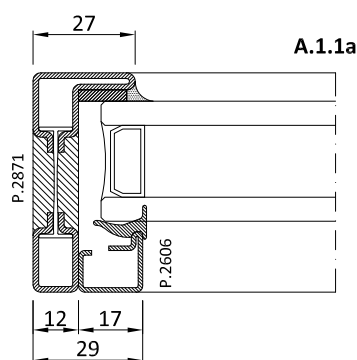
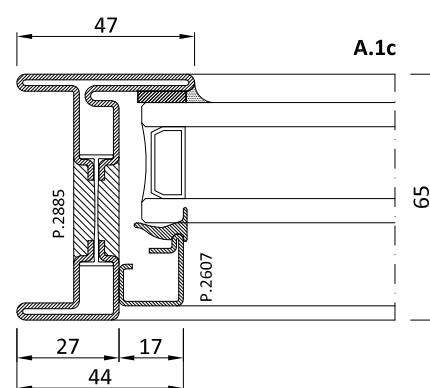
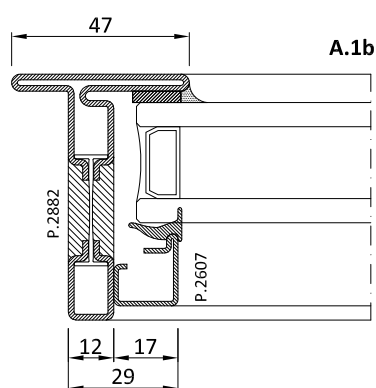
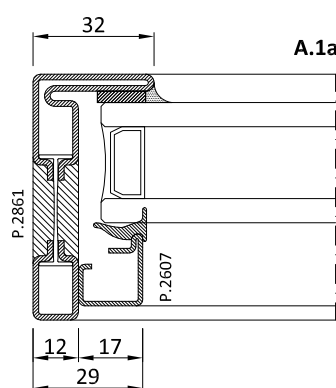
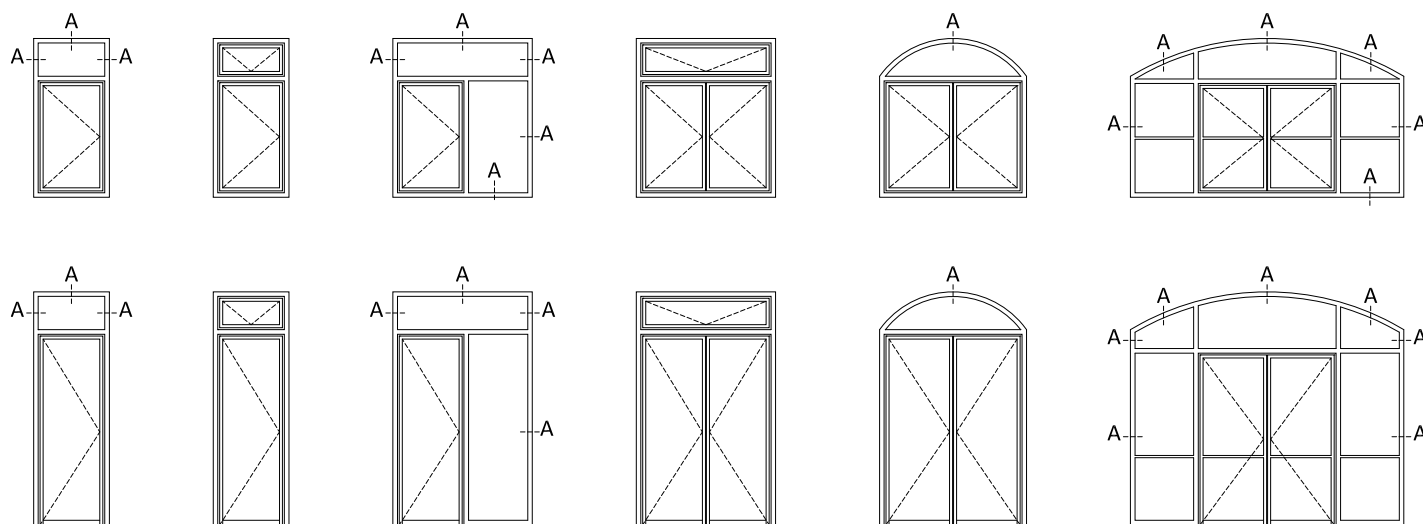


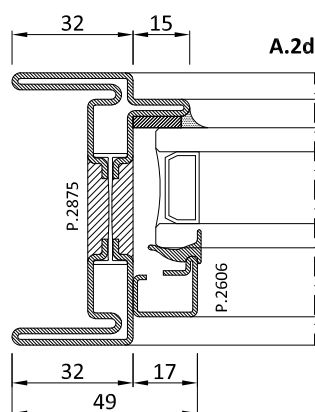
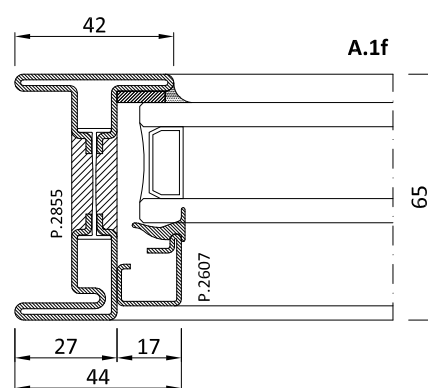
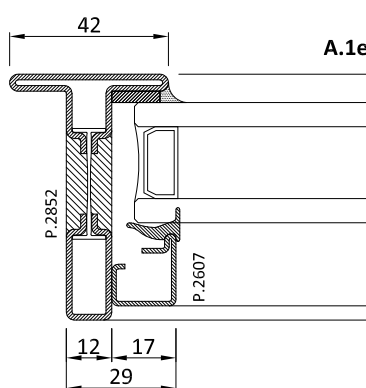
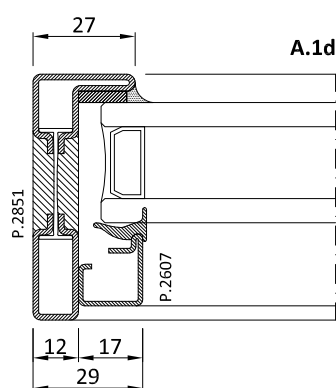
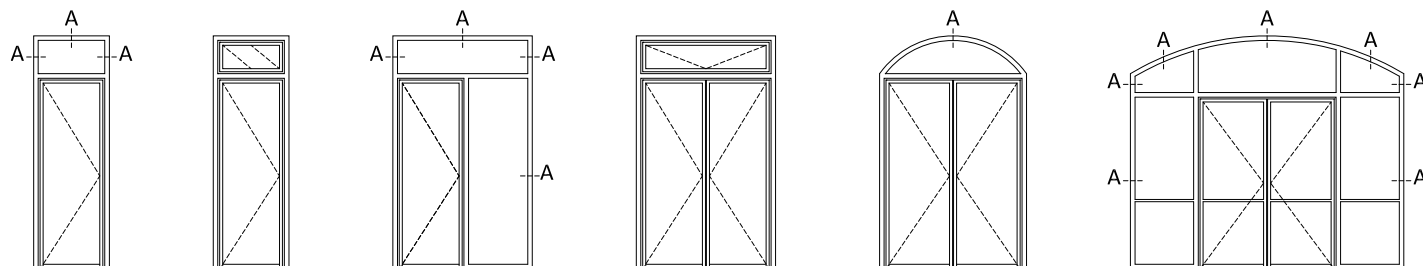
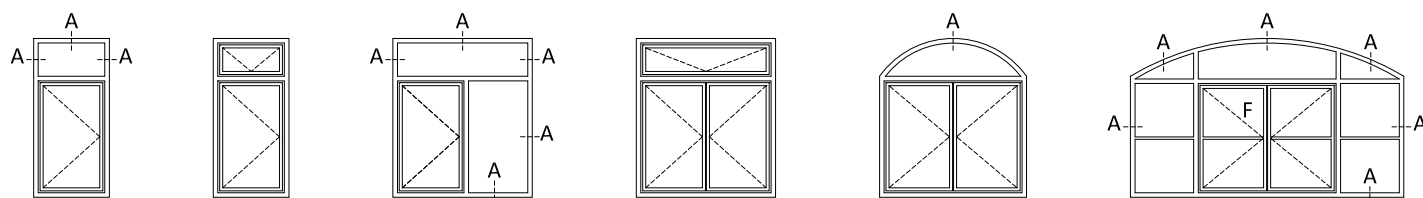
* Porta a due ante con profili P.2843/42 standard profilo zoccolo P.2874

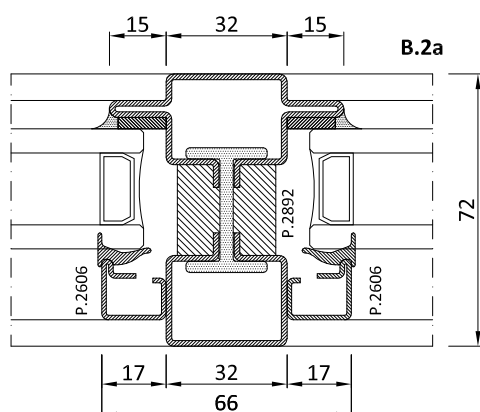
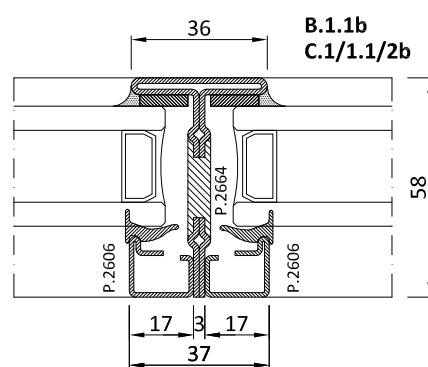
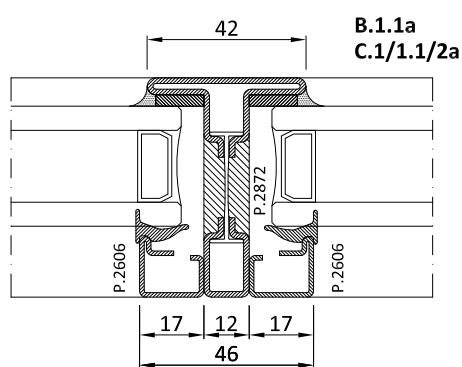
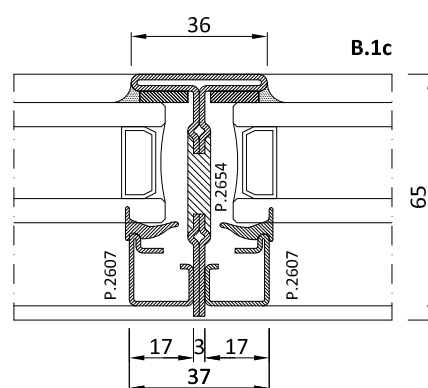
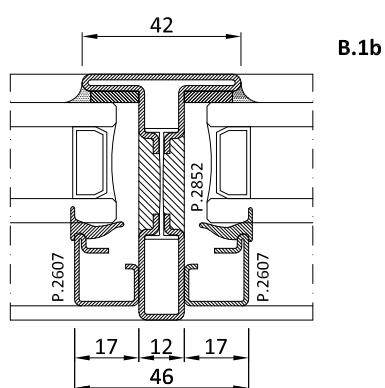
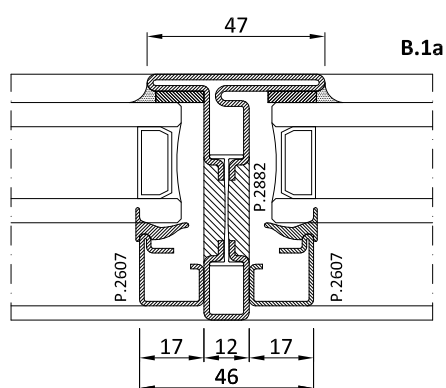
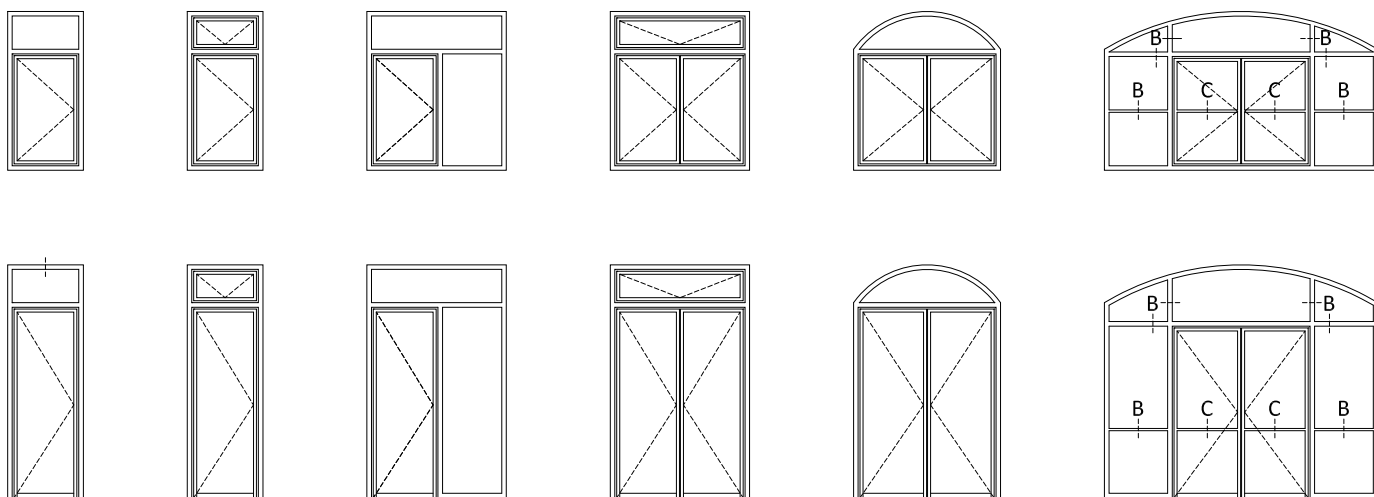
* Double leaf door with profiles P.2843/42 standard socle profile P.2874

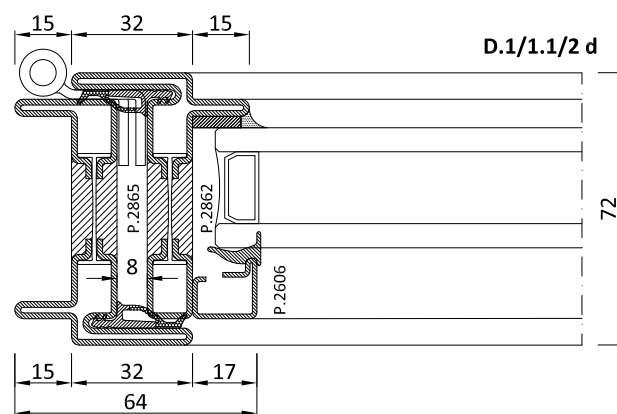
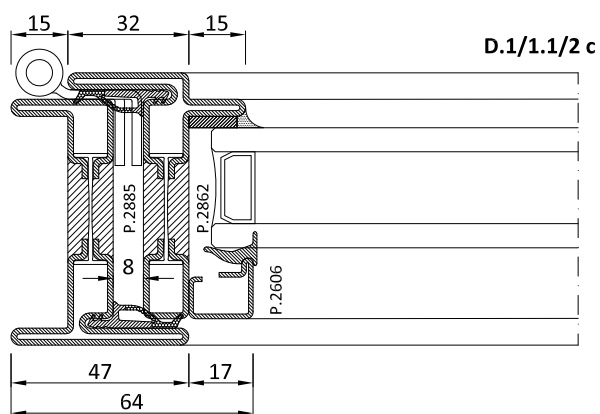
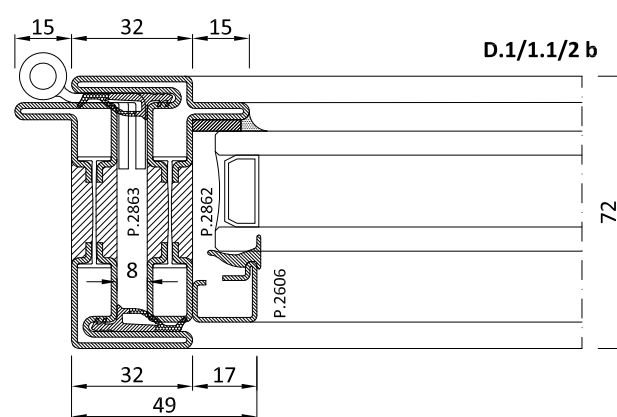
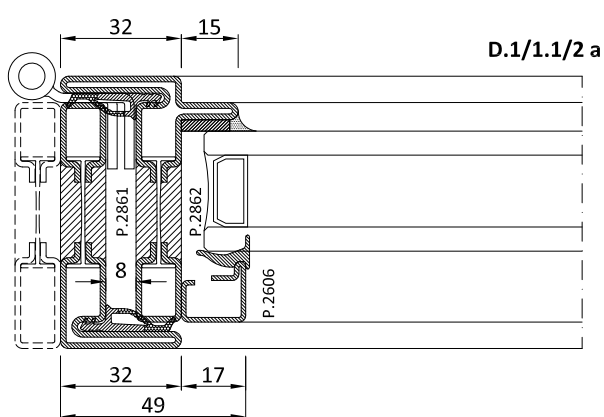
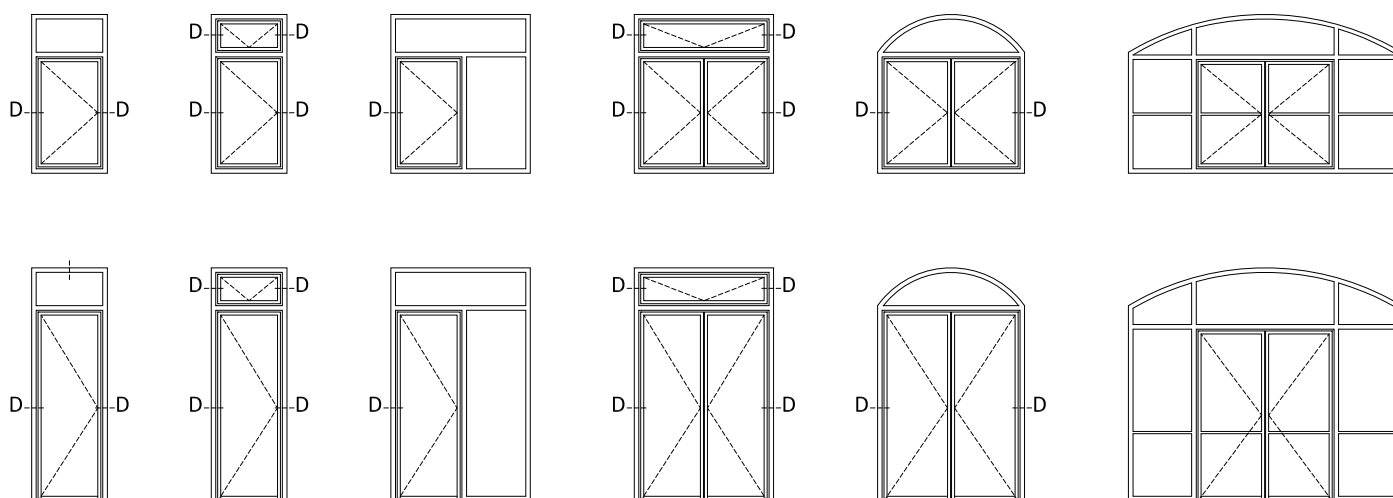


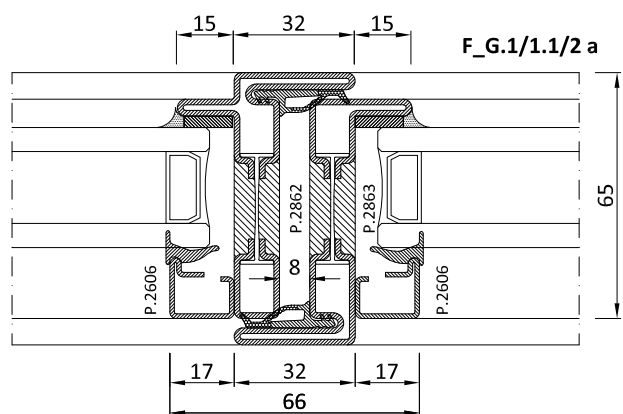
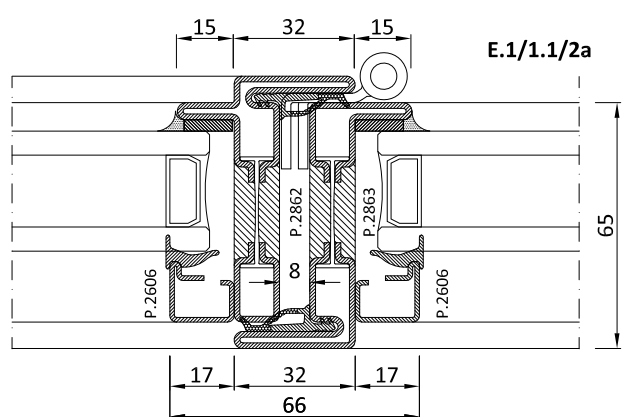
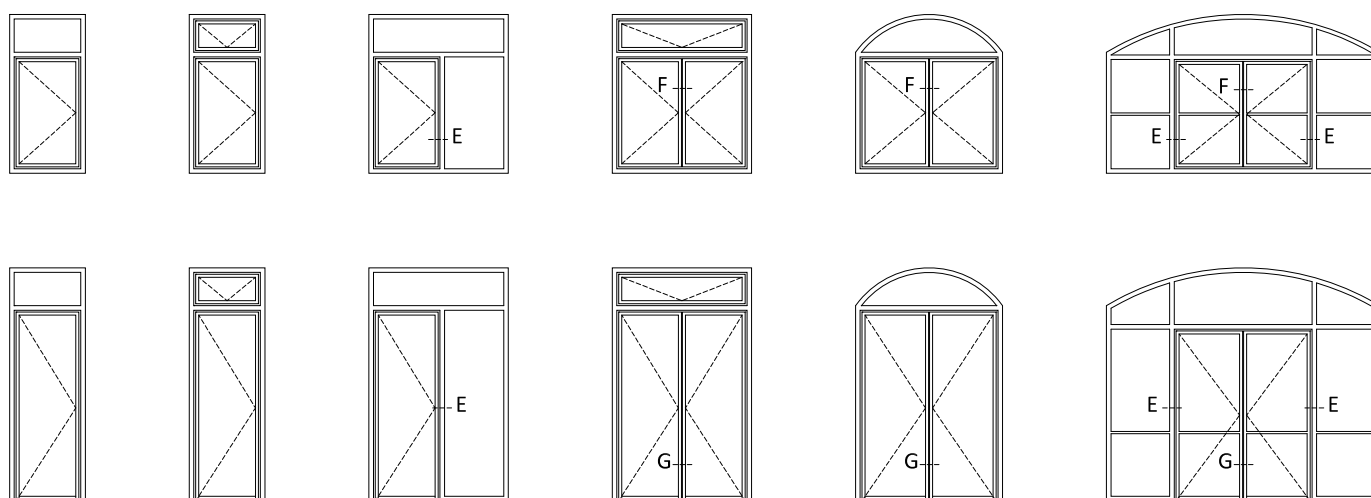


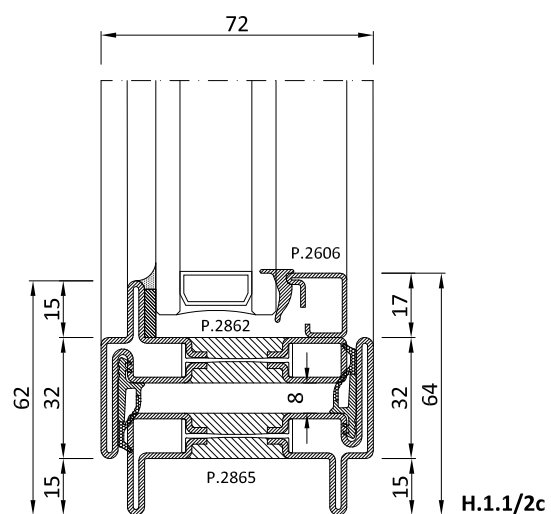
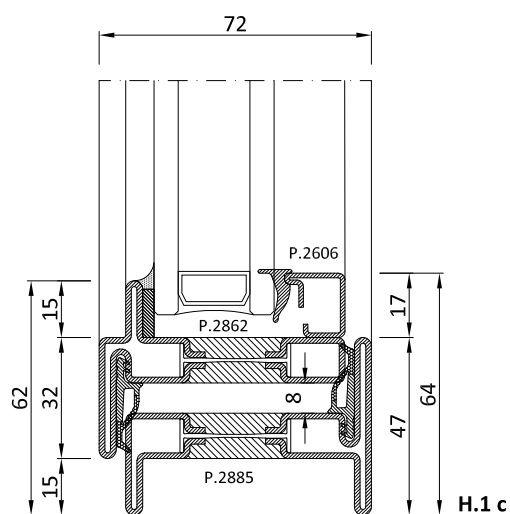
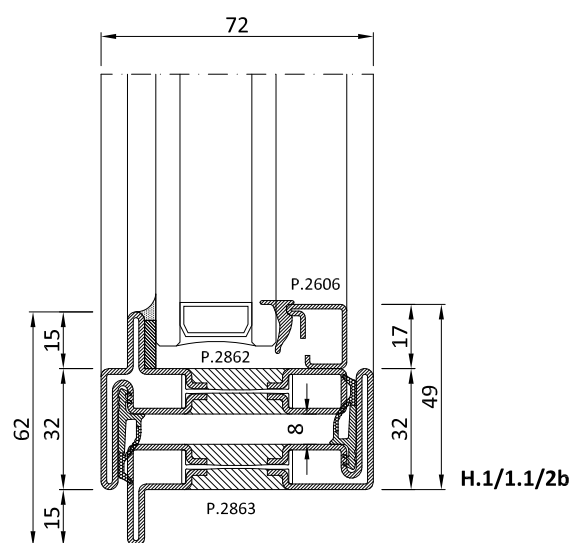
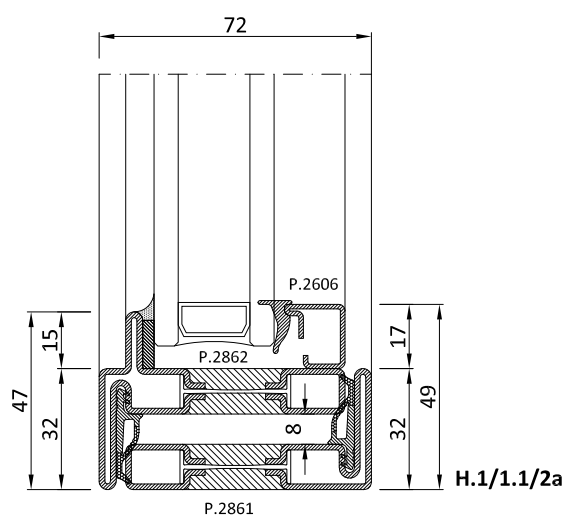
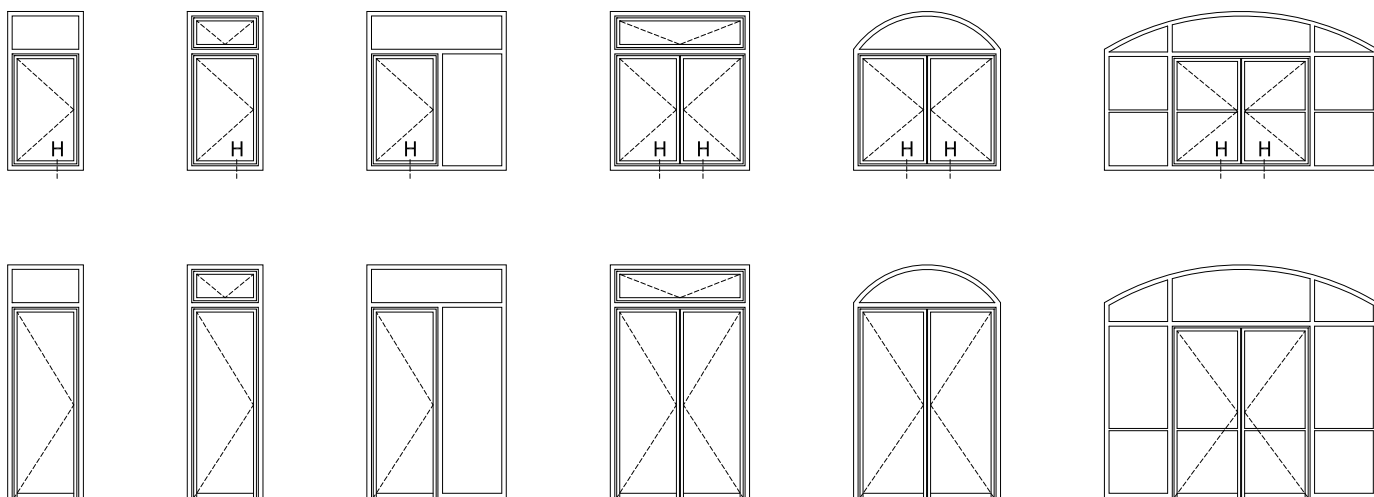


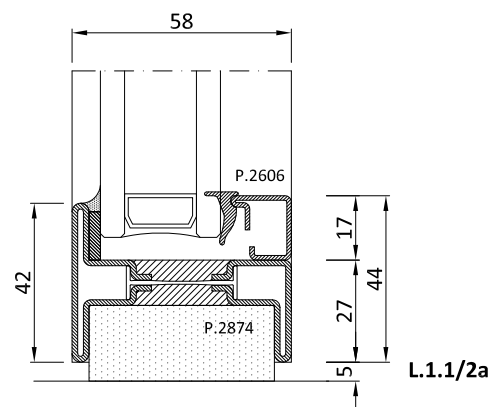
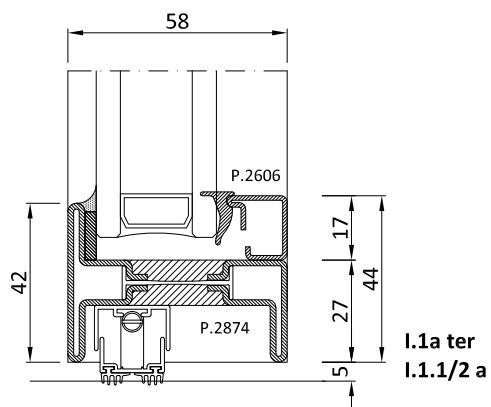
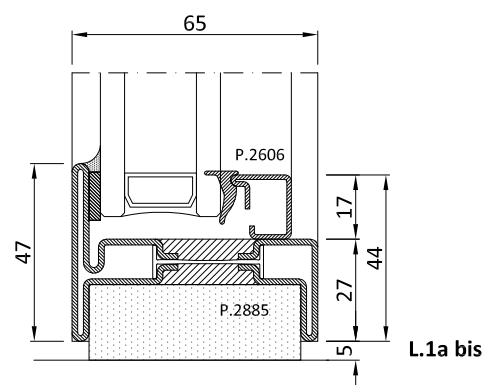
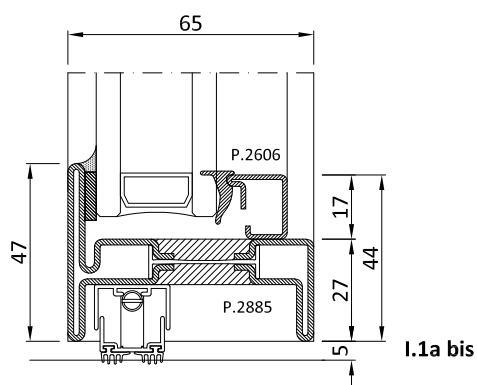
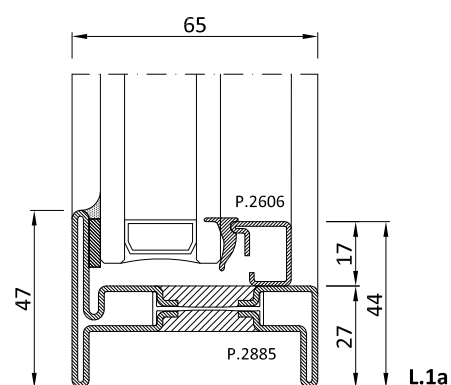
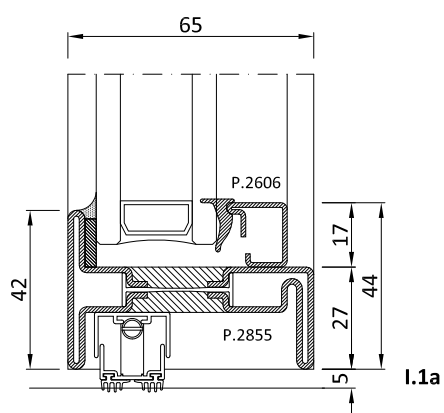
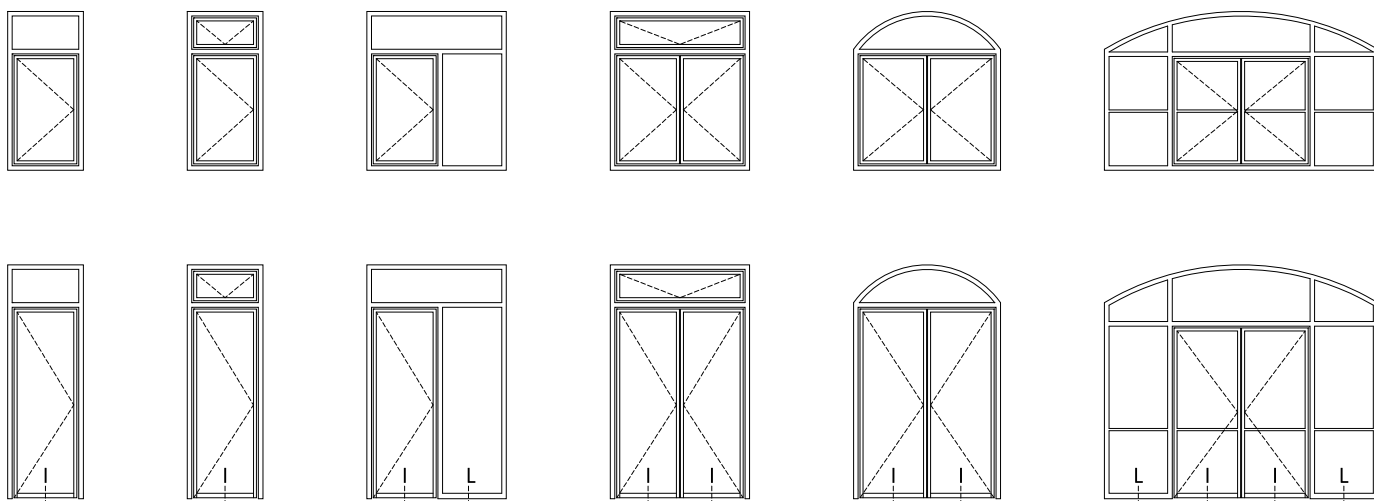






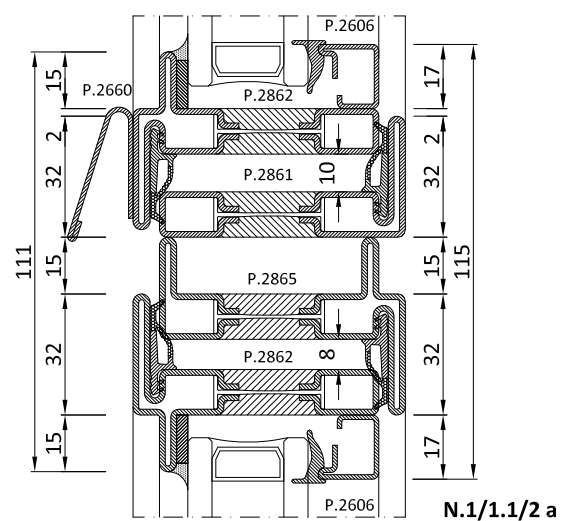
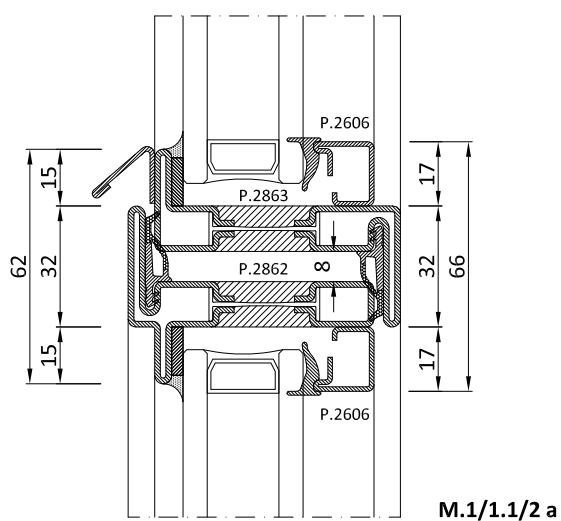
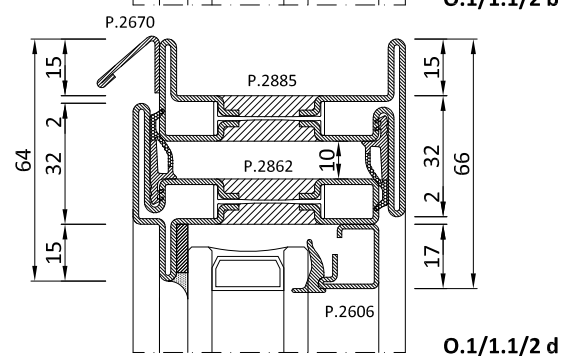
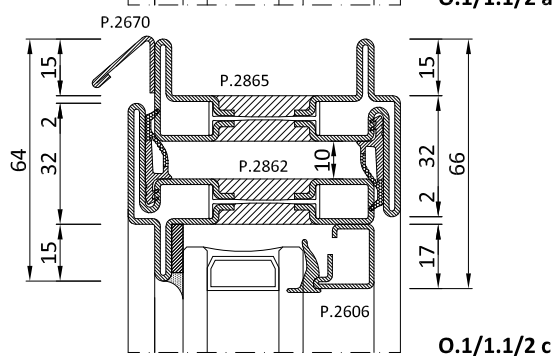
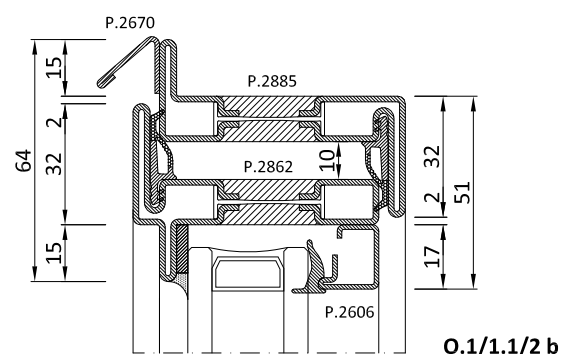
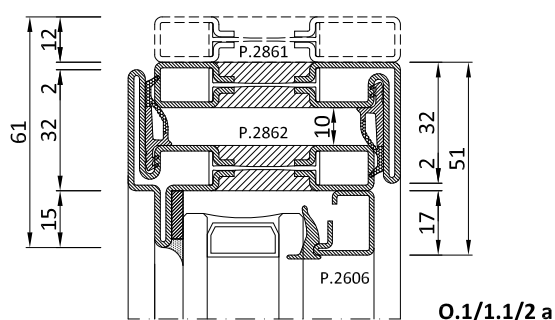
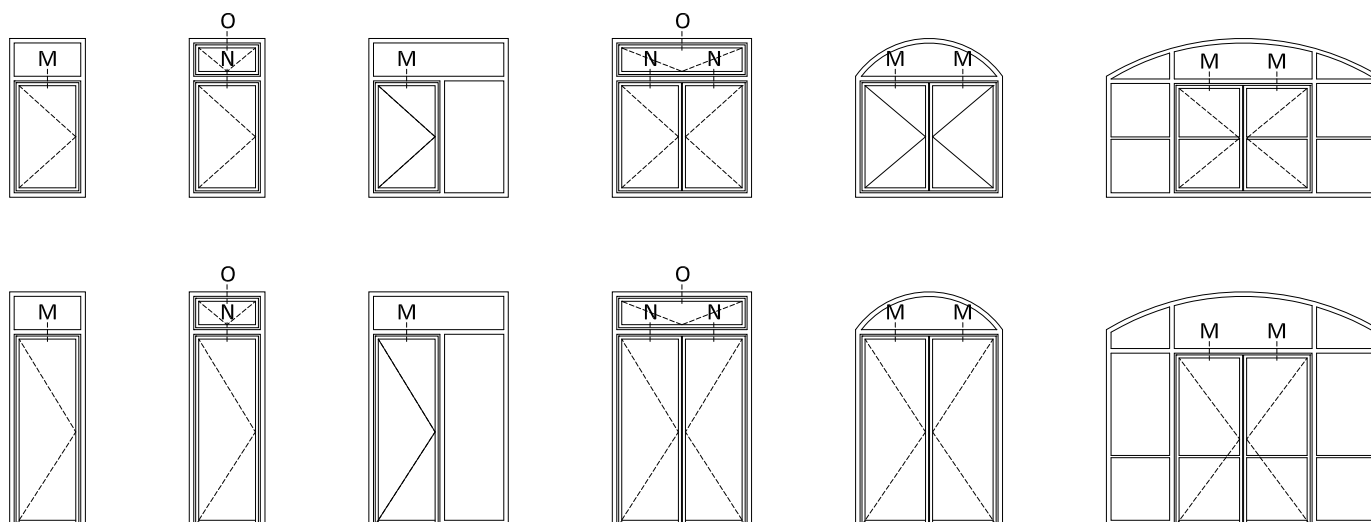


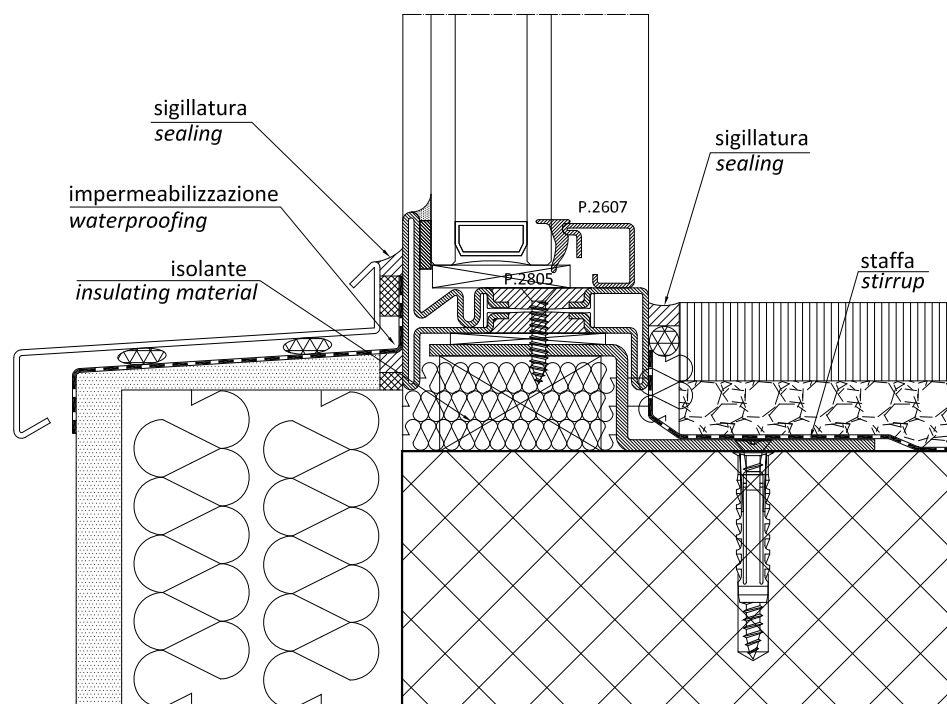
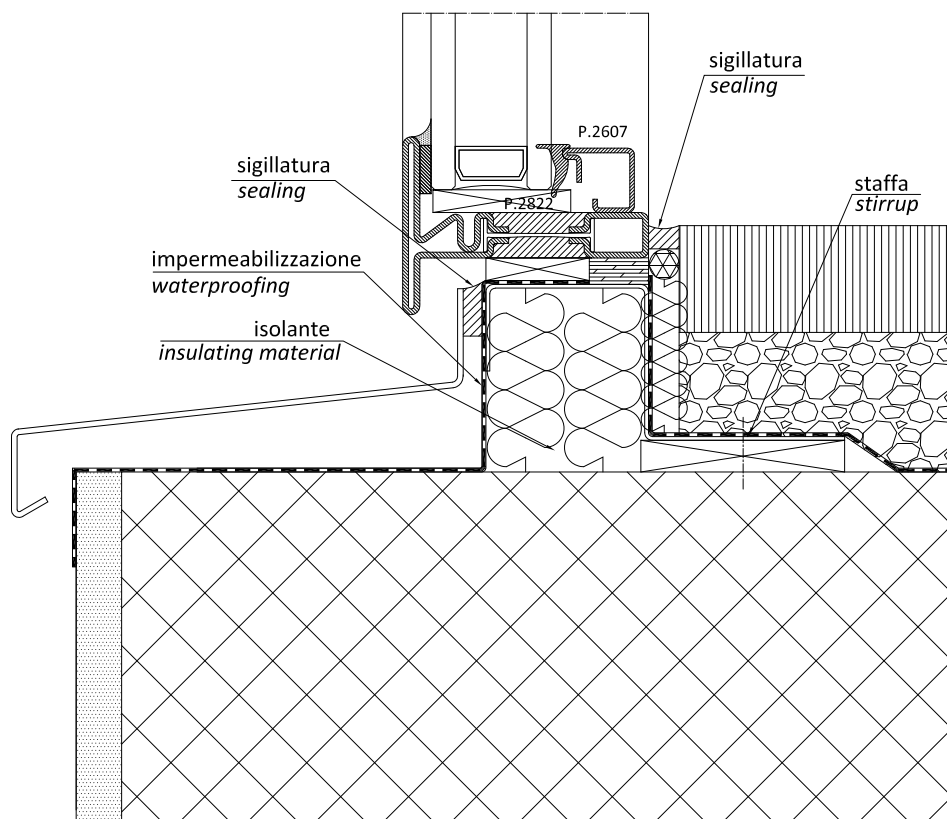


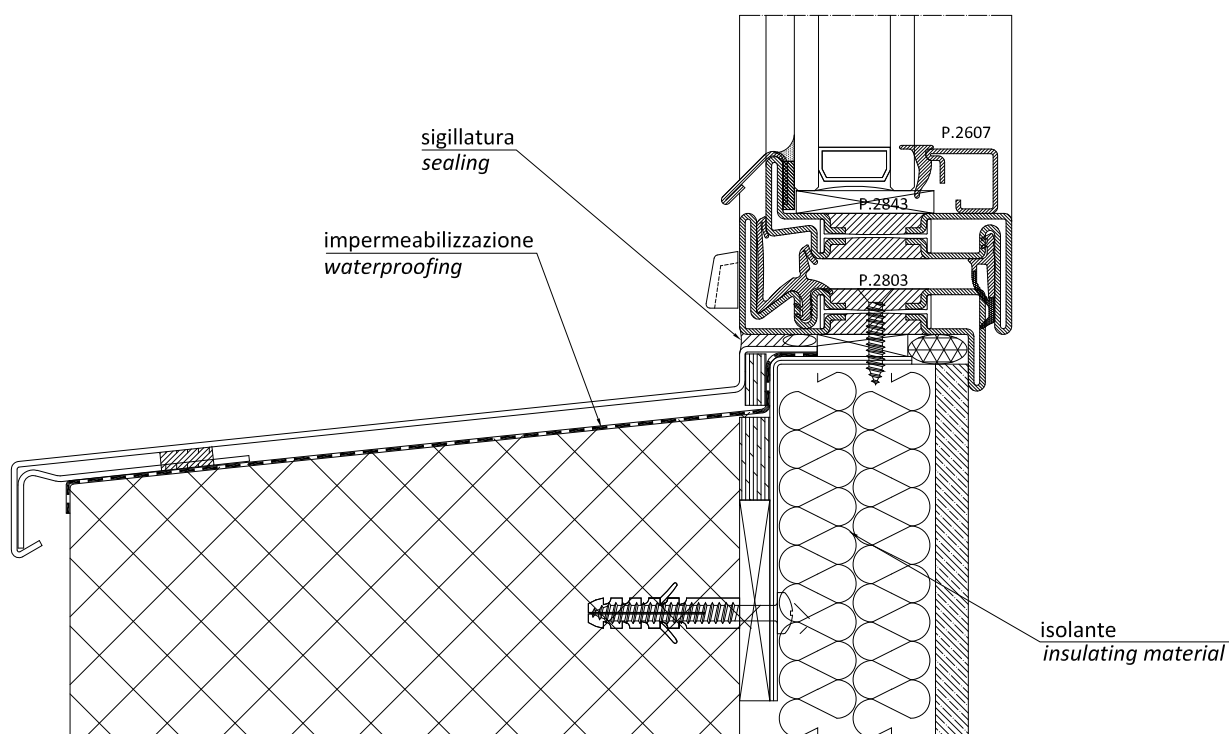
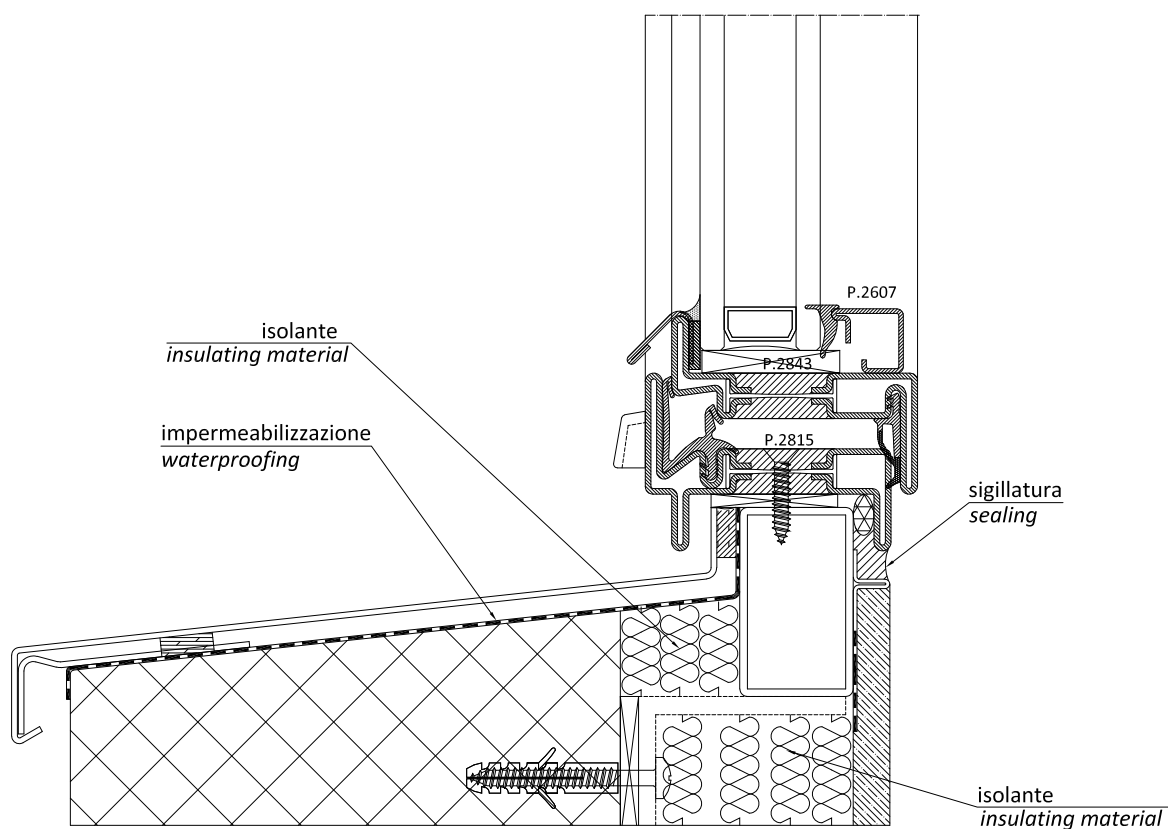


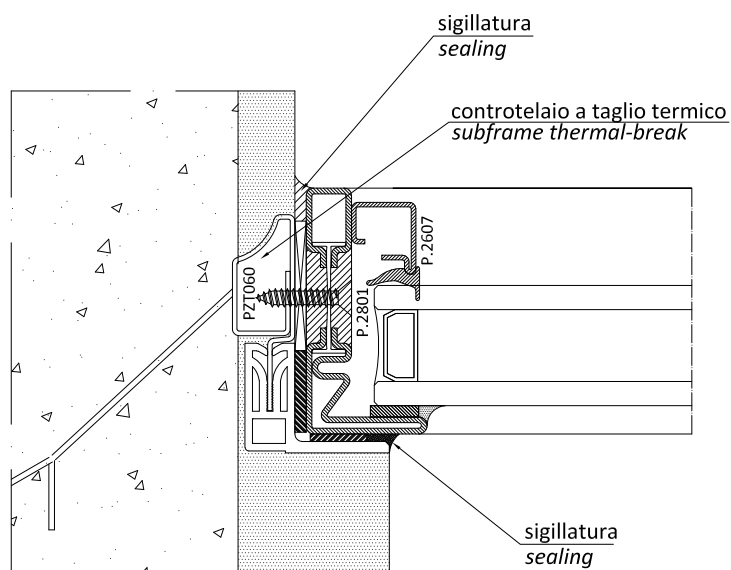
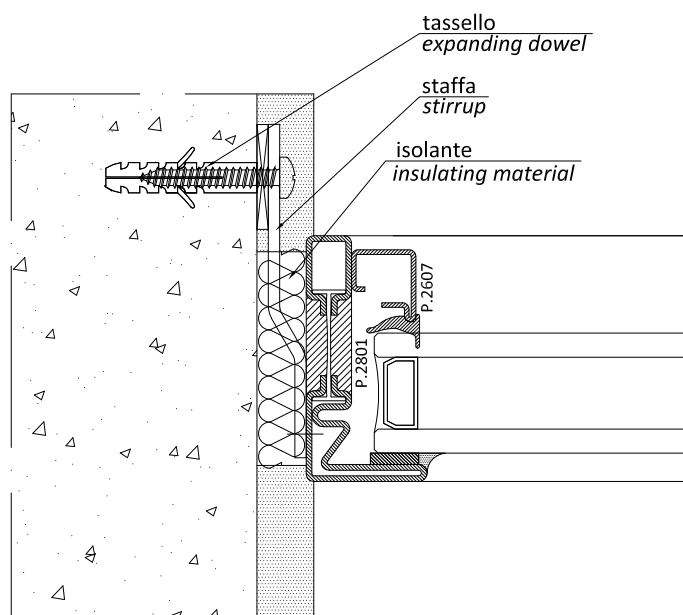
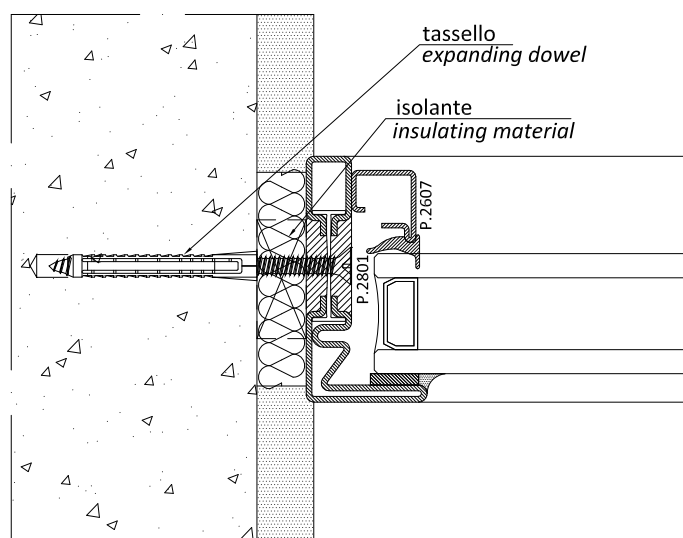
* Porta a due ante con profili P.2862/63 standard profilo zoccolo P.2874

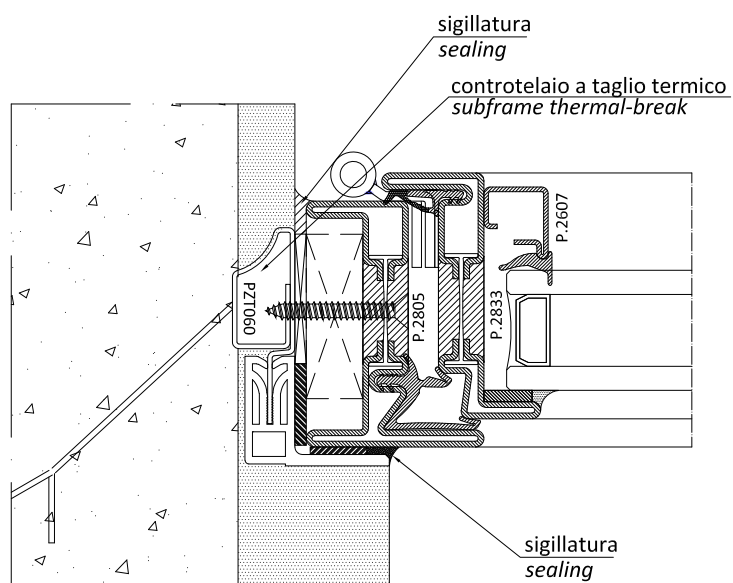
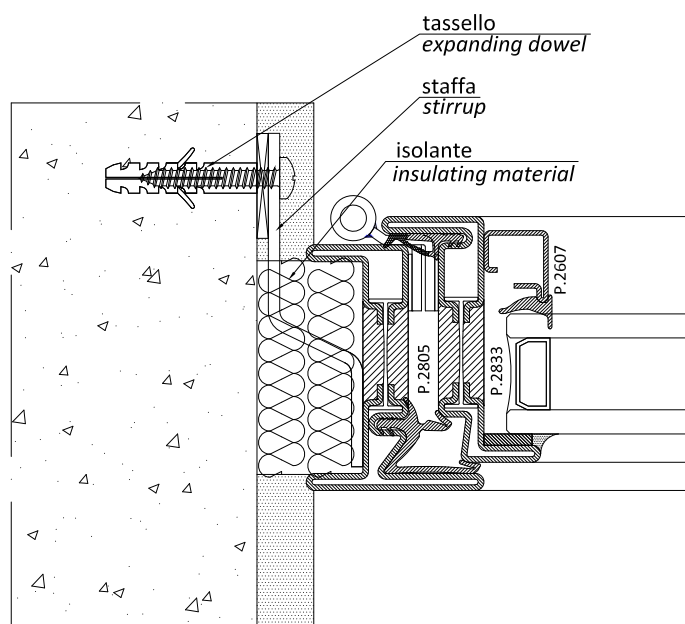
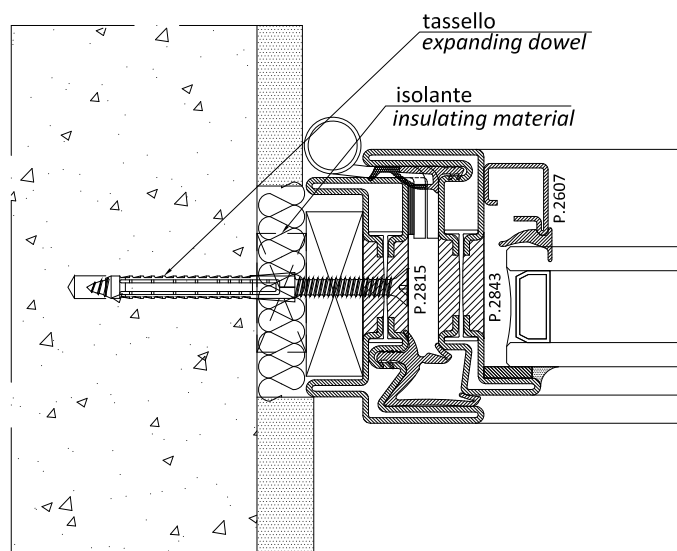
* Double leaf door with profiles P.2862/63 standard socle profile P.2874



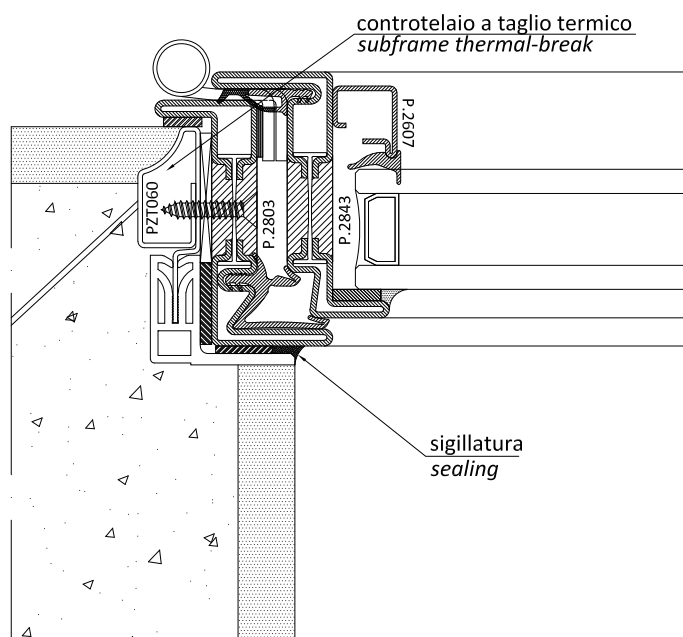
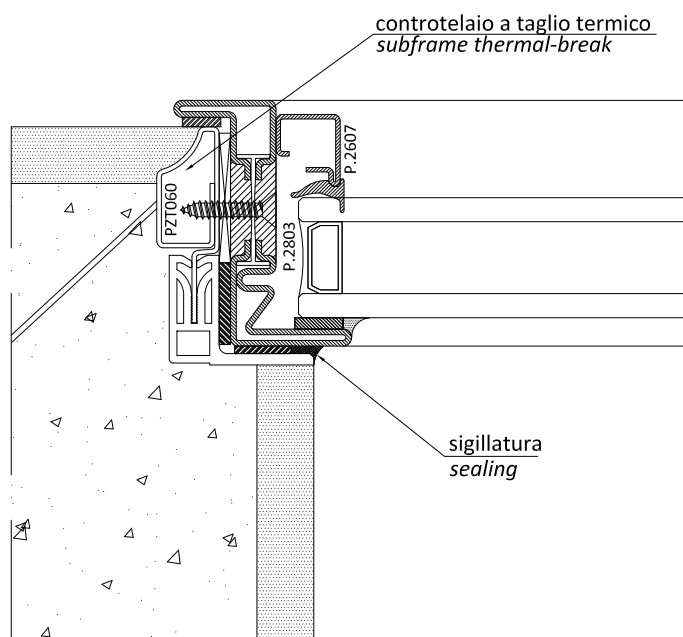








Applicare viti di fissaggio profilo a muro in corrispondenza dell'asse cerniere
 Fixing screws in correspondence of hinge axis



Applicare viti di fissaggio profilo a muro in corrispondenza dell'asse cerniere
 Fixing screws in correspondence of 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.

Lavorazioni su barra / Section working

Taglio / Cut	5.1.1-2 5.2.1-2
Fori per cerniere ad avvitare / Screw-on hinges holes	4.3.27-38
Fori e asole per cremonese / Cremonese bolt holes and slots	4.3.17-24
Fori e asole per chiusura supplementare / Additional locking points slots and holes	4.3.25-26
Fori per scarico acqua / Water drip holes	4.3.13
Taglio punta per inversione battuta / Secondary leaf top central joint working	4.3.3-18
Fori inserimento rinforzi cerniere / Hinge reinforcement holes	4.3.1-2
Fresatura per catenacci 2° anta / Secondary leaf flush bolt milling	4.3.48-50
Fori limitatori apertura per apertura ad anta / Casement restrictor stays holes	4.3.39-44
Fresature per compassi e limitatori sporgere / Stay arm and restrictor stays for awning windows milling	4.3.45-47
Fori staffe per P.2610 / P.2610 coupling brackets holes	4.3.12
Lavorazione gocciolatoio / Water drip section workink	4.3.13
Fori fissaggio a muro / Wall mounting holes	3.3.1-5

Assiemaggio / AssemblyCostruzione telai / Frame assembly

Saldatura / Welding	4.4.1-4
Inserimento squadrette (profili ottone) / Brackets insertion (brass section)	4.4.2-3
Sigillatura interna della giunzione (profili ottone) / Internal joint sealing (brass sections)	4.4.1

Applicazione accessori / Accessories installation

Saldatura cerniere a saldare / Screw-on hinges holes	4.4.5-7
Fori snapper 2° anta / Secondary leaf snapper holes	4.5.6 4.5.8
Fori cerniera a scomparsa vasistas / Concealed hinges for bottom-hung window holes	4.5.21-22
Fori cricchetto e braccetti vasistas / Finger catch and stay arms for bottom hung window holes	4.5.23
Fori chiusure mediane a scomparsa / Concealed hinge side middle closing holes	4.5.16
Fori maniglia trascinalimento seconda anta / Pulling handle secondary leaf holes	4.5.24
Fori limitatori apertura per apertura ad anta / Restrictor stays holes	4.3.39-44
Fori per compassi e limitatori sporgere / Stay arm and restrictor stays for awning windows holes	4.3.45-47

Preparazione per verniciatura e ossidazione / Preparation for the powder coating - burnishing

Fori su telaio per scarichi liquidi pretrattamento / Holes on frame for the drainage of pretreatment liquid	5.1.4
Pulitura della superficie (ottone) / Cleaning of the surface	5.1.4

Montaggio accessori / Accessories installation

Applicazione e sigillatura guarnizioni giunto aperto / Sealing of central gasket	4.5.1-2
Applicazione scarichi acqua / Water drip installation	4.5.1
Montaggio cerniere / compassi / vasistas etc. / Hinges and arms installation (side hung, bottom-hung, awning)	4.5.15-23
Montaggio cremonese e incontri / Cremonese bolt installation	4.5.3-15
Montaggio guarnizioni di battuta / Gasket installation	...
Sigillatura angolo nel TT / Corner joint sealing	4.5.1

Vetrazione / Glazing

Applicazione clips fermavetro / Glazing bead clips installation	2.8.1-12
Applicazione vetro (spessoramento) / Glazing installation (setting blocks)	4.6.1

Lavorazioni su barra / Bar workings

Taglio / Cut	5.1.1-2 5.2.1-2
Fori per cerniere ad avvitare / Screw-on hinges holes	4.3.27-38
Fori e asole per serratura e incontri / Lock and strike slots and holes	4.3.53-56
Fori e asole per chiusura supplementare / Additional locking points slots and holes	4.3.57-58
Taglio punta per inversione battuta / Secondary leaf top central joint working	4.3.3-8
Fori inserimento rinforzi cerniere / Hinge reinforcement holes	4.3.1-2
Fresatura per catenacci 2° anta / Secondary leaf flush bolt milling	4.3.48-50
Fori fissaggio a muro / Wall mounting holes	3.3.1-5

Assiemaggio / Assembly

<u>Costruzione telai / Frame assembly</u>	
Saldatura / Welding	4.4.1-3
Inserimento squadrette (profili ottone) / Brackets insertion (brass section)	4.4.2-3
Sigillatura interna della giunzione (profili ottone) / Internal corner joint sealing (brass sections)	4.4.1
<u>Applicazione accessori / Accessories installation</u>	
Saldatura cerniere a saldare / Weld-on hinges welding	4.4.5-7
Lavorazione per paraspiro automatico / Automatic door bottom seal working	4.3.51-52

Preparazione per verniciatura e ossidazione / Preparation for the powder coating – burnishing

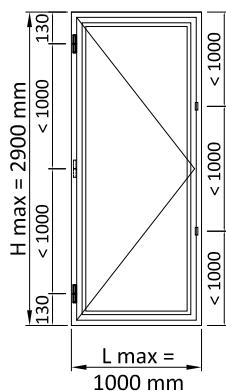
Fori su telaio per scarichi liquidi pretrattamento / Holes on frame for the drainage of pretreatment liquid	5.1.4
Pulitura della superficie (ottone) / Cleaning of the surface	5.1.4

Montaggio accessori / Accessories installation

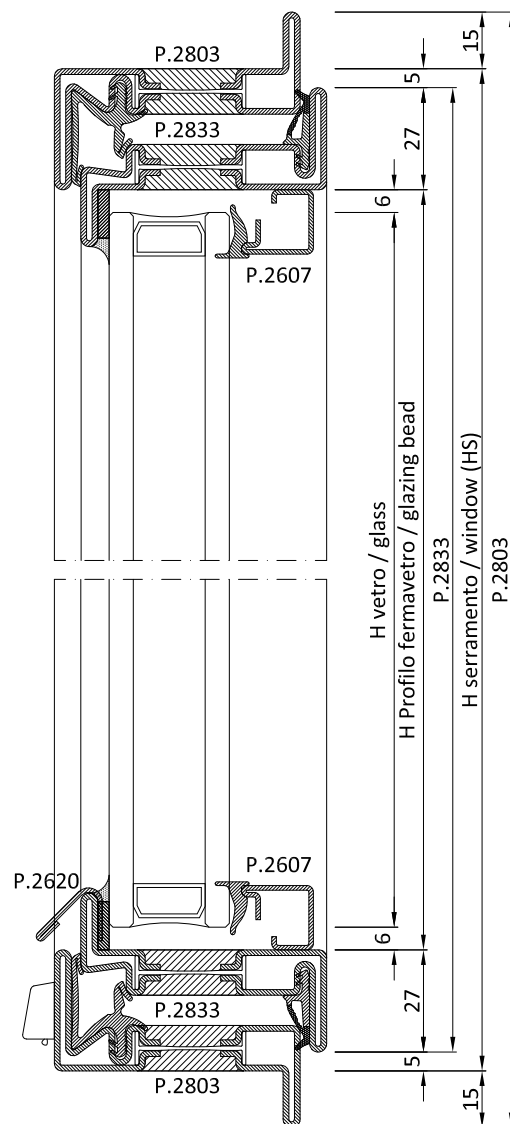
Montaggio cerniere / Hinges installation	4.3.27-38
Montaggio serratura e incontri / Lock and strikes installation	4.5.25-28
Applicazione paraspiro automatico / Automatic door bottom seal installation	4.3.51-52
Montaggio catenaccio / Flush bolt installation	4.3.48-50
Montaggio guarnizioni di battuta / Gasket installation	...
Sigillatura angolo nel TT / Corner joint sealing	4.5.1

Vetrazione / Glazing

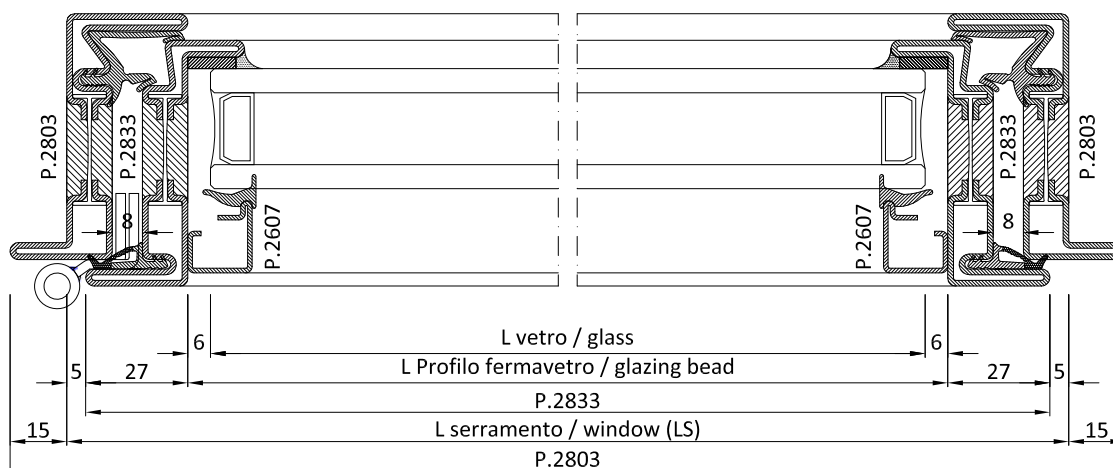
Applicazione clips fermavetro / Glazing bead clips installation	2.8.1-12
Applicazione vetro (spessoramento) / Glazing installation (setting blocks)	4.6.1

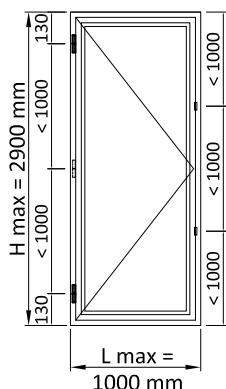


PROFILI		PROFILES				
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
Telaio		Frame				
P.2803	Profilo a "Z" telaio	"Z" profile frame	2	LS+30	45°	45°
P.2803	Profilo a "Z" telaio	"Z" profile frame	2	HS+30	45°	45°
Anta		Leaf				
P.2833	Profilo a "Z" anta	"Z" profile leaf	2	LS-10	45°	45°
P.2833	Profilo a "Z" anta	"Z" profile leaf	2	HS-10	45°	45°
P.2620	Profilo battiacqua	Water drip profile	1	LS-69	90°	90°
Fermavetri		Glazing beads				
P.2607	Profilo fermavetro	Glazing bead profile	2	LS-64	45°	45°
P.2607	Profilo fermavetro	Glazing bead profile	2	HS-64	45°	45°
Vetri		Glass unit				
-	Vetrocamera	Insulated glass	1	LS-76 x HS-76		
ACCESSORI		HARDWARE				
Cod.	Descrizione	Description	n°			
AC2608	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.			
AC2617	Guarnizione d'angolo	Vulcanised corner gasket	4			
AC2618	Scarico acqua	Water drip	Var.			
AC2623D/S	Kit cremonese	Cremone bolt set	1			
AC2626R	Kit per terza chiusura	Three-point lock system kit	Var.			
AC2627	Chiusura mediana lato cerniere	Hinge-side middle closing	Var.			
AC	Cerniere	Hinges	Var.			
ACV78..	Maniglia "Vitruvio"	"Vitruvio" handle	1			
AC2803I*	Kit squadrette per P.2803	Corner brackets kit for P.2803	4			
AC2833I*	Kit squadrette per P.2833	Corner brackets kit for P.2833	4			
GUARNIZIONI		GASKETS				
Cod.	Descrizione	Description	n°	Dim.		
GE2600TT	Guarnizione esterna di battuta	Rebating gasket	1	2xLS+2xHS		
GE2603	Guarnizione giunto aperto	Weather strip for open joint	1	2xLS+2xHS		
GU2036	Piattina adesiva fondo giunto	Adhesive shim for joint	1	2xLS+2xHS		
GP0095	Guarnizione interna vetro	Internal weather strip	1	2xLS+2xHS		

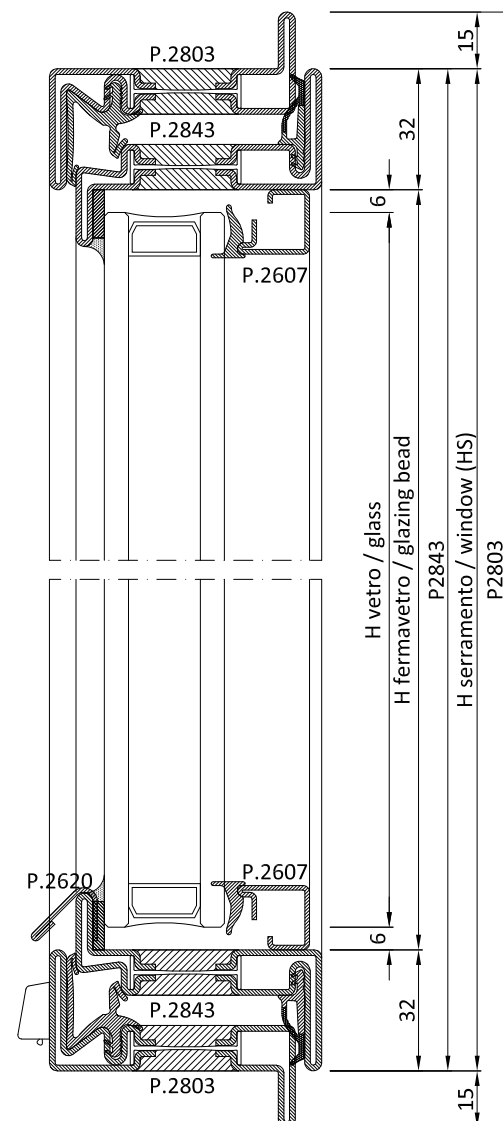


* solo con profili ottone
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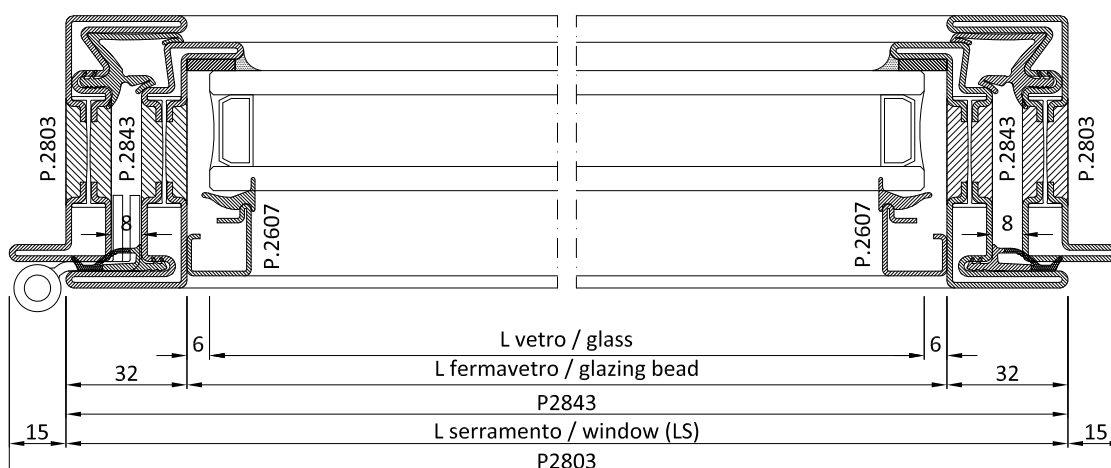


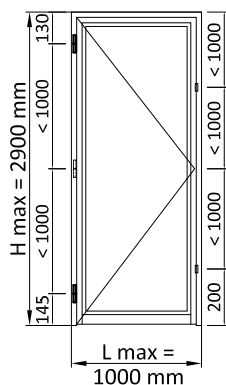


PROFILI			PROFILES			
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
Telaio			Frame			
P.2803	Profilo a "Z" telaio	"Z" profile frame	2	LS+30	45°	45°
P.2803	Profilo a "Z" telaio	"Z" profile frame	2	HS+30	45°	45°
Anta			Leaf			
P.2843	Profilo a "Z" anta	"Z" profile leaf	2	LS	45°	45°
P.2843	Profilo a "Z" anta	"Z" profile leaf	2	HS	45°	45°
P.2620	Profilo battiacqua	Water drip profile	1	LS-69	90°	90°
Fermavetri			Glazing beads			
P.2607	Profilo fermavetro	Glazing bead profile	2	LS-64	45°	45°
P.2607	Profilo fermavetro	Glazing bead profile	2	HS-64	45°	45°
Vetri			Glass unit			
-	Vetrocamera	Insulated glass	1	LS-76 x HS-76		
ACCESSORI			HARDWARE			
Cod.	Descrizione	Description	n°			
AC2608	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.			
AC2617	Guarnizione d'angolo	Vulcanised corner gasket	4			
AC2618	Scarico acqua	Water drip	Var.			
AC2625D/S	Kit cremonese	Cremone bolt set	1			
AC2626R	Kit per terza chiusura	Three-point lock system kit	Var.			
AC2627	Chiusura mediana lato cerniere	Hinge-side middle closing	Var.			
AC	Cerniere	Hinges	Var.			
ACV77..	Maniglia "Vitruvio"	"Vitruvio" handle	1			
AC2803I*	Kit squadrette per P.2803	Corner brackets kit for P.2803	4			
AC2843I*	Kit squadrette per P.2843	Corner brackets kit for P.2843	4			
GUARNIZIONI			GASKETS			
Cod.	Descrizione	Description	n°	Dim.		
GE2645TT	Guarnizione esterna di battuta	Rebating gasket	1	2xLS+2xHS		
GE2603	Guarnizione giunto aperto	Weather strip for open joint	1	2xLS+2xHS		
GU2036	Piattina adesiva fondo giunto	Adhesive shim for joint	1	2xLS+2xHS		
GP0095	Guarnizione interna vetro	Internal weather strip	1	2xLS+2xHS		

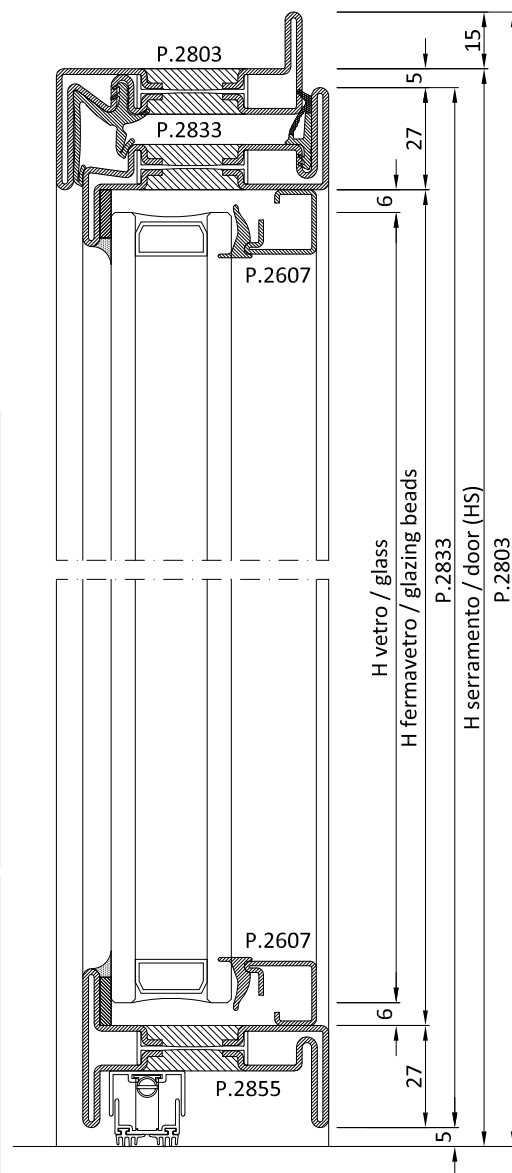


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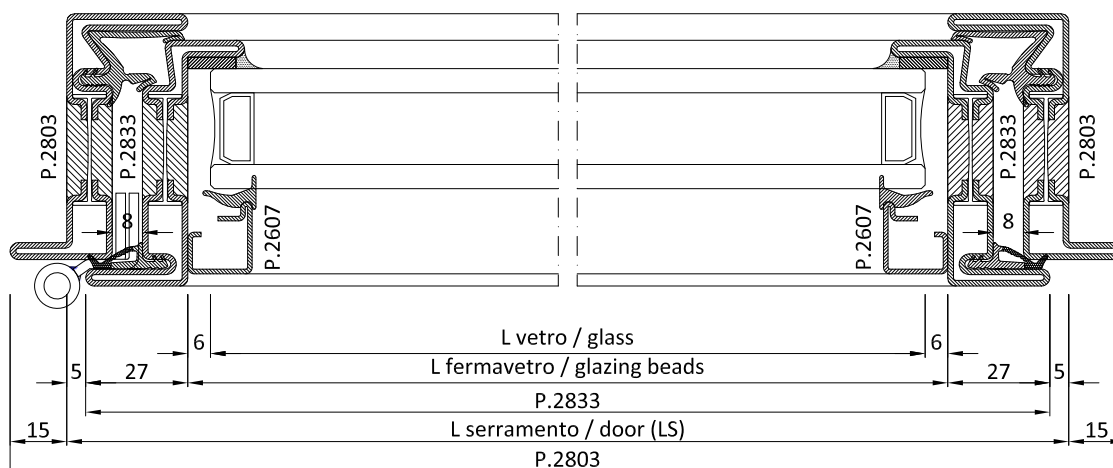


