

EBE 85

CATALOGO TECNICO TECHNICAL CATALOGUE

METALFORM™



1 Informazioni generali / General informations

Descrizione del sistema / System description	1.1.1
Tipologie e limiti dimensionali / Typologies and dimensional limits	1.2.1 – 1.2.3

2 Componenti del sistema / System component

Profili / Profiles	2.1.1 – 2.1.4
Accessori / Accessories	2.2.1 – 2.2.6
Ferramenta / Hardware	2.3.1 – 2.3.12
Squadrette / Corner joint	2.4.1 – 2.4.4
Maniglie / Handles	2.5.1 – 2.5.3
Guarnizioni / Gaskets	2.6.1 – 2.6.3
Attrezzature / Working tools	2.7.1 – 2.7.3
Prodotti / Products	2.8.1 – 2.8.2
Fermavetri / Glazing beads	2.9.1 – 2.9.12
Dividivetro / Glazing beads	2.10.1 – 2.10.2

3 Tecnica del sistema / System technique

Sezioni porte / Doors sections	3.1.1 – 3.1.11
Sezioni finestre / Windows sections	3.2.1 – 3.2.7
Attacchi alla muratura / Attachment to structure	3.3.1 – 3.3.5

4 Lavorazioni e ciclo produttivo / Processing plan

Distinte di taglio / Cutting list	4.1.1 – 4.1.17
Assiemaggio / Assembly	4.2.1 – 4.2.24
Lavorazione e applicazione accessori porte / Working and installation of door accessories	4.3.1 – 4.3.44
Lavorazione e applicazione accessori finestre / Working and installation of window accessories	4.4.1 – 4.4.72

5 Note generali sul processo / Processing general informations

Raccomandazioni per la lavorazione / Working recommendations	5.1.1 – 5.1.6
Taglio, asolature, forature / Cutting, slots, holes	5.2.1 – 5.2.2
Verifica qualità / Quality audit cycle	5.3.1
Caratteristiche materiali / Materials characteristic	5.4.1 – 5.4.2
Indice analitico / Subject index	5.5.1 – 5.5.2

Sistema integrato di profili, accessori e guarnizioni a taglio termico con profili aventi sezione di 85 mm e/o 93.5 mm, idoneo per la realizzazione di porte e finestre, rettangolari, sagomate o curve con o senza fissi laterali e superiori.

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

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

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

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

Sistema porte:

Complanarità delle ante;

Doppia guarnizione di tenuta per elevate caratteristiche prestazionali e acustiche;

Completa dotazione di accessori negli stessi materiali del profilo;

Cerniere a saldare, avvitare e a scomparsa per grandi portate;

Maniglie con diverse soluzioni estetiche;

Paraspifferi inferiore con guarnizione a pinna.

Sistema finestre:

Complanarità esterna e sormonto interno delle ante;

Sistema di guarnizioni a giunto aperto per le massime prestazioni di resistenza all'aria, acqua e vento ed elevati valori di resistenza acustica;

Idonea camera porta-accessori per l'alloggiamento di ferramenta certificata e per la riduzione dei tempi di lavorazione;

Sistema integrato completo di accessori per lo scarico acqua;

Completa dotazione di accessori:

Ferramenta per apertura ad anta, anta ribalta, vasistas per serramenti rettangolari, trapezoidali e curvi fino a 150 kg;

Ferramenta per cerniere a scomparsa.

Integrated system of thermally broken profiles, hardware and gaskets with 85 mm and 93.5 mm sections, suitable for rectangular, profiled or arched doors and windows, with or without sidelights and upper lights.

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 thermal break of the profiles is realized with an extruded polyamide reinforced with fibre-glass that is collocated flush with the external parts in metal by means of a high-density polyurethane resin injected at high pressure. The result is a seamless connection without interruptions which guarantees maximum resistance to torsional and bending stress.

For frame assembly the profiles must be joined by welding the sections in contact with each other, or by mechanically assembling and then internally welding which does not need finishing touches. Double or triple thermally insulated glazing may be used with single or stratified (safety) glass.

Doors system:

coplanarity of the doors;

double sealing gasket for high performance and acoustics;

complete with accessories in same material as profile;

hinges to be welded, screwed or concealed for large capacities;

selection of handles with different aesthetic solutions;

lower seal with fin.

Windows system:

external coplanarity and internal overlap of the leaves;

system of open joint gaskets for maximum resistance to air, water and wind, as well as high levels of acoustic resistance;

hardware container to keep all certified hardware and reduce time required for tooling;

integrated system complete with accessories for drainage of water;

all accessories furnished:

hardware for side hung opening, tilt and turn, bottom-hung windows for rectangular, trapezoidal and arched fixtures up to 150 kg. hardware for concealed hinge

PRESTAZIONI

Sistema finestre

Trasmittanza termica (UNI EN 10077-2)

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

-Finestra tipo (1230x1480 mm con $U_{g0,6}$) $U_w = 1,1 \text{ W/m}^2\text{K}$

Isolamento acustico (UNI EN 717-1)

-Fino a 47 dB

Resistenza all'aria (UNI EN 12207)

-Classe 4

Resistenza all'acqua (UNI EN 12208)

-Classe 9A

Resistenza al vento (UNI EN 12210)

-Classe C5

Resistenza alla forza di azionamento (UNI EN 13115)

-Classe 1 – < 100 N

Prova carico verticale e torsione statica (UNI EN 13115)

-Classe 4 – 800 N / 350 N

Prova di durata a cicli di apertura (UNI EN 12400)

-Classe 2 - 10.000 cicli

PERFORMANCES

Windows system

Thermal transmittance (UNI EN 10077-2)

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

-Typical window (1230x1480 mm with $U_{g0,6}$) $U_w = 1,1 \text{ W/m}^2\text{K}$

Acoustic insulation (UNI EN 717-1)

-Up to 47 dB

Air resistance (UNI EN 12207)

-Class 4

Watertightness (UNI EN 12208)

-Class 9A

Resistance to wind load (UNI EN 12210)

-Class C5

Resistance to drive force (UNI EN 13115)

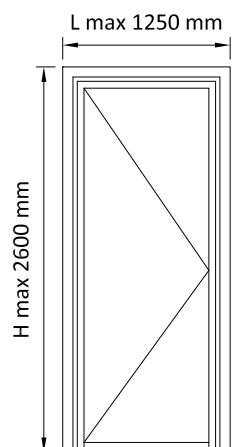
-Class 1 – < 100 N

Test for vertical load and static torsion (UNI EN 13115)

-Class 4 – 800 N / 350 N

Resistance to repeated opening and closing (UNI EN 12400)

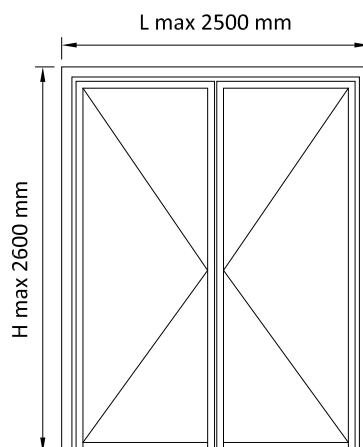
-Class 2 – 10.000 opening and closing

Limiti dimensionali - Maximum dimension

porta ad un anta
one-leaf doors

peso massimo anta*
*maximum leaf weight**

AC1033 - 160 kg
AC1058 - 180 kg
AC6023 - 200 kg
AC1037 - 250 kg

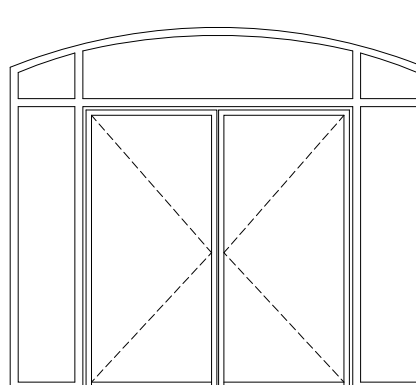
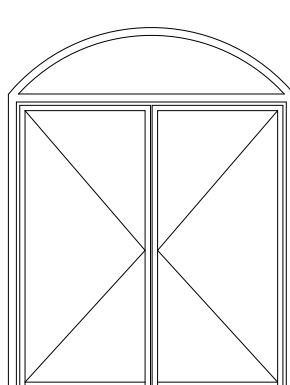
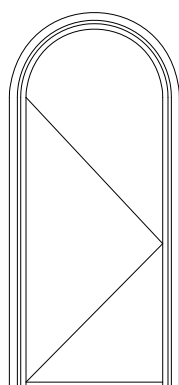
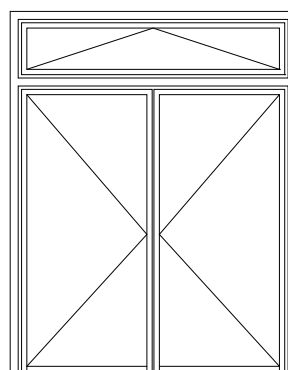
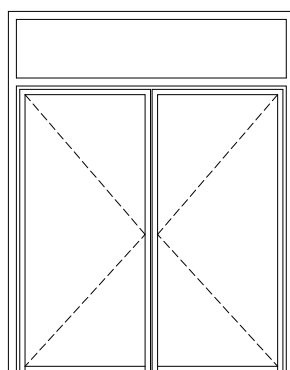
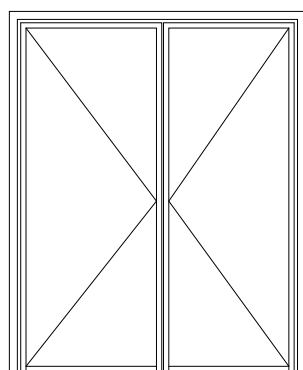
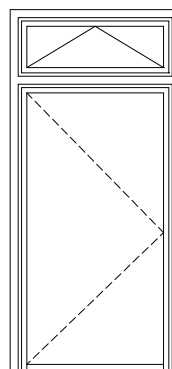
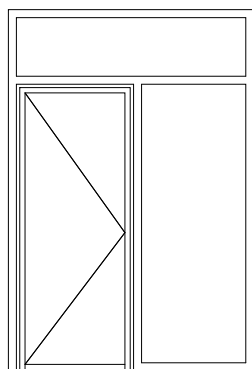
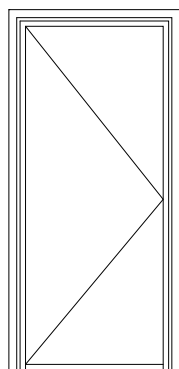


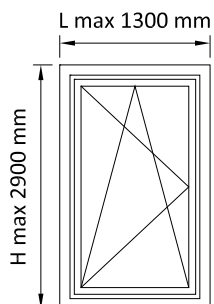
porta a due ante
two-leaf doors

peso massimo anta*
*maximum leaf weight**

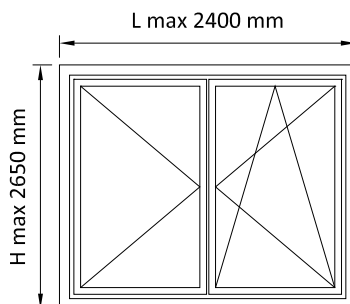
AC1033 - 160 kg
AC1058 - 180 kg
AC6023 - 200 kg
AC1037 - 250 kg

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

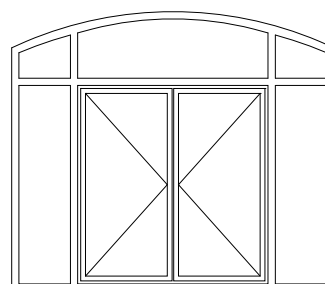
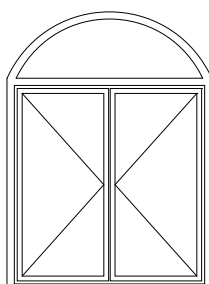
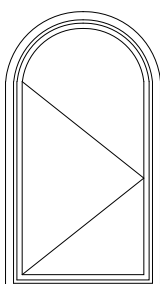
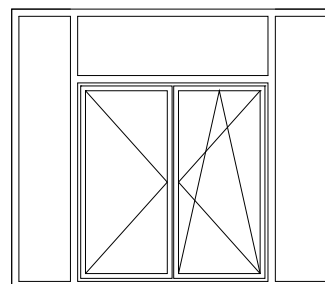
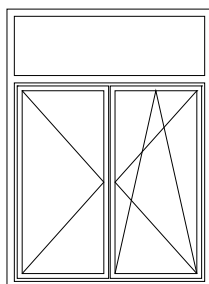
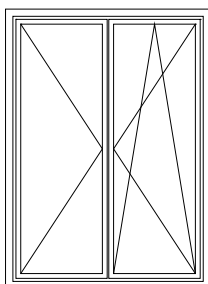
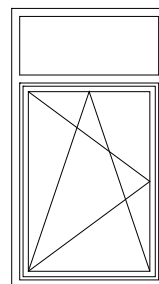
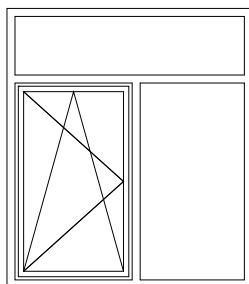
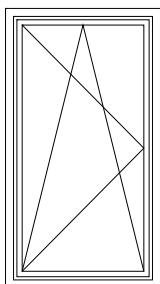
Esempi tipologie realizzabili - Types of door

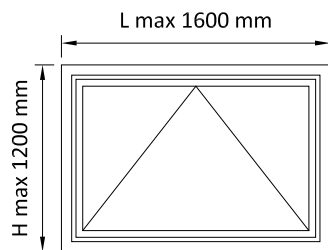
Limiti dimensionali - Maximum dimensionfinestra ad un anta
one-leaf opening windowspeso massimo anta
maximum leaf weight

AC1237	- 180 kg	
AC2632/C	- 80 kg	
AGE271-2	- 150 kg	Easy
AG1273	- 80 kg	Easy
AG1278	- 80 kg	Easy
AGE281-2	- 130 kg	Easy
AGE291-2	- 130 kg	Easy
AGA271	- 180 kg	Easy
AG1271-2	- 150 kg	RC2
AG1281-2	- 130 kg	RC2
AG1291-2	- 130 kg	RC2

finestra a due ante
two-leaf opening windowspeso massimo anta
maximum leaf weight

AC1237	- 180 kg	
AC2632/C	- 80 kg	
AGE271-2-5-6	- 150 kg	Easy
AG1273	- 80 kg	Easy
AG1278	- 80 kg	Easy
AGE281-2-5-6	- 130 kg	Easy
AGE291-2-5-6	- 130 kg	Easy
AGE775-6	- 150 kg	Easy
AGE785-6	- 130 kg	Easy
AGE795-6	- 130 kg	Easy
AGA271-5	- 180 kg	Easy
AG1271-2-5-6	- 150 kg	RC2
AG1281-2-5-6	- 130 kg	RC2
AG1291-2-5-6	- 130 kg	RC2

Esempi tipologie realizzabili - Types of window

Limiti dimensionali - Maximum dimension

ferramenta e cremonese
hardware and cremone

finestra a vasistas
bottom-hung window

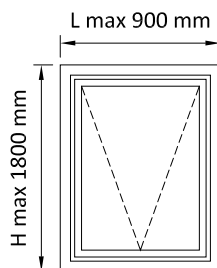
peso massimo anta
maximum leaf weight

AG1264 - AG1274

AC2632/C - 100 kg

AC1221 - 100 kg

AG1224 - 100 kg

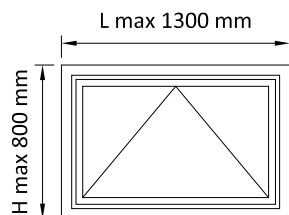


finestra a sporgere
awning window

peso massimo anta
maximum leaf weight

AC1046 - 75 kg

AC1046M - 120 kg



braccetti e cricchetto
stays and finger catch

finestra a vasistas
bottom-hung window

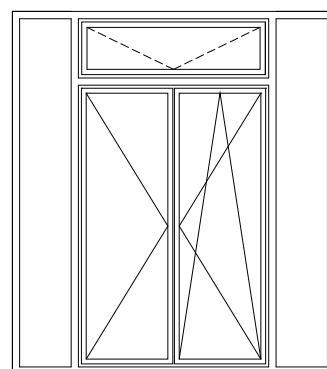
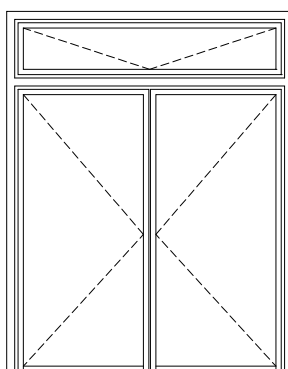
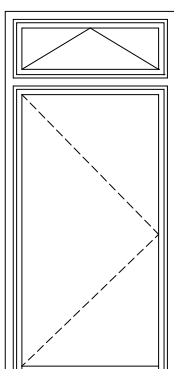
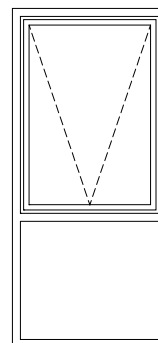
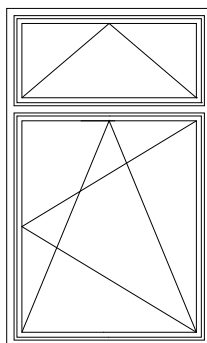
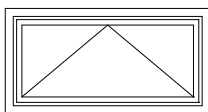
peso massimo anta
maximum leaf weight

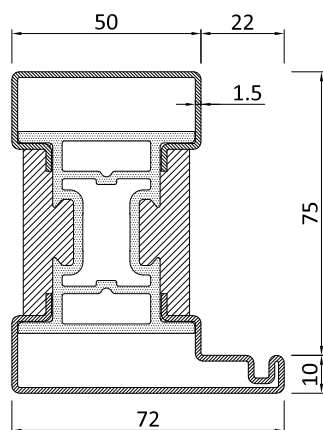
AC1235

AC2632/C - 70 kg

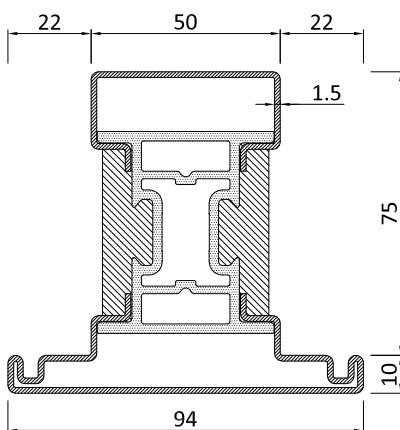
AC1221 - 70 kg

AG1224 - 70 kg

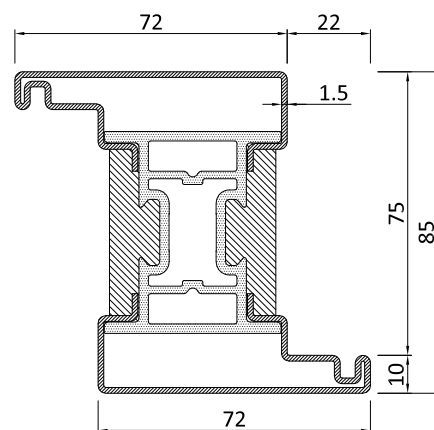
Esempi tipologie realizzabili - Types of window



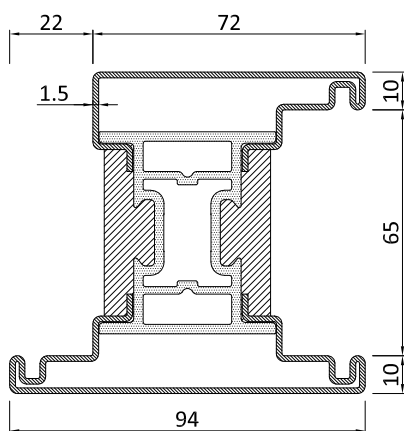
P.1101



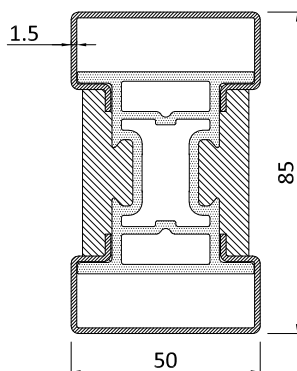
P.1102



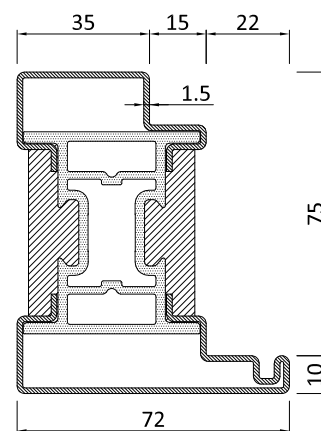
P.1103



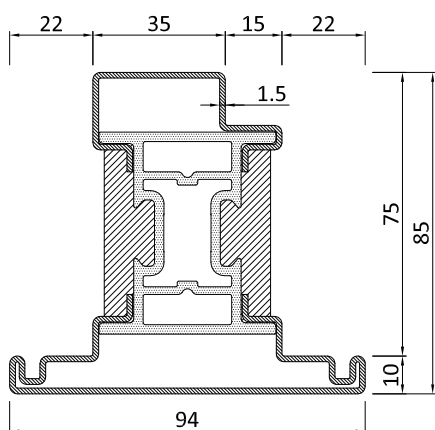
P.1105



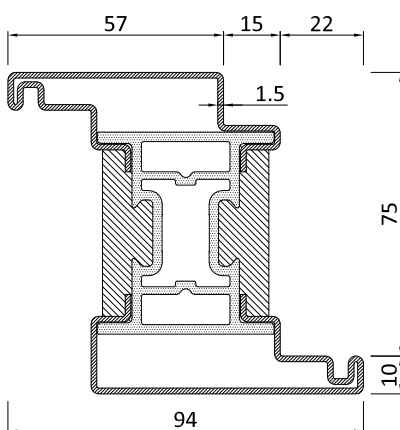
P.1110



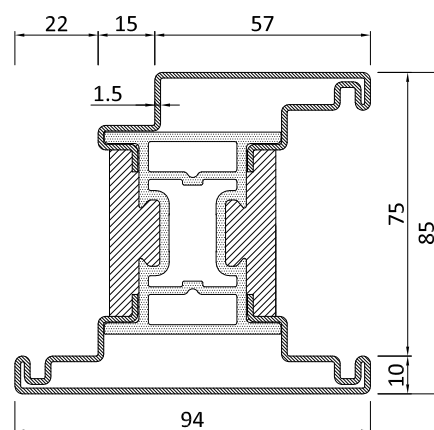
P.1111



P.1112

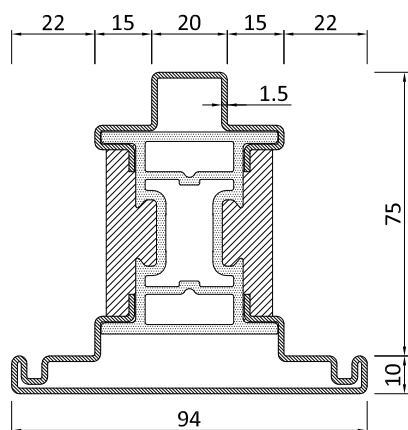


P.1113

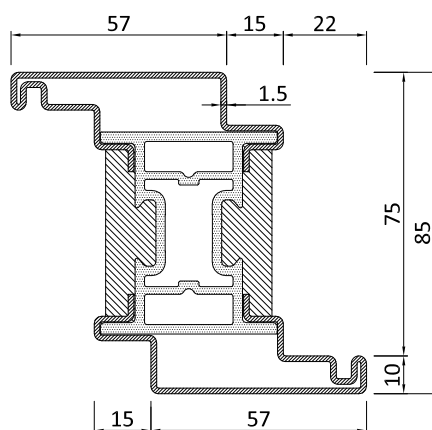


P.1115

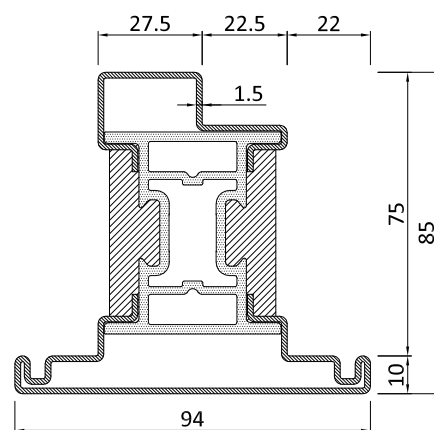
Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m	Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m
	ZN / I - CT	OT						ZN / I - CT	OT				
P.1101	4,94	5,20	0,35	35,21	21,92	6	P.1111	4,90	5,16	0,35	33,26	21,11	6
P.1102	5,48	5,78	0,40	38,44	37,36	6	P.1112	5,44	5,74	0,40	36,33	36,25	6
P.1103	5,51	5,83	0,40	41,74	34,49	6	P.1113	5,50	5,81	0,40	40,28	338	6
P.1105	6,5	6,41	0,46	45,99	47,37	6	P.1115	64	6,39	0,46	44,39	45,72	6
P.1110	4,37	4,57	0,30	30,13	12,17	6							



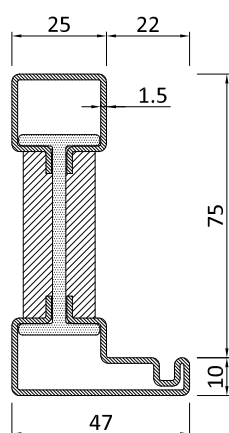
P.1122 Non fornito in acciaio zincato
Not in galvanized steel



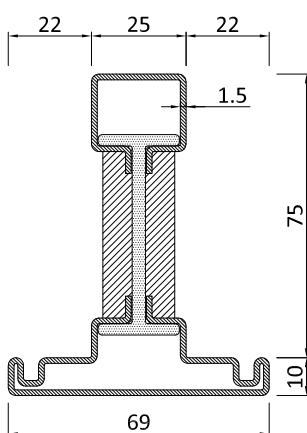
P.1123



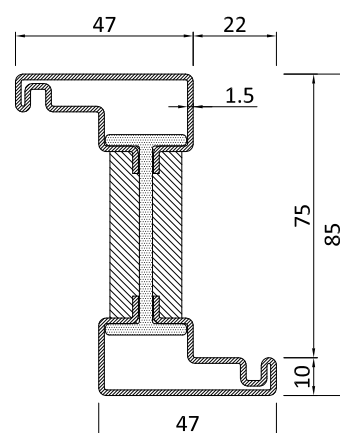
P.1127



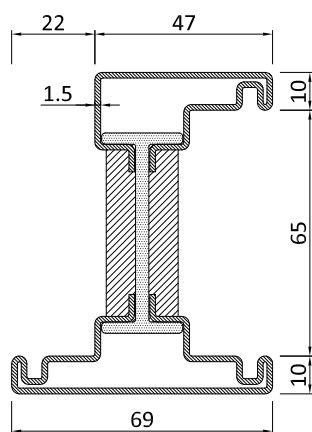
P.1301



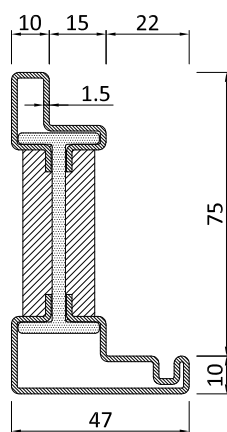
P.1302



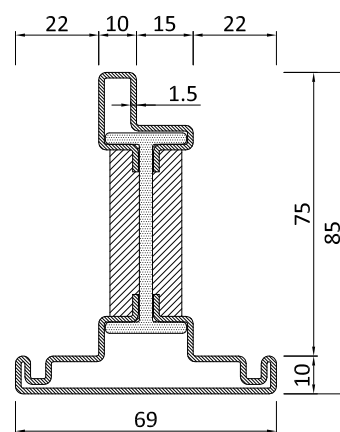
P.1303



P.1305



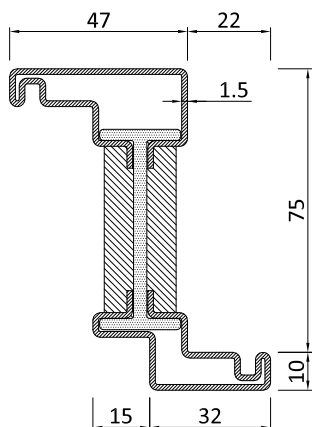
P.1311



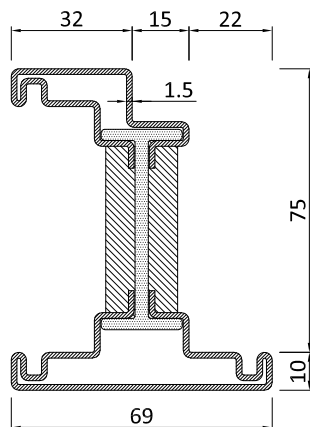
P.1312

Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m
	ZN / I - CT	OT				
P.1122	5,50	5,52	0,40	34,15	35,22	6
P.1123	5,49	5,79	0,40	38,86	31,70	6
P.1127	5,48	5,78	0,40	35,30	36,5	3
P.1301	3,67	3,88	0,30	27,35	6,59	6
P.1302	4,22	4,48	0,35	30,61	14,14	6

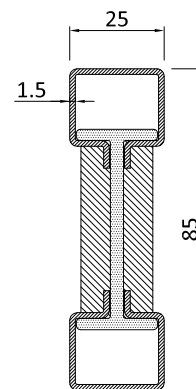
Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m
	ZN / I - CT	OT				
P.1303	4,25	4,51	0,35	35,07	12,71	6
P.1305	4,80	5,11	0,40	39,27	18,76	6
P.1311	3,65	3,86	0,30	25,15	6,56	6
P.1312	4,20	4,46	0,35	28,20	13,83	6



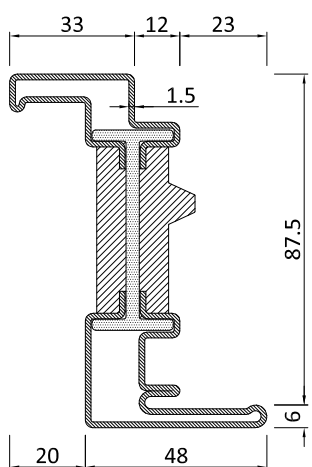
P.1313



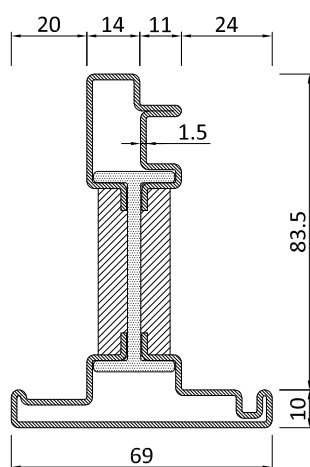
P.1315



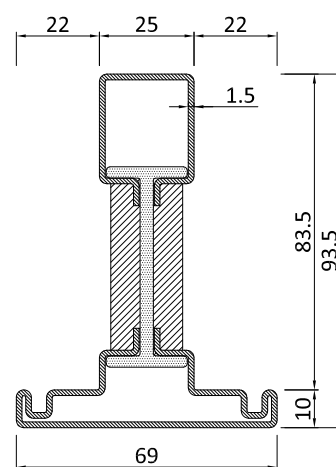
P.1320



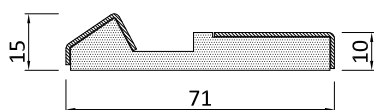
P.1333



P.1924

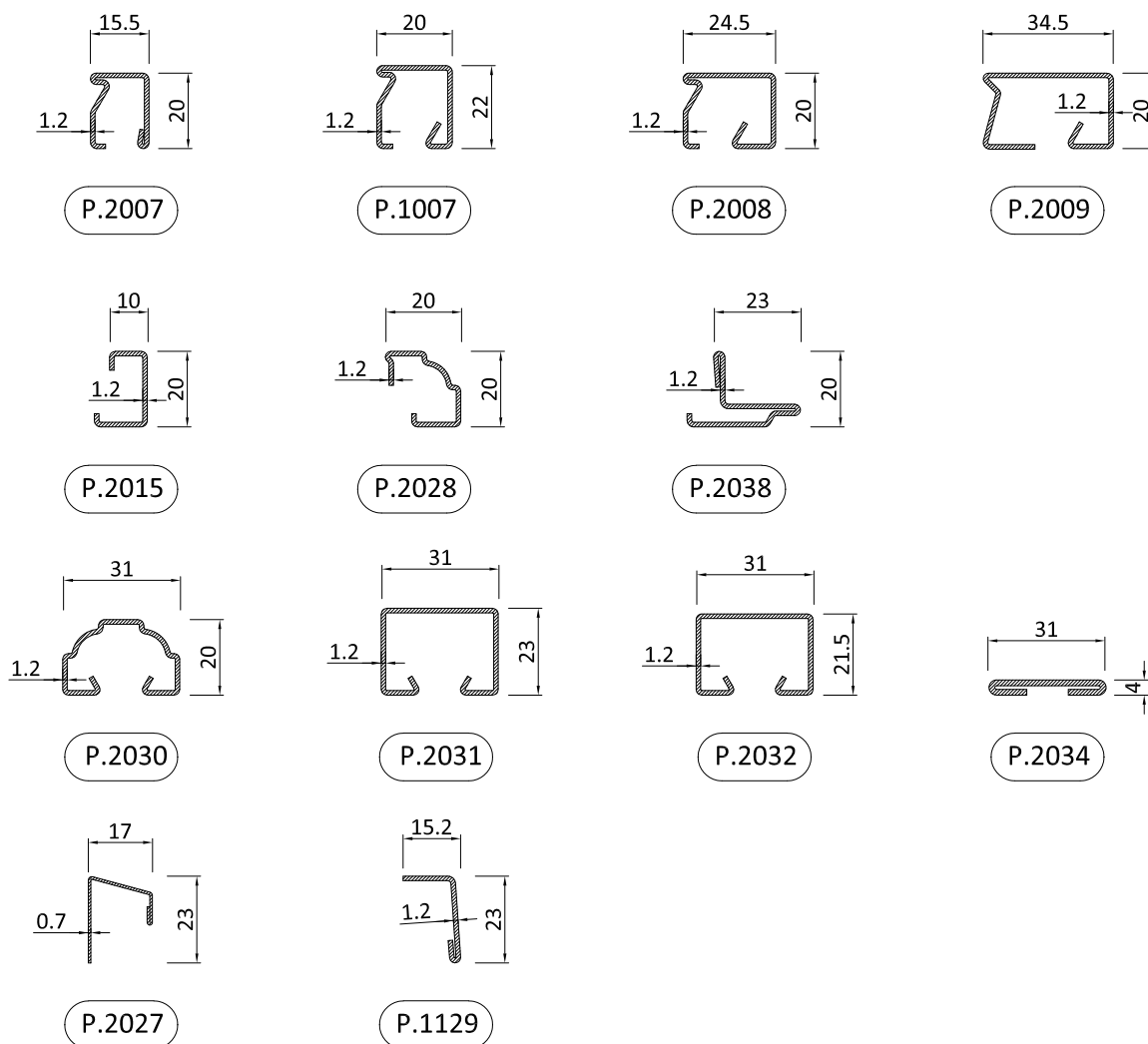


P.1902



P.1130

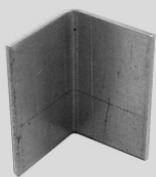
Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m	Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m
	ZN / I - CT	OT						ZN / I - CT	OT				
P.1313	4,20	4,46	0,35	33,50	12,21	6	P.1902	4,22	4,48	0,35	34,95	14,14	3
P.1315	4,75	5,60	0,40	38,20	18,60	6	P.1130	1,64	1,71	0,16			3
P.1320	3,90	3,25	0,25	21,80	2,16	6							
P.1333	4,64	4,93	0,39	42,97	9,86	6							
P.1924	4,53	4,81	0,36	37,56	13,34	6							



MATERIALE | MATERIAL

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

Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m
	ZN / I - CT	OT				
P.2007	0,57	0,62	0,13			6
P.1007	0,70	0,75	0,16			6
P.2008	0,75	0,82	0,17			6
P.2009	0,91	0,99	0,20			6
P.2015	0,43	0,46	0,09			6
P.2028	0,48	0,52	0,11			6
P.2038	0,68	0,74	0,16			6
P.2030	0,73	0,79	0,17			6
P.2031	0,98	1,06	0,20			4
P.2032	0,95	1,03	0,19			4
P.2034	0,51	0,56	0,10			4
P.2027	0,51	0,56	0,10			3
P.1129	0,41	0,44	0,06			3



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

AC 1014

Accessorio inversione battuta
per porte
P.1112-P.1113

n.2 pz. per ogni angolo

Reverse closure kit for doors
P.1112-P.1113

n. 2 pieces for each corner



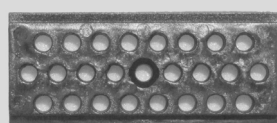
AC1037SB inox scotch brite | *scotch brite st. steel*
AC1037ST inox satinato | *satinated stainless steel*
AC1037L inox lucido | *polished stainless steel*
AC1037B inox brunito | *burnished stainless steel*

AC1037.

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

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

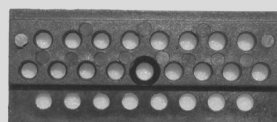
AISI 304



AC 1020XL

Supporto per spessore vetro
Vetro superiore a 42 mm

Glass spacer
Glass over 42 mm



AC 1020XS

Supporto per spessore vetro
Vetro fino a 42 mm

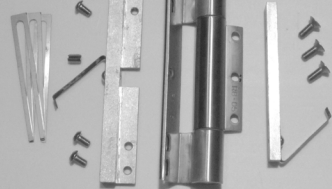
Glass spacer
Glass up to 42 mm



AC 1037/R

Rinforzo cerniera AC1037 su
profili ridotti

*Reinforcement for hinge AC1037
on reduced profiles*



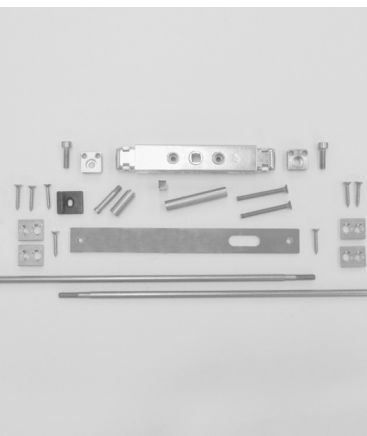
AC1033IZ inox verniciabile | *paintable stainless steel*
AC1033SB inox scotch brite | *scotch brite st. steel*
AC1033ST inox satinato | *satinated stainless steel*
AC1033L inox lucido | *polished stainless steel*
AC1033B inox brunito | *burnished stainless steel*
AC1033CZ corten grezzo | *untreated corten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

AC1033.

Cerniera a stilo ad avvitare con
viti e rinforzi per porta
Peso massimo anta: 160 kg

*Screw-on hinge with screws and
strengtheners for door*
Maximum leaf weight: 160 kg

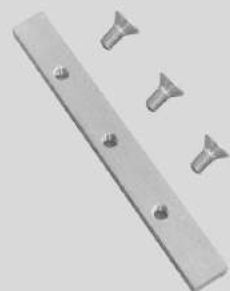
AISI 304



AC 1039

Kit cremone per chiusura
orizzontale su sporgere

*Cremone bolt set for horizontal
awning closing*



AC 1033/R

Rinforzo cerniera AC1033 su
profili ridotti

*Reinforcement for hinge AC1033
on reduced profiles*



AC 1040

Kit chiusura porte seconda anta
Acciaio inox

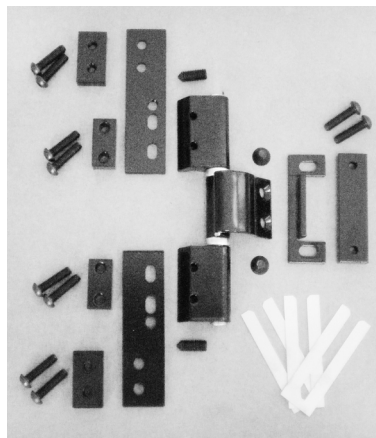
Second leaf door closing kit
Stainless steel



AC 1046

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

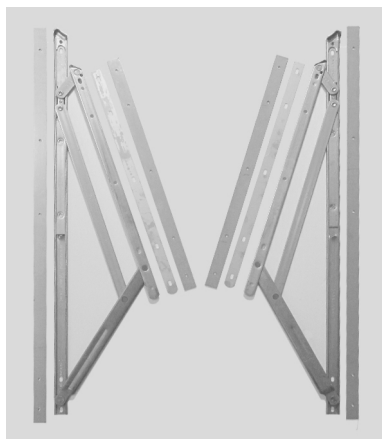
Pair of side arms for awning opening
Stainless steel
Maximum leaf weight: 75 kg



AC 1068

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

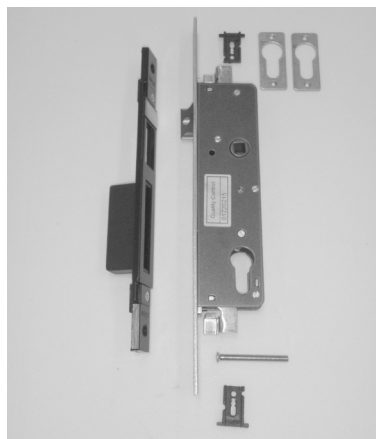
Concealed hinge for door
Maximum leaf weight: 180 kg
Maximum opening: 96°



AC 1046M

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

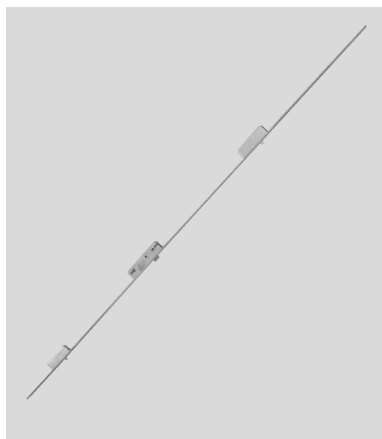
Pair of side arms for awning opening
Stainless steel
Maximum leaf weight: 120 kg



AC 1070

Serratura con scrocco e catenaccio

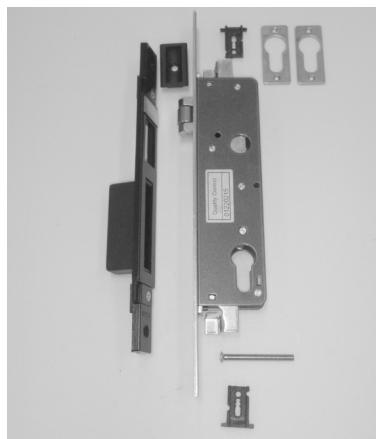
Lock with spring latch and bolt



AC 1065W D-S

Serratura multipunto
Altezza anta da 2000 a 2300 mm

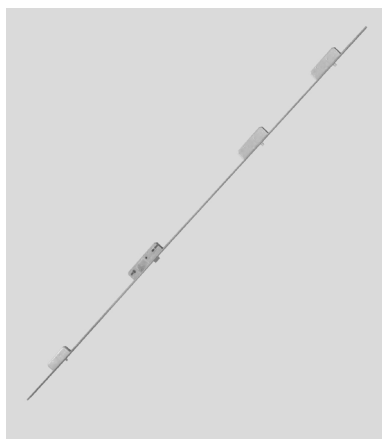
Multipoint lock
Leaf height from 2000 to 2300 mm



AC 1071

Serratura con rullo e catenaccio

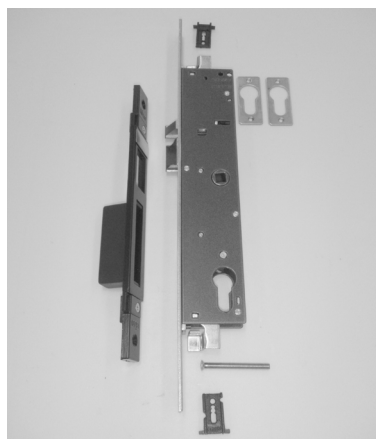
Lock with roller and bolt



AC 1067W D-S

Serratura multipunto
Altezza anta oltre 2900 mm

Multipoint lock
Leaf height over 2900 mm



AC 1072

Elettroserratura

Electric lock

**AC 1075**

Deviatore per triplice chiusura

Deviator for three-point lock

**AC 1219.**

Scarico acqua per aperture interne in metallo

Metal drip for inward openings

AC 1219NE

Scarico acqua per aperture interne in plastica nera

Black plastic drip for inward openings

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

**AC 1080I**

Rostro di sicurezza in acciaio inox
Completo di viti e rinforzi

*Stainless steel security pin
With screws and strengtheners*

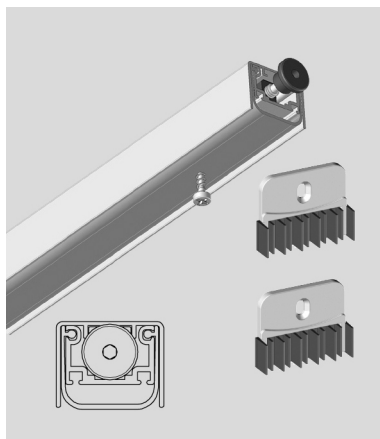
**AC 1221.**

Cerniera in acciaio inox a tre ali
ad avvitare per vasistas
Peso massimo anta: 70-100 kg

*Stainless steel hinge to be
screwed for bottom-hung
window
Maximum leaf weight: 70-100 kg*

AC1221SB inox scotch brite | scotch brite st. steel
AC1221L inox lucido | polished stainless steel
AC1221B inox brunito | burnished stainless steel

AISI 316

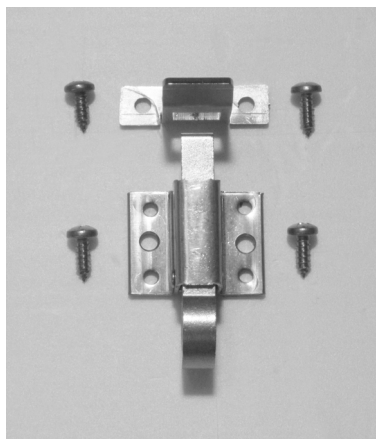
**AC 1081**

Paraspiffero automatico a
ghigliottina

Guillotine type draught excluder

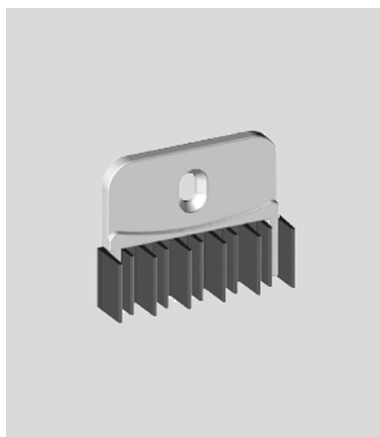
Dimensioni anta | *Leaf dimension*

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

**AC 1223I**

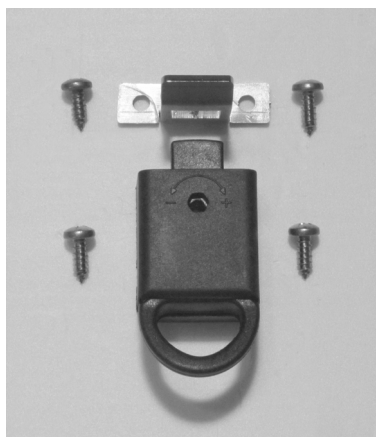
Cricchetto ed incontro da
avvitare in acciaio inox, per
vasistas

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

**AC 1081 AT**

Accessorio di battuta

Stop accessory

**AC 1231S**

Cricchetto ed incontro da avvitare in nylon nero, per vasistas

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

**AC 1235**

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

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

**AC 1714**

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

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

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

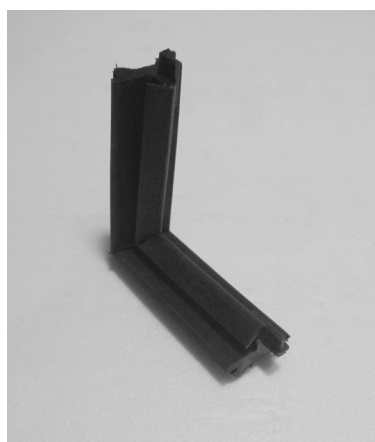
**AC 1237.**

Cerniera a stilo ad avvitare con viti e rinforzi per finestra
Peso massimo anta: 180 kg

Hinge to be screwed with screws and strengtheners for window
Maximum leaf weight: 180 kg

AC1237IZ inox verniciabile | *paintable stainless steel*
AC1237SB inox scotch brite | *scotch brite st. steel*
AC1237L inox lucido | *polished stainless steel*
AC1237B inox brunito | *burnished stainless steel*

AISI 304

**AC 1716**

Guarnizione d'angolo vulcanizzata per GE1701

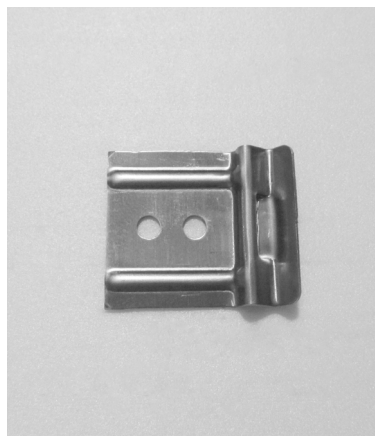
Vulcanised corner gasket for GE1701

**AC 1355**

Kit inversione battuta finestra A/R a due ante - nodo ZTZ

Reverse closing 2nd-leaf Tilt&Turn window - ZTZ profiles

AC1355 acciaio zincato | *galvanized steel*
AC1355CZ acciaio corten | *corten steel*
AC1355I acciaio inox | *stainless steel*
AC1355B inox brunito | *burnished stainless steel*

**AC 2608**

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

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

**AC 1356**

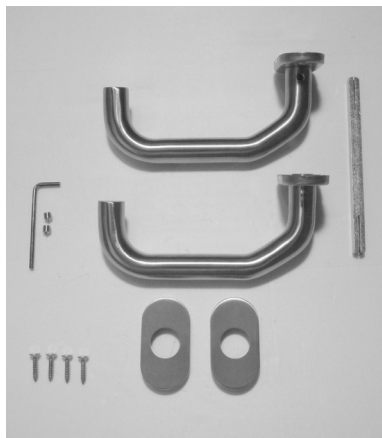
Meccanismo DK esterno per maniglie "Vitruvio"

External tilt and turn mechanism for "Vitruvio" handles

**AC 2632/C**

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

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

**AC 5002**

Coppia di maniglie per porta in acciaio inox completa di viti

Pair of stainless steel door handles with screws

**AG 1224**

Cerniera a tre ali ad avvitare per vasistas

Peso massimo anta: 70-100 kg

Screw-on hinge for bottom-hung window

Maximum leaf weight: 70-100 kg

**AC 5037**

Maniglia con incontro in lega colore nero per apertura a sporgere

Completa di viti di fissaggio

Handle with black alloy plate for projecting opening

With fixing screws

**AG 1224 ..**

Kit copertine in plastica per cerniere AG 1224

Plastic cover for hinges AG 1224

AG1224/C argento | matt silver
AG1224MC marrone | brown
AG1224BC bronzato chiaro | light bronze plated
AG1224BO ottonato opaco | matt brass plated
AG1224OL ottonato lucido | brass plated
AG1224ST inox | stainless steel
AG1224GR grigio | gray
AG1224NI nichelato | nickel
AG1224WB bianco RAL 9001 | white RAL 9001
AG1224WC bianco RAL 9010 | white RAL 9010

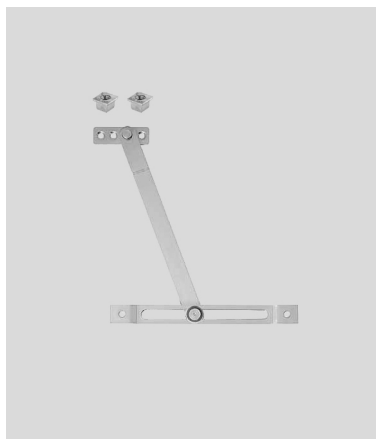
**AC 5056**

Maniglia DK per cremone in acciaio inox scotch brite per P.1333

Completa di viti

DK handle for cremone bolt in scotch-brite stainless steel for P.1333

With fixing screws

**AG 1385**

Limitatore di apertura frizionato per meccanismi A/R a vista

Solo per meccanismi EASY

Friction stay for tilt-turn mechanism, visible hinges

Only for EASY mechanism

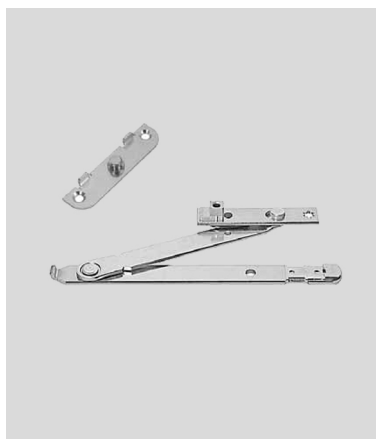
**AC 6023**

Cerniera registrabile a due ali in acciaio zincato a saldare | Ø 20

Peso massimo anta: 200 kg

Adjustable weld-on hinge in galvanised steel | Ø 20

Maximum leaf weight: 200 kg

**AG 1386**

Limitatore di apertura frizionato per meccanismi A/R a scomparsa

Solo per meccanismi EASY

Friction stay for tilt-turn mechanism, concealed hinges

Only for EASY mechanism



AG 6530

Limitatore di corsa per
meccanismi A/R

*Opening limiter on tilt&turn
mechanism*



CV 5001.

Vite per boccola fermavetri

Screw for glazing bead bushing

TPS 4.2x16 mm

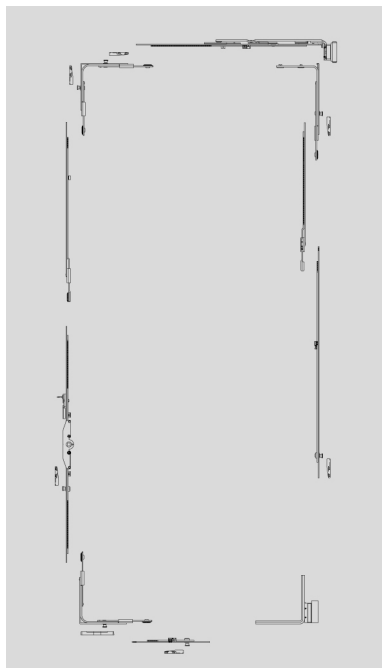
CV 5012.

Boccola per fermavetri

Bushing for glazing bead

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

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

**AGE 271**

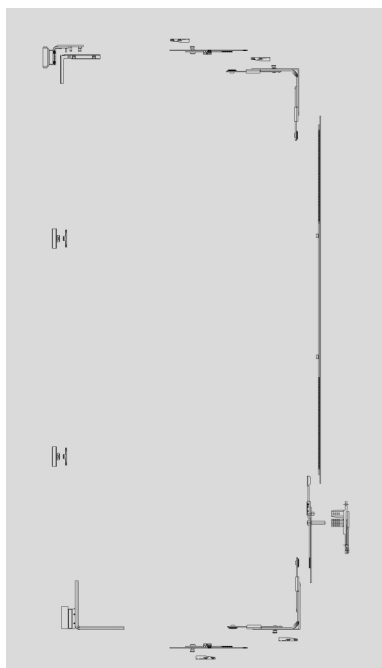
Meccanismo A/R prima anta Dx cerniere a vista

*First leaf RH tilt-turn mechanism with visible hinges***EASY****AGE 272**

Meccanismo A/R prima anta Sx cerniere a vista

*First leaf LH tilt-turn mechanism with visible hinges***EASY**

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

Limiti dimensionali | LimitsPeso massimo anta | *Maximum leaf weight: 150 kg*misure cava ferramenta - H>L | *hardware measure - H>W***AGE 275**

Meccanismo A/R seconda anta Dx cerniere a vista - Nodo ZTZ

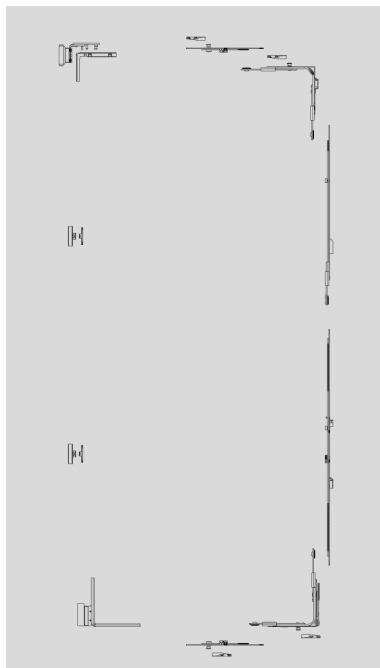
*Second leaf RH tilt-turn mechanism with visible hinges - ZTZ profiles***EASY****AGE 276**

Meccanismo A/R seconda anta Sx cerniere a vista - Nodo ZTZ

*Second leaf LH tilt-turn mechanism with visible hinges - ZTZ profiles***EASY**

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

Limiti dimensionali | LimitsPeso massimo anta | *Maximum leaf weight: 150 kg*misure cava ferramenta - H>L | *hardware measure - H>W*

**AGE 775**

Meccanismo A/R seconda anta Dx cerniere a vista - Nodo TZ

*Second leaf RH tilt-turn mechanism with visible hinges - TZ profiles***EASY****AGE 776**

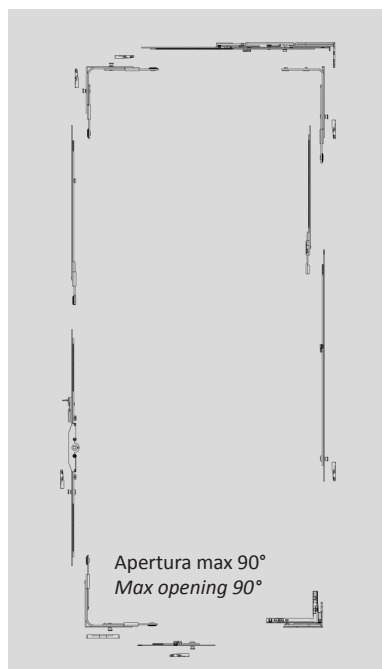
Meccanismo A/R seconda anta Sx cerniere a vista - Nodo TZ

*Second leaf LH tilt-turn mechanism with visible hinges - TZ profiles***EASY**

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

Limiti dimensionali | LimitsPeso massimo anta | *Maximum leaf weight: 150 kg*misure cava ferramenta - H>L | *hardware measure - H>W***AG 1271 ..**Kit copertine destre in plastica
per kit A/R AGE 271-5*Plastic right-cover kit for
tilt&turn for kit AGE 271-5***AG 1272 ..**Kit copertine sinistre in plastica
per kit A/R AGE 272-6*Plastic left-cover kit for tilt&turn
for kit AGE 272-6*

AG127-/C argento | *matt silver*
AG127-MC marrone | *brown*
AG127-BC bronzato chiaro | *light bronze plated*
AG127-BO ottonato opaco | *matt brass plated*
AG127-OL ottonato lucido | *brass plated*
AG127-ST inox | *stainless steel*
AG127-NI nichelato | *nickel*
AG127-WB bianco RAL 9001 | *white RAL 9001*
AG127-WC bianco RAL 9010 | *white RAL 9010*

**AGE 281**

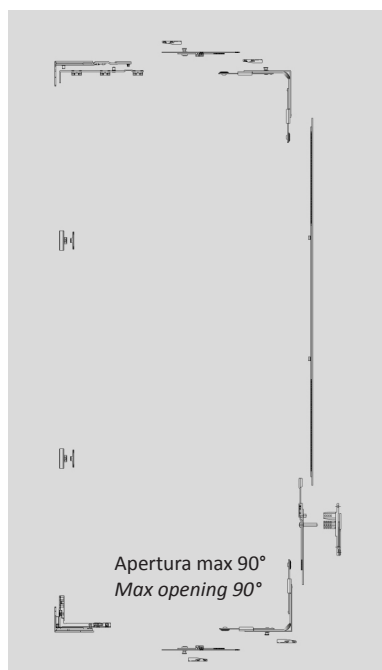
Meccanismo A/R prima anta Dx cerniere a scomparsa

*First leaf RH tilt-turn mechanism with concealed hinges***EASY****AGE 282**

Meccanismo A/R prima anta Sx cerniere a scomparsa

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

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

Limiti dimensionali | LimitsPeso massimo anta | *Maximum leaf weight: 130 kg*misure cava ferramenta - H>L | *hardware measure - H>W***AGE 285**

Meccanismo A/R seconda anta Dx cerniere a scomparsa - Nodo ZTZ

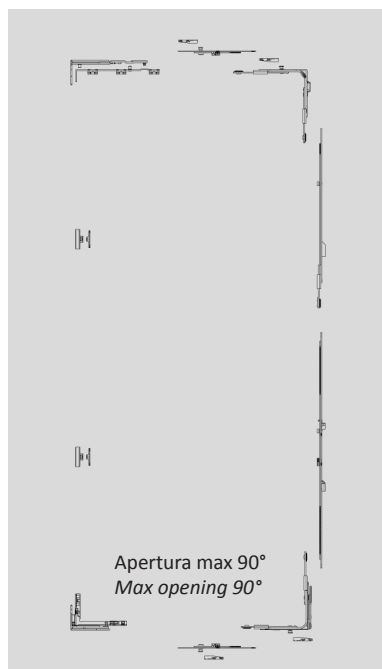
*Second leaf RH tilt-turn mechanism with concealed hinges - ZTZ profiles***EASY****AGE 286**

Meccanismo A/R seconda anta Sx cerniere a scomparsa - Nodo ZTZ

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

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

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

**AGE 785**

Meccanismo A/R seconda anta Dx cerniere a scomparsa - Nodo TZ

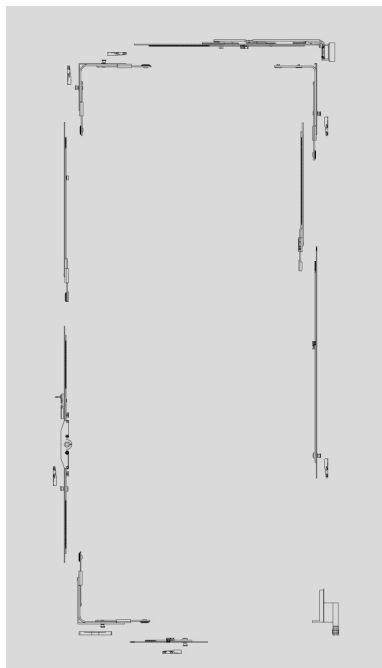
*Second leaf RH tilt-turn mechanism with concealed hinges - TZ profiles***EASY****AGE 786**

Meccanismo A/R seconda anta Sx cerniere a scomparsa - Nodo TZ

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

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

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

**AGE 291**

Meccanismo A/R prima anta Dx cerniere a vista in acciaio inox

First leaf RH tilt-turn mechanism with visible stainless steel hinges

EASY

AGE 292

Meccanismo A/R prima anta Sx cerniere a vista in acciaio inox

First leaf LH tilt-turn mechanism with visible stainless steel hinges

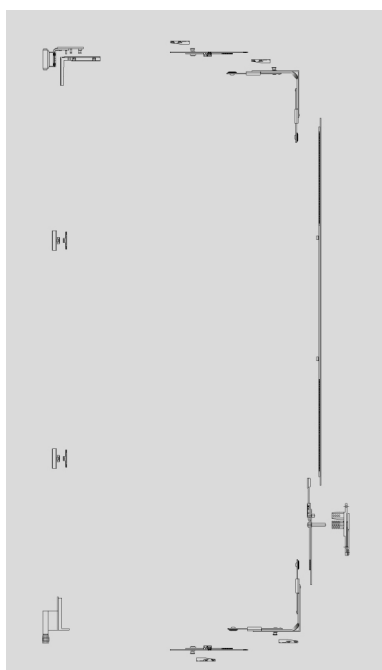
EASY

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

Limiti dimensionali | Limits

Peso massimo anta | *Maximum leaf weight: 130 kg*

misure cava ferramenta - H>L | *hardware measure - H>W*

**AGE 295**

Meccanismo A/R seconda anta Dx cerniere a vista in acciaio inox - Nodo ZTZ

Second leaf RH tilt-turn mechanism with visible stainless steel hinges - ZTZ profiles

EASY

AGE 296

Meccanismo A/R seconda anta Sx cerniere a vista in acciaio inox - Nodo ZTZ

Second leaf LH tilt-turn mechanism with visible stainless steel hinges - ZTZ profiles

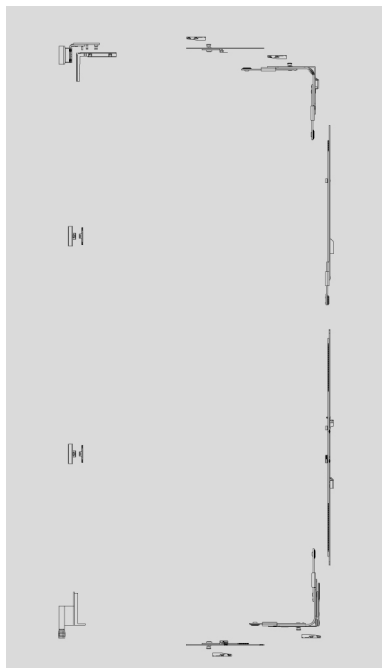
EASY

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

Limiti dimensionali | Limits

Peso massimo anta | *Maximum leaf weight: 130 kg*

misure cava ferramenta - H>L | *hardware measure - H>W*

**AGE 795**

Meccanismo A/R seconda anta Dx cerniere a vista in acciaio inox - Nodo TZ

Second leaf RH tilt-turn mechanism with visible stainless steel hinges - TZ profiles

EASY

AGE 796

Meccanismo A/R seconda anta Sx cerniere a vista in acciaio inox - Nodo TZ

Second leaf LH tilt-turn mechanism with visible stainless steel hinges - TZ profiles

EASY

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

Limiti dimensionali | Limits

Peso massimo anta | *Maximum leaf weight: 130 kg*

misure cava ferramenta - H>L | *hardware measure - H>W*

**AGA 271**

Meccanismo di chiusura anta principale Dx o Sx con telaio sui quattro lati, cerniere escluse

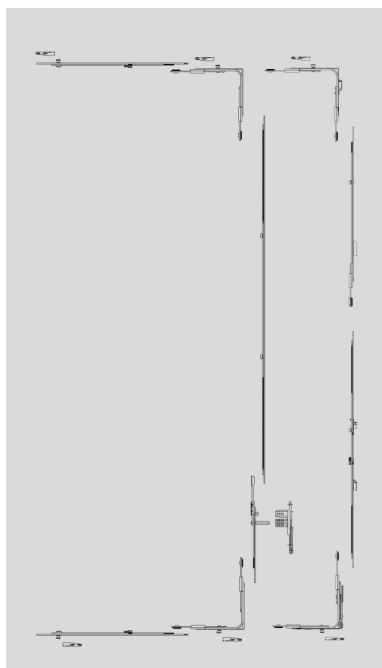
Master leaf RH or LH locking mechanism on four sides, hinges excluded

EASY

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

Limiti dimensionali | Limits

misure cava ferramenta - H>L | *hardware measure - H>W*

**AGA 275**

Meccanismo di chiusura seconda anta Dx o Sx con telaio sui quattro lati, cerniere escluse - nodo ZTZ

Second leaf leaf RH or LH locking mechanism on four sides, hinges excluded - ZTZ profiles

EASY

AGA 775

Meccanismo di chiusura seconda anta Dx o Sx con telaio sui quattro lati, cerniere escluse - nodo TZ

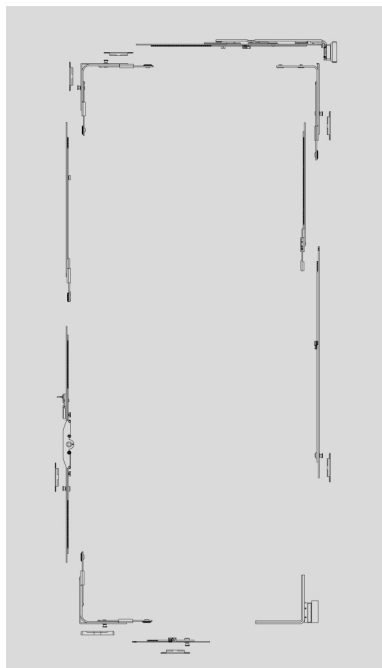
Second leaf leaf RH or LH locking mechanism on four sides, hinges excluded - TZ profiles

EASY

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

Limiti dimensionali | Limits

misure cava ferramenta - H>L | *hardware measure - H>W*

**AG 1271**

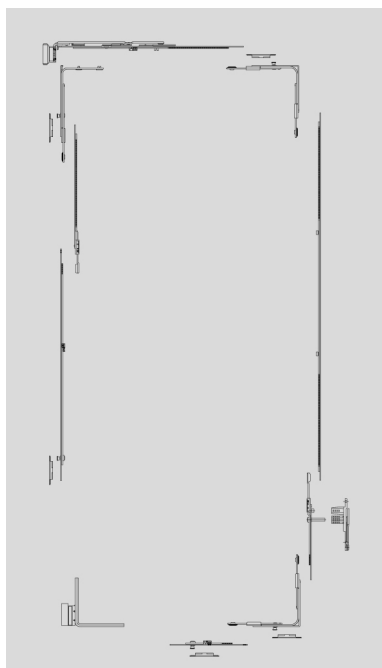
Meccanismo A/R prima anta Dx cerniere a vista

*First leaf RH tilt-turn mechanism with visible hinges***RC2** (no su profili in ottone | *not on brass profiles*)**AG 1272**

Meccanismo A/R prima anta Sx cerniere a vista

*First leaf LH tilt-turn mechanism with visible hinges***RC2** (no su profili in ottone | *not on brass profiles*)

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

Limiti dimensionali | LimitsPeso massimo anta | *Maximum leaf weight: 150 kg*misure cava ferramenta - H>L | *hardware measure - H>W***AG 1275**

Meccanismo A/R seconda anta Dx cerniere a vista - Nodo ZTZ

*Second leaf RH tilt-turn mechanism with visible hinges - ZTZ profiles***RC2** (no su profili in ottone | *not on brass profiles*)**AG 1276**

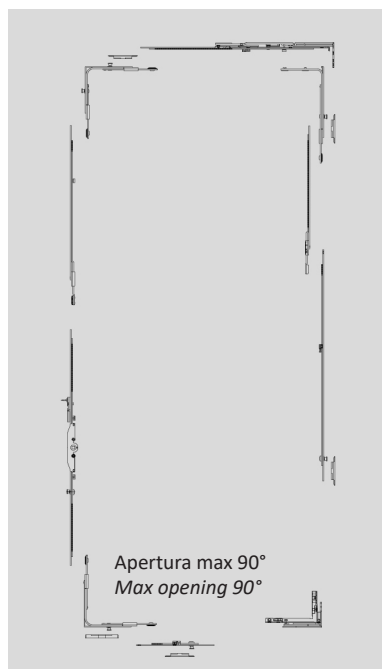
Meccanismo A/R seconda anta Sx cerniere a vista - Nodo ZTZ

*Second leaf LH tilt-turn mechanism with visible hinges - ZTZ profiles***RC2** (no su profili in ottone | *not on brass profiles*)

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

Limiti dimensionali | LimitsPeso massimo anta | *Maximum leaf weight: 150 kg*misure cava ferramenta - H>L | *hardware measure - H>W***AG 1271 ..**Kit copertine destre in plastica
per kit A/R AG 1271-5*Plastic right-cover kit for
tilt&turn for kit AG 1271-5***AG 1272 ..**Kit copertine sinistre in plastica
per kit A/R AG 1272-6*Plastic left-cover kit for tilt&turn
for kit AG 1272-6*

AG127-/C argento | *matt silver*
AG127-MC marrone | *brown*
AG127-BC bronzato chiaro | *light bronze plated*
AG127-BO ottonato opaco | *matt brass plated*
AG127-OL ottonato lucido | *brass plated*
AG127-ST inox | *stainless steel*
AG127-NI nichelato | *nickel*
AG127-WB bianco RAL 9001 | *white RAL 9001*
AG127-WC bianco RAL 9010 | *white RAL 9010*

**AG 1281**

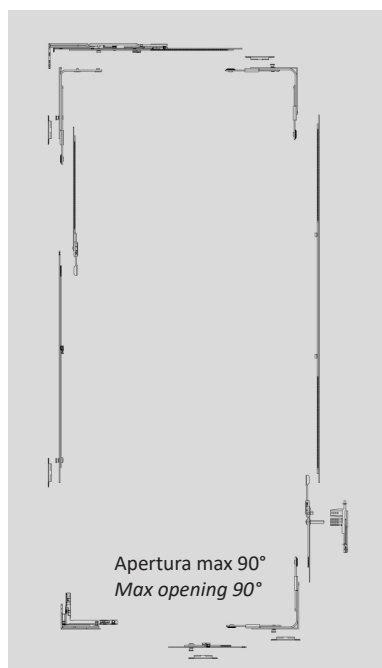
Meccanismo A/R prima anta Dx cerniere a scomparsa

*First leaf RH tilt-turn mechanism with concealed hinges***RC2** (no su profili in ottone | *not on brass profiles*)**AG 1282**

Meccanismo A/R prima anta Sx cerniere a scomparsa

*First leaf LH tilt-turn mechanism with concealed hinges***RC2** (no su profili in ottone | *not on brass profiles*)

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

Limiti dimensionali | LimitsPeso massimo anta | *Maximum leaf weight: 130 kg*misure cava ferramenta - H>L | *hardware measure - H>W***AG 1285**

Meccanismo A/R seconda anta Dx cerniere a scomparsa - Nodo ZTZ

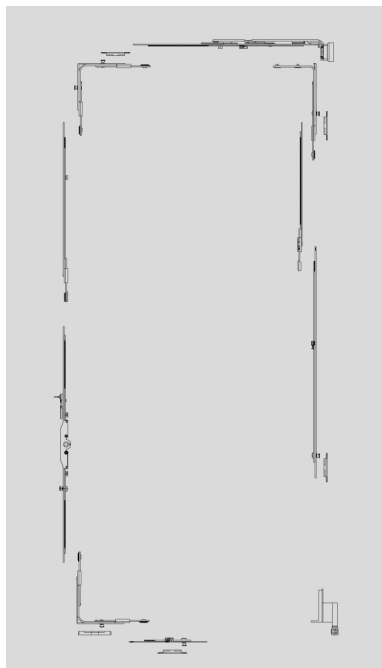
*Second leaf RH tilt-turn mechanism with concealed hinges - ZTZ profiles***RC2** (no su profili in ottone | *not on brass profiles*)**AG 1286**

Meccanismo A/R seconda anta Sx cerniere a scomparsa - Nodo ZTZ

*Second leaf LH tilt-turn mechanism with concealed hinges - ZTZ profiles***RC2** (no su profili in ottone | *not on brass profiles*)

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

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

**AG 1291**

Meccanismo A/R prima anta Dx cerniere a vista in acciaio inox

First leaf RH tilt-turn mechanism with visible stainless steel hinges

RC2 (no su profili in ottone | *not on brass profiles*)

AG 1292

Meccanismo A/R prima anta Sx cerniere a vista in acciaio inox

First leaf LH tilt-turn mechanism with visible stainless steel hinges

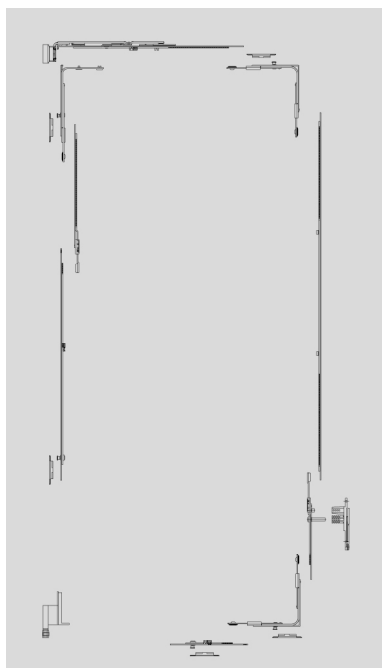
RC2 (no su profili in ottone | *not on brass profiles*)

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

Limiti dimensionali | Limits

Peso massimo anta | *Maximum leaf weight: 130 kg*

misure cava ferramenta - H>L | *hardware measure - H>W*

**AG 1295**

Meccanismo A/R seconda anta Dx cerniere a vista in acciaio inox - Nodo ZTZ

Second leaf RH tilt-turn mechanism with visible stainless steel hinges - ZTZ profiles

RC2 (no su profili in ottone | *not on brass profiles*)

AG 1296

Meccanismo A/R seconda anta Sx cerniere a vista in acciaio inox - Nodo ZTZ

Second leaf LH tilt-turn mechanism with visible stainless steel hinges - ZTZ profiles

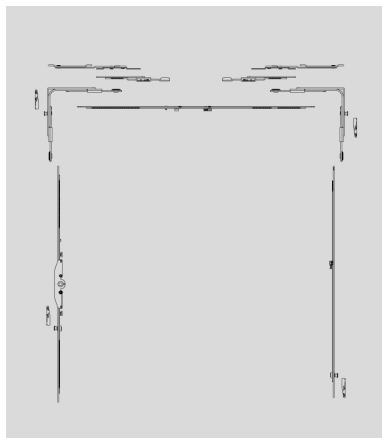
RC2 (no su profili in ottone | *not on brass profiles*)

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

Limiti dimensionali | Limits

Peso massimo anta | *Maximum leaf weight: 130 kg*

misure cava ferramenta - H>L | *hardware measure - H>W*

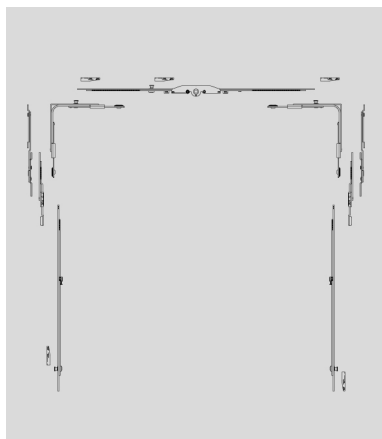
**AG 1264**

Meccanismo vasistas con cremonese su montante laterale

Bottom-hung window mechanism with lateral cremone bolt set
EASY

altezza - height

		560	661	861	1201
		660	860	1200	1600
	645-910	A1	B1	C1	D1
larghezza	911-1110	A2	B2	C2	D2
width	1111-1470	A3	B3	C3	D3
	1471-1860	A4	B4	C4	D4

Limiti dimensionali | LimitsPeso massimo anta | *Maximum leaf weight: 100 kg* 3 cerniere | *3 hinges*Peso massimo anta | *Maximum leaf weight: 70 kg* 2 cerniere | *2 hinges***AG 1274**

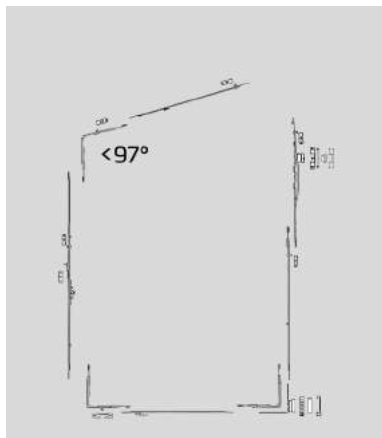
Meccanismo vasistas con cremonese su traverso superiore

Bottom-hung window mechanism with top cremone bolt set
EASY

altezza - height

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

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

**AG 1273**

Meccanismo A/R trapezoidale ad una o due ante con cerniere a vista
(specificare all'ordine misure cava ferramenta e mano di apertura)

*Tilt-turn mechanism with visible hinges for trapezoidal windows
(Specify hardware slot size and the opening)*

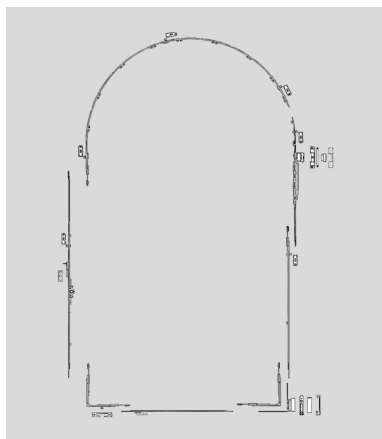
EASY

Limiti dimensionali | Limits

Peso massimo anta | *Maximum leaf weight: 80 kg*

Larghezza massima | *Maximum width: 1200 mm*

Altezza massima | *Maximum height: 2400 mm*

**AG 1278**

Meccanismo A/R curvo ad una o due ante con cerniere a vista
(specificare all'ordine misure cava ferramenta e mano di apertura)

*Tilt-turn mechanism with visible hinges for arched windows
(Specify hardware slot size and the opening)*

EASY

Limiti dimensionali | Limits

Peso massimo anta | *Maximum leaf weight: 80 kg*

Larghezza massima | *Maximum width: 1200 mm*

Altezza massima arco reale | *Maximum height arch: 1900 mm*

Altezza massima arco ribassato | *Maximum height segmental arch: 2400 mm*

**AG 1278 ..**

Kit copertine destre in plastica
per kit A/R AG 1273-8

*Plastic right-cover kit for
tilt&turn for kit AG 1273-8*

AG 1279 ..

Kit copertine sinistre in plastica
per kit A/R AG 1273-8

*Plastic left-cover kit for tilt&turn
for kit AG 1273-8*

AG127-/C argento | *matt silver*
AG127-MC marrone | *brown*
AG127-BC bronzato chiaro | *light bronze plated*
AG127-BO ottonato opaco | *matt brass plated*
AG127-OL ottonato lucido | *brass plated*
AG127-ST inox | *stainless steel*
AG127-NI nichelato | *nickel*
AG127-WB bianco RAL 9001 | *white RAL 9001*
AG127-WC bianco RAL 9010 | *white RAL 9010*

**AC 1001I**

Kit per giunzione angolo
Acciaio inox

*Corner joint kit
Stainless steel*

P.1101

**AC 1005I**

Kit per giunzione angolo
Acciaio inox

*Corner joint kit
Stainless steel*

P.1112

**AC 1002I**

Kit per giunzione angolo
Acciaio inox

*Corner joint kit
Stainless steel*

P.1102

**AC 1006I**

Kit per giunzione angolo
Acciaio inox

*Corner joint kit
Stainless steel*

P.1113 cassa | frame

**AC 1003I**

Kit per giunzione angolo
Acciaio inox

*Corner joint kit
Stainless steel*

P.1103

**AC 1007I**

Kit per giunzione angolo
Acciaio inox

*Corner joint kit
Stainless steel*

P.1113 anta | leaf

**AC 1004I**

Kit per giunzione angolo
Acciaio inox

*Stainless steel Corner joint kit
Stainless steel*

P.1111

**AC 1008I**

Kit per giunzione angolo
Acciaio inox

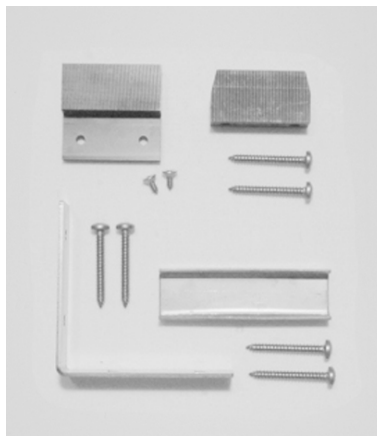
*Stainless steel
Corner joint kit*

P.1112-P.1113

**AC 1009I**

Kit per giunzione angolo
Acciaio inox

*Corner joint kit
Stainless steel
P.1105*

**AC 1023**

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

*Butt joint kit on corner section
for oversize profiles
Stainless steel*

**AC 1013I**

Kit per giunzione angolo
Acciaio inox

*Corner joint kit
Stainless steel*

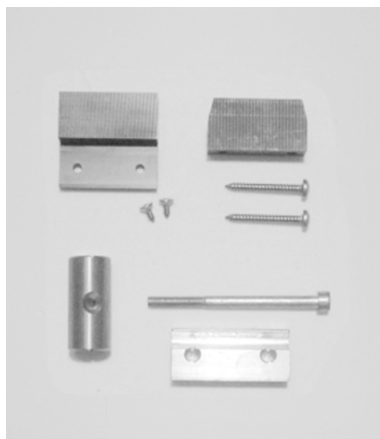
P.1110

**AC 1024ID**

Kit per giunzione angolo destro
Acciaio inox

*Right corner joint kit
Stainless steel*

P.1127-P.1112

**AC 1021**

Kit per giunzione 90°
Acciaio inox

*Butt joint kit
Stainless steel*

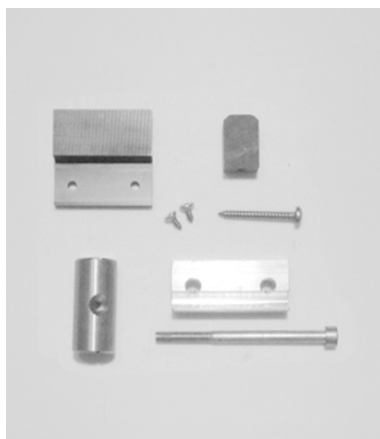
P.1105
P.1101
P.1102

**AC 1024IS**

Kit per giunzione angolo sinistro
Acciaio inox

*Left corner joint kit
Stainless steel*

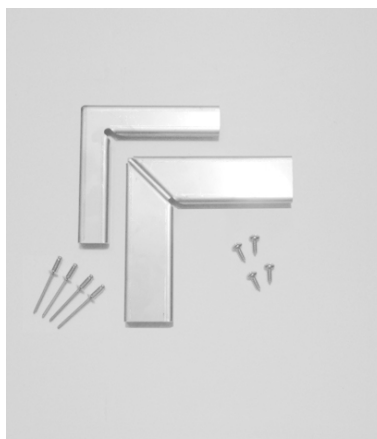
P.1127-P.1112

**AC 1022**

Kit per giunzione 90°
Acciaio inox

*Butt joint kit
Stainless steel*

P.1122

**AC 1201I**

Kit per giunzione angolo
Acciaio inox

*Corner joint kit
Stainless steel*

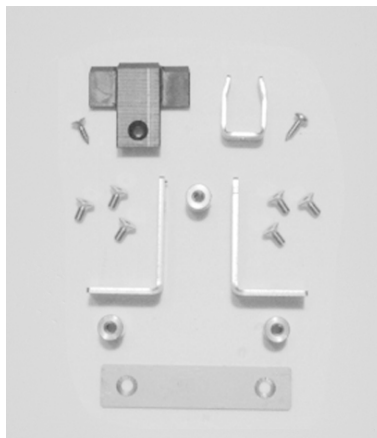
P.1301

**AC 1202I**

Kit per giunzione angolo
Acciaio inox

*Corner joint kit
Stainless steel*

P.1302

**AC 1211I**

Kit per giunzione 90°
Acciaio inox

*Butt joint kit
Stainless steel*

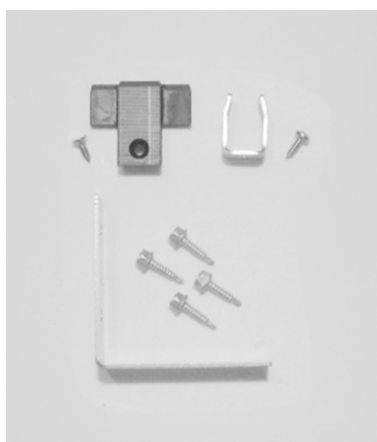
P.1302
1/2 - P.1301 | P.1305

**AC 1203I**

Kit per giunzione angolo
Acciaio inox

*Corner joint kit
Stainless steel*

P.1303

**AC 1211IA**

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

*Butt joint kit on corner section
for reduced profiles
Stainless steel*

**AC 1207I**

Kit per giunzione angolo
Acciaio inox

*Corner joint kit
Stainless steel*

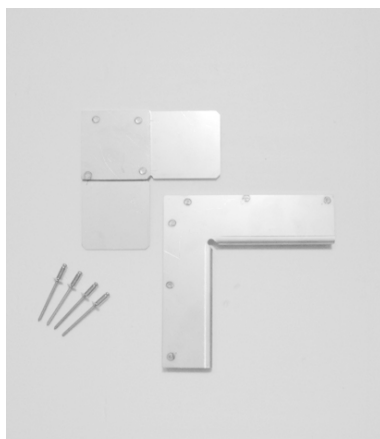
P.1333

**AC 1708I**

Kit per giunzione angolo
Acciaio inox

*Corner joint kit
Stainless steel*

P.1924-P.1333

**AC 1209I**

Kit per giunzione angolo
Acciaio inox

*Corner joint kit
Stainless steel*

P.1305

**AC 1730I**

Kit per giunzione angolo
Acciaio inox

*Corner joint kit
Stainless steel*

P.1320



AC 1731I

Kit per giunzione angolo
Acciaio inox

*Corner joint kit
Stainless steel*

P.1311



AC 1735I

Kit per giunzione angolo
Acciaio inox

*Corner joint kit
Stainless steel*

P.1315



AC 1732I

Kit per giunzione angolo
Acciaio inox

*Corner joint kit
Stainless steel*

P.1312



AC 1733I

Kit per giunzione angolo
Acciaio inox

*Corner joint kit
Stainless steel*

P.1313 anta | leaf



AC 1733IE

Kit per giunzione angolo
Acciaio inox

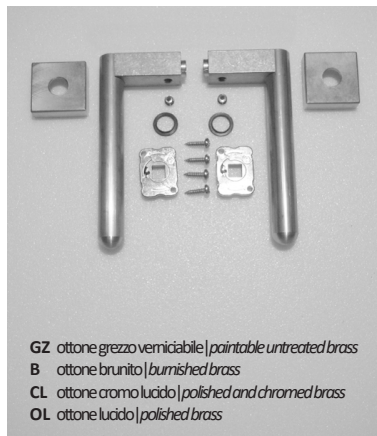
*Corner joint kit
Stainless steel*

P.1313 cassa | frame

**ACV 085**

Quadro per doppia maniglia

Spindle bar for double handle

**ACV 944**

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

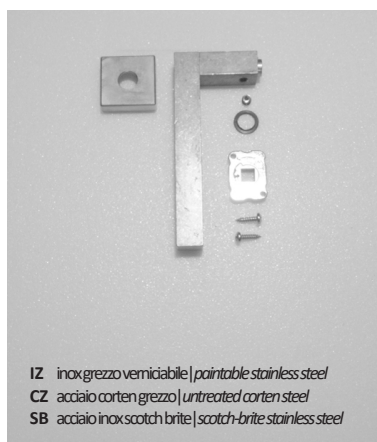
*Double door handlesets
"VITRUVIO" medium
square escutcheon
L | round | sphere*

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

**ACV 085/R**

Quadro per maniglia singola

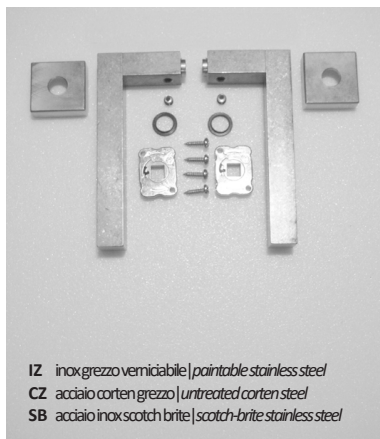
Spindle bar for single handle

**ACV 947**

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

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

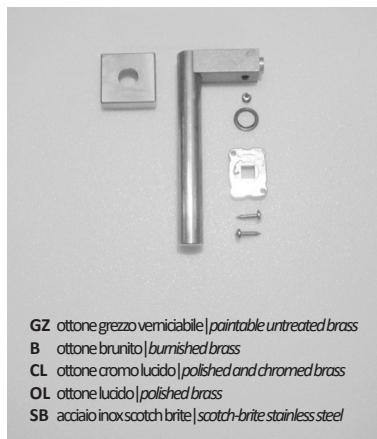
IZ inox grezzo verniciabile | paintable stainless steel
CZ acciaio corten grezzo | untreated corten steel
SB acciaio inox scotch brite | scotch-brite stainless steel

**ACV 942**

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

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

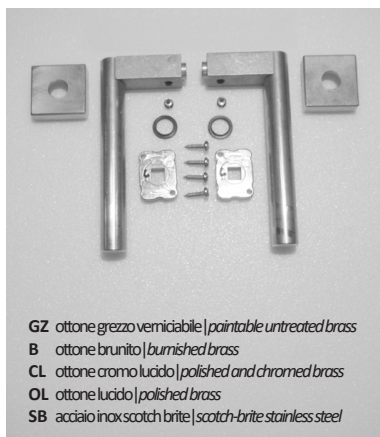
IZ inox grezzo verniciabile | paintable stainless steel
CZ acciaio corten grezzo | untreated corten steel
SB acciaio inox scotch brite | scotch-brite stainless steel

**ACV 948**

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

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

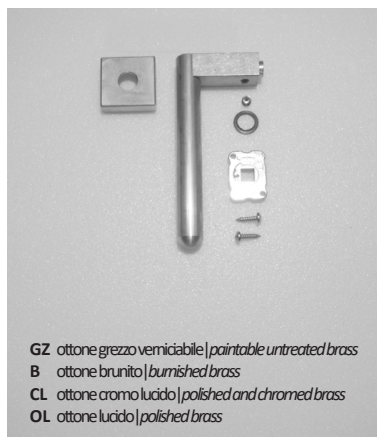
GZ ottone grezzo verniciabile | paintable untreated brass
B ottone brunito | burnished brass
CL ottone cromo lucido | polished and chromed brass
OL ottone lucido | polished brass
SB acciaio inox scotch brite | scotch-brite stainless steel

**ACV 943**

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

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

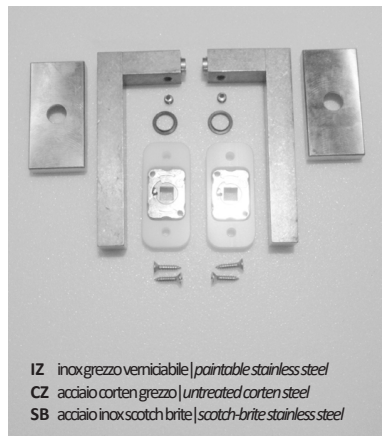
GZ ottone grezzo verniciabile | paintable untreated brass
B ottone brunito | burnished brass
CL ottone cromo lucido | polished and chromed brass
OL ottone lucido | polished brass
SB acciaio inox scotch brite | scotch-brite stainless steel

**ACV 949**

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

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

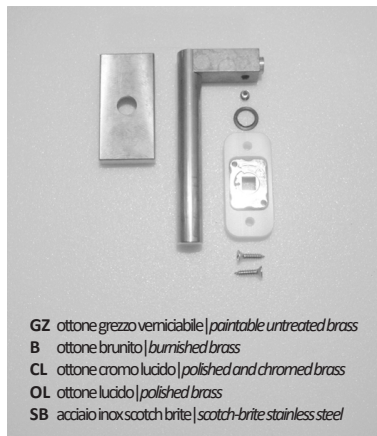
GZ ottone grezzo verniciabile | paintable untreated brass
B ottone brunito | burnished brass
CL ottone cromo lucido | polished and chromed brass
OL ottone lucido | polished brass

**ACV 952**

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

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

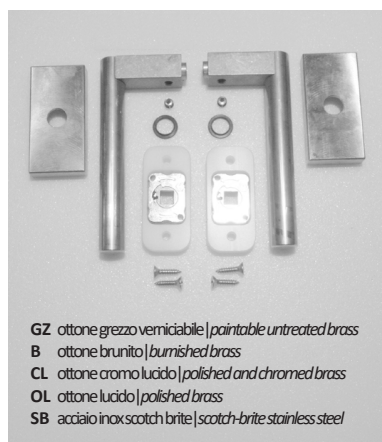
IZ inox grezzo verniciabile | paintable stainless steel
CZ acciaio corten grezzo | untreated corten steel
SB acciaio inox scotch brite | scotch-brite stainless steel

**ACV 958**

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

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

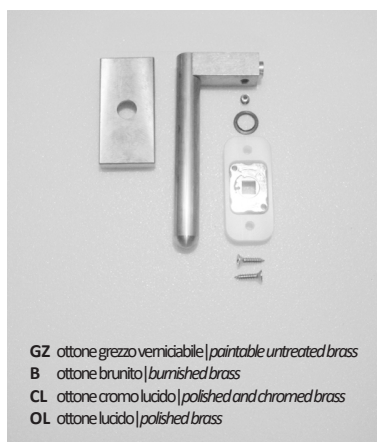
GZ ottone grezzo verniciabile | paintable untreated brass
B ottone brunito | burnished brass
CL ottone cromo lucido | polished and chromed brass
OL ottone lucido | polished brass
SB acciaio inox scotch brite | scotch-brite stainless steel

**ACV 953**

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

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

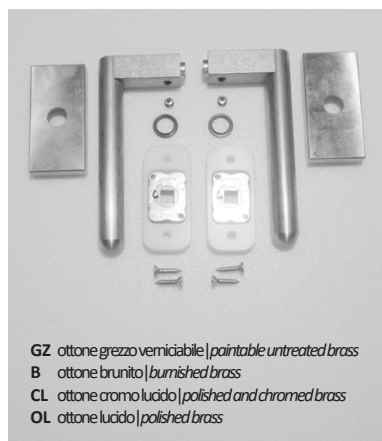
GZ ottone grezzo verniciabile | paintable untreated brass
B ottone brunito | burnished brass
CL ottone cromo lucido | polished and chromed brass
OL ottone lucido | polished brass
SB acciaio inox scotch brite | scotch-brite stainless steel

**ACV 959**

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

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

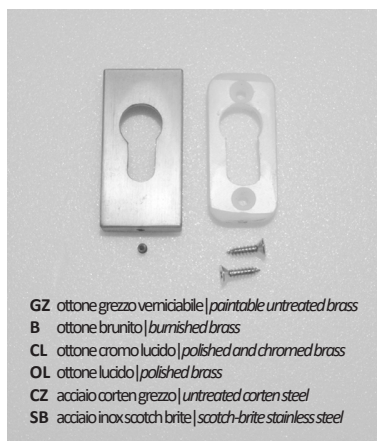
GZ ottone grezzo verniciabile | paintable untreated brass
B ottone brunito | burnished brass
CL ottone cromo lucido | polished and chromed brass
OL ottone lucido | polished brass

**ACV 954**

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

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

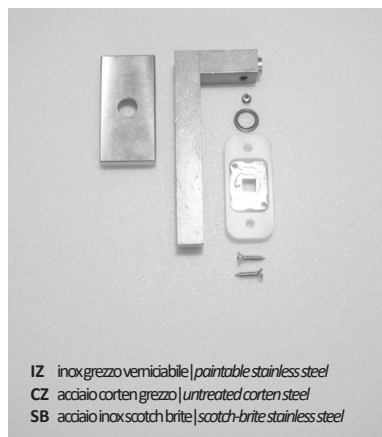
GZ ottone grezzo verniciabile | paintable untreated brass
B ottone brunito | burnished brass
CL ottone cromo lucido | polished and chromed brass
OL ottone lucido | polished brass

**ACV 964**

Bocchetta copri cilindro a profilo europeo

Euro profile cylinder escutcheon plate

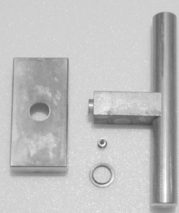
GZ ottone grezzo verniciabile | paintable untreated brass
B ottone brunito | burnished brass
CL ottone cromo lucido | polished and chromed brass
OL ottone lucido | polished brass
CZ acciaio corten grezzo | untreated corten steel
SB acciaio inox scotch brite | scotch-brite stainless steel

**ACV 957**

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

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

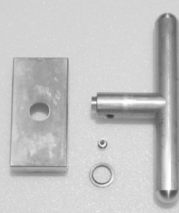
IZ inox grezzo verniciabile | paintable stainless steel
CZ acciaio corten grezzo | untreated corten steel
SB acciaio inox scotch brite | scotch-brite stainless steel

**ACV 971**

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

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

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

**ACV 976**

Maniglia per DK finestra
"VITRUVIO" medium
KIDS

*DK window handle
"VITRUVIO" medium
KIDS*

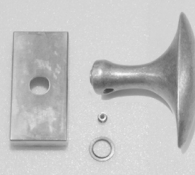
GZ ottone grezzo verniciabile | paintable untreated brass
B ottone brunito | burnished brass
CL ottone cromo lucido | polished and chromed brass
OL ottone lucido | polished brass

**ACV 972**

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

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

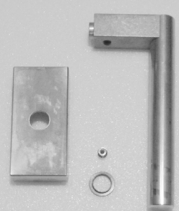
IZ inox grezzo verniciabile | paintable stainless steel
CZ acciaio corten grezzo | untreated corten steel
SB acciaio inox scotch brite | scotch-brite stainless steel

**ACV 977**

Maniglia per DK finestra
"VITRUVIO" medium
OVALE

*DK window handle
"VITRUVIO" medium
OVALE*

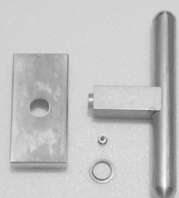
GZ ottone grezzo verniciabile | paintable untreated brass
B ottone brunito | burnished brass
CL ottone cromo lucido | polished and chromed brass
OL ottone lucido | polished brass

**ACV 973**

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

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

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

**ACV 979**

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

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

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

**ACV 974**

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

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

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

**GE 1001TT**

Guarnizione di battuta per porte e finestre

Gasket for doors and windows

**GE 1012**

Guarnizione interna fermavetro spessore 6-8 mm

Internal gasket for 6-8 mm thick glazing bead

**GE 1006**

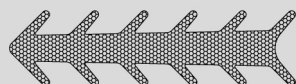
Guarnizione esterna vetro

External gasket

**GE 1013**

Guarnizione interna fermavetro spessore 12-16 mm

Internal gasket for 12-16 mm thick glazing bead

**GE 1007TT**

Guarnizione sotto vetro

Under glass gasket

**GE 1200TT**

Guarnizione di battuta interna per finestre

Internal gasket for windows

**GE 1011**

Guarnizione interna fermavetro spessore 3-4 mm

Internal gasket for 3-4 mm thick glazing bead

**GE 1206**

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

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

**GE 1233TT**

Guarnizione di battuta per
finestre

Gasket for windows

**GE 2029**

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

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

**GE 1701**

Guarnizione centrale di battuta
giunto aperto finestre
telaio - nodo TZT

*Central open-joint gasket for
windows
frame - TZT profiles*

**GP 0095**

Guarnizione interna fermavetro
spessore 3 mm

*Internal gasket for glazing bead,
3mm thick*

**GE 1704**

Guarnizione centrale di battuta
giunto aperto finestre
anta P.1924 - nodo TZ

*Central open-joint gasket for
windows
leaf P.1924 - TZ profiles*

**GU 0087**

Spazzolino per porte su GU0120
H=8 mm

*Brush for doors on GU0120
H=8 mm*

**GE 2028**

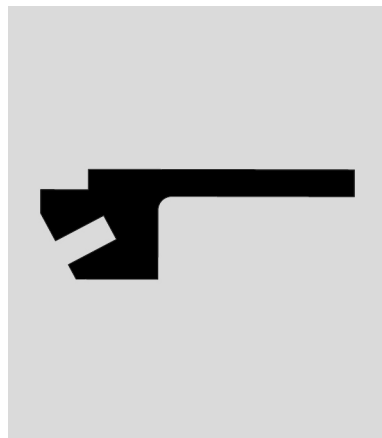
Guarnizione interna per
fermavetro P.2028

Gasket for glazing bead P.2028

**GU 0120**

Estruso in PVC porta spazzolino
per porte

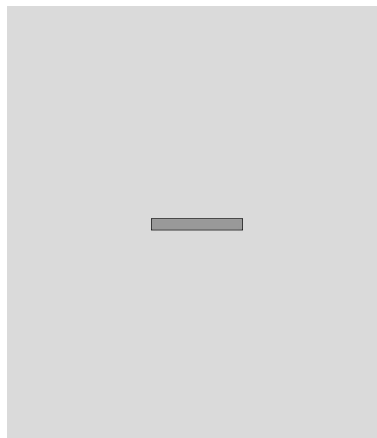
*Extruded PVC brush holder for
doors*



GU 1134

Estruso rigido in PVC per soglia porta P.1130

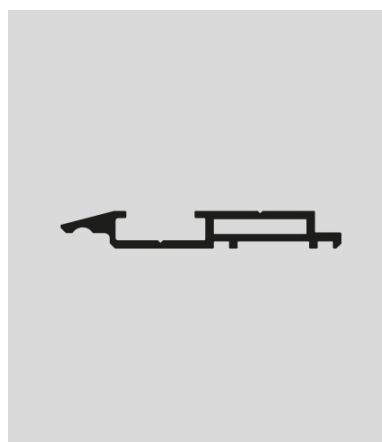
Rigid extruded PVC section for P.1130 threshold



GU 2031

Biadesivo per dividivetro 12x1.5 mm

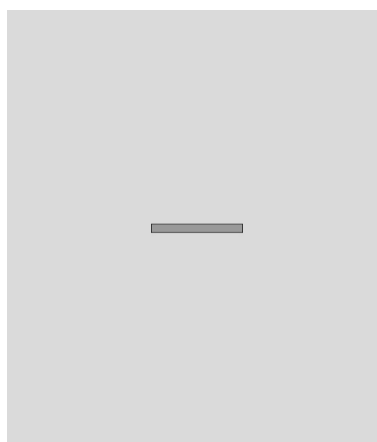
Bi-adhesive tape for glass divider 12x1.5 mm



GU 1302

Estruso rigido in PVC per GE1701-GE1704

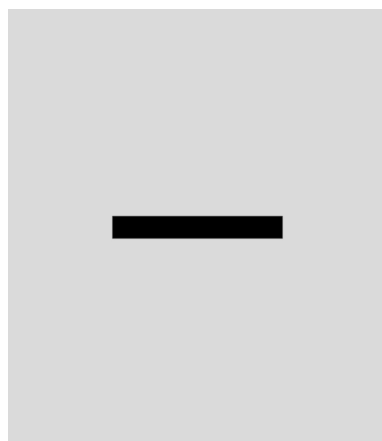
Rigid extruded PVC section for GE1701-GE1704



GU 2032

Biadesivo per dividivetro 12x1 mm

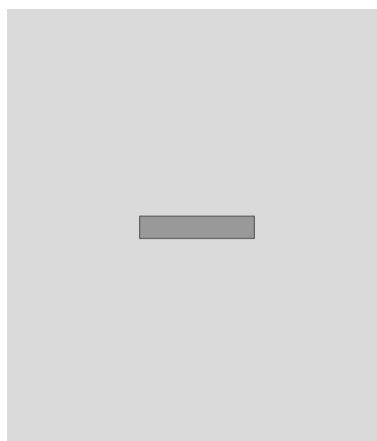
Bi-adhesive tape for glass divider 12x1 mm



GU 1311

Profilo in PVC per scarico acqua aperture a sporgere

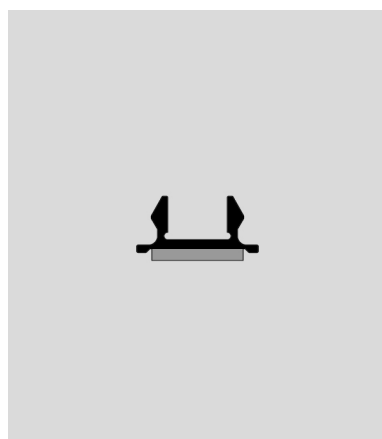
PVC profile for water drain in awning opening



GU 2035

Piattina adesiva morbida per fondo giunto esterno vetro 15x3 mm

Soft adhesive shim for external window joint 15x3 mm



GU 2030E

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

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



AT 1001

Maschera per esecuzione fori di fissaggio squadretta su profili maggiorati

Jig for drilling holes for corner plate on oversize profiles

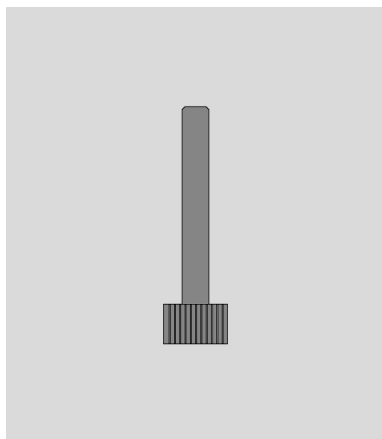


AT 1242

Maschera per esecuzione fori fissaggio cerniere A/R in acciaio inox

Jig for drilling holes for tilt-turn hinges in stainless steel

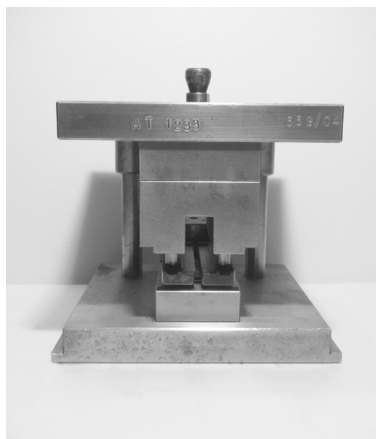
AGE 291-2-5-6



AT 1058

Fresa per lavorazione spacco cerniera AC1068

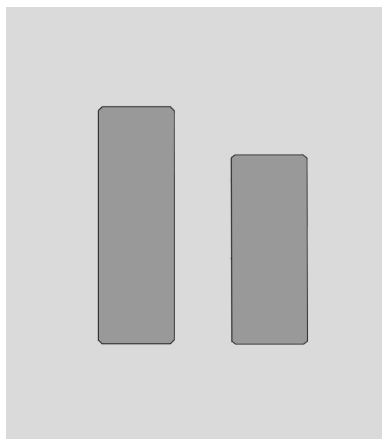
Milling cutter for hinge slot AC1068



AT 1333

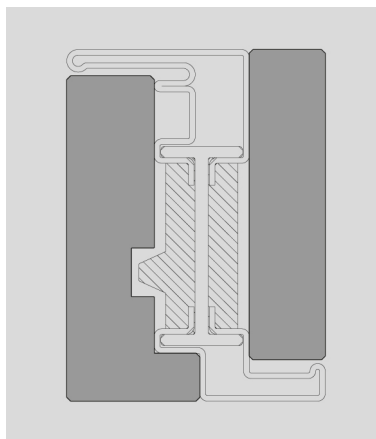
Stampo per esecuzione fori di fissaggio squadretta su profilo P.1333 | P.1924

Die for drilling holes for corner plate on profile P.1333 | P.1924



AT 1100

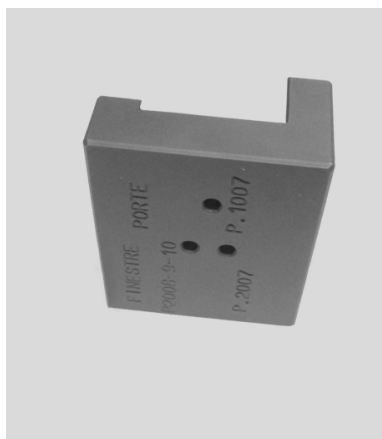
Ganasce di taglio per profili EBE 85
Cutting jaws for profiles EBE 85



AT 1336

Ganasce di taglio per profilo P.1333

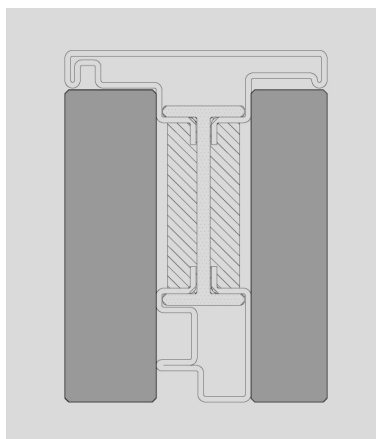
Cutting jaws for P.1333



AT 1234

Maschera per esecuzione fori fissaggio fermavetri con boccole

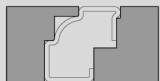
Jig for drilling holes for glazing bead with bushings



AT 1924

Ganasce di taglio per profilo P.1924 - P.1902

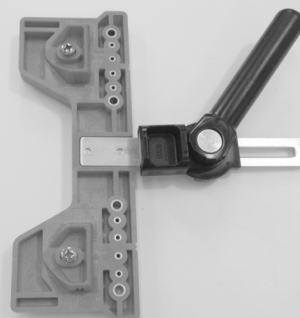
Cutting jaws for P.1924 - P.1902



AT 2029

Ganasce di taglio per fermavetro
P.2028

*Cutting jaws for glazing bead
P.2028*

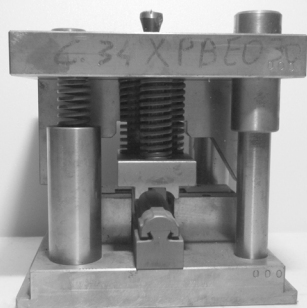


ATG 271

Dima per esecuzione fori
montaggio A/R cerniere a
sormonto

*Template for drilling holes for
tilt-turn kit with overlap hinges*

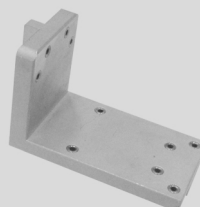
AGE 271-2-5-6



AT 2030

Stampo per intestatura
P.2030

*Butt die for
P.2030*



ATG 281

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

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

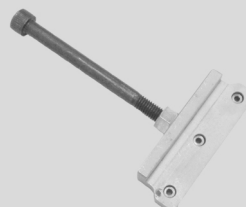
AGE 281-2-5-6



AT 2038

Ganasce di taglio per P.2038

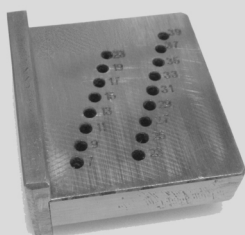
Cutting jaws for P.2038



ATG 303

Maschera per esecuzione fori
montaggio riscontri nottolini
RC2

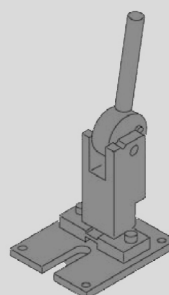
*Jig for drilling holes for cam
strikes
RC2*



AT 2828

Maschera per esecuzione fori
fissaggio fermavetri con clips

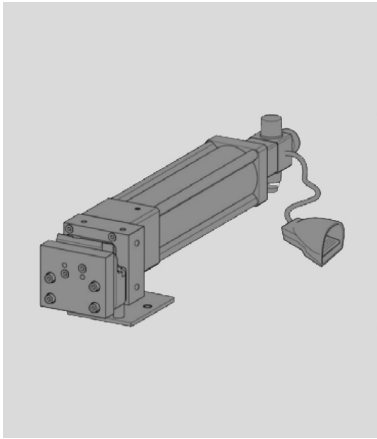
*Jig for drilling holes for glazing
bead with clips*



ATG 311

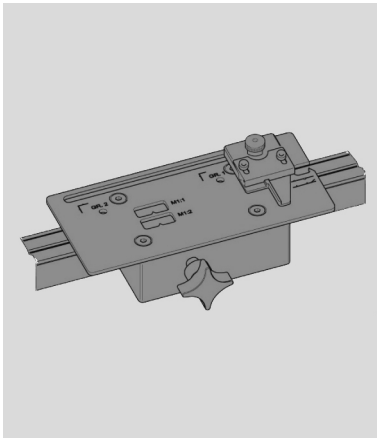
Trancia manuale

Manual punching machine

**ATG 312**

Trancia oleopneumatica

Oil-pneumatic punching machine

**ATG 313**

Asta millimetrata per trancia oleopneumatica

Rod divided into millimetres for oil-pneumatic punching machine

**SA 005/01**

Liquido neritore per brunitura
1 Kg

*Burnishing liquid
1 Kg*

SA 005/10

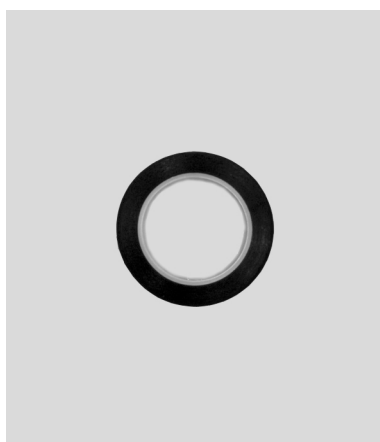
Liquido neritore per brunitura
10 Kg

*Burnishing liquid
10 Kg*

**SA 2002**

Spray solvente per rimozione
collanti su superfici in acciaio
inox

*Solvent adhesive remover spray
for stainless steel surfaces*

**SA 1042**

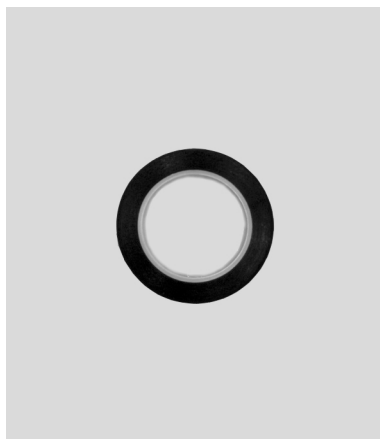
Nastro adesivo protettivo per
verniciatura
42 mm

*Adhesive tape for painting
42 mm*

**SA 2031**

Liquido deumidificante vetri

Glass dehumidifying liquid

**SA 1052**

Nastro adesivo protettivo per
verniciatura
52 mm

*Adhesive tape for painting
52 mm*

**SA 2032**

Primer di adesione per profili
verniciati

*Adhesion primer for painted
profiles*

**SA 2001**

Spray detergente antimpronta
per superfici in acciaio inox

*Anti-fingerprint detergent spray
for stainless steel surfaces*

**SA 2033**

Liquido di adesione per
materiale plastico

Adhesion liquid for plastic



SA 3001

Acido per ossidazione corten

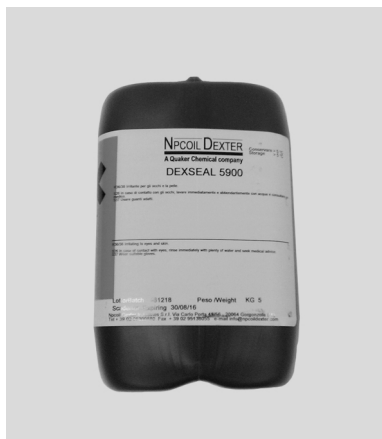
Oxidising acid for corten



SL 0021

Silicone nero per guarnizioni

Black silicone for gaskets



SA 3002

Passivante per ossidazione corten
25 Kg

*Passivating agent for corten
25 Kg*

SA 3002/5

Passivante per ossidazione corten
5 Kg

*Passivating agent for corten
5 Kg*



SL 0100

Silicone strutturale grigio
per vetri
RC2

*Gray structural silicone
for glass
RC2*



SA 3003

Cera d'api per finitura corten

Beeswax for Corten finishing

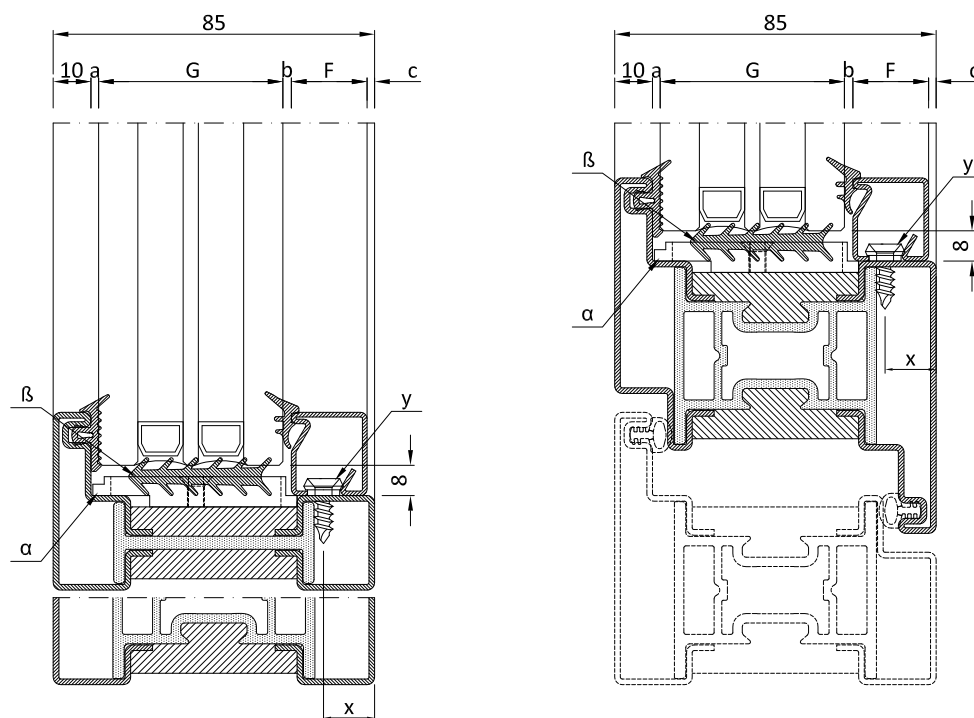


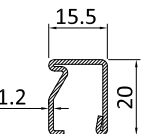
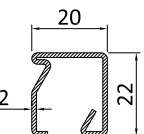
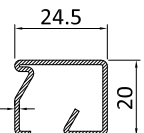
SL 0019

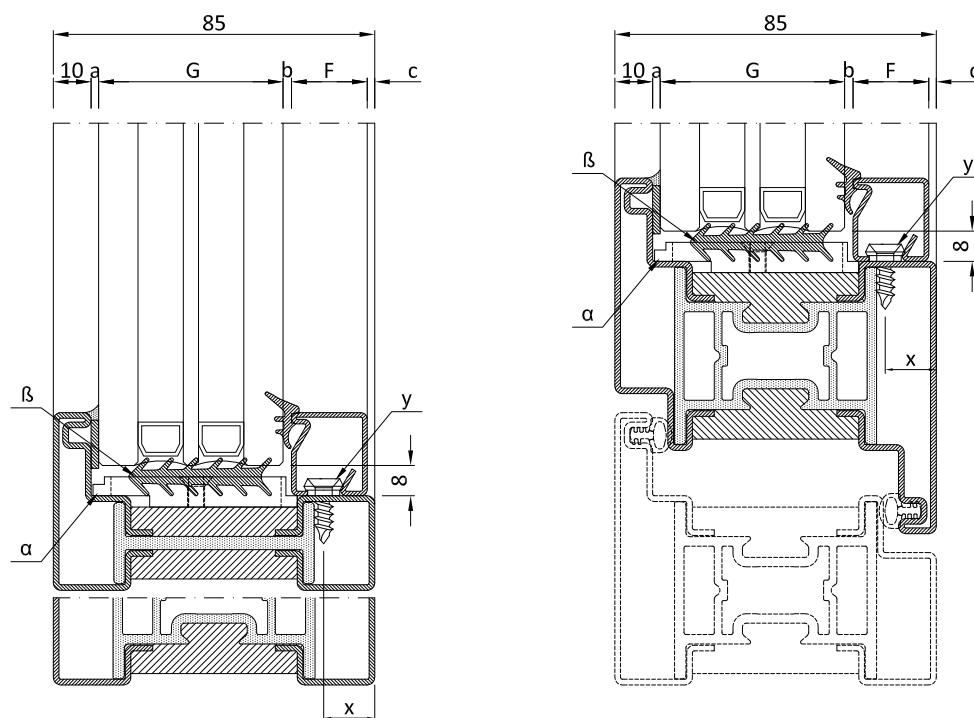
Sigillante a freddo per giunzione
angoli e trasversi

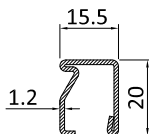
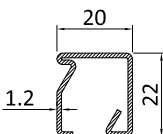
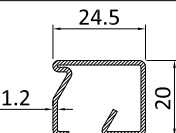
*Cold sealant for corner and
transom joints*

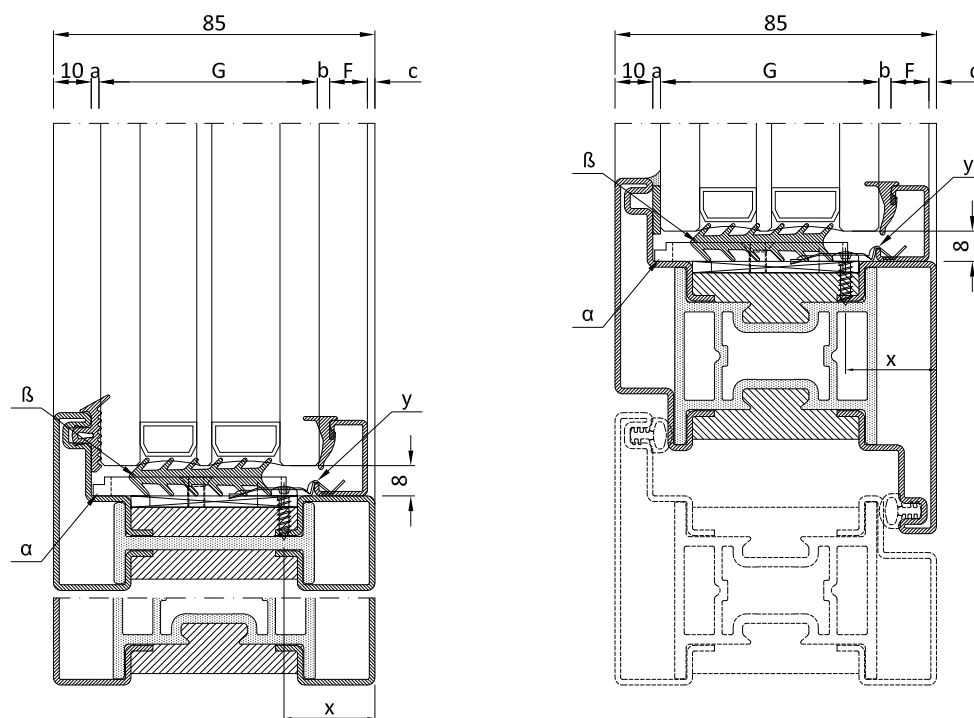
1 kg



F	G	Guarnizioni - gaskets										
fermavetro glazing bead	range vetro glass range	GE1006 3 mm 	GP0095 2 / 3 mm 	GE1011 3 / 4 mm 	GE1012 6 / 8 mm 	GE1013 12 / 16 mm 	asse fissaggio viti fermavetro securing axis for screws for the glazing beads	rientro fermavetro glazing beads gap	boccole e viti fissaggio fermavetro Bushling and screws for glazing bead fixing	spessore per vetro glass shim	guarnizione sotto vetro under glass gasket	
Code		a	b	b	b	b	x	c	y	α	β	
 P.2007	38 - 54	3	51 - 52	50 - 51	46 - 48	38 - 42	9.5	2	CV5001(i) CV5012(i)	AC1020XL	GE1007TT	
			53 - 54	52 - 53	48 - 50	40 - 44	7.5	0				
			 P.1007	38 - 50		47 - 48	46 - 47	42 - 44	38 min	13.5	2	CV5001(i) CV5012(i)
49 - 50	48 - 49					44 - 46	38 min - 40	11.5	0			
 P.2008	39 - 45					-	-	-	-	-	-	CV5001(i) CV5012(i)
			44 - 45	43 - 44	39 - 41	-	16	0				



F	G	Guarnizioni - <i>gaskets</i>										
fermavetro <i>glazing bead</i>	range vetro <i>glass range</i>	GU2035  2 mm + sigillatura + <i>sealing</i>	GP0095  2 / 3 mm	GE1011  3 / 4 mm	GE1012  6 / 8 mm	GE1013  12 / 16 mm	asse fissaggio viti fermavetro <i>securing axis for screws for the glazing beads</i>	rientro fermavetro <i>glazing beads gap</i>	boccole e viti fissaggio fermavetro <i>Bushings and screws for glazing bead fixing</i>	spessore per vetro <i>glass shim</i>	guarnizione sotto vetro <i>under glass gasket</i>	
<i>Code</i>		a	b	b	b	b	x	c	y	α	β	
 P.2007	39 - 55	2	52 - 53	51 - 52	47 - 49	39 - 43	9.5	2	CV5001(i) CV5012(i)	AC1020XL	GE1007TT	
			54 - 55	53 - 54	49 - 51	41 - 45	7.5	0				
 P.1007	38 - 51		48 - 49	47 - 48	43 - 45	-	13.5	2	CV5001(i) CV5012(i)	AC1020XL	GE1007TT	
			50 - 51	49 - 50	45 - 47	38 min - 41	11.5	0				
 P.2008	40 - 46		-	-	-	-	-	-	-	CV5001(i) CV5012(i)	AC1020XS	GE1007TT
			45 - 46	44 - 45	40 - 42	-	16	0				