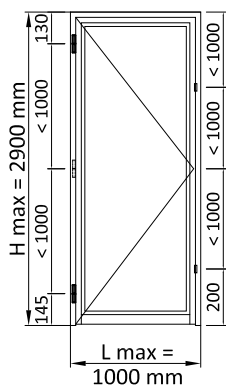


PROFILI			PROFILES			
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
Telaio			Frame			
P.2803	Profilo a "Z" telaio	"Z" profile frame	1	LS+30	45°	45°
P.2803	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	45°	90°
P.2803	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	90°	45°
Anta			Leaf			
P.2833	Profilo a "Z" anta	"Z" profile leaf	1	LS-10	45°	45°
P.2833	Profilo a "Z" anta	"Z" profile leaf	1	HS-10	45°	90°
P.2833	Profilo a "Z" anta	"Z" profile leaf	1	HS-10	90°	45°
P.2855	Profilo Zoccolo	Socle profile	1	LS-64	90°	90°
Fermavetri			Glazing beads			
P.2607	Profilo fermavetro	Glazing bead profile	2	LS-64	45°	45°
P.2607	Profilo fermavetro	Glazing bead profile	2	HS-64	45°	45°
Vetri			Glass unit			
-	Vetrocamera	Insulated glass	1	LS-76 x HS-76		
ACCESSORI			HARDWARE			
Cod.	Descrizione	Description	n°			
AC2608	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.			
AC2617	Guarnizione d'angolo	Vulcanised corner gasket	2			
AC2636/.	Guarnizione automatica	Automatic underdoor seal gasket	1			
AC	Serratura	Lock	1			
AC2695D/S	Punto di chiusura agg. (con AC2694)	Additional closing	Opz.			
AC2696 /97	Scatola copri serratura	Lock cover box	1			
AC	Cerniere	Hinges	Var.			
ACV95..	Maniglia "Vitruvio"	"Vitruvio" handle	1			
AC2803I*	Kit squadrette per P.2803	Corner brackets kit for P.2803	2			
AC2833I*	Kit squadrette per P.2833	Corner brackets kit for P.2833	2			
GUARNIZIONI			GASKETS			
Cod.	Descrizione	Description	n°	Dim.		
GE2600TT	Guarnizione esterna di battuta	Rebating gasket	1	1xLS+2xHS		
GE2603	Guarnizione giunto aperto	Weather strip for open joint	1	1xLS+2xHS		
GU2036	Piattina adesiva fondo giunto	Adhesive shim for joint	1	2xLS+2xHS		
GP0095	Guarnizione interna vetro	Internal weather strip	1	2xLS+2xHS		



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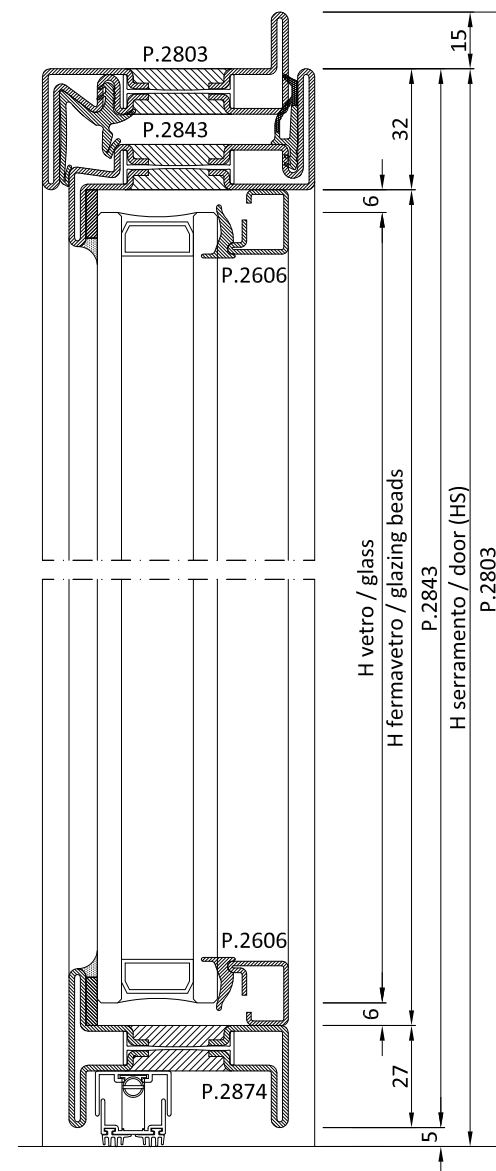




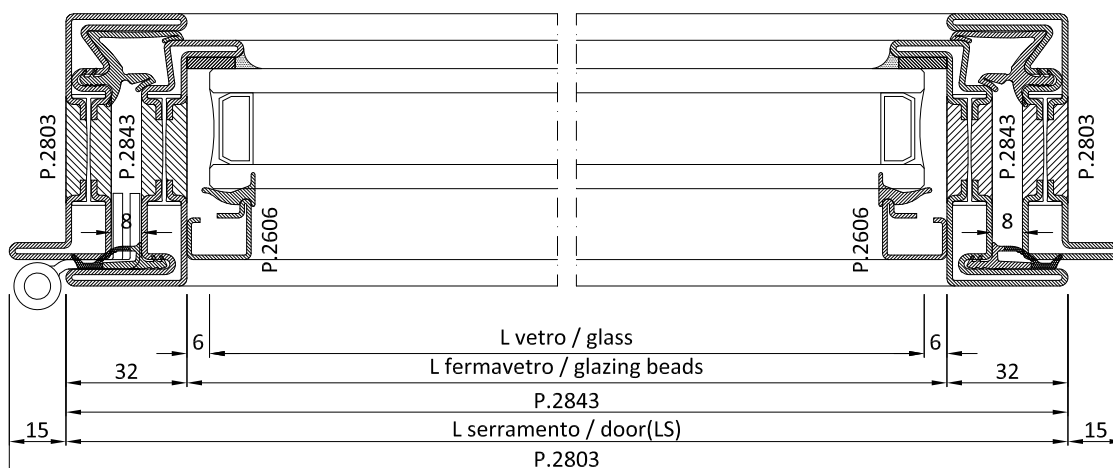
PROFILI		PROFILES				
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
Telaio		Frame				
P.2803	Profilo a "Z" telaio	"Z" profile frame	1	LS+30	45°	45°
P.2803	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	45°	90°
P.2803	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	90°	45°
Anta		Leaf				
P.2843	Profilo a "Z" anta	"Z" profile leaf	1	LS	45°	45°
P.2843	Profilo a "Z" anta	"Z" profile leaf	1	HS-5	45°	90°
P.2843	Profilo a "Z" anta	"Z" profile leaf	1	HS-5	90°	45°
P.2874	Profilo Zoccolo	Socle profile	1	LS-64	90°	90°
Fermavetri		Glazing beads				
P.2606	Profilo fermavetro	Glazing bead profile	2	LS-64	45°	45°
P.2606	Profilo fermavetro	Glazing bead profile	2	HS-64	45°	45°
Vetri		Glass unit				
-	Vetrocamera	Insulated glass	1	LS-76 x HS-76		

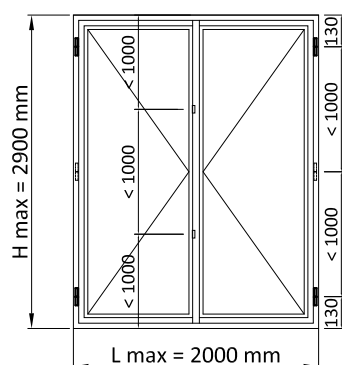
ACCESSORI		HARDWARE			
Cod.	Descrizione	Description	n°		
AC2608	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.		
AC2617	Guarnizione d'angolo	Vulcanised corner gasket	2		
AC2636/.	Guarnizione automatica	Automatic underdoor seal gasket	1		
AC	Serratura	Lock	1		
AC2695D/S	Punto di chiusura agg. (con AC2694)	Additional closing	Opz.		
AC2696 /97	Scatola copri serratura	Lock cover box	1		
AC	Cerniere	Hinges	Var.		
ACV95..	Maniglia "Vitruvio"	"Vitruvio" handle	1		
AC2803I*	Kit squadrette per P.2803	Corner brackets kit for P.2803	2		
AC2843I*	Kit squadrette per P.2843	Corner brackets kit for P.2843	2		

GUARNIZIONI		GASKETS			
Cod.	Descrizione	Description	n°	Dim.	
GE2645TT	Guarnizione esterna di battuta	Rebating gasket	1	1xLS+2xHS	
GE2603	Guarnizione giunto aperto	Weather strip for open joint	1	1xLS+2xHS	
GU2036	Piattina adesiva fondo giunto	Adhesive shim for joint	1	2xLS+2xHS	
GP0095	Guarnizione interna vetro	Internal weather strip	1	2xLS+2xHS	

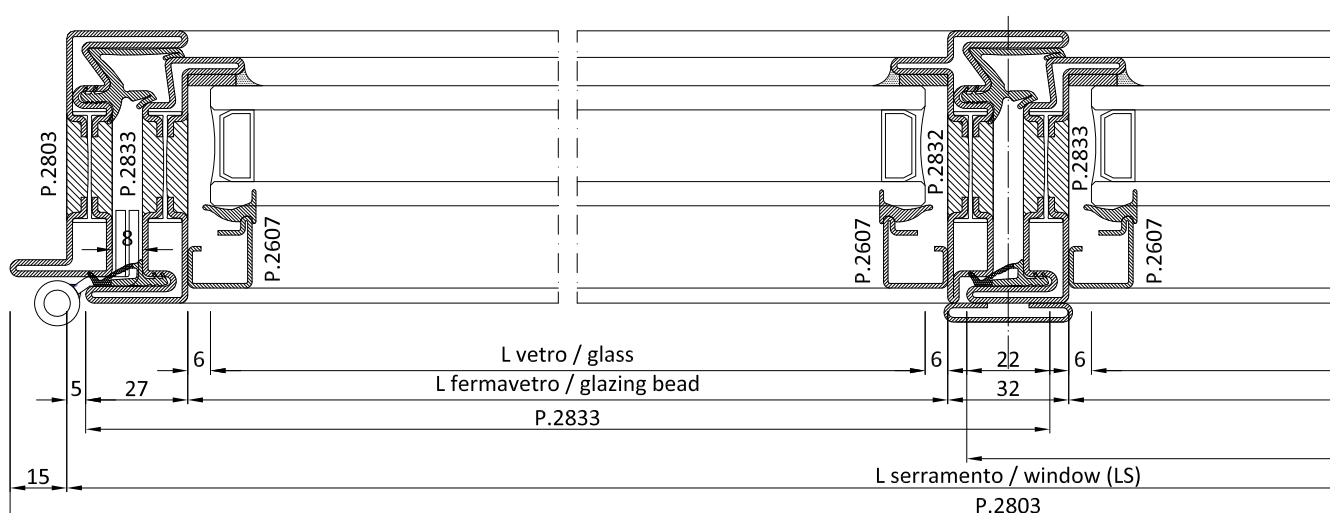


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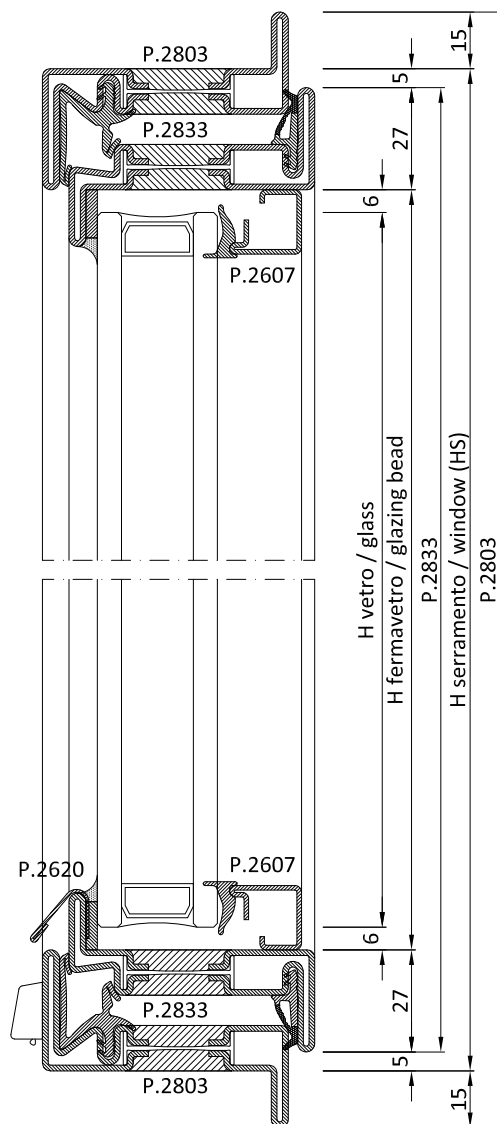
PROFILI		PROFILES				
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
Telaio		Frame				
P.2803	Profilo a "Z" telaio	"Z" profile frame	2	LS+30	45°	45°
P.2803	Profilo a "Z" telaio	"Z" profile frame	2	HS+30	45°	45°
Anta		Leaf				
P.2833	Profilo a "Z" anta	"Z" profile leaf	4	LS/2+6	45°	45°
P.2833	Profilo a "Z" anta	"Z" profile leaf	3	HS-10	45°	45°
P.2832	Profilo a "T" anta	"T" profile leaf	1	HS	45°	45°
P.2610	Profilo riporto per cremonese	additional profile for cremone	1	HS-10	90°	90°
P.2620	Profilo battiacqua	Water drip profile	2	LS/2-53	90°	90°
Fermavetri		Glazing beads				
P.2607	Profilo fermavetro	Glazing bead profile	4	LS/2-48	45°	45°
P.2607	Profilo fermavetro	Glazing bead profile	4	HS-64	45°	45°
Vetri		Glass unit				
-	Vetrocamera	Insulated glass	2	LS/2-60 x HS-76		

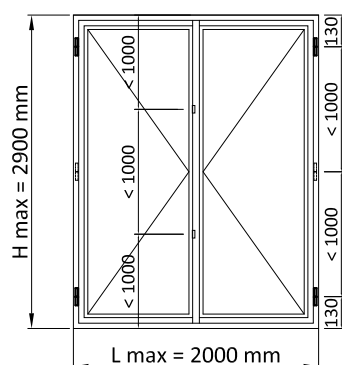


ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
AC2608	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.
AC2610	Accessorio fissaggio P.2610	Accessories for fixing P.2610	Var.
AC2617	Guarnizione d'angolo	Vulcanised corner gasket	4
AC2618	Scarico acqua	Water drip	Var.
AC2622	Fermo a scatto per 2^ anta	Snapper for second leaf window	1
AC2624D/S	Kit cremonese	Cremona bolt set	1
AC2626R	Kit per terza chiusura	Three-point lock system kit	Var.
AC2627	Chiusura mediana lato cerniere	Hinge-side middle closing	Var.
AC2651	Fondino per 2^ anta	Botton plate for second leaf	2
AC	Cerniere	Hinges	Var.
ACV77..	Maniglia "Vitruvio"	"Vitruvio" handle	1
AC2803I*	Kit squadrette per P.2803	Corner brackets kit for P.2803	4
AC2832I*	Kit squadrette per P.2833-32	Corner brackets kit for P.2833-32	2
AC2833I*	Kit squadrette per P.2833	Corner brackets kit for P.2833	6

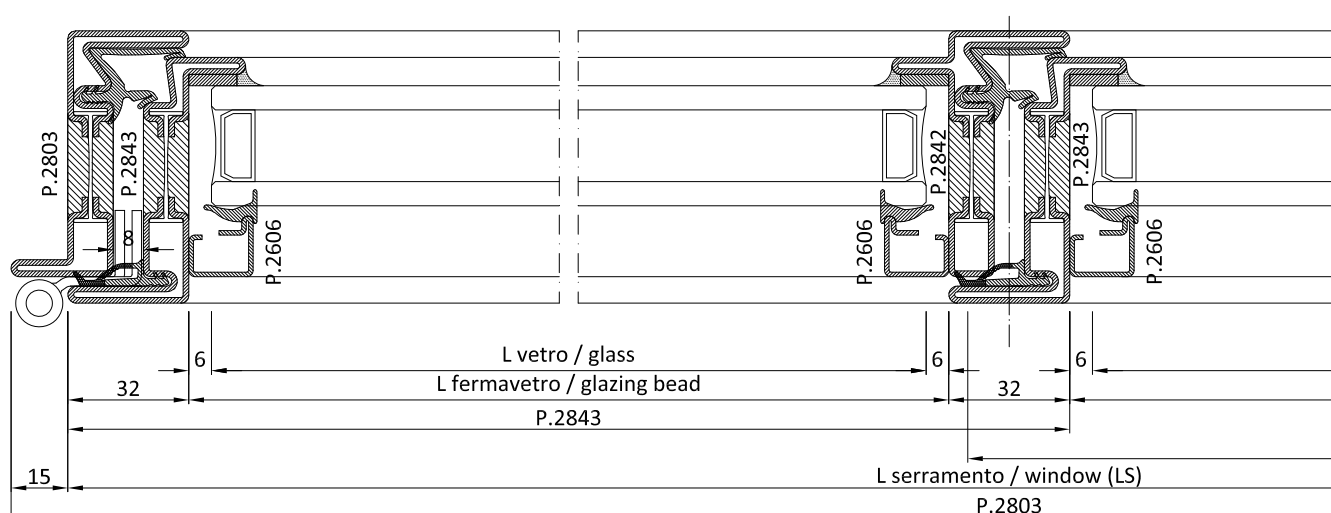
GUARNIZIONI		GASKETS		
Cod.	Descrizione	Description	n°	Dim.
GE2600TT	Guarnizione esterna di battuta	Rebating gasket	1	2xLS+3xHS
GE2603	Guarnizione giunto aperto	Weather strip for open joint	1	2xLS+3xHS
GU2036	Piattina adesiva fondo giunto	Adhesive shim for joint	1	2xLS+4xHS
GP0095	Guarnizione interna vetro	Internal weather strip	1	2xLS+4xHS

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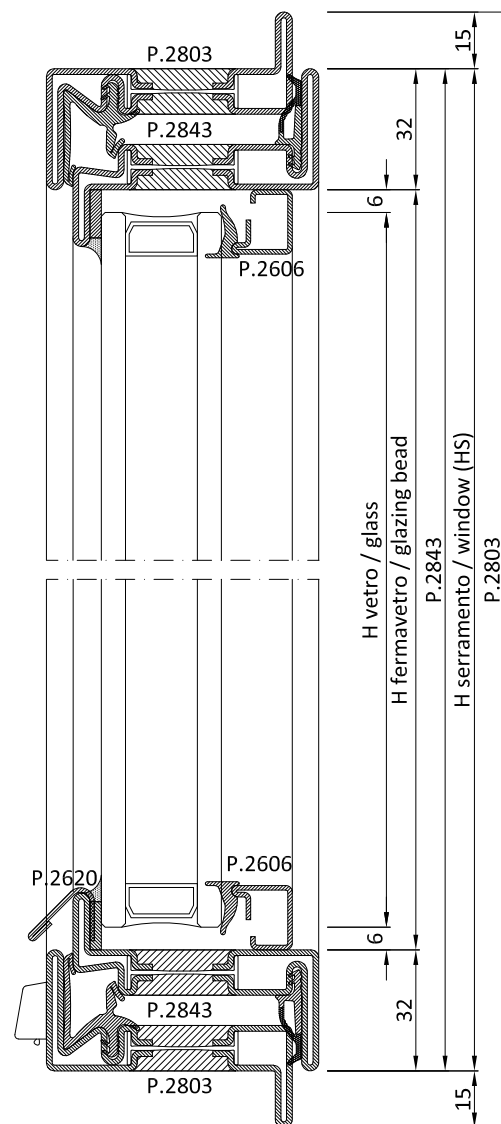
PROFILI		PROFILES			
Cod.	Descrizione	Description	n°	Dim.	Taglio Cutting
Telaio		Frame			
P.2803	Profilo a "Z" telaio	"Z" profile frame	2	LS+30	45° 45°
P.2803	Profilo a "Z" telaio	"Z" profile frame	2	HS+30	45° 45°
Anta		Leaf			
P.2843	Profilo a "Z" anta	"Z" profile leaf	4	LS/2+16	45° 45°
P.2843	Profilo a "Z" anta	"Z" profile leaf	3	HS	45° 45°
P.2842	Profilo a "T" anta	"T" profile leaf	1	HS	45° 45°
P.2620	Profilo battiacqua	Water drip profile	2	LS/2-53	90° 90°
Fermavetri		Glazing beads			
P.2606	Profilo fermavetro	Glazing bead profile	4	LS/2-48	45° 45°
P.2606	Profilo fermavetro	Glazing bead profile	4	HS-64	45° 45°
Vetri		Glass unit			
-	Vetrocamera	Insulated glass	2	LS/2-60 x HS-76	

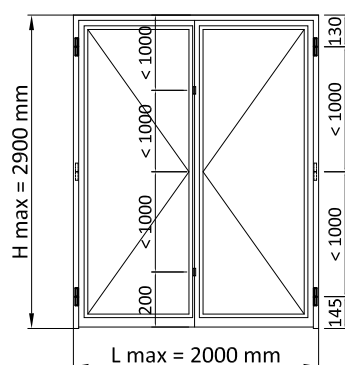


ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
AC2608	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.
AC2617	Guarnizione d'angolo	Vulcanised corner gasket	4
AC2618	Scarico acqua	Water drip	Var.
AC2622	Fermo a scatto per 2^ anta	Snapper for second leaf window	1
AC2624D/S	Kit cremonese	Cremone bolt set	1
AC2626R	Kit per terza chiusura	Three-point lock system kit	Var.
AC2627	Chiusura mediana lato cerniere	Hinge-side middle closing	Var.
AC2652	Fondino per 2^ anta	Bottom plate for second leaf	2
AC	Cerniere	Hinges	Var.
ACV77..	Maniglia "Vitruvio"	"Vitruvio" handle	1
AC2803I*	Kit squadrette per P.2803	Corner brackets kit for P.2803	4
AC2832I*	Kit squadrette per P.2843-42	Corner brackets kit for P.2843-42	2
AC2843I*	Kit squadrette per P.2843	Corner brackets kit for P.2843	6

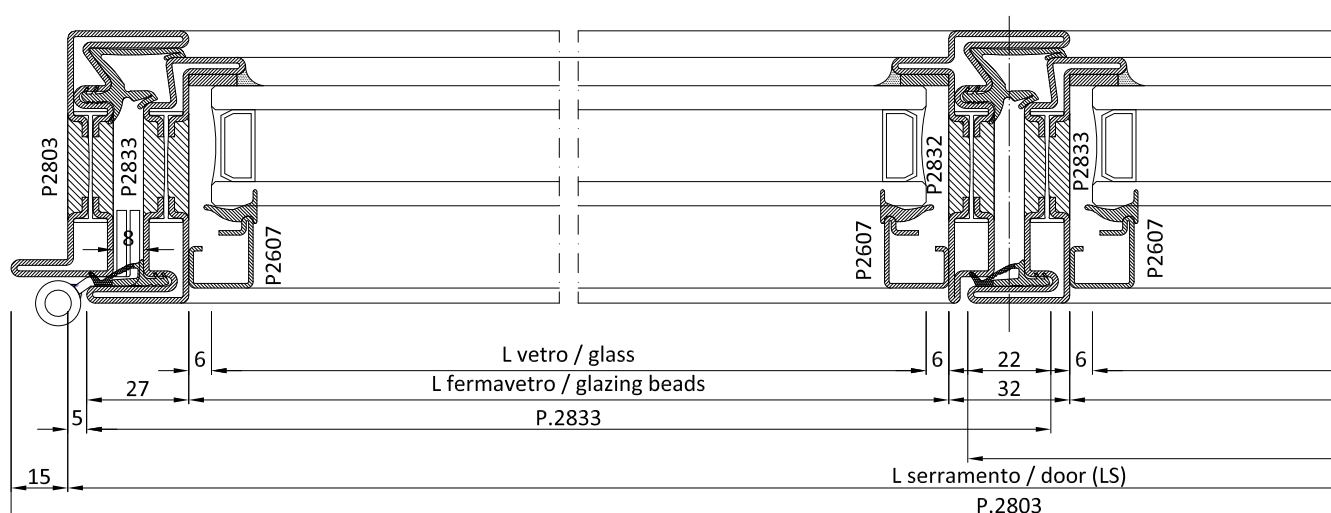
GUARNIZIONI		GASKETS		
Cod.	Descrizione	Description	n°	Dim.
GE2645TT	Guarnizione esterna di battuta	Rebating gasket	1	2xLS+3xHS
GE2603	Guarnizione giunto aperto	Weather strip for open joint	1	2xLS+3xHS
GU2036	Piattina adesiva fondo giunto	Adhesive shim for joint	1	2xLS+4xHS
GP0095	Guarnizione interna vetro	Internal weather strip	1	2xLS+4xHS

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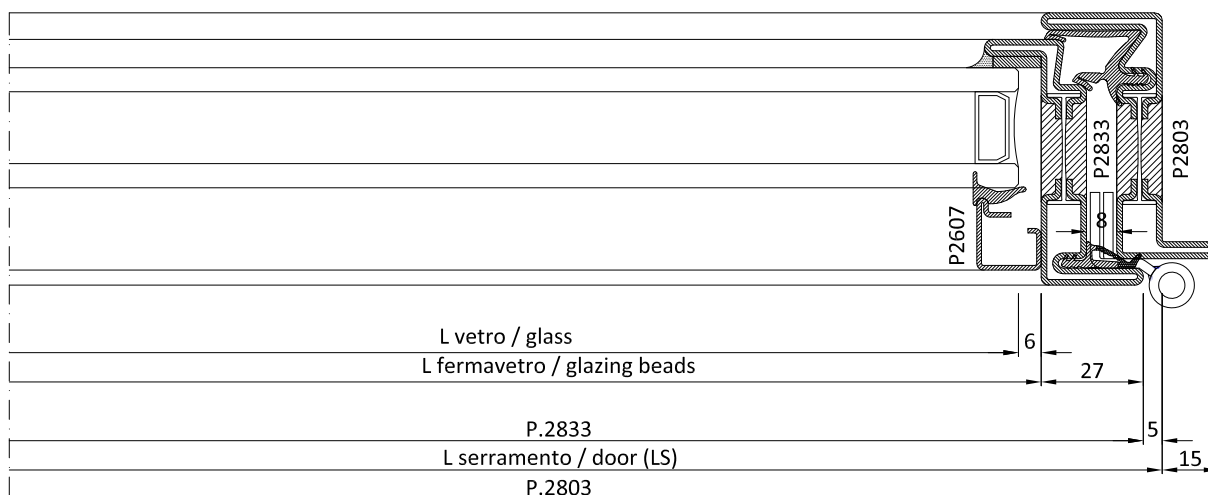
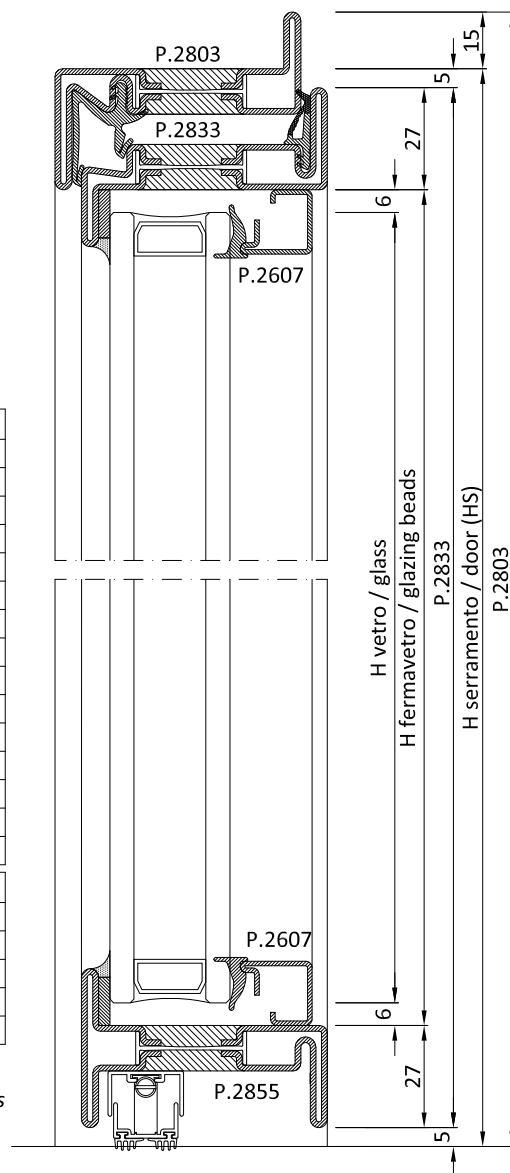
PROFILI		PROFILES			
Cod.	Descrizione	Description	n°	Dim.	Taglio Cutting
Telaio		Frame			
P.2803	Profilo a "Z" telaio	"Z" profile frame	1	LS+30	45° 45°
P.2803	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	45° 90°
P.2803	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	90° 45°
Anta		Leaf			
P.2833	Profilo a "Z" anta	"Z" profile leaf	2	LS/2+6	45° 45°
P.2833	Profilo a "Z" anta	"Z" profile leaf	2	HS-10	45° 90°
P.2833	Profilo a "Z" anta	"Z" profile leaf	1	HS-10	90° 45°
P.2832	Profilo a "T" anta	"T" profile leaf	1	HS-5	90° 45°
P.2855	Profilo Zoccolo	Socle profile	2	LS/2-48	90° 90°
Fermavetri		Glazing beads			
P.2607	Profilo fermavetro	Glazing bead profile	4	LS/2-48	45° 45°
P.2607	Profilo fermavetro	Glazing bead profile	4	HS-64	45° 45°
Vetri		Glass unit			
-	Vetrocamera	Insulated glass	2	LS/2-60 x HS-76	

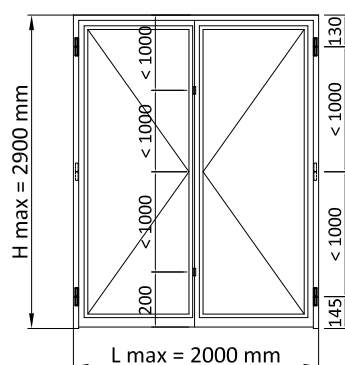


ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
AC2608	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.
AC2617	Guarnizione d'angolo	Vulcanised corner gasket	2
AC2621GB	Catenaccio 2^ anta (h 220)	Second leaf bolt	1
AC2621GC	Catenaccio 2^ anta (h 650)	Second leaf bolt	1
AC2636/.	Guarnizione automatica	Automatic underdoor seal gasket	2
AC2651	Fondino per 2^ anta	Bottom plate for second leaf	1
AC	Serratura	Lock	1
AC2695D/S	Punto di chiusura agg. (con AC2694)	Additional closing	Opz.
AC2696/ 97	Scatola copri serratura	Lock cover box	1
AC	Cerniere	Hinges	Var.
ACV95..	Maniglia "Vitruvio"	"Vitruvio" handle	1
AC2803I*	Kit squadrette per P.2803	Corner brackets kit for P.2803	2
AC2832I*	Kit squadrette per P.2833-32	Corner brackets kit for P.2833-32	1
AC2833I*	Kit squadrette per P.2833	Corner brackets kit for P.2833	3

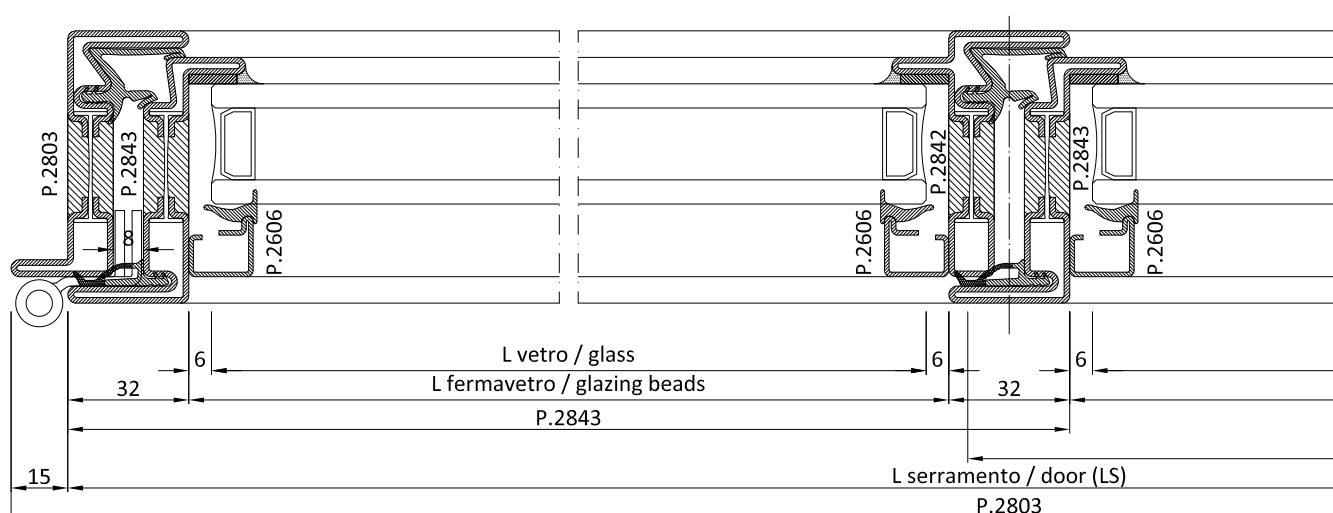
GUARNIZIONI		GASKETS	
Cod.	Descrizione	Description	n° Dim.
GE2600TT	Guarnizione esterna di battuta	Rebating gasket	1 1xLS+3xHS
GE2603	Guarnizione giunto aperto	Weather strip for open joint	1 1xLS+3xHS
GU2036	Piattina adesiva fondo giunto	Adhesive shim for joint	1 2xLS+4xHS
GP0095	Guarnizione interna vetro	Internal weather strip	1 2xLS+4xHS

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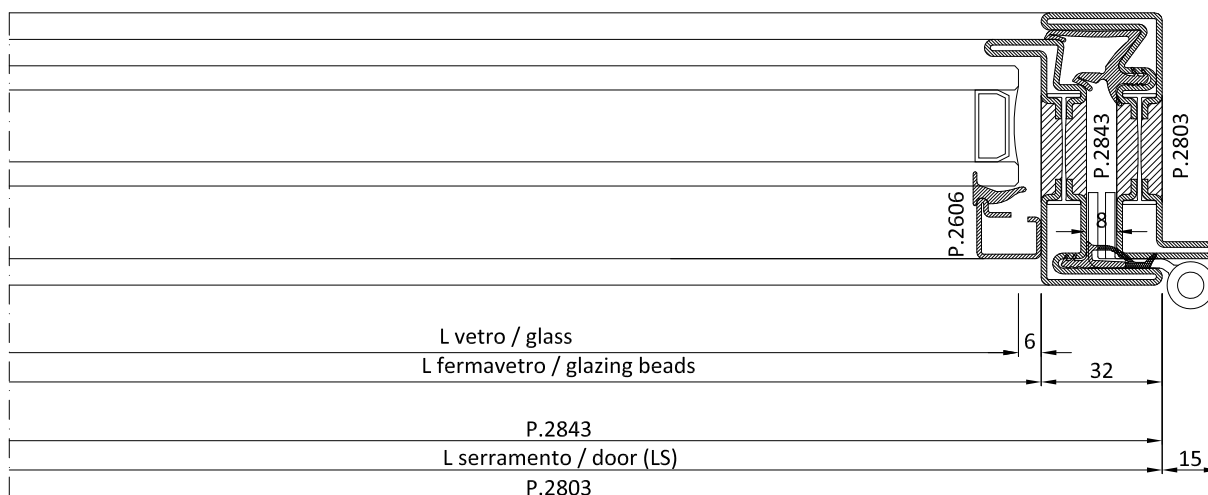
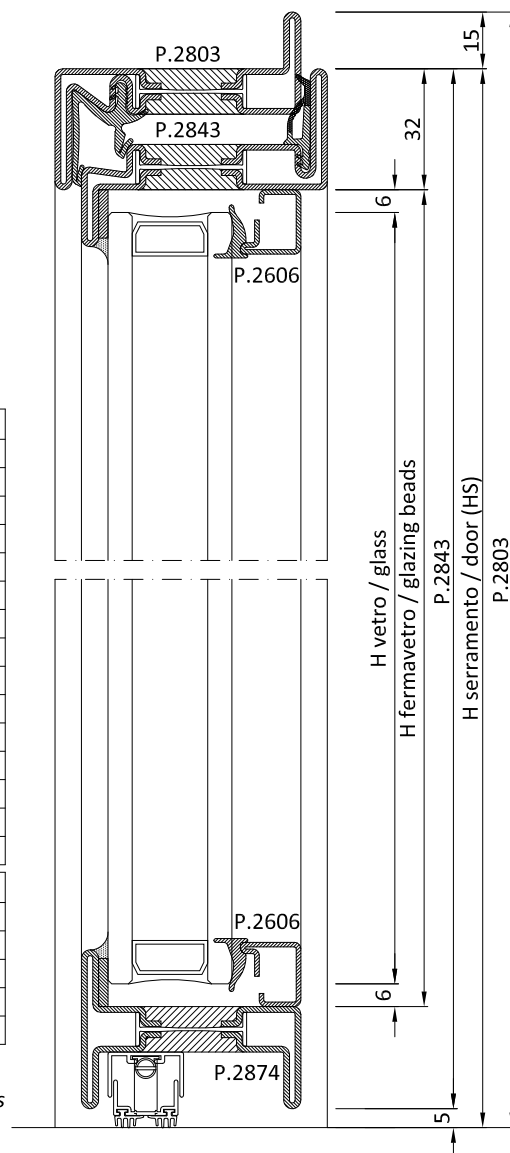
PROFILI		PROFILES			
Cod.	Descrizione	Description	n°	Dim.	Taglio Cutting
Telaio		Frame			
P.2803	Profilo a "Z" telaio	"Z" profile frame	1	LS+30	45° 45°
P.2803	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	45° 90°
P.2803	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	90° 45°
Anta		Leaf			
P.2843	Profilo a "Z" anta	"Z" profile leaf	2	LS/2+16	45° 45°
P.2843	Profilo a "Z" anta	"Z" profile leaf	2	HS-5	45° 90°
P.2843	Profilo a "Z" anta	"Z" profile leaf	1	HS-5	90° 45°
P.2842	Profilo a "T" anta	"T" profile leaf	1	HS-5	90° 45°
P.2874	Profilo Zoccolo	Socle profile	2	LS/2-48	90° 90°
Fermavetri		Glazing beads			
P.2606	Profilo fermavetro	Glazing bead profile	4	LS/2-48	45° 45°
P.2606	Profilo fermavetro	Glazing bead profile	4	HS-64	45° 45°
Vetri		Glass unit			
-	Vetrocamera	Insulated glass	2	LS/2-60 x HS-76	

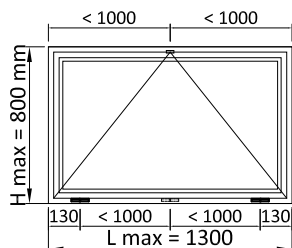


ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
AC2608	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.
AC2617	Guarnizione d'angolo	Vulcanised corner gasket	2
AC2621GB	Catenaccio 2^ anta (h 220)	Second leaf bolt	1
AC2621GC	Catenaccio 2^ anta (h 650)	Second leaf bolt	1
AC2636/.	Guarnizione automatica	Automatic underdoor seal gasket	2
AC2652	Fondino per 2^ anta	Botton plate for second leaf	1
AC	Serratura	Lock	1
AC2695D/S	Punto di chiusura agg. (con AC2694)	Additional closing	Opz.
AC2696/ 97	Scatola copri serratura	Lock cover box	1
AC	Cerniere	Hinges	Var.
ACV95..	Maniglia "Vitruvio"	"Vitruvio" handle	1
AC2803I*	Kit squadrette per P.2803	Corner brackets kit for P.2803	2
AC2832I*	Kit squadrette per P.2843-32	Corner brackets kit for P.2843-32	1
AC2843I*	Kit squadrette per P.2843	Corner brackets kit for P.2843	3

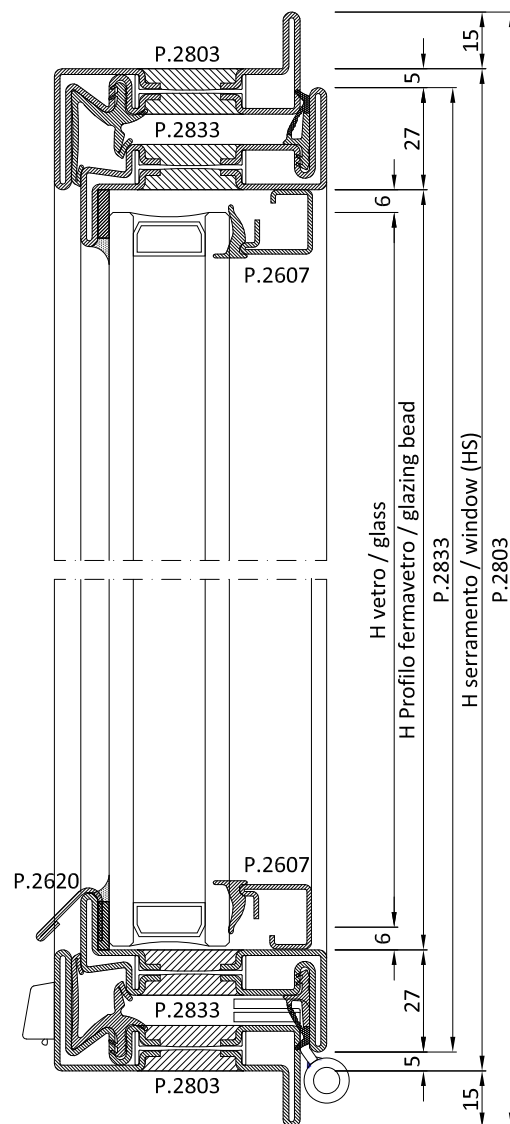
GUARNIZIONI		GASKETS		
Cod.	Descrizione	Description	n°	Dim.
GE2645TT	Guarnizione esterna di battuta	Rebating gasket	1	1xLS+3xHS
GE2603	Guarnizione giunto aperto	Weather strip for open joint	1	1xLS+3xHS
GU2036	Piattina adesiva fondo giunto	Adhesive shim for joint	1	2xLS+4xHS
GP0095	Guarnizione interna vetro	Internal weather strip	1	2xLS+4xHS

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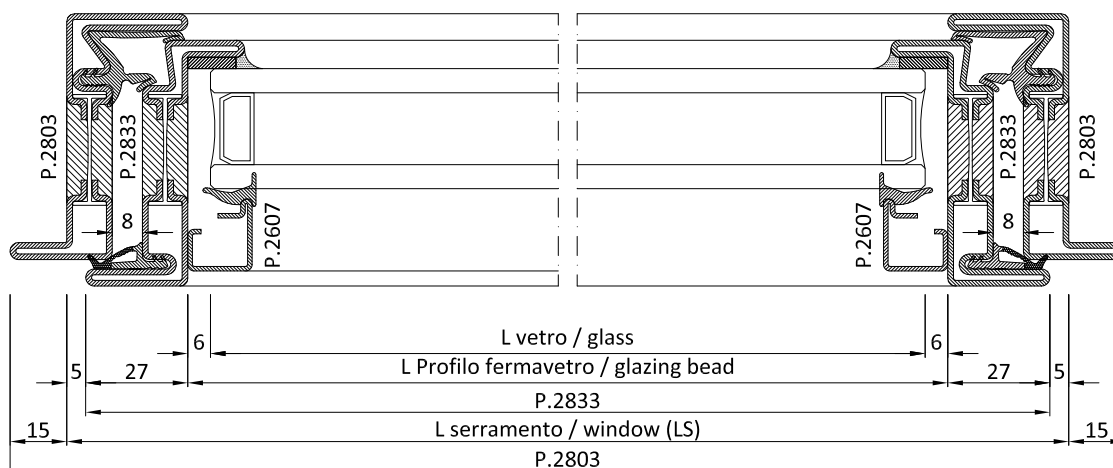


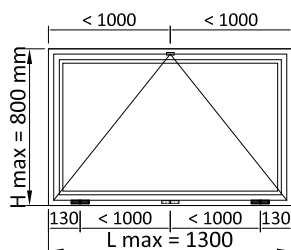


PROFILI		PROFILES		n°	Dim.	Taglio	Cutting
Cod.	Descrizione	Description					
Telaio		Frame					
P.2803	Profilo a "Z" telaio	"Z" profile frame	2	LS+30	45°	45°	
P.2803	Profilo a "Z" telaio	"Z" profile frame	2	HS+30	45°	45°	
Anta		Leaf					
P.2833	Profilo a "Z" anta	"Z" profile leaf	2	LS-10	45°	45°	
P.2833	Profilo a "Z" anta	"Z" profile leaf	2	HS-10	45°	45°	
P.2620	Profilo battiacqua	Water drip profile	1	LS-69	90°	90°	
Fermavetri		Glazing beads					
P.2607	Profilo fermavetro	Glazing bead profile	2	LS-64	45°	45°	
P.2607	Profilo fermavetro	Glazing bead profile	2	HS-64	45°	45°	
Vetri		Glass unit					
-	Vetrocamera	Insulated glass	1	LS-76 x HS-76			
ACCESSORI		HARDWARE					
Cod.	Descrizione	Description	n°				
AC2608	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.				
AC2617	Guarnizione d'angolo	Vulcanised corner gasket	4				
AC2618	Scarico acqua	Water drip	Var.				
AC2640..	Cricchetto per vasistas	Finger catch for bottom-hung windows	1				
AC2641	Braccetti per vasistas	Stays for bottom-hung windows	1				
AC	Cerniere	Hinges	Var.				
AC2803I*	Kit squadrette per P.2803	Corner brackets kit for P.2803	4				
AC2833I*	Kit squadrette per P.2833	Corner brackets kit for P.2833	4				
GUARNIZIONI		GASKETS					
Cod.	Descrizione	Description	n°	Dim.			
GE2600TT	Guarnizione esterna di battuta	Rebating gasket	1	2xLS+2xHS			
GE2603	Guarnizione giunto aperto	Weather strip for open joint	1	2xLS+2xHS			
GU2036	Piattina adesiva fondo giunto	Adhesive shim for joint	1	2xLS+2xHS			
GP0095	Guarnizione interna vetro	Internal weather strip	1	2xLS+2xHS			

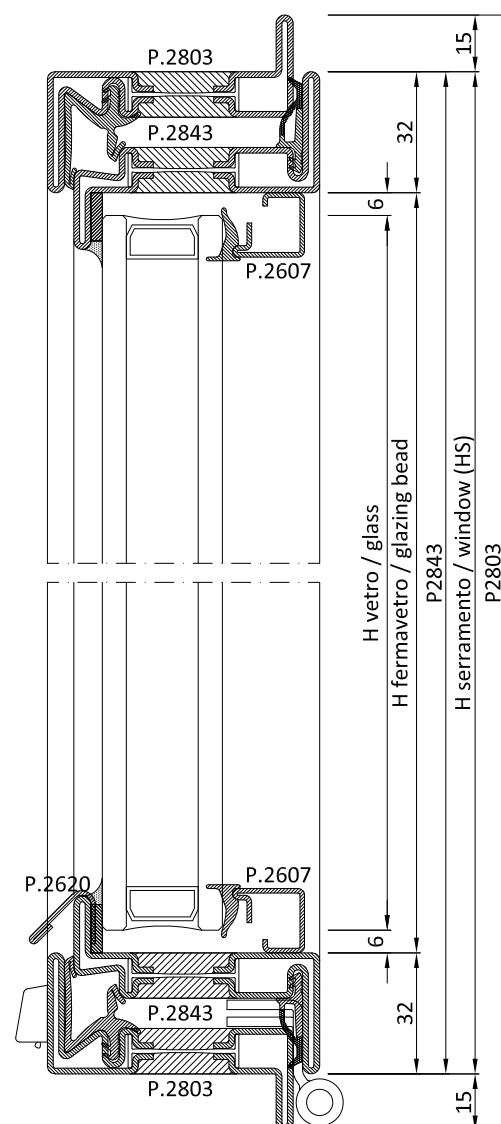


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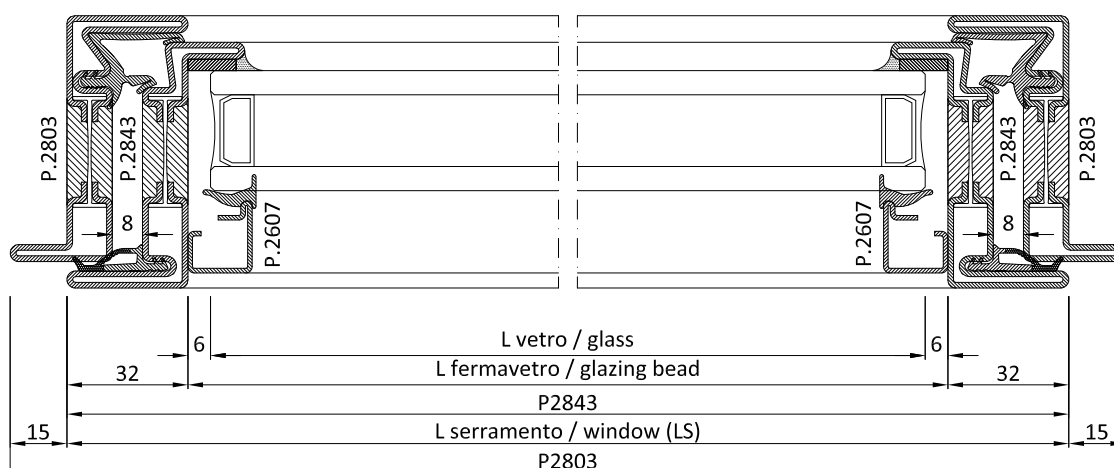


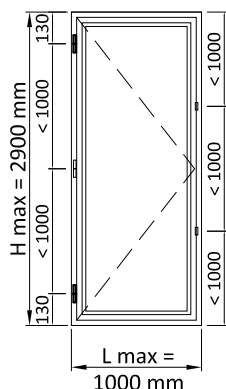


PROFILI		PROFILES				
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
Telaio		Frame				
P.2803	Profilo a "Z" telaio	"Z" profile frame	2	LS+30	45°	45°
P.2803	Profilo a "Z" telaio	"Z" profile frame	2	HS+30	45°	45°
Anta		Leaf				
P.2843	Profilo a "Z" anta	"Z" profile leaf	2	LS	45°	45°
P.2843	Profilo a "Z" anta	"Z" profile leaf	2	HS	45°	45°
P.2620	Profilo battiacqua	Water drip profile	1	LS-69	90°	90°
Fermavetri		Glazing beads				
P.2607	Profilo fermavetro	Glazing bead profile	2	LS-64	45°	45°
P.2607	Profilo fermavetro	Glazing bead profile	2	HS-64	45°	45°
Vetri		Glass unit				
-	Vetrocamera	Insulated glass	1	LS-76 x HS-76		
ACCESSORI		HARDWARE				
Cod.	Descrizione	Description	n°			
AC2608	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.			
AC2617	Guarnizione d'angolo	Vulcanised corner gasket	4			
AC2618	Scarico acqua	Water drip	Var.			
AC2640..	Cricchetto per vasistas	Finger catch for bottom-hung windows	1			
AC2641	Braccetti per vasistas	Stays for bottom-hung windows	1			
AC	Cerniere	Hinges	Var.			
AC28031*	Kit squadrette per P.2803	Corner brackets kit for P.2803	4			
AC28431*	Kit squadrette per P.2843	Corner brackets kit for P.2843	4			
GUARNIZIONI		GASKETS				
Cod.	Descrizione	Description	n°	Dim.		
GE2645TT	Guarnizione esterna di battuta	Rebating gasket	1	2xLS+2xHS		
GE2603	Guarnizione giunto aperto	Weather strip for open joint	1	2xLS+2xHS		
GU2036	Piattina adesiva fondo giunto	Adhesive shim for joint	1	2xLS+2xHS		
GP0095	Guarnizione interna vetro	Internal weather strip	1	2xLS+2xHS		

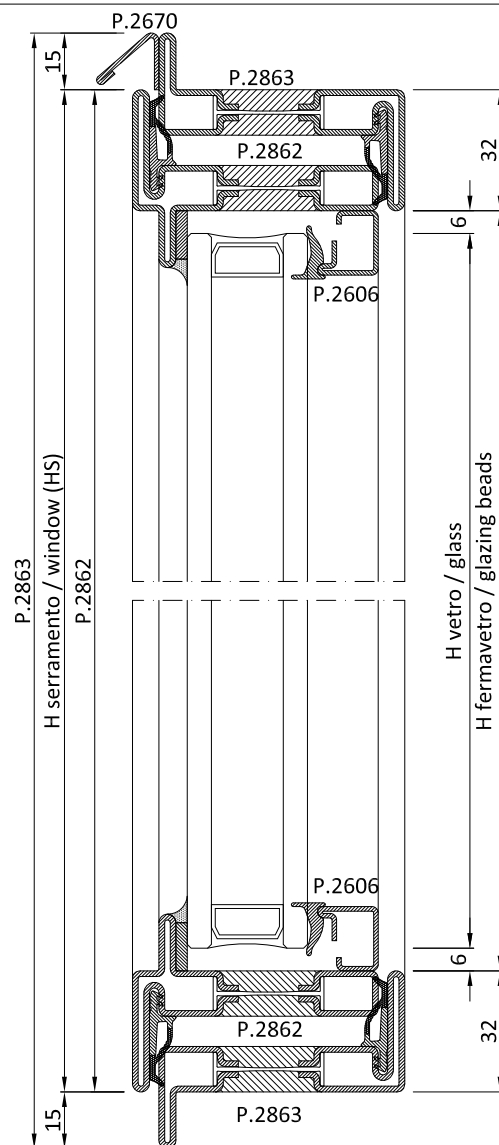


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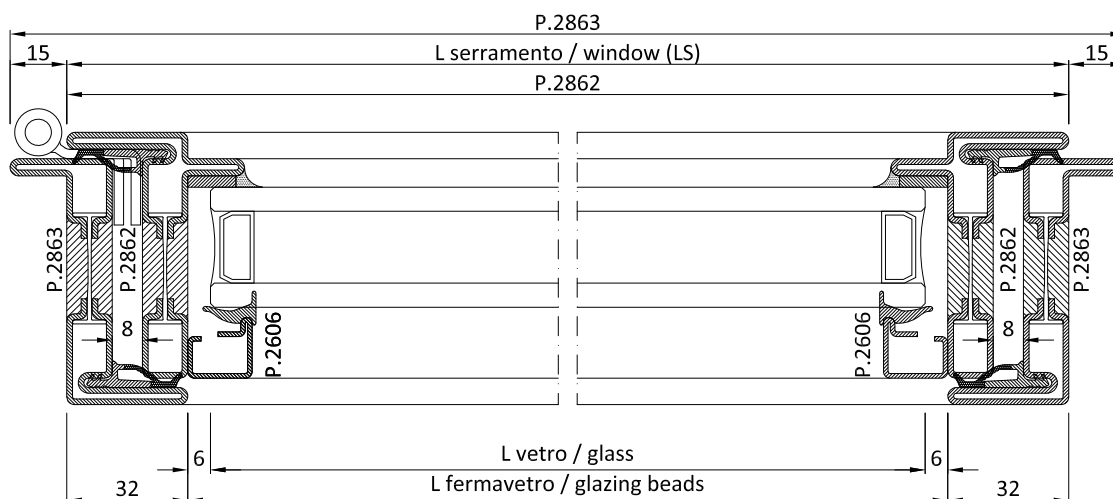


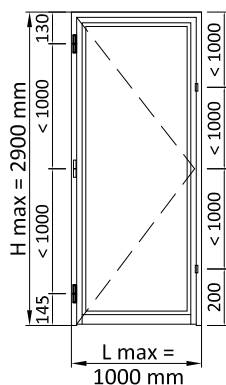


PROFILI			PROFILES			
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
Telaio			Frame			
P.2863	Profilo a "Z" telaio	"Z" profile frame	2	LS+30	45°	45°
P.2863	Profilo a "Z" telaio	"Z" profile frame	2	HS+30	45°	45°
P.2670	Profilo battiacqua	Water drip profile	1	LS+30	90°	90°
Anta			Leaf			
P.2862	Profilo a "T" anta	"T" profile leaf	2	LS	45°	45°
P.2862	Profilo a "T" anta	"T" profile leaf	2	HS	45°	45°
Fermavetri			Glazing beads			
P.2606	Profilo fermavetro	Glazing bead profile	2	LS-64	45°	45°
P.2606	Profilo fermavetro	Glazing bead profile	2	HS-64	45°	45°
Vetri			Glass unit			
-	Vetrocamera	Insulated glass	1	LS-76 x HS-76		
ACCESSORI			HARDWARE			
Cod.	Descrizione	Description	n°			
AC2608	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.			
AC2626R	Kit per terza chiusura	Three-point lock system kit	Var.			
AC2627	Chiusura mediana lato cerniere	Hinge-side middle closing	Var.			
AC2680 ..	Maniglia di trascinamento	Dragging leaf handle	1			
AC2683D/S	Kit cremonese	Cremone bolt set	1			
AC2687	Braccetti limitatori	Casement stays	Opz.			
AC	Cerniere	Hinges	Var.			
ACV77..	Maniglia "Vitruvio"	"Vitruvio" handle	1			
AC2803I*	Kit squadrette per P.2863	Corner brackets kit for P.2863	4			
AC2862I*	Kit squadrette per P.2862	Corner brackets kit for P.2862	4			
GUARNIZIONI			GASKETS			
Cod.	Descrizione	Description	n°	Dim.		
GE2645TT	Guarnizione esterna di battuta	Rebating gasket	2	4xLS+4xHS		
GU2036	Piattina adesiva fondo giunto	Adhesive shim for joint	1	2xLS+2xHS		
GP0095	Guarnizione interna vetro	Internal weather strip	1	2xLS+2xHS		

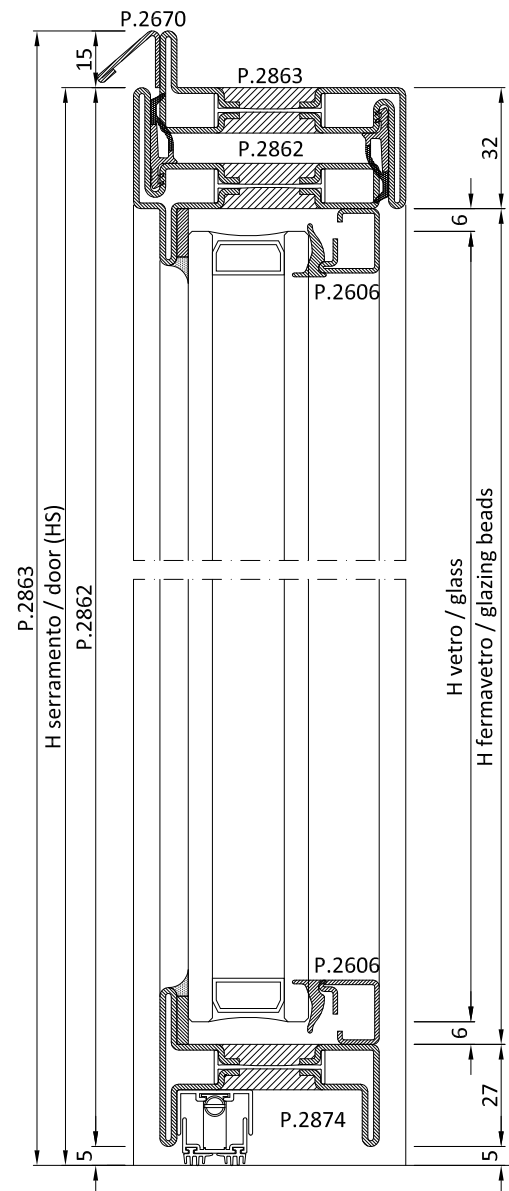


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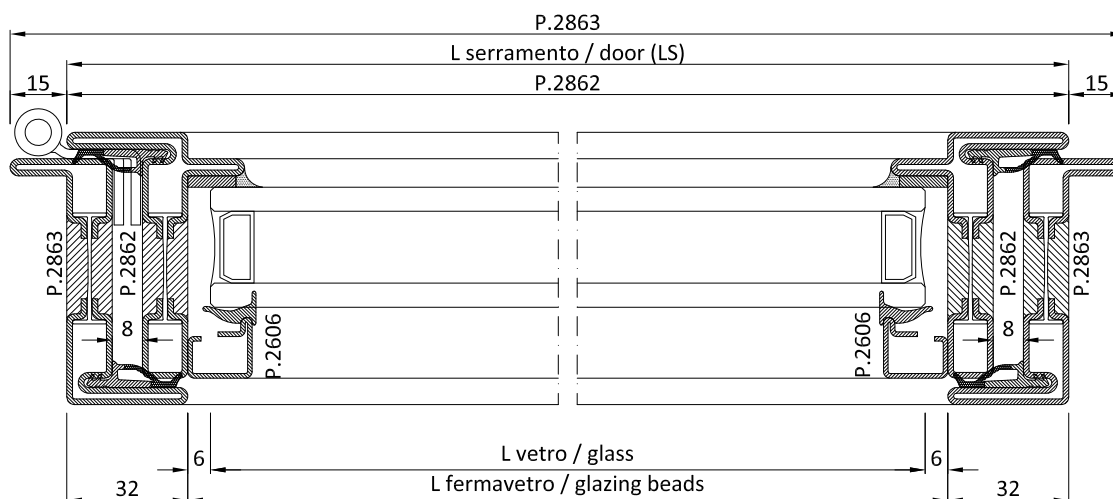


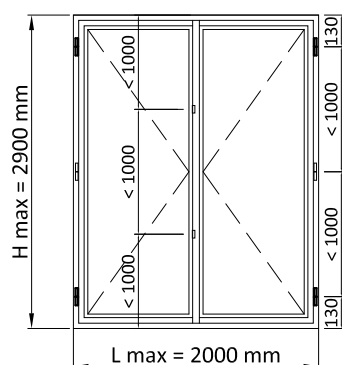


PROFILI			PROFILES			
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
Telaio			Frame			
P.2863	Profilo a "Z" telaio	"Z" profile frame	1	LS+30	45°	45°
P.2863	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	90°	45°
P.2863	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	45°	90°
P.2670	Profilo battiacqua	Water drip profile	1	LS+30	90°	90°
Anta			Leaf			
P.2862	Profilo a "T" anta	"T" profile leaf	1	LS	45°	45°
P.2862	Profilo a "T" anta	"T" profile leaf	1	HS-5	90°	45°
P.2862	Profilo a "T" anta	"T" profile leaf	1	HS-5	45°	90°
P.2874	Profilo Zoccolo	Socle profile	1	LS-64	90°	90°
Fermavetri			Glazing beads			
P.2606	Profilo fermavetro	Glazing bead profile	2	LS-64	45°	45°
P.2606	Profilo fermavetro	Glazing bead profile	2	HS-64	45°	45°
Vetri			Glass unit			
-	Vetrocamera	Insulated glass	1	LS-76 x HS-76		
ACCESSORI			HARDWARE			
Cod.	Descrizione	Description	n°			
AC2608	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.			
AC2636/.	Guarnizione automatica	Automatic underdoor seal gasket	1			
AC	Serratura	Lock	1			
AC2695D/S	Punto di chiusura agg. (con AC2694)	Additional closing	Opz.			
AC2696 /97	Scatola copri serratura	Lock cover box	1			
AC	Cerniere	Hinges	Var.			
ACV95..	Maniglia "Vitruvio"	"Vitruvio" handle	1			
AC2803I*	Kit squadrette per P.2863	Corner brackets kit for P.2863	2			
AC2862I*	Kit squadrette per P.2862	Corner brackets kit for P.2862	2			
GUARNIZIONI			GASKETS			
Cod.	Descrizione	Description	n°	Dim.		
GE2645TT	Guarnizione esterna di battuta	Rebating gasket	2	1xLS+2xHS		
GU2036	Piattina adesiva fondo giunto	Adhesive shim for joint	1	2xLS+2xHS		
GP0095	Guarnizione interna vetro	Internal weather strip	1	2xLS+2xHS		

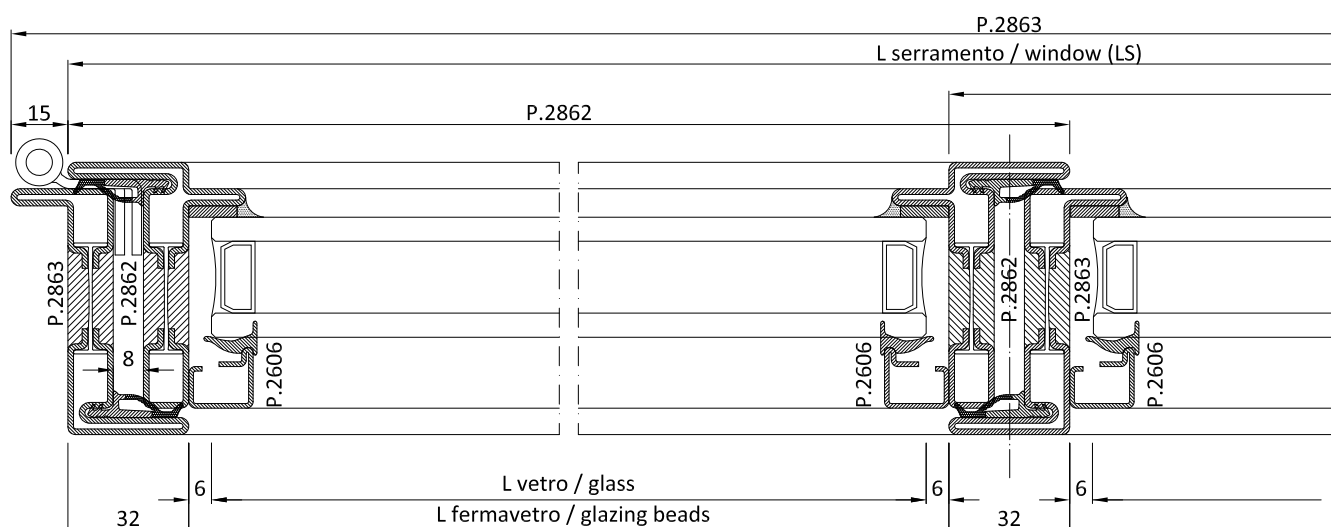


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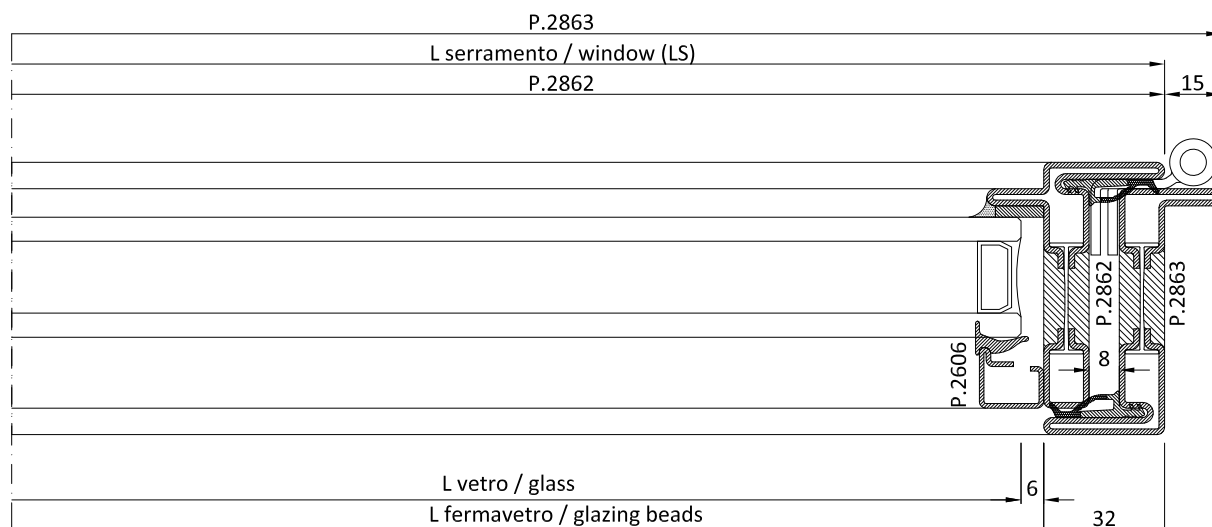
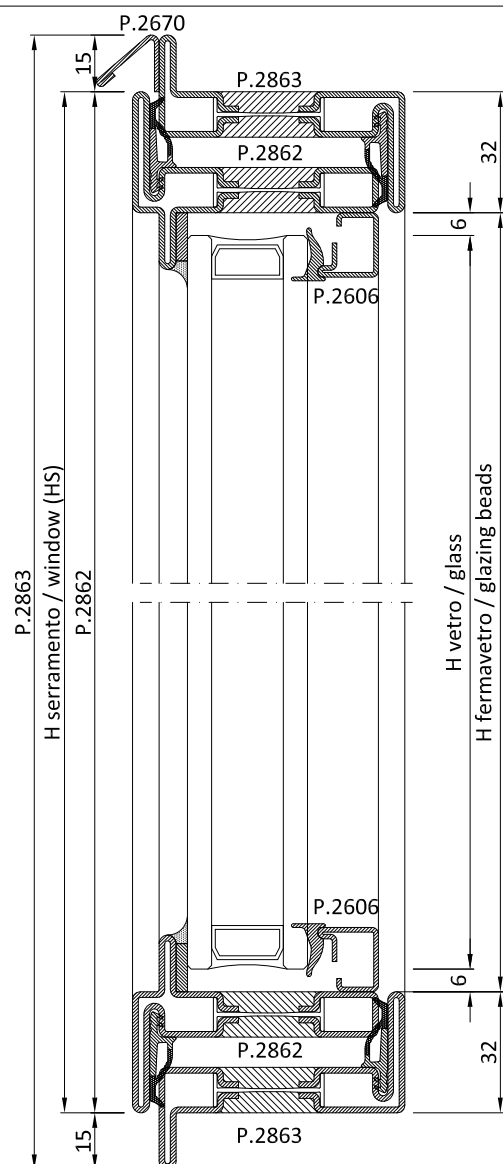
PROFILI		PROFILES			
Cod.	Descrizione	Description	n°	Dim.	Taglio Cutting
Telaio		Frame			
P.2863	Profilo a "Z" telaio	"Z" profile frame	2	LS+30	45° 45°
P.2863	Profilo a "Z" telaio	"Z" profile frame	2	HS+30	45° 45°
P.2670	Profilo battiacqua	Water drip profile	1	LS+30	90° 90°
Anta		Leaf			
P.2862	Profilo a "T" anta	"T" profile leaf	4	LS/2+16	45° 45°
P.2862	Profilo a "T" anta	"T" profile leaf	3	HS	45° 45°
P.2863	Profilo a "Z" anta	"Z" profile leaf	1	HS	45° 45°
Fermavetri		Glazing beads			
P.2606	Profilo fermavetro	Glazing bead profile	4	LS/2-48	45° 45°
P.2606	Profilo fermavetro	Glazing bead profile	4	HS-64	45° 45°
Vetri		Glass unit			
-	Vetrocamera	Insulated glass	2	LS/2-60 x HS-76	

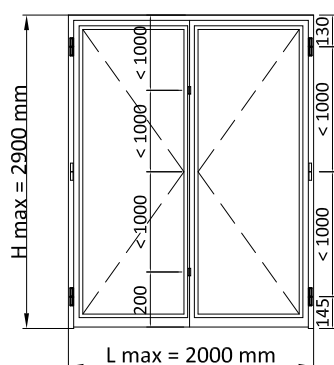


ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
AC2608	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.
AC2626R	Kit per terza chiusura	Three-point lock system kit	Var.
AC2627	Chiusura mediana lato cerniere	Hinge-side middle closing	Var.
AC2653	Fondino per 2^ anta	Botton plate for second leaf	2
AC2680	Maniglia di trascinamento	Dragging leaf handle	1
AC2684D/S	Kit cremonese	Cremona bolt set	1
AC2687	Braccetti limitatori	Casement stays	Opz.
AC	Cerniere	Hinges	Var.
ACV77..	Maniglia "Vitruvio"	"Vitruvio" handle	1
AC2803I*	Kit squadrette per P.2863	Corner brackets kit for P.2863	4
AC2832I*	Kit squadrette per P.2862-63	Corner brackets kit for P.2862-63	2
AC2862I*	Kit squadrette per P.2862	Corner brackets kit for P.2862	6

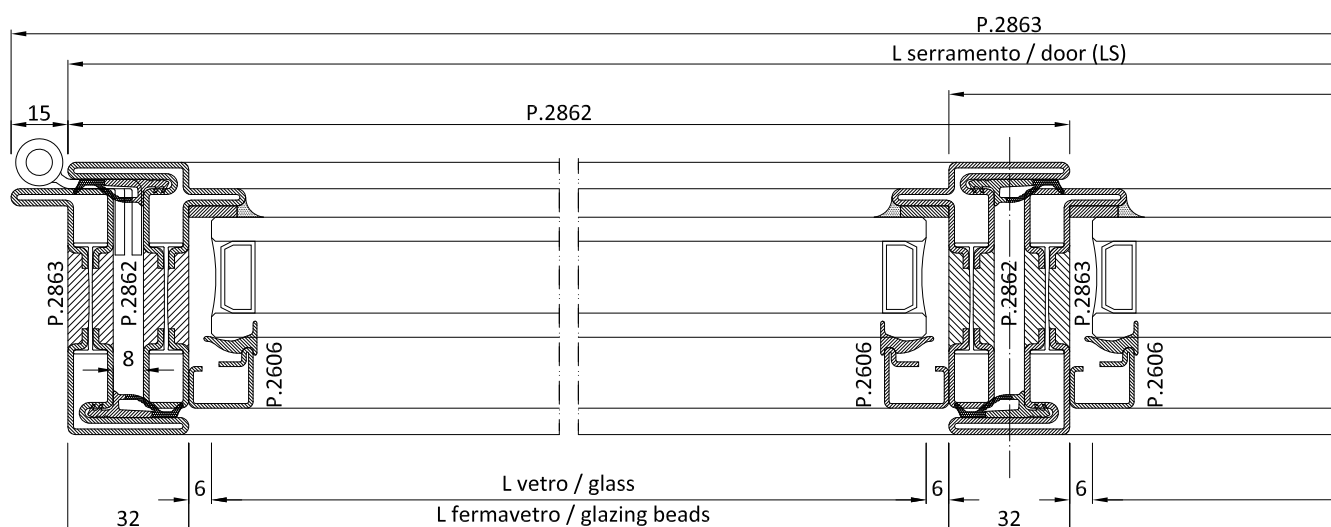
GUARNIZIONI		GASKETS		
Cod.	Descrizione	Description	n°	Dim.
GE2645TT	Guarnizione esterna di battuta	Rebating gasket	2	2xLS+3xHS
GU2036	Piattina adesiva fondo giunto	Adhesive shim for joint	1	2xLS+4xHS
GP0095	Guarnizione interna vetro	Internal weather strip	1	2xLS+4xHS

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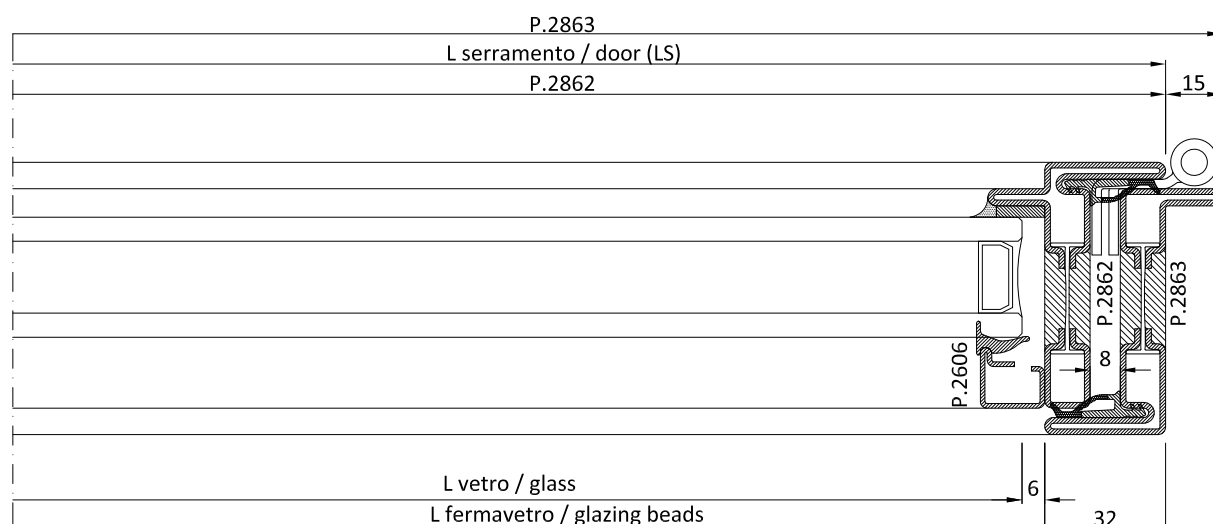
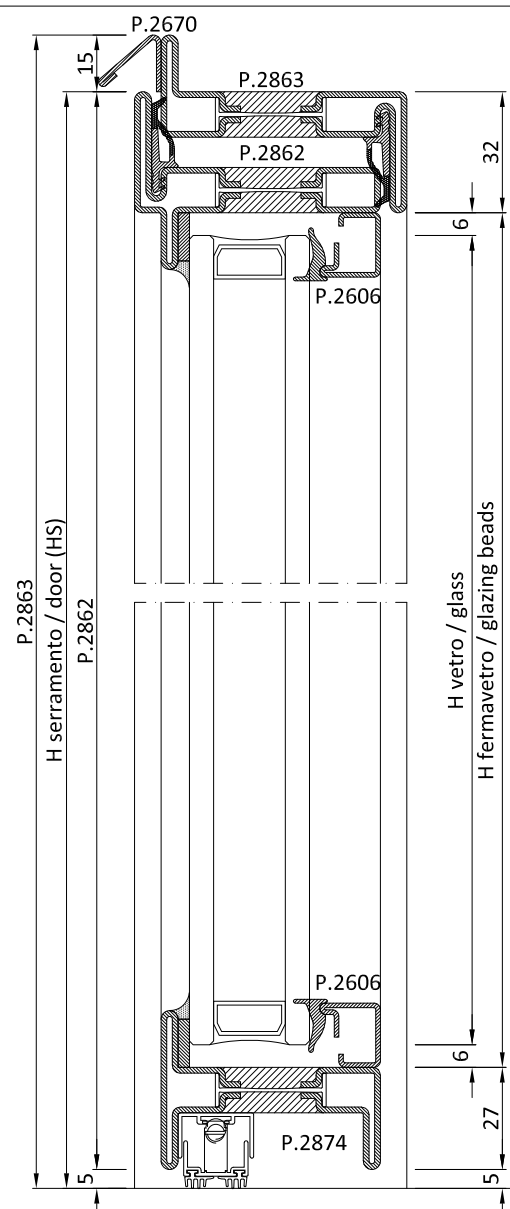
PROFILI		PROFILES			
Cod.	Descrizione	Description	n°	Dim.	Taglio Cutting
Telaio		Frame			
P.2863	Profilo a "Z" telaio	"Z" profile frame	1	LS+30	45° 45°
P.2863	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	90° 45°
P.2863	Profilo a "Z" telaio	"Z" profile frame	1	HS+15	45° 90°
P.2670	Profilo battiacqua	Water drip profile	1	LS+30	90° 90°
Anta		Leaf			
P.2862	Profilo a "Z" anta	"Z" profile leaf	2	LS/2+16	45° 45°
P.2862	Profilo a "Z" anta	"Z" profile leaf	2	HS-5	90° 45°
P.2862	Profilo a "Z" anta	"Z" profile leaf	1	HS-5	45° 90°
P.2863	Profilo a "T" anta	"T" profile leaf	1	HS-5	45° 90°
P.2874	Profilo Zoccolo	Socle profile	2	LS/2-48	90° 90°
Fermavetri		Glazing beads			
P.2606	Profilo fermavetro	Glazing bead profile	4	LS/2-48	45° 45°
P.2606	Profilo fermavetro	Glazing bead profile	4	HS-64	45° 45°
Vetri		Glass unit			
-	Vetrocamera	Insulated glass	2	LS/2-60 x HS-76	

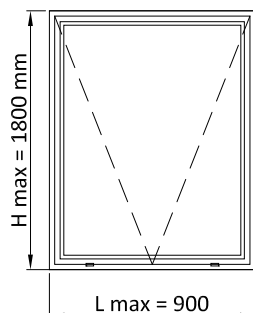


ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
AC2608	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.
AC2621GB	Catenaccio 2^ anta (h 220)	Second leaf bolt	1
AC2621GC	Catenaccio 2^ anta (h 650)	Second leaf bolt	1
AC2636/.	Guarnizione automatica	Automatic underdoor seal gasket	2
AC2653	Fondino per 2^ anta	Botton plate for second leaf	1
AC	Serratura	Lock	1
AC2695D/S	Punto di chiusura agg. (con AC2694)	Additional closing	Opz.
AC2696/ 97	Scatola copri serratura	Lock cover box	1
AC	Cerniere	Hinges	Var.
ACV95..	Maniglia "Vitruvio"	"Vitruvio" handle	1
AC2803I*	Kit squadrette per P.2863	Corner brackets kit for P.2863	2
AC2832I*	Kit squadrette per P.2862-63	Corner brackets kit for P.2862-63	1
AC2862I*	Kit squadrette per P.2862	Corner brackets kit for P.2862	3

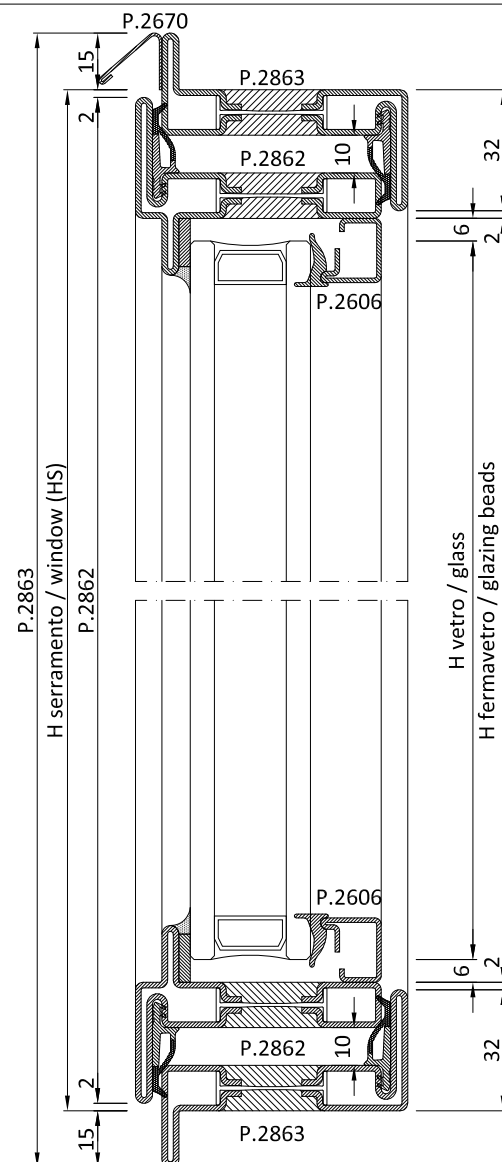
GUARNIZIONI		GASKETS		
Cod.	Descrizione	Description	n°	Dim.
GE2645TT	Guarnizione esterna di battuta	Rebating gasket	2	1xLS+3xHS
GU2036	Piattina adesiva fondo giunto	Adhesive shim for joint	1	2xLS+4xHS
GP0095	Guarnizione interna vetro	Internal weather strip	1	2xLS+4xHS

* solo con profili ottone
only with brass profiles

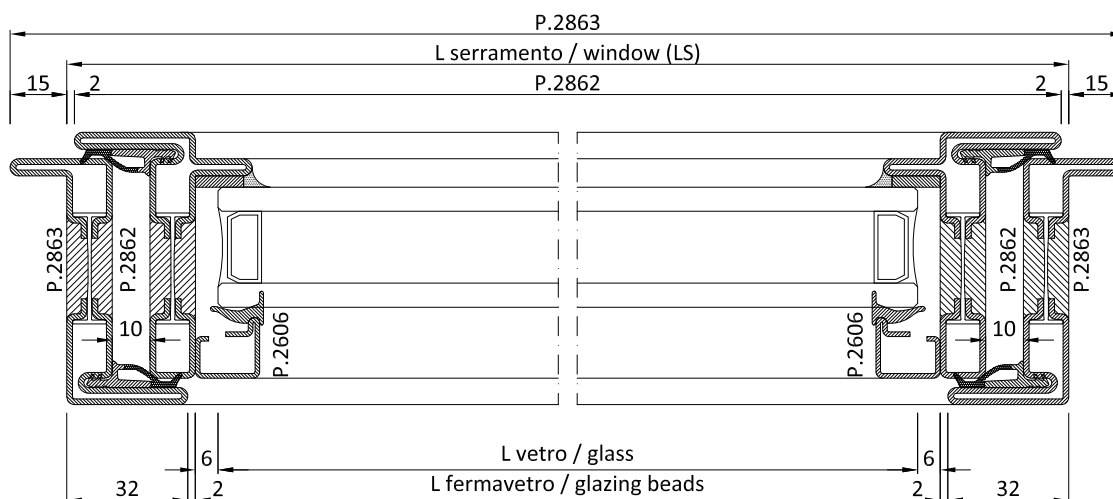


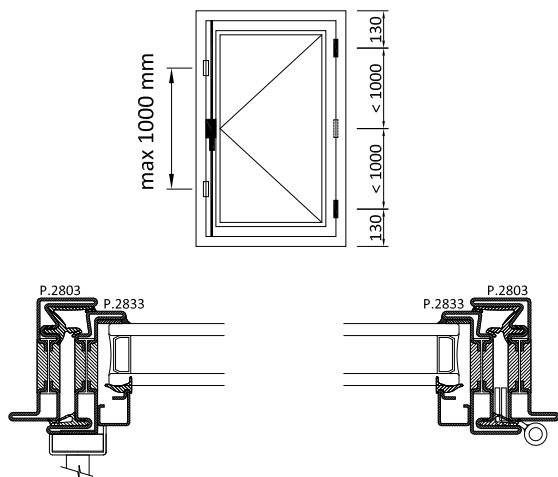


PROFILI		PROFILES		n°	Dim.	Taglio	Cutting
Cod.	Descrizione	Description					
Telaio		Frame					
P.2863	Profilo a "Z" telaio	"Z" profile frame	2	LS+30	45°	45°	
P.2863	Profilo a "Z" telaio	"Z" profile frame	2	HS+30	45°	45°	
P.2670	Profilo battiacqua	Water drip profile	1	LS+30	90°	90°	
Anta		Leaf					
P.2862	Profilo a "T" anta	"T" profile leaf	2	LS-4	45°	45°	
P.2862	Profilo a "T" anta	"T" profile leaf	2	HS-4	45°	45°	
Fermavetri		Glazing beads					
P.2606	Profilo fermavetro	Glazing bead profile	2	LS-68	45°	45°	
P.2606	Profilo fermavetro	Glazing bead profile	2	HS-68	45°	45°	
Vetri		Glass unit					
-	Vetrocamera	Insulated glass	1	LS-80 x HS-80			
ACCESSORI		HARDWARE					
Cod.	Descrizione	Description	n°				
AC2608	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.				
AC2680 ..	Maniglia di trascinamento	Dragging leaf handle	1				
AC2683D/S	Kit cremonese	Cremone bolt set	1				
AC	Coppia compassi	Pair of side arm	1				
AC	Cerniere (solo con AC2690)	Hinges (only with AC2690)	Opz.				
ACV77..	Maniglia "Vitruvio"	"Vitruvio" handle	1				
AC2803I*	Kit squadrette per P.2863	Corner brackets kit for P.2863	4				
AC2862I*	Kit squadrette per P.2862	Corner brackets kit for P.2862	4				
GUARNIZIONI		GASKETS					
Cod.	Descrizione	Description	n°	Dim.			
GE2645TT	Guarnizione esterna di battuta	Rebating gasket	2	4xLS+4xHS			
GU2036	Piattina adesiva fondo giunto	Adhesive shim for joint	1	2xLS+2xHS			
GP0095	Guarnizione interna vetro	Internal weather strip	1	2xLS+2xHS			



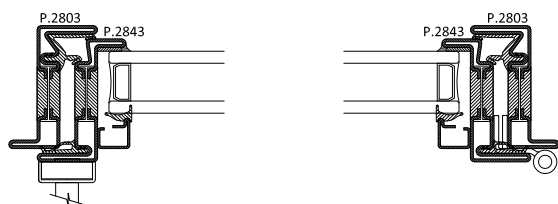
* solo con profili ottone
only with brass profiles





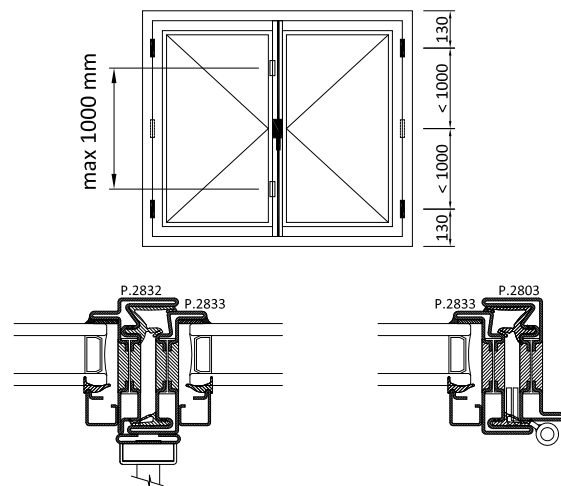
APERTURA INTERNA AD UN ANTA PROFILO P.2833
ONE-LEAF INWARD OPENING P.2833 PROFILE

Art.	Code	Descrizione Description	Pag.
AC2623 D/S		Kit cremonese chiusura finestra ad un anta <i>Cremone bolt set for one-leaf window</i>	4.3.17 4.5.3 4
AC2628		Cerniere a tre ali ad avvitare <i>Three-wing screw-in hinge</i>	4.3.27 28
AC2629/30		Cerniere a due ali ad avvitare <i>Two-wing screw-in hinge</i>	4.3.29 30
AC2631 A/B		Cerniere a saldare <i>Welding hinge</i>	4.4.5
AC2632 B/C		Cerniere a saldare <i>Welding hinge</i>	4.4.5
AC2626 R		Chiusura supplementare <i>Additional lock</i>	4.3.25 4.5.15



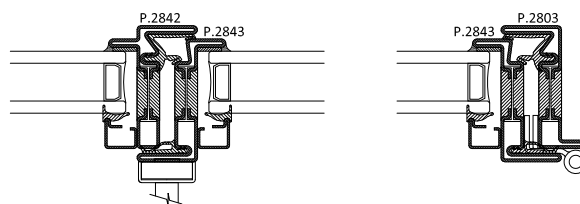
APERTURA INTERNA AD UN ANTA PROFILO P.2843
ONE-LEAF INWARD OPENING P.2843 PROFILE

Art.	Code	Descrizione Description	Pag.
AC2625 D/S		Kit cremonese chiusura finestra ad un anta <i>Cremone bolt set for one-leaf window</i>	4.3.20 4.5.9 10
AC2648		Cerniere a tre ali ad avvitare <i>Three-wing screw-in hinge</i>	4.3.31 32
AC2649/50		Cerniere a due ali ad avvitare <i>Two-wing screw-in hinge</i>	4.3.35 36
AC2631 A/B		Cerniere a saldare <i>Welding hinge</i>	4.4.6
AC2632 B/C		Cerniere a saldare <i>Welding hinge</i>	4.4.6
AC2626 R		Chiusura supplementare <i>Additional lock</i>	4.3.25 4.5.15



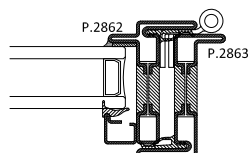
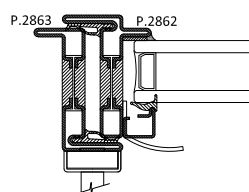
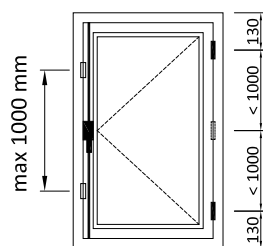
APERTURA INTERNA A DUE ANTE PROFILO P.2833
TWO-LEAF INWARD OPENING P.2833 PROFILE

Art.	Code	Descrizione Description	Pag.
AC2624 D/S		Kit cremonese chiusura finestra a due ante <i>Cremone bolt set for two-leaf window</i>	4.3.18 4.5.5 6
AC2622		Snapper chiusura 2^ anta <i>Snapper for 2nd leaf</i>	4.5.6
AC2628		Cerniere a tre ali ad avvitare <i>Three-wing screw-in hinge</i>	4.3.27 28
AC2629/30		Cerniere a due ali ad avvitare <i>Two-wing screw-in hinge</i>	4.3.29 30
AC2631 A/B		Cerniere a saldare <i>Welding hinge</i>	4.4.5
AC2632 B/C		Cerniere a saldare <i>Welding hinge</i>	4.4.5
AC2626 R		Chiusura supplementare <i>Additional lock</i>	4.3.25 4.5.15



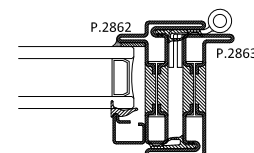
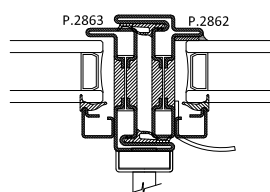
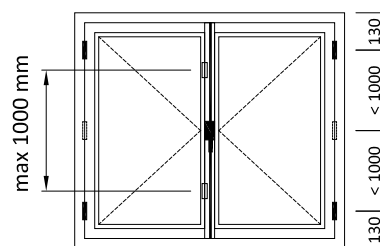
APERTURA INTERNA A DUE ANTE PROFILO P.2843
TWO-LEAF INWARD OPENING P.2843 PROFILE

Art.	Code	Descrizione Description	Pag.
AC2624 D/S		Kit cremonese chiusura finestra a due ante <i>Cremone bolt set for two-leaf window</i>	4.3.19 4.5.7 8
AC2622		Snapper chiusura 2^ anta <i>Snapper for 2nd leaf</i>	4.5.6
AC2648		Cerniere a tre ali ad avvitare <i>Three-wing screw-in hinge</i>	4.3.31 32
AC2649/50		Cerniere a due ali ad avvitare <i>Two-wing screw-in hinge</i>	4.3.35 36
AC2631 A/B		Cerniere a saldare <i>Welding hinge</i>	4.4.6
AC2632 B/C		Cerniere a saldare <i>Welding hinge</i>	4.4.6
AC2626 R		Chiusura supplementare <i>Additional lock</i>	4.3.25 4.5.15



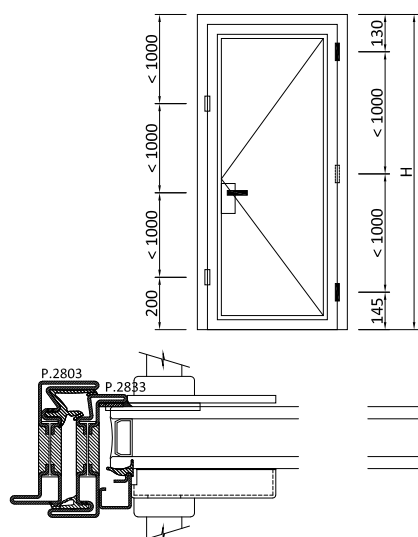
APERTURA ESTERNA AD UN ANTA PROFILO P.2862
ONE-LEAF OUTWARD OPENING P.2862 PROFILE

Art.	Code	Descrizione Description	Pag.
AC2683 D/S		Kit cremonese chiusura finestra ad un anta <i>Cremone bolt set for one-leaf window</i>	4.3.21 22 4.5.11 12
AC2680		Maniglia trascinamento anta <i>Pulling handle</i>	4.5.24
AC2648		Cerniere a tre ali ad avvitare <i>Three-wing screw-in hinge</i>	4.3.33 34
AC2649/50		Cerniere a due ali ad avvitare <i>Two-wing screw-in hinge</i>	4.3.37 38
AC2631 A/B		Cerniere a saldare <i>Cerniere a saldare</i>	4.4.7
AC2632 B/C		Cerniere a saldare <i>Welding hinge</i>	4.4.7
AC2626 R		Chiusura supplementare <i>Additional lock</i>	4.3.26 4.5.15



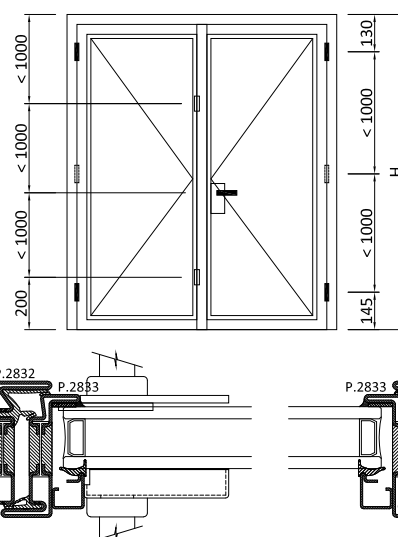
APERTURA ESTERNA A DUE ANTE PROFILO P.2862
TWO-LEAF OUTWARD OPENING P.2862 PROFILE

Art.	Code	Descrizione Description	Pag.
AC2684 D/S		Kit cremonese chiusura finestra a due ante <i>Cremone bolt set for two-leaf window</i>	4.3.23 24 4.5.13 14
AC2680		Maniglia trascinamento anta <i>Pulling handle</i>	4.5.24
AC2648		Cerniere a tre ali ad avvitare <i>Three-wing screw-in hinge</i>	4.3.33 34
AC2649/50		Cerniere a due ali ad avvitare <i>Two-wing screw-in hinge</i>	4.3.37 38
AC2631 A/B		Cerniere a saldare <i>Welding hinge</i>	4.4.7
AC2632 B/C		Cerniere a saldare <i>Welding hinge</i>	4.4.7
AC2626 R		Chiusura supplementare <i>Additional lock</i>	4.3.26 4.5.15



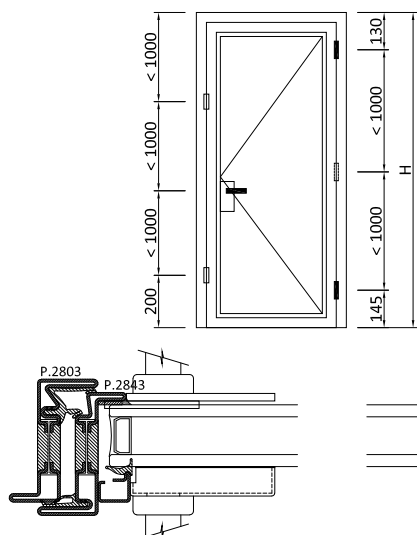
APERTURA INTERNA AD UN ANTA PROFILO P.2833
ONE-LEAF INWARD OPENING P.2833 PROFILE

Art.	Code	Descrizione Description	Pag.
AC2693		Serratura con scrocco e catenaccio <i>Lock with spring latch and bolt</i>	4.3.53
AC2694 D/S		Kit serratura a multipunto <i>Multi-lock kit</i>	4.3.55 4.5.25 26
AC2695 D/S		Punto di chiusura aggiuntivo <i>Additional lock</i>	4.3.57 4.5.27
AC2696/97		Scatola copri serratura <i>Lock cover box</i>	4.5.28
AC2628		Cerniere a tre ali ad avvitare <i>Three-wing screw-in hinge</i>	4.3.27 28
AC2629/30		Cerniere a due ali ad avvitare <i>Two-wing screw-in hinge</i>	4.3.29 30
AC2631/B		Cerniere a saldare <i>Welding hinge</i>	4.4.5
AC2632/B-C		Cerniere a saldare <i>Welding hinge</i>	4.4.5



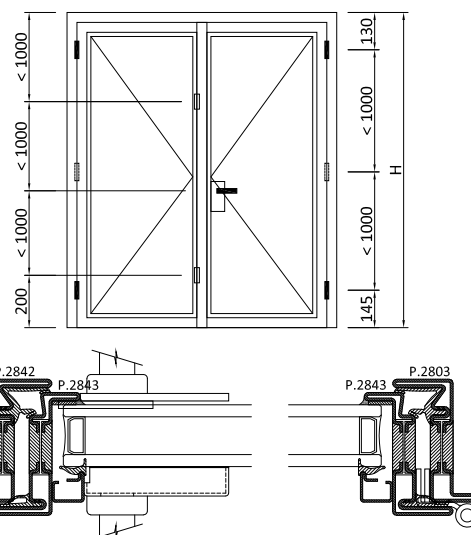
APERTURA INTERNA A DUE ANTE PROFILO P.2833
TWO-LEAF INWARD OPENING P.2833 PROFILE

Art.	Code	Descrizione Description	Pag.
AC2693		Serratura con scrocco e catenaccio <i>Lock with spring latch and bolt</i>	4.3.53
AC2694 D/S		Kit serratura a multipunto <i>Multi-lock kit</i>	4.3.55 4.5.25 26
AC2695 D/S		Punto di chiusura aggiuntivo <i>Additional lock</i>	4.3.57 4.5.27
AC2696/97		Scatola copri serratura <i>Lock cover box</i>	4.5.28
AC2621GB AC2621GC		Catenaccio seconda anta <i>Second leaf bolt</i>	4.3.48
AC2628		Cerniere a tre ali ad avvitare <i>Three-wing screw-in hinge</i>	4.3.27 28
AC2629/30		Cerniere a due ali ad avvitare <i>Two-wing screw-in hinge</i>	4.3.29 30
AC2631/B		Cerniere a saldare <i>Welding hinge</i>	4.4.5
AC2632/B-C		Cerniere a saldare <i>Welding hinge</i>	4.4.5



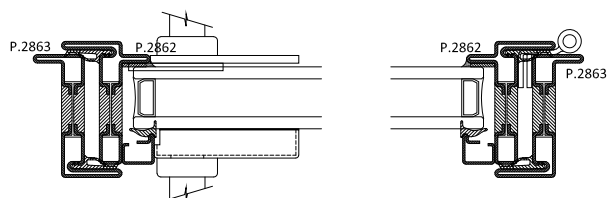
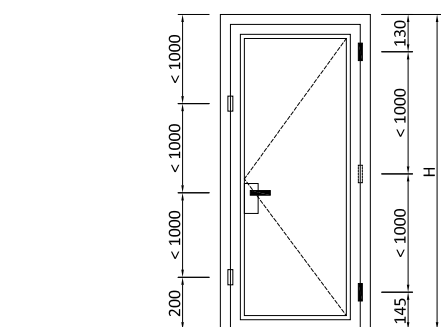
APERTURA INTERNA AD UN ANTA PROFILO P.2843
ONE-LEAF INWARD OPENING P.2843 PROFILE

Art.	Code	Descrizione Description	Pag.
AC2693		Serratura con scrocco e catenaccio <i>Lock with spring latch and bolt</i>	4.3.53
AC2694 D/S		Kit serratura a multipunto <i>Multi-lock kit</i>	4.3.55 4.5.25 26
AC2695 D/S		Punto di chiusura aggiuntivo <i>Additional lock</i>	4.3.57 4.5.27
AC2696/97		Scatola copri serratura <i>Lock cover box</i>	4.5.28
AC2648		Cerniere a tre ali ad avvitare <i>Three-wing screw-in hinge</i>	4.3.31 32
AC2649/50		Cerniere a due ali ad avvitare <i>Two-wing screw-in hinge</i>	4.3.35 36
AC2631/B		Cerniere a saldare <i>Welding hinge</i>	4.4.6
AC2632/B-C		Cerniere a saldare <i>Welding hinge</i>	4.4.6



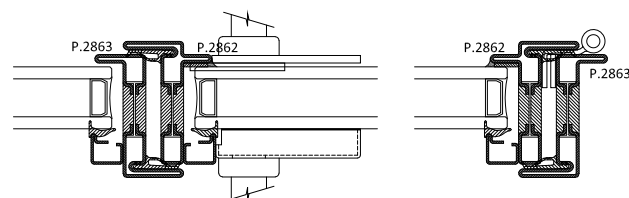
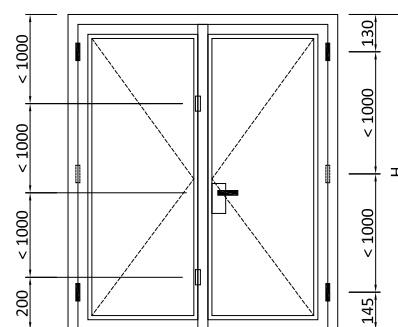
APERTURA INTERNA A DUE ANTE PROFILO P.2843
TWO-LEAF INWARD OPENING P.2843 PROFILE

Art.	Code	Descrizione Description	Pag.
AC2693		Serratura con scrocco e catenaccio <i>Lock with spring latch and bolt</i>	4.3.53
AC2694 D/S		Kit serratura a multipunto <i>Multi-lock kit</i>	4.3.55 4.5.25 26
AC2695 D/S		Punto di chiusura aggiuntivo <i>Additional lock</i>	4.3.57 4.5.27
AC2696/97		Scatola copri serratura <i>Lock cover box</i>	4.5.28
AC2621GB AC2621GC		Catenaccio seconda anta <i>Second leaf bolt</i>	4.3.49
AC2648		Cerniere a tre ali ad avvitare <i>Three-wing screw-in hinge</i>	4.3.31 32
AC2649/50		Cerniere a due ali ad avvitare <i>Two-wing screw-in hinge</i>	4.3.35 36
AC2631/B		Cerniere a saldare <i>Welding hinge</i>	4.4.6
AC2632/B-C		Cerniere a saldare <i>Welding hinge</i>	4.4.6



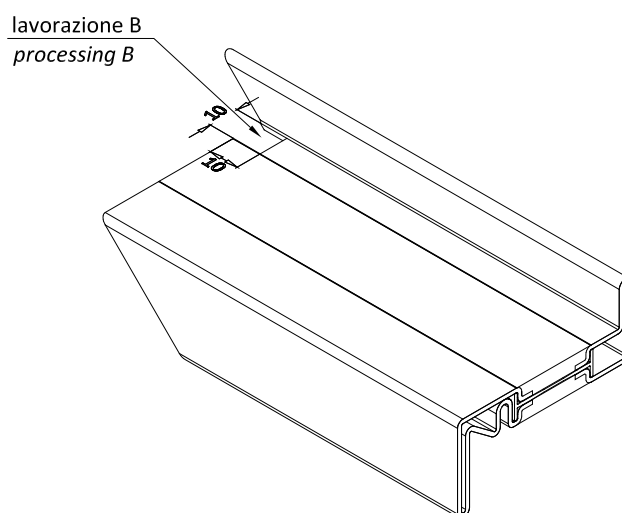
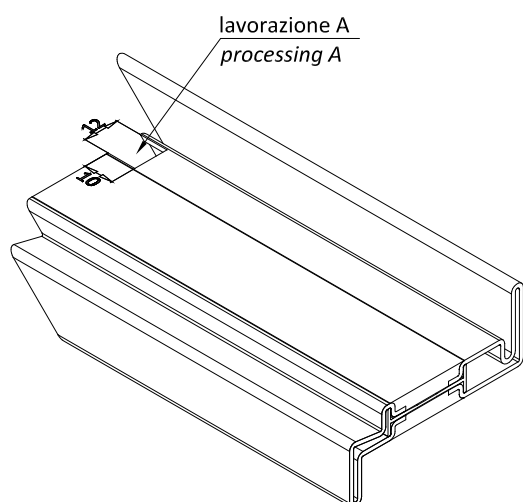
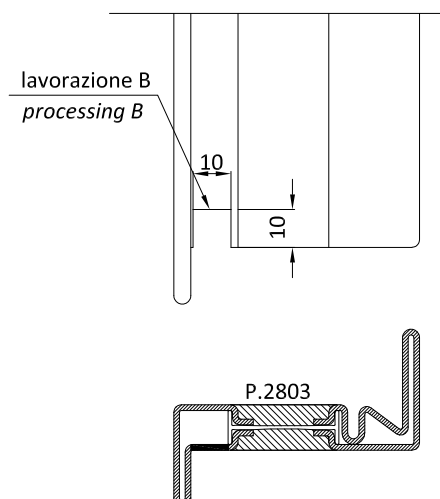
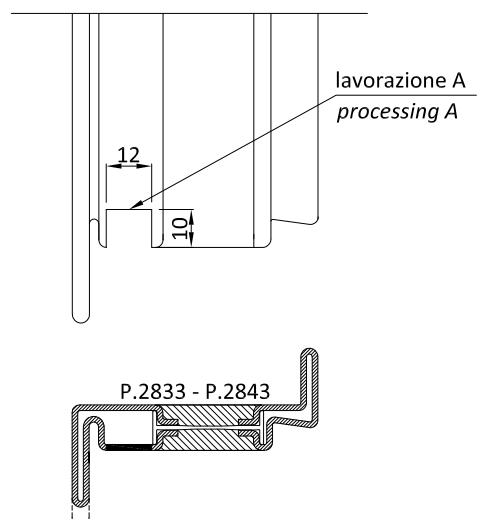
APERTURA ESTERNA AD UN ANTA PROFILO P.2862
ONE-LEAF OUTWARD OPENING P.2862 PROFILE

Art.	Code	Descrizione Description	Pag.
AC2693		Serratura con scrocco e catenaccio Lock with spring latch and bolt	4.3.54
AC2694 D/S		Kit serratura a multipunto Multi-lock kit	4.3.56 4.5.25 26
AC2695 D/S		Punto di chiusura aggiuntivo Additional lock	4.3.58 4.5.27
AC2696/97		Scatola copri serratura Lock cover box	4.5.28
AC2648		Cerniere a tre ali ad avvitare Three-wing screw-in hinge	4.3.33 34
AC2649/50		Cerniere a due ali ad avvitare Two-wing screw-in hinge	4.3.37 38
AC2631/B		Cerniere a saldare Welding hinge	4.4.7
AC2632/B-C		Cerniere a saldare Welding hinge	4.4.7

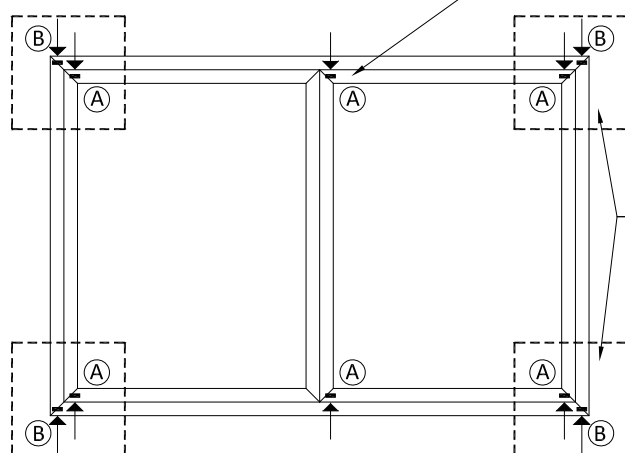


APERTURA ESTERNA A DUE ANTE PROFILO P.2862
TWO-LEAF OUTWARD OPENING P.2862 PROFILE

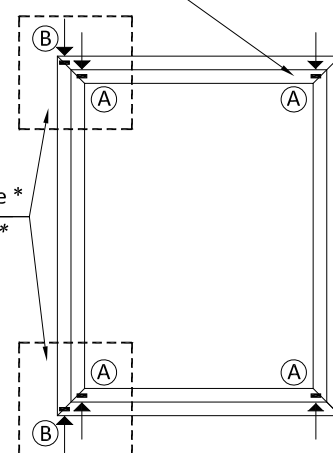
Art.	Code	Descrizione Description	Pag.
AC2693		Serratura con scrocco e catenaccio Lock with spring latch and bolt	4.3.54
AC2694 D/S		Kit serratura a multipunto Multi-lock kit	4.3.56 4.5.25 26
AC2695 D/S		Punto di chiusura aggiuntivo Additional lock	4.3.58 4.5.27
AC2696/97		Scatola copri serratura Lock cover box	4.5.28
AC2621GB AC2621GC		Catenaccio seconda anta Second leaf bolt	4.3.50
AC2648		Cerniere a tre ali ad avvitare Three-wing screw-in hinge	4.3.33 34
AC2649/50		Cerniere a due ali ad avvitare Two-wing screw-in hinge	4.3.37 38
AC2631/B		Cerniere a saldare Welding hinge	4.4.7
AC2632/B-C		Cerniere a saldare Welding hinge	4.4.7



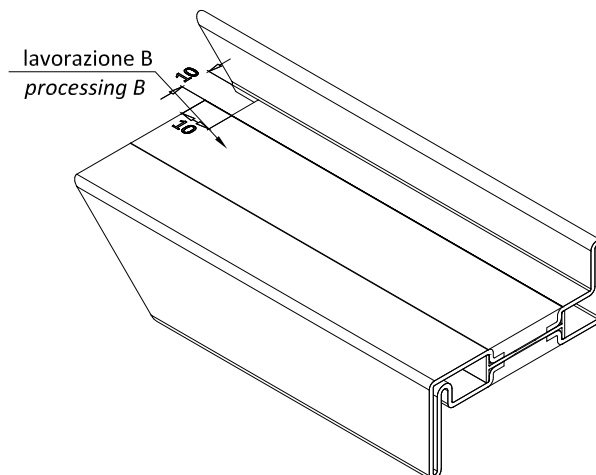
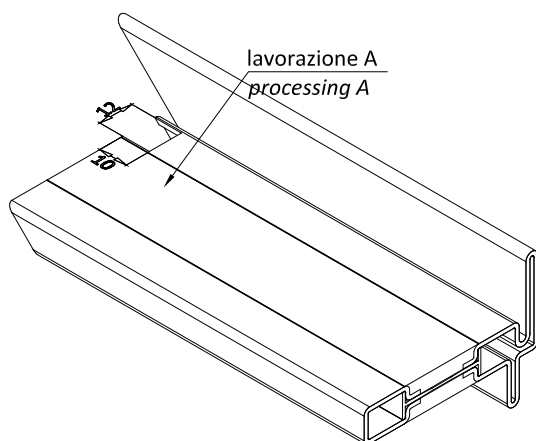
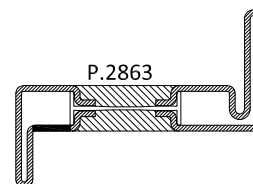
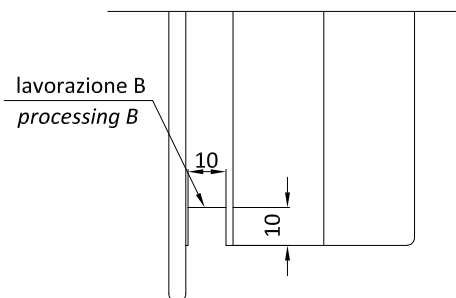
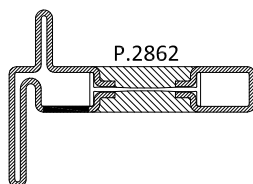
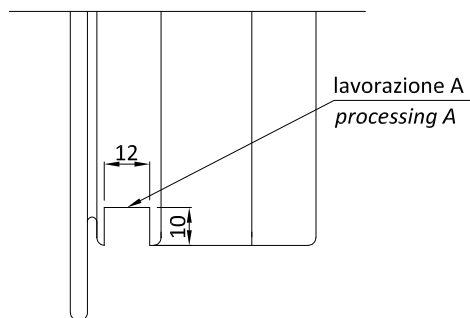
lavorazione per inserimento aste cremone
processing for inserting cremone bolt rod



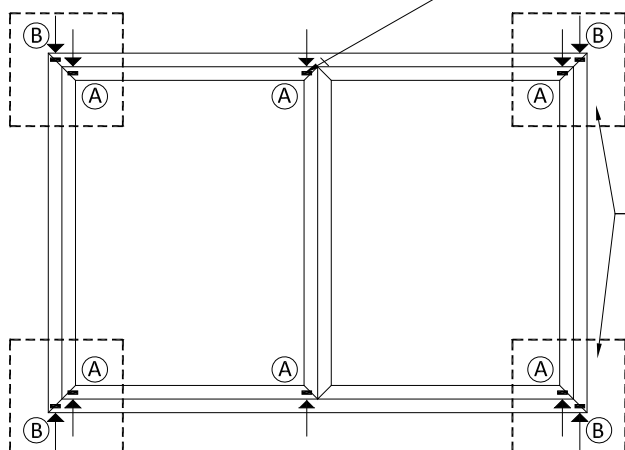
lavorazione per inserimento rinforzo cerniere *
processing for inserting hinge strengtheners *



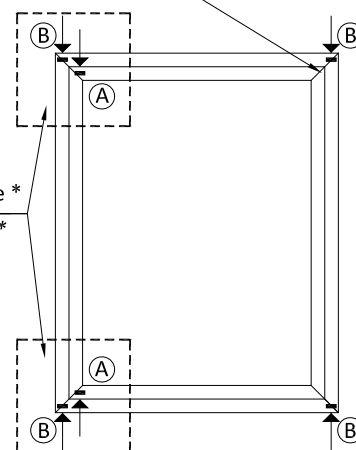
* Lavorazione per rinforzo cerniere necessaria per profili in ottone e acciaio inox
* Working for hinges reinforcement is necessary on brass and stainless steel profiles



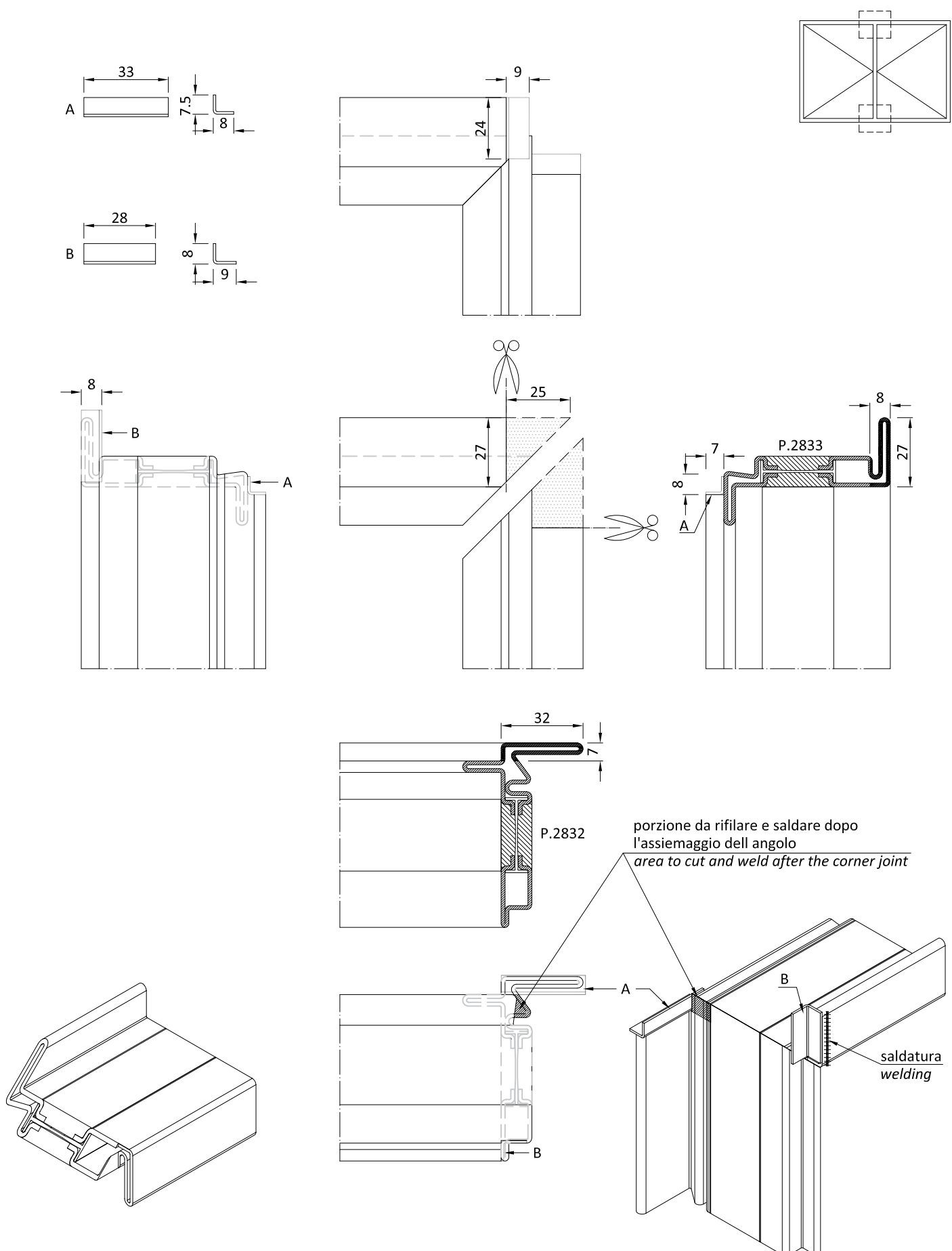
lavorazione per inserimento aste cremonese
processing for inserting cremone bolt rod



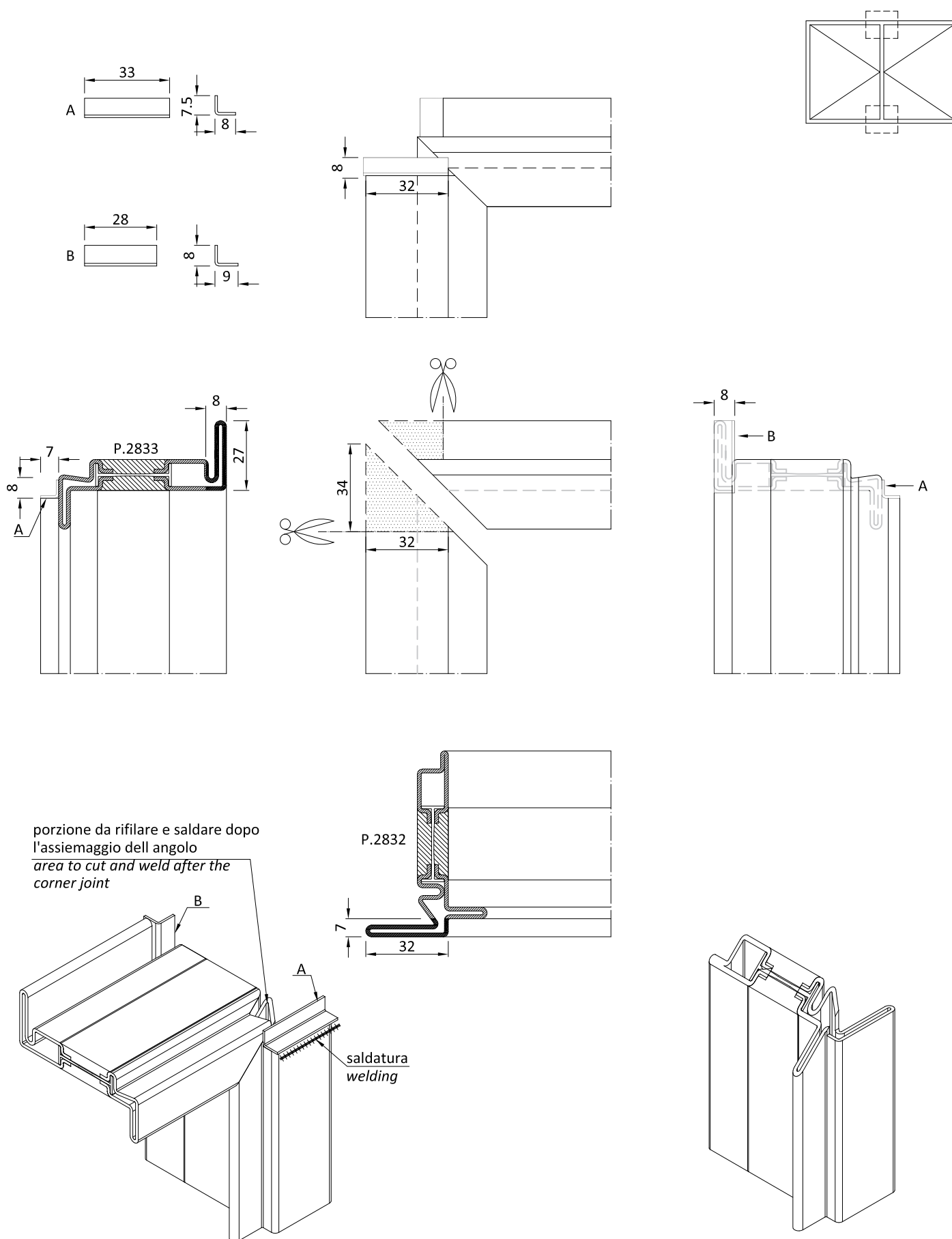
lavorazione per inserimento rinforzo cerniere *
processing for inserting hinge strengtheners *



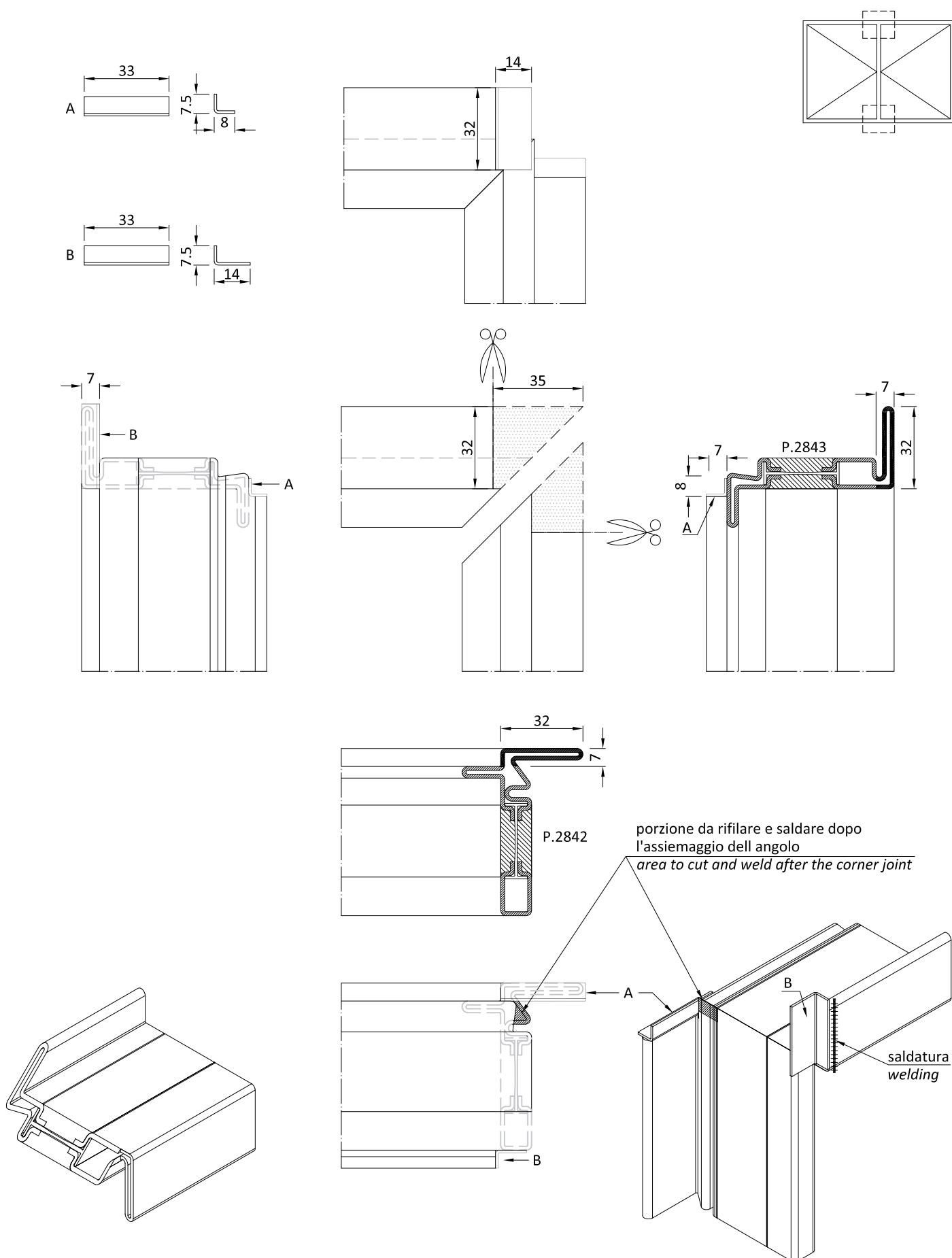
* Lavorazione per rinforzo cerniere necessaria per profili in ottone e acciaio inox
* Working for hinges reinforcement is necessary on brass and stainless steel profiles



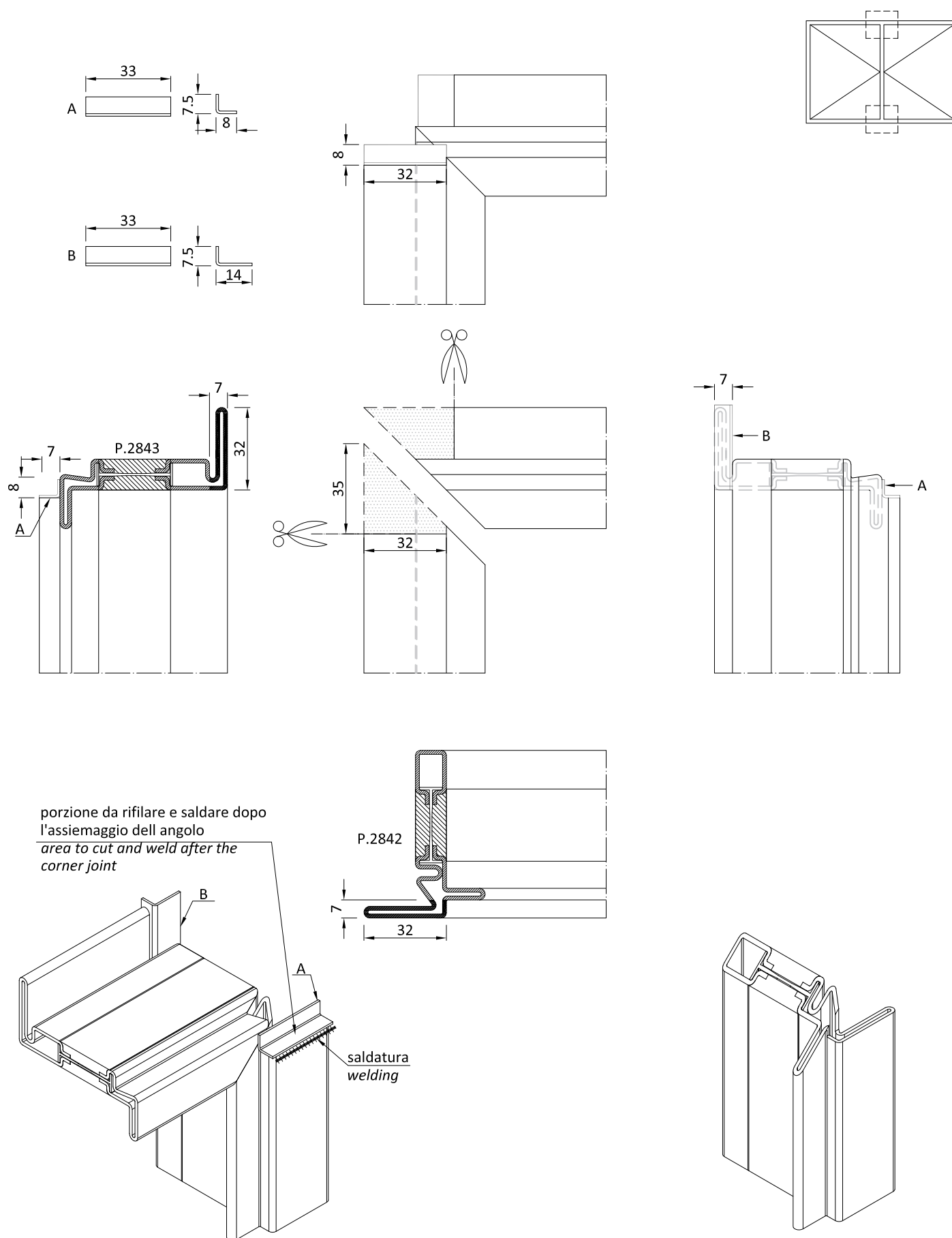
Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura
 Note: the fitting are provided larger by trimming after welding



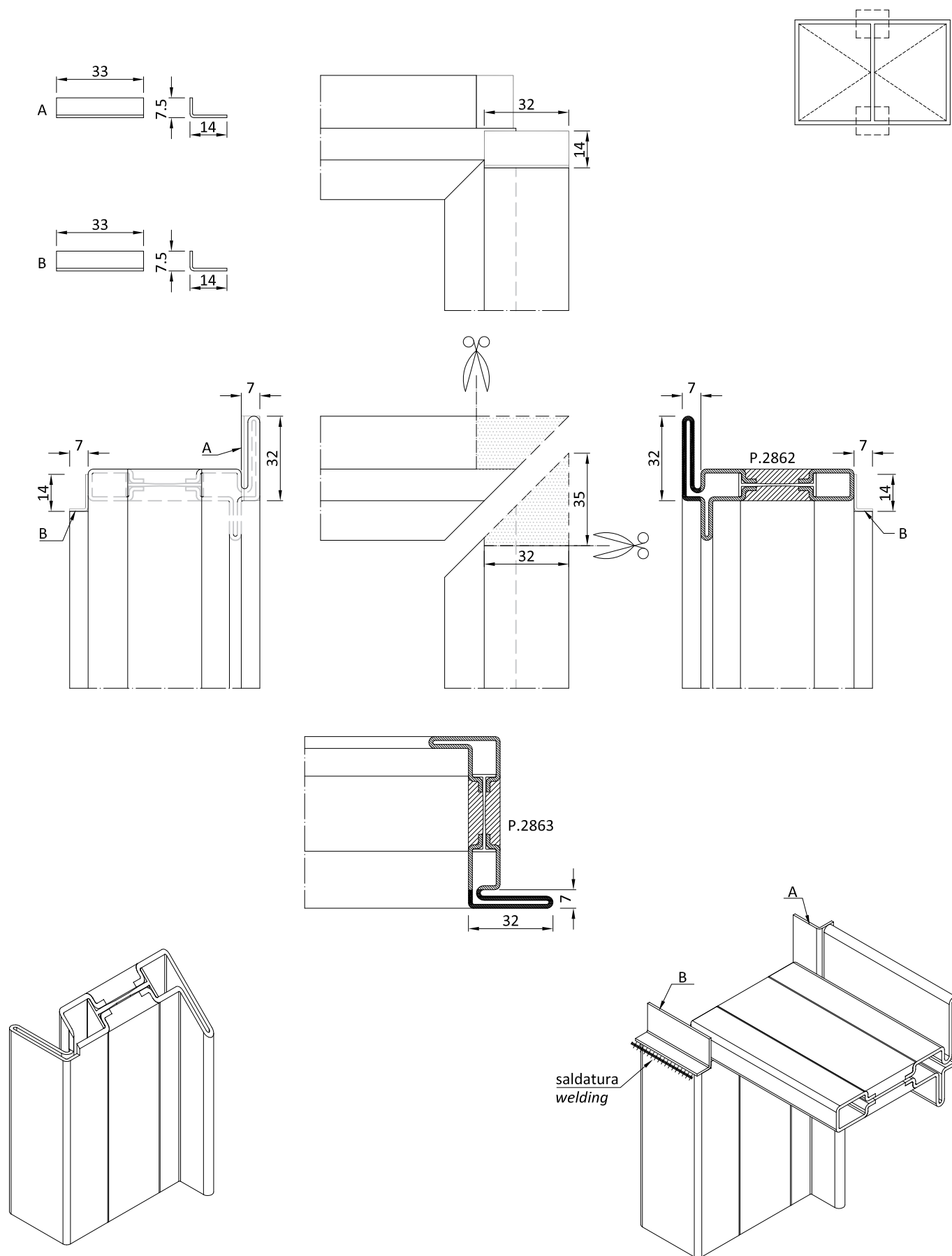
Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura
Note: the fitting are provided larger by trimming after welding



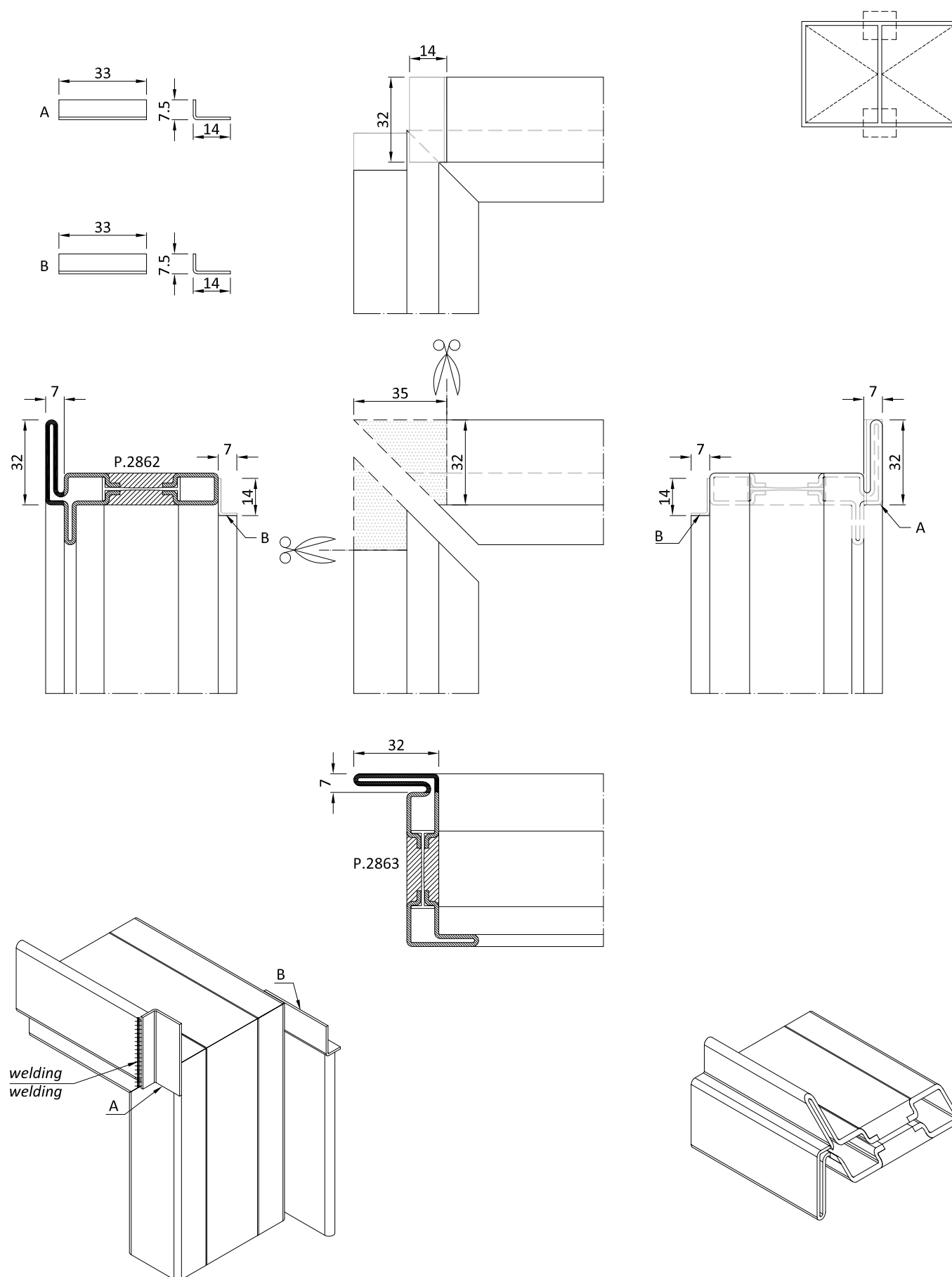
Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura
Note: the fitting are provided larger by trimming after welding



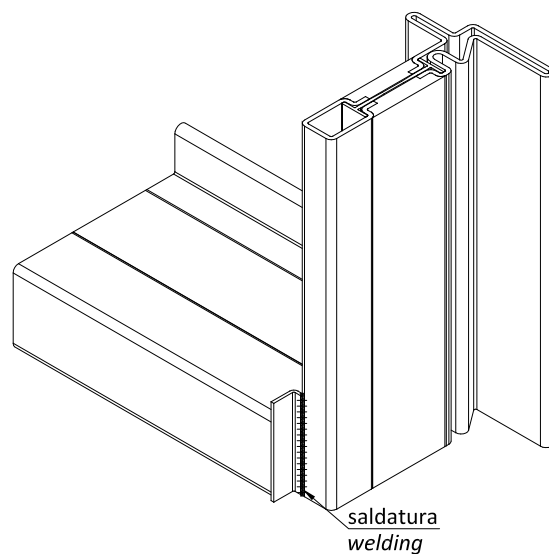
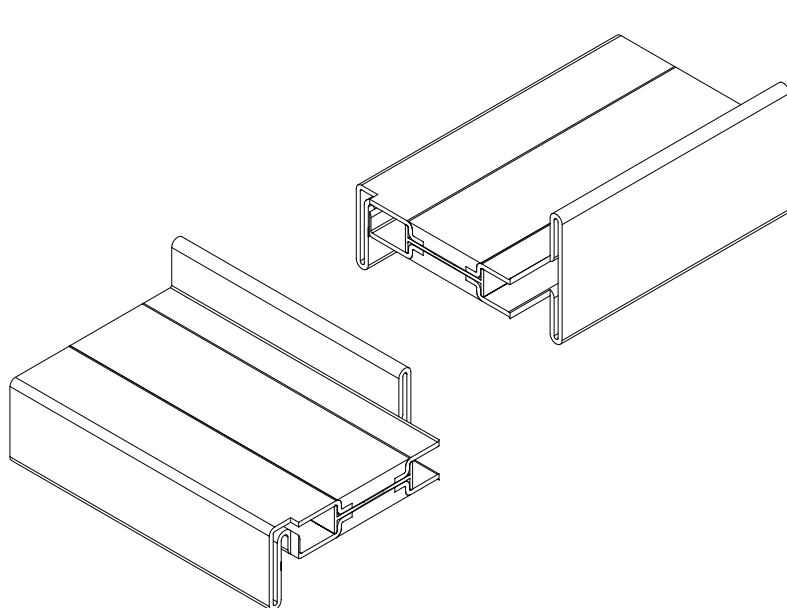
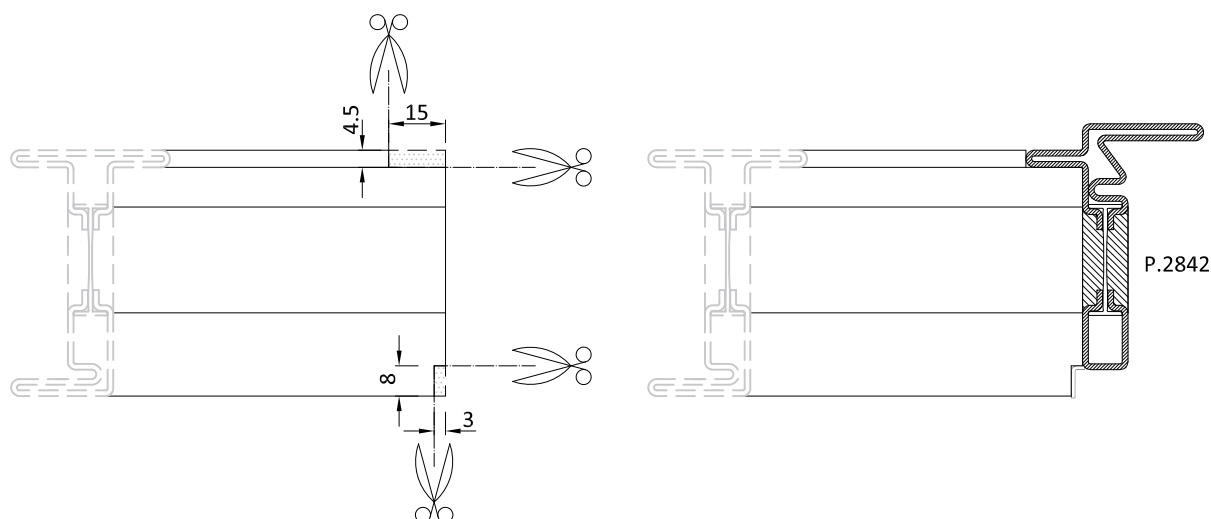
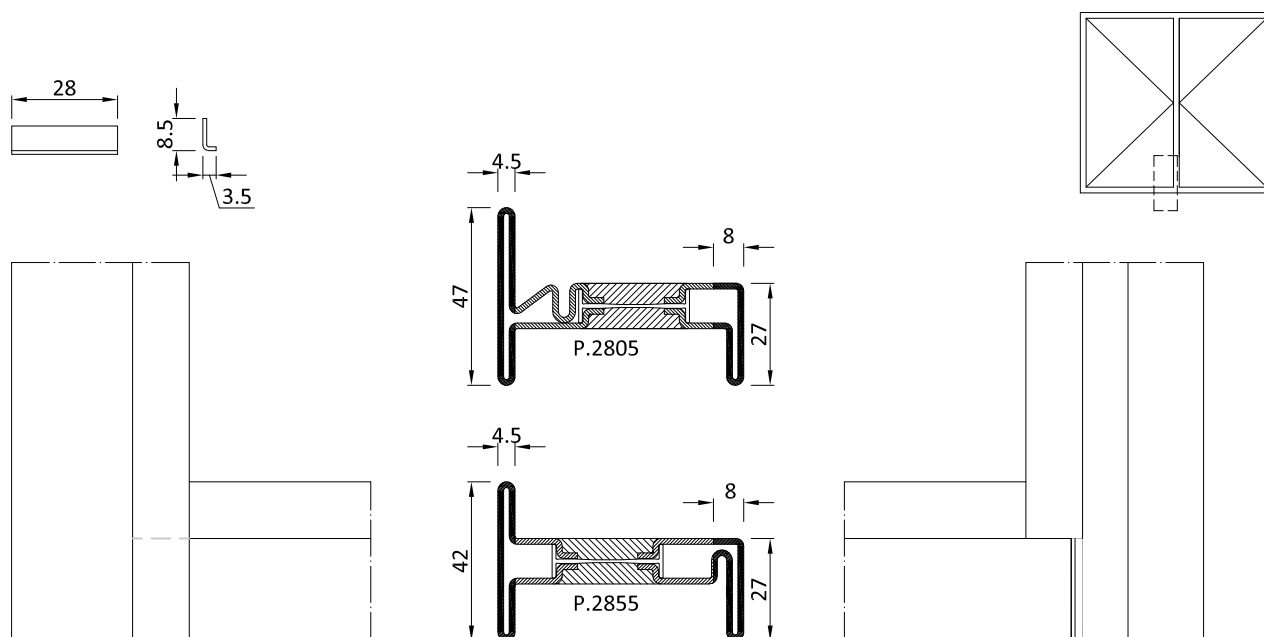
Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura
 Note: the fitting are provided larger by trimming after welding



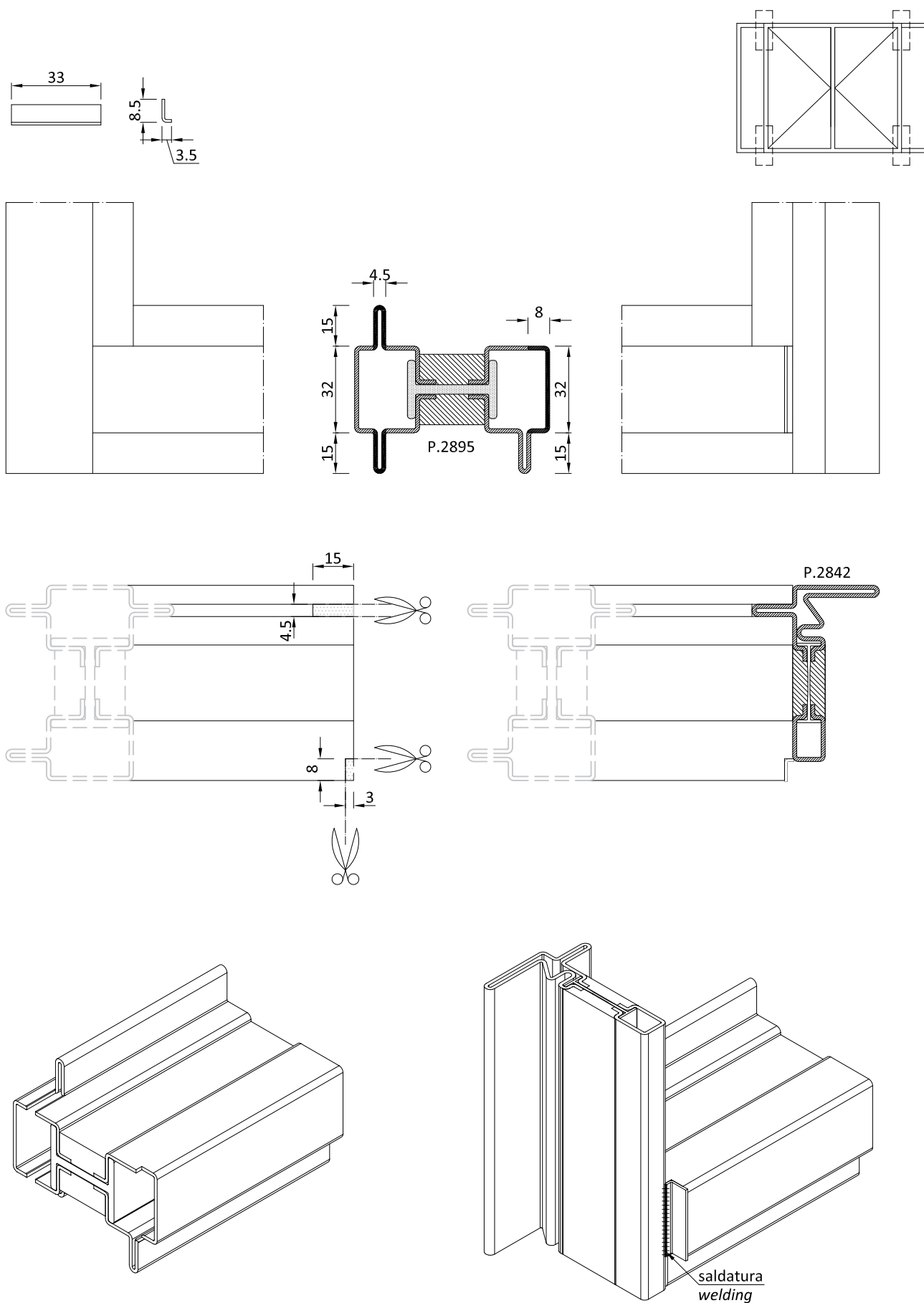
Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura
 Note: the fitting are provided larger by trimming after welding



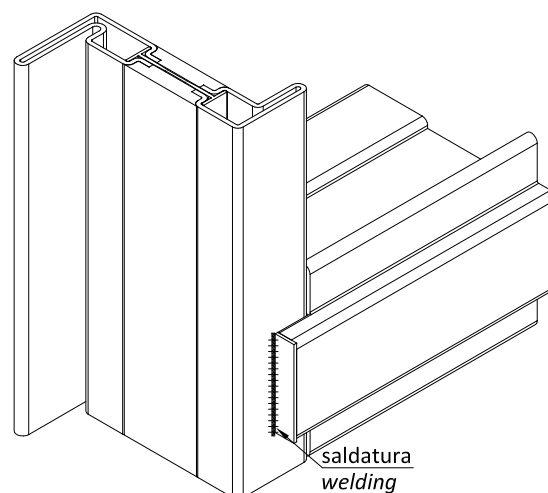
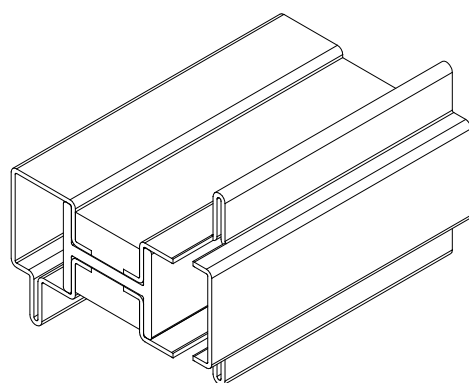
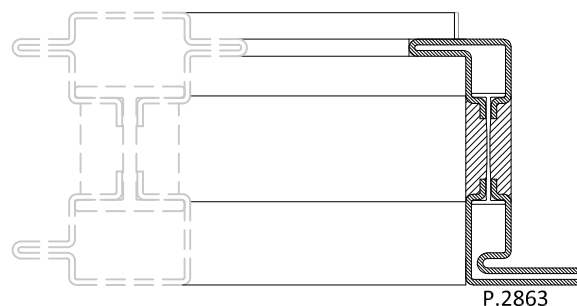
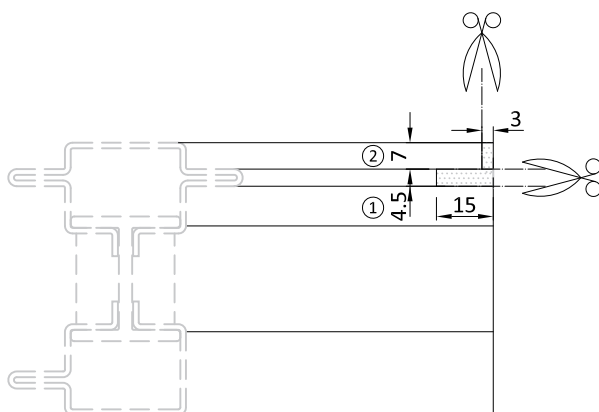
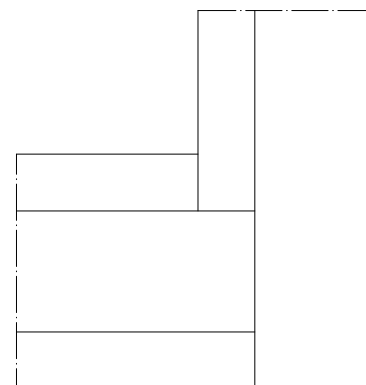
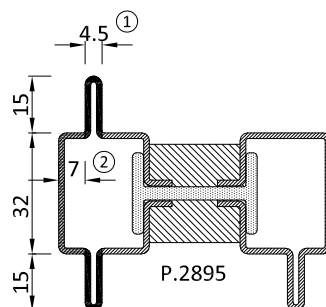
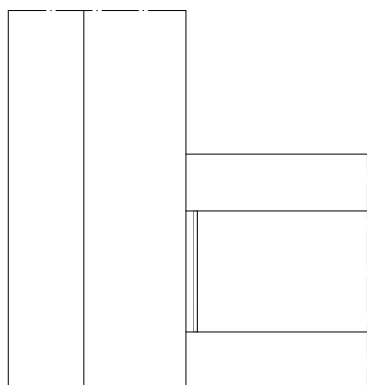
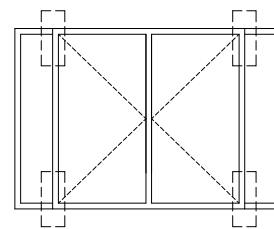
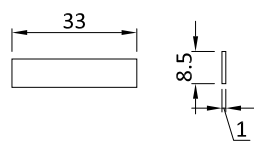
Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura
 Note: the fitting are provided larger by trimming after welding



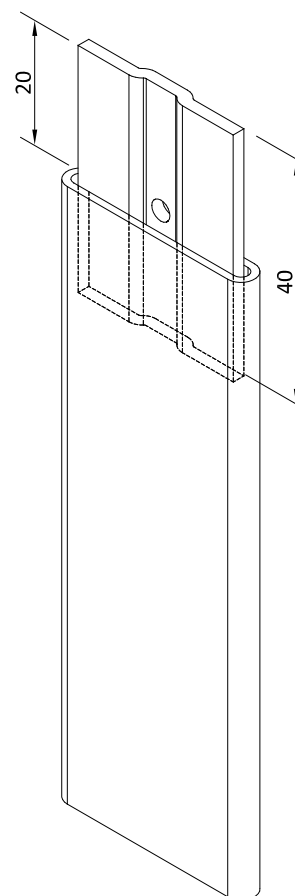
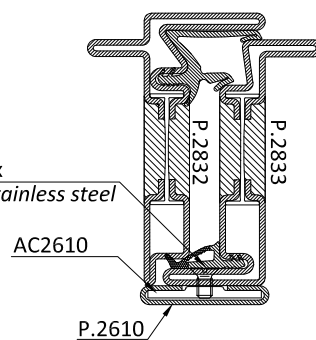
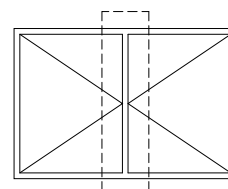
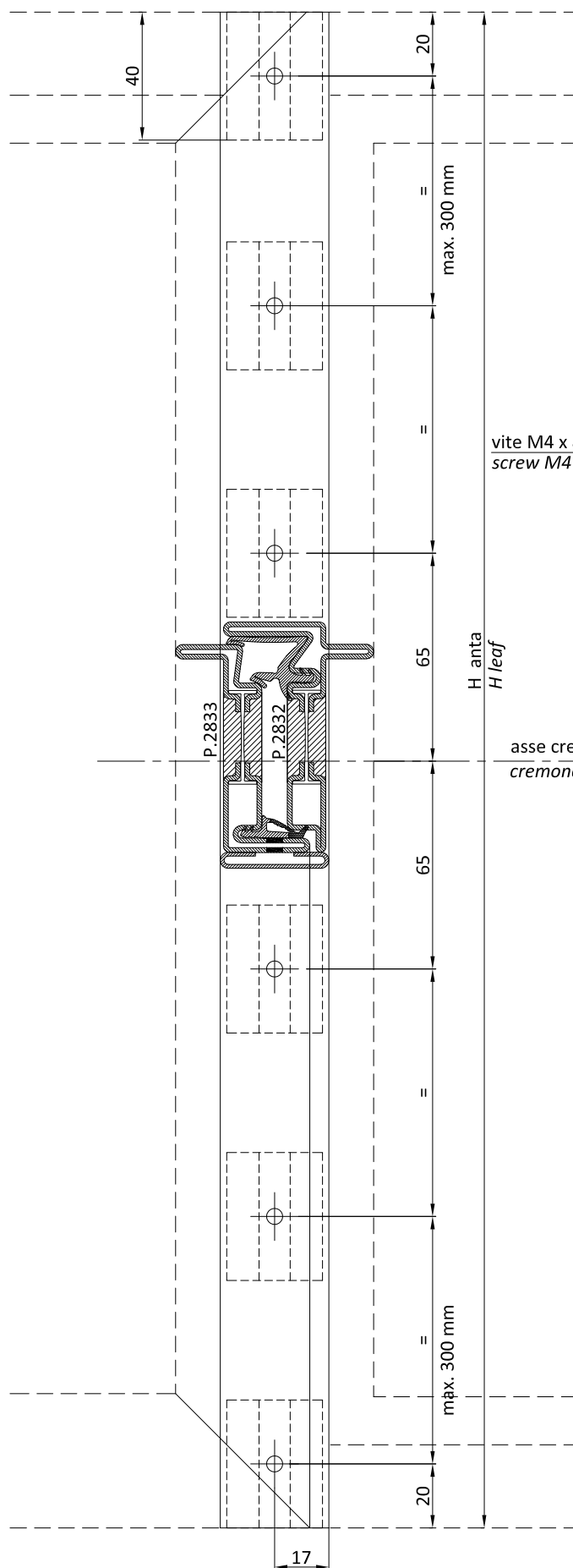
Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura
Note: the fittings are provided larger by trimming after welding

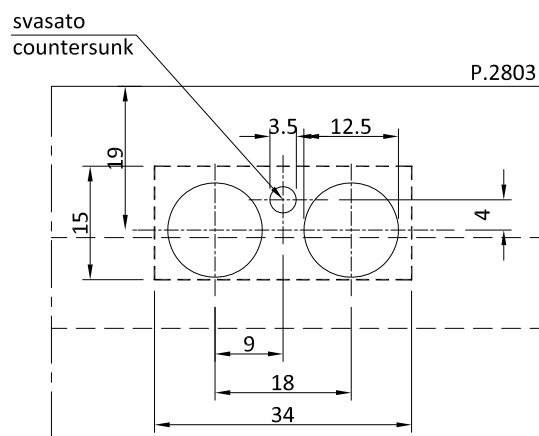
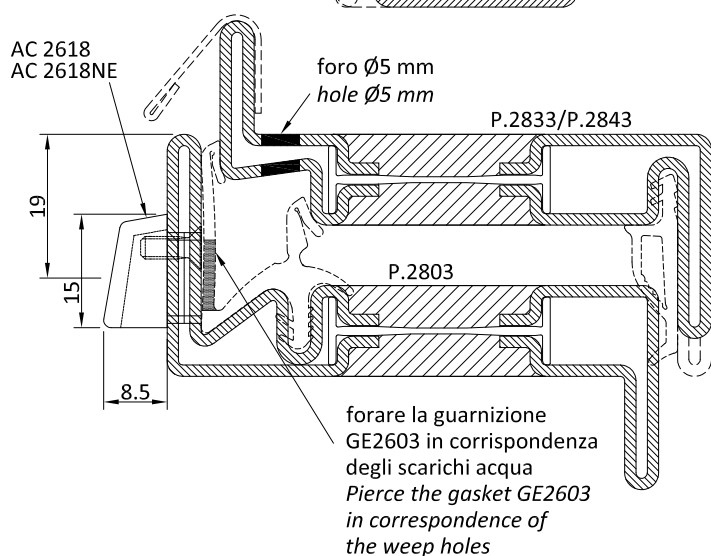
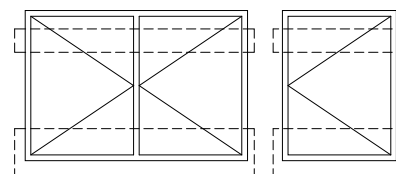
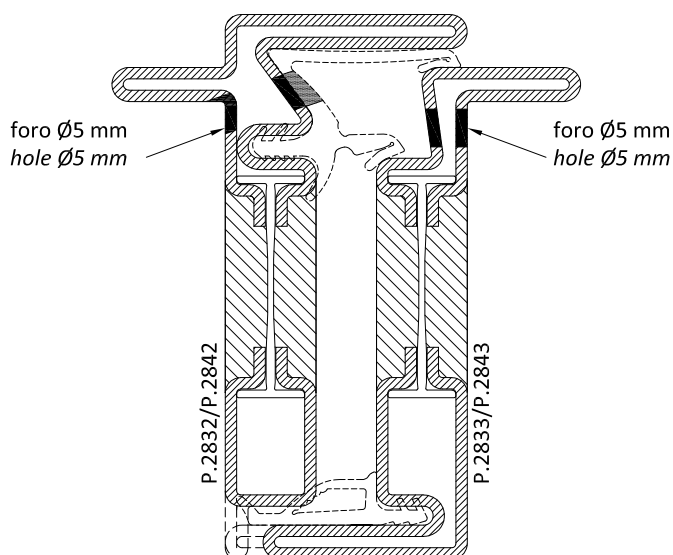


Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura
 Note: the fitting are provided larger by trimming after welding

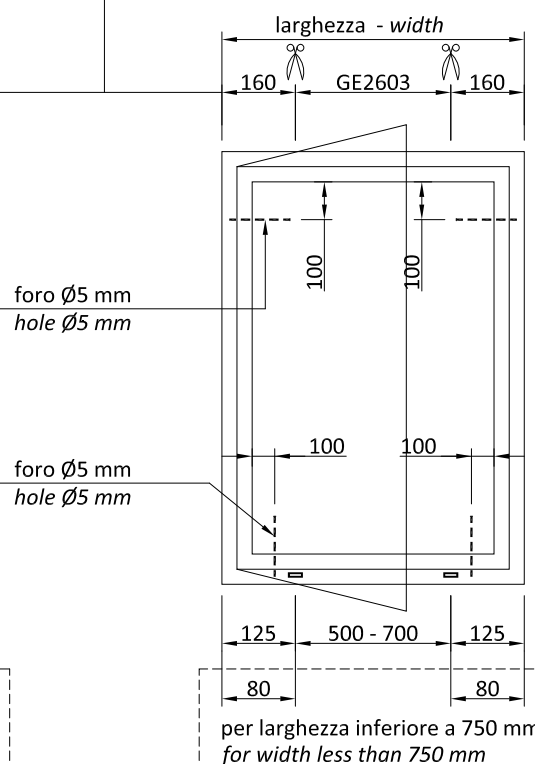
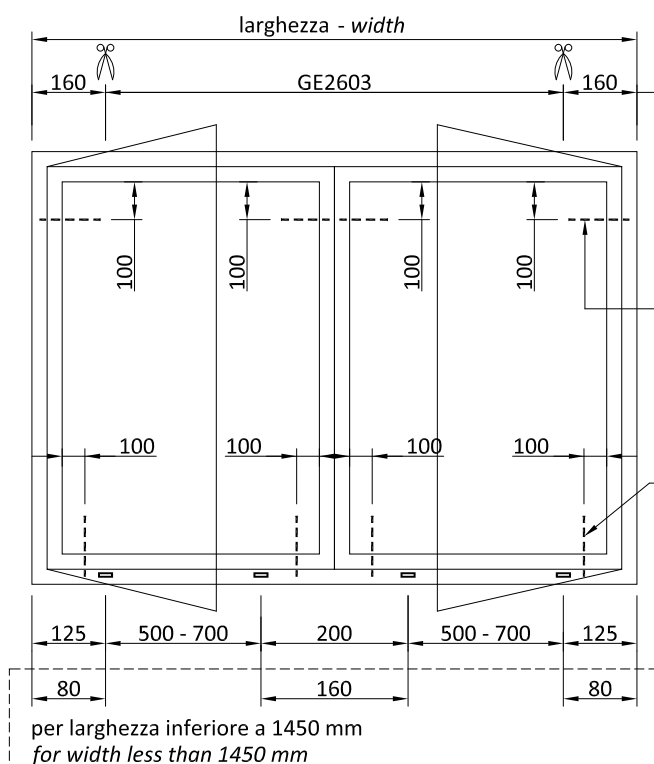


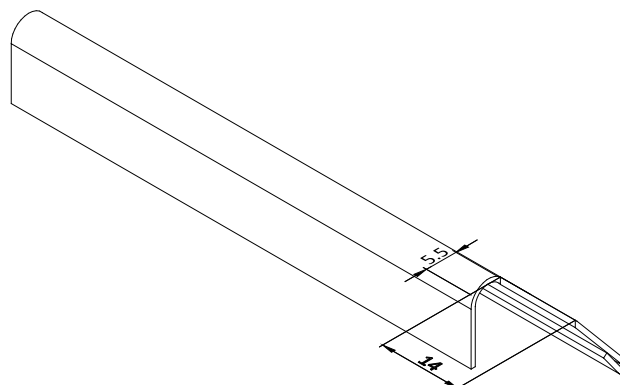
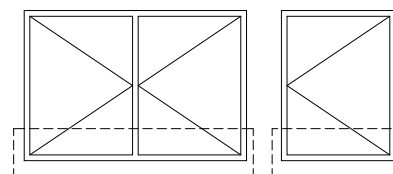
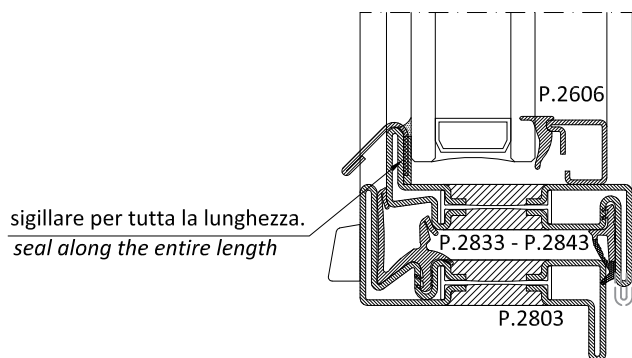
Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura
Note: the fitting are provided larger by trimming after welding