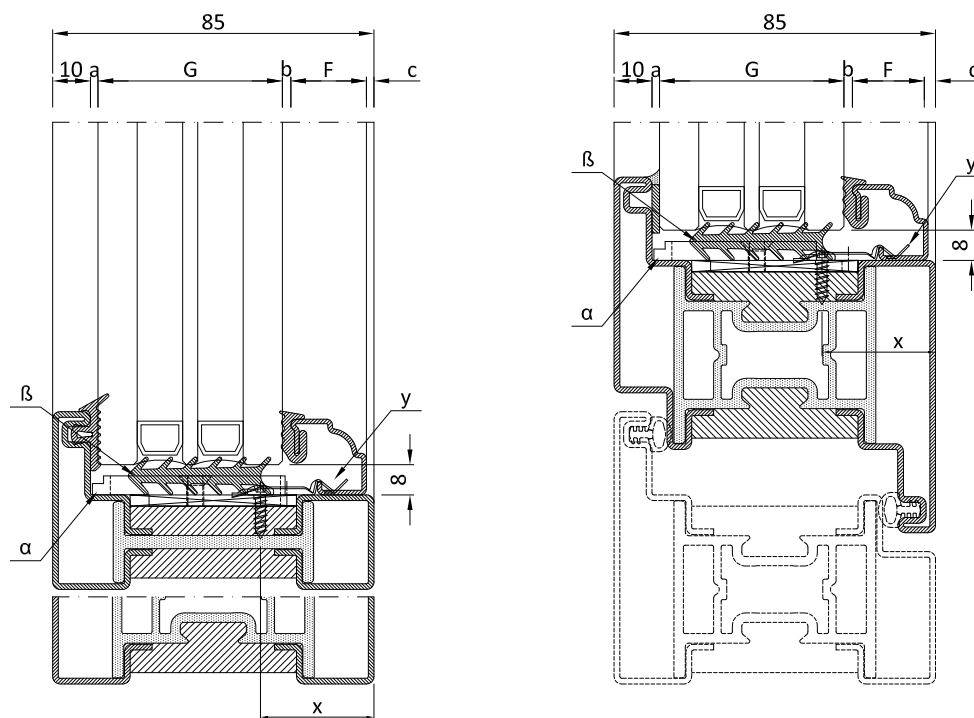


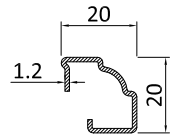
F		Guarnizioni - gaskets		G						
fermavetro glazing bead	range vetro glass range	GE1006 3 mm 	GP0095 3 mm 	spessore vetro glass thickness	asse fissaggio viti fermavetro securing axis for screws for the glazing beads	rientro fermavetro glazing beads gap	clips fissaggio fermavetro securing clips for glazing beads	spessore di compensazione * Shim *	spessore per vetro glass shim	guarnizione sotto vetro under glass gasket
Code		a	b	mm.	x	c	y	z	α	β
 P.2015	57	3	3	57	31	2	AC2608	3 mm.	AC1020XL	GE1007TT
	59			59	29	0				

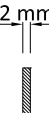
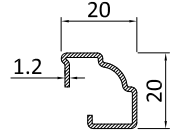
F		Guarnizioni - gaskets		G						
fermavetro glazing bead	range vetro glass range	GU2035 2 mm + sigillatura + sealing	GP0095 3 mm 	spessore vetro glass thickness	asse fissaggio viti fermavetro securing axis for screws for the glazing beads	rientro fermavetro glazing beads gap	clips fissaggio fermavetro securing clips for glazing beads	spessore di compensazione * Shim *	spessore per vetro glass shim	guarnizione sotto vetro under glass gasket
Code		a	b	mm.	x	c	y	z	α	β
 P.2015	58	2	3	58	31	2	AC2608	3 mm.	AC1020XL	GE1007TT
	60			60	29	0				

*non fornito

*not included



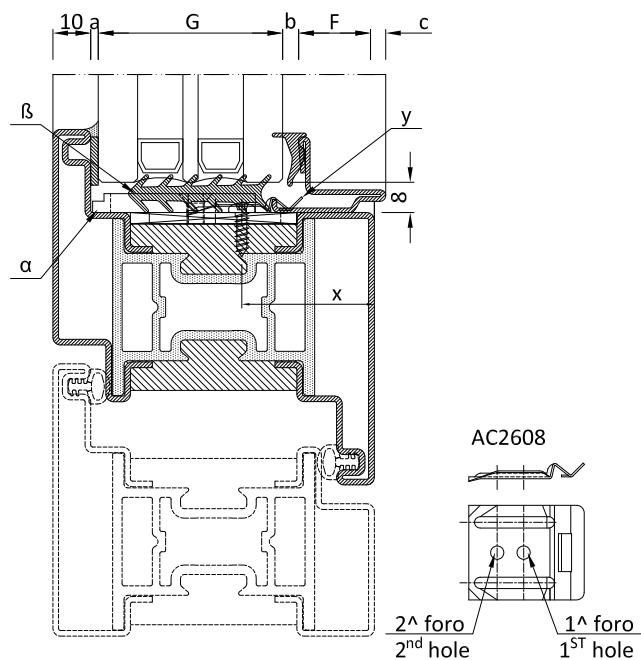
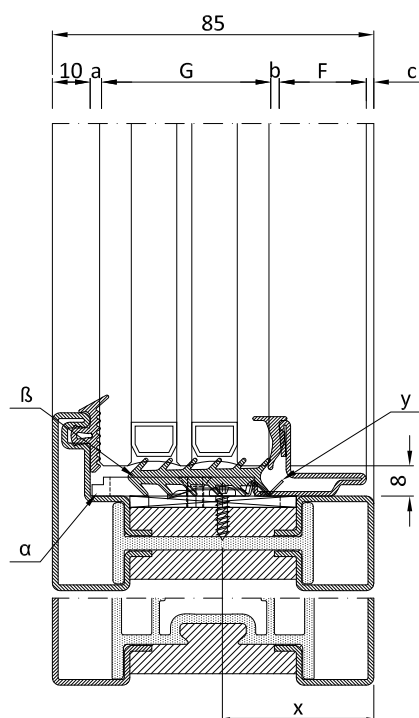
F		Guarnizioni - gaskets		G						
fermavetro glazing bead	range vetro glass range	GE1006 3 mm 	GE2028 2.5 mm 	spessore vetro glass thickness	asse fissaggio viti fermavetro securing axis for screws for the glazing beads	rientro fermavetro glazing beads gap	clips fissaggio fermavetro securing clips for glazing beads	spessore di compensazione * Shim *	spessore per vetro glass shim	guarnizione sotto vetro under glass gasket
Code		a	b	mm.	x	c	y	z	α	β
 P.2028	44 - 50	3	2.5	44	34	6	AC2608	3 mm.	AC1020XL	GE1007TT
				46	32	4				
				48	30	2				
				50	28	0				

F		Guarnizioni - gaskets		G						
fermavetro glazing bead	range vetro glass range	GU2035 2 mm  + sigillatura + sealing	GE2028 2.5 mm 	spessore vetro glass thickness	asse fissaggio viti fermavetro securing axis for screws for the glazing beads	rientro fermavetro glazing beads gap	clips fissaggio fermavetro securing clips for glazing beads	spessore di compensazione * Shim *	spessore per vetro glass shim	guarnizione sotto vetro under glass gasket
Code		a	b	mm.	x	c	y	z	α	β
 P.2028	45 - 51	2	2.5	45	34	6	AC2608	3 mm.	AC1020XL	GE1007TT
				47	32	4				
				49	30	2				
				51	28	0				

*non fornito

*not included

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



F		Guarnizioni - gaskets		G						
fermavetro glazing bead	range vetro glass range	GE1006 3 mm 	GP0095 3 mm 	spessore vetro glass thickness	asse fissaggio viti fermavetro securing axis for screws for the glazing beads	rientro fermavetro glazing beads gap	clips fissaggio fermavetro securing clips for glazing beads	spessore di compensazione * Shim *	spessore per vetro glass shim	guarnizione sotto vetro under glass gasket
Code		a	b	mm.	x	c	y	z	α	β
 P.2038	44 - 50	3	3	44	40**	2	AC2608	3 mm.	AC1020XS	GE1007TT
				46	38**	0				
				48	36**	-2				
				50	34**	-4				

F		Guarnizioni - gaskets		G						
fermavetro glazing bead	range vetro glass range	GU2035 2 mm + sigillatura + sealing	GP0095 3 mm 	spessore vetro glass thickness	asse fissaggio viti fermavetro securing axis for screws for the glazing beads	rientro fermavetro glazing beads gap	clips fissaggio fermavetro securing clips for glazing beads	spessore di compensazione * Shim *	spessore per vetro glass shim	guarnizione sotto vetro under glass gasket
Code		a	b	mm.	x	c	y	z	α	β
 P.2038	45 - 51	2	3	45	40**	2	AC2608	3 mm.	AC1020XS	GE1007TT
				47	38**	0				
				49	36**	-2				
				51	34**	-4				

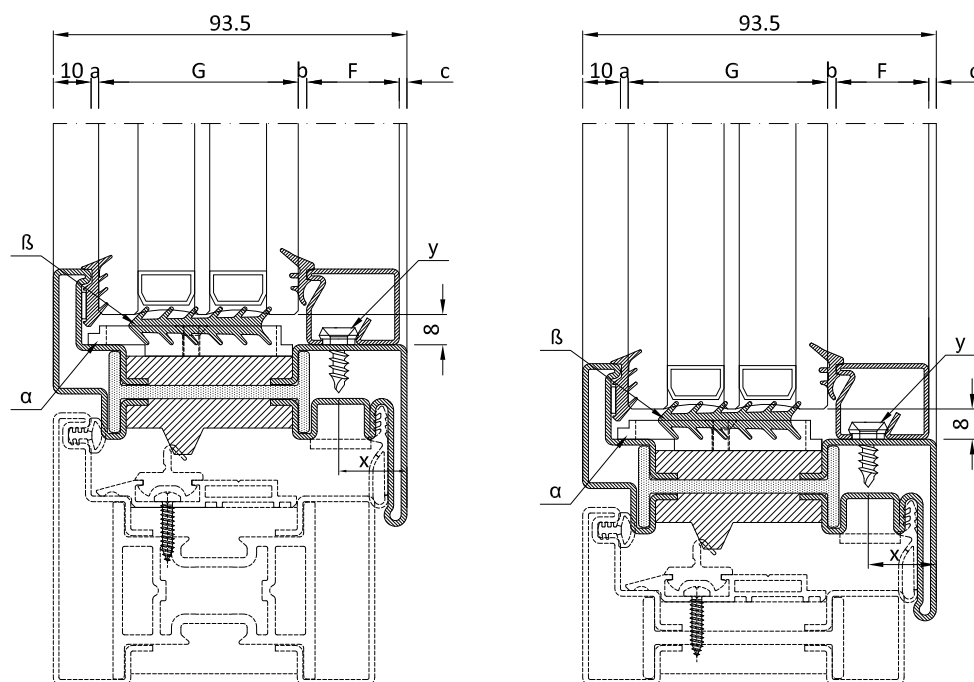
*non fornito

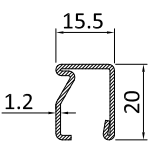
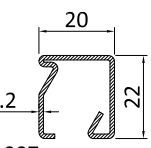
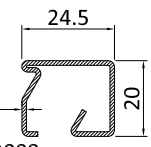
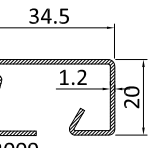
*not included

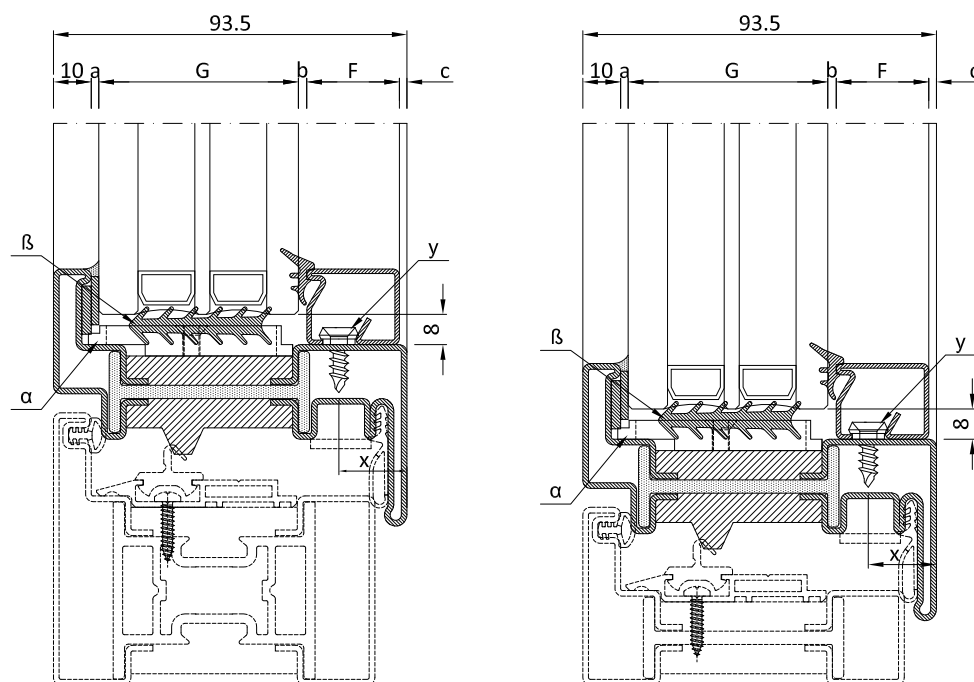
Taglio a 45° dei fermavetri effettuabile utilizzando la ganascia AT2038
45° cutting of the glazing beads done using the cutting jaw AT2038

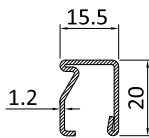
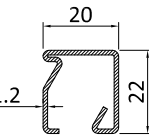
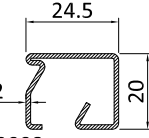
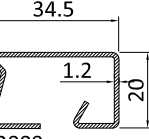
** fissare tramite il primo foro della clip

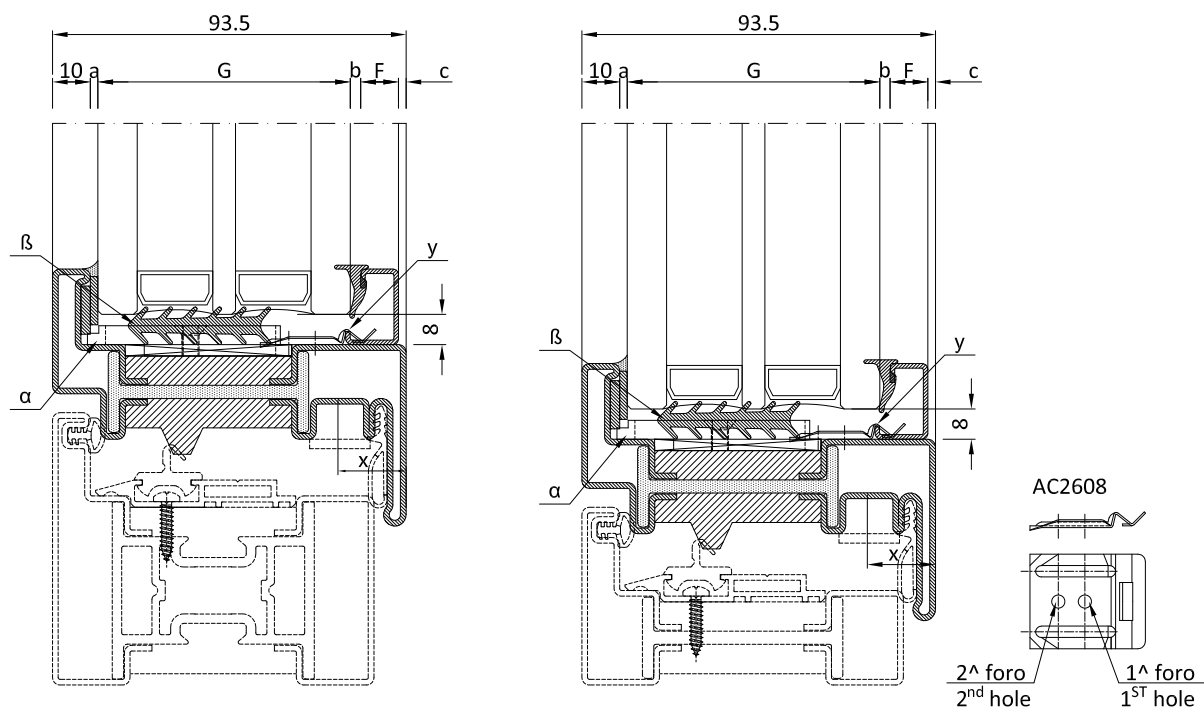
** screw in the upper hole of the clip



F	G	Guarnizioni - gaskets										
fermavetro glazing bead	range vetro glass range	GE1206 3 mm 	GP0095 2 / 3 mm 	GE1011 3 / 4 mm 	GE1012 6 / 8 mm 	GE1013 12 / 16 mm 	asse fissaggio viti fermavetro securing axis for screws for the glazing beads	rientro fermavetro glazing beads gap	boccole e viti fissaggio fermavetro Bushings and screws for glazing bead fixing	spessore per vetro glass shim	guarnizione sotto vetro under glass gasket	
Code		a	b	b	b	b	x	c	y	α	β	
 P.2007	47 - 63	3	60 - 61	59 - 60	55 - 57	47 - 51	9.5	2	CV5001(i) CV5012(ii)	AC1020XL	GE1007TT	
			62 - 63	61 - 62	57 - 59	29 - 53	7.5	0				
			 P.1007	43 - 59		56 - 57	55 - 56	51 - 53	43 - 47	13.5	2	CV5001(i) CV5012(ii)
58 - 59	57 - 58					53 - 35	45 - 49	11.5	0			
 P.2008	38 - 54					51 - 52	50 - 51	46 - 48	38 - 42	18	2	CV5001(i) CV5012(ii)
			53 - 54	52 - 53	48 - 50	40 - 44	16	0				
			 P.2009	38 - 44		41 - 42	40 - 41	38 min. - 40	-	18	2	CV5001(i) CV5012(ii)
43 - 44	42 - 43					38 - 40	-	16	0			



F	G	Guarnizioni - <i>gaskets</i>												
fermavetro glazing bead	range vetro glass range	GU2035 2 mm  + sigillatura + sealing	GP0095 2 / 3 mm 	GE1011 3 / 4 mm 	GE1012 6 / 8 mm 	GE1013 12 / 16 mm 	asse fissaggio viti fermavetro securing axis for screws for the glazing beads	rientro fermavetro glazing beads gap	boccole e viti fissaggio fermavetro Bushings and screws for glazing bead fixing	spessore per vetro glass shim	guarnizione sotto vetro under glass gasket			
Code		a	b	b	b	b	x	c	y	α	β			
 P.2007	48 - 64	2	61	60	56	48	9.5	2	CV5001(i) CV5012(i)	AC1020XL	GE1007TT			
			-	-	-	-								
			62	61	58	52	7.5	0						
			63	62	58	50								
 P.1007	44 - 60		-	-	-	-	13.5	2	CV5001(i) CV5012(i)	AC1020XL	GE1007TT			
			64	63	60	54								
			57	56	52	44	11.5	0						
			58	57	54	48								
 P.2008	39 - 55		59	58	54	46	18	2	CV5001(i) CV5012(i)	AC1020XL	GE1007TT			
			-	-	-	-								
			60	59	56	50	16	0						
			52	51	47	39								
 P.2009	38 - 45		-	-	-	-	18	2	CV5001(i) CV5012(i)	AC1020XS	GE1007TT			
			53	52	49	43								
			54	53	49	41	16	0						
			-	-	-	-								
		55	54	51	45	18	2	CV5001(i) CV5012(i)	AC1020XS	GE1007TT				
		42	41	38 min.	-									
		-	-	-	-	16	0							
		43	42	-	-									
		44	43	39	-	16	0	CV5001(i) CV5012(i)	AC1020XS	GE1007TT				
		-	-	-	-									
		45	44	41	-									

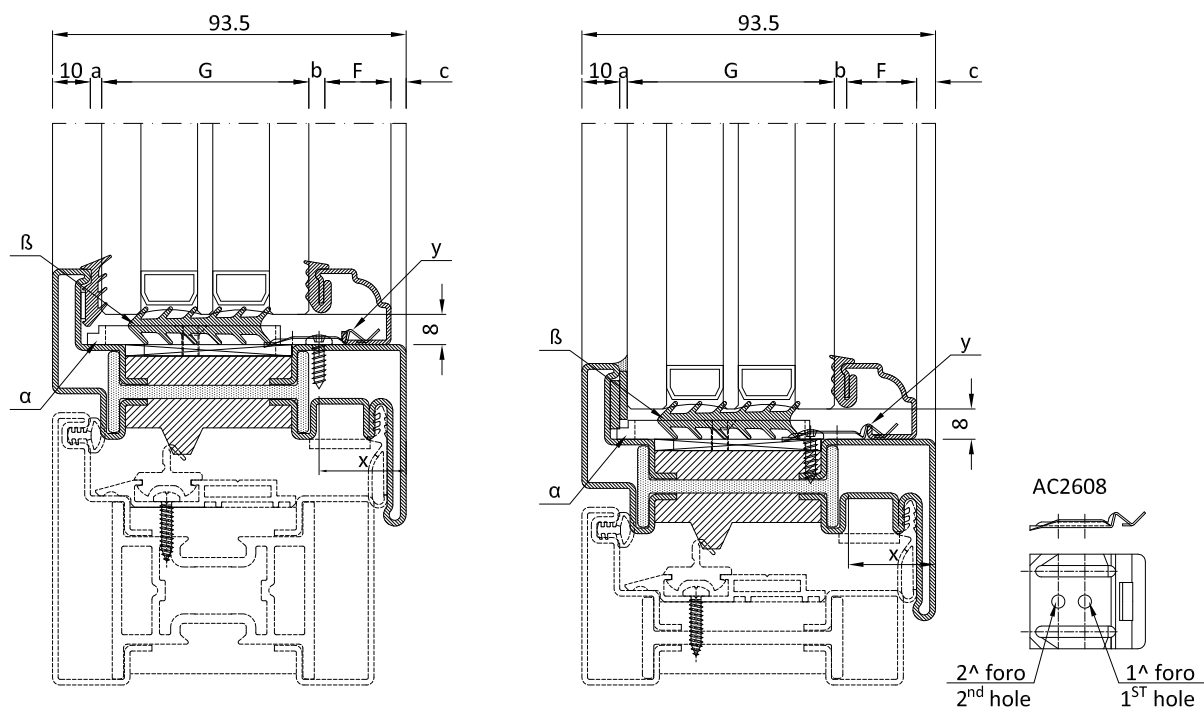


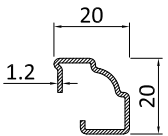
F		Guarnizioni - gaskets		G						
fermavetro glazing bead	range vetro glass range	GE1206 3 mm 	GP0095 3 mm 	spessore vetro glass thickness	asse fissaggio viti fermavetro securing axis for screws for the glazing beads	rientro fermavetro glazing beads gap	clips fissaggio fermavetro securing clips for glazing beads	spessore di compensazione * Shim *	spessore per vetro glass shim	guarnizione sotto vetro under glass gasket
Code		a	b	mm.	x	c	y	z	α	β
 P.2015	63	3	3	63	26**	2	AC2608	3 mm.	AC1020XL	GE1007TT
	65			65	24**	0				

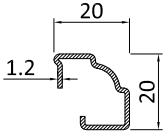
F		Guarnizioni - gaskets		G						
fermavetro glazing bead	range vetro glass range	GU2035 2 mm + sigillatura + sealing	GP0095 3 mm 	spessore vetro glass thickness	asse fissaggio viti fermavetro securing axis for screws for the glazing beads	rientro fermavetro glazing beads gap	clips fissaggio fermavetro securing clips for glazing beads	spessore di compensazione * Shim *	spessore per vetro glass shim	guarnizione sotto vetro under glass gasket
Code		a	b	mm.	x	c	y	z	α	β
 P.2015	64	2	3	64	26**	2	AC2608	3 mm.	AC1020XL	GE1007TT
	66			66	24**	0				

*non fornito
*not included

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



F		Guarnizioni - gaskets		G						
fermavetro glazing bead	range vetro glass range	GE1206 3 mm 	GE2028 2.5 mm 	spessore vetro glass thickness	asse fissaggio viti fermavetro securing axis for screws for the glazing beads	rientro fermavetro glazing beads gap	clips fissaggio fermavetro securing clips for glazing beads	spessore di compensazione * Shim *	spessore per vetro glass shim	guarnizione sotto vetro under glass gasket
Code		a	b	mm.	x	c	y	z	α	β
 P.2028	52 - 58	3	2.5	52	34	6	AC2608	3 mm.	AC1020XL	GE1007TT
				54	25**	4				
				56	23**	2				
				58	21**	0				

F				G						
fermavetro glazing bead	range vetro glass range	GU2035 2 mm  + sigillatura + sealing	GE2028 2.5 mm 	spessore vetro glass thickness	asse fissaggio viti fermavetro securing axis for screws for the glazing beads	rientro fermavetro glazing beads gap	clips fissaggio fermavetro securing clips for glazing beads	spessore di compensazione * Shim *	spessore per vetro glass shim	guarnizione sotto vetro under glass gasket
Code		a	b	mm.	x	c	y	z	α	β
 P.2028	53 - 59	2	2.5	53	34	6	AC2608	3 mm.	AC1020XL	GE1007TT
				55	25**	4				
				57	23**	2				
				59	21**	0				

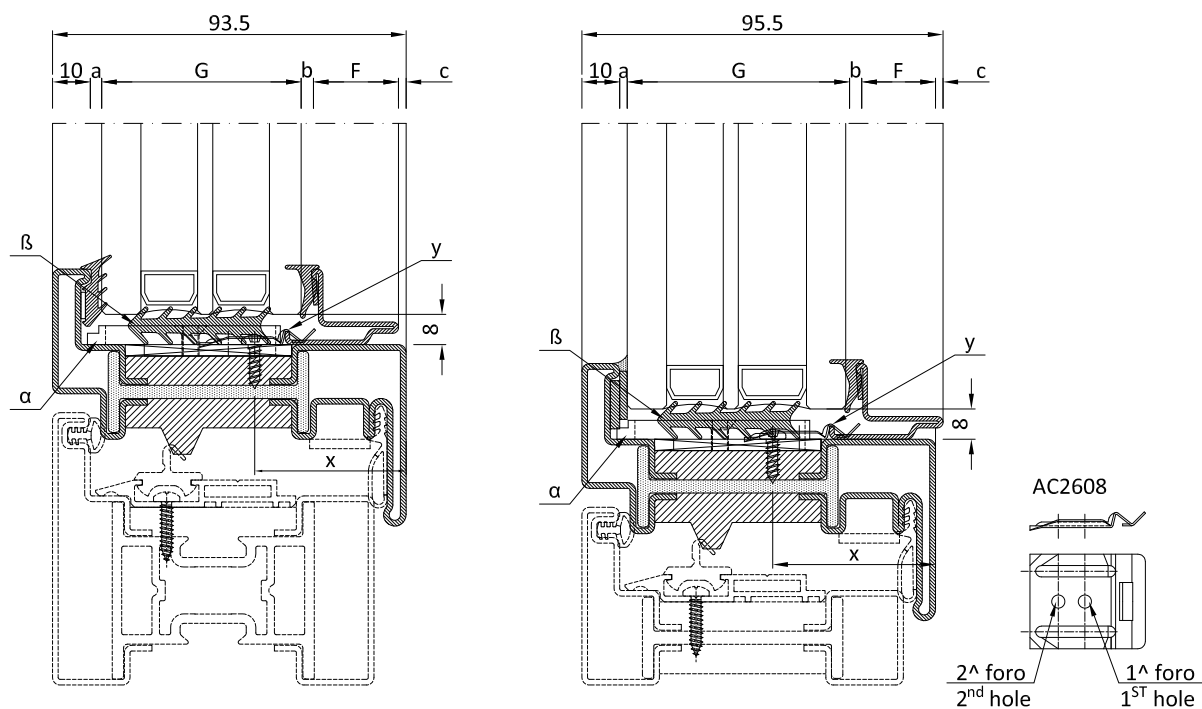
*non fornito

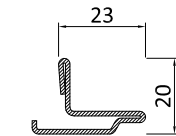
*not included

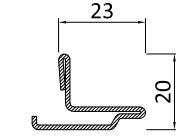
Taglio a 45° dei fermavetri effettuabile utilizzando la ganaschia AT2029
45° cutting of the glazing beads done using the cutting jaw AT2029

** fissare tramite il primo foro della clip

** screw in the upper hole of the clip



F		Guarnizioni - gaskets		G						
fermavetro glazing bead	range vetro glass range	GE1206 3 mm 	GP0095 3 mm 	spessore vetro glass thickness	asse fissaggio viti fermavetro securing axis for screws for the glazing beads	rientro fermavetro glazing beads gap	clips fissaggio fermavetro securing clips for glazing beads	spessore di compensazione * Shim *	spessore per vetro glass shim	guarnizione sotto vetro under glass gasket
Code		a	b	mm.	x	c	y	z	α	β
 P.2038	52	3	3	52	40**	2	AC2608	3 mm.	AC1020XL	GE1007TT
	58			54	38**	0				
				56	43	-2				
				58	41	-4				

F		Guarnizioni - gaskets		G						
fermavetro glazing bead	range vetro glass range	GU2035 2 mm  + sigillatura + sealing	GP0095 3 mm 	spessore vetro glass thickness	asse fissaggio viti fermavetro securing axis for screws for the glazing beads	rientro fermavetro glazing beads gap	clips fissaggio fermavetro securing clips for glazing beads	spessore di compensazione * Shim *	spessore per vetro glass shim	guarnizione sotto vetro under glass gasket
Code		a	b	mm.	x	c	y	z	α	β
 P.2038	53	2	3	53	40**	2	AC2608	3 mm.	AC1020XL	GE1007TT
	59			55	38**	0				
				57	36	-2				
				59	34	-4				

*non fornito

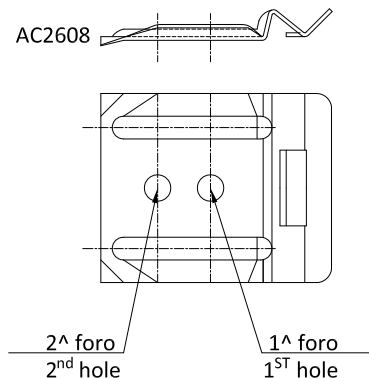
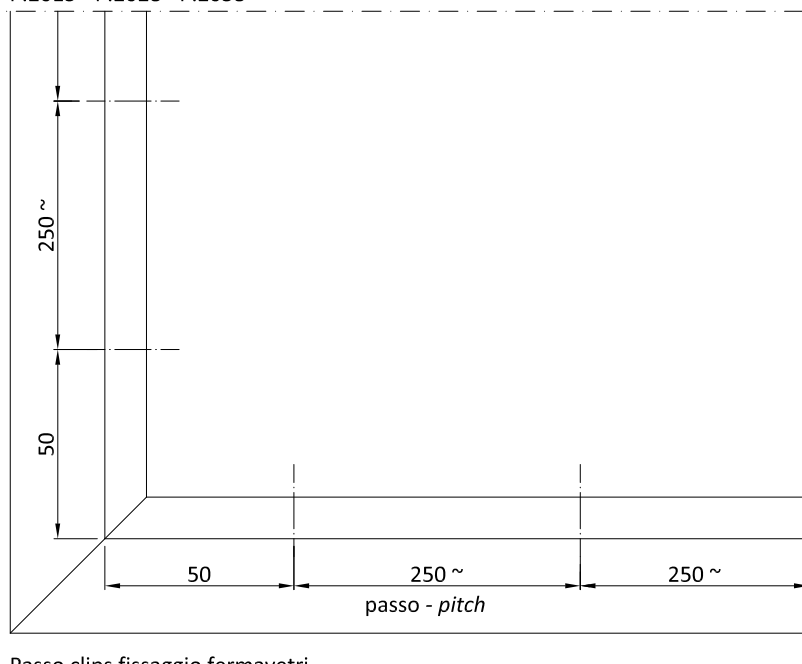
*not included

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

** fissare tramite il primo foro della clip

** screw in the upper hole of the clip

P.2015 - P.2028 - P.2038

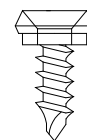
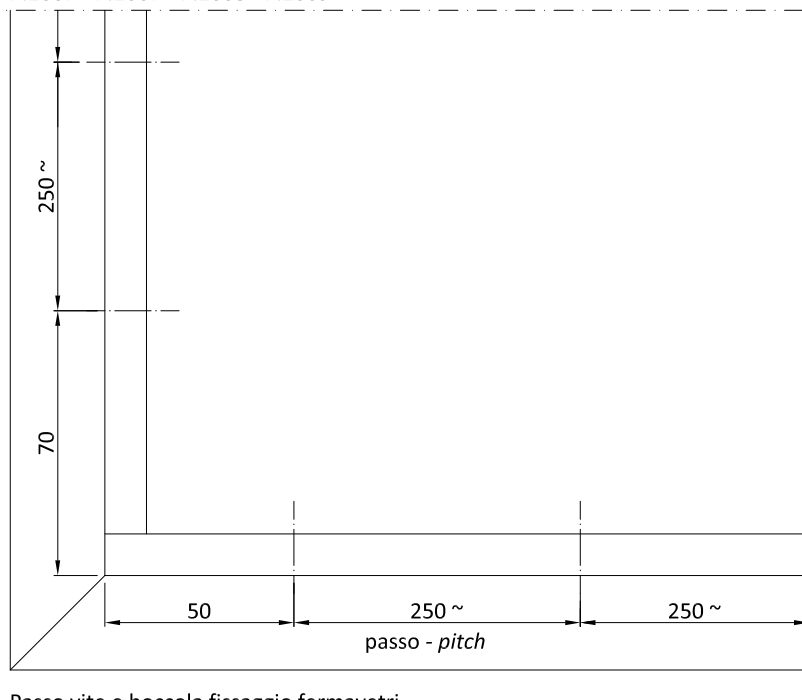


Passo clips fissaggio fermavetri
Clip pitch for fixing the glazing beads

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

Fori eseguibili con maschera AT2828
Holes to be done with AT2828

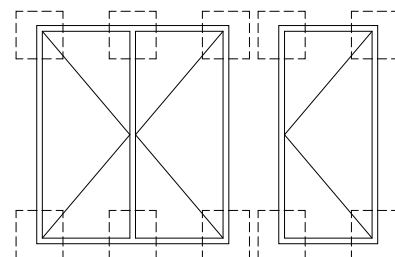
P.2007 - P.1007 - P.2008 - P.2009



CV5001 + CV5012
CV5001I + CV5012I

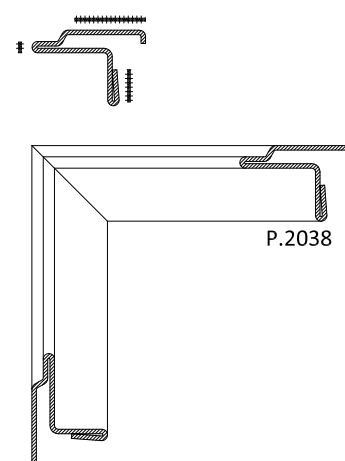
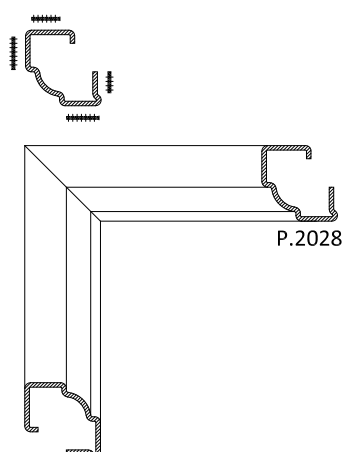
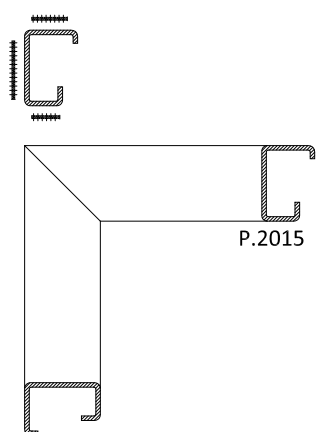
Passo vite e boccia fissaggio fermavetri
Clip pitch to fix glazing beads

Fori eseguibili con maschera AT1234
Holes to be done with AT1234



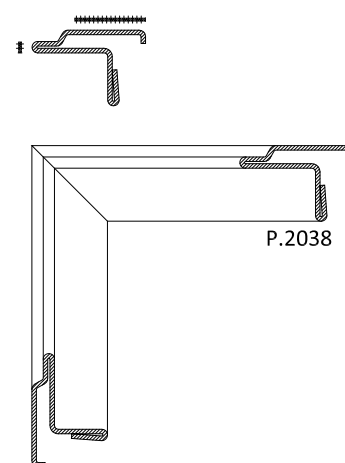
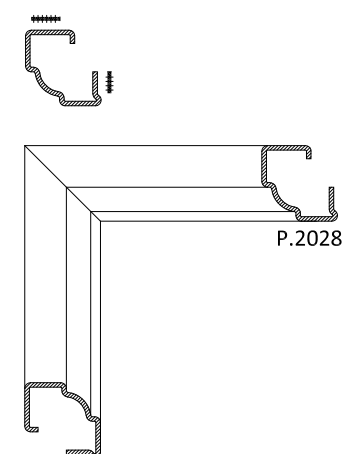
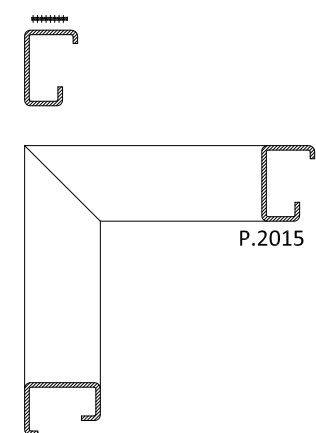
Acciaio zincato - Acciaio Corten - Acciaio inox
Saldare in continuo le superfici di contatto indicate

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



Ottone
Saldare a TIG a punti le zone indicate.

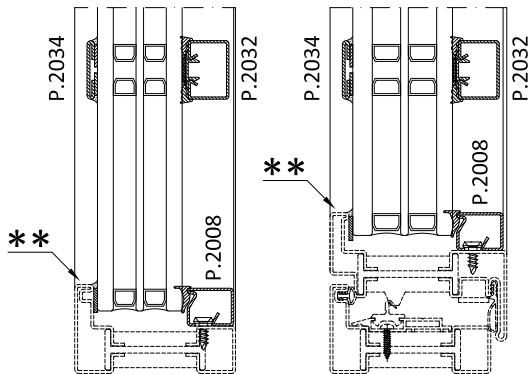
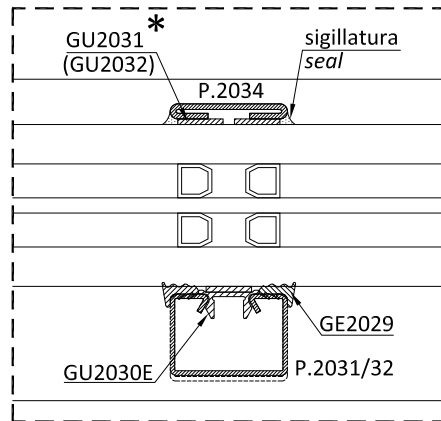
Brass
Spot weld (TIG) the marked areas.



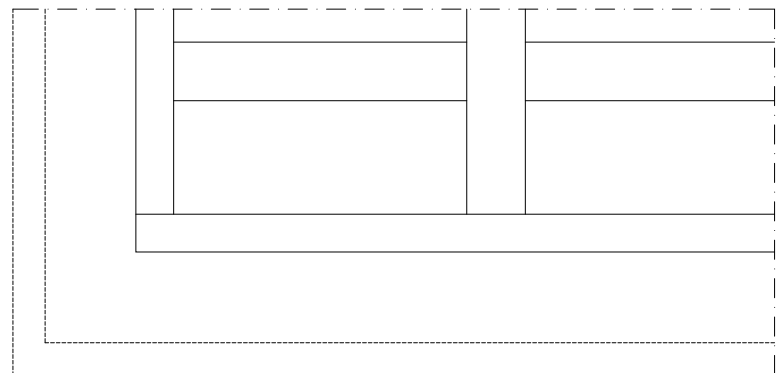
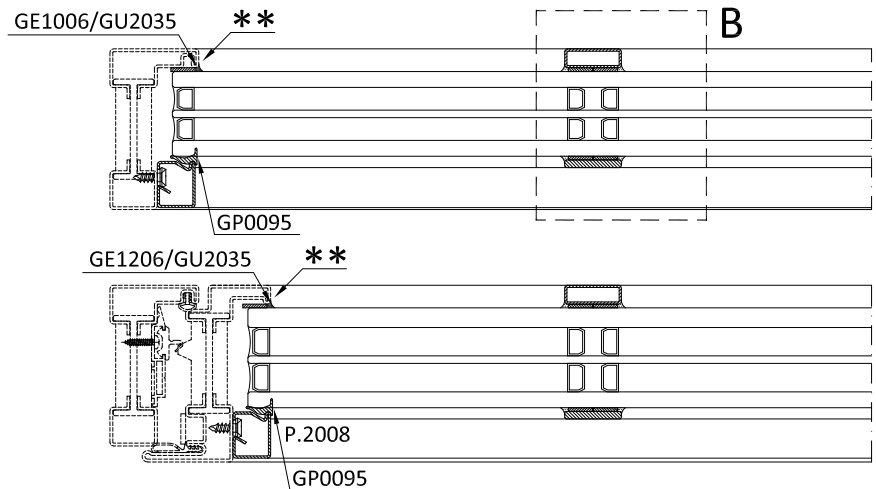
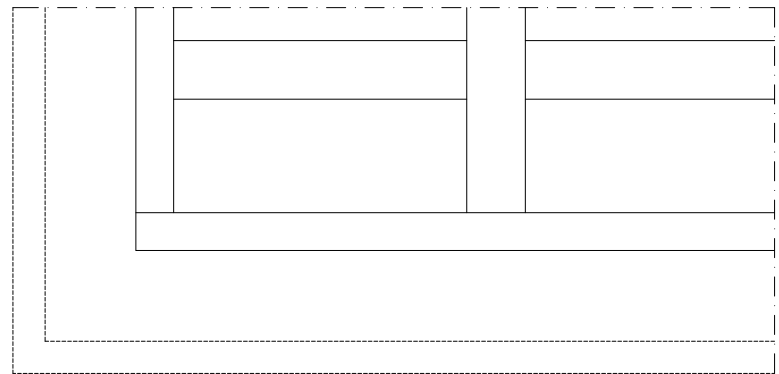
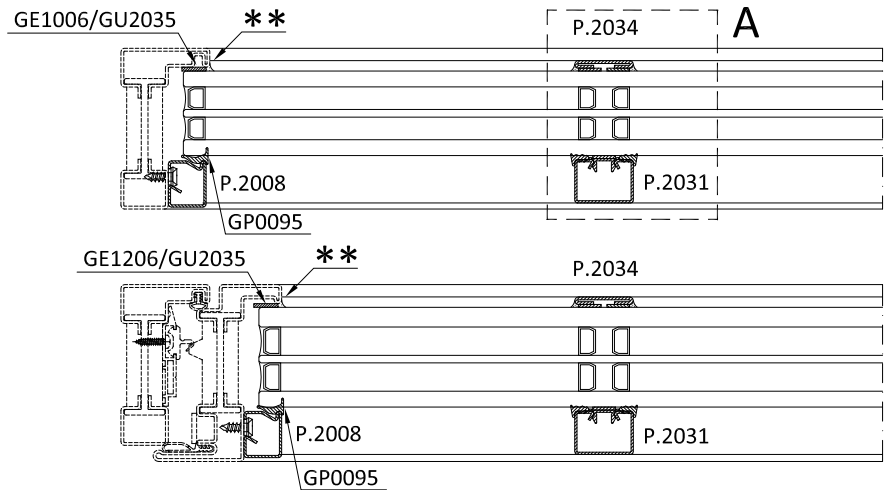
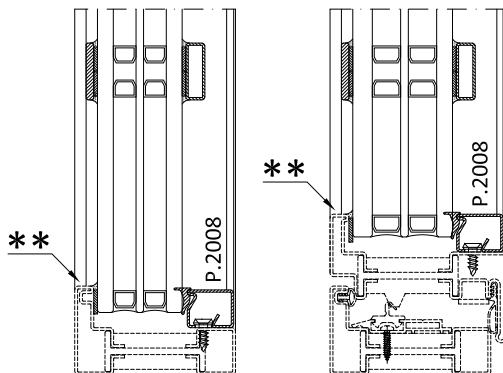
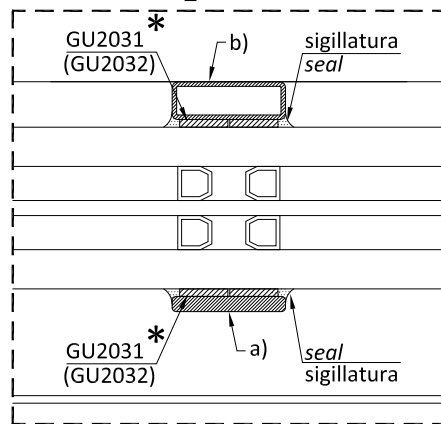
P.2028
Taglio a 45° dei fermavetri effettuabile utilizzando la ganascia AT2029
45° cutting of the glazing beads done using the cutting jaw AT2029

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

PARTICOLARE "A" _ DETAIL "A"



PARTICOLARE "B" _ DETAIL "B"

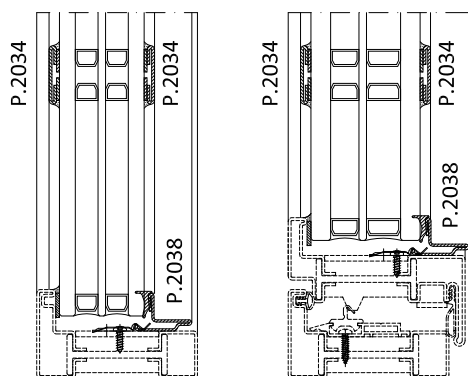
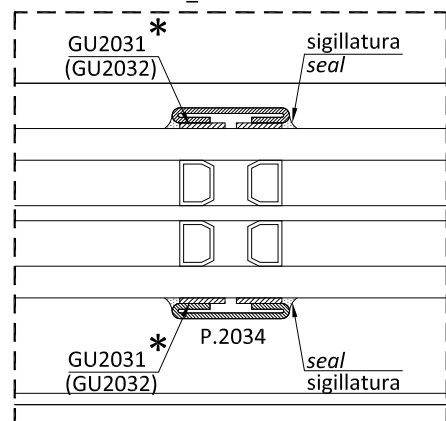


* Per utilizzo dividivetro SOLO orizzontali o SOLO verticali GU2031
Per utilizzo dividivetro orizzontali e verticali GU2031 verticalmente GU2032 orizzontalmente
For ONLY horizontal or ONLY vertical glazing beads use GU2031
For horizontal and vertical glazing beads use GU2031 vertically and GU2032 horizontally

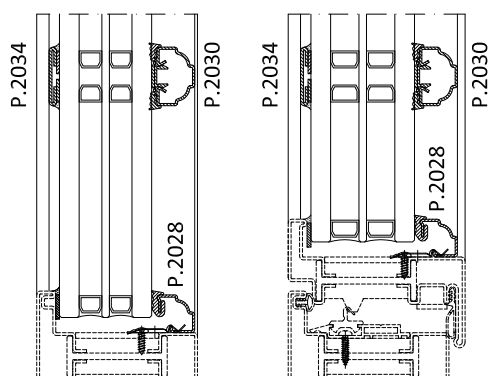
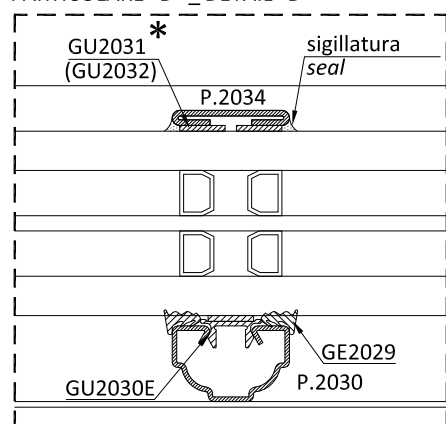
** Saldare o sigillare
Weld or seal

a) profilo commerciale | section profile 30x4 mm
b) profilo commerciale | section profile 30x10 mm

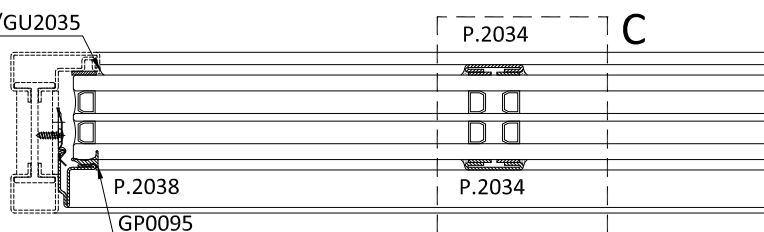
PARTICOLARE "C" _ DETAIL "C"



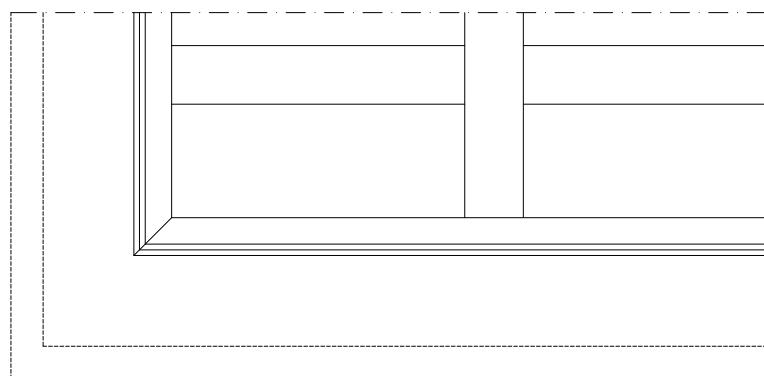
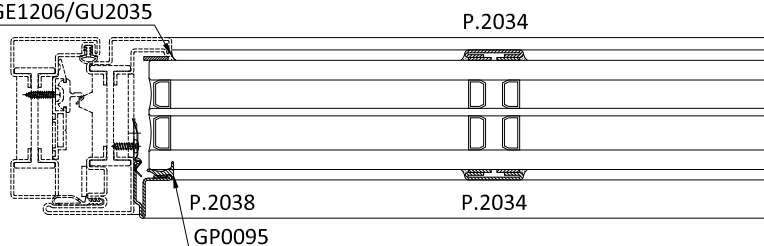
PARTICOLARE "D" _ DETAIL "D"



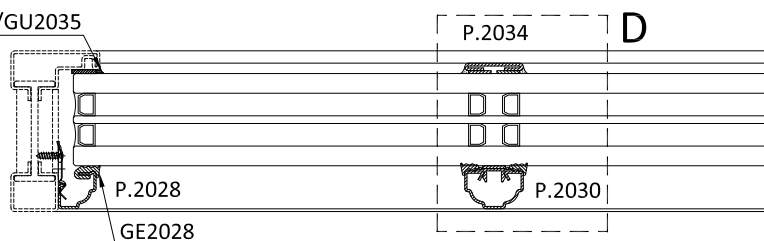
GE1006/GU2035



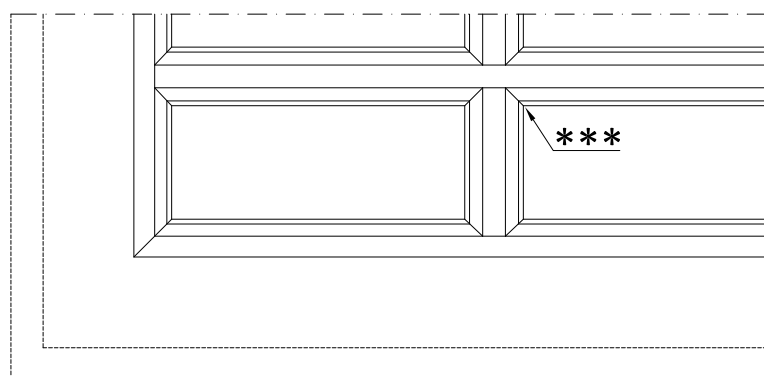
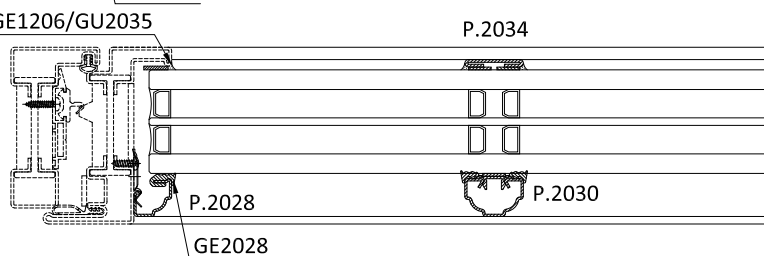
GE1206/GU2035



GE1006/GU2035



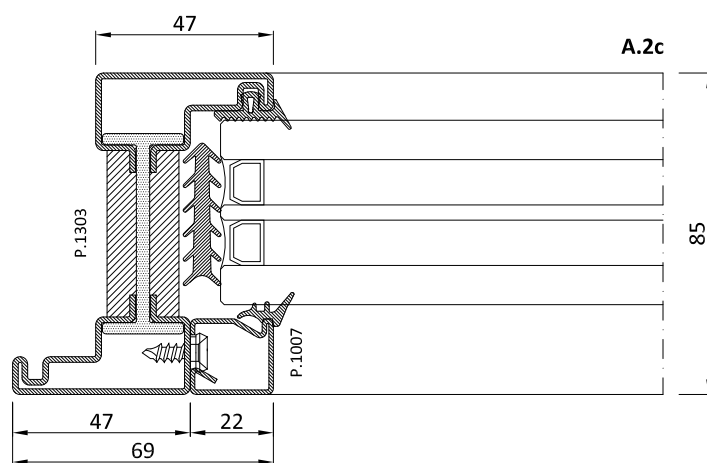
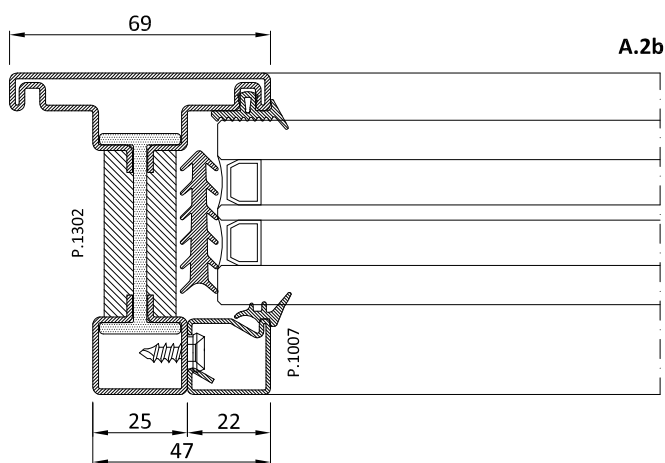
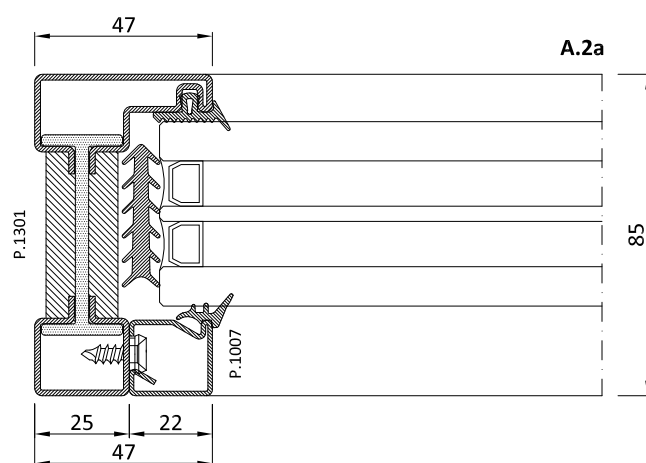
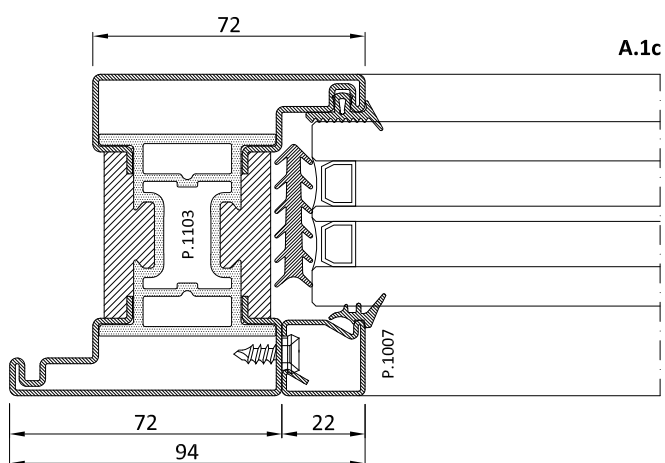
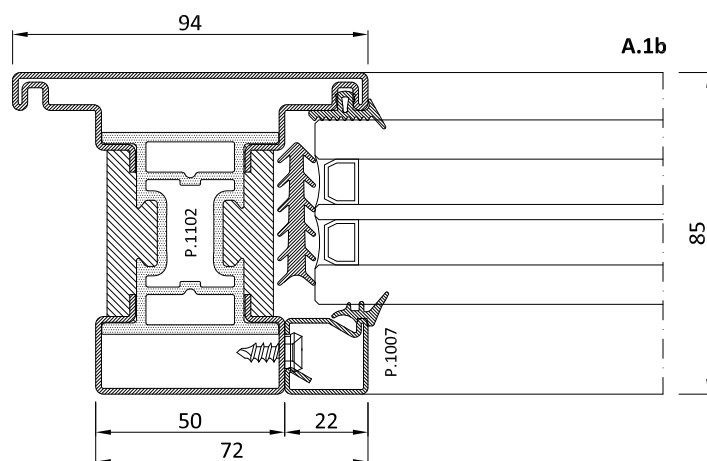
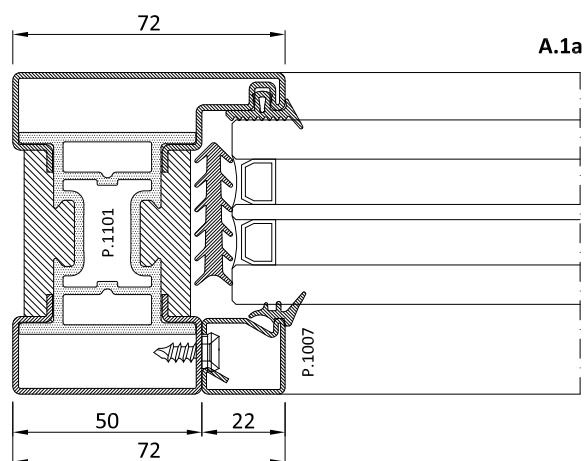
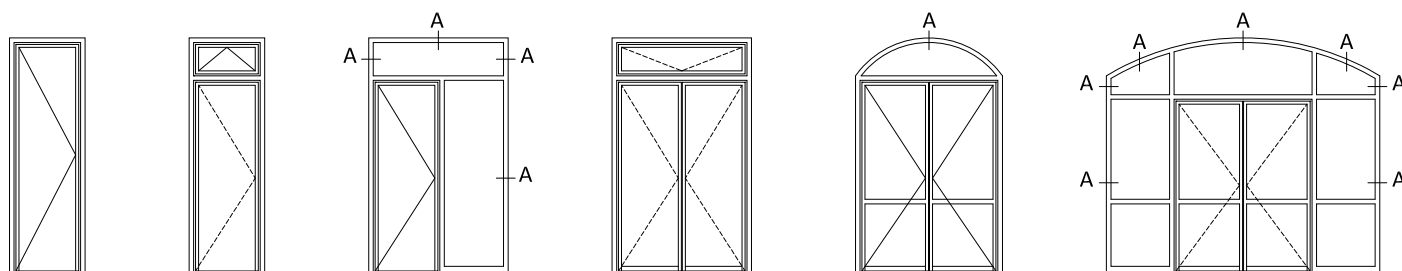
GE1206/GU2035

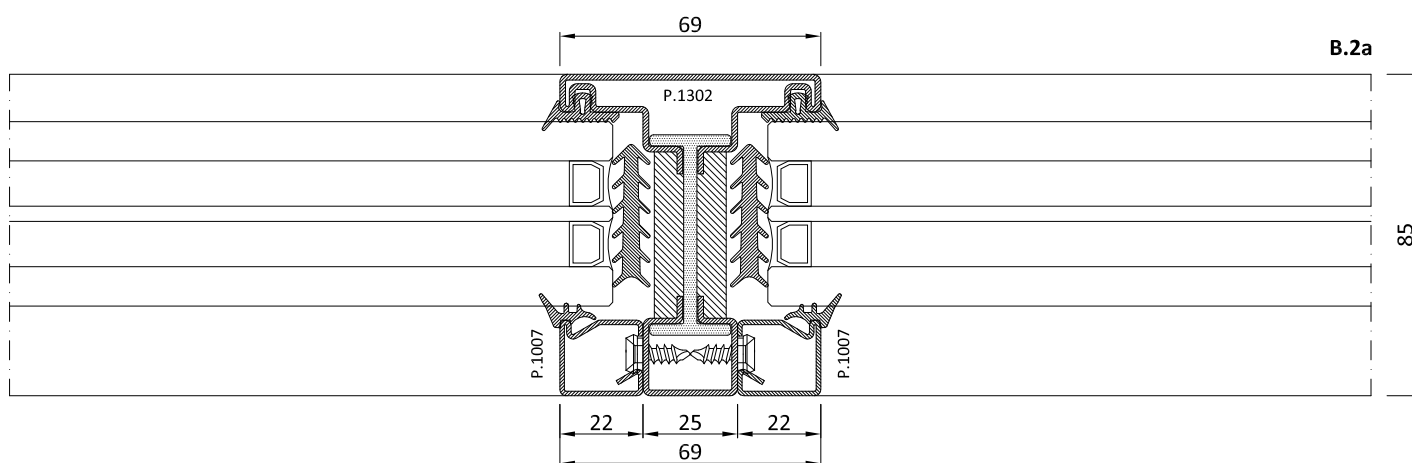
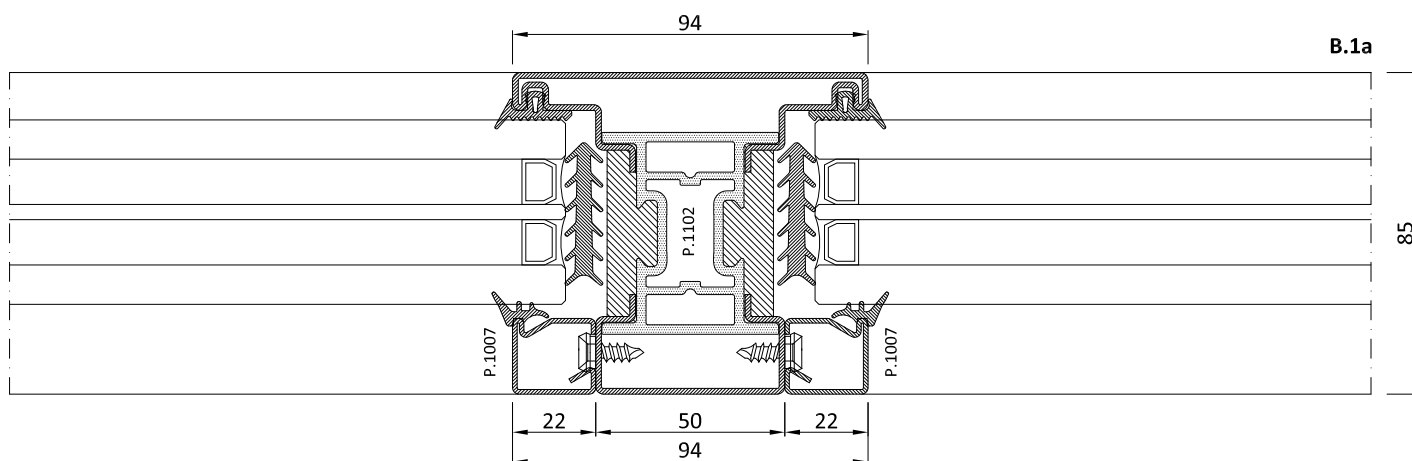
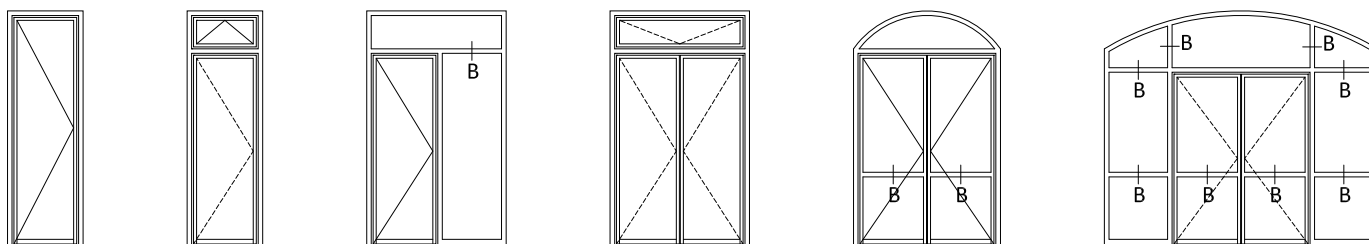


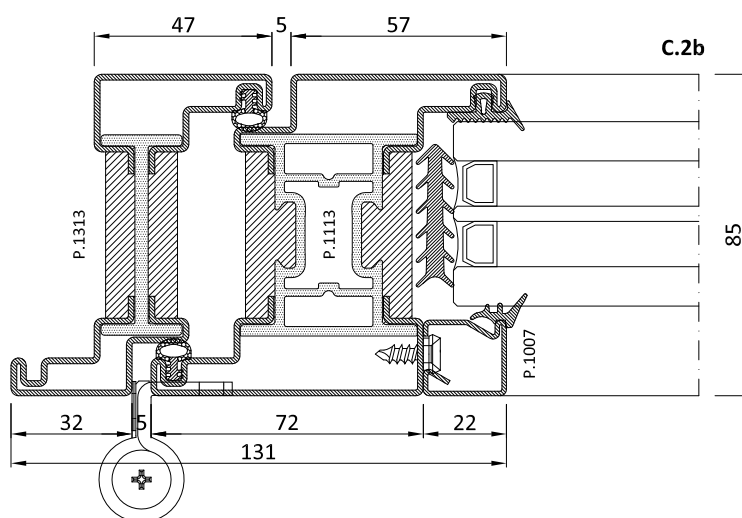
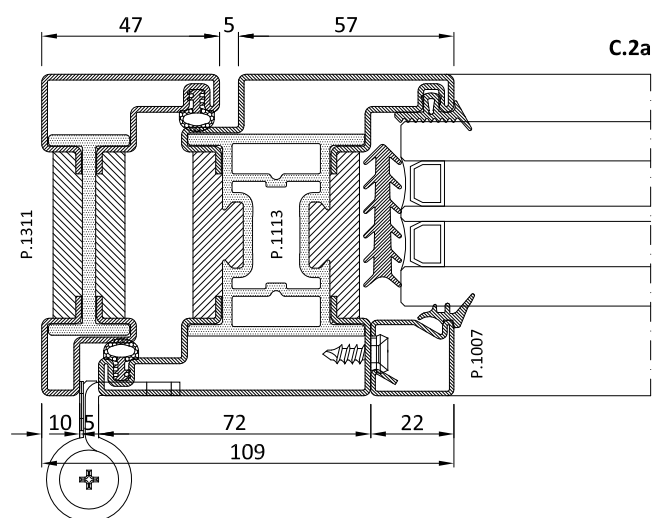
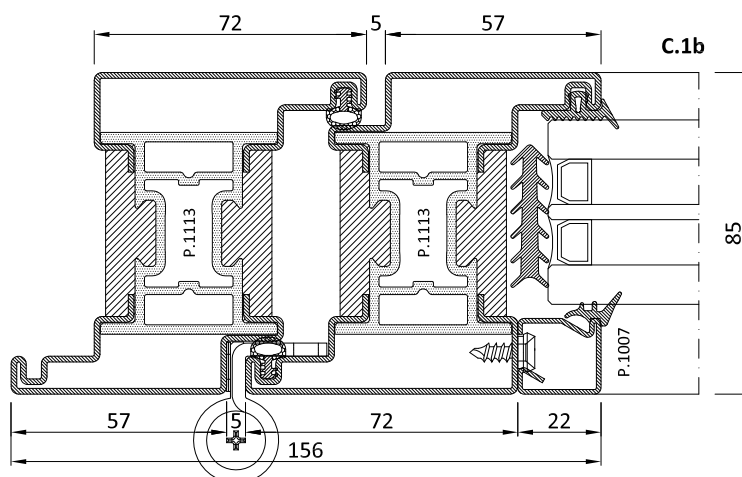
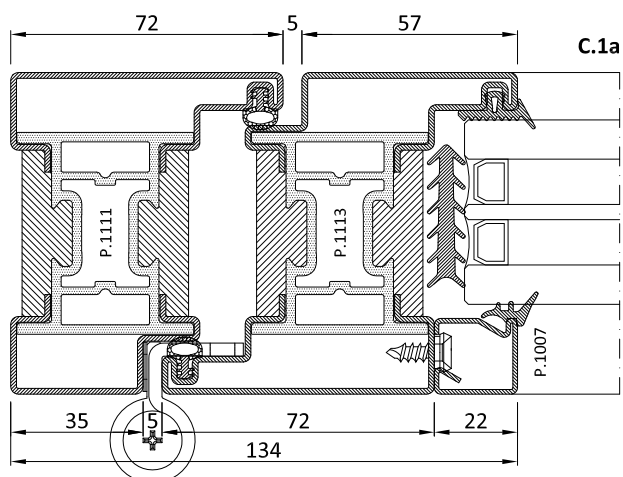
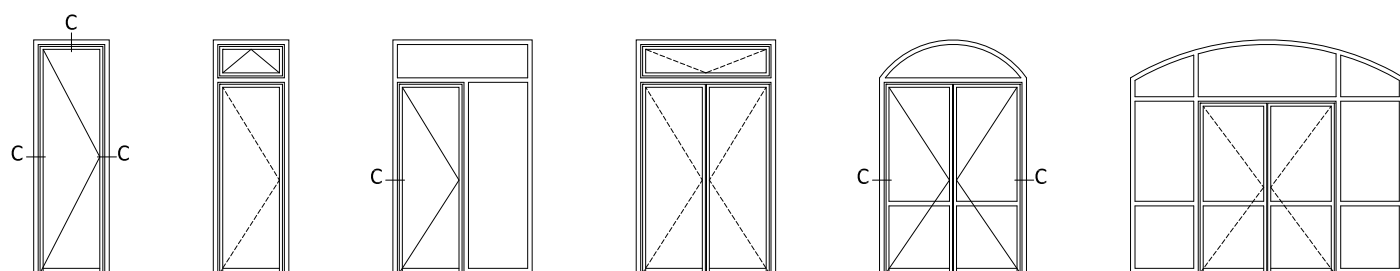
* Per utilizzo dividivetro SOLO orizzontali o SOLO verticali GU2031
Per utilizzo dividivetro orizzontali e verticali GU2031 verticalmente GU2032 orizzontalmente
For ONLY horizontal or ONLY vertical glazing beads use GU2031
For horizontal and vertical glazing beads use GU2031 vertically and GU2032 horizontally

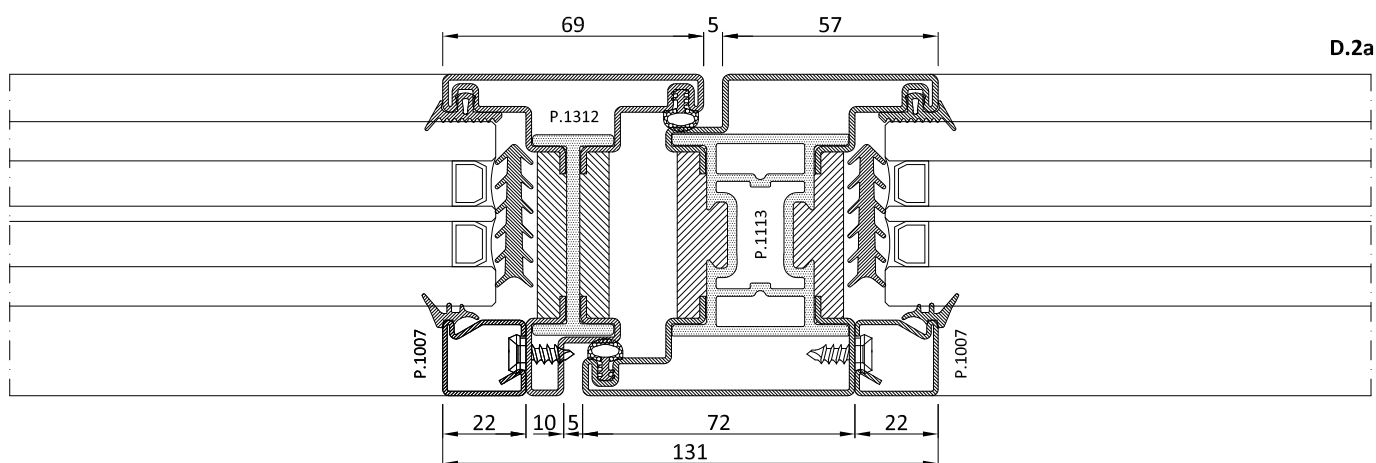
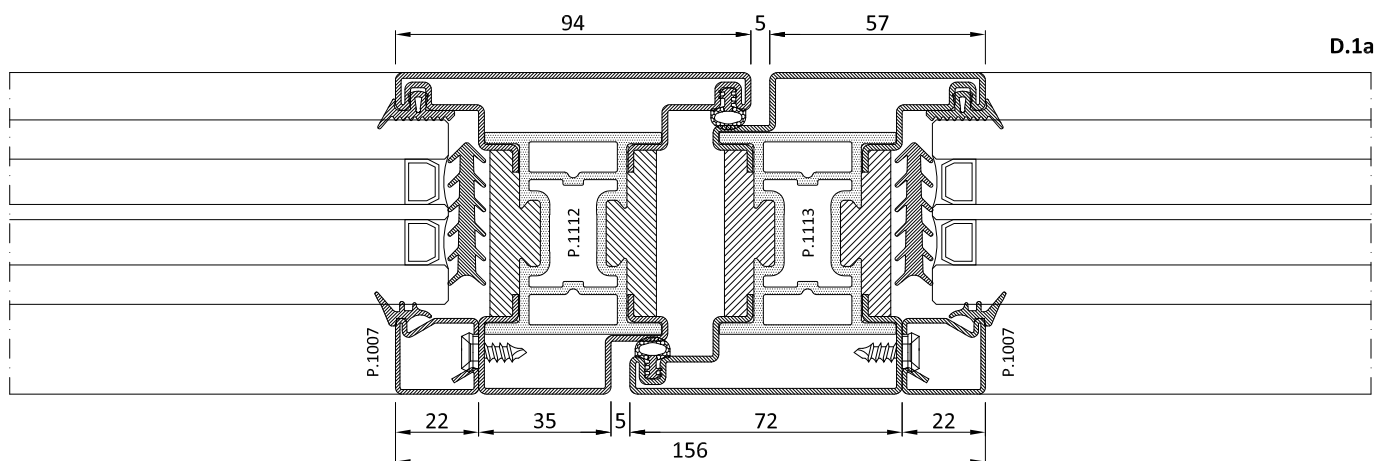
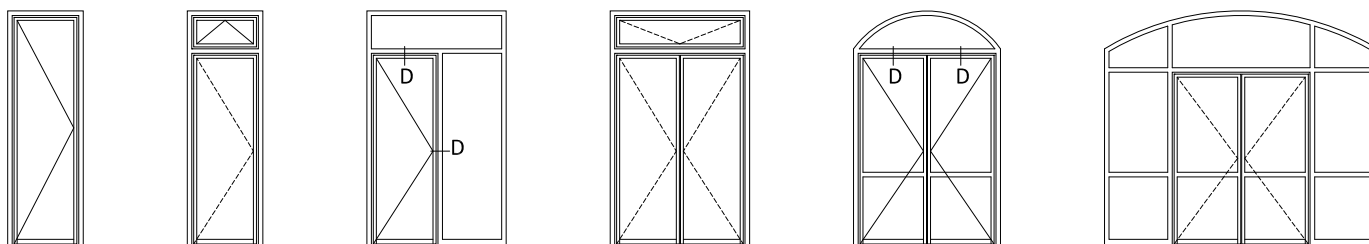
** Saldare o sigillare
Weld or seal

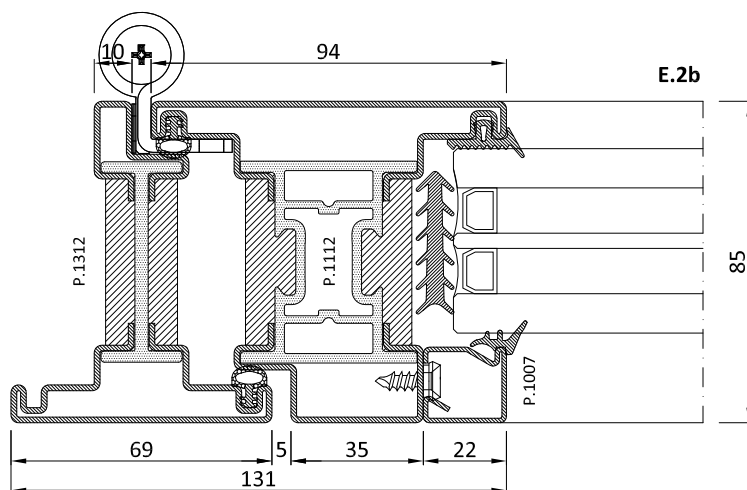
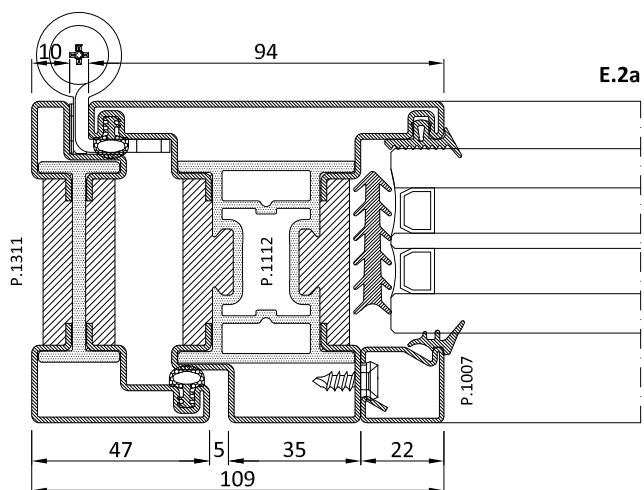
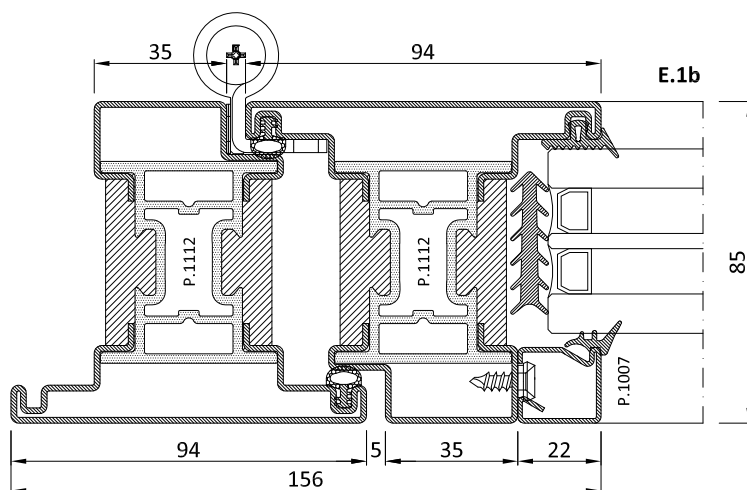
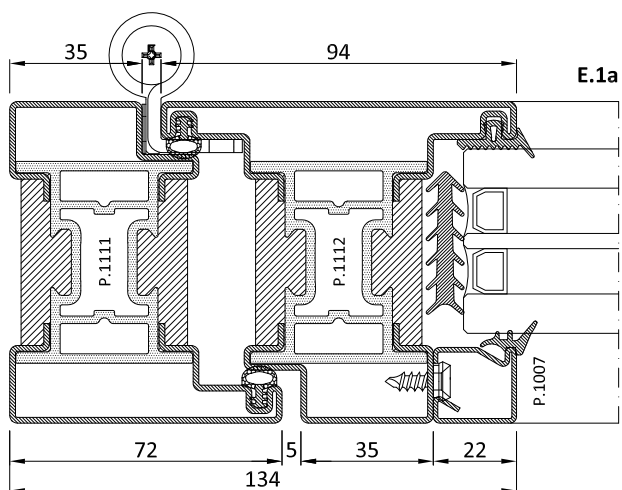
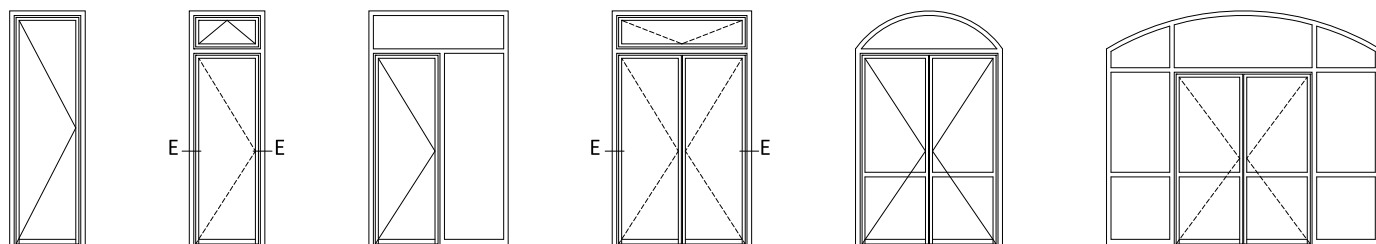
*** Lavorazione di intestatura effettuabile con stampo AT2030
Processing of butt jointing carried out with a mould

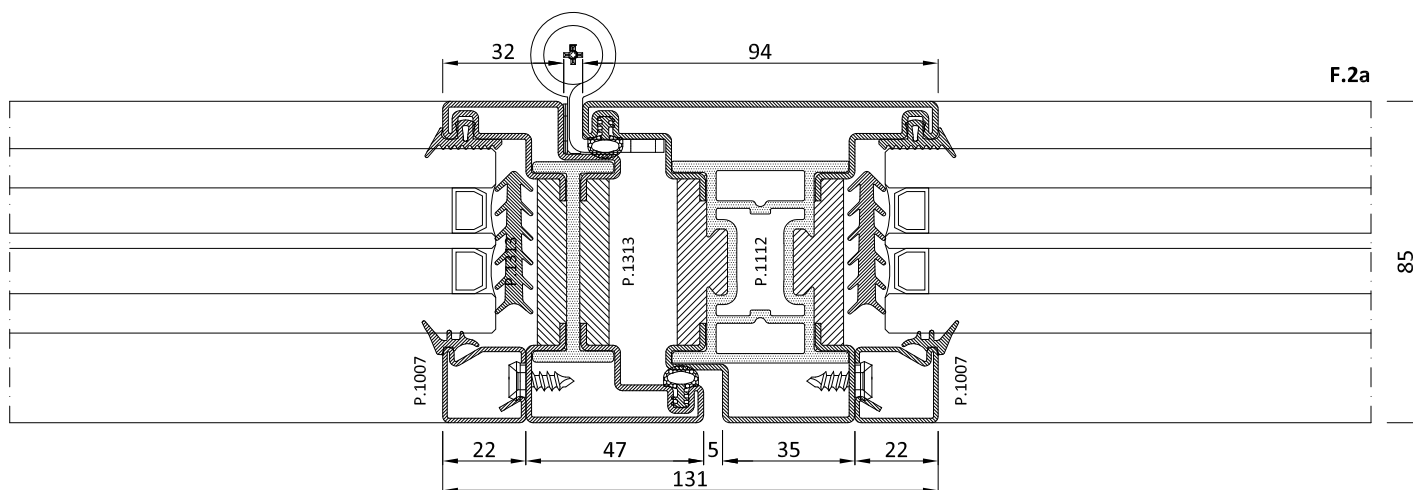
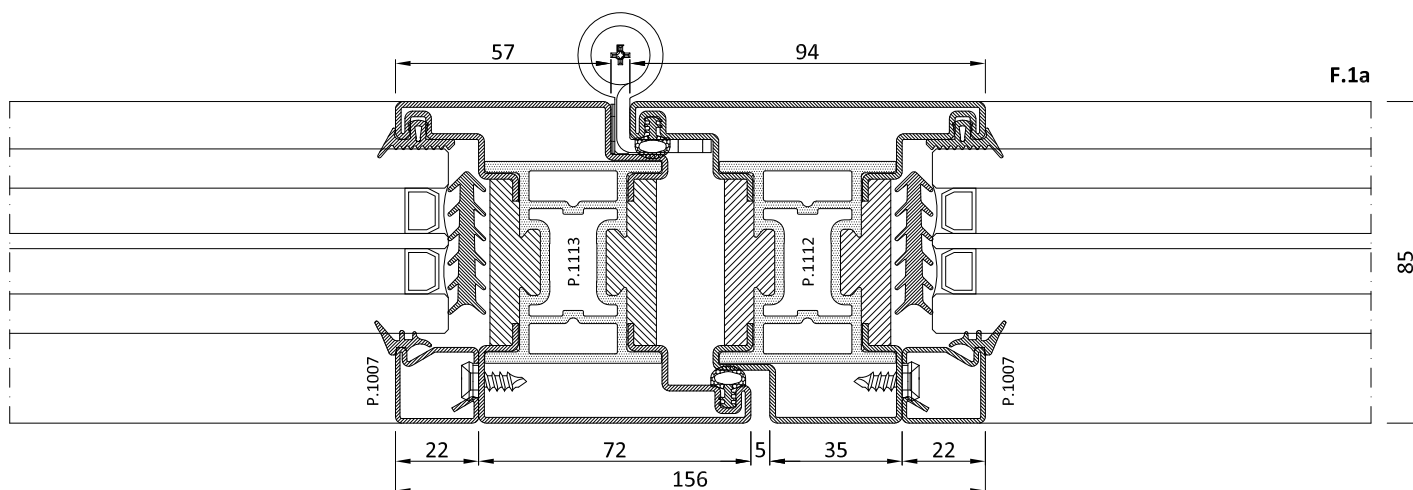
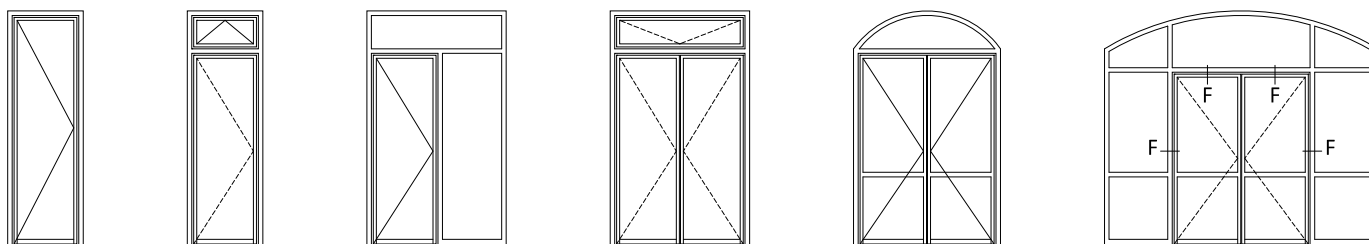


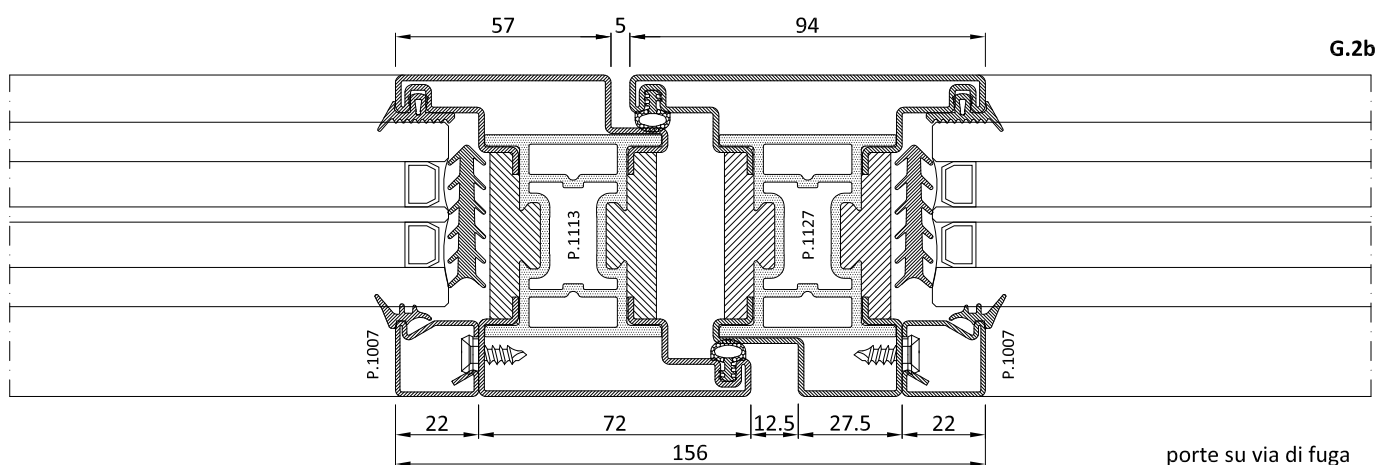
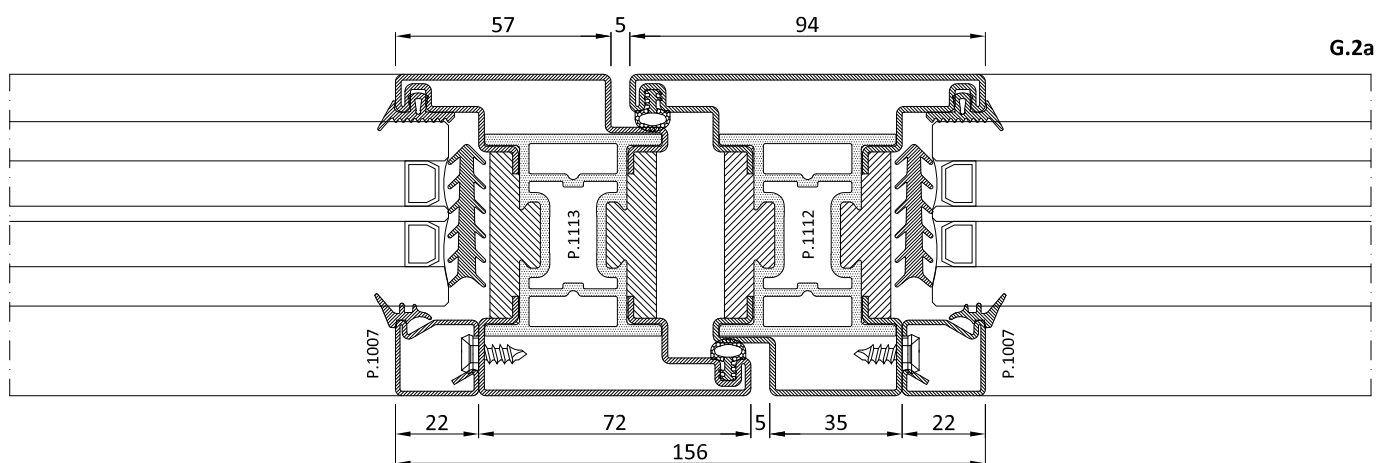
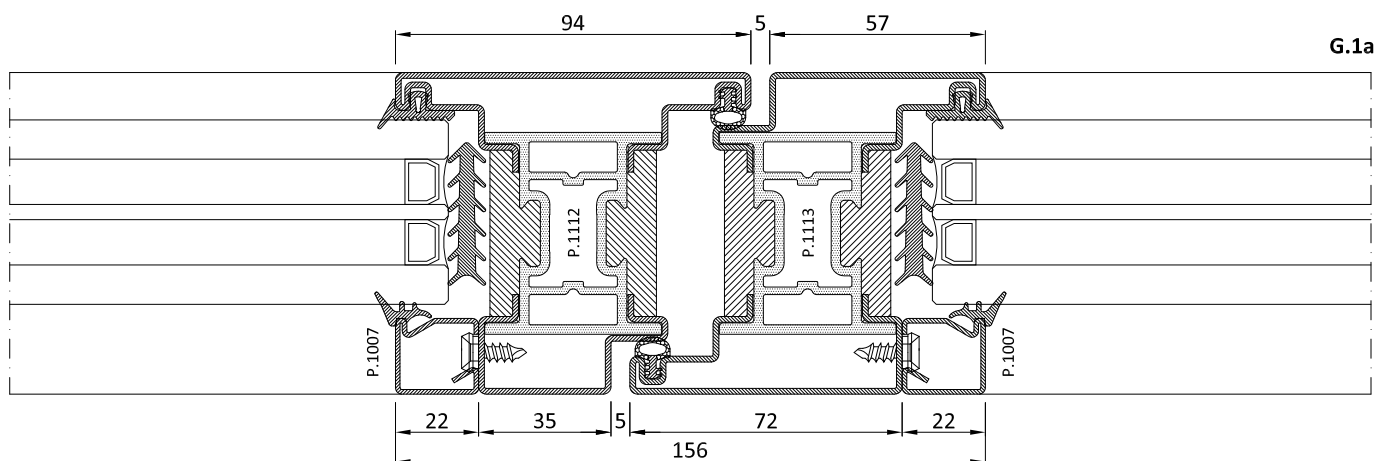
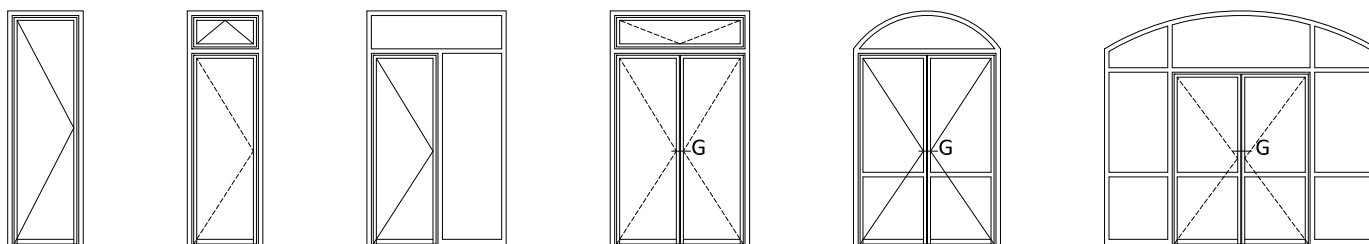




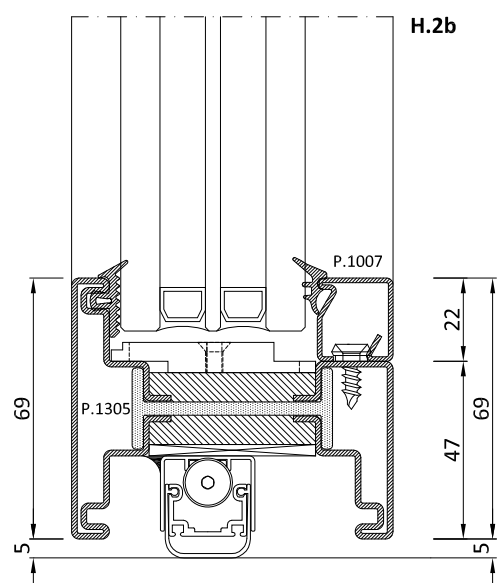
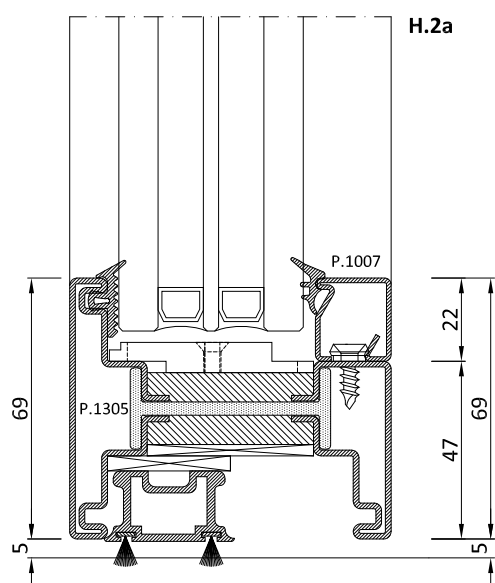
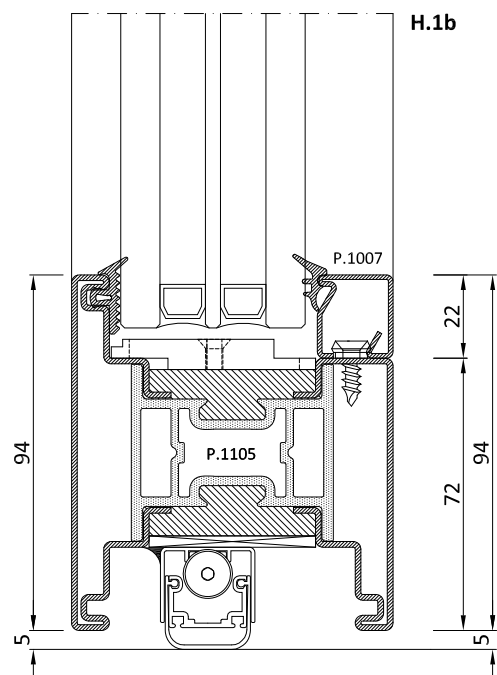
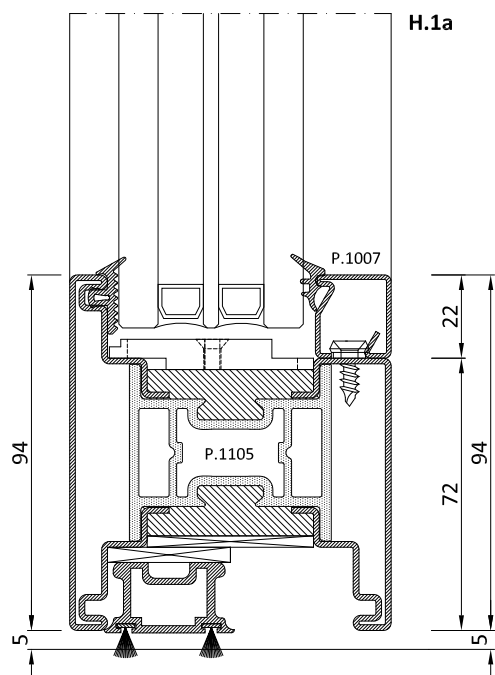
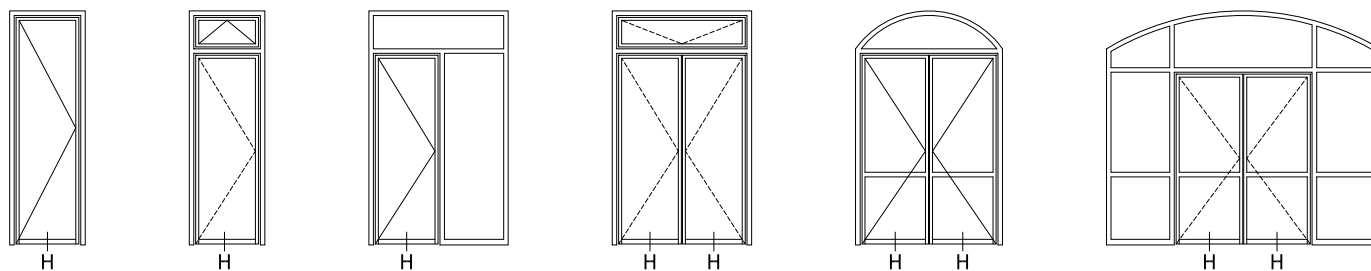


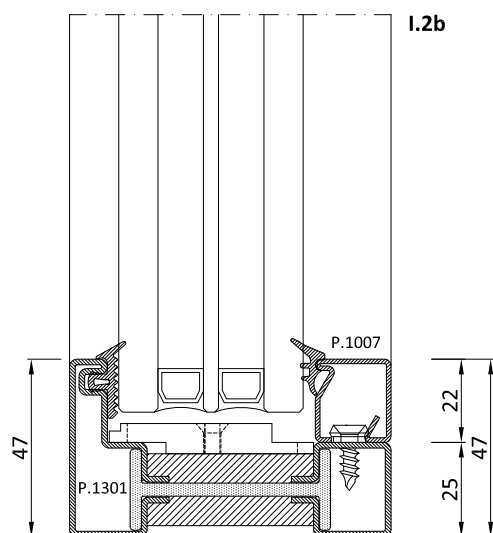
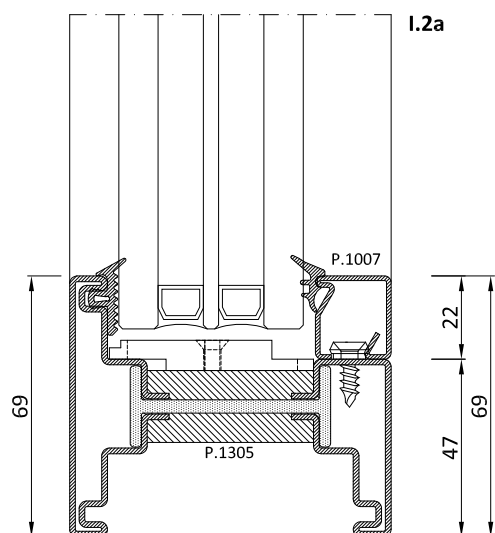
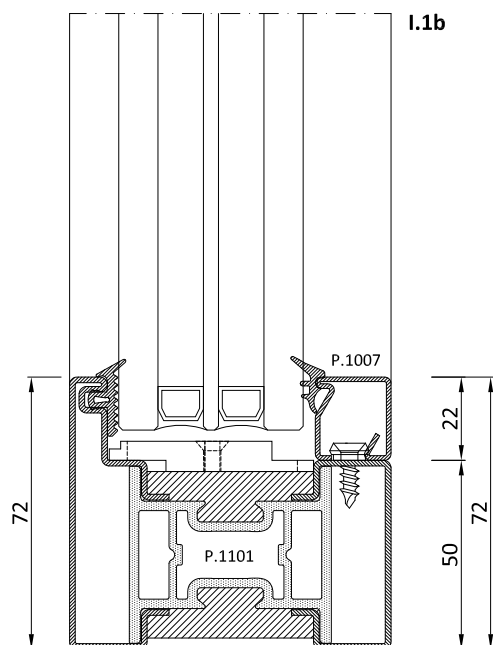
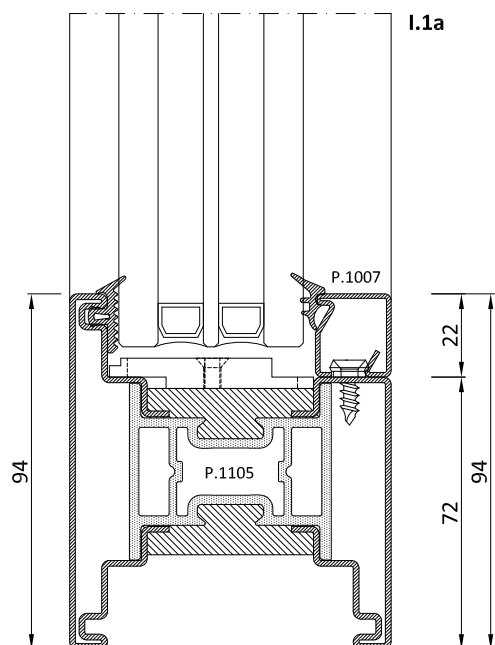
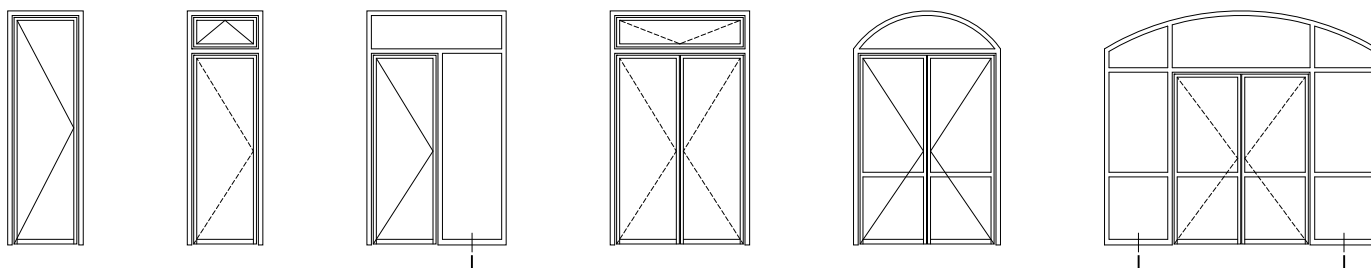


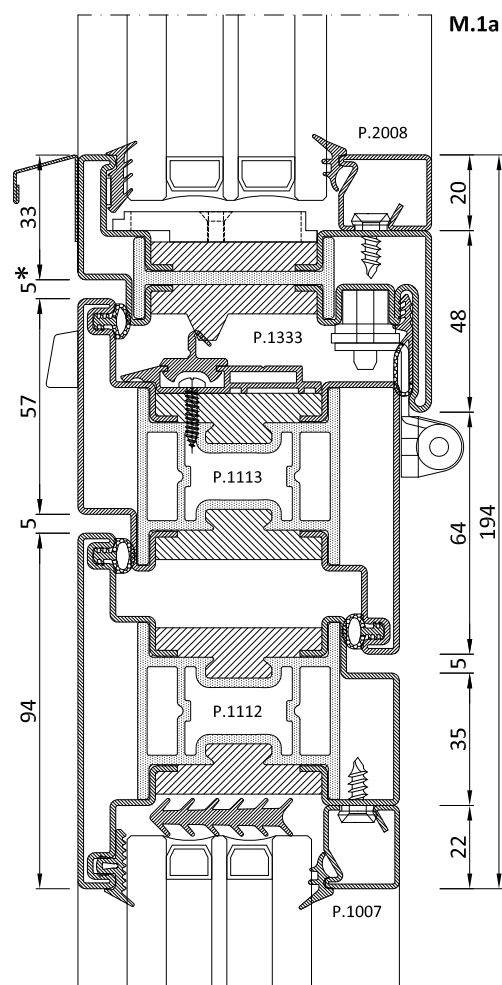
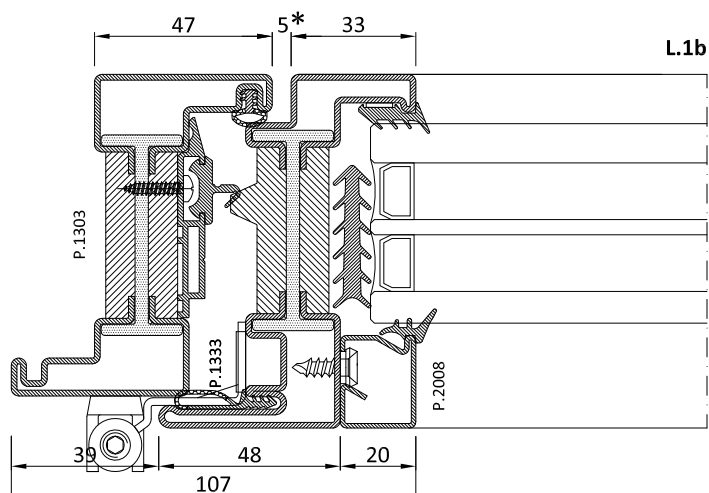
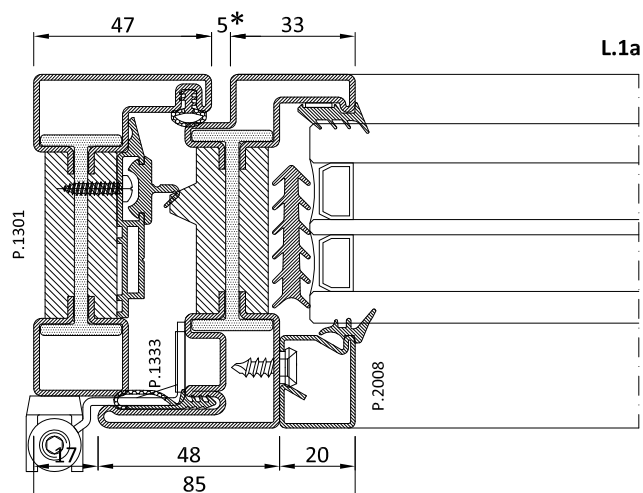
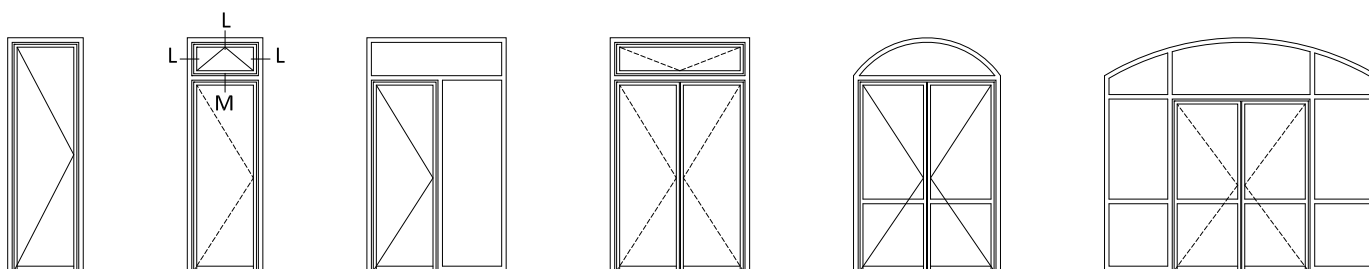




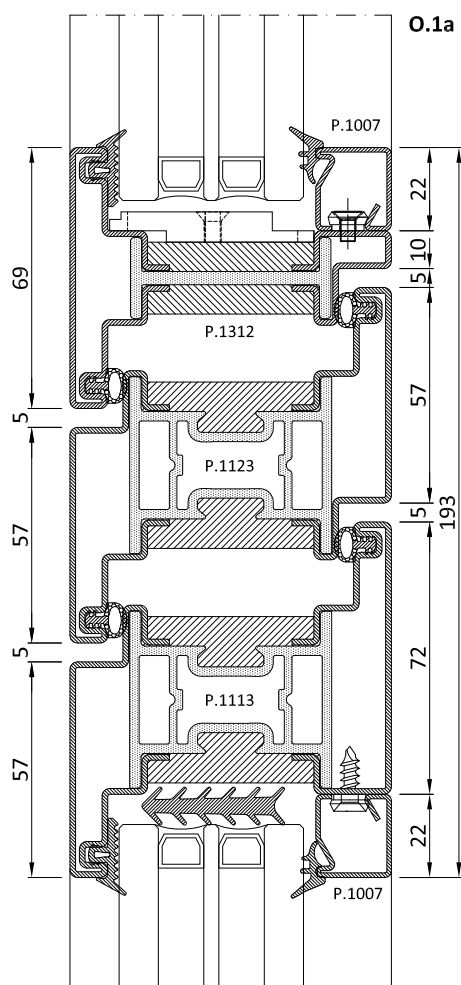
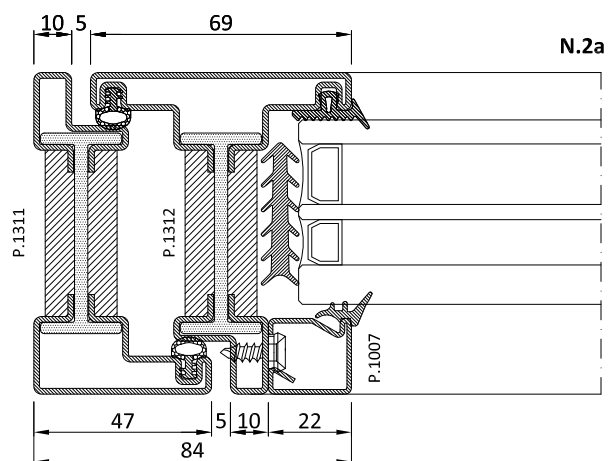
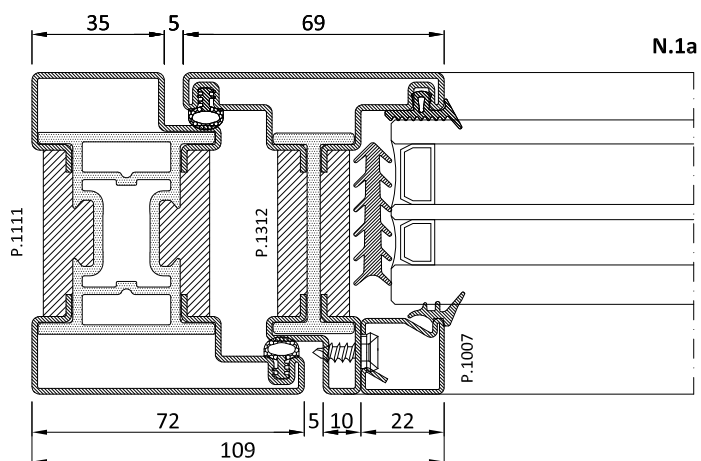
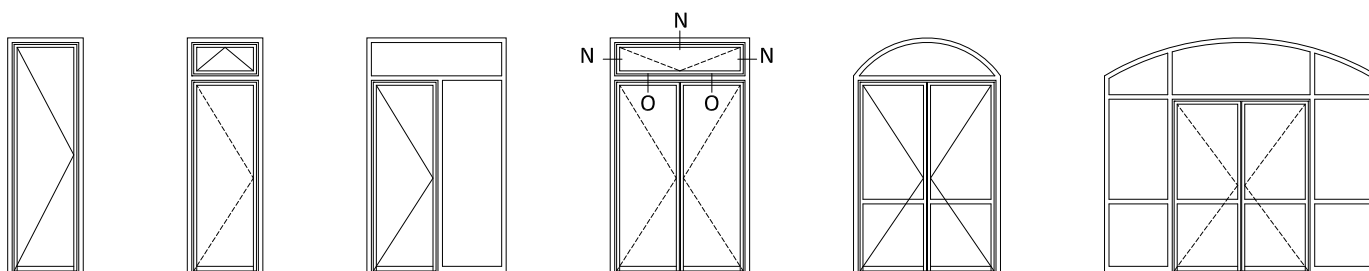
porte su via di fuga
Escape route door

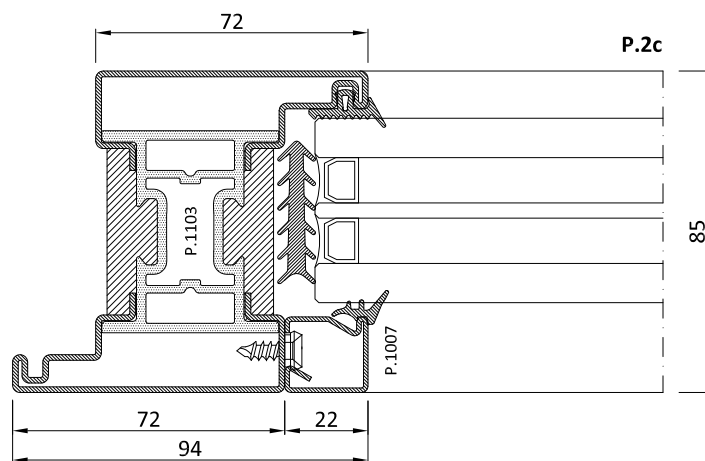
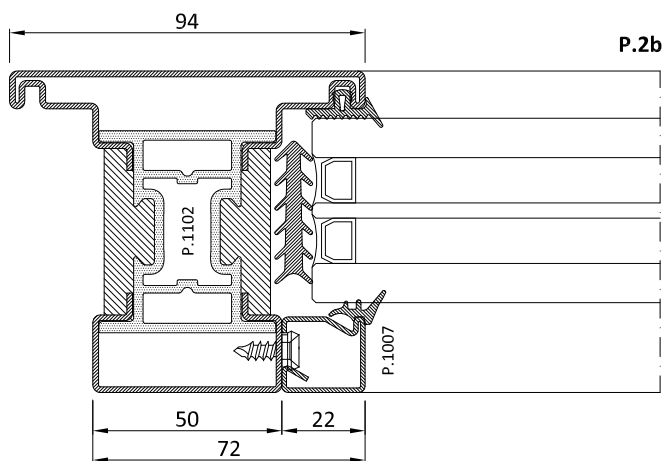
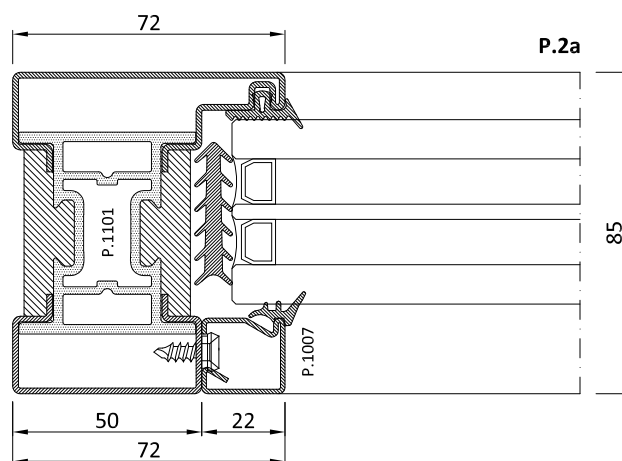
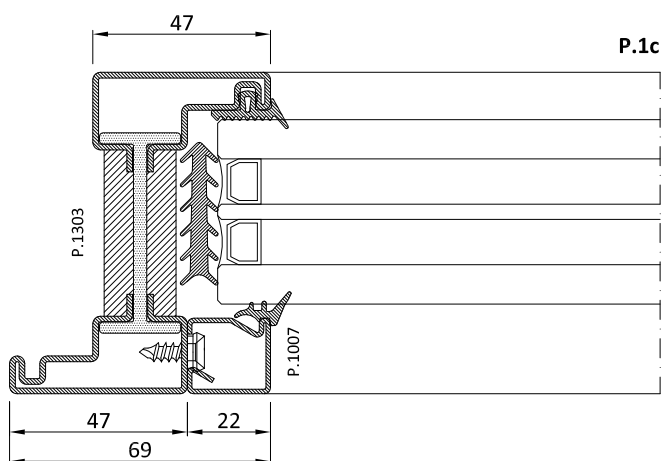
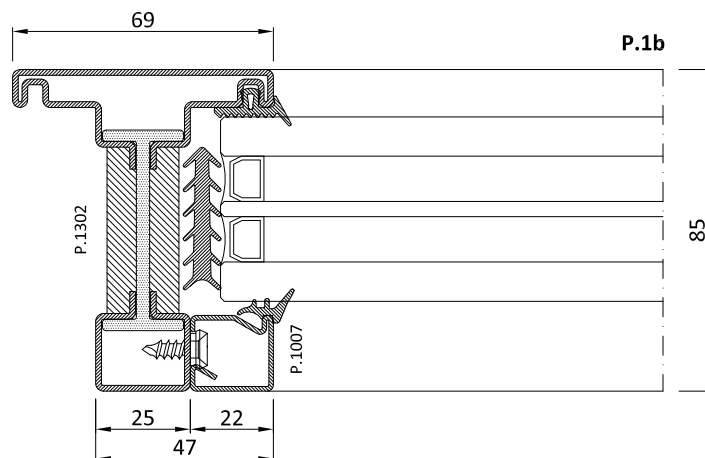
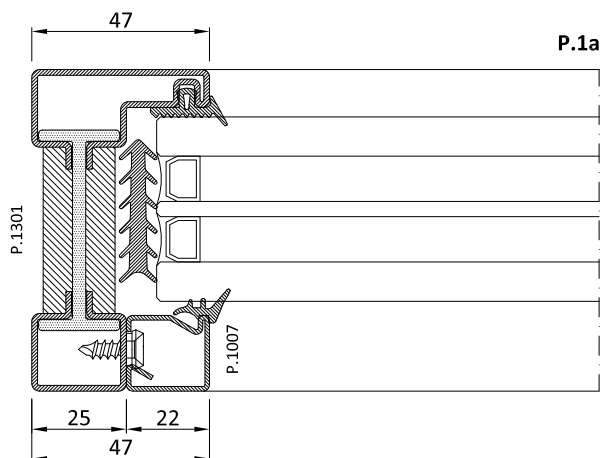
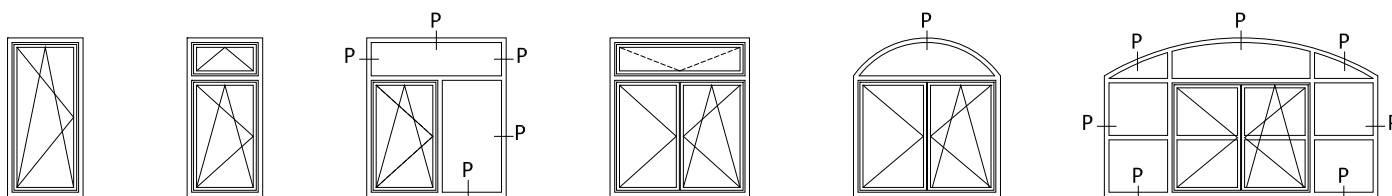


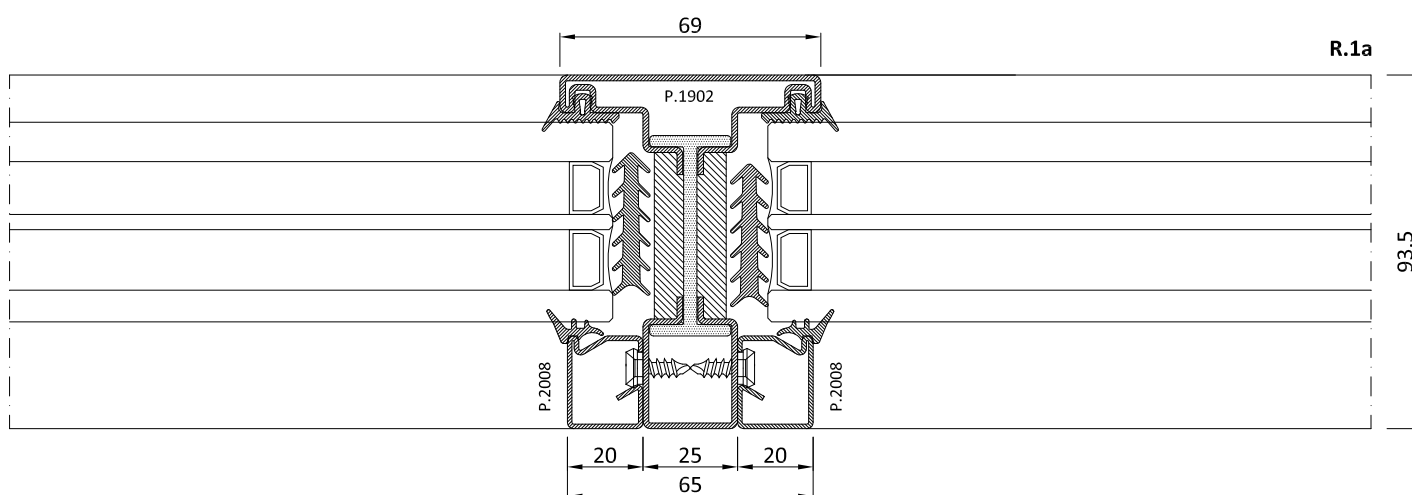
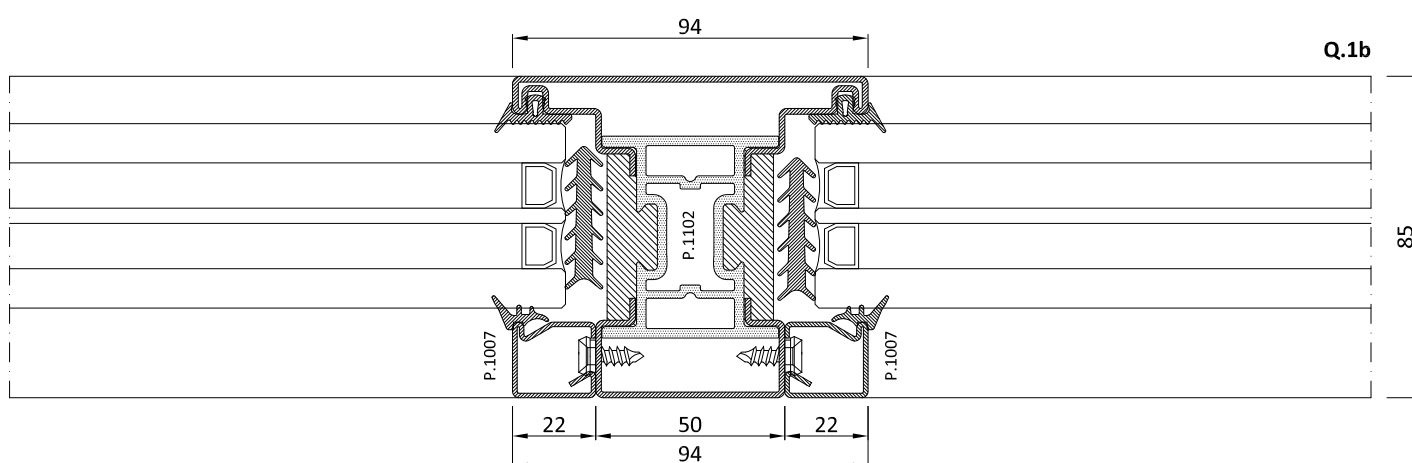
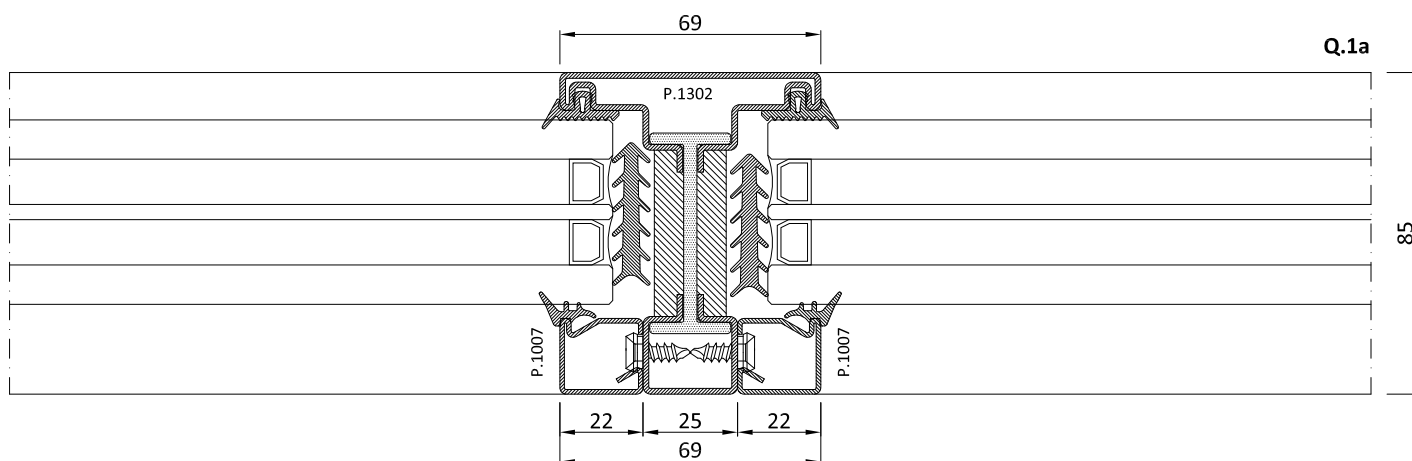
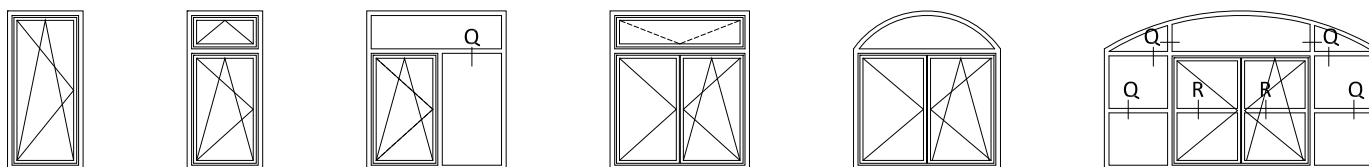