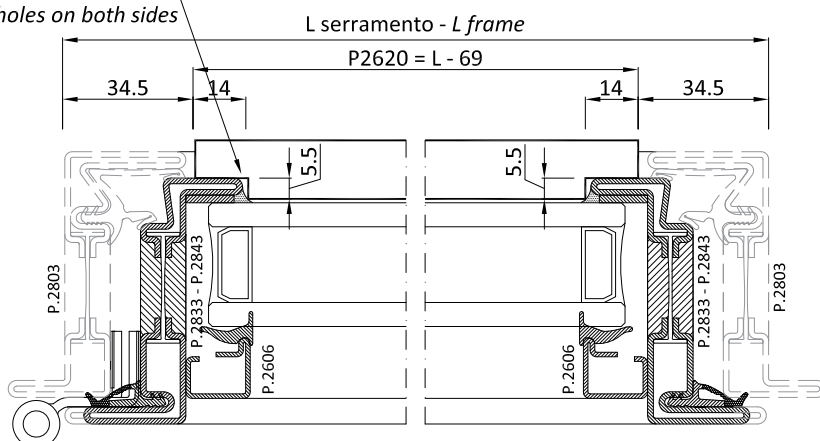


Tagliare la guarnizione per 20 mm | Cut the gasket to 20 mm

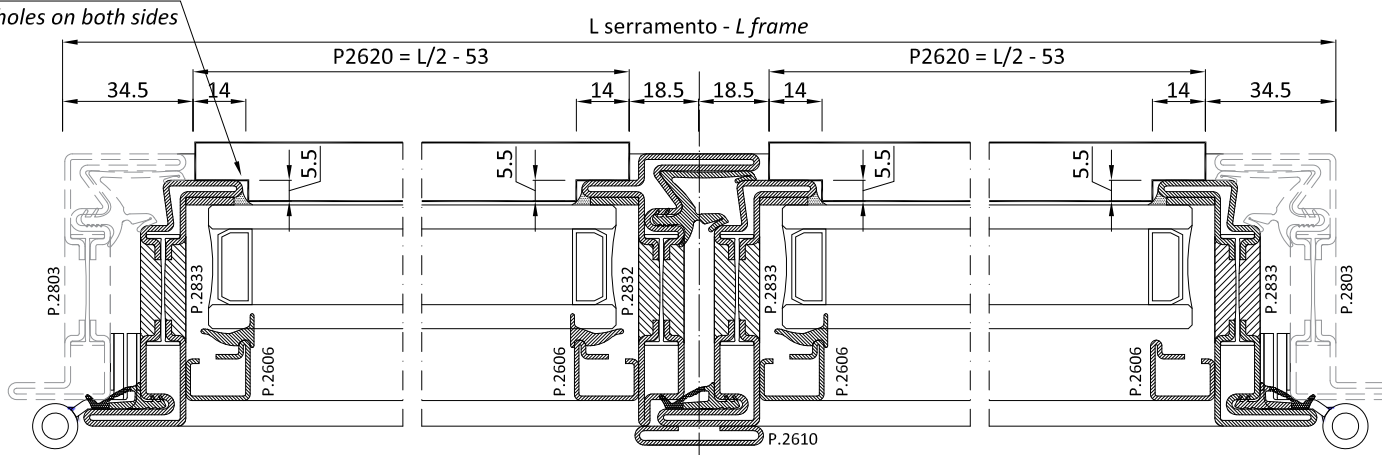




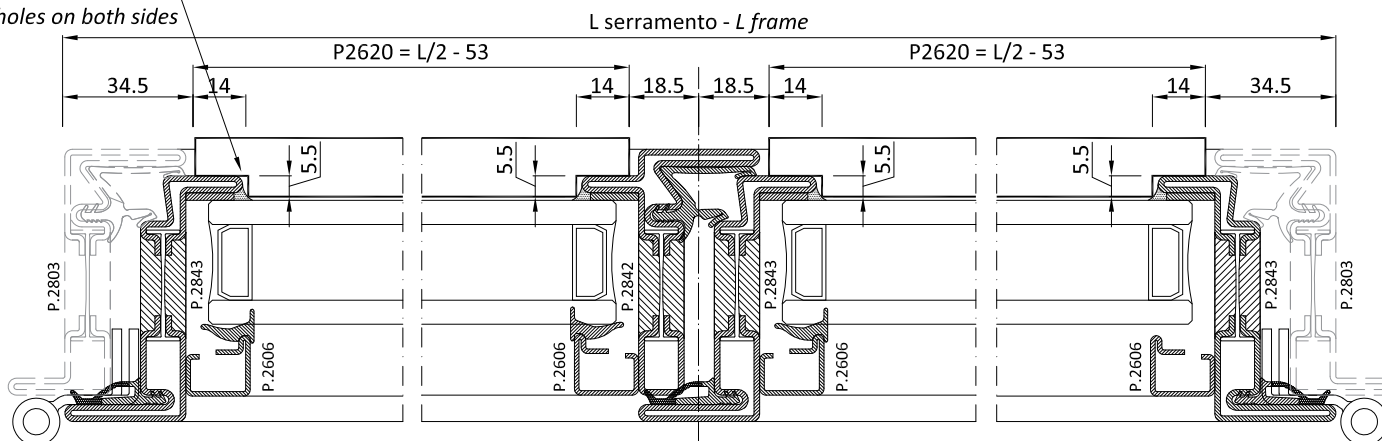
spacco ambo i lati
holes on both sides

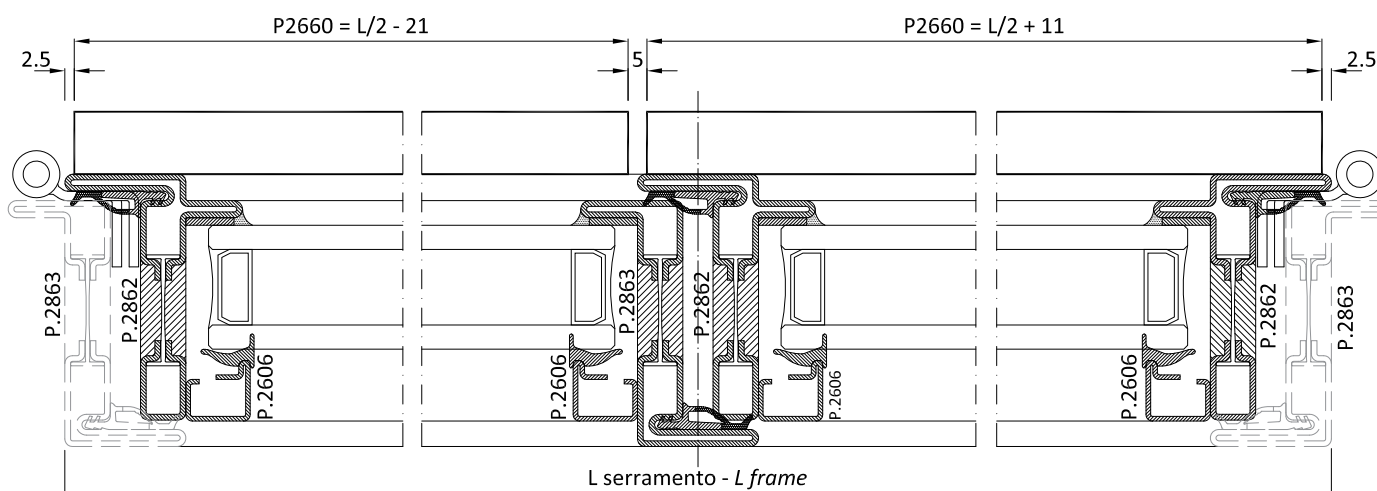
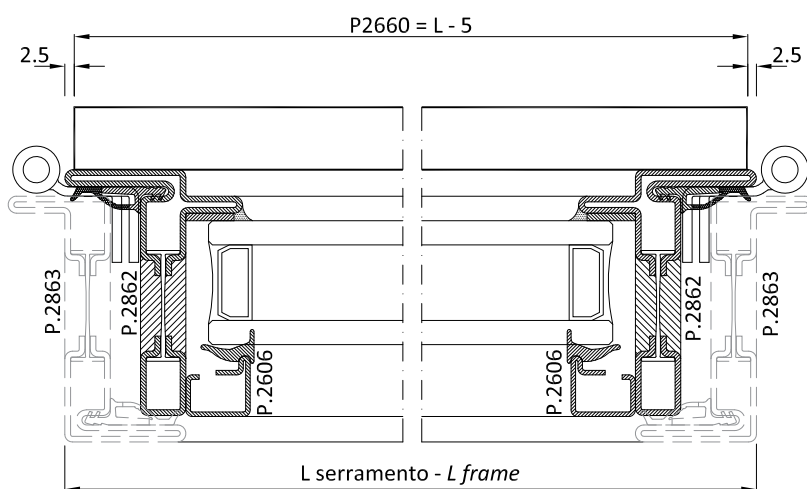
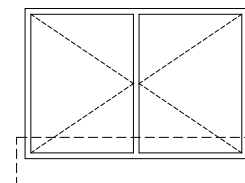
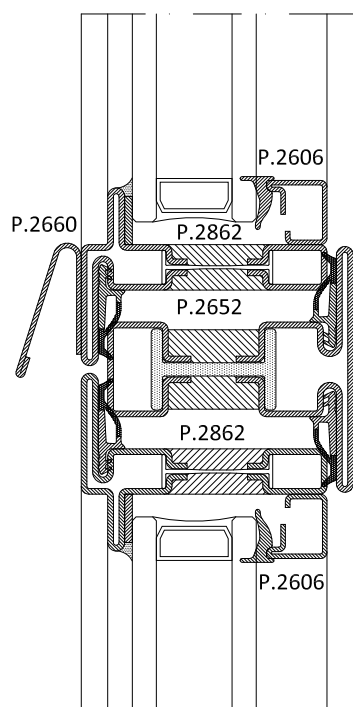


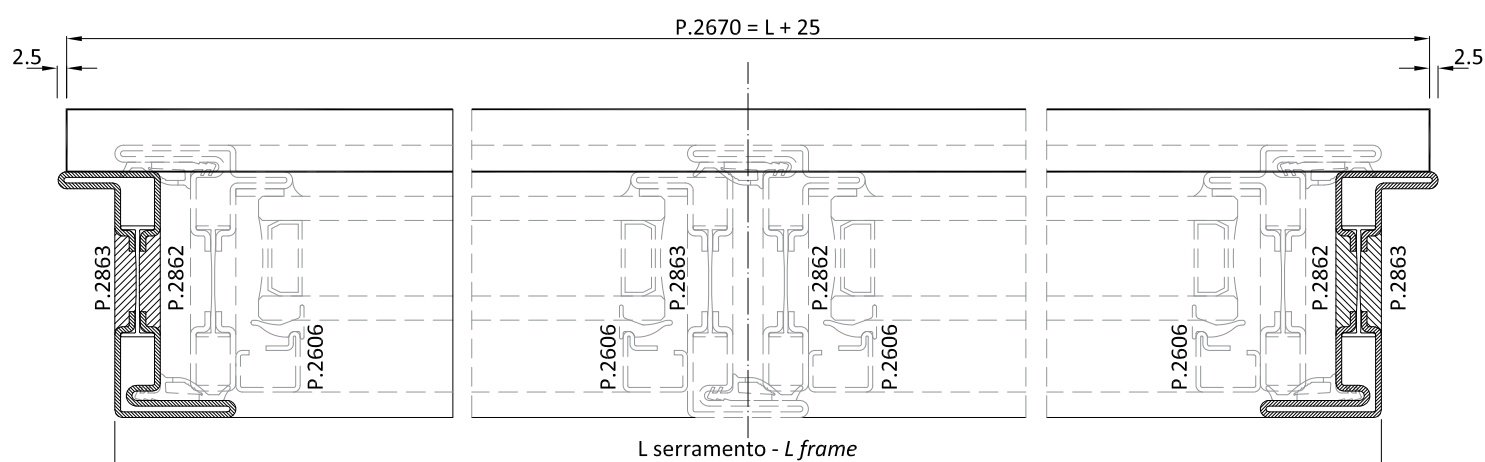
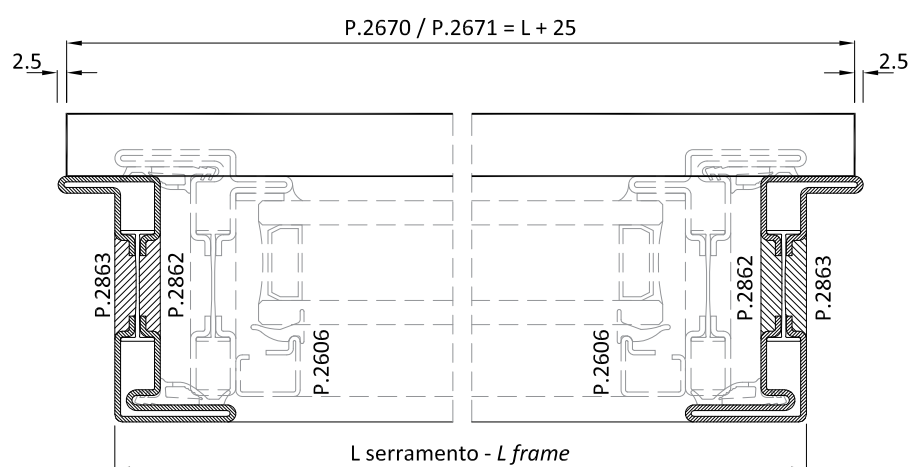
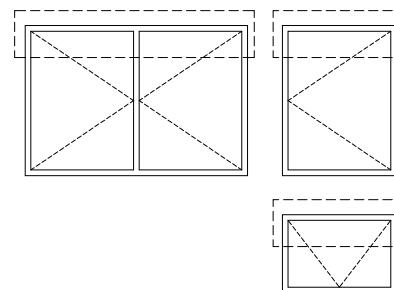
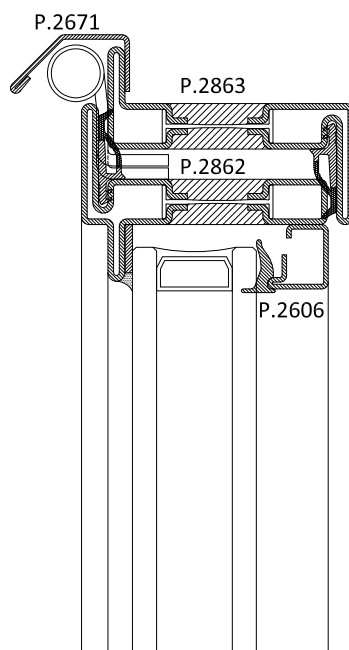
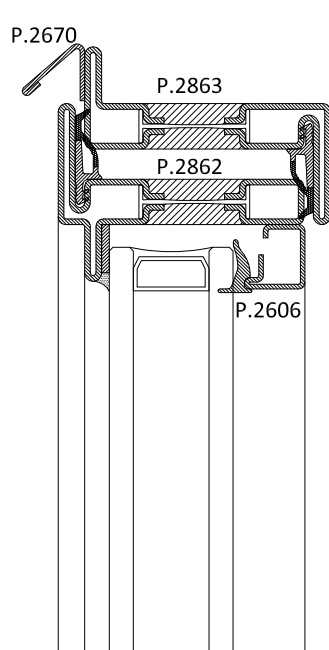
spacco ambo i lati
holes on both sides

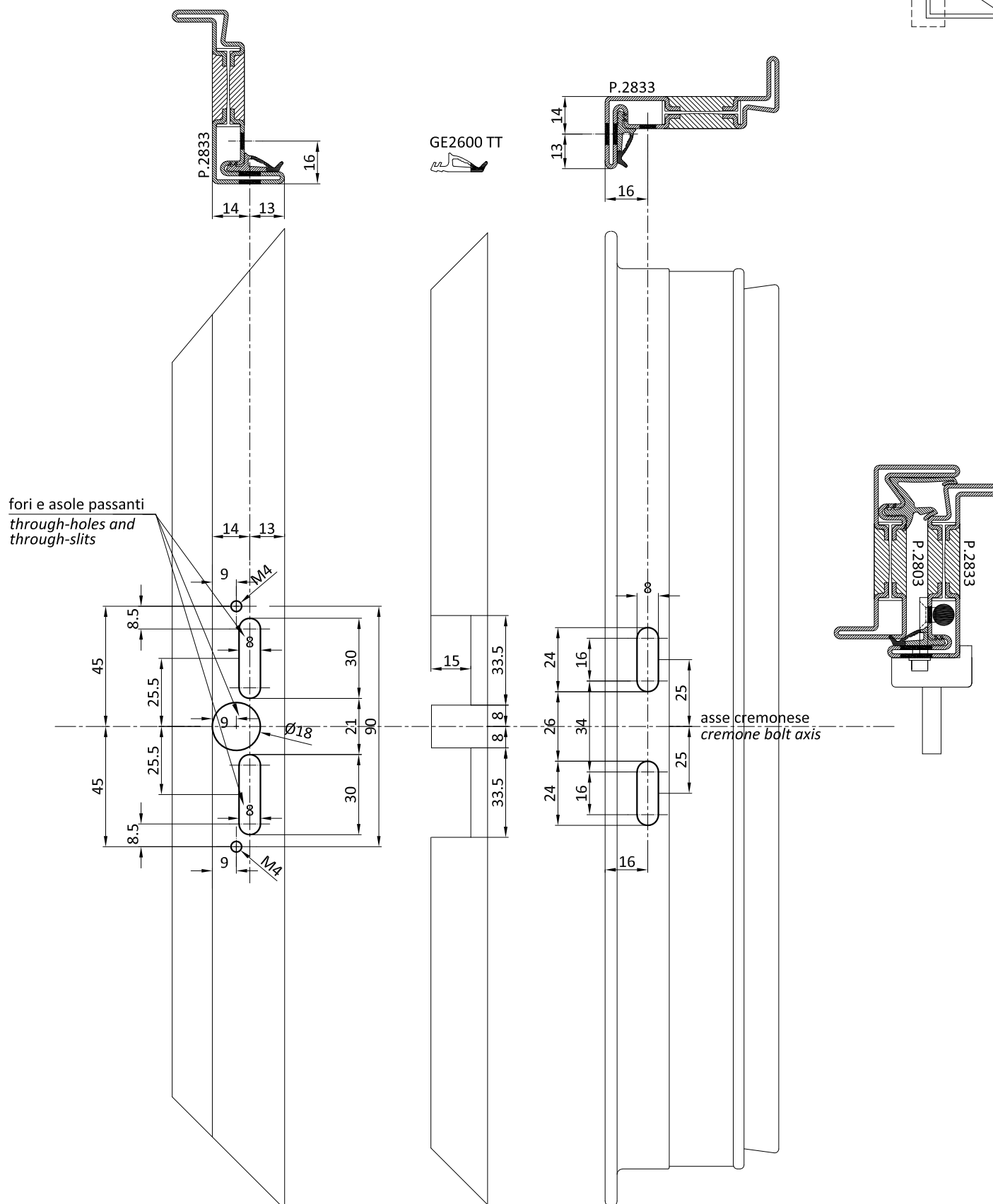


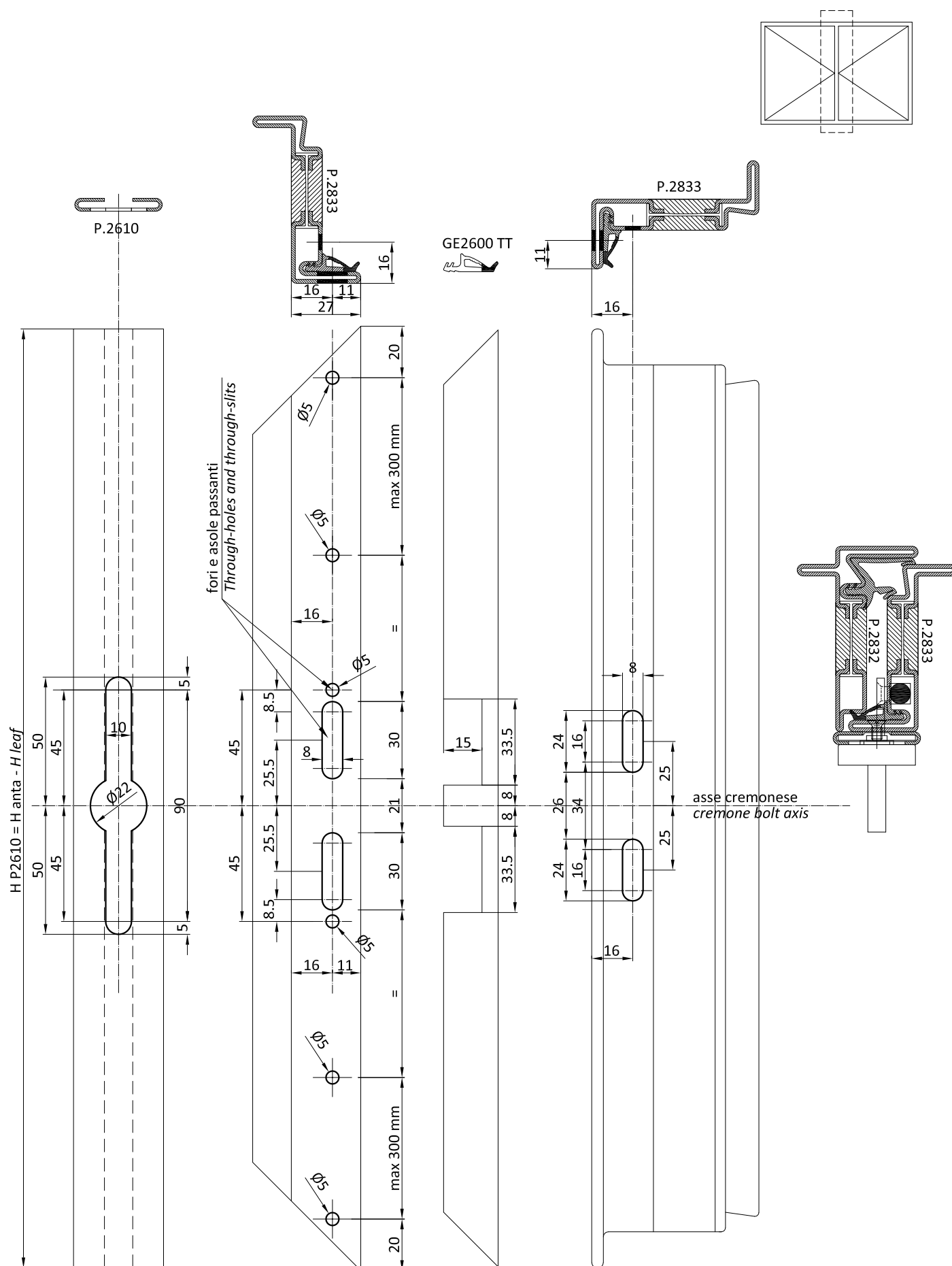
spacco ambo i lati
holes on both sides

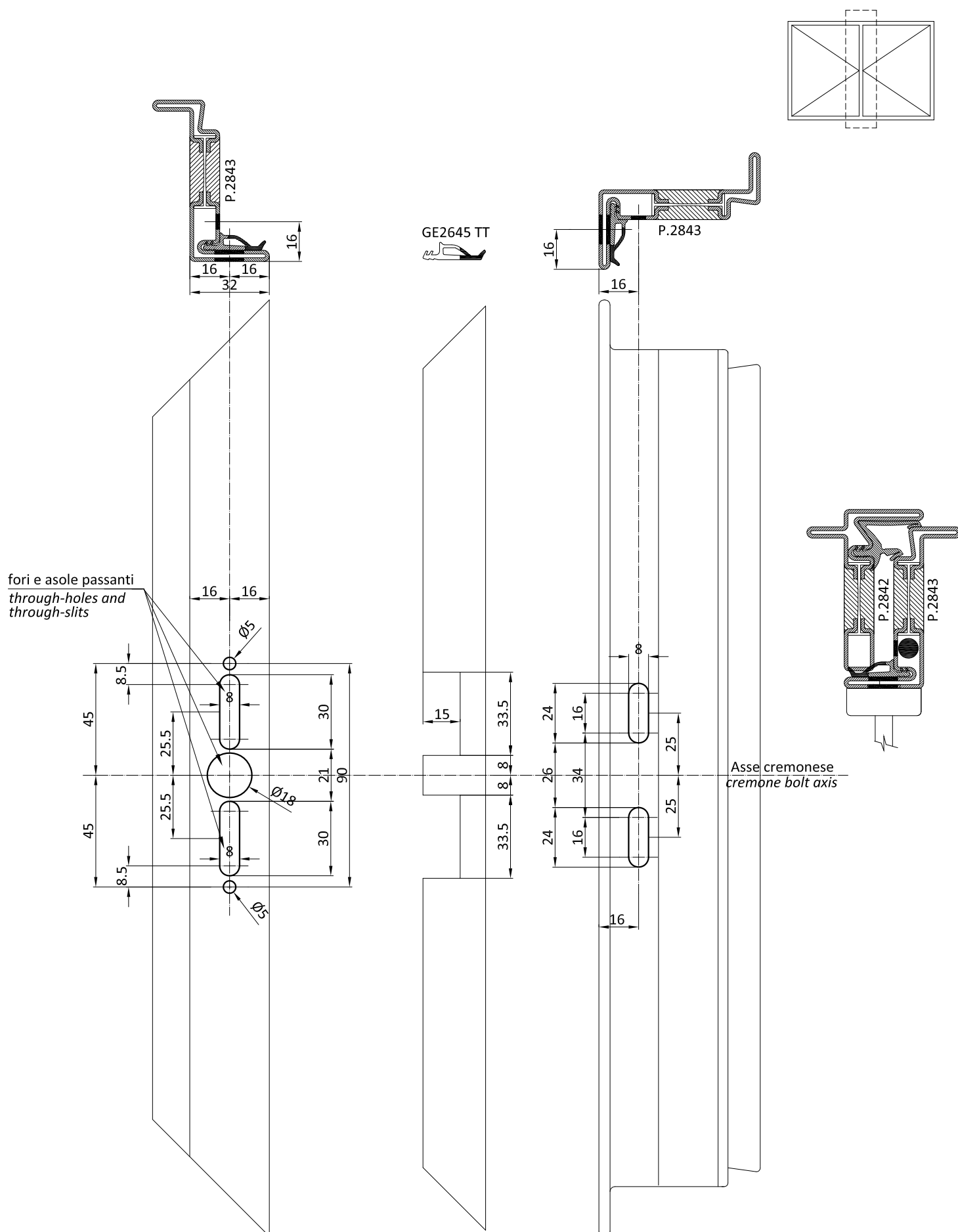


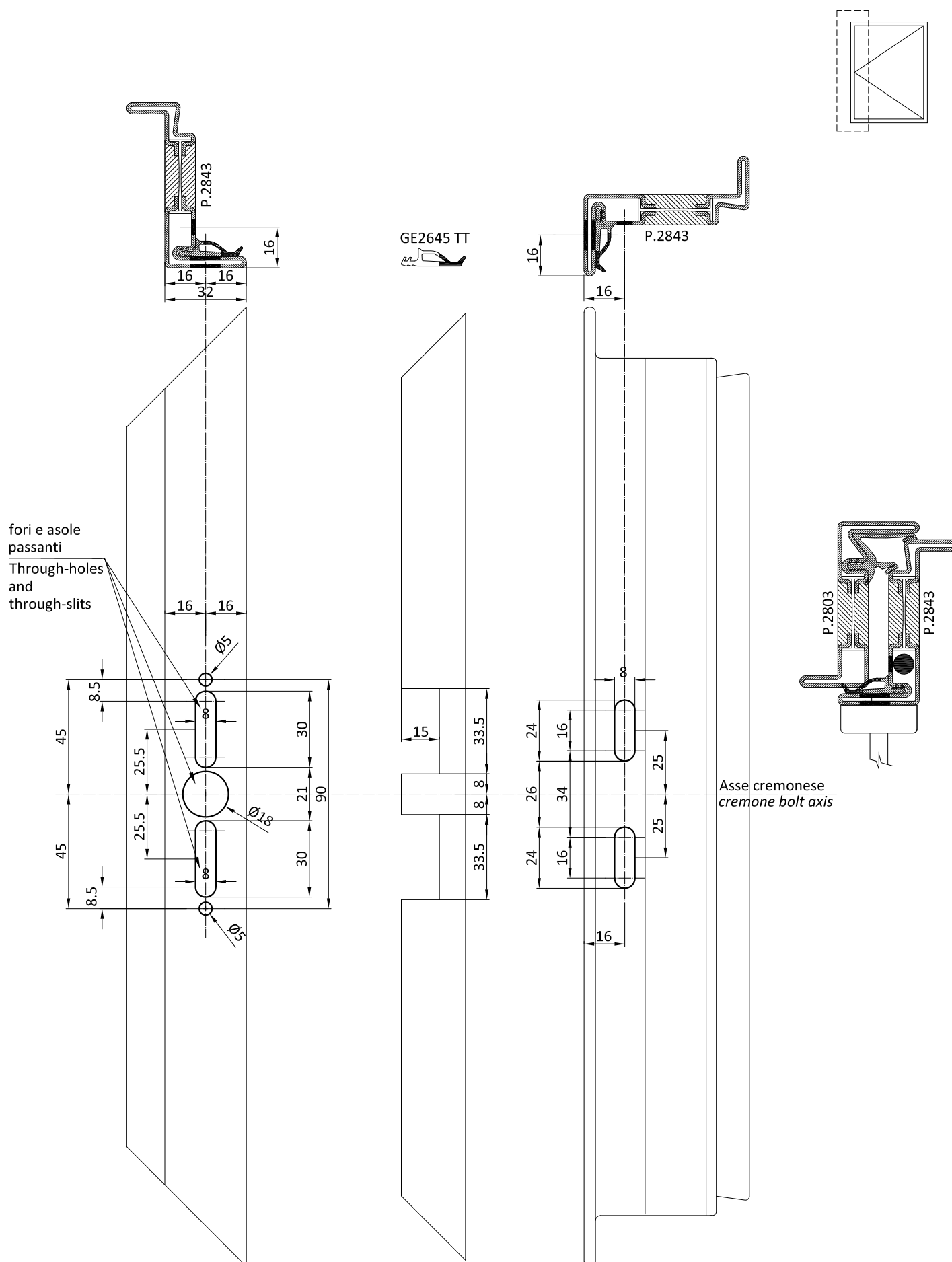


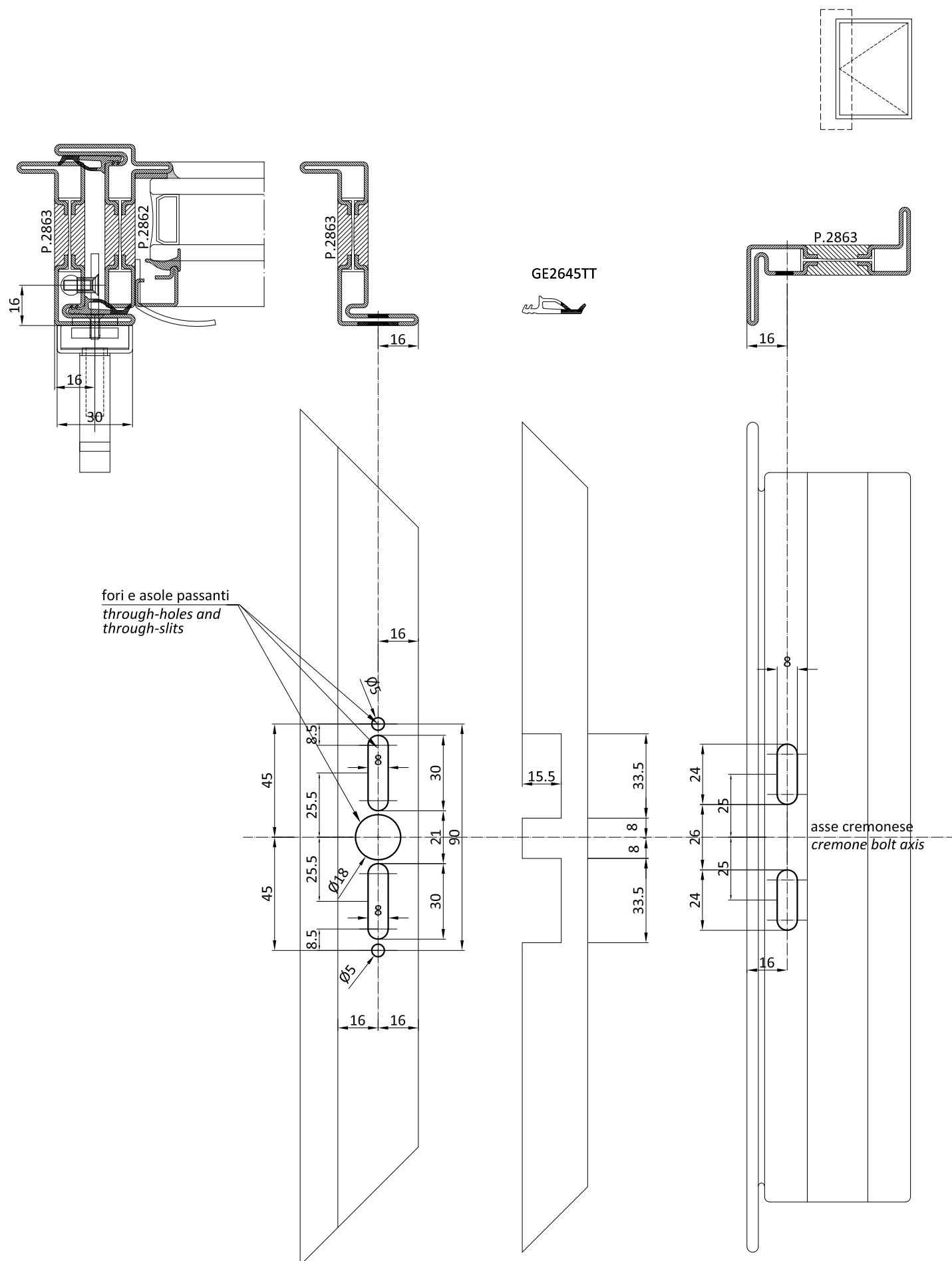


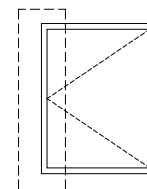




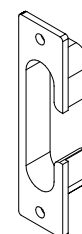
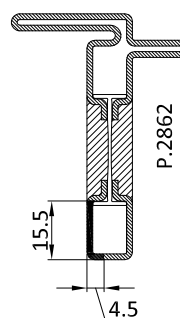
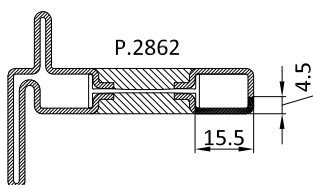
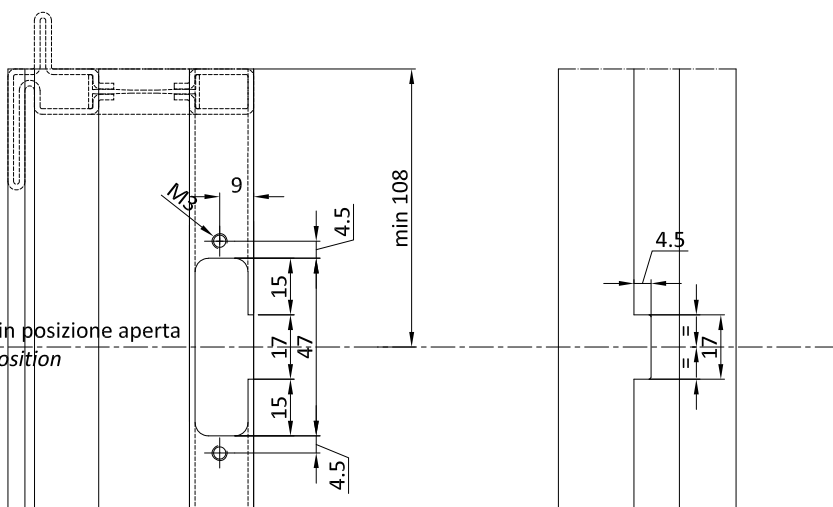






lavorazione applicazione incontro
Processing for strike plate installation

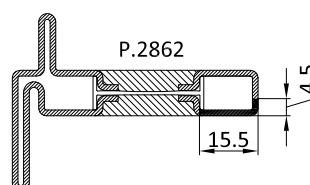
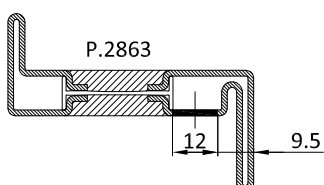
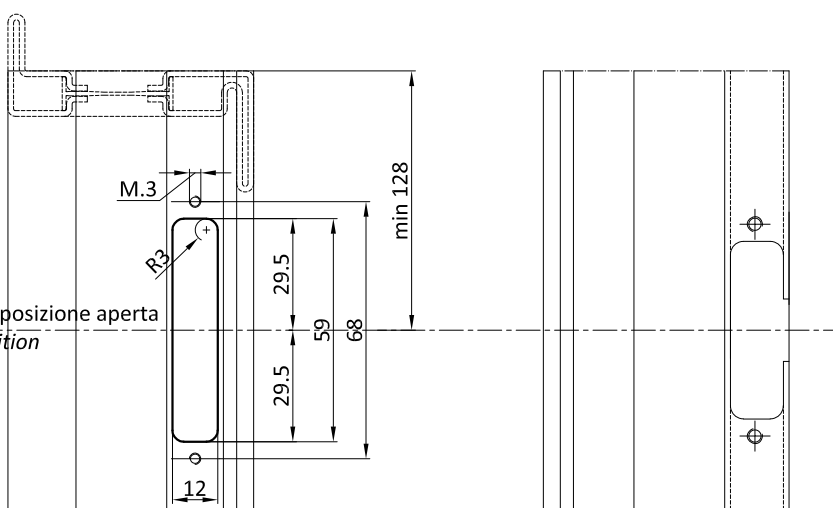
asse nottolino 3^a chiusura in posizione aperta
3rd plug axis in open leaf position

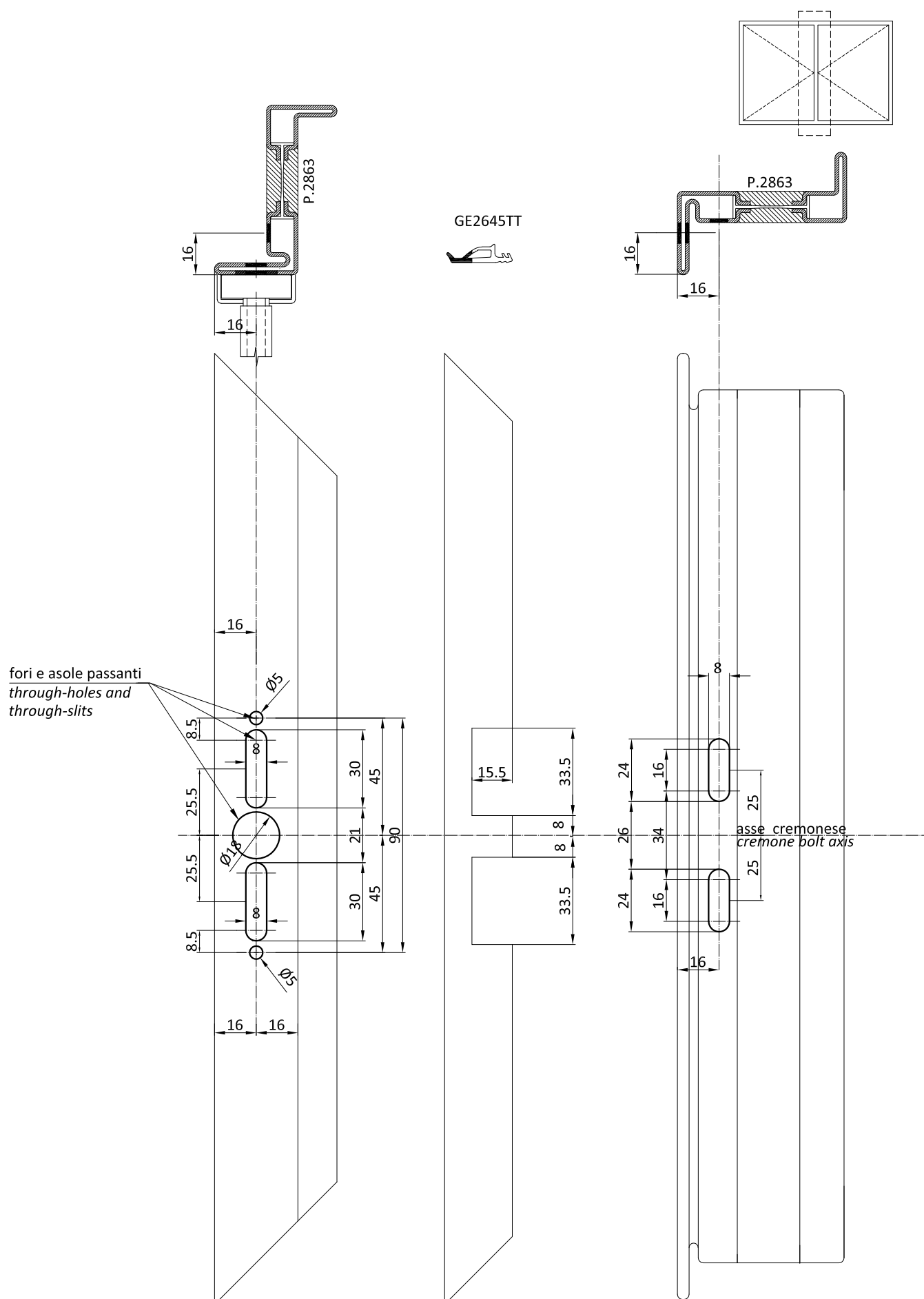


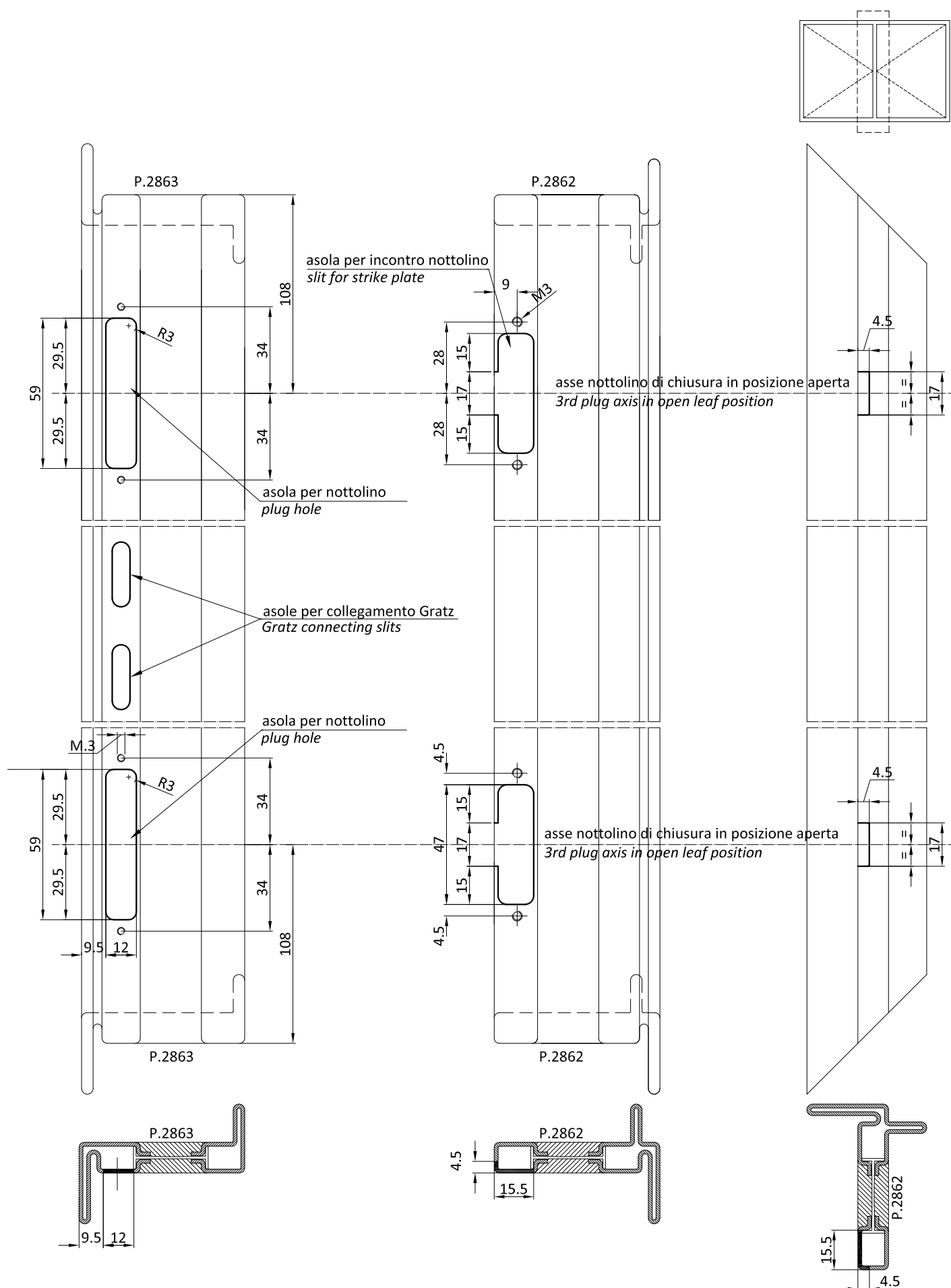
Incontro 3^a chiusura
3rd lock strike plate

lavorazione applicazione nottolino
Processing for plug installation

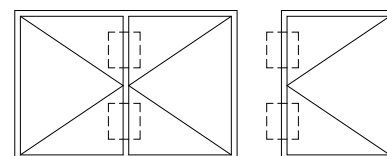
asse nottolino 3^a chiusura in posizione aperta
3rd plug axis in open leaf position



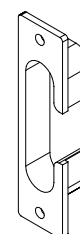
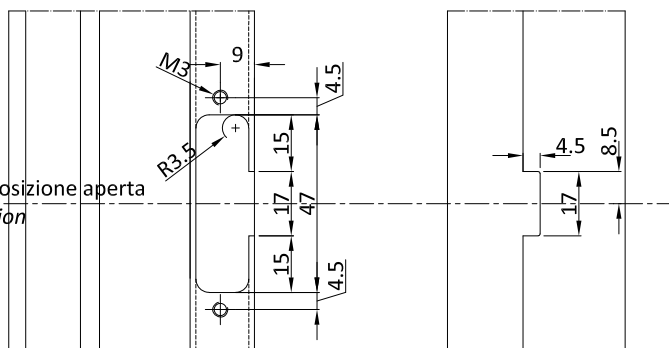




lavorazione applicazione incontro
Processing for the installation of the strike plate



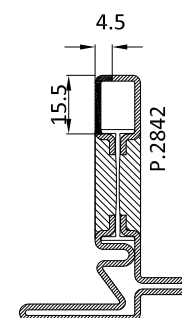
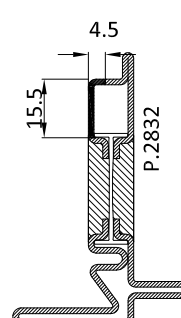
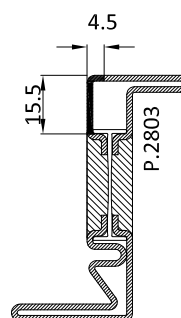
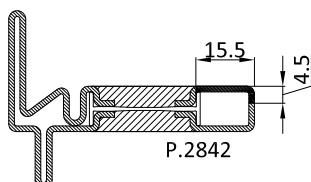
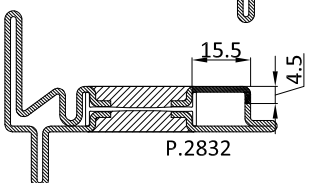
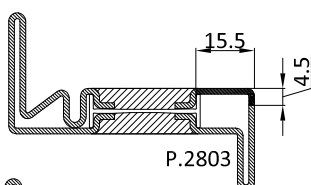
asse nottolino 3^a chiusura in posizione aperta
3rd plug axis in open leaf position



Incontro 3^a chiusura
3rd lock strike plate

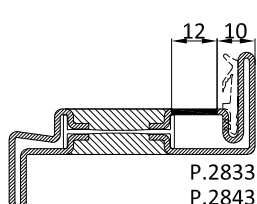
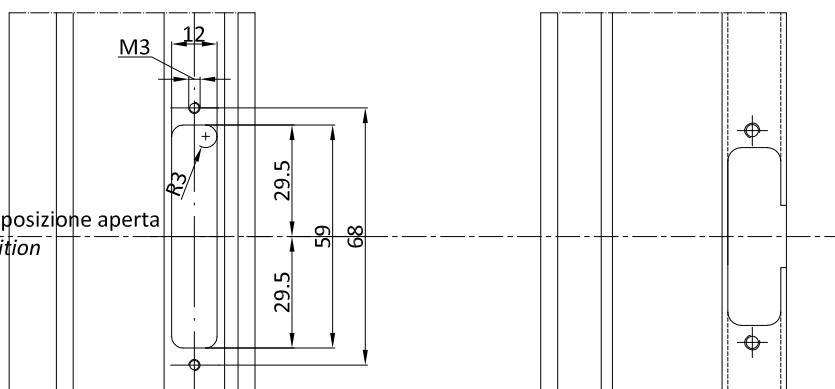
N.B.: Distanza massima tra i punti
di chiusura 1000 mm

N.B.: Distance between the closing
points max. 1000 mm

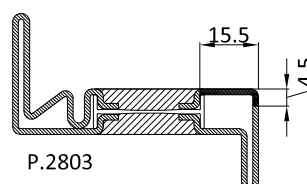


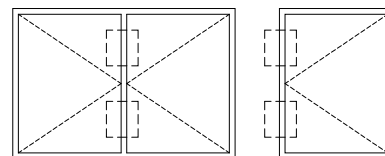
lavorazione applicazione nottolino
Processing for plug installation

asse nottolino 3^a chiusura in posizione aperta
3rd plug axis in open leaf position



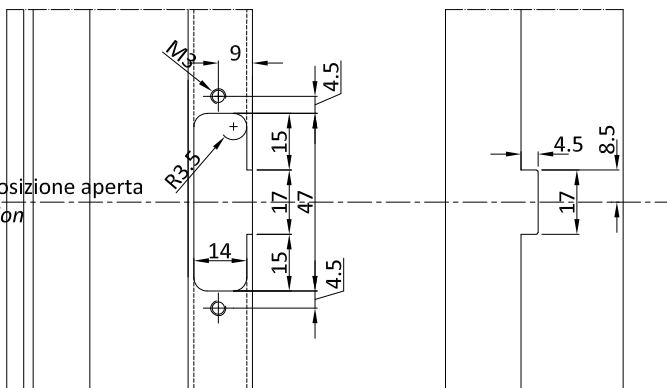
tagliare la
guarnizione
dove interseca
la chiusura
cut the gasket
in correspondence
of closure





lavorazione applicazione incontro
Processing for the installation of the strike plate

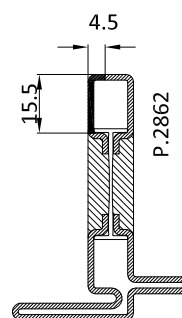
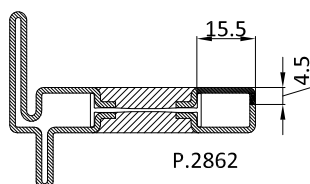
asse nottolino 3^a chiusura in posizione aperta
3rd plug axis in open leaf position



Incontro 3^a chiusura
3rd lock strike plate

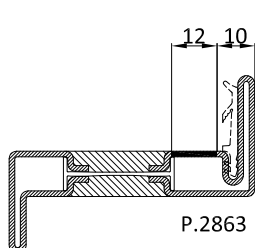
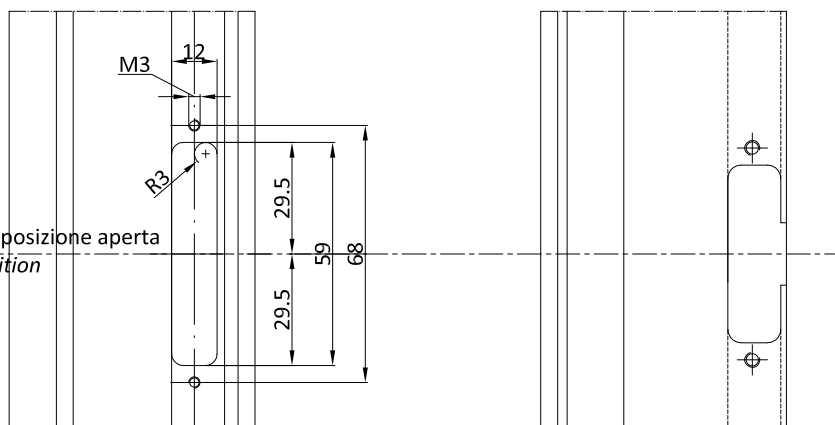
N.B.: Distanza massima tra i punti
di chiusura 1000 mm

N.B.: Distance between the closing
points max. 1000 mm

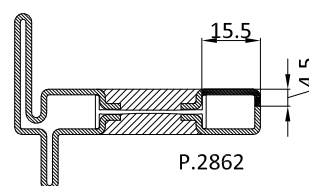


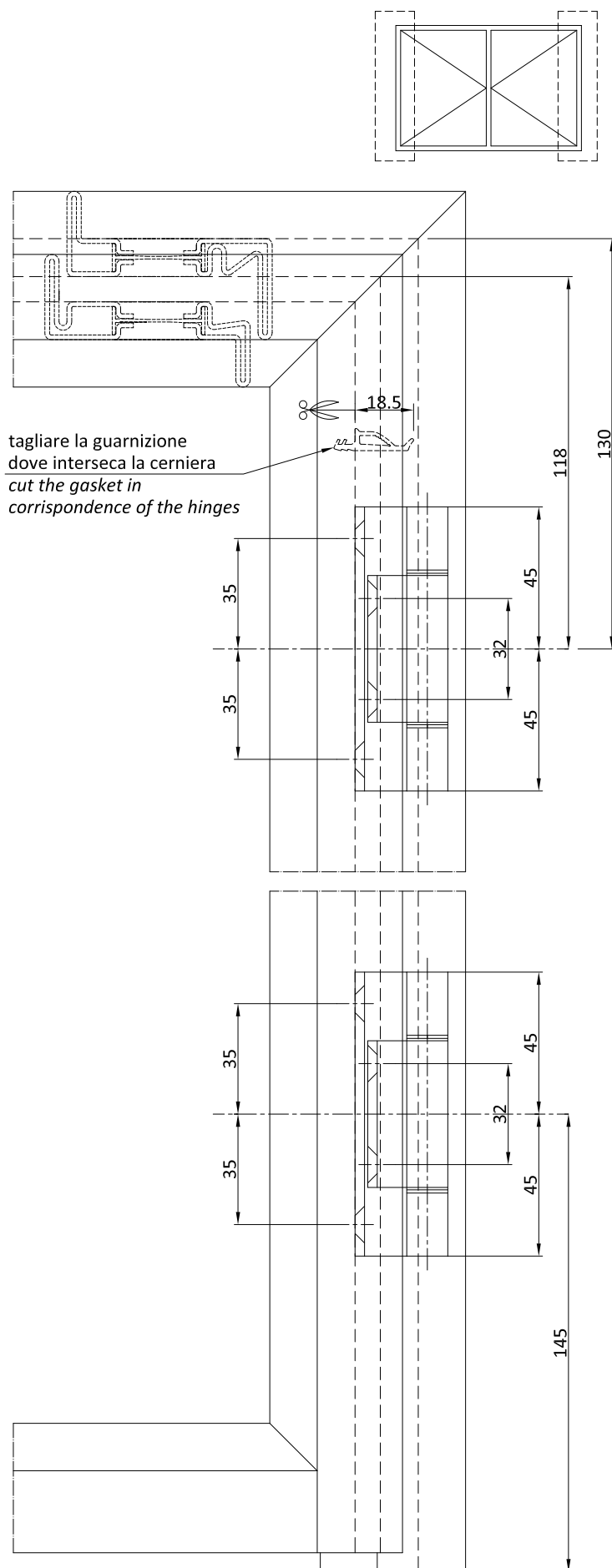
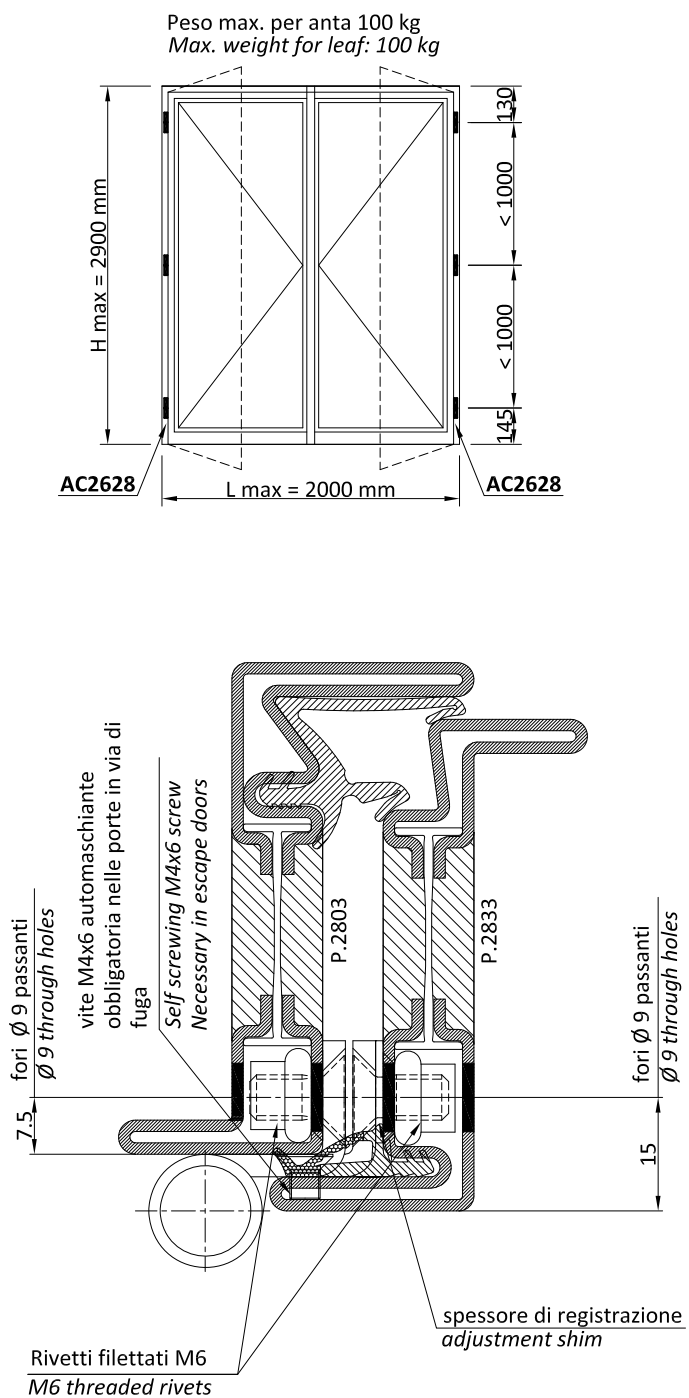
lavorazione applicazione nottolino
Processing for plug installation

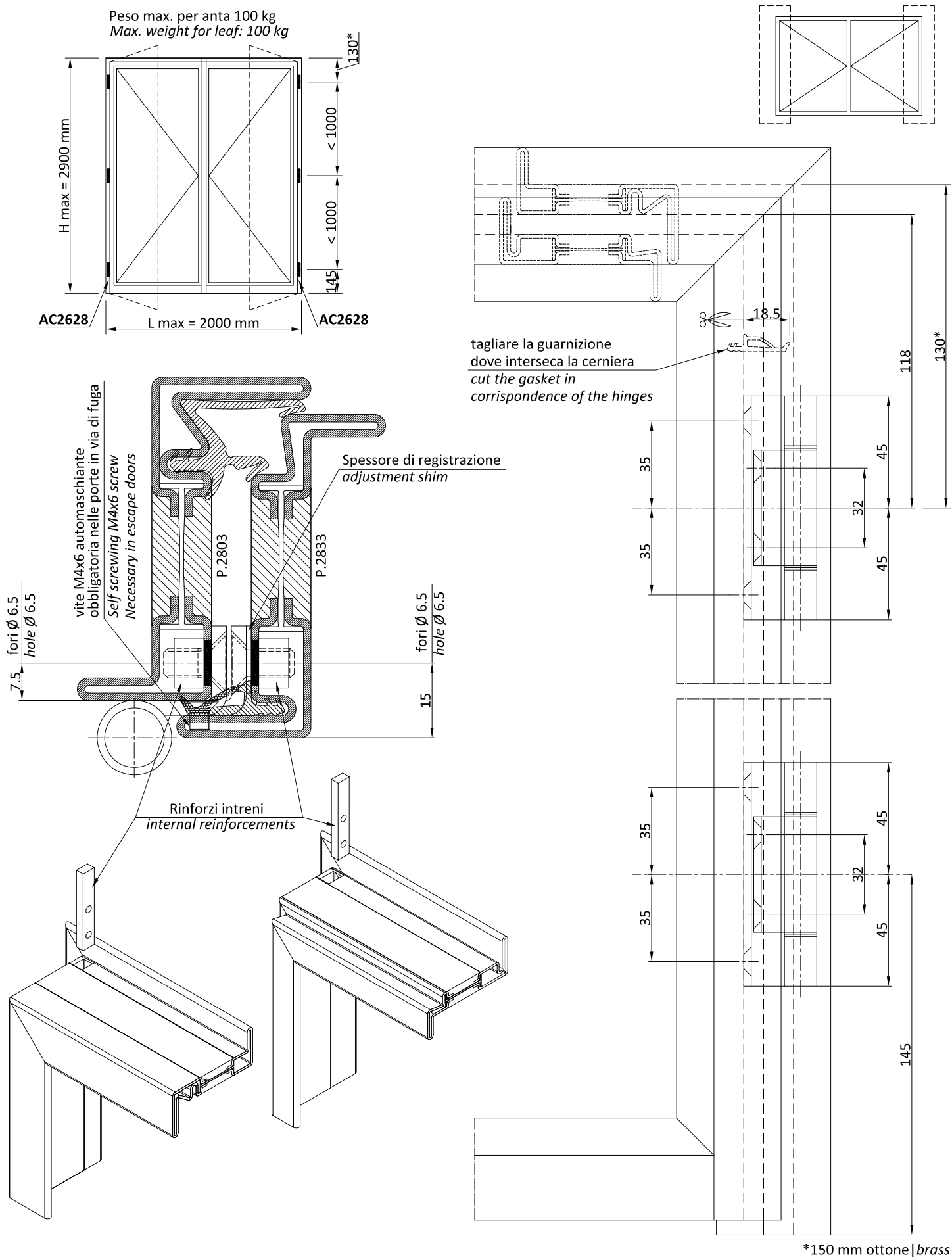
asse nottolino 3^a chiusura in posizione aperta
3rd plug axis in open leaf position

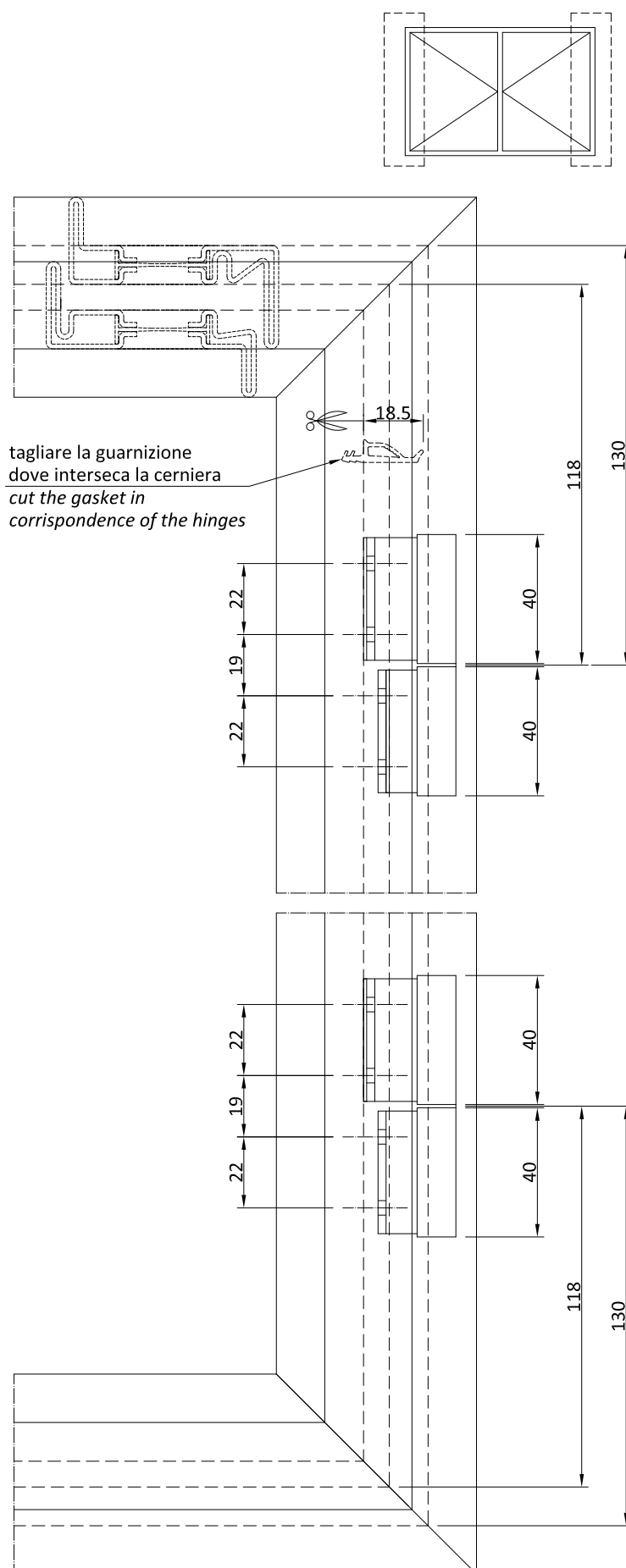
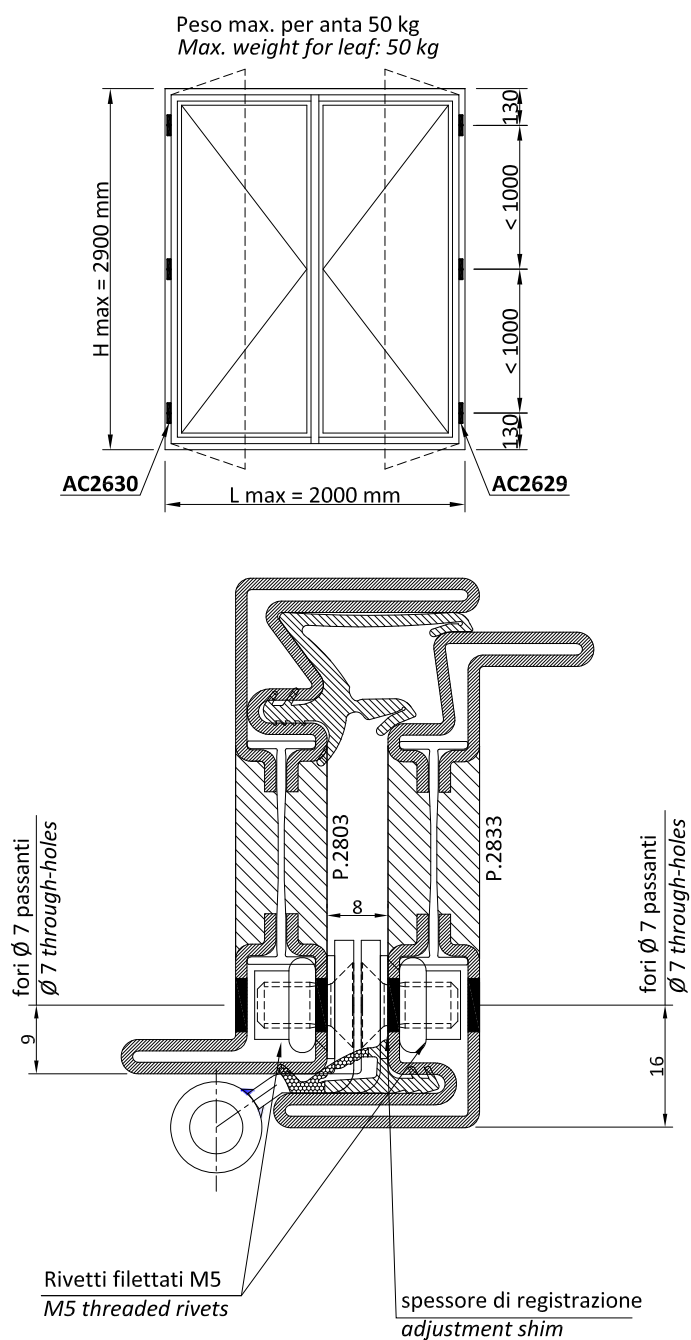


tagliare la
guarnizione
dove interseca
la chiusura
cut the gasket
in correspondence
of closure

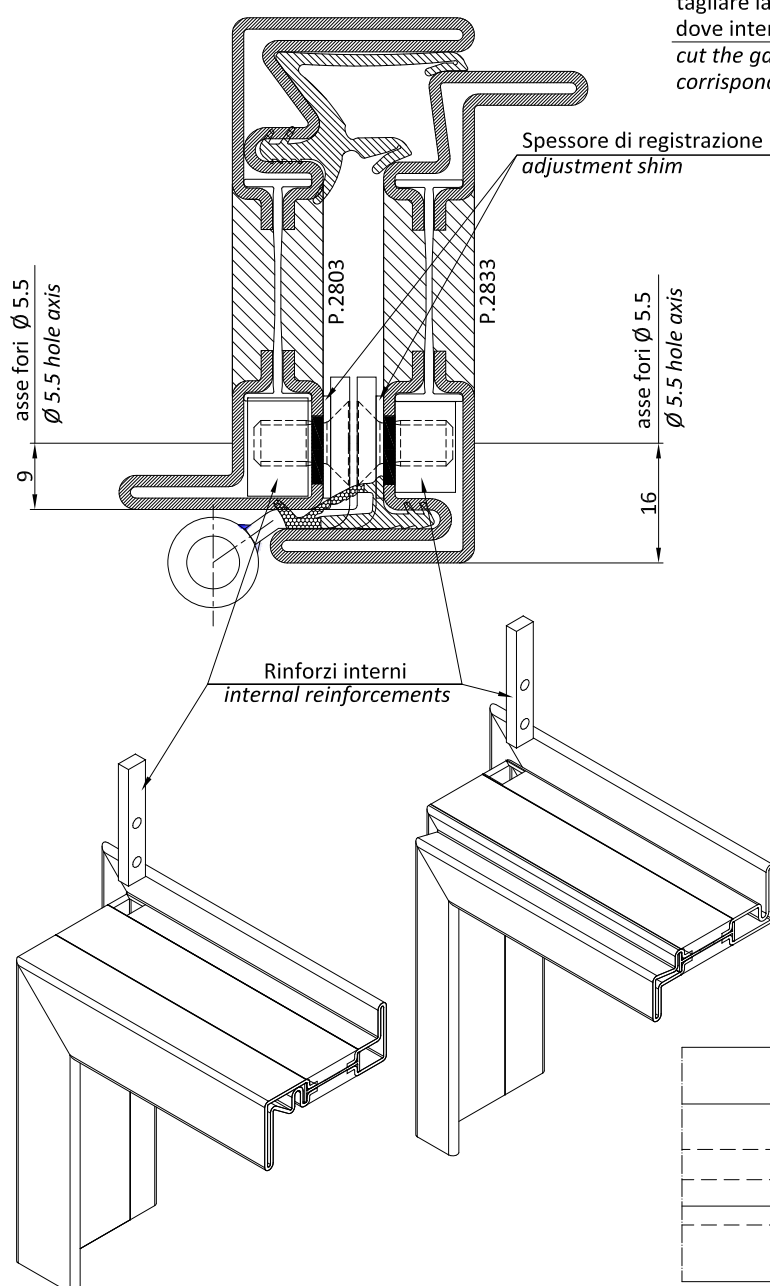
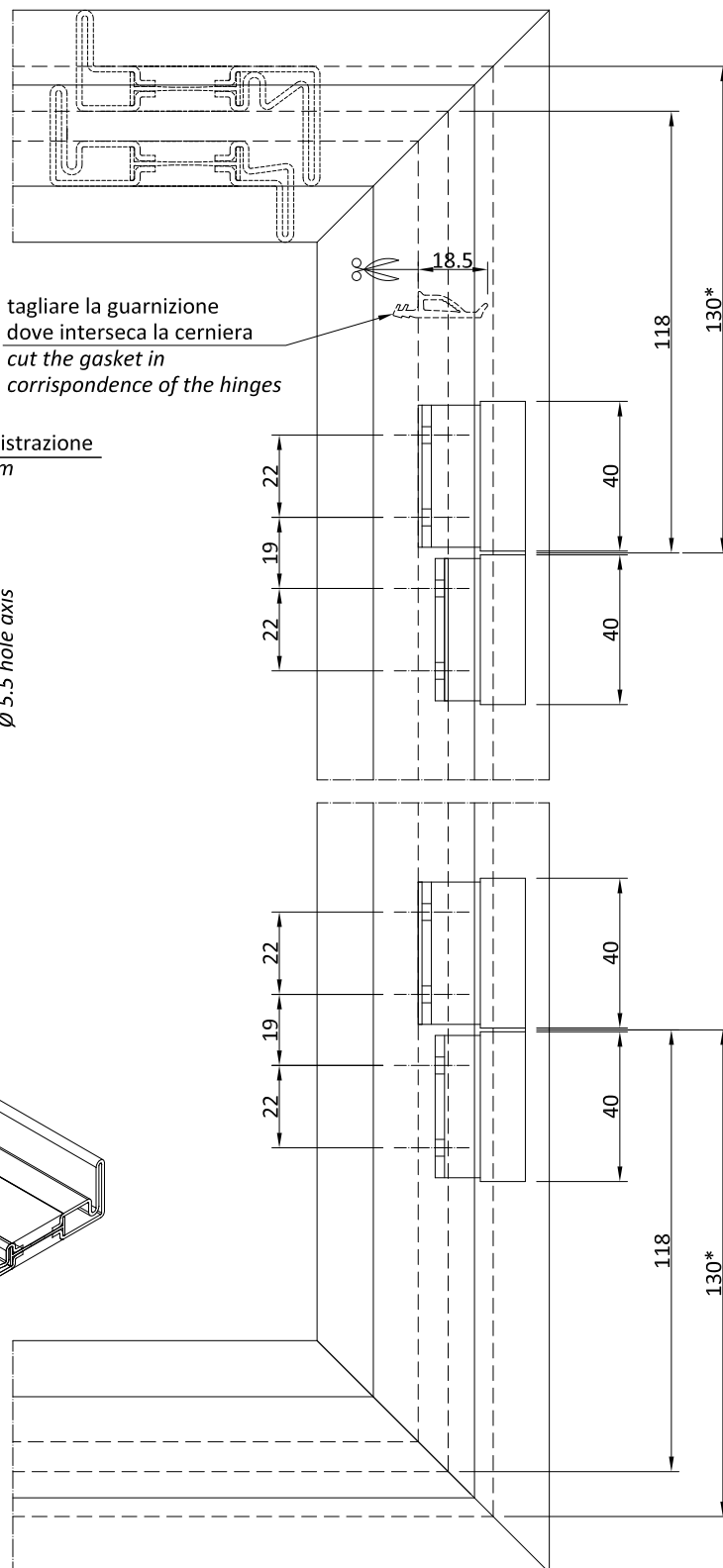
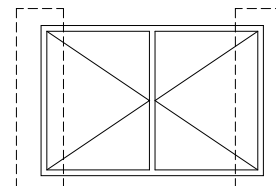
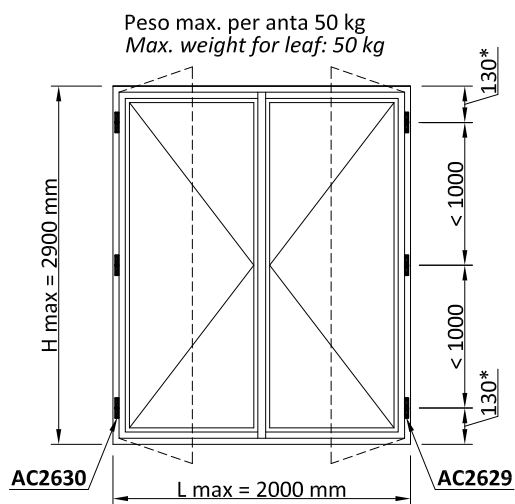






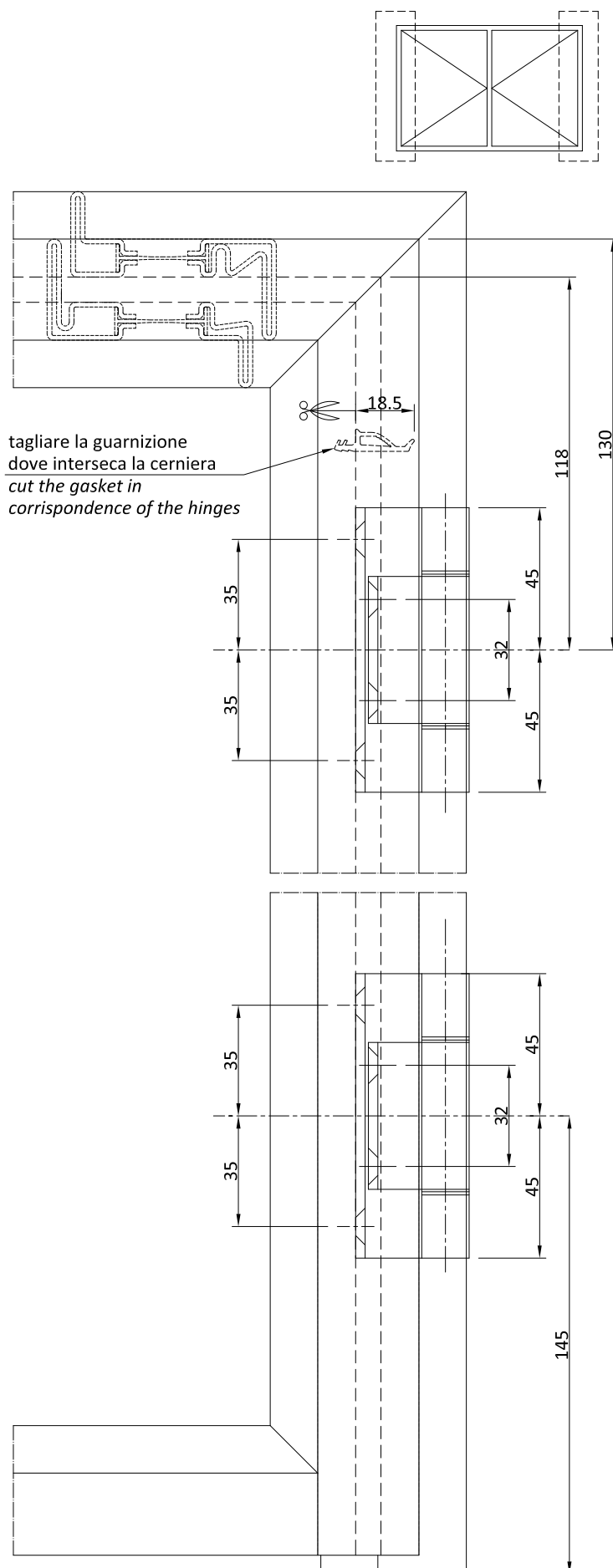
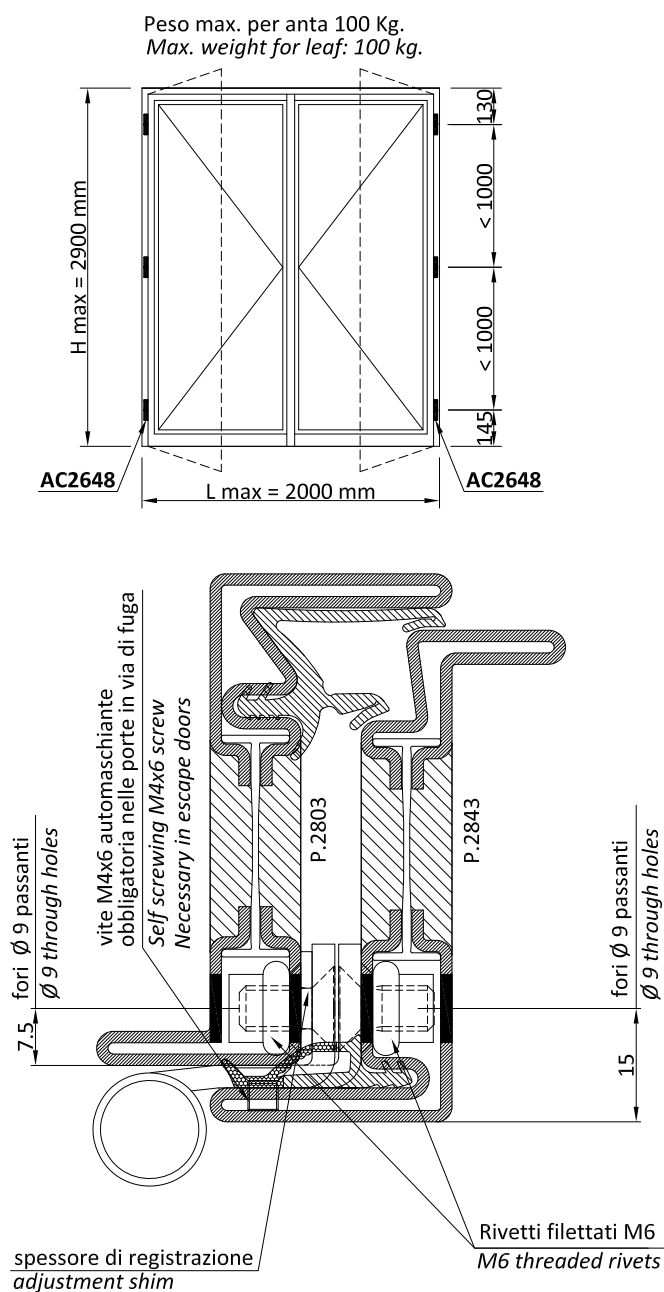


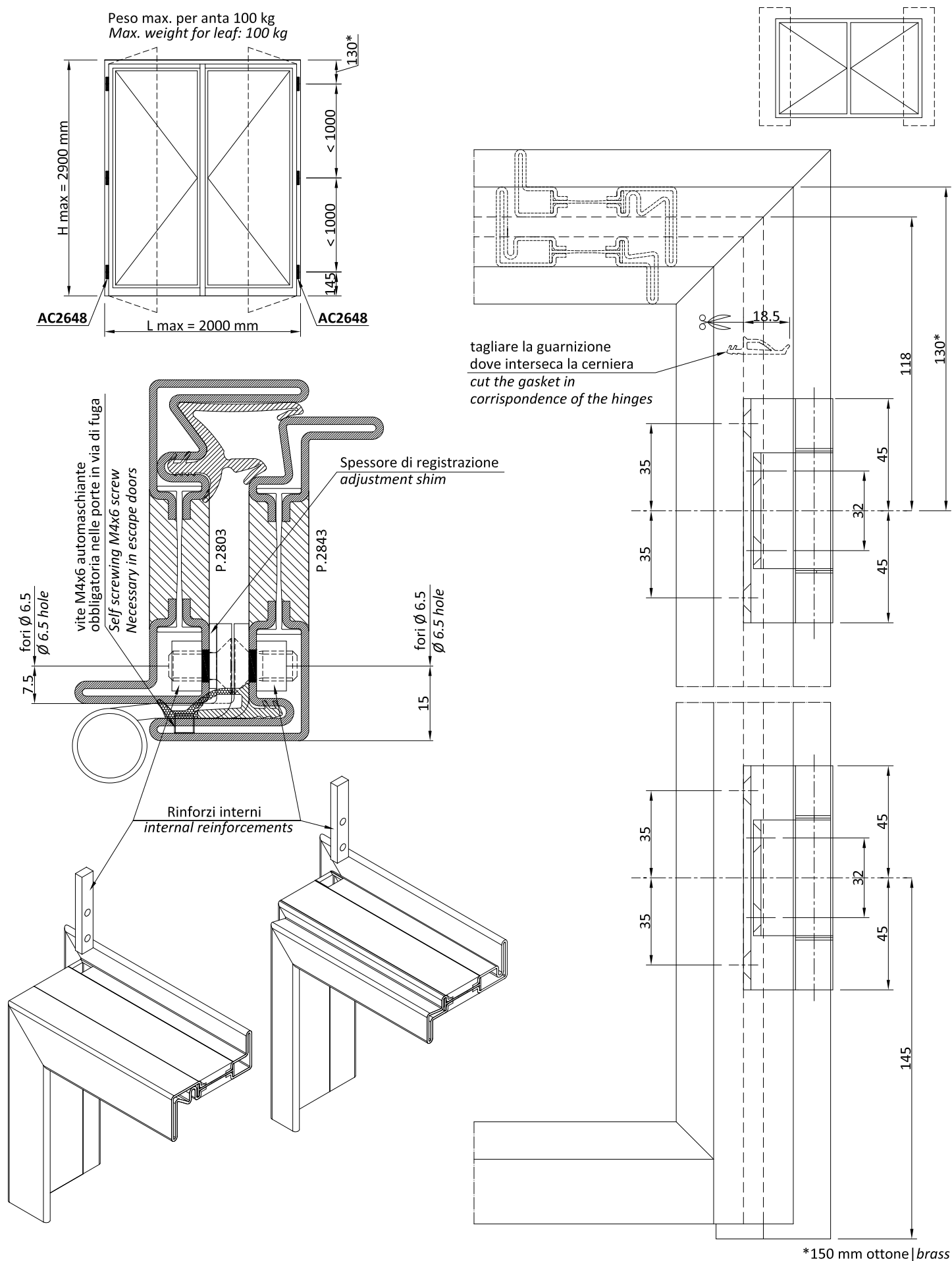
Per l'applicazione delle cerniere AC2629/AC2630 utilizzare maschera AT2629
For the installation of hinges AC2629/AC2630 please use the jig AT2629



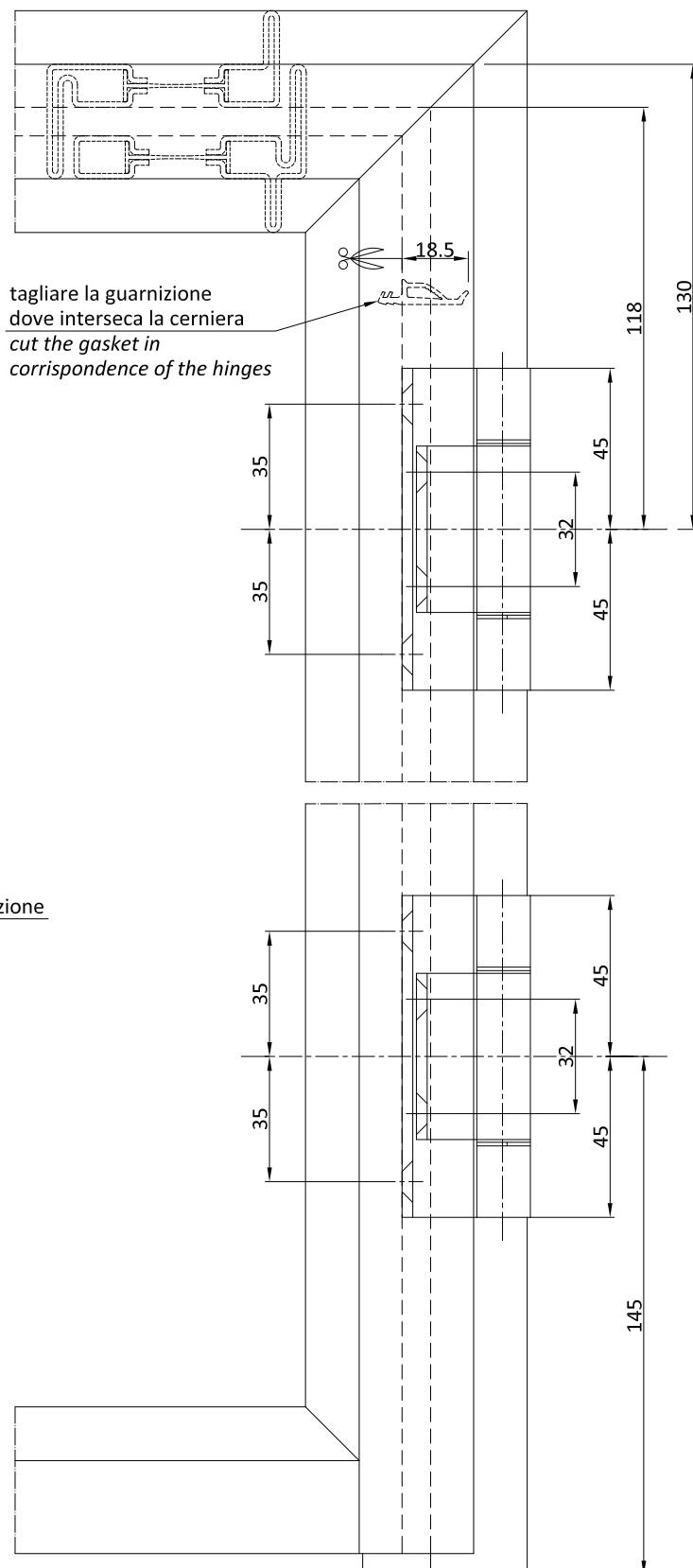
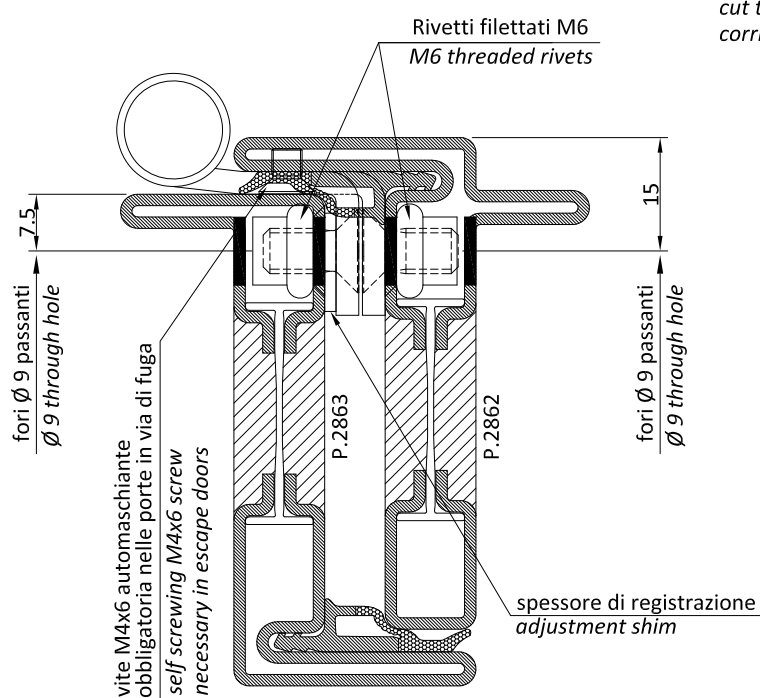
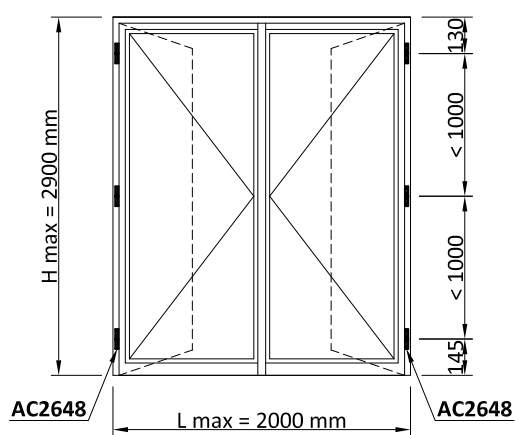
Per l'applicazione delle cerniere AC2629/AC2630 utilizzare maschera AT2629
For the installation of hinges AC2629/AC2630 please use the jig AT2629

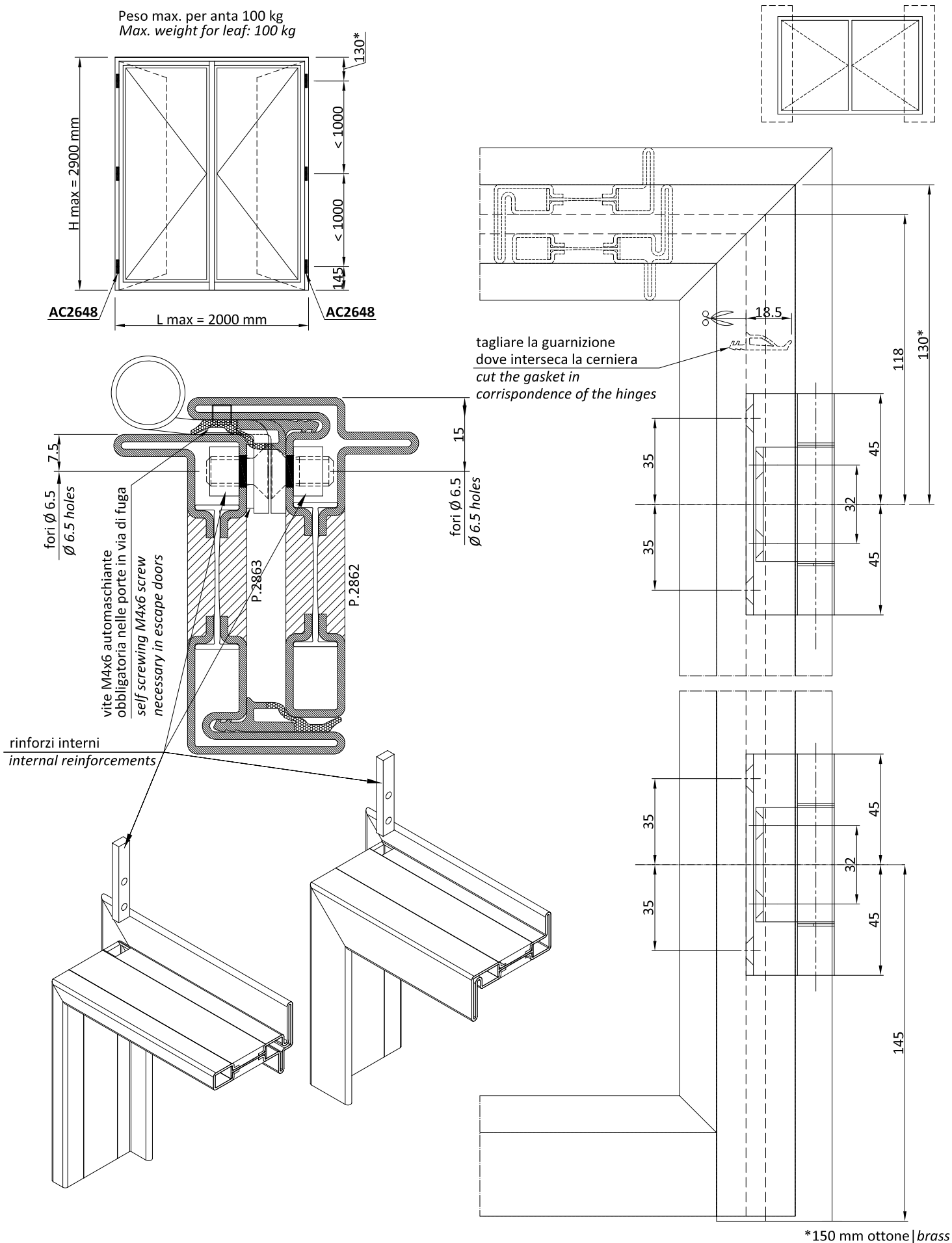
*150 mm ottone | brass

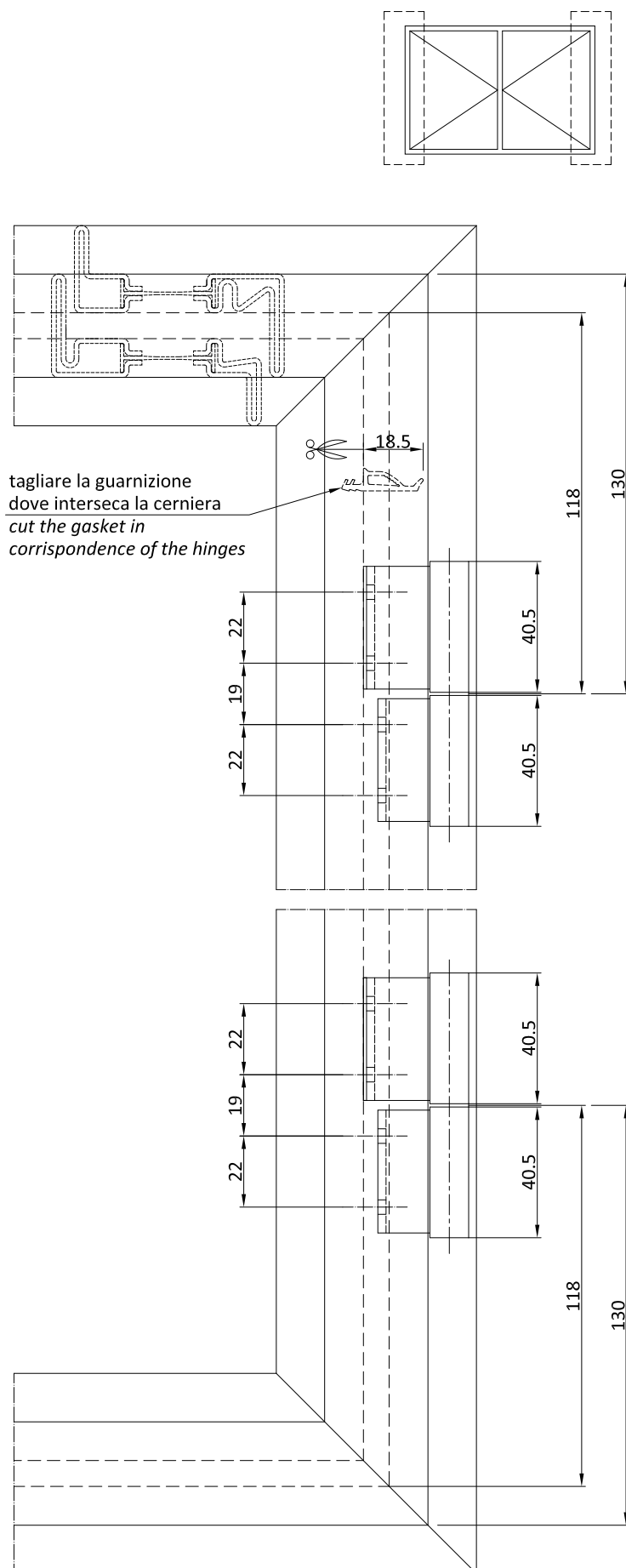
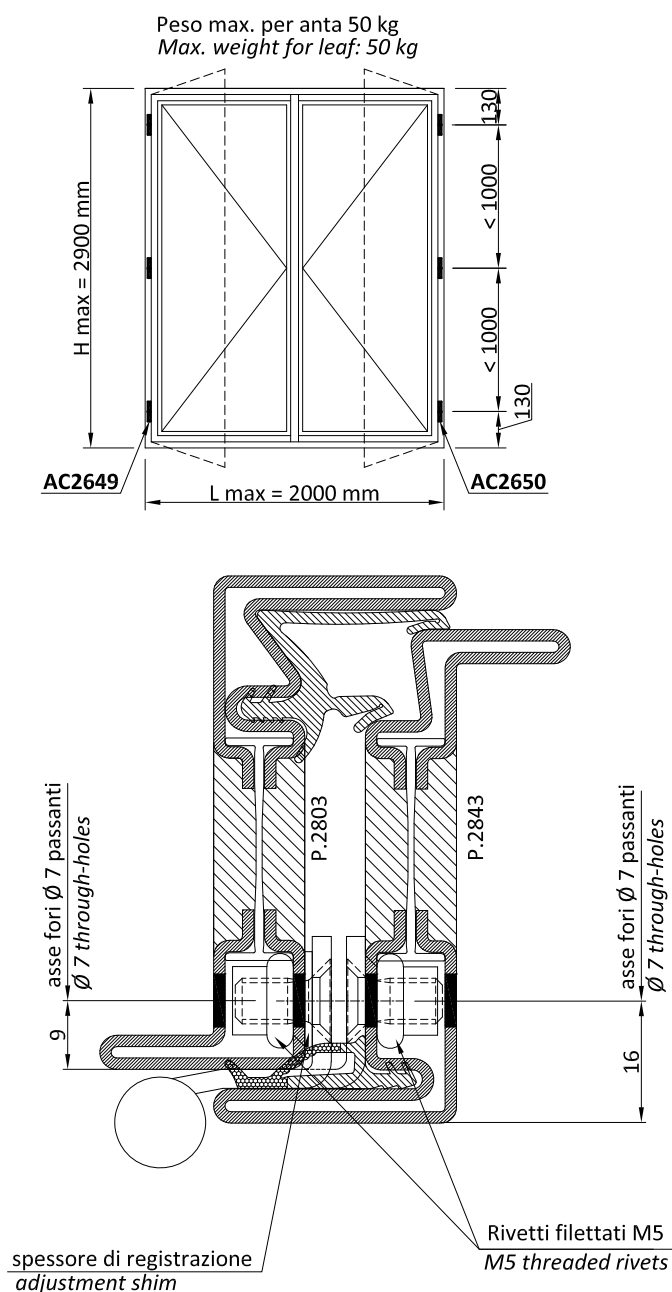




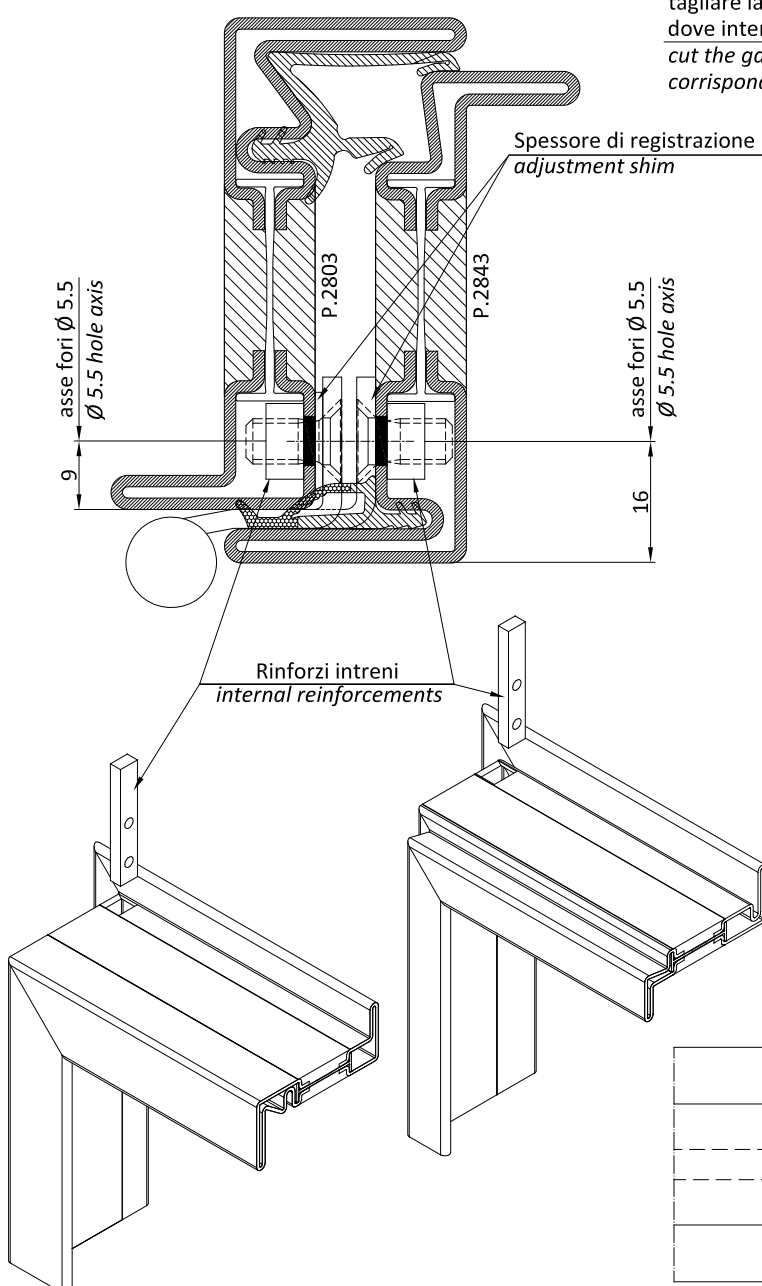
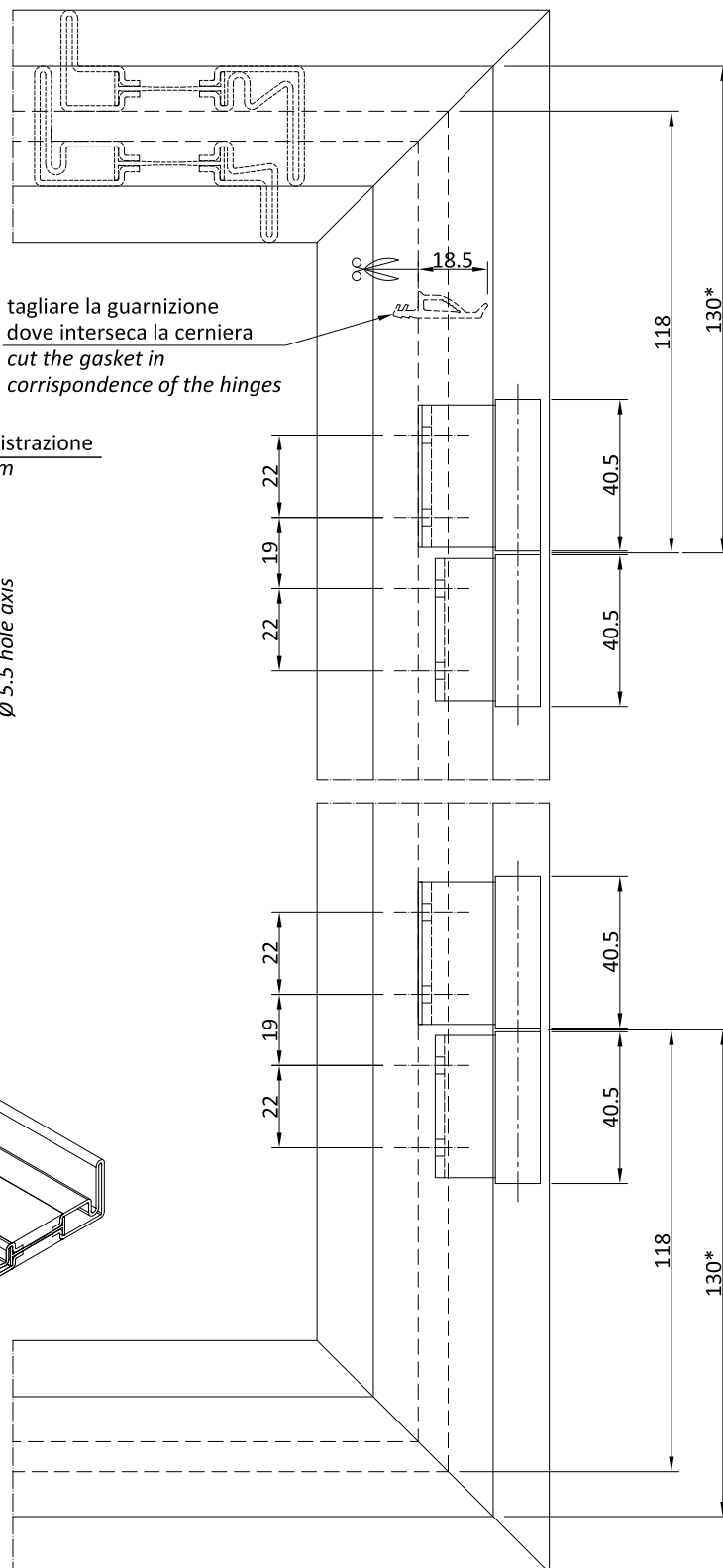
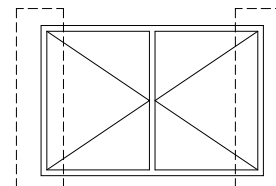
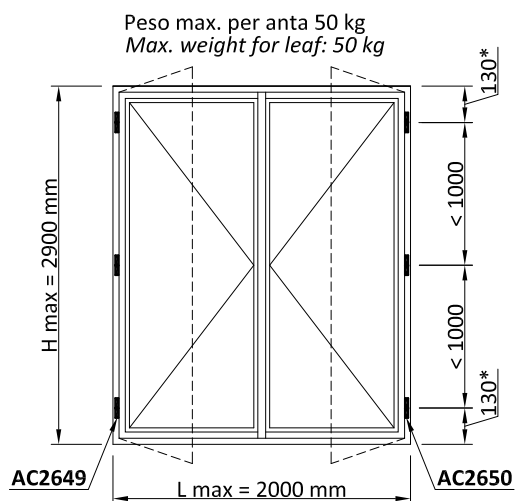
Peso max. per anta 100 kg
Max. weight for leaf: 100 kg







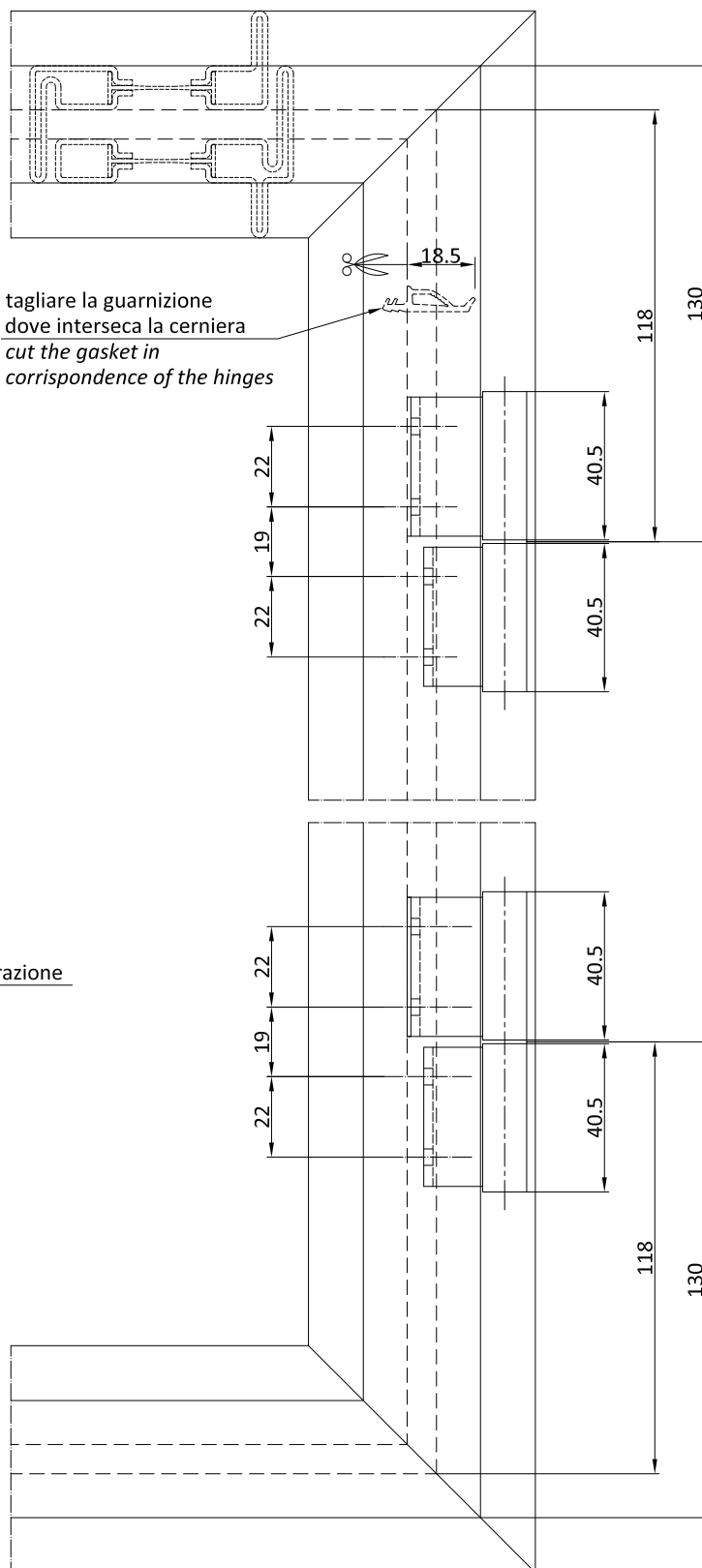
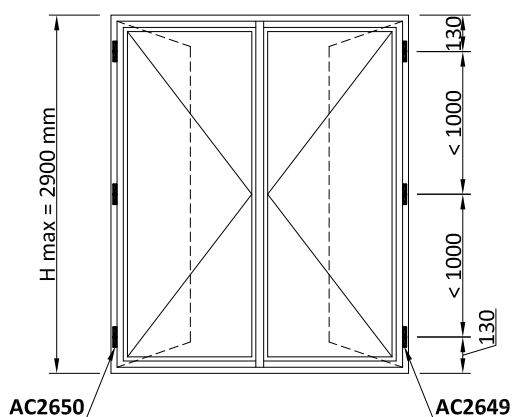
Per l'applicazione delle cerniere AC2629/AC2630 utilizzare maschera AT2629
For the installation of hinges AC2629/AC2630 please use the jig AT2629



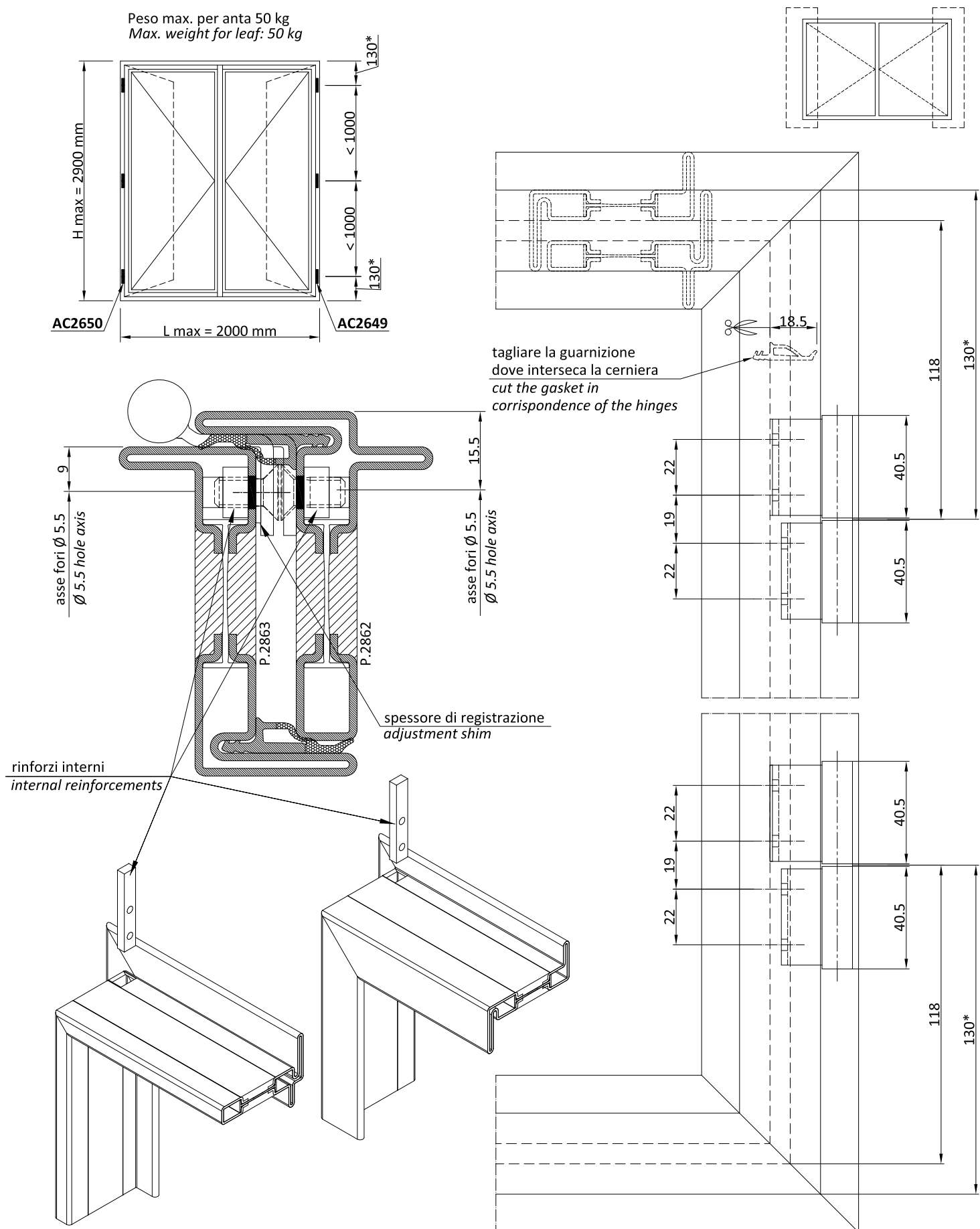
Per l'applicazione delle cerniere AC2649/AC2650 utilizzare maschera AT2629
For the installation of hinges AC2649/AC2650 please use the jig AT2629

*150 mm ottone | brass

Peso max. per anta 50 kg
Max. weight for leaf: 50 kg

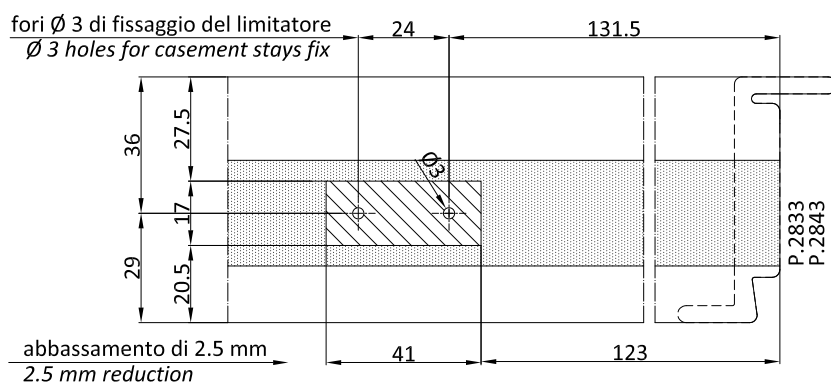
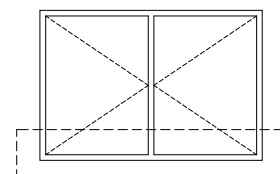


Per l'applicazione delle cerniere AC2649/AC2650 utilizzare maschera AT2629
For the installation of hinges AC2649/AC2650 please use the jig AT2629

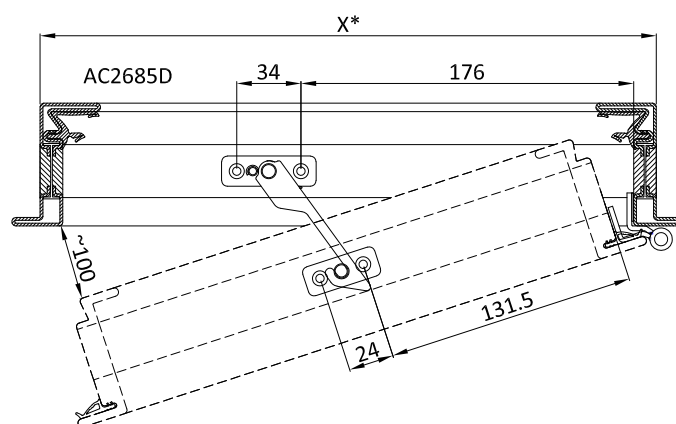
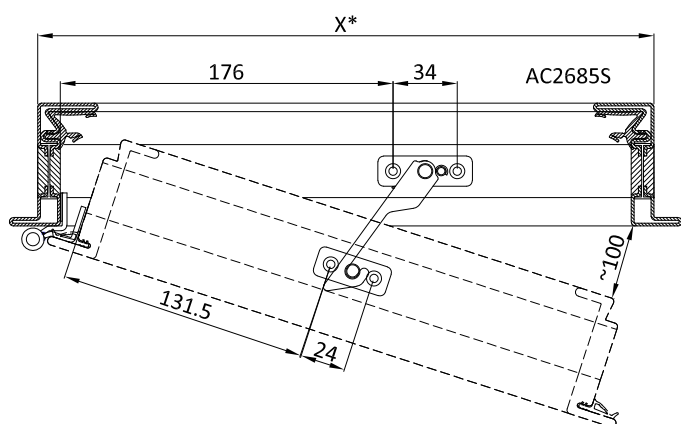
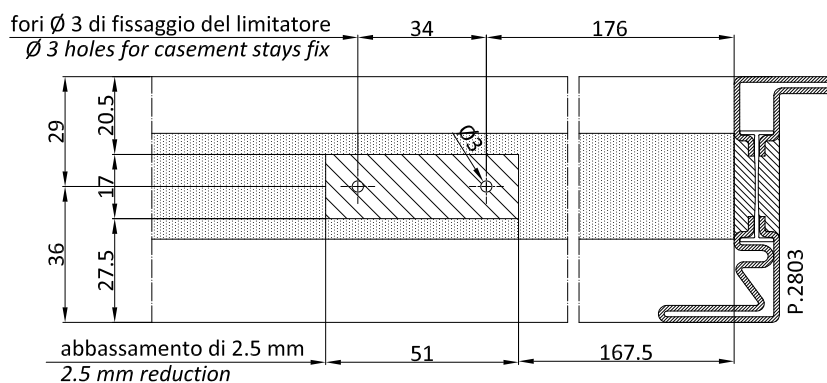
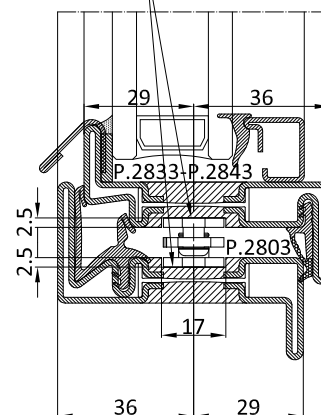


Per l'applicazione delle cerniere AC2629/AC2630 utilizzare maschera AT2629
For the installation of hinges AC2629/AC2630 please use the jig AT2629

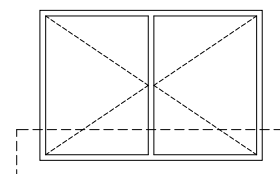
*150 mm ottone | *brass*



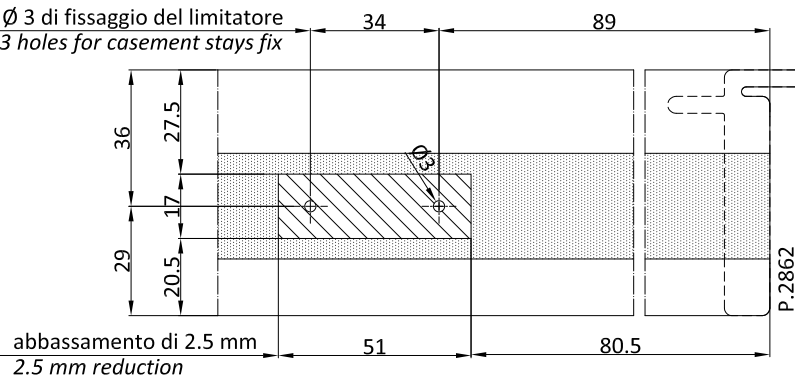
abbassamento di 2.5 mm
2.5 mm reduction



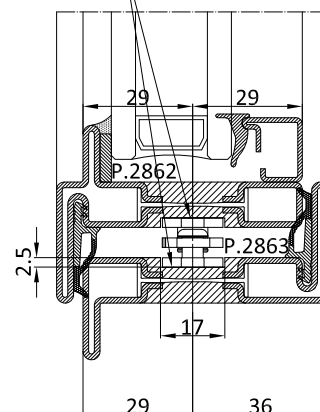
* simulazione di applicazione su larghezza telaio (X) 500 mm e apertura massima ~100 mm
* fitting simulation for frame width (X) 500mm and maximum opening ~100 mm



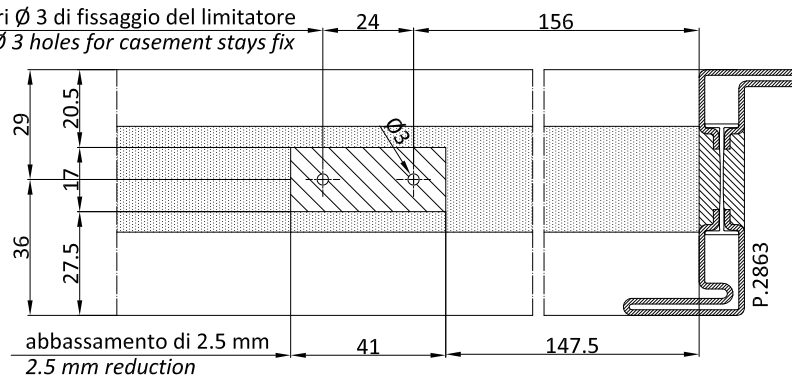
fori $\varnothing 3$ di fissaggio del limitatore
 $\varnothing 3$ holes for casement stays fix



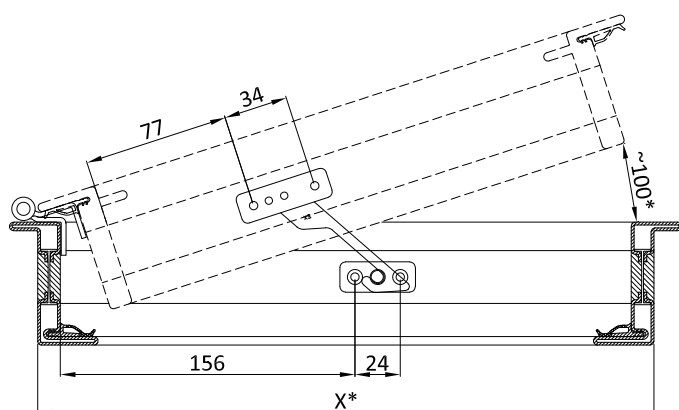
abbassamento di 2.5 mm
2.5 mm reduction



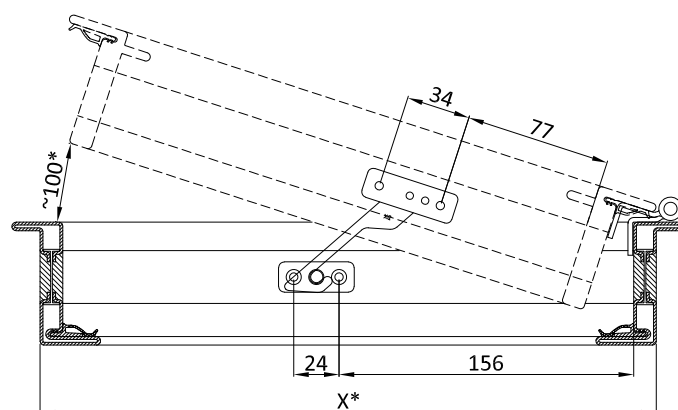
fori $\varnothing 3$ di fissaggio del limitatore
 $\varnothing 3$ holes for casement stays fix



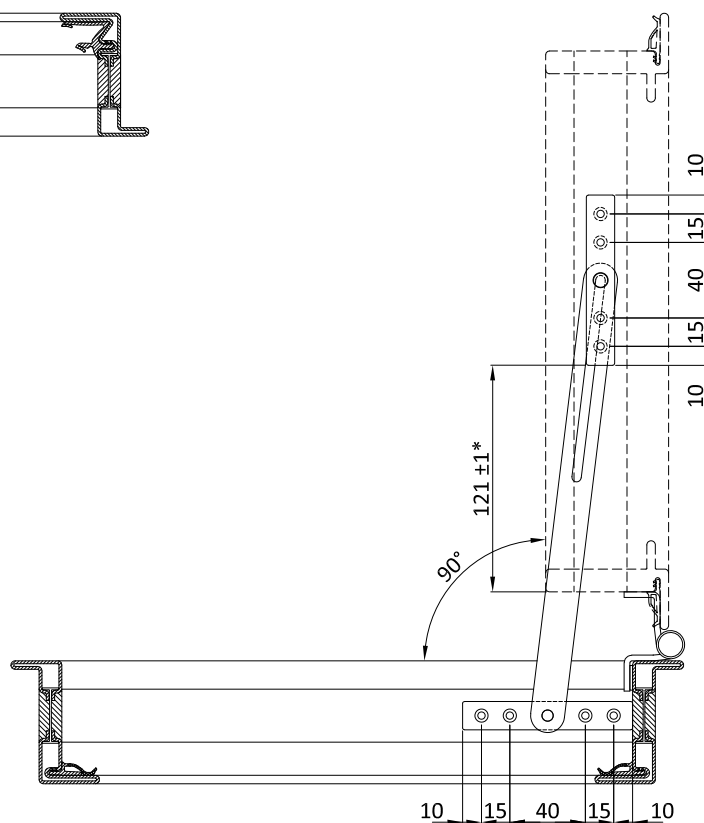
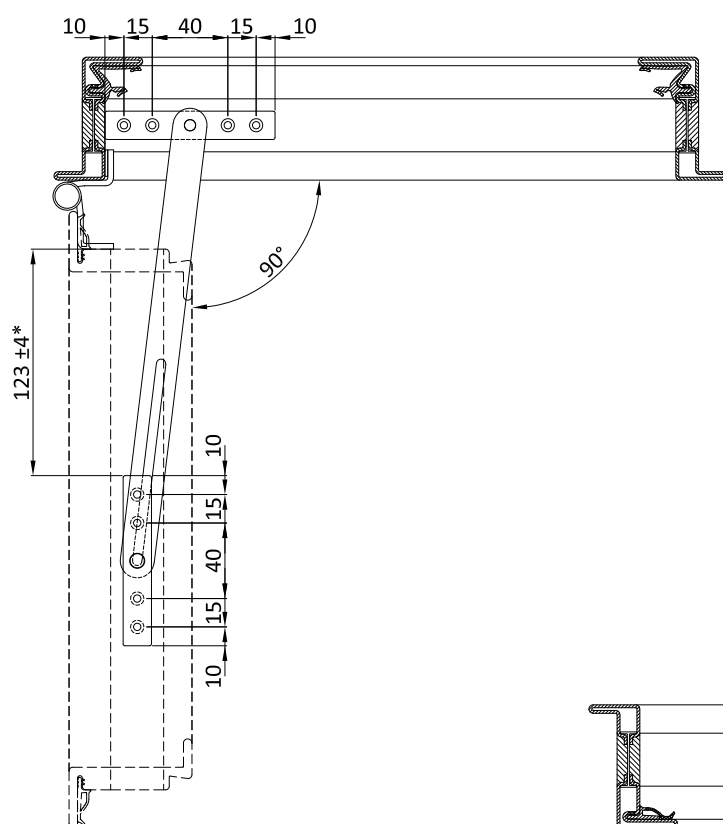
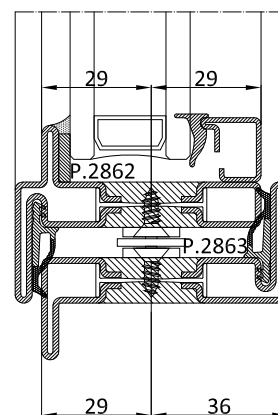
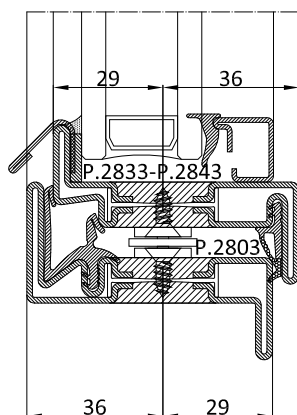
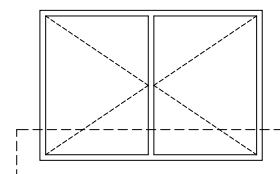
AC2685S



AC2685D



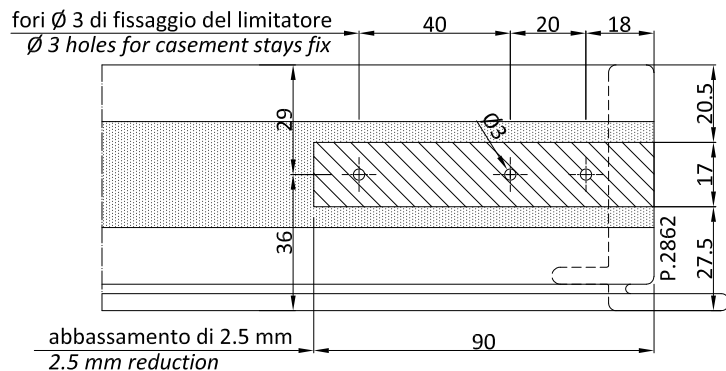
* simulazione di applicazione su larghezza telaio (X) 500 mm e apertura massima ~100 mm
* fitting simulation for frame width (X) 500mm and maximum opening ~100 mm



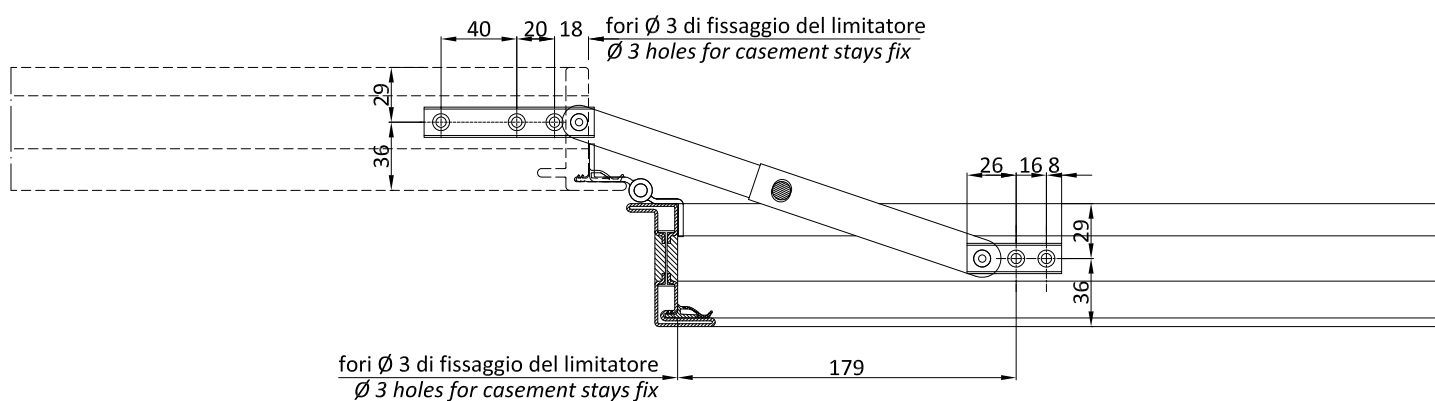
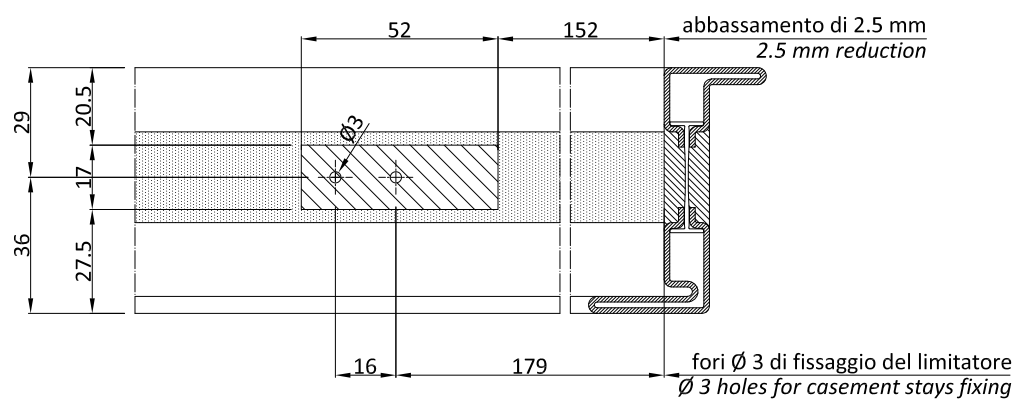
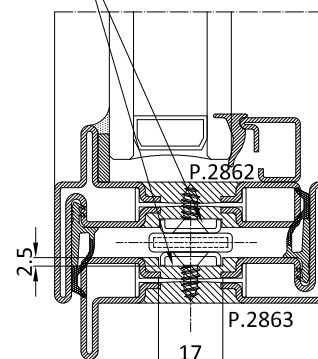
* dimensione variabile a seconda del profilo e delle cerniere utilizzate. Si consiglia il posizionamento sull'anta in opera.

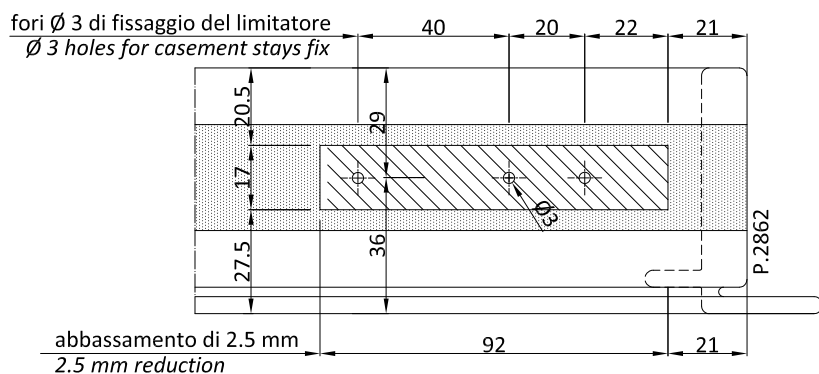
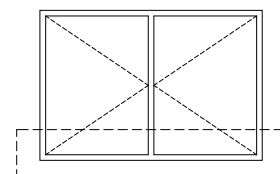
* variable dimension according to the selected profile and hinges. To be positioned with the leaf in place.

fori $\varnothing 3$ di fissaggio del limitatore
 $\varnothing 3$ holes for casement stays fix

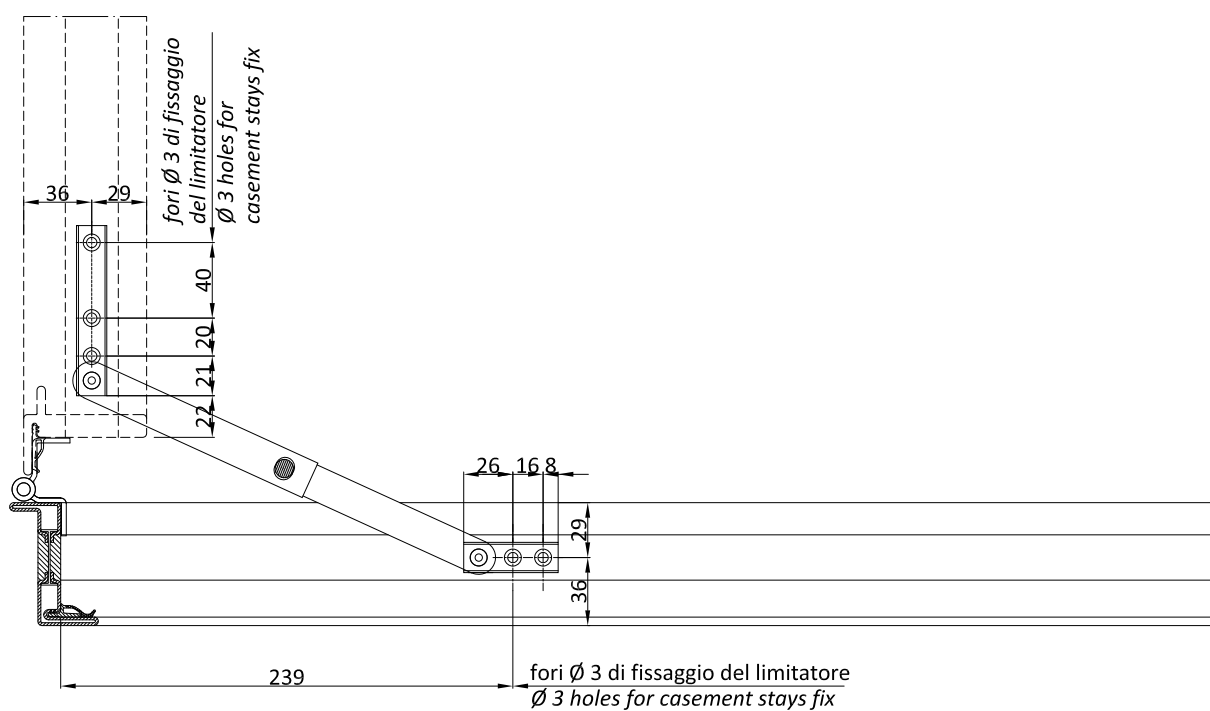
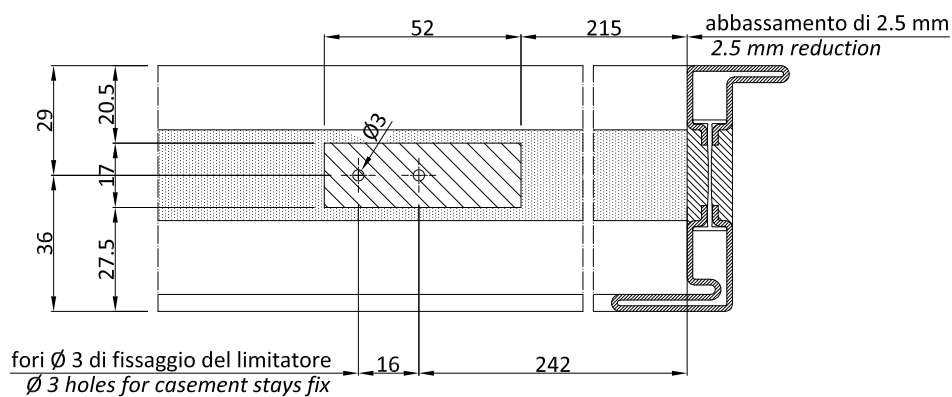
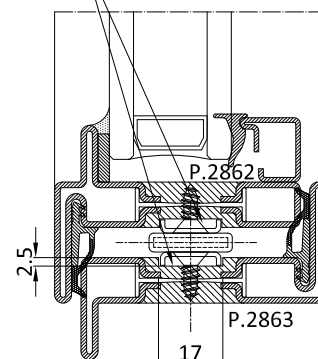


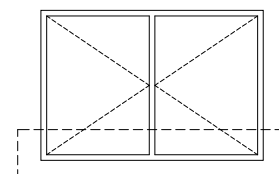
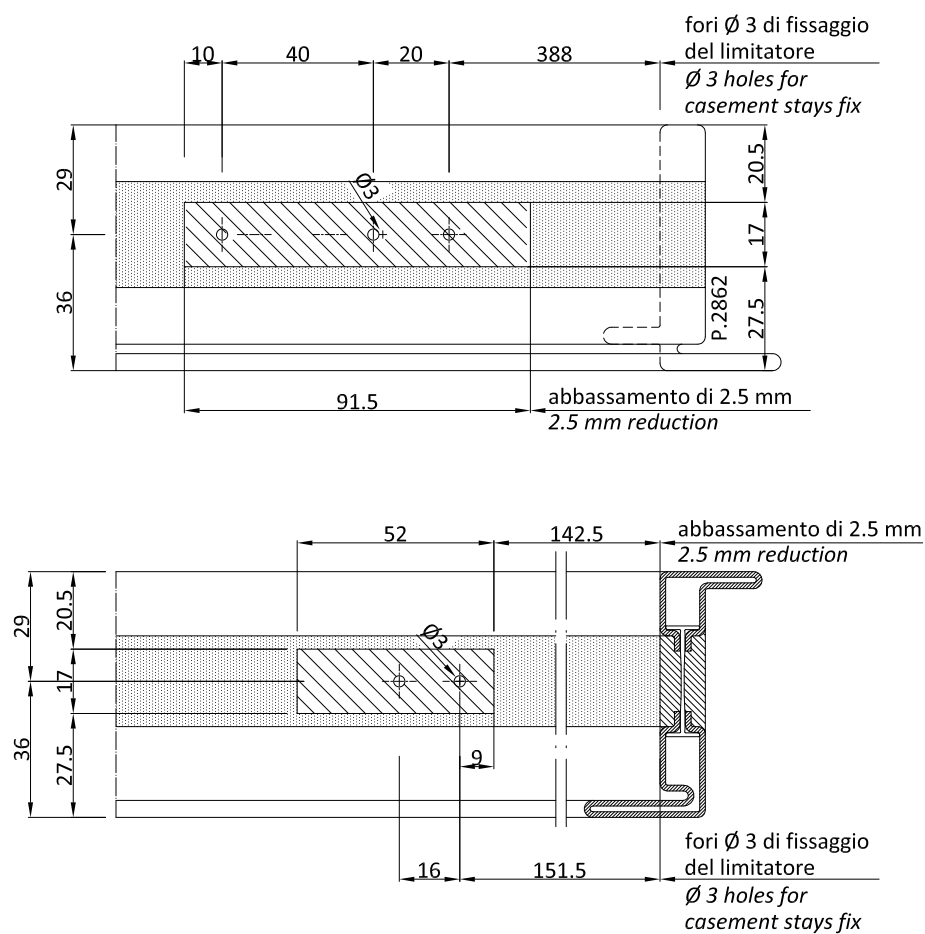
abbassamento di 2.5 mm
2.5 mm reduction



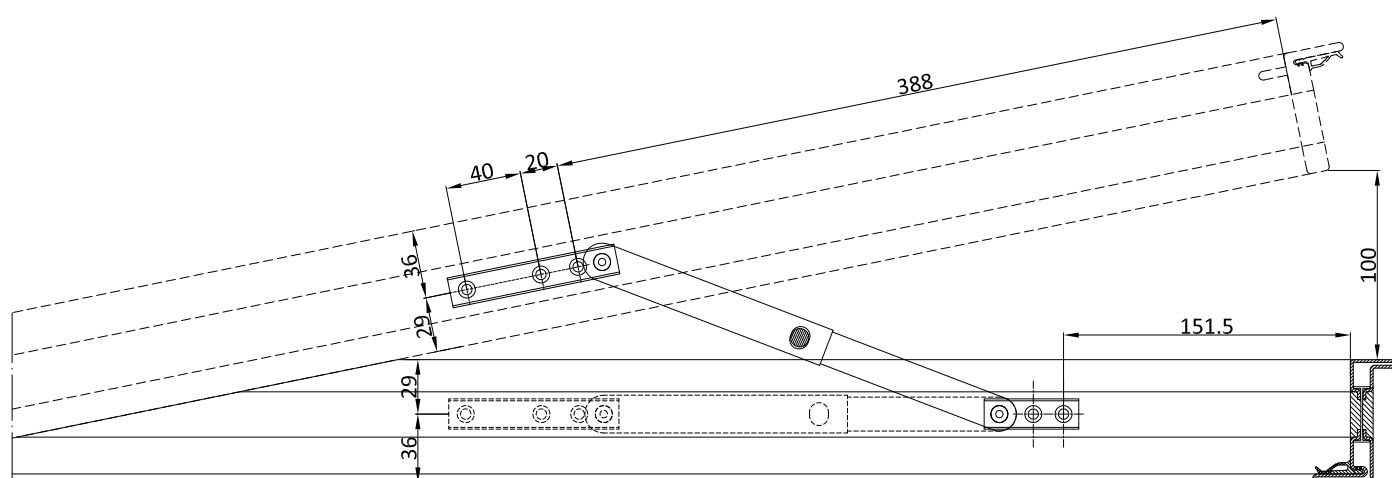
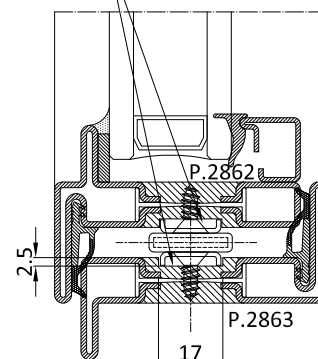


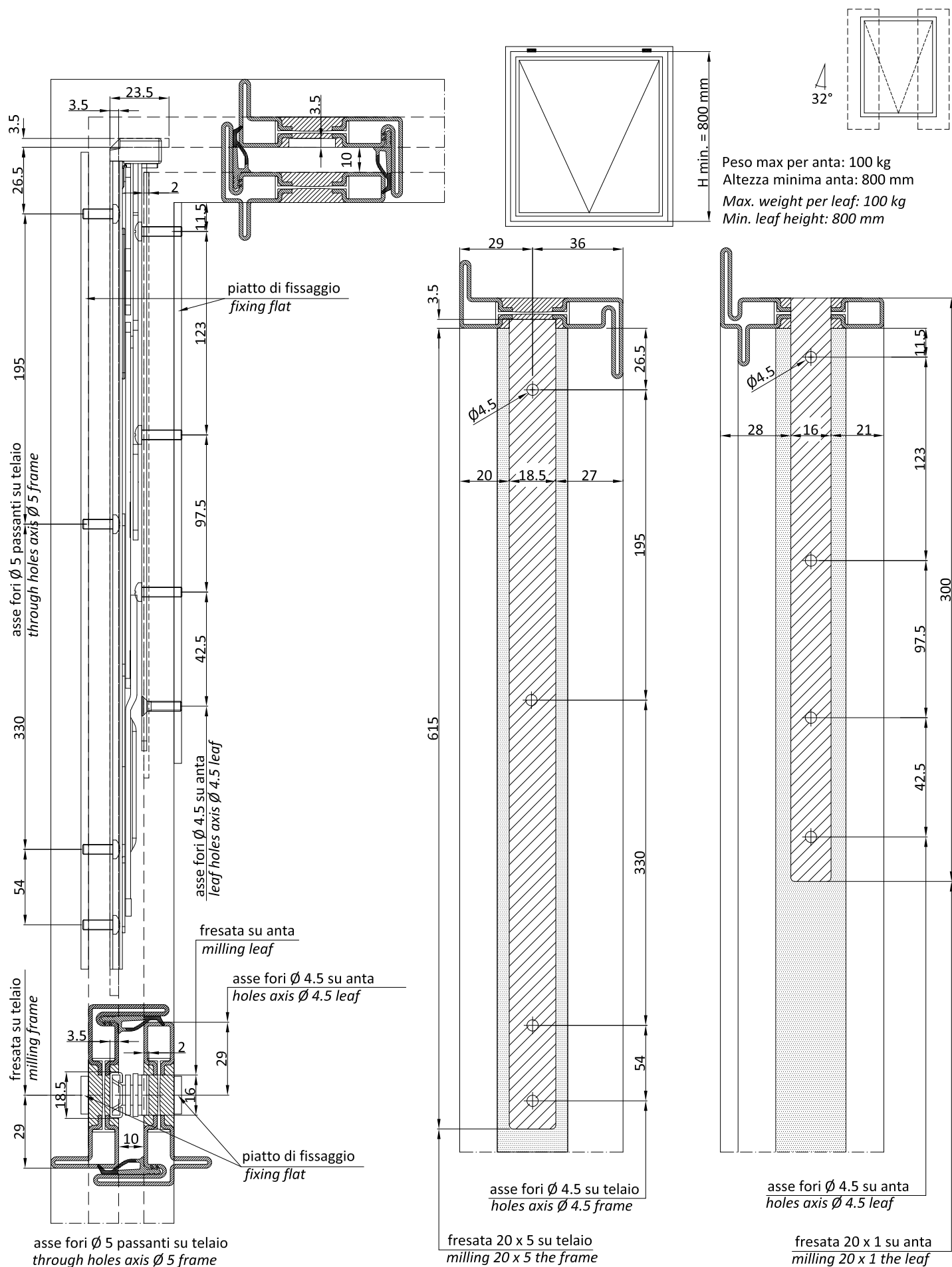
abbassamento di 2.5 mm
2.5 mm reduction

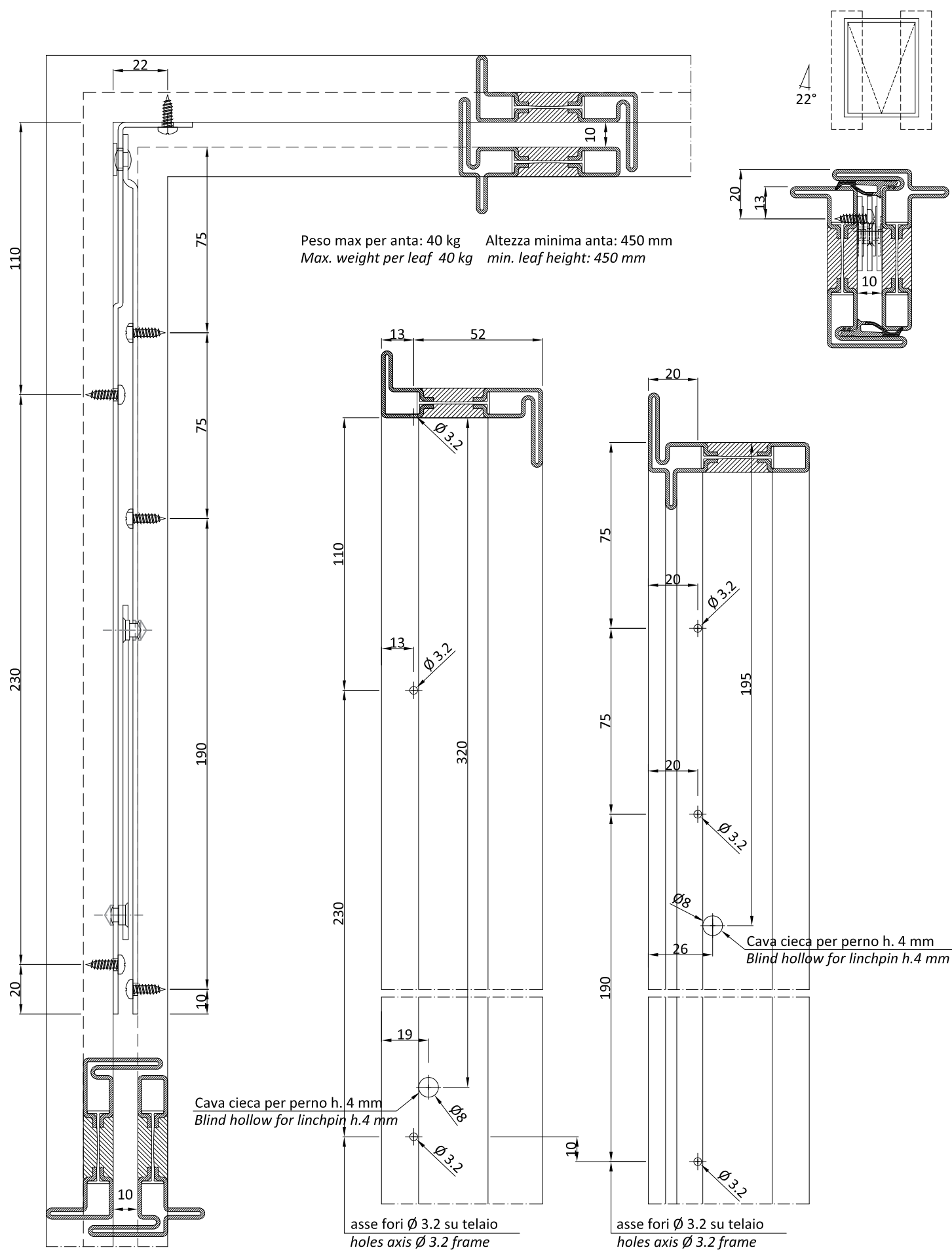


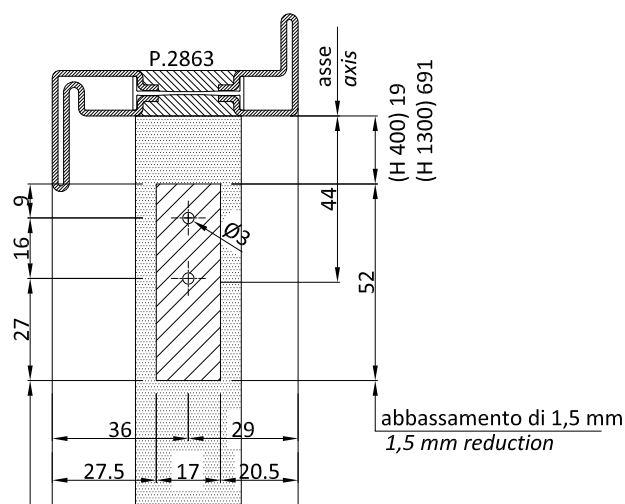


abbassamento di 2.5 mm
2.5 mm reduction



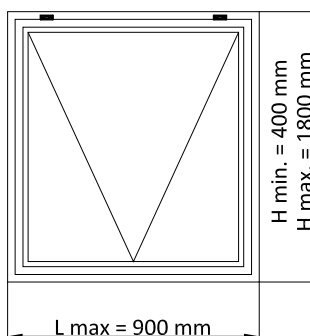




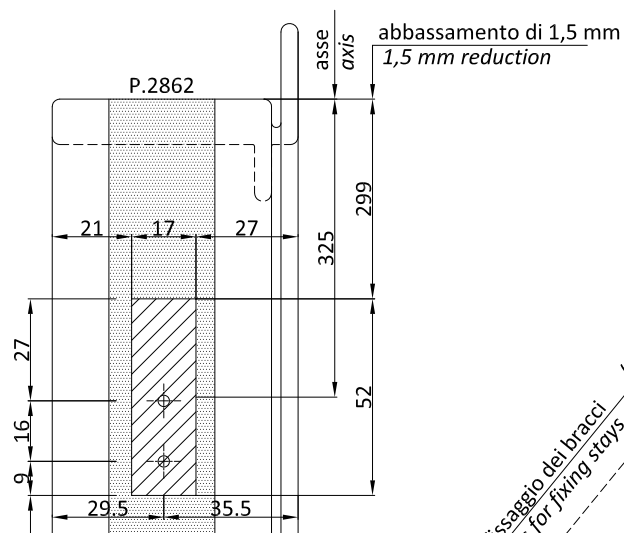


fori Ø 3 di fissaggio dei bracci
Ø 3 holes for fixing stays

peso max. per anta: 60 Kg
max. leaf weight: 60 Kg



fori Ø 3 di fissaggio dei bracci
Ø 3 holes for fixing stays



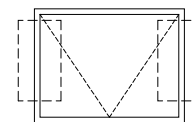
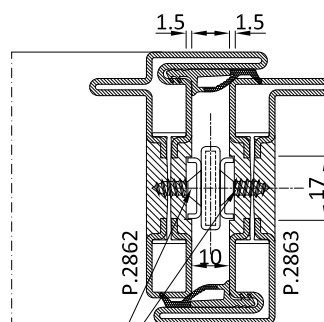
fori Ø 3 di fissaggio dei bracci
Ø 3 holes for fixing stays

fori Ø 3 di fissaggio dei bracci
Ø 3 holes for fixing stays

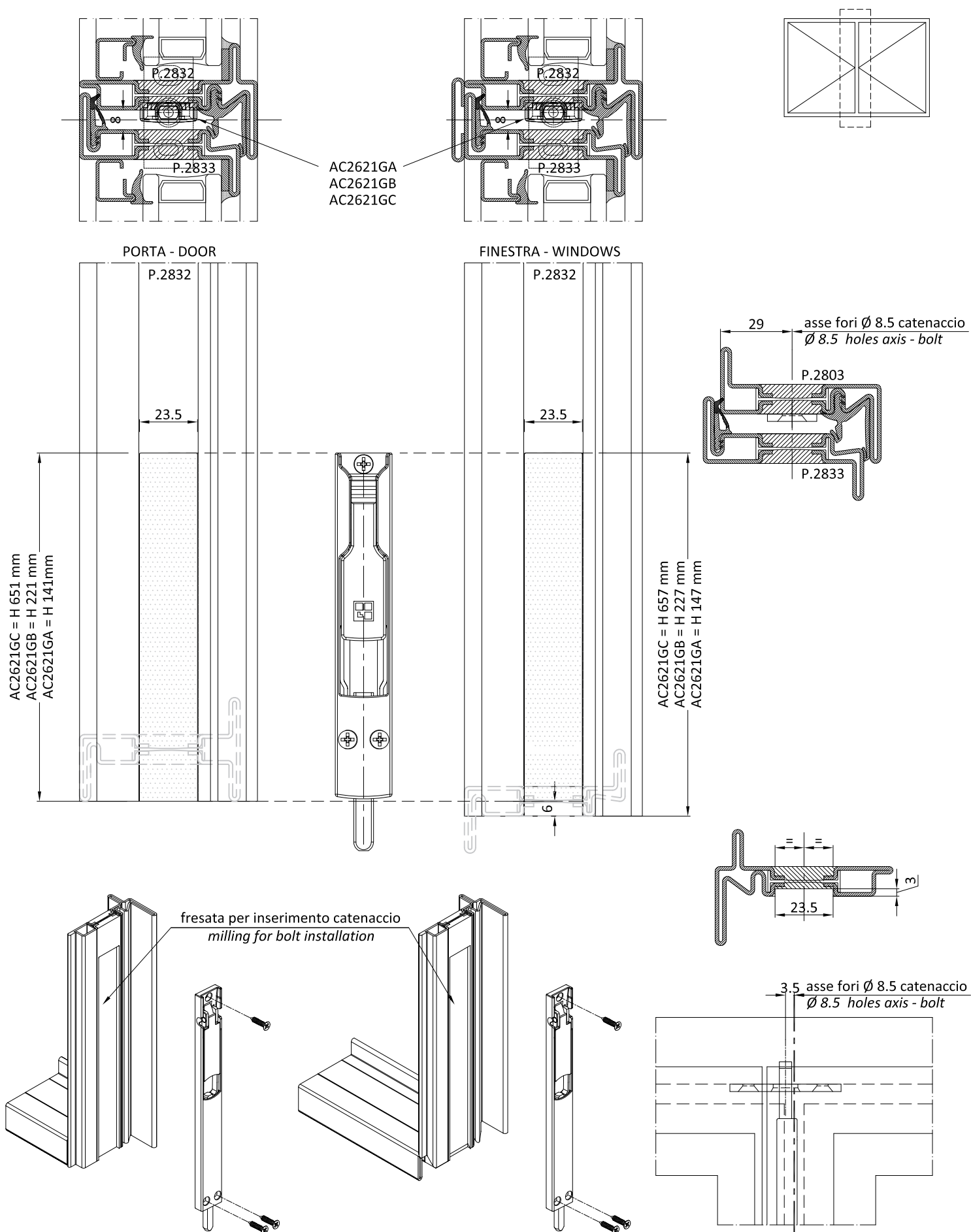
fori Ø 3 di fissaggio dei bracci
Ø 3 holes for fixing stays

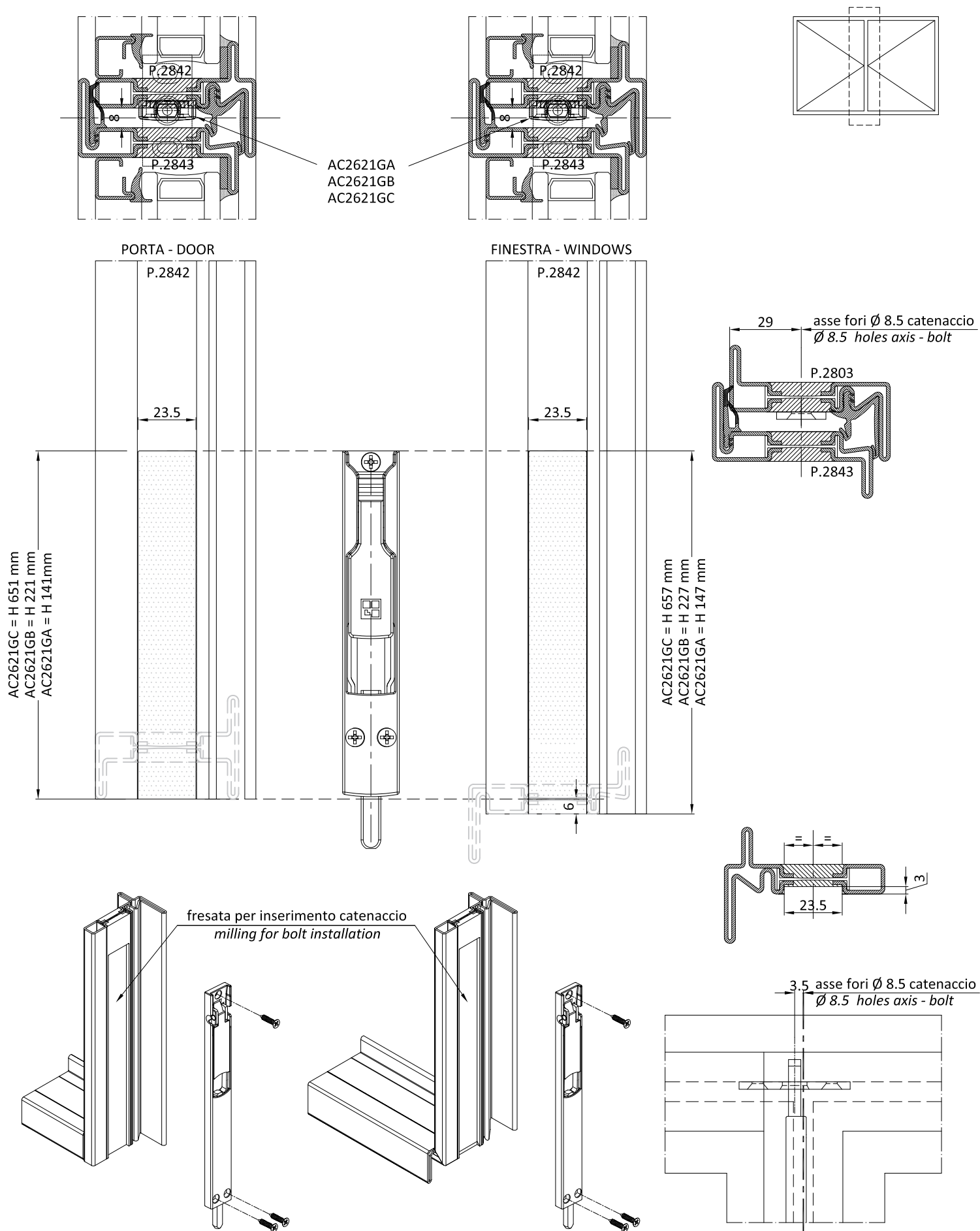
(H 400) ≈ 230
(H 1300) ≈ 300

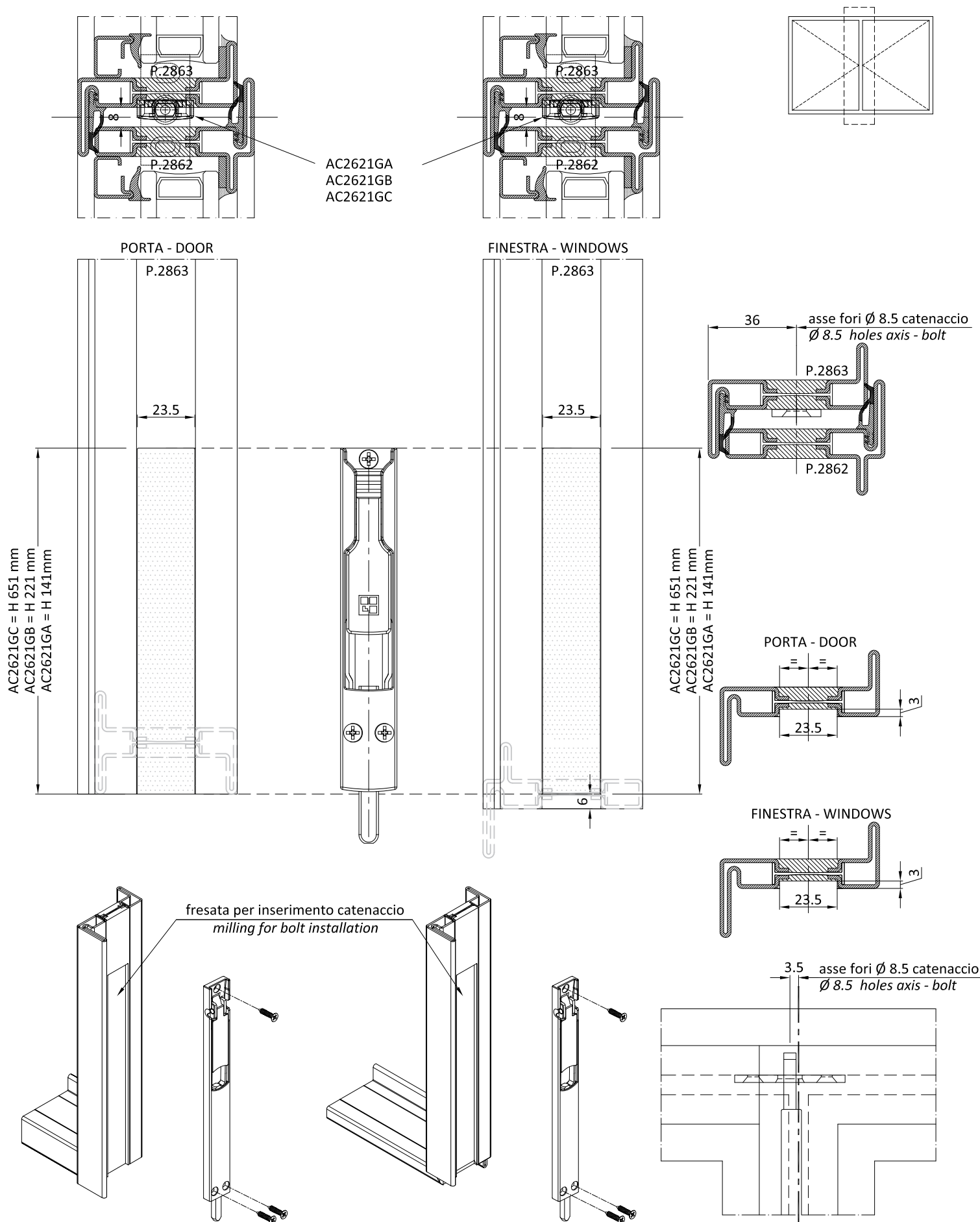
abbassamento di 1,5 mm
1,5 mm reduction



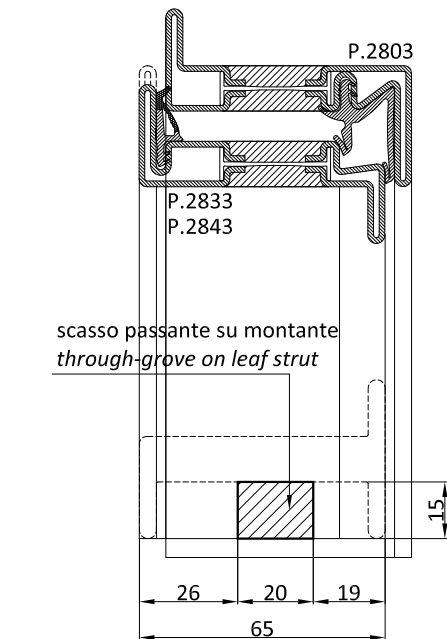
fori Ø 3 di fissaggio dei bracci
Ø 3 holes for fixing stays