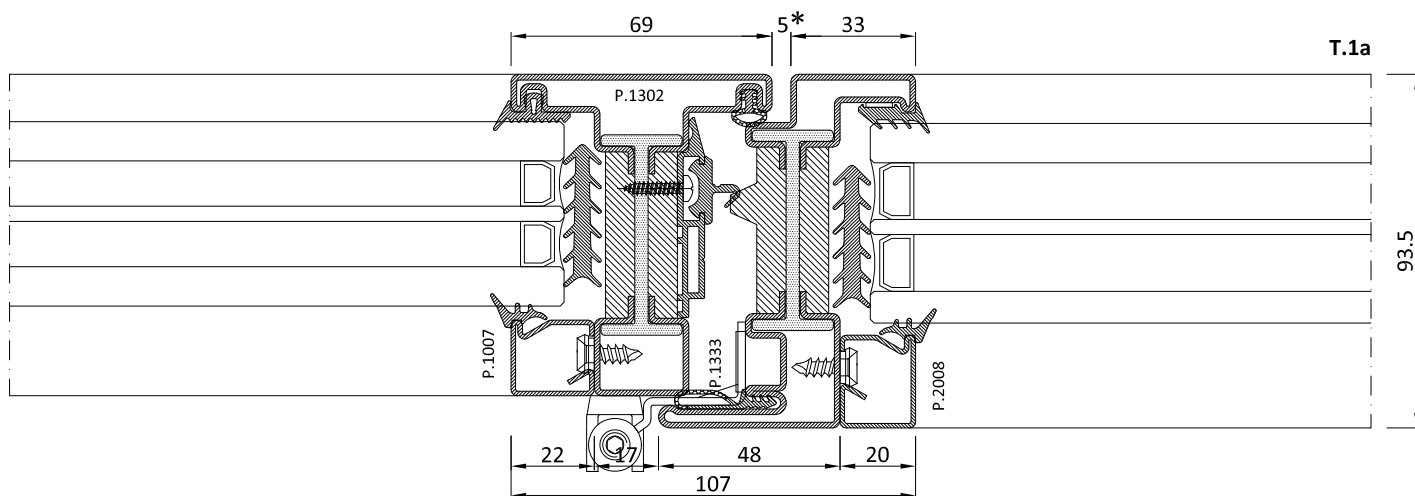
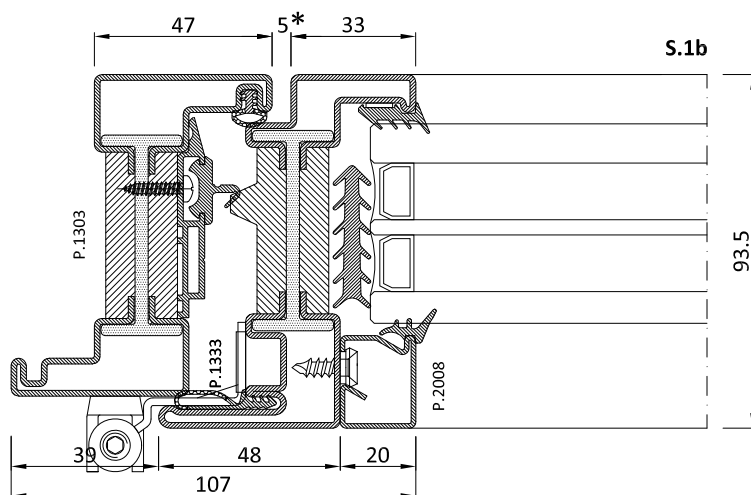
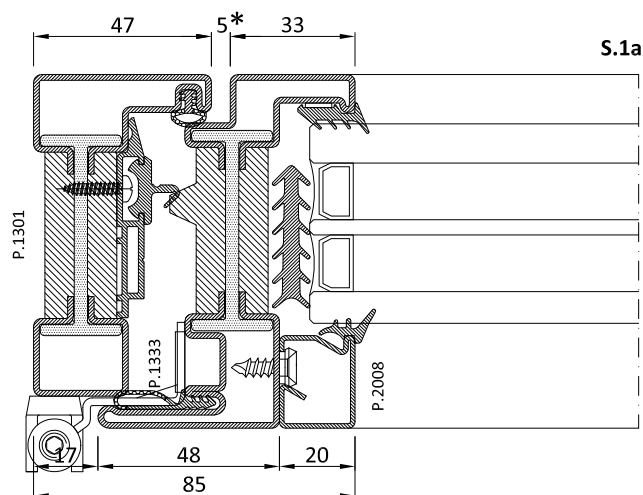
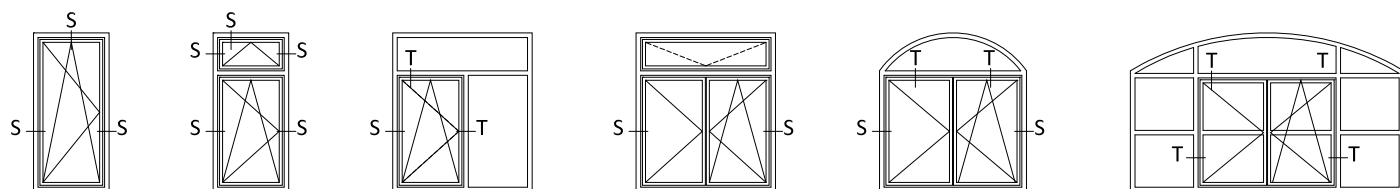


* Vedi tabella 4.1.5
* See chart 4.1.5

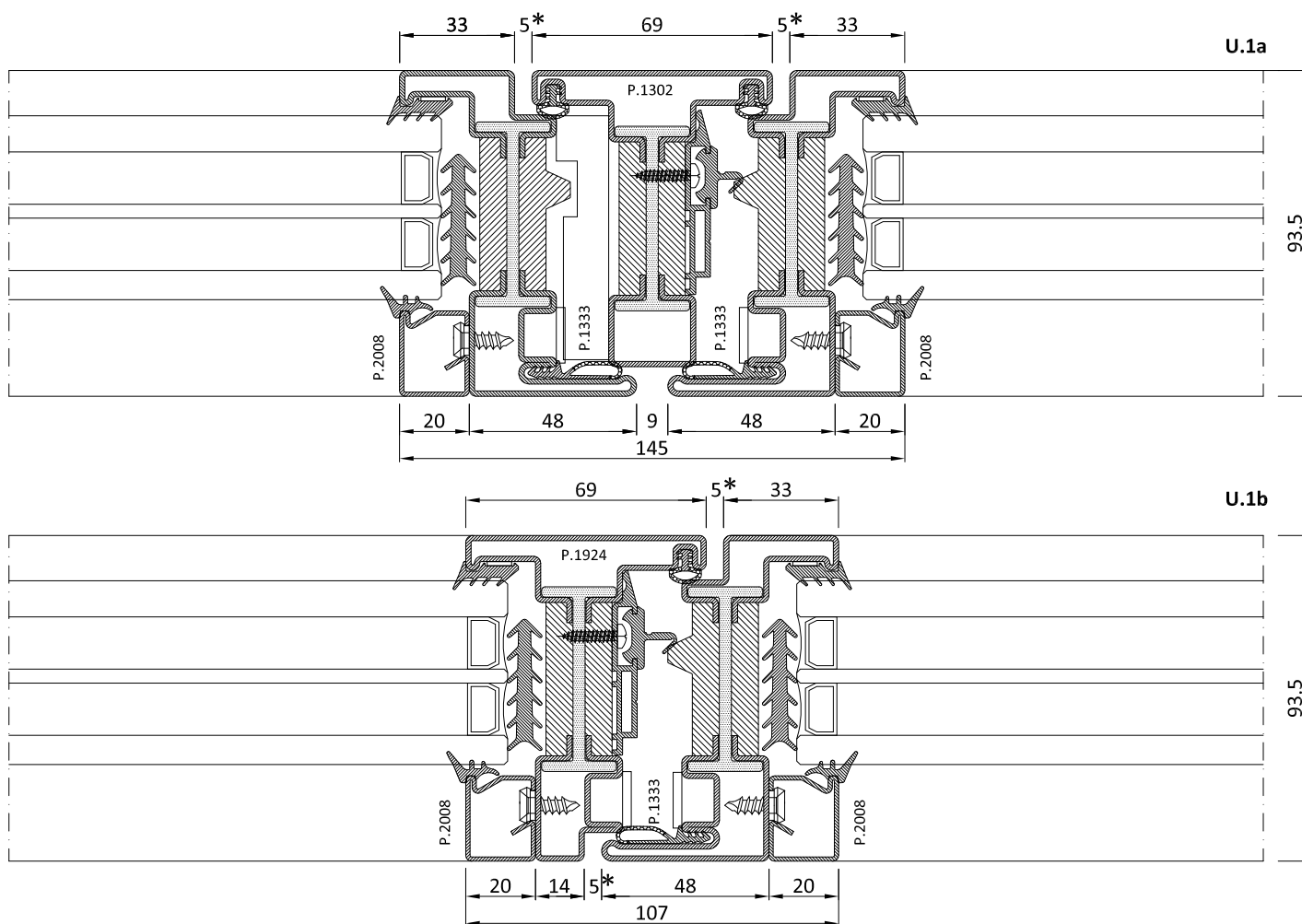
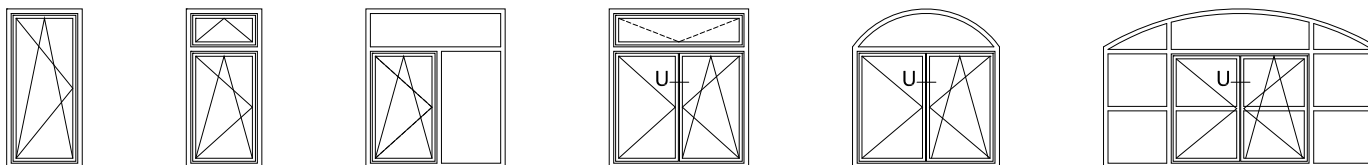




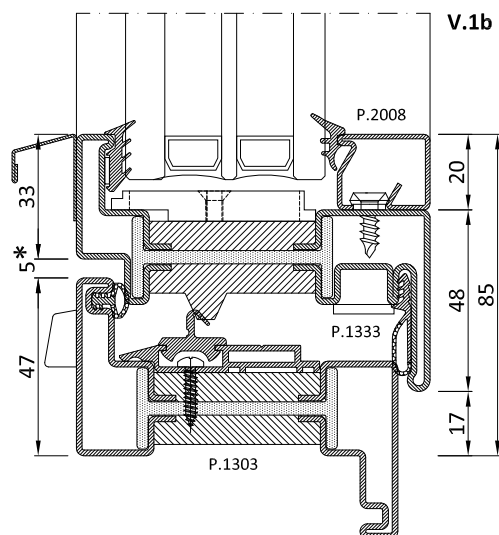
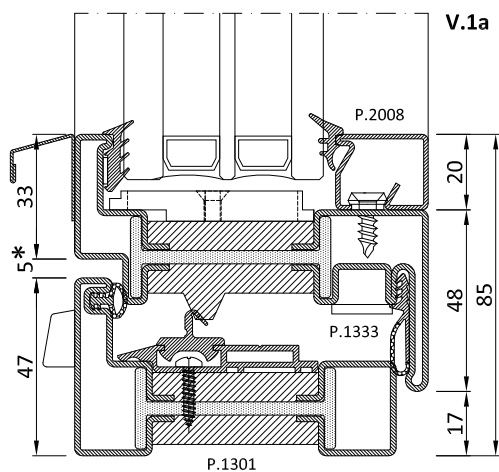
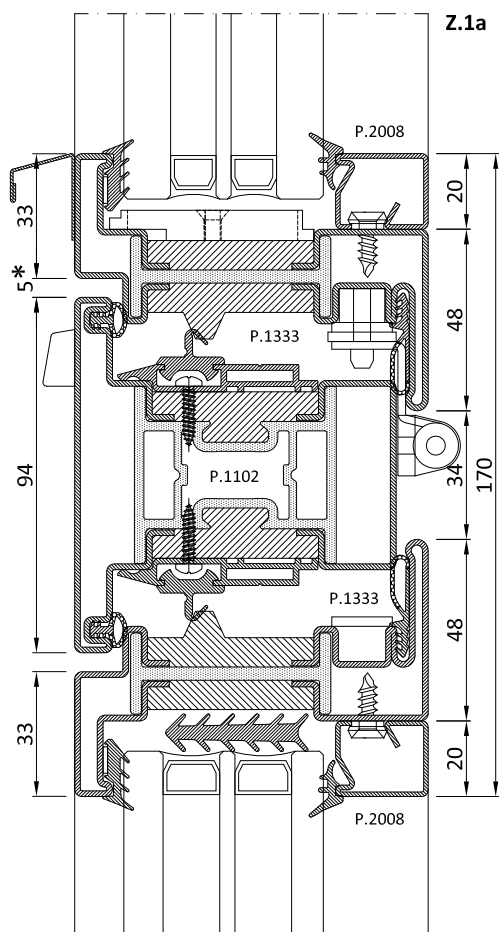
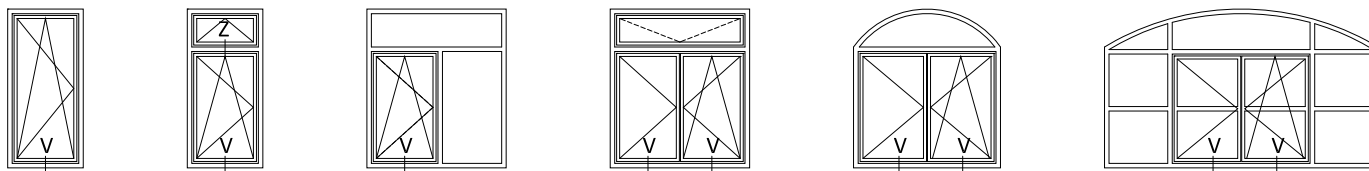




* Vedi tabella 4.1.5
* See chart 4.1.5

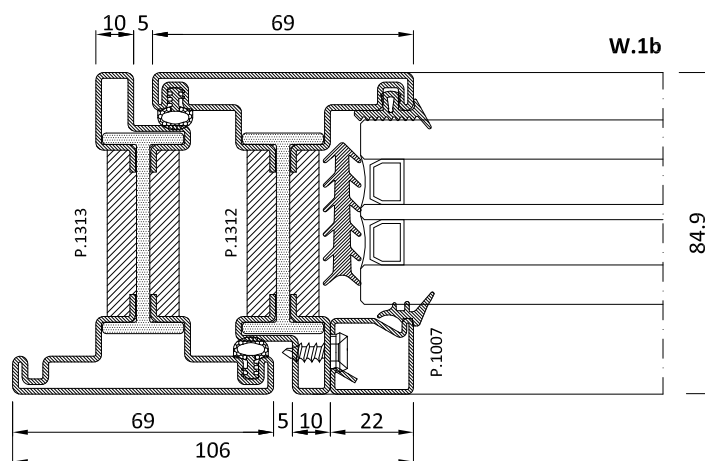
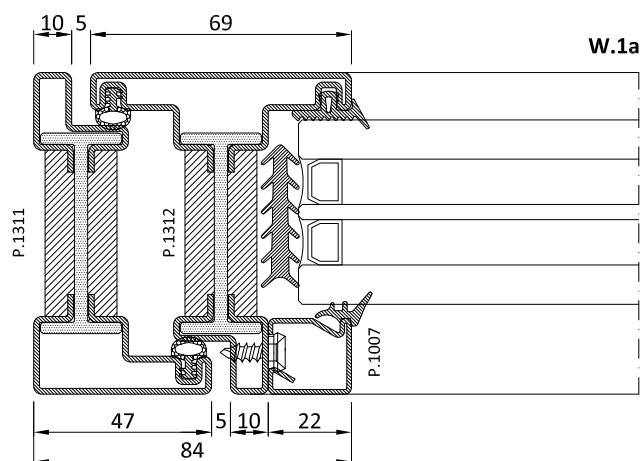
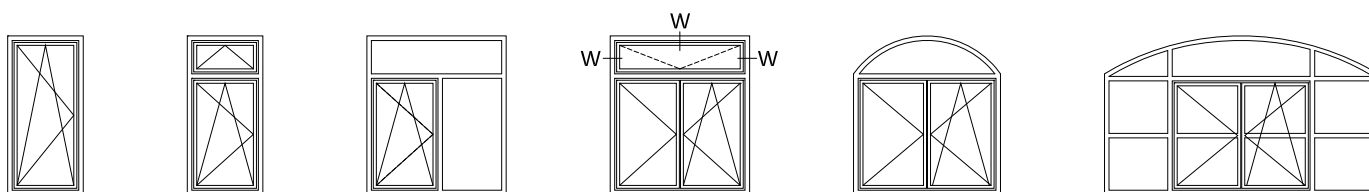


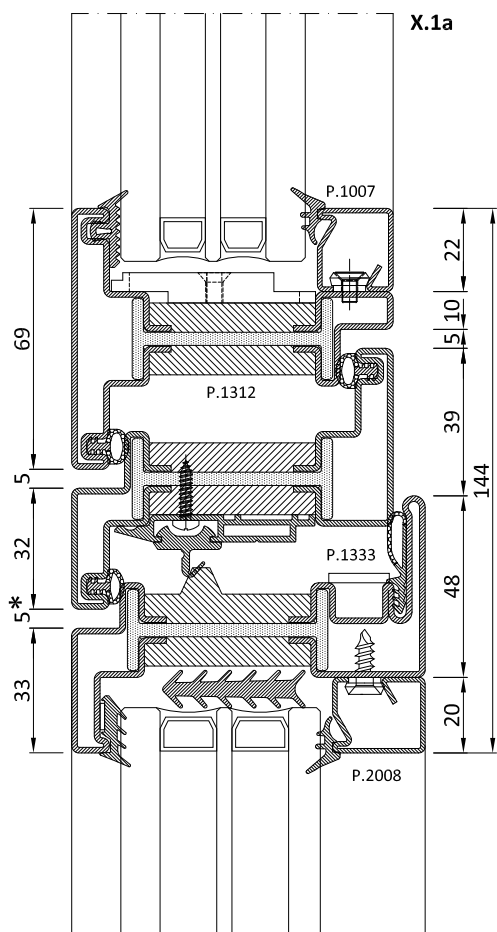
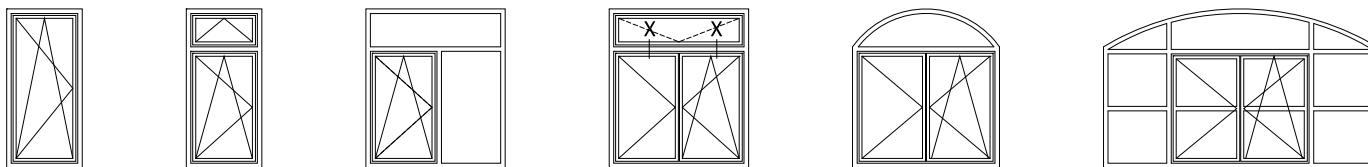
* Vedi tabella 4.1.5
* See chart 4.1.5



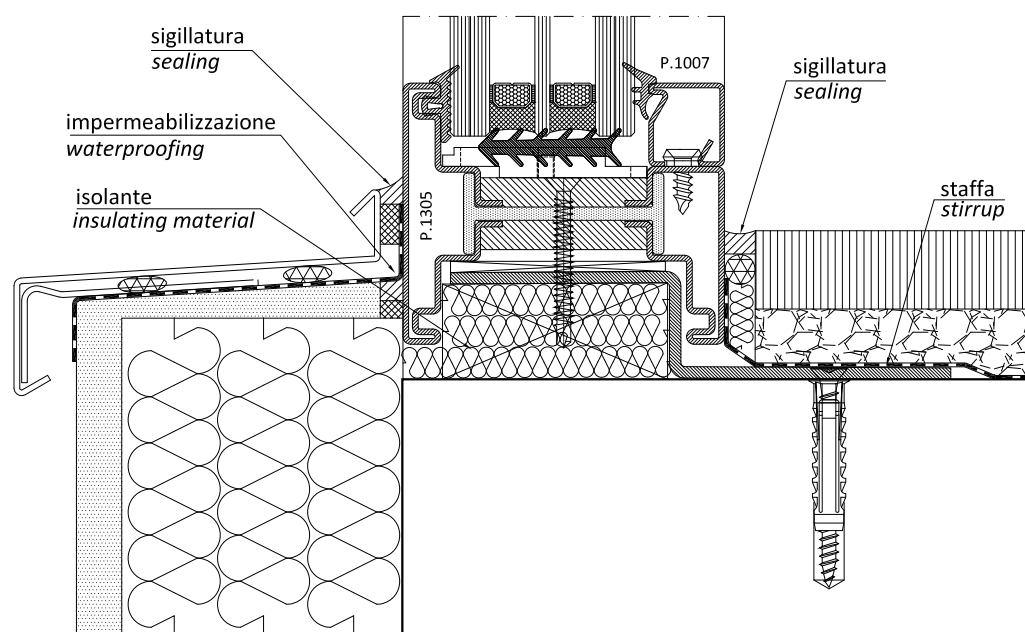
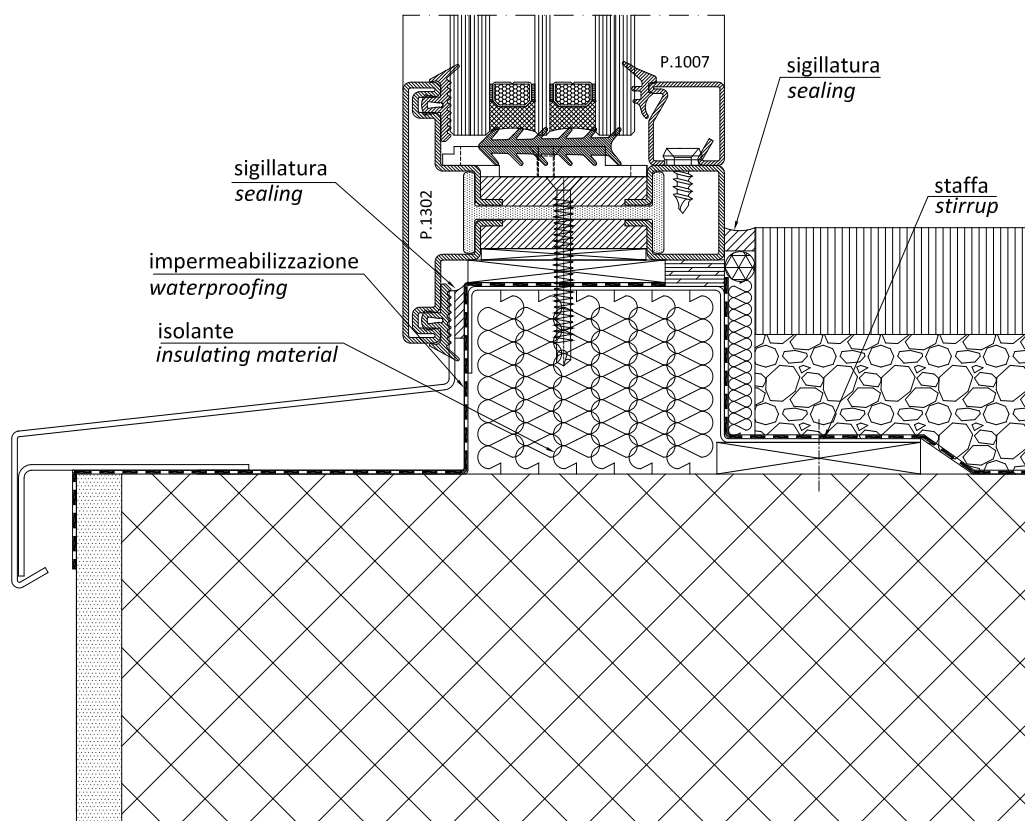
* Vedi tabella 4.1.5

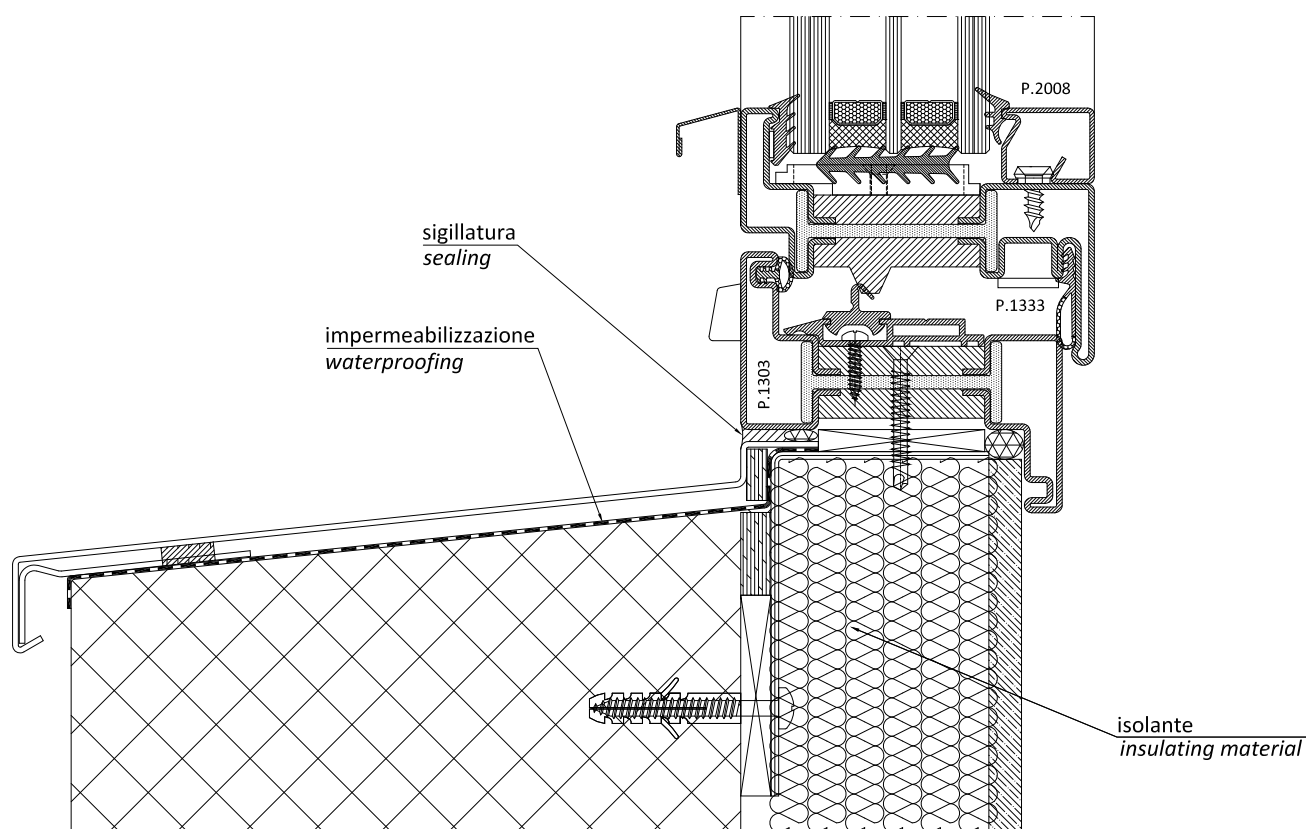
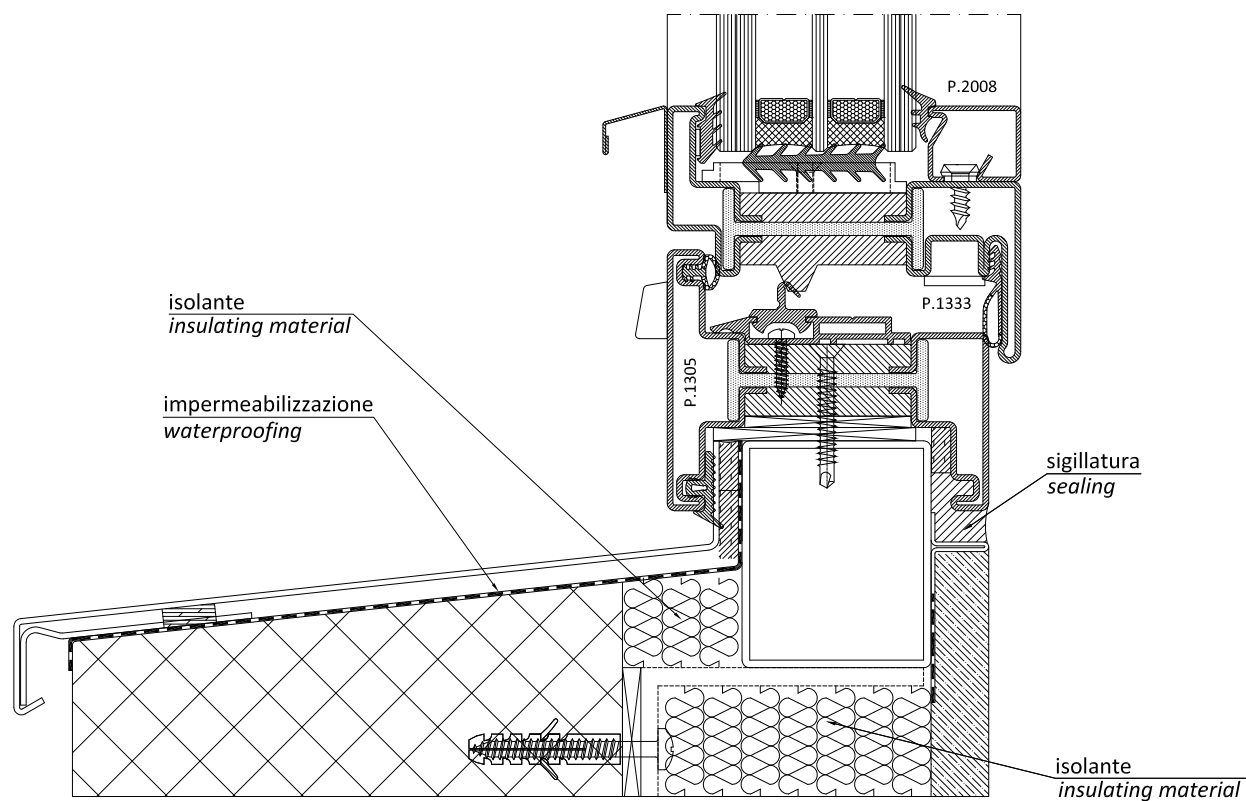
* See chart 4.1.5

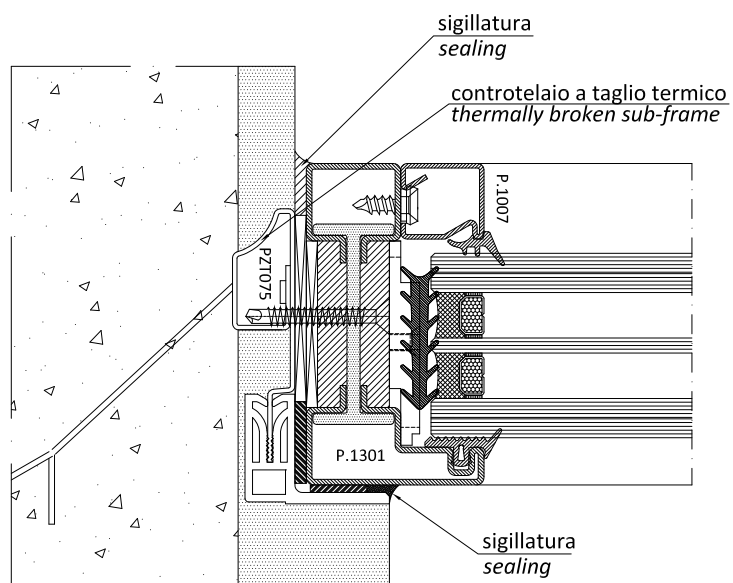
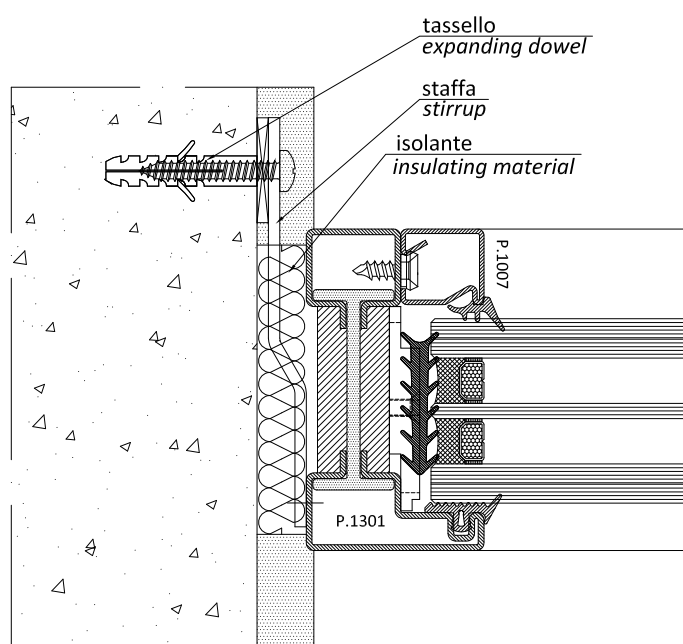
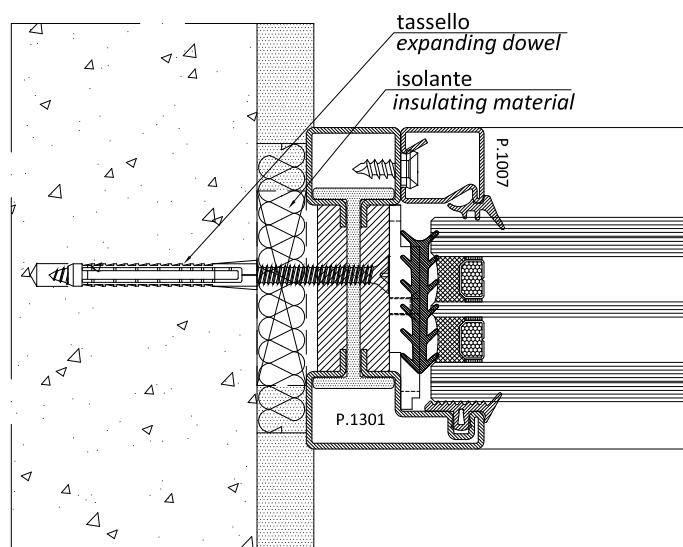


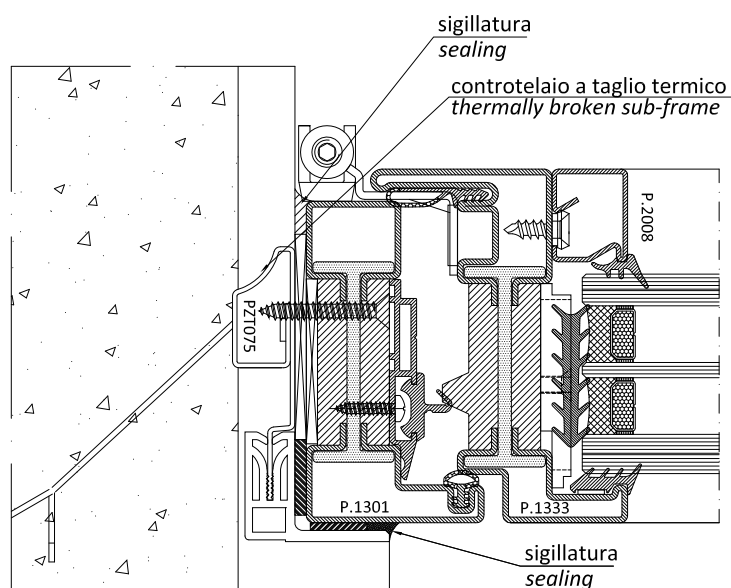
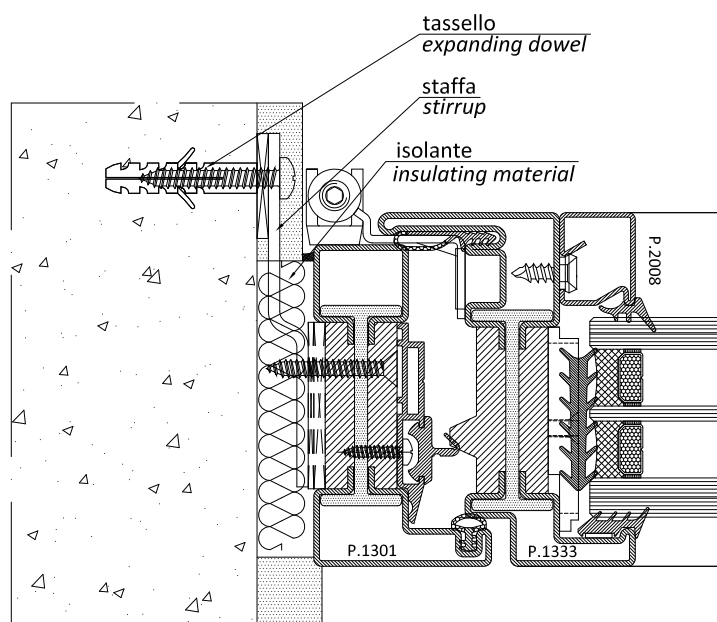
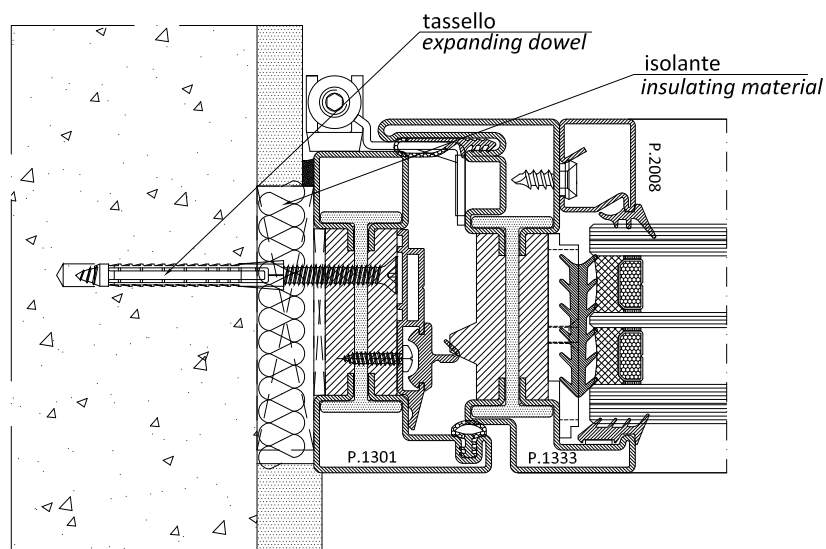


* Vedi tabella 4.1.5
* See chart 4.1.5

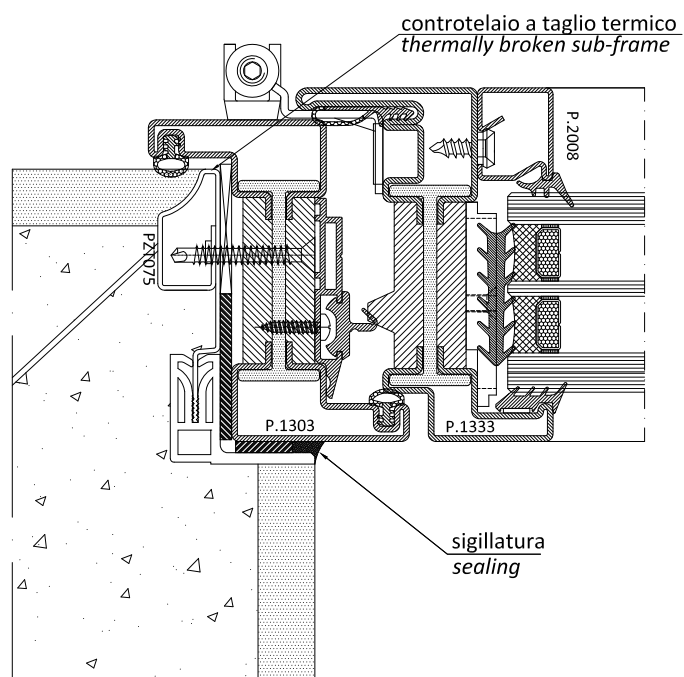
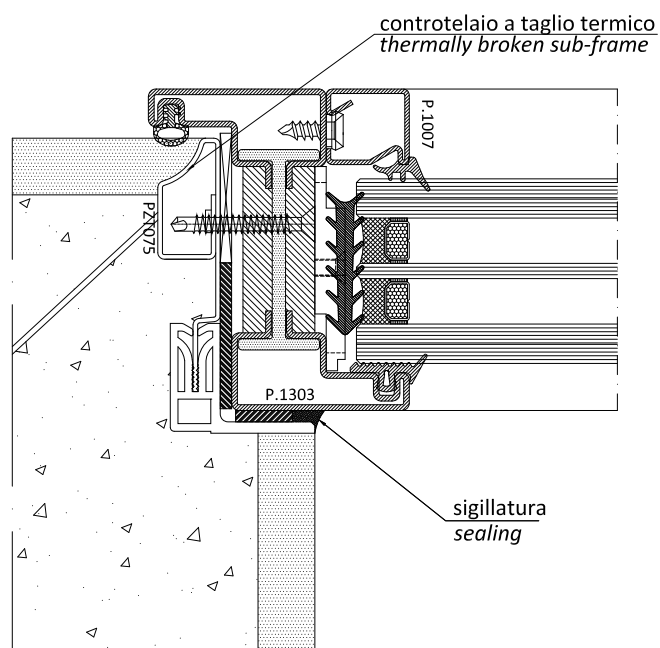








Applicare viti di fissaggio profilo a muro in corrispondenza dell'asse cerniere
Apply anchoring screws to the hinge axis



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

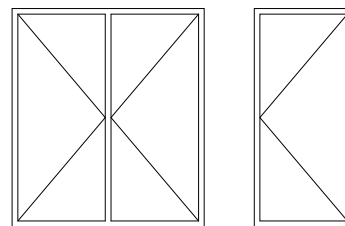
Distinta di taglio e lista componenti | Cutting list and components list

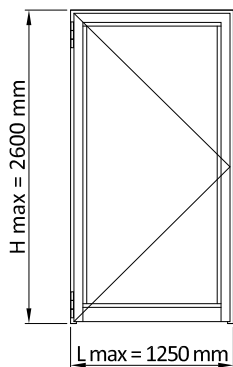
Le distinte di taglio e le liste accessori individuate per le diverse tipologie sono state redatte per un serramento tipo.

E' compito dei tecnici specializzati delle ditte produttrici analizzare criticamente tali indicazioni al fine di verificare la compatibilità del tipo e numero di accessori previsti con il serramento oggetto della commessa reale.

The cutting and hardware lists, which have been identified for the different typologies, have been produced for a standard window.

The specialized technicians of the window manufacturers will have to critically analyze such information in order to verify the compatibility of both the type and the number of accessories provided with the window object of the real order.

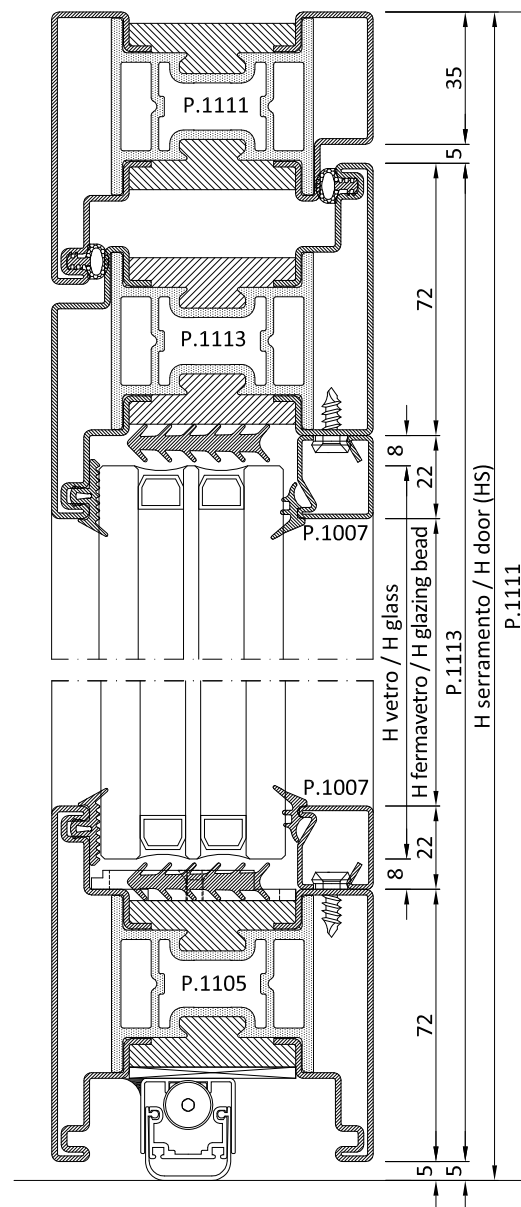




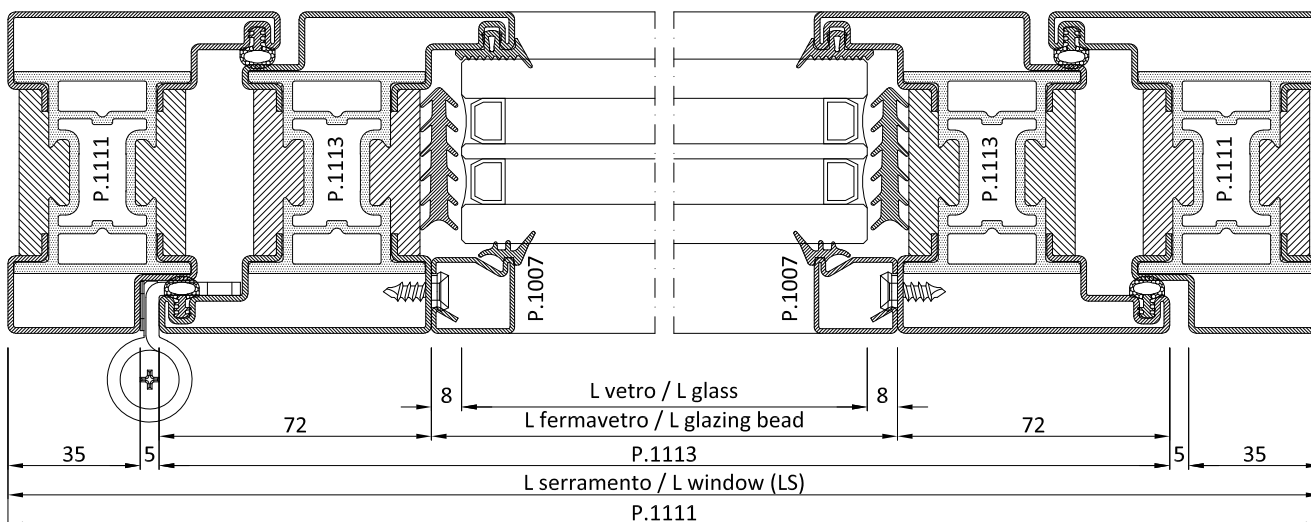
PROFILI		PROFILES			
Cod.	Descrizione	Description	n°	Dim.	Taglio Cutting
Telaio					
P.1111	Profilo a "L" telaio	"L" profile frame	1	LS	45° 45°
P.1111	Profilo a "L" telaio	"L" profile frame	1	HS	45° 90°
P.1111	Profilo a "L" telaio	"L" profile frame	1	HS	90° 45°
Anta					
P.1113	Profilo a "Z" anta	"Z" profile leaf	1	LS-80	45° 45°
P.1113	Profilo a "Z" anta	"Z" profile leaf	1	HS-45	45° 90°
P.1113	Profilo a "Z" anta	"Z" profile leaf	1	HS-45	90° 45°
P.1105	Profilo zoccolo	Socle profile	1	LS-224	90° 90°
Fermavetri					
P.1007	Fermavetro	Glazing bead profile	2	LS-224	90° 90°
P.1007	Fermavetro	Glazing bead profile	2	HS-233	90° 90°
Vetri					
-	Vetrocamera	Insulated glass	1	LS-240 x HS-205	

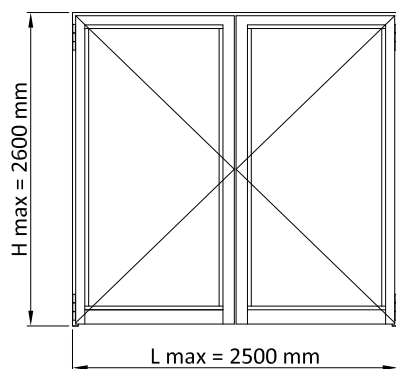
ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
AC1004I*	Kit squadrette per P.1111	Corner joint kit for P.1111	2
AC1007I*	Kit squadrette per P.1113	Corner joint kit for P.1113	2
AC1021*	Cavallotto per P.1105	Butt joint kit P.1105	2
AC1020 ..	Supporto spessore vetro	Glass support	6
AC1033 ..	Cerniera a stilo	Road hinges	Var.
AC1065/6/7..	Serratura multipunto	Multi-point lock	1
AC1081/..	Paraspiffero automatico	Authomatic door seal	1
ACV9...	Maniglia "Vitruvio"	"Vitruvio" handle	1
CV5001(i)	Vite per boccola fermavetro	Screw for glazing bead bushing	Var.
CV5012(i)	Boccola per fermavetro	Bushing for glazing bead	Var.

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

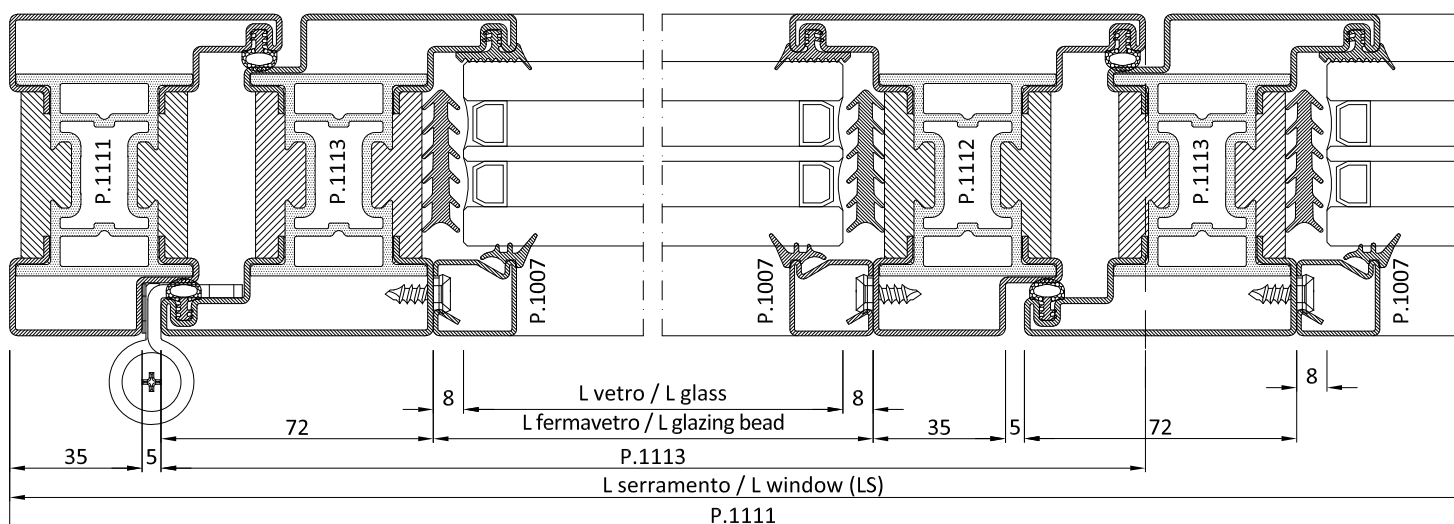


* solo con profili ottone
only with brass profiles





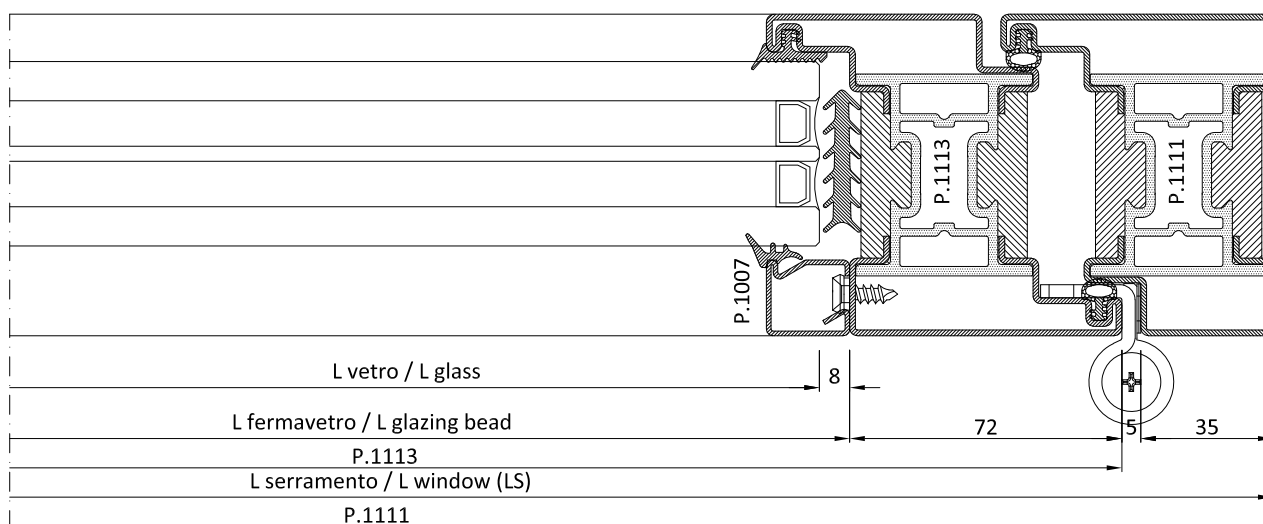
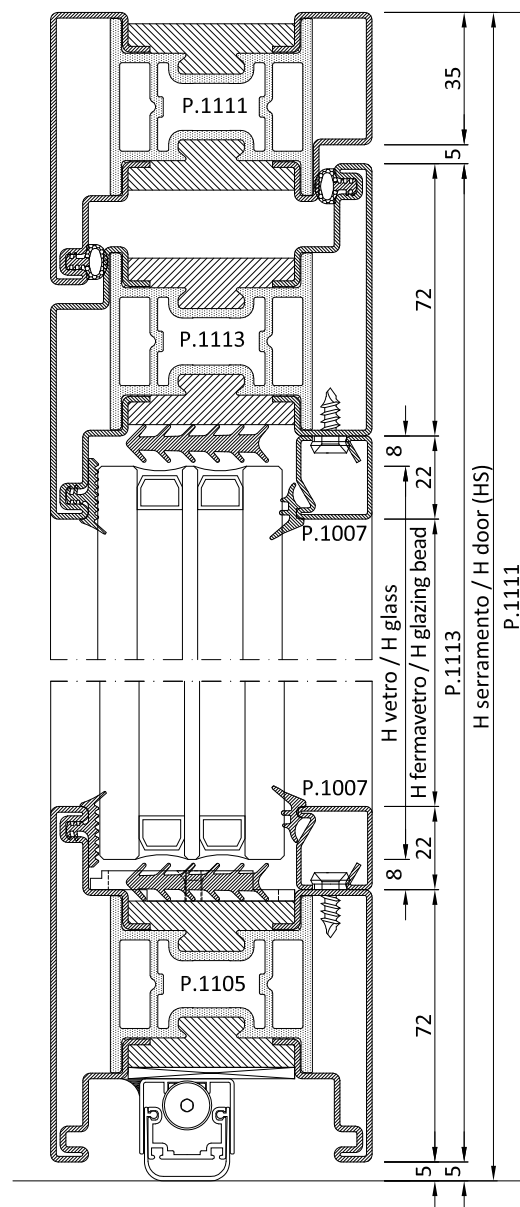
PROFILI		PROFILES				
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
Telaio		Frame				
P.1111	Profilo a "L" telaio	"L" profile frame	1	LS	45°	45°
P.1111	Profilo a "L" telaio	"L" profile frame	1	HS	45°	90°
P.1111	Profilo a "L" telaio	"L" profile frame	1	HS	90°	45°
Anta		Leaf				
P.1113	Profilo a "Z" anta	"Z" profile leaf	2	(LS-48)/2	45°	45°
P.1113	Profilo a "Z" anta	"Z" profile leaf	2	HS-45	45°	90°
P.1113	Profilo a "Z" anta	"Z" profile leaf	1	HS-45	90°	45°
P.1112	Profilo a "T" anta	"T" profile leaf	1	HS-45	90°	45°
P.1105	Profilo zoccolo	Socle profile	2	(LS-336)/2	90°	90°
Fermavetri		Glazing beads				
P.1007	Fermavetro	Glazing bead profile	4	(LS-336)/2	90°	90°
P.1007	Fermavetro	Glazing bead profile	4	HS-233	90°	90°
Vetri		Glass unit				
-	Vetrocamera	Insulated glass	2	(LS-368)/2 x HS-205		



ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
AC1004I*	Kit squadrette per P.1111	Corner joint kit for P.1111	2
AC1007I*	Kit squadrette per P.1113	Corner joint kit for P.1113	3
AC1008I*	Kit squadrette per P.1113-12	Corner joint kit for P.1113-12	1
AC1021*	Cavallotto per P.1105	Butt joint kit P.1105	4
AC1014	Fondino inversione battuta	Steel ending cap for reverting rebate	2
AC1020 ..	Supporto spessore vetro	Glass support	12
AC1033 ..	Cerniera a stilo	Road hinges	Var.
AC1040	Kit catenaccio 2^ anta	Kit for closing second leaf	1
AC1065/6/7..	Serratura multipunto	Multi-point lock	1
AC1081/..	Paraspiffero automatico	Authomatic door seal	2
ACV9...	Maniglia "Vitruvio"	"Vitruvio" handle	1
CV5001(i)	Vite per boccola fermavetro	Screw for glazing bead bushing	Var.
CV5012(i)	Boccola per fermavetro	Bushing for glazing bead	Var.

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

* solo con profili ottone
only with brass profiles



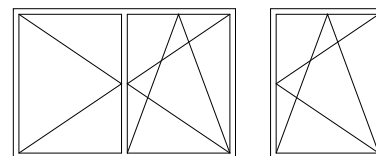
Distinta di taglio e lista componenti | Cutting list and components list

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

E' compito dei tecnici specializzati delle ditte produttrici analizzare criticamente tali indicazioni al fine di verificare la compatibilità del tipo e numero di accessori previsti con il serramento oggetto della commessa reale.

The cutting and hardware lists, which have been identified for the different typologies, have been produced for a standard window.

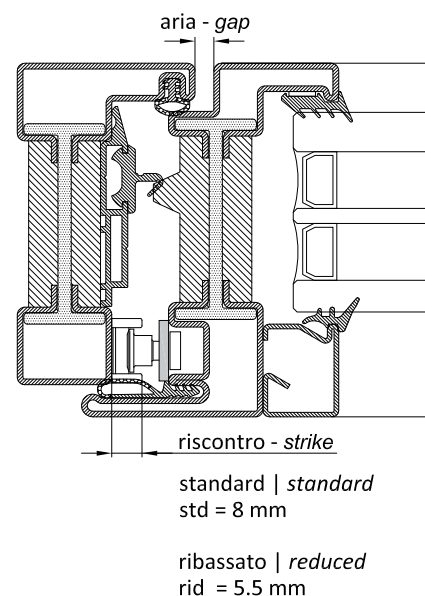
The specialized technicians of the window manufacturers will have to critically analyze such information in order to verify the compatibility of both the type and the number of accessories provided with the window object of the real order.

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

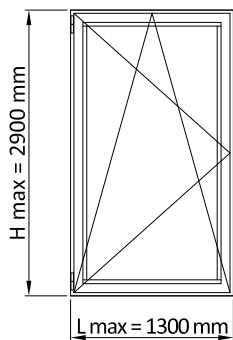
In essa è riportata la misura da considerare nella distanza tra telaio anta e telaio fisso nella produzione di finestre in funzione della tipologia, del tipo di cerniera e della larghezza delle ante da produrre.

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

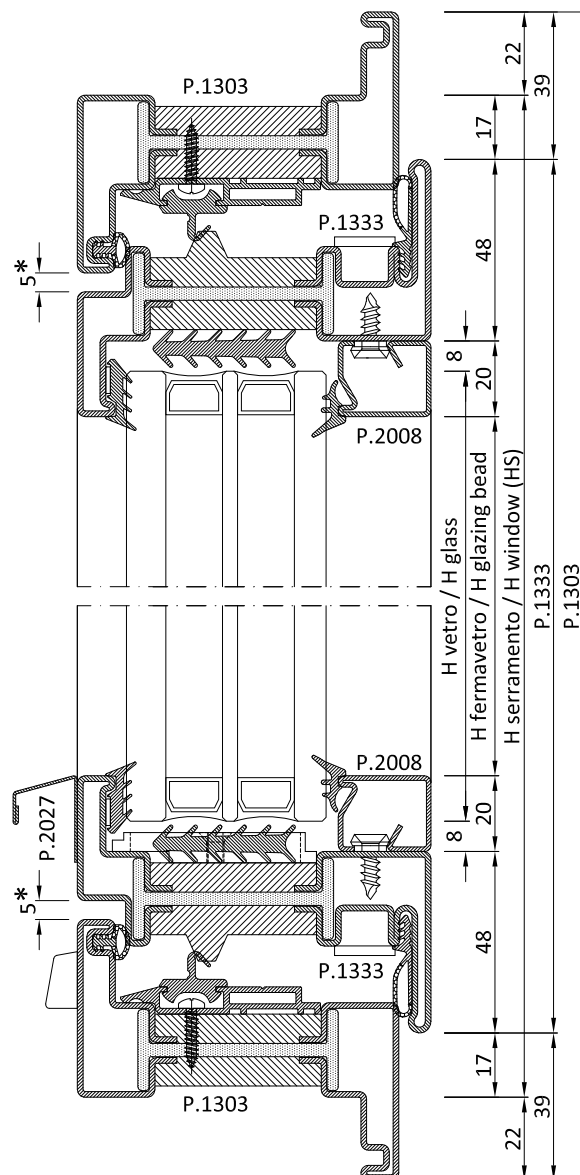
			larghezza anta (cava ferramenta in mm) leaf width (hardware slot in mm)				
			280 360	361 480	481 600	601 800	> 800
AR Easy DK Easy	AGE 271(2)	aria - gap	-	6	6	5,5	5
	AGE 271(2)-276(5)						
	AGE 291(2)	riscontro - strike	-	rid	rid	std	std
	AGE 291(2)-296(5)						
	AGE 281(2)	aria - gap	-	5,5	5,5	5,5	5,5
	AGE 281(2)-286(5)						
	AGE 281(2)-786(5)	riscontro - strike	-	rid	std	std	std
	AGE 271(2)-776(5)	aria - gap	-	6	6	6	5,5
	AGE 291(2)-796(5)	riscontro - strike	-	rid	rid	std	std
AR RC2 DK RC2	AG 1273	aria - gap	-	6	6	5,5	5
	AG 1278	riscontro - strike	-	rid	rid	std	std
	AG 1271(2)	aria - gap	-	-	6	5,5	5
	AG 1271(2)-1276(5)						
	AG 1291(2)	riscontro - strike	-	-	std	std	std
Anta Casement	AG 1291(2)-1296(5)						
	AG 1281(2)	aria - gap	-	-	6	6	5,5
	AG 1281(2)-1286(5)	riscontro - strike	-	-	std	std	std
Anta Casement	AGA 271	aria - gap	-	6	6	5,5	5
	AGA 271-275						
	AGA 271-775	riscontro - strike	-	rid	rid	std	std
Anta Casement	AGA 271-775	aria - gap	-	6	6	6	5,5
		riscontro - strike	-	rid	rid	std	std



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

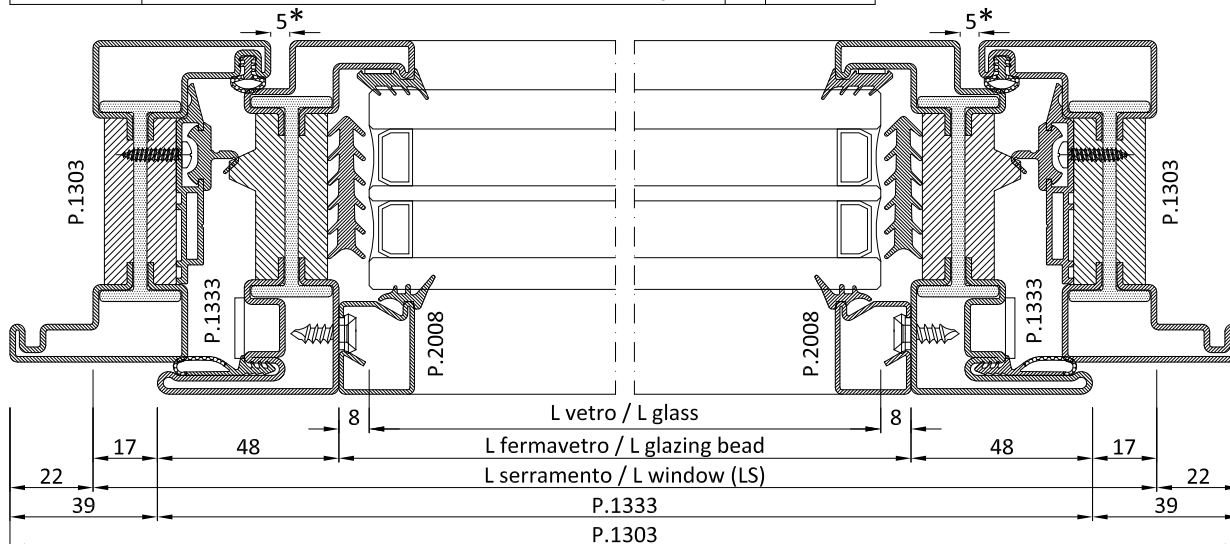


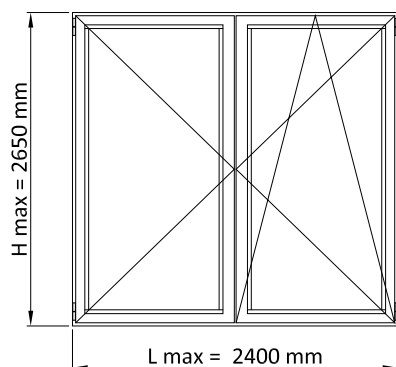
PROFILI		PROFILES				
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
Telaio		Frame				
P.1303	Profilo a "Z" telaio	"Z" profile frame	2	LS+44	45°	45°
P.1303	Profilo a "Z" telaio	"Z" profile frame	2	HS+44	45°	45°
Anta		Leaf				
P.1333	Profilo a "Z" anta	"Z" profile frame	2	LS-34	45°	45°
P.1333	Profilo a "Z" anta	"Z" profile frame	2	HS-34	45°	45°
P.2027	Profilo battiacqua	Water drip profile	2	LS-104	90°	90°
Fermavetri		Glazing beads				
P.2008	Fermavetro	Glazing bead profile	2	LS-130	90°	90°
P.2008	Fermavetro	Glazing bead profile	2	HS-170	90°	90°
Vetri		Glass unit				
-	Vetrocamera	Insulated glass	1	LS-146 x HS-146		
ACCESSORI		HARDWARE				
Cod.	Descrizione	Description	n°			
AC1203I**	Kit squadrette per P.1203	Corner joint kit for P.1203	4			
AC1207I**	Kit squadrette per P.1233	Corner joint kit for P.1233	4			
AC1716	Guarnizione d'angolo	Vulcanised corner gasket	4			
AC1219	Scarico acqua	Water drip	Var.			
AGE271/2..	Meccanismo Anta Ribalta	Tilt and Turn mechanism	1			
AG1271/C	Kit copertine plastica	Kit of RH plastic	1			
ACV97..	Maniglia "Vitruvio"	"Vitruvio" handle	1			
AC1356	Meccanismo DK	External tilt & turn mechanism	1			
AC1020	Supporto spessore vetro	Glass support	6			
CV5001(i)	Vite per boccola fermavetro	Screw for glazing bead bushing	Var.			
CV5012(i)	Boccola per fermavetro	Bushing for glazing bead	Var.			
GUARNIZIONI		GASKETS				
Cod.	Descrizione	Description	n°	Dim.		
GE1233TT	Guarnizione esterna di battuta	External rebating gasket	1	2xLS+2xHS		
GE1701	Guarnizione giunto aperto	Open joint system gasket	1	2xLS+2xHS		
GU1302	Estruso PVC giunto aperto	Open joint systemPVC profile	1	2xLS+2xHS		
GE1200TT	Guarnizione interna di battuta	Internal rebating gasket	1	2xLS+2xHS		
GE1206	Guarnizione esterna vetro	External gasket	1	2xLS+2xHS		
GE1007TT	Guarnizione sottovetro	Gasket to put under the glass	1	2xLS+2xHS		
GE..	Guarnizione interna vetro	Internal gasket	1	2xLS+2xHS		



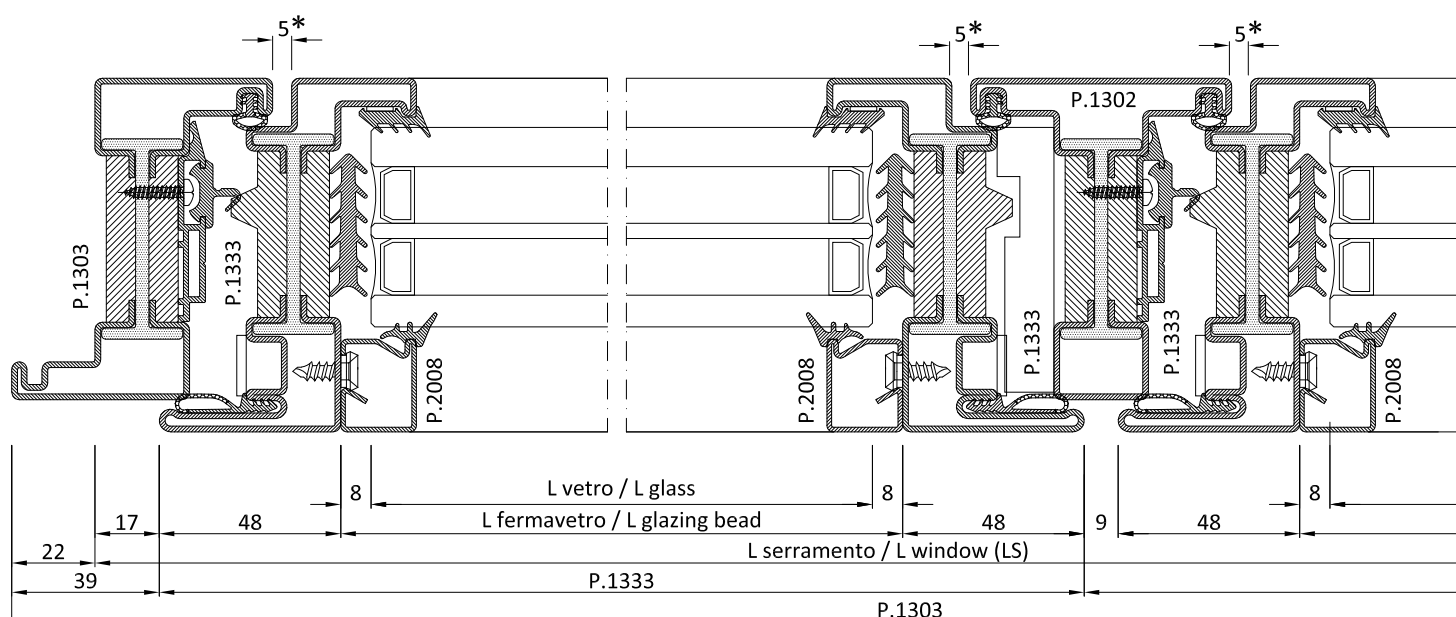
* vedi tabella 4.1.5
see chart 4.1.5

** solo con profili ottone
only with brass profiles





PROFILI		PROFILES				
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
Telaio		Frame				
P.1303	Profilo a "Z" telaio	"Z" profile frame	2	LS+44	45°	45°
P.1303	Profilo a "Z" telaio	"Z" profile frame	2	HS+44	45°	45°
Anta		Leaf				
P.1333	Profilo a "Z" anta	"Z" profile frame	4	(LS-43)/2	45°	45°
P.1333	Profilo a "Z" anta	"Z" profile frame	4	HS-34	45°	45°
P.1302	Profilo a "T" anta	"T" profile frame	1	HS-82.5	90°	90°
P.2027	Profilo battiacqua	Water drip profile	2	(LS-183)/2	90°	90°
Fermavetri		Glazing beads				
P.2008	Fermavetro	Glazing bead profile	4	(LS-235)/2	90°	90°
P.2008	Fermavetro	Glazing bead profile	4	HS-170	90°	90°
Vetri		Glass unit				
-	Vetrocamera	Insulated glass	2	[(LS-267)/2] x HS-146		

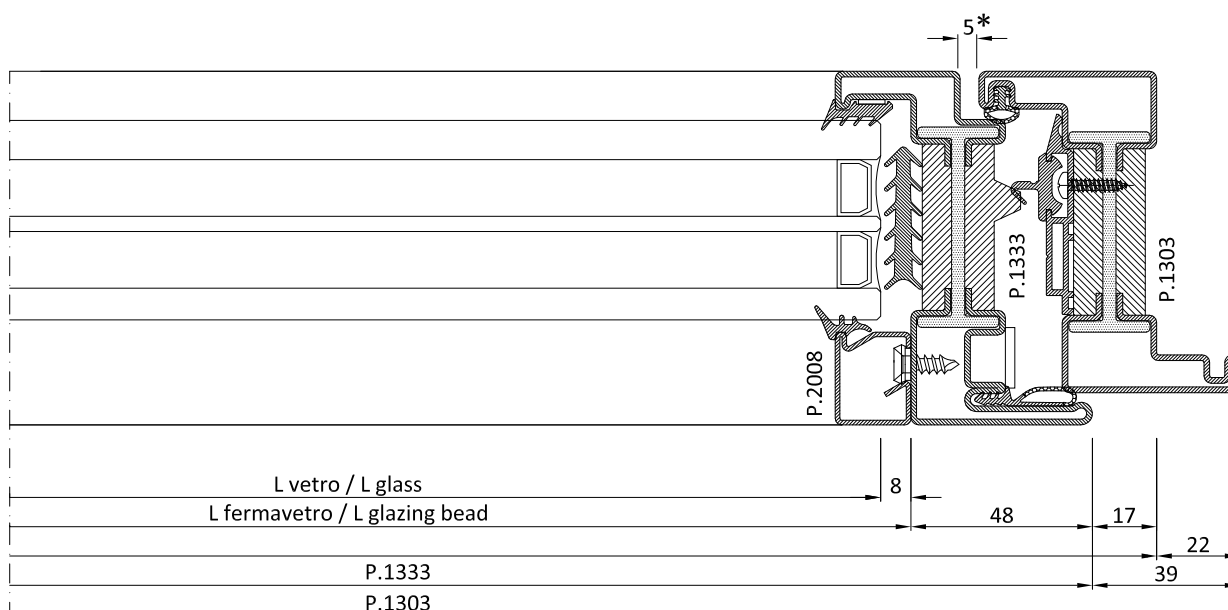
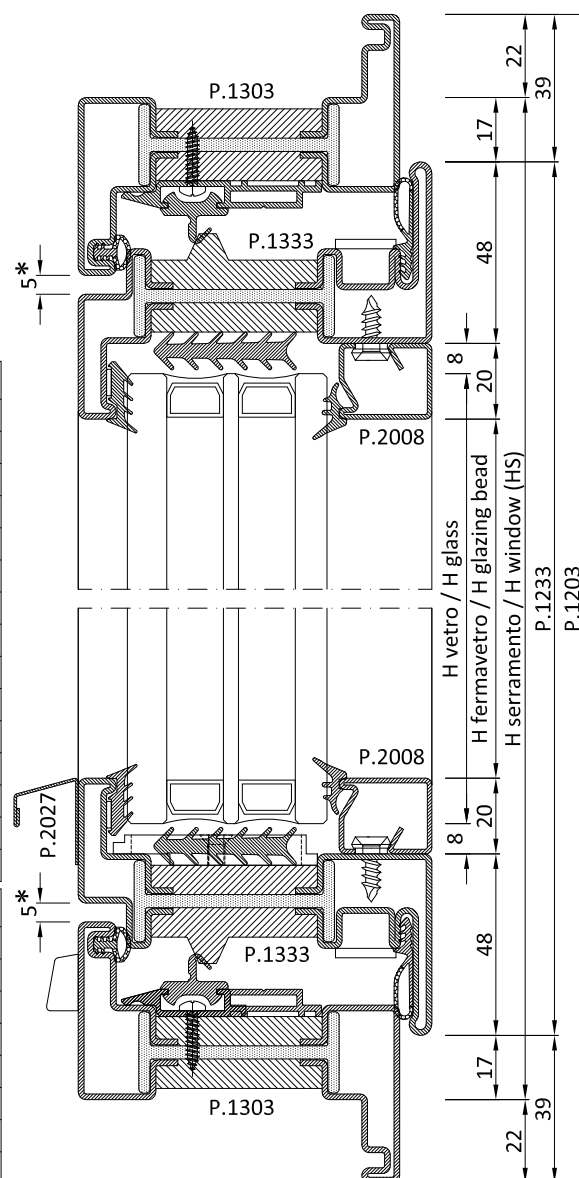


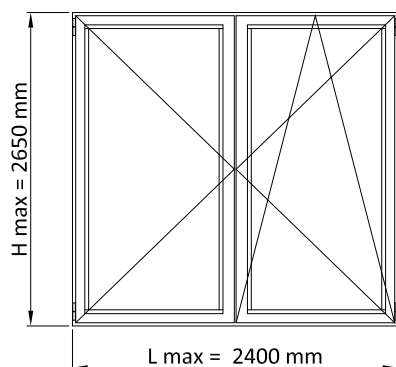
ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
AC1203I**	Kit squadrette per P.1303	Corner joint kit for P.1303	4
AC1207I**	Kit squadrette per P.1333	Corner joint kit for P.1333	8
AC1716	Guarnizione d'angolo	Vulcanised corner gasket	4
AC1219	Scarico acqua	Water drip	Var.
AC1355	Kit inversione battuta 2^ anta	2nd leaf reverse closure kit	2
AGE271/2..	Meccanismo Anta Ribalta 1^ anta	1st leaf tilt/turn mechanism	1
AGE275/6..	Meccanismo Anta Ribalta 2^ anta	2nd leaf tilt/turn mechanism	1
AG1271/C	Kit copertine plastica - dx	Kit of RH plastic - right	1
AG1272/C	Kit copertine plastica - sx	Kit of RH plastic - left	1
ACV97..	Maniglia "Vitruvio"	"Vitruvio" handle	1
AC1356	Meccanismo DK	External tilt & turn mechanism	1
AC1020	Supporto spessore vetro	Glass support	12
CV5001(i)	Vite per boccola fermavetro	Screw for glazing bead bushing	Var.
CV5012(i)	Boccola per fermavetro	Bushing for glazing bead	Var.

GUARNIZIONI		GASKETS	
Cod.	Descrizione	Description	n° Dim.
GE1233TT	Guarnizione esterna di battuta	External rebating gasket	1 2xLS+4xHS
GE1701	Guarnizione giunto aperto	Open joint system gasket	1 2xLS+3xHS
GU1302	Estruso PVC giunto aperto	Open joint system PVC profile	1 2xLS+3xHS
GE1200TT	Guarnizione interna di battuta	Internal rebating gasket	1 2xLS+4xHS
GE1206	Guarnizione esterna vetro	External gasket	1 2xLS+4xHS
GE1007TT	Guarnizione sottovetro	Gasket to put under the glass	1 2xLS+4xHS
GE..	Guarnizione interna vetro	Internal gasket	1 2xLS+4xHS

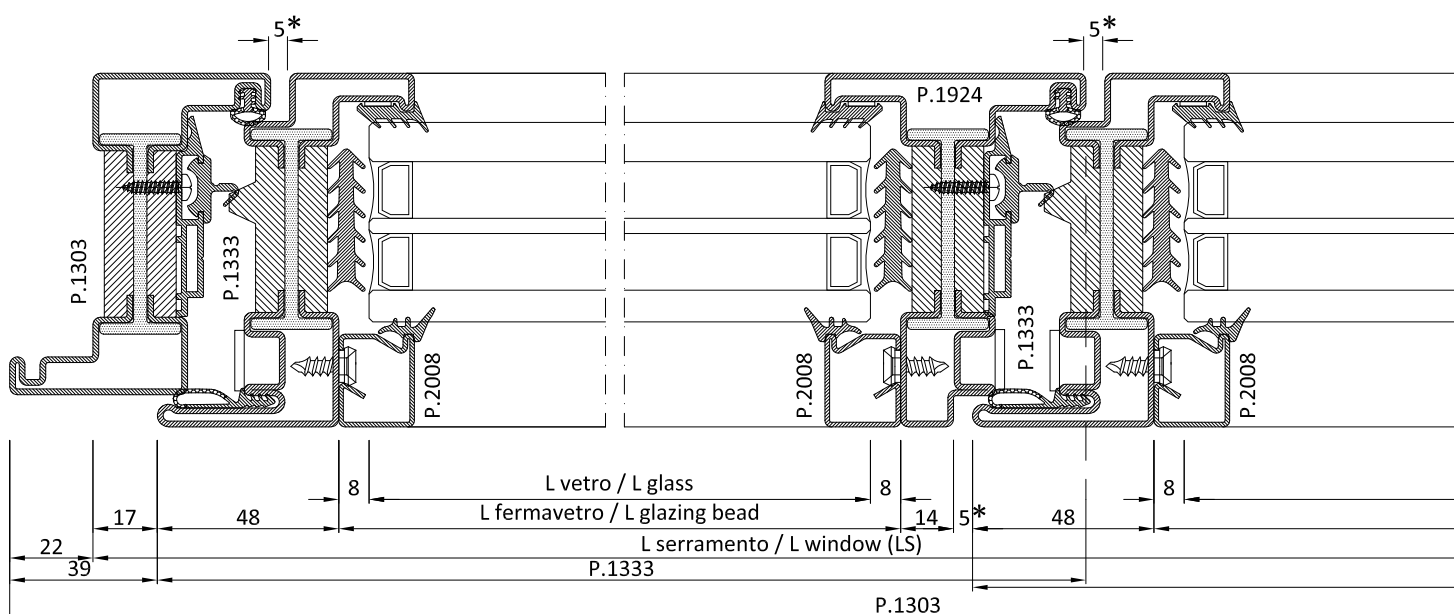
* vedi tabella 4.1.5
see chart 4.1.5

** solo con profili ottone
only with brass profiles





PROFILI		PROFILES				
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
Telaio		Frame				
P.1303	Profilo a "Z" telaio	"Z" profile frame	2	LS+44	45°	45°
P.1303	Profilo a "Z" telaio	"Z" profile frame	2	HS+44	45°	45°
Anta		Leaf				
P.1333	Profilo a "Z" anta	"Z" profile frame	4	(LS-5)/2	45°	45°
P.1333	Profilo a "Z" anta	"Z" profile frame	3	HS-34	45°	45°
P.1924	Profilo a "T" anta	"T" profile frame	1	HS-32	45°	45°
P.2027	Profilo battiacqua	Water drip profile	1	(LS-75)/2	90°	90°
P.2027	Profilo battiacqua	Water drip profile	2	(LS-143)/2	90°	90°
Fermavetri		Glazing beads				
P.2008	Fermavetro	Glazing bead profile	4	(LS-197)/2	90°	90°
P.2008	Fermavetro	Glazing bead profile	4	HS-170	90°	90°
Vetri		Glass unit				
-	Vetrocamera	Insulated glass	2	[(LS-229)/2] x HS-146		

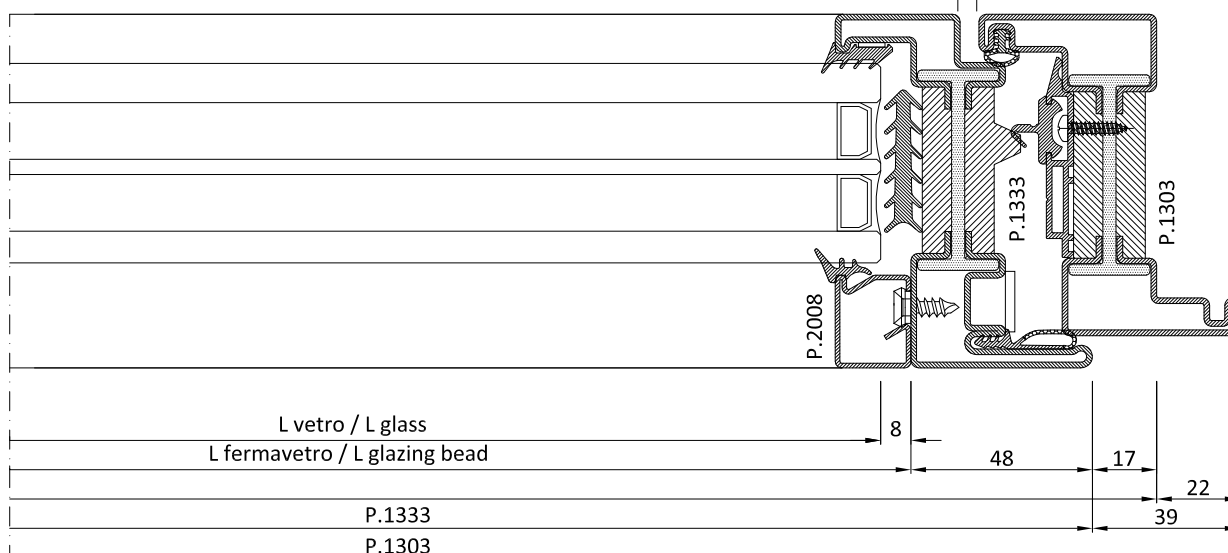
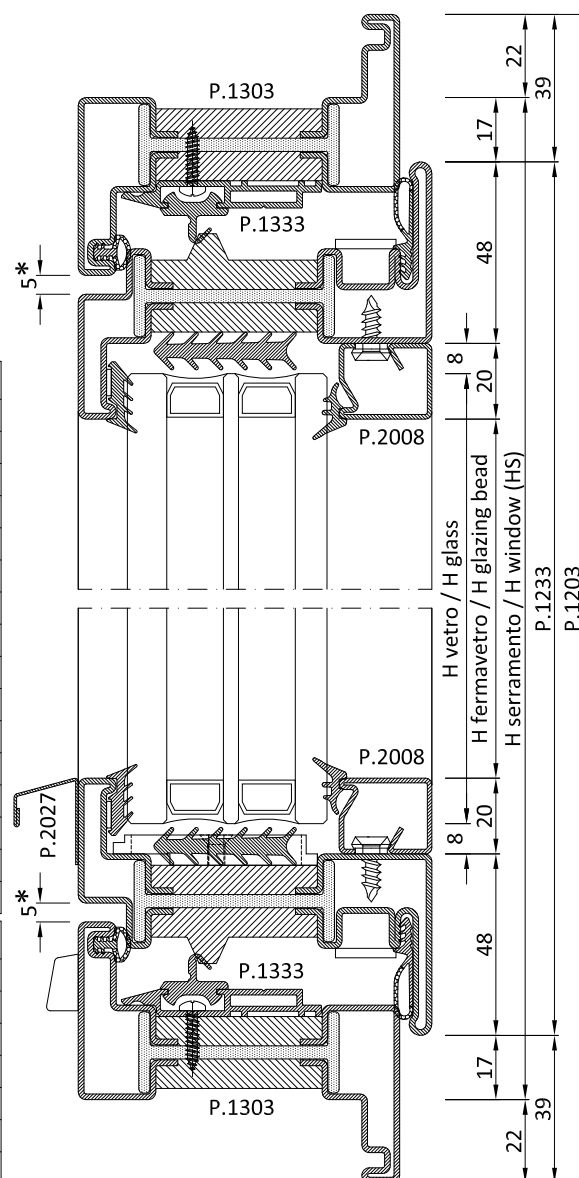


ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
AC1203I**	Kit squadrette per P.1303	Corner joint kit for P.1303	4
AC1207I**	Kit squadrette per P.1333	Corner joint kit for P.1333	6
AC1708I**	Kit squadrette per P.1333-1924	Corner joint kit for P.1333-1924	2
AC1716	Guarnizione d'angolo	Vulcanised corner gasket	4
AC1219	Scarico acqua	Water drip	Var.
AC1714	Kit inversione battuta 2^ anta	2nd leaf reverse closure kit	1
AGE271/2..	Meccanismo Anta Ribalta 1^ anta	1st leaf tilt/turn mechanism	1
AGE775/6..	Meccanismo Anta Ribalta 2^ anta	2nd leaf tilt/turn mechanism	1
AG1271/C	Kit copertine plastica - dx	Kit of RH plastic - right	1
AG1272/C	Kit copertine plastica - dx	Kit of RH plastic - left	1
ACV97..	Maniglia "Vitruvio"	"Vitruvio" handle	1
AC1356	Meccanismo DK	External tilt & turn mechanism	1
AC1020	Supporto spessore vetro	Glass support	12
CV5001(i)	Vite per boccola fermavetro	Screw for glazing bead bushing	Var.
CV5012(i)	Boccola per fermavetro	Bushing for glazing bead	Var.

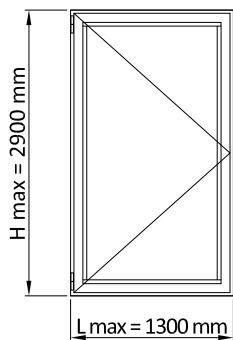
GUARNIZIONI			GASKETS	
Cod.	Descrizione	Description	n°	Dim.
GE1233TT	Guarnizione esterna di battuta	External rebating gasket	1	2xLS+3xHS
GE1701	Guarnizione giunto aperto	Open joint system gasket	1	2xLS+3xHS
GE1704	Guarnizione giunto aperto P.1924	Open joint system gasket P.1924	1	1xHS
GU1302	Estruso PVC giunto aperto	Open joint systemPVC profile	1	2xLS+3xHS
GE1200TT	Guarnizione interna di battuta	Internal rebating gasket	1	2xLS+3xHS
GE1206	Guarnizione esterna vetro	External gasket	1	2xLS+4xHS
GE1007TT	Guarnizione sottovetro	Gasket to put under the glass	1	2xLS+4xHS
GE..	Guarnizione interna vetro	Internal gasket	1	2xLS+4xHS

* vedi tabella 4.1.5
see chart 4.1.5

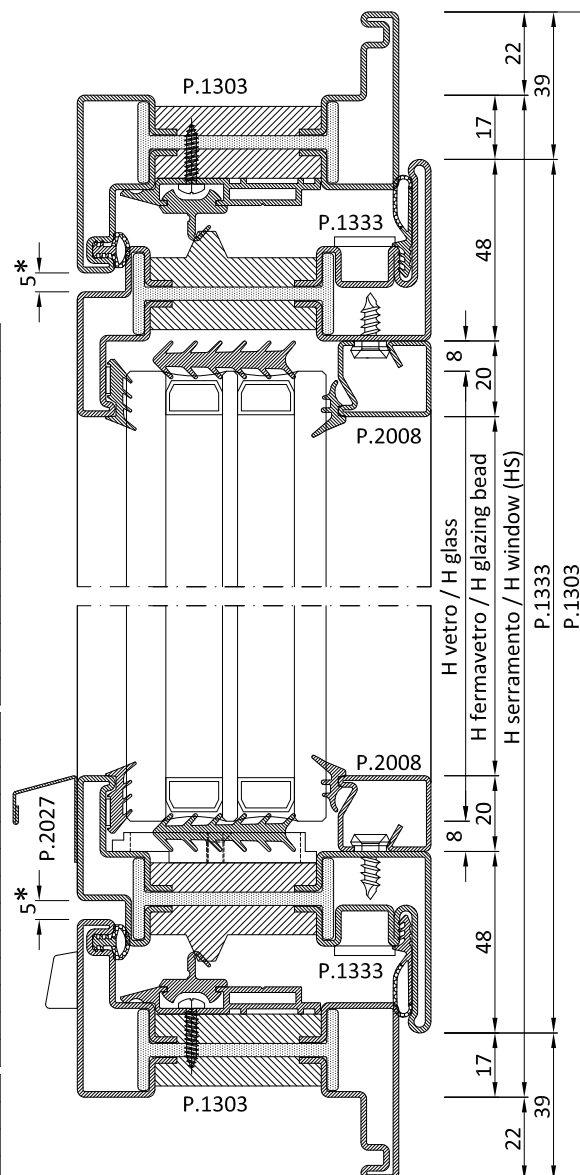
** solo con profili ottone
only with brass profiles



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

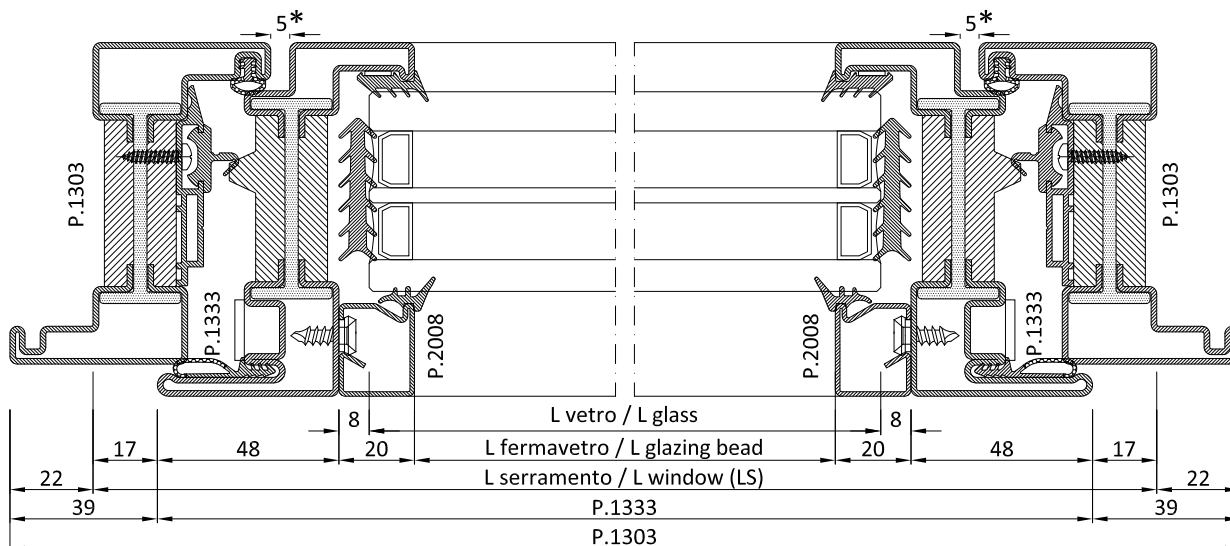


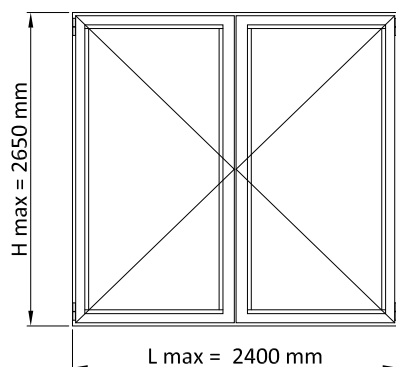
PROFILI		PROFILES				
Cod.	Descrizione	Description	n°	Dim.	Taglio Cutting	
Telaio		Frame				
P.1303	Profilo a "Z" telaio	"Z" profile frame	2	LS+44	45°	45°
P.1303	Profilo a "Z" telaio	"Z" profile frame	2	HS+44	45°	45°
Anta		Leaf				
P.1333	Profilo a "Z" anta	"Z" profile frame	2	LS-34	45°	45°
P.1333	Profilo a "Z" anta	"Z" profile frame	2	HS-34	45°	45°
P.2027	Profilo battiacqua	Water drip profile	2	LS-104	90°	90°
Fermavetri		Glazing beads				
P.2008	Fermavetro	Glazing bead profile	2	LS-130	90°	90°
P.2008	Fermavetro	Glazing bead profile	2	HS-170	90°	90°
Vetri		Glass unit				
-	Vetrocamera	Insulated glass	1	LS-146 x HS-146		
ACCESSORI		HARDWARE				
Cod.	Descrizione	Description	n°			
AC1203I**	Kit squadrette per P.1303	Corner joint kit for P.1303	4			
AC1207I**	Kit squadrette per P.1333	Corner joint kit for P.1333	4			
AC1716	Guarnizione d'angolo	Vulcanised corner gasket	4			
AC1219	Scarico acqua	Water drip	Var.			
AC1237	Cerniera ad avvitare	Screw-on hinge	Var.			
AGA271..	Meccanismo apertura ad anta	Casement window mechanism	1			
ACV97..	Maniglia "Vitruvio"	"Vitruvio" handle	1			
AC1356	Meccanismo DK	External tilt & turn mechanism	1			
AC1020	Supporto spessore vetro	Glass support	6			
CV5001(i)	Vite per boccola fermavetro	Screw for glazing bead bushing	Var.			
CV5012(i)	Boccola per fermavetro	Bushing for glazing bead	Var.			
GUARNIZIONI		GASKETS				
Cod.	Descrizione	Description	n°	Dim.		
GE1233TT	Guarnizione esterna di battuta	External rebating gasket	1	2xLS+2xHS		
GE1701	Guarnizione giunto aperto	Open joint system gasket	1	2xLS+2xHS		
GU1302	Estruso PVC giunto aperto	Open joint systemPVC profile	1	2xLS+2xHS		
GE1200TT	Guarnizione interna di battuta	Internal rebating gasket	1	2xLS+2xHS		
GE1206	Guarnizione esterna vetro	External gasket	1	2xLS+2xHS		
GE1007TT	Guarnizione sottovetro	Gasket to put under the glass	1	2xLS+2xHS		
GE..	Guarnizione interna vetro	Internal gasket	1	2xLS+2xHS		



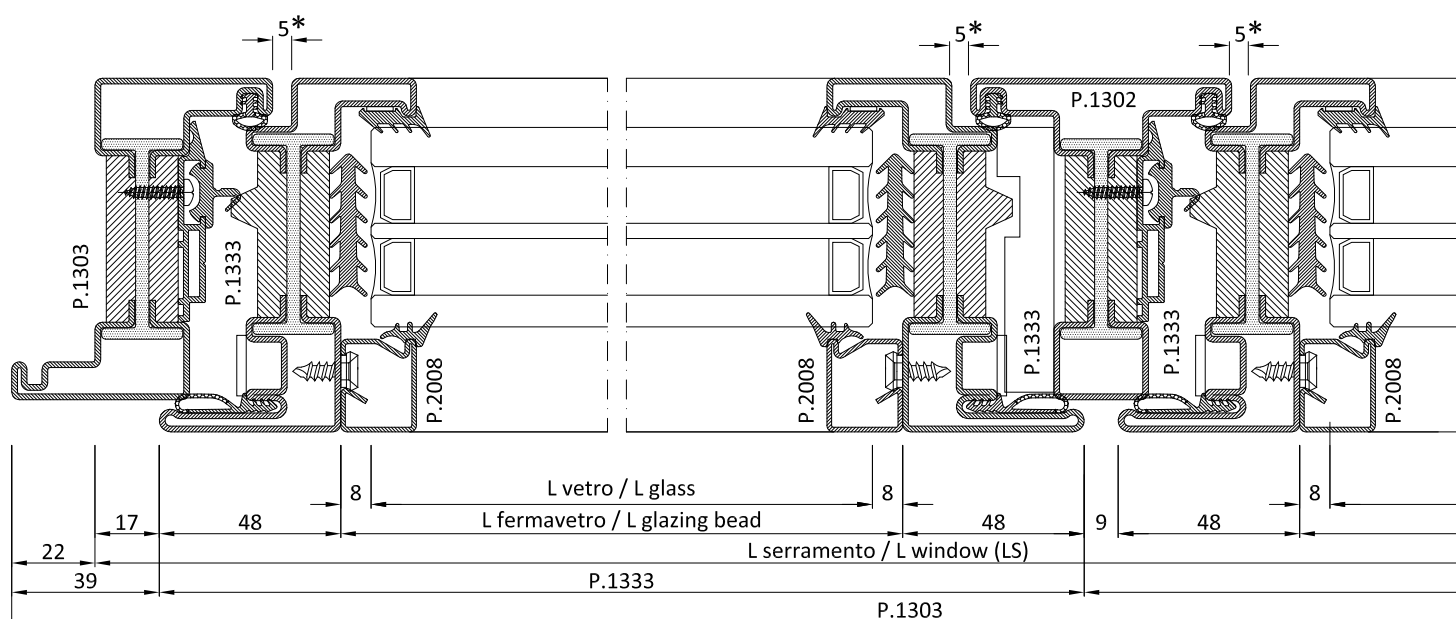
* vedi tabella 4.1.5
see chart 4.1.5

** solo con profili ottone
only with brass profiles





PROFILI		PROFILES				
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
Telaio		Frame				
P.1303	Profilo a "Z" telaio	"Z" profile frame	2	LS+44	45°	45°
P.1303	Profilo a "Z" telaio	"Z" profile frame	2	HS+44	45°	45°
Anta		Leaf				
P.1333	Profilo a "Z" anta	"Z" profile frame	4	(LS-43)/2	45°	45°
P.1333	Profilo a "Z" anta	"Z" profile frame	4	HS-34	45°	45°
P.1302	Profilo a "T" anta	"T" profile frame	1	HS-82.5	90°	90°
P.2027	Profilo battiacqua	Water drip profile	2	(LS-183)/2	90°	90°
Fermavetri		Glazing beads				
P.2008	Fermavetro	Glazing bead profile	4	(LS-235)/2	90°	90°
P.2008	Fermavetro	Glazing bead profile	4	HS-170	90°	90°
Vetri		Glass unit				
-	Vetrocamera	Insulated glass	2	[(LS-267)/2] x HS-146		

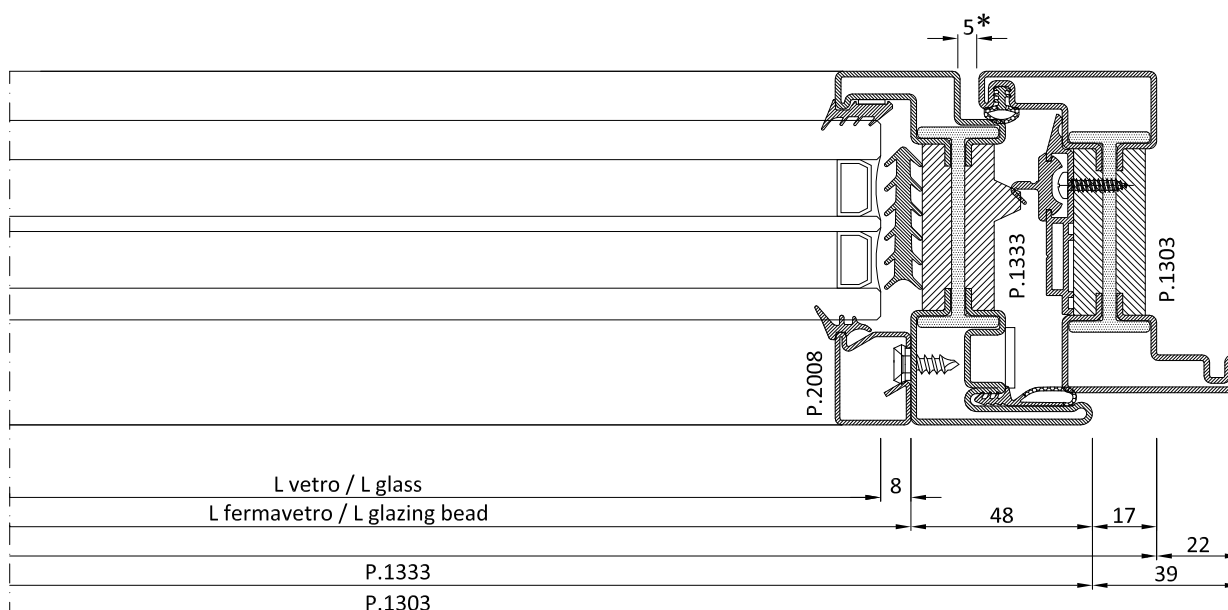
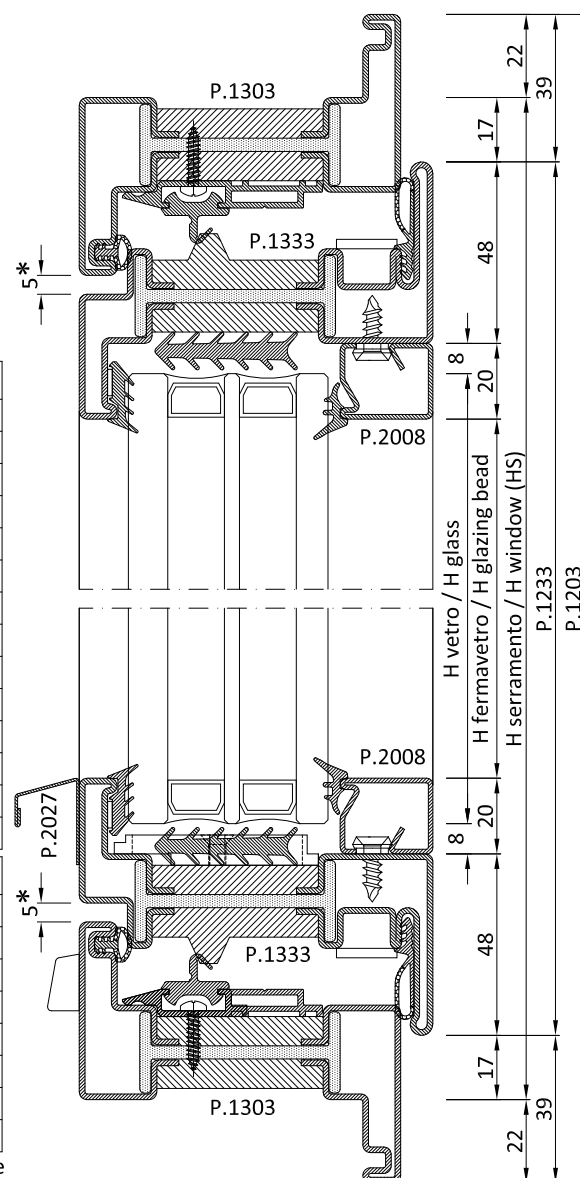


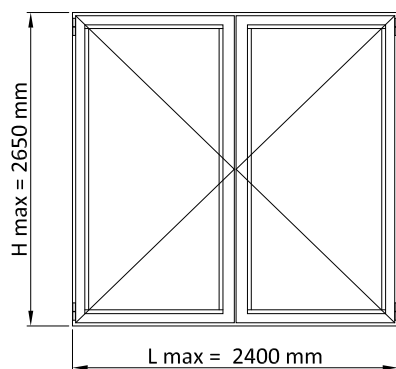
ACCESSORI		HARDWARE	
Cod.	Descrizione	Description	n°
AC1203I**	Kit squadrette per P.1303	Corner joint kit for P.1303	4
AC1207I**	Kit squadrette per P.1333	Corner joint kit for P.1333	8
AC1716	Guarnizione d'angolo	Vulcanised corner gasket	4
AC1219	Scarico acqua	Water drip	Var.
AC1355	Kit inversione battuta 2^ anta	2nd leaf reverse closure kit	2
AC1237	Cerniera ad avvitare	Screw-on hinge	Var.
AGA271..	Meccanismo apertura 1^ anta	1st leaf opening mechanism	1
AGA275..	Meccanismo apertura 2^ anta	2nd leaf opening mechanism	1
ACV97..	Maniglia "Vitruvio"	"Vitruvio" handle	1
AC1356	Meccanismo DK	External tilt & turn mechanism	1
AC1020	Supporto spessore vetro	Glass support	12
CV5001(i)	Vite per boccola fermavetro	Screw for glazing bead bushing	Var.
CV5012(i)	Boccola per fermavetro	Bushing for glazing bead	Var.

GUARNIZIONI		GASKETS	
Cod.	Descrizione	Description	n° Dim.
GE1233TT	Guarnizione esterna di battuta	External rebating gasket	1 2xLS+4xHS
GE1701	Guarnizione giunto aperto	Open joint system gasket	1 2xLS+3xHS
GU1302	Estruso PVC giunto aperto	Open joint system PVC profile	1 2xLS+3xHS
GE1200TT	Guarnizione interna di battuta	Internal rebating gasket	1 2xLS+4xHS
GE1206	Guarnizione esterna vetro	External gasket	1 2xLS+4xHS
GE1007TT	Guarnizione sottovetro	Gasket to put under the glass	1 2xLS+4xHS
GE..	Guarnizione interna vetro	Internal gasket	1 2xLS+4xHS

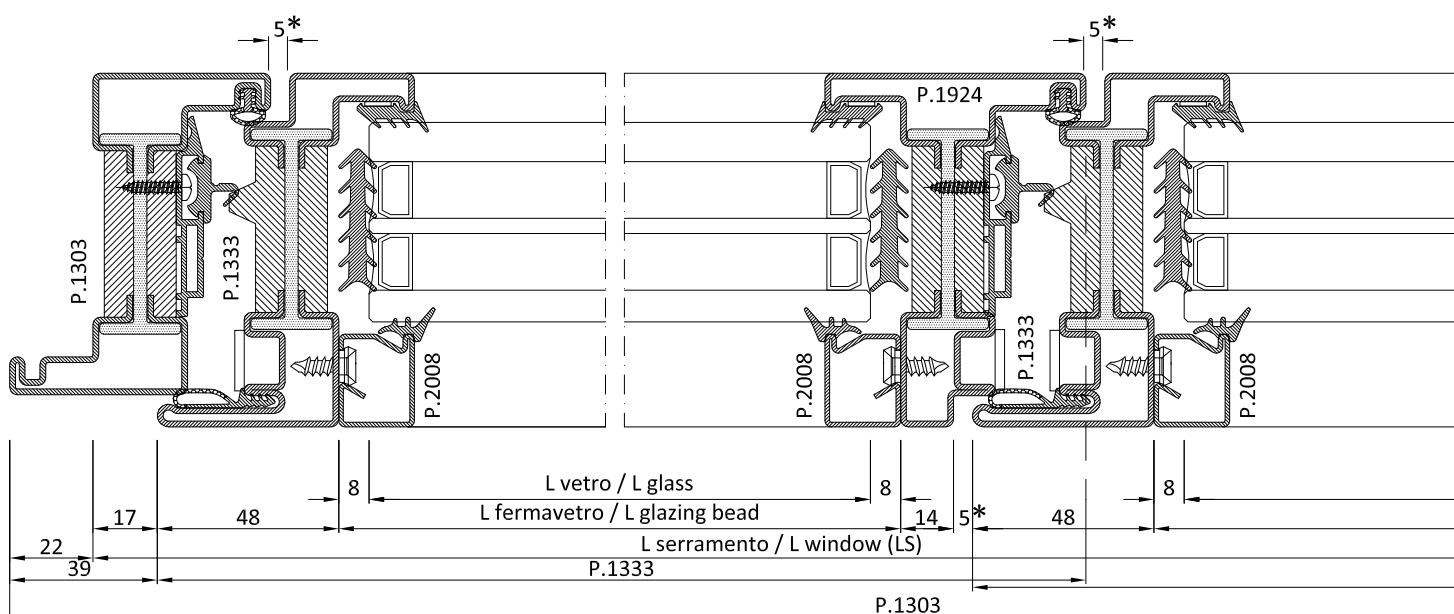
* vedi tabella 4.1.5
see chart 4.1.5

** solo con profili ottone
only with brass profiles





PROFILI		PROFILES				
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
Telaio		Frame				
P.1303	Profilo a "Z" telaio	"Z" profile frame	2	LS+44	45°	45°
P.1303	Profilo a "Z" telaio	"Z" profile frame	2	HS+44	45°	45°
Anta		Leaf				
P.1333	Profilo a "Z" anta	"Z" profile frame	4	(LS-5)/2	45°	45°
P.1333	Profilo a "Z" anta	"Z" profile frame	3	HS-34	45°	45°
P.1924	Profilo a "T" anta	"T" profile frame	1	HS-32	45°	45°
P.2027	Profilo battiacqua	Water drip profile	1	(LS-75)/2	90°	90°
P.2027	Profilo battiacqua	Water drip profile	2	(LS-143)/2	90°	90°
Fermavetri		Glazing beads				
P.2008	Fermavetro	Glazing bead profile	4	(LS-197)/2	90°	90°
P.2008	Fermavetro	Glazing bead profile	4	HS-170	90°	90°
Vetri		Glass unit				
-	Vetrocamera	Insulated glass	2	[(LS-229)/2] x HS-146		



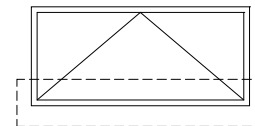
Distinta di taglio e lista componenti | Cutting list and components list

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

E' compito dei tecnici specializzati delle ditte produttrici analizzare criticamente tali indicazioni al fine di verificare la compatibilità del tipo e numero di accessori previsti con il serramento oggetto della commessa reale.

The cutting and hardware lists, which have been identified for the different typologies, have been produced for a standard window.

The specialized technicians of the window manufacturers will have to critically analyze such information in order to verify the compatibility of both the type and the number of accessories provided with the window object of the real order.

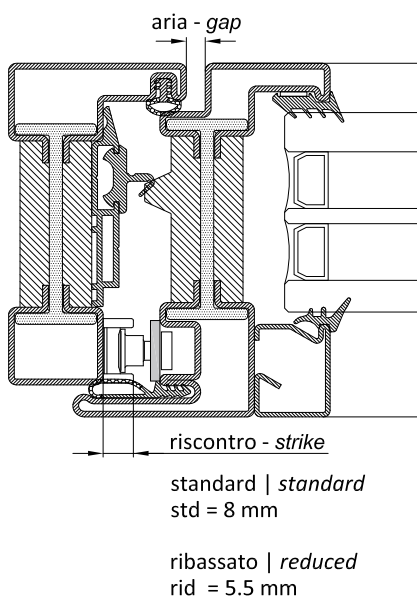
**La tabella seguente va attentamente letta prima del taglio dei profili | The following table should be carefully read before the profiles cutting**

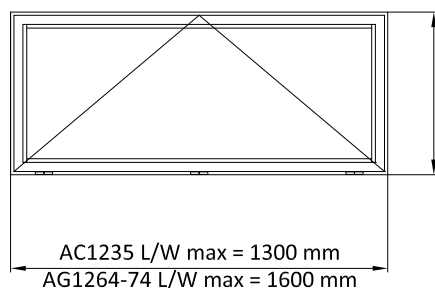
In essa è riportata la misura da considerare nella distanza tra telaio anta e telaio fisso nella produzione di finestre in funzione della tipologia, del tipo di cerniera e della larghezza delle ante da produrre.

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

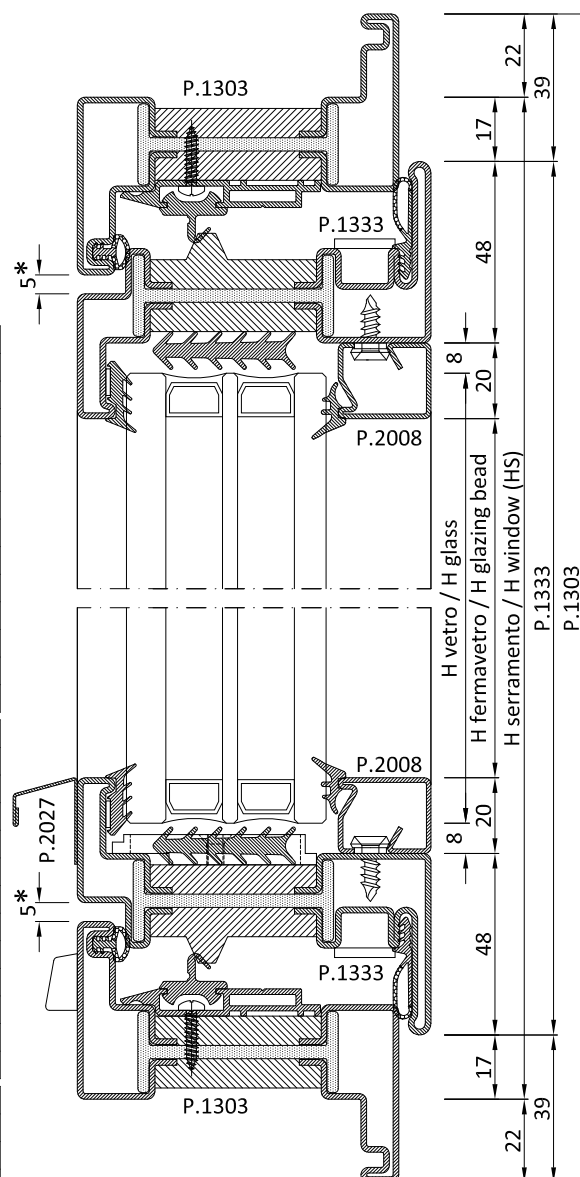
larghezza anta (cava ferramenta in mm) leaf width (hardware slot in mm)				
			< 480	> 480
Vasistas	AG 1264	aria - gap	6	5
Bottom hung	AG 1274	riscontro - strike	std	std

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



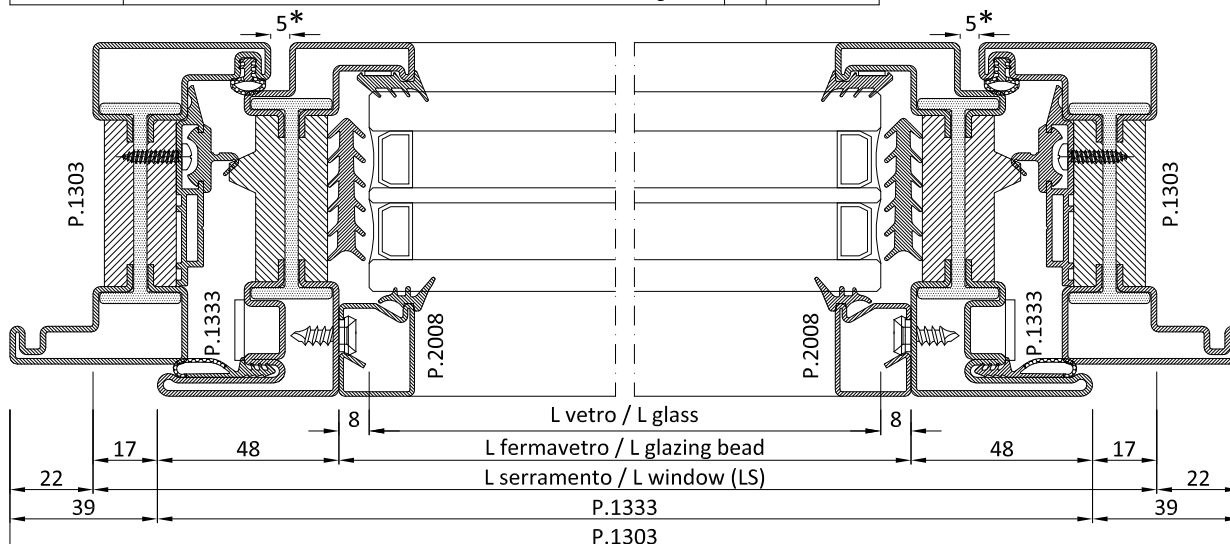


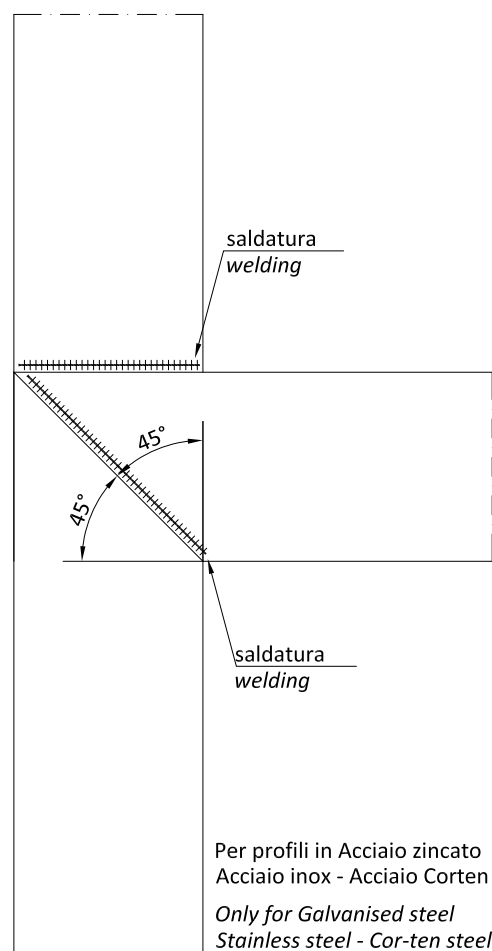
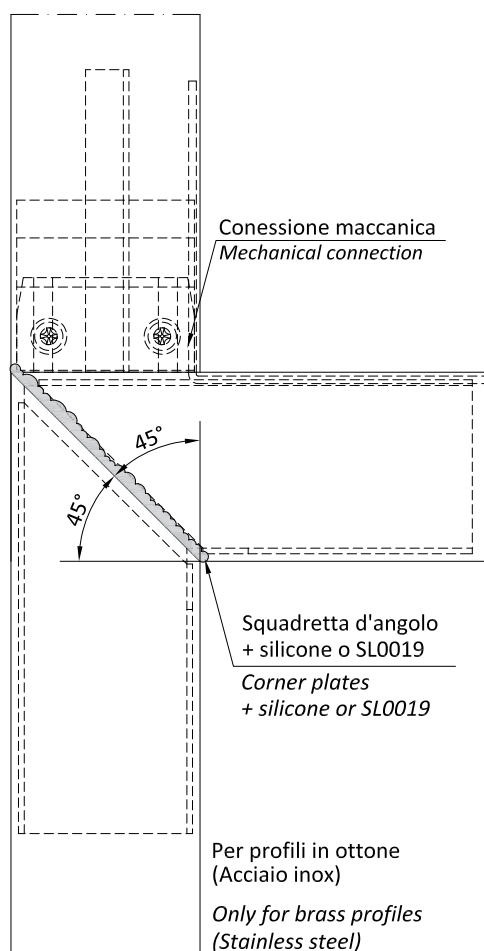
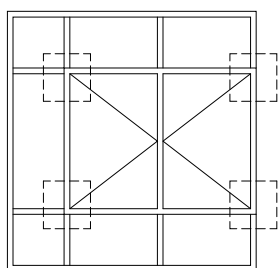
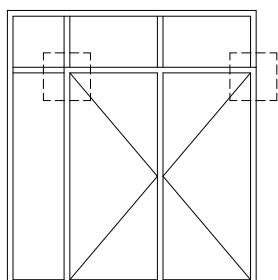
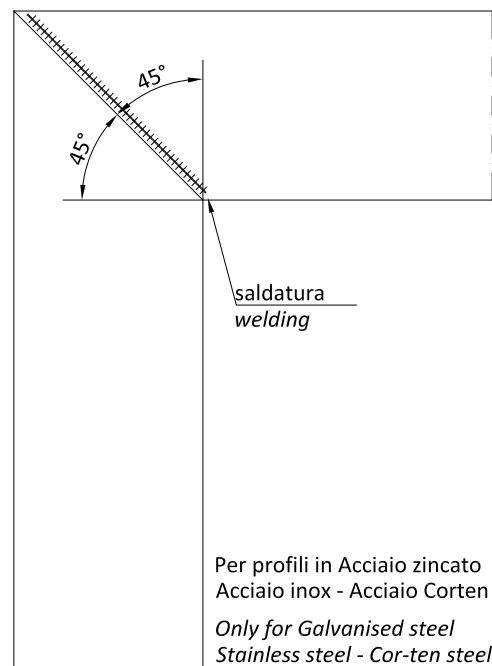
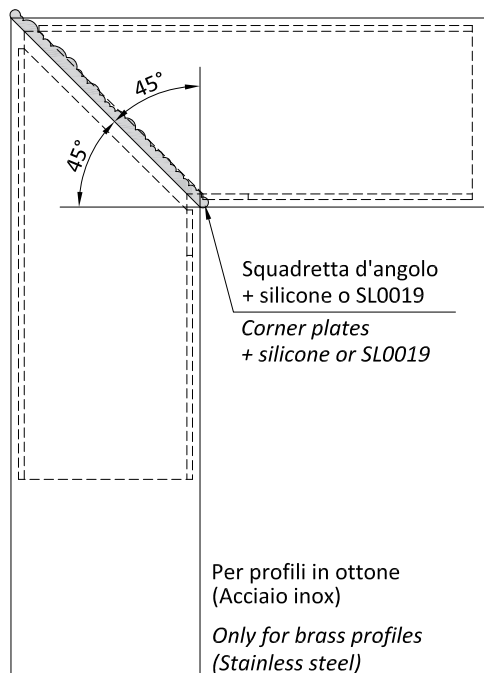
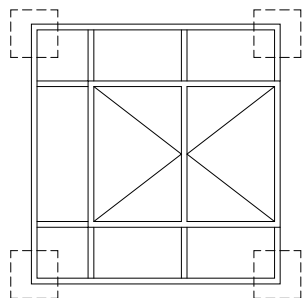
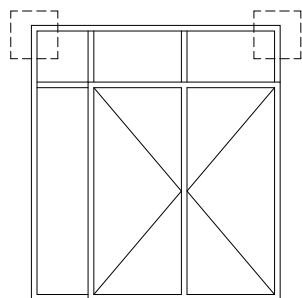
PROFILI			PROFILES			
Cod.	Descrizione	Description	n°	Dim.	Taglio Cutting	
Telaio			Frame			
P.1303	Profilo a "Z" telaio	"Z" profile frame	2	LS+44	45°	45°
P.1303	Profilo a "Z" telaio	"Z" profile frame	2	HS+44	45°	45°
Anta			Leaf			
P.1333	Profilo a "Z" anta	"Z" profile frame	2	LS-34	45°	45°
P.1333	Profilo a "Z" anta	"Z" profile frame	2	HS-34	45°	45°
P.2027	Profilo battiacqua	Water drip profile	2	LS-104	90°	90°
Fermavetri			Glazing beads			
P.2008	Fermavetro	Glazing bead profile	2	LS-130	90°	90°
P.2008	Fermavetro	Glazing bead profile	2	HS-170	90°	90°
Vetri			Glass unit			
-	Vetrocamera	Insulated glass	1	LS-146 x HS-146		
ACCESSORI			HARDWARE			
Cod.	Descrizione	Description	n°			
AC1203I**	Kit squadrette per P.1303	Corner joint kit for P.1303	4			
AC1207I**	Kit squadrette per P.1333	Corner joint kit for P.1333	4			
AC1716	Guarnizione d'angolo	Vulcanised corner gasket	4			
AC1219	Scarico acqua	Water drip	Var.			
AC../AG..	Cerniere	Hinges	2/3			
AG1264/74..	Meccanismo Vasistas	Bottom hung mechanism	1			
ACV97..	Maniglia "Vitruvio"	"Vitruvio" handle	1			
AC1356	Meccanismo DK	External tilt & turn mechanism	1			
AC1020	Supporto spessore vetro	Glass support	6			
CV5001(i)	Vite per boccola fermavetro	Screw for glazing bead bushing	Var.			
CV5012(i)	Boccola per fermavetro	Bushing for glazing bead	Var.			
GUARNIZIONI			GASKETS			
Cod.	Descrizione	Description	n°	Dim.		
GE1233TT	Guarnizione esterna di battuta	External rebating gasket	1	2xLS+2xHS		
GE1701	Guarnizione giunto aperto	Open joint system gasket	1	2xLS+2xHS		
GU1702	Estruso PVC giunto aperto	Open joint systemPVC profile	1	2xLS+2xHS		
GE1200TT	Guarnizione interna di battuta	Internal rebating gasket	1	2xLS+2xHS		
GE1206	Guarnizione esterna vetro	External gasket	1	2xLS+2xHS		
GE1007TT	Guarnizione sottovetro	Gasket to put under the glass	1	2xLS+2xHS		
GE..	Guarnizione interna vetro	Internal gasket	1	2xLS+2xHS		

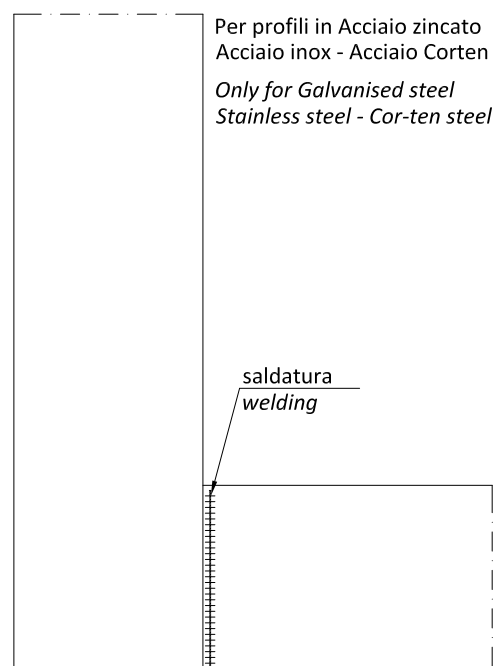
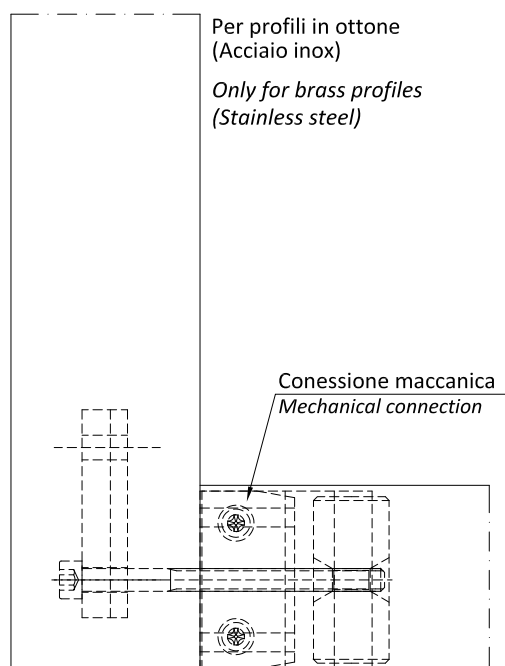
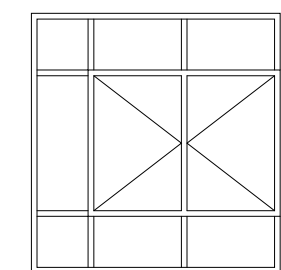
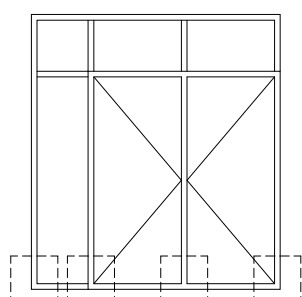
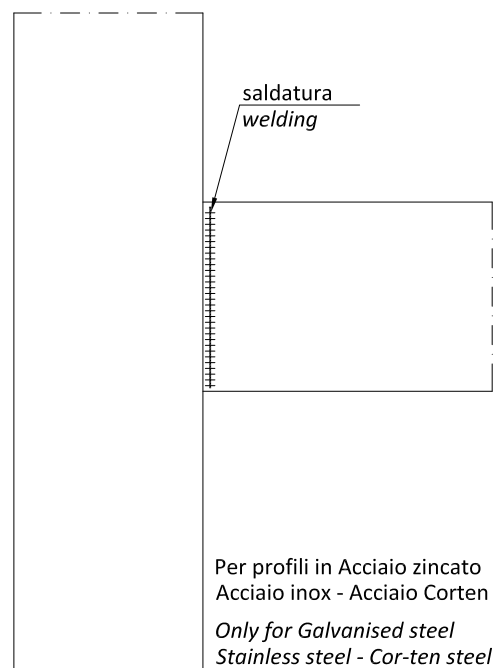
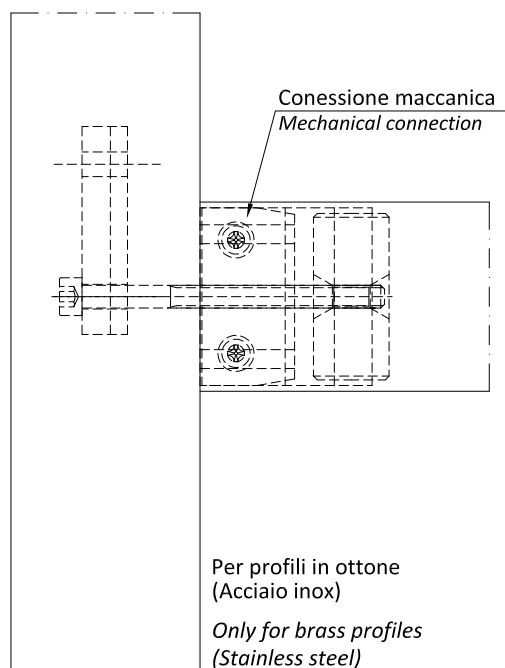
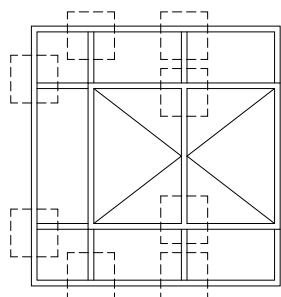
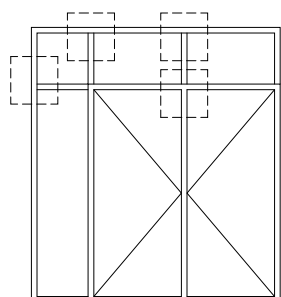


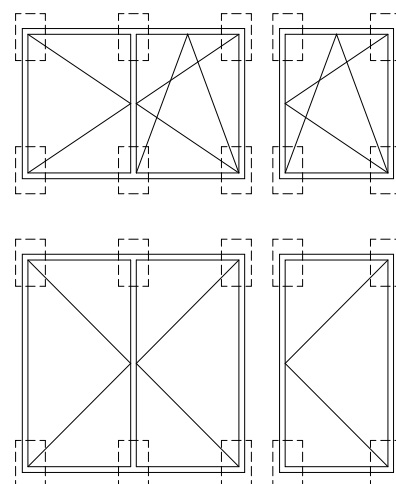
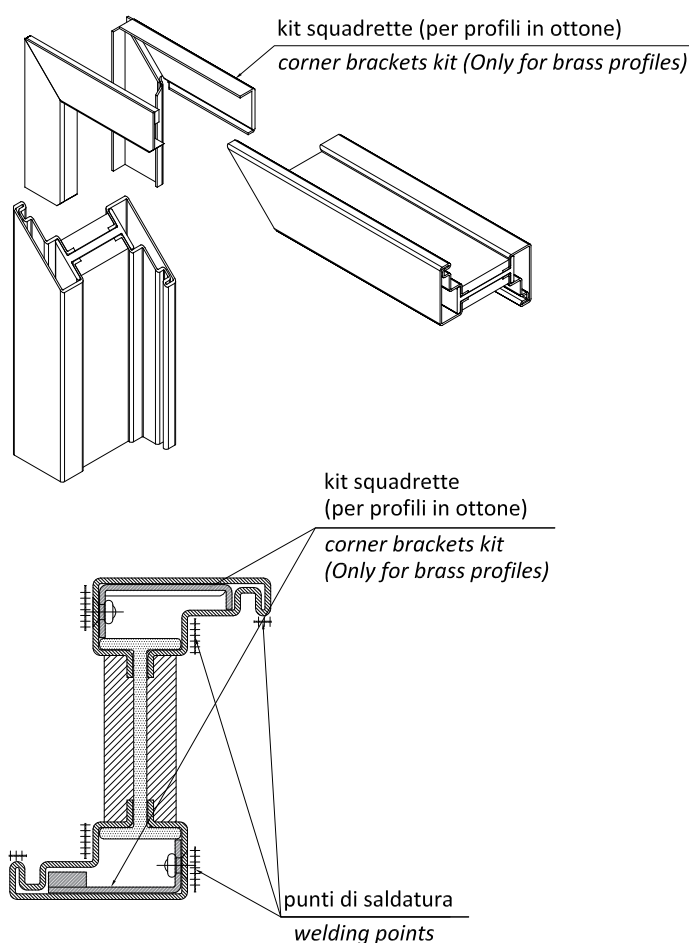
* vedi tabella 4.1.16
see chart 4.1.16

** solo con profili ottone
only with brass profiles







**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

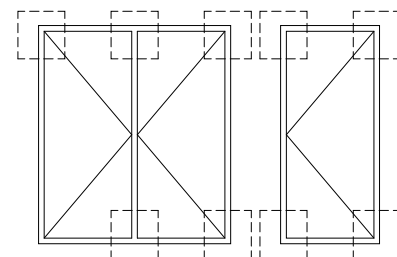
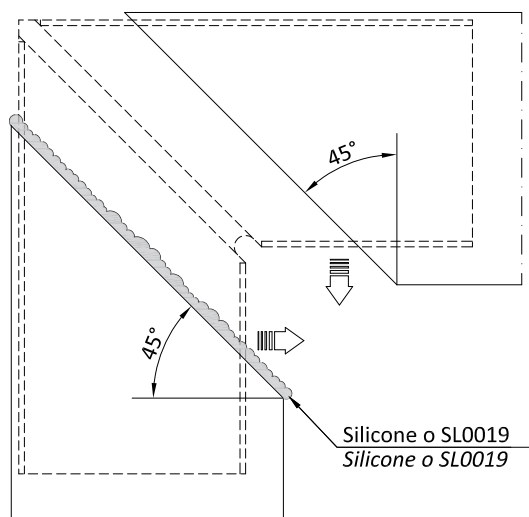
Saldare in continuo le superfici di contatto.