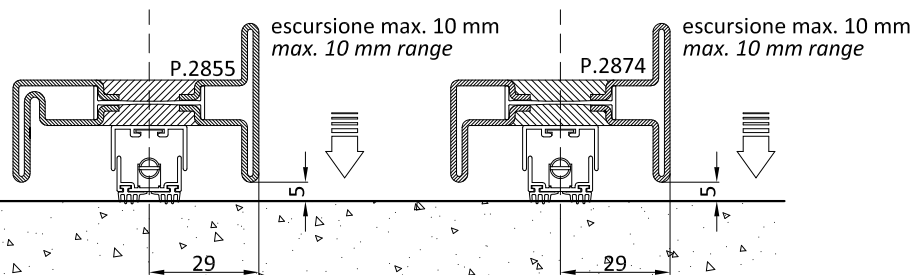
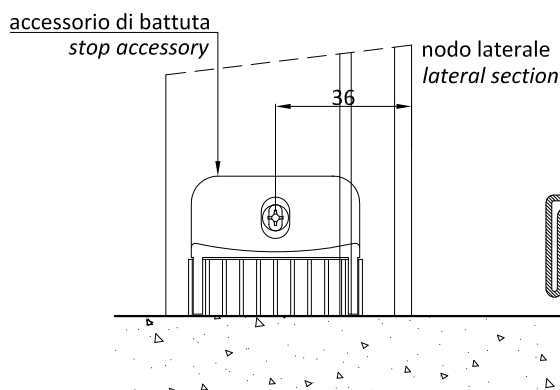
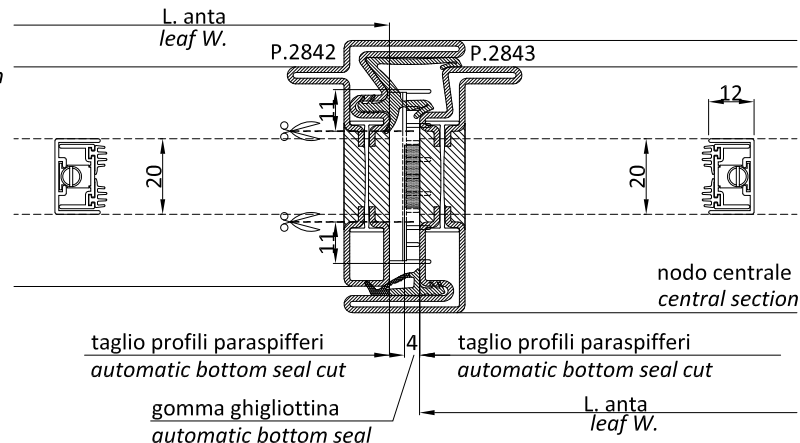
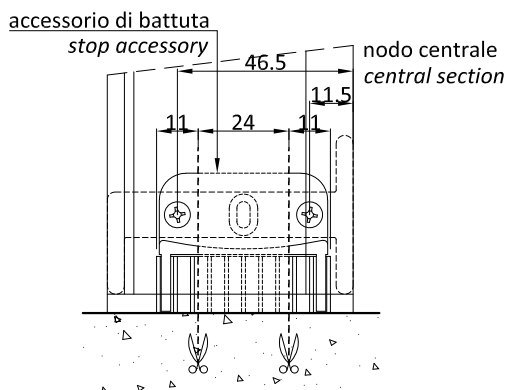
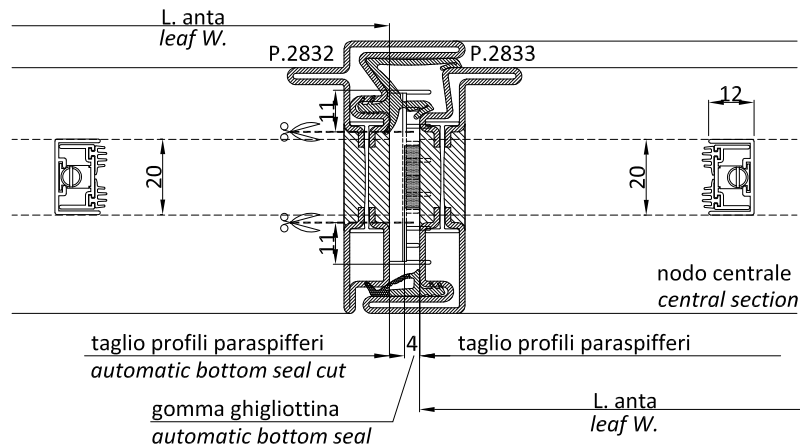
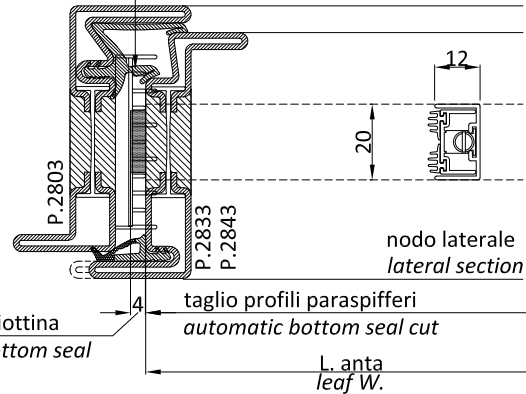




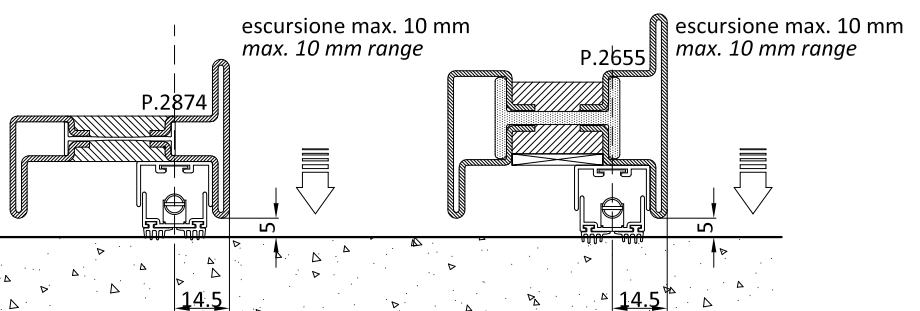
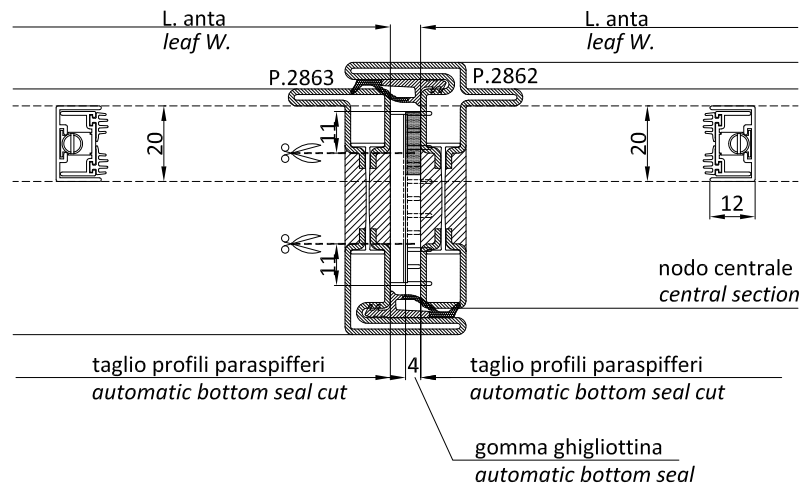
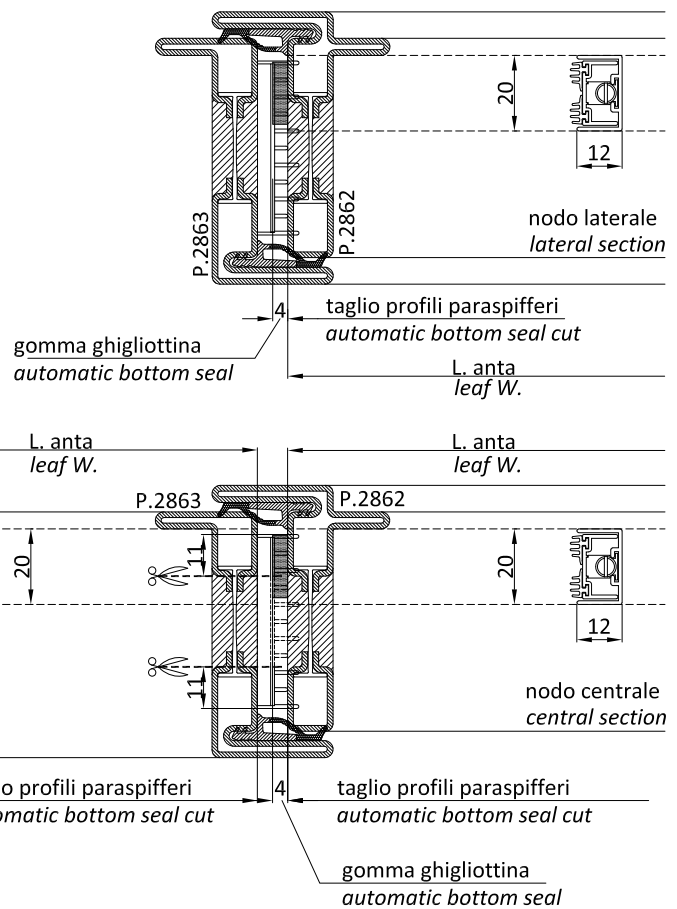
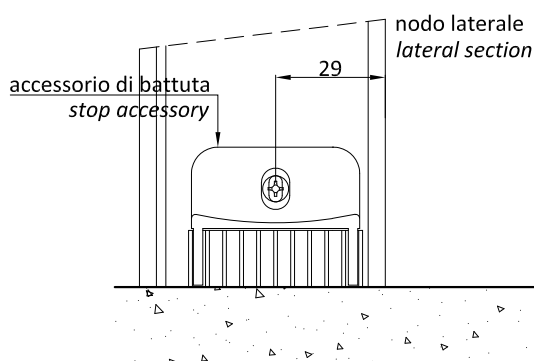
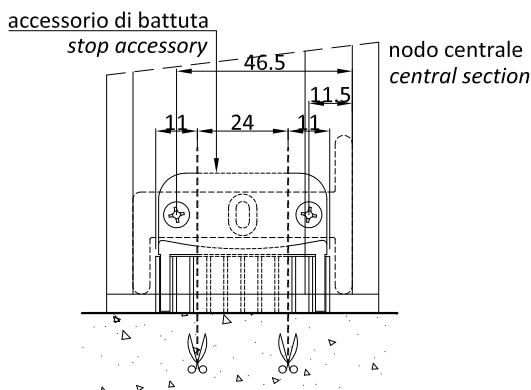
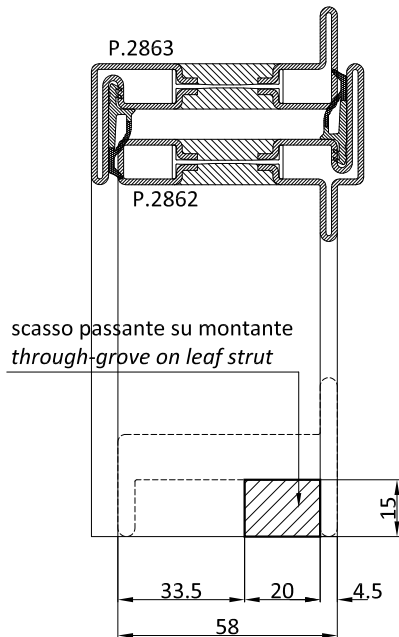
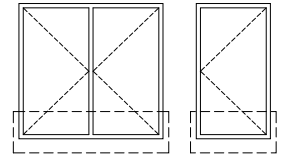
Cod. Cod.	lunghezza guarnizione automatica automatic bottom seal lenght	lunghezza anta leaf width
AC2636/Z	315 - 430 mm	299 - 414 mm
AC2636/A	380 - 530 mm	364 - 514 mm
AC2636/B	480 - 630 mm	464 - 614 mm
AC2636/C	580 - 730 mm	564 - 714 mm
AC2636/D	680 - 830 mm	664 - 814 mm
AC2636/E	780 - 930 mm	764 - 914 mm
AC2636/F	880 - 1030 mm	864 - 1014 mm
AC2636/G	980 - 1130 mm	964 - 1164 mm
AC2636/H	1080 - 1230 mm	1114 - 1314 mm

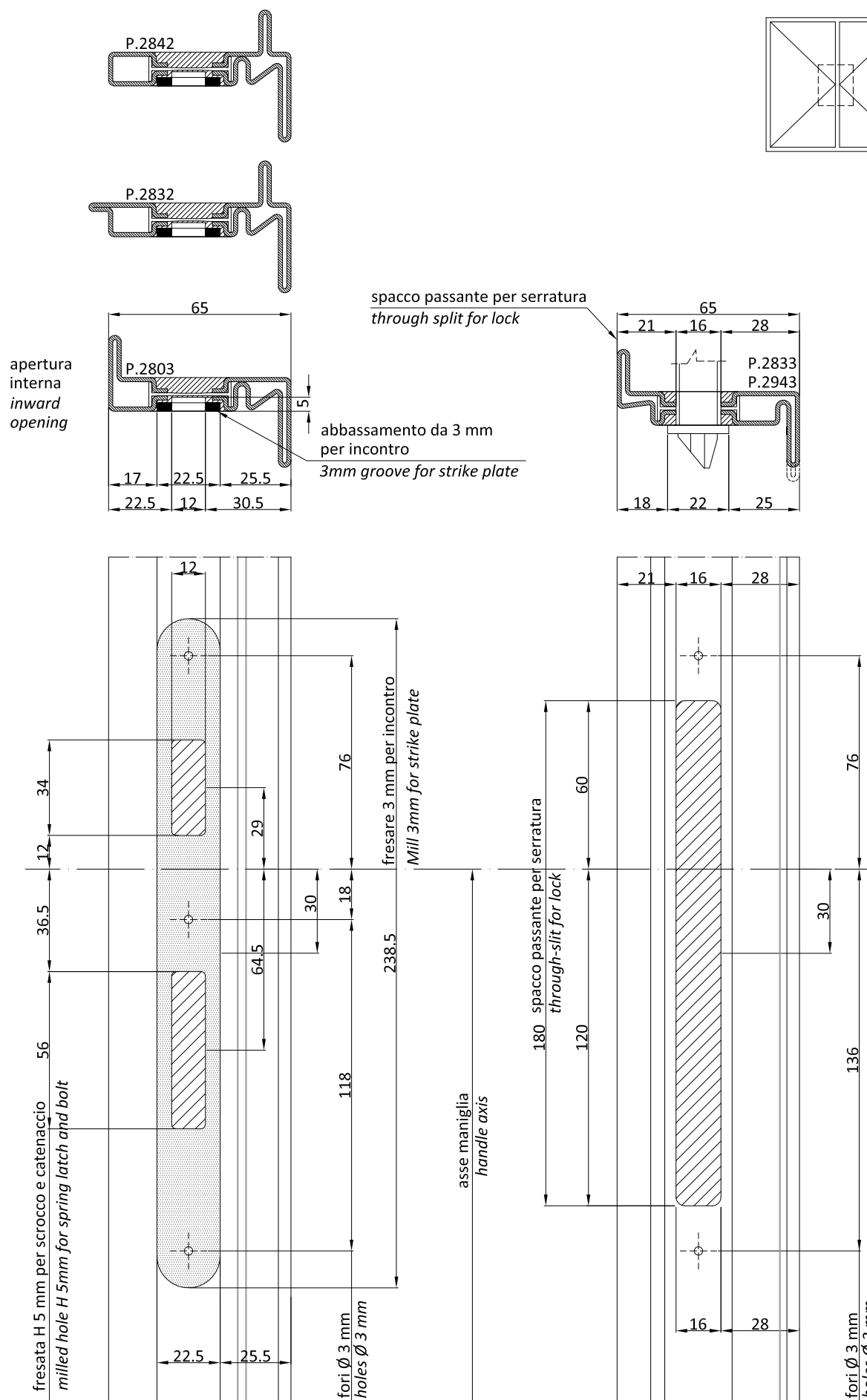


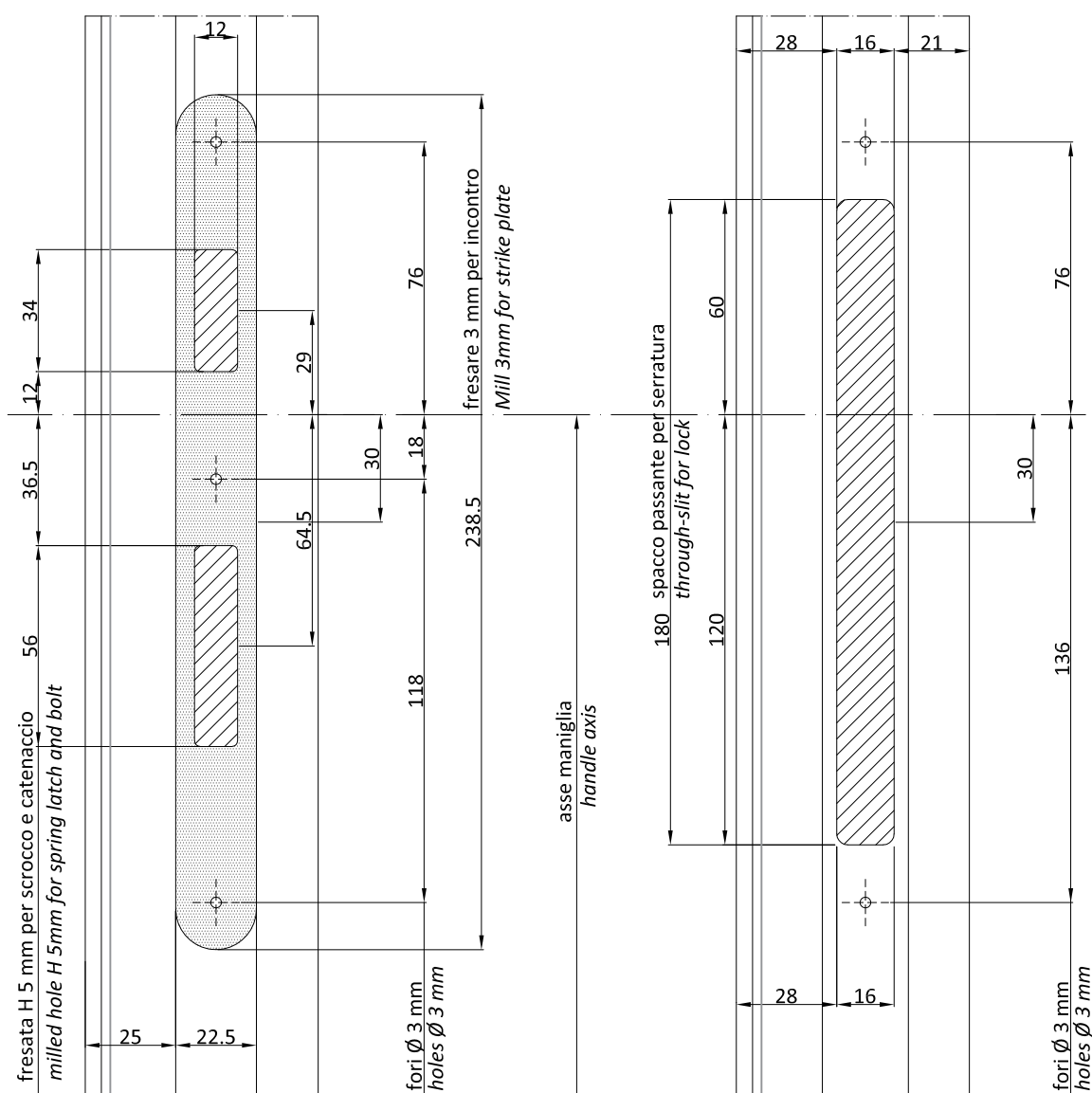
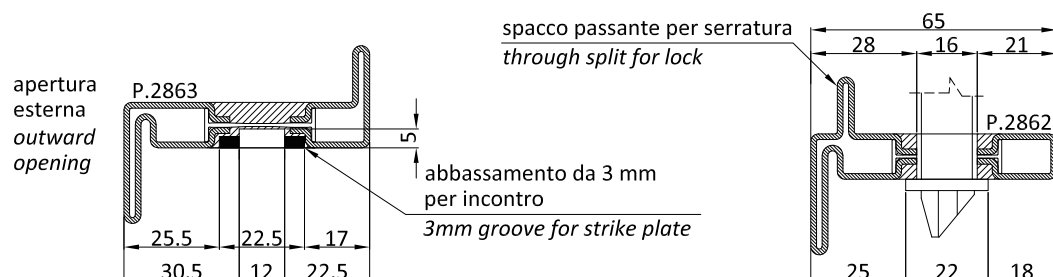
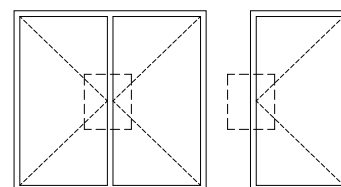
accessorio di battuta
stop accessory

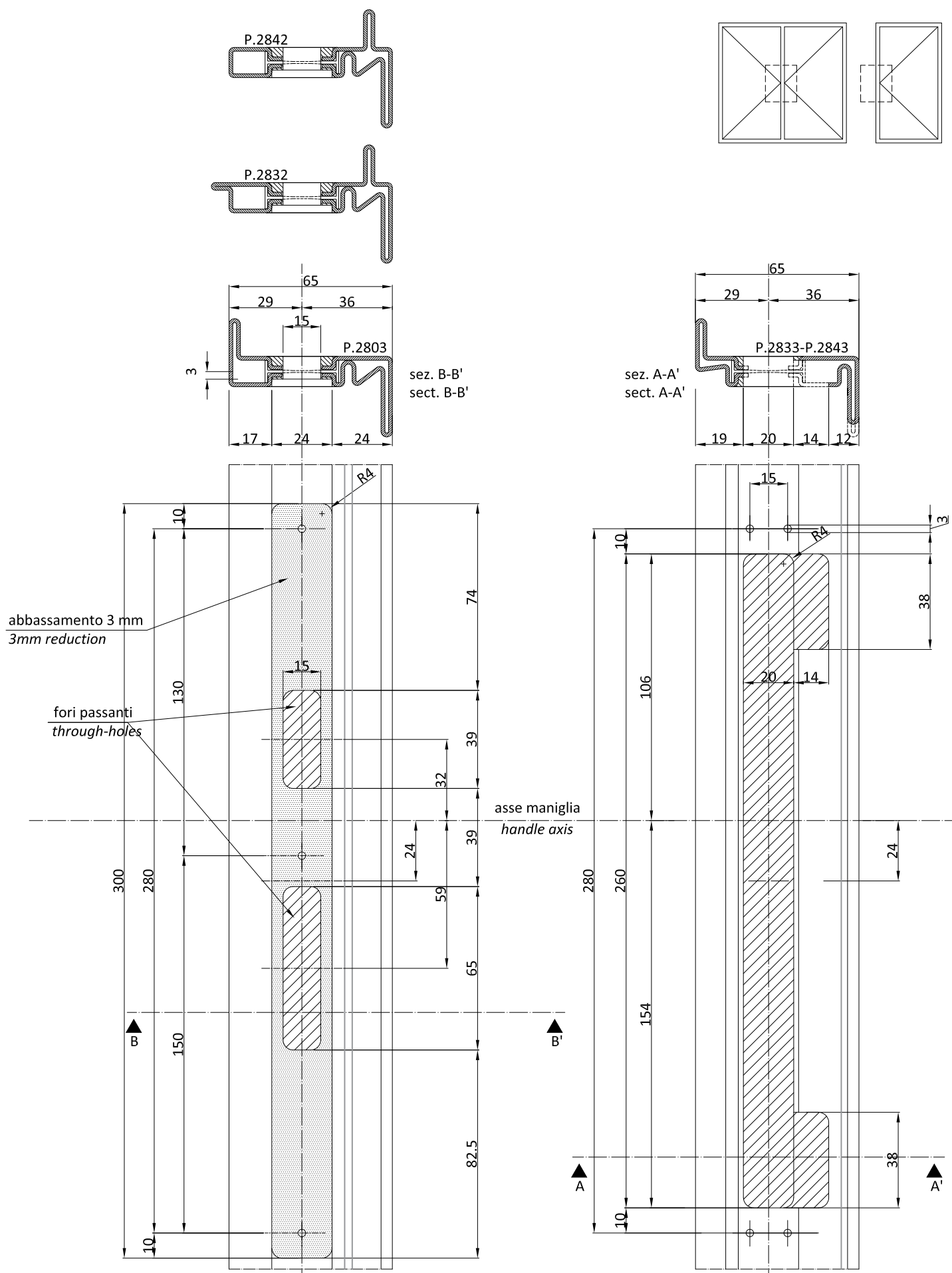


Cod. Cod.	lunghezza guarnizione automatica automatic bottom seal lenght	lunghezza anta leaf width
AC2636/Z	315 - 430 mm	299 - 414 mm
AC2636/A	380 - 530 mm	364 - 514 mm
AC2636/B	480 - 630 mm	464 - 614 mm
AC2636/C	580 - 730 mm	564 - 714 mm
AC2636/D	680 - 830 mm	664 - 814 mm
AC2636/E	780 - 930 mm	764 - 914 mm
AC2636/F	880 - 1030 mm	864 - 1014 mm
AC2636/G	980 - 1130 mm	964 - 1164 mm
AC2636/H	1080 - 1230 mm	1114 - 1314 mm



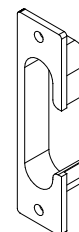
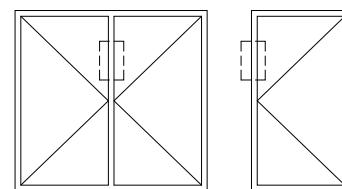
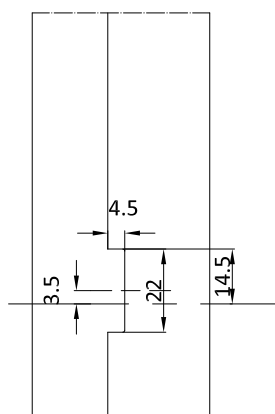
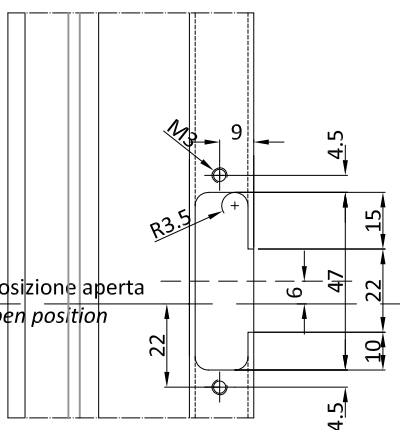




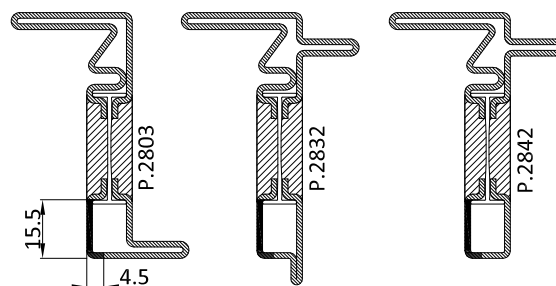
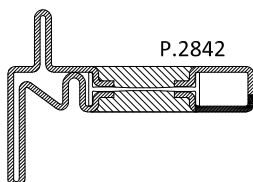
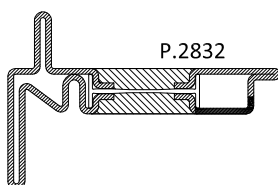
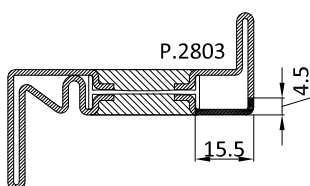


lavorazione applicazione incontro
Processing strike plate installation

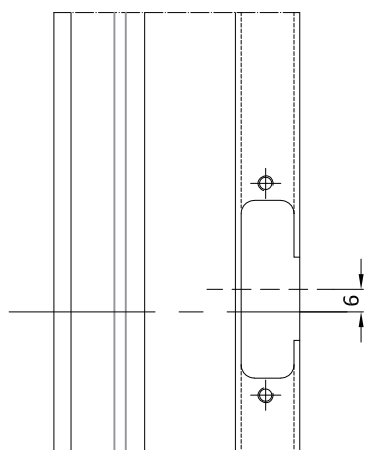
asse nottolino 3^a chiusura in posizione aperta
Latch axis for the 3rd lock in open position



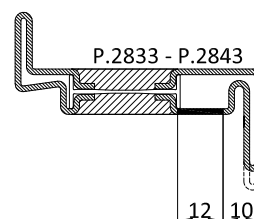
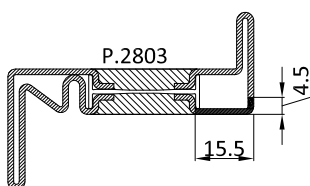
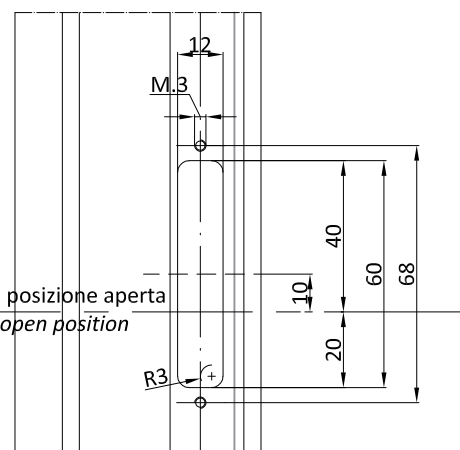
Incontro 3^a chiusura
3rd lock strike plate



lavorazione applicazione nottolino
Processing for the assembling of the 3rd lock



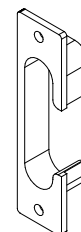
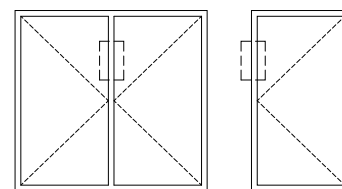
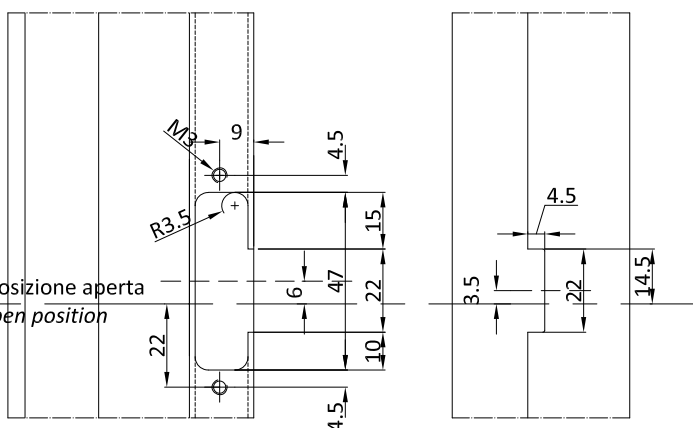
asse nottolino 3^a chiusura in posizione aperta
Latch axis for the 3rd lock in open position



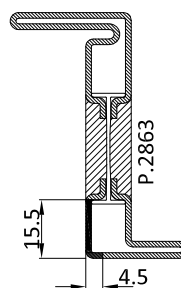
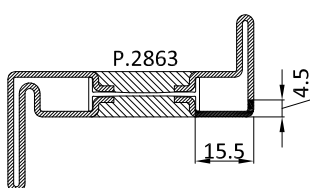
lavorazione superiore-inferiore specchiata orizzontalmente
upper working-bottom working horizontally mirrored

lavorazione applicazione incontro
Processing strike plate installation

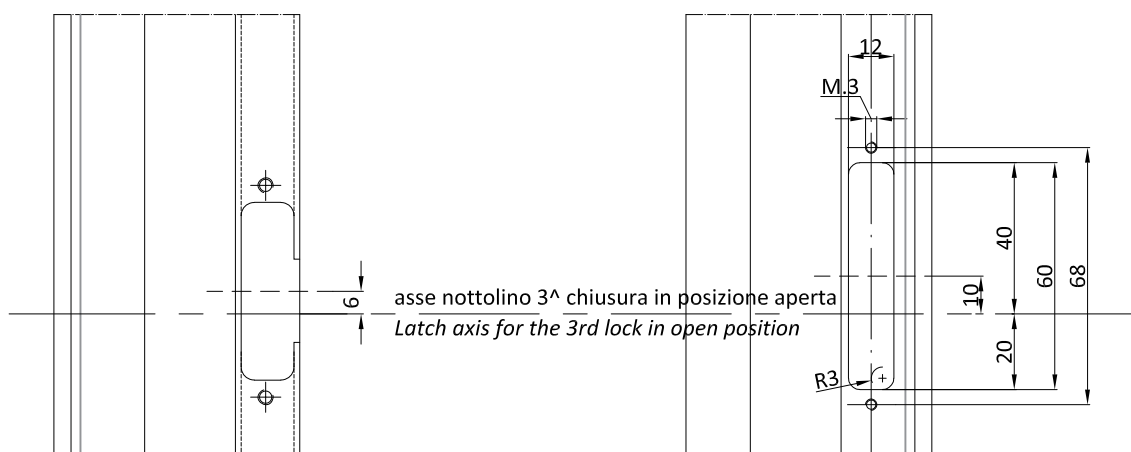
asse nottolino 3^a chiusura in posizione aperta
Latch axis for the 3rd lock in open position



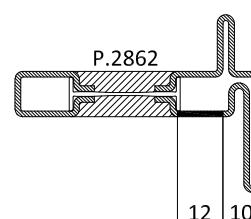
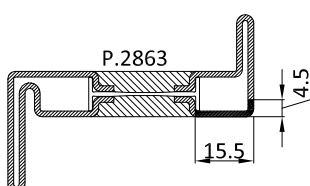
Incontro 3^a chiusura
3rd lock strike plate



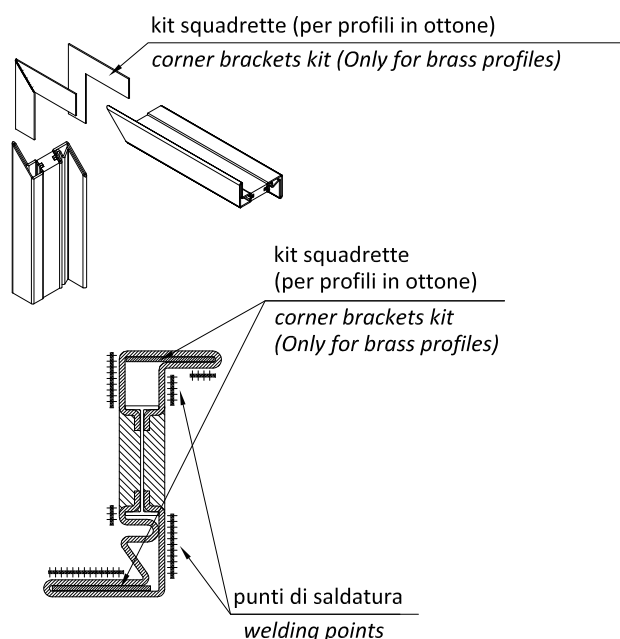
lavorazione applicazione nottolino
Processing for the assembling of the 3rd lock



asse nottolino 3^a chiusura in posizione aperta
Latch axis for the 3rd lock in open position



lavorazione superiore; inferiore specchiata orizzontalmente
Upper working; bottom working horizontally mirrored

**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.

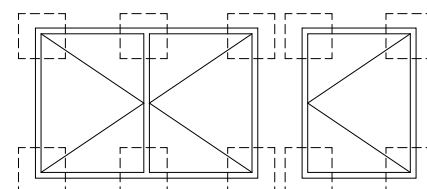
Acciaio zincato - Acciaio Corten - Acciaio inox

Saldare in continuo le superfici di contatto.

Galvanised steel - Cor-ten steel - Stainless steel

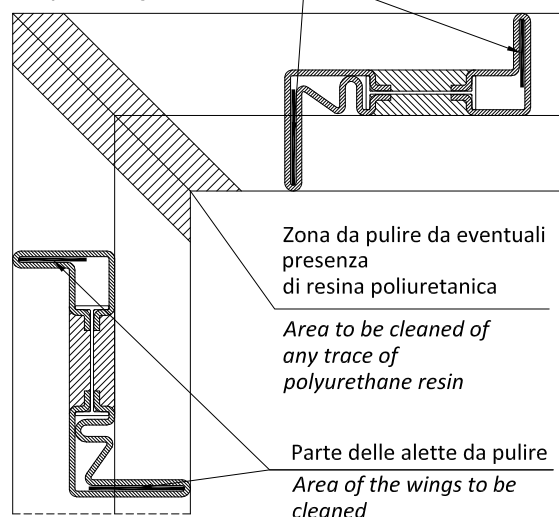
Seam-weld all contact surfaces.

Profilo	Profile	Kit squadrette	Corner brackets set
Codice	Code	Codice	Code
P.2801-P.2801		AC 2801I	
P.2803-P.2803		AC 2803I	
P.2805-P.2805		AC 2805I	
P.2801-P.2805		AC 2801I	
P.2801-P.2822		AC 2801I	
P.2803-P.2805		AC 2803I	
P.2803-P.2822		AC 2801I	
P.2805-P.2822		AC 2822I	
P.2815-P.2815		AC 2803I	
P.2822-P.2822		AC 2822I	
P.2832-P.2833		AC 2832I	
P.2833-P.2833		AC 2833I	
P.2842-P.2842		AC 2801I	
P.2842-P.2843		AC 2832I	
P.2843-P.2843		AC 2843I	
P.2801-P.2842		AC 2801I	
P.2803-P.2842		AC 2801I	
P.2805-P.2842		AC 2801I	
P.2815-P.2842		AC 2801I	
P.2851-P.2851		AC 2851I	



Parte delle alette da pulire

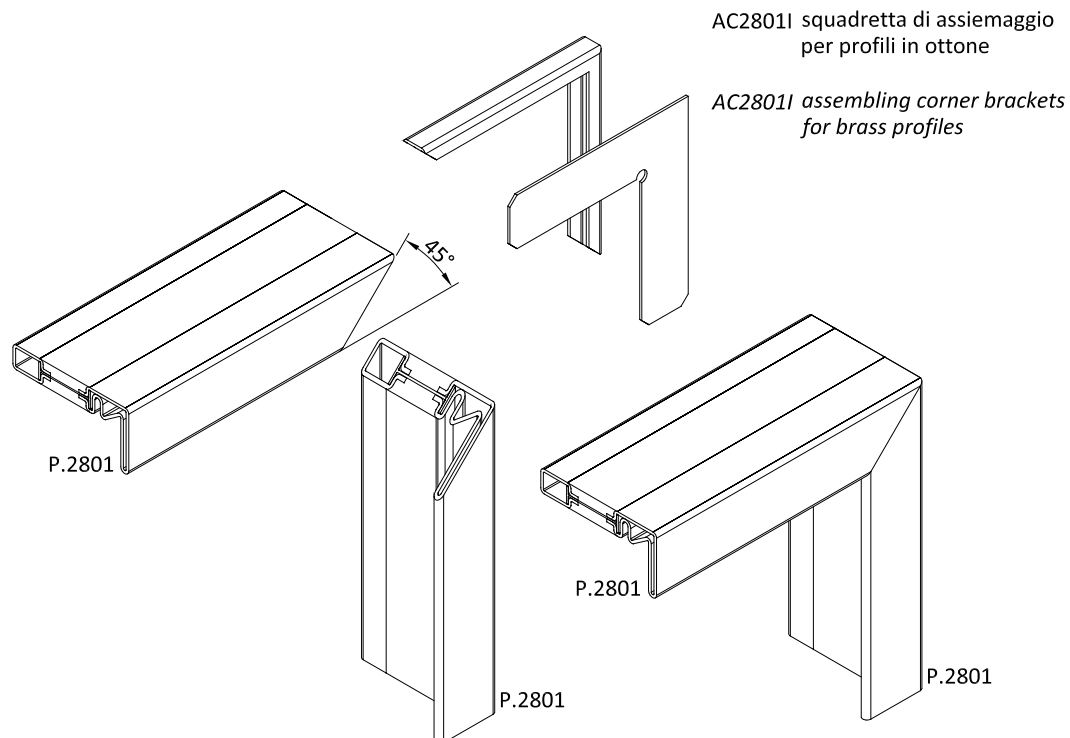
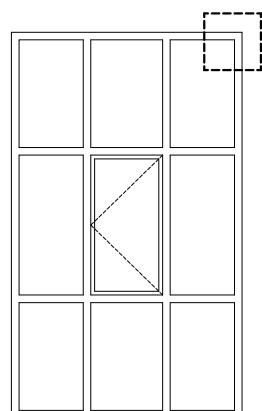
Area of the wings to be cleaned



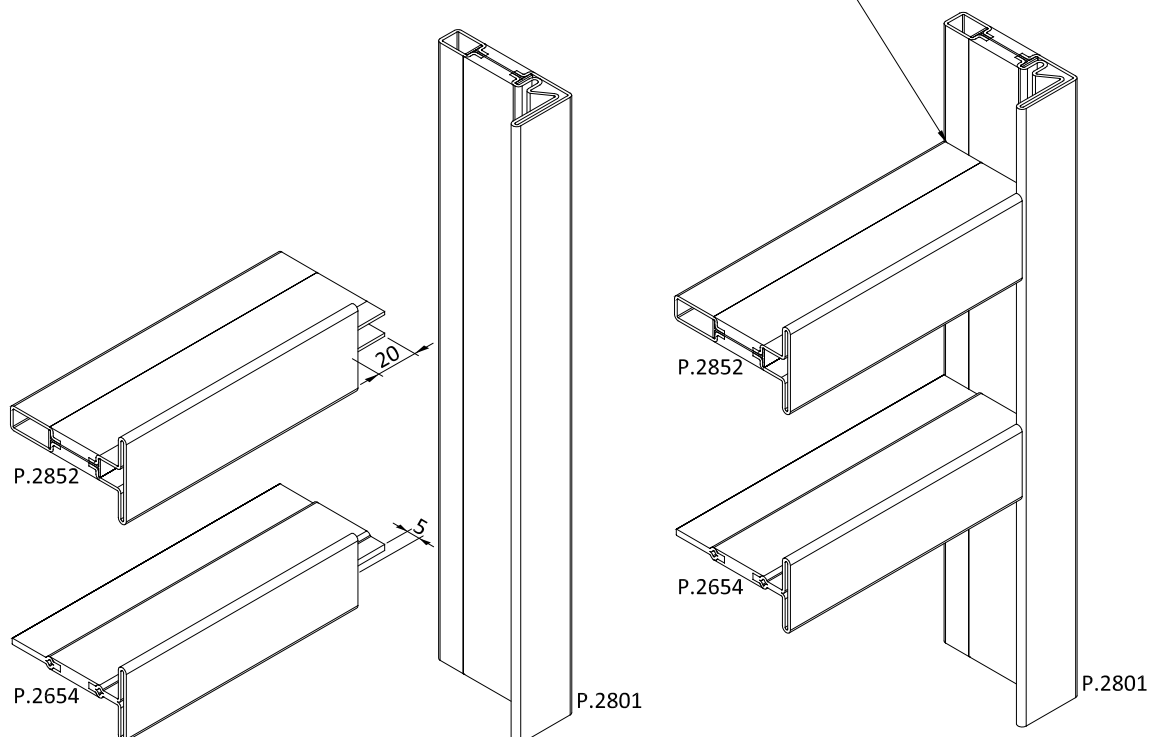
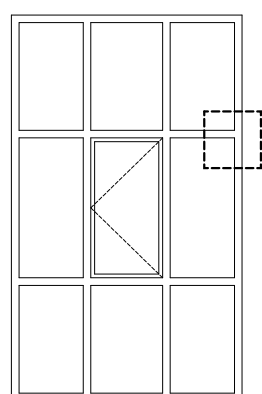
N.B. Prima di saldare l'angolo del profilo eliminare l'eventuale resina poliuretanica presente all'interno dell'aletta scaldando leggermente il profilo stesso per circa 20 mm. in modo da sciogliere la resina ed eliminare le impurità presenti

ATTN. Before welding the corner please remove any trace of polyurethane resin in the internal side of casin, heating the profile for ca. 20 mm to melt the resin and remove in this way all other impurities.

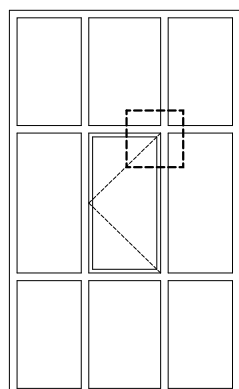
Profilo	Profile	Kit squadrette	Corner brackets set
Codice	Code	Codice	Code
P.2852-P.2852		AC 2852I	
P.2853-P.2853		AC 2853I	
P.2855-P.2855		AC 2855I	
P.2861-P.2861		AC 2801I	
P.2862-P.2862		AC 2862I	
P.2863-P.2863		AC 2803I	
P.2865-P.2865		AC 2865I	
P.2862-P.2863		AC 2832I	anta / leaf
P.2862-P.2863		AC 2801I	telaio / frame
P.2865-P.2863		AC 2803I	
P.2871-P.2871		AC 2871I	
P.2872-P.2872		AC 2872I	
P.2873-P.2873		AC 2853I	
P.2874-P.2874		AC 2855I	
P.2875-P.2875		AC 2875I	
P.2882-P.2882		AC 2822I	
P.2885-P.2885		AC 2805I	
P.2891-P.2891		AC 2891I	
P.2892-P.2892		AC 2892I	
P.2893-P.2893		AC 2892I	
P.2895-P.2895		AC 2895I	



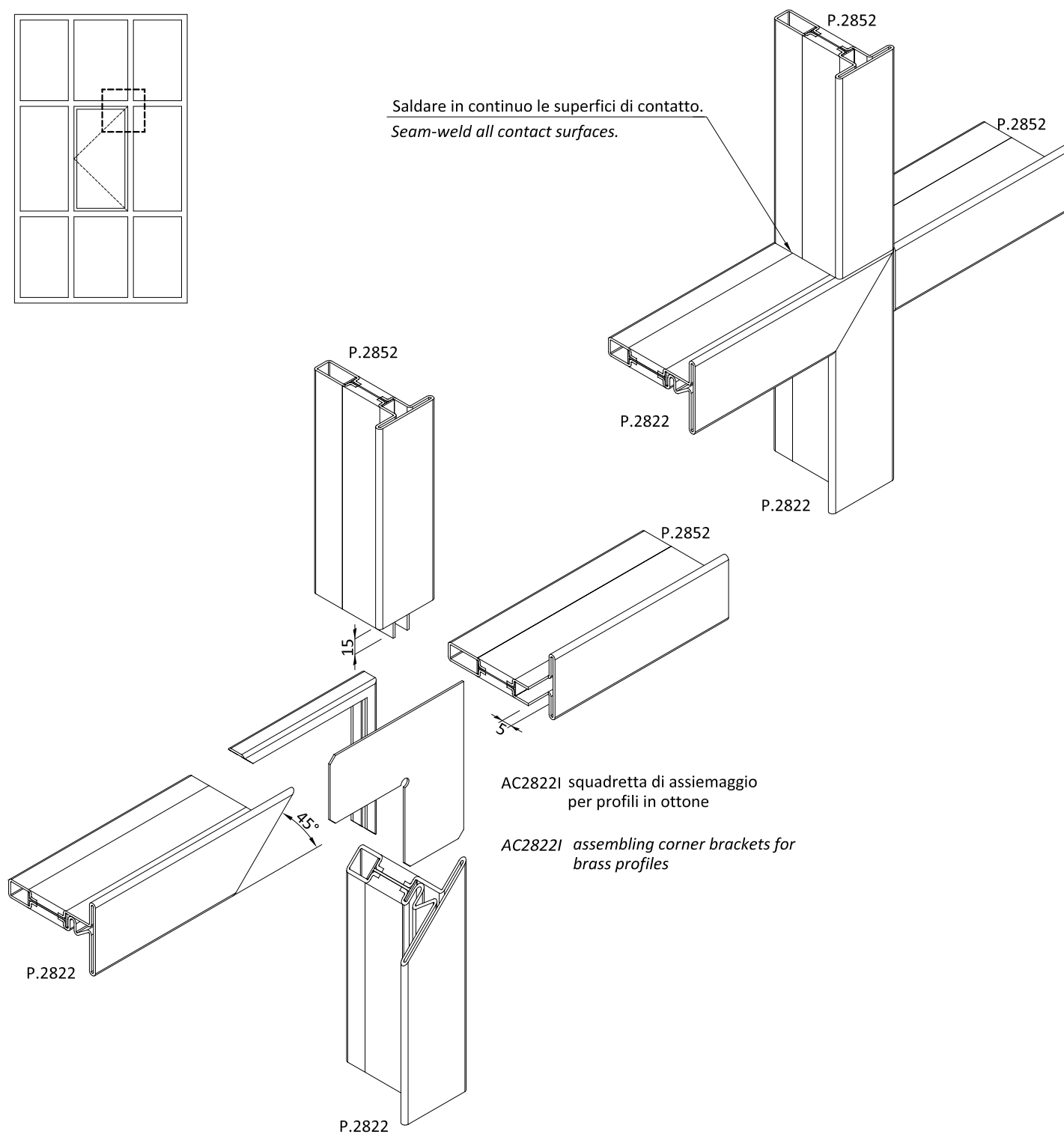
Saldare in continuo le superfici di contatto.
Seam-weld all contact surfaces.



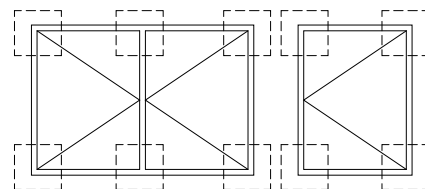
Linee guida valide per tutte le giunzioni
Same installation guide for all profiles connection



Saldare in continuo le superfici di contatto.
Seam-weld all contact surfaces.

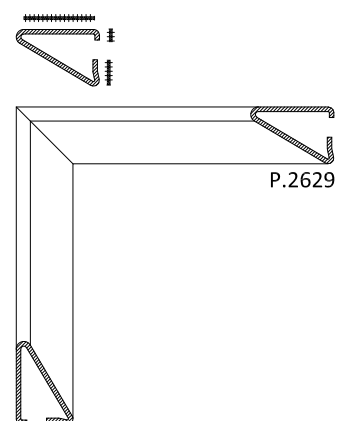
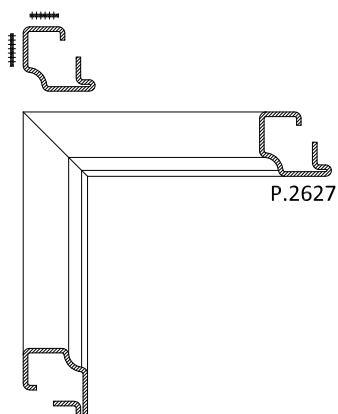
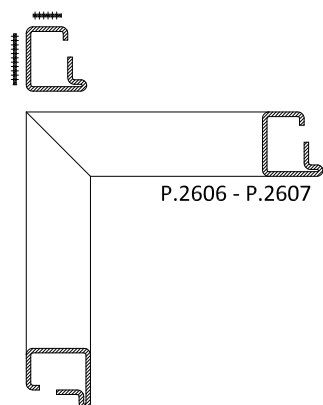


Linee guida valide per tutte le giunzioni
Same installation guide for all profiles connection



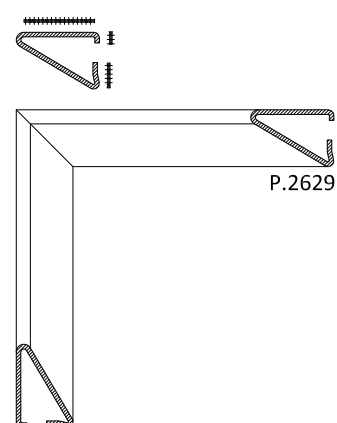
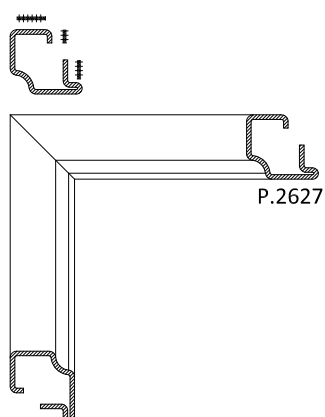
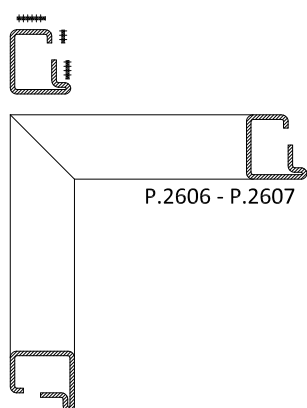
Acciaio zincato - Acciaio Corten - Acciaio inox
Saldare in continuo le superfici di contatto indicate

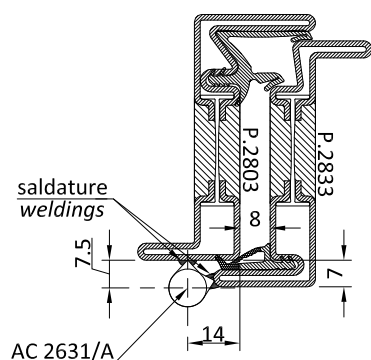
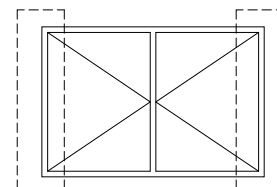
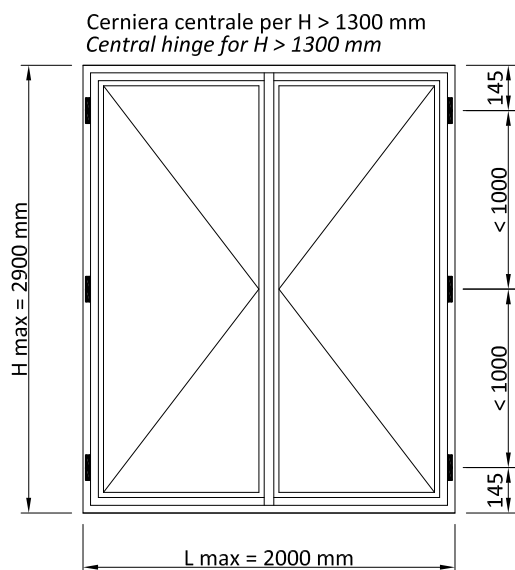
Galvanised steel - Cor-ten steel - Stainless steel
Seam-weld the shown areas



Ottone
Saldare a TIG a punti le zone indicate.

Brass
Spot weld (TIG) the marked areas.





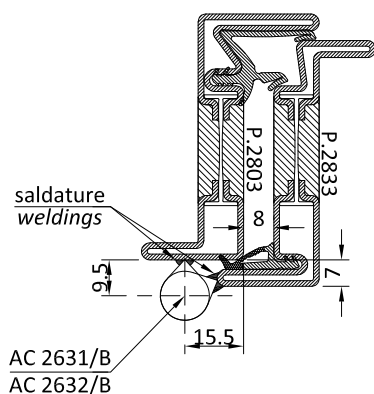
schema di fissaggio
AC 2631/A non registrabile
cerniera Ø 10
peso massimo anta 40 kg.

installation chart

AC2631/A non-adjustable

Ø 10 Hinge

Max leaf weight 40 kg



schema di fissaggio
AC 2631/B non registrabile
AC 2632/B registrabile in altezza
cerniera Ø 13
peso massimo anta 70 kg.

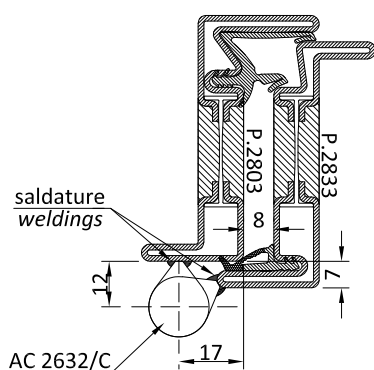
installation chart

AC2631/B non-adjustable

AC2632/B adjustable in height

Ø 13 Hinge

Max leaf weight 70 kg



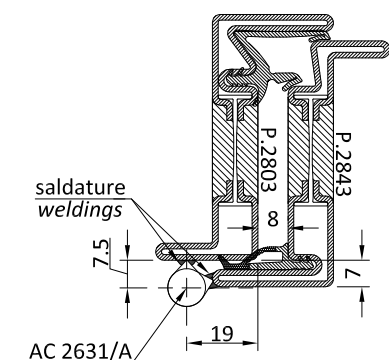
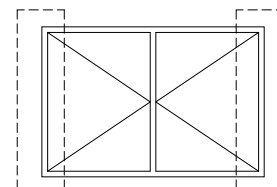
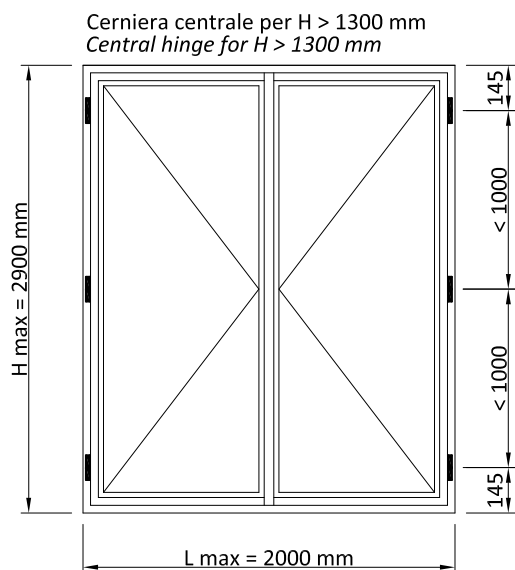
schema di fissaggio
AC 2632/C registrabile in altezza
cerniera Ø 16
peso massimo anta 80 kg.

installation chart

AC2632/C adjustable in height

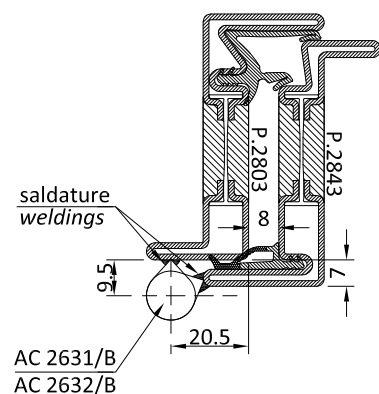
Ø 16 hinge

Max leaf weight 80 kg



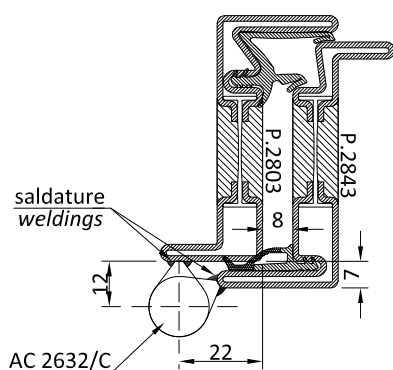
schema di fissaggio
AC 2631/A non registrabile
cerniera Ø 10
peso massimo anta 40 kg.

installation chart
AC2631/A non-adjustable
Ø 10 Hinge
Max leaf weight 40 kg



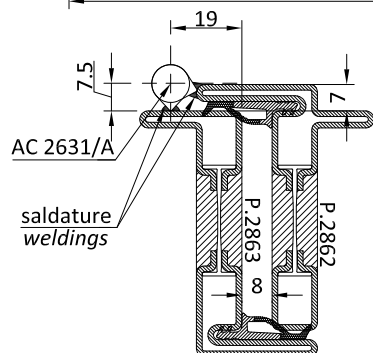
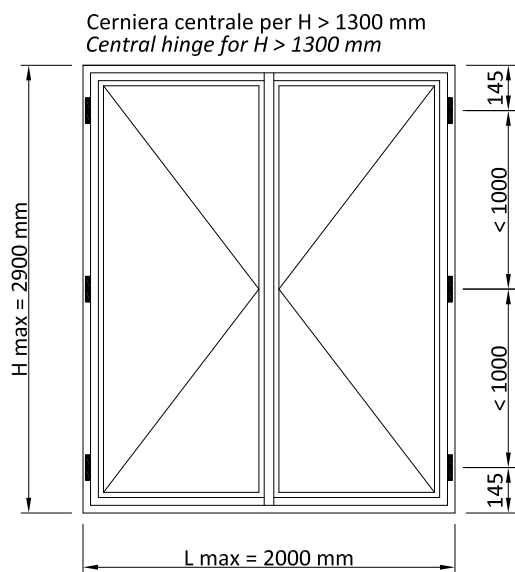
schema di fissaggio
AC 2631/B non registrabile
AC 2632/B registrabile in altezza
cerniera Ø 13
peso massimo anta 70 kg.

installation chart
AC2631/B non-adjustable
AC2632/B adjustable in height
Ø 13 Hinge
Max leaf weight 70 kg



schema di fissaggio
AC 2632/C registrabile in altezza
cerniera Ø 16
peso massimo anta 80 kg.

installation chart
AC2632/C adjustable in height
Ø 16 hinge
Max leaf weight 80 kg



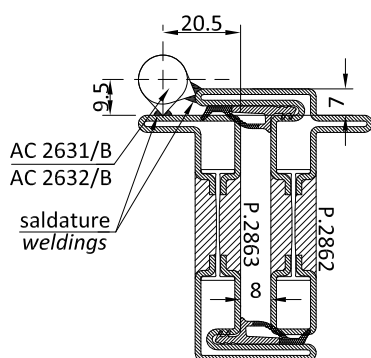
schema di fissaggio
AC 2631/A non registrabile
cerniera Ø 10
peso massimo anta 40 kg.

installation chart

AC2631/A non-adjustable

Ø 10 Hinge

Max leaf weight 40 kg



schema di fissaggio
AC 2631/B non registrabile
AC 2632/B registrabile in altezza
cerniera Ø 13
peso massimo anta 70 kg.

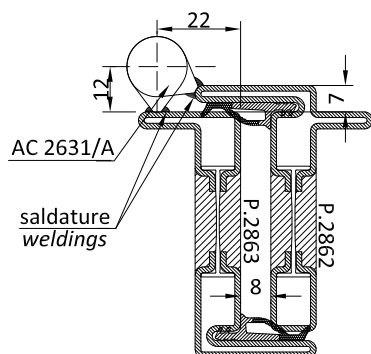
installation chart

AC2631/B non-adjustable

AC2632/B adjustable in height

Ø 13 Hinge

Max leaf weight 70 kg



schema di fissaggio
AC 2632/C registrabile in altezza
cerniera Ø 16
peso massimo anta 80 kg.

installation chart

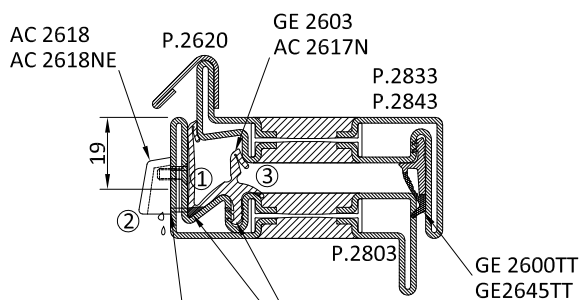
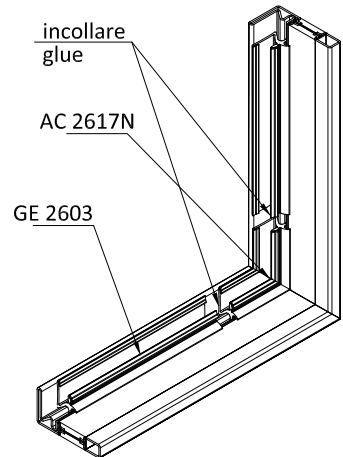
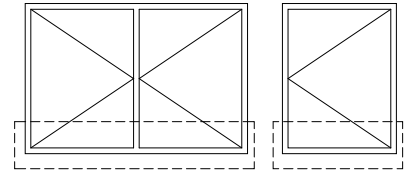
AC2632/C adjustable in height

Ø 16 hinge

Max leaf weight 80 kg

- 1) Eseguire i fori come da disegno (lavorazione effettuabile con maschera AT2618).
- 2) Posizionare lo scarico acqua e sigillare fissare con viti in dotazione Inox A2.
- 3) Posizionare la guarnizione di giunto centrale e gli angoli vulcanizzati, incollare gli angoli alla guarnizione a mezzo di colla ciano-acrilica.
- 4) Sigillare per tutta la lunghezza la base inferiore e per 150 mm in altezza il telaio.

- 1) Drill the holes as shown in the diagram (using jig AT2618).
- 2) Position the water drain, seal and secure with the supplied A2 stainless screw.
- 3) Position the central weather strip and vulcanised corner, glue the corners to the weather strip using cyanoacrylate glue.
- 4) seal the entire lower base of the frame and vertically for 150 mm

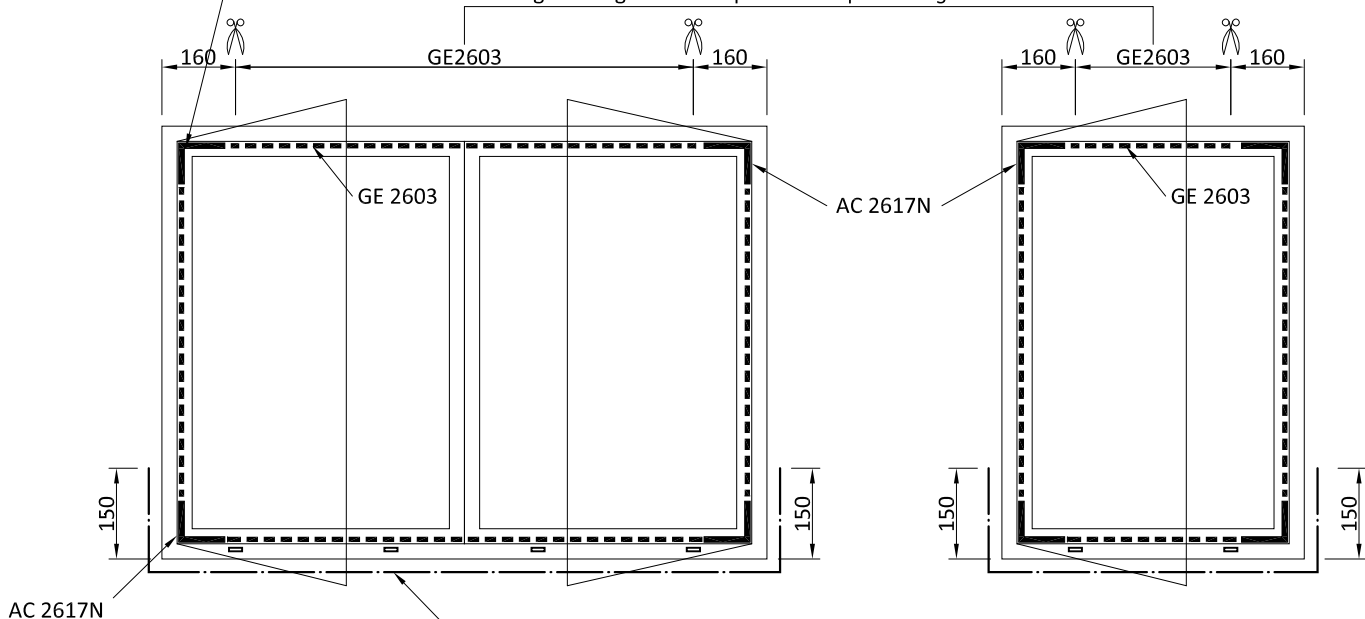


sigillare per tutta la lunghezza la base inferiore e per 150 mm in altezza il telaio.
seal the entire base of the frame and vertically for 150 mm

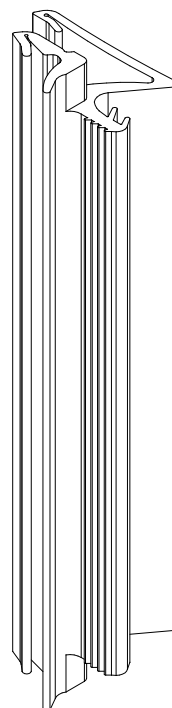
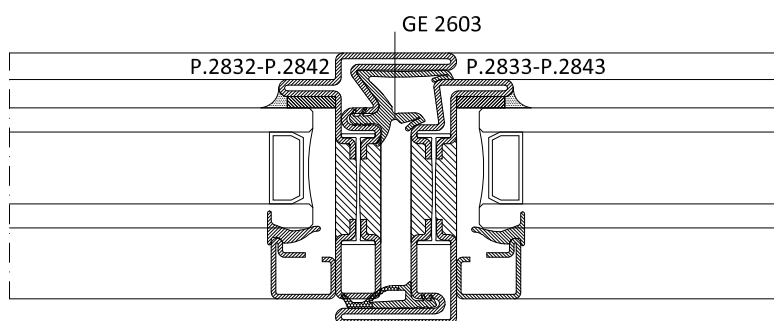
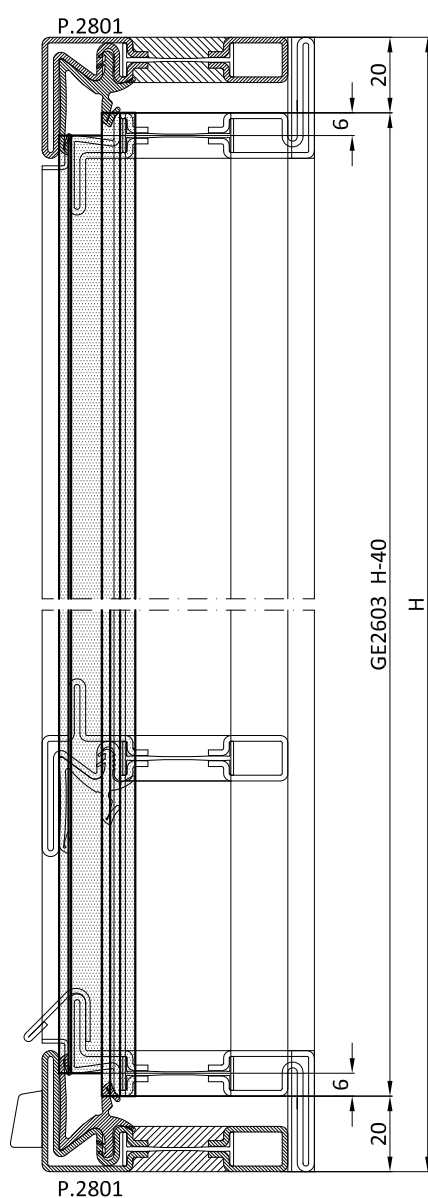
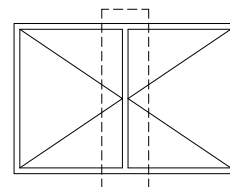
sigillare il perimetro dello scarico acqua
sigillare il perimetro dello scarico acqua

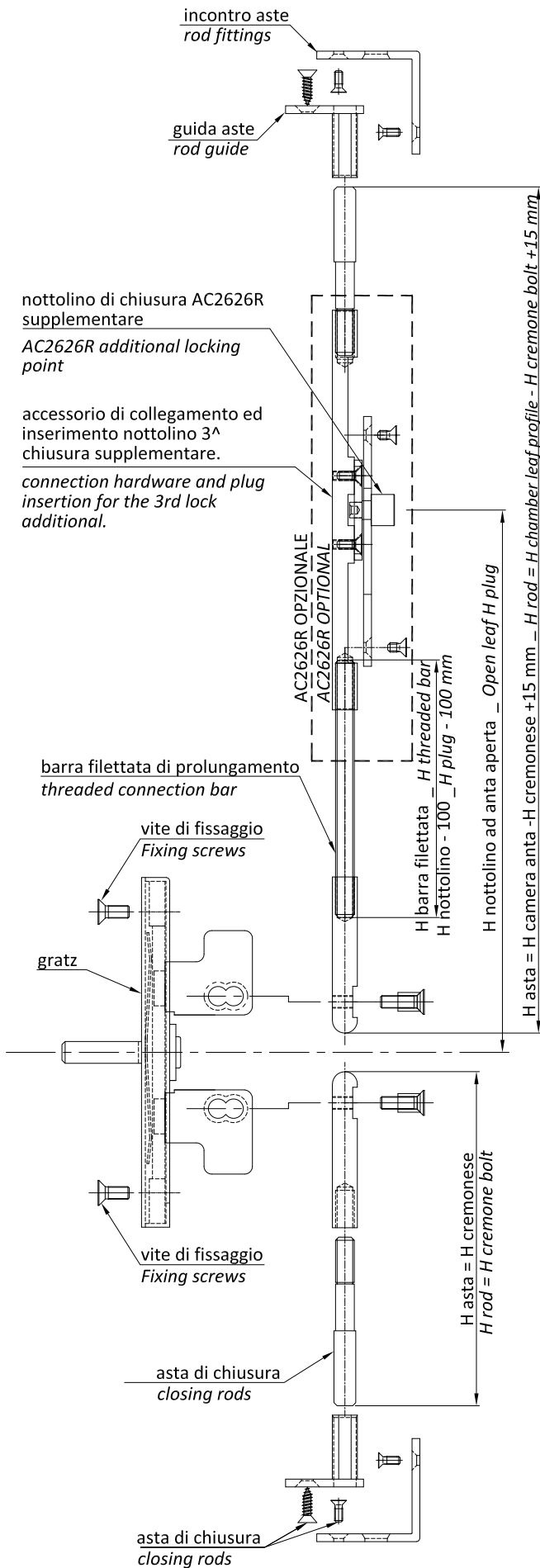
incollare gli angoli vulcanizzati AC2617 alla guarnizione con colla cianoacrilica
glue the AC2617 vulcanised corner to the gasket using cyanoacrylate glue

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



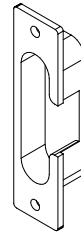
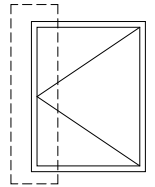
- ④ sigillare per tutta la lunghezza la base inferiore e per 150 mm in altezza il telaio.
- ④ seal the entire base of the frame and vertically for 150 mm





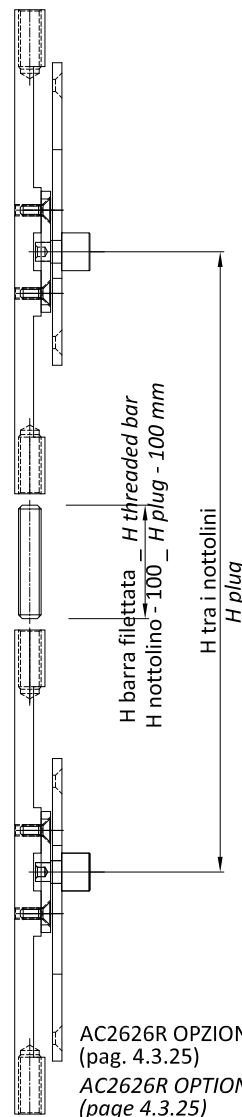
- 1) Avvitare le aste di chiusura agli accessori di collegamento.
- 2) Inserire le aste negli spacchi predisposti agli angoli dell'anta.
- 3) Inserire e fissare il GRATZ all'anta.
- 4) Fissare le aste di chiusura al GRATZ con viti M4 in dotazione.
- 5) Inserire gli accessori guida aste negli spacchi predisposti e fissati all'anta.
- 6) Fissare gli incontri al telaio.

- 1) Screw the closing rods to the connection fittings.
- 2) Insert the rods into the slits on the leaf corners.
- 3) Insert the "GRATZ" mechanism into the leaf and secure.
- 4) Secure the closing rods to the "GRATZ" mechanism using the M4 screws.
- 5) Insert the rod guides into the slits and fix them to the leaf.
- 6) Secure the fittings to the frame.

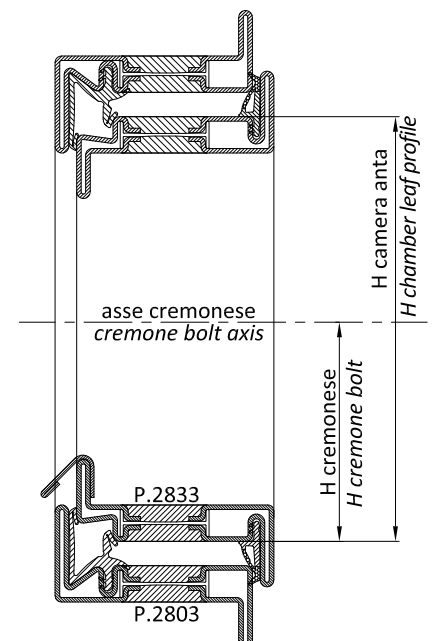


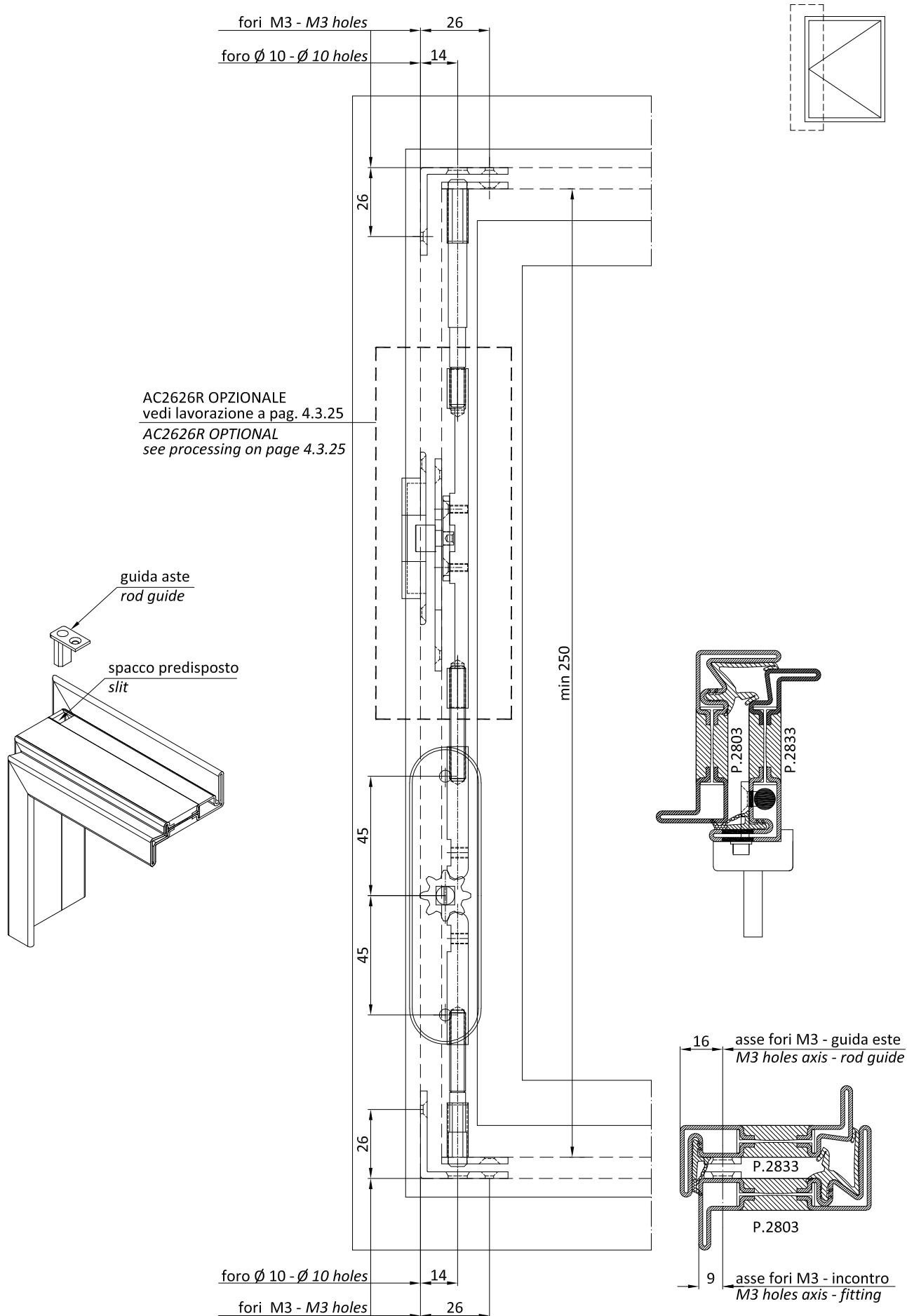
AC2626R incontro 3ª chiusura
OPZIONALE
AC2626R 3rd lock strike plate
OPTIONAL

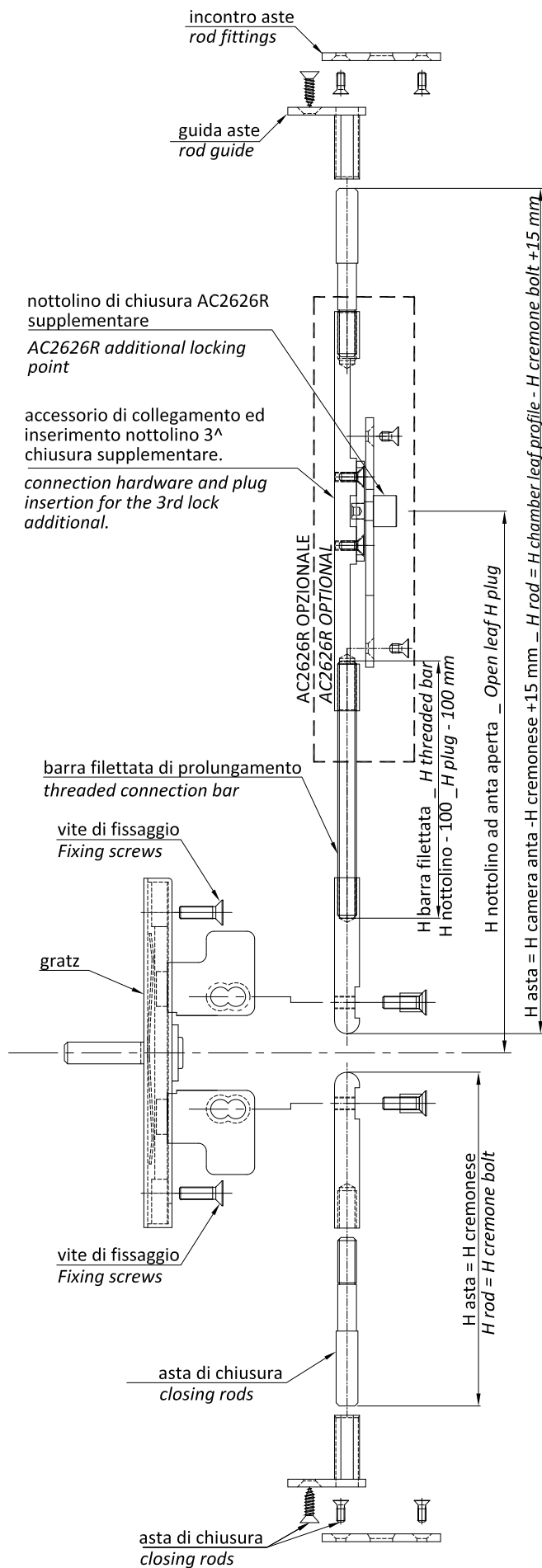
N.B. prevedere un punto di chiusura ogni 1000 mm max.
Attn. Consider one locking point every 1000 mm max.



AC2626R OPZIONALE
(pag. 4.3.25)
AC2626R OPTIONAL
(page 4.3.25)

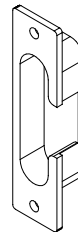






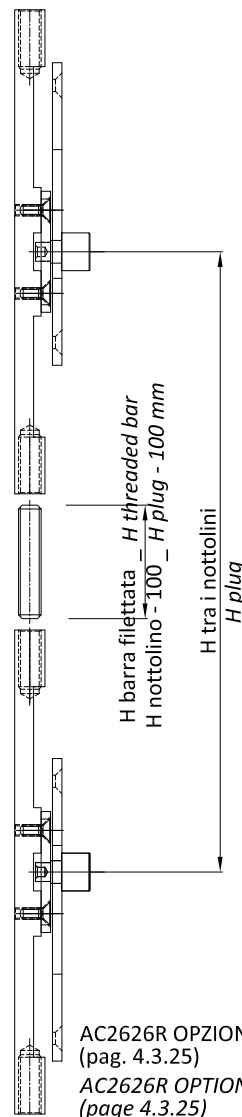
- 1) Avvitare le aste di chiusura agli accessori di collegamento.
- 2) Inserire le aste negli spacchi predisposti agli angoli dell'anta.
- 3) Inserire e fissare il GRATZ all'anta.
- 4) Fissare le aste di chiusura al GRATZ con viti M4 in dotazione.
- 5) Inserire gli accessori guida aste negli spacchi predisposti e fissati all'anta.
- 6) Fissare gli incontri al telaio.

- 1) Screw the closing rods to the connection fittings.
- 2) Insert the rods into the slits on the leaf corners.
- 3) Insert the "GRATZ" mechanism into the leaf and secure.
- 4) Secure the closing rods to the "GRATZ" mechanism using the M4 screws.
- 5) Insert the rod guides into the slits and fix them to the leaf.
- 6) Secure the fittings to the frame.

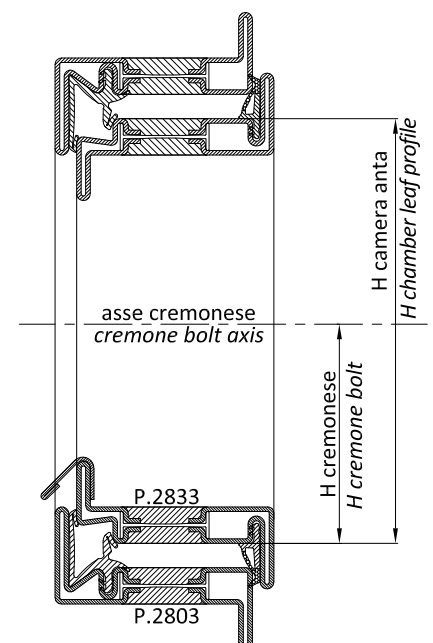


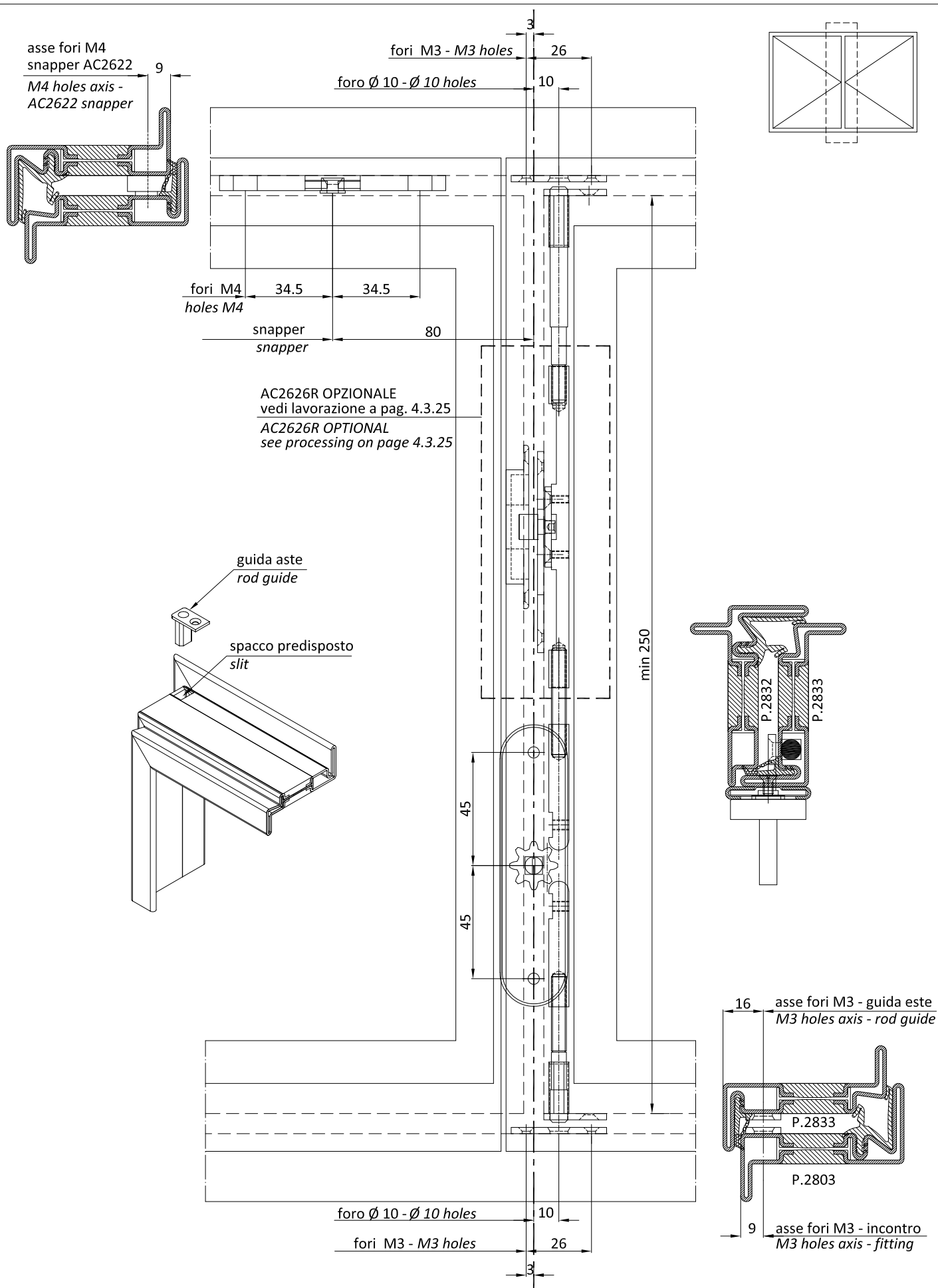
AC2626R incontro 3ª chiusura
OPZIONALE
AC2626R 3rd lock strike plate
OPTIONAL

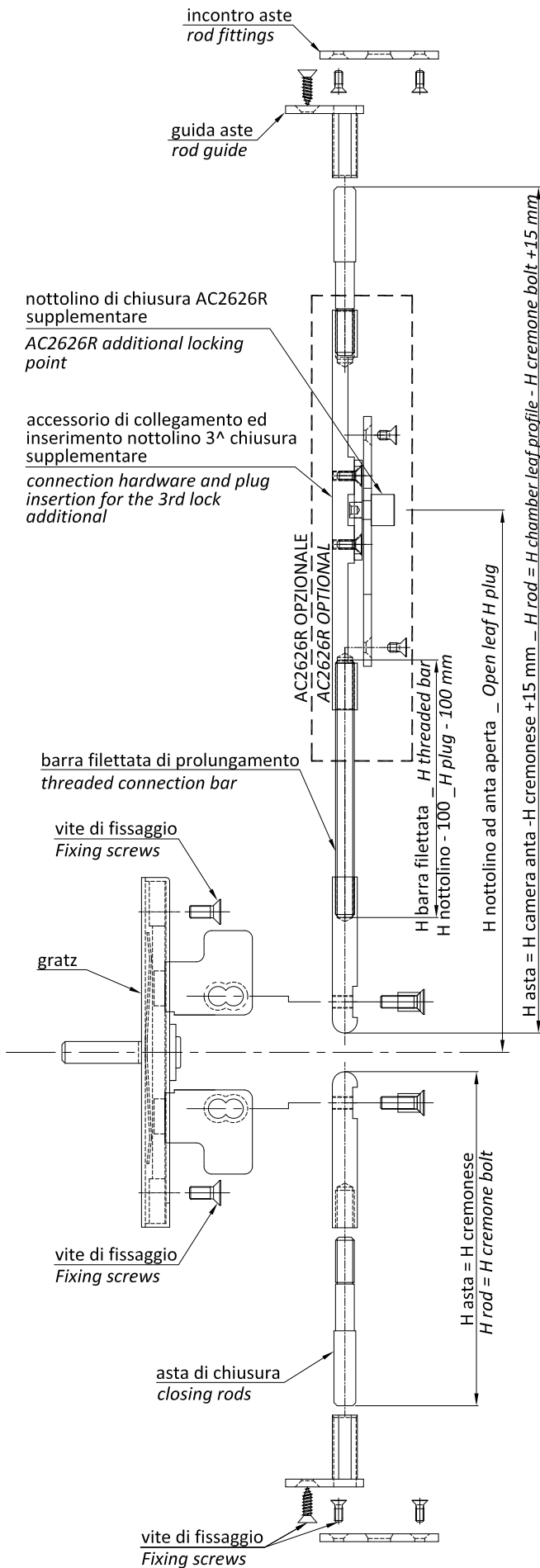
N.B. prevedere un punto di chiusura ogni 1000 mm max.
Attn. Consider one locking point every 1000 mm max.



AC2626R OPZIONALE
(pag. 4.3.25)
AC2626R OPTIONAL
(page 4.3.25)

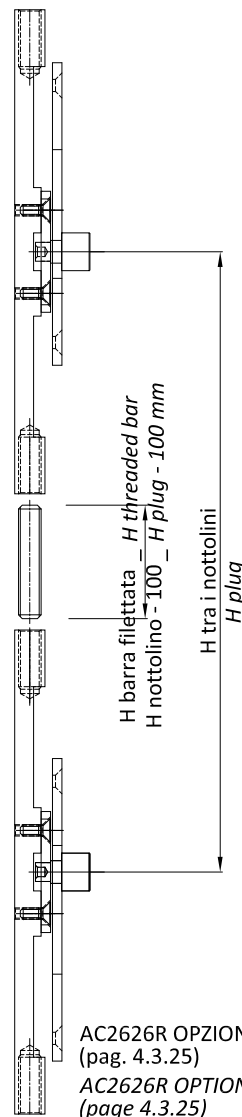
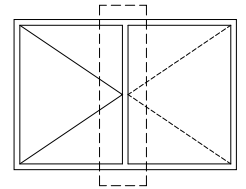




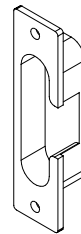


- 1) Avvitare le aste di chiusura agli accessori di collegamento
- 2) Inserire le aste negli spacchi predisposti agli angoli dell'anta
- 3) Inserire e fissare il GRATZ all'anta
- 4) Fissare le aste di chiusura al GRATZ con viti M4 in dotazione
- 5) Inserire gli accessori guida aste negli spacchi predisposti e fissarli all'anta
- 6) Fissare gli incontri al telaio

- 1) Screw the closing rods to the connection fittings
- 2) Insert the rods into the slits on the leaf corners
- 3) Insert the "GRATZ" mechanism into the leaf and secure
- 4) Secure the closing rods to the "GRATZ" mechanism using the M4 screws
- 5) Insert the rod guides into the slits and fix them to the leaf
- 6) Secure the fittings to the frame

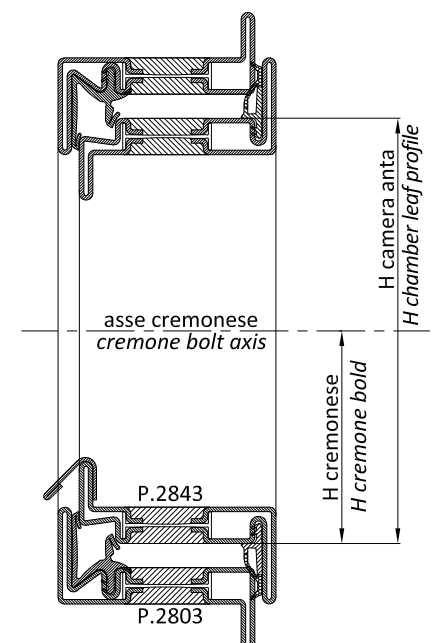


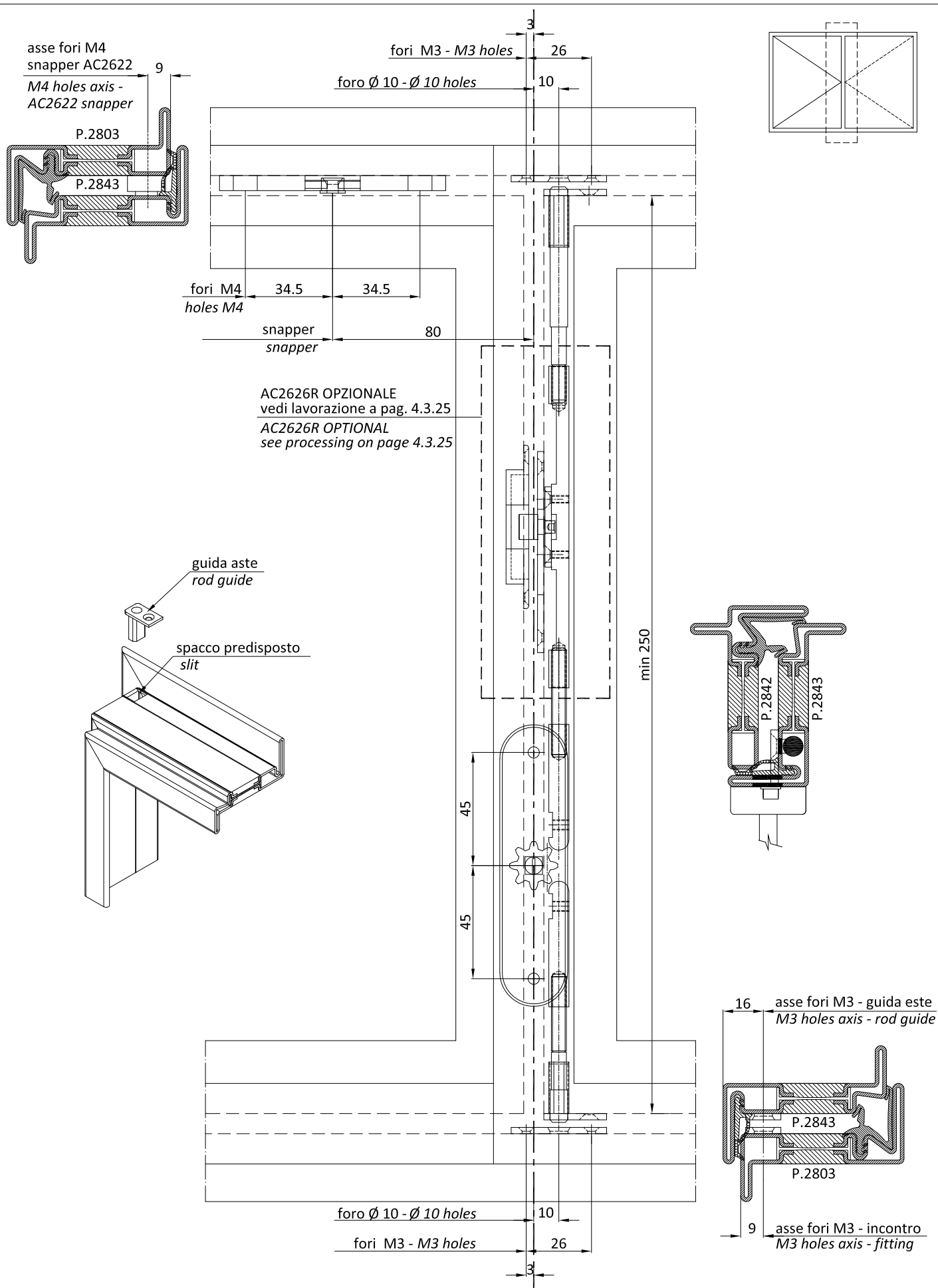
AC2626R OPZIONALE
(pag. 4.3.25)
AC2626R OPTIONAL
(page 4.3.25)

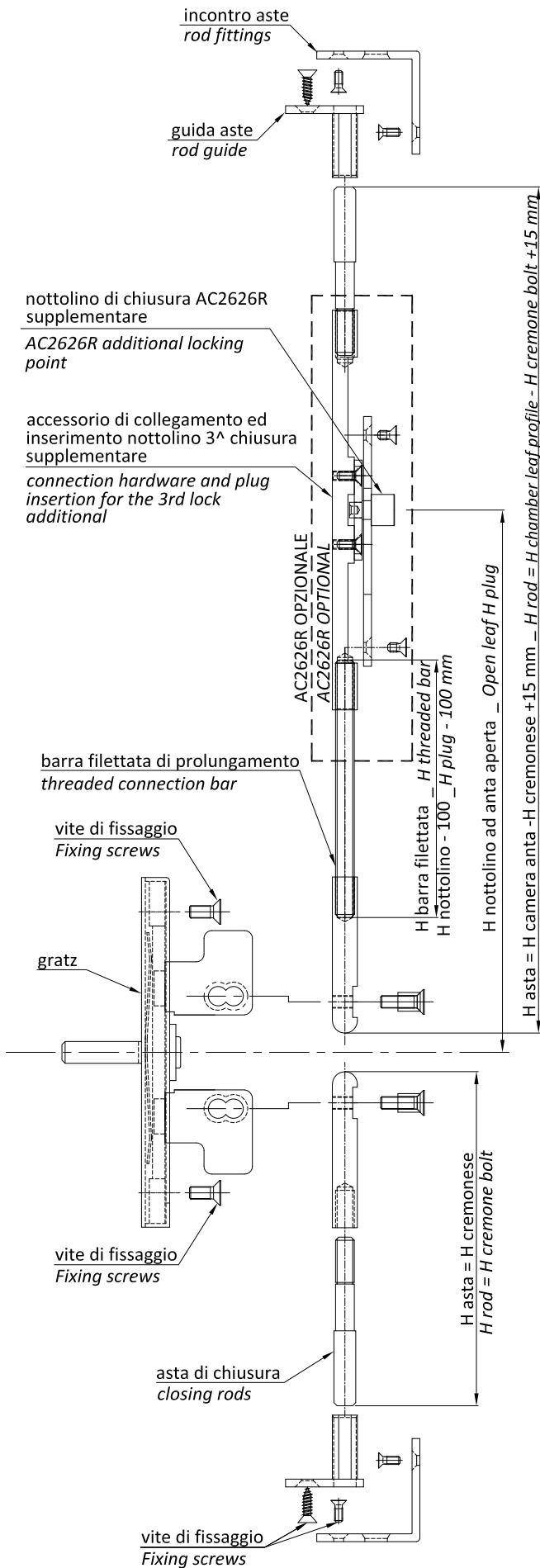


AC2626R incontro 3ª chiusura
OPZIONALE
AC2626R 3rd lock strike plate
OPTIONAL

N.B. prevedere un punto di chiusura ogni 1000 mm max.
Attn. Consider one locking point every 1000 mm max

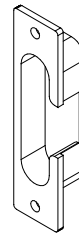






- 1) Avvitare le aste di chiusura agli accessori di collegamento
- 2) Inserire le aste negli spacchi predisposti agli angoli dell'anta
- 3) Inserire e fissare il GRATZ all'anta
- 4) Fissare le aste di chiusura al GRATZ con viti M4 in dotazione
- 5) Inserire gli accessori guida aste negli spacchi predisposti e fissati all'anta
- 6) Fissare gli incontri al telaio

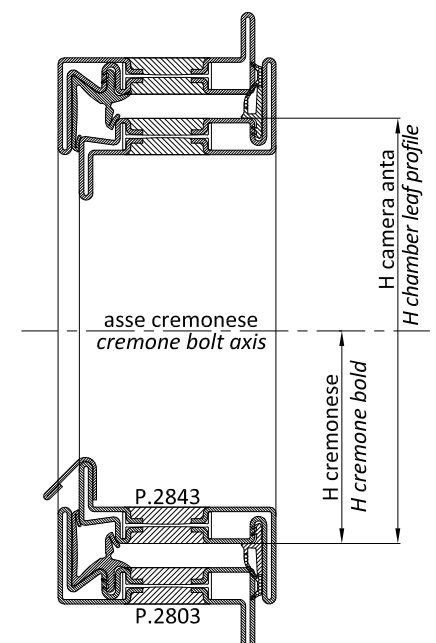
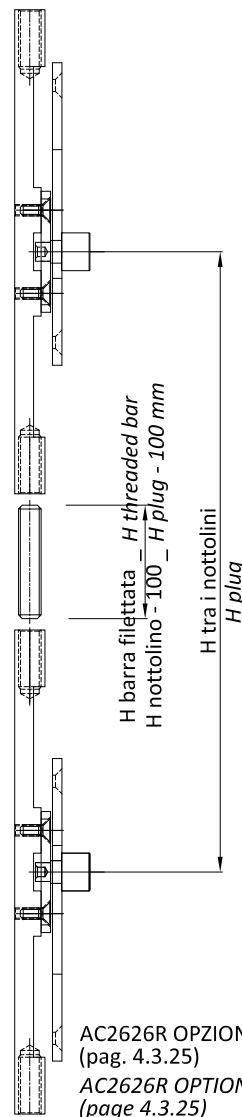
- 1) Screw the closing rods to the connection fittings
- 2) Insert the rods into the slits on the leaf corners
- 3) Insert the "GRATZ" mechanism into the leaf and secure
- 4) Secure the closing rods to the "GRATZ" mechanism using the M4 screws
- 5) Insert the rod guides into the slits and fix them to the leaf
- 6) Secure the fittings to the frame

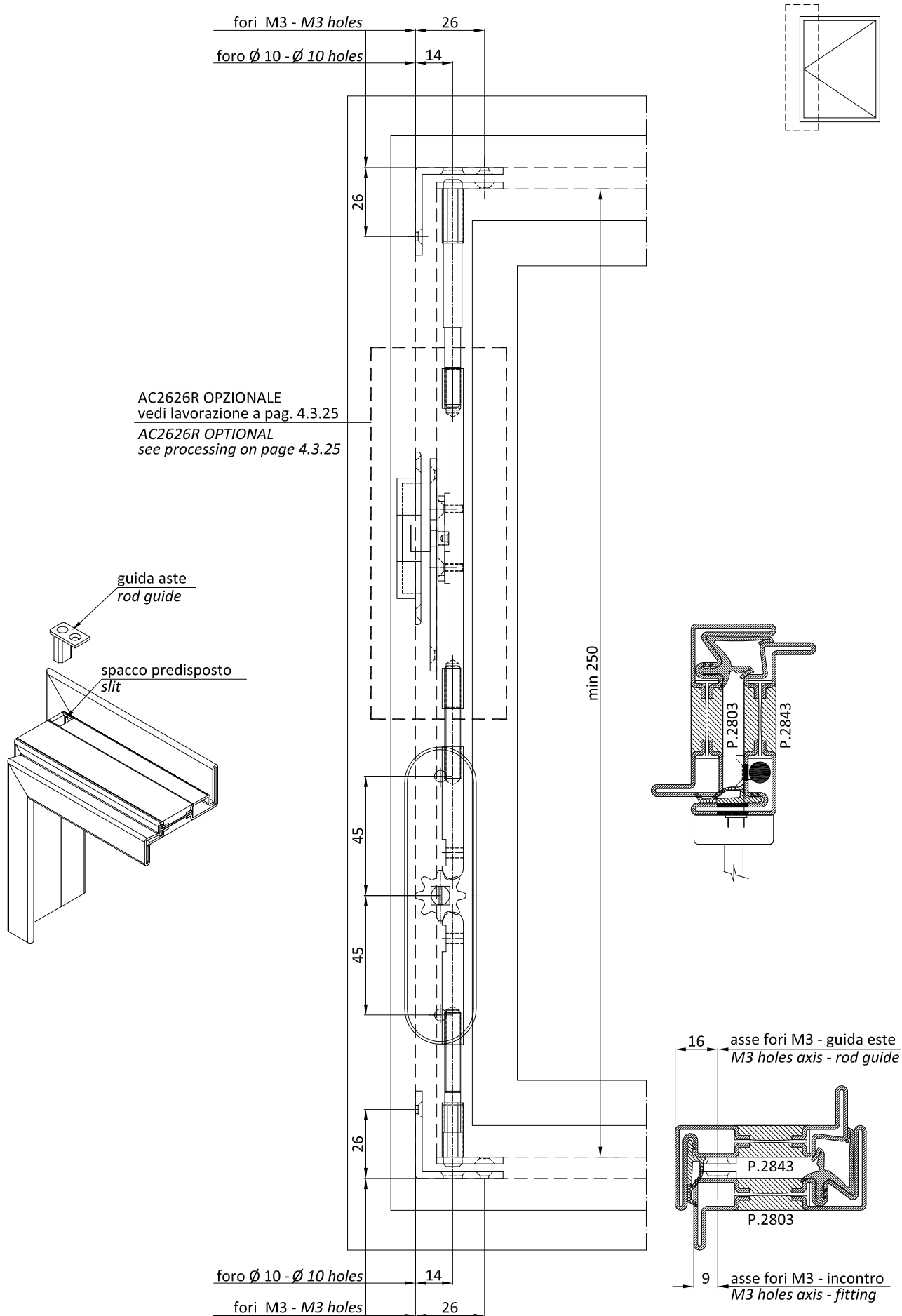


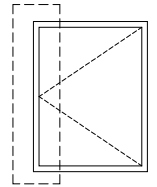
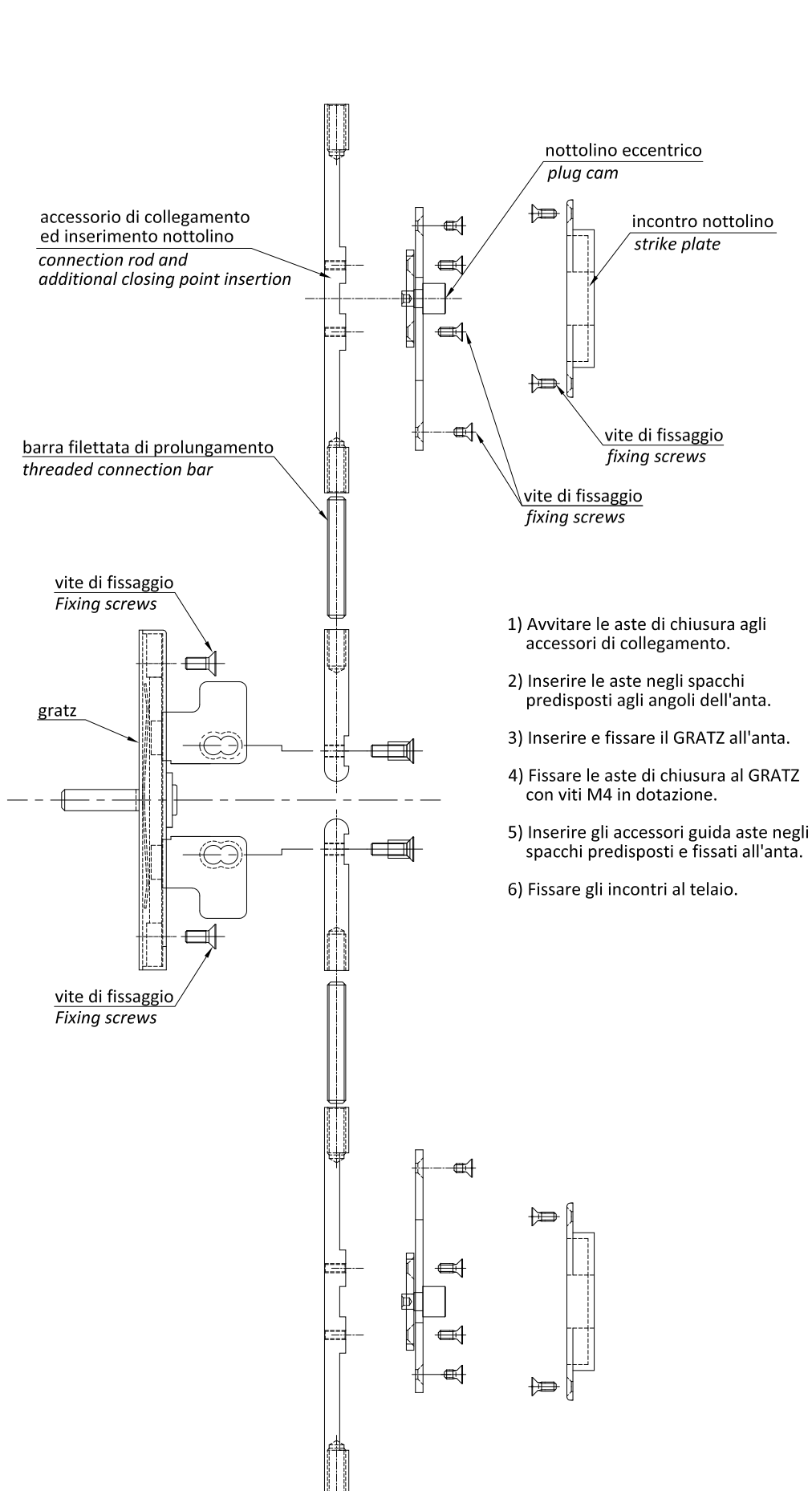
AC2626R incontro 3^a chiusura
OPZIONALE
AC2626R 3rd lock strike plate
OPTIONAL

N.B. prevedere un punto di chiusura ogni 1000 mm max.

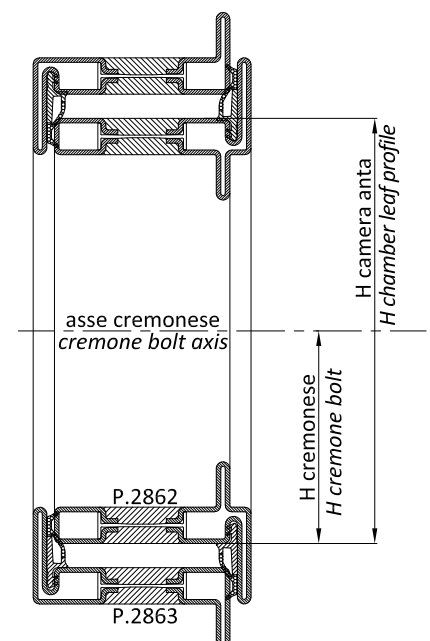
Attn. Consider one locking point every 1000 mm max

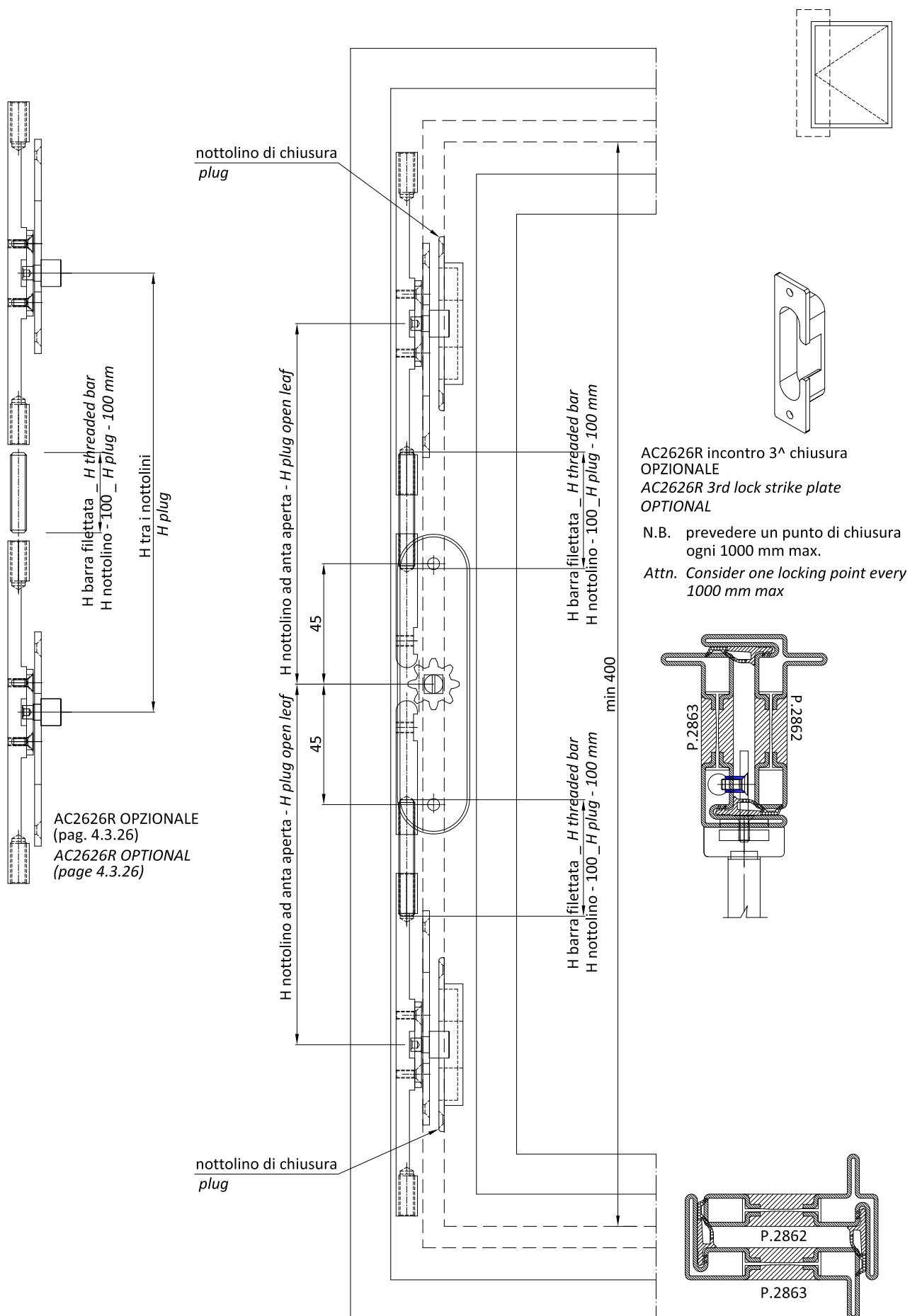


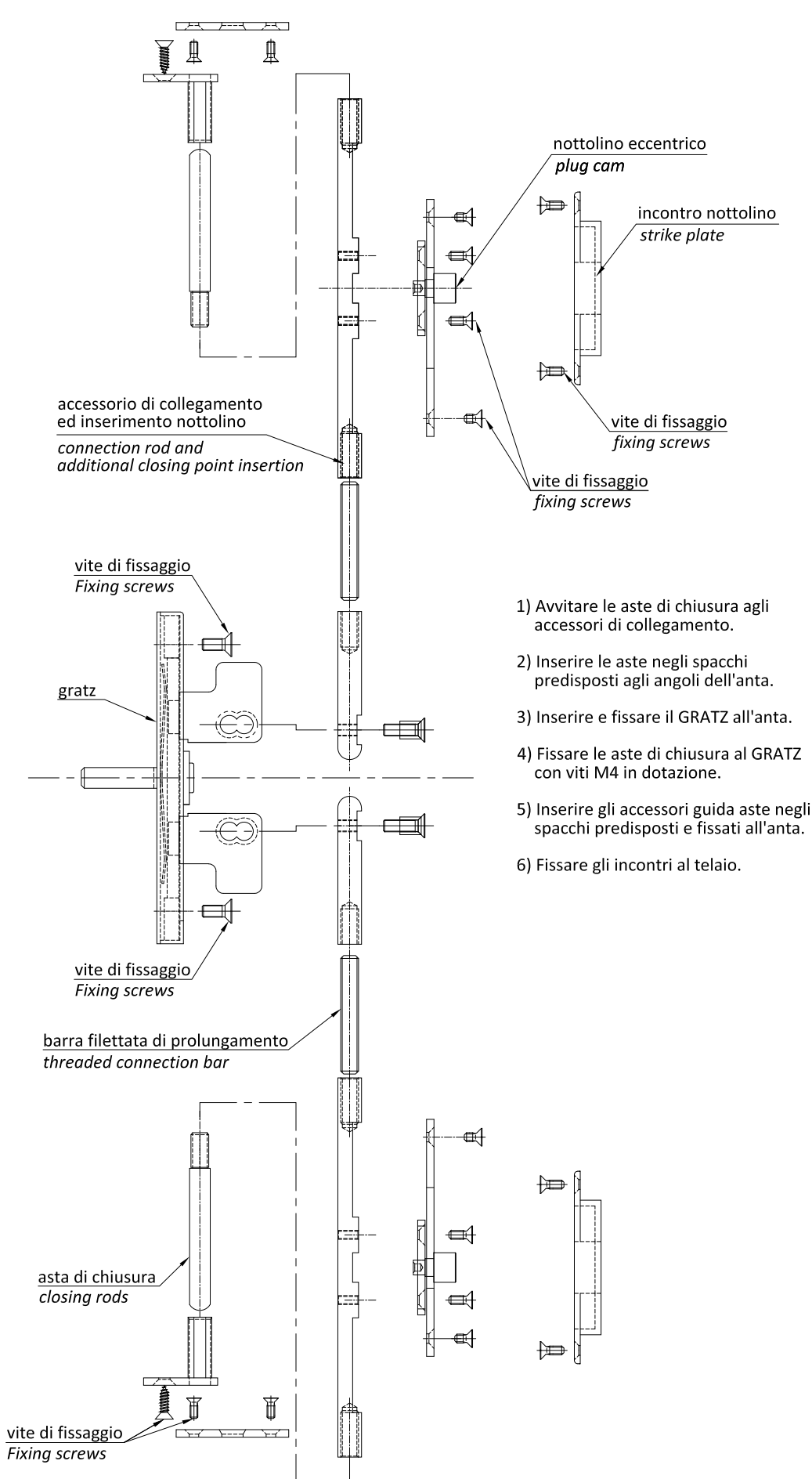




- 1) Screw the closing rods to the connection fittings.
- 2) Insert the rods into the slits on the leaf corners.
- 3) Insert the "GRATZ" mechanism into the leaf and secure.
- 4) Secure the closing rods to the "GRATZ" mechanism using the M4 screws.
- 5) Insert the rod guides into the slits and fix them to the leaf.
- 6) Secure the fittings to the frame.

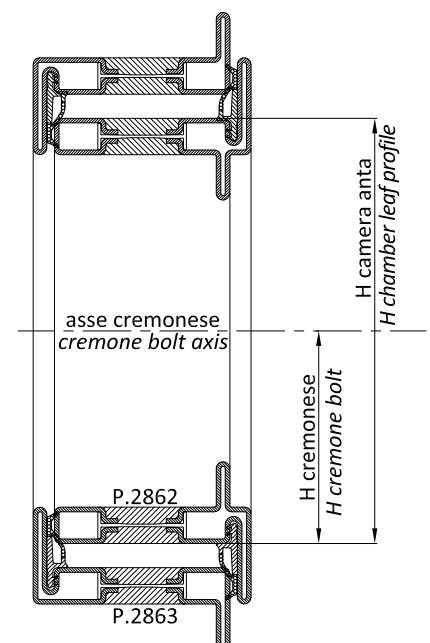


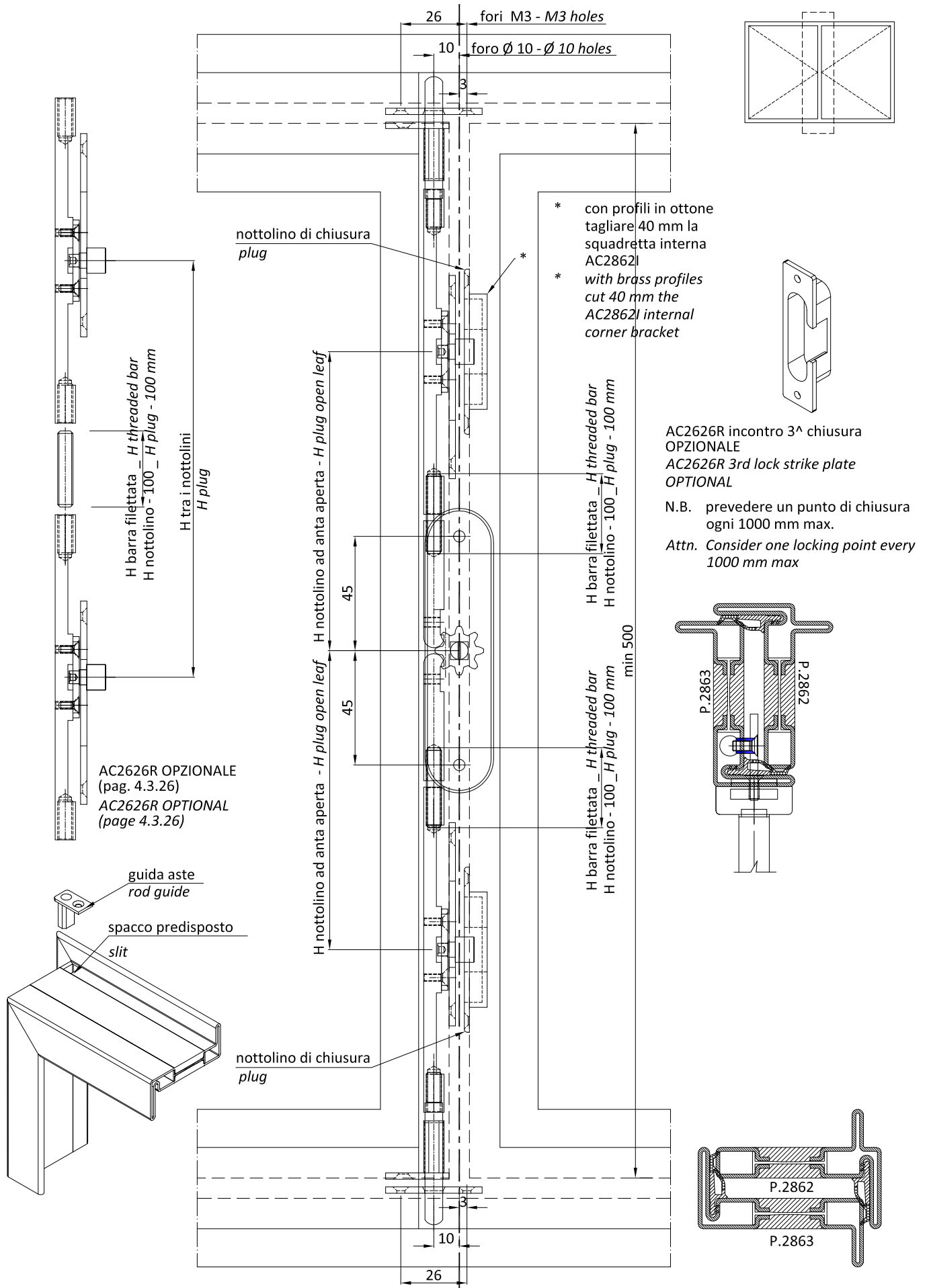


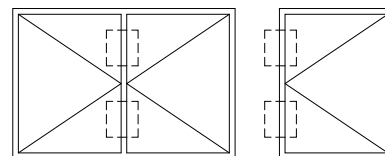
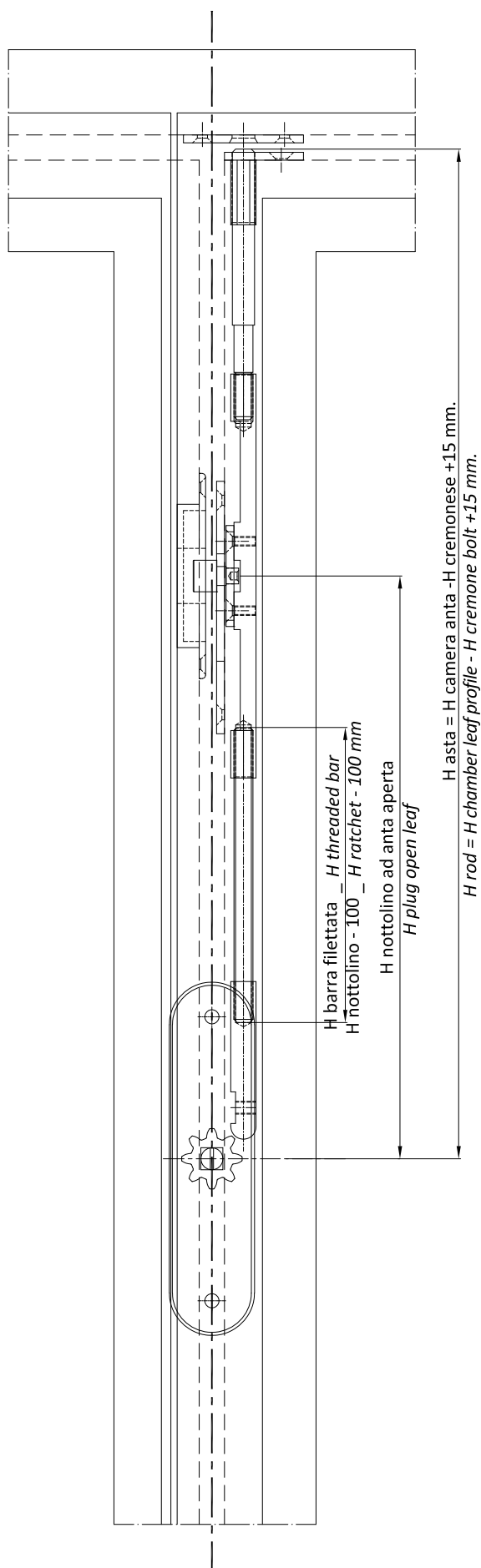


- 1) Avvitare le aste di chiusura agli accessori di collegamento.
- 2) Inserire le aste negli spacchi predisposti agli angoli dell'anta.
- 3) Inserire e fissare il GRATZ all'anta.
- 4) Fissare le aste di chiusura al GRATZ con viti M4 in dotazione.
- 5) Inserire gli accessori guida aste negli spacchi predisposti e fissati all'anta.
- 6) Fissare gli incontri al telaio.

- 1) Screw the closing rods to the connection fittings.
- 2) Insert the rods into the slits on the leaf corners.
- 3) Insert the "GRATZ" mechanism into the leaf and secure.
- 4) Secure the closing rods to the "GRATZ" mechanism using the M4 screws.
- 5) Insert the rod guides into the slits and fix them to the leaf.
- 6) Secure the fittings to the frame.

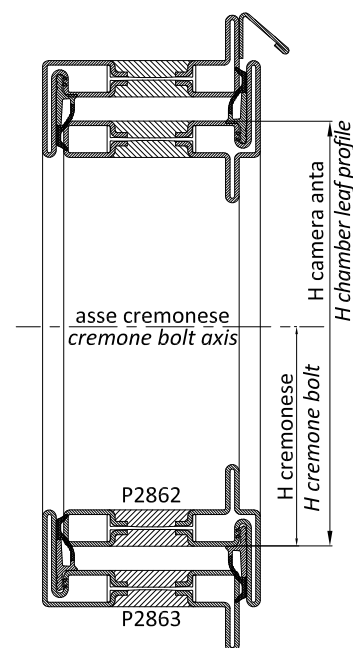
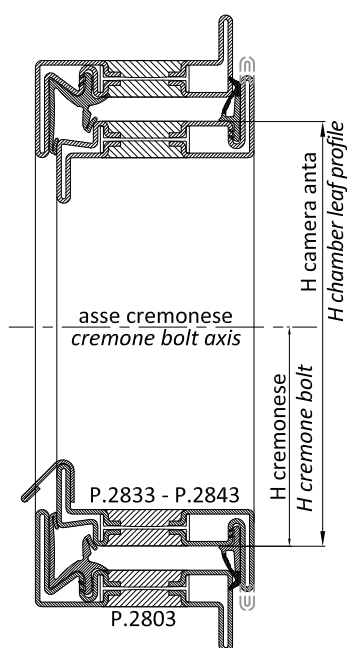
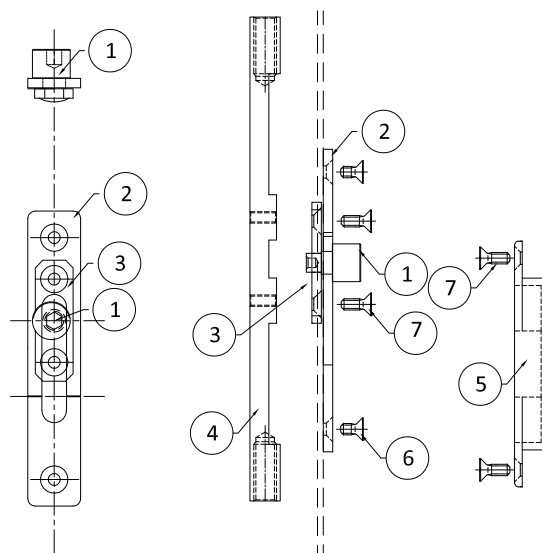


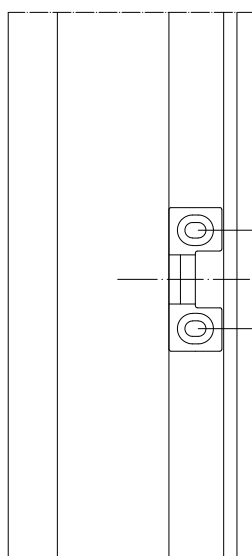
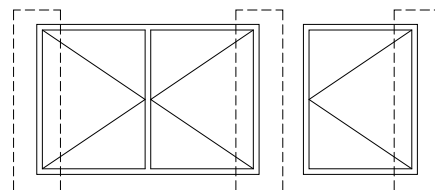
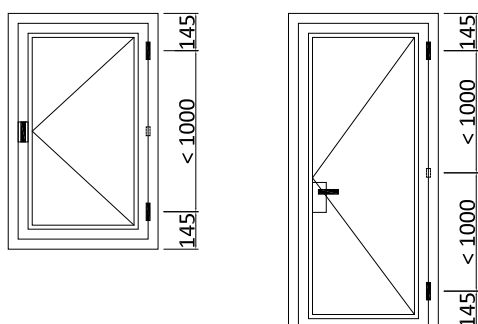




- 1) Rullino eccentrico
- 2) Piastra di fissaggio
- 3) Piastra di collegamento
- 4) Accessorio aggancio aste
- 5) Incontro 3^a chiusura
- 6) viti M3 x 6
- 7) viti M3 x 8

- 1) Barrel cam
- 2) Installation plate
- 3) Connecting plate
- 4) Rod docking accessory
- 5) 3rd lock strike plate
- 6) screws M3 x 6
- 7) screws M3 x 8

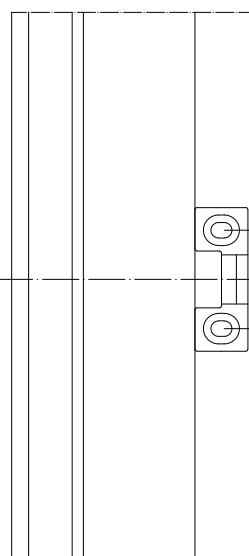




asse fori filettati M4
M4 threaded holes axis

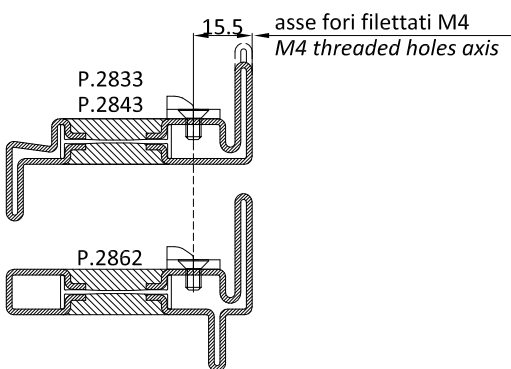
asse chiusura mediana
middle closing axis

26



asse fori filettati M4
M4 threaded holes axis

26

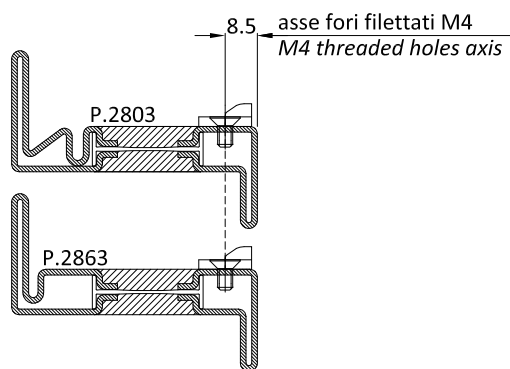


asse fori filettati M4
M4 threaded holes axis

P.2833
P.2843

P.2862

15.5

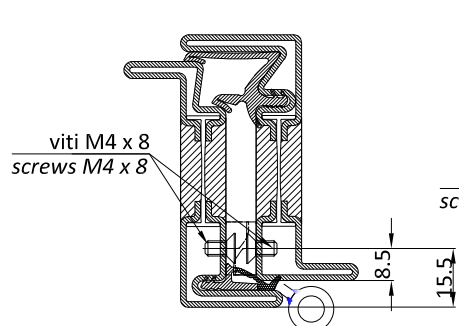


asse fori filettati M4
M4 threaded holes axis

P.2803

P.2863

8.5

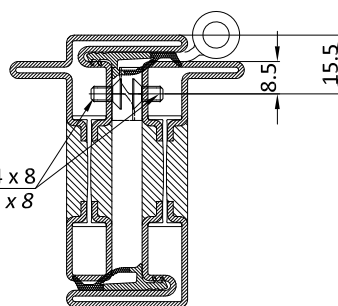


viti M4 x 8
screws M4 x 8

viti M4 x 8
screws M4 x 8

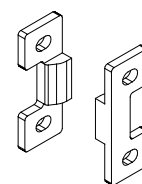
8.5

15.5



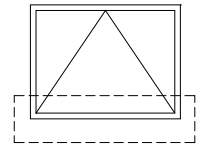
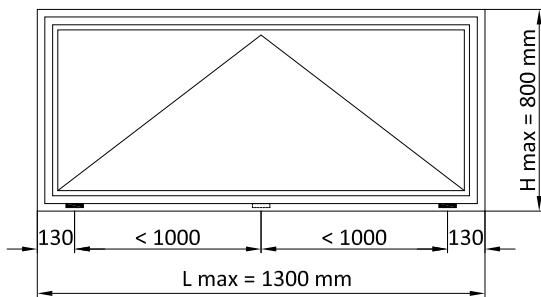
8.5

15.5



chiusura mediana
Middle closing

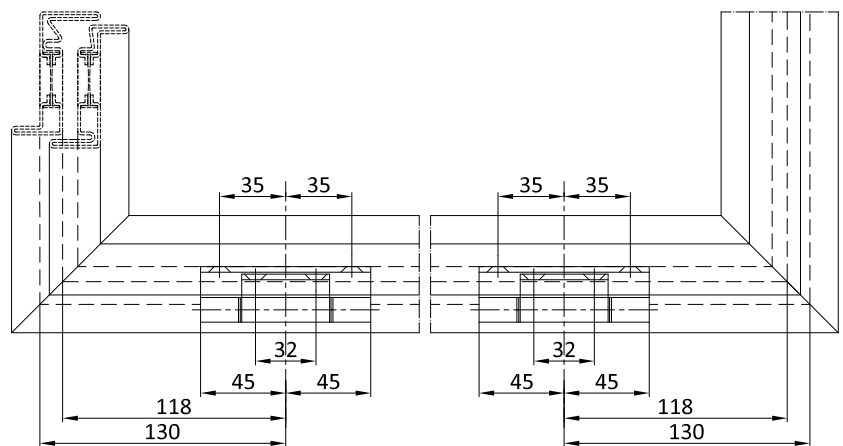
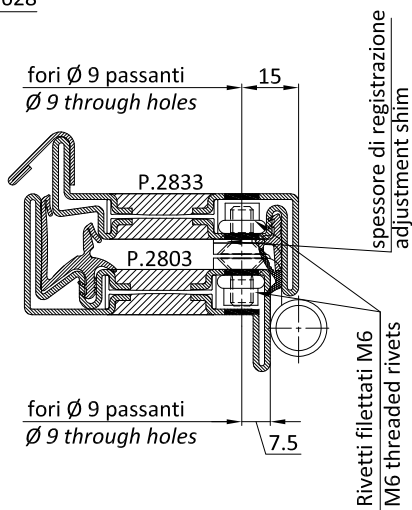
peso max. per anta: 40 kg
max. leaf weight: 40 kg



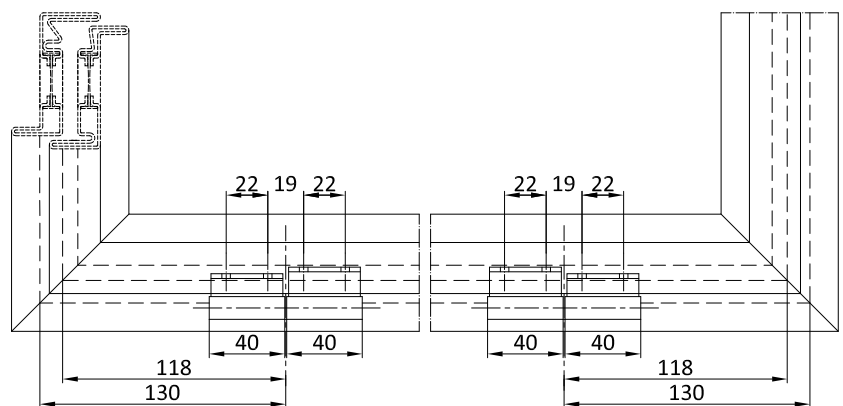
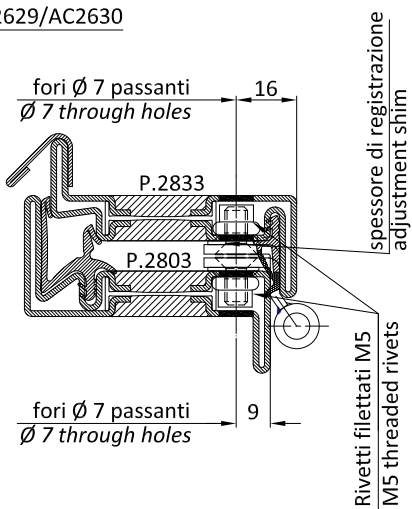
NOTA: Con cerniere AC2628, AC2629 e AC2630 installare braccetti limitatori AC2641

ATTN: With hinges AC2628, AC2629 and AC2630 please install the restrictor stay AC2641

AC2628



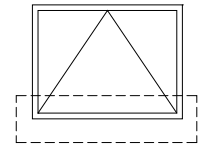
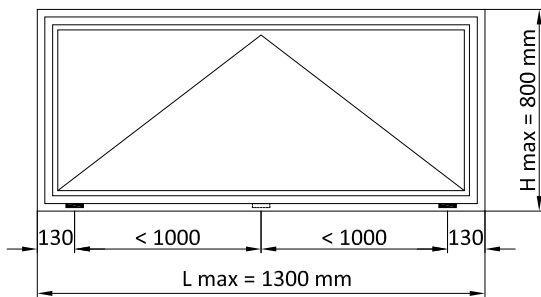
AC2629/AC2630



NOTA: Per vasistas installare una cerniera destra AC2629 e una cerniera sinistra AC2630

ATTN: For top hung windows please install one right hinge AC2629 and one left hinge AC2630

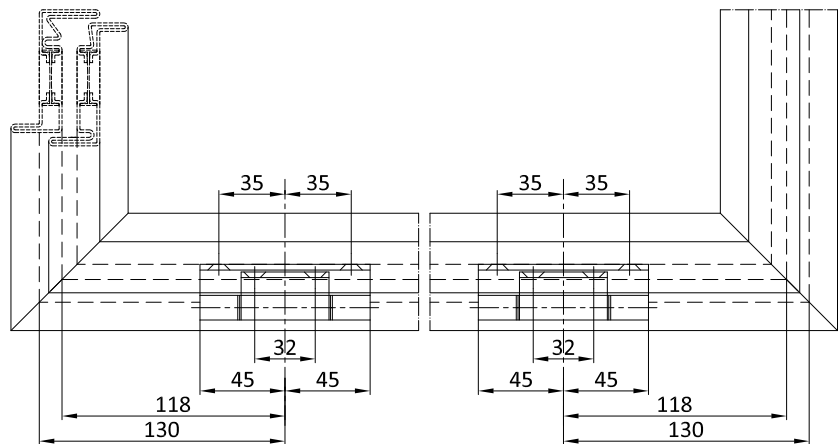
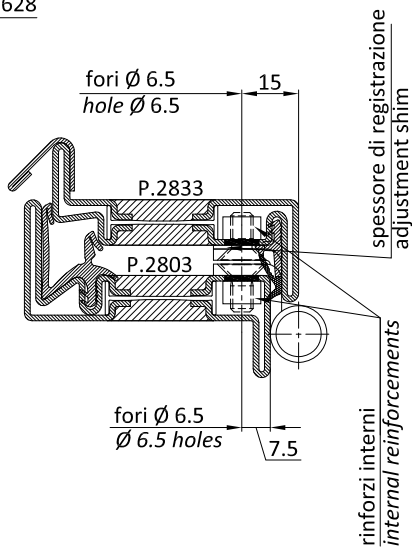
peso max. per anta: 40 kg
max. leaf weight: 40 kg



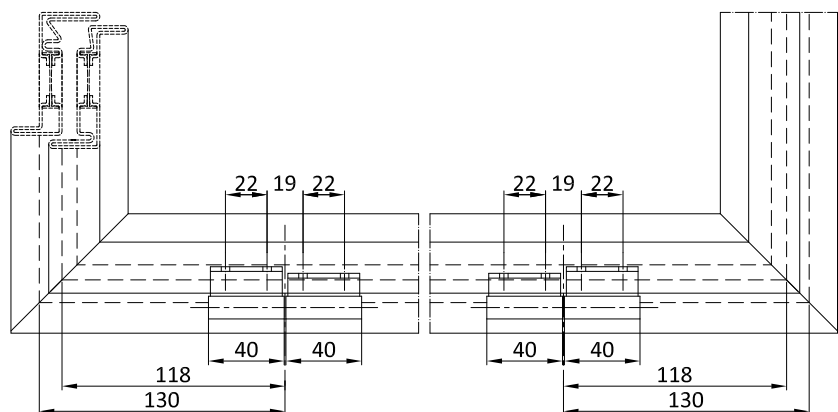
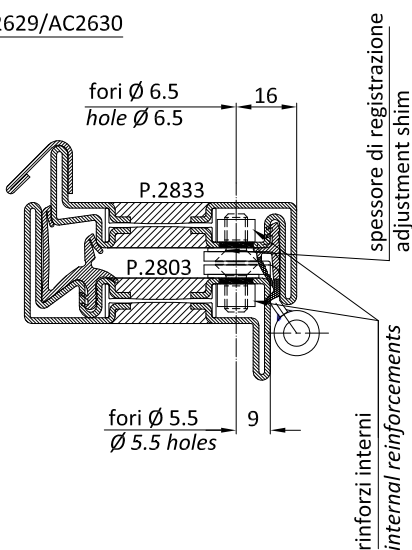
NOTA: Con cerniere AC2628, AC2629 e AC2630
installare braccetti limitatori AC2641

ATTN: With hinges AC2628, AC2629 and AC2630
please install the restrictor stay AC2641

AC2628



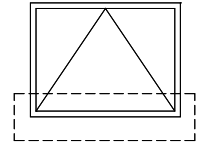
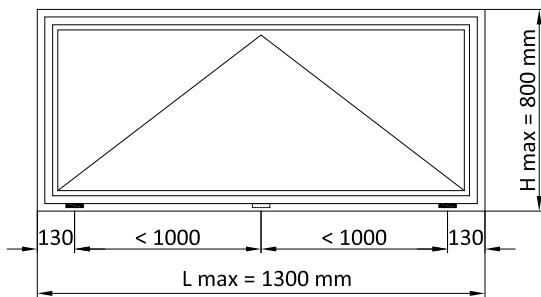
AC2629/AC2630



NOTA: Per vasistas installare una cerniera destra
AC2629 e una cerniera sinistra AC2630

ATTN: For top hung windows please install one right
hinge AC2629 and one left hinge AC2630

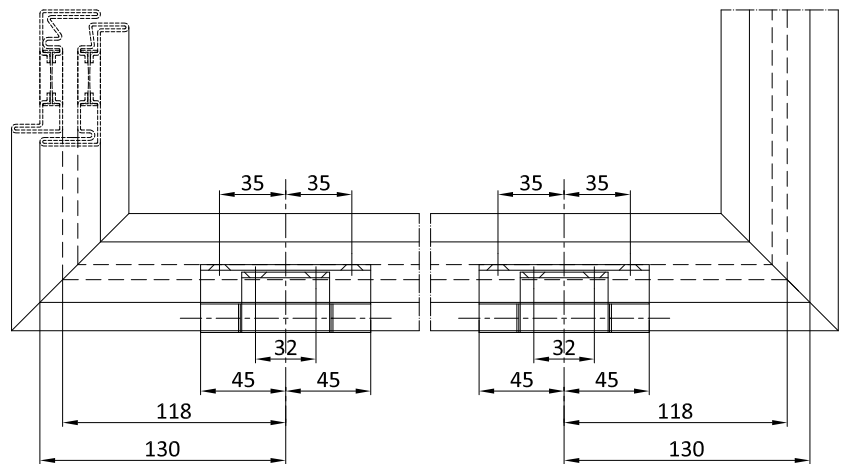
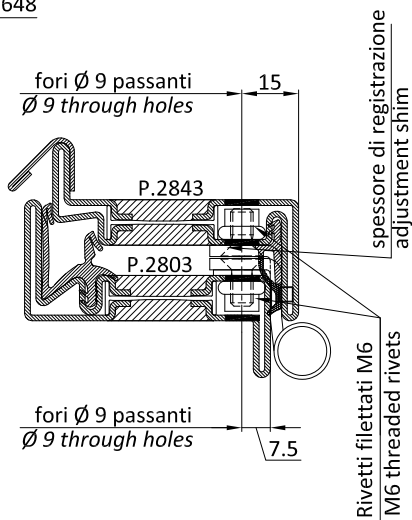
peso max. per anta: 40 kg
max. leaf weight: 40 kg



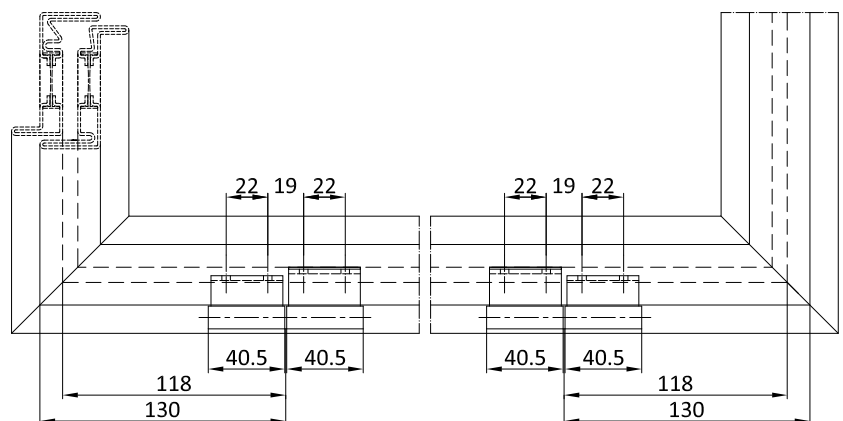
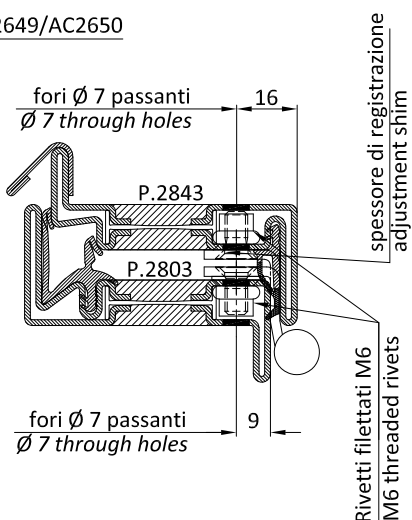
NOTA: Con cerniere AC2648, AC2649 e AC2650
installare braccetti limitatori AC2641

ATTN: With hinges AC2648, AC2649 and AC2650
please install the restrictor stay AC2641

AC2648



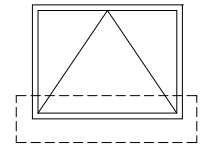
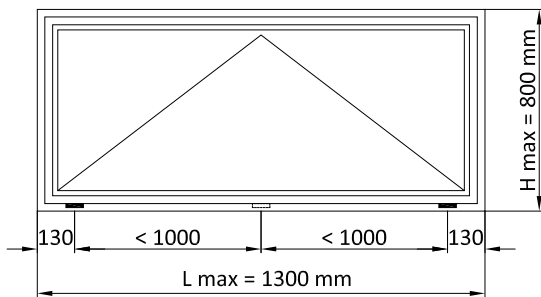
AC2649/AC2650



NOTA: Per vasistas installare una cerniera destra
AC2649 e una cerniera sinistra AC2650

ATTN: For top hung windows please install one right
hinge AC2649 and one left hinge AC2650

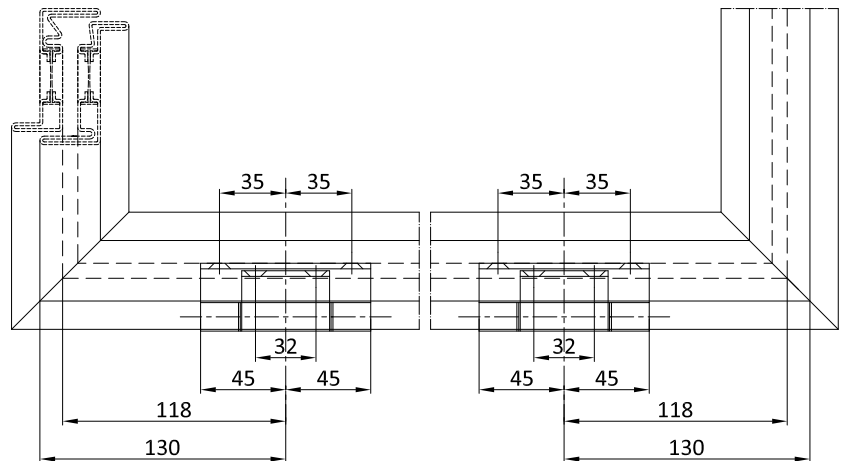
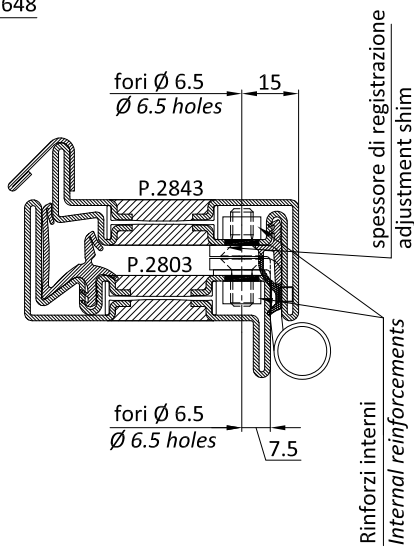
peso max. per anta: 40 kg
max. leaf weight: 40 kg



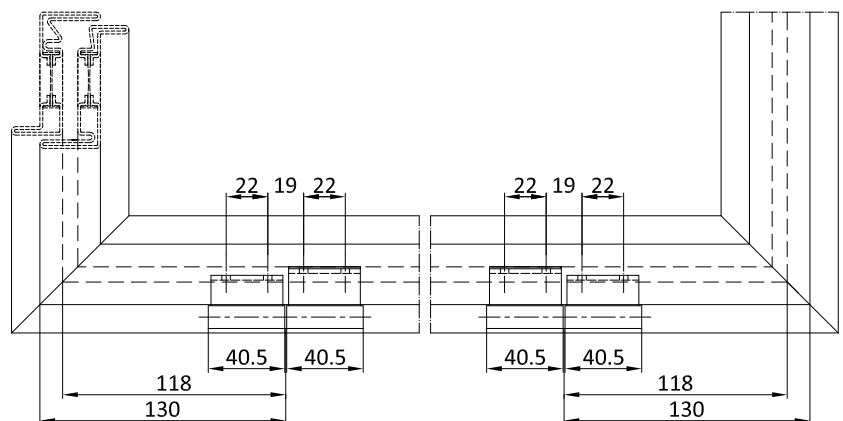
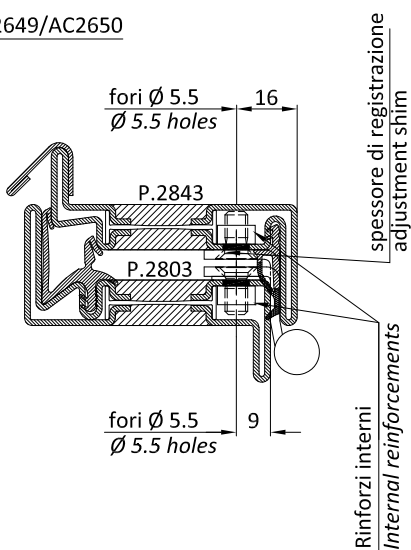
NOTA: Con cerniere AC2648, AC2649 e AC2650
installare braccetti limitatori AC2641

ATTN: With hinges AC2648, AC2649 and AC2650
please install the restrictor stay AC2641

AC2648



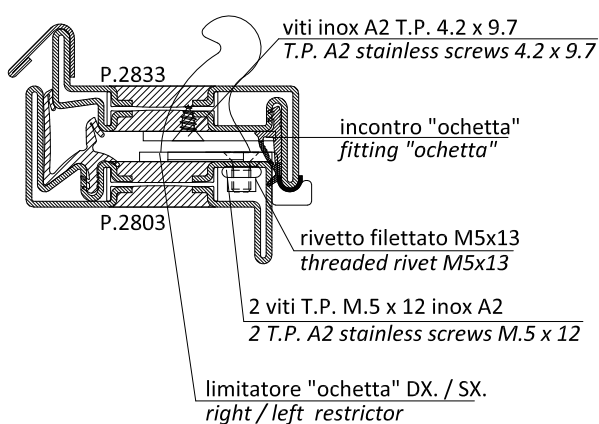
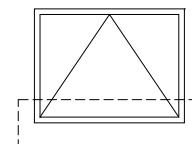
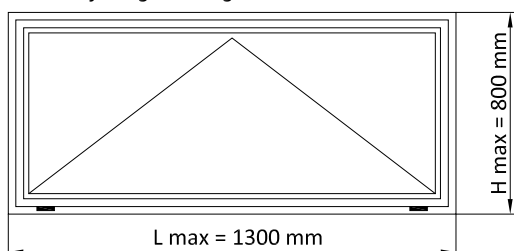
AC2649/AC2650

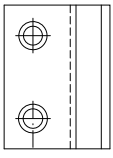
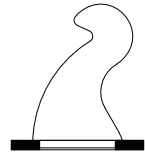
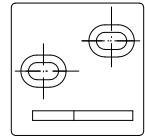
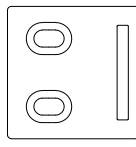
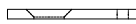


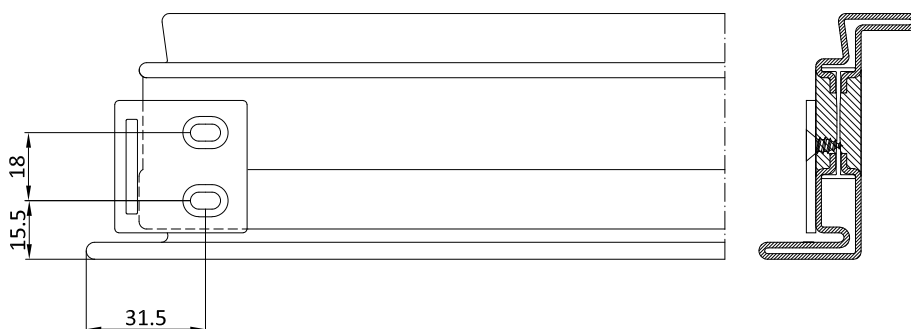
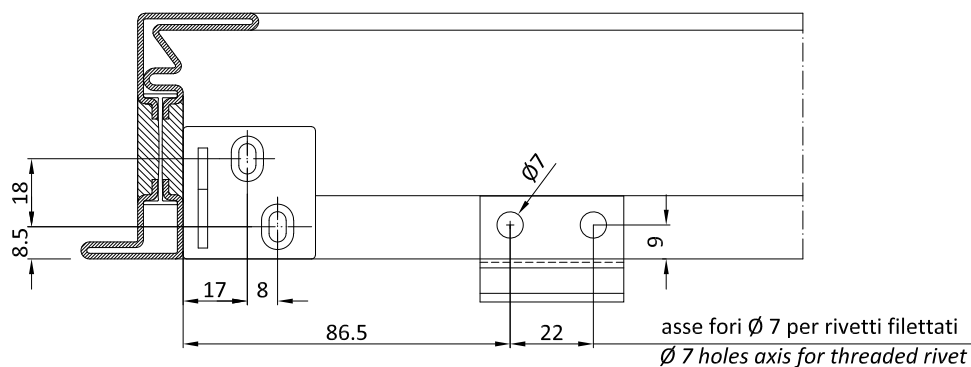
NOTA: Per vasistas installare una cerniera destra
AC2649 e una cerniera sinistra AC2650

ATTN: For top hung windows please install one right
hinge AC2649 and one left hinge AC2650

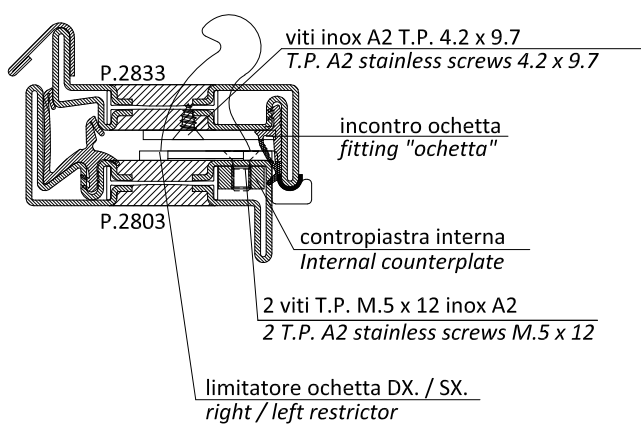
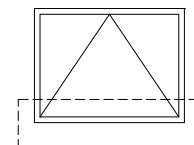
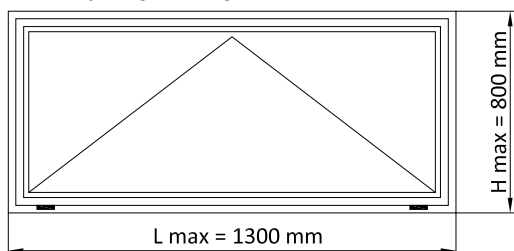
peso max. per anta: 40 kg
max. leaf weight: 40 kg

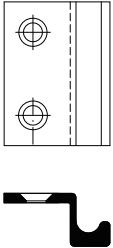
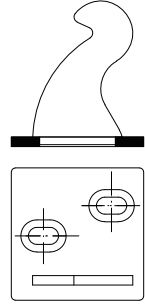
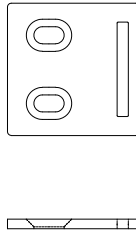
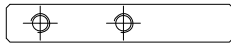


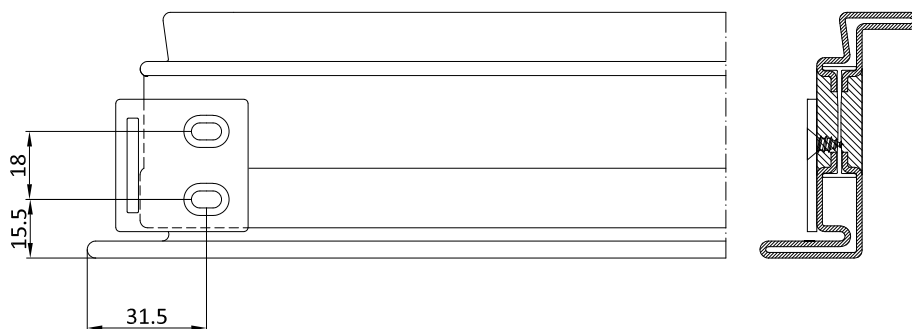
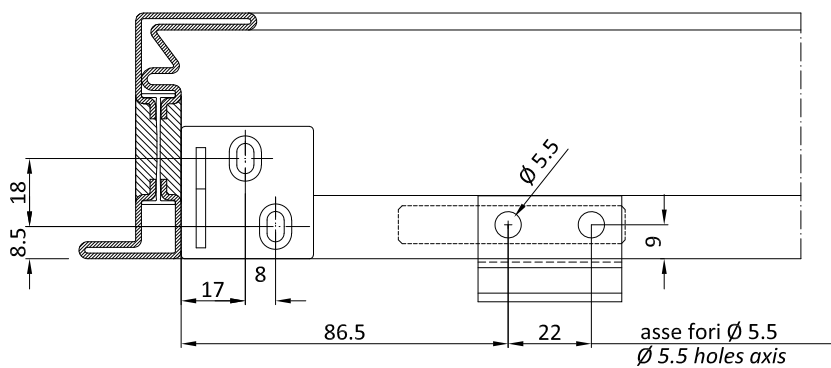
supporto anta leaf reinforcement   nr. 02 pezzi 02 pieces	limitatore "ochetta" limiter "ochetta"   nr. 02 pezzi 02 pieces	incontro "ochetta" strike plate   nr. 02 pezzi 02 pieces
rivetto filettato svasato M5 x 13 threaded rivet M5x13  nr. 02 pezzi 02 pieces	guaina appoggio anta sheath for leaf support  nr. 02 pezzi 02 pieces	