Galvanised steel - Cor-ten steel - Stainless steel

Seam-weld all contact surfaces.

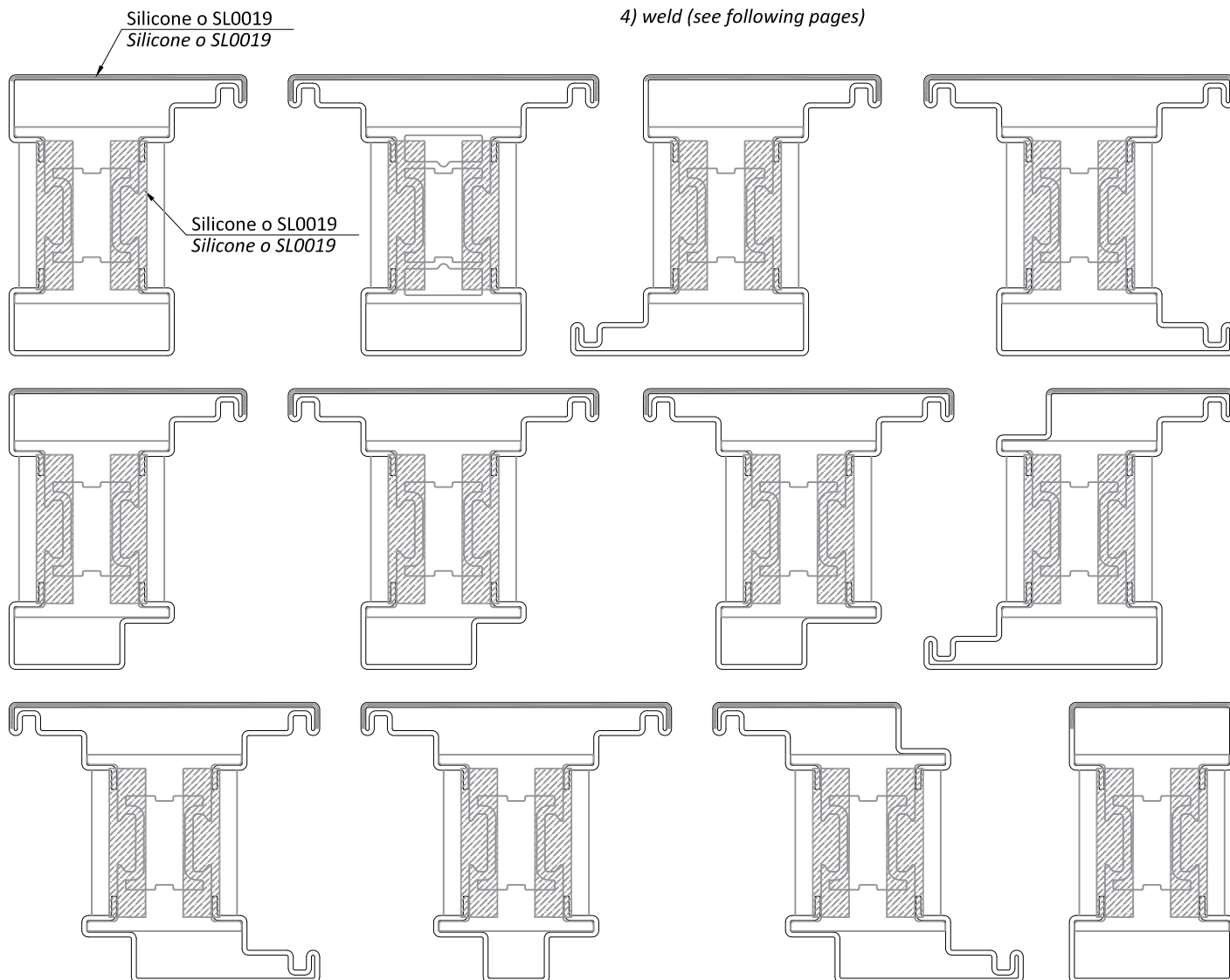
Profilo	Profile	Kit squadrette	Corner brackets set
Codice	Code	Codice	Code
P.1101-P.1101		AC 1001I	
P.1102-P.1102		AC 1002I	
P.1103-P.1103		AC 1003I	
P.1111-P.1111		AC 1004I	
P.1112-P.1112		AC 1005I	
P.1113-P.1113		AC 1006I	telaio / frame
P.1113-P.1113		AC 1007I	anta / leaf
P.1112-P.1113		AC 1008I	
P.1105-P.1105		AC 1009I	
P.1110-P.1110		AC 1013I	
P.1127-P.1112		AC 1024ID	
P.1127-P.1112		AC 1024IS	

Profilo	Profile	Kit squadrette	Corner brackets set
Codice	Code	Codice	Code
P.1301-P.1301		AC 1201I	
P.1302-P.1302		AC 1202I	
P.1303-P.1303		AC 1203I	
P.1333-P.1333		AC 1207I	
P.1305-P.1305		AC 1209I	
P.1924-P.1333		AC 1208I	
P.1320-P.1320		AC 1730I	
P.1311-P.1311		AC 1731I	
P.1312-P.1312		AC 1732I	
P.1313-P.1313		AC 1733I	anta / leaf
P.1313-P.1313		AC 1733IE	telaio / frame
P.1315-P.1315		AC 1735I	

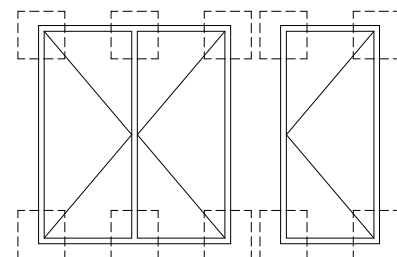
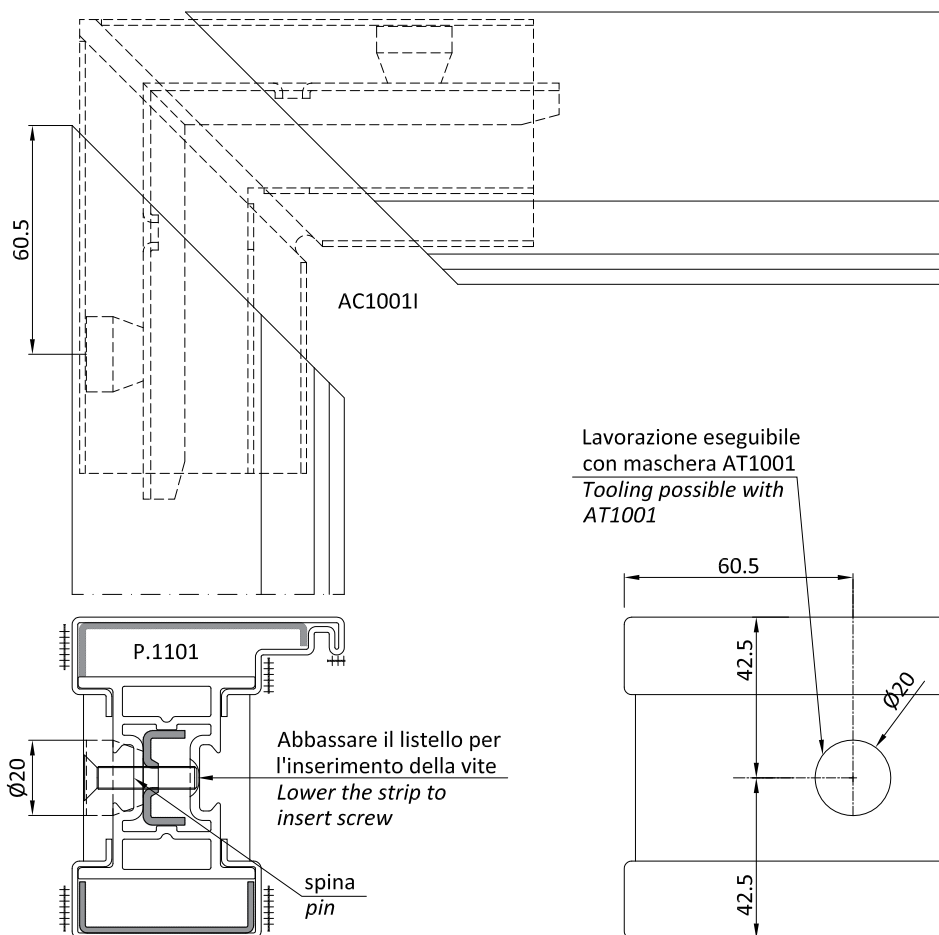


- 1) inserire la squadretta
- 2) siliconare nelle zone indicate
- 3) accostare i profili
- 4) procedere con la saldatura (vedasi pagine successive)

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

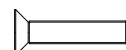


 Sigillare con silicone o sigillante a freddo SL0019 nelle zone evidenziate (sempre lato esterno profilo)
 Seal with silicone or cold-working sealant SL0019 in the areas marked (always on the outer side of the profile)



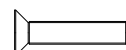
Saldare a TIG con materiale di riporto
nelle zone indicate con +++++

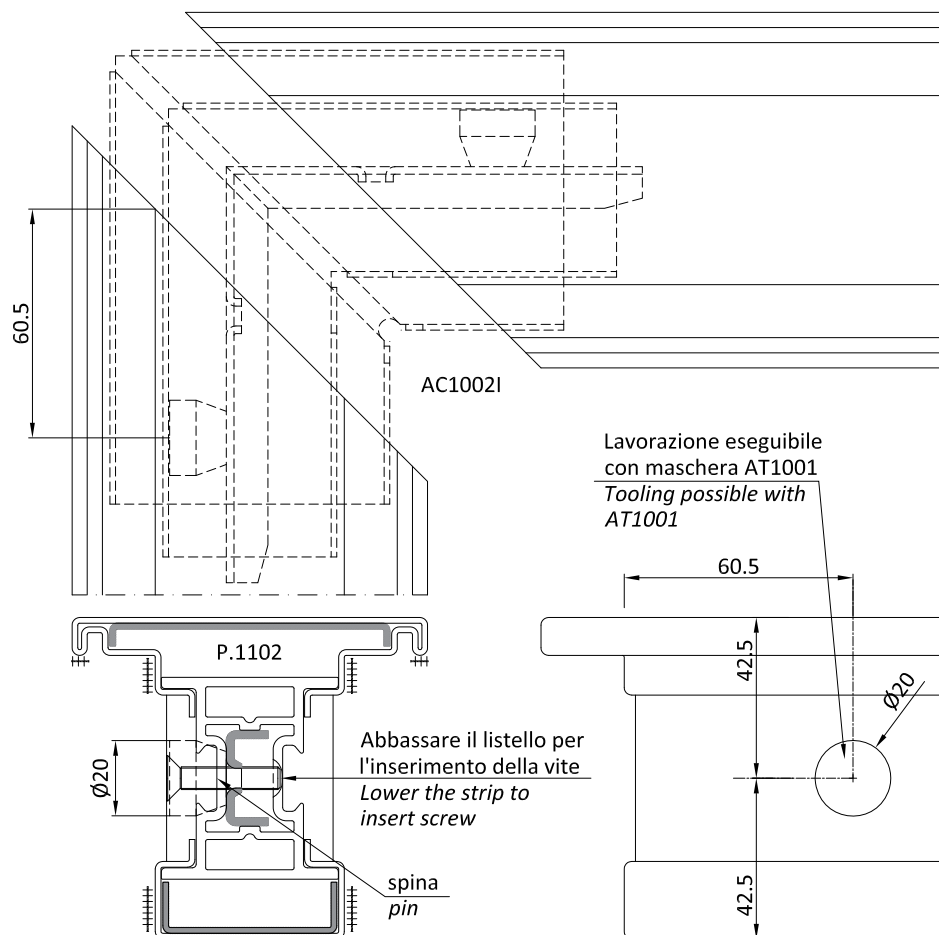
Sigillare tutte le superfici di contatto
esterne con silicone o SL0019

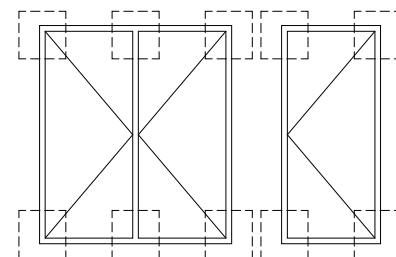
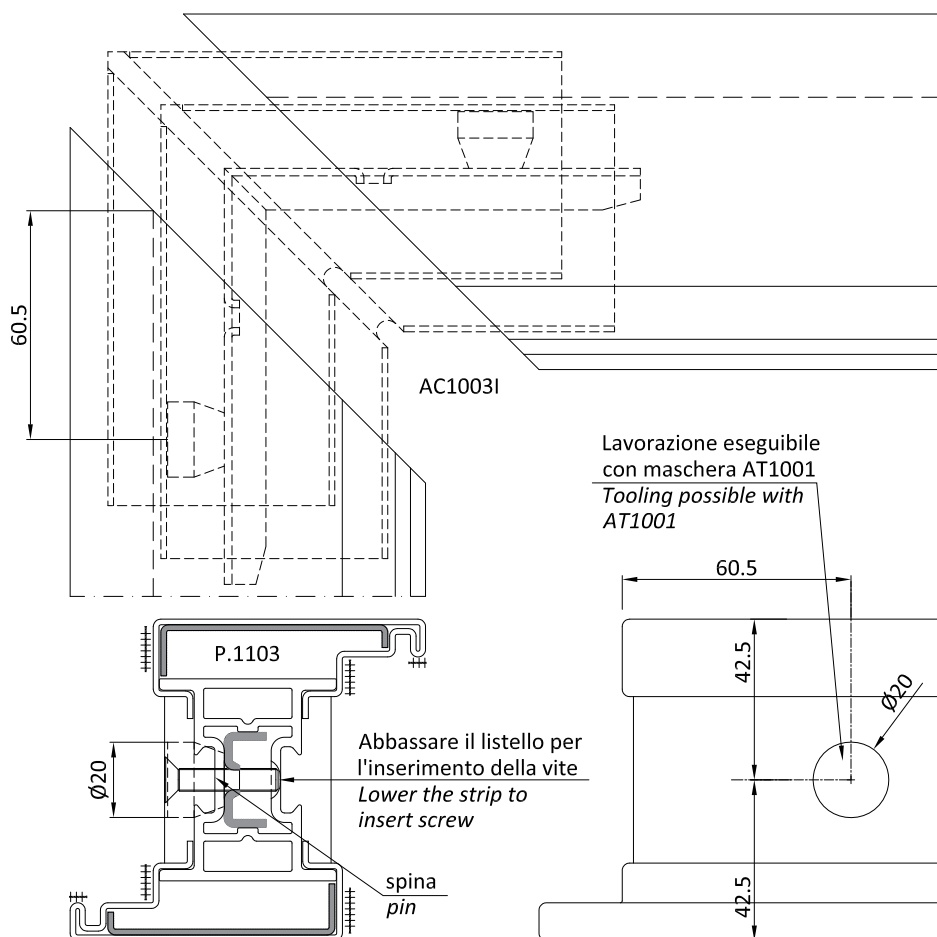
 vite TSPEI M6x30 inox

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

Seal all the external contact surfaces
with silicone our SL0019

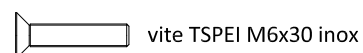
 stainless steel screws
TSPEI M6x30





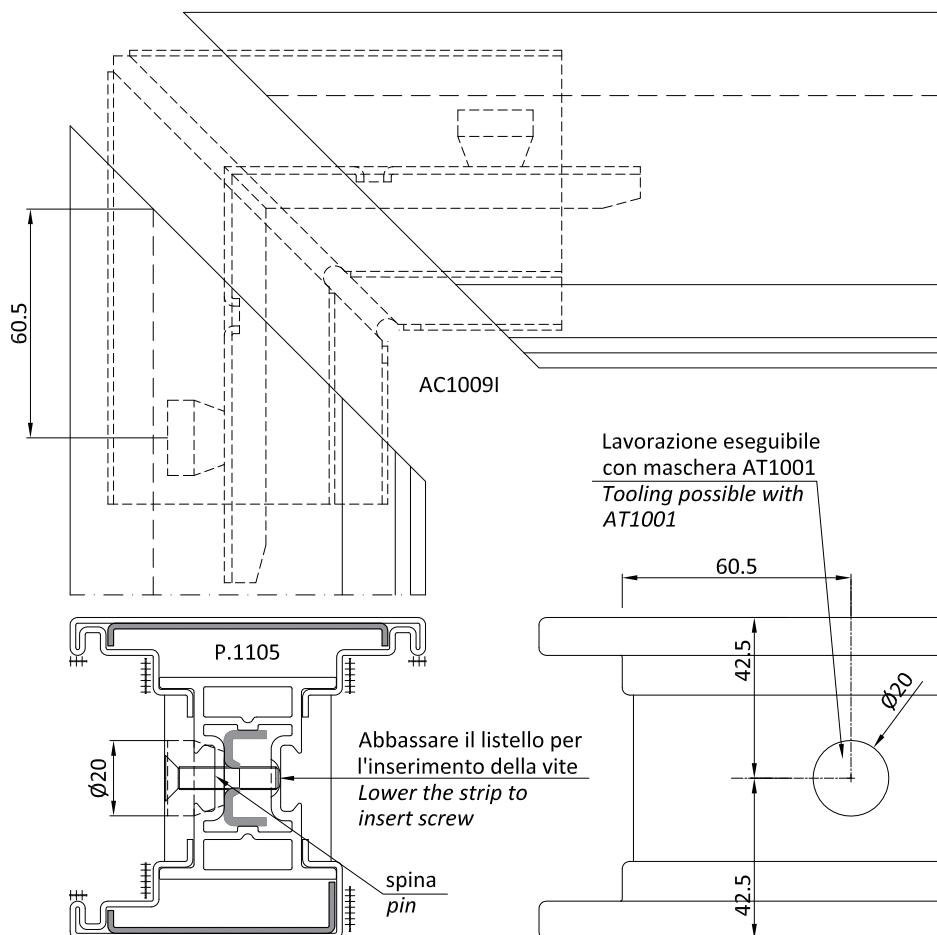
Saldare a TIG con materiale di riporto nelle zone indicate con +++++

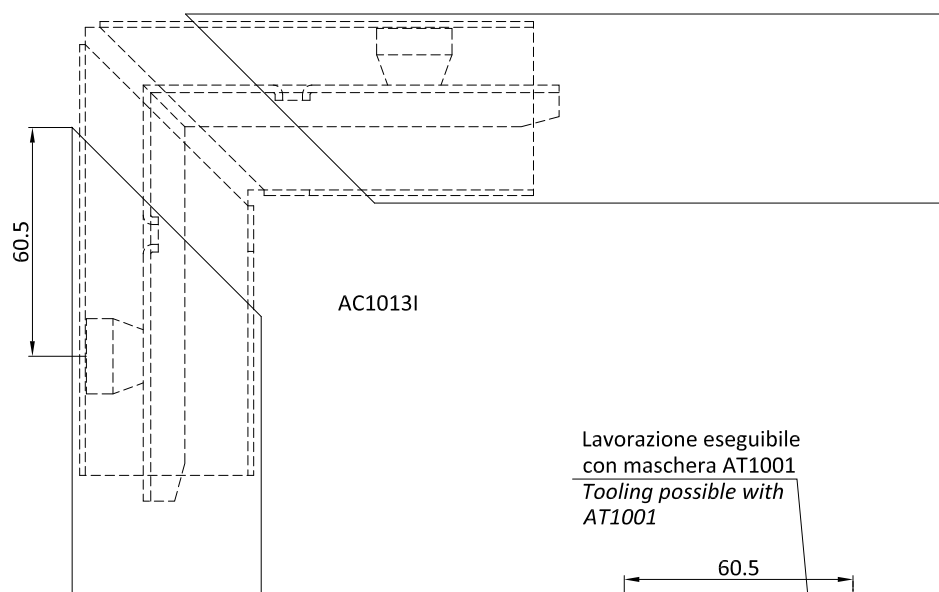
Sigillare tutte le superfici di contatto esterne con silicone o SL0019



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

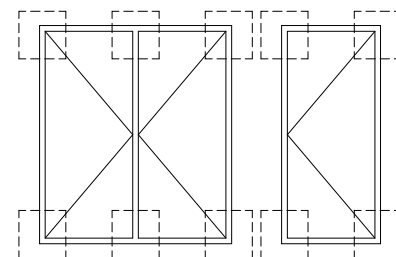
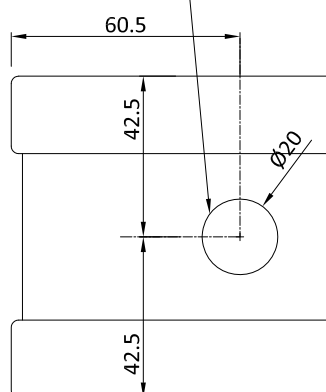
Seal all the external contact surfaces with silicone or SL0019





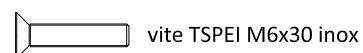
AC1013I

Lavorazione eseguibile
con maschera AT1001
*Tooling possible with
AT1001*



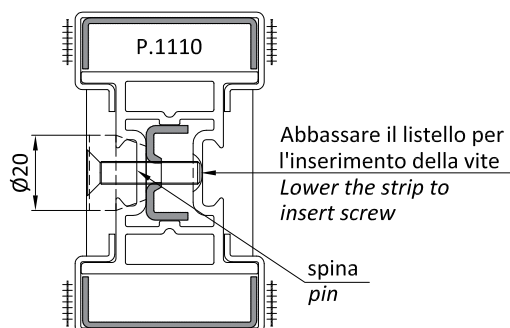
Saldare a TIG con materiale di riporto
nelle zone indicate con +++++

Sigillare tutte le superfici di contatto
esterne con silicone o SL0019



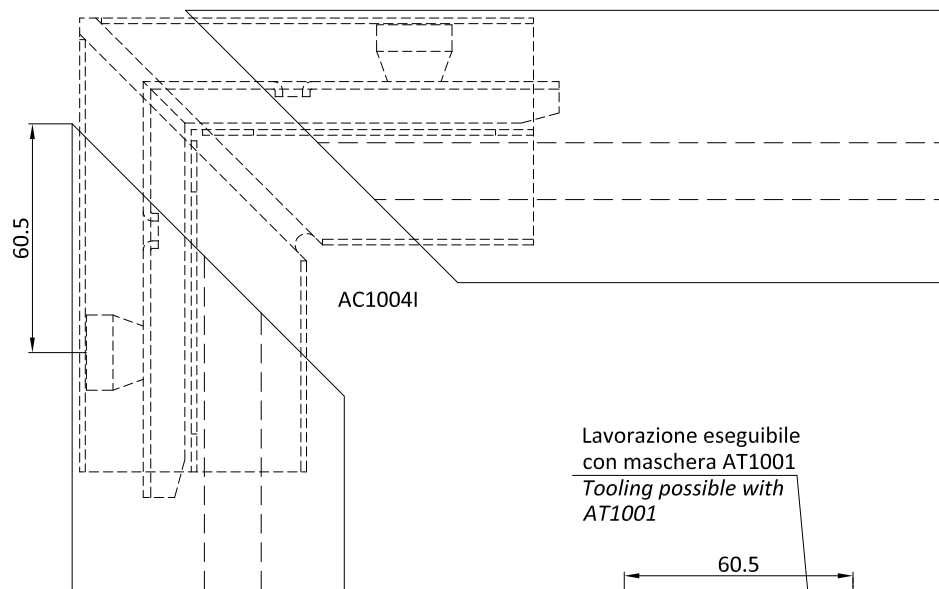
TIG welding with filler material in the
areas indicated with +++++

Seal all the external contact surfaces
with silicone our SL0019



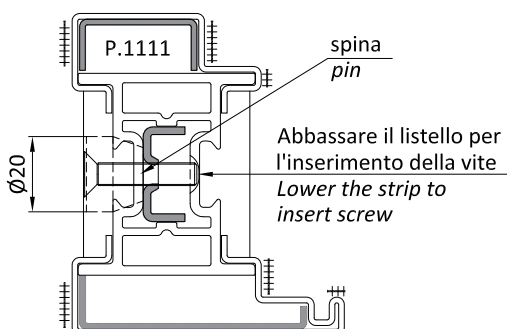
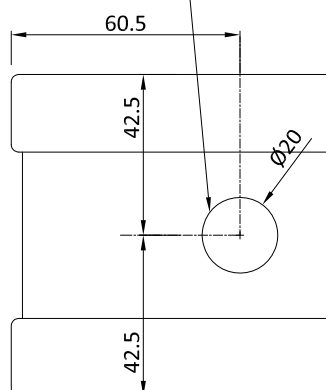
Abbassare il listello per
l'inserimento della vite
*Lower the strip to
insert screw*

spina
pin



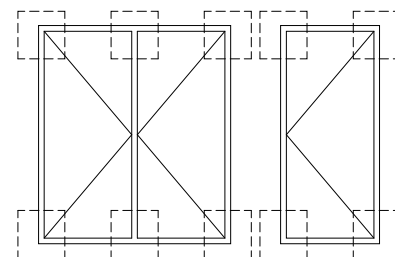
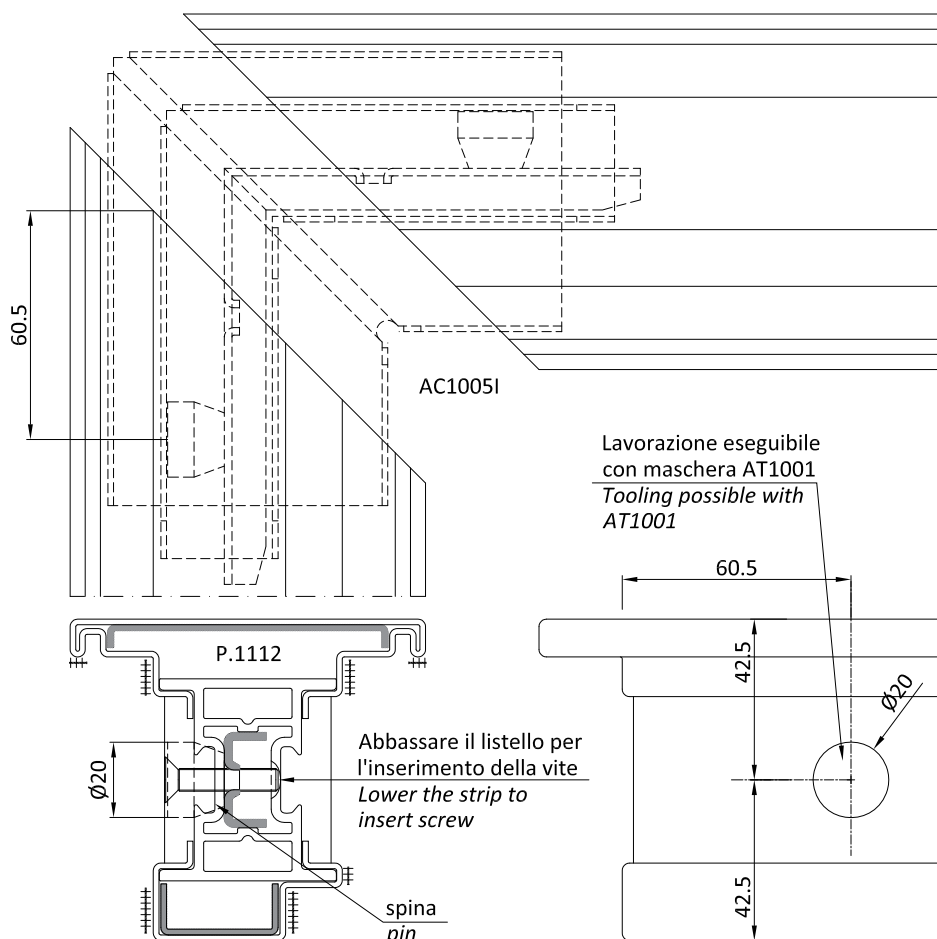
AC1004I

Lavorazione eseguibile
con maschera AT1001
*Tooling possible with
AT1001*



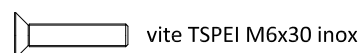
Abbassare il listello per
l'inserimento della vite
*Lower the strip to
insert screw*

spina
pin



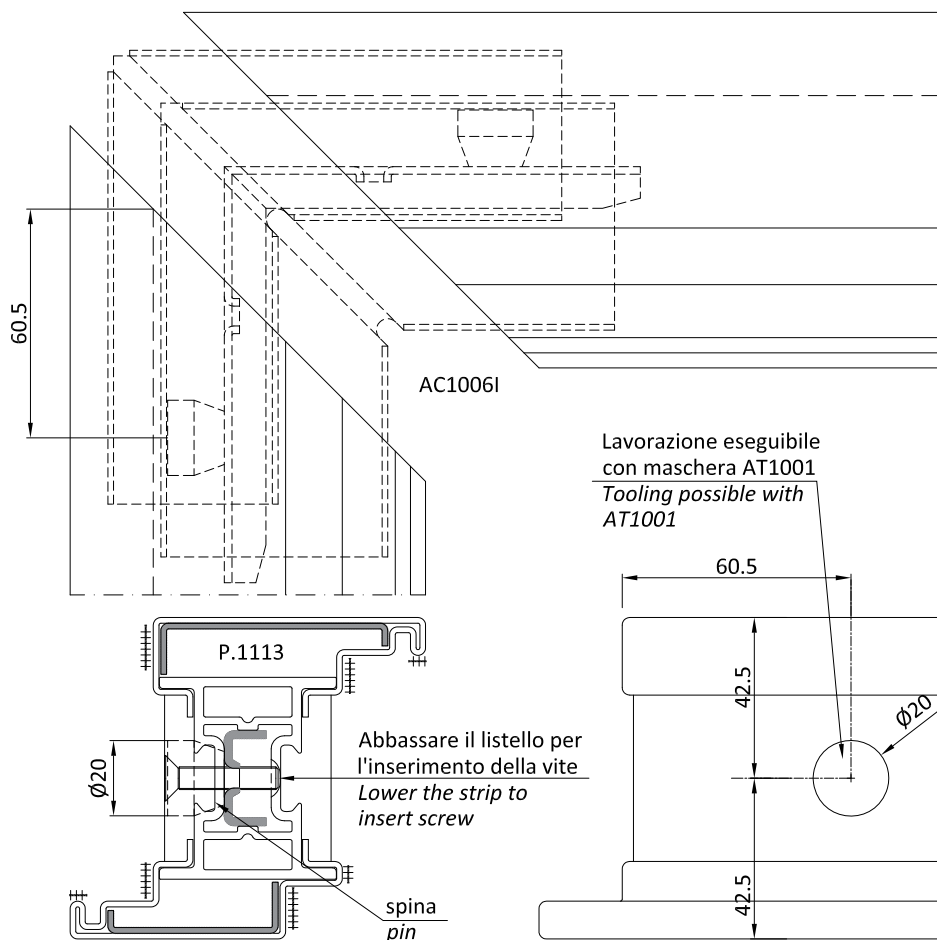
Saldare a TIG con materiale di riporto nelle zone indicate con +++++

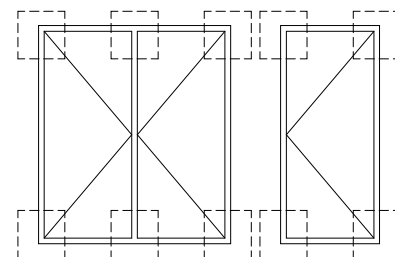
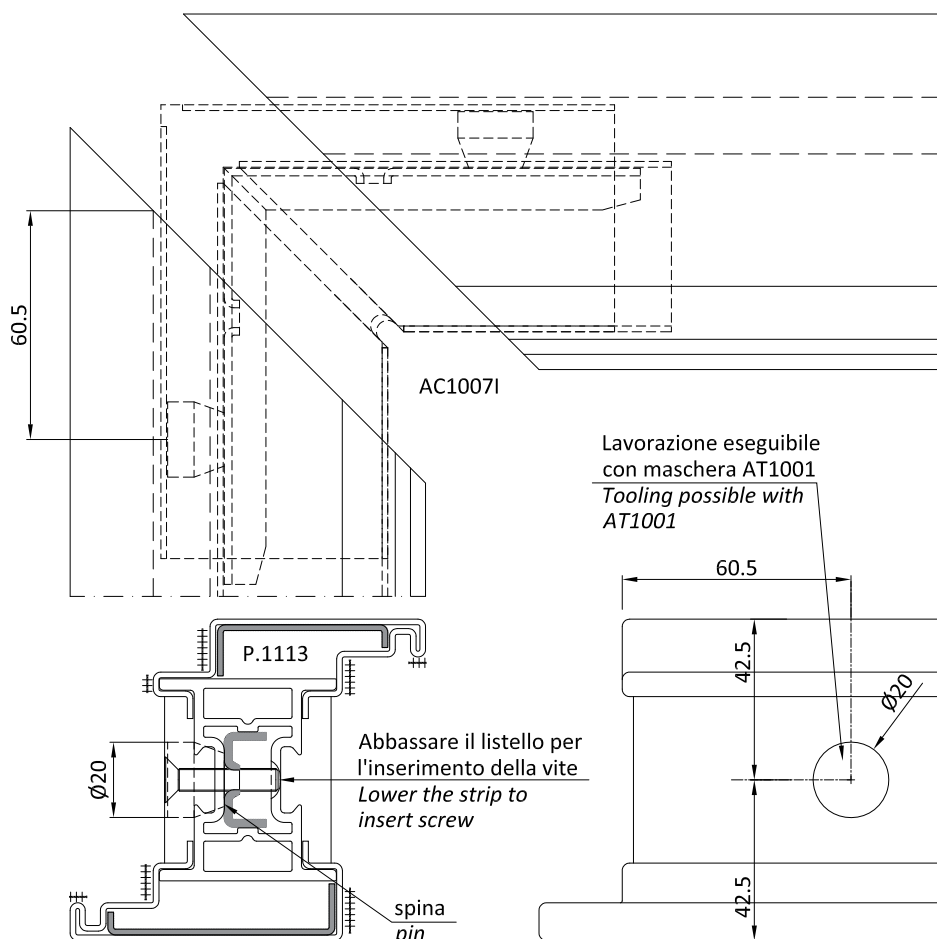
Sigillare tutte le superfici di contatto esterne con silicone o SL0019



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

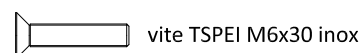
Seal all the external contact surfaces with silicone or SL0019





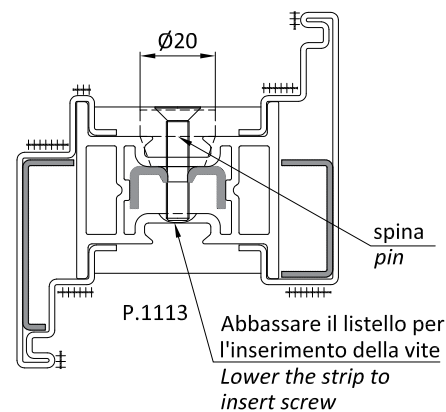
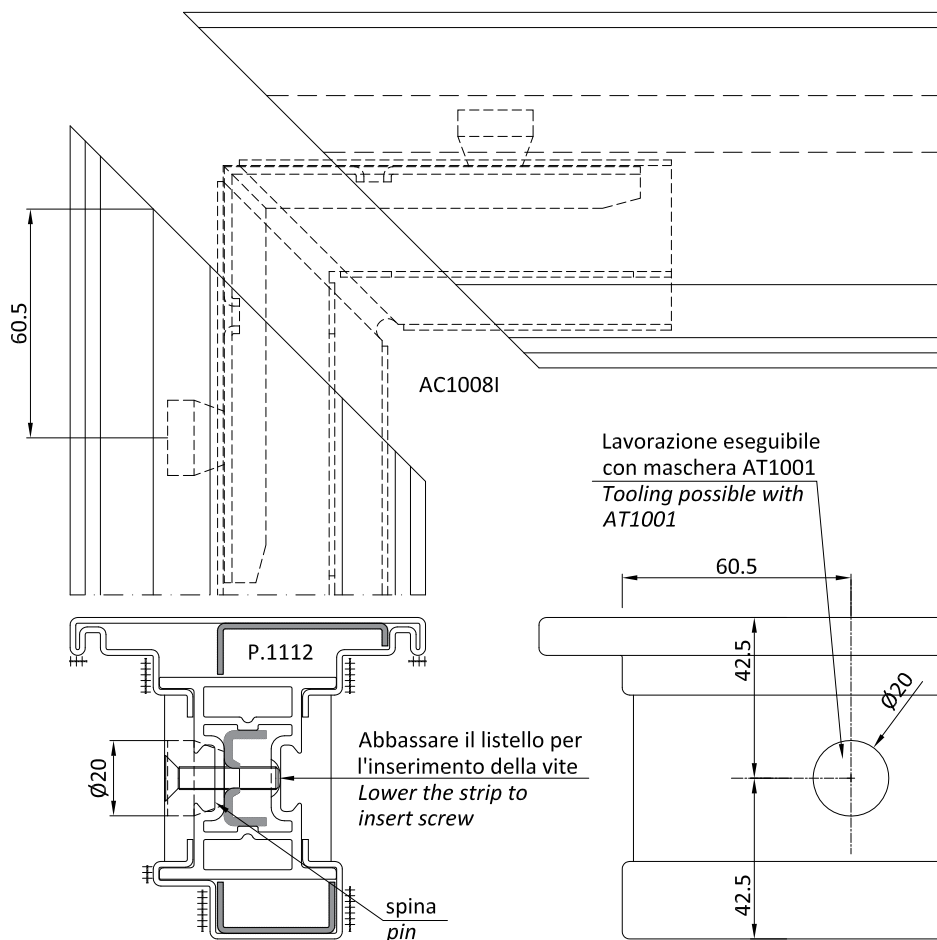
Saldare a TIG con materiale di riporto nelle zone indicate con +++++

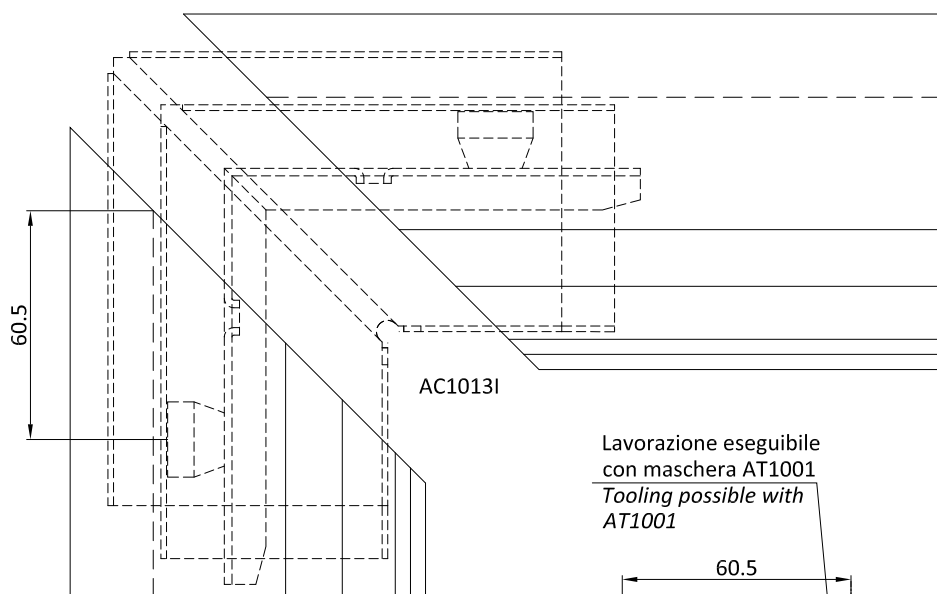
Sigillare tutte le superfici di contatto esterne con silicone o SL0019



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

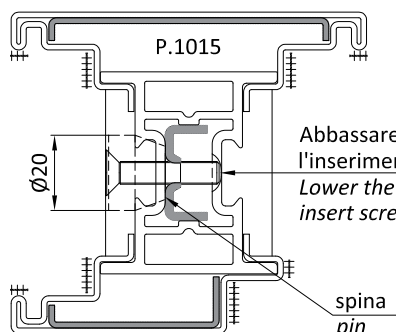
Seal all the external contact surfaces with silicone or SL0019





AC1013I

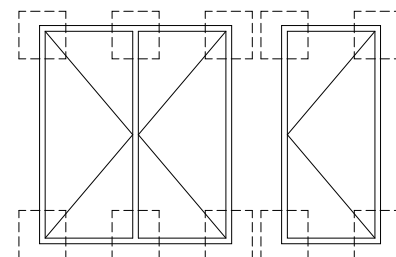
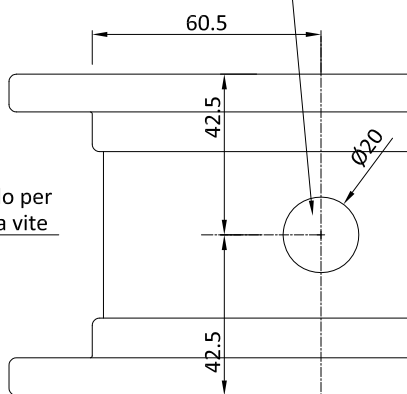
Lavorazione eseguibile
con maschera AT1001
*Tooling possible with
AT1001*



P.1015

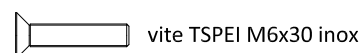
Abbassare il listello per
l'inserimento della vite
*Lower the strip to
insert screw*

spina
pin



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

Sigillare tutte le superfici di contatto
esterne con silicone o SL0019



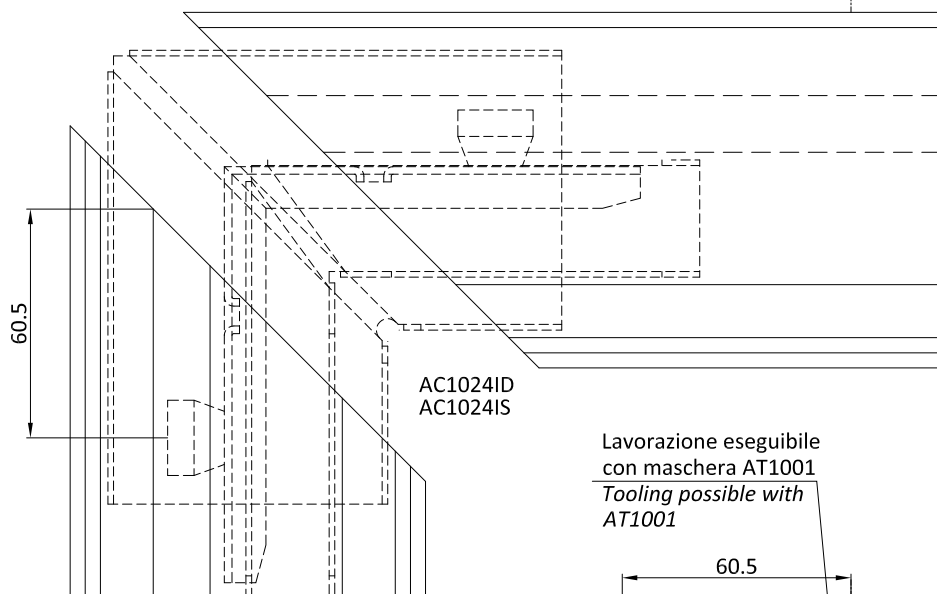
vite TSPEI M6x30 inox

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

Seal all the external contact surfaces
with silicone our SL0019

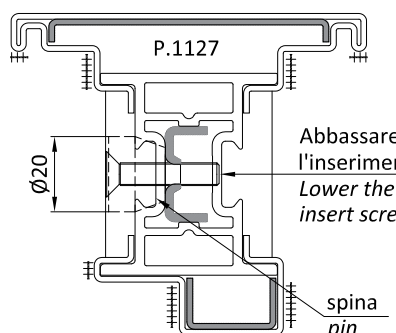


stainless steel screws
TSPEI M6x30



AC1024ID
AC1024IS

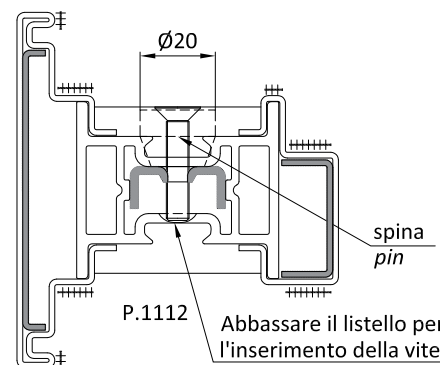
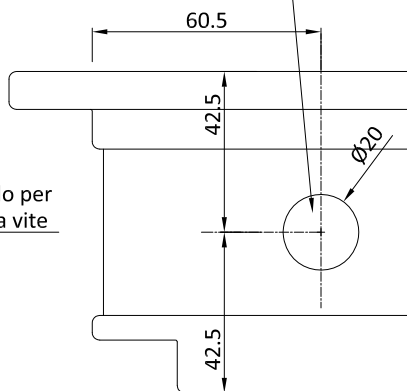
Lavorazione eseguibile
con maschera AT1001
*Tooling possible with
AT1001*



P.1127

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

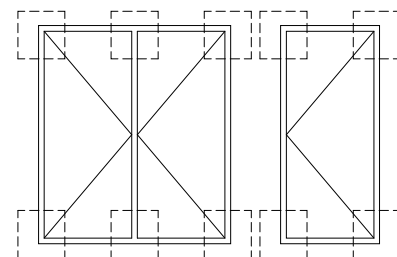
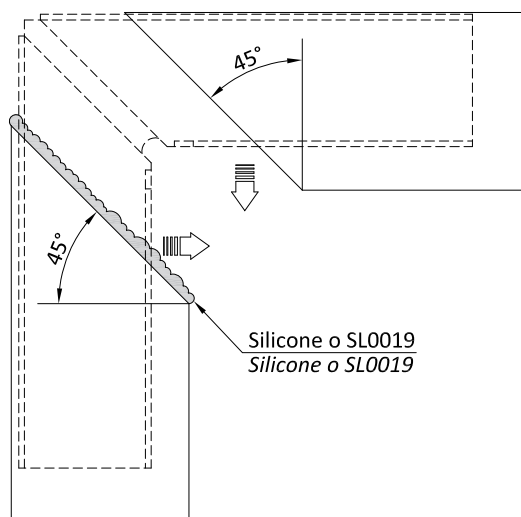
spina
pin



P.1112

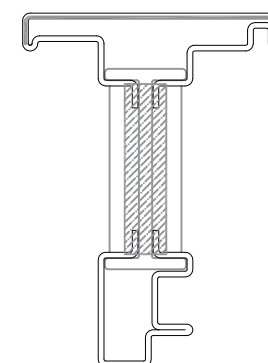
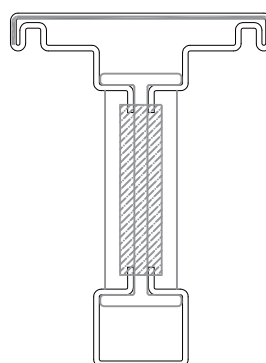
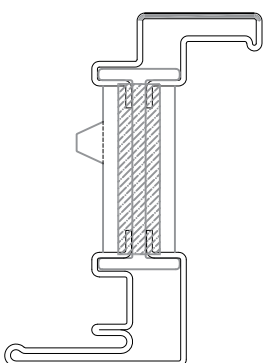
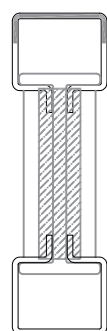
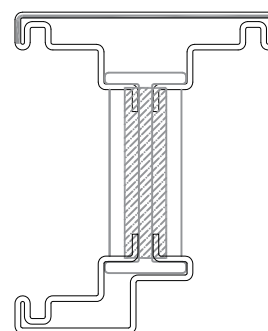
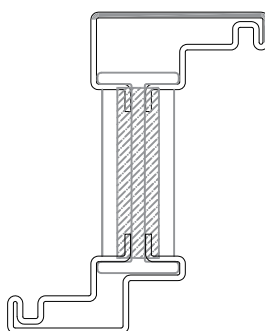
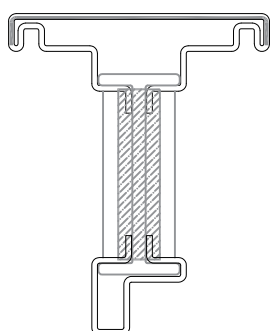
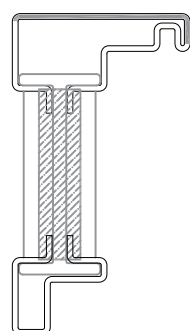
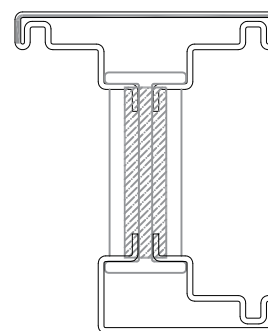
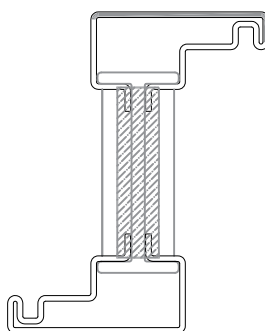
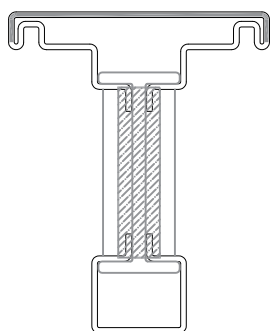
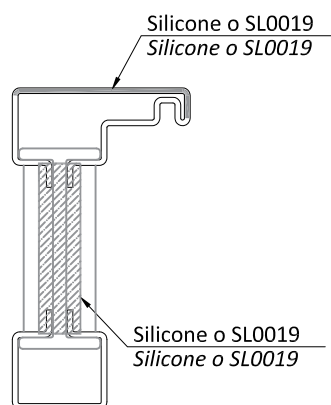
Abbassare il listello per
l'inserimento della vite
*Lower the strip to
insert screw*

spina
pin

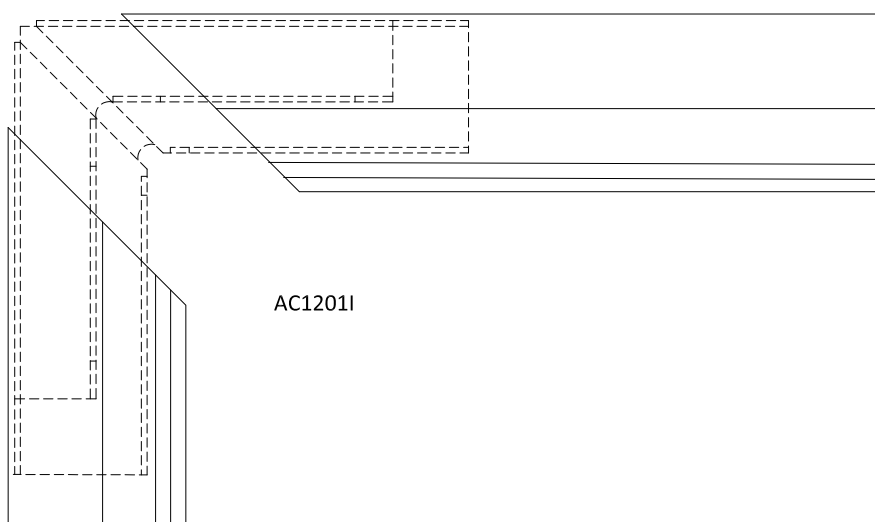


- 1) inserire la squadretta
- 2) siliconare nelle zone indicate
- 3) accostare i profili
- 4) procedere con la saldatura (vedasi pagine successive)

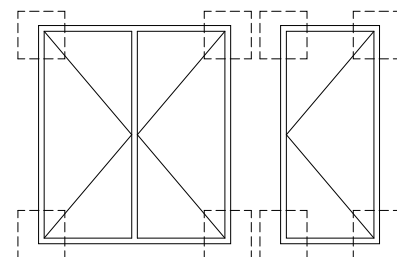
- 1) insert the bracket
- 2) seal in the specified areas
- 3) align the profiles
- 4) weld (see following pages)



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



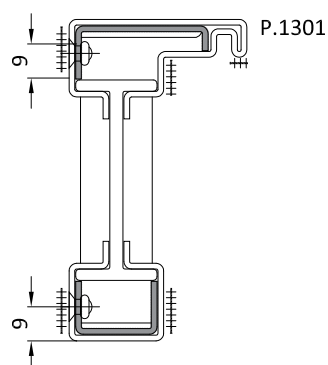
AC1201I



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

Sigillare tutte le superfici di contatto esterne con silicone o SL0019

 Rivetti svasati Ø 4

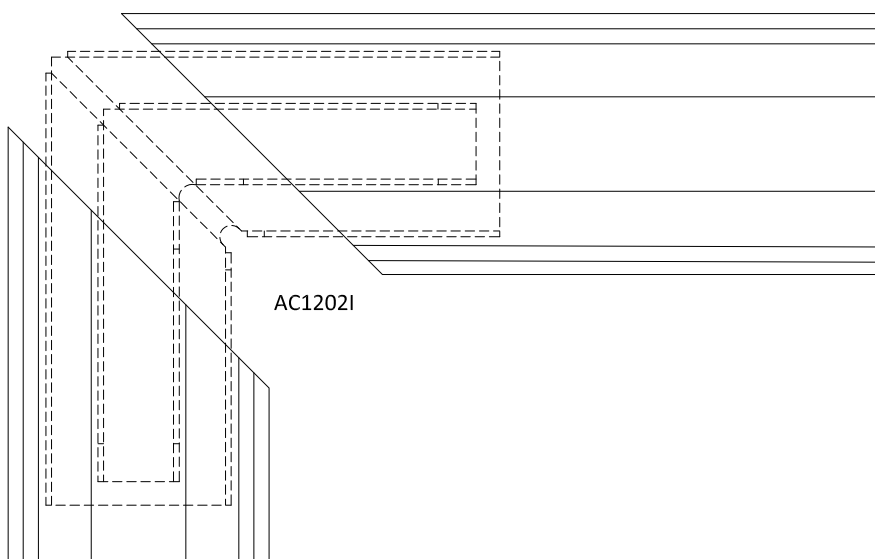


P.1301

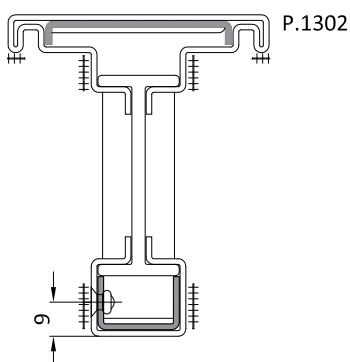
TIG welding with filler material in the areas indicated with +++++

Seal all the external contact surfaces with silicone or SL0019

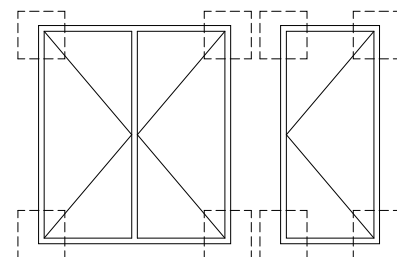
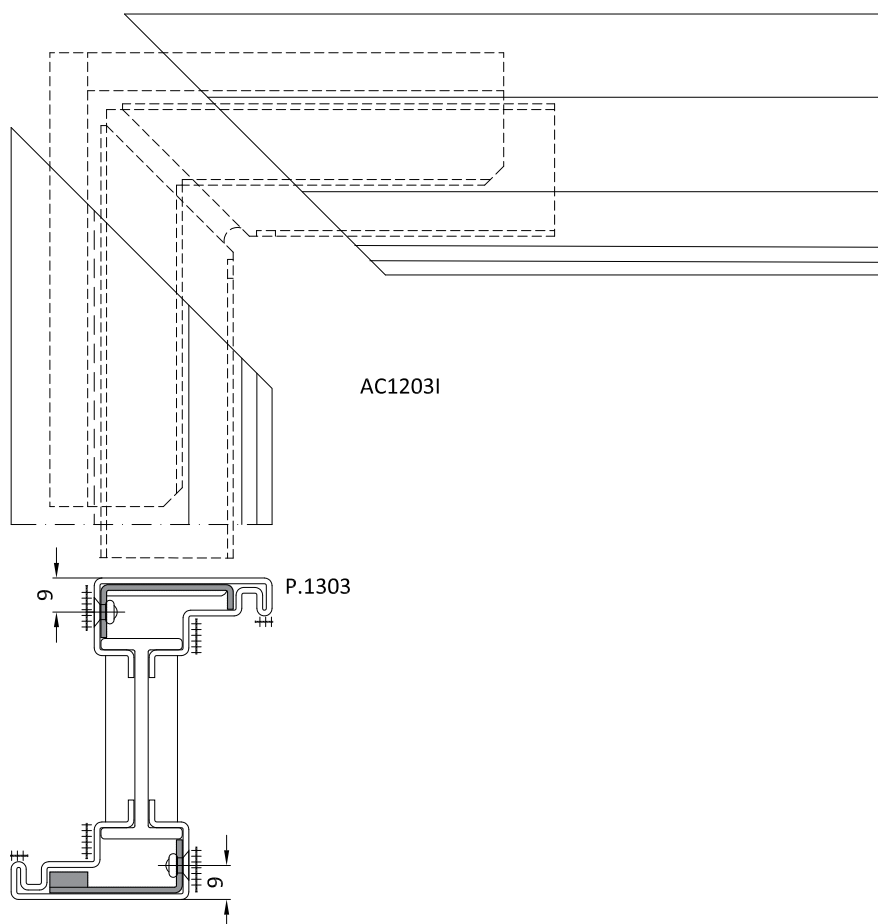
 Countersunk rivets Ø 4



AC1202I



P.1302



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

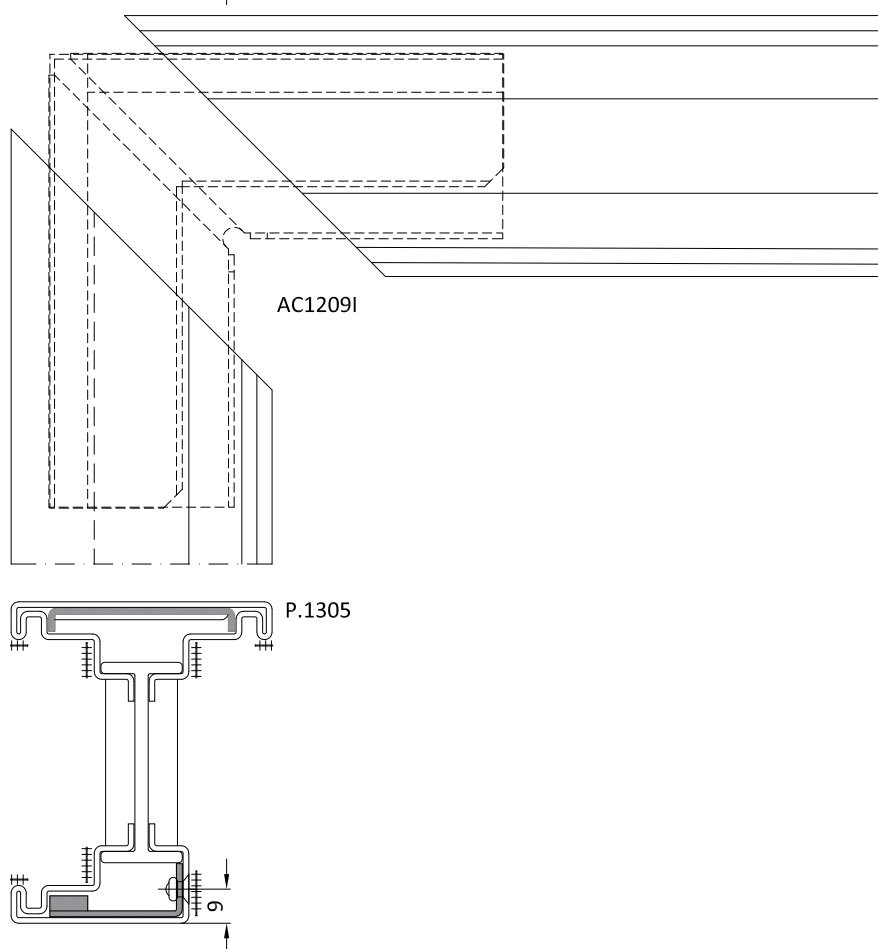
Sigillare tutte le superfici di contatto esterne con silicone o SL0019

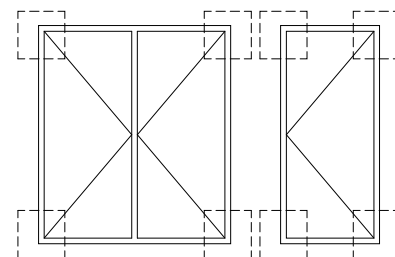
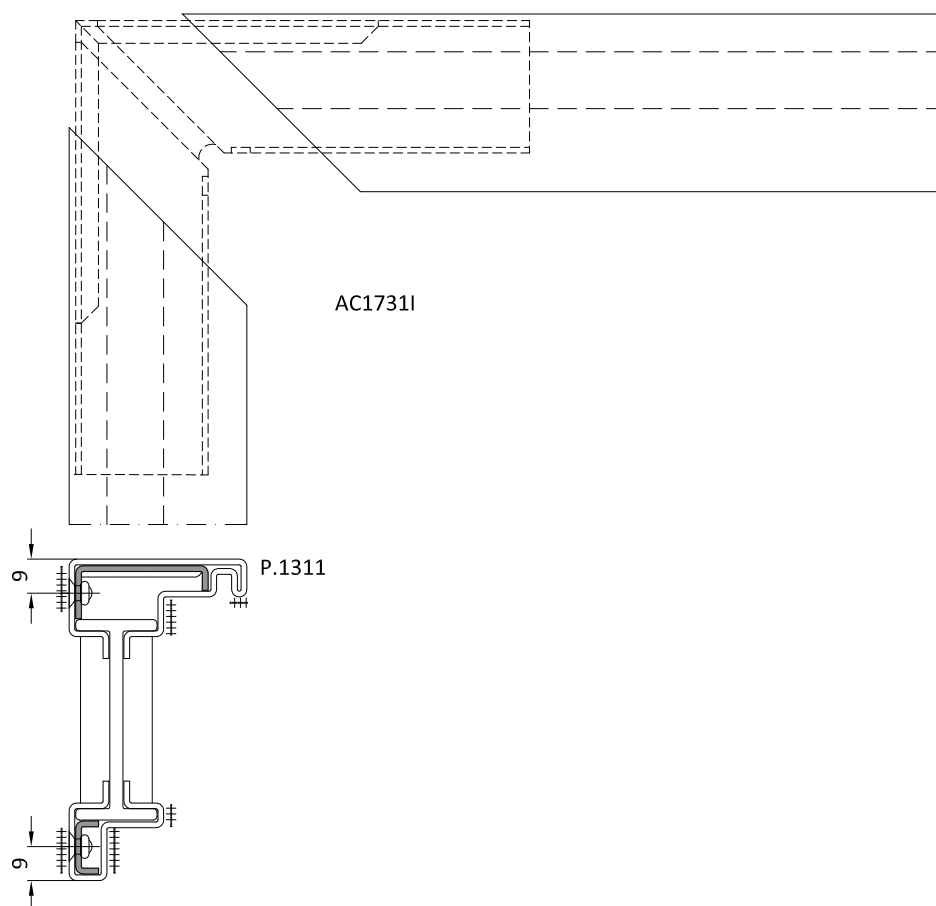
 Rivetti svasati Ø 4

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

Seal all the external contact surfaces with silicone or SL0019

 Countersunk rivets Ø 4





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

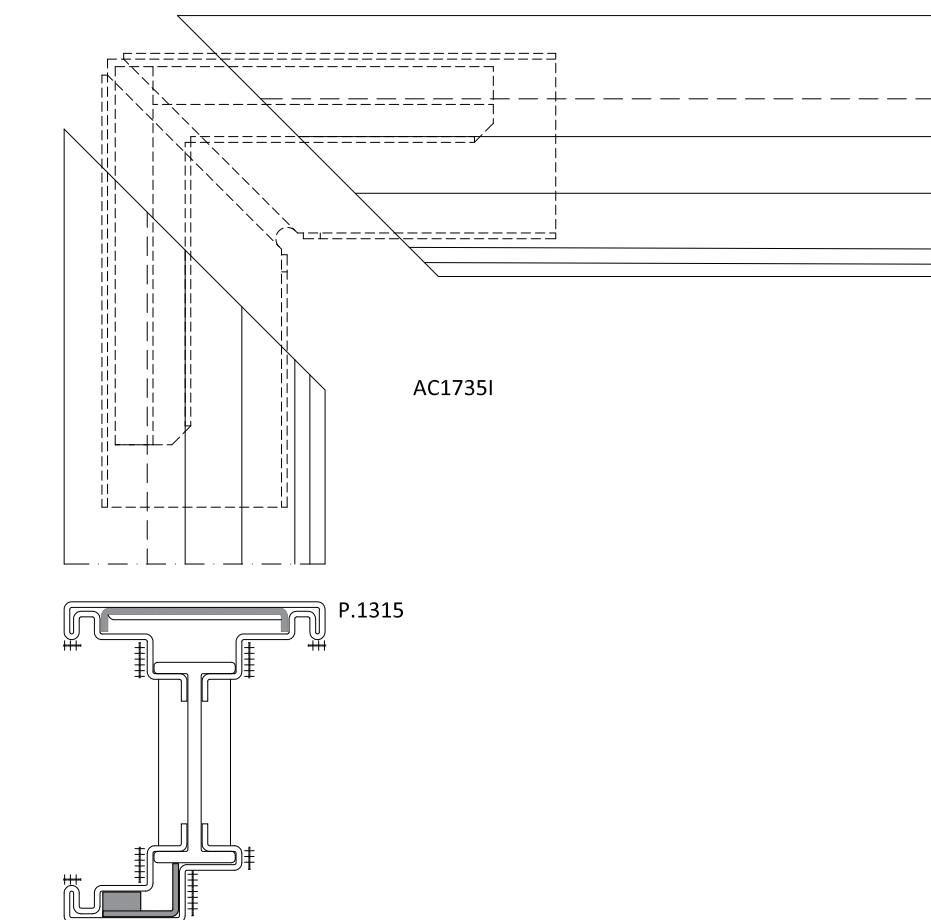
Sigillare tutte le superfici di contatto esterne con silicone o SL0019

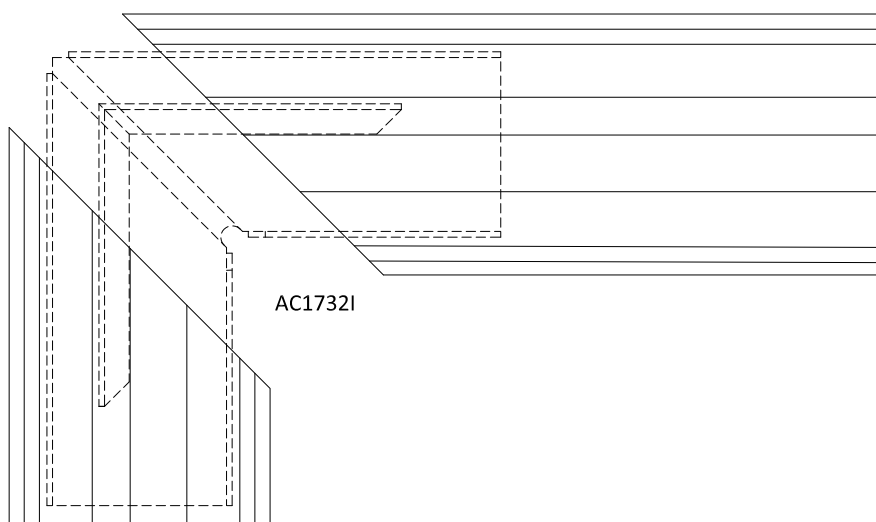
 Rivetti svasati Ø 4

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

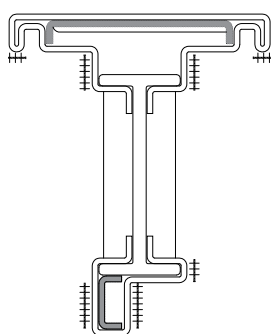
Seal all the external contact surfaces with silicone our SL0019

 Countersunk rivets Ø 4

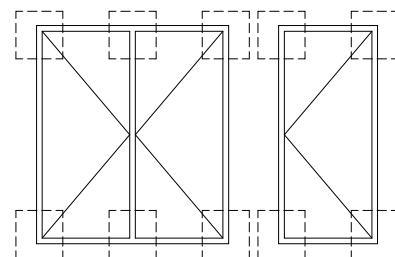




AC1732I



P.1312



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

Sigillare tutte le superfici di contatto
esterne con silicone o SL0019



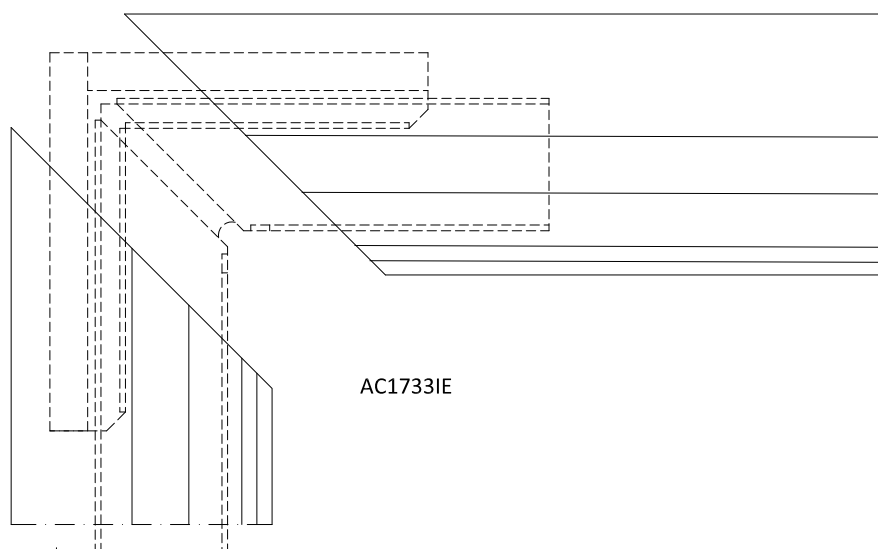
Rivetti svasati Ø 4

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

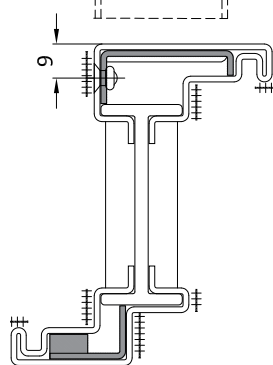
*Seal all the external contact surfaces
with silicone our SL0019*



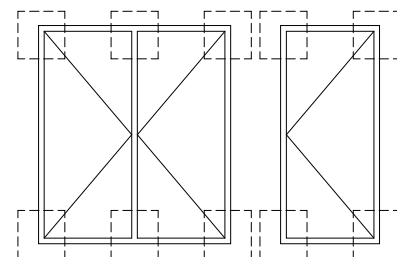
Countersunk rivets Ø 4



AC1733IE



P.1313 (telaio | frame)



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

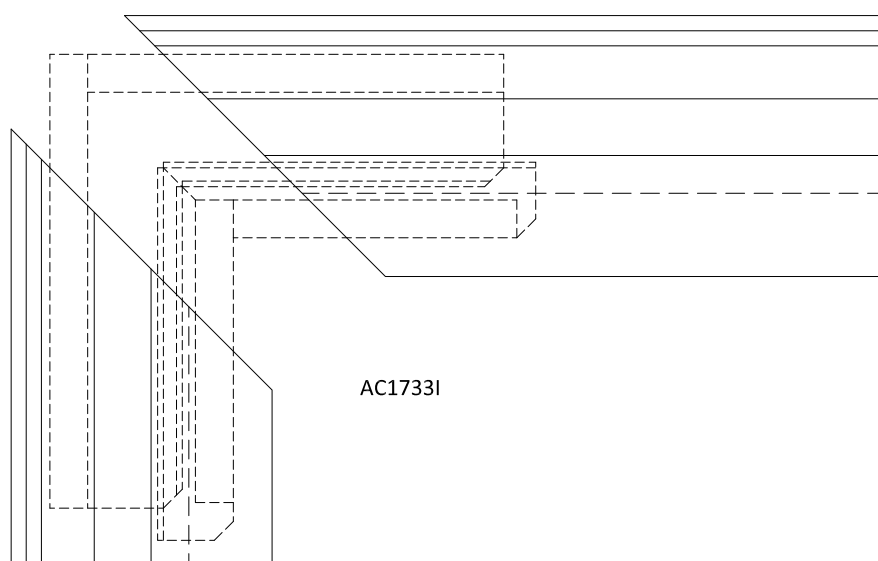
Sigillare tutte le superfici di contatto esterne con silicone o SL0019

 Rivetti svasati Ø 4

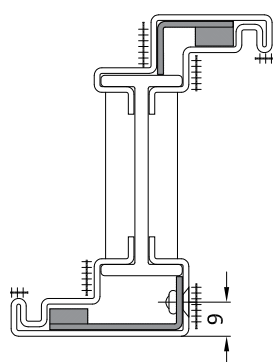
TIG welding with filler material in the areas indicated with +++++

Seal all the external contact surfaces with silicone or SL0019

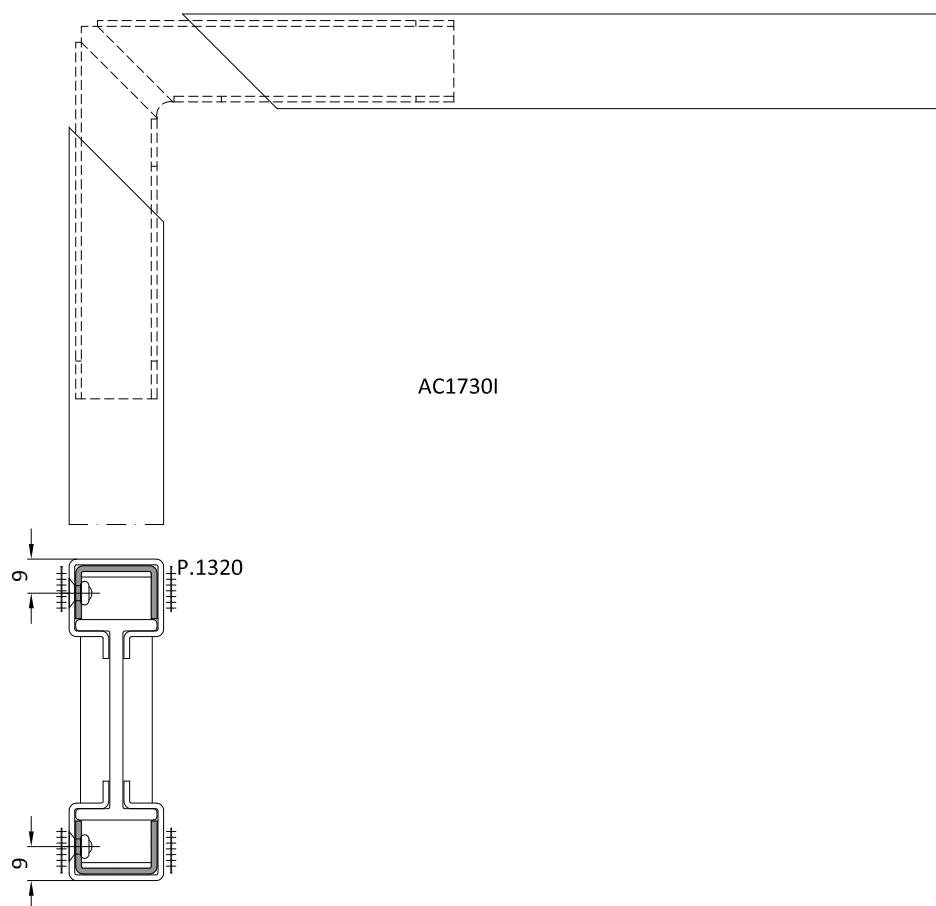
 Countersunk rivets Ø 4



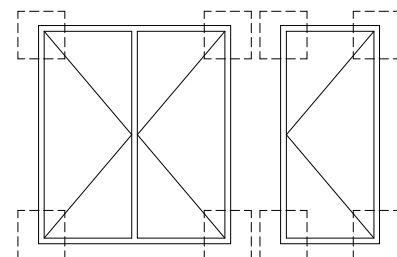
AC1733I



P.1313 (anta | leaf)



AC1730I



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

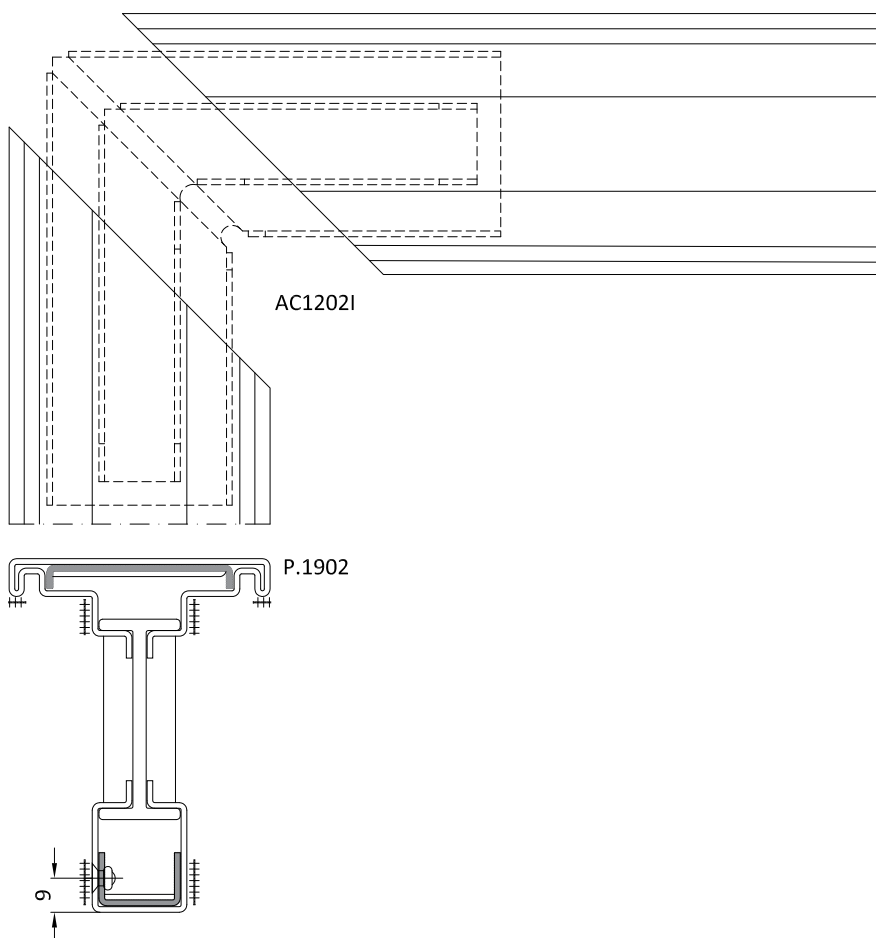
Sigillare tutte le superfici di contatto esterne con silicone o SL0019

 Rivetti svasati Ø 4

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

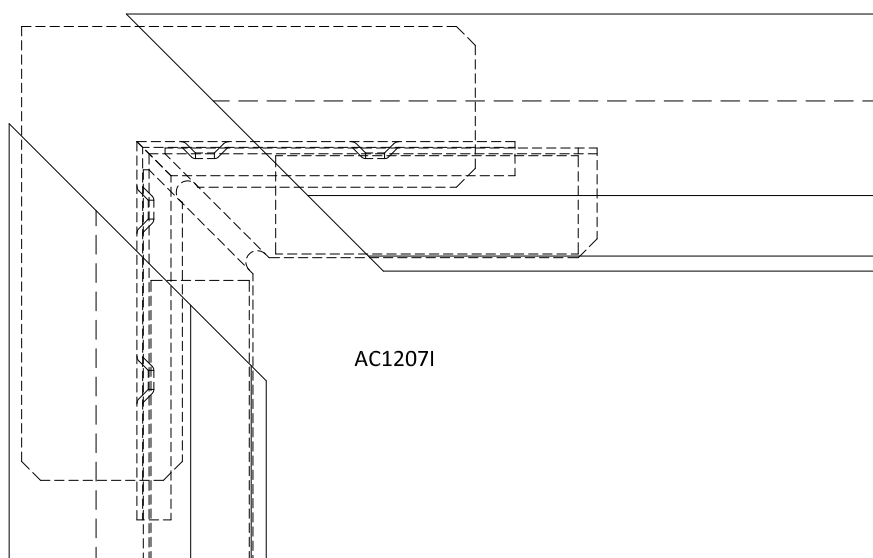
Seal all the external contact surfaces with silicone or SL0019

 Countersunk rivets Ø 4

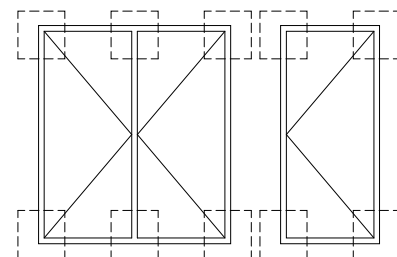


AC1202I

P.1902



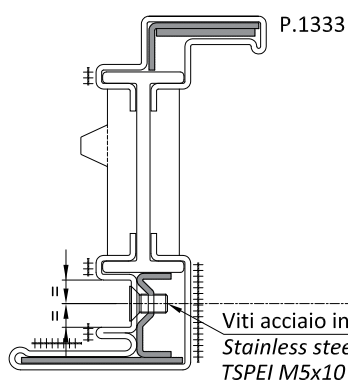
AC1207I



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

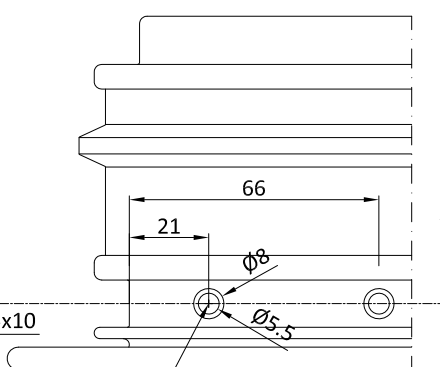
Sigillare tutte le superfici di contatto esterne con silicone o SL0019

 Rivetti svasati Ø 4



P.1333

Viti acciaio inox TSPEI M5x10
Stainless steel screws
TSPEI M5x10



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

Seal all the external contact surfaces with silicone our SL0019

 Countersunk rivets Ø 4

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

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

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

Sigillare tutte le superfici di contatto
esterne con silicone o SL0019

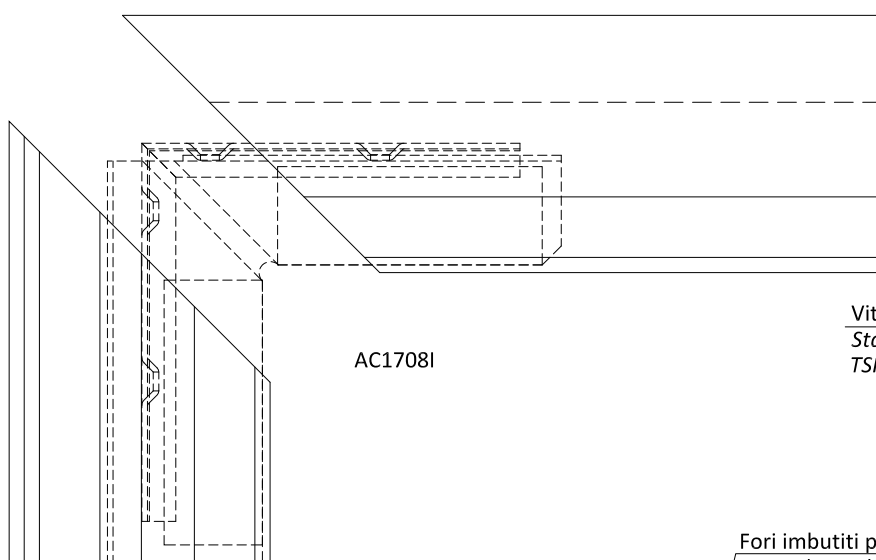
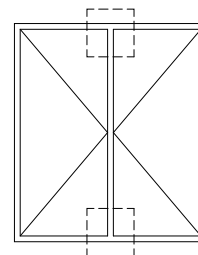
*Seal all the external contact surfaces
with silicone our SL0019*



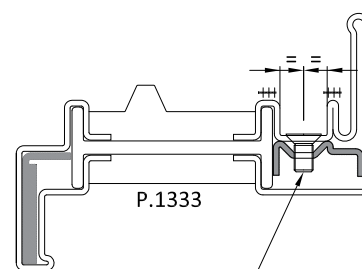
 Rivetti svasati Ø 4



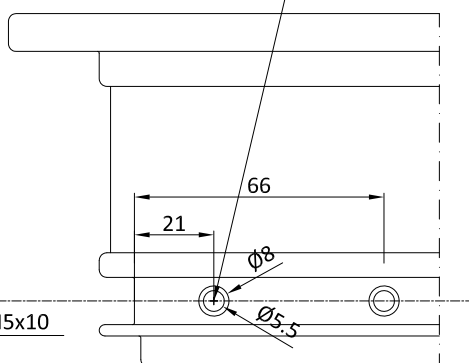
 Countersunk rivets Ø 4



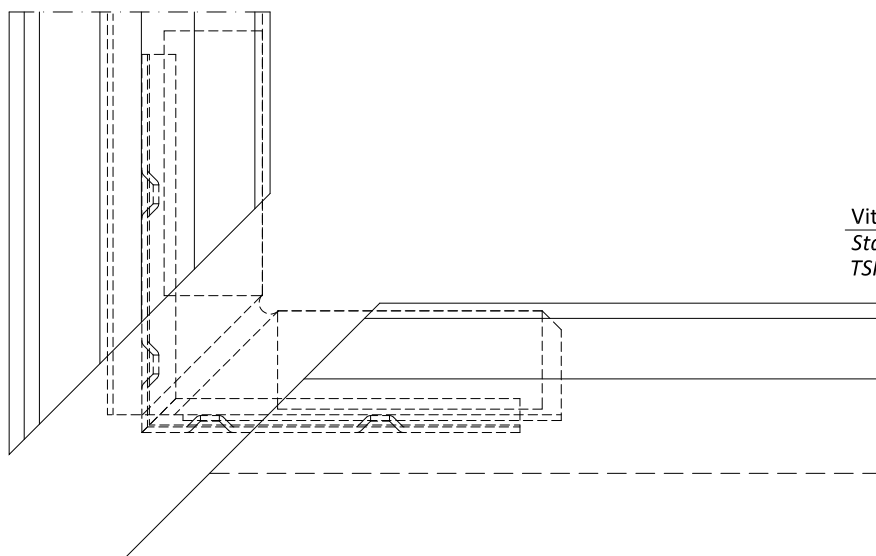
Viti acciaio inox TSPEI M5x10
Stainless steel screws
TSPEI M5x10



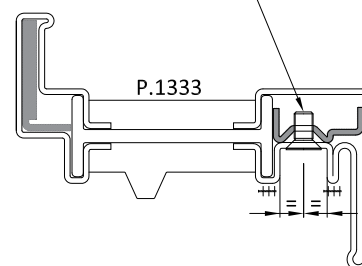
Fori imbutiti per Viti TSPEI M5x10 con stampo AT1233
Deep-drawn holes for TSPEI M5x10 screws with mould AT1233

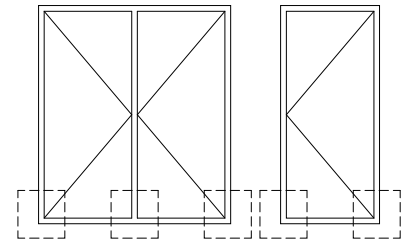
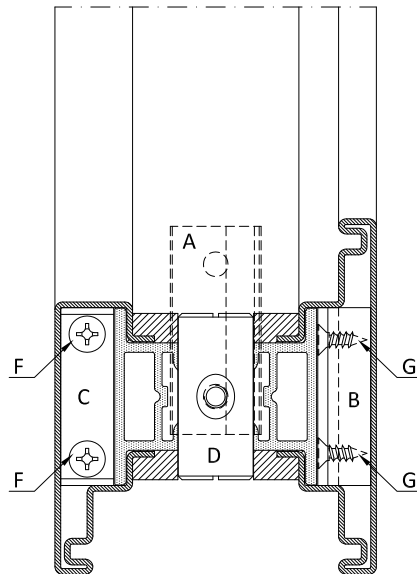
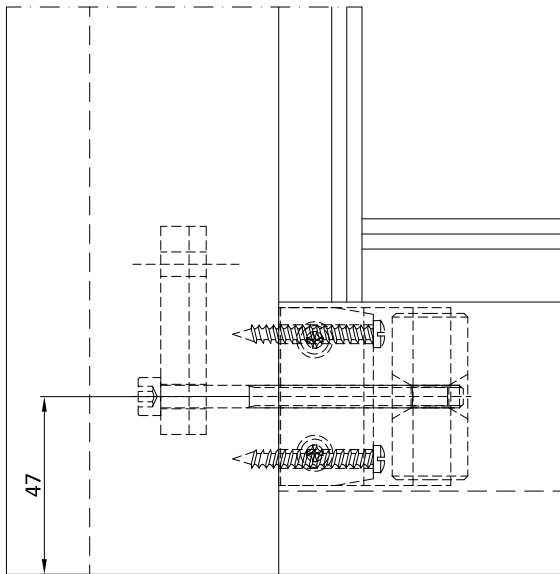


Viti acciaio inox TSPEI M5x10
Stainless steel screws
TSPEI M5x10



Viti acciaio inox TSPEI M5x10
Stainless steel screws
TSPEI M5x10





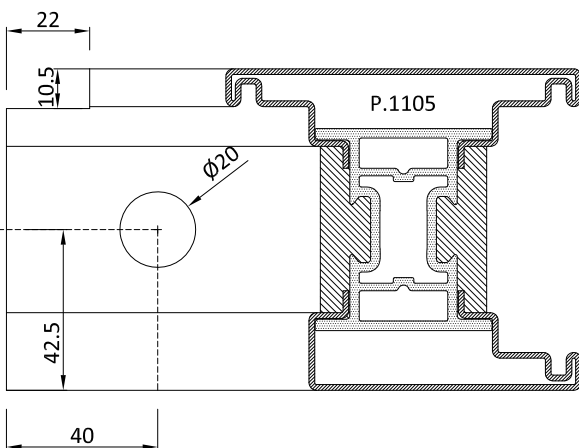
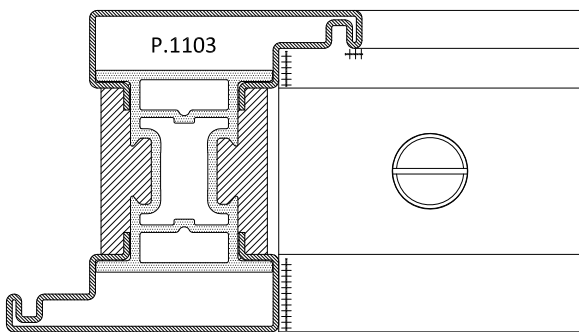
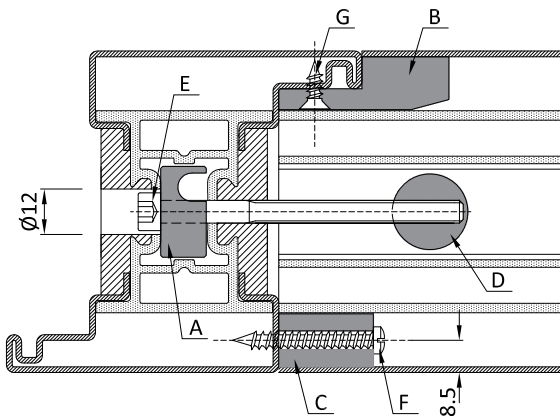
Saldare a TIG con materiale di riporto nelle zone indicate con +-----+

Sigillare tutte le superfici di contatto con silicone o SL0019

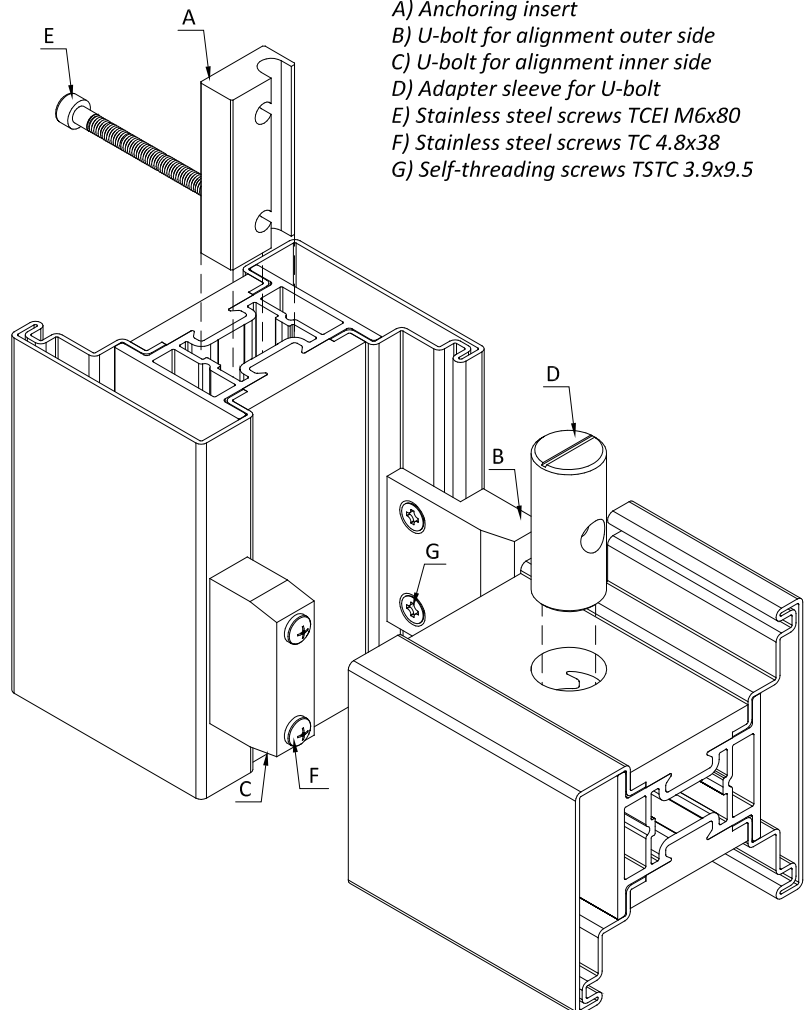
- A) Inserto di fissaggio
- B) Cavallotto di allineamento lato esterno
- C) Cavallotto di allineamento lato interno
- D) Tirante per cavallotto
- E) Vite acciaio inox TCEI M6x80
- F) Vite acciaio inox TC 4.8x38
- G) Vite autofilettante TSTC 3.9x9.5

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

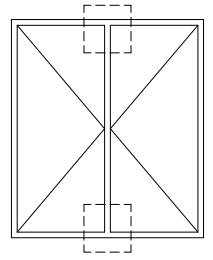
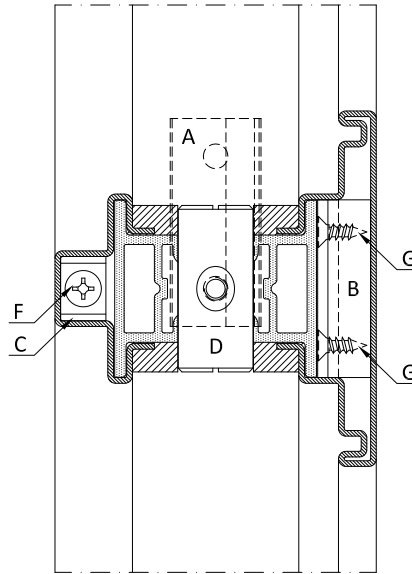
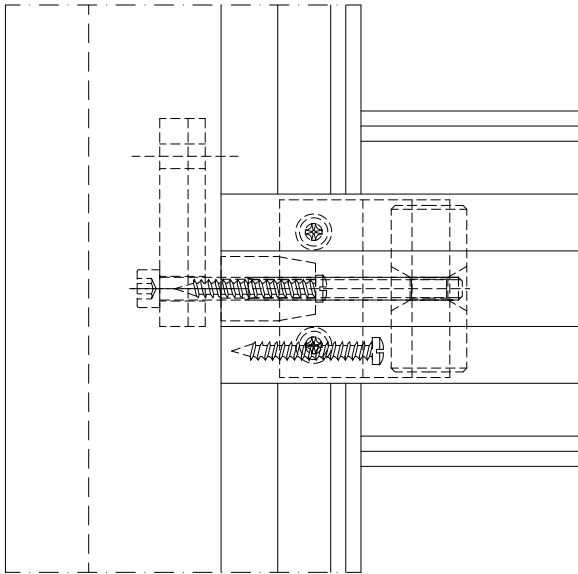
Seal all the external contact surfaces with silicone or SL0019



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



Lavorazione valida per profili P.1101 - P.1102 - 1105
Tooling valid for profiles P.1101 - P.1102 - P.1105



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

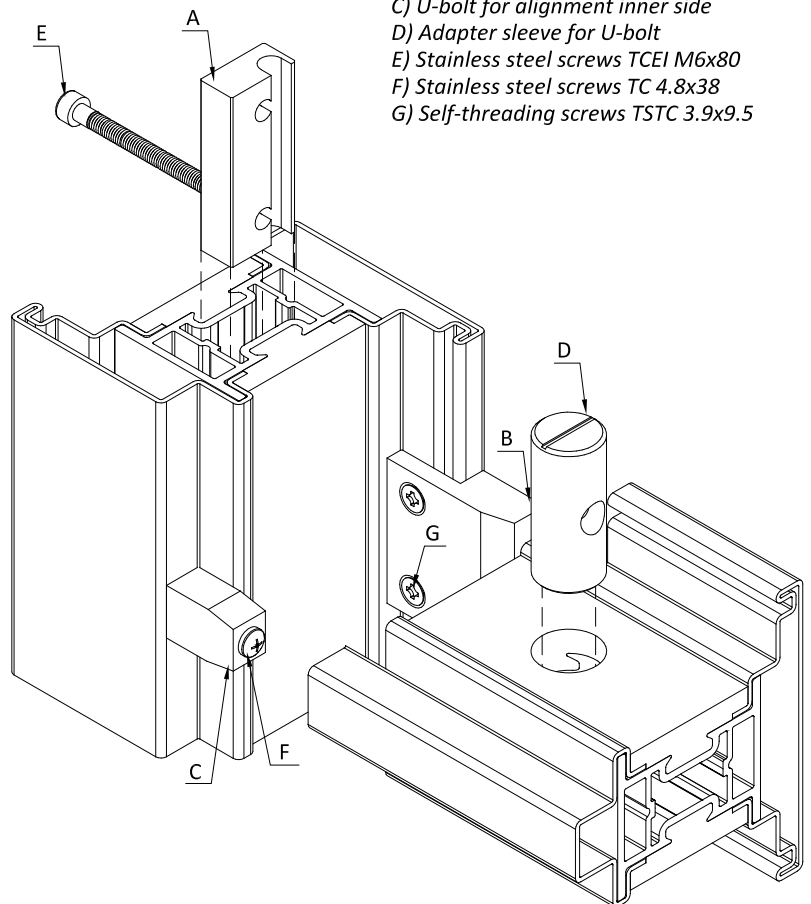
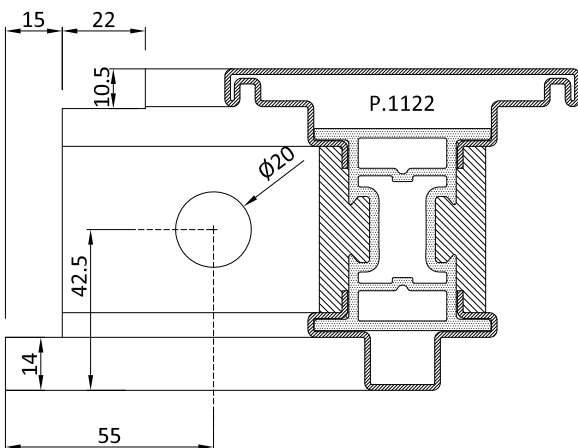
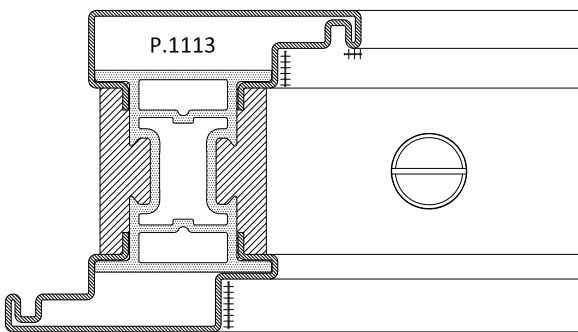
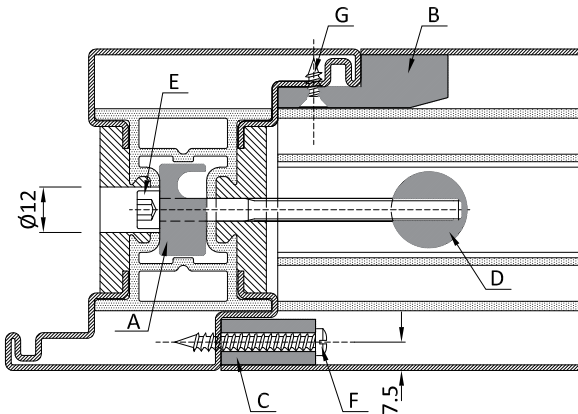
Sigillare tutte le superfici di contatto con silicone o SL0019

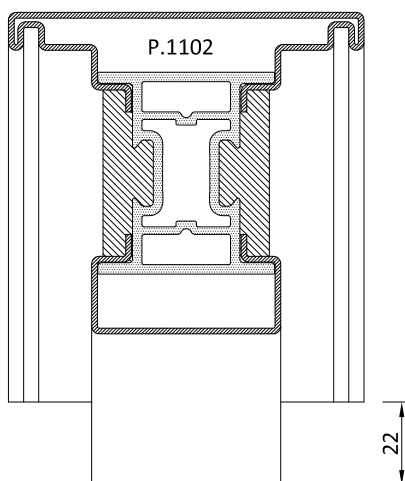
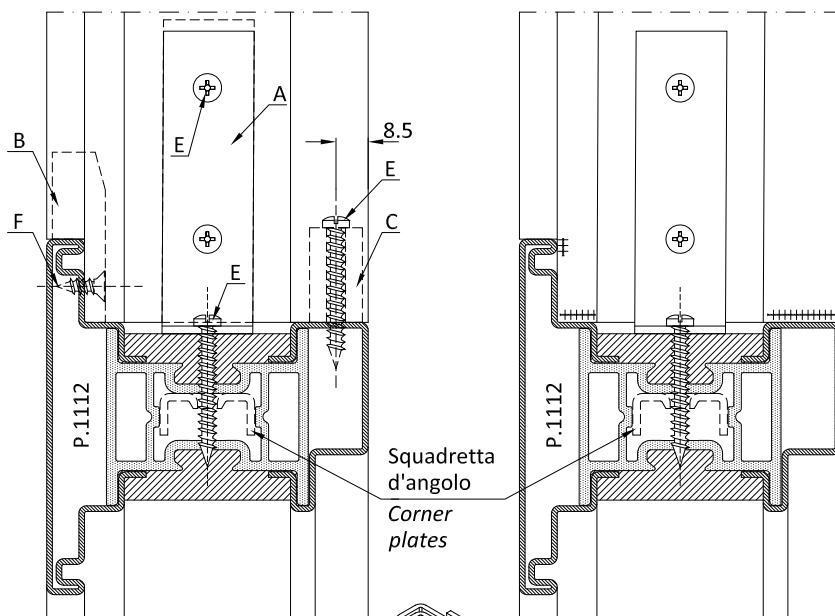
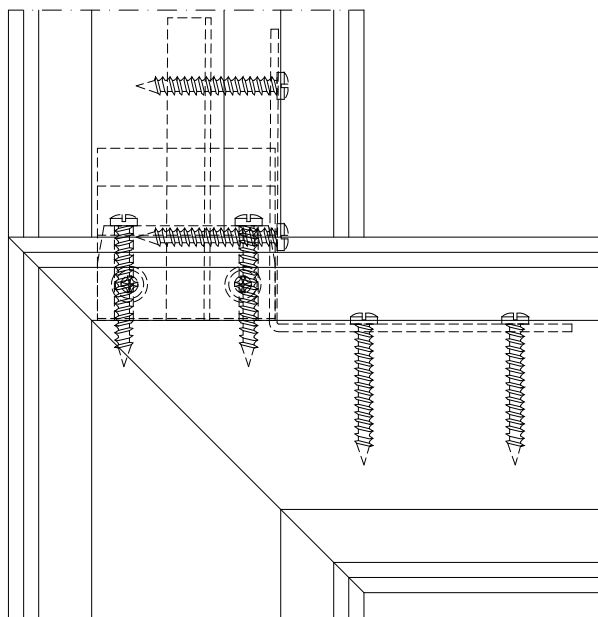
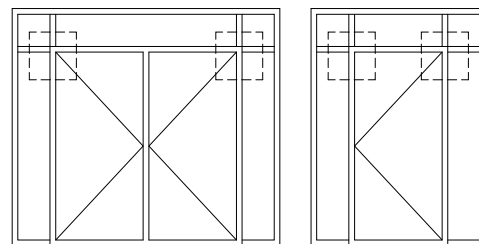
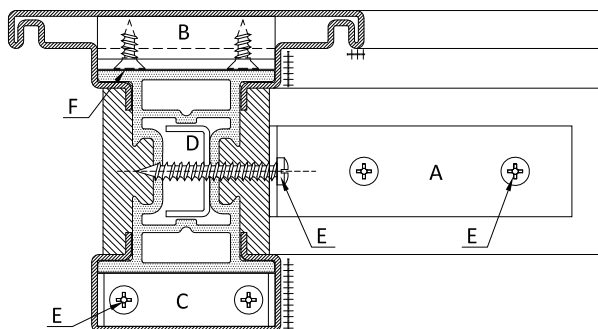
- A) Inserto di fissaggio
- B) Cavallotto di allineamento lato esterno
- C) Cavallotto di allineamento lato interno
- D) Tirante per cavallotto
- E) Vite acciaio inox TCEI M6x80
- F) Vite acciaio inox TC 4.8x38
- G) Vite autofilettante TSTC 3.9x9.5

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

Seal all the external contact surfaces with silicone or SL0019

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





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

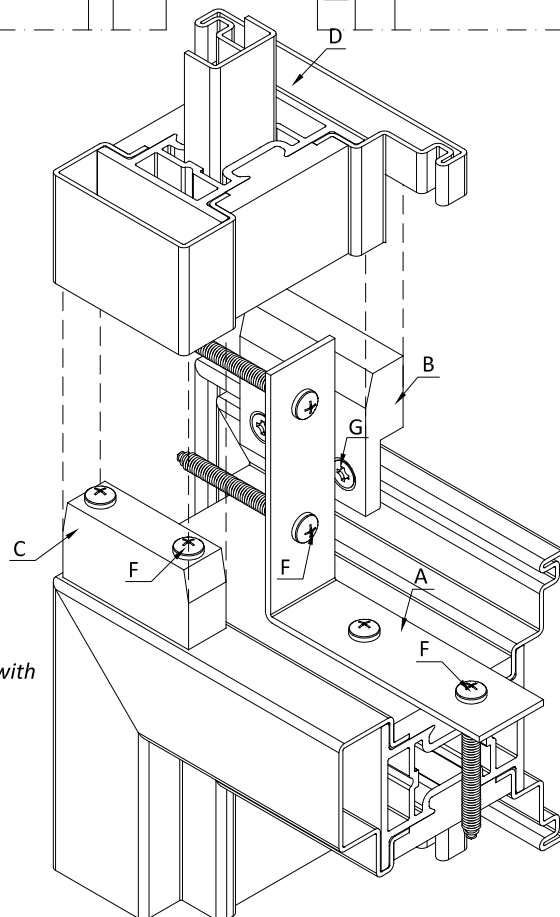
Sigillare tutte le superfici di contatto con silicone o SL0019

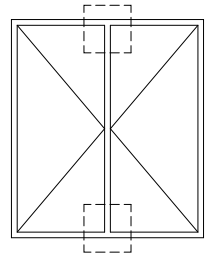
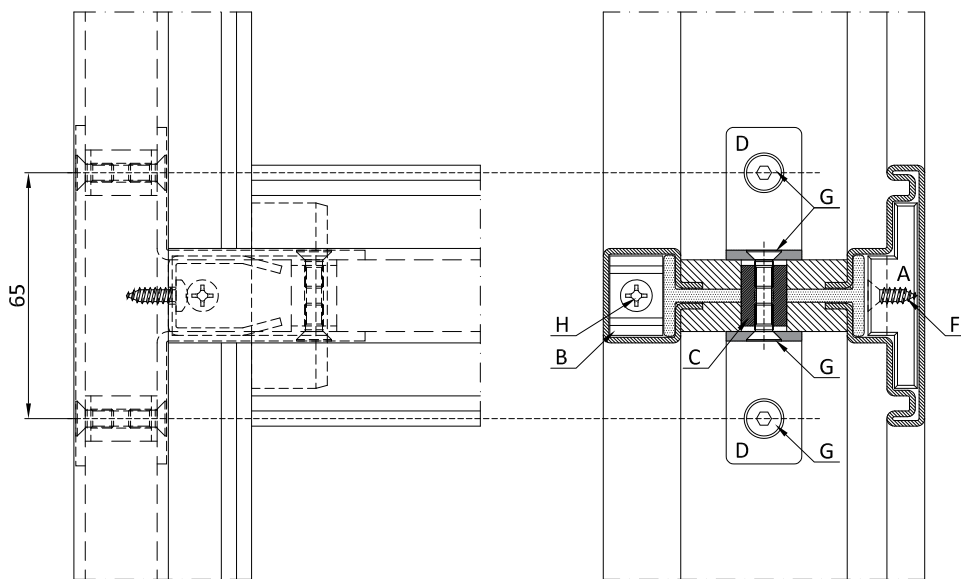
- A) Squadretta giunzione 90°
- B) Cavallotto di allineamento lato esterno
- C) Cavallotto di allineamento lato interno
- D) Rinforzo interno
- E) Vite acciaio inox TC 4.8x38
- F) Vite autofilettante TSTC 3.9x9.5

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

Seal all the external contact surfaces with silicone or SL0019

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





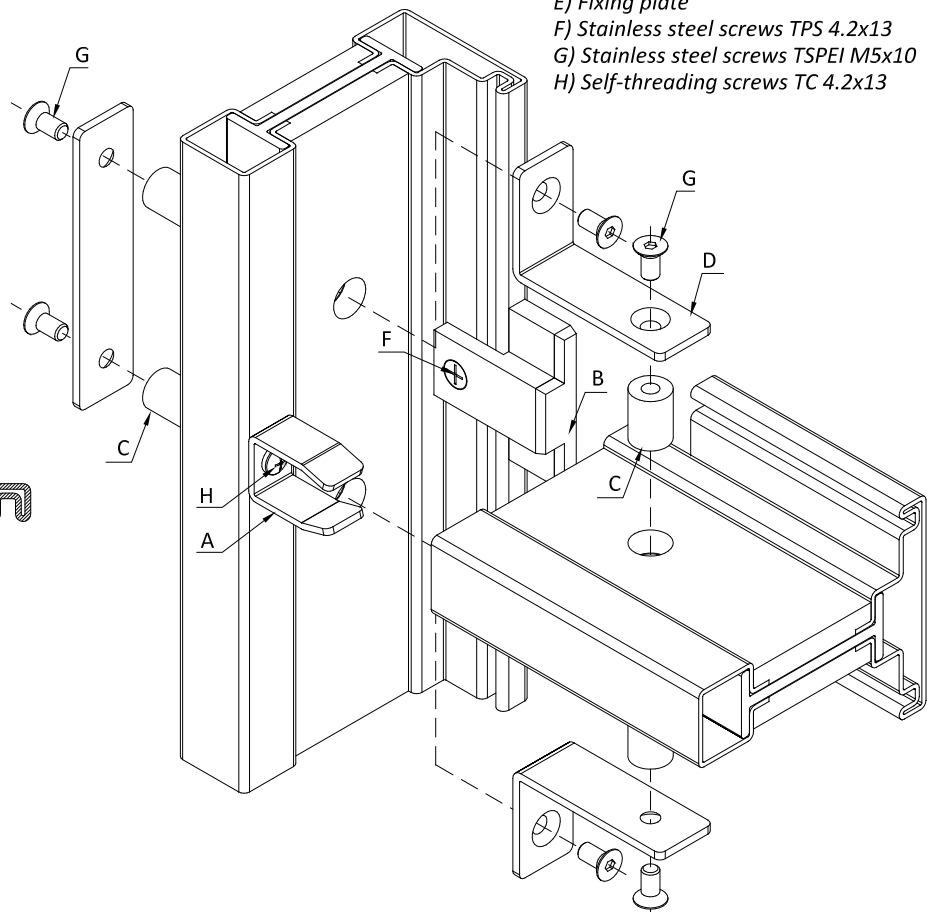
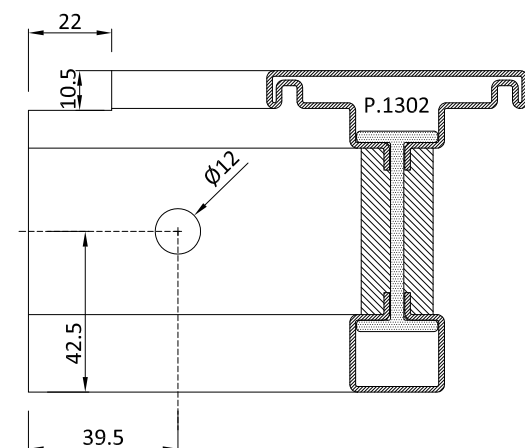
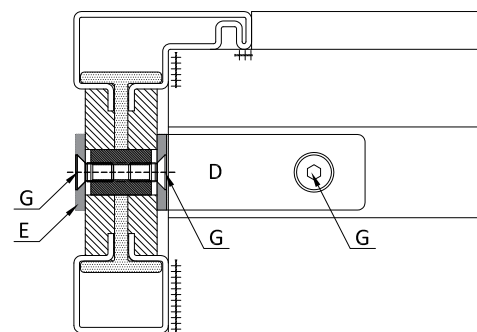
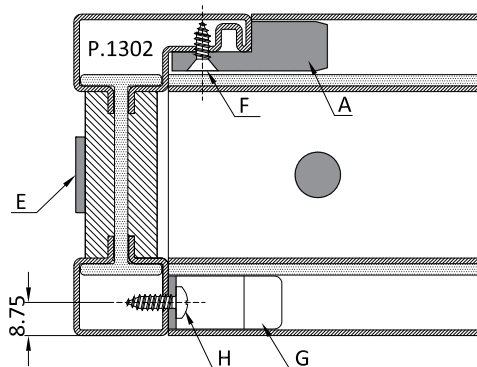
Saldare a TIG con materiale di riporto nelle zone indicate con +++++

Sigillare tutte le superfici di contatto con silicone o SL0019

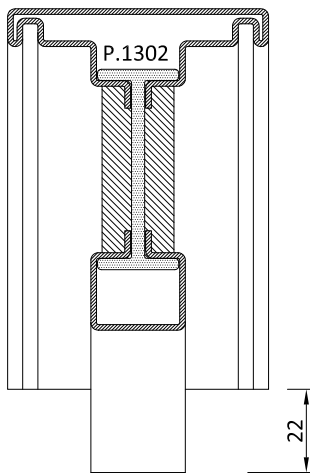
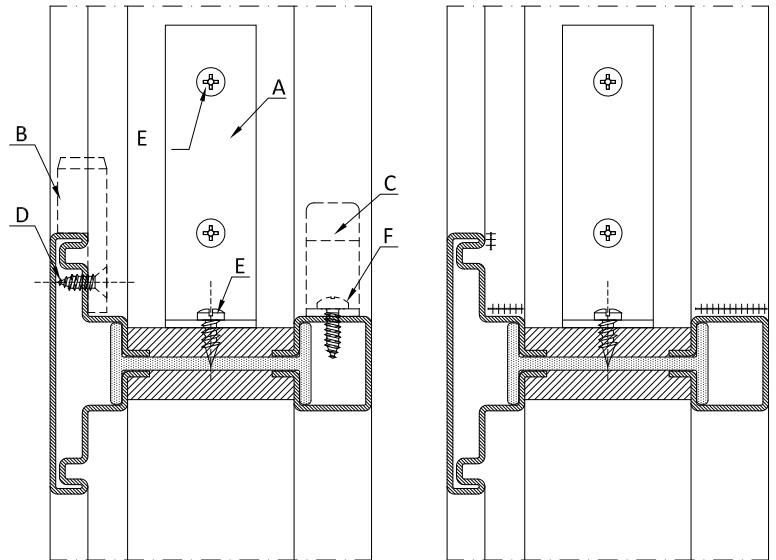
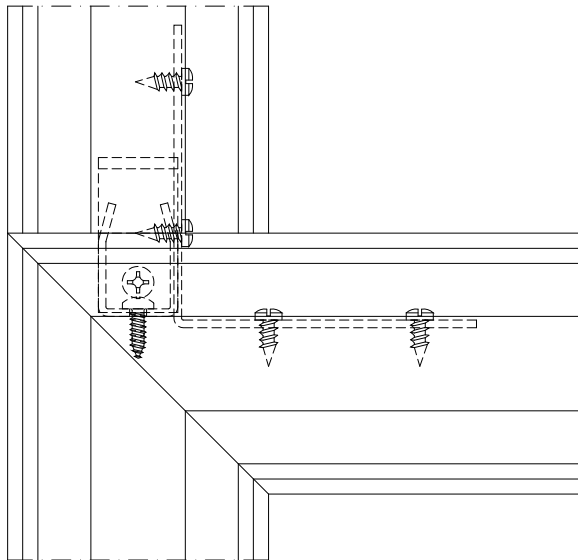
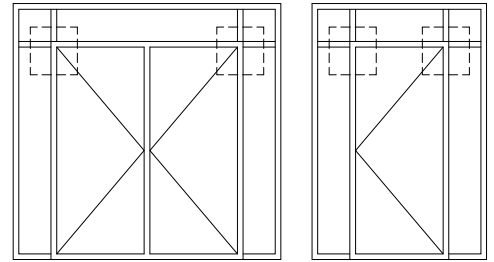
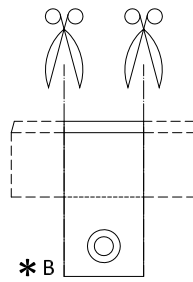
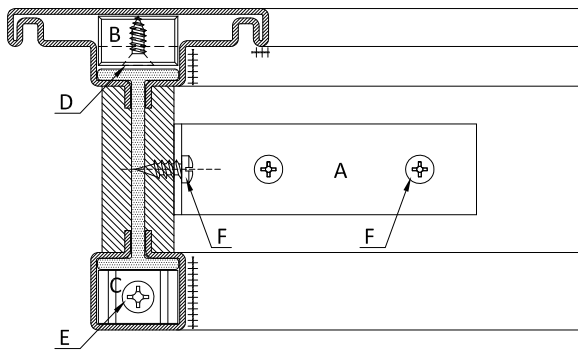
- A) Cavallotto di allineamento lato interno
- B) Cavallotto di allineamento lato esterno
- C) Bussola filettata
- D) Squadretta di tiraggio
- E) Piastrina di fissaggio
- F) Vite acciaio inox TPS 4.2x13
- G) Vite acciaio inox TSPEI M5x10
- H) Vite autofilettante TC 4.2x13

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

Seal all the external contact surfaces with silicone or SL0019



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



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

Sigillare tutte le superfici di contatto con silicone o SL0019

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

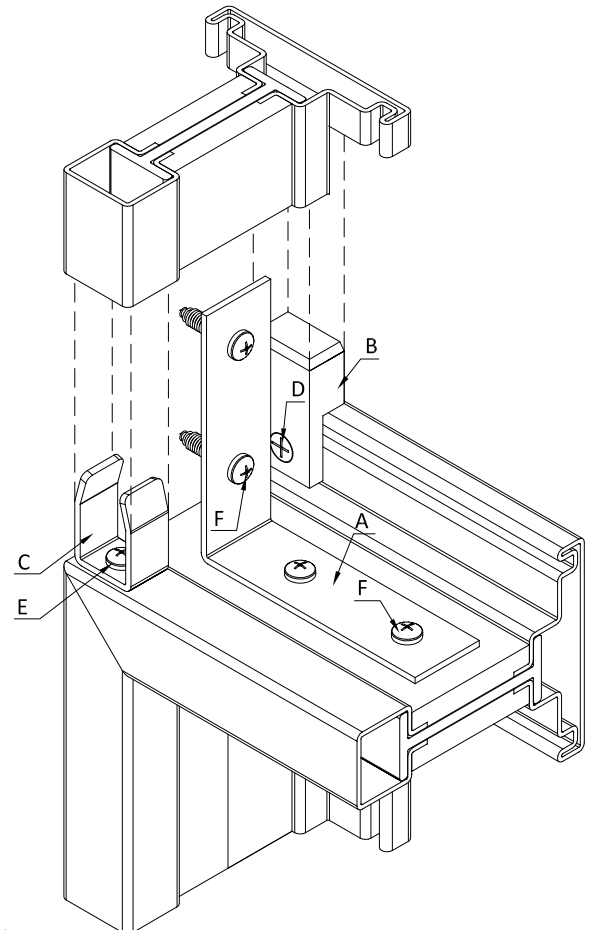
* Tagliare le alette del cavallo B come da disegno

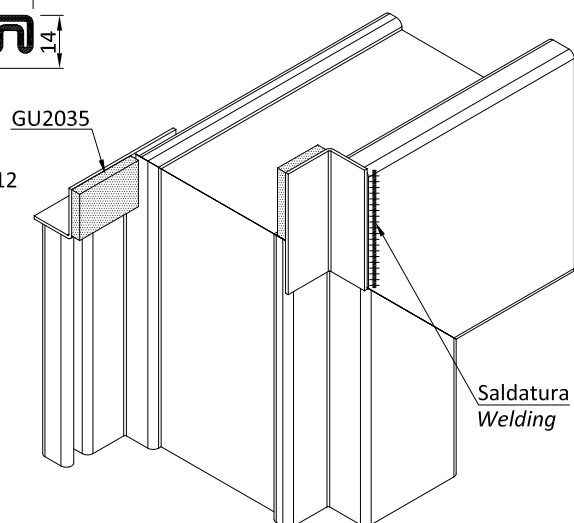
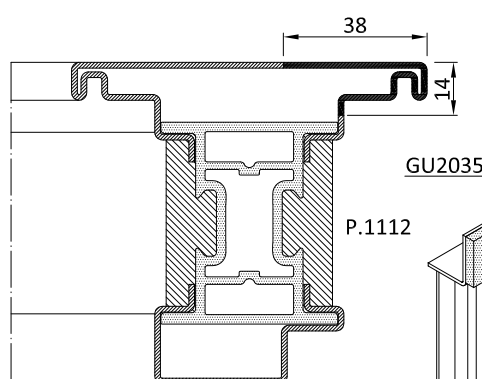
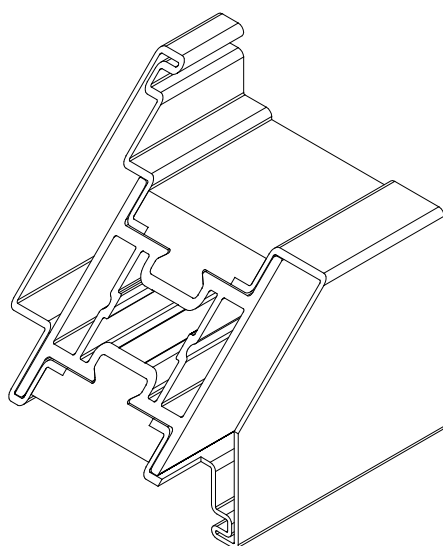
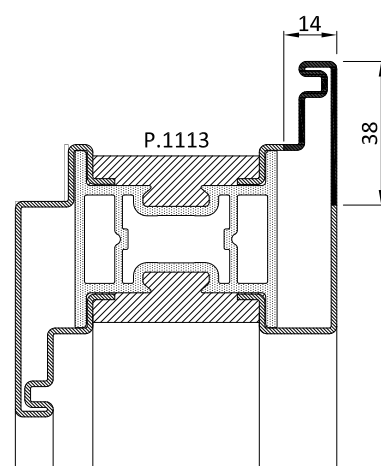
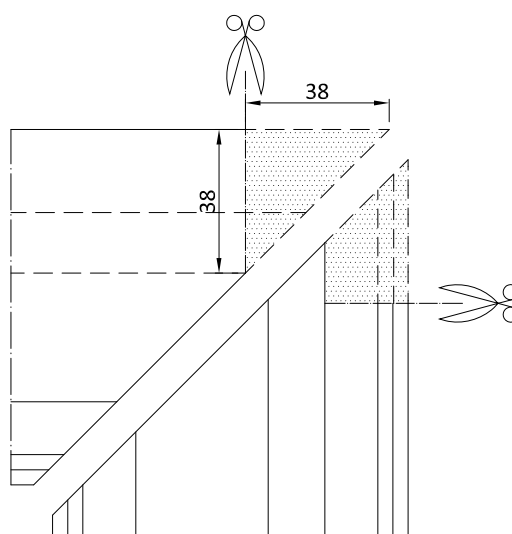
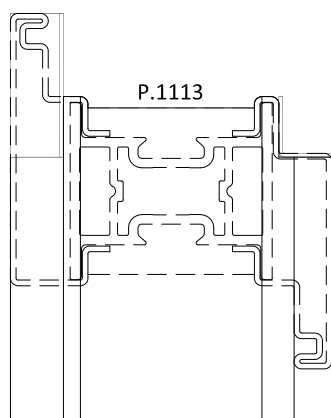
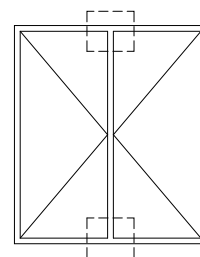
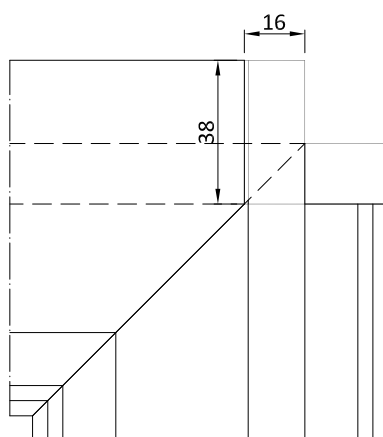
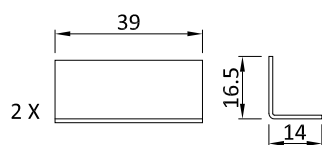
TIG welding with filler material in the areas indicated with +++++

Seal all the external contact surfaces with silicone or SL0019

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

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



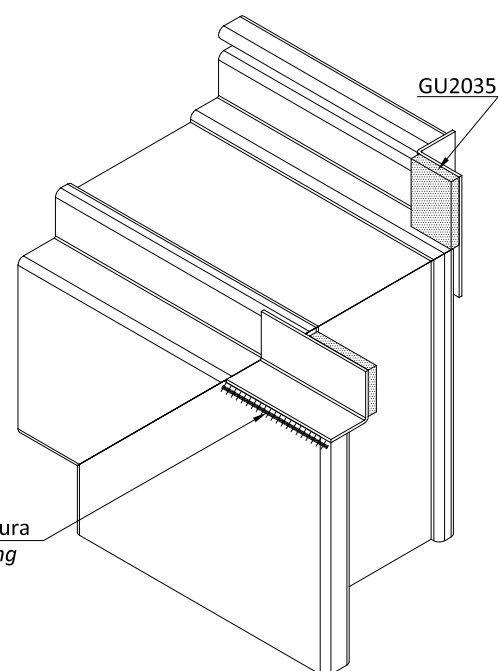
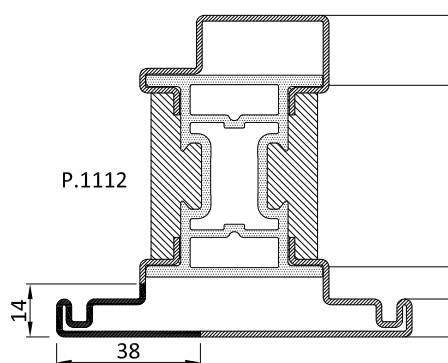
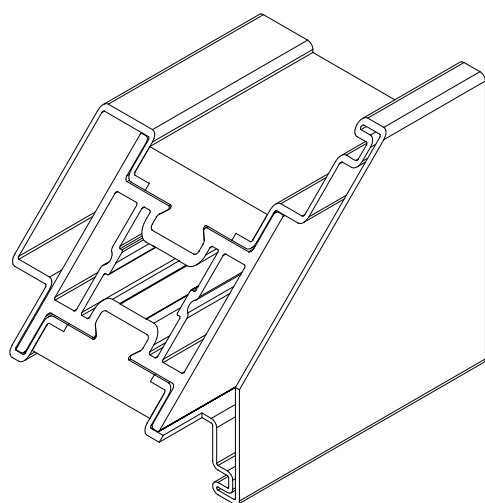
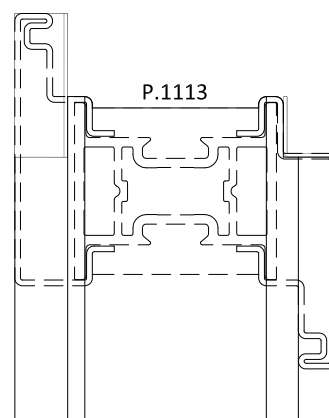
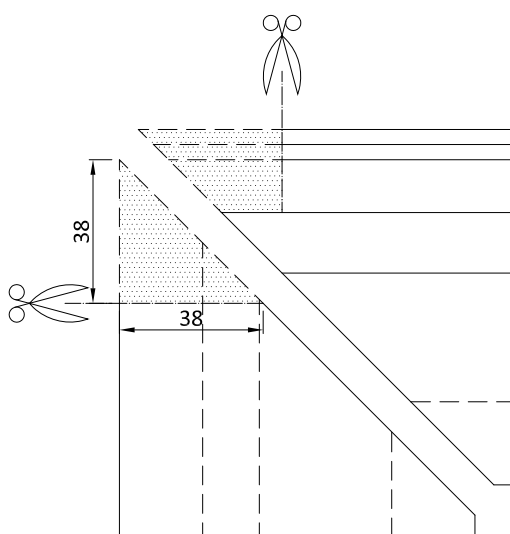
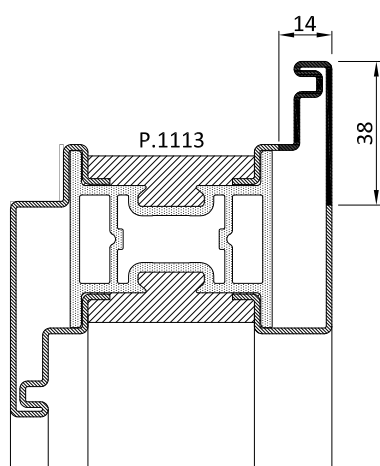
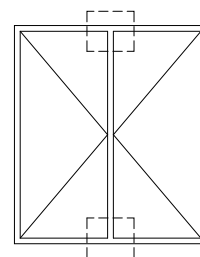
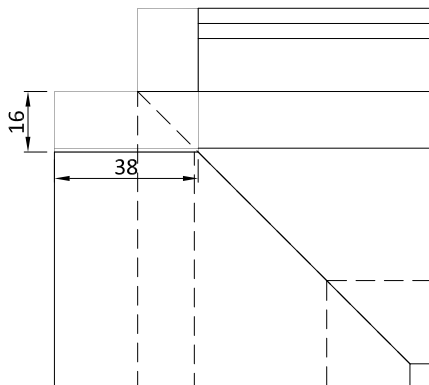
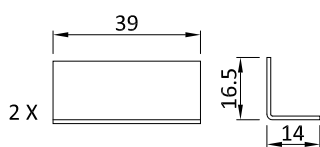


Nota: Saldare e sigillare l'accessorio secondo la tipologia e la mano di apertura

Note: Weld and seal the AC1014 according to the typology and the hand of opening

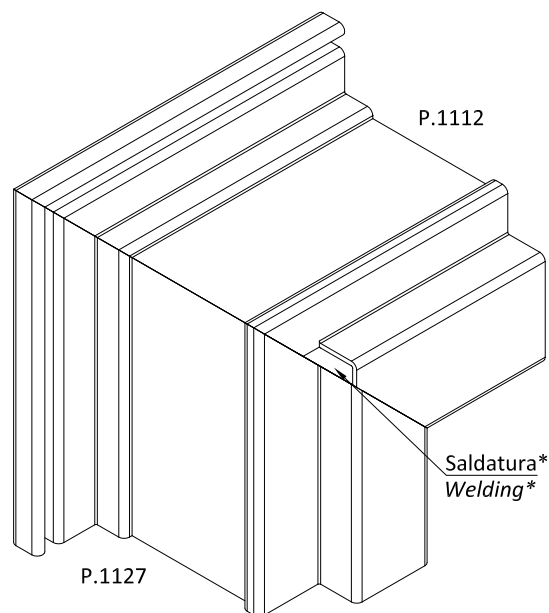
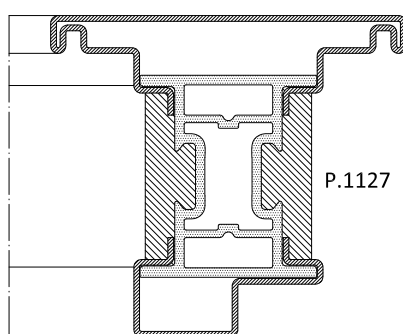
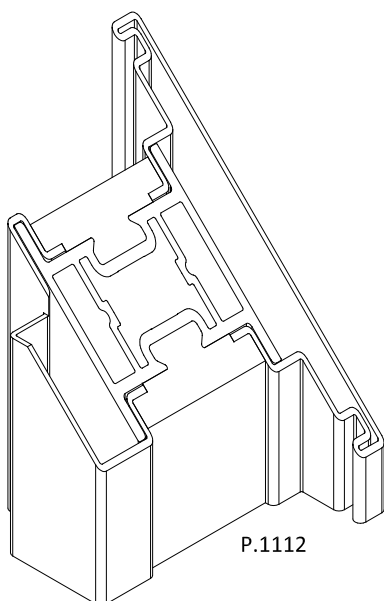
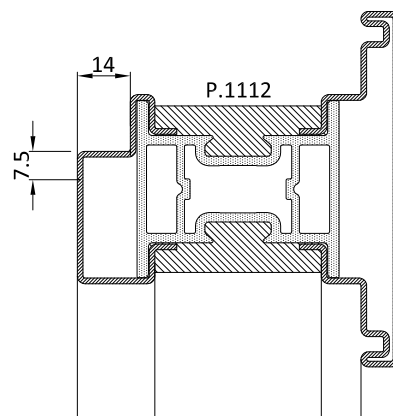
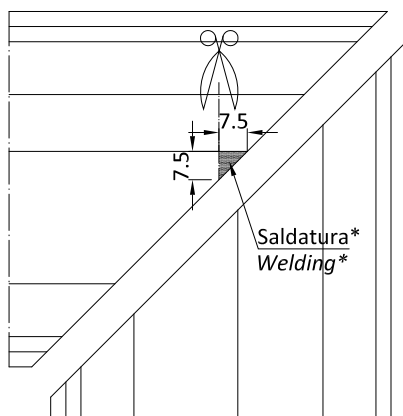
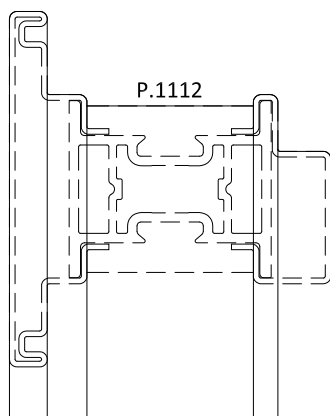
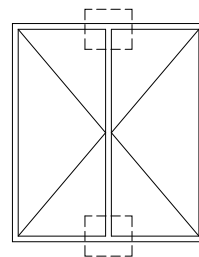
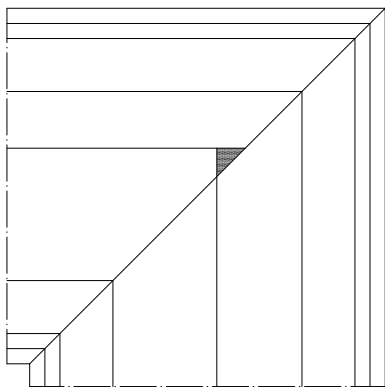
Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura

Note: strike plates are provided with larger dimensions. They have to be trimmed after welding

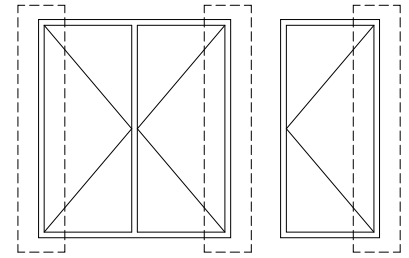
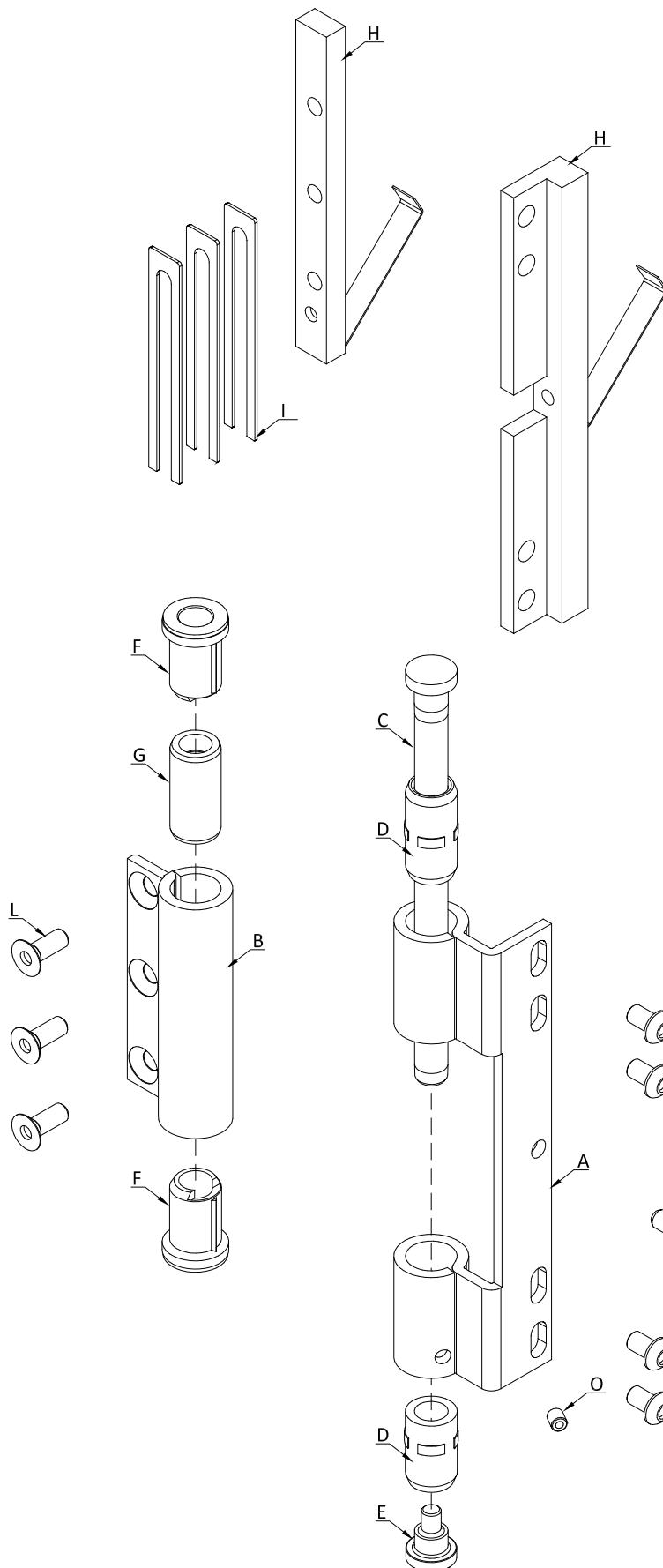


Nota: Saldare e sigillare l'accessorio secondo la tipologia e la mano di apertura
Note: Weld and seal the AC1014 according to the typology and the hand of opening

Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura
Note: strike plates are provided with larger dimensions. They have to be trimmed after welding

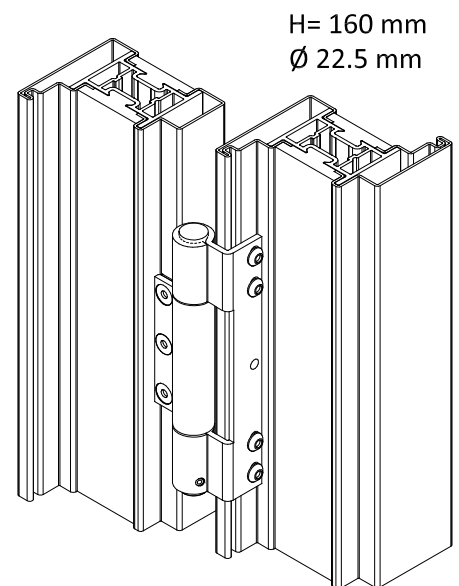


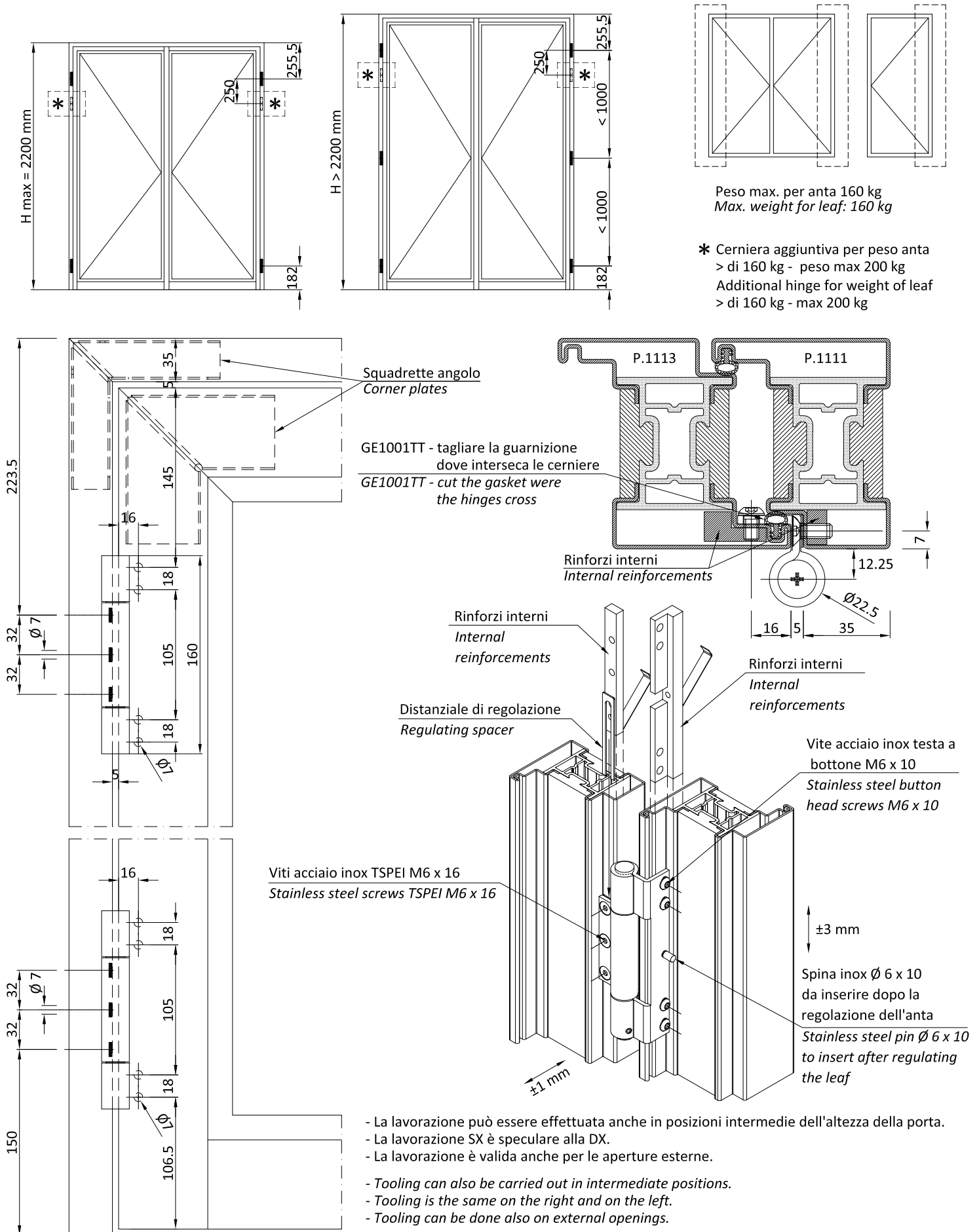
* Saldare con materiale di riporto
* Welding with filler material

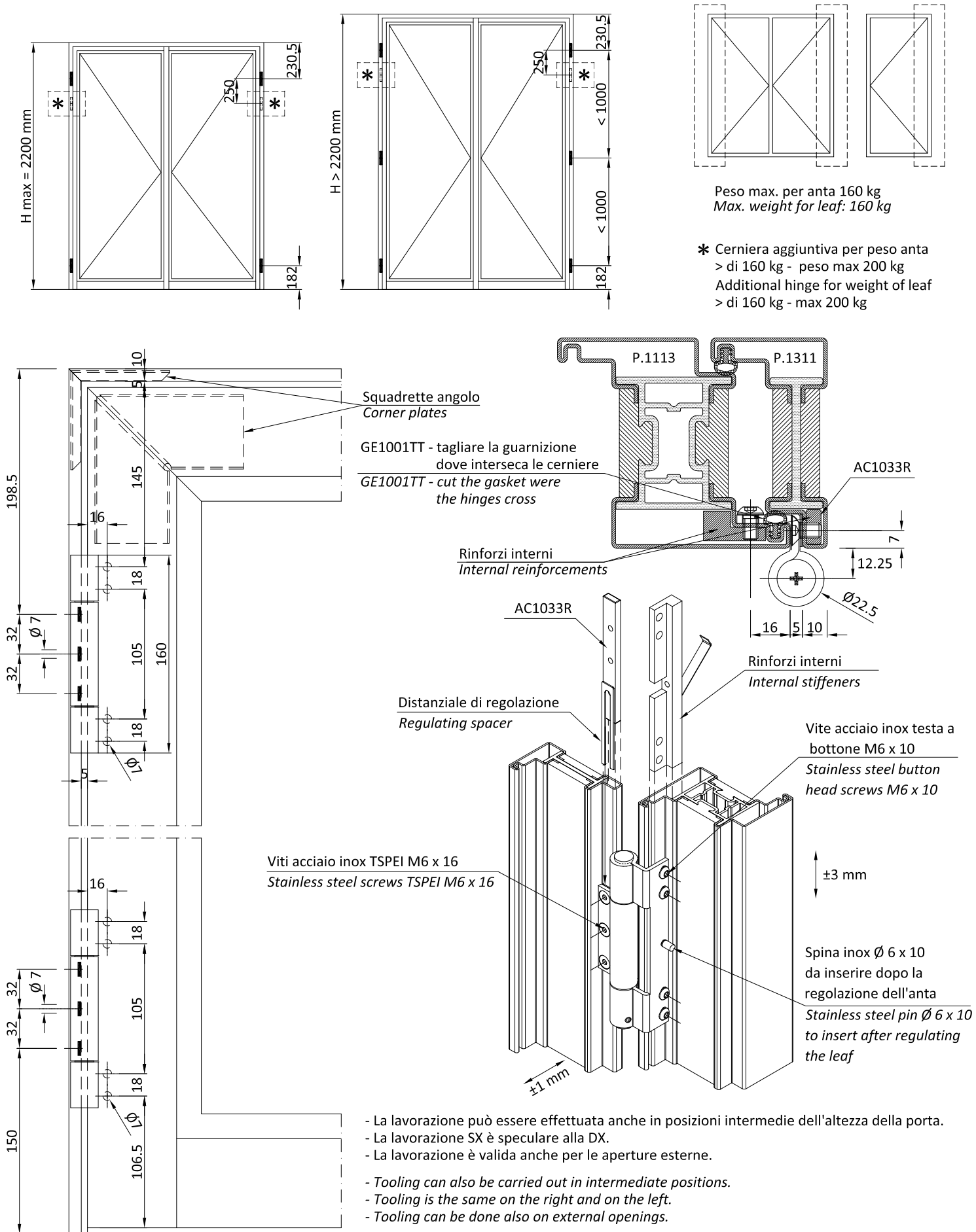


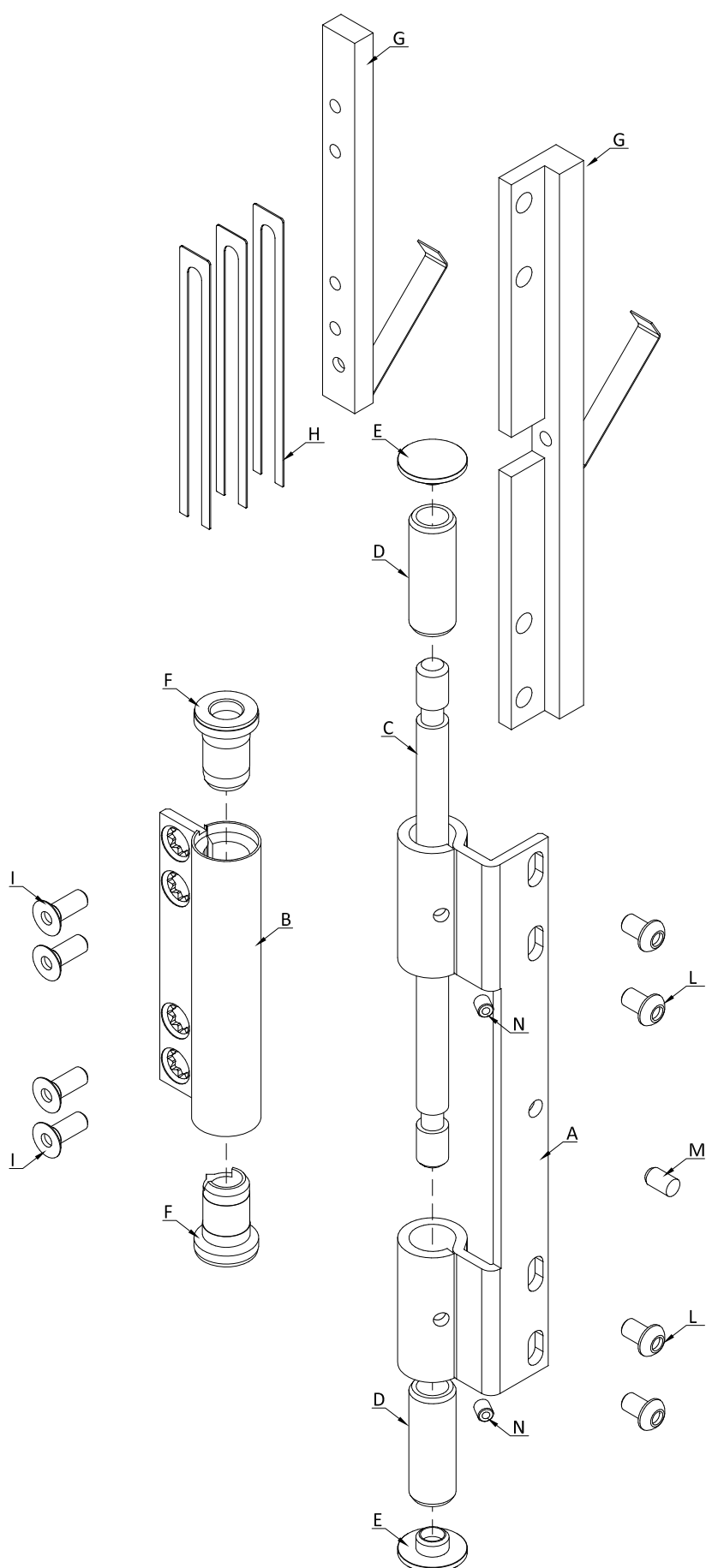
- A) Corpo cerniera A
- B) Corpo cerniera B
- C) Perno
- D) Distanziatore
- E) Tappo a vite
- F) Boccola antifrizione
- G) Distanziatore
- H) Rinforzi interni
- I) Distanziale di regolazione
- L) Viti acciaio inox TSPEI M6 x 16
- M) Vite acciaio inox testa a bottone M6 x 10
- N) Spina inox Ø 6 x 10 da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

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



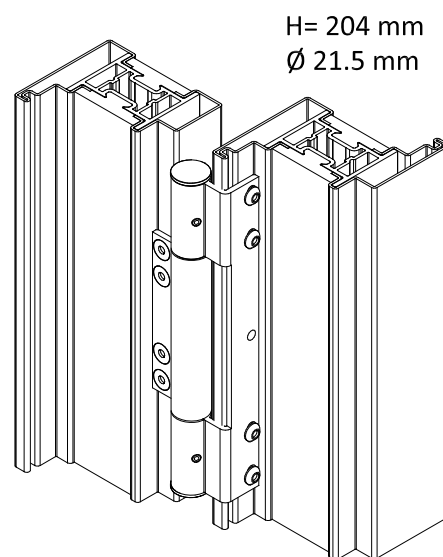
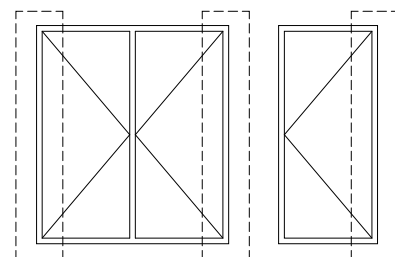


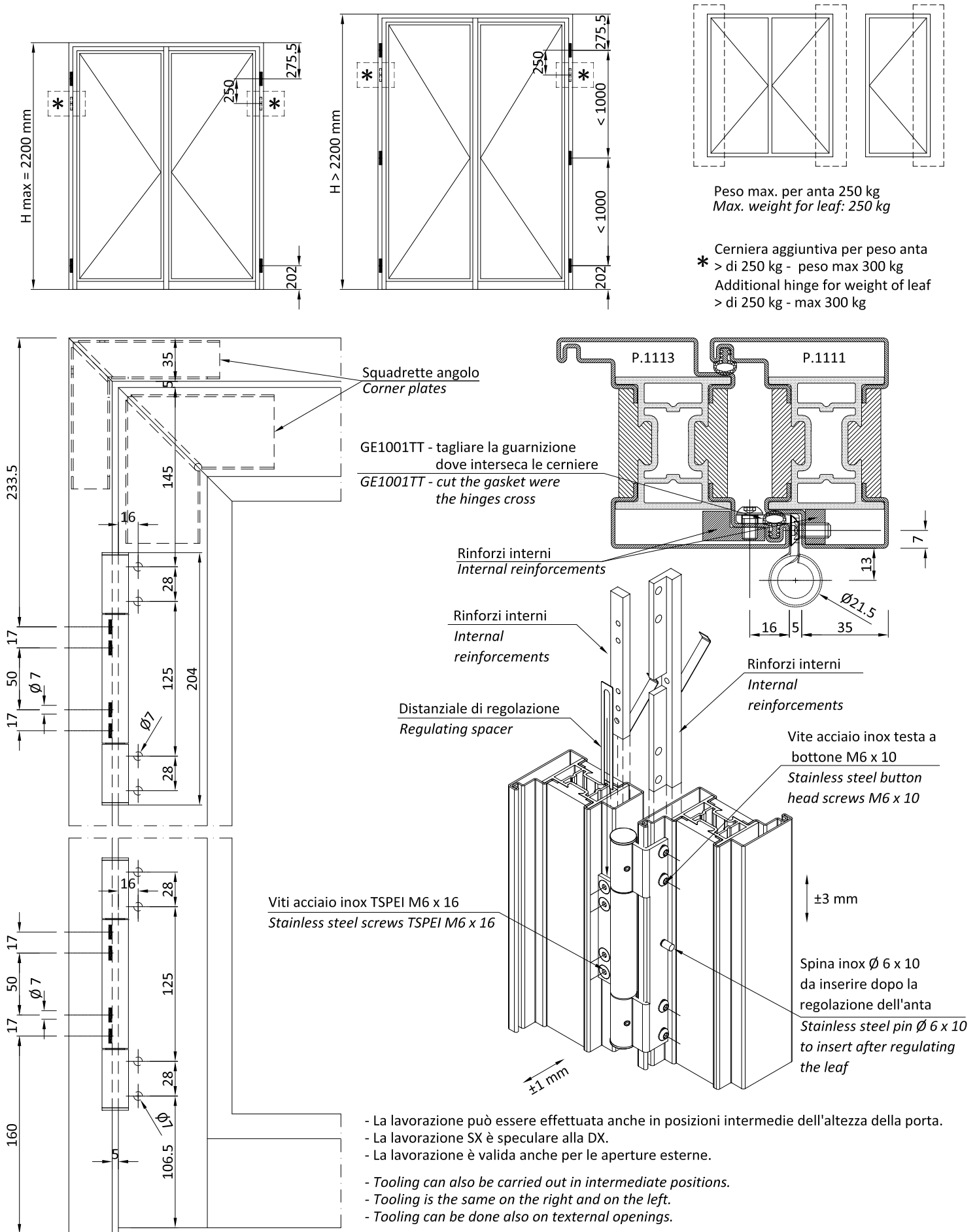


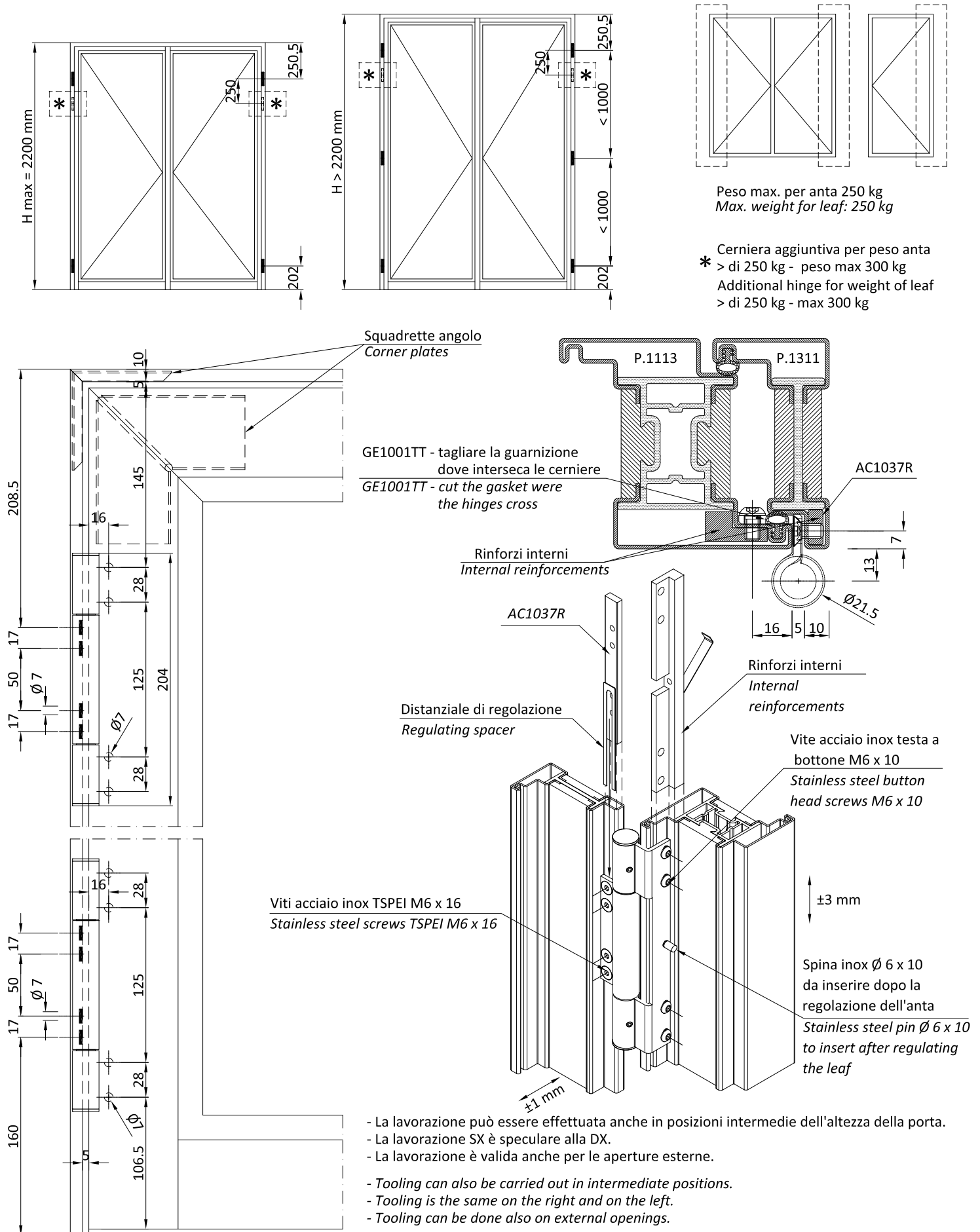


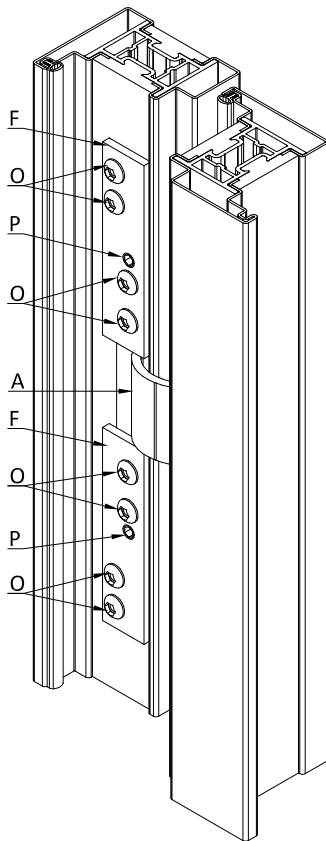
- A) Corpo cerniera A
 B) Corpo cerniera B
 C) Perno
 D) Distanziatore
 E) Tappo di finitura
 F) Boccola antifrizione
 G) Rinforzi interni
 H) Distanziale di regolazione
 I) Viti acciaio inox TSPEI M6 x 16
 L) Vite acciaio inox testa a bottone M6 x 10
 M) Spina inox $\varnothing 6 \times 10$ da inserire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

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

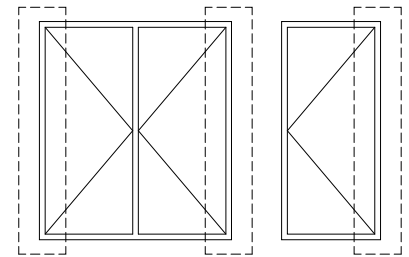




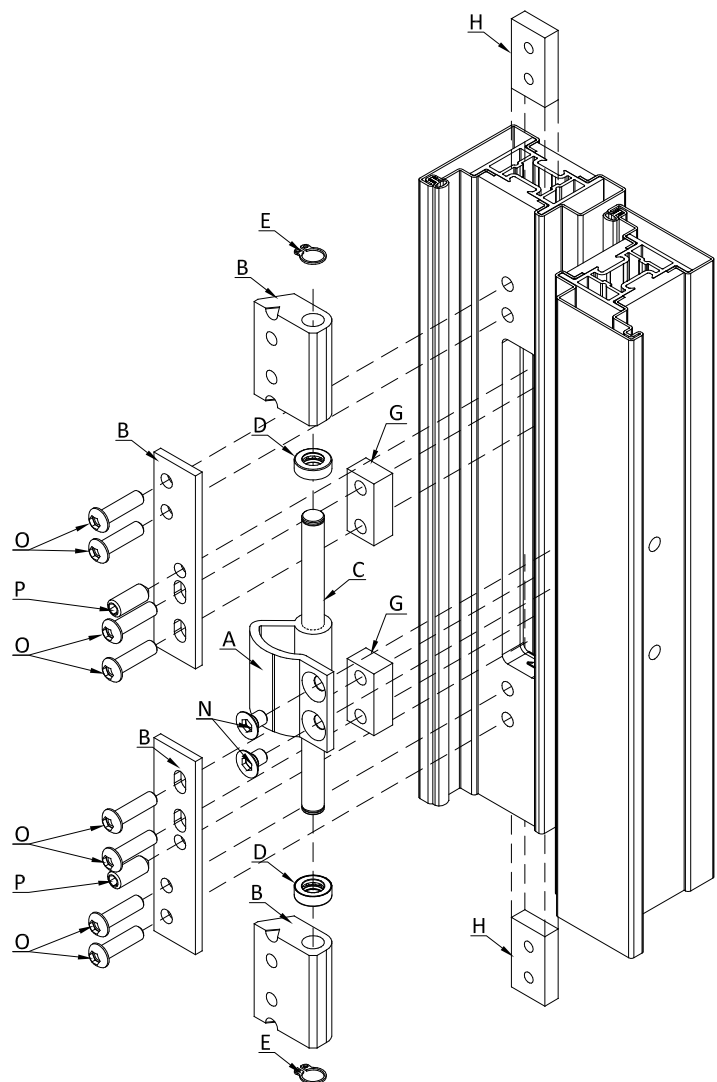
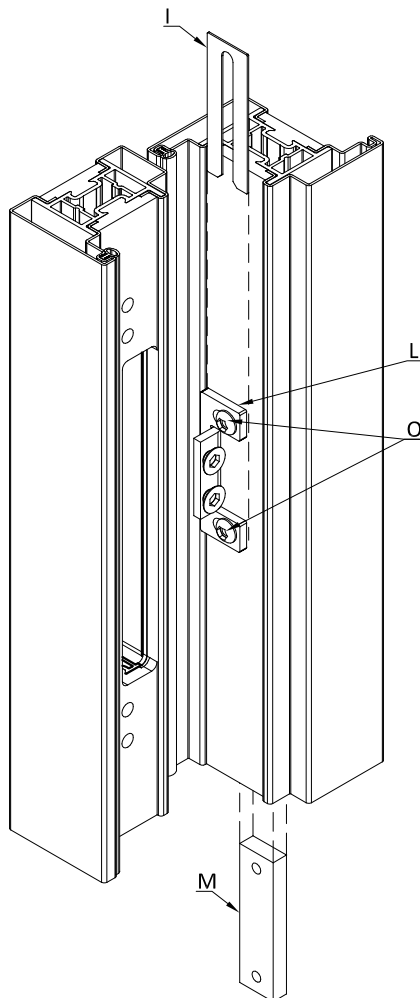


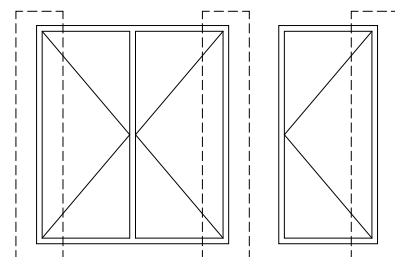
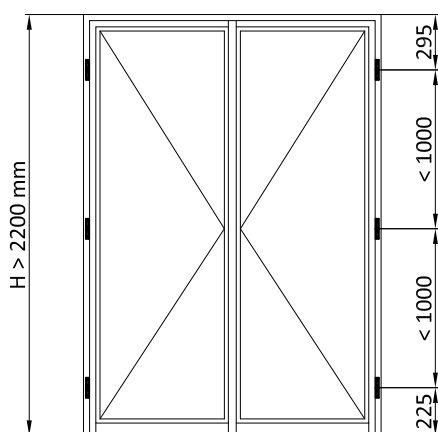
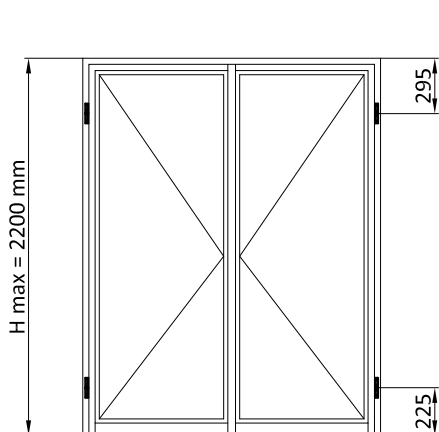


- A) Corpo cerniera A
B) Corpo cerniera B
C) Perno
D) Cuscinetto
E) Seger
F) Piastra
G) Contro-piastra A
H) Contro-piastra B
I) Spessore
L) Staffa di fissaggio
M) Contropiastra C
N) n°2 x Vite TPEI M8x12 mm
O) n°10 x Vite TCEI M8x30 mm
P) Grano M10x25 mm punta conica



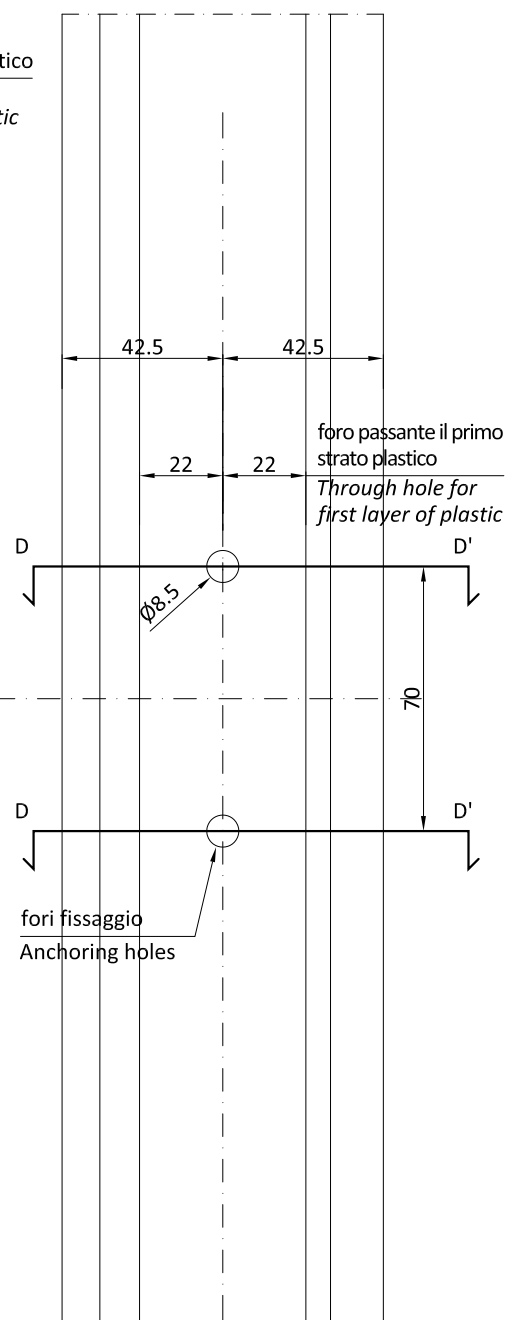
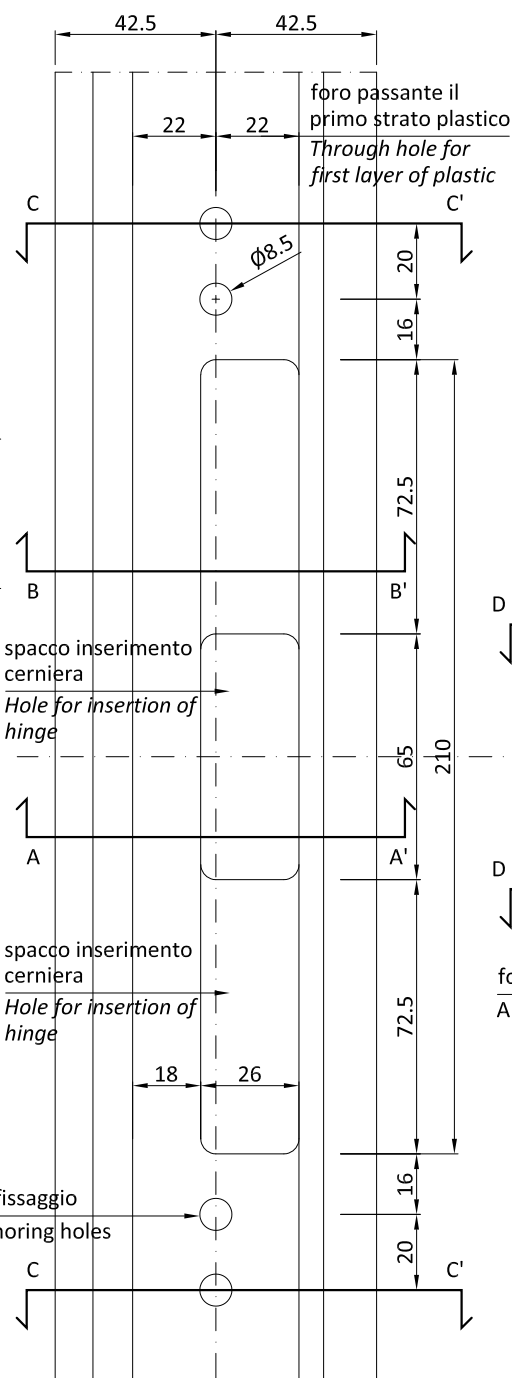
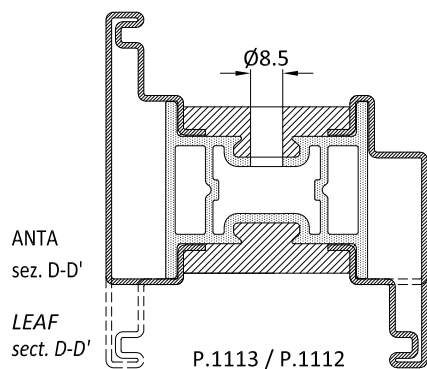
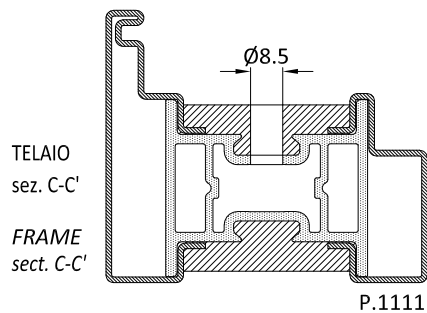
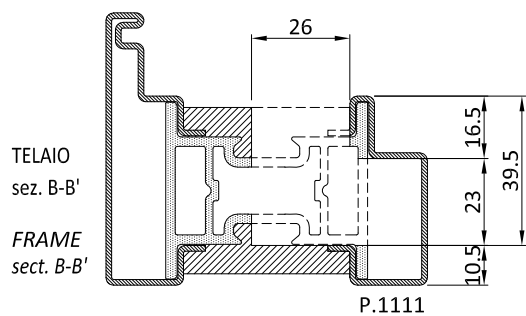
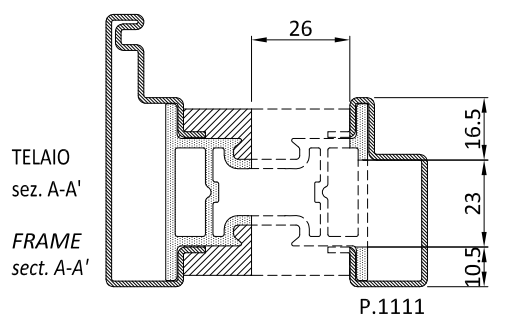
- A) Body hinge A
B) Body hinge B
C) Pin
D) Bearing
E) Seger
F) Plate
G) Retainer plate A
H) Retainer plate B
I) Shim
L) Anchoring bracket
M) Counter-plate C
N) n° 2 x Screws TPEI M8x12 mm
O) n°10 x Screws TCEI M8x30 mm
P) Dowel M10x25mm cone point

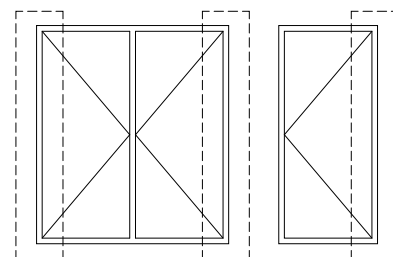
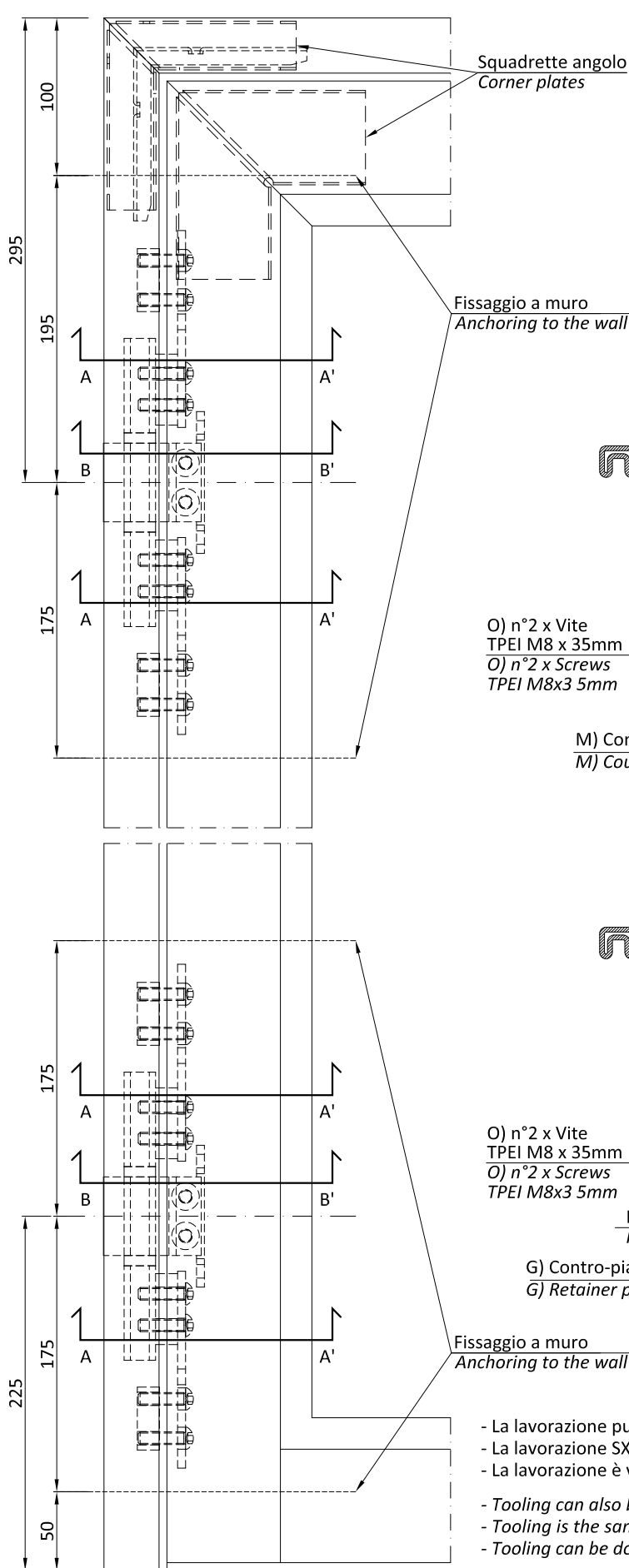




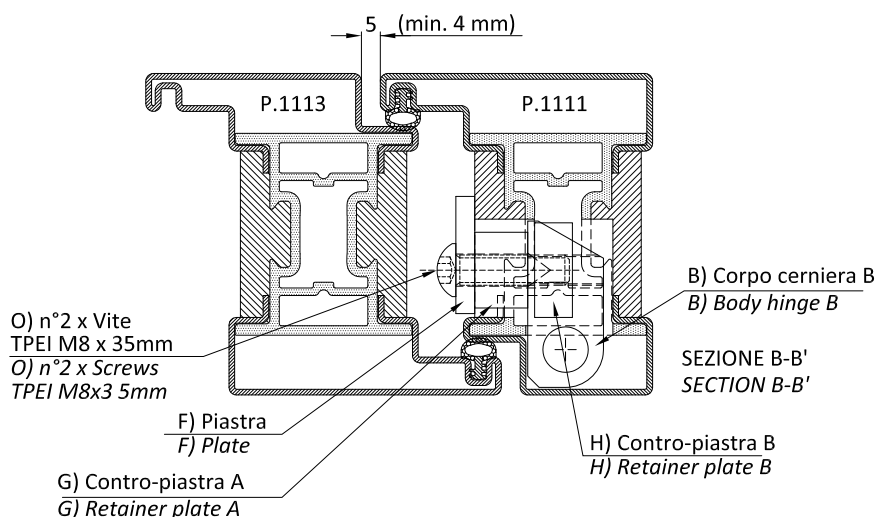
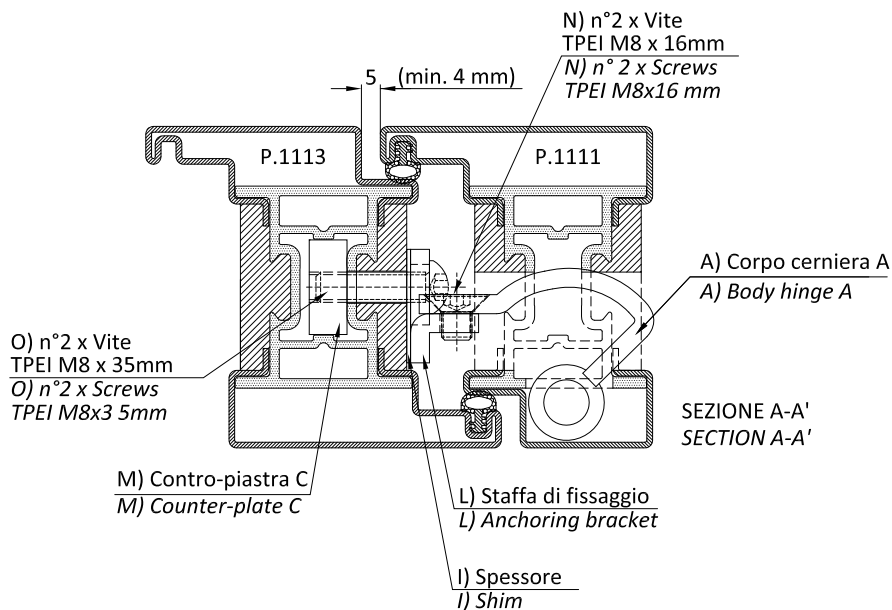
Peso max. per anta 180 kg
Massima apertura 96°
Max. weight for leaf: 180 kg
Maximum opening 96°

Lavorazione eseguibile con fresa AT1068
Tooling possible with milling cutter AT1068

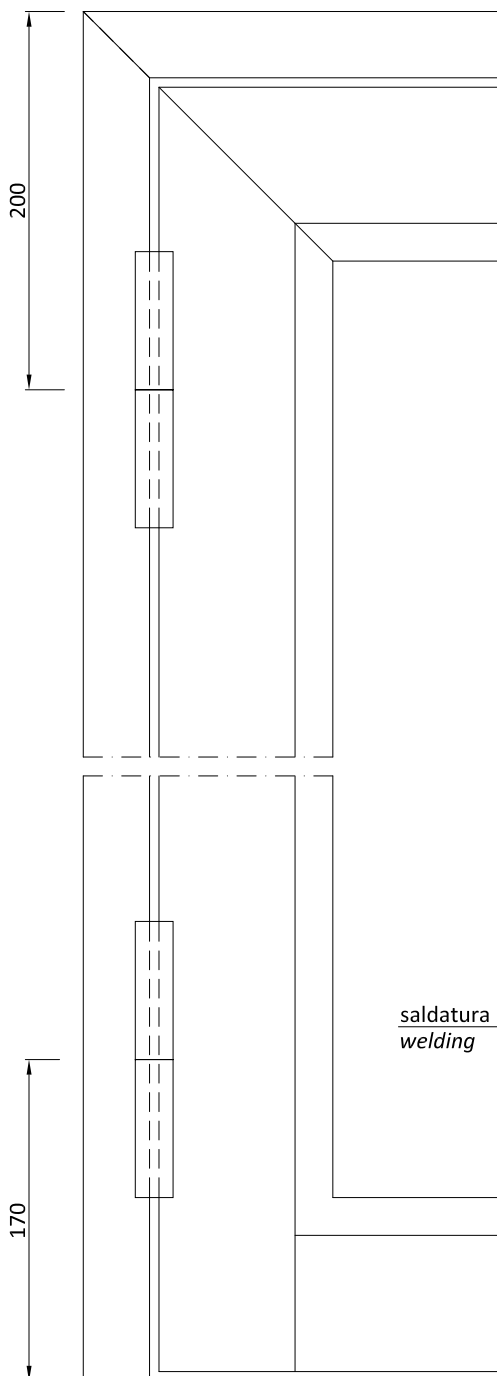
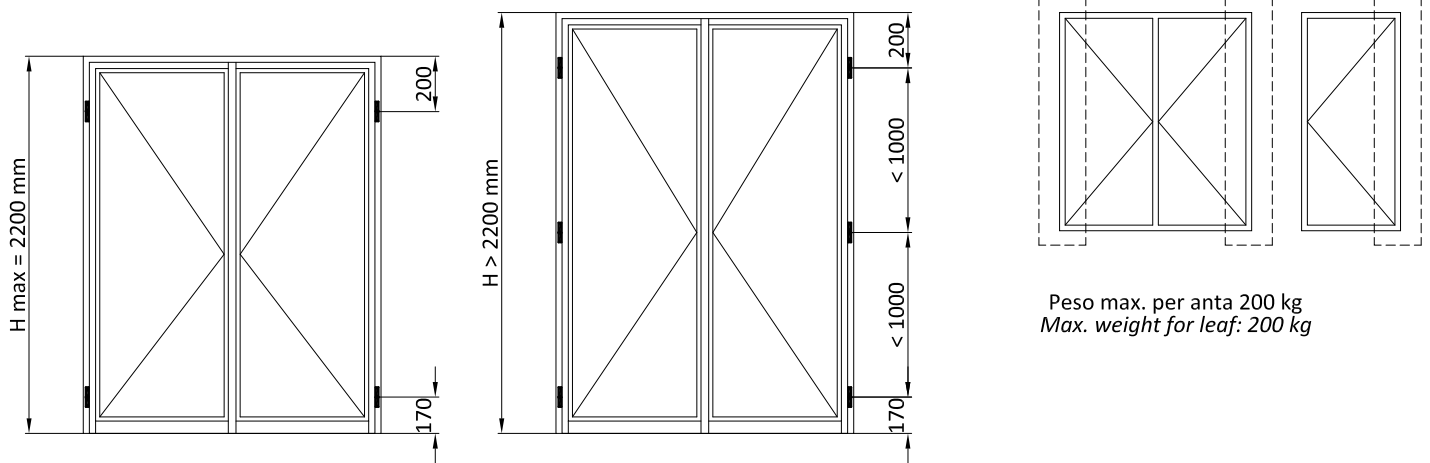




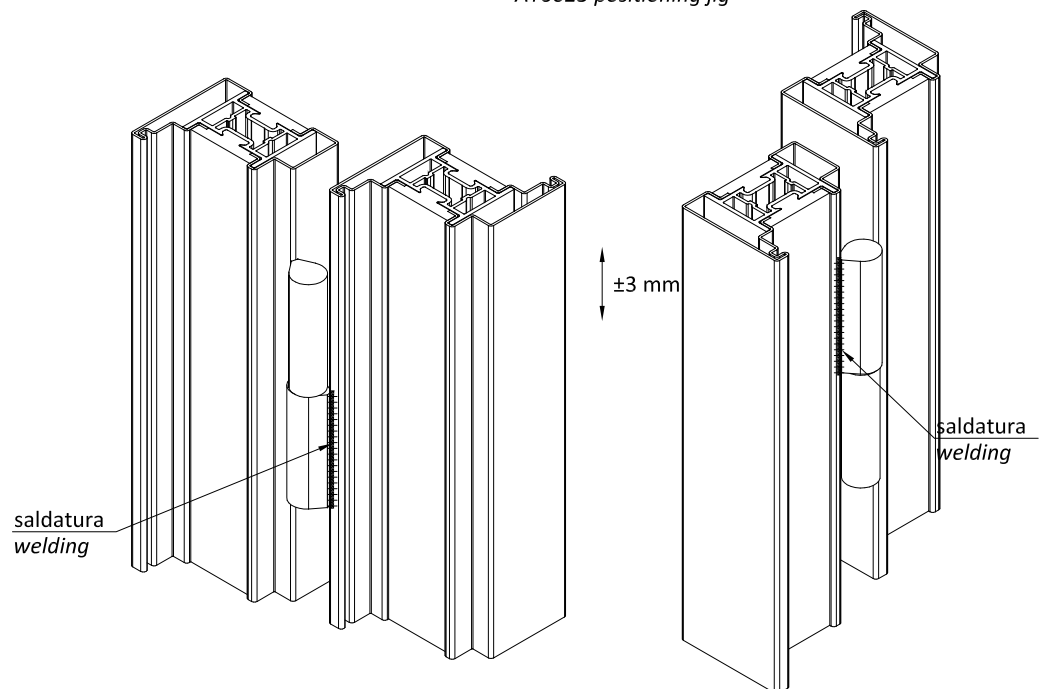
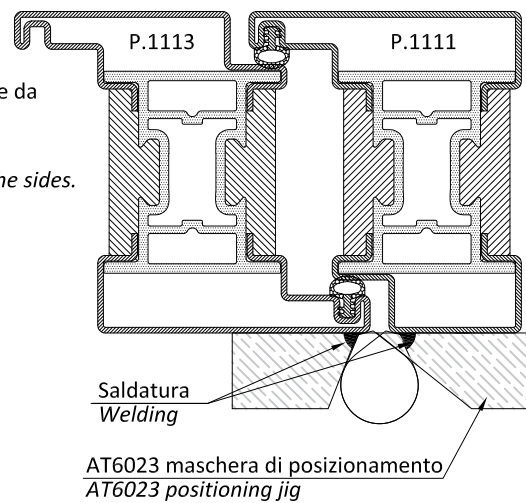
Peso max. per anta 180 kg
Max. weight for leaf: 180 kg



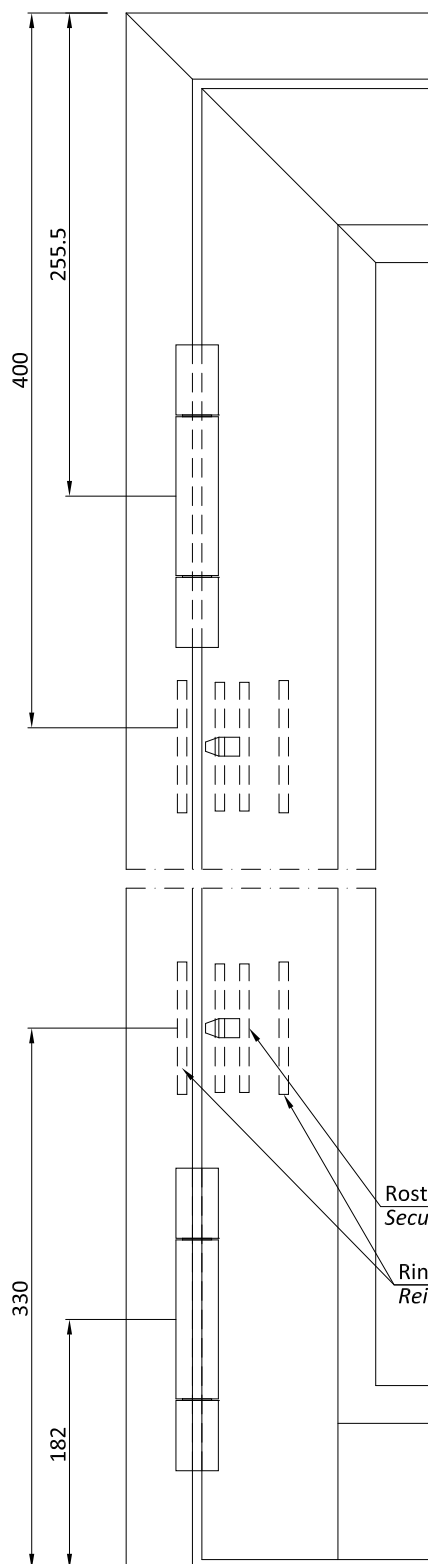
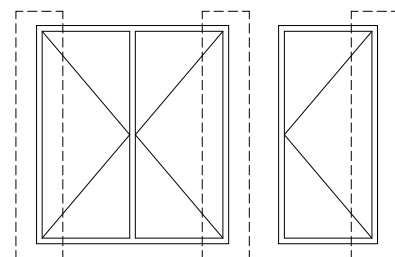
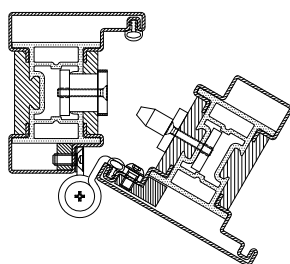
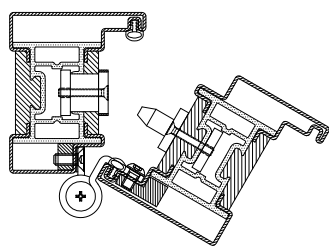
- La lavorazione può essere effettuata anche in posizioni intermedie dell'altezza della porta.
- La lavorazione SX è speculare alla DX.
- La lavorazione è valida anche per le aperture esterne.
- Tooling can also be carried out in intermediate positions.
- Tooling is the same on the right and on the left.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



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

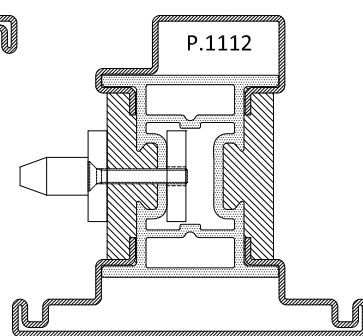
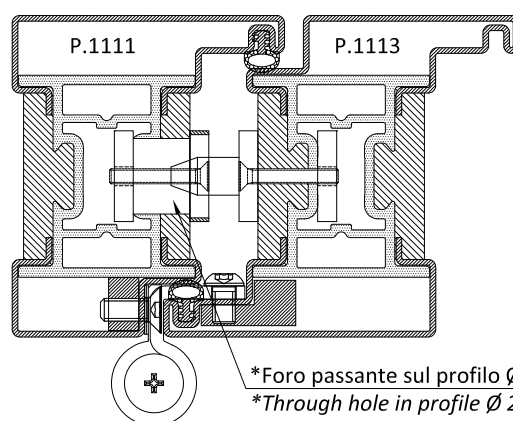
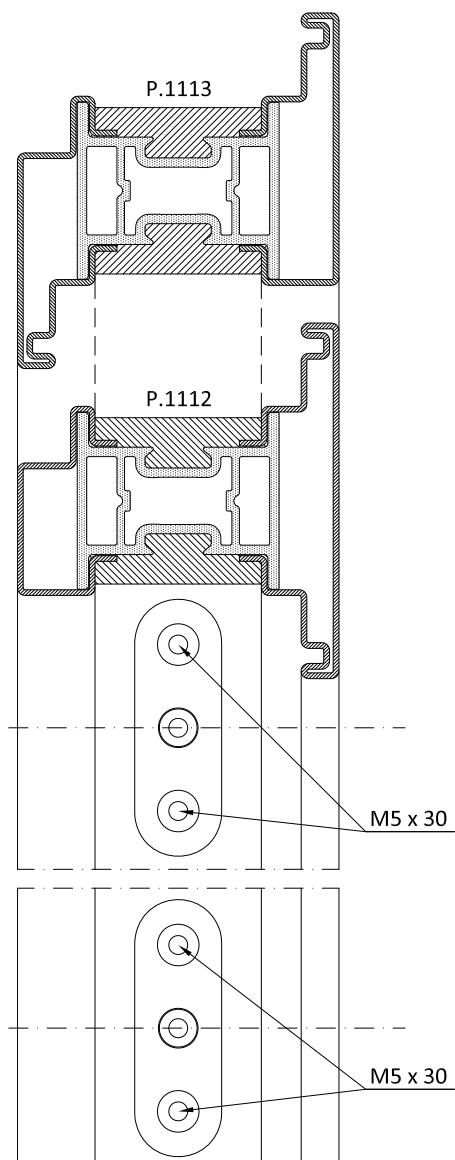
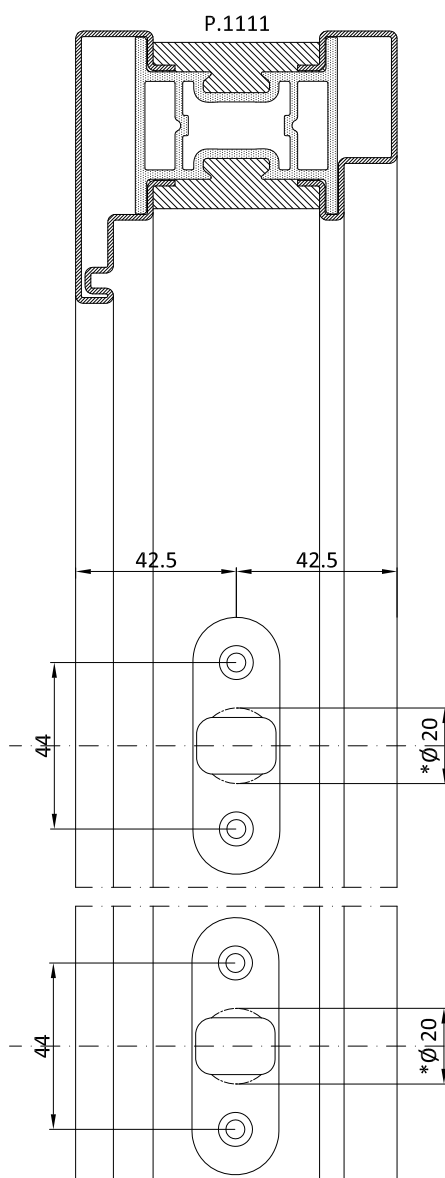


- La lavorazione può essere effettuata anche in posizioni intermedie dell'altezza della porta.
- La lavorazione SX è speculare alla DX.
- La lavorazione è valida anche per le aperture esterne.
- Tooling can be carried out also in intermediate positions regarding the height of the door.
- Tooling on left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



Rostro AC1080I
Security pin AC1080I

Rinforzo
Reinforcement



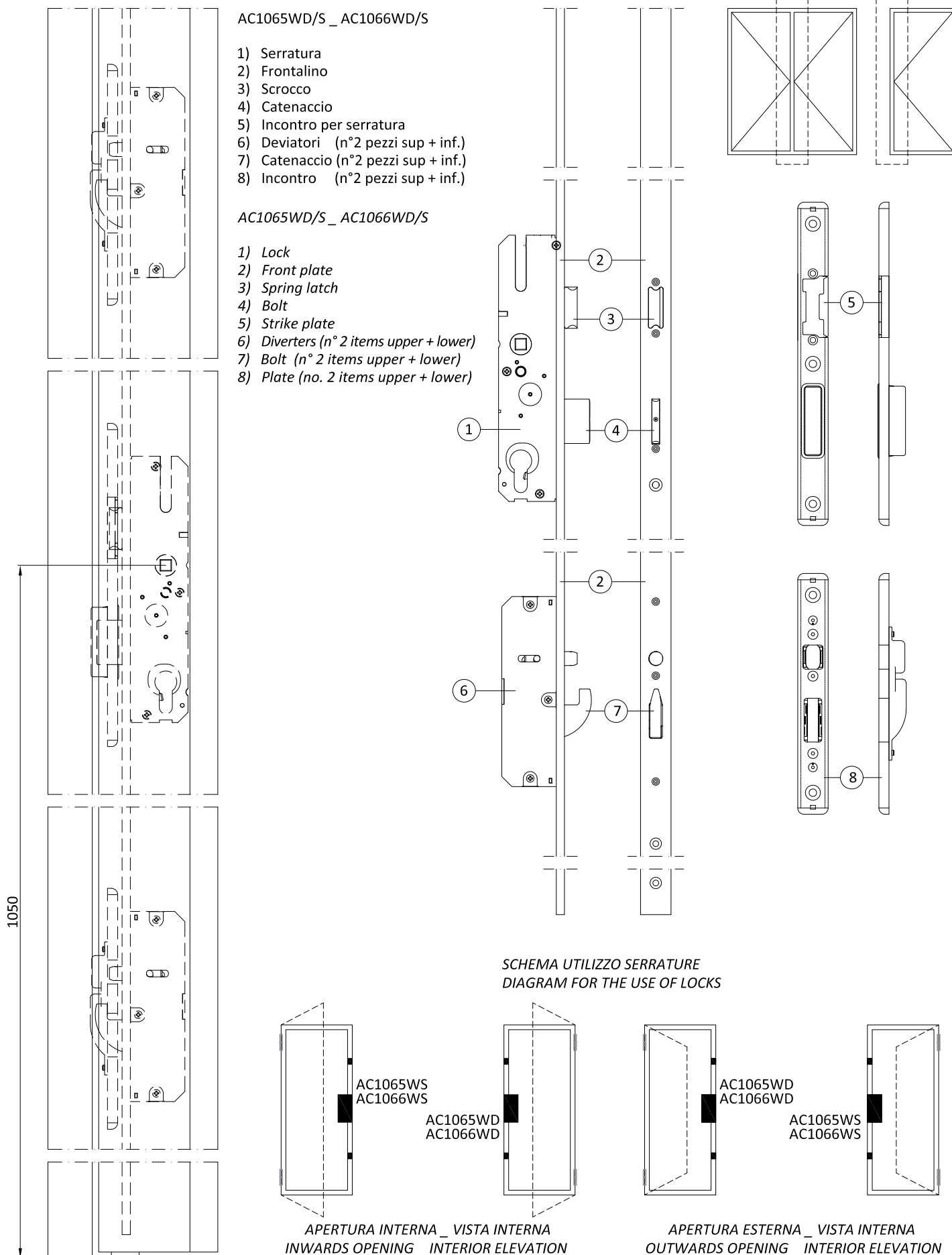
*Foro passante sul profilo Ø 20 mm.
*Through hole in profile Ø 20 mm.

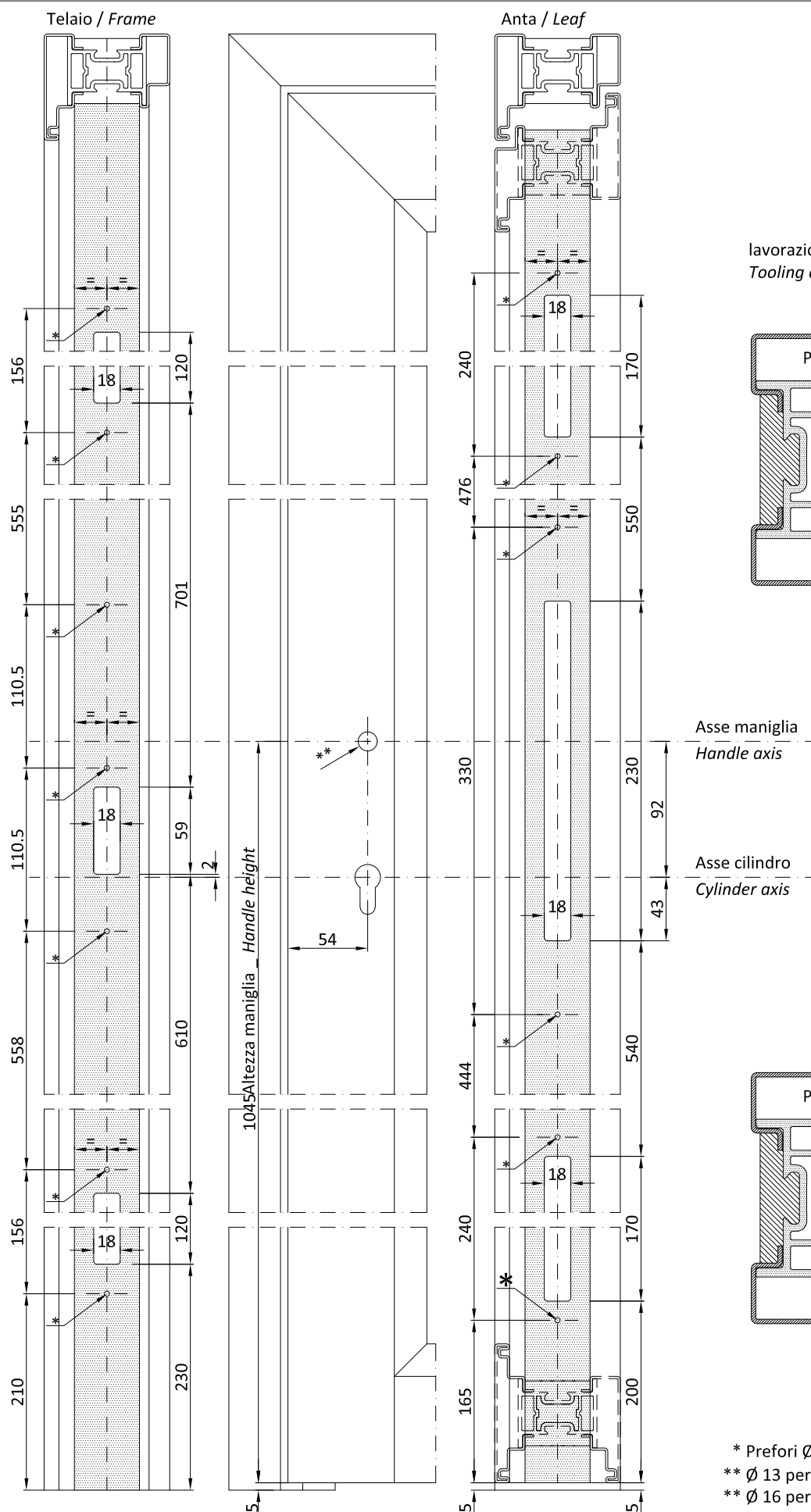
AC1065WD/S _ AC1066WD/S

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

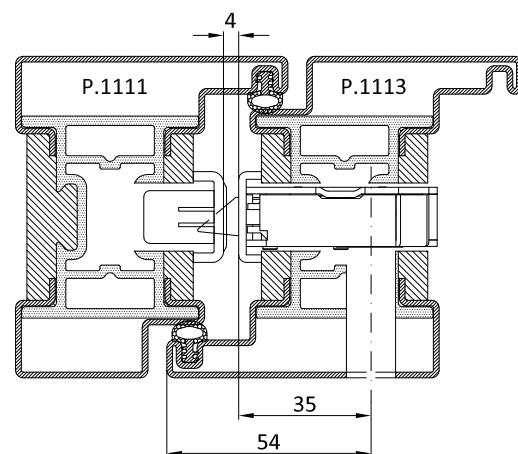
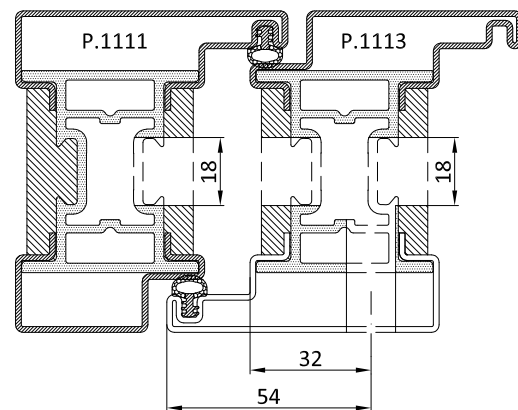
AC1065WD/S _ AC1066WD/S

- 1) Lock
- 2) Front plate
- 3) Spring latch
- 4) Bolt
- 5) Strike plate
- 6) Diverters (n° 2 items upper + lower)
- 7) Bolt (n° 2 items upper + lower)
- 8) Plate (no. 2 items upper + lower)

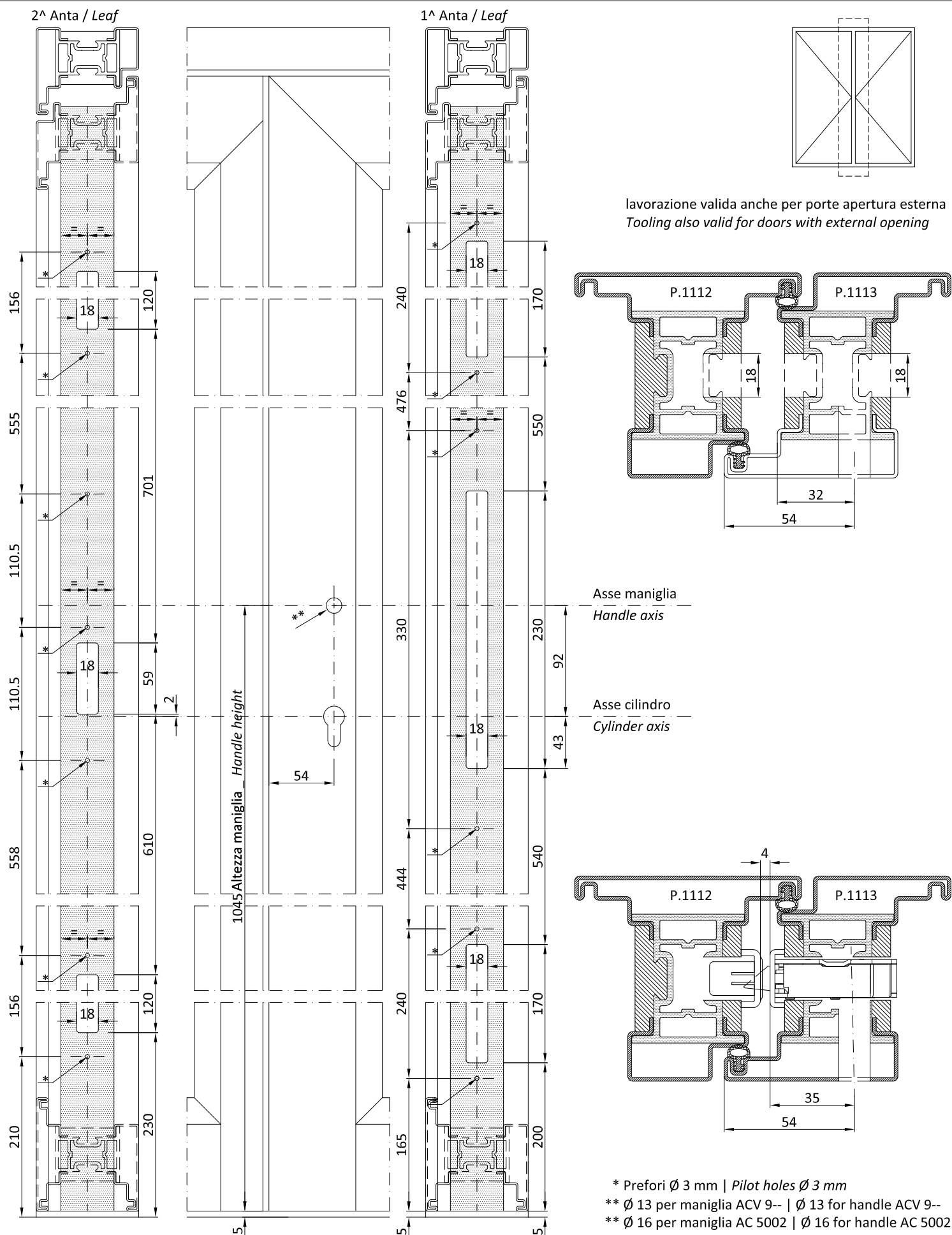


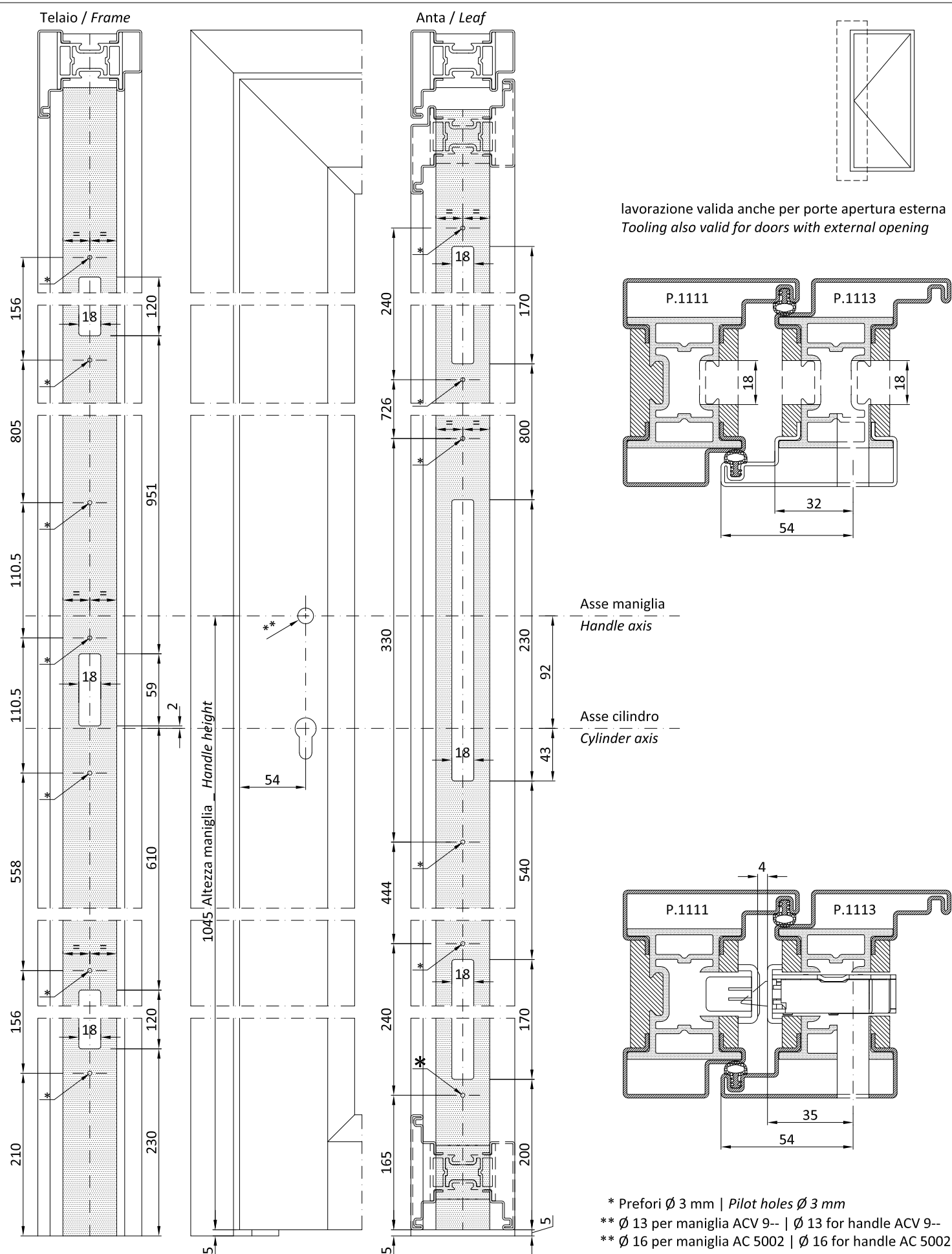


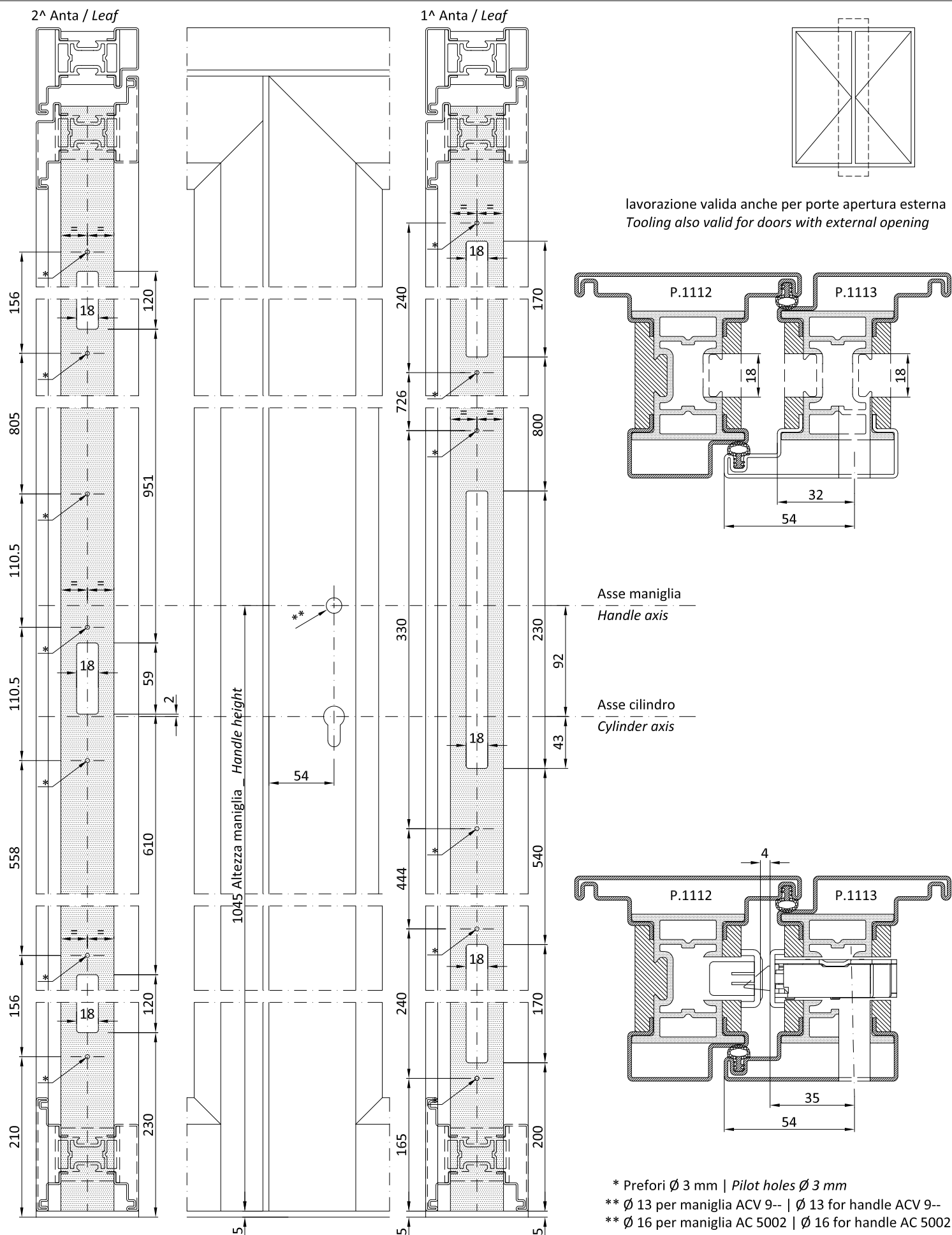
lavorazione valida anche per porte apertura esterna
Tooling also valid for doors with external opening



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







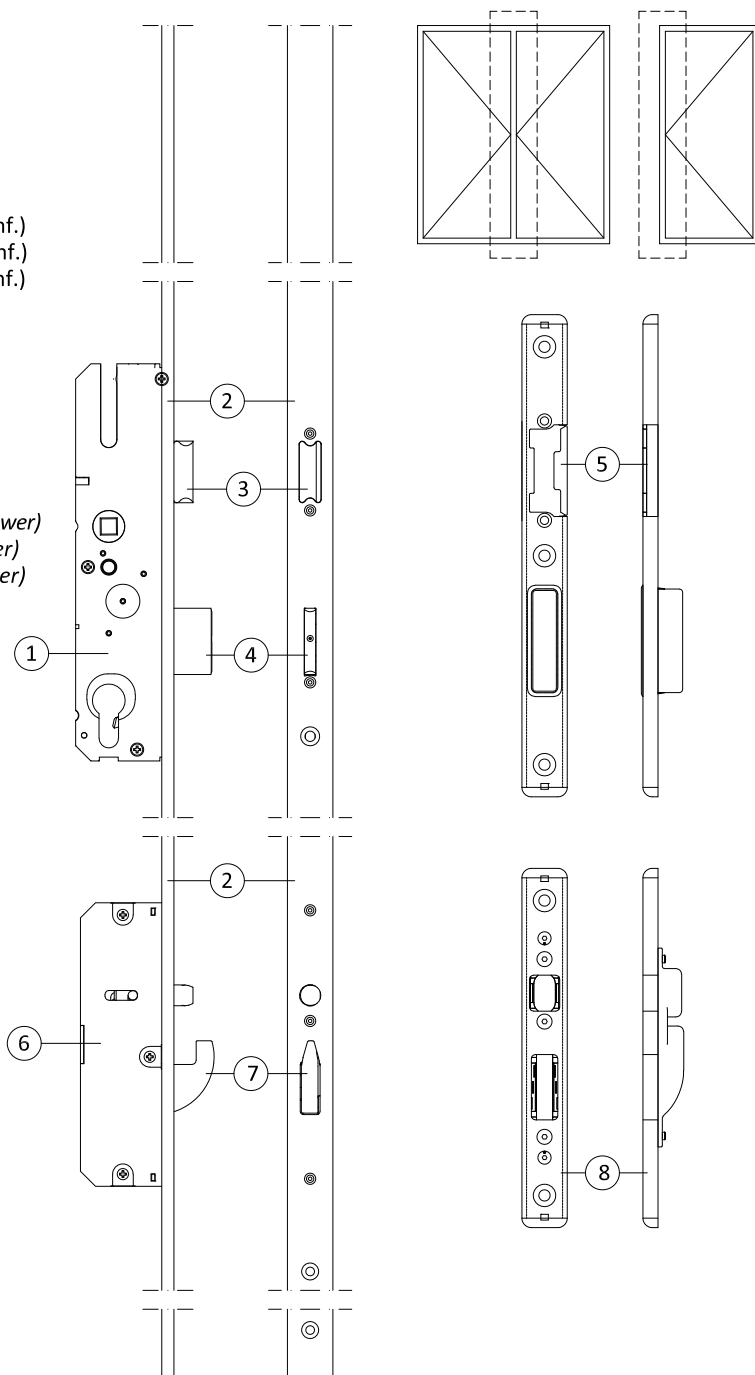
AC1067WD/S

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

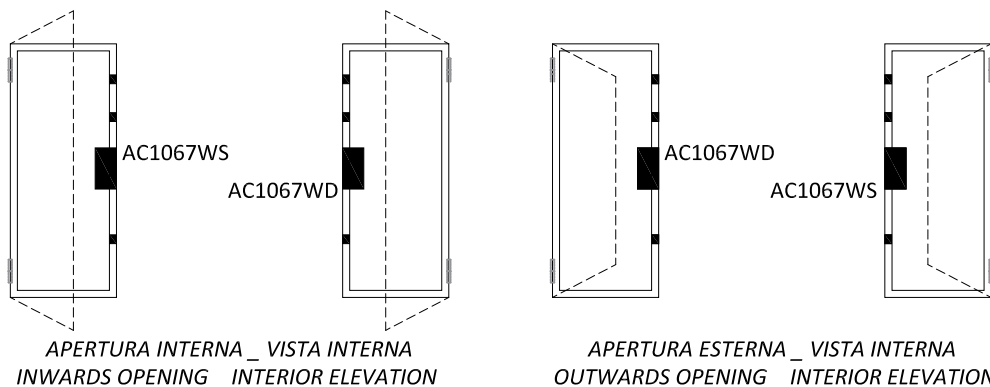
AC1067WD/S

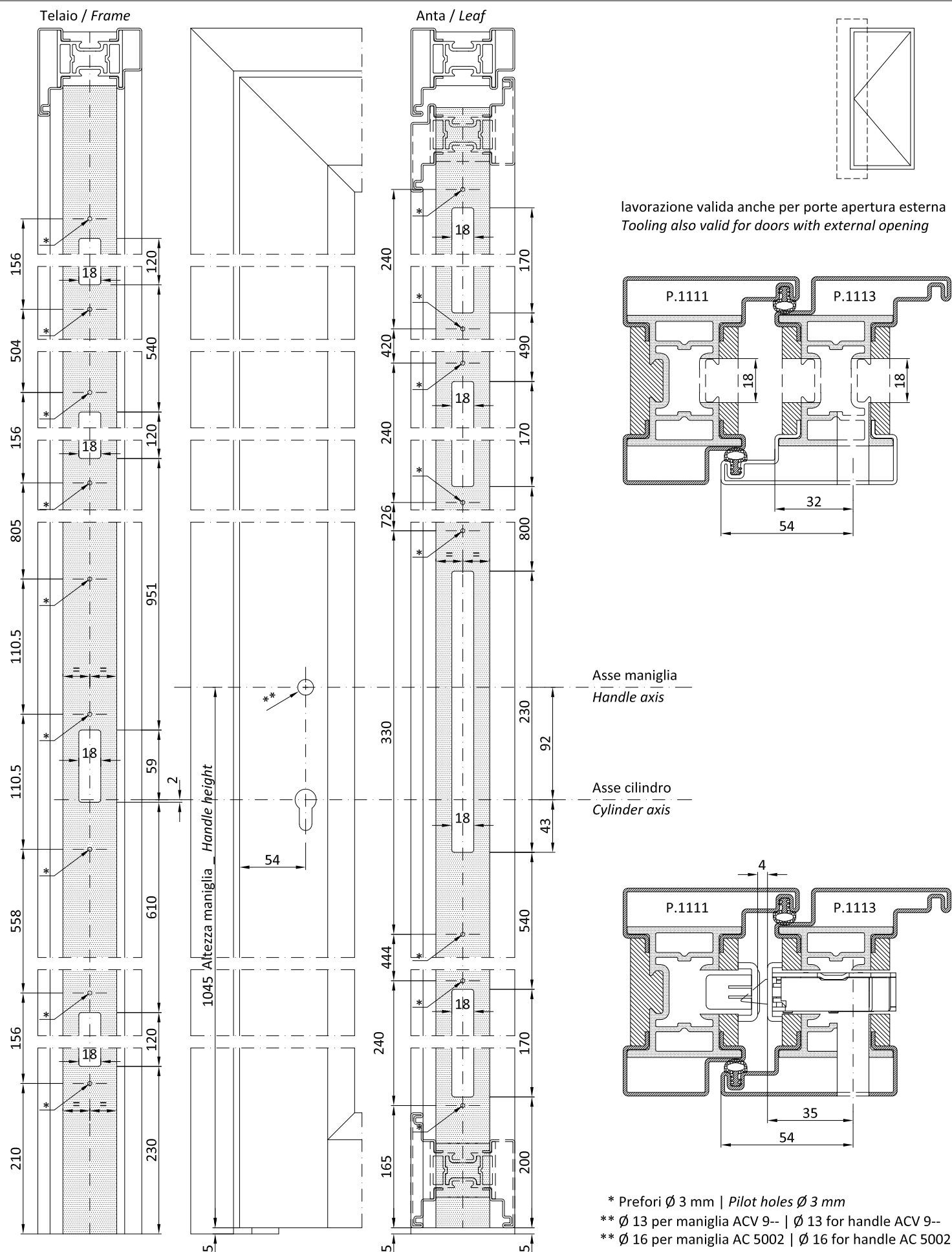
- 1) Lock
- 2) Front plate
- 3) Spring latch
- 4) Bolt
- 5) Strike plate
- 6) Diverters (n° 3 items upper + lower)
- 7) Bolt (n° 3 items upper + lower)
- 8) Plate (n° 3 items upper + lower)

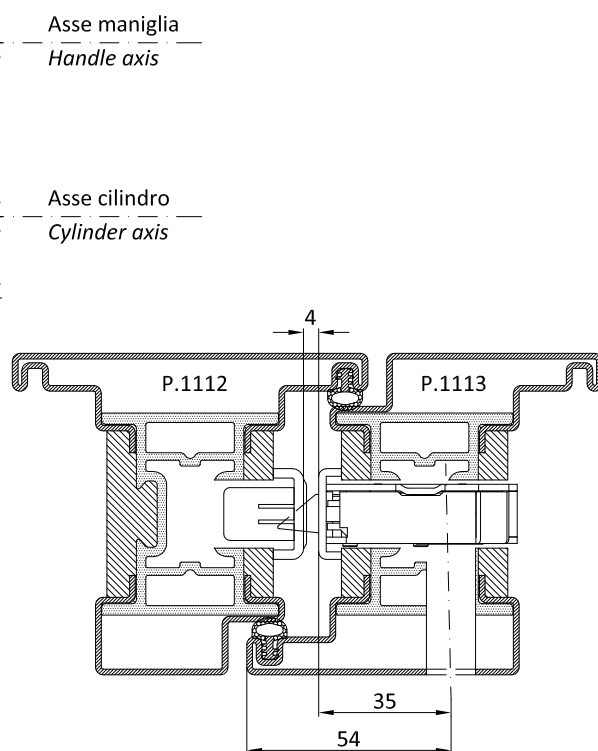
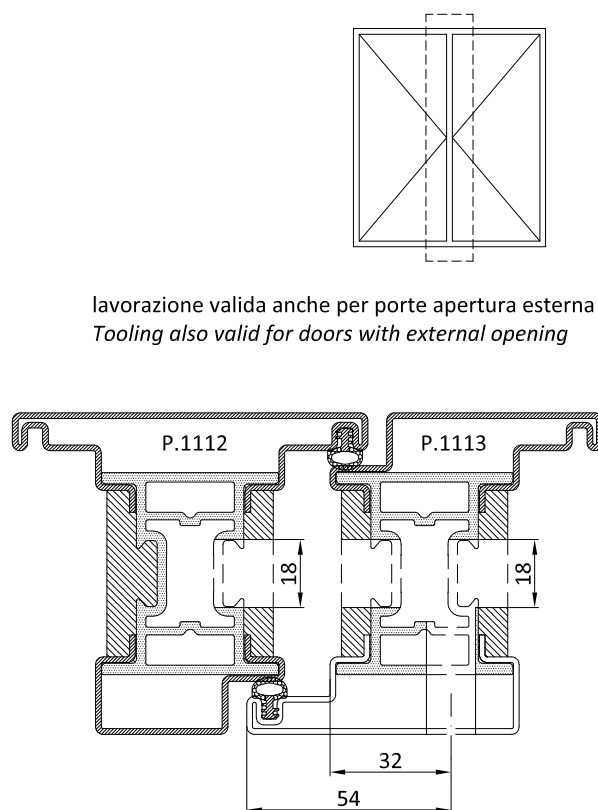
1050



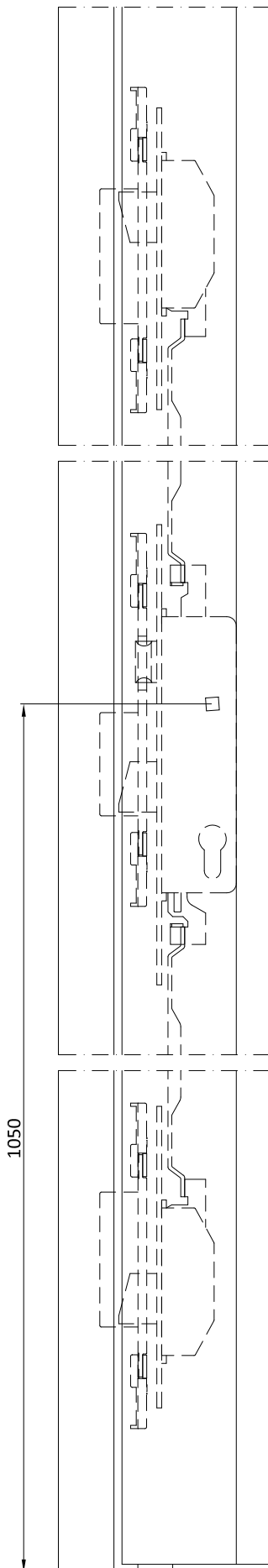
SCHEMA UTILIZZO SERRATURE
DIAGRAM FOR THE USE OF LOCKS



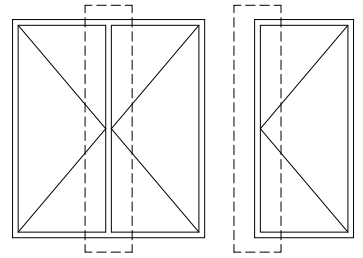




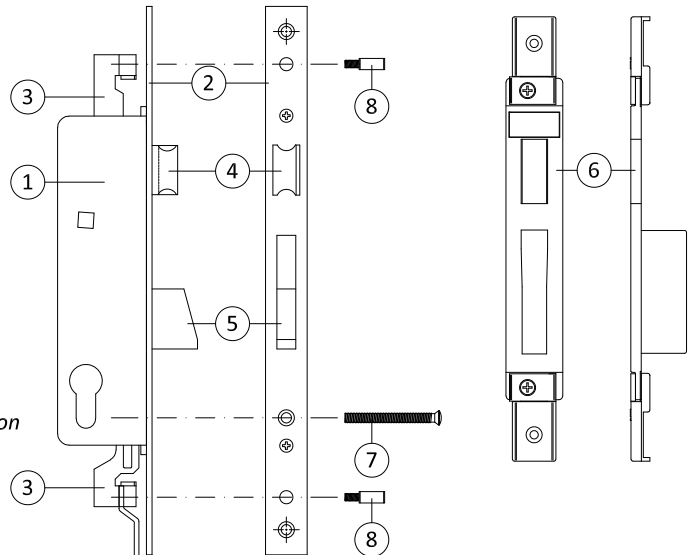
**** Ø 16 per maniglia AC 5002 | Ø 16 for handle AC 5002**

**AC1070**

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

**AC1075**

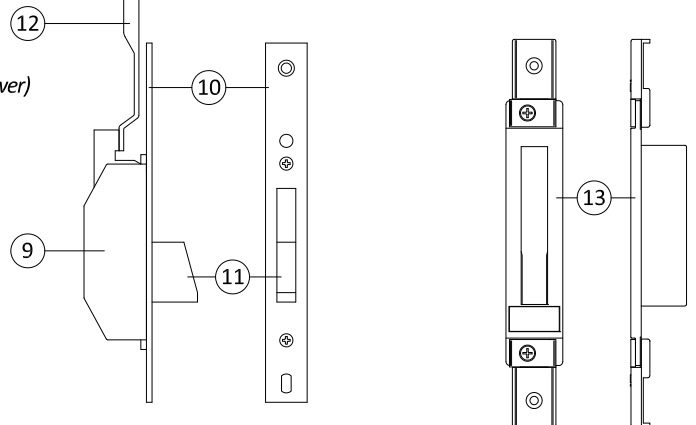
- 9) Deviatori (n°2 pezzi sup + inf.)
- 10) Frontalino (n°2 pezzi sup + inf.)
- 11) Catenaccio (n°2 pezzi sup + inf.)
- 12) Aste inox (n°2 pezzi sup + inf.)
- 13) Incontro (n°2 pezzi sup + inf.)

**AC1070**

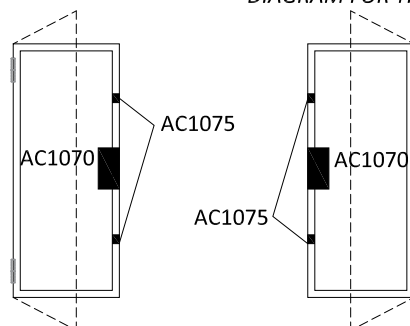
- 1) Lock
- 2) Front plate
- 3) Reduction unit/adaptor for connection
- 4) Spring latch
- 5) Bolt
- 6) Strike plate
- 7) Stainless steel screws TS M5x50
- 8) Pin for anchoring the rod

AC1075

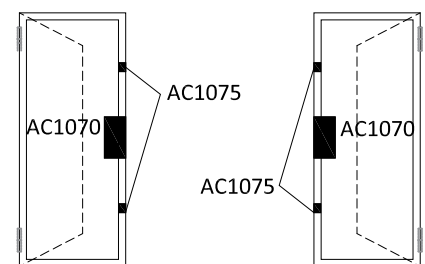
- 9) Diverters (n° 2 items upper + lower)
- 10) Apron lining (n° 2 items upper + lower)
- 11) Bolt (n° 2 items upper + lower)
- 12) Stainless steel rods (n° 2 items upper + lower)
- 13) Plate (n° 2 items upper + lower)



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



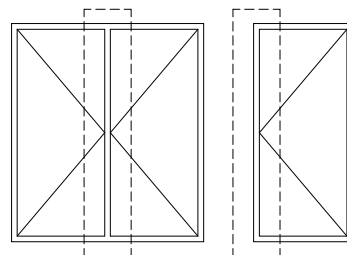
APERTURA INTERNA _ VISTA INTERNA
INWARDS OPENING _ INTERIOR ELEVATION



APERTURA ESTERNA _ VISTA INTERNA
OUTWARDS OPENING _ INTERIOR ELEVATION

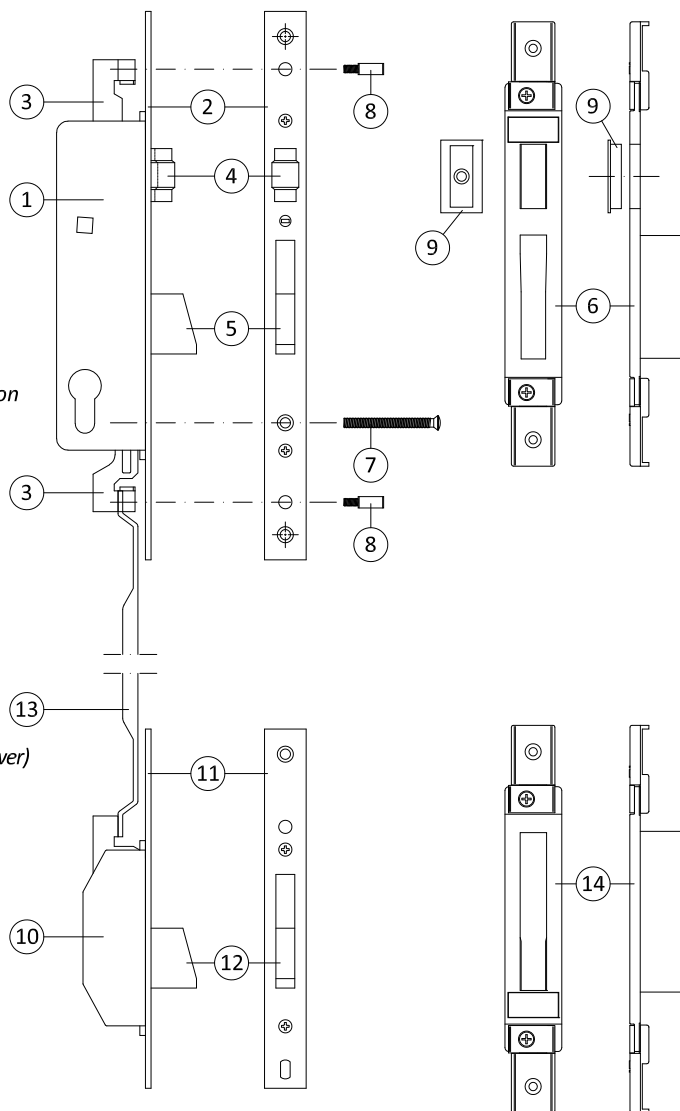
AC1071

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



AC1075

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

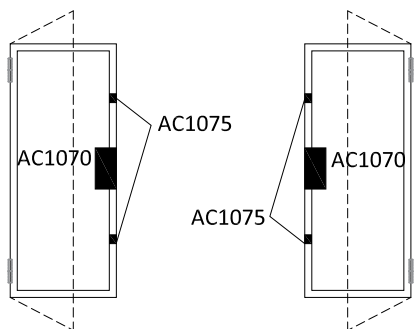
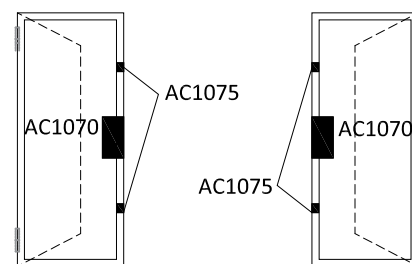


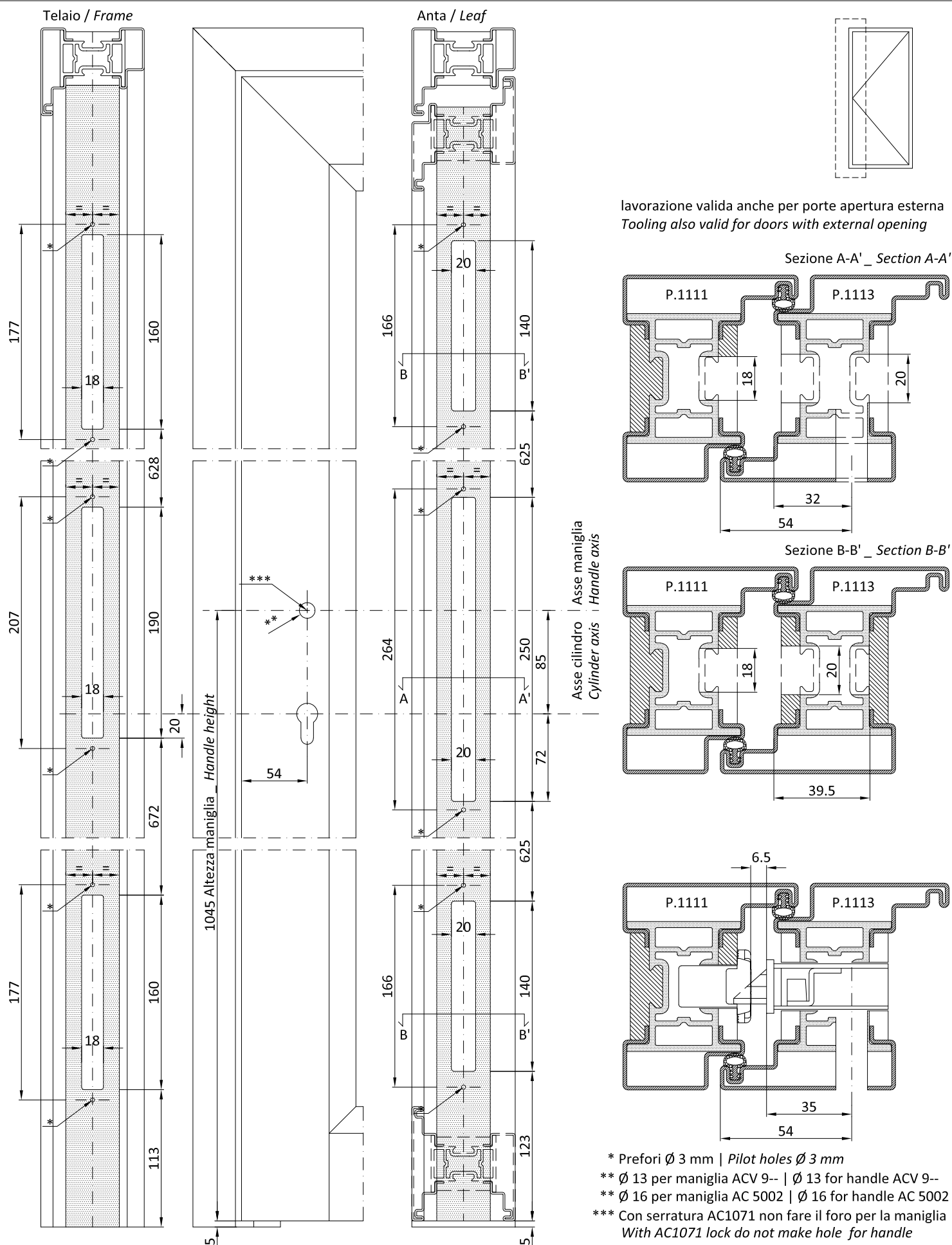
AC1071

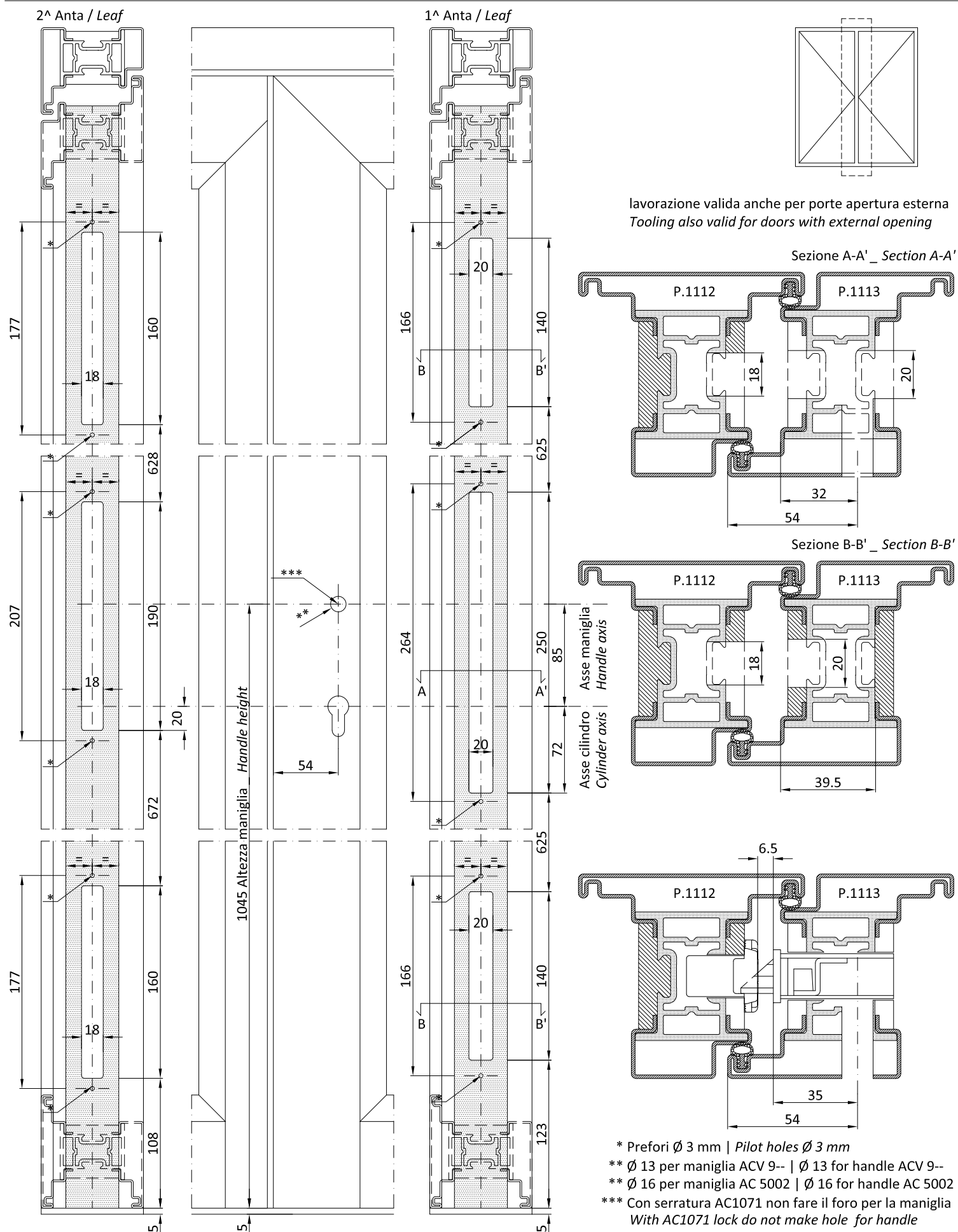
- 1) Lock
- 2) Front plate
- 3) Reduction unit/adaptor for connection
- 4) Roller
- 5) Bolt
- 6) Strike plate
- 7) Compartment for roller
- 8) Stainless steel screws TS M5x50
- 9) Pin for anchoring the rod

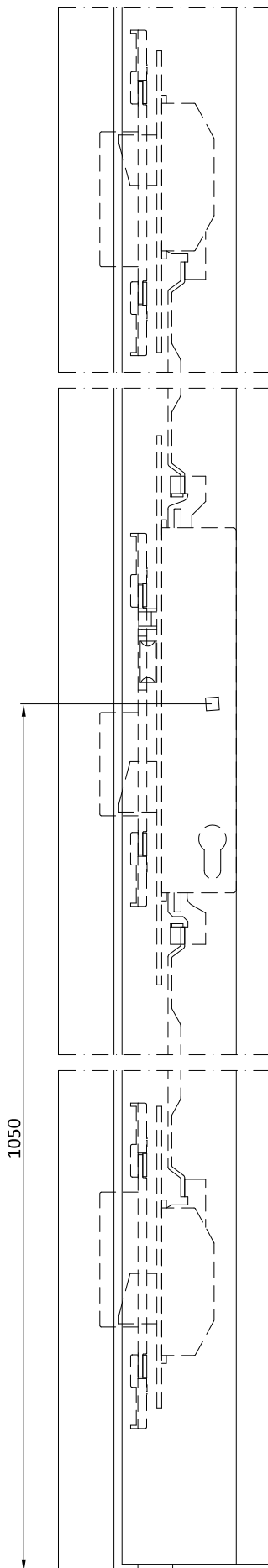
AC1075

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

SCHEMA UTILIZZO SERRATURE E TERZE CHIUSURE
DIAGRAM FOR THE USE OF LOCKS AND THIRD LOCKSAPERTURA INTERNA _ VISTA INTERNA
INWARDS OPENING _ INTERIOR ELEVATIONAPERTURA ESTERNA _ VISTA INTERNA
OUTWARDS OPENING _ INTERIOR ELEVATION







AC1072

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

AC1075

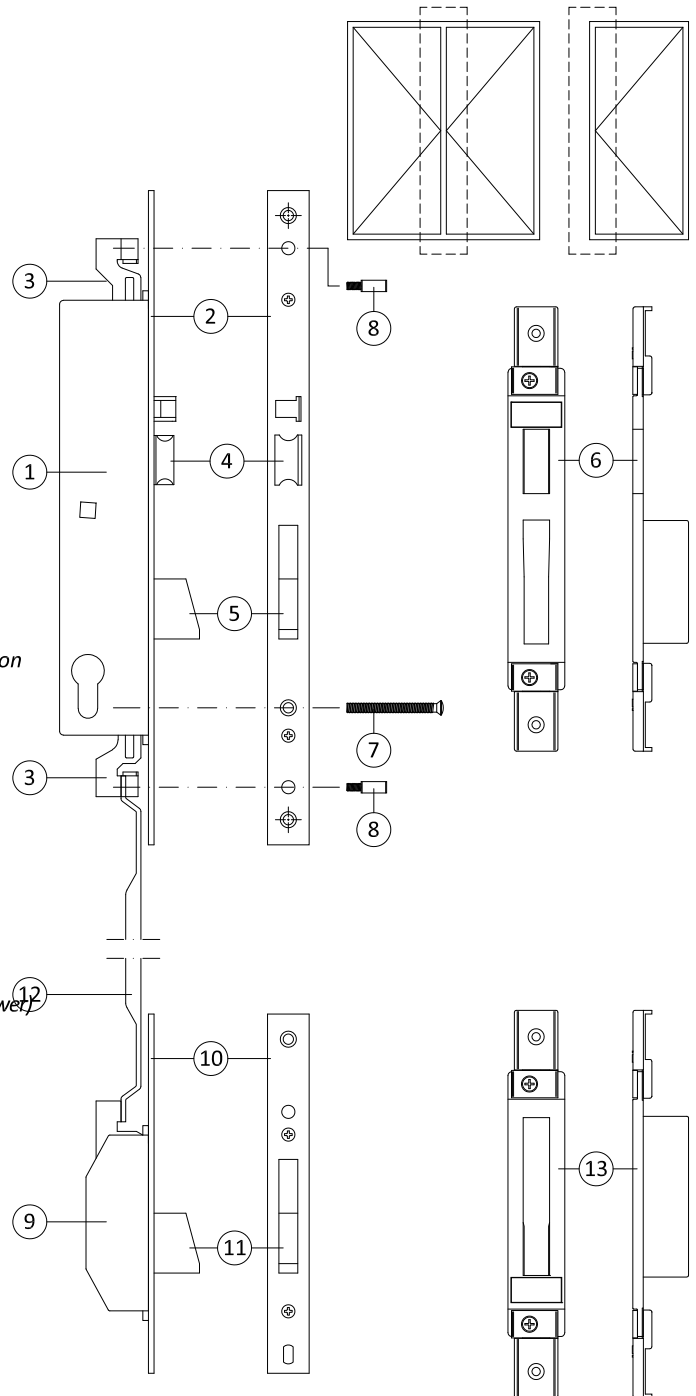
- 9) Deviatori (n°2 pezzi sup + inf.)
- 10) Frontalino (n°2 pezzi sup + inf.)
- 11) Catenaccio (n°2 pezzi sup + inf.)
- 12) Aste inox (n°2 pezzi sup + inf.)
- 13) Incontro (n°2 pezzi sup + inf.)