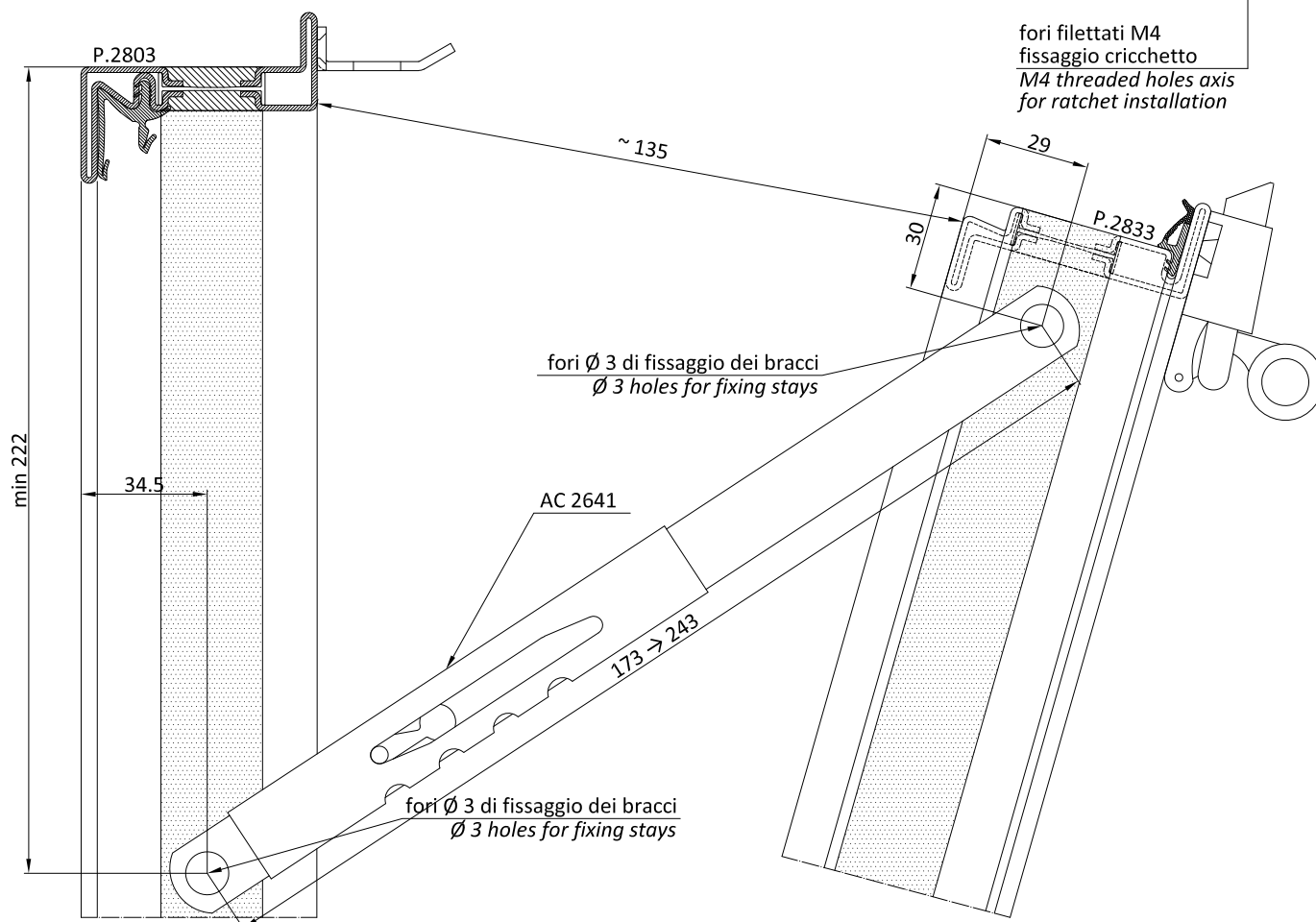
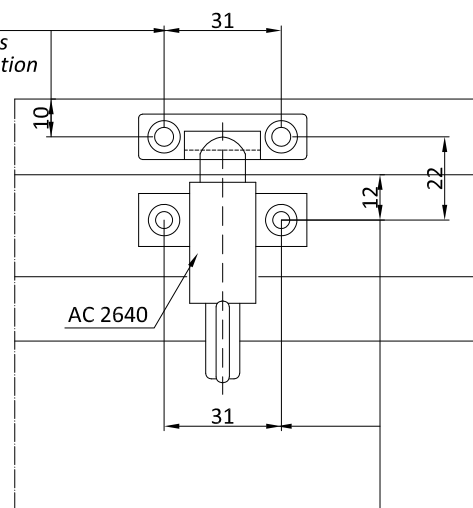
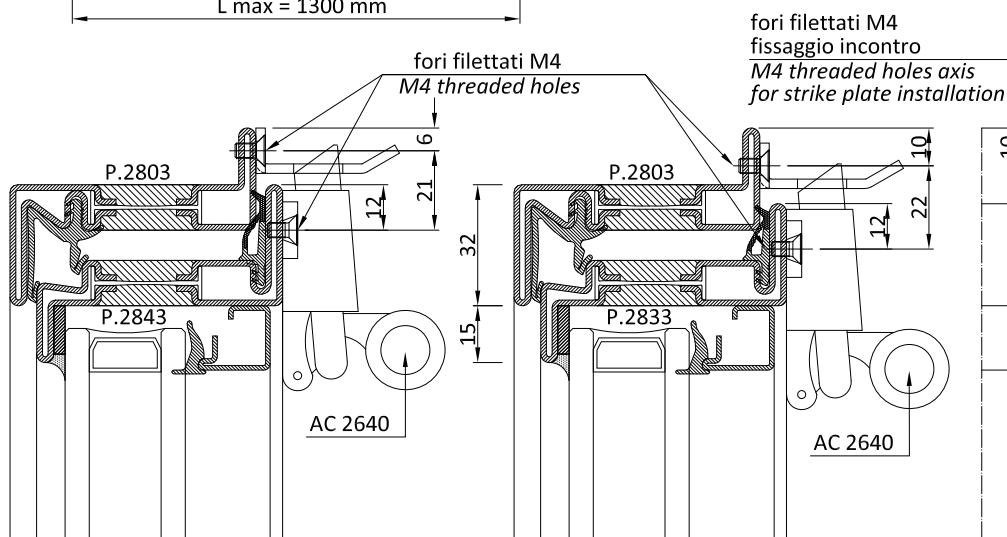
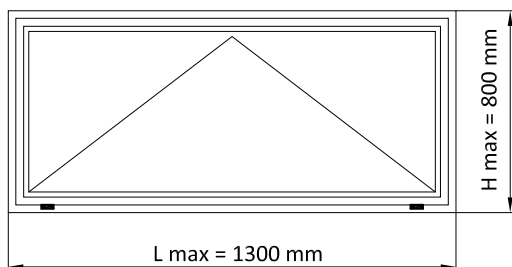
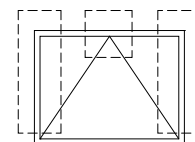
peso max. per anta: 40 kg
max. leaf weight: 40 kg

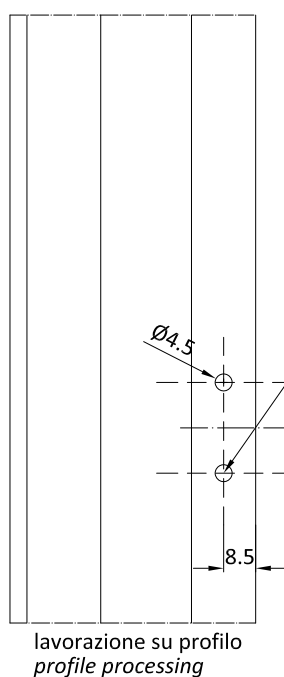
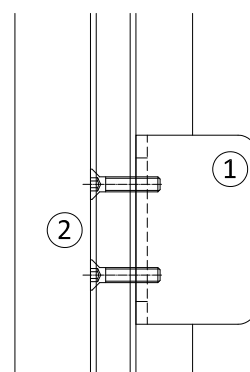
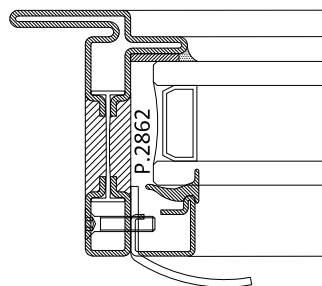
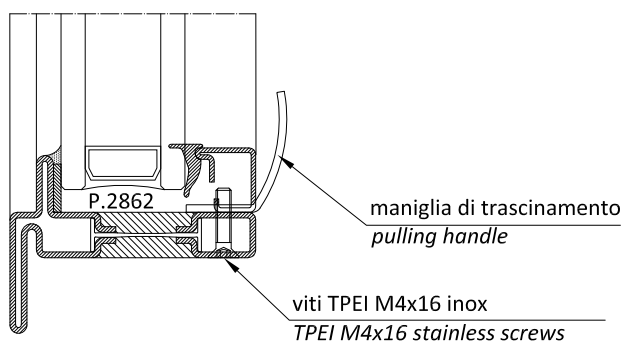
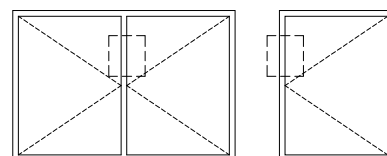
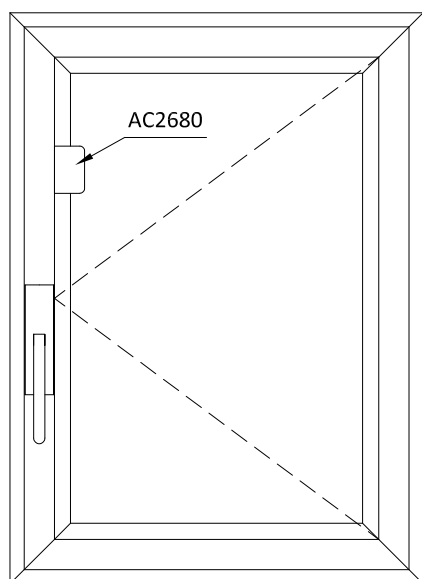


supporto anta leaf reinforcement  nr. 02 pezzi 02 pieces	limitatore "ochetta" limiter "ochetta"  nr. 02 pezzi 02 pieces	incontro "ochetta" strike plate  nr. 02 pezzi 02 pieces
contropiasta interna fissaggio supporto Internal counterplate for support  nr. 02 pezzi 02 pieces		guaina appoggio anta sheath for leaf support  nr. 02 pezzi 02 pieces

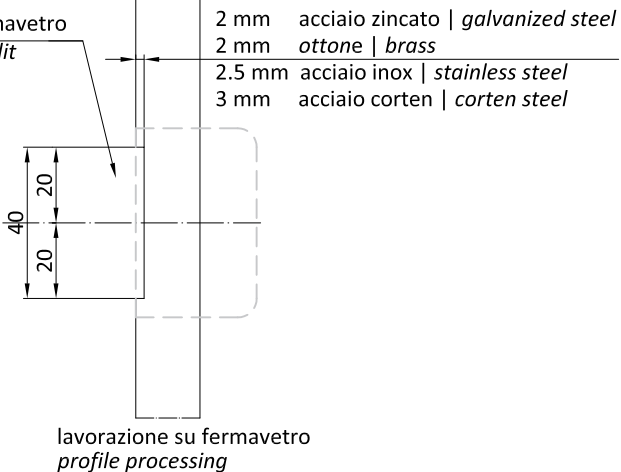


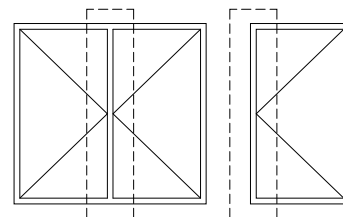
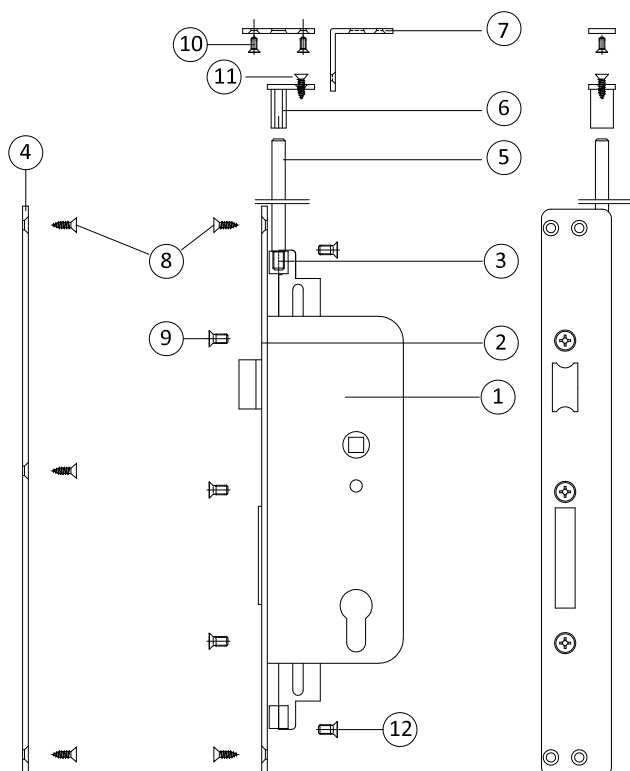
peso max. per anta: 40 kg
max. leaf weight: 40 kg



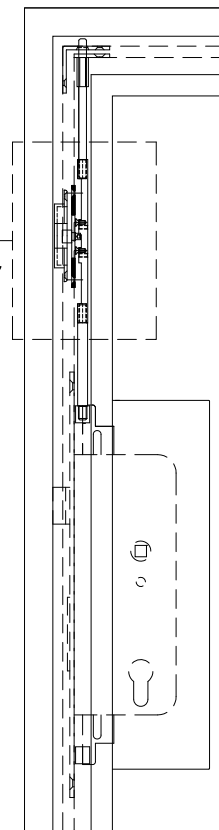


spacco su fermavetro
glazing bead slit





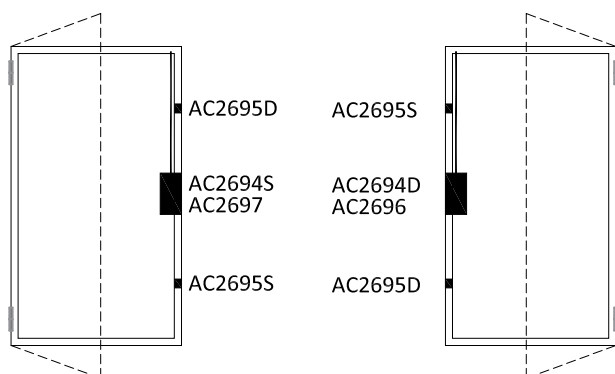
AC2695 OPZIONALE
vedi lavorazione a pag. 4.3.57-58 | 4.5.27
AC2695 OPTIONAL
see processing on page 4.3.57-58 | 4.5.27



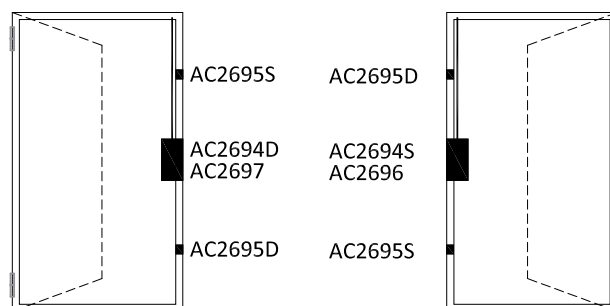
- 1) Serratura
- 2) Frontalino (Dx o Sx)
- 3) Riduttore di collegamento
- 4) Incontro per serratura
- 5) Aste inox
- 6) Guida aste superiore
- 7) Incontro aste per porte a due ante
- 7 bis) Incontro aste per porte ad un anta
- 8) Viti autof. Inox A2 T.P.T.C. 3,9x13
- 9) Viti Inox T.P.T.C. m5x10
- 10) Viti Inox T.P.E.I. 3x8
- 11) Viti autof. Inox T.P.T.C. 3,5x13
- 12) Viti Inox T.S.P.E.I. M4x8

- 1) Lock
- 2) Faceplate right/left
- 3) Connecting adaptor
- 4) Strike plate for lock
- 5) Stainless rods
- 6) Upper rods guide
- 7) Rod fittings for two-leaf doors
- 7 bis) Rod fittings for one-leaf doors
- 8) A2 T.P.T.C. 3.9x13 self-drilling stainless screws
- 9) T.P.T.C. m5x10 stainless screws
- 10) T.P.E.I. 3x8 stainless screws
- 11) T.P.T.C. 3.9 x 13 self-drilling stainless screws
- 12) T.S.P.E.I. M4 x 8 stainless screws

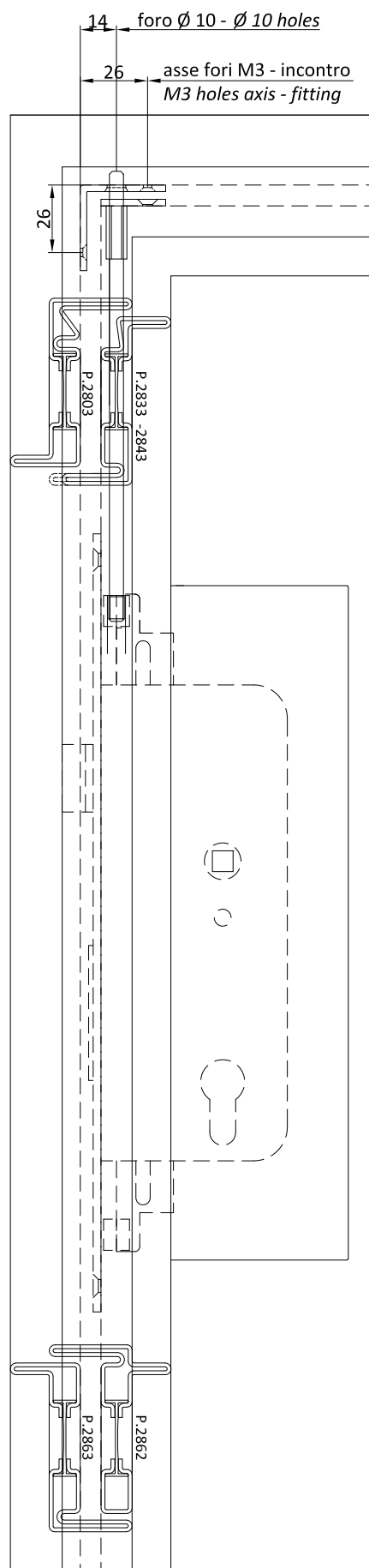
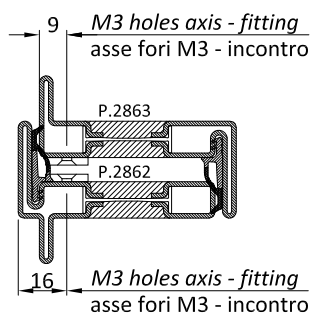
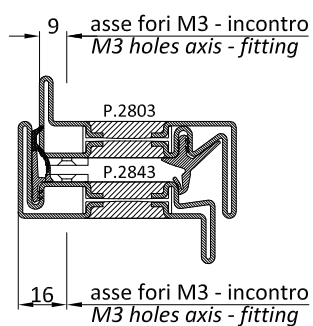
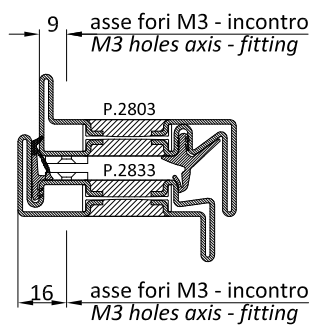
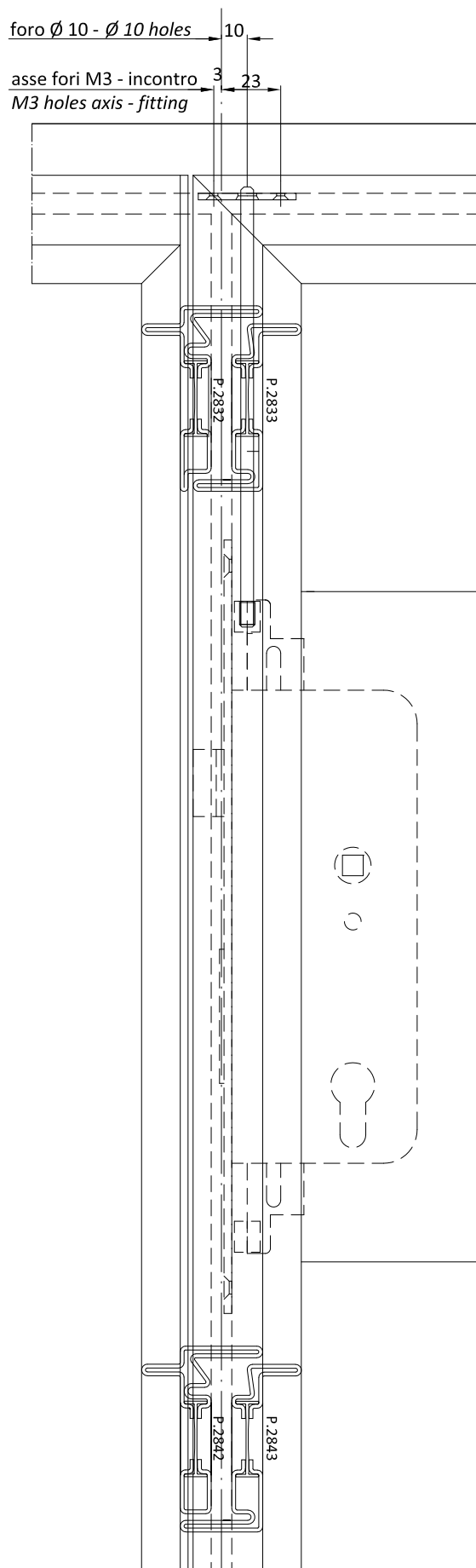
SCHEMA UTILIZZO SERRATURE E TERZE CHIUSURE CHART FOR THE USE OF LOCKS AND THIRD LOCKS



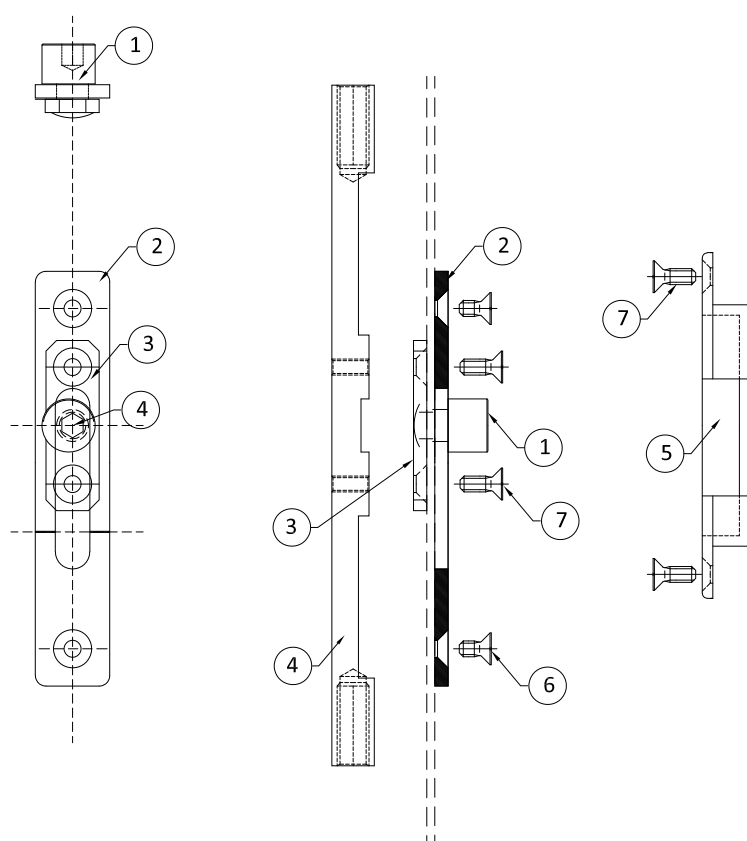
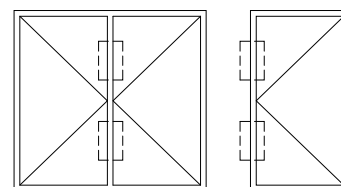
APERTURA INTERNA _ VISTA INTERNA
INWARDS OPENING _ INTERIOR ELEVATION



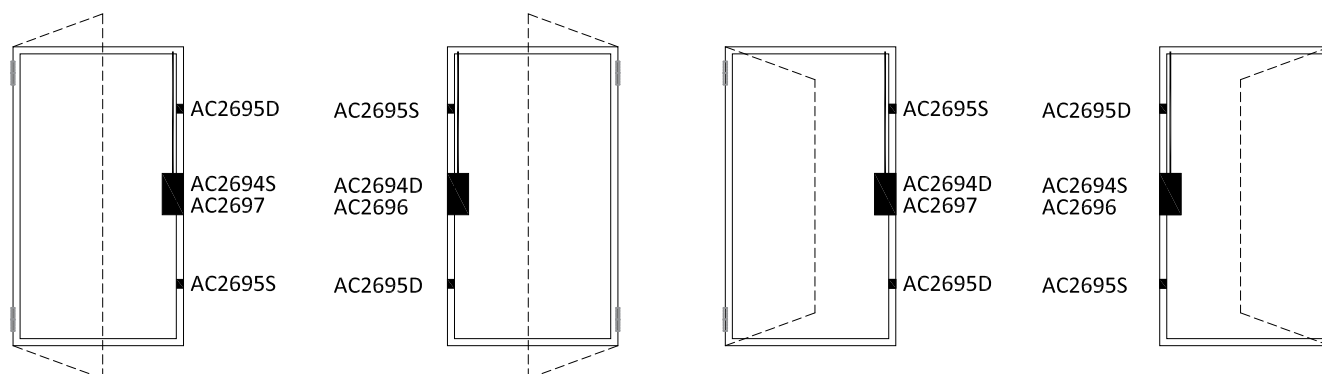
APERTURA ESTERNA _ VISTA INTERNA
OUTWARDS OPENING _ INTERIOR ELEVATION



- | | |
|-------------------------------------|--------------------------|
| 1) Rullino eccentrico | 1) Barrel cam |
| 2) Piastra di fissaggio | 2) Installation plate |
| 3) Piastra di collegamento | 3) Connecting plate |
| 4) Accessorio aggancio aste | 4) Rod docking accessory |
| 5) Incontro 3 ^a chiusura | 5) 3rd lock strike plate |
| 6) viti M3 x 6 | 6) screws M3 x 6 |
| 7) viti M3 x 8 | 7) screws M3 x 8 |

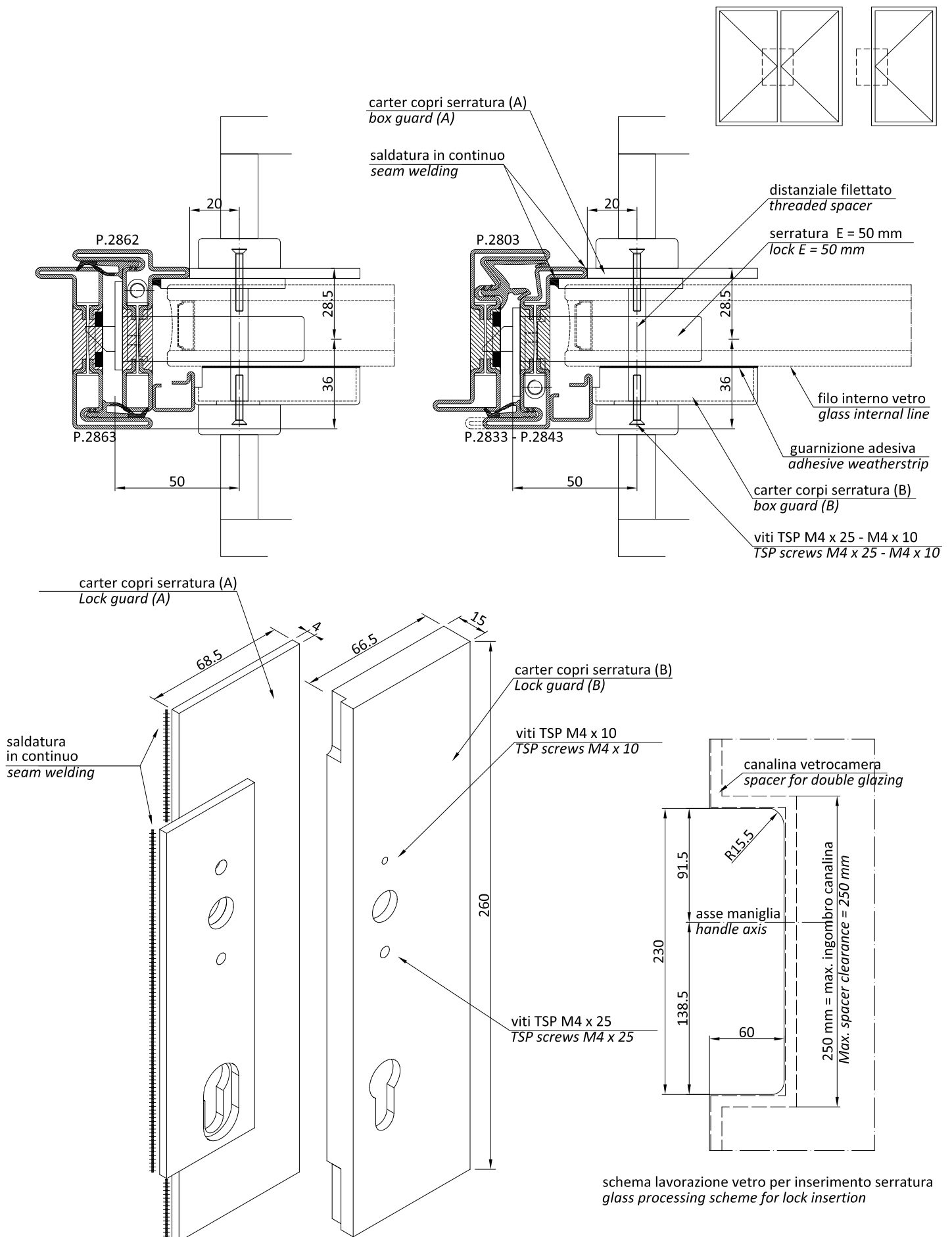


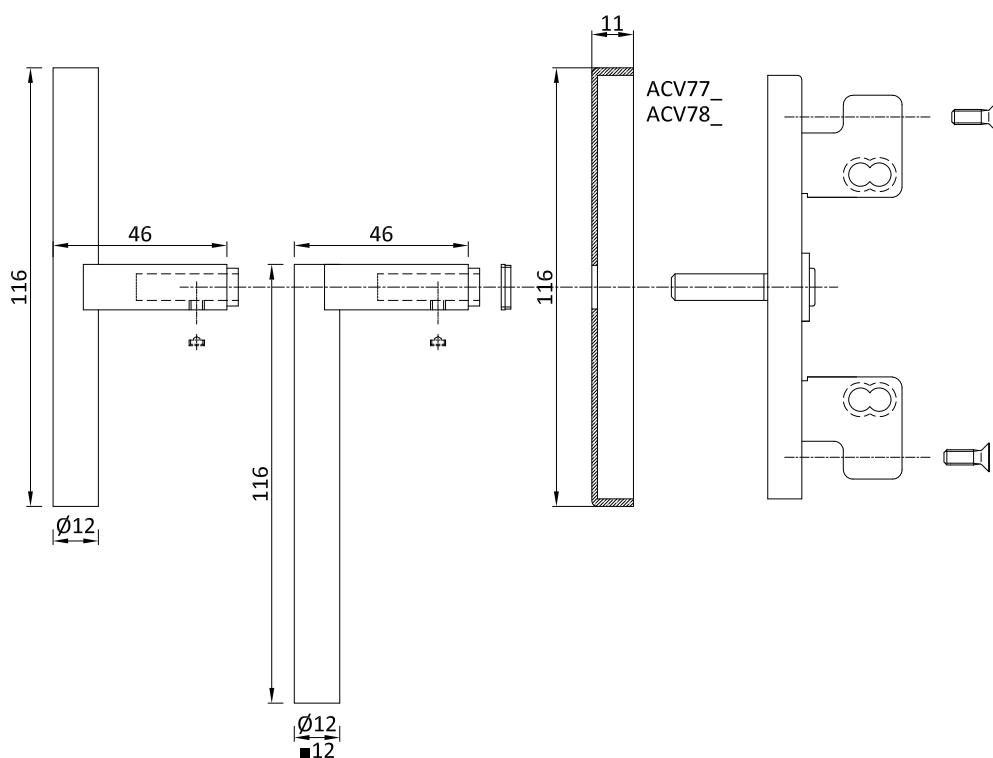
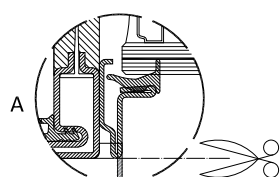
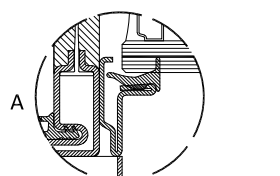
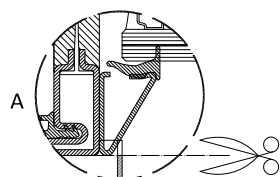
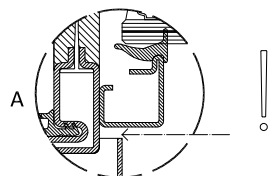
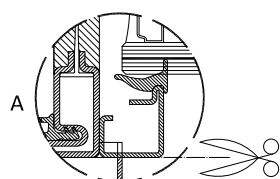
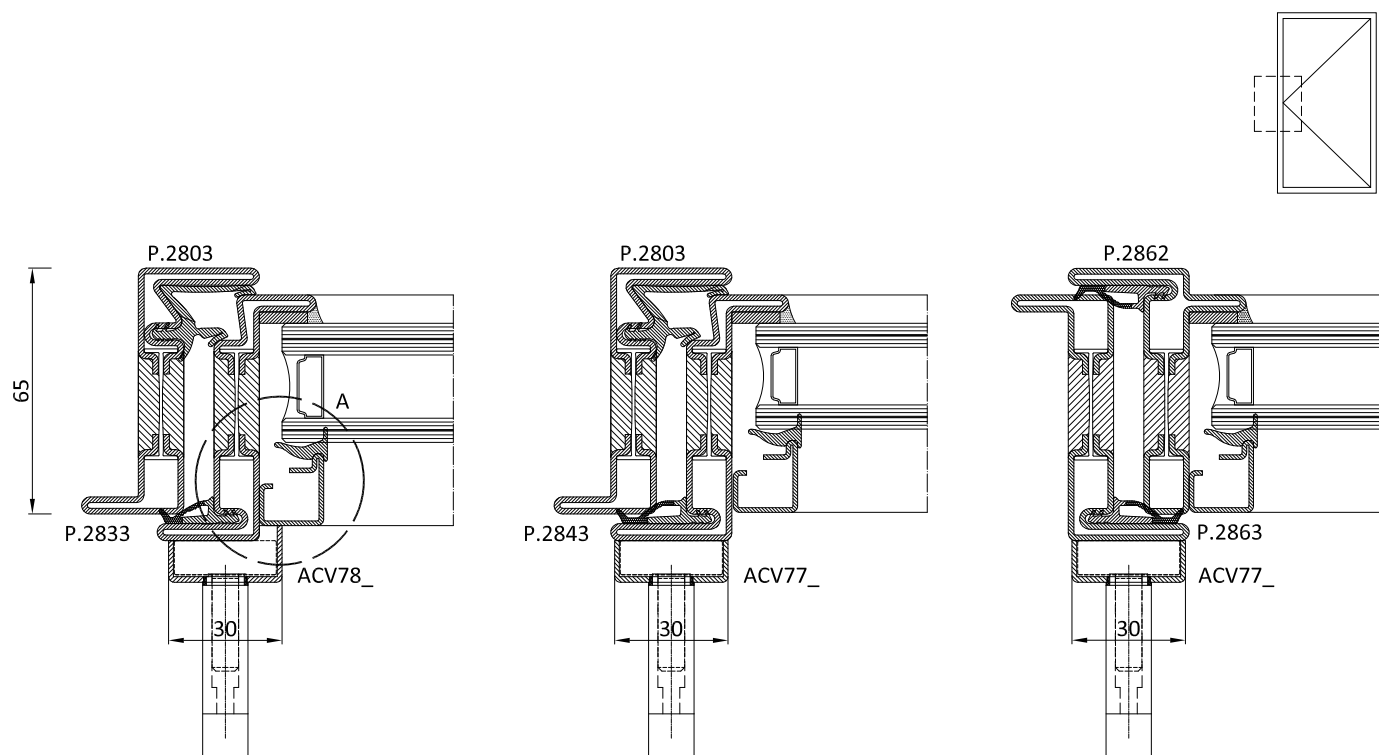
SCHEMA UTILIZZO SERRATURE E TERZE CHIUSURE
CHART FOR THE USE OF LOCKS AND THIRD LOCKS

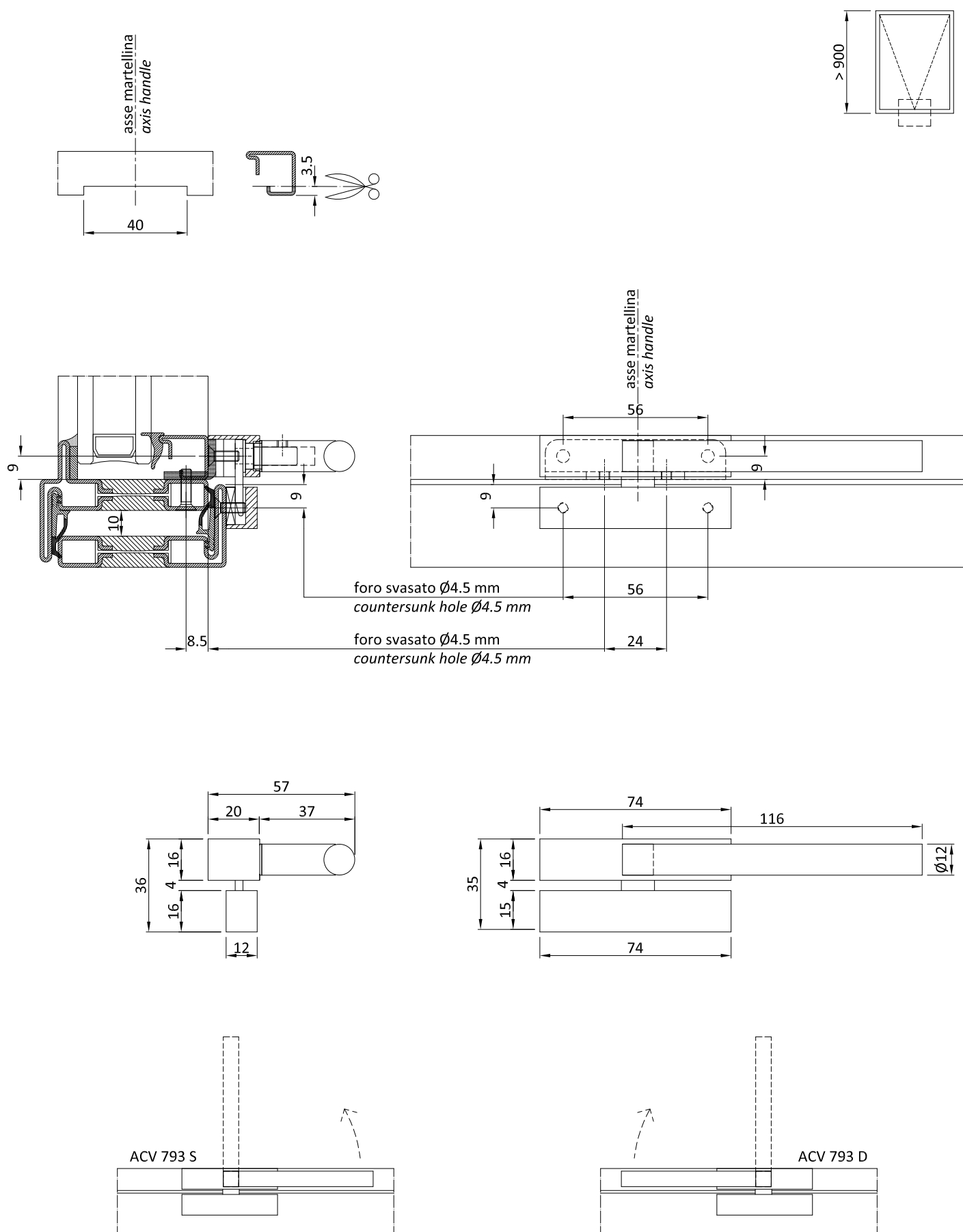


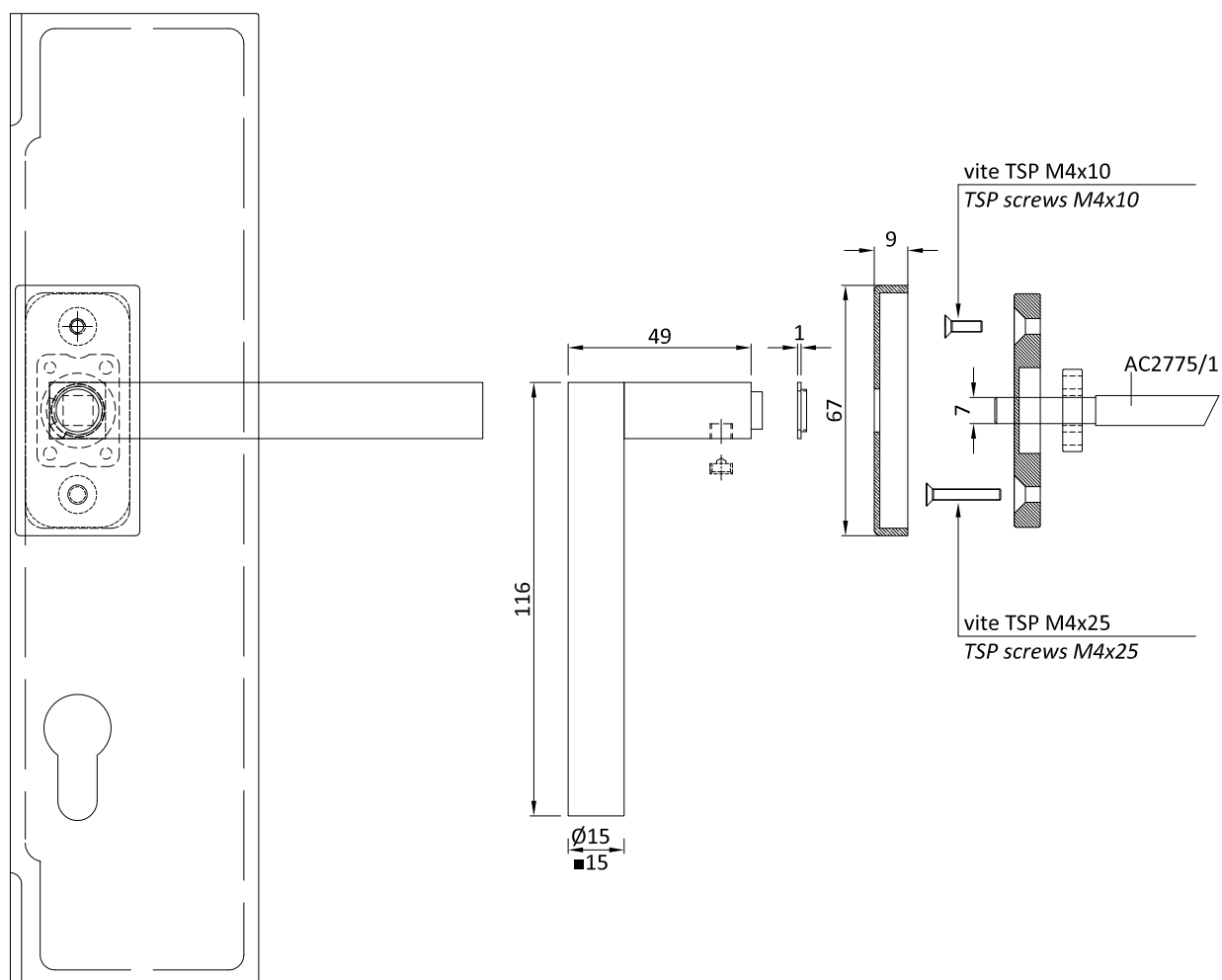
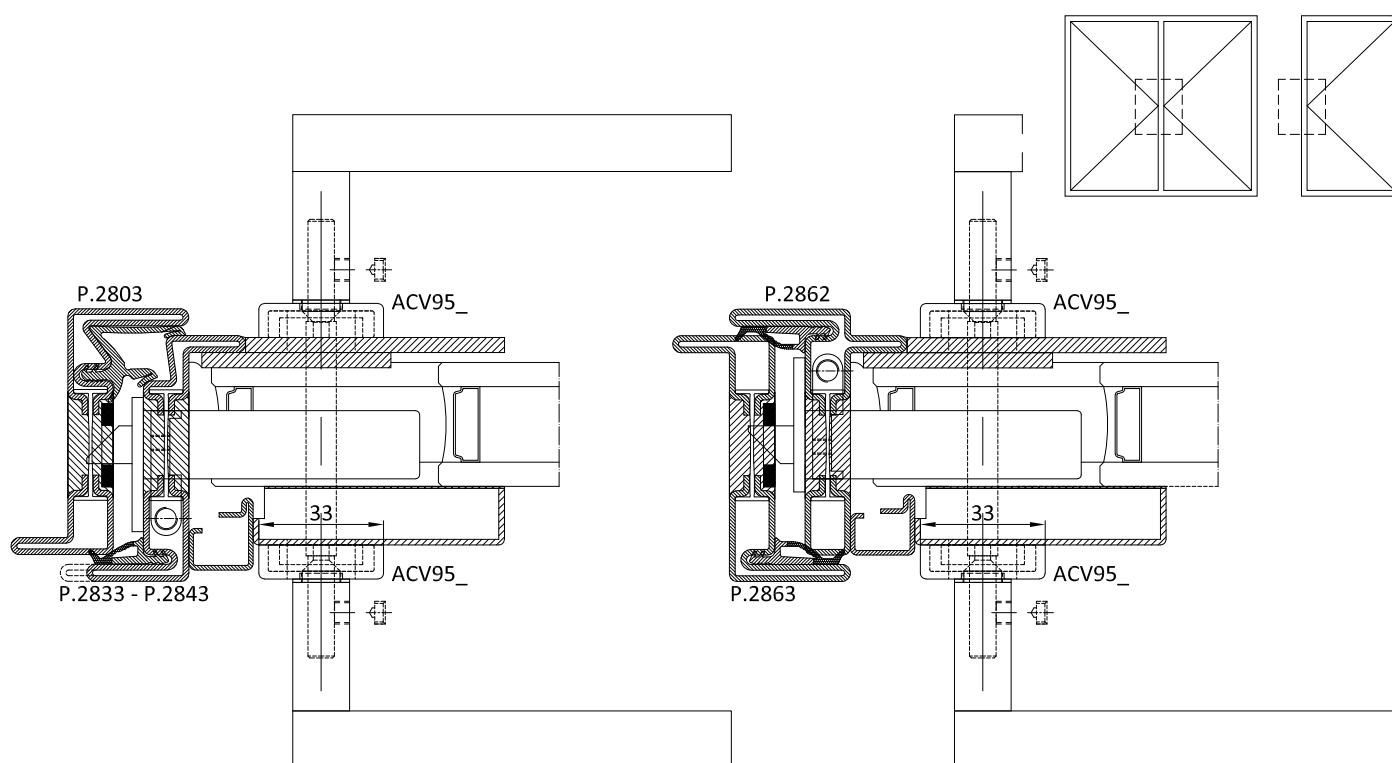
APERTURA INTERNA _ VISTA INTERNA
INWARDS OPENING _ INTERIOR ELEVATION

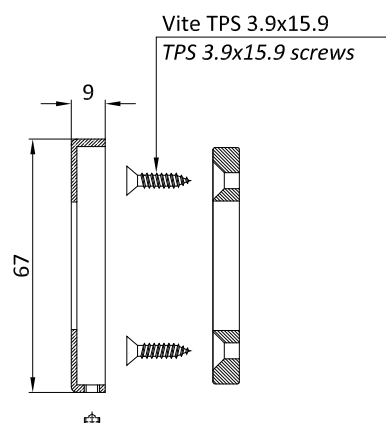
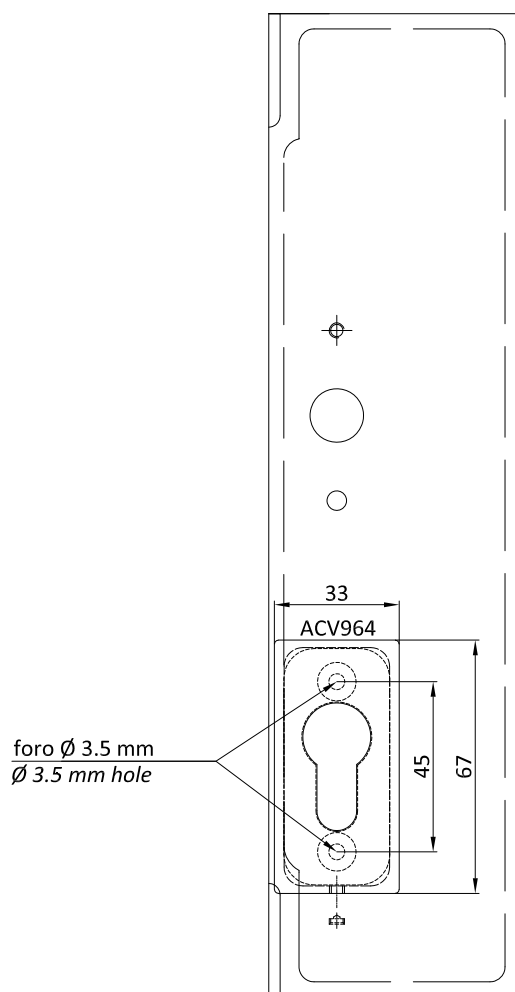
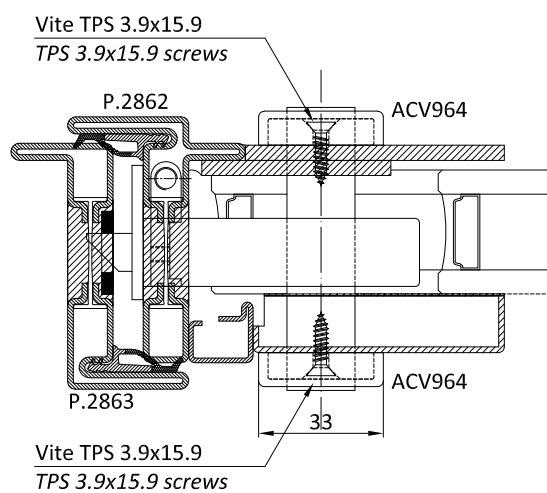
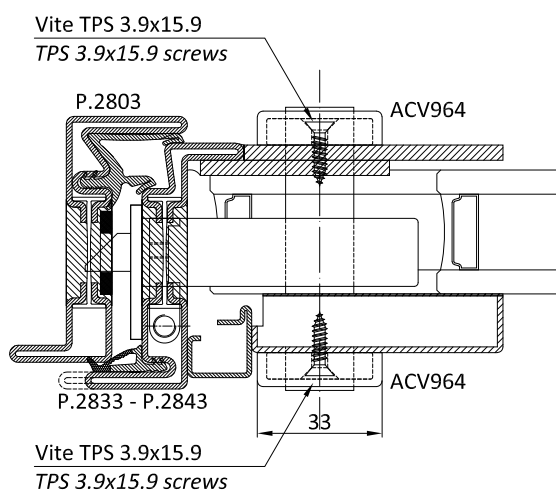
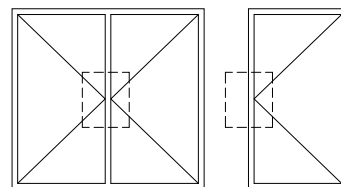
APERTURA ESTERNA _ VISTA INTERNA
OUTWARDS OPENING _ INTERIOR ELEVATION



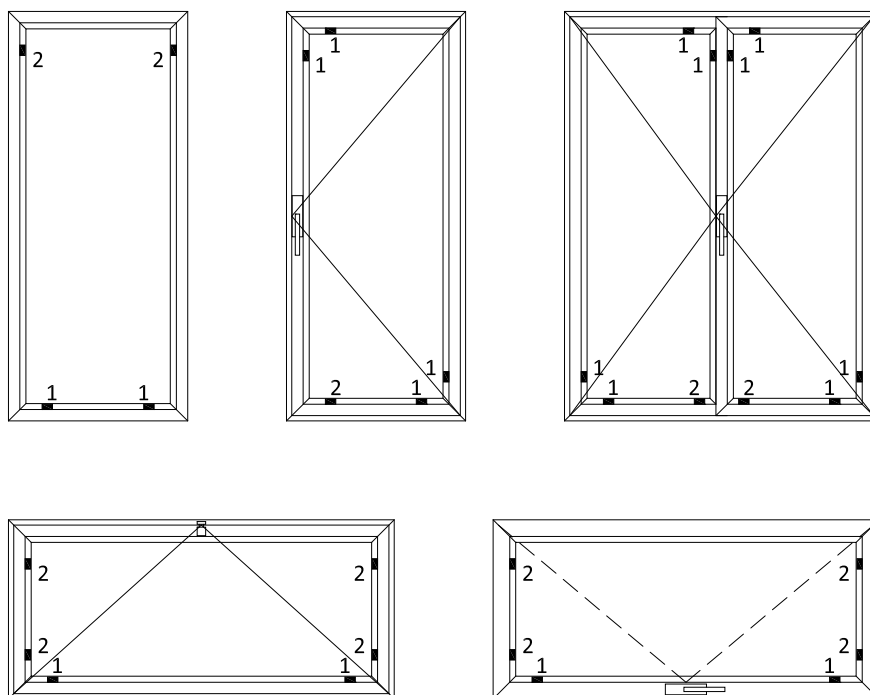






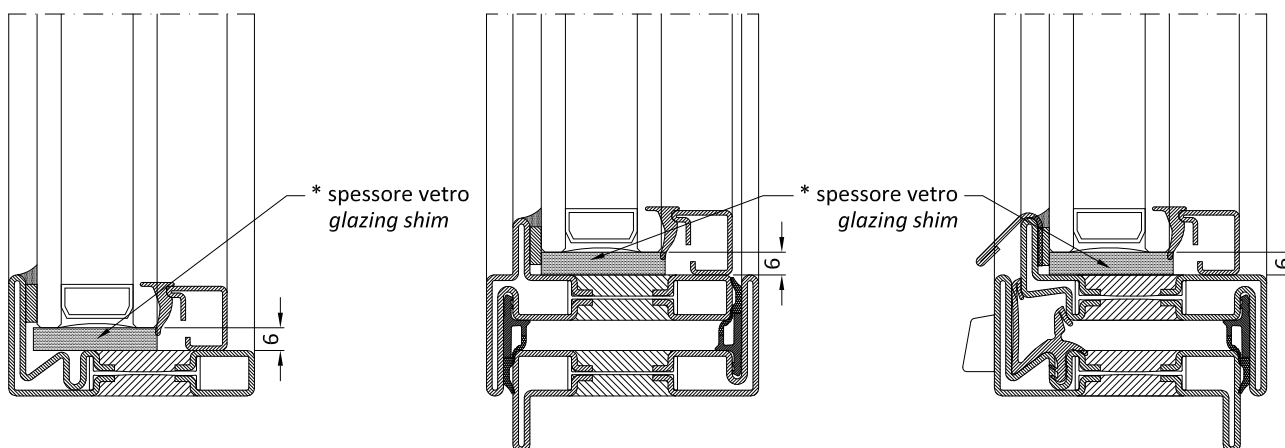


Finestra | Window



1) spessore portante | *carry shim*

2) spessore distanziatore | *compensation shim*

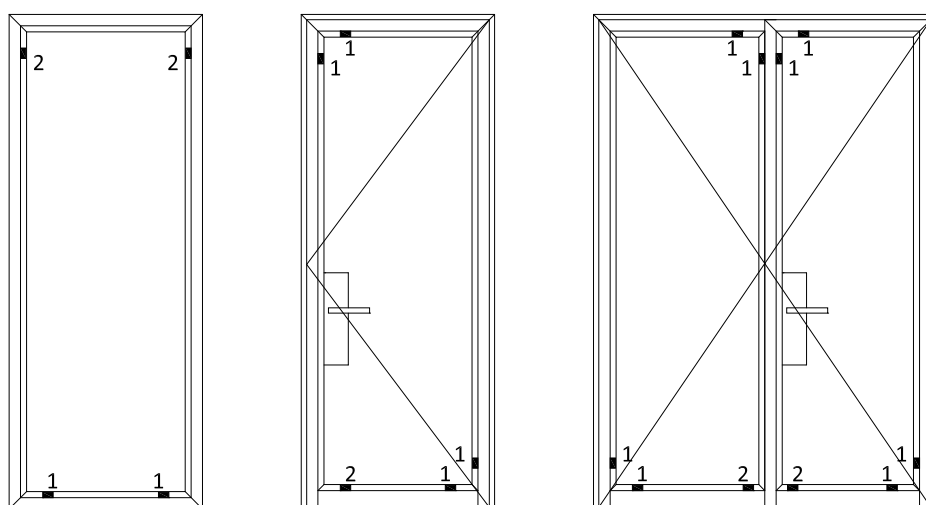


Note / Note

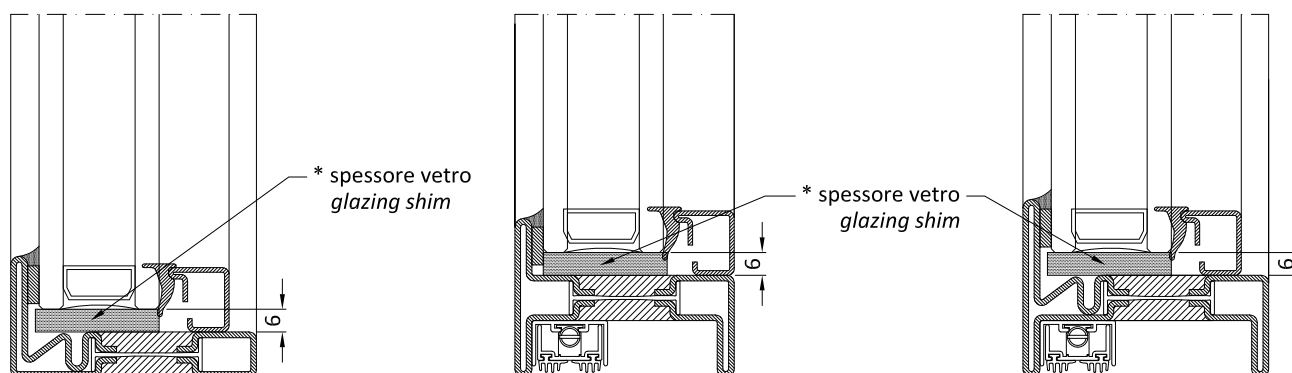
- La larghezza degli spessori è almeno pari o maggiore (+2 mm) dello spessore del vetro installato.
- The shims width is the same or bigger (+2 mm) than the installed glass spacer.
- La posizione degli spessori deve essere garantita dall'utilizzo di materiale adeguato che ne eviti la migrazione.
- The shims position has to be provided by using an appropriate material which avoids any movements.

* spessori vetro non inclusi - *glazing shims not included*

Porta | Door



- 1) spessore portante | *carry shim*
 2) spessore distanziatore | *compensation shim*



Note / Note

- La larghezza degli spessori è almeno pari o maggiore (+2 mm) dello spessore del vetro installato.
- *The shims width is the same or bigger (+2 mm) than the installed glass spacer.*
- La posizione degli spessori deve essere garantita dall'utilizzo di materiale adeguato che ne eviti la migrazione.
- *The shims position has to be provided by using an appropriate material which avoids any movements.*

* spessori vetro non inclusi - *glazing shims not included*

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.

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

OS2 65 è composto da una serie di profili dalle ridottissime dimensioni e prevede un accoppiamento dei telai esterni con le ante apribili con distanza di 8 mm. 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/-1 mm e la tolleranza per il sormonto degli stessi compresa tra +0/+0.5 mm.

Taglio/Lavorazioni

I profili OS2 65 in acciaio, 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 utilizzate per le serie di alluminio. Vista la loro particolare dimensione e forma si consiglia di utilizzare le ganasce di taglio previste dal sistema (AT2800) per assicurare una perfetta stabilità dei profili durante il taglio. La verifica del taglio sia per la sezione inclinata a 45° che per la sezione verticale a 90° dovrebbe garantire una tolleranza compresa tra -1°/+1°. Tutte le lavorazioni devono essere eseguite con il rispetto della seguente nota tecnica ed eventuali modifiche concordate con l'ufficio tecnico Secco Sistemi.

Saldatura

I profili OS2 65 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 OS2 65 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 (SA1024/33/42/52). 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 e all'esterno, l'utilizzo di siliconatura o inserimento della guarnizione adesiva GE2606 (il sistema con sigillatura è da utilizzarsi quando le ante superano 1 m² di superficie per garantire una maggior rigidità del pannello vetrato). Per il corretto funzionamento del sistema si suggerisce di verificare la perfetta compressione delle guarnizioni interne del fermavetro e la mancanza di imperfezioni lungo il perimetro della siliconatura esterna.

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 contro telaio/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

OS2 65 is made of a series of very thin profiles. It provides coupling of external frames with opening leaves with a distance of 8 mm. To ensure the correct use of hardware and gaskets the processing 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

OS2 65 profiles in steel, stainless steel and corten can be cut with normal saws, like the ones used for steel pipes. OS2 65 profiles in brass can be cut with saws used for aluminium. Given their dimension and size, it is recommended to use the cutting jaws provided with the system (AT2800) to ensure perfect stability during the cutting procedure. In order to verify the correctness of the cut, the tolerance of both the 45° and the 90° sections must be between -1°/+1°. Processing must be performed in line with this technical note and any variation agreed with Secco Sistemi's Technical Department.

Welding

OS2 65 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 DPLs provided and in areas with sufficient ventilation and with fumes 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 a later painting without any visible imperfections (pores and ripples). The proper set up must guarantee that the performance in the CE marking and verified in the lab will remain constant. It is advised

Painting/Burnishing

OS2 65 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 (SA1024/33/42/52). Holes must be drilled (as per instructions) in the frames 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 cooling. It is advised to follow pre-treatment and painting cycles as outlined in Secco Sistemi documentation.

Glass application

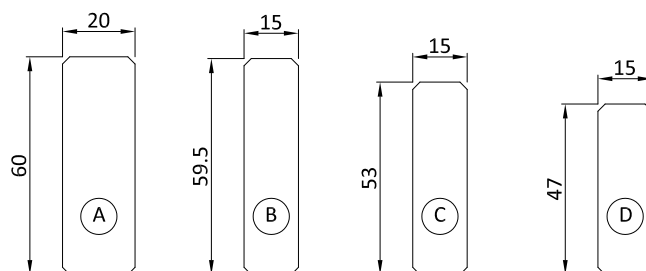
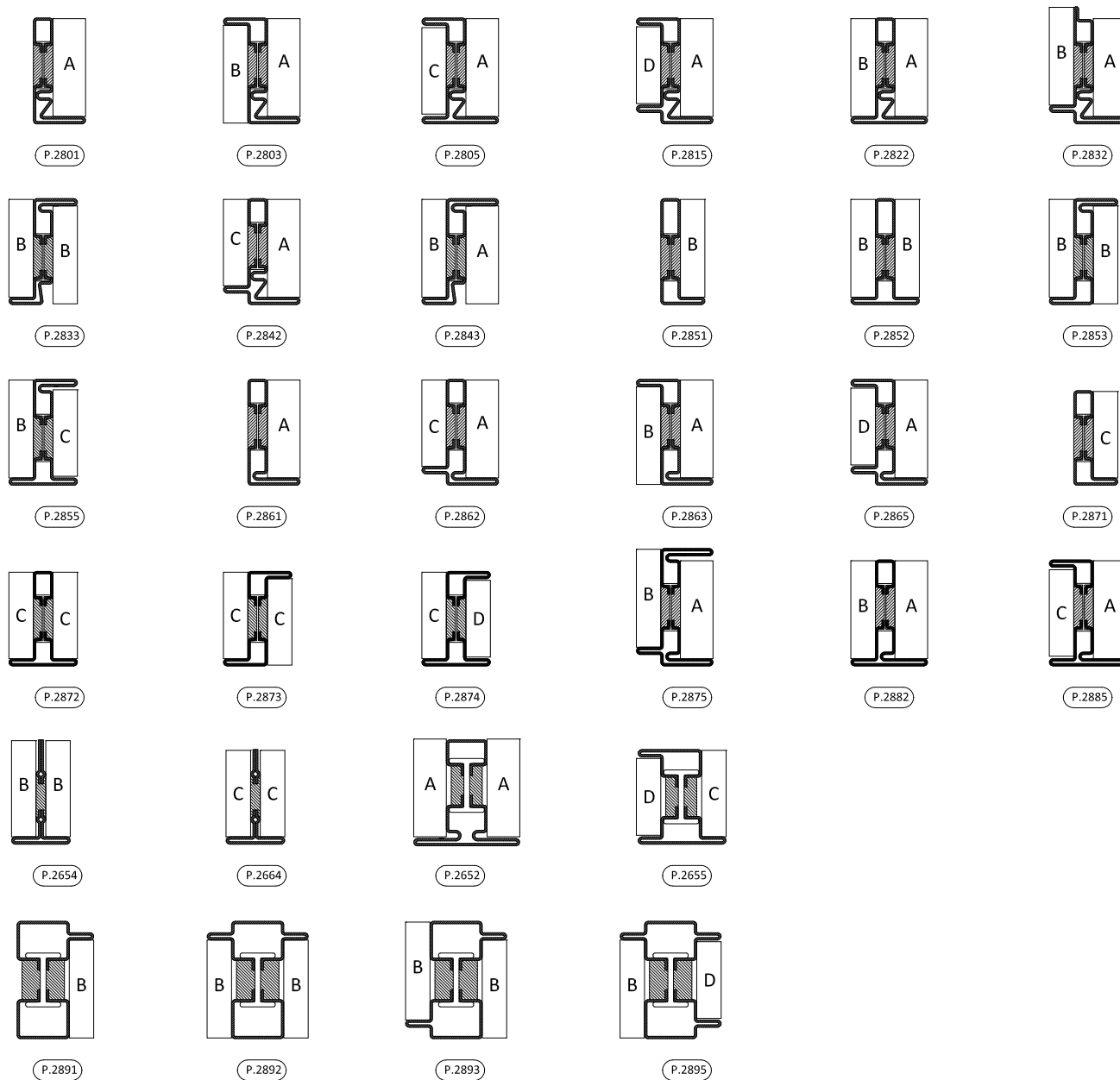
The glazing unit is secured by means of glazing beads which must be fixed by pressure with the dedicated clips or bushings to then fit the appropriate gasket.

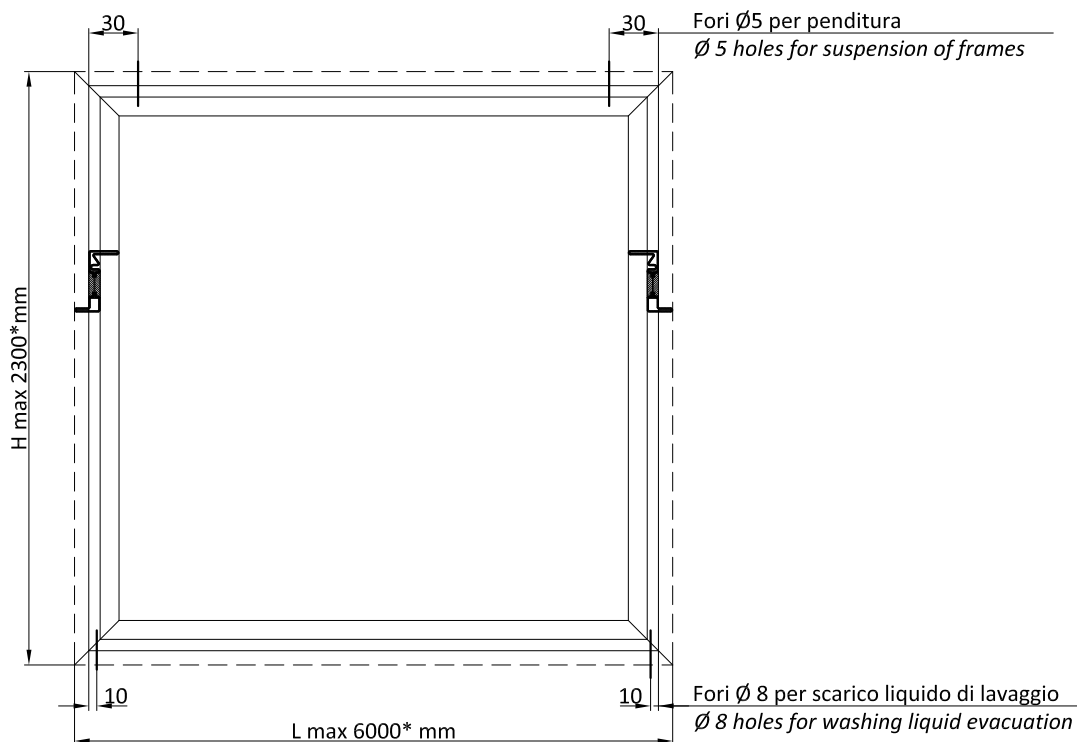
Externally, the glazing unit must be sealed with GE2606 or by applying silicone on the whole perimeter (the latter is recommended when the glazed surface is greater than 1 sqm in order to guarantee a higher rigidity of the glazing unit).

In order to ensure the correct behaviour of the system, it is recommended to verify the proper pressurization of the internal glass bead gaskets and that the external silicone perimeter is completely free of imperfections.

Set up

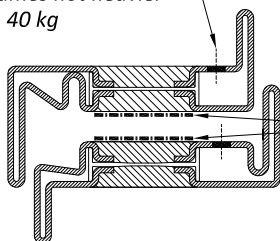
The proper set up must guarantee that the performance in the CE marking and verified in the lab will remain constant. It is advised to design a correct series of set ups with reference to the existing type of subframe/brickwork and to the dimensions of the elements to set up. Once the set up is finished, you should verify the proper behaviour of the window/door (easiness of opening/closing, stability of the open leaf, etc.), 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.



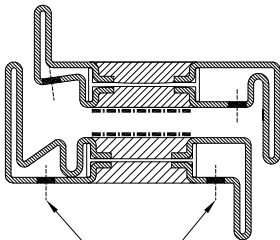


Fori Ø5 per pendinatura
telai con peso inferiore
a 40 kg

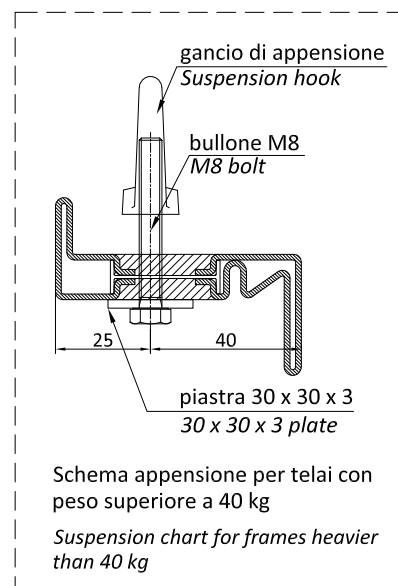
Ø 5 holes for suspension
of frames not heavier
than 40 kg



SOLO PER VERNICIATURA
Nastro adesivo protettivo da
25 mm. resistente alle alte
temperature (220-230°)
ONLY FOR PAINTING
Protective 25 mm tape resistant
to high temperatures (220-230°)



Fori Ø 8 per lo scarico del
liquido di lavaggio
Ø 8 holes for washing
liquid evacuation



Schema appensione per telai con
peso superiore a 40 kg
Suspension chart for frames heavier
than 40 kg

SOLO PER BRUNITURA

Preparare il profilo da trattare pulendolo con una paglietta tipo Scotch Brite in modo da ottenere superfici lucide e uniformi.

Movimentare il prodotto carteggiato con cautela per non danneggiare la finitura superficiale e non toccare a mani nude il profilo per ottenere un trattamento di brunitura uniforme.

ONLY FOR BURNISHING

Prepare the profile grinding it with a Scotch Brite wool in order to obtain uniform surfaces.

Ease profiles carefully to avoid any damages on the surface as well as do not touch it with hands to allow an uniform burnishing.

* Dimensioni massime disponibili nell'impianto di Secco Sistemi
Maximum available size in the Secco Sistemi plant

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

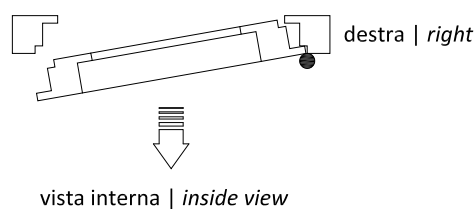
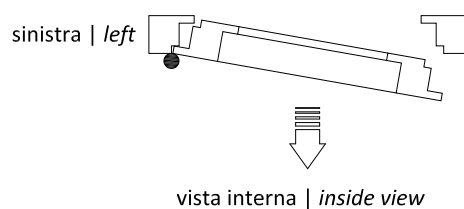
- Material: HSS (please verify availability of longer lasting material on the market);
- Use a 4-tooth milling machine;
- Use a milling machine with a 5-mm diameter for groove processing.

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.

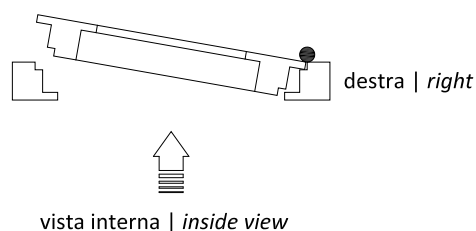
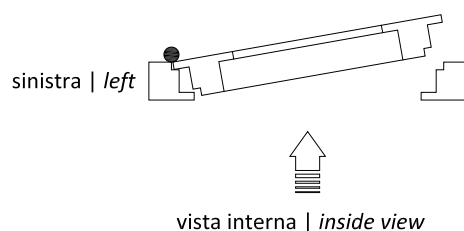
Milling slots and loops in the profiles

- 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.

APERTURA INTERNA | INWARD OPENING

Codice Code	Profilo anta Leaf profile
Kit cremonese Cremona bolt	
AC 2623 S	P.2833
AC 2624 S	P.2833-P.2843
AC 2625 S	P.2843
Cerniere Hinges	
AC 2630	P.2833
AC 2649	P.2843
Serratura multipunto Multi-lock set	
AC 2694 S	P.2833-P.2843

Codice Code	Profilo anta Leaf profile
Kit cremonese Cremona bolt	
AC 2623 D	P.2833
AC 2624 D	P.2833-P.2843
AC 2625 D	P.2843
Cerniere Hinges	
AC 2629	P.2833
AC 2650	P.2843
Serratura multipunto Multi-lock set	
AC 2694 D	P.2833-P.2843

APERTURA ESTERNA | OUTWARD OPENING

Codice Code	Profilo anta Leaf profile
Kit cremonese Cremona bolt	
AC 2683 S	P.2862
AC 2684 S	P.2862
Cerniere Hinges	
AC 2650	P.2862
Serratura multipunto Multi-lock set	
AC 2694 D	P.2862

Codice Code	Profilo anta Leaf profile
Kit cremonese Cremona bolt	
AC 2683 D	P.2862
AC 2684 D	P.2862
Cerniere Hinges	
AC 2649	P.2862
Serratura multipunto Multi-lock set	
AC 2694 S	P.2862

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*
- Rettilinearità 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°

3. Lavorazioni su barra / Section processing

Finestra / Window	Aperture interne / Inward opening		Aperture esterne / Outward opening
Fori per cerniere a tre ali <i>Three-wing hinge holes</i>	AC2628 sez 4.3.27-28	AC2648 sez 4.3.31-32	AC2648 sez 4.3.33-34
Foratura per cerniera a due ali <i>Two-wing hinge holes</i>	AC2629/30 sez 4.3.29-30	AC2649/50 sez 4.3.35-36	AC2649/50 sez 4.3.37-38
Fori e asole per cremonese anta singola <i>Single leaf windows espagnolette holes</i>	AC2623 sez 4.3.17	AC2625 sez 4.3.20	AC2683 sez 4.3.21-22
Fori e asole per cremonese anta doppia <i>Double leaf windows espagnolette holes</i>	AC2624 sez 4.3.18	AC2624 sez 4.3.19	AC2684 sez 4.3.23-24
Fori e asole per chiusura supplementare <i>Additional locking points slots and holes</i>	AC2626R sez 4.3.25		AC2626R sez 4.3.26
Fori per scarico acqua <i>Water drip holes</i>	AC2618 sez 4.3.13		
Taglio punta per inversione battuta <i>Secondary leaf top central joint working</i>	AC2651 sez 4.3.3-4	AC2652 sez 4.3.5-6	AC2653 sez 4.3.7-8
Fori inserimento rinforzi cerniere <i>Hinge reinforcement holes</i>	- sez 4.3.1		- sez 4.3.2
Fresatura per catenacci 2° anta <i>Secondary leaf flush bolt milling</i>	AC2621RX/MX sez 4.3.48-49		AC2621RX/MX sez 4.3.50
Fori limitatori apertura per apertura ad anta <i>Restrictor stays holes</i>			AC2687 sez 4.3.42-44
Fresature per compassi sporgere <i>Stay arm for awning windows milling</i>			AC2688 sez 4.3.45
Fresature per limitatori sporgere <i>Stay arm for awning windows milling</i>	-	-	AC2690 sez 4.3.47
Fori staffe per P.2610 <i>P.2610 coupling brackets holes</i>	AC2610I sez 4.3.12		
Lavorazione gocciolatoio <i>Water drip section workink</i>	P.2620 sez 4.3.14		
Fori fissaggio a muro <i>Wall mounting holes</i>	sez 3.3.1-5		sez 3.3.1-5

Porta / Door	Aperture interne / Inward opening		Aperture esterne / Outward opening	
Fori per cerniere a tre ali <i>Three-wing hinge holes</i>	AC2628 sez 4.3.27-28	AC2648 sez 4.3.31-32	AC2648 sez 4.3.33-34	
Foratura per cerniera a due ali <i>Two-wing hinge holes</i>	AC2629/30 sez 4.3.29-30	AC2649/50 sez 4.3.35-36	AC2649/50 sez 4.3.37-38	
Fori e asole per serratura e incontri <i>Lock and strike slots and holes</i>	AC2693 sez 4.3.53	AC2694 sez 4.3.55	AC2693 sez 4.3.54	AC2694 sez 4.3.56
Fori e asole per chiusura supplementare <i>Additional locking points slots and holes</i>	AC2695 sez 4.3.57		AC2695 sez 4.3.58	
Taglio punta per inversione battuta <i>Secondary leaf top central joint working</i>	AC2651 sez 4.3.3-4	AC2652 sez 4.3.5-6	AC2653 sez 4.3.7-8	
Fori inserimento rinforzi cerniere <i>Hinge reinforcement holes</i>	- sez 4.3.1		- sez 4.3.2	
Fresatura per catenacci 2° anta <i>Secondary leaf flush bolt milling</i>	AC2621RX/MX sez 4.3.48-49		AC2621RX/MX sez 4.3.50	
Fori fissaggio a muro <i>Wall mounting holes</i>	sez 3.3.1-5		sez 3.3.1-5	

4. Assiemaggio / Assembly

Finestra / Window	Aperture interne / Inward opening		Aperture esterne / Outward opening	
Costruzione telai				
Inserimento squadrette (profili ottone) – Saldatura / Brackets insertion (brass section) - Welding	AC28xx sez 4.4.1-3		AC28xx sez 4.4.1-3	
Sigillatura interna della giunzione (ottone) Internal joint sealing (brass sections)	AC28xx sez 4.4.1-3		AC28xx sez 4.4.1-3	
Taglio punta per inversione battuta Secondary leaf top central joint working	AC2651 sez 4.3.3-4	AC2652 sez 4.3.5-6	AC2653 sez 4.3.7-8	
Applicazione accessori				
Fori inserimento rinforzi cerniere Hinge reinforcement holes	- sez 4.3.1		- sez 4.3.2	
Fori per cerniere a tre ali Three-wing hinge holes	AC2628 sez 4.3.27-28	AC2648 sez 4.3.31-32	AC2648 sez 4.3.33-34	
Foratura per cerniera a due ali Two-wing hinge holes	AC2629/30 sez 4.3.29-30	AC2649/50 sez 4.3.35-36	AC2649/50 sez 4.3.37-38	
Saldatura cerniere a saldare Hinge welding	AC2631/32 sez 4.4.5	AC2631/32 sez 4.4.6	AC2631/32 sez 4.4.7	
Fori snapper 2° anta Secondary leaf snapper holes	AC2622 sez 4.5.6	AC2622 sez 4.5.8		
Fori cerniera a scomparsa vasistas Concealed hinges for bottom hung window holes	AC2639 sez 4.5.21-22			
Fori cricchetto e braccetti vasistas Finger catch and stay arms for bottom hung window holes	AC2640/41 sez 4.5.23			
Fori chiusure mediane a scomparsa Concealed medians closures holes	AC2627 sez 4.5.16			
Fori maniglia trascinalmento seconda anta Fixed handle for secondary leaf holes			AC2680 sez 4.5.24	
Fori limitatori apertura per apertura ad anta Restrictor stays holes			AC2687 sez 4.3.42-44	
Fori compassi sporgere Stay arm for awning windows holes			AC2688 sez 4.3.45	AC2689 sez 4.3.46
Fori limitatori sporgere Stay arm for awning windows holes	-	-	AC2690 sez 4.3.47	

Porta / Door**Aperture interne / Inward opening****Aperture esterne / Outward opening**Costruzione telai / Frame assembly

Inserimento squadrette (profili ottone) – Saldatura / Brackets insertion (brass section) - Welding	AC28xx sez 4.4.1-3		AC28xx sez 4.4.1-3
Sigillatura interna della giunzione (ottone) Internal joint sealing (brass sections)	AC28xx sez 4.4.1-3		AC28xx sez 4.4.1-3
Taglio punta per inversione battuta Secondary leaf top central joint working	AC2651 sez 4.3.3-4	AC2652 sez 4.3.5-6	AC2653 sez 4.3.7-8

Applicazione accessori / Accessories installation

Fori inserimento rinforzi cerniere <i>Hinge reinforcement holes</i>	- sez 4.3.1	- sez 4.3.2	
Fori per cerniere a tre ali <i>Three-wing hinge holes</i>	AC2628 sez 4.3.27-28	AC2648 sez 4.3.31-32	AC2648 sez 4.3.33-34
Foratura per cerniera a due ali <i>Two-wing hinge holes</i>	AC2629/30 sez 4.3.29-30	AC2649/50 sez 4.3.35-36	AC2649/50 sez 4.3.37-38
Saldatura cerniere a saldare <i>Hinge welding</i>	AC2631/32 sez 4.4.5	AC2631/32 sez 4.4.6	AC2631/32 sez 4.4.7
Lavorazione per paraspiro automatico <i>Automatic door bottom seal installation holes</i>	AC2636 sez 4.3.51		AC2636 sez 4.3.52

5. Preparazione per verniciatura - brunitura / *Preparation for the powder coating - burnishing*
 - a. Fori su telaio per scarichi liquidi pretrattamento
Holes on frame for the drainage of pretreatment liquid sez 5.1.4
 - b. Marcatura e imballo telai esterni e ante
External frames and leafs branding and packing -
 - c. Marcatura e imballo telai fermavetro
Glazingbeads frames branding and packing -
 - d. Marcatura e imballo profili complementari
Additional profiles branding and packing -
 - e. Imballo scarichi acqua e cerniere
Accessories (water drip, hinges) branding and packing -
6. Applicazione accessori e sigillatura / *Hardware and accessories installation and sealing*
 - a. Porta / *Door*
 - I. Montaggio cerniere / *Hinges installation* sez 4.3.27-28 | 4.4.5-7
 - II. Montaggio serratura e incontri / *Lock and strikes installation* sez 4.5.25-28
 - III. Applicazione paraspiro automatico /
Automatic door bottom seal installation holes sez 4.3.51-52
 - IV. Montaggio catenaccio / *Flush bolt installation* sez. 4.3.48-49
 - V. Montaggio guarnizioni di battuta / *Gasket installation*
 - VI. Sigillatura angolo nel TT / *Corner joint sealing*
 - b. Finestra e fissi
 - I. Applicazione e sigillatura guarnizioni giunto aperto /
Sealing of central gasket sez 4.5.1
 - II. Applicazione scarichi acqua / *water drip installation* sez 4.5.1
 - III. Montaggio cerniere / compassi / vasistas etc /
Hinges and arms installation (side hung, bottom hung, awning, etc) sez 4.5.16-24
 - IV. Montaggio cremonese e incontri / *Espagnolette installion* sez 4.5.3-15
 - V. Montaggio guarnizioni di battuta / *Gasket installation*
 - VI. Sigillatura angolo nel TT / *Corner joint sealing*
7. Vetrazione / *Glazing*
 - a. Applicazione clips fermavetro / *glazing bead clips installation* sez 2.8.1-12
 - b. Applicazione guarnizione esterna / *External glazing gasket installation*
 - c. Applicazione vetro (spessoramento) / *Glazing installation (setting blocks)* sez 4.6.1-2
 - d. Inserimento fermavetri / *Glazing beads application*
 - e. Inserimento guarnizione interna fermavetro / *Fit glazing bead to glass gasket*
 - f. Verifica corretta compressione guarnizione /
Control of the right compression of the gasket

8. Controlli su prodotto finito / *Control on finished element*
- a. Verifica distanza tra anta e telaio / *Control of gap between leaf and frame* +0 +0.5 mm
 - b. Verifica sormonto anta su telaio / *Control of leaf surmount* +0 +1 mm
 - c. Verifica sigillature per scarico acqua / *Control of central gasket sealing* test con acqua su giunto
test with water
 - d. Verifica funzionamento cremonese/maniglia serratura
Control of hardware functioning
 - e. Verifica finitura superficiale / *Control of surface finishing*
9. Controlli dopo la posa / *Controls after installation*
- a. Verifica corretta installazione telai: squadra, piombo, misure / *Control of alignment and plumbing of frame and leaf*
 - b. Verifica distanza tra anta e telaio / *Control of gap between leaf and frame* +0 +0.5 mm
 - c. Verifica sormonto anta su telaio / *Control of leaf surmount* +0, +1 mm
 - d. Verifica sigillature per scarico acqua / *Control of central gasket sealing* test con acqua su giunto
test with water
 - e. Verifica funzionamento cremonese/maniglia serratura
Control of hardware functioning
 - f. Verifica finitura superficiale / *Control of surface finishing*

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 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 e 33% zinco)

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

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 and 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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