AC1072

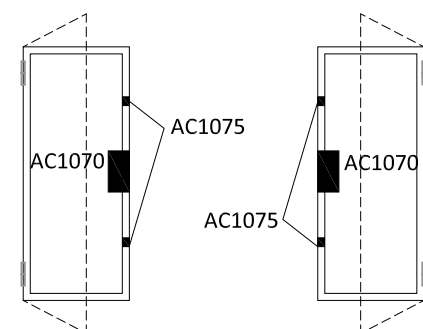
- 1) Lock
- 2) Front plate
- 3) Reduction unit/adaptor for connection
- 4) Spring latch
- 5) Bolt
- 6) Strike plate
- 7) Stainless steel screws TS M5x50
- 8) Pin for anchoring the rod

AC1075

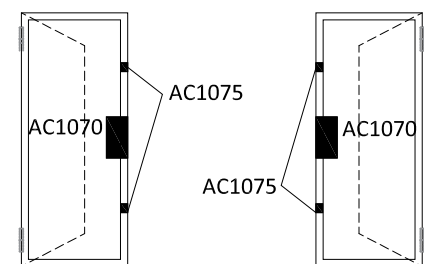
- 9) Diverters (n° 2 items upper + lower)
- 10) Apron lining (n° 2 items upper + lower)
- 11) Bolt (n° 2 items upper + lower)
- 12) Stainless steel rods (n° 2 items upper + lower)
- 13) Plate (n° 2 items upper + lower)



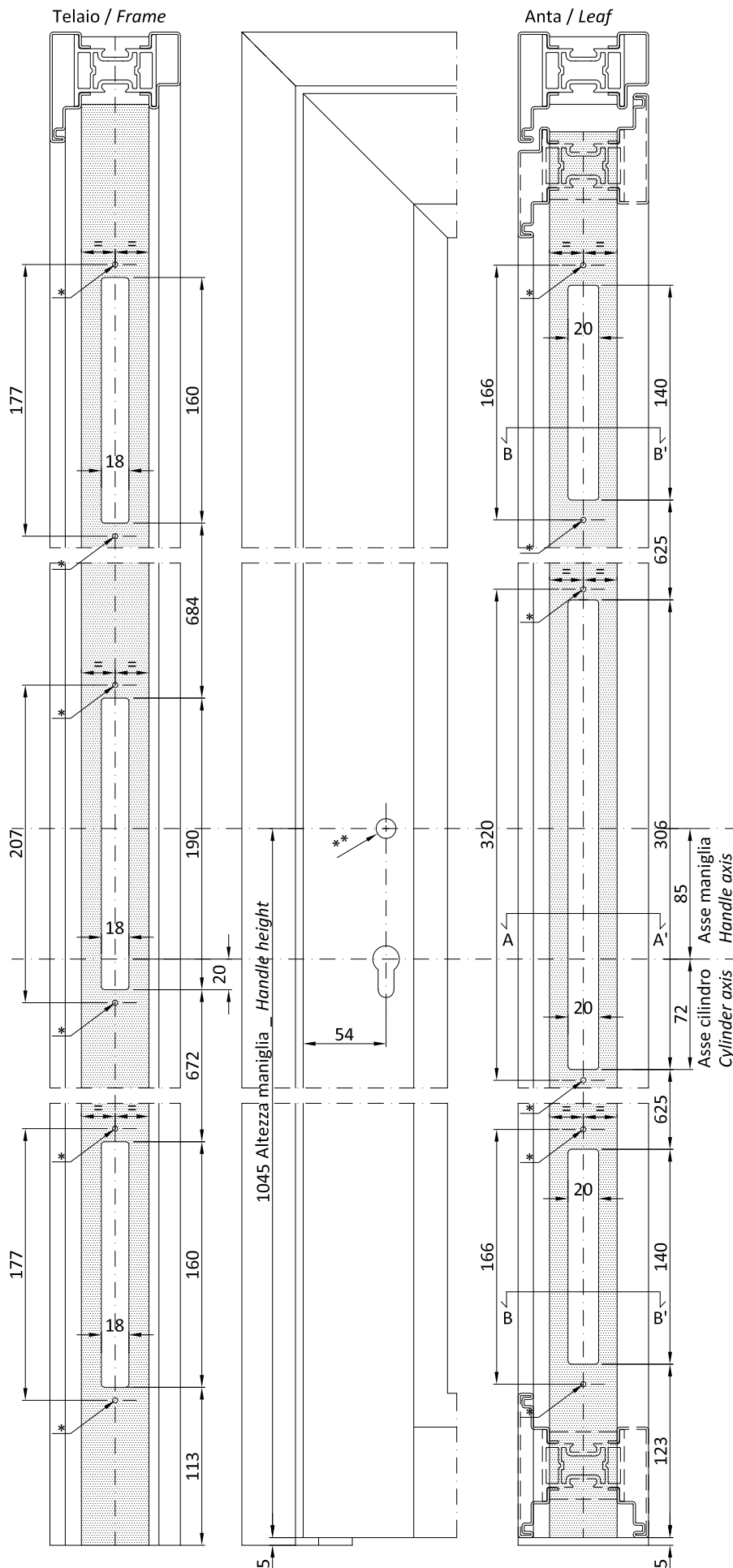
SCHEMA UTILIZZO SERRATURE E TERZE CHIUSURE
DIAGRAM FOR THE USE OF LOCKS AND THIRD LOCKS



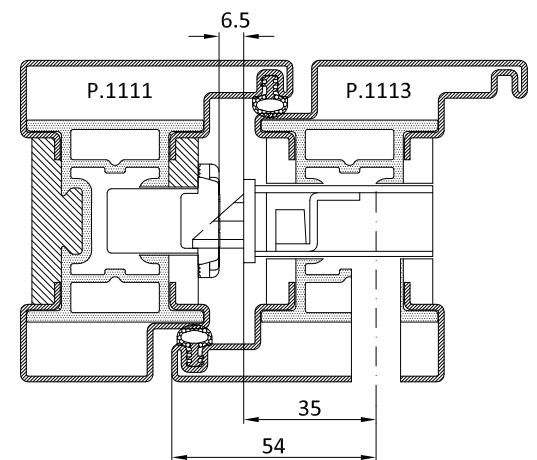
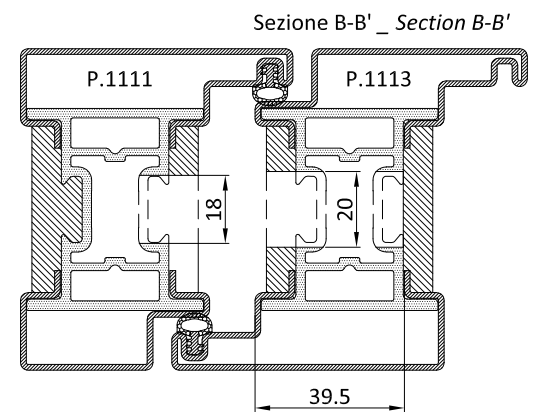
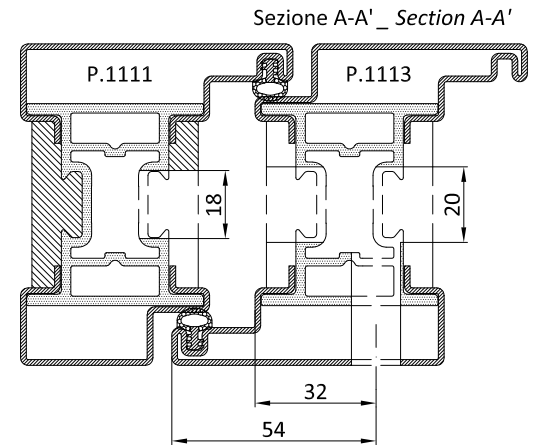
APERTURA INTERNA _ VISTA INTERNA
INWARDS OPENING _ INTERIOR ELEVATION



APERTURA ESTERNA _ VISTA INTERNA
OUTWARDS OPENING _ INTERIOR ELEVATION



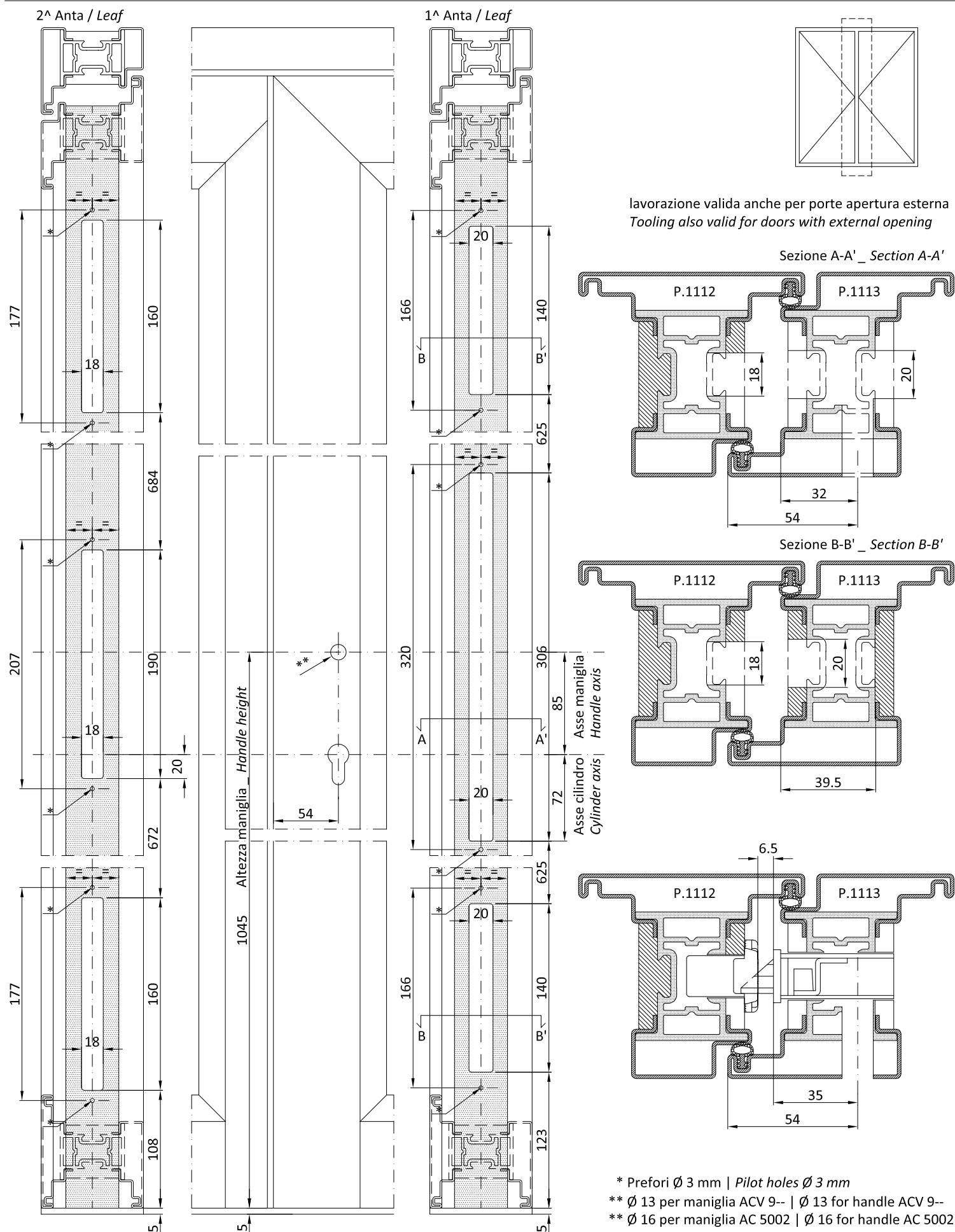
lavorazione valida anche per porte apertura esterna
Tooling also valid for doors with external opening

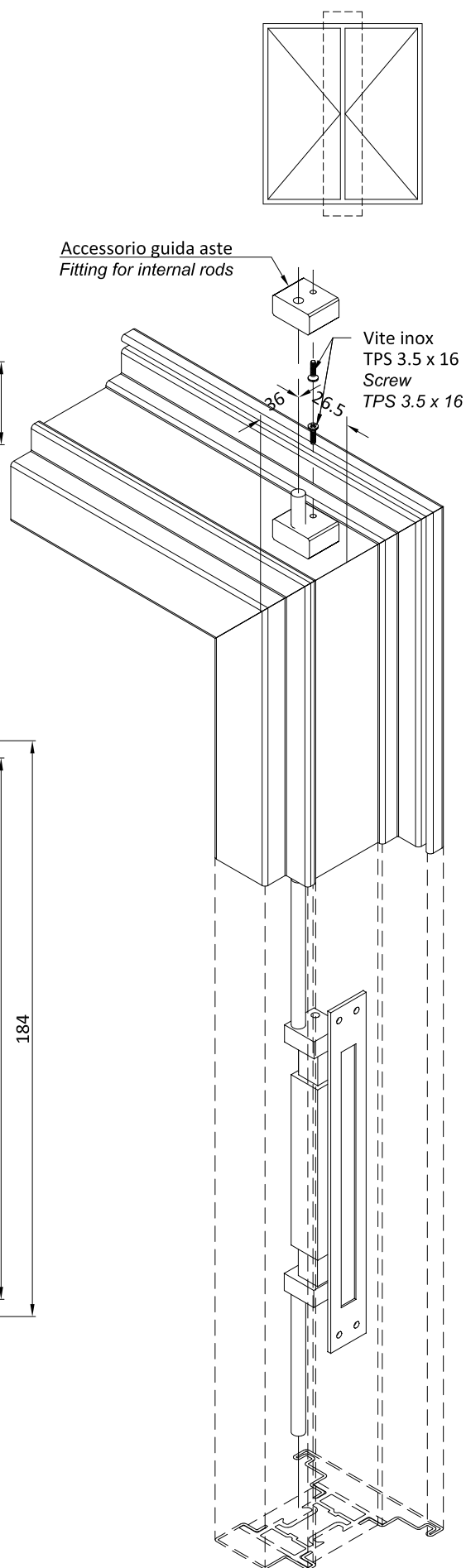
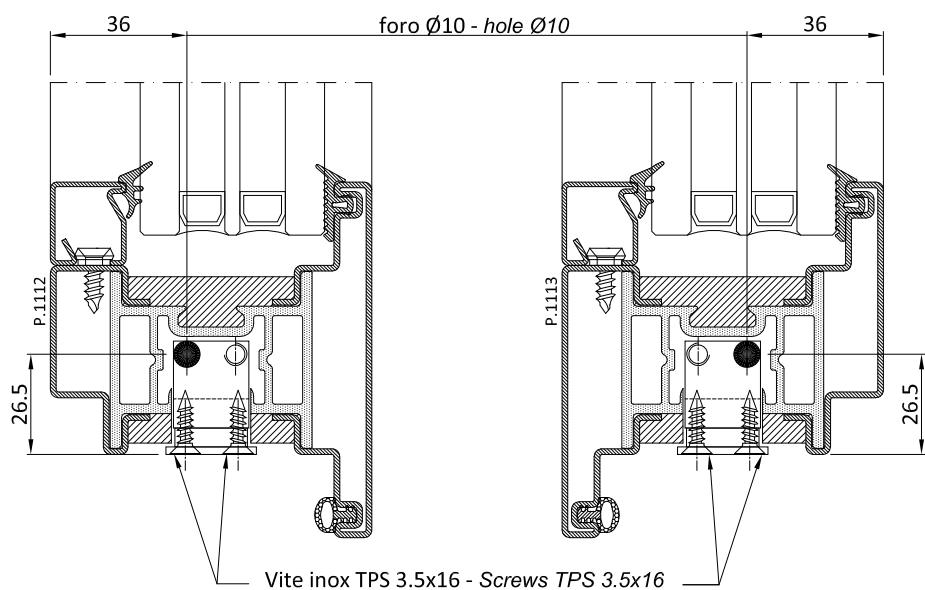


* Prefori Ø 3 mm | Pilot holes Ø 3 mm

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

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



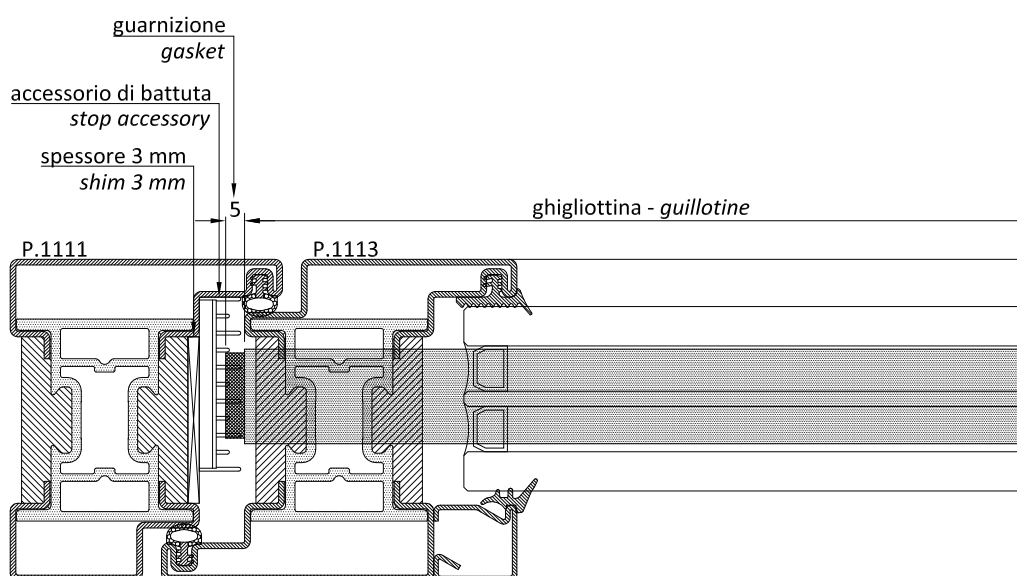
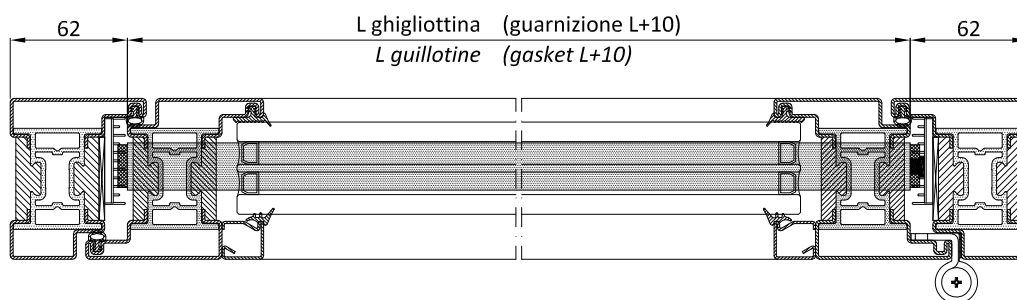
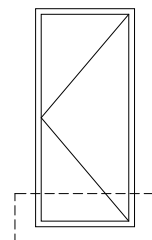


Aste $\varnothing 7$ mm L. mm. 1500
 $\varnothing 7$ mm L. mm. 1500 rods

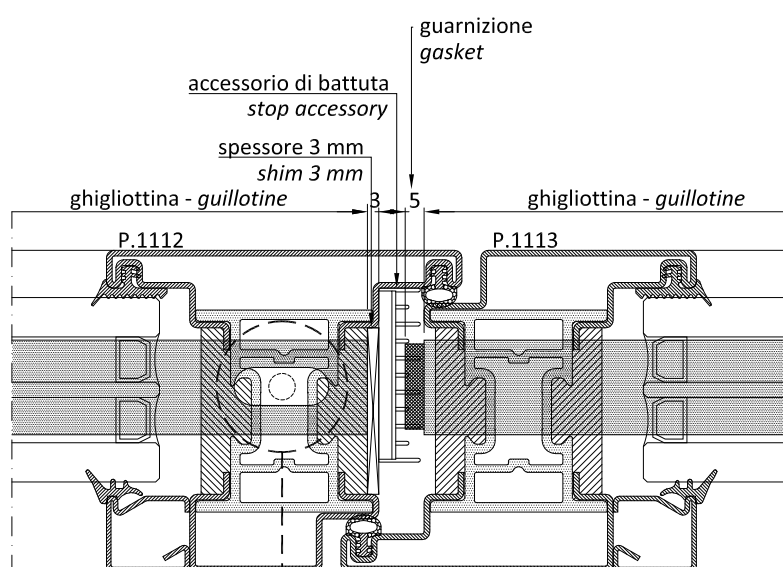
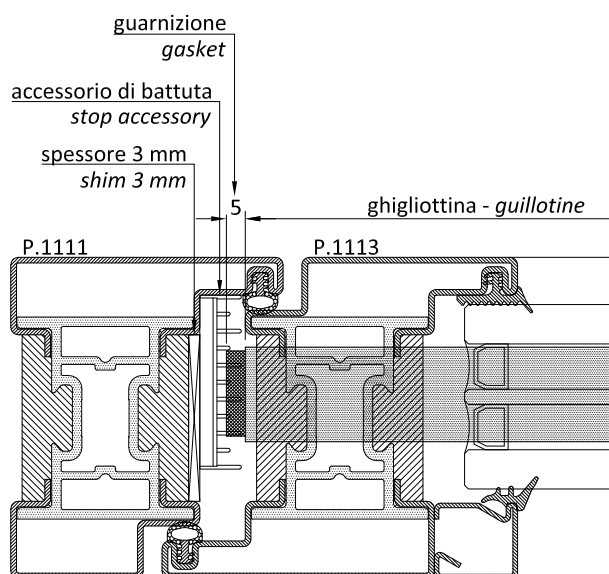
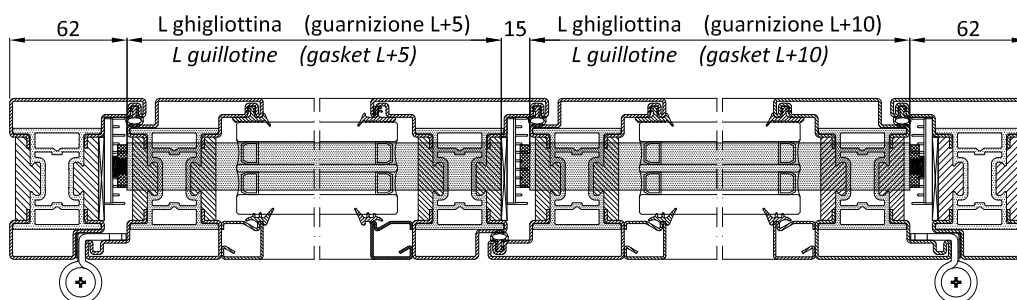
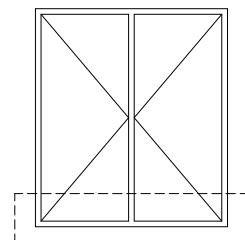


AC1040 catenaccio
AC1040 bolt

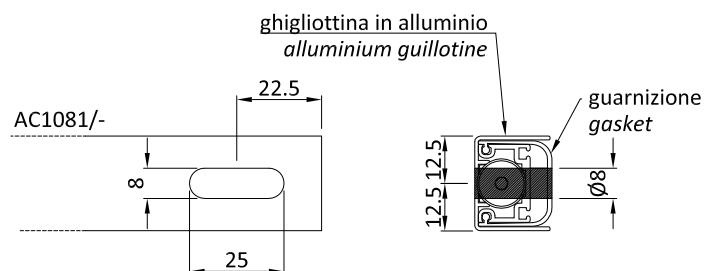
cod.	dimensioni dimensions [mm]
AC1081/A	615 → 730
AC1081/B	715 → 830
AC1081/C	815 → 930
AC1081/D	915 → 1030
AC1081/E	1015 → 1130
AC1081/F	1115 → 1230

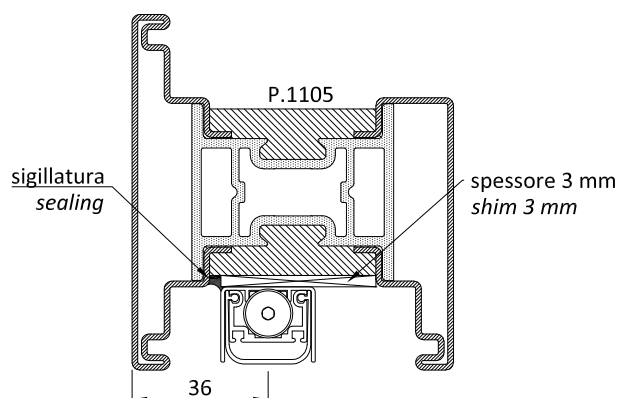
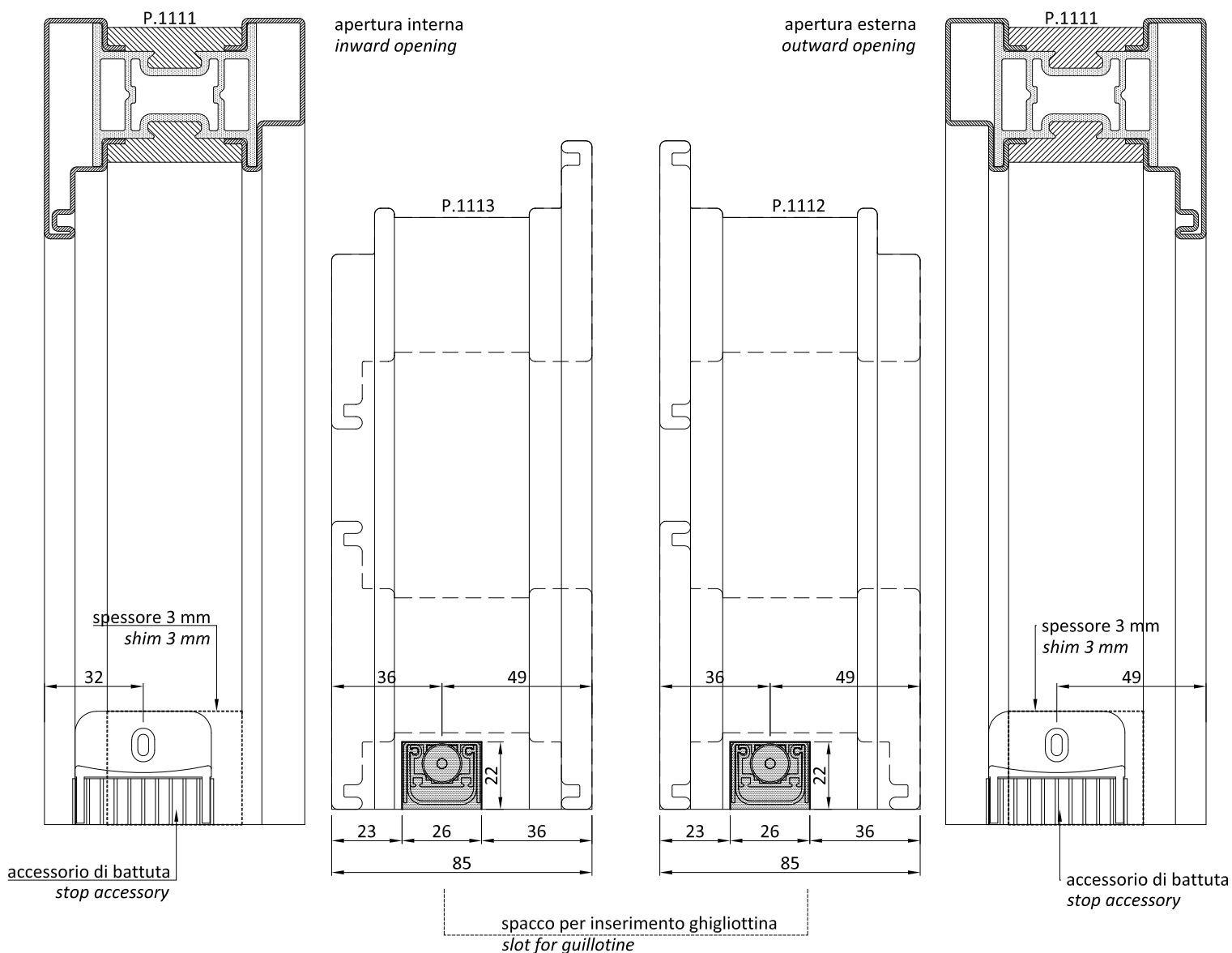
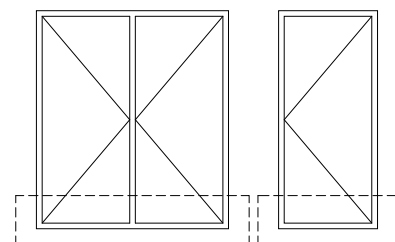


cod.	dimensioni dimensions [mm]
AC1081/A	615 → 730
AC1081/B	715 → 830
AC1081/C	815 → 930
AC1081/D	915 → 1030
AC1081/E	1015 → 1130
AC1081/F	1115 → 1230

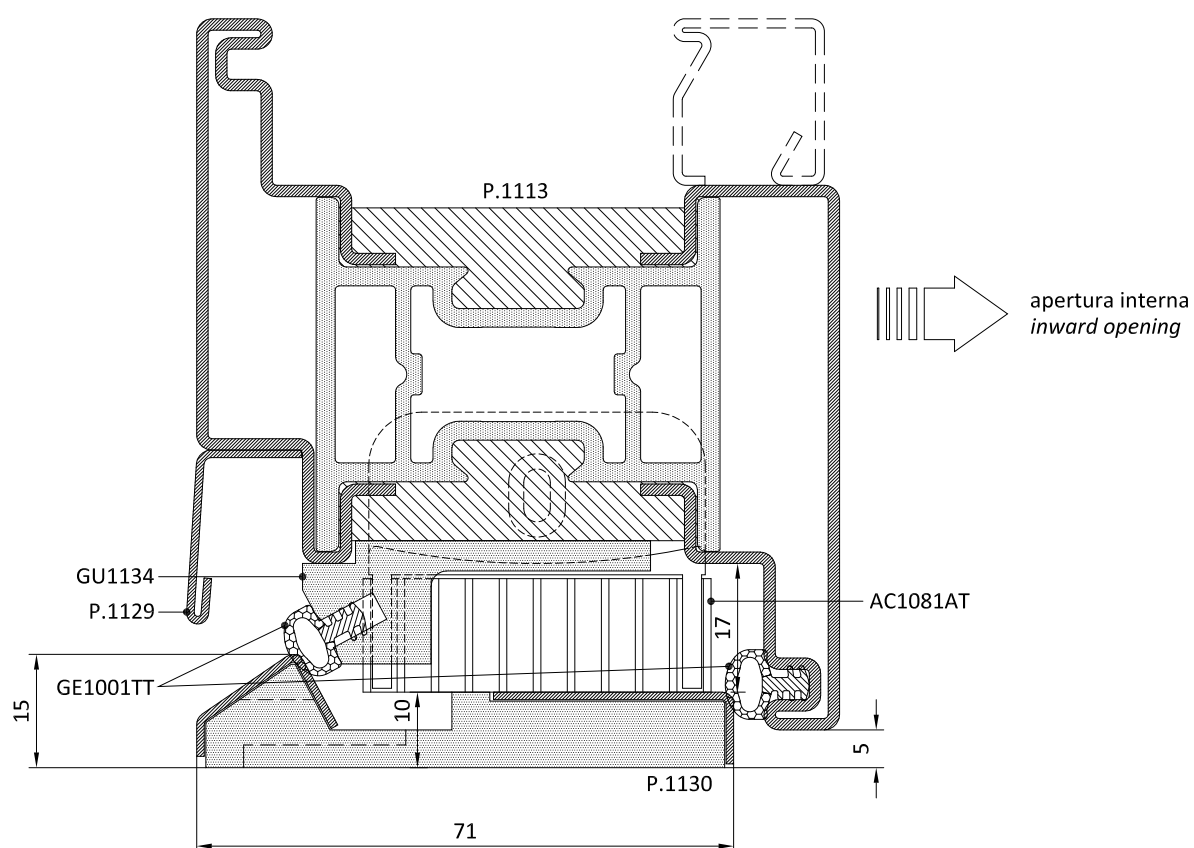
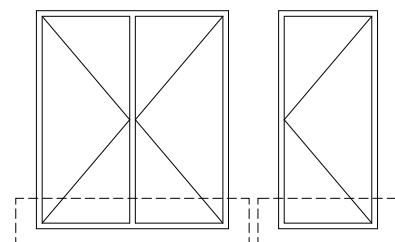


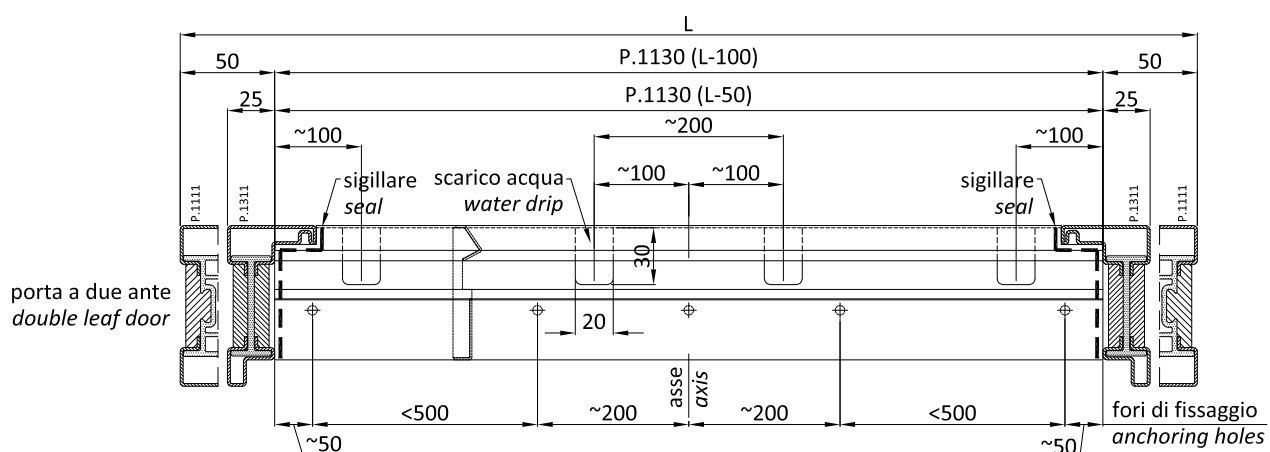
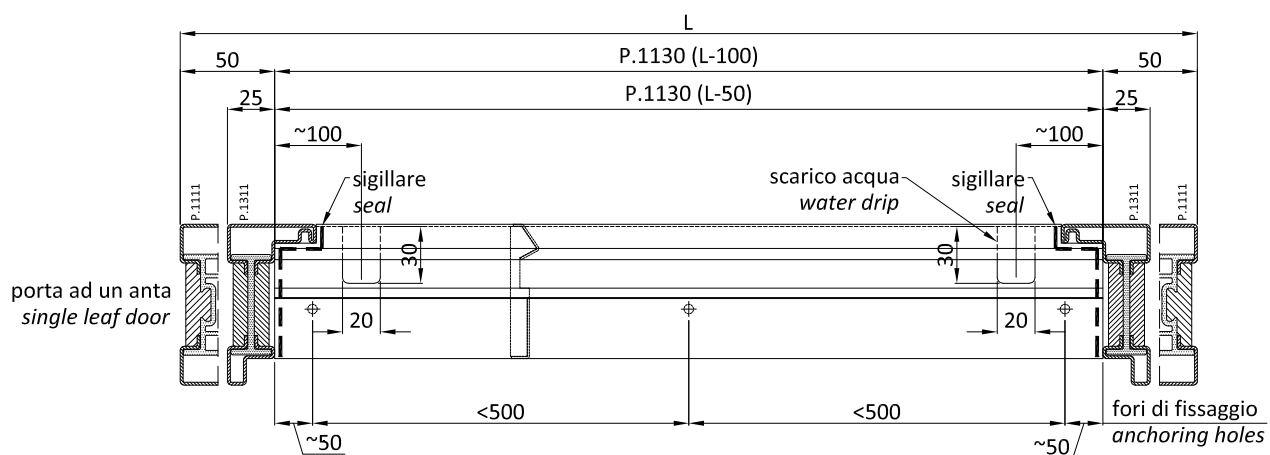
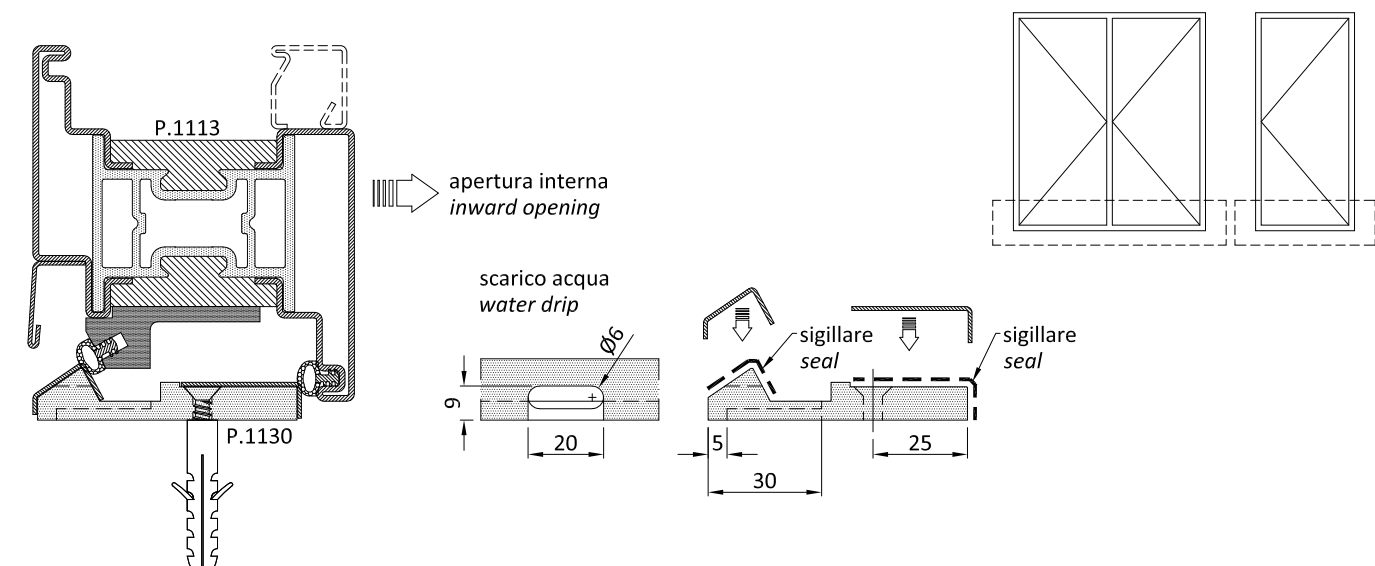
Lavorazione per porta a due ante con AC1040
Working for two leaf door with AC1040

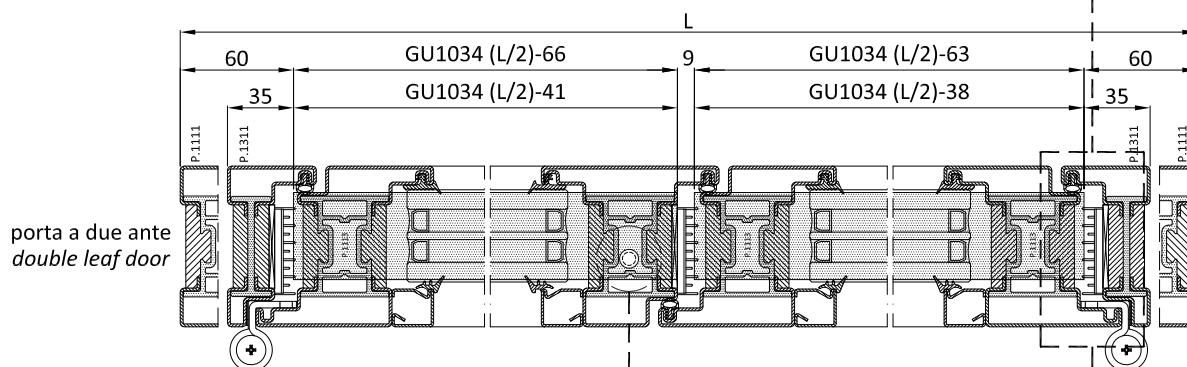
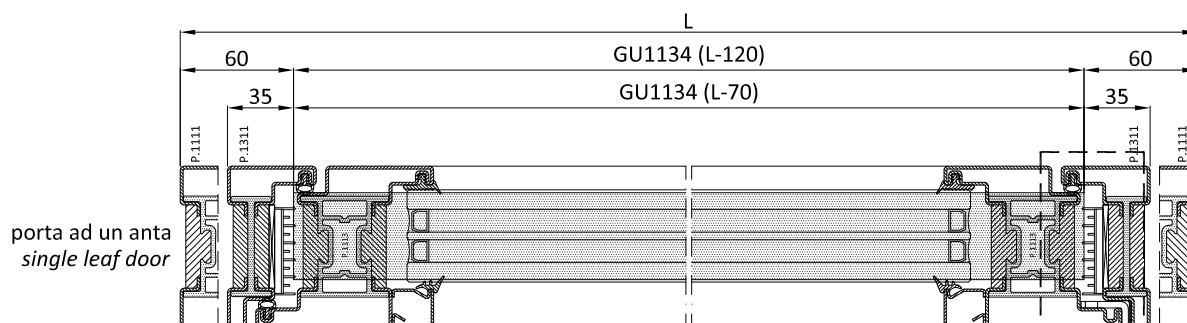
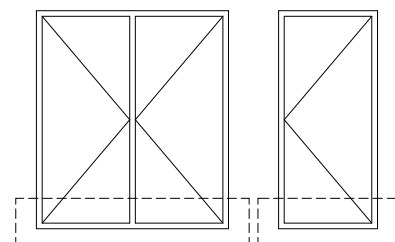
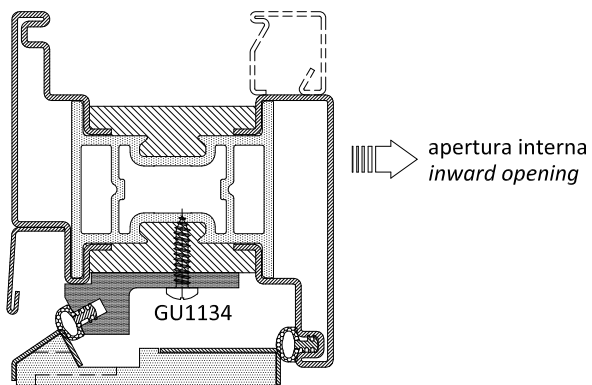




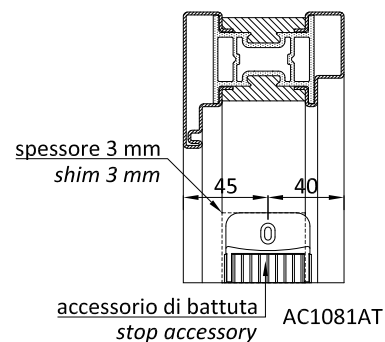
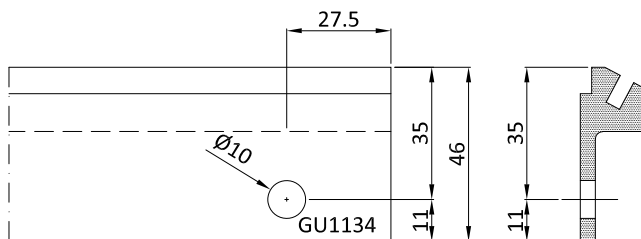
viti in dotazione
supplied screws

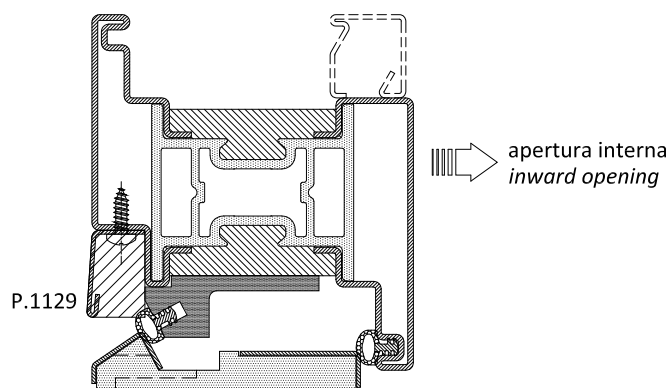




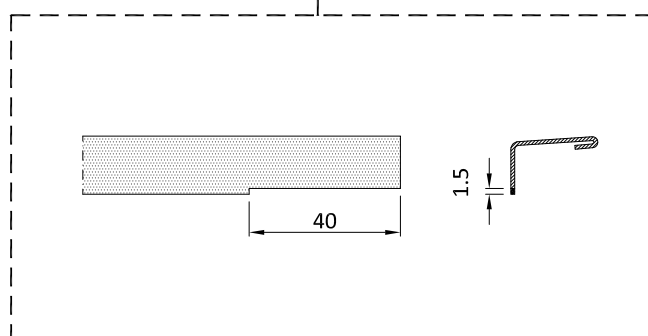
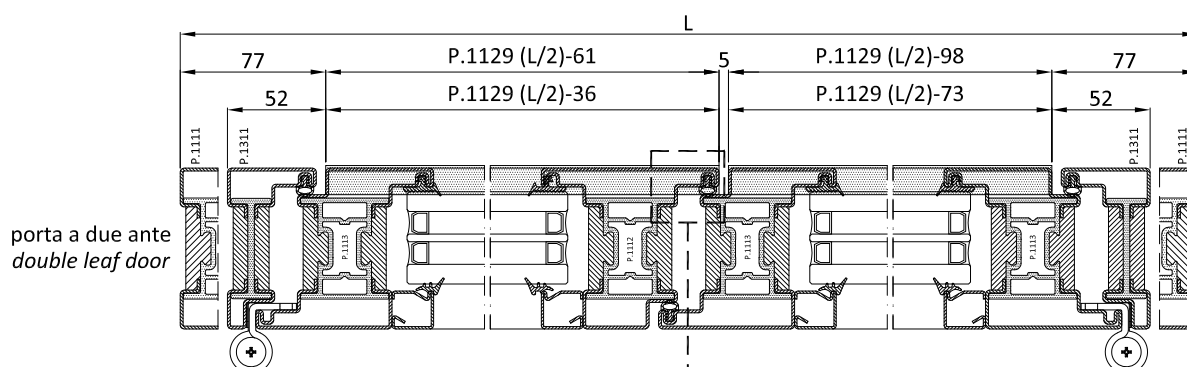
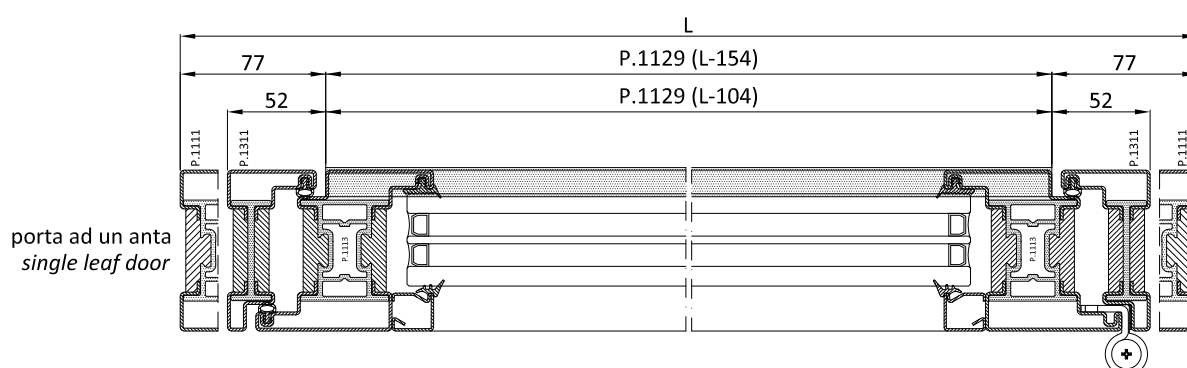
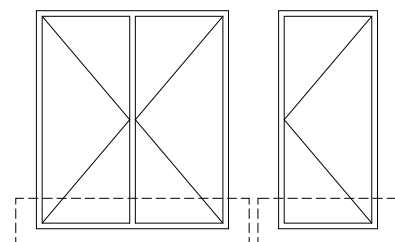
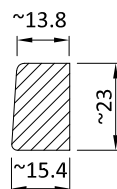


Lavorazione per porta a due ante con AC1040
Working for two leaf door with AC1040

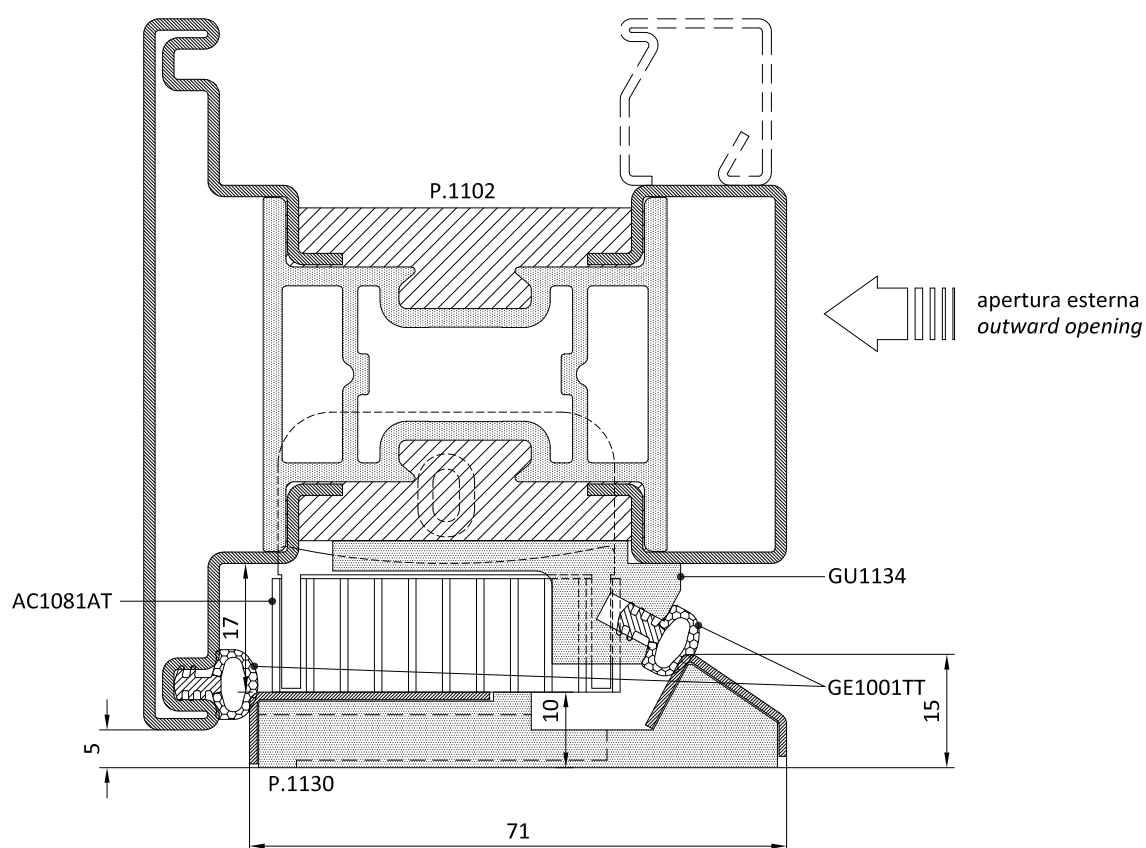
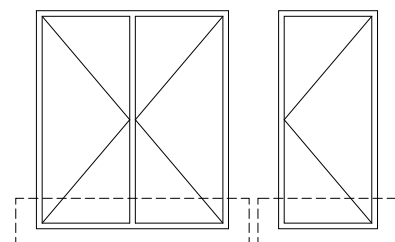


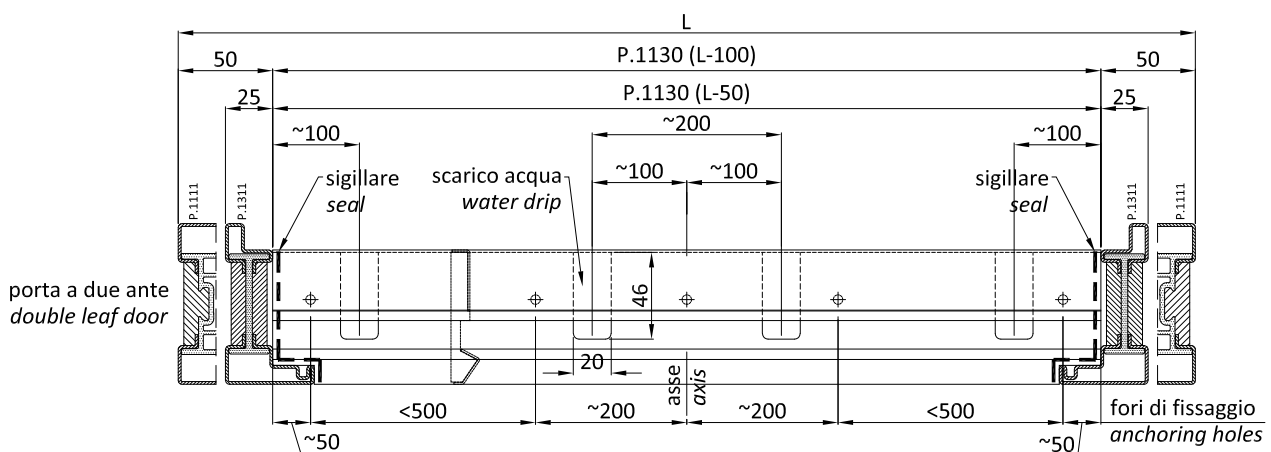
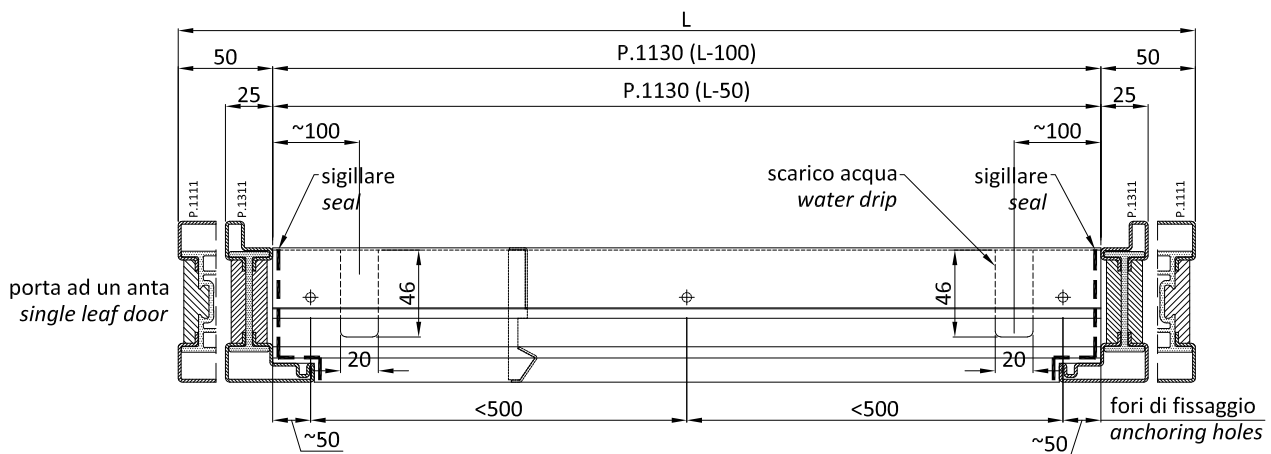
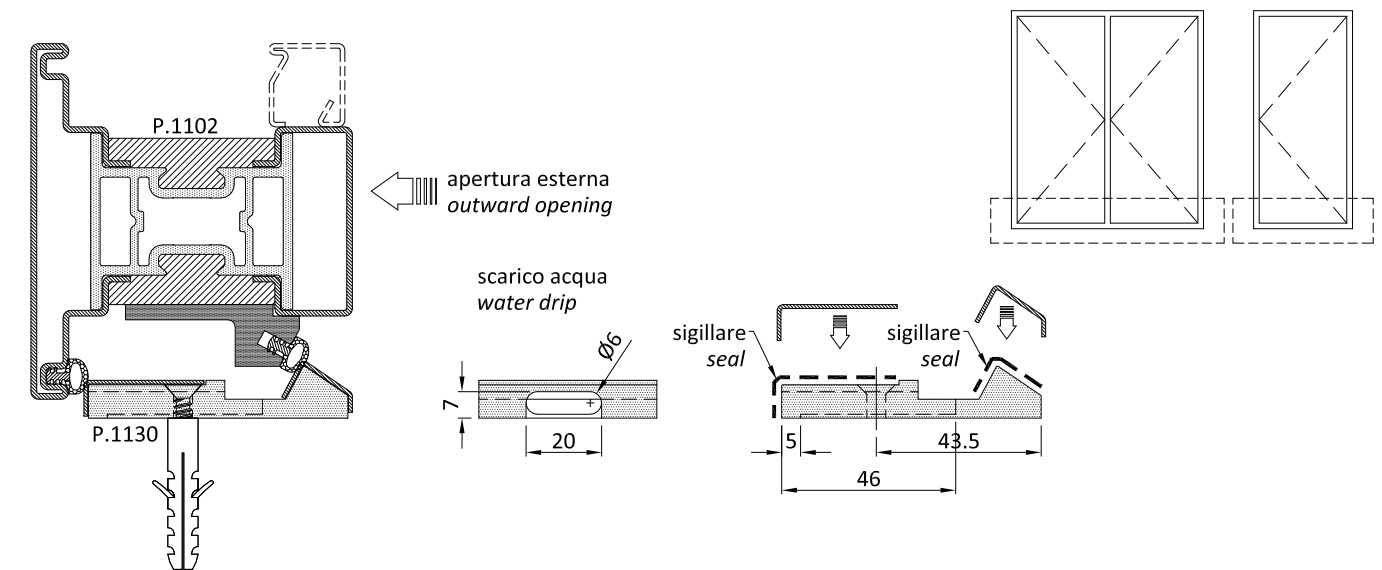


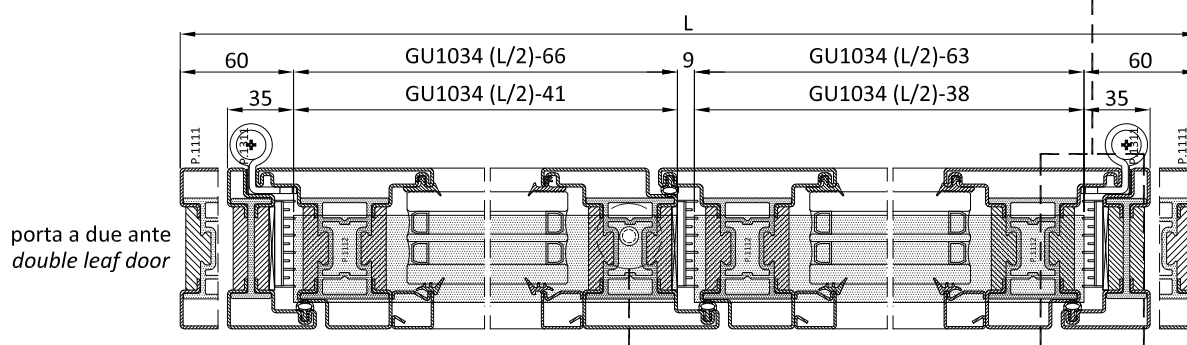
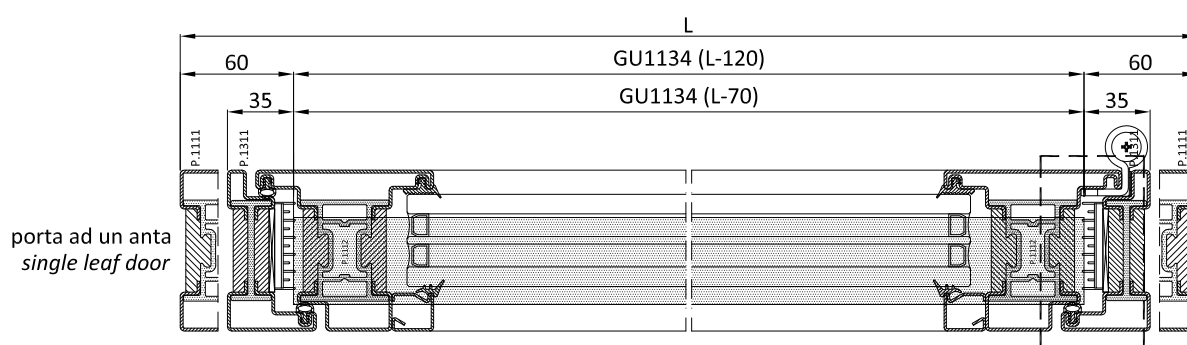
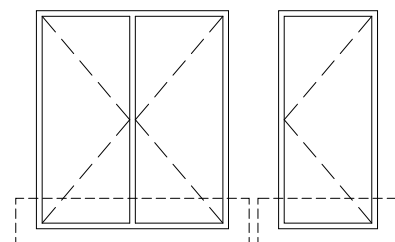
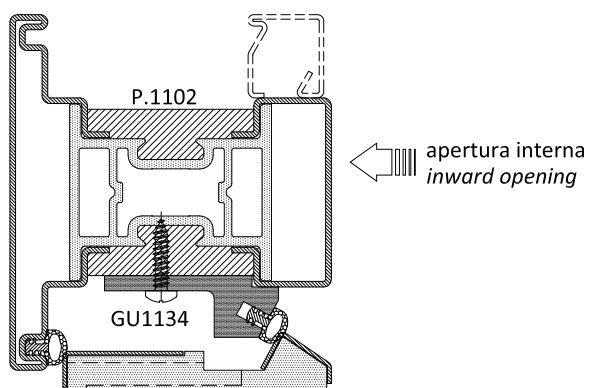
tappo di finitura*
ending cap*



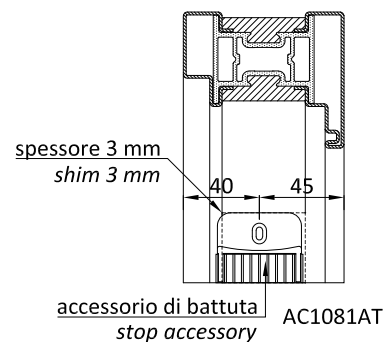
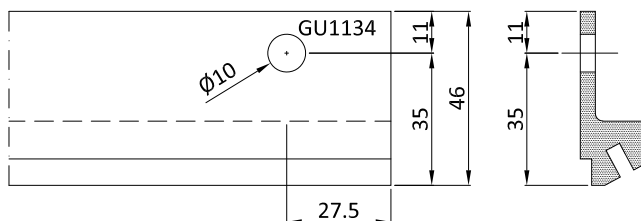
*non forniti
*not included

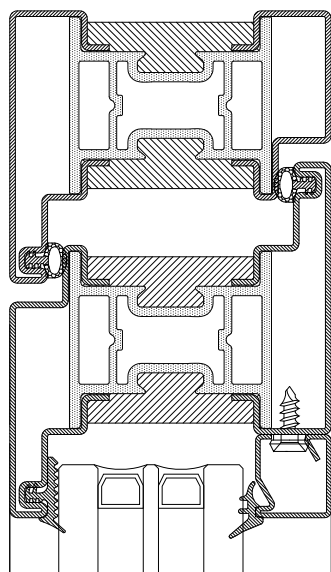
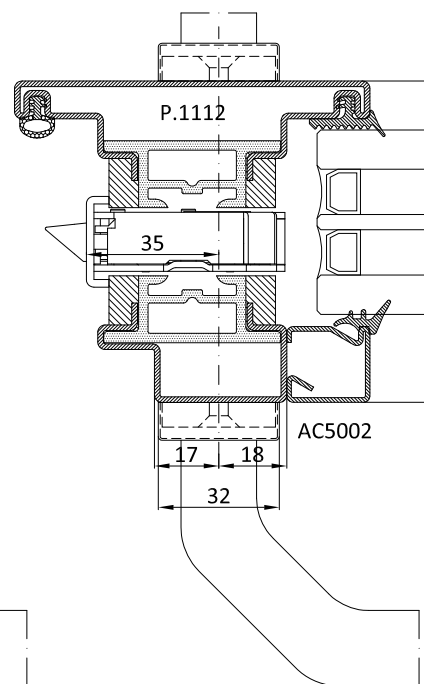
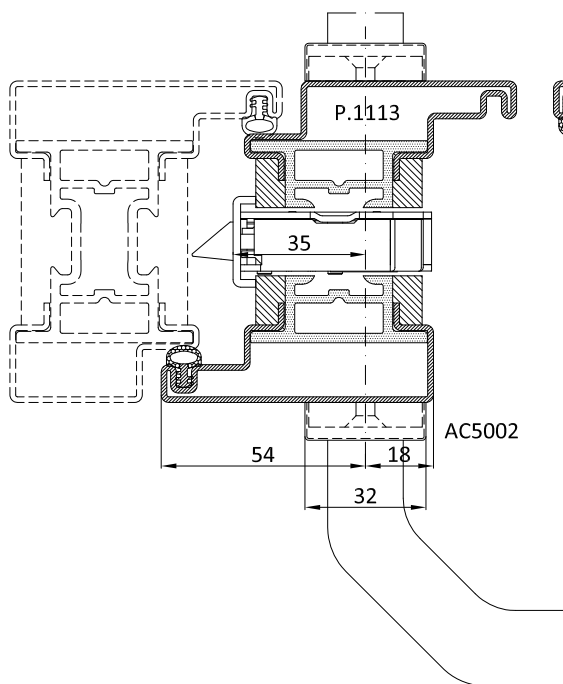
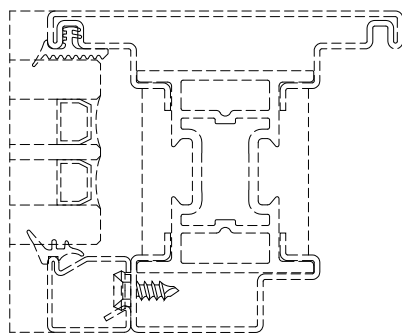
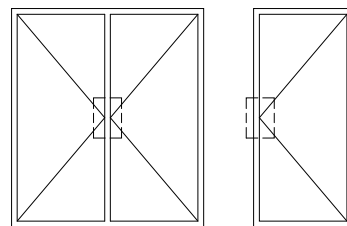






Lavorazione per porta a due ante con AC1040
Working for two leaf door with AC1040



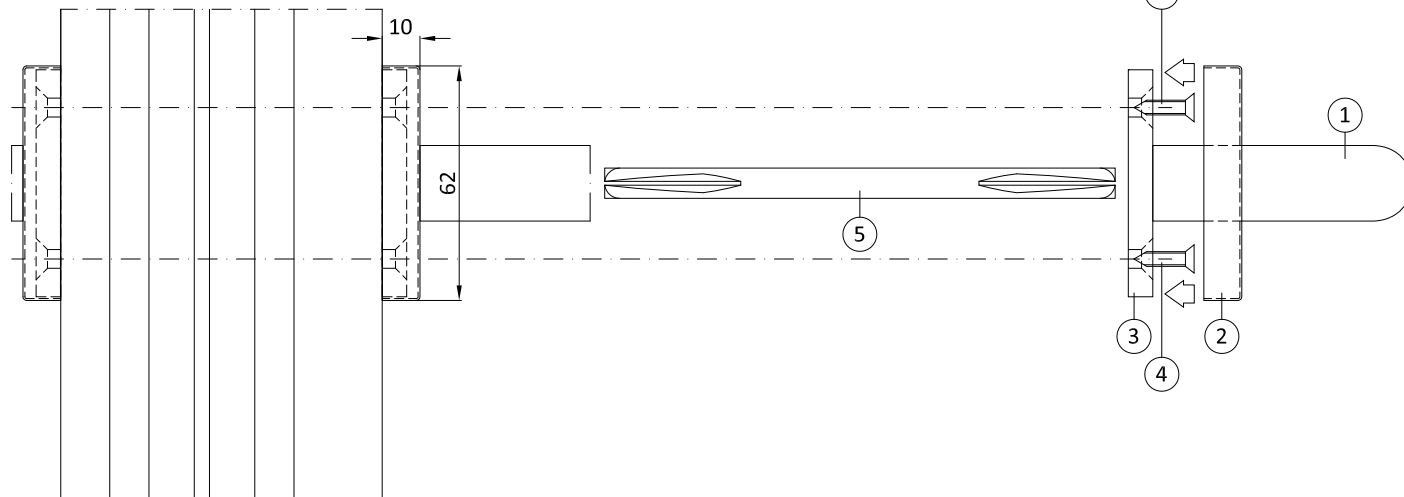


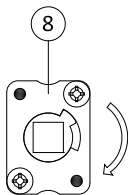
AC5002 :

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

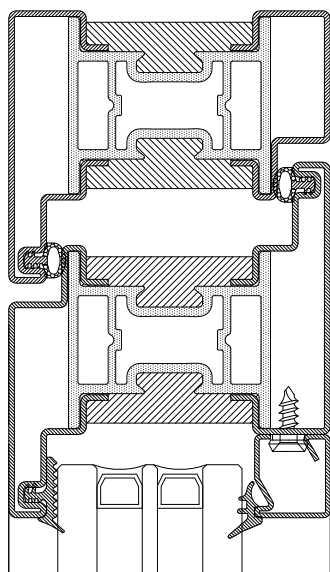
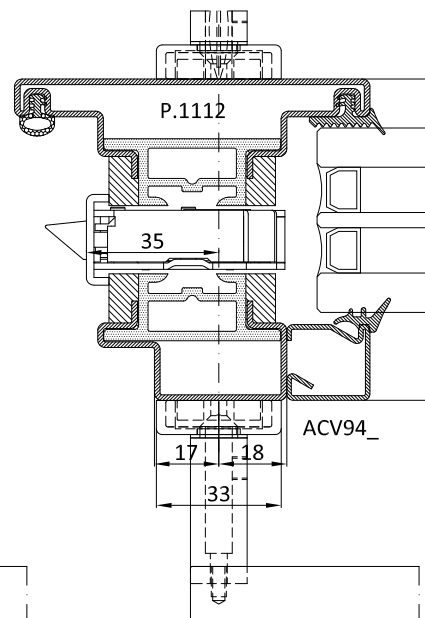
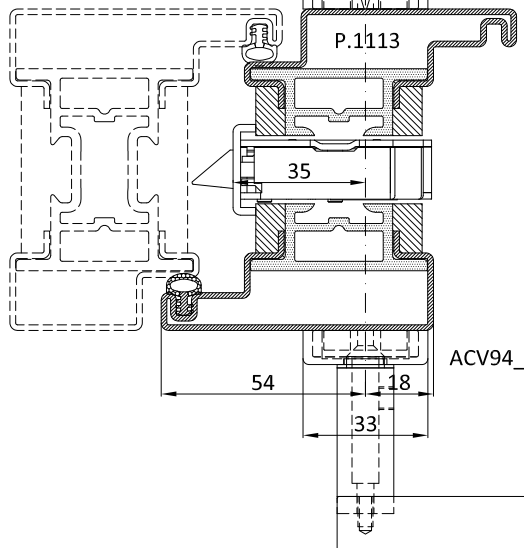
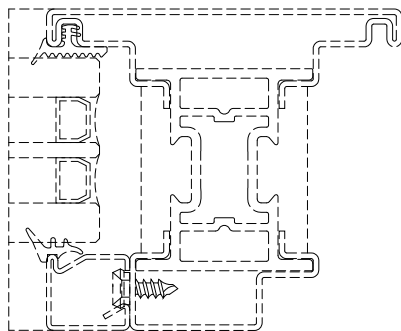
AC5002 :

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





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

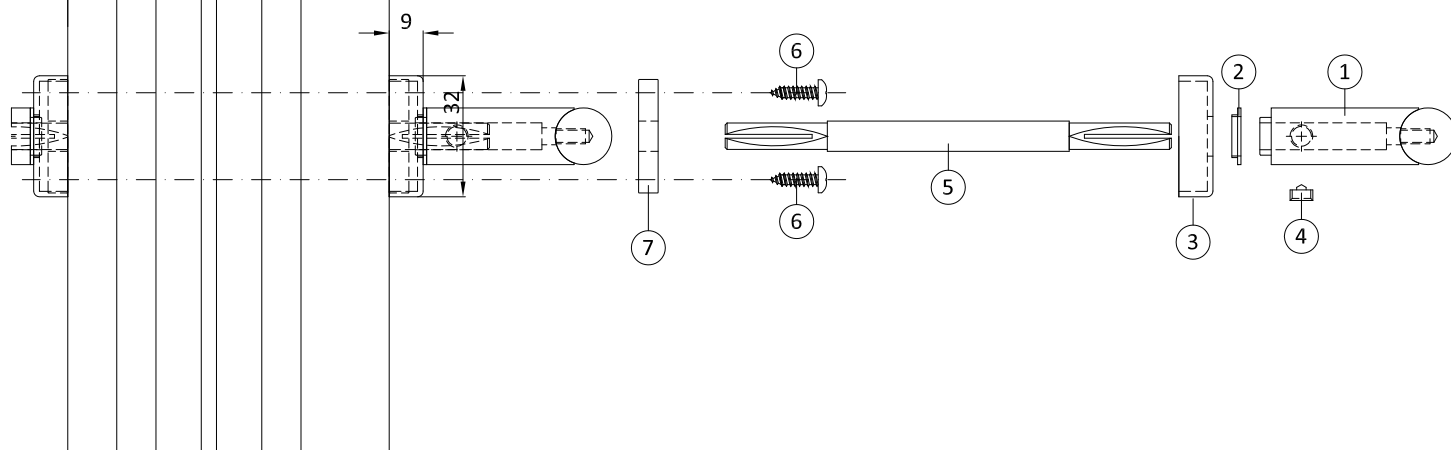


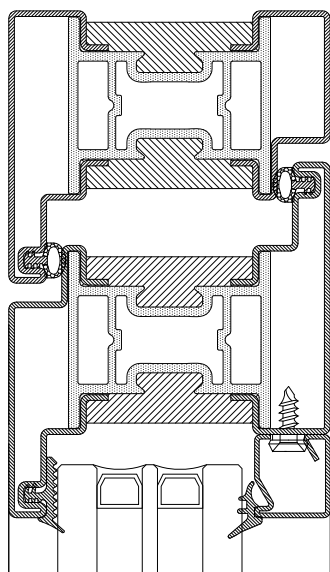
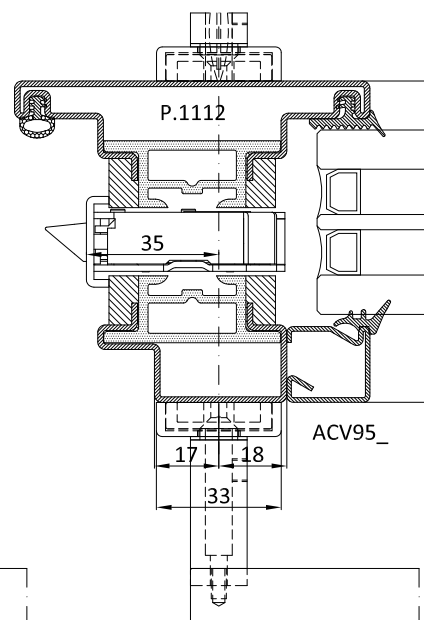
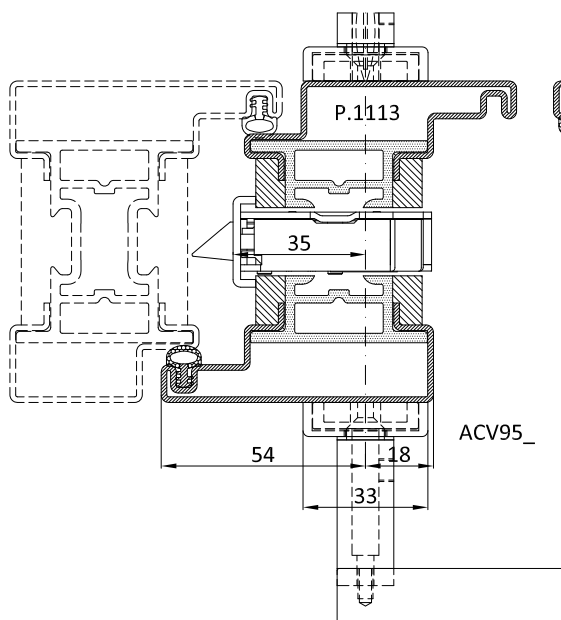
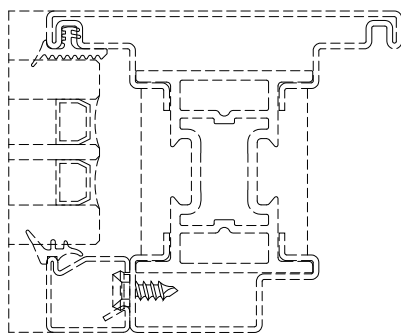
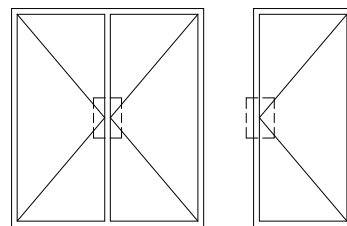
ACV94- :

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

ACV94- :

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



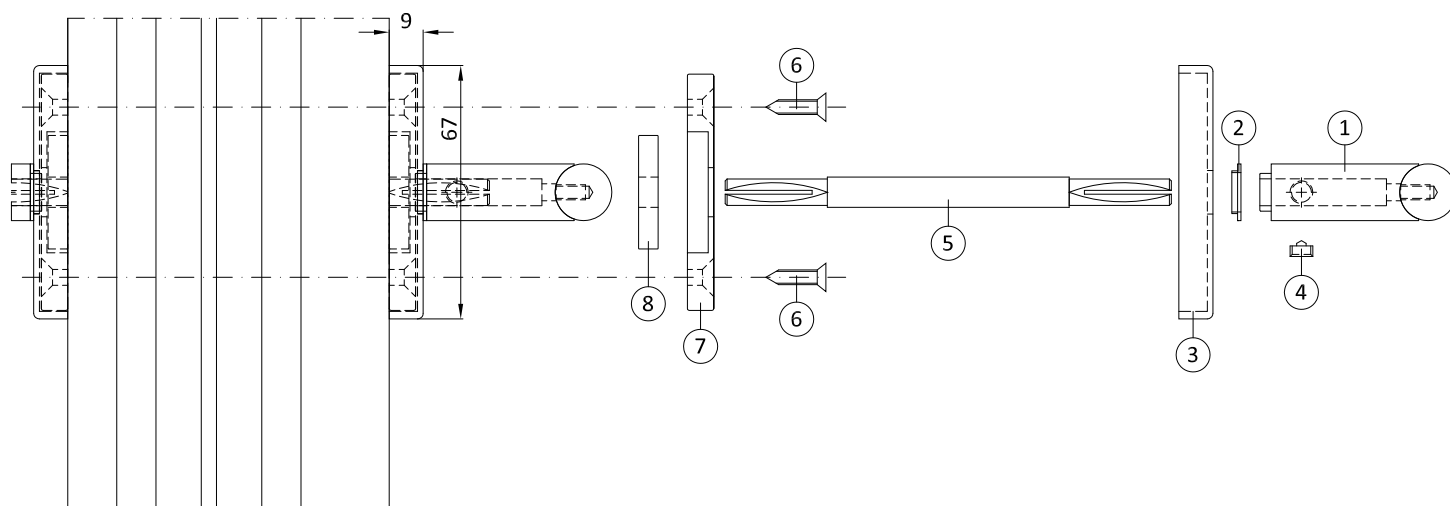


ACV95- :

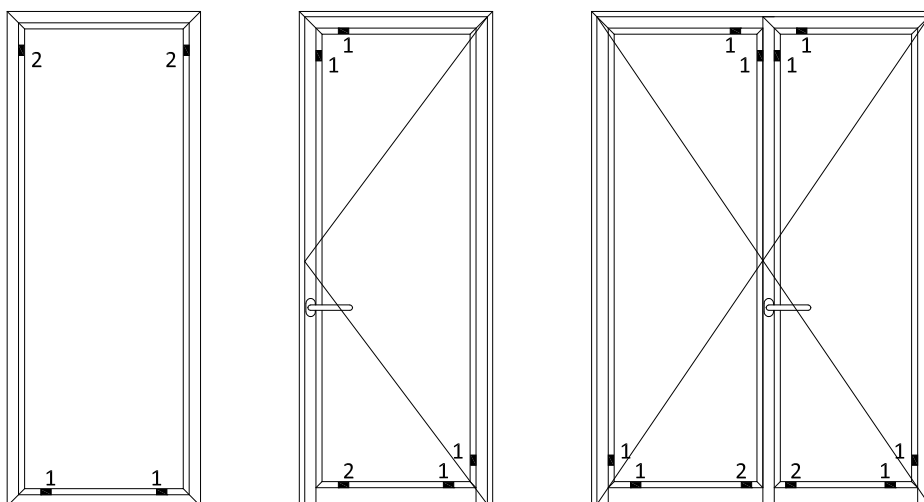
- 1) Impugnatura
- 2) Rondella
- 3) Rosetta
- 4) Grano M6x6
- 5) Quadro
- 6) Vite TPS 3.9x15.9
- 7) Adattatore per molla
- 8) Molla

ACV95- :

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

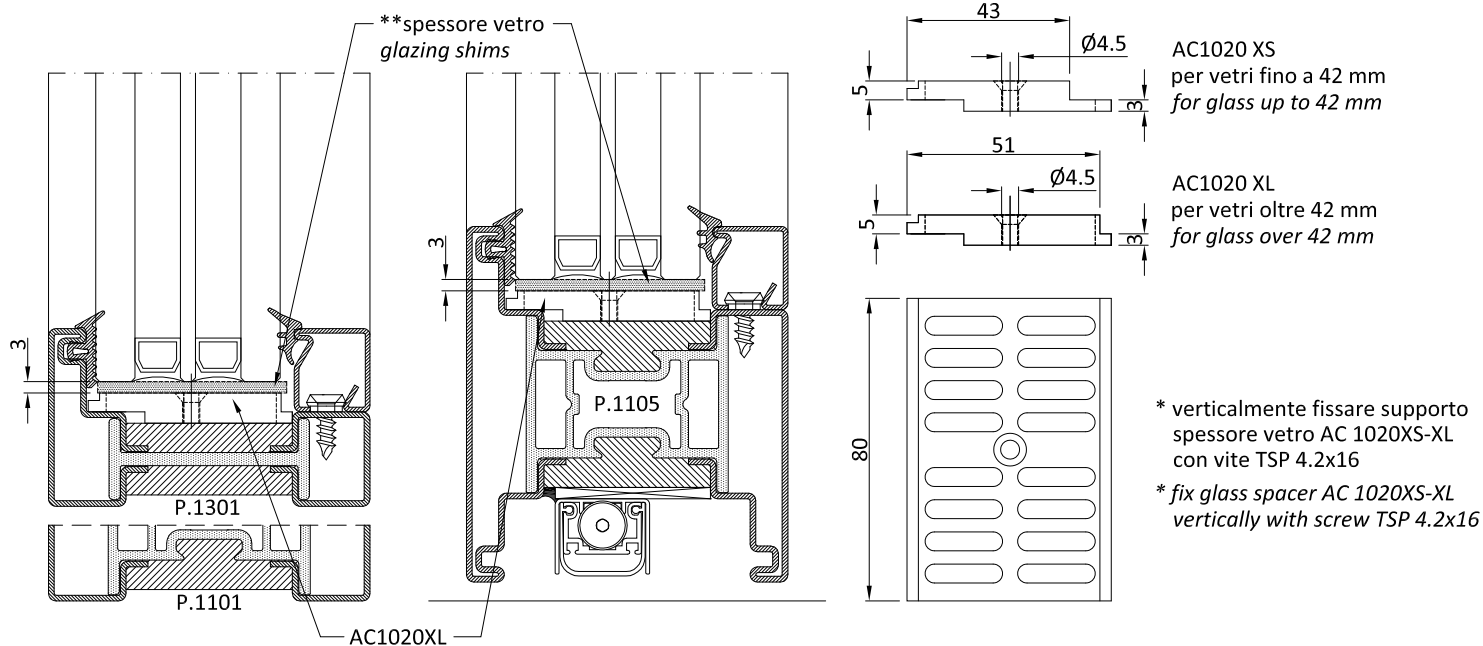


Porta | Door



1) spessore portante | *carry shim*

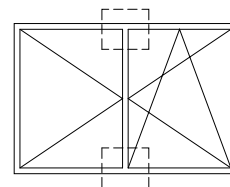
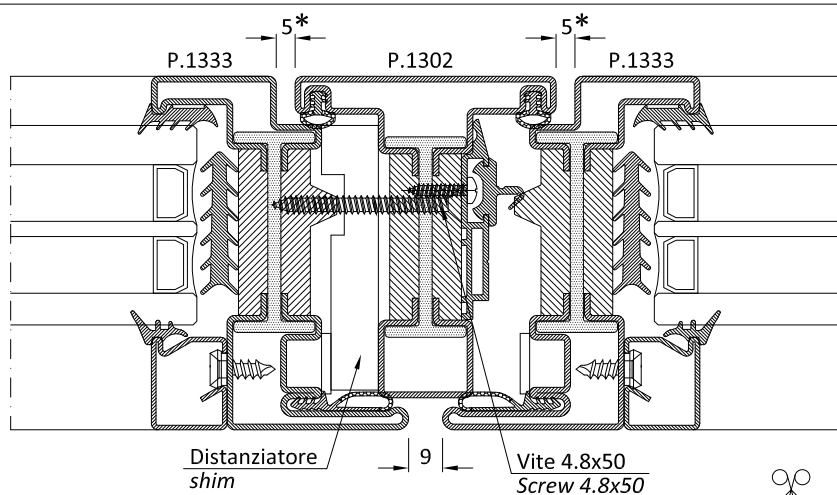
2) spessore distanziatore | *compensation shim*



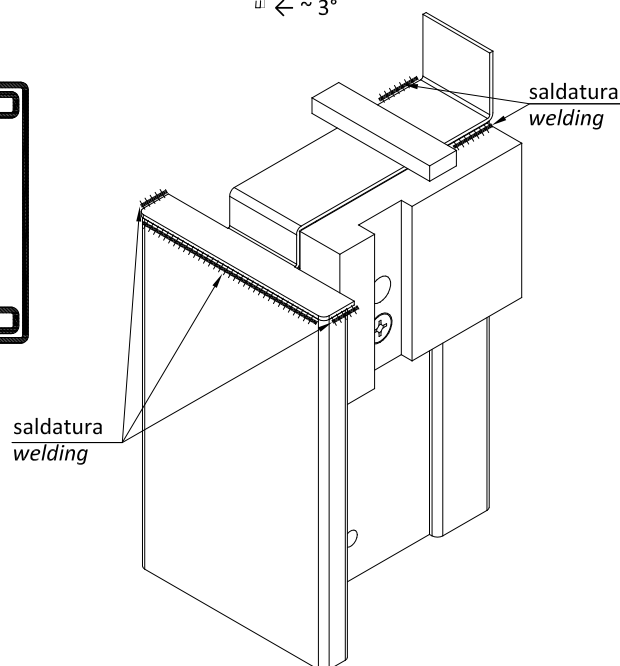
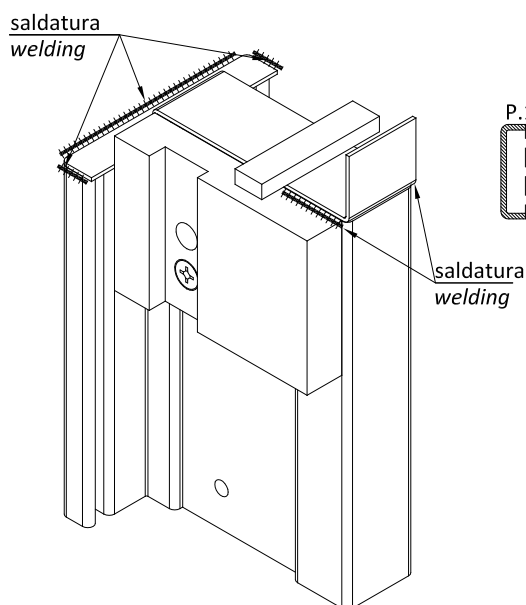
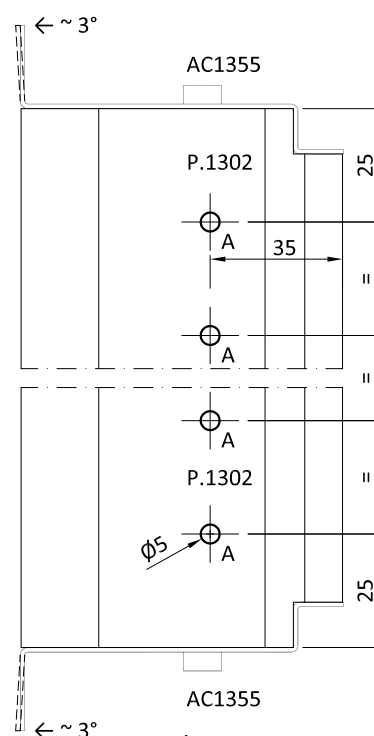
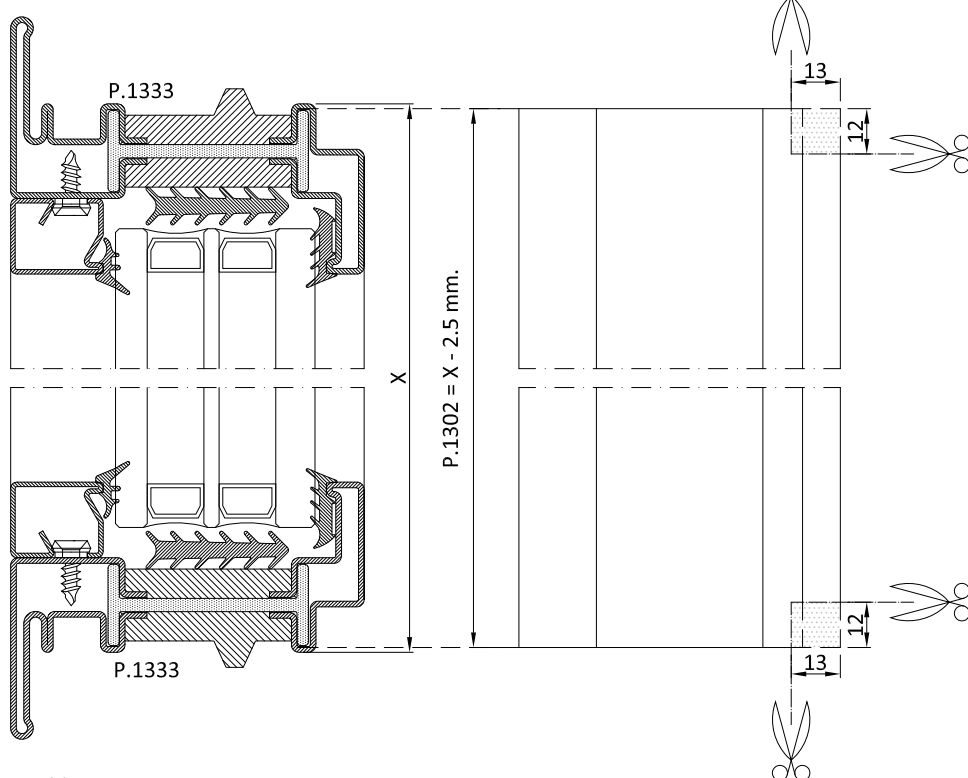
Note / Note

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

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

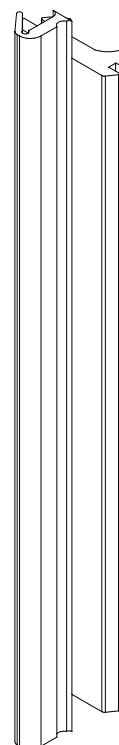
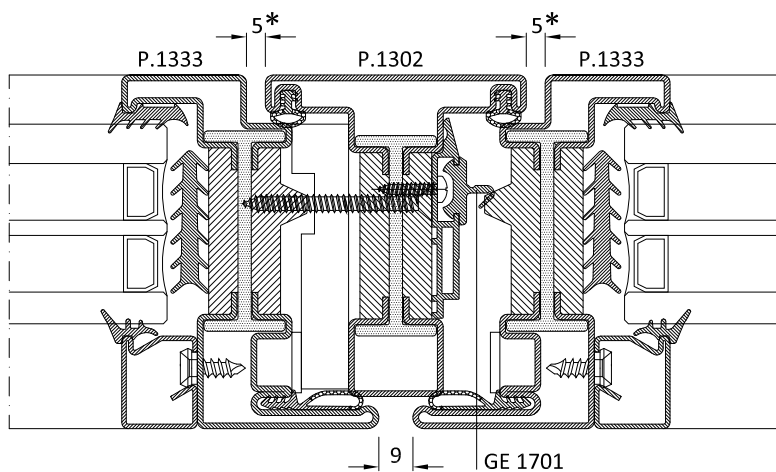
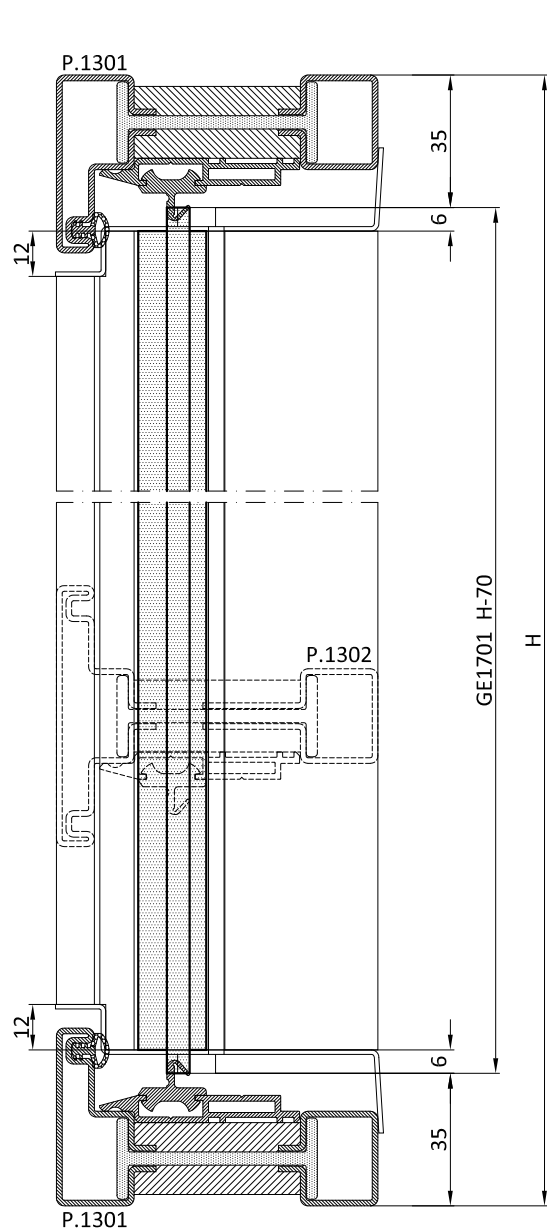
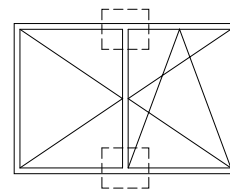


A = Fori di fissaggio P.1302 con P.1333
A = Anchoring holes P.1302 with P.1333

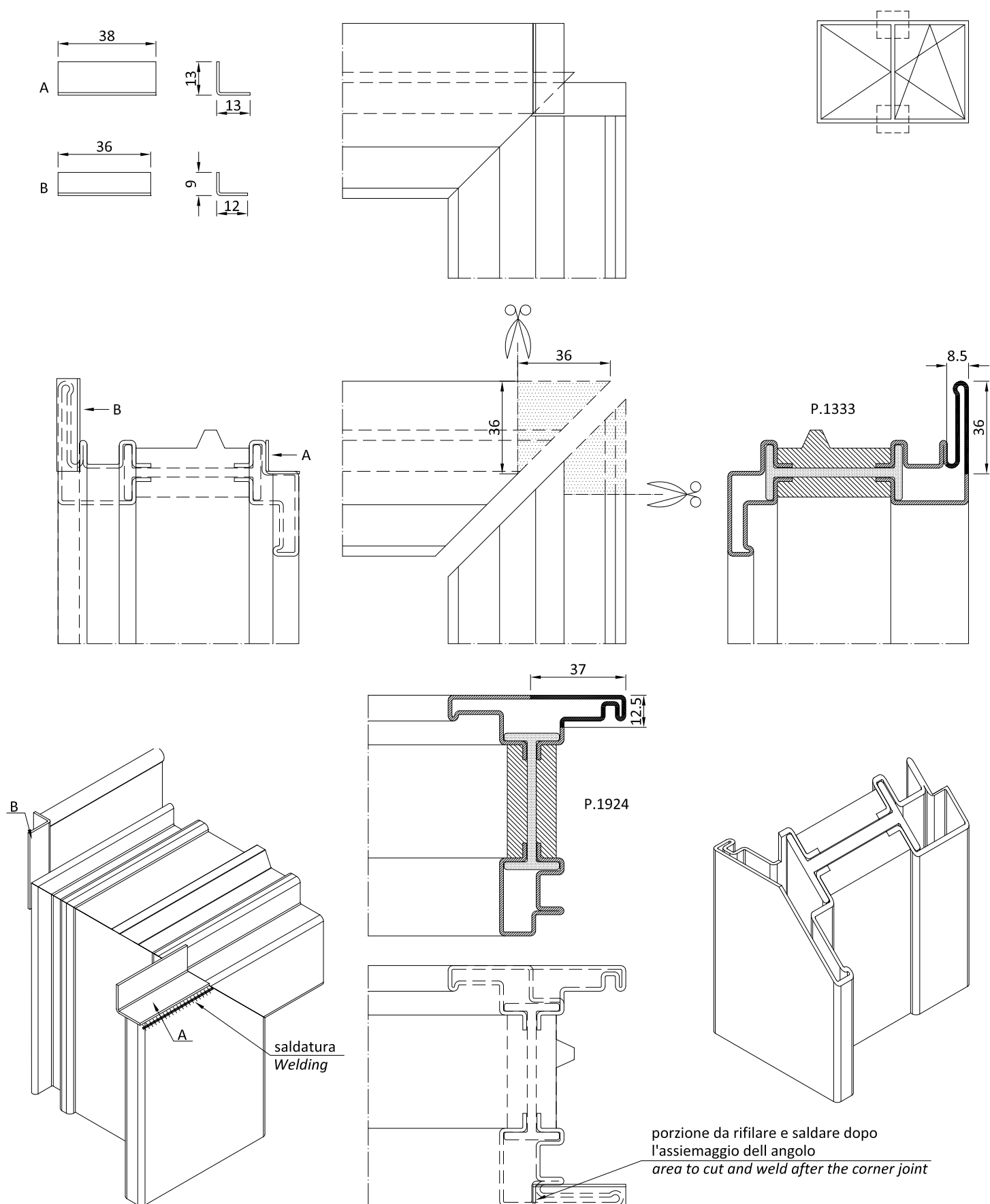


Saldare e sigillare l'accessorio AC1215 al profilo montante P.1202
Weld and seal AC1215 to P.1202 transom profile

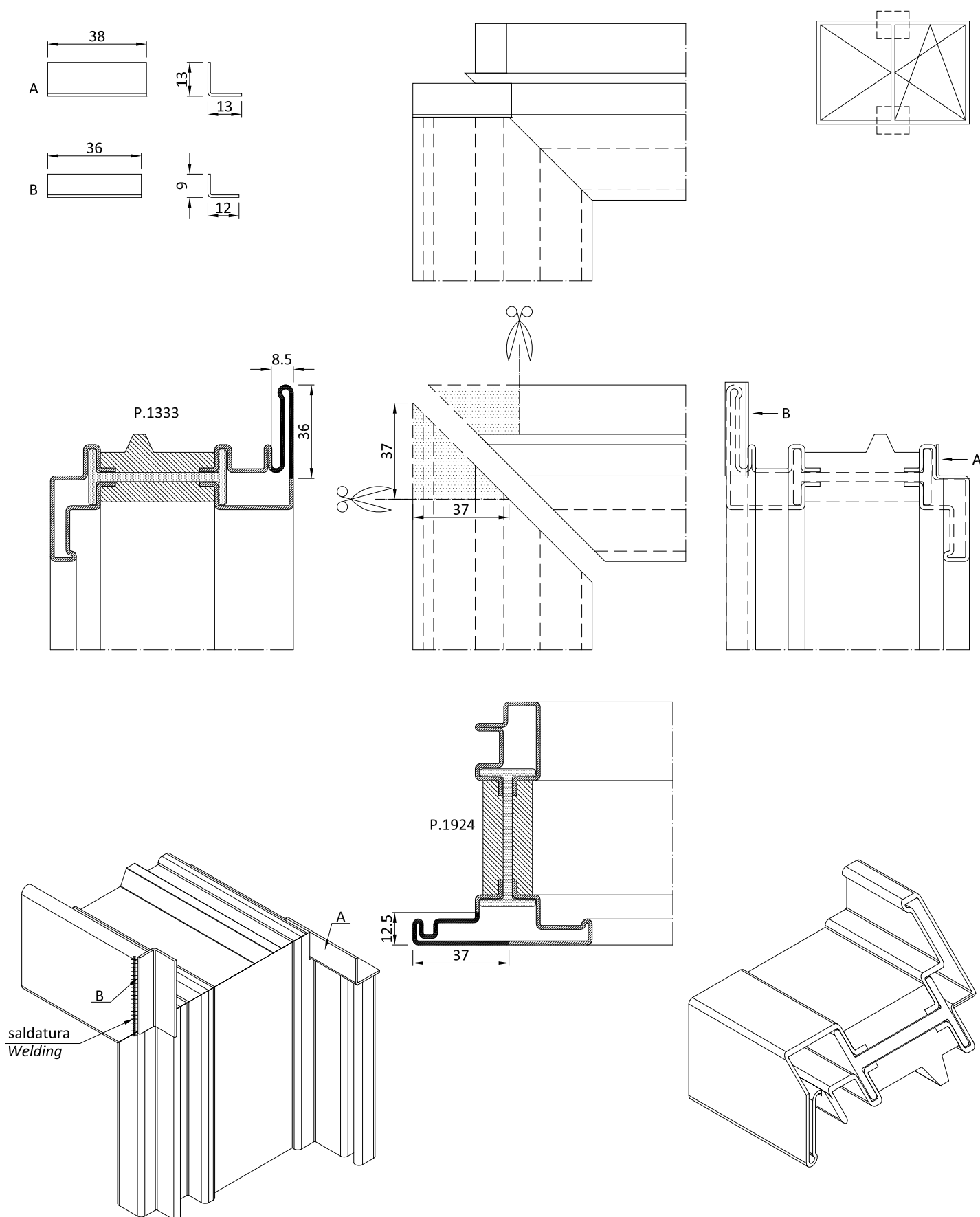
* Vedi tabella 4.1.5
* See chart 4.1.5



* Vedi tabella 4.1.5
* See chart 4.1.5

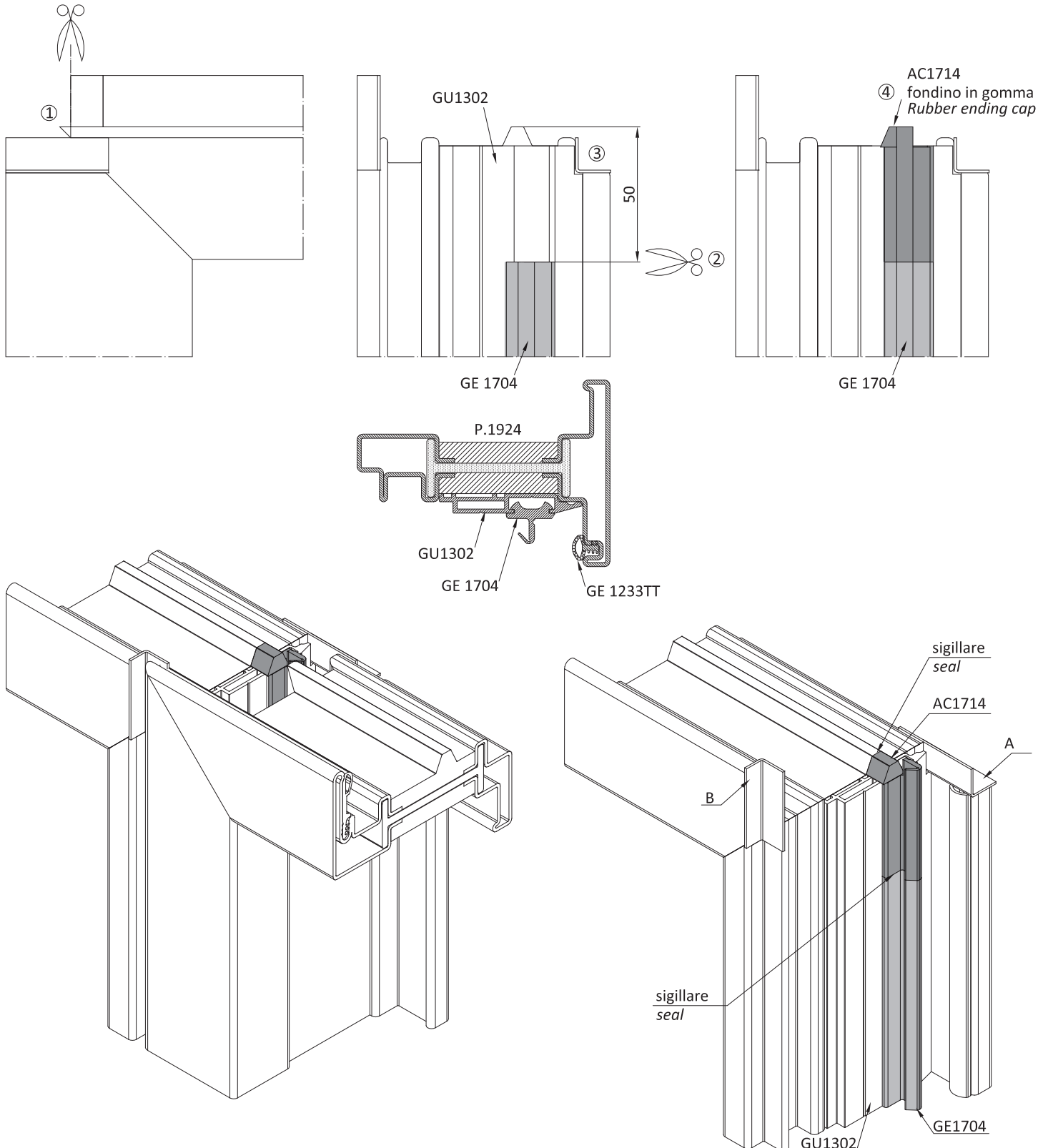
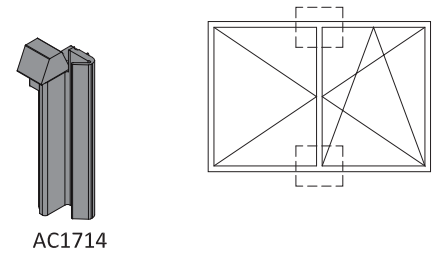


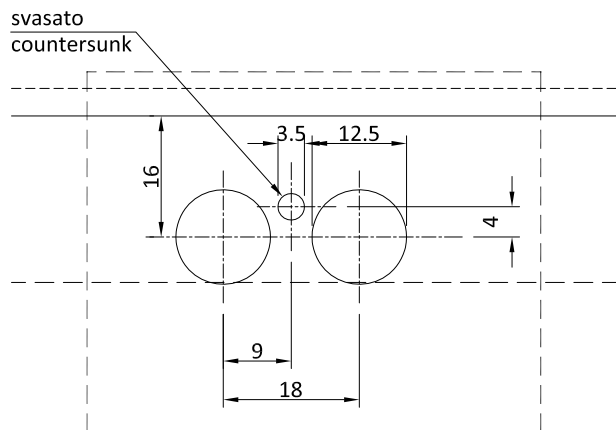
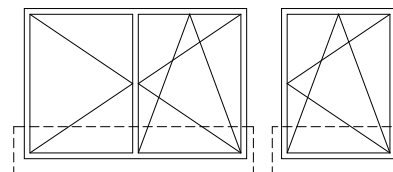
Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura.
Note: the ending caps for T-Z joint are furnished in larger dimensions and should be trimmed down after welding.



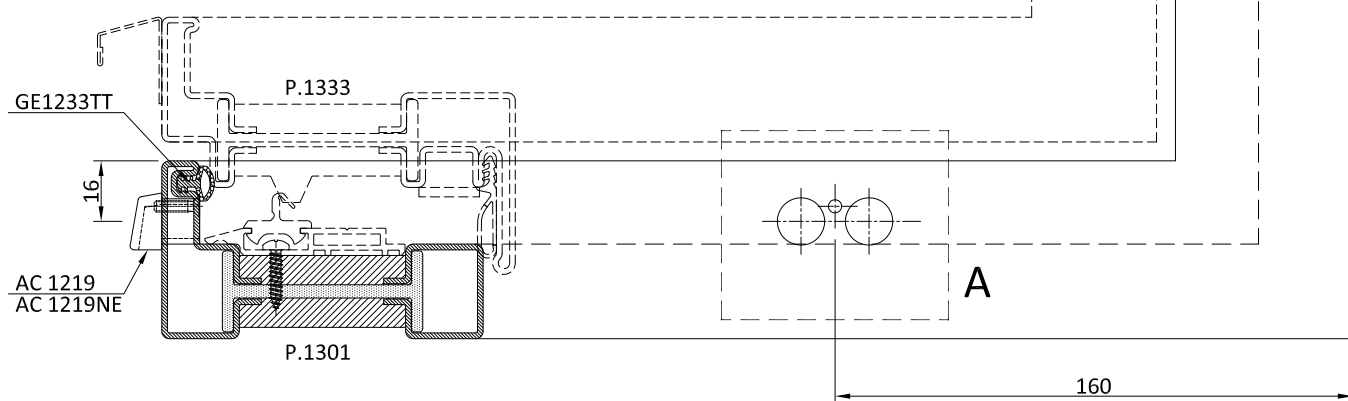
Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura.
Note: the ending caps for T-Z joint are furnished in larger dimensions and should be trimmed down after welding.

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

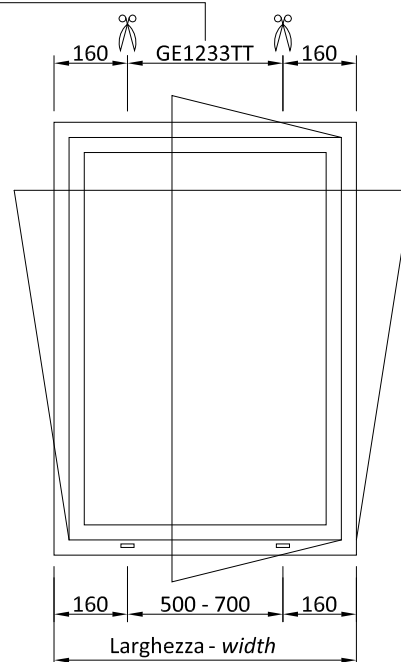
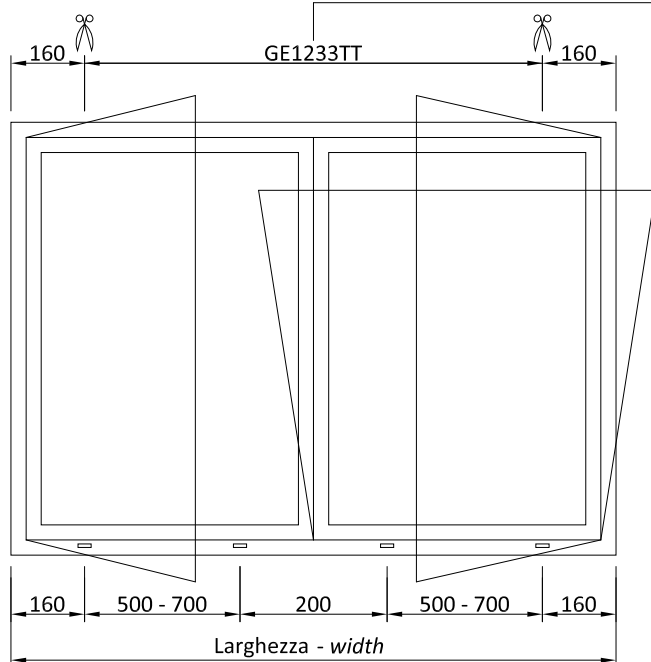




Particolare A - Detail "A"

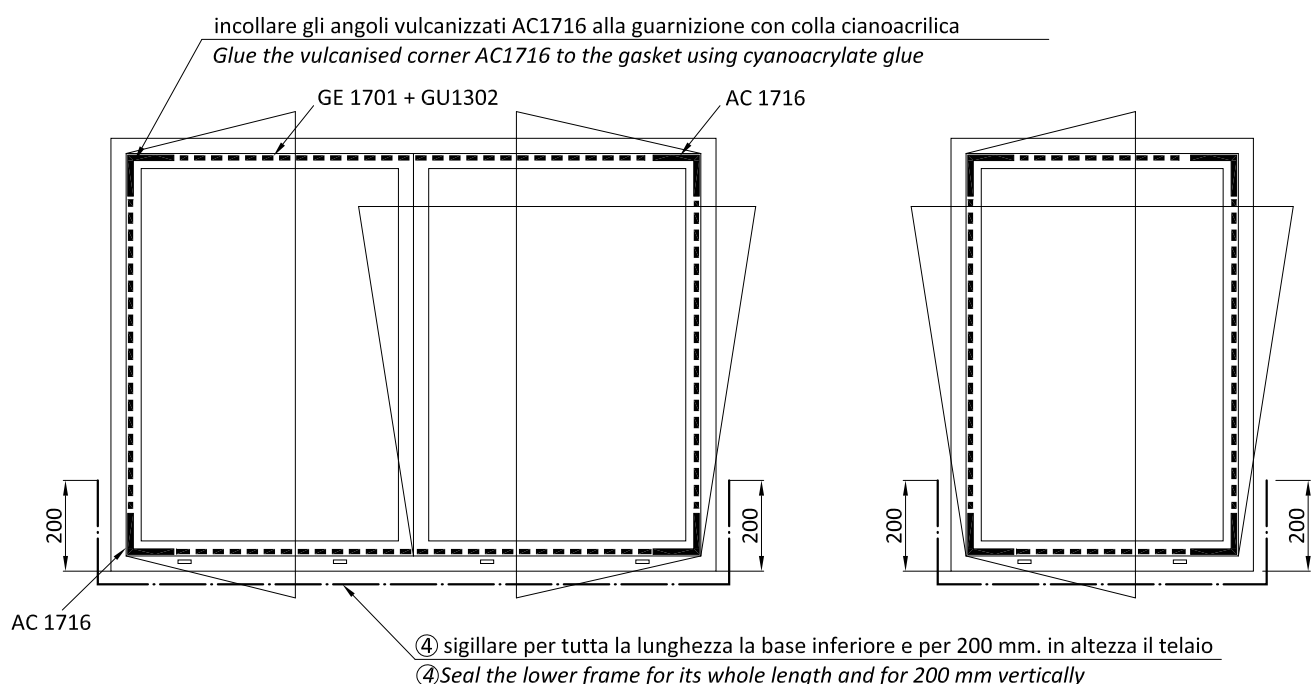
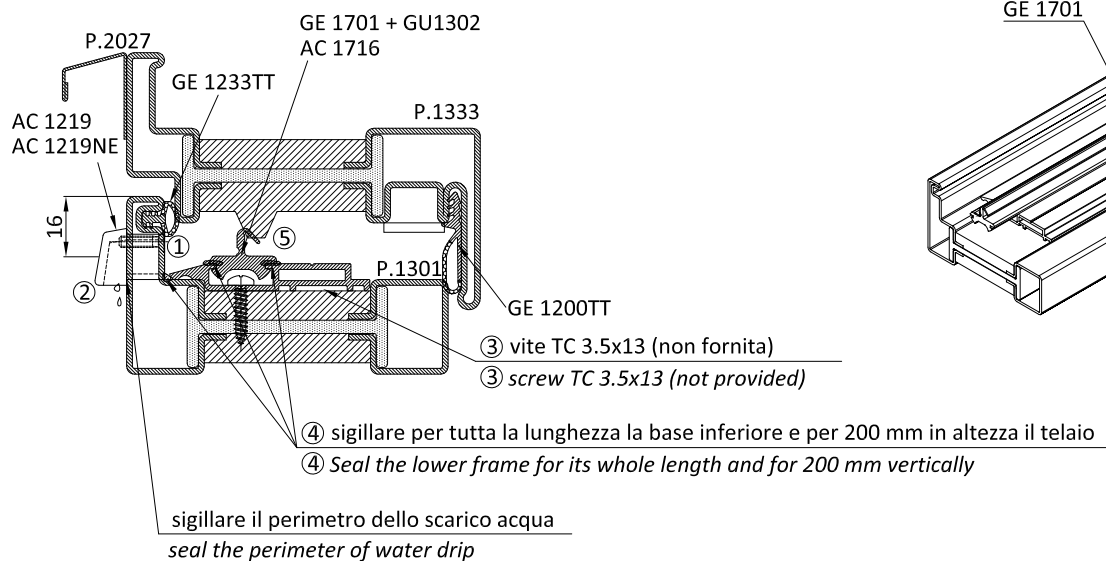
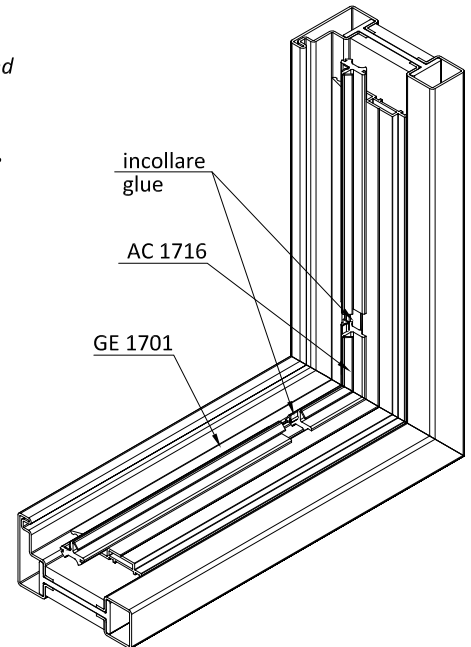
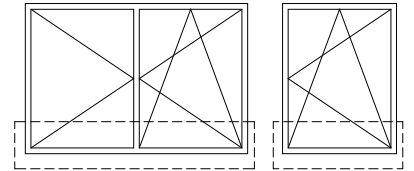


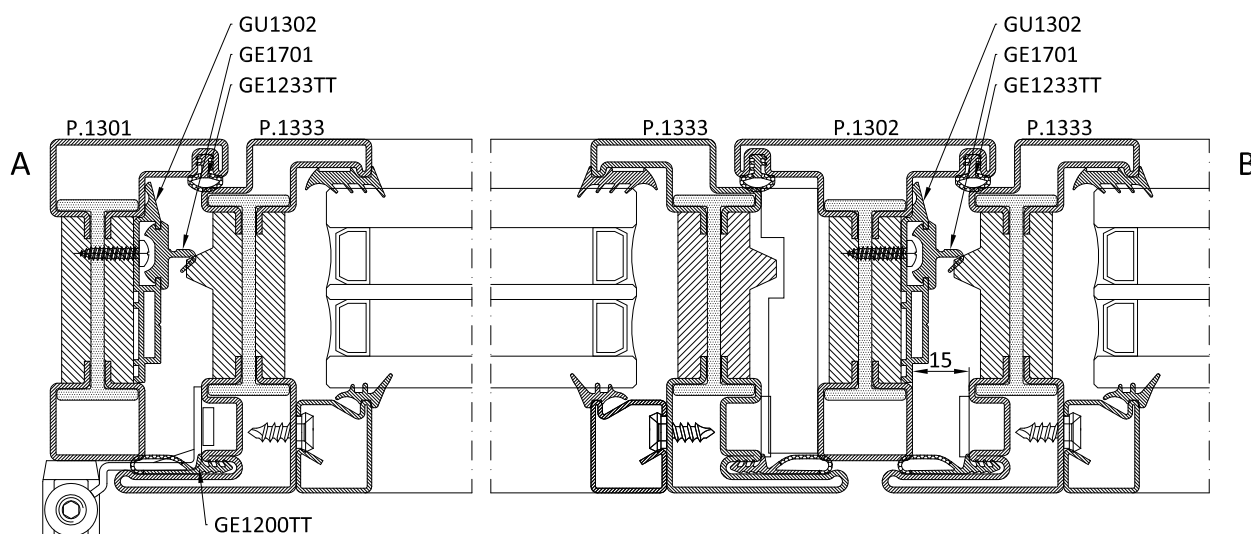
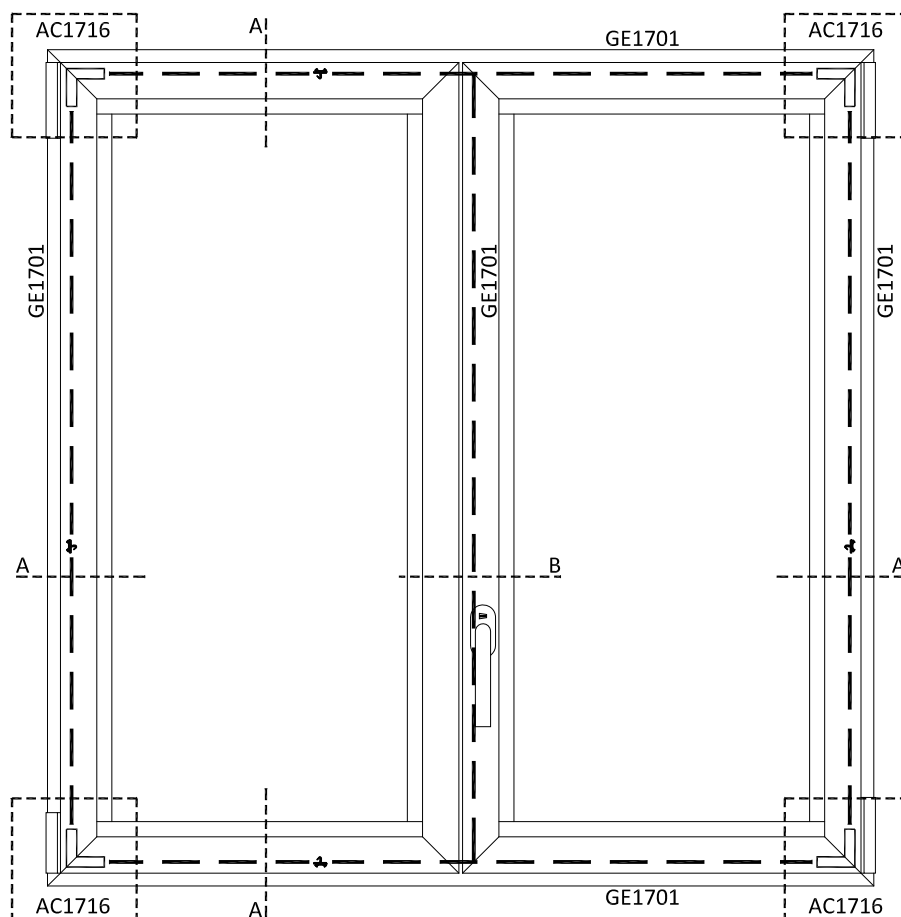
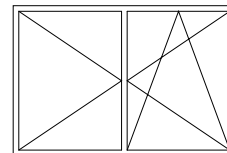
Tagliare la guarnizione per 20 mm | Cut the gasket to 20 mm

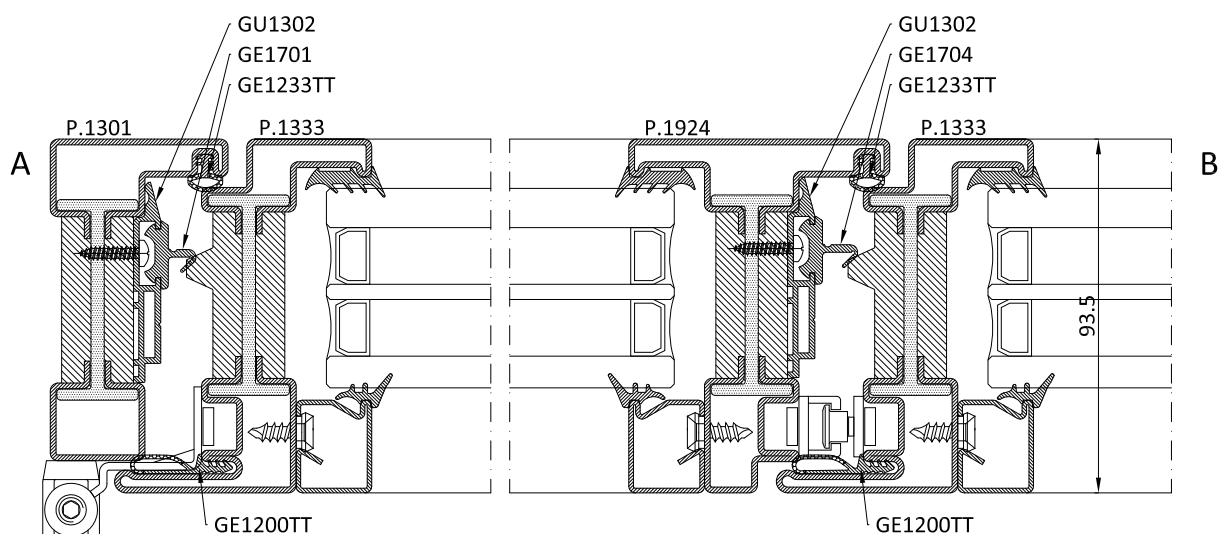
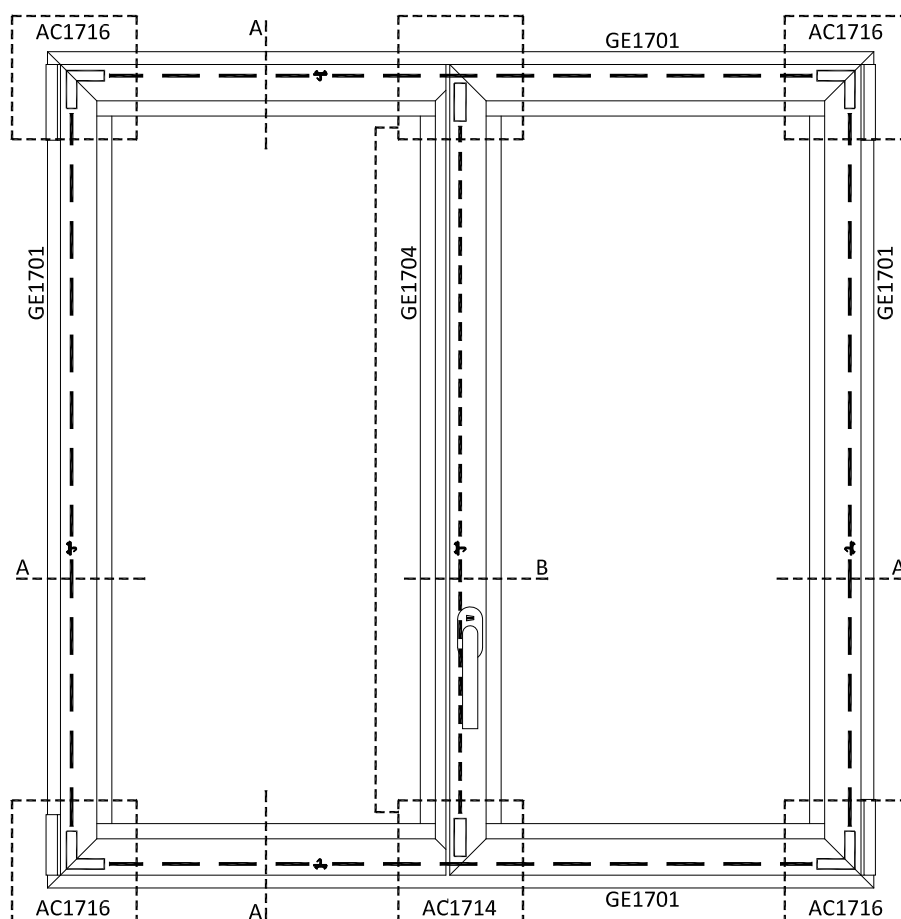
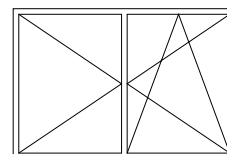


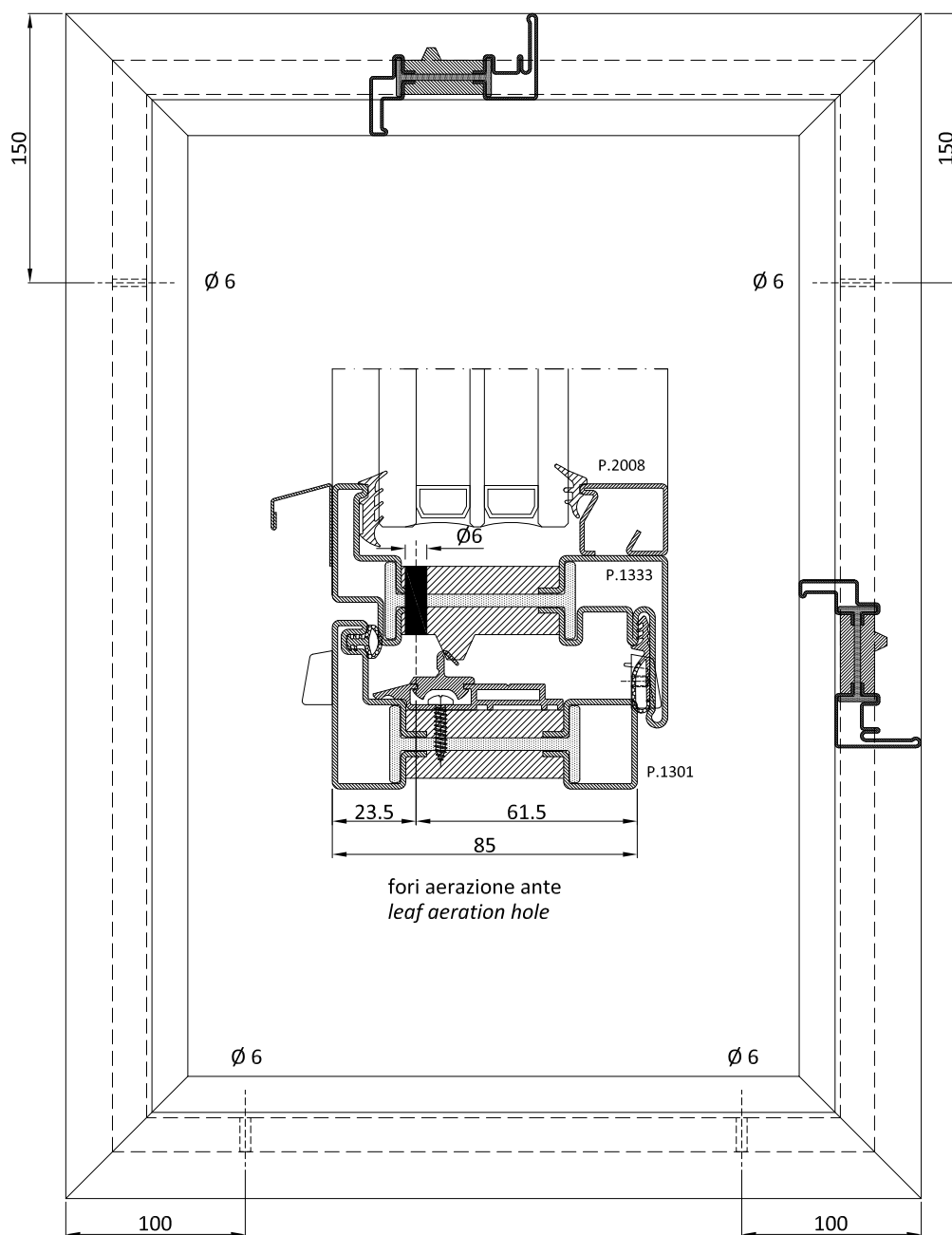
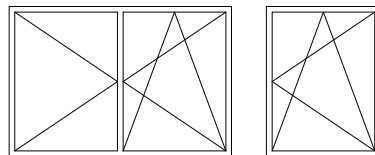
- 1) Eseguire i fori come da disegno
- 2) Posizionare lo scarico acqua e sigillare fissare con viti in dotazione M3x12
- 3) Posizionare il supporto della guarnizione di giunto GU1702 e fissarlo con vite TC 3.5x13 (non fornita)
- 4) Sigillare la guarnizione di giunto GE1701 con il supporto GU1702 per tutta lunghezza e per 200 mm in altezza sul telaio
- 5) Posizionare la guarnizione di giunto centrale GE1701 e gli angoli vulcanizzati AC1716, incollare gli angoli alla guarnizione a mezzo di colla ciano-acrilica

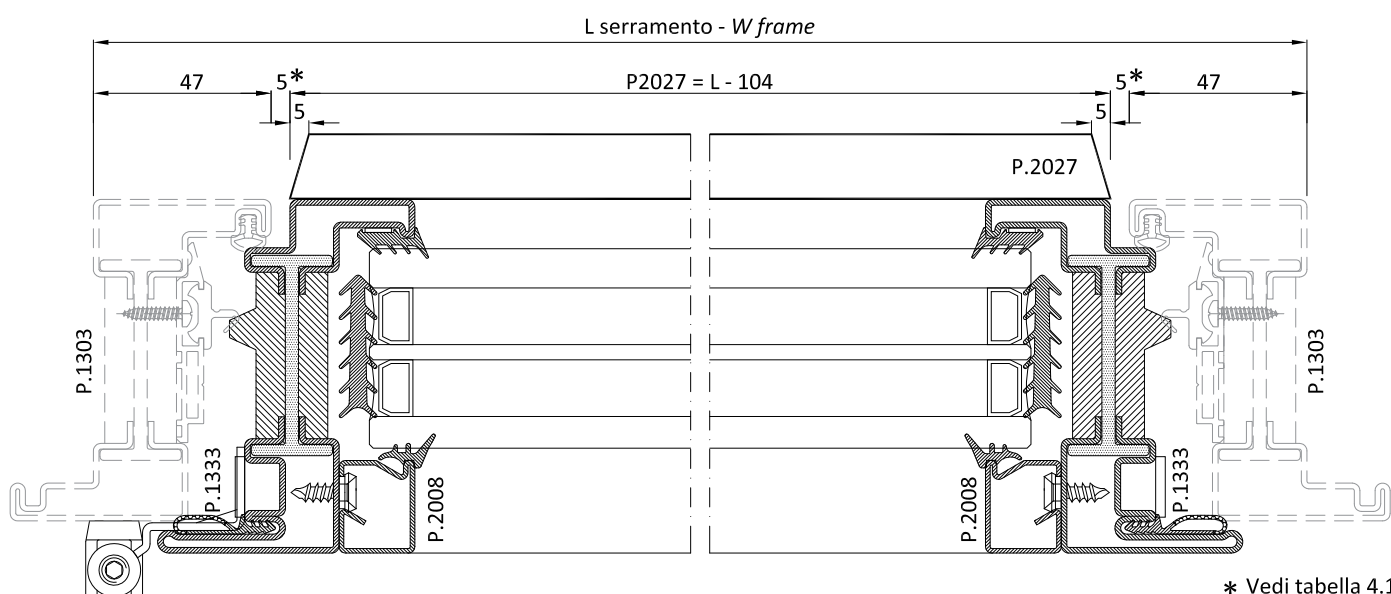
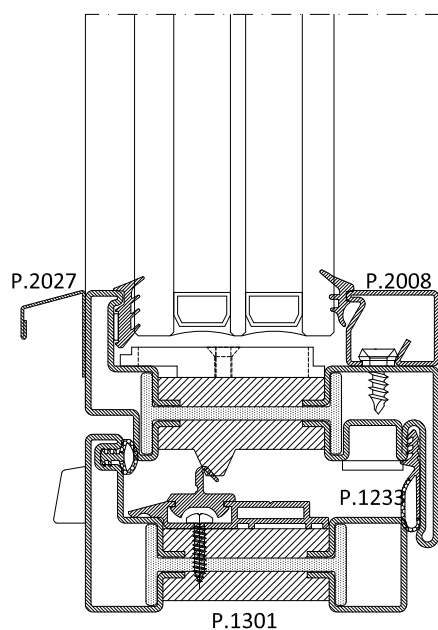
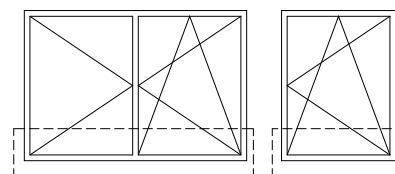
- 1) Drill the holes according to drawing
- 2) Install the water drip accessory, seal and secure with the supplied M3x12 screw
- 3) Position the support of the weather strip GU1702 and anchor it with the double-sided adhesive tape provided and screws TC 3.5x13 (not provided)
- 4) Seal the weather strip GE1701 with the support GU1702 for the whole length and for 200 mm vertically on the frame
- 5) Install the central weather strip GE1701 and the vulcanised corners AC1716, glue the corners to the weather strip using cyanoacrylate glue



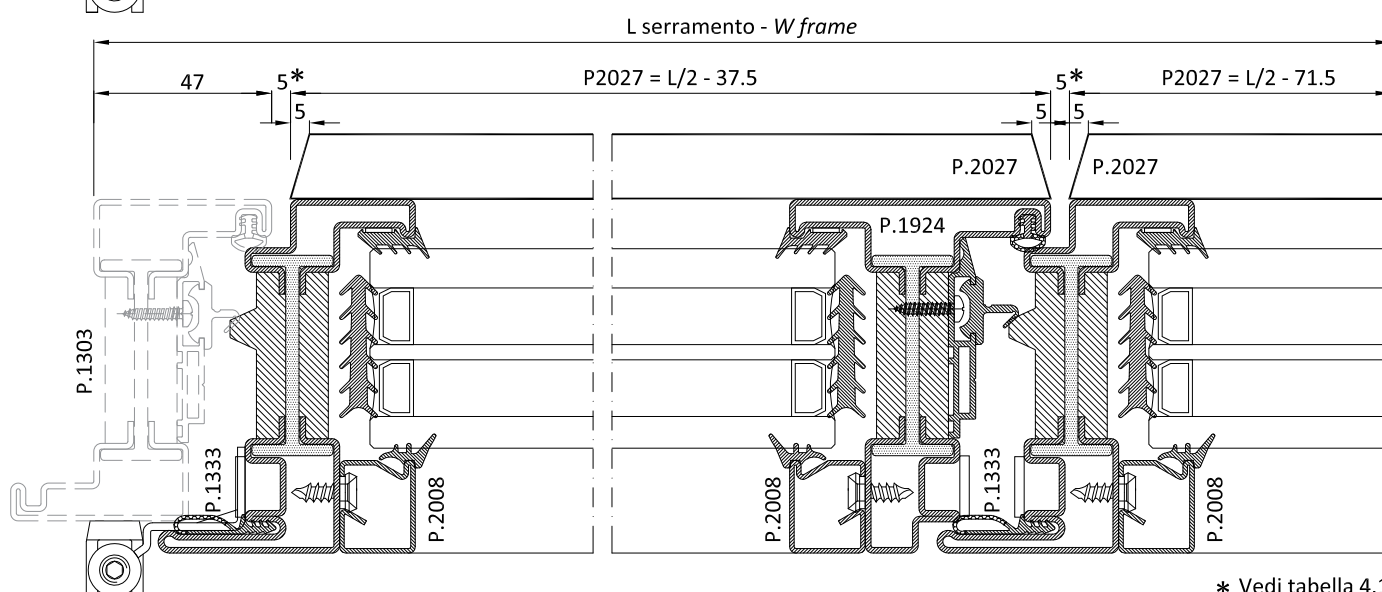
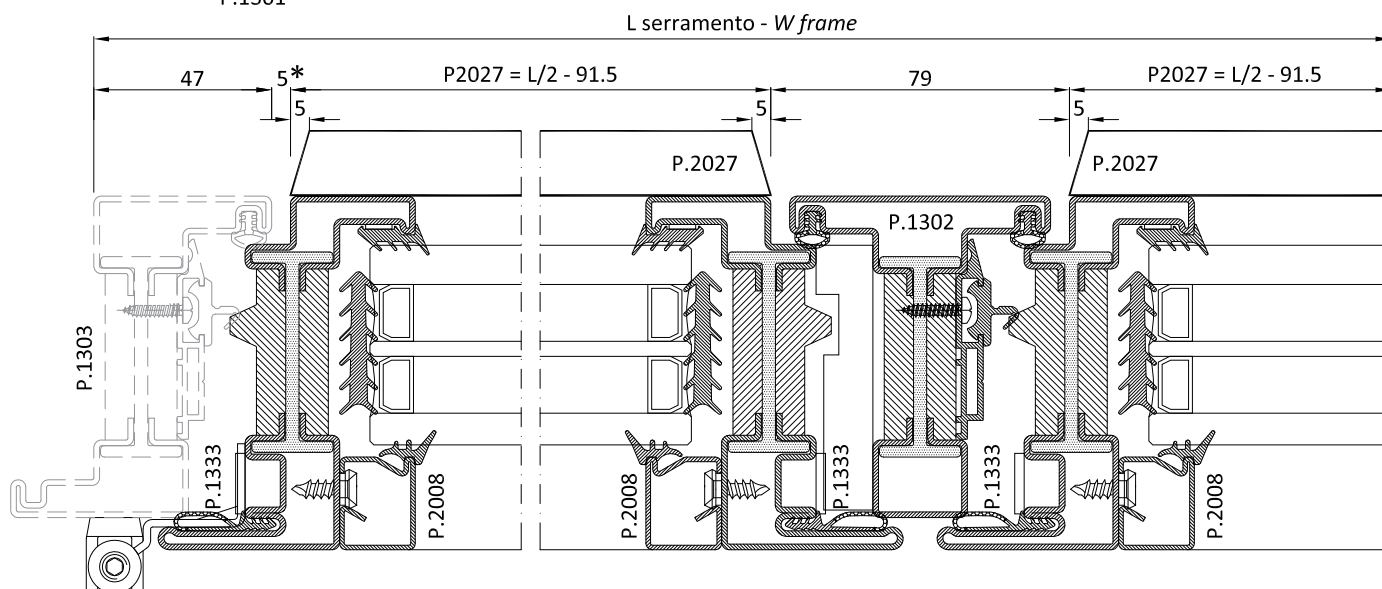
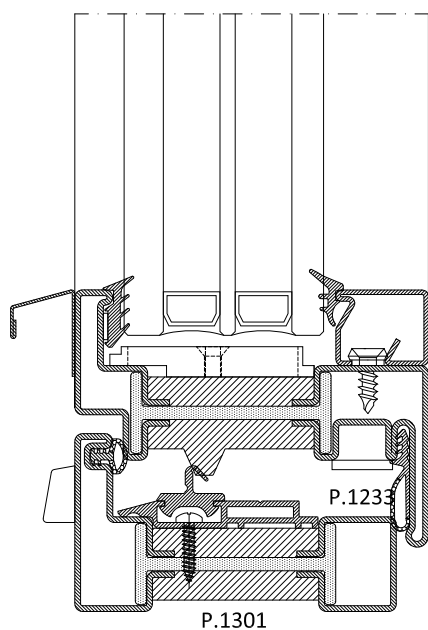
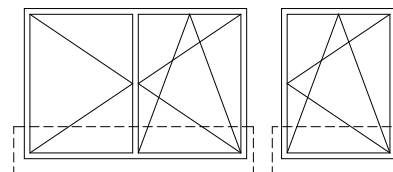




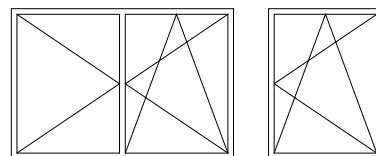




* Vedi tabella 4.1.5
* See chart 4.1.5

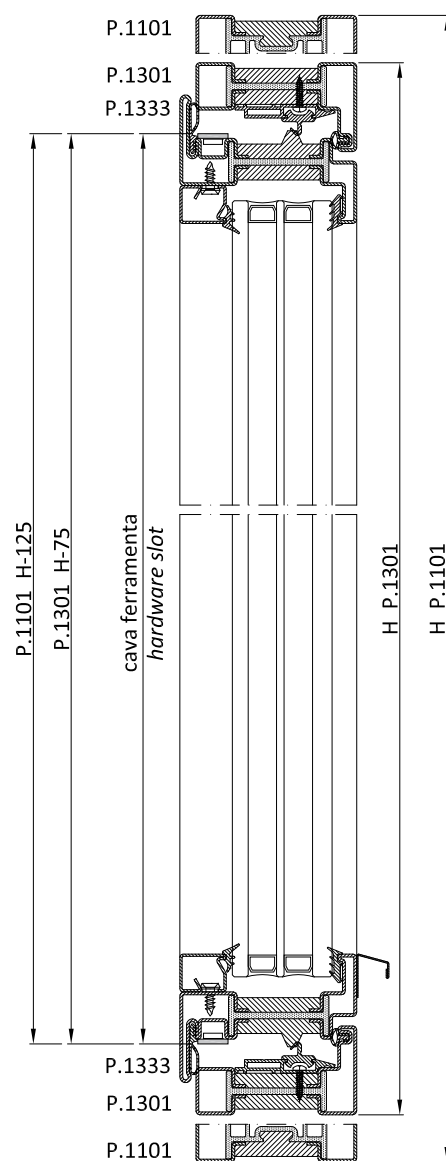
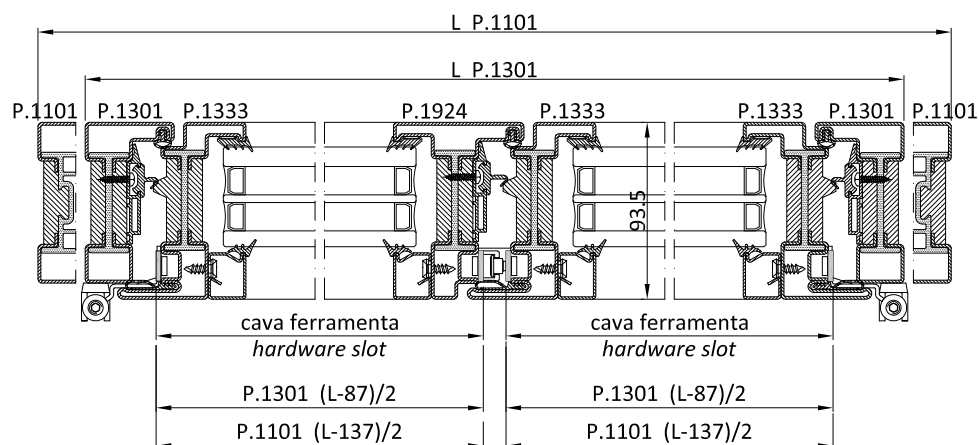
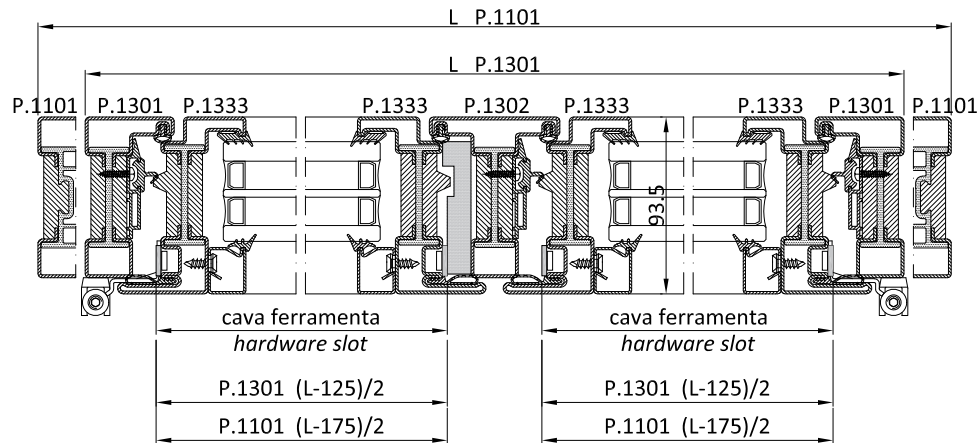
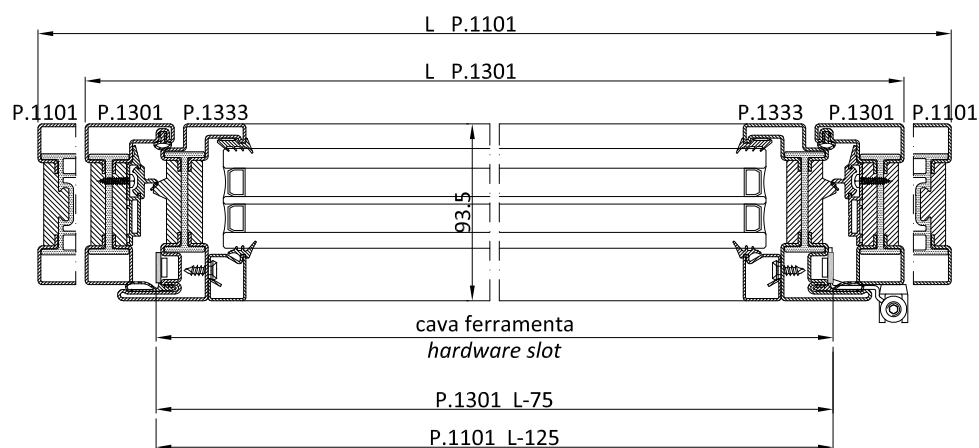


* Vedi tabella 4.1.5
* See chart 4.1.5

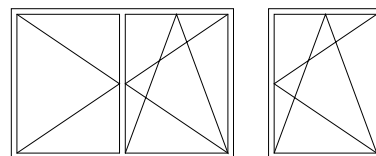


		H altezza - height								
Easy		661 860	861 1000	1001 1200	1201 1400	1401 1600	1601 1800	1801 2000	2001 2200	2201 2400
L larghezza width	601-800	A1	B1	C1	D1	E1	F1	G1	H1	I1
	801-1000	-	B2	C2	D2	E2	F2	G2	H2	I2
	1001-1200	-	-	C3	D3	E3	F3	G3	H3	I3
	1201-1400	-	-	-	D4	E4	-	-	-	-

AGA271-5	AGA775	180 kg	Easy
AGE271-2-5-6	AGE775-6	150 kg	Easy
AGE281-2-5-6	AGE785-6	130 kg	Easy
AGE291-2-5-6	AGE795-6	130 kg	Easy
AG1273		80 kg	Easy
AG1278		80 kg	Easy



RC2		H altezza - height								
		661 860	861 1000	1001 1200	1201 1400	1401 1600	1601 1800	1801 2000	2001 2200	2201 2400
L larghezza width	601-800	A1	B1	C1	D1	E1	F1	G1	H1	I1
	801-1000	-	B2	C2	D2	E2	F2	G2	H2	I2
	1001-1200	-	-	C3	D3	E3	F3	G3	H3	I3
	1201-1400	-	-	-	D4	E4	-	-	-	-



AG1271-2-5-6

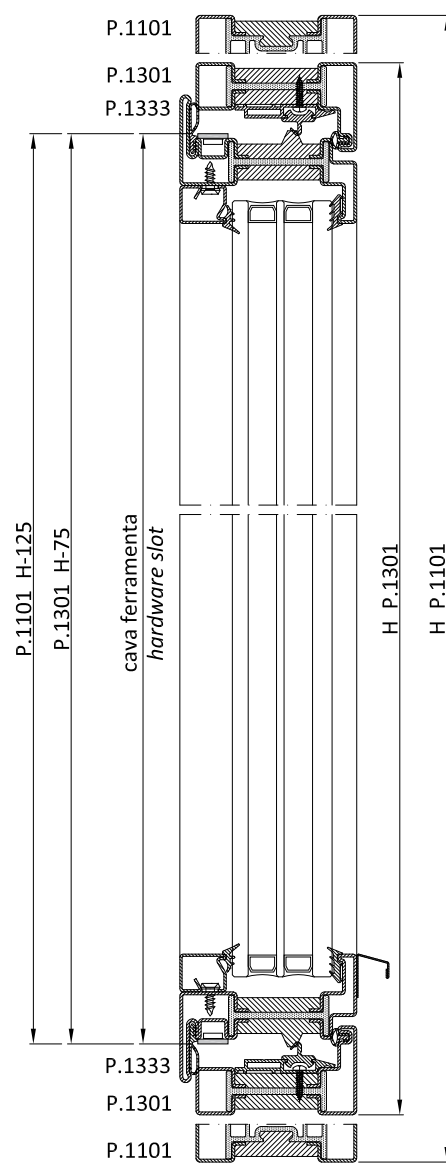
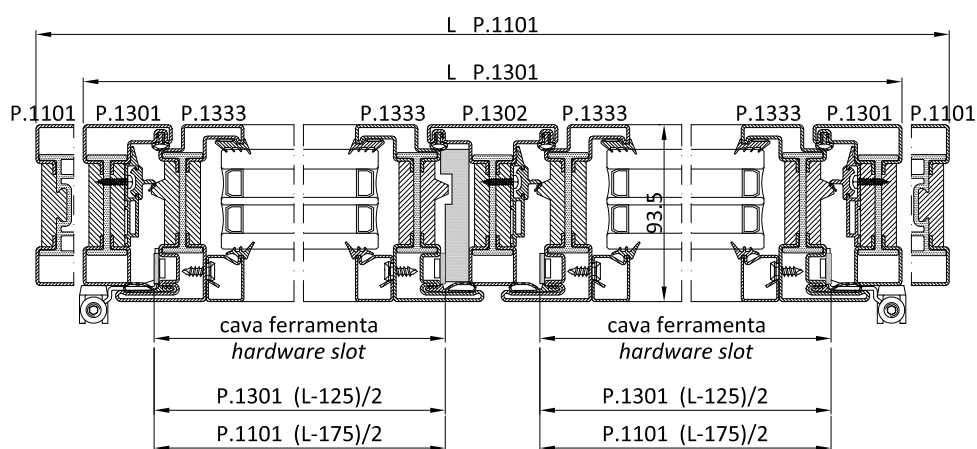
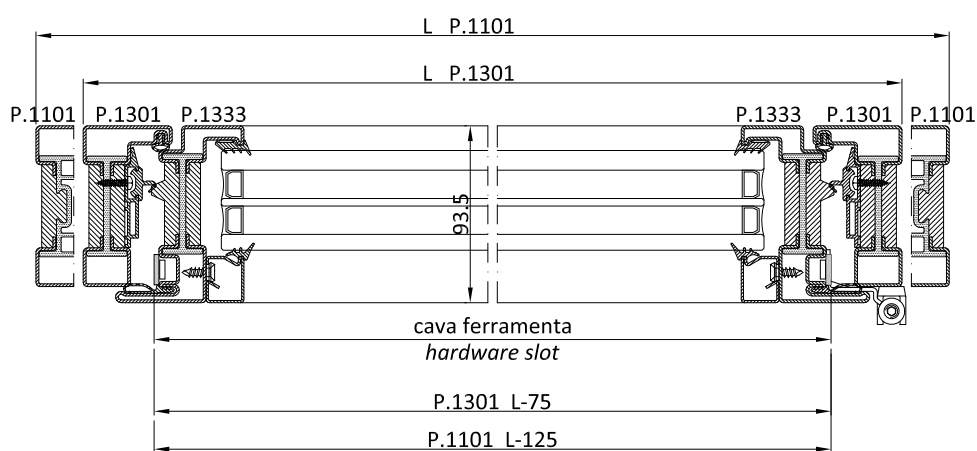
150 kg RC2

AG1281-2-5-6

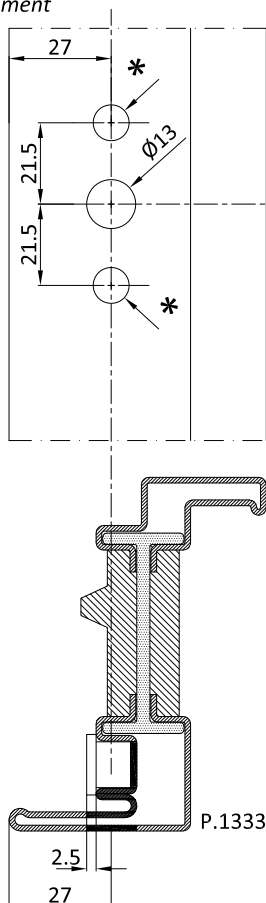
130 kg RC2

AG1291-2-5-6

130 kg RC2



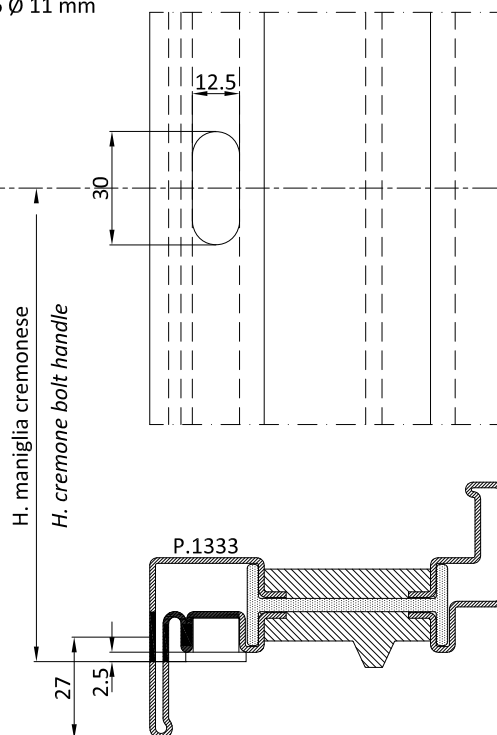
Fori per inserimento quadro comando
e fissaggio maniglia / movimento DK
holes for inserting control panel and
anchoring of handle / TT (tilt and turn)
movement



* AC5056 Ø 9.5 mm - AC1356 Ø 11 mm

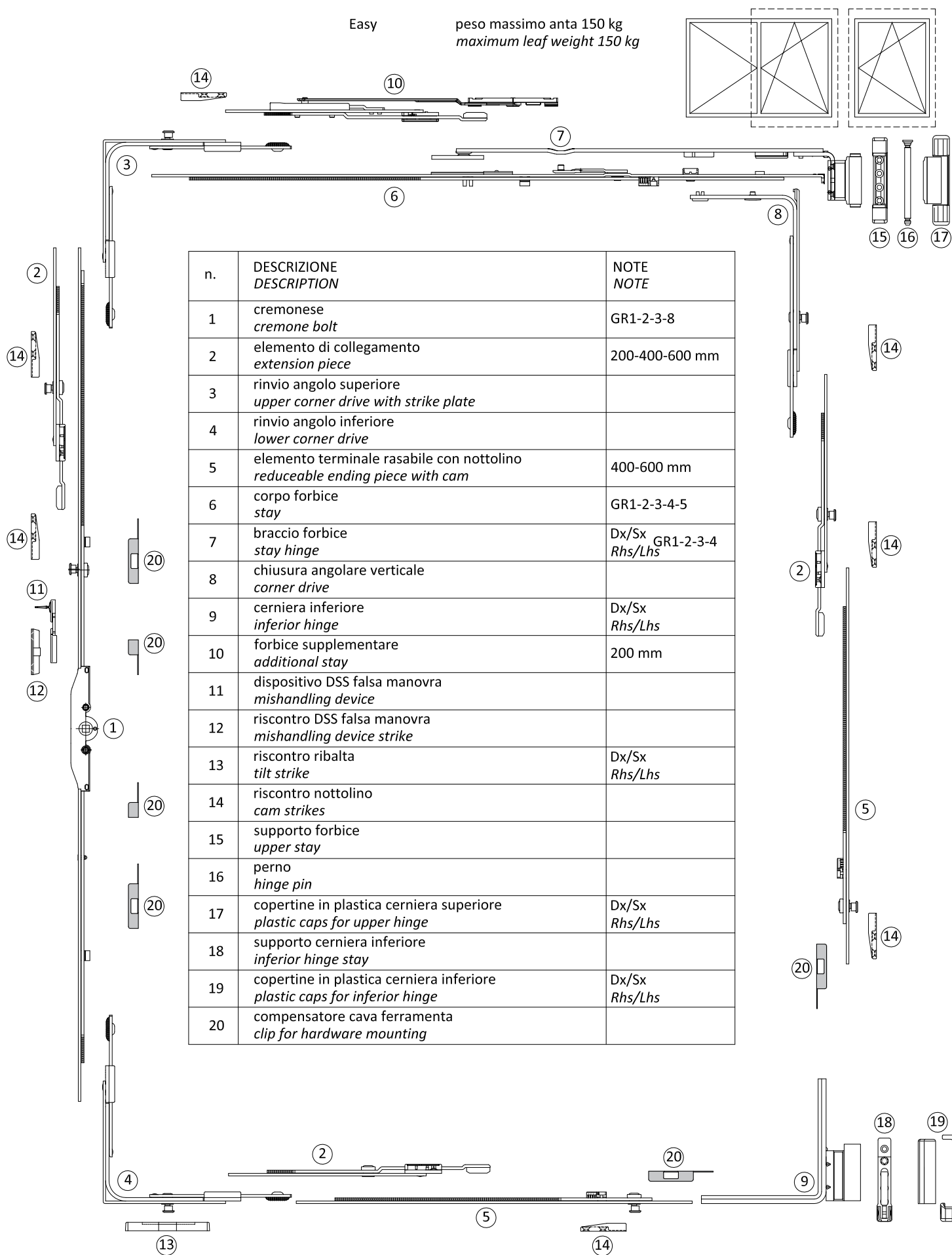
H. maniglia cremonese
H. cremone bolt handle

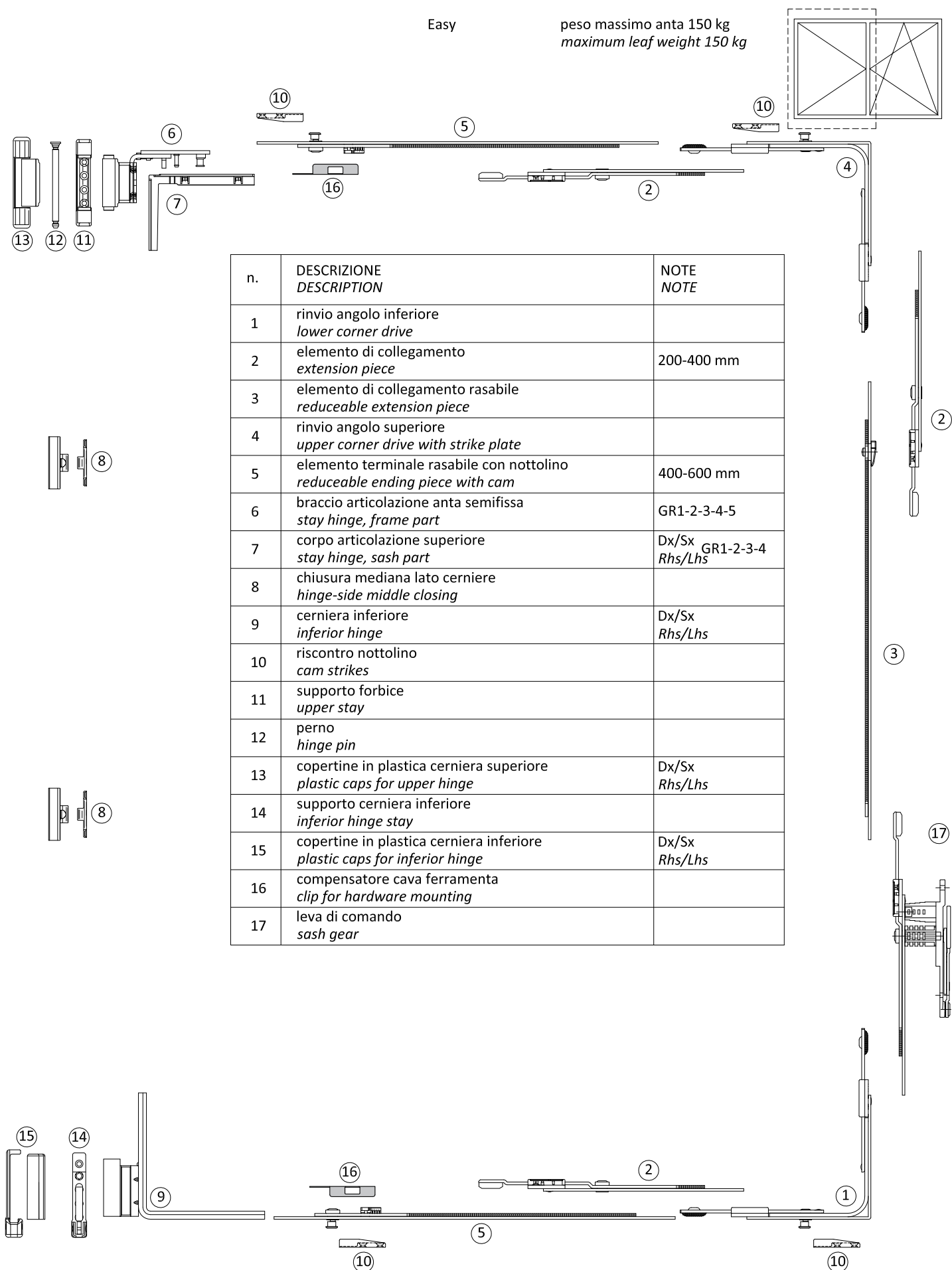
Asola per inserimento meccanismo
cremonese
Slot for insertion of cremone
mechanism

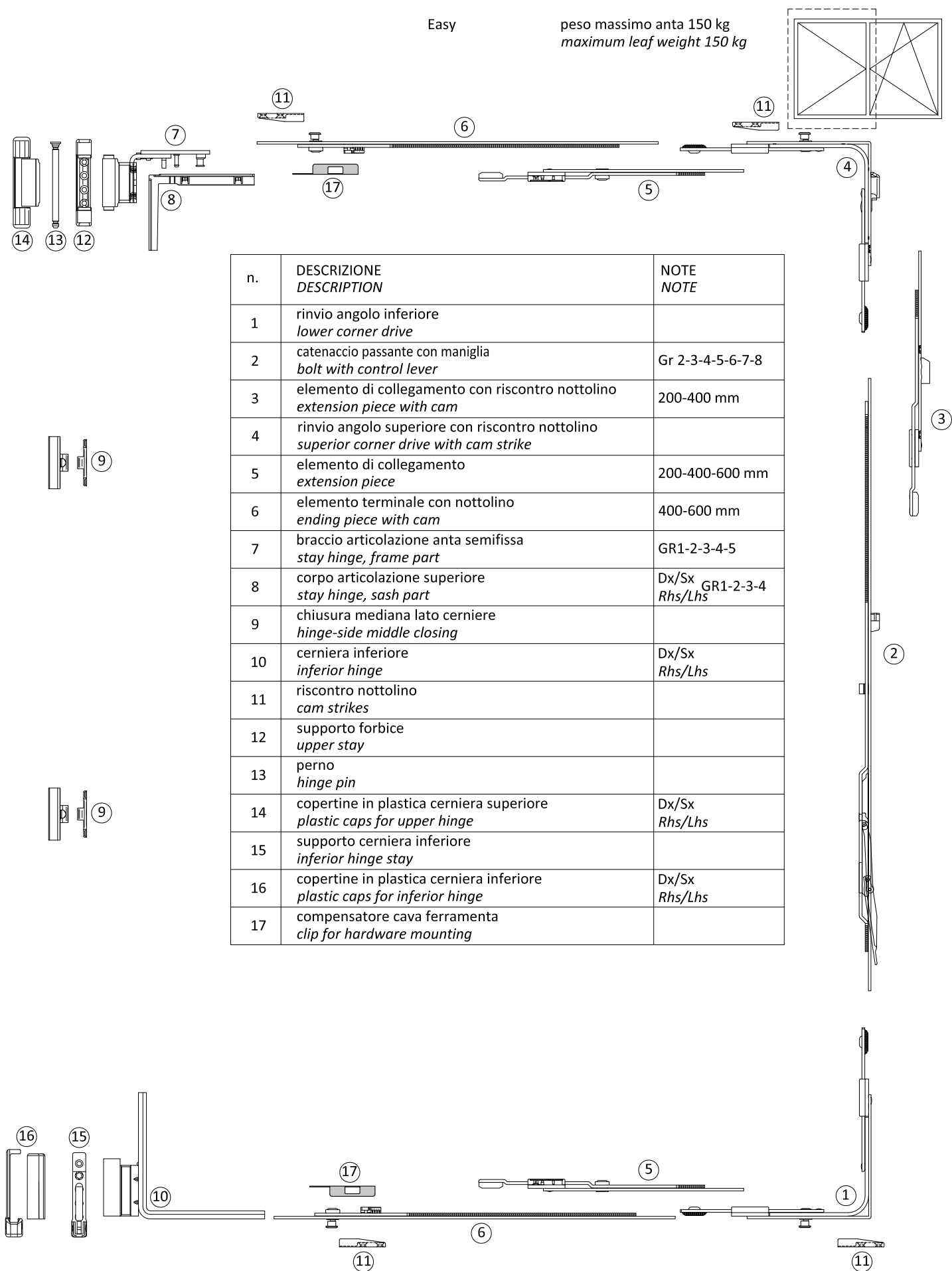


ALTEZZA MANIGLIA CREMONESE - CREMONE BOLT HANDLE HEIGHT		
Tipo Type	H cava ferramenta - H hardware slot Easy - RC2	
Finestre Windows	Y	370 → 520 (No RC2)
	Z	521 → 660 (No RC2)
	A	661 → 860
	B	861 → 1000
	C	1001 → 1200
	D	1201 → 1400
	E	1401 → 1600
	F	1601 → 1800
Porte - finestra French Windows	G	1801 → 2000
	H	2001 → 2200
	I	2201 → 2400
	J	2401 → 2600
	K	2601 → 2800
	L	2801 → 3000
		H maniglia cremonese H cremone bolt handle
Finestre Windows		H/2
		H/2
		H/2
		H/2
		500
		500
		500
		500
Porte - finestra French Windows		1050
		1050
		1050
		1050
		1050
		1050

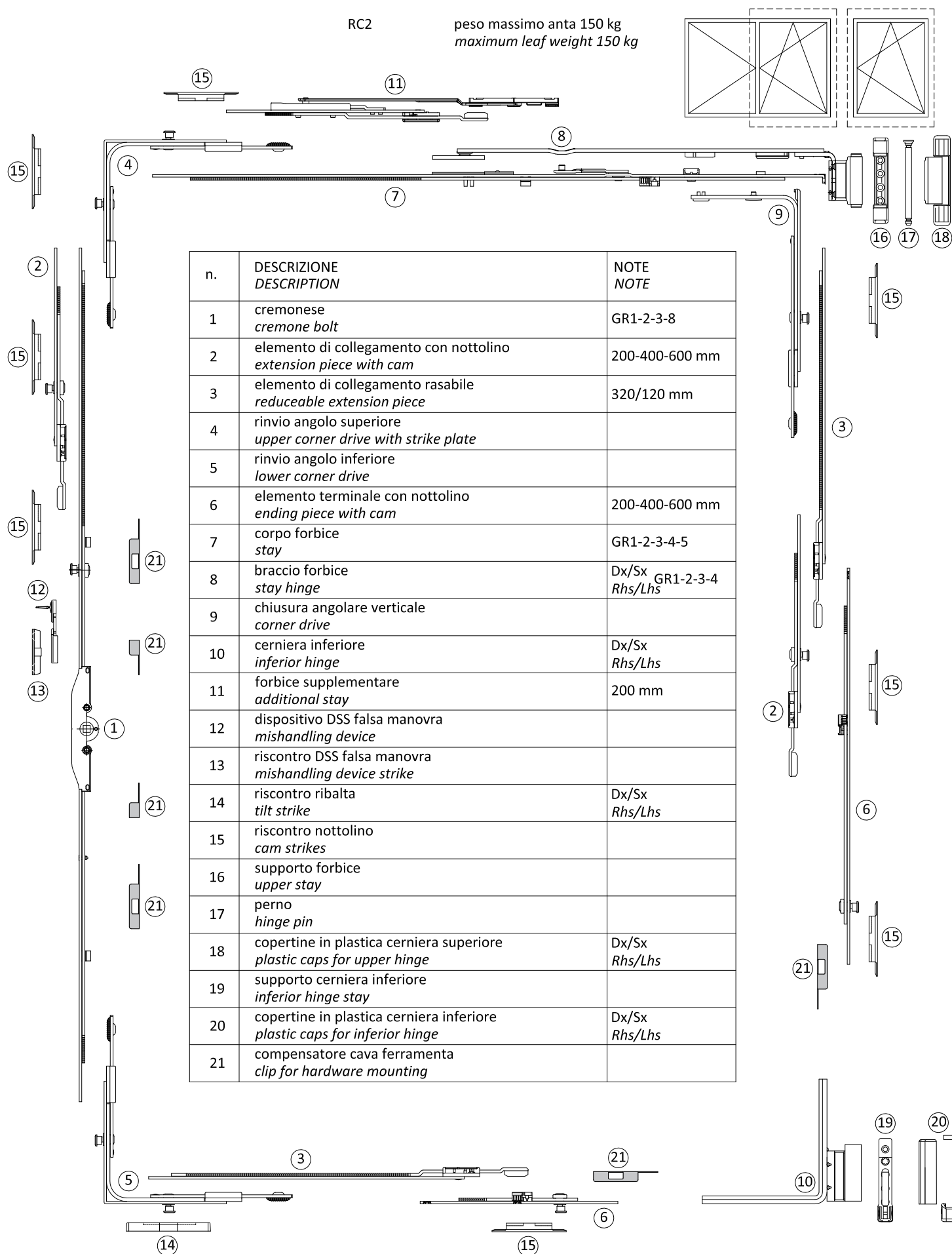
Easy

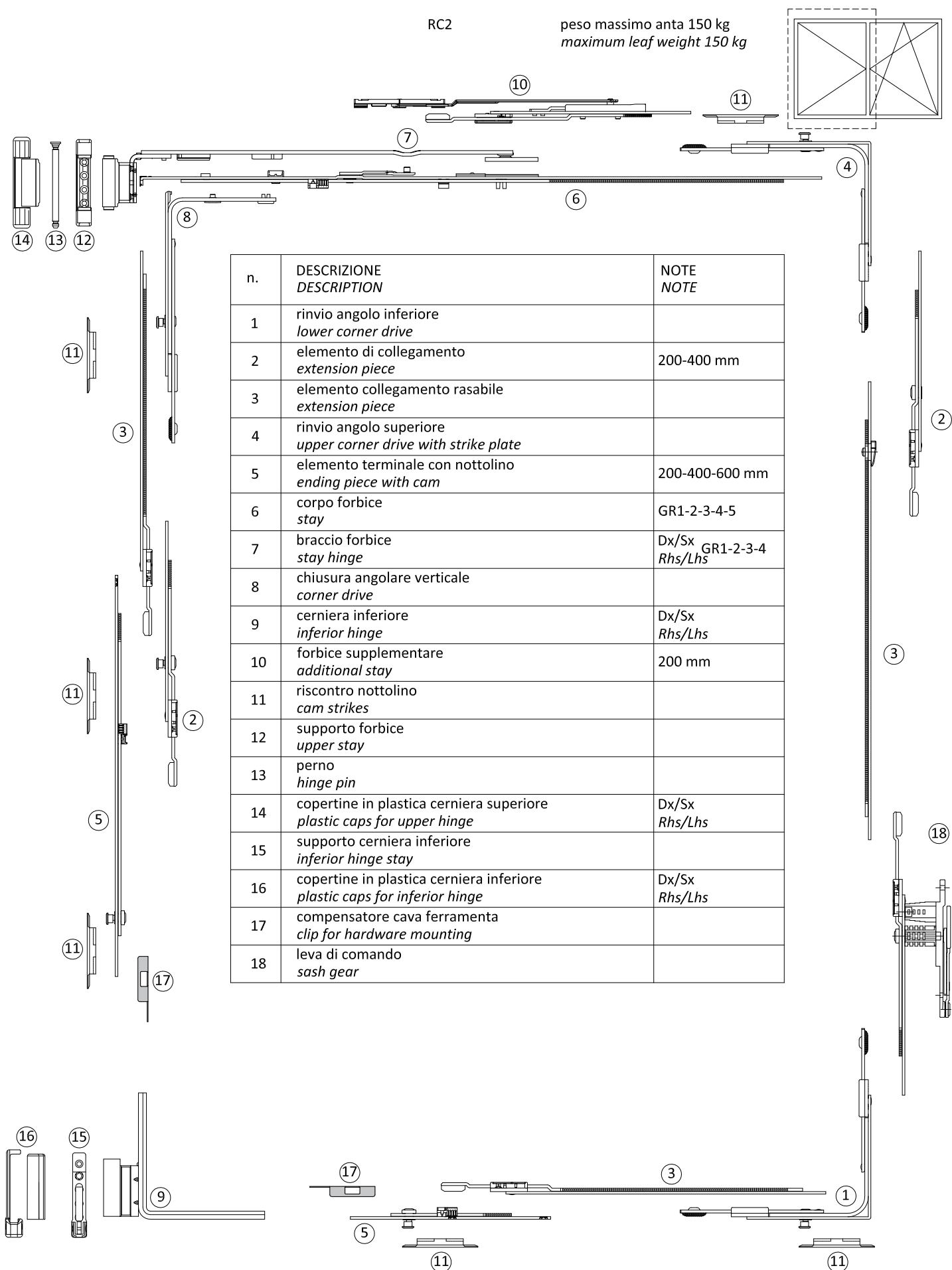
peso massimo anta 150 kg
maximum leaf weight 150 kg

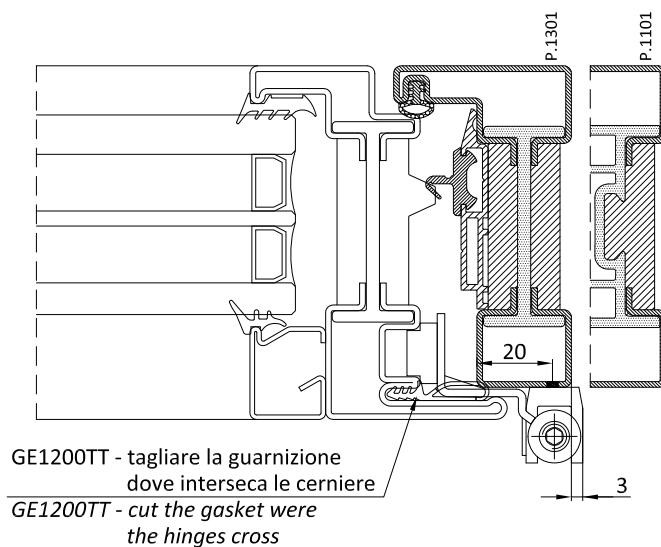
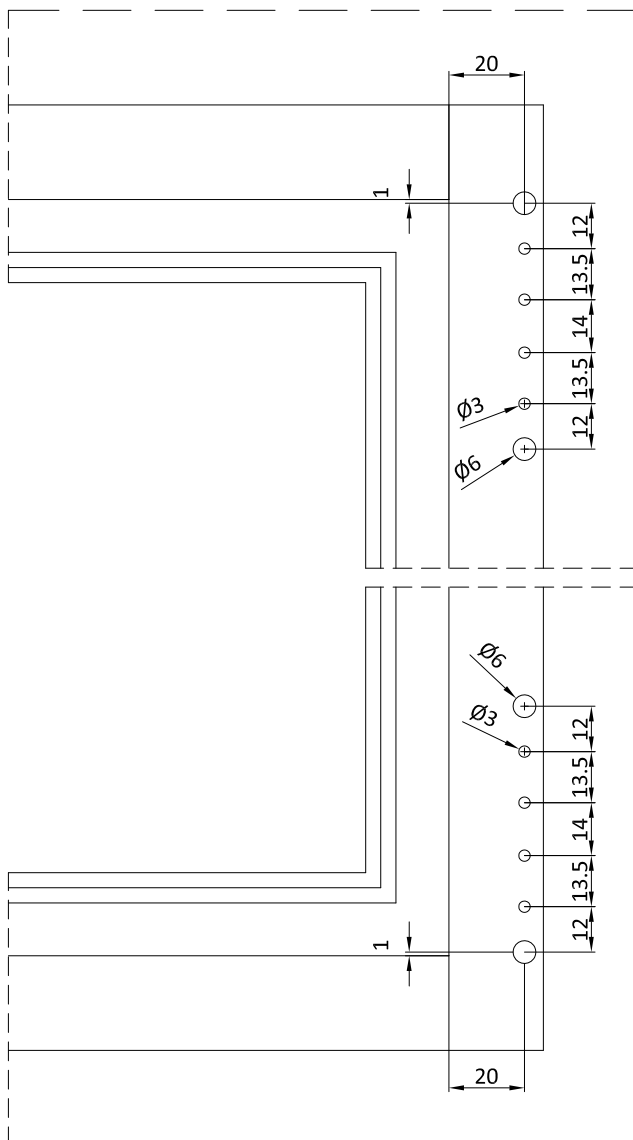
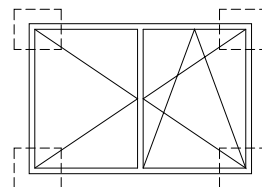




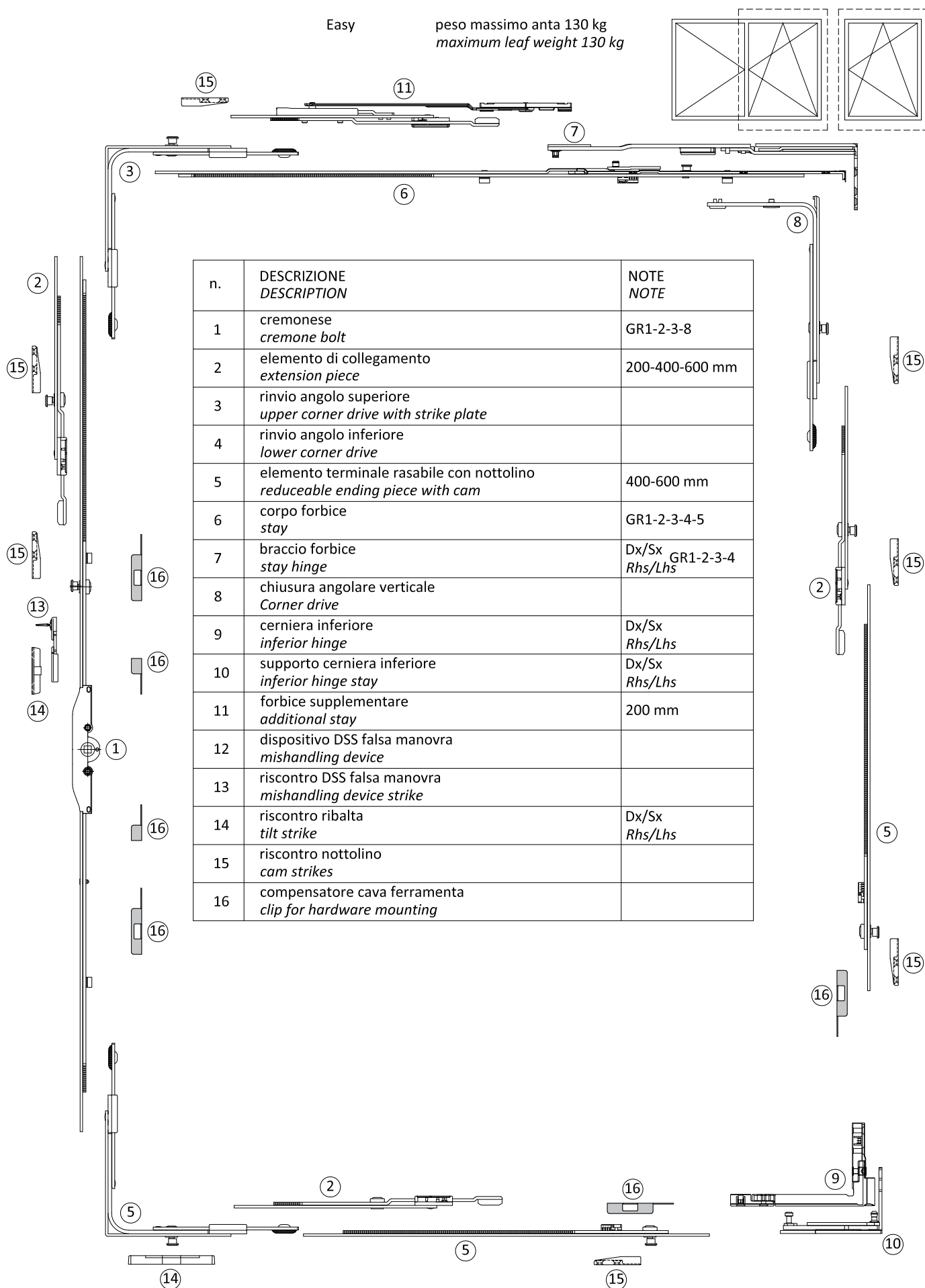
RC2

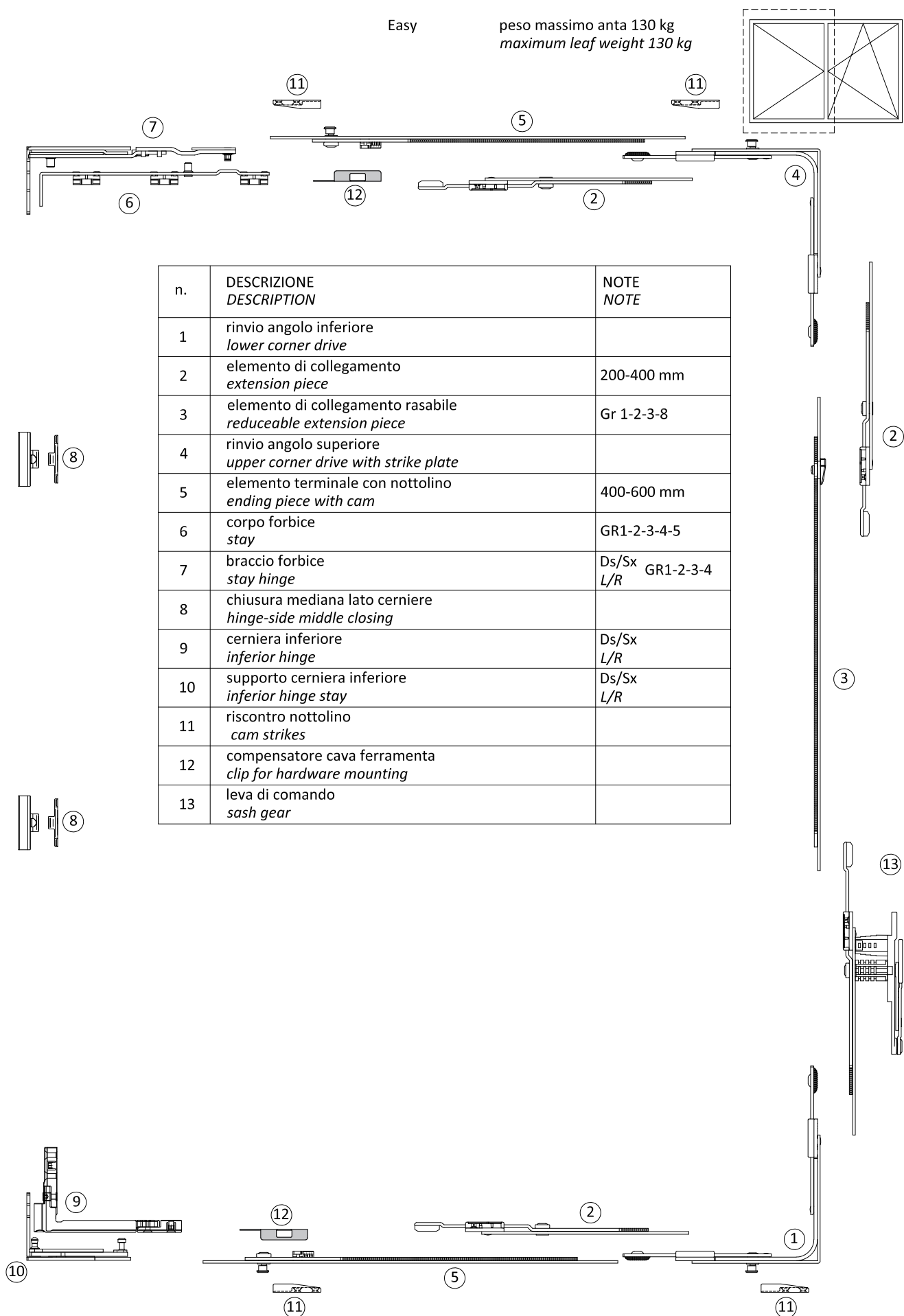
peso massimo anta 150 kg
maximum leaf weight 150 kg

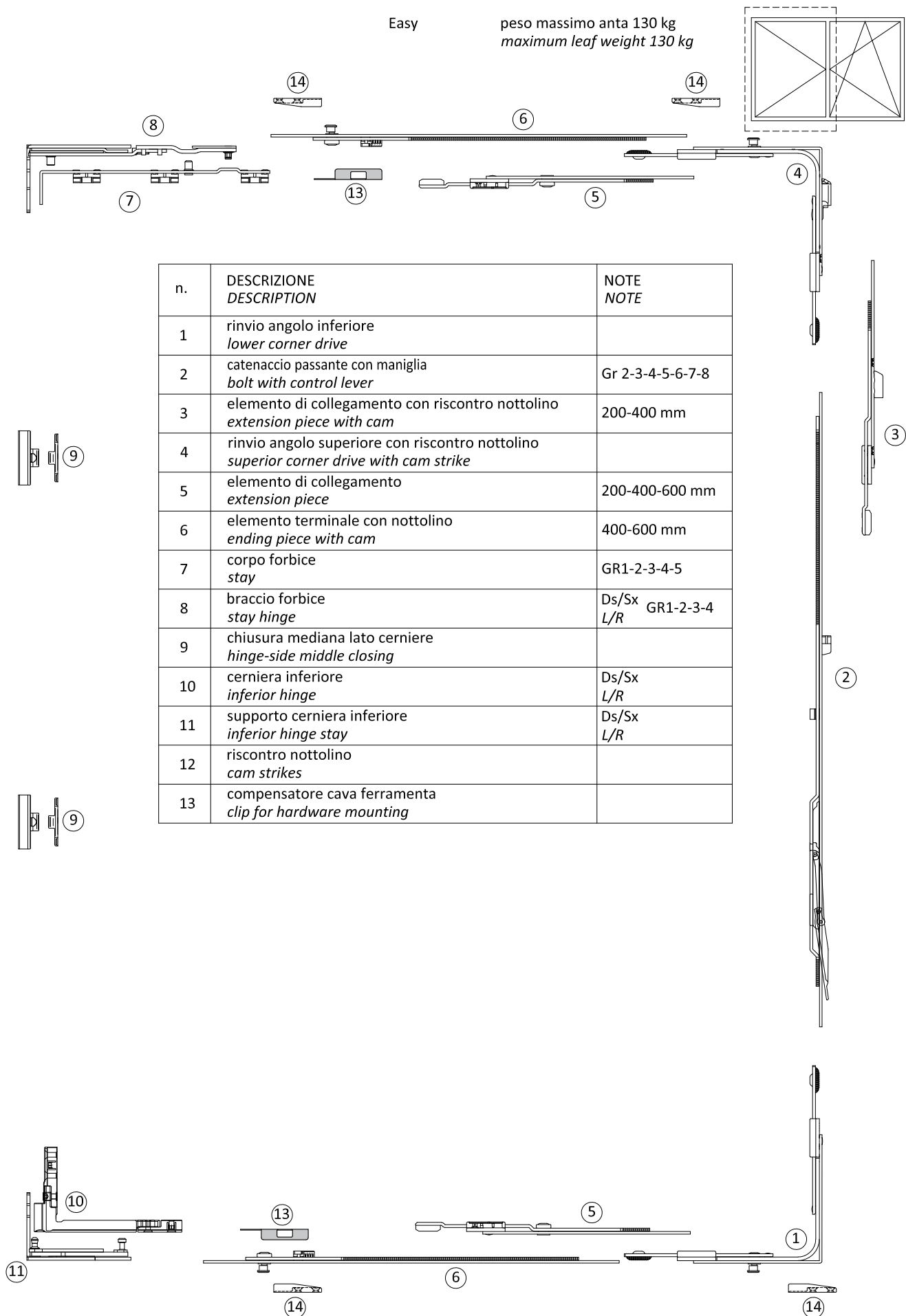


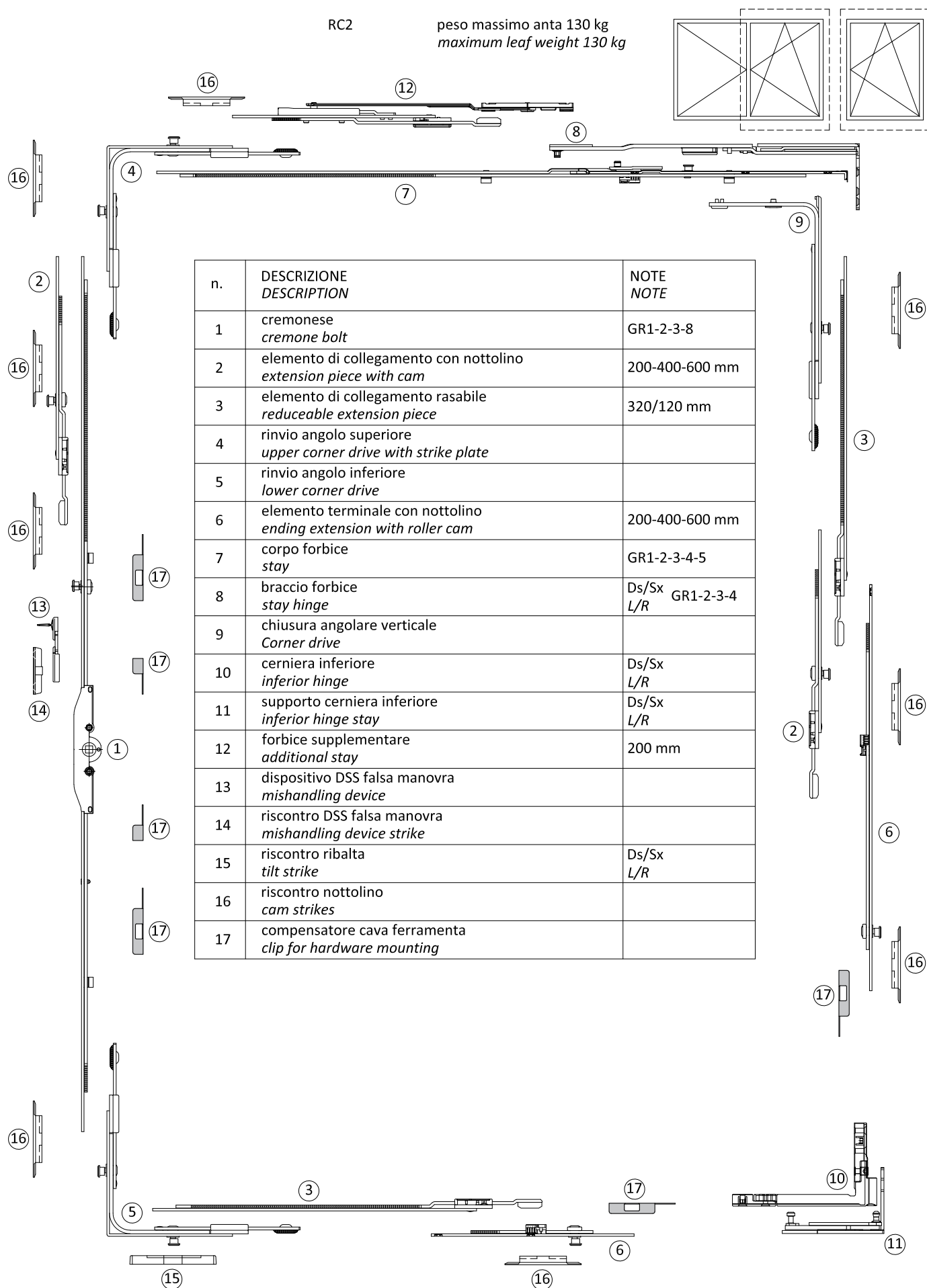


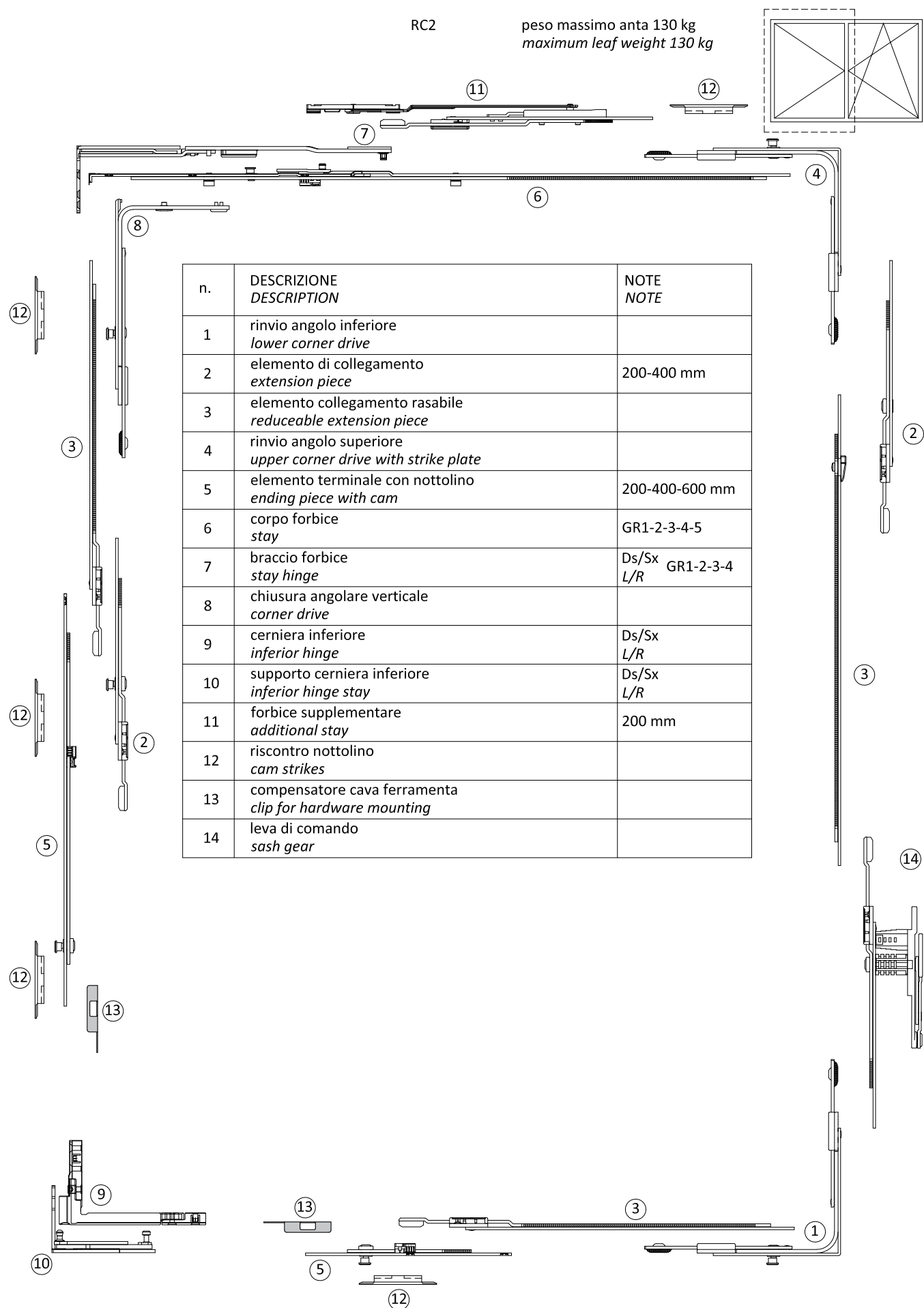
Fori eseguibili con maschera ATG271
Holes to be done with ATG271

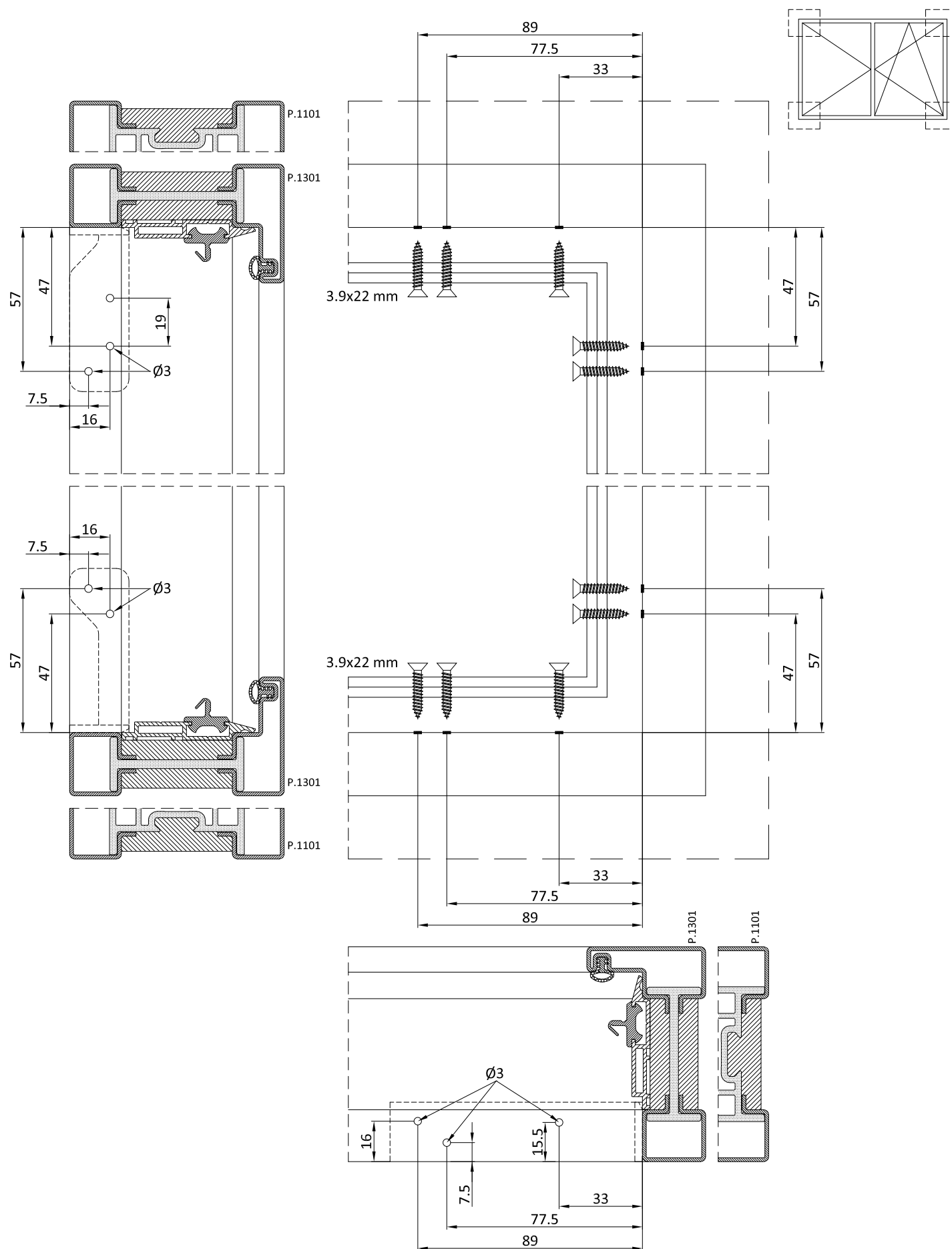




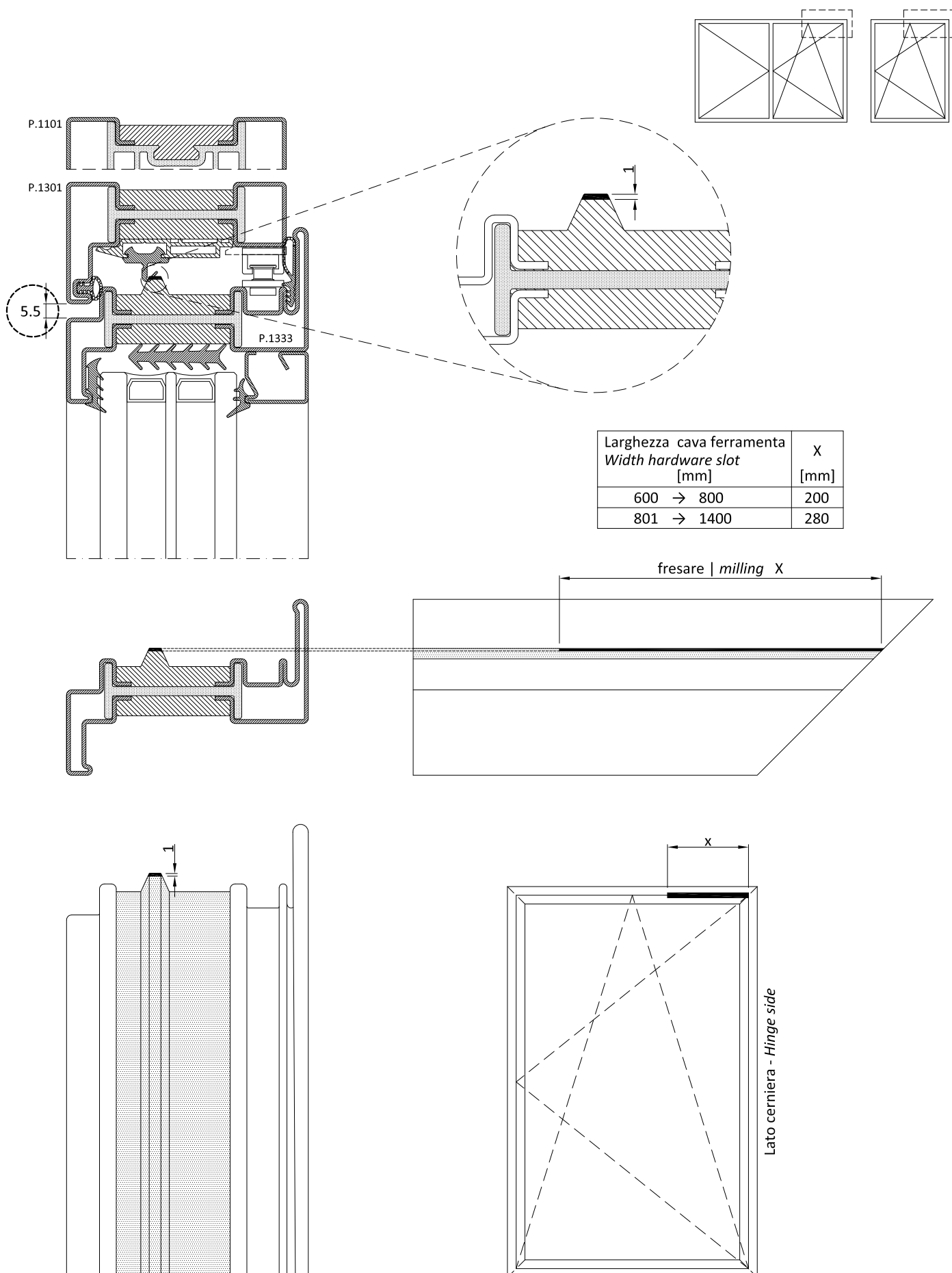




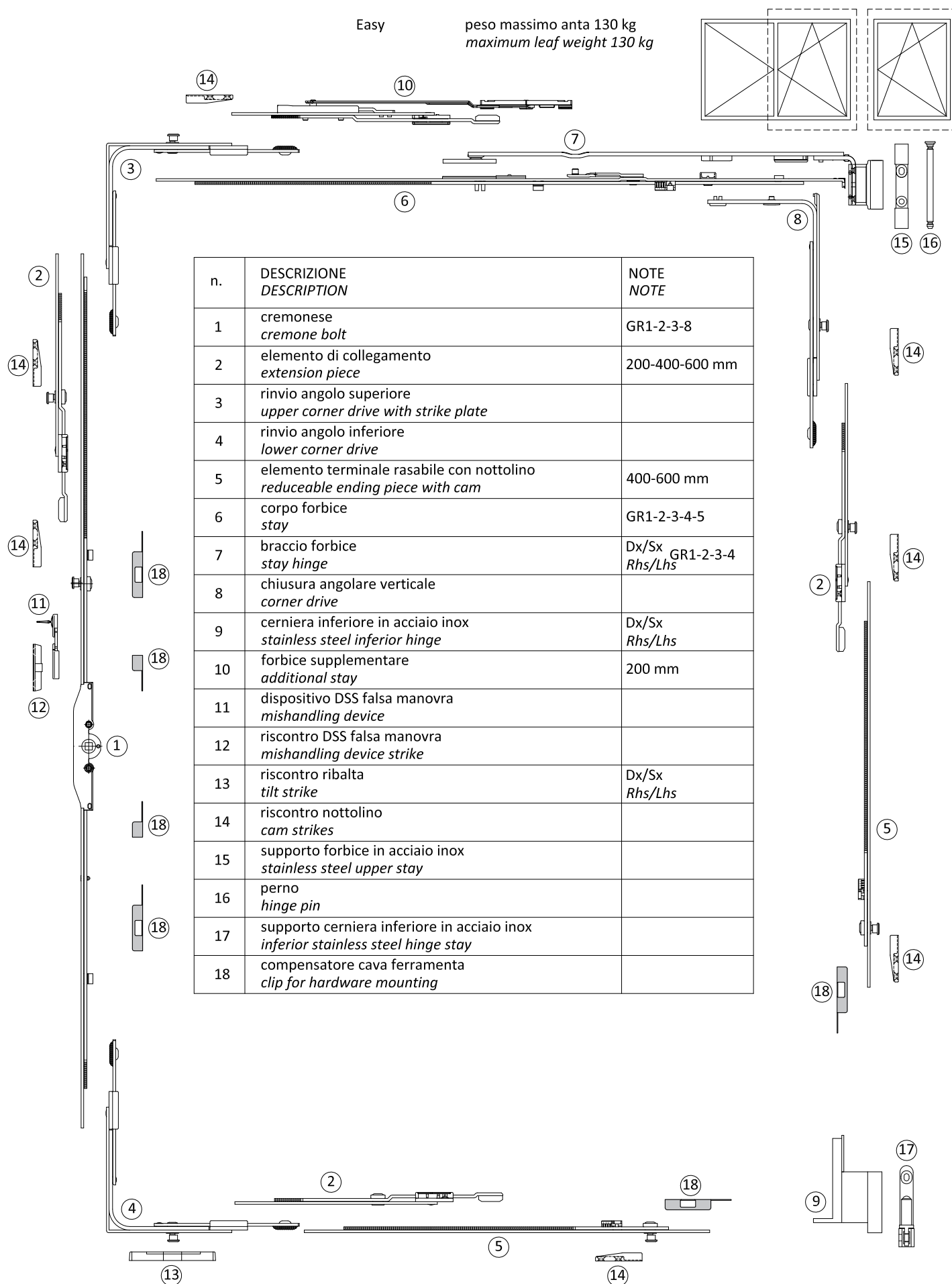




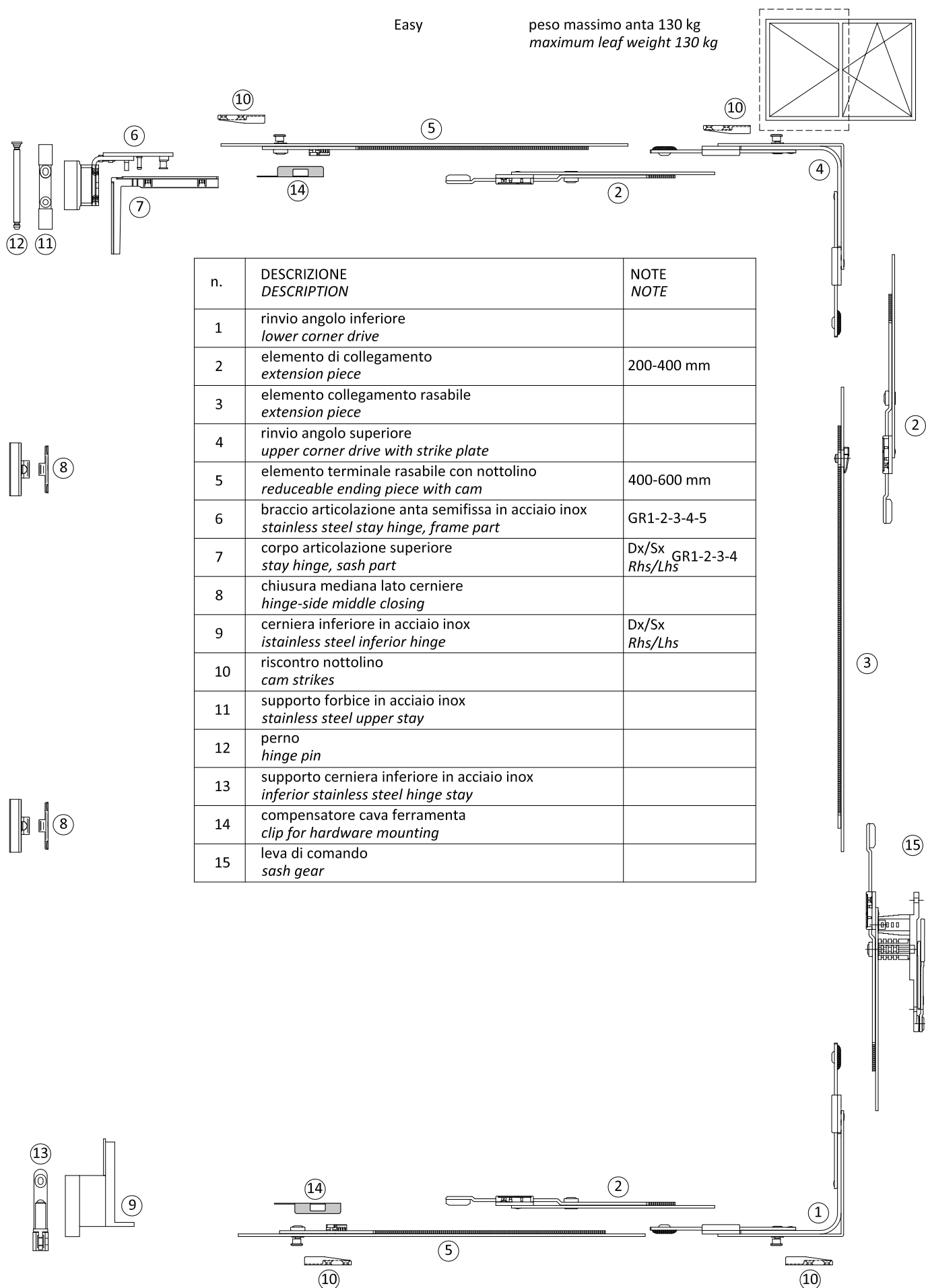
Fori eseguibili con maschera ATG281
Holes to be done with ATG281



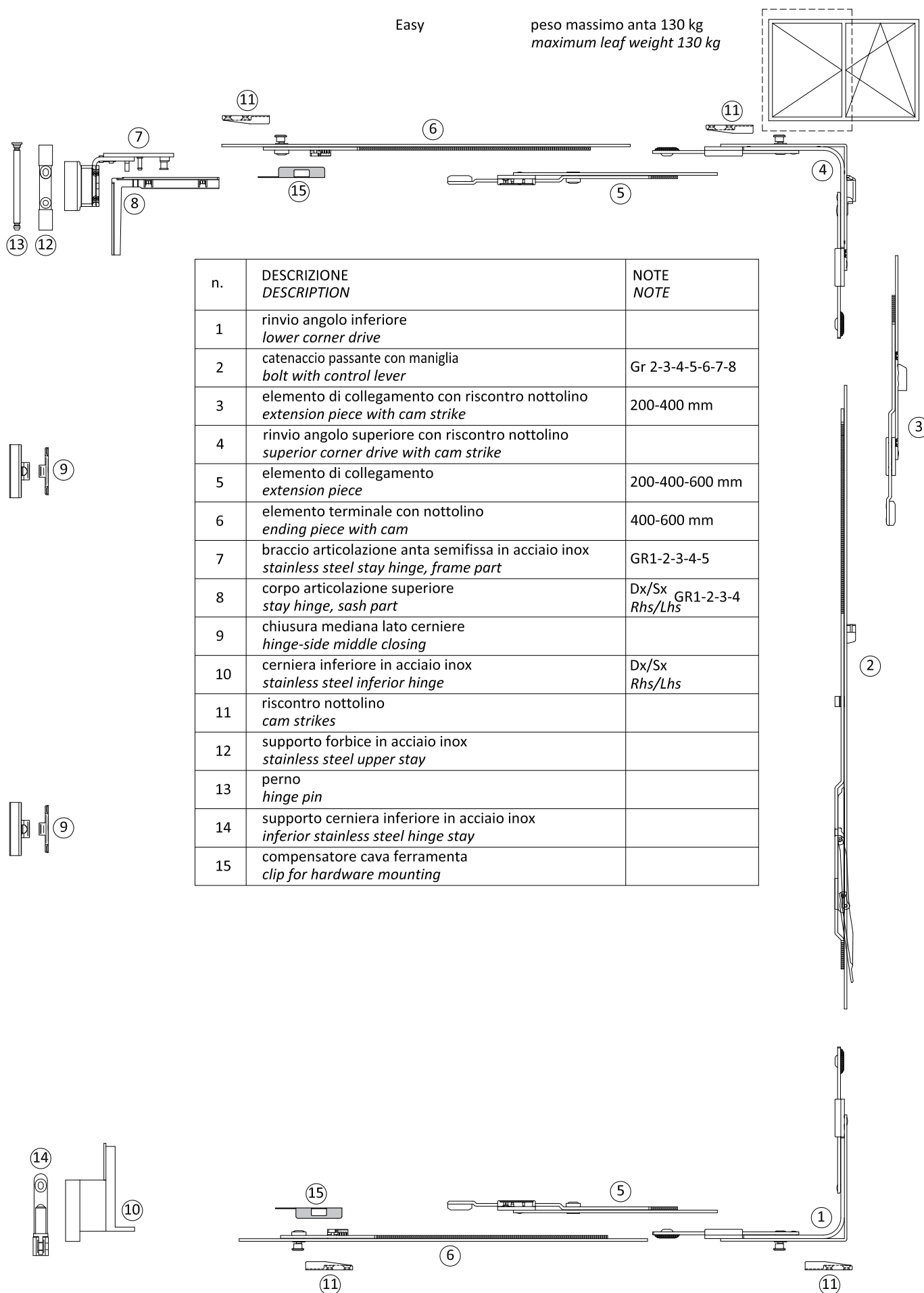
Easy

peso massimo anta 130 kg
maximum leaf weight 130 kg

Easy

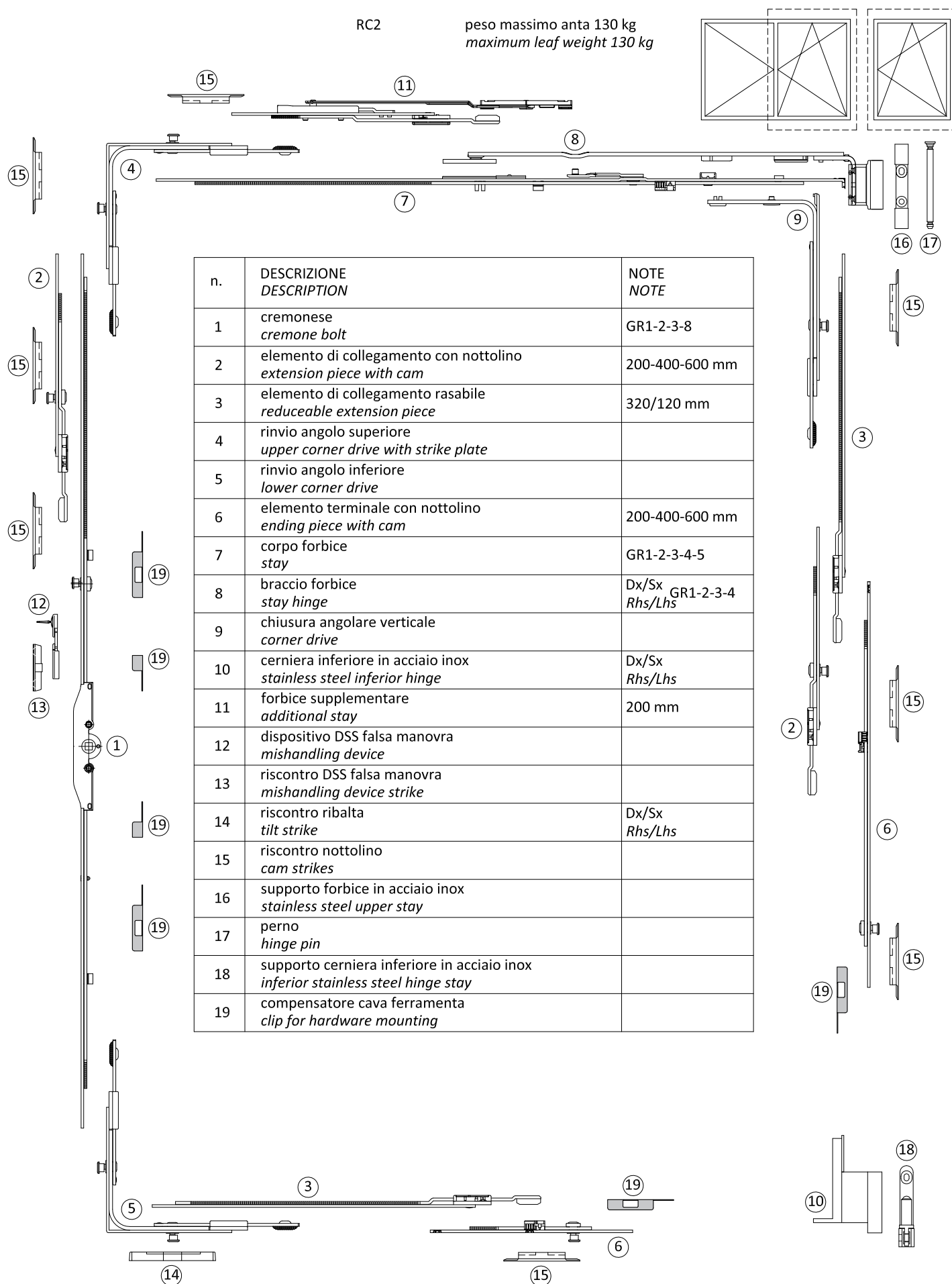
peso massimo anta 130 kg
maximum leaf weight 130 kg

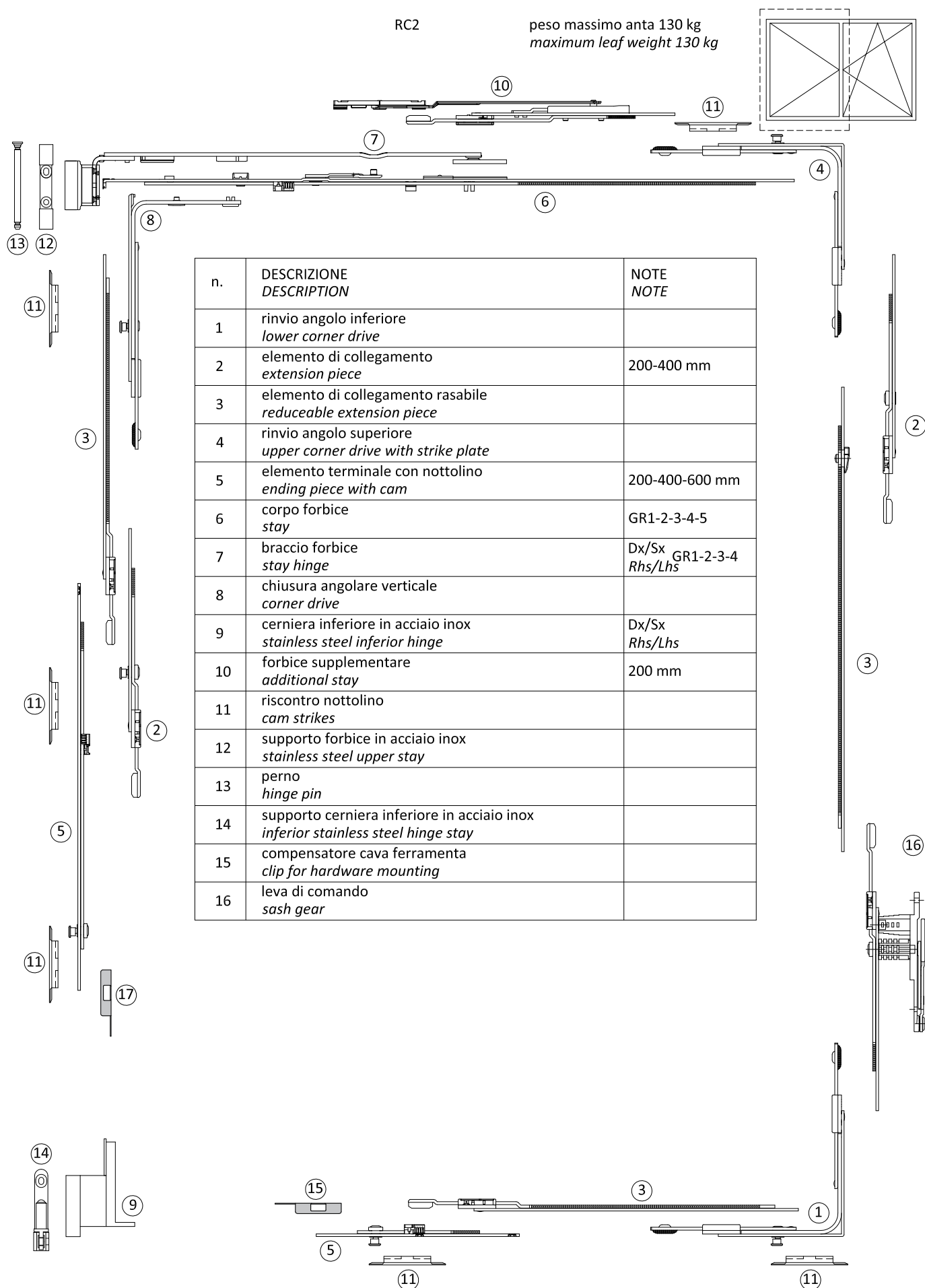
Easy

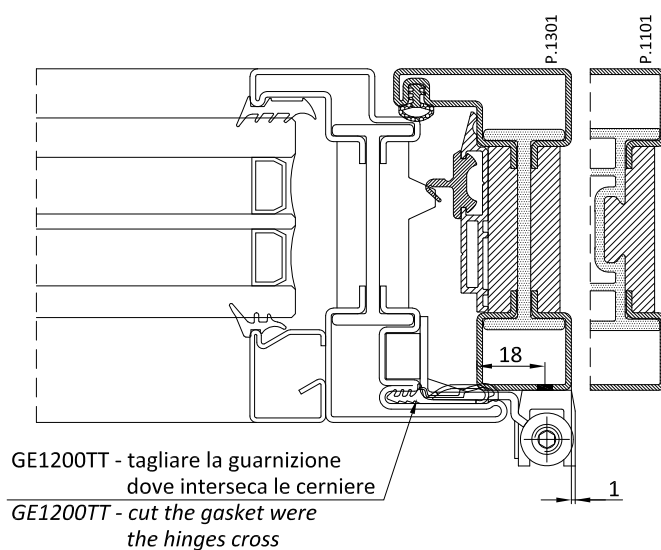
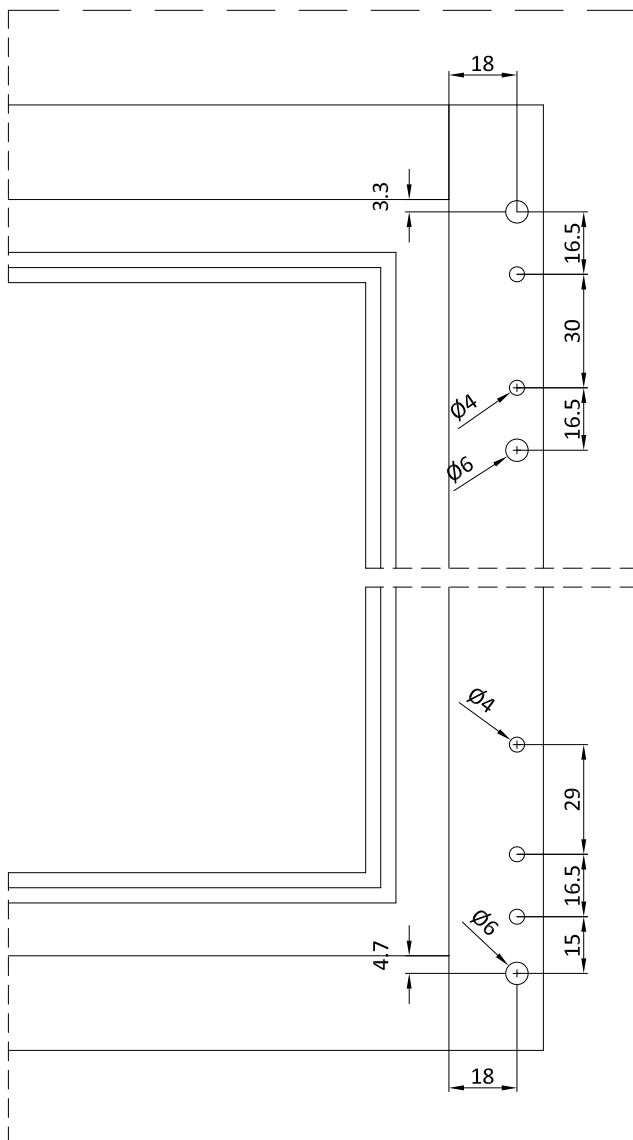
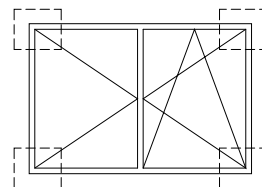
peso massimo anta 130 kg
maximum leaf weight 130 kg

n.	DESCRIZIONE DESCRIPTION	NOTE NOTE
1	rinio angolo inferiore lower corner drive	
2	catenaccio passante con maniglia bolt with control lever	Gr 2-3-4-5-6-7-8
3	elemento di collegamento con riscontro nottolino extension piece with cam strike	200-400 mm
4	rinio angolo superiore con riscontro nottolino superior corner drive with cam strike	
5	elemento di collegamento extension piece	200-400-600 mm
6	elemento terminale con nottolino ending piece with cam	400-600 mm
7	braccio articolazione anta semifissa in acciaio inox stainless steel stay hinge, frame part	GR1-2-3-4-5
8	corpo articolazione superiore stay hinge, sash part	Dx/Sx GR1-2-3-4 Rhs/Lhs
9	chiusura mediana lato cerniere hinge-side middle closing	
10	cerniera inferiore in acciaio inox stainless steel inferior hinge	Dx/Sx Rhs/Lhs
11	riscontro nottolino cam strikes	
12	supporto forbice in acciaio inox stainless steel upper stay	
13	perno hinge pin	
14	supporto cerniera inferiore in acciaio inox inferior stainless steel hinge stay	
15	compensatore cava ferramenta clip for hardware mounting	

RC2

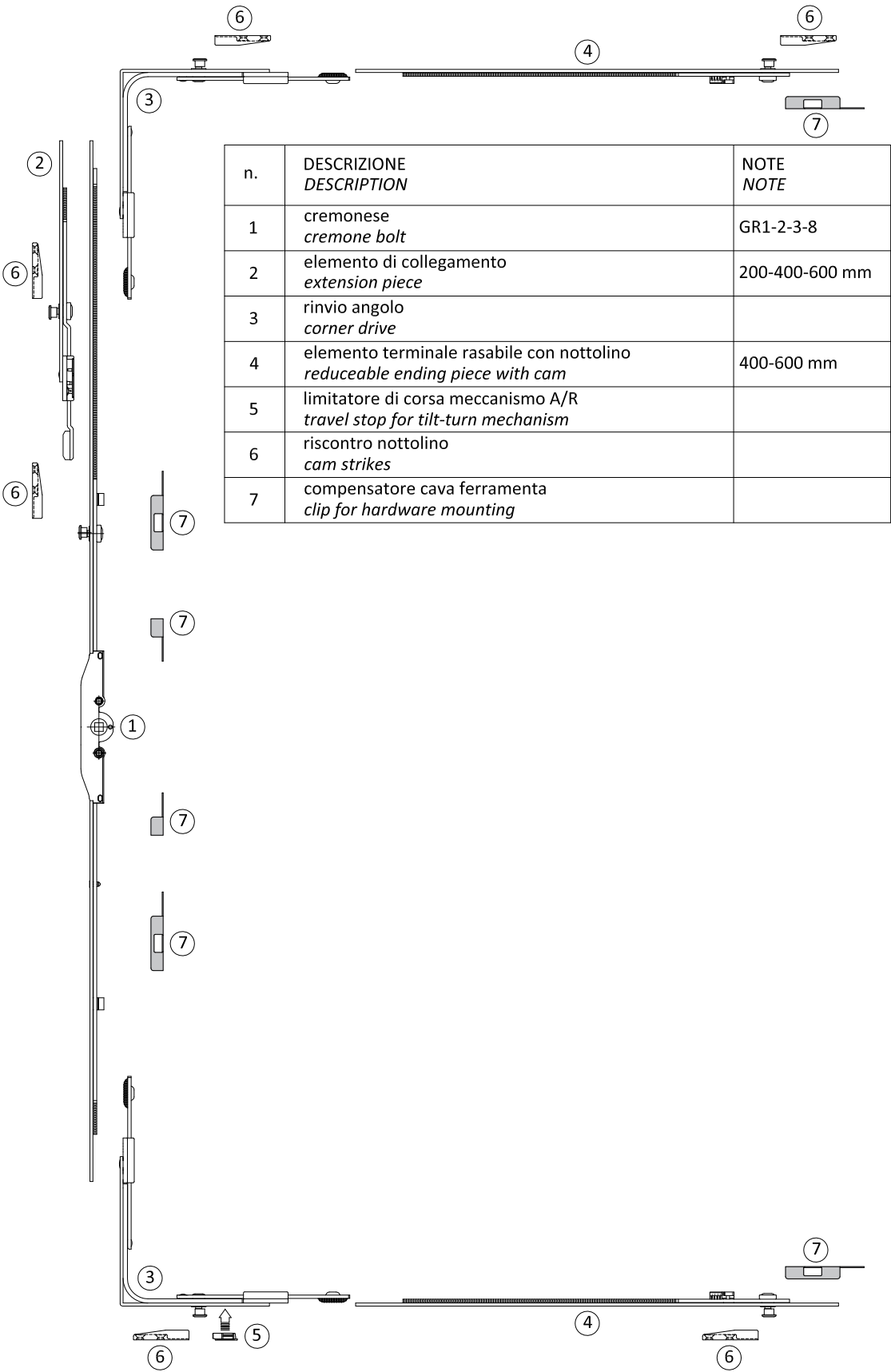
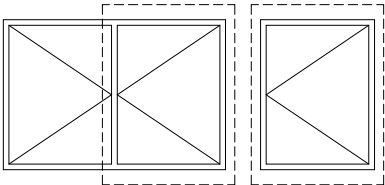
peso massimo anta 130 kg
maximum leaf weight 130 kg





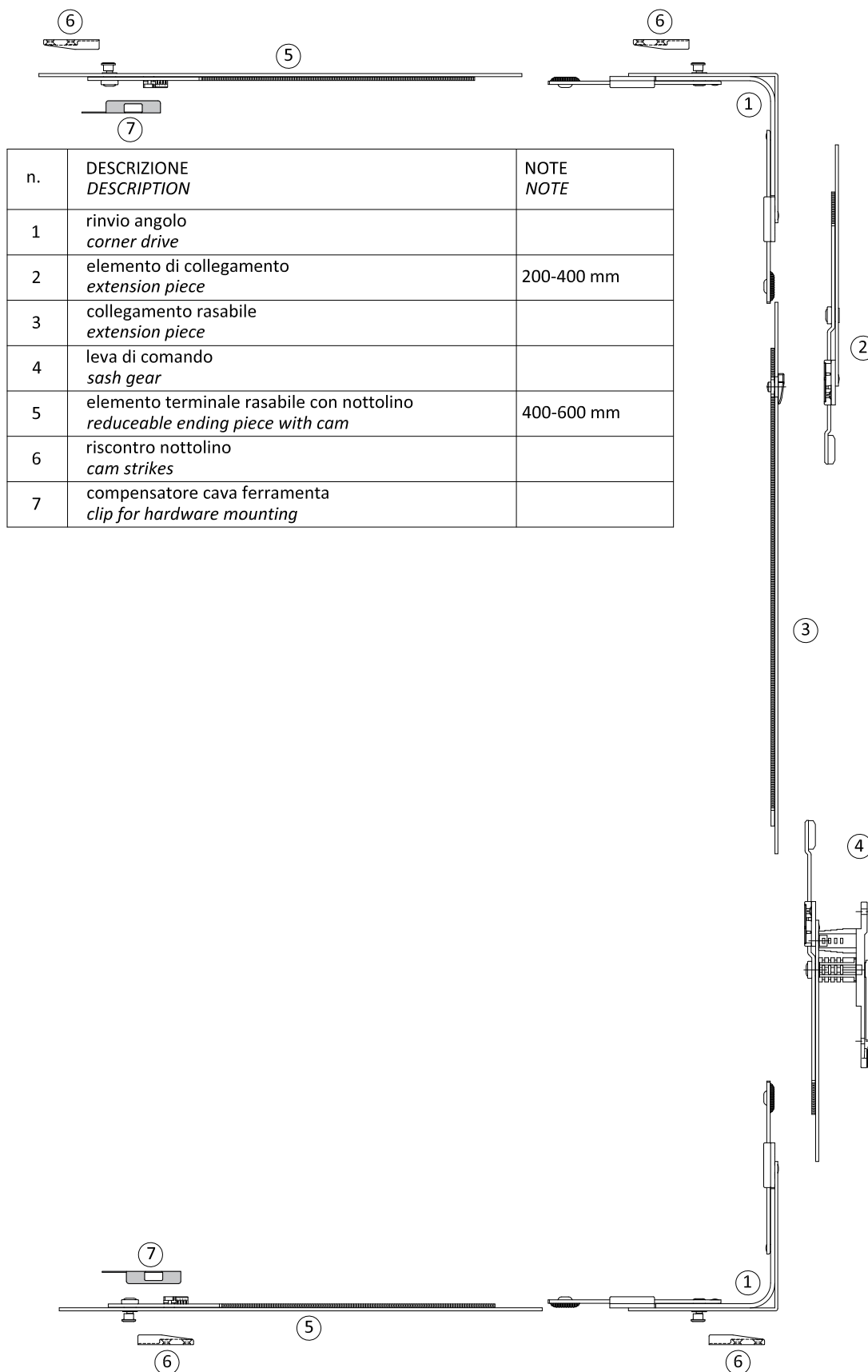
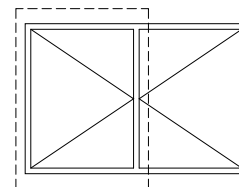
Fori eseguibili con maschera AT1242
Holes to be done with AT1242

Easy
peso massimo anta 180 kg
(AC1237)
maximum leaf weight 180 kg
(AC1237)



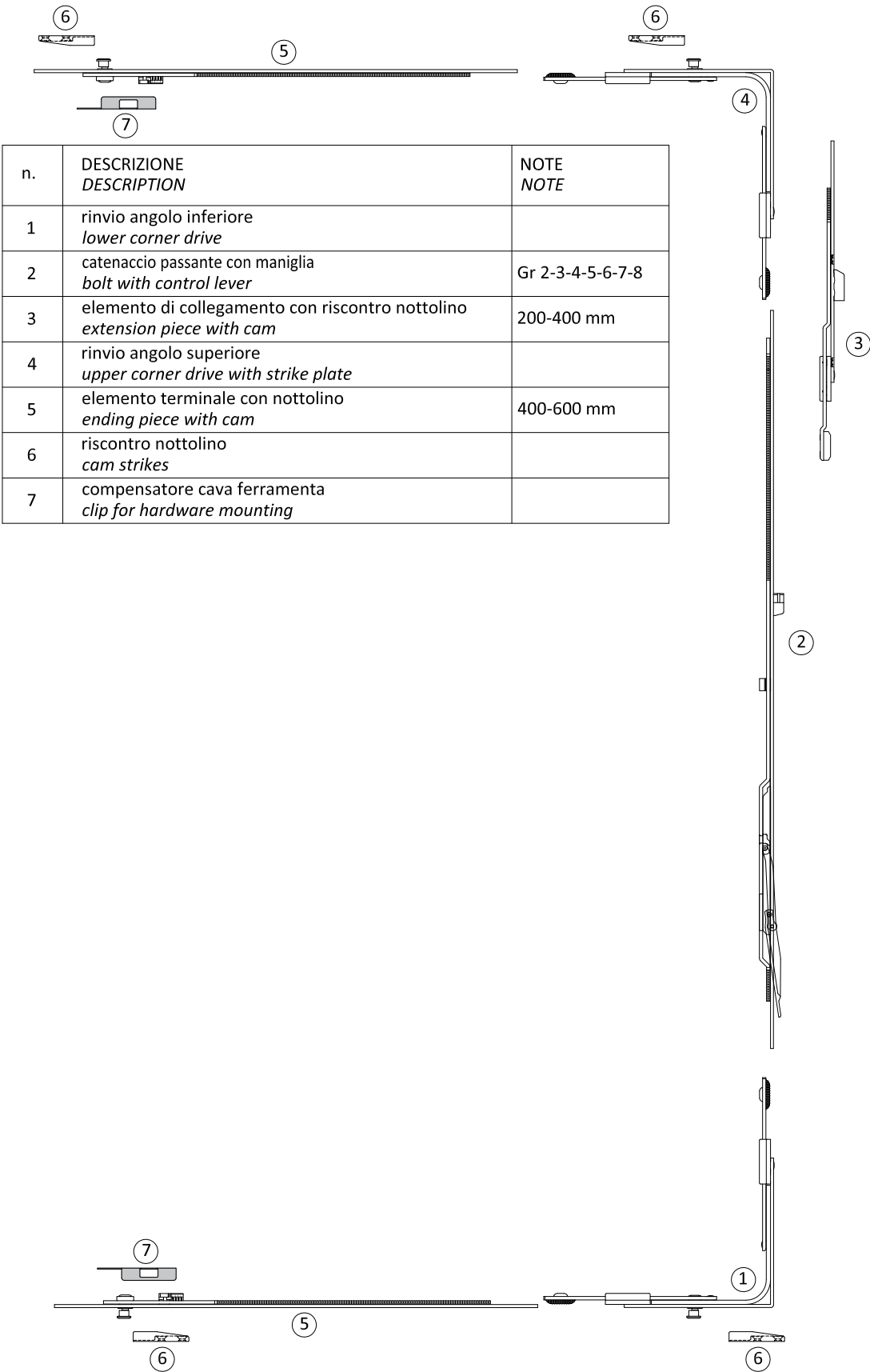
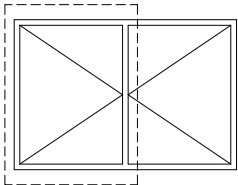
Easy

peso massimo anta 180 kg
(AC1237)
maximum leaf weight 180 kg
(AC1237)



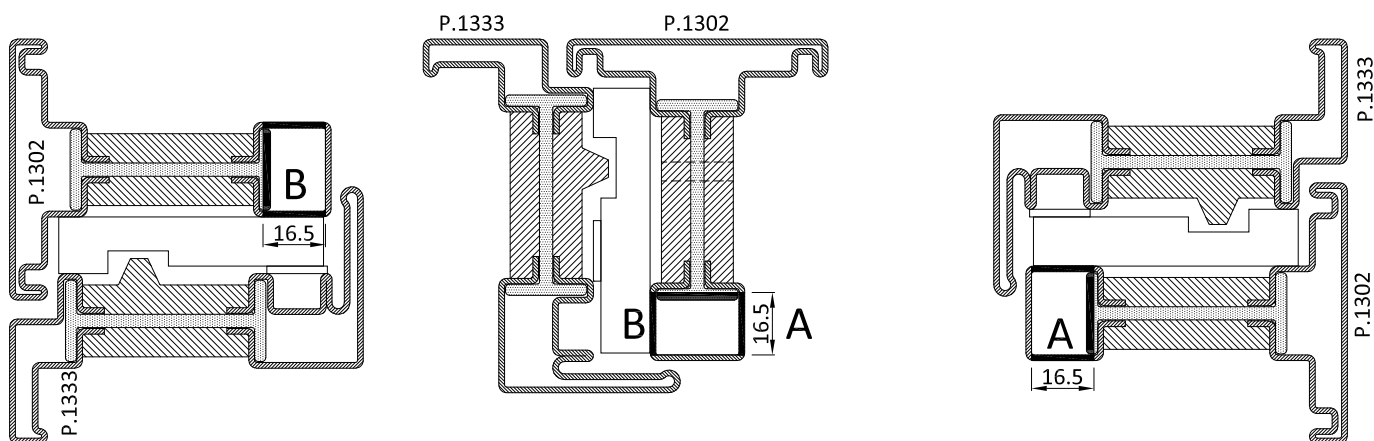
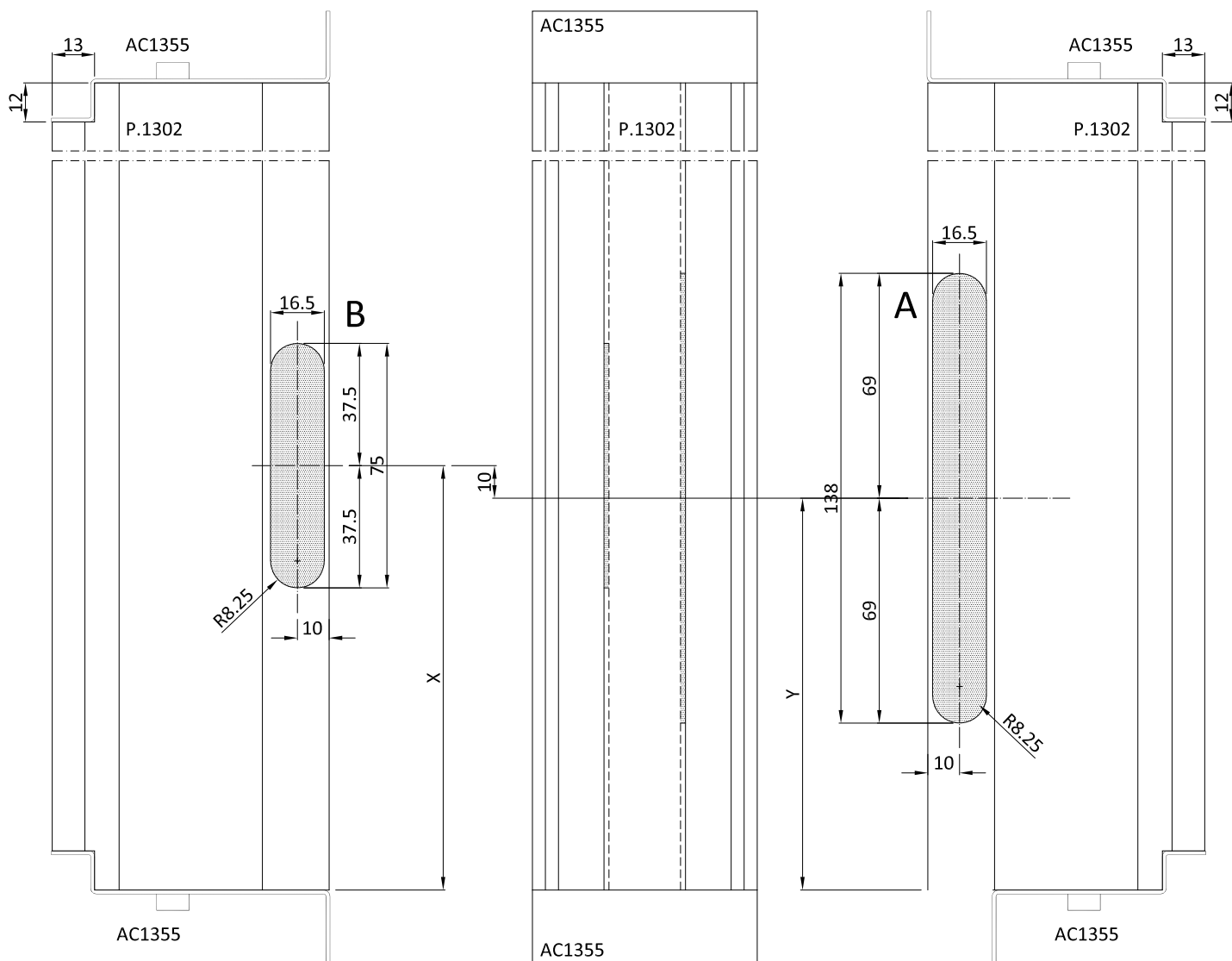
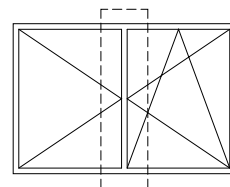
Easy

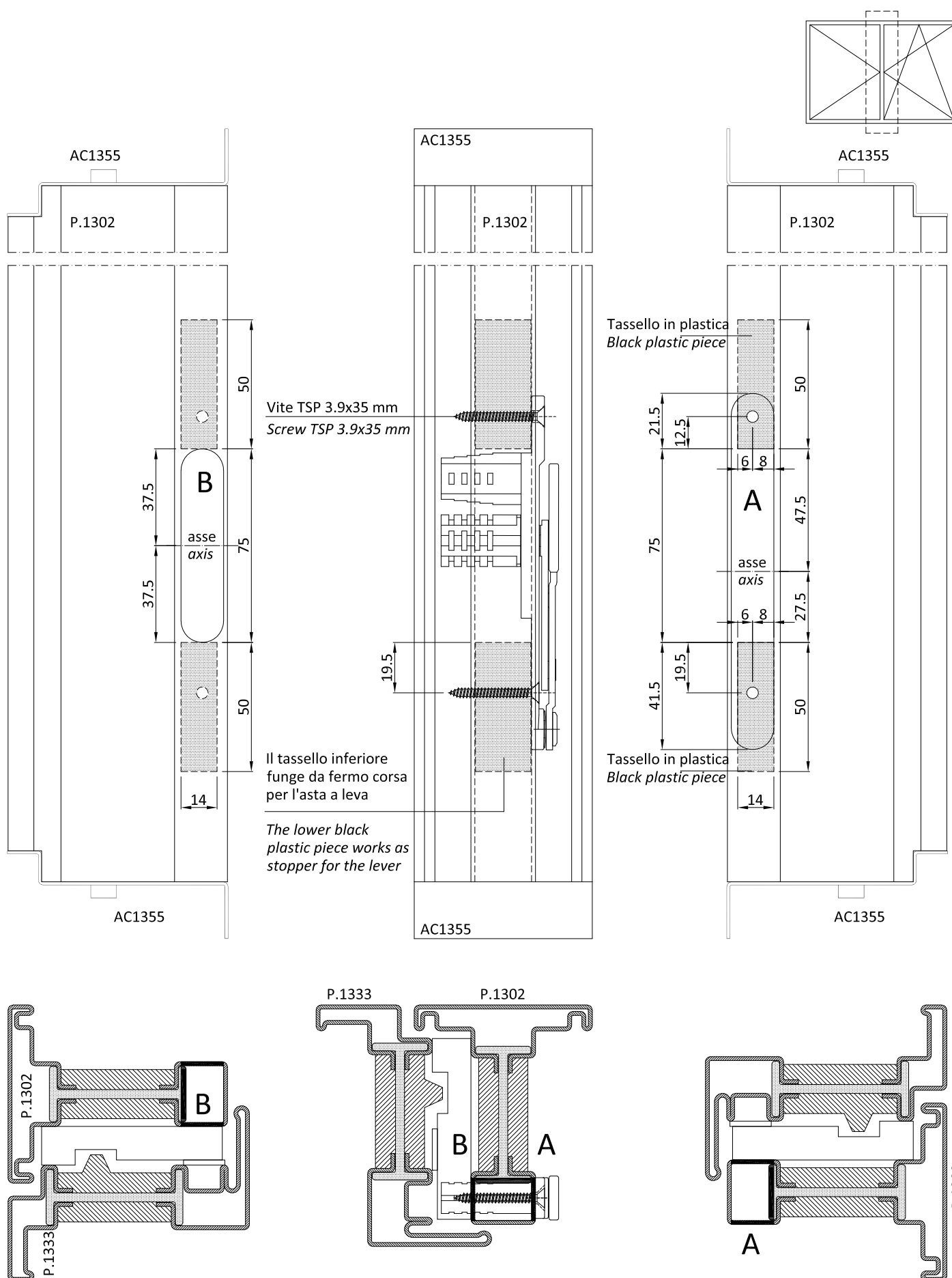
peso massimo anta 180 kg
(AC1237)
maximum leaf weight 180 kg
(AC1237)

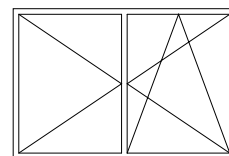


n.	DESCRIZIONE DESCRIPTION	NOTE NOTE
1	rinvio angolo inferiore lower corner drive	
2	catenaccio passante con maniglia bolt with control lever	Gr 2-3-4-5-6-7-8
3	elemento di collegamento con riscontro nottolino extension piece with cam	200-400 mm
4	rinvio angolo superiore upper corner drive with strike plate	
5	elemento terminale con nottolino ending piece with cam	400-600 mm
6	riscontro nottolino cam strikes	
7	compensatore cava ferramenta clip for hardware mounting	

Easy RC2	H cava ferramenta H hardware slot [mm]	X [mm]	Y [mm]
	661 → 1000	183	173
	1001 → 1800	275	265
	1801 → 2400	855	845

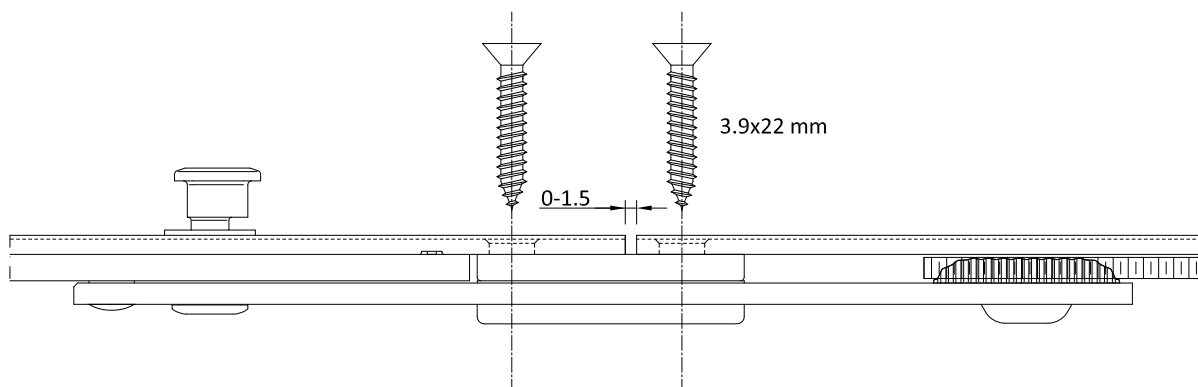
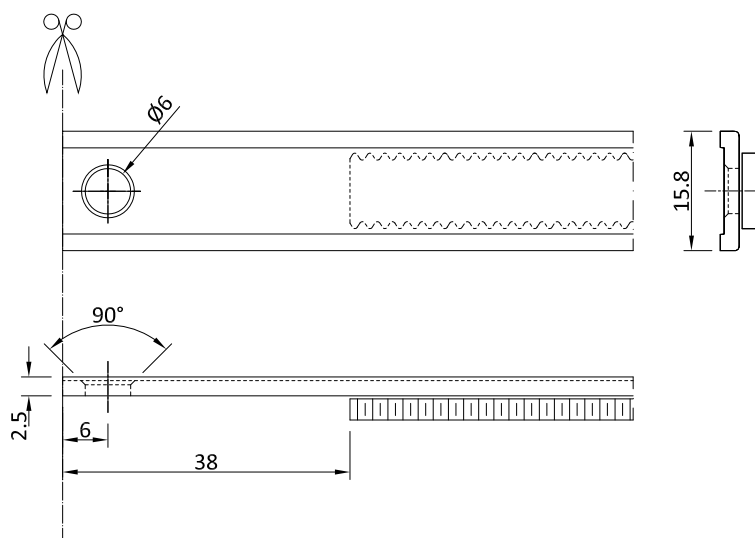




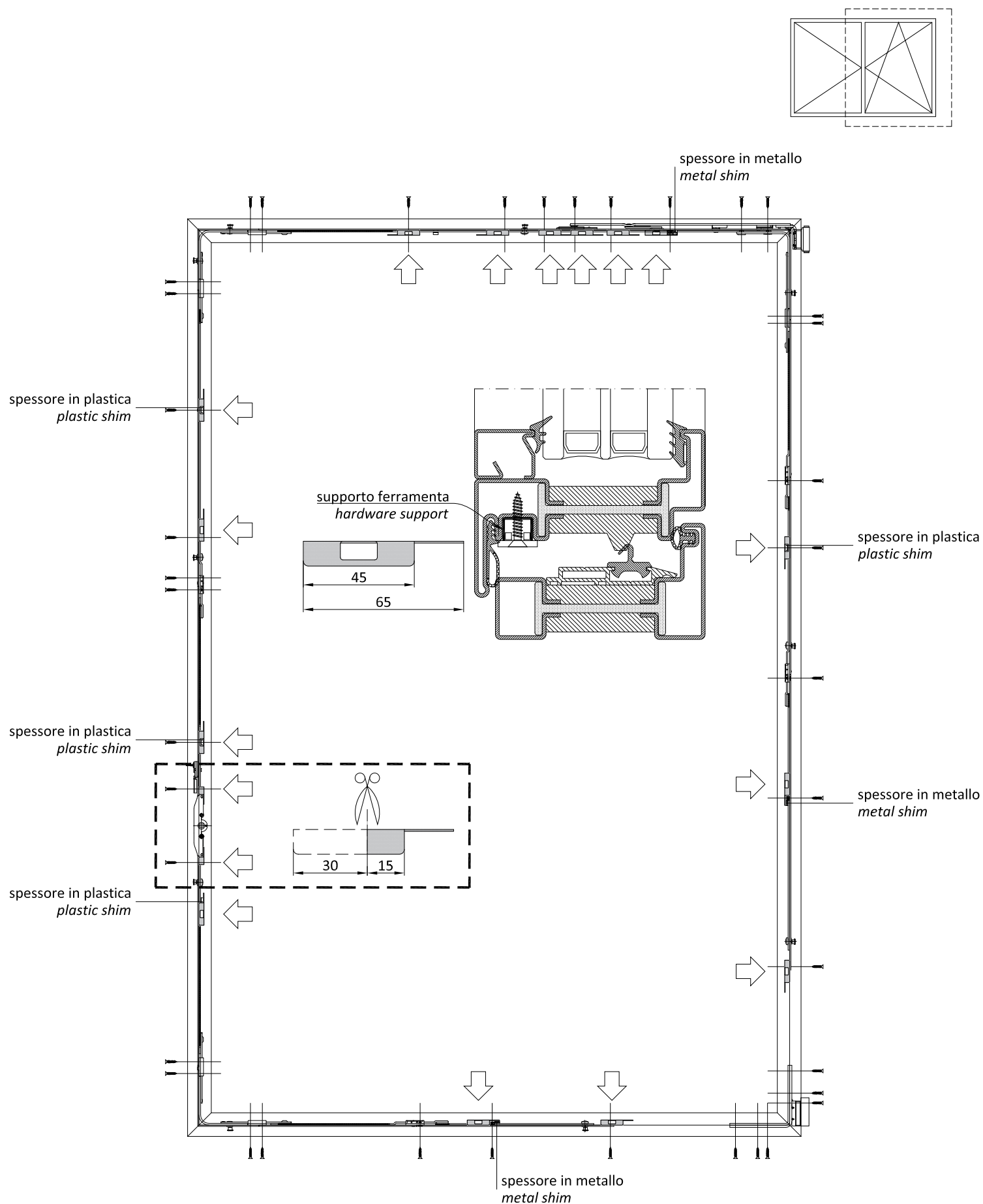


Lavorazione da eseguire sui componenti rasabili della ferramenta
Working on the cuttable pieces of the hardware

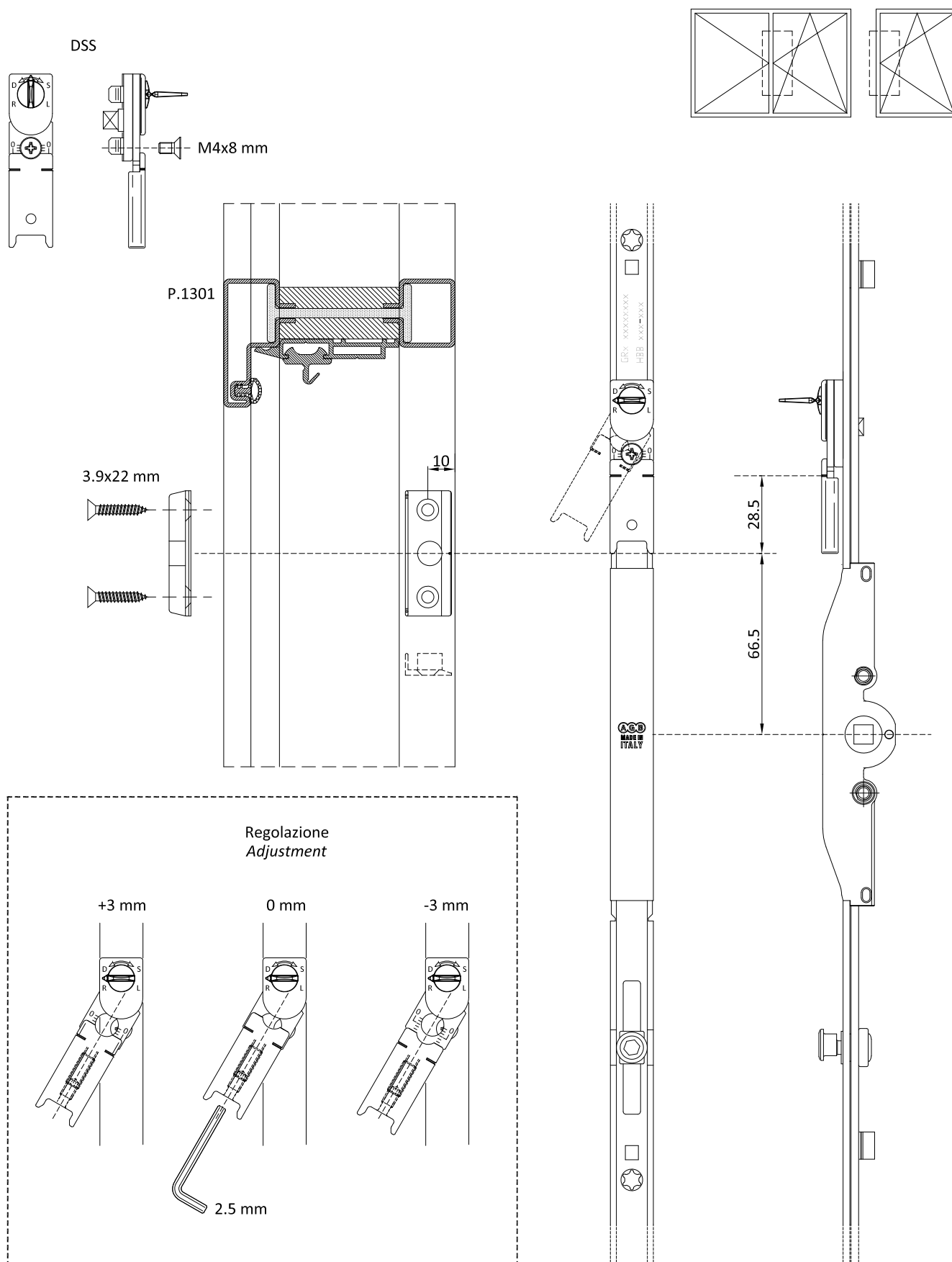
- 1 - Eseguire taglio della ferramenta sfalsato
 - 2 - Eseguire foro e svasatura
-
- 1 - Cutting of the hardware
 - 2 - Hole drilling and countersink



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

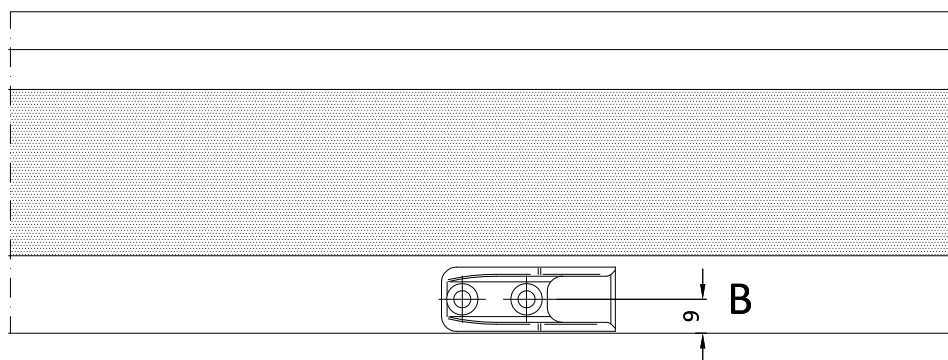
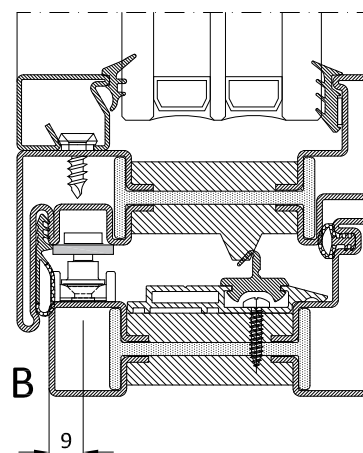
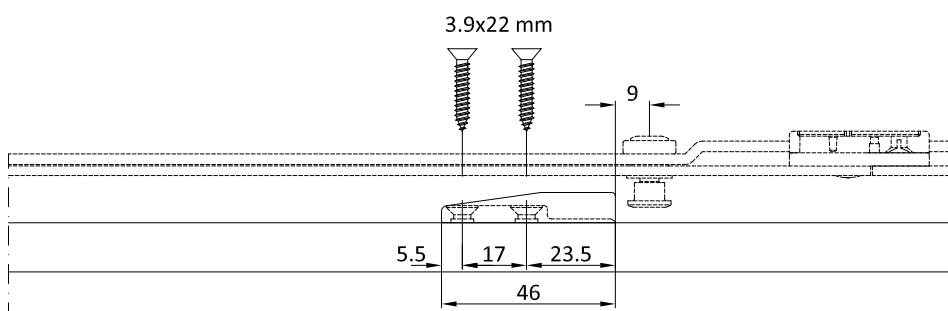
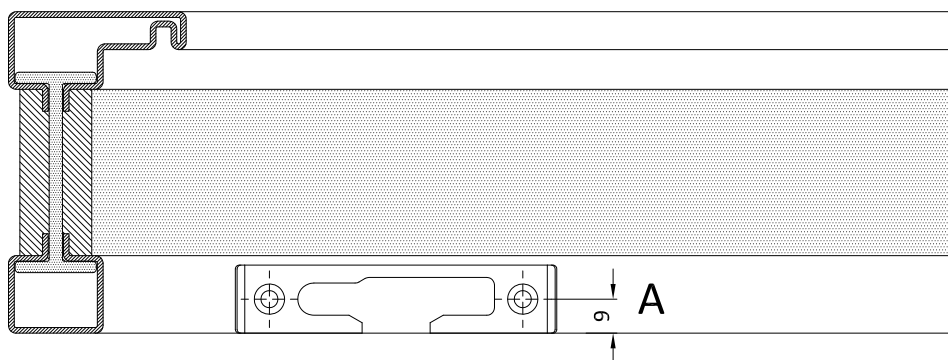
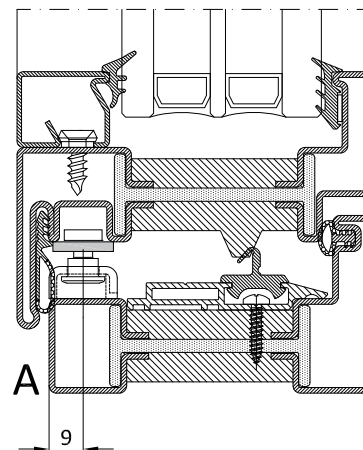
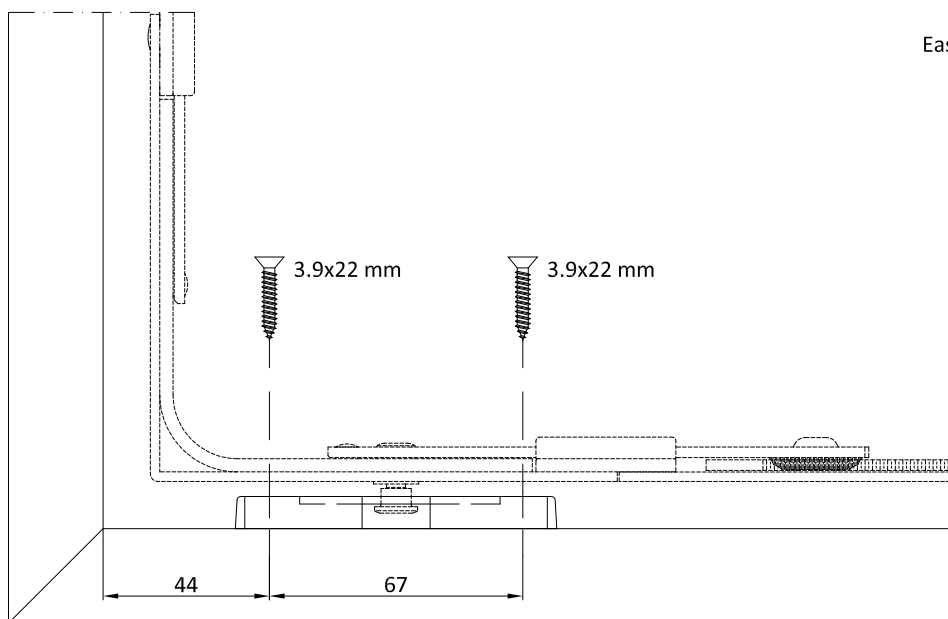
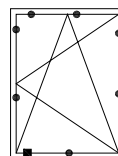


viti | screws TPS 3.9x22 mm

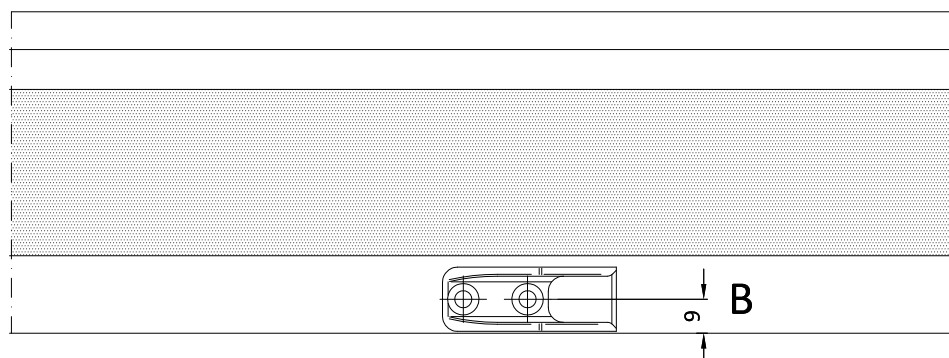
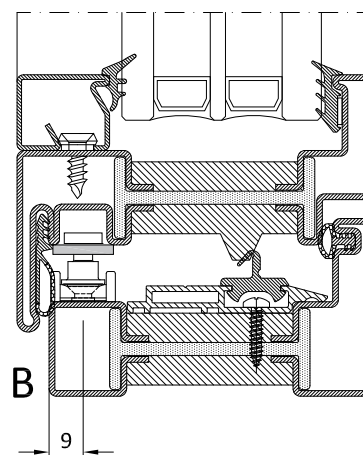
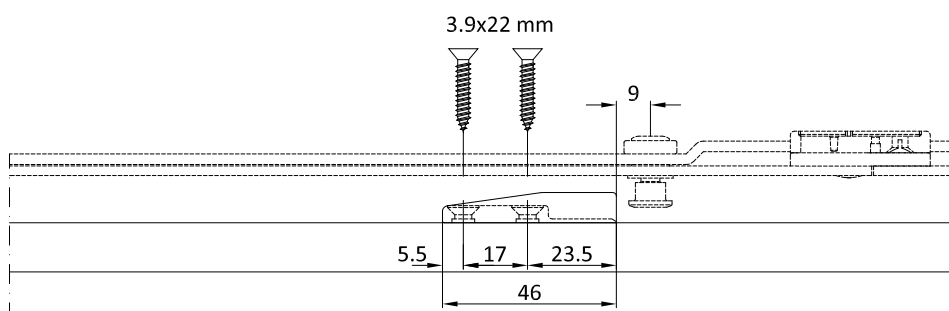
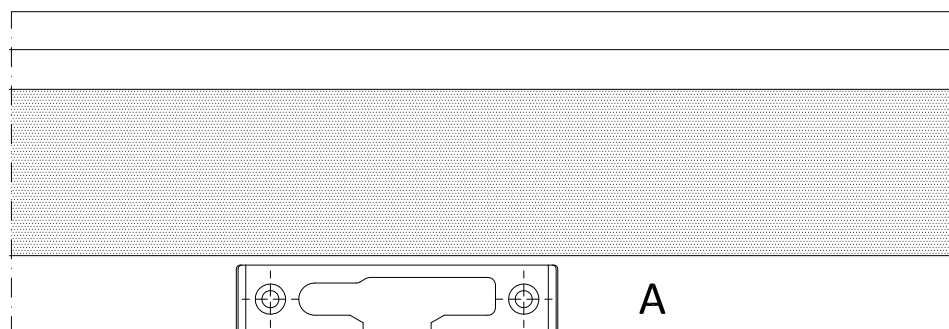
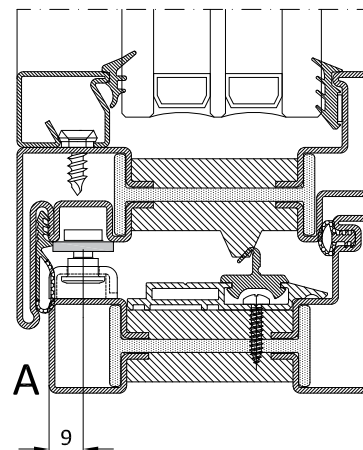
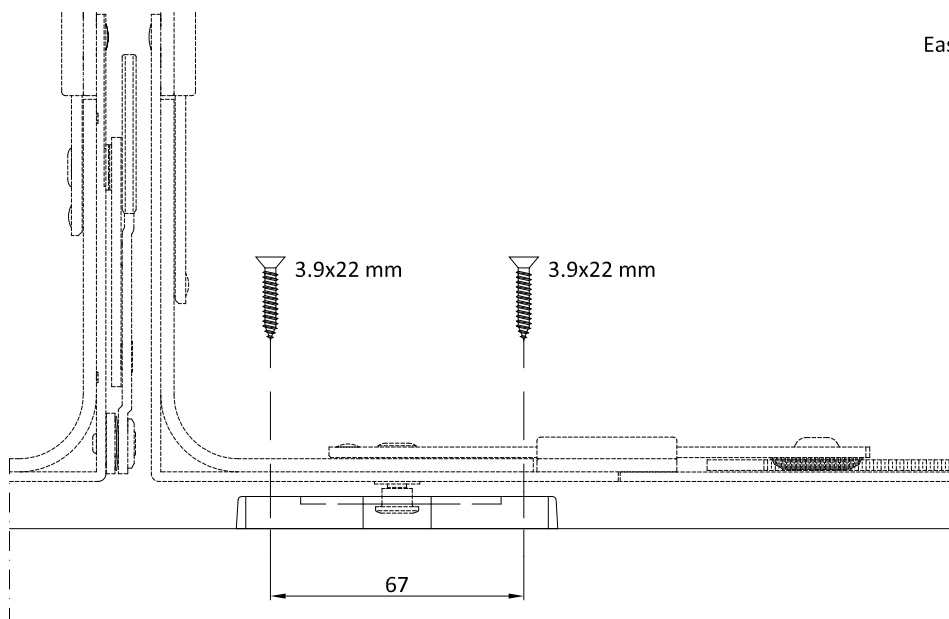
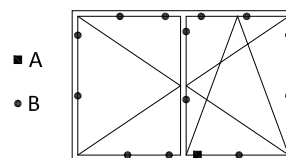


Easy

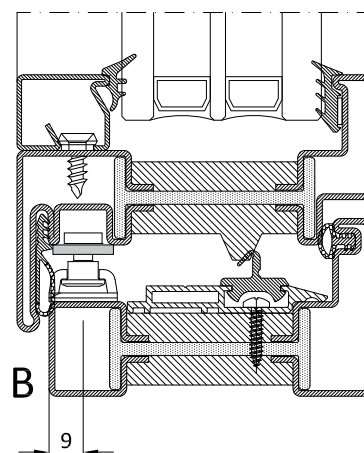
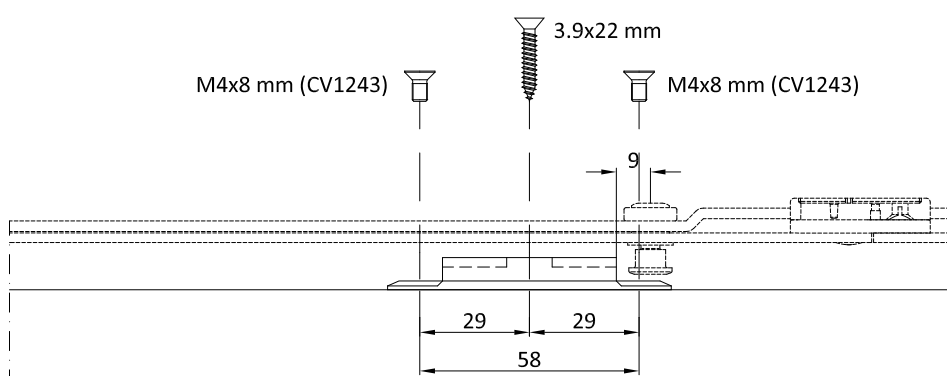
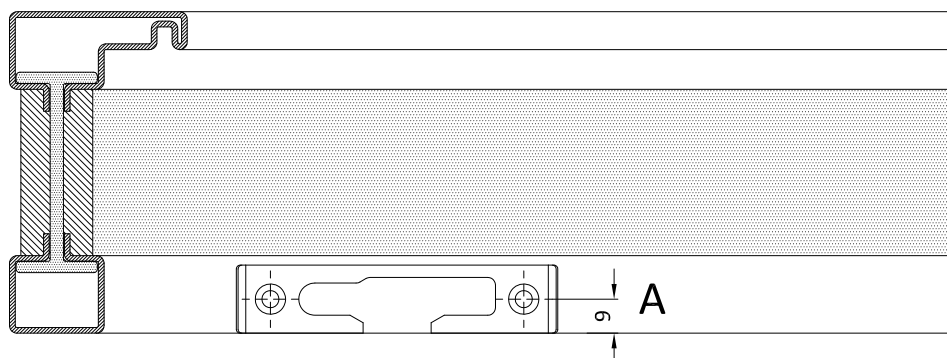
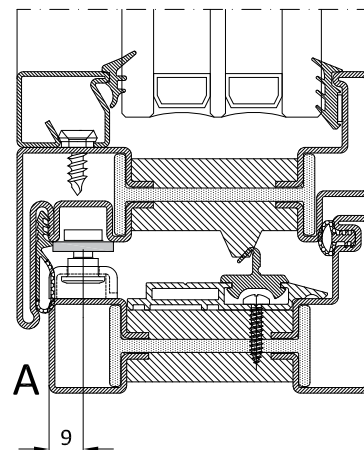
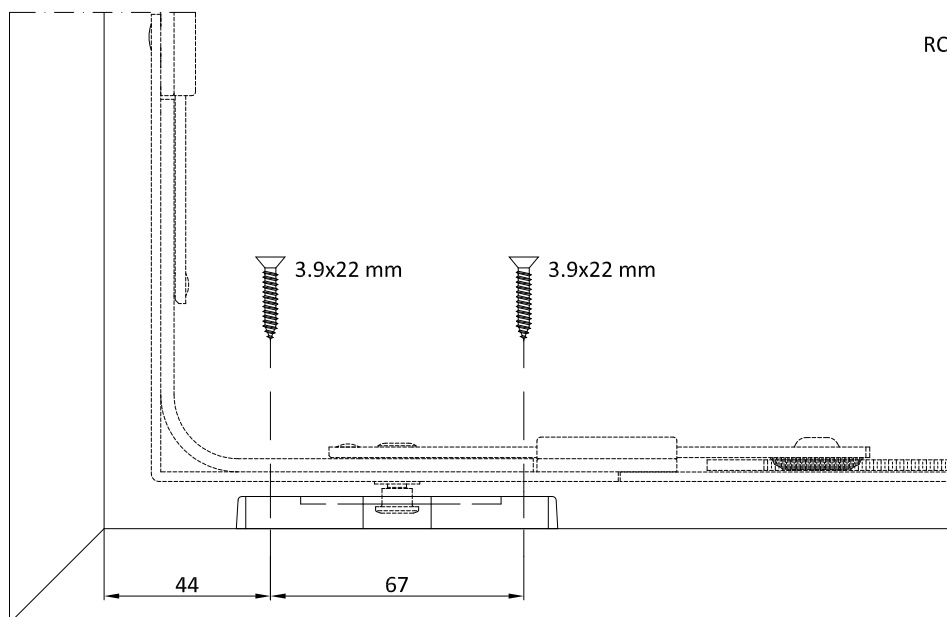
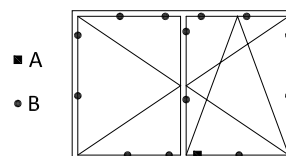
■ A
● B



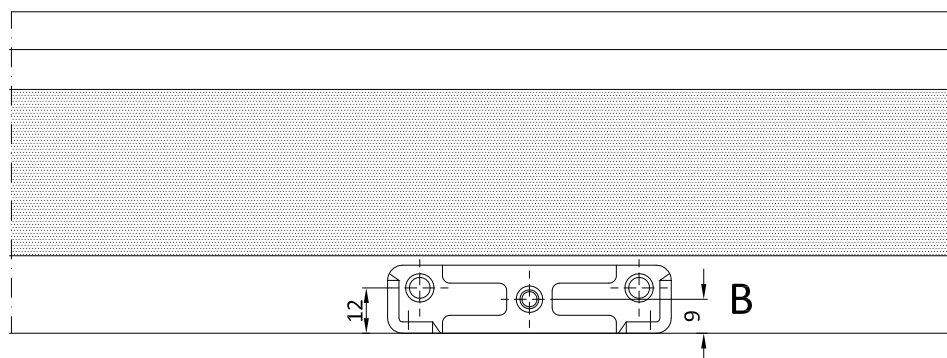
Easy



RC2

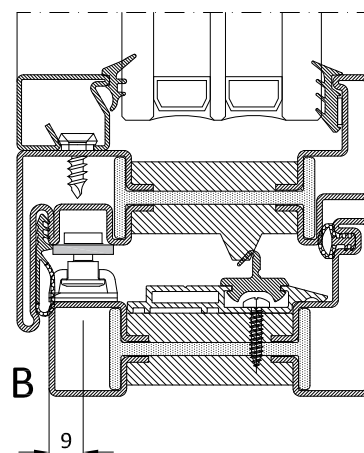
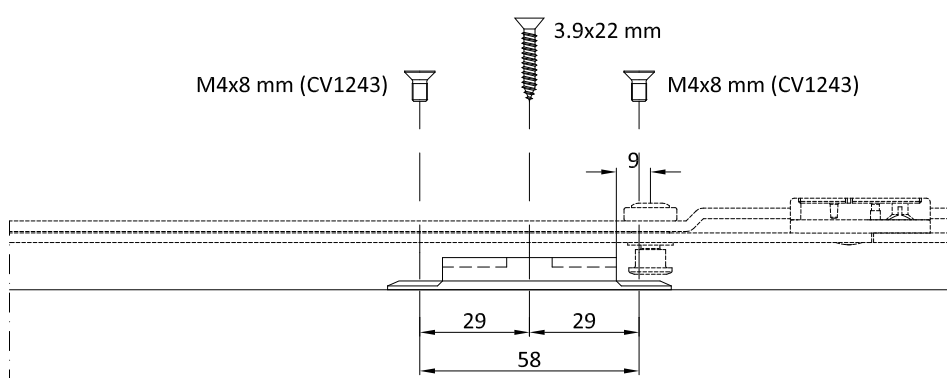
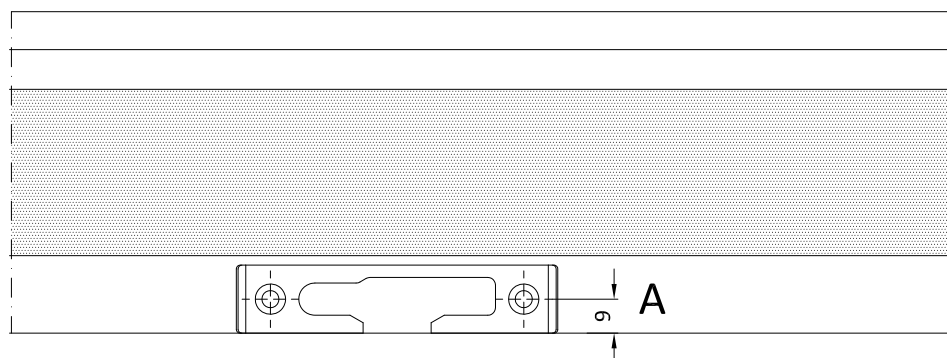
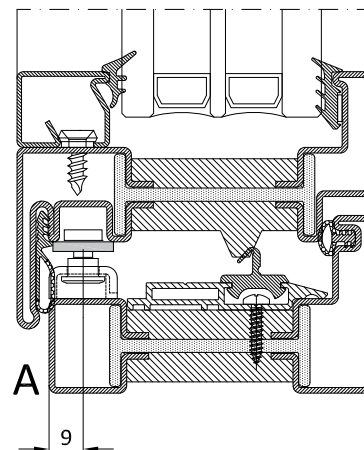
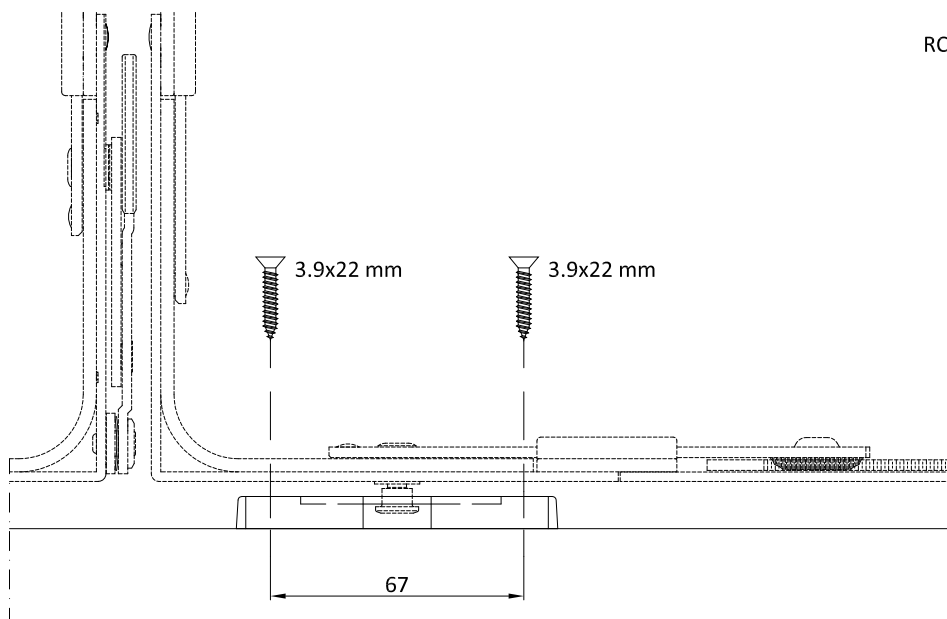
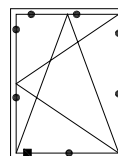


Fori eseguibili con
maschera ATG303
Holes to be done with
ATG303

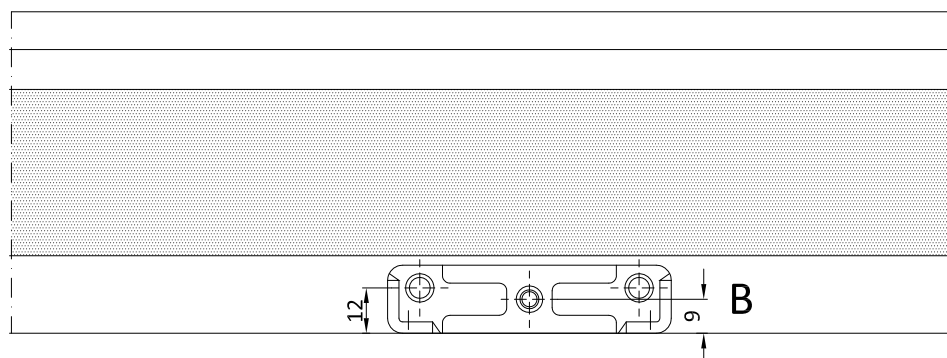


RC2

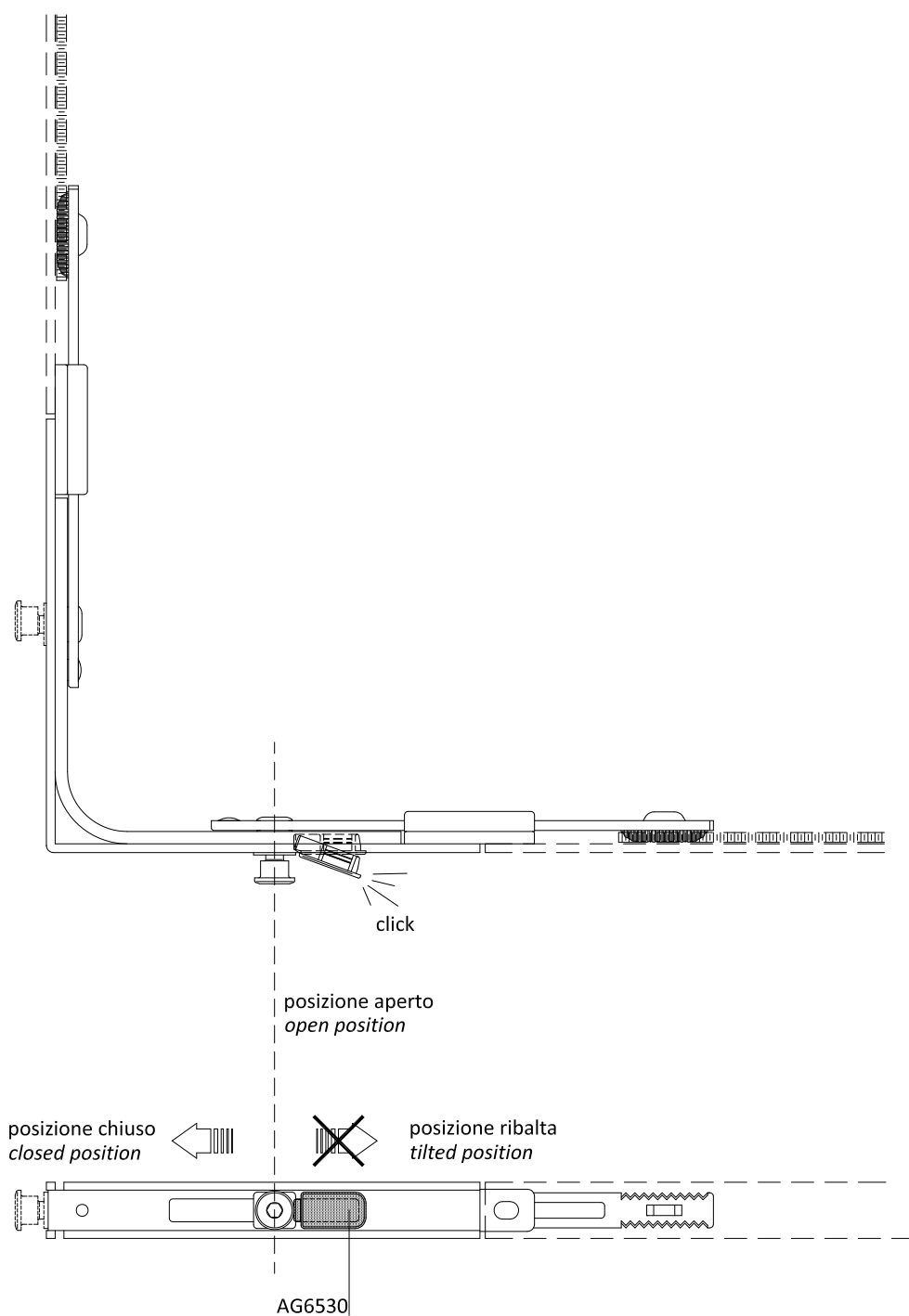
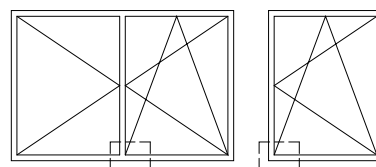
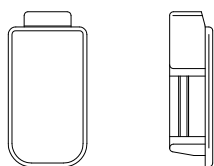
■ A
● B

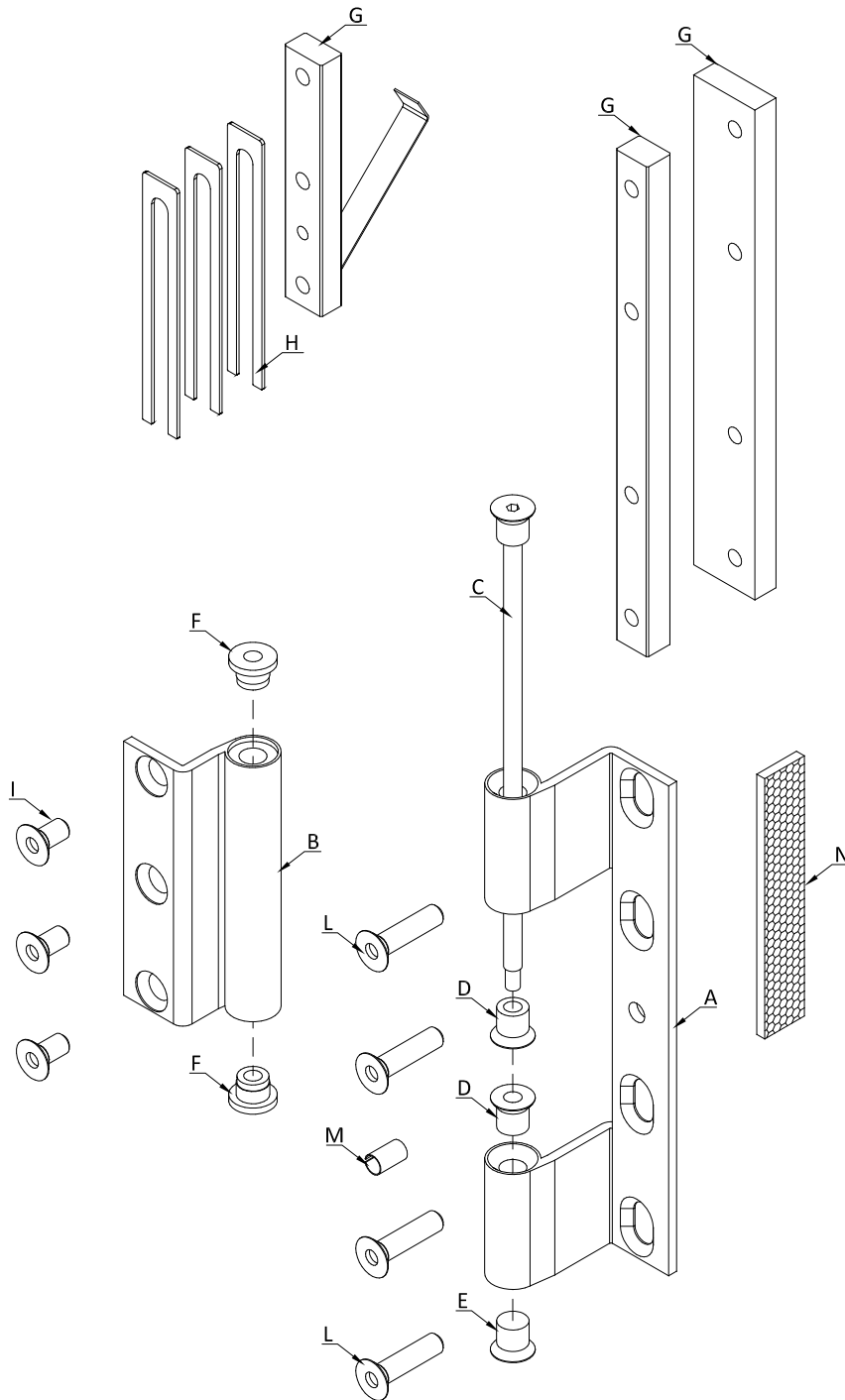
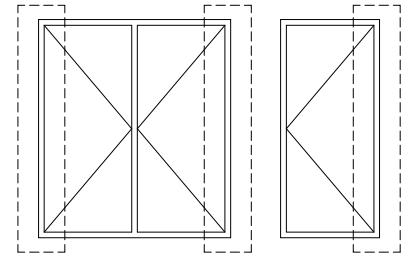


Fori eseguibili con
maschera ATG303
Holes to be done with
ATG303



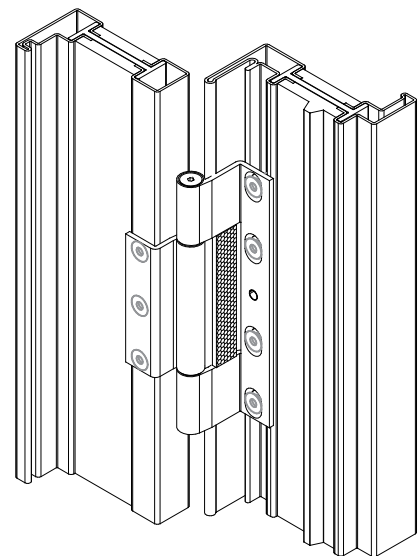
AG6530

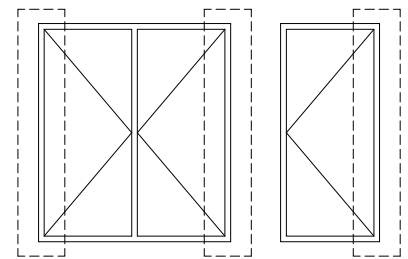
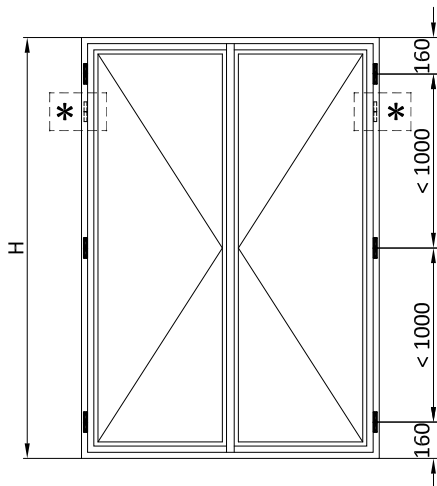




- A) Corpo cerniera A
- B) Corpo cerniera B
- C) Perno
- D) Guida perno
- E) Tappo a vite
- F) Bronzina
- G) Rinforzi interni
- H) Distanziale di regolazione
- I) Viti acciaio inox TSPEI M6 x 12 mm
- L) Viti acciaio inox TSPEI M6 x 25 mm
- M) Spina inox Ø 6 x 10 mm da inserire dopo la regolazione dell'anta
- N) Guarnizione adesiva 15x3 mm

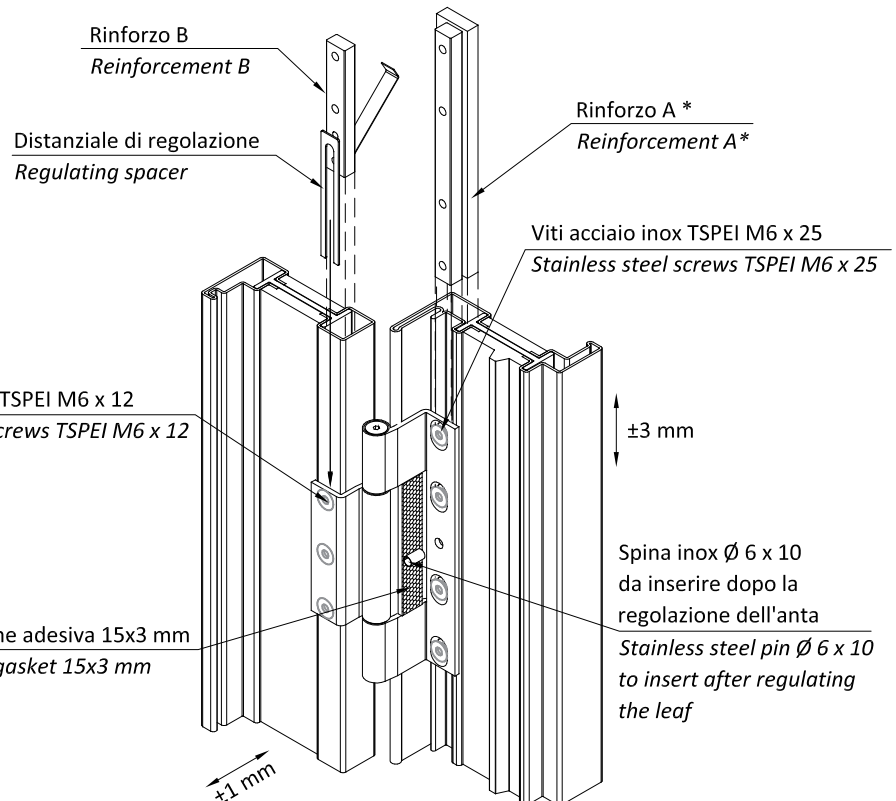
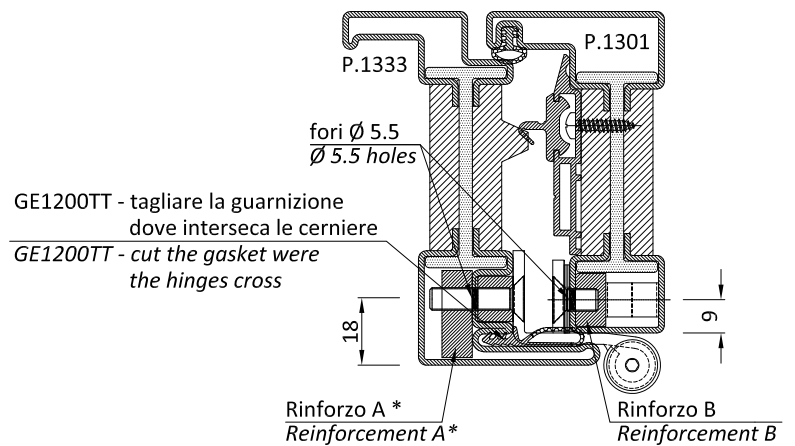
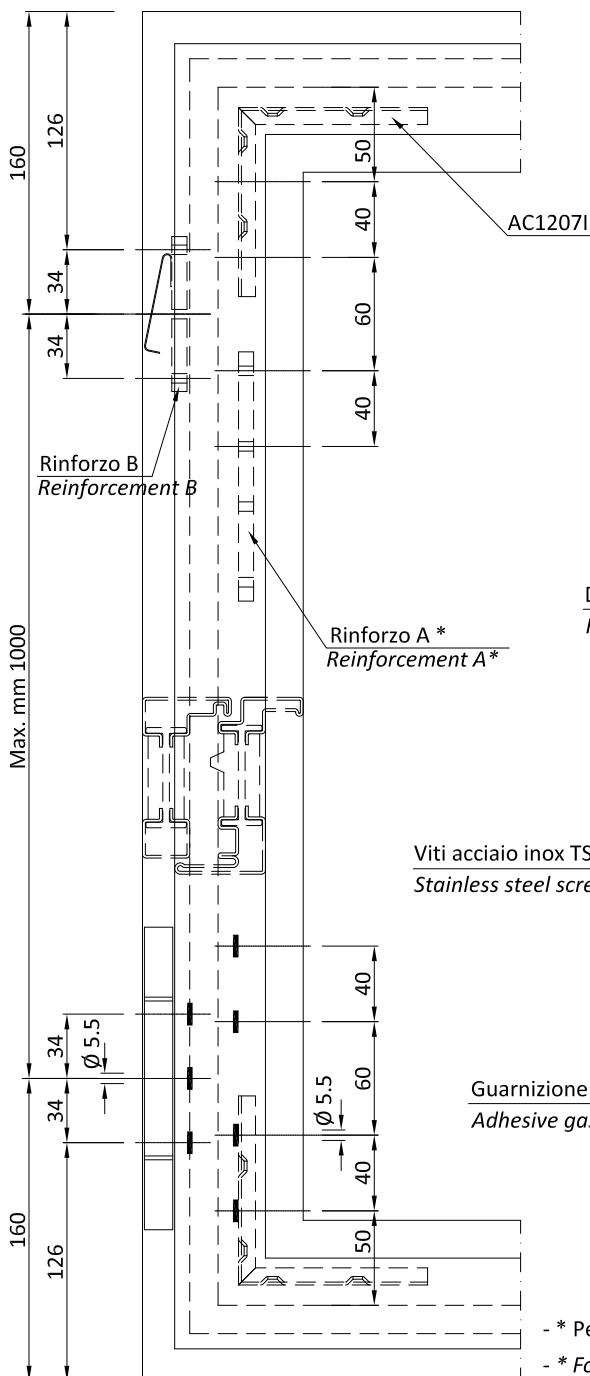
- A) Body hinge A
- B) Body hinge B
- C) Pin
- D) Pin groove/guide
- E) Screw cap
- F) Bronze bush
- G) Internal reinforcements
- H) Regulating spacer
- I) Stainless steel screws TSPEI M6 x 12 mm
- L) Stainless steel screws TSPEI M6 x 25 mm
- M) Stainless steel pin Ø 6 x 10 mm to insert after regulating the leaf
- N) adhesive gasket 15x3 mm





Peso max. per anta 180 kg
Max. weight for leaf: 180 kg

* Cerniera aggiuntiva per peso anta
> di 180 kg - peso max 200 kg
Additional hinge for leaf weight
> 180 kg - max weight 200 kg



- * Per cerniere intermedie allineare i 4 fori di fissaggio della cerniera con i fori del rinforzo A
- * For intermediate hinges align the 4 anchoring holes of the hinge with the holes of reinforcement A

LAVORAZIONE VALIDA ANCHE PER CERNIERE INTERMEDIE /
AGGIUNTIVE

Dopo aver tagliato montanti e traversi dell'anta e del telaio ed aver effettuato le lavorazioni delle squadrette, forare con punta $\varnothing 5,5$ il profilo "telaio" ed il profilo "anta" come indicato nel disegno.

Prima di assiemare il telaio e l'anta inserire i rinforzi "A" - "B" e bloccarli con le viti in dotazione.

Effettuare le medesime lavorazioni per la cerniera superiore e per le eventuali posizioni intermedie.

Forare la squadretta AC1207I di assiemaggio dell'anta e filettare i fori M5.

Dopo aver assemblato definitivamente l'infixo, vetri compresi, registrare le cerniere e bloccare l'elemento femmina della cerniera alla'anta con la spina $\varnothing 6$ in dotazione

TOOLING VALID ALSO FOR INTERMEDIATE/ADDITIONAL
HINGES

After cutting mullions and transoms for the wing and frame and carrying out the tooling with the corner brackets, drill the holes in the frame and wing profiles as indicated in the drawings. Use a $\varnothing 5.5$ drill bit.

Before assembling the frame and the wing, insert the reinforcements "A" - "B" and secure them with the screws provided.

Carry out the same procedures for the upper hinge and for any other mid positions.

Drill a hole in the AC1207I assembling bracket for the wing and thread the M5 holes.

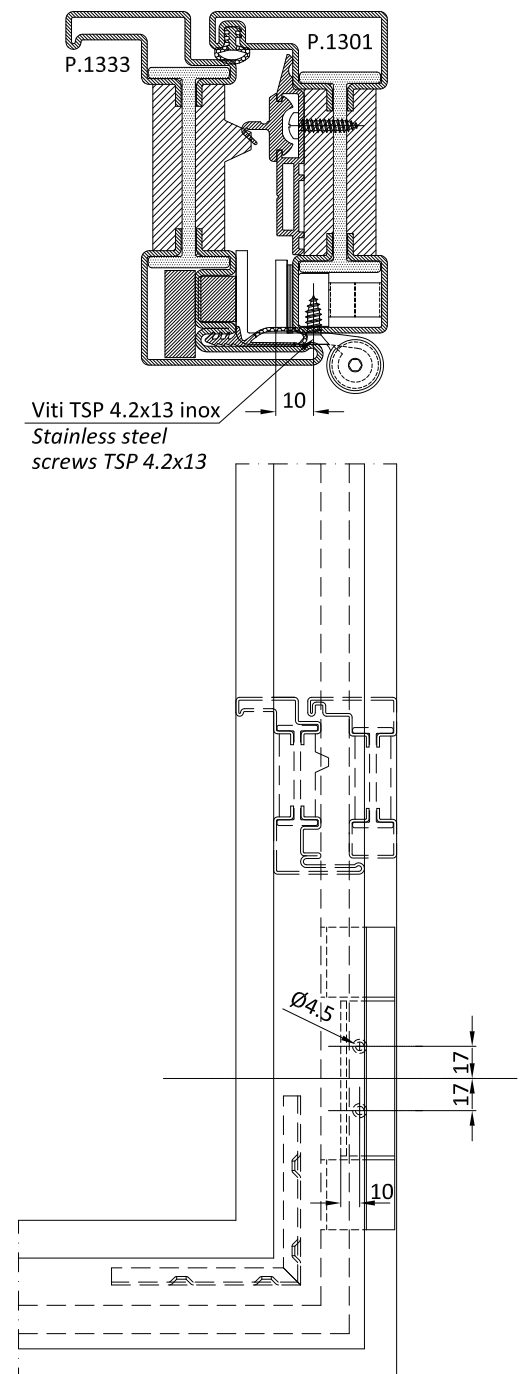
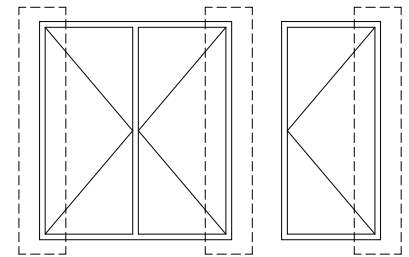
After assembling the door/window, glass included, adjust the hinges and secure the female element of the hinge to the wing with the $\varnothing 6$ pin provided.

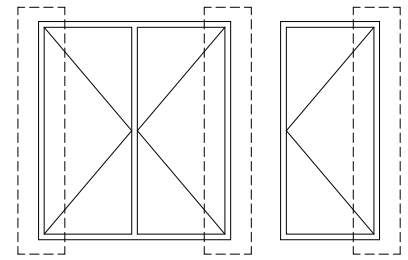
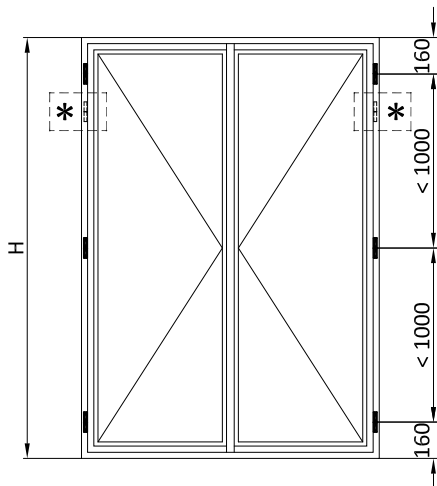
PER ANTE CON PESO SUPERIORE A 180 kg

Eseguire sulla cerniera due fori svasati $\varnothing 4,5$ dopo aver assemblato definitivamente l'infixo, vetri compresi, registrare le cerniere e bloccare con la spina $\varnothing 6$ in dotazione l'elemento femmina sull'anta e l'elemento maschio al telaio con due viti TPS 4,2x13

FOR WINGS HEAVIER THAN 180 kg

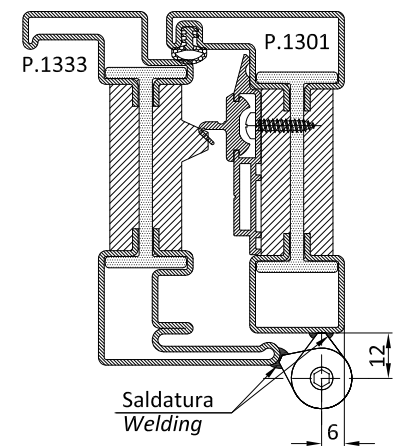
After assembling the door/window, glass included, drill 2 $\varnothing 4.5$ countersunk holes in the hinge; adjust the hinges and secure the female element of the hinge to the wing with the $\varnothing 6$ pin provided and the male element to the frame with 2 TPS 4.2x13 screws.



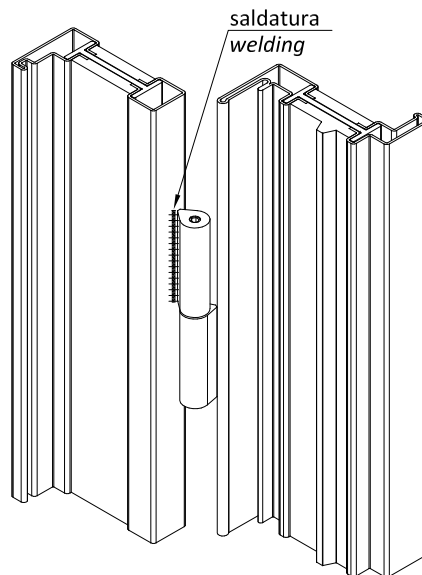
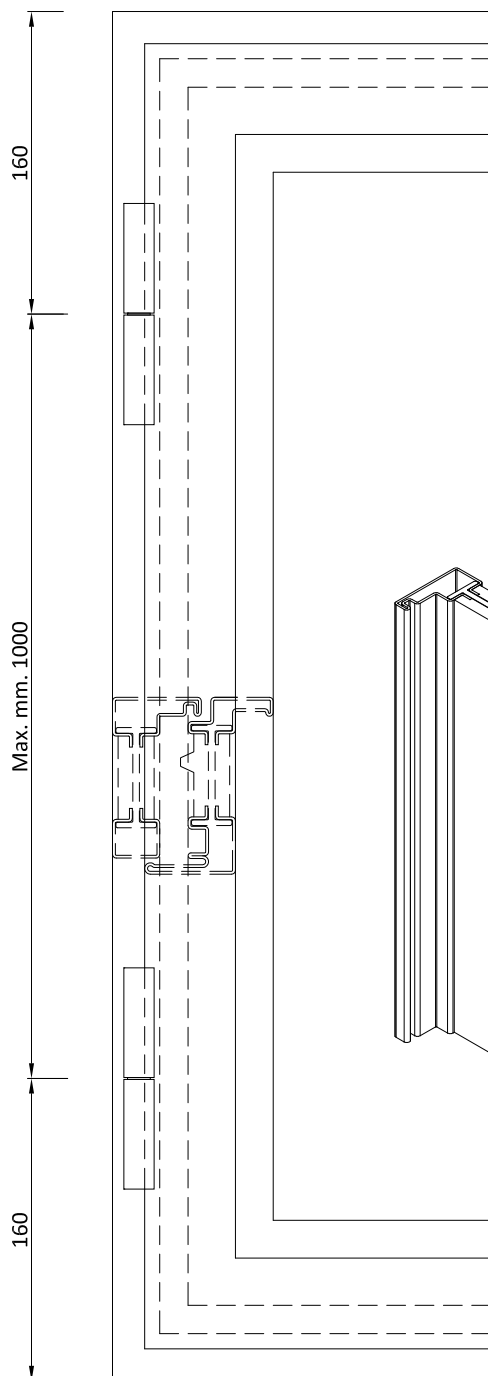


Peso max. per anta 80 Kg.
Max. weight for leaf: 80 kg.

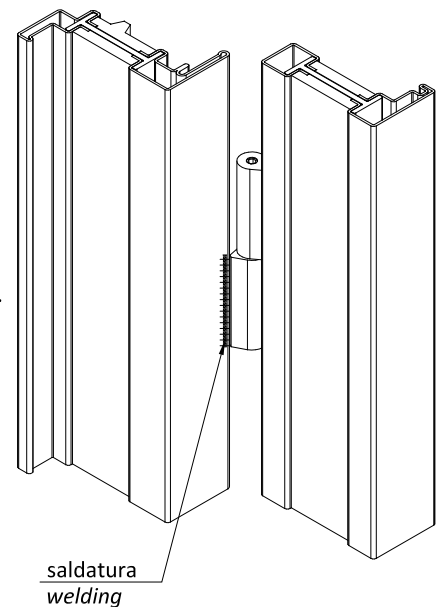
* Cerniera aggiuntiva per peso anta
> di 80 kg - peso max 100 kg.
Additional hinge for leaf weight > 80
kg - max weight 100 kg



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



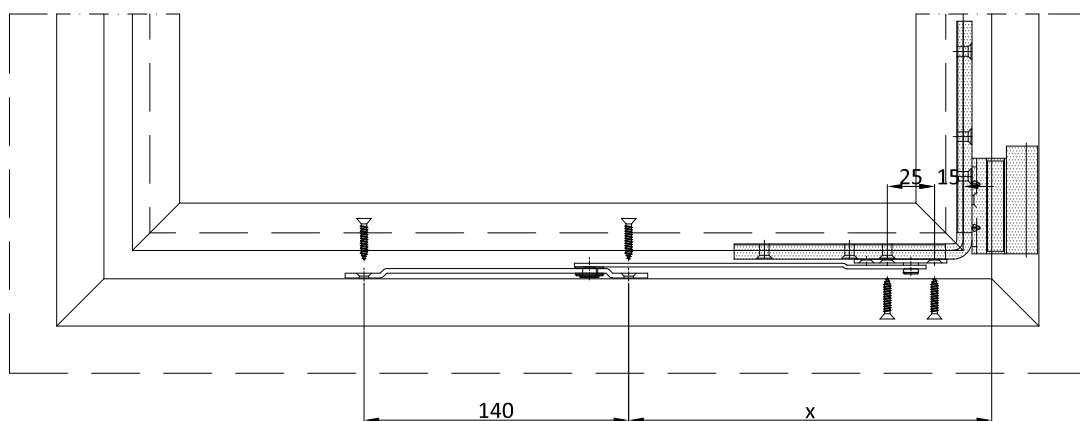
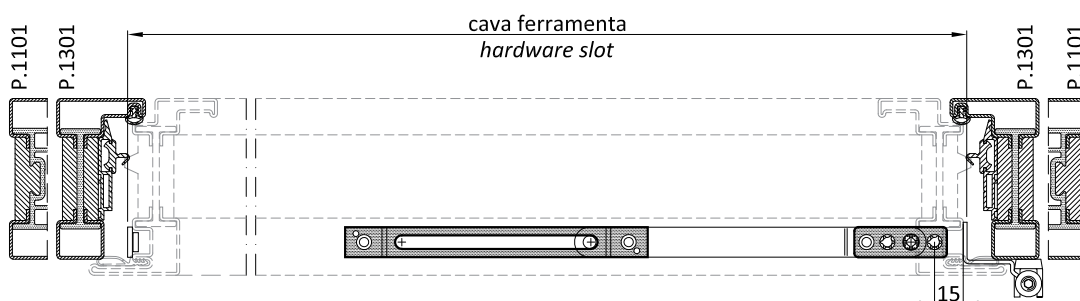
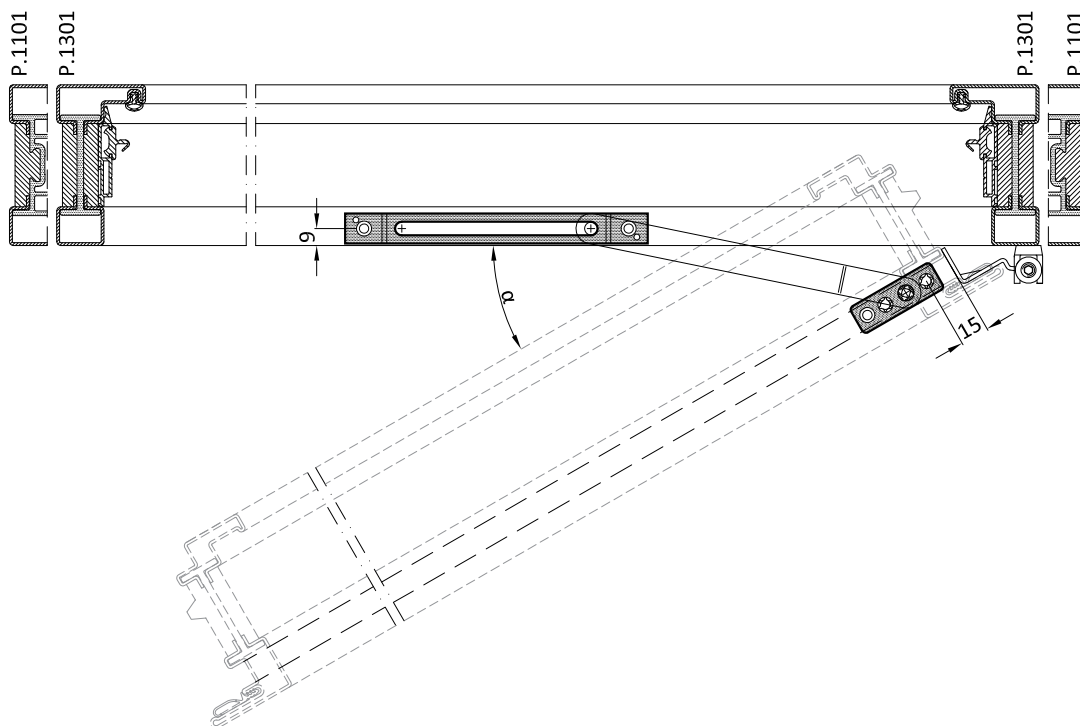
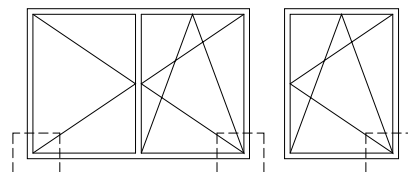
±2 mm.



- La lavorazione può essere effettuata anche in posizioni intermedie dell'altezza della finestra.
- La lavorazione SX è speculare alla DX.

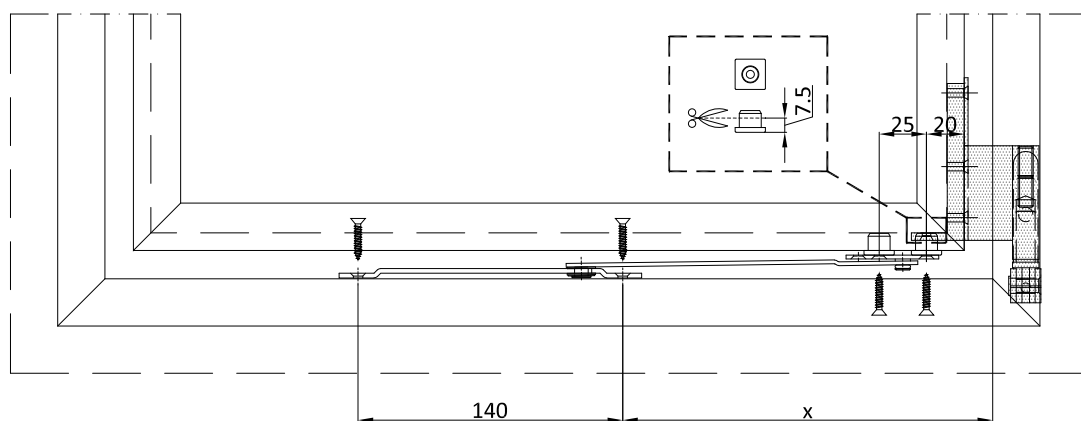
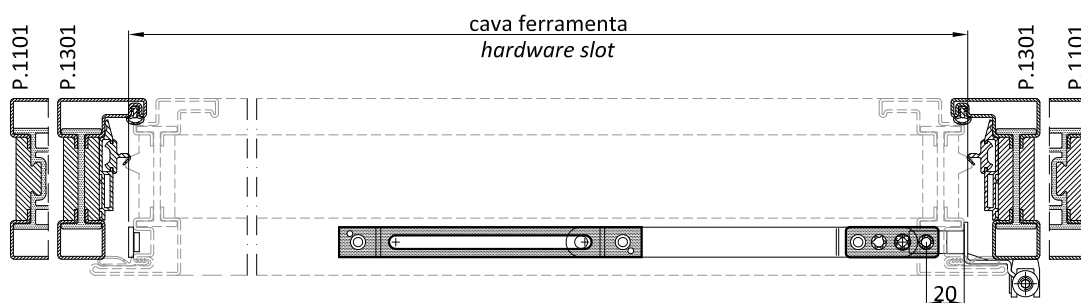
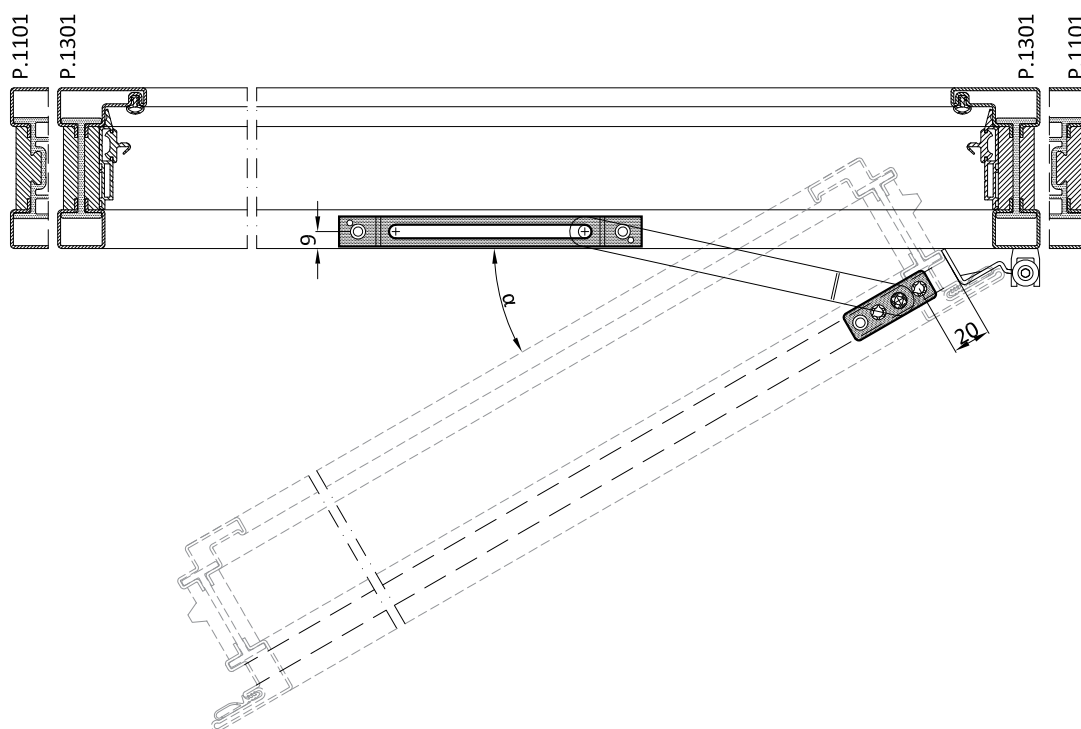
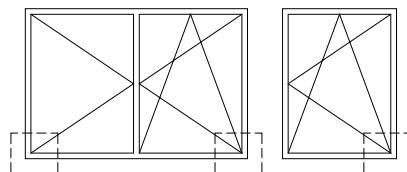
- Tooling can be carried out also in intermediate positions regarding the height of the window.
- Tooling on left is the same as that on the right.

α	x [mm]	min. cava ferramenta hardware slot min.	[mm]
30°	192	445	
45°	182.5	435	
90°	130	385	
100°	117.5	370	



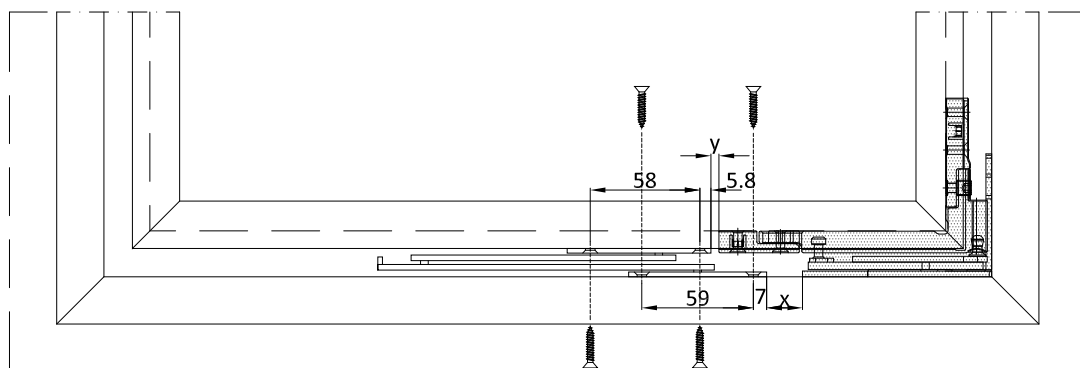
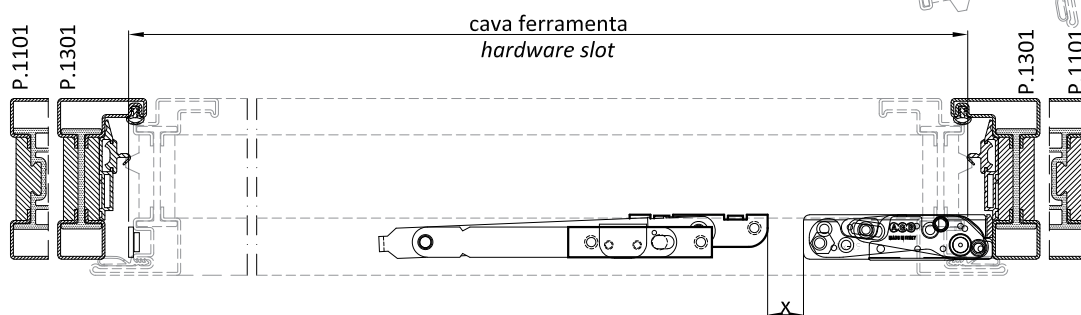
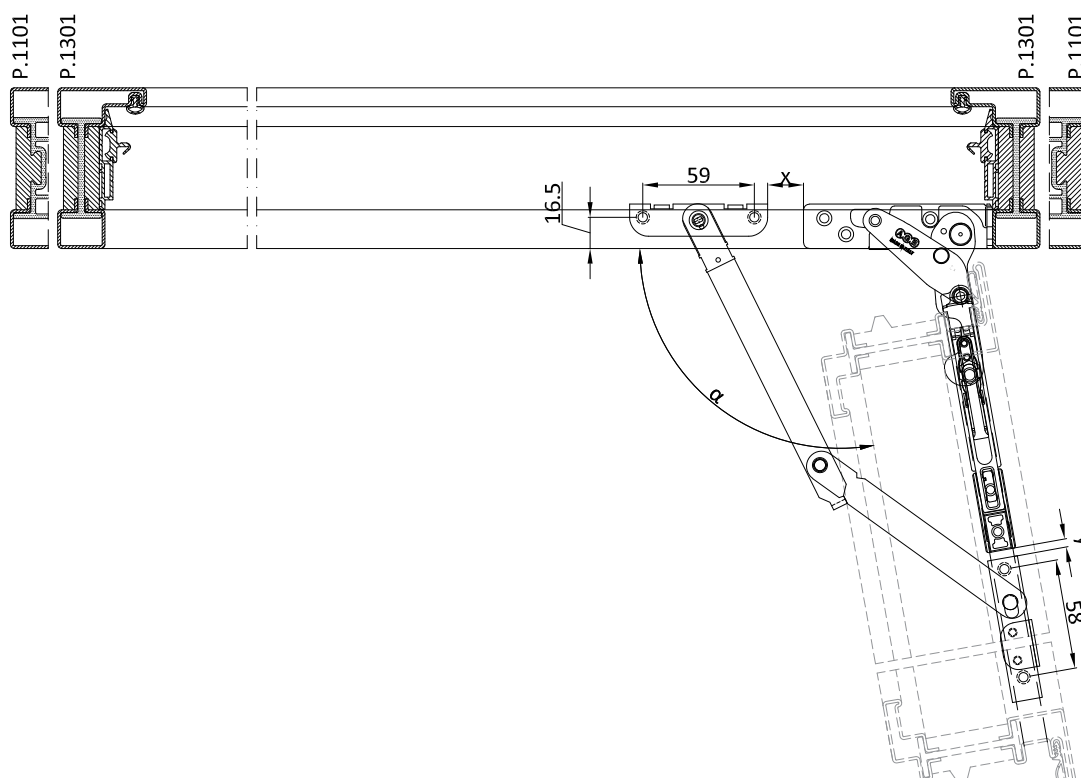
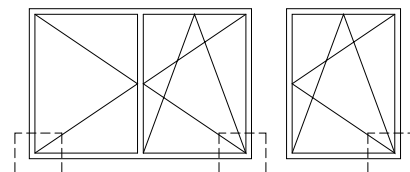
non installabile su kit AG1271-2-5-6
not possible to install on kit AG1271-2-5-6

α	x [mm]	min. cava ferramenta hardware slot min.	[mm]
30°	196	450	
45°	186	440	
90°	130.5	380	
100°	117.5	370	



non installabile su kit AG1291-2-5-6
not possible to install on kit AG1291-2-5-6

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

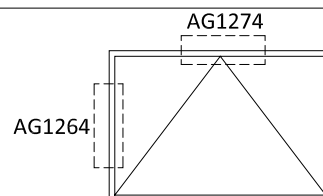


non installabile su kit AG1281-2-5-6
not possible to install on kit AG1281-2-5-6

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

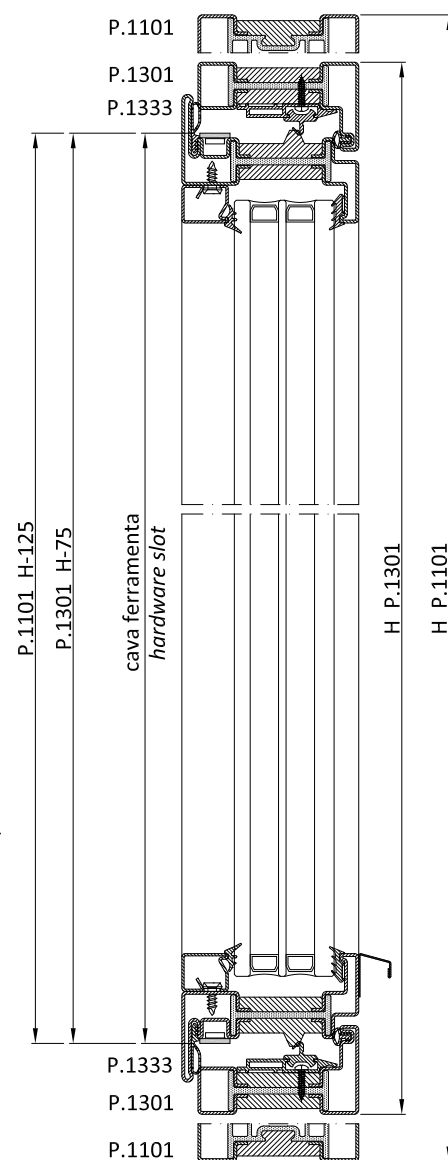
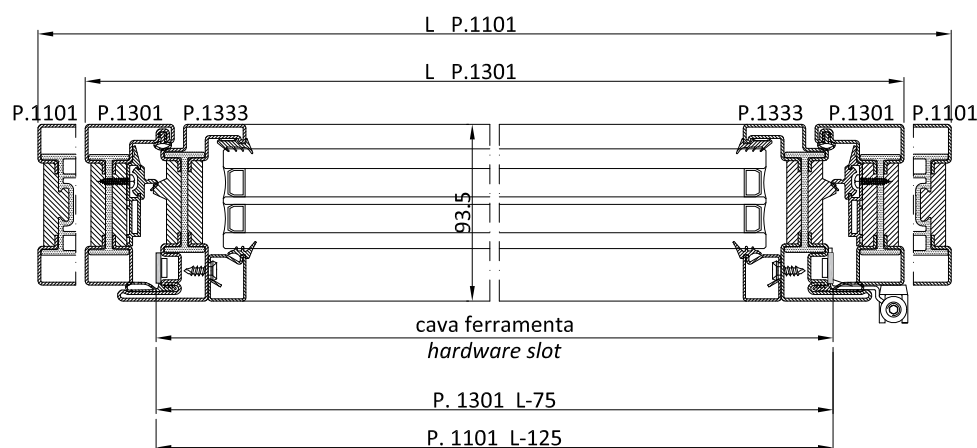
Specificare all'ordine misure cava ferramenta
Specify hardware slot size

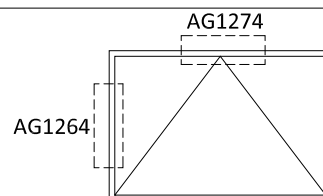
	AG1274	H altezza - Height			
		350 660	661 860	861 1200	1201 1400
L W larghezza width	560-660	A1	B1	C1	D1
	661-860	A2	B2	C2	D2
	861-1200	A3	B3	C3	D3
	1201-1600	A4	B4	C4	D4



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

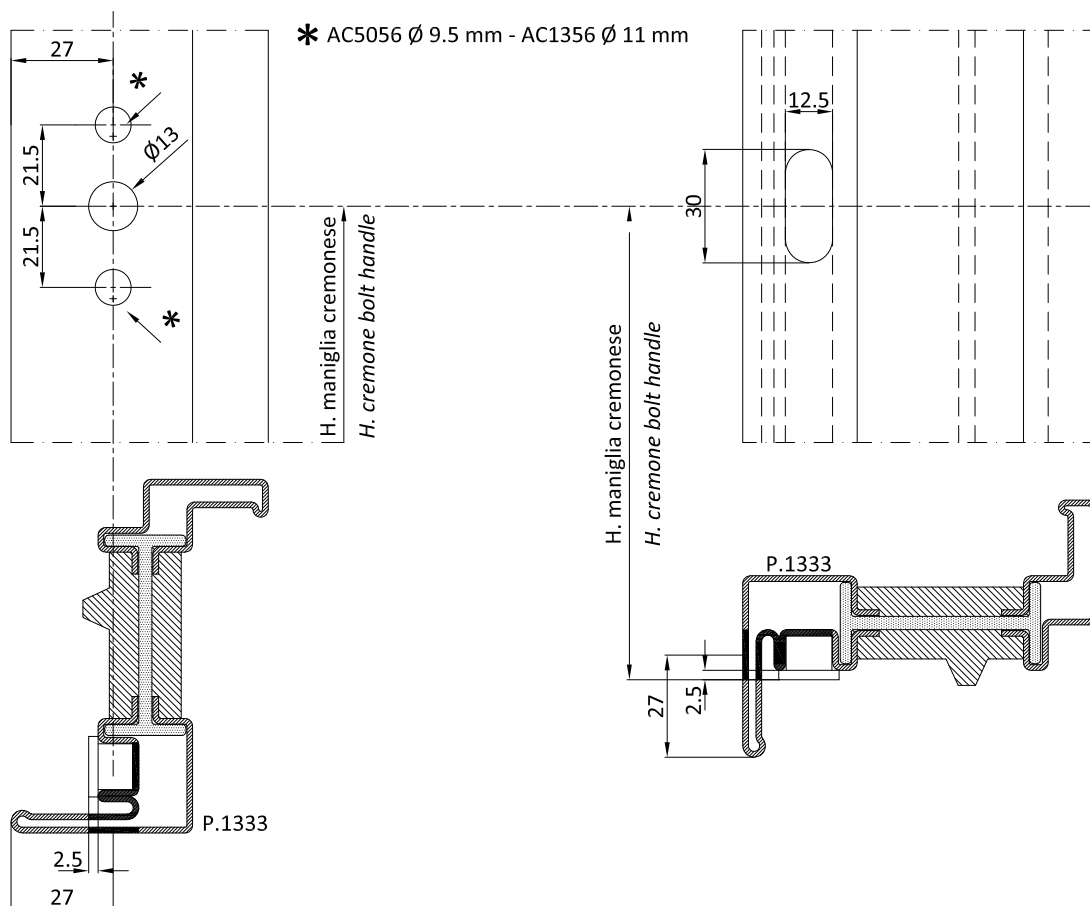
2 hinges - maximum leaf weight 70 kg
3 hinges - maximum leaf weight 100 kg





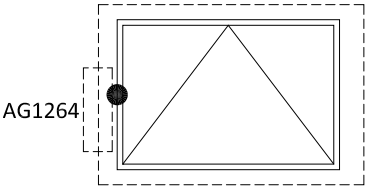
Fori per inserimento quadro comando
e fissaggio maniglia / movimento DK
holes for inserting control panel and
anchoring of handle / TT (tilt and turn)
movement

Asola per inserimento meccanismo
cremonese
Slot for insertion of cremone
mechanism



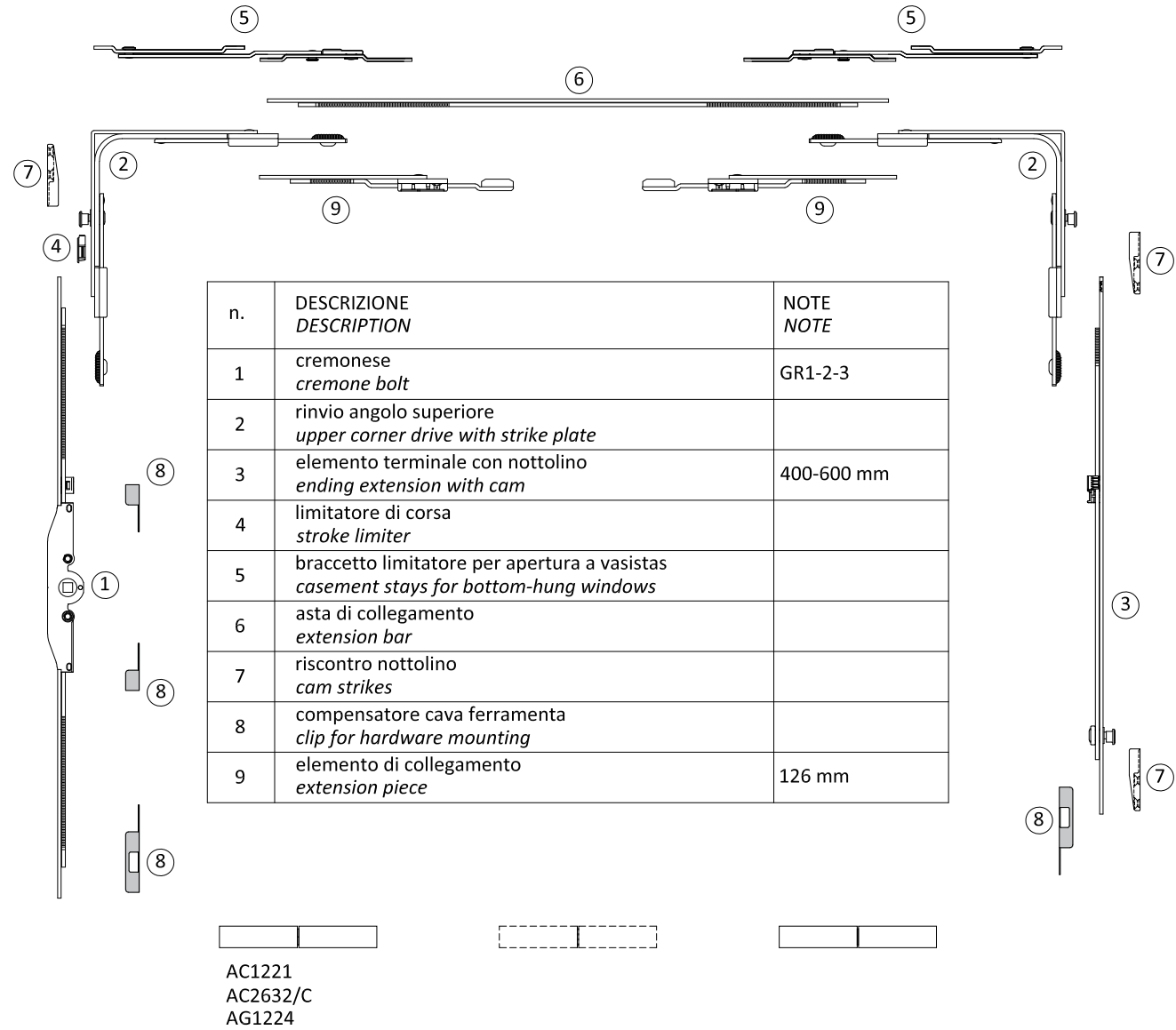
AG1264 ALTEZZA MANIGLIA CREMONESE - CREMONE BOLT HANDLE HEIGHT		
Tipo Type	cava ferramenta hardware slot	H maniglia cremone H cremone bolt handle
Vasistas Bottom-hung	560 → 660	H/2
	661 → 860	H/2
	861 → 1200	H/2
	1201 → 1600	H/2

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



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

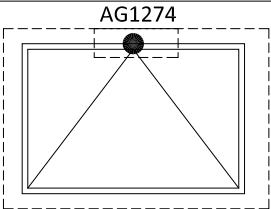
2 hinges - maximum leaf weight 70 kg
3 hinges - maximum leaf weight 100 kg



cerniere non incluse nel kit
hinges not included in the kit

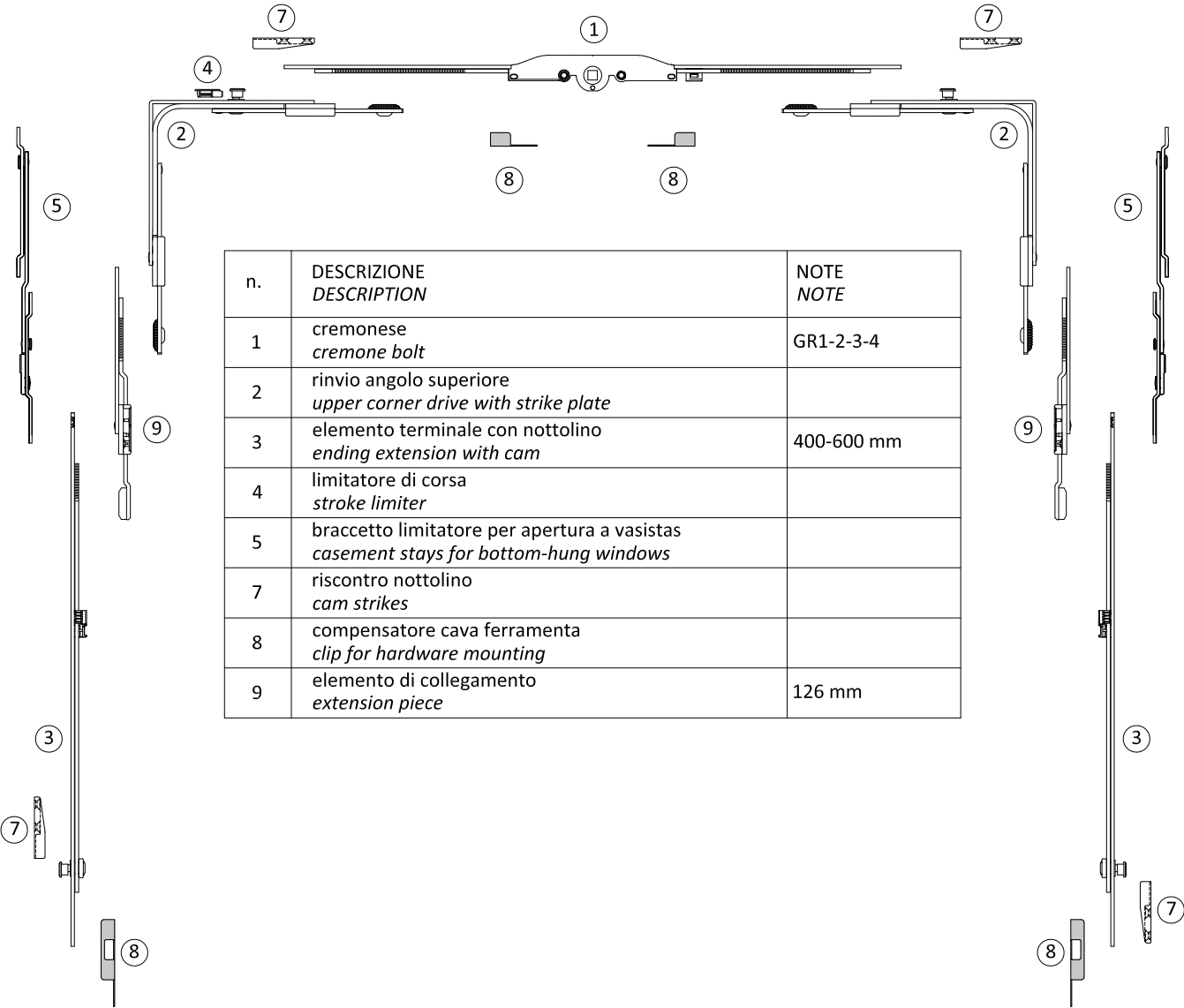
Specificare all'ordine misure cava ferramenta
Specify hardware slot size





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

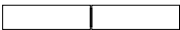
2 hinges - maximum leaf weight 70 kg
3 hinges - maximum leaf weight 100 kg



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

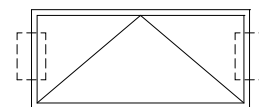
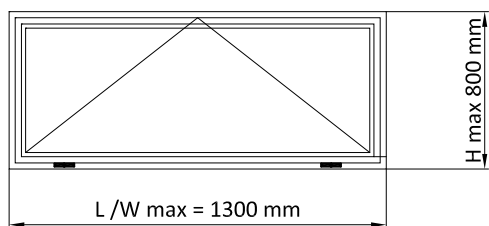


AC1221
AC2632/C
AG1224

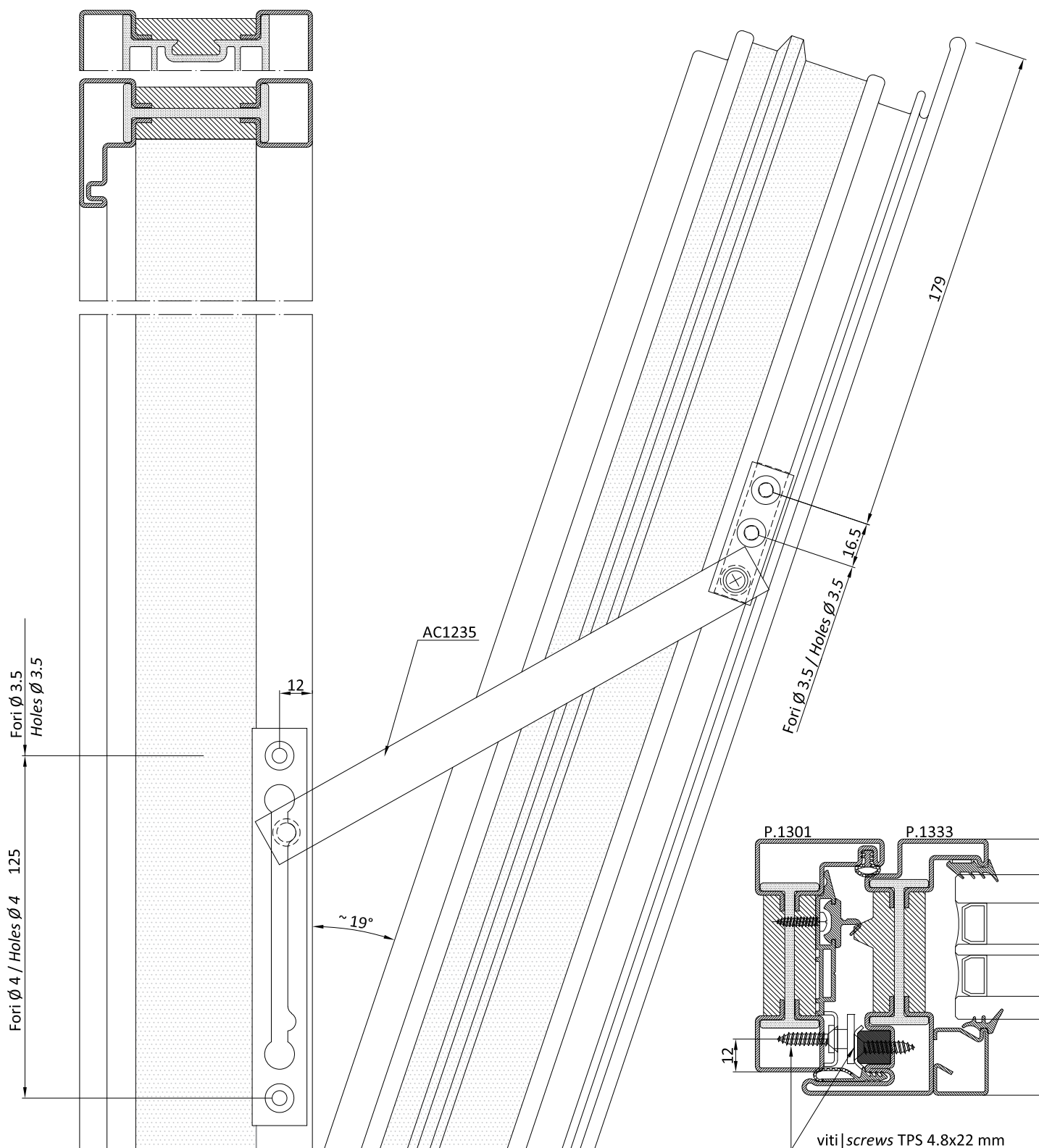


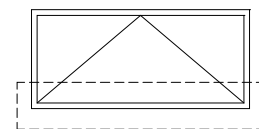
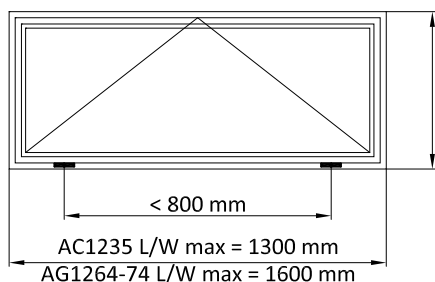
cerniere non incluse nel kit
hinges not included in the kit





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



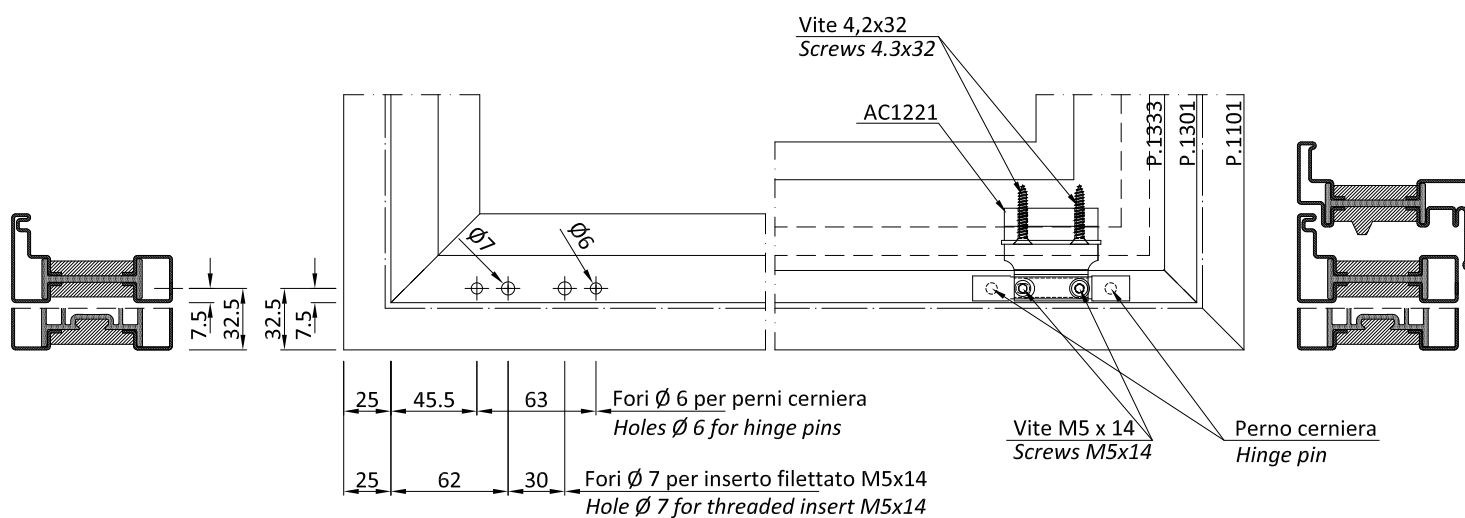
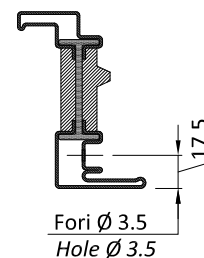
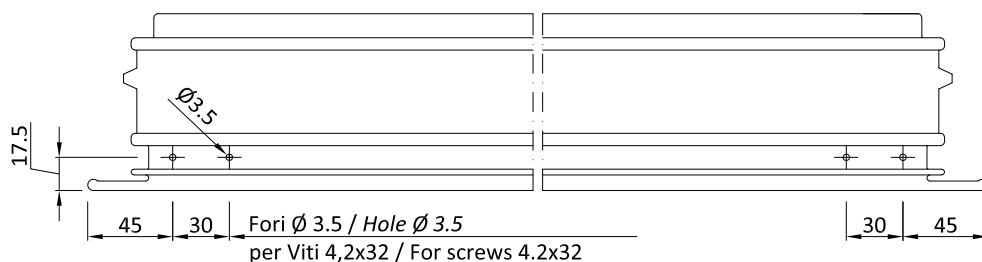
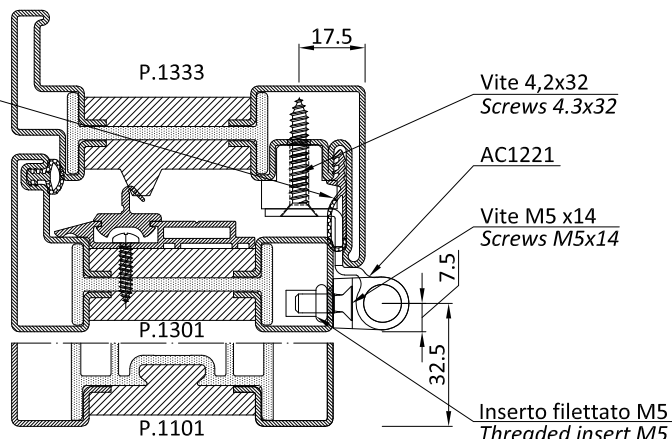


AC1235
Peso max. per anta 70 kg
Max. weight for leaf: 70 kg

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

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

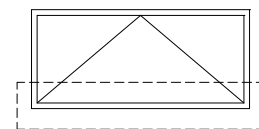
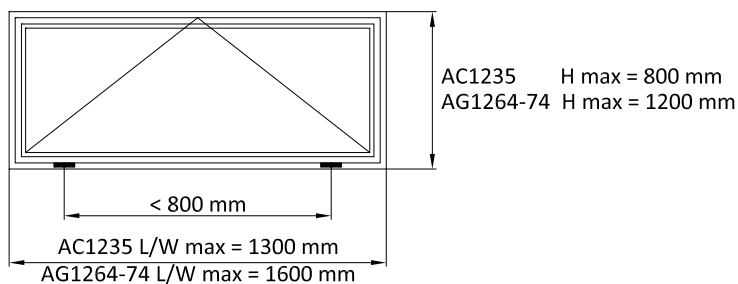
GE1200TT - tagliare la guarnizione
dove interseca le cerniere
GE1200TT - cut the gasket where
the hinges cross



Viti non fornite
Screws not supplied



Applicazione cerniere AC1221
AC1221 hinge installation

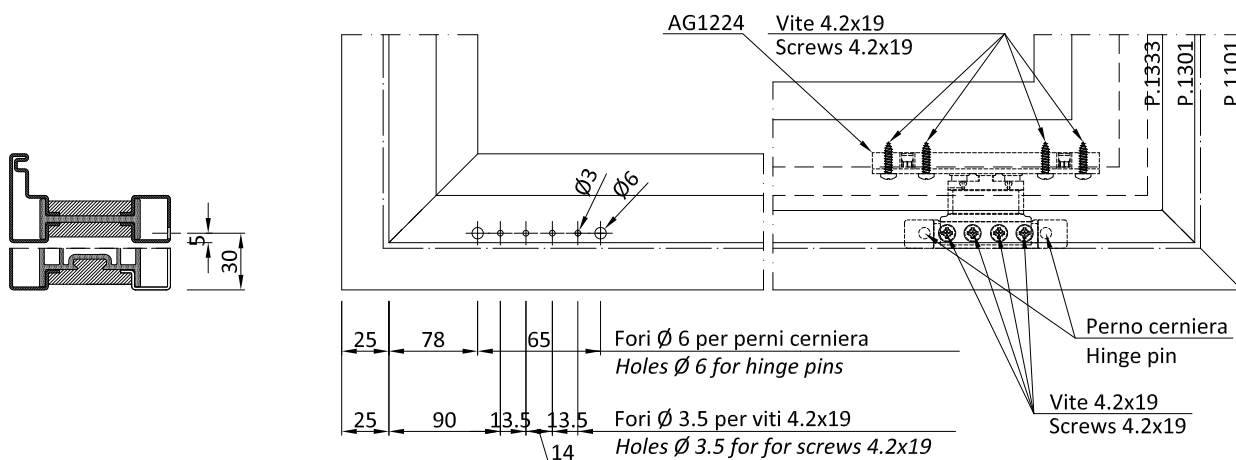
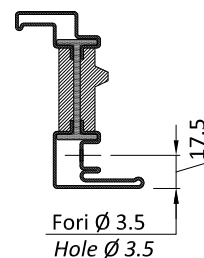
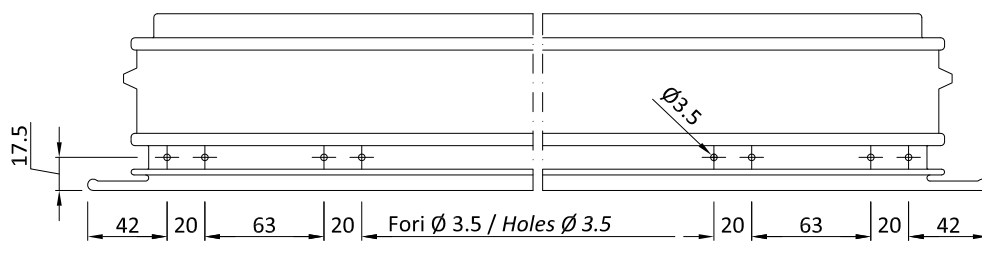
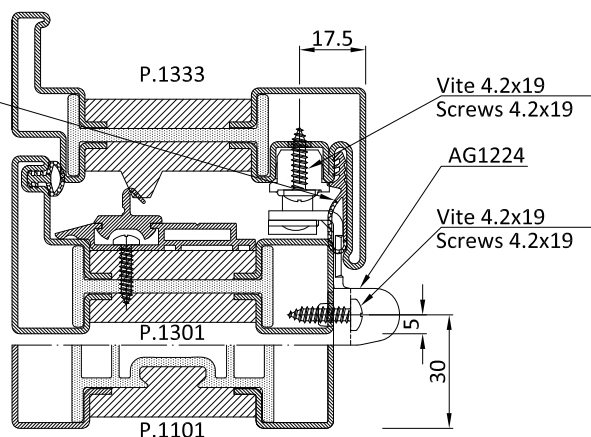


AC1235
Peso max. per anta 70 kg
Max. weight for leaf: 70 kg

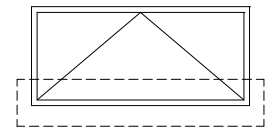
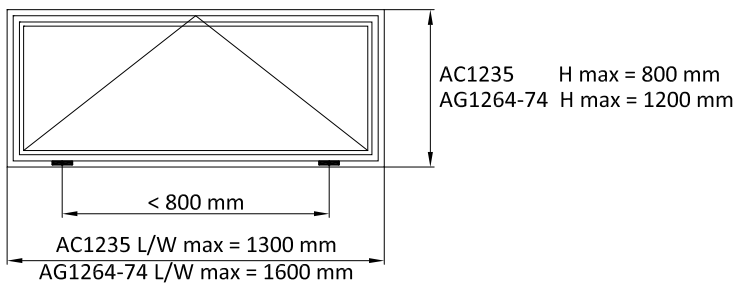
AG1264 - AG1274
2 cerniere
peso massimo anta 70 kg
3 cerniere
peso massimo anta 100 kg

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

GE1200TT - tagliare la guarnizione
dove interseca le cerniere
GE1200TT - cut the gasket where
the hinges cross



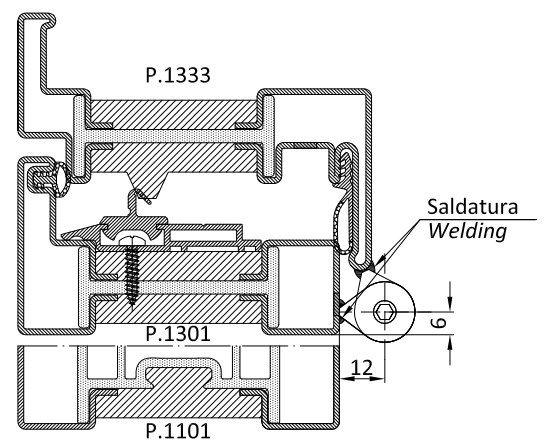
Viti non fornite
Screws not supplied



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

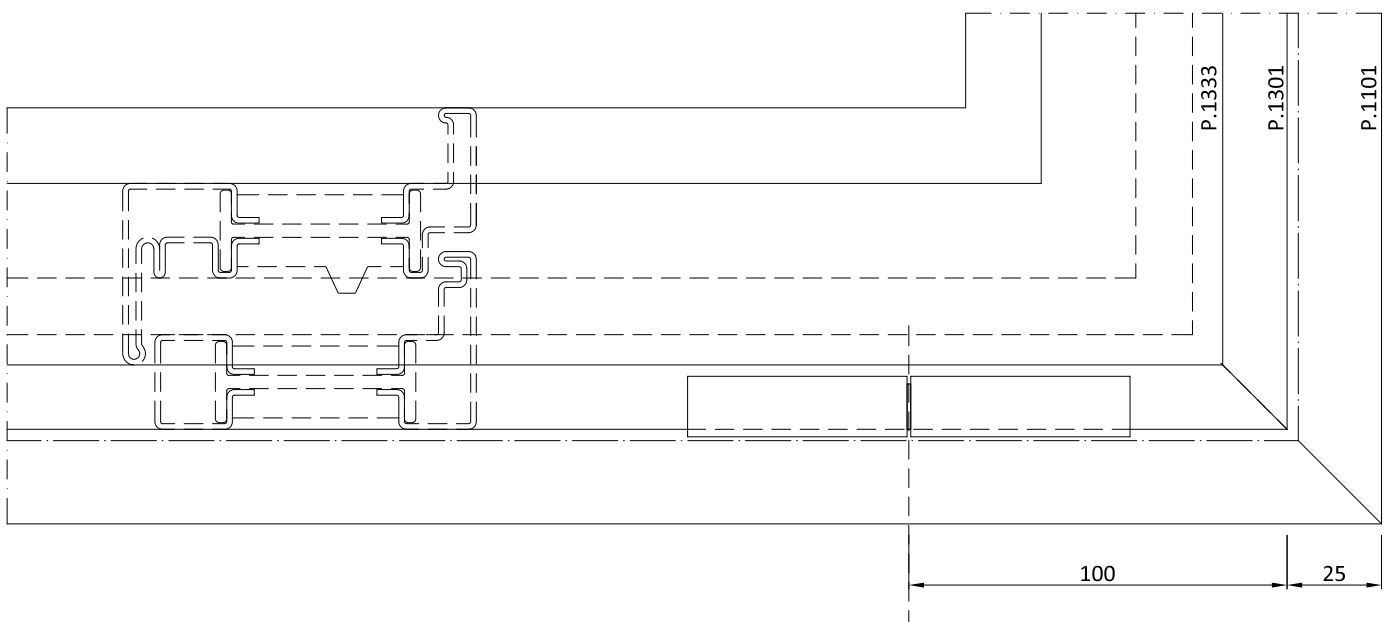
AG1264 - AG1274
2 cerniere
peso massimo anta 70 kg
3 cerniere
peso massimo anta 100 kg

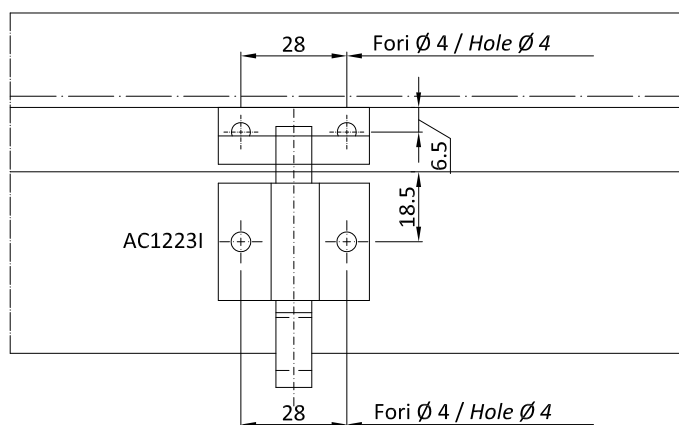
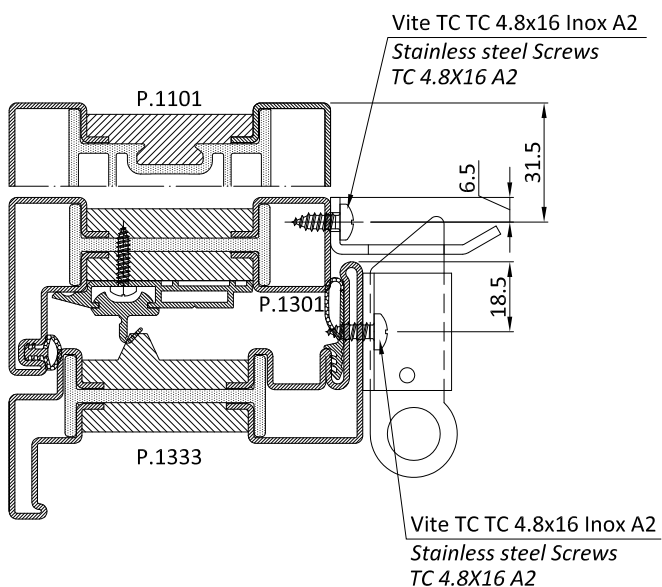
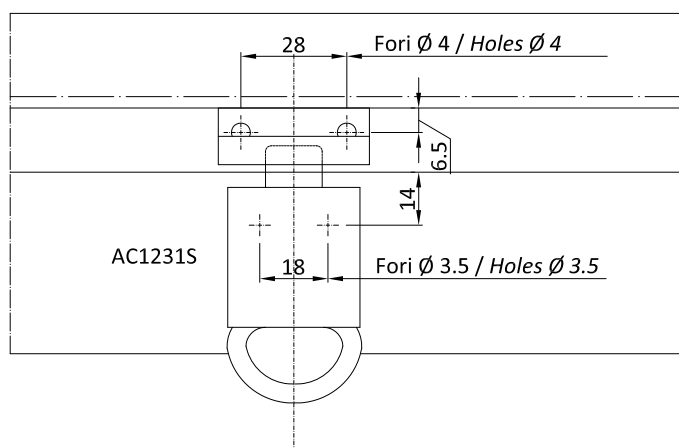
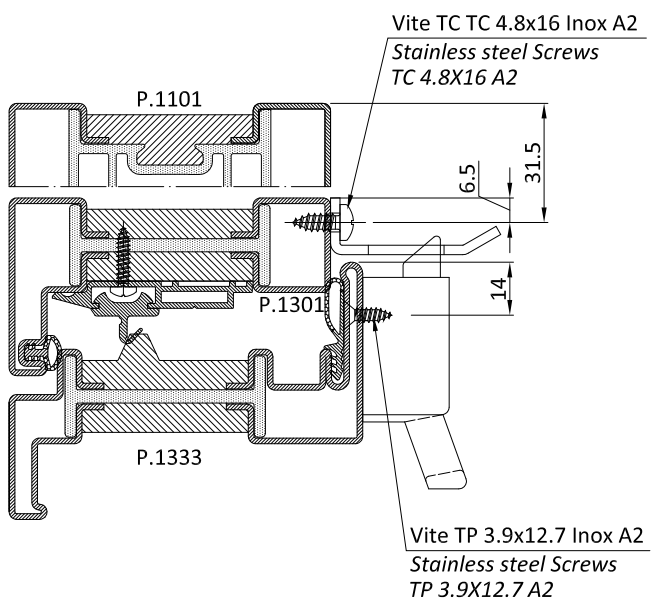
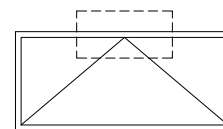
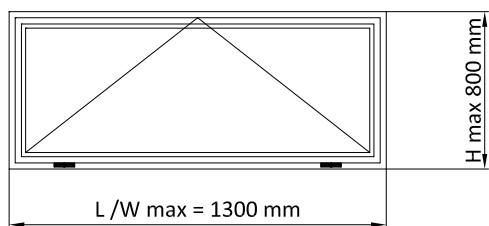
2 hinges
maximum leaf weight 70 kg
3 hinges
maximum leaf weight 100 kg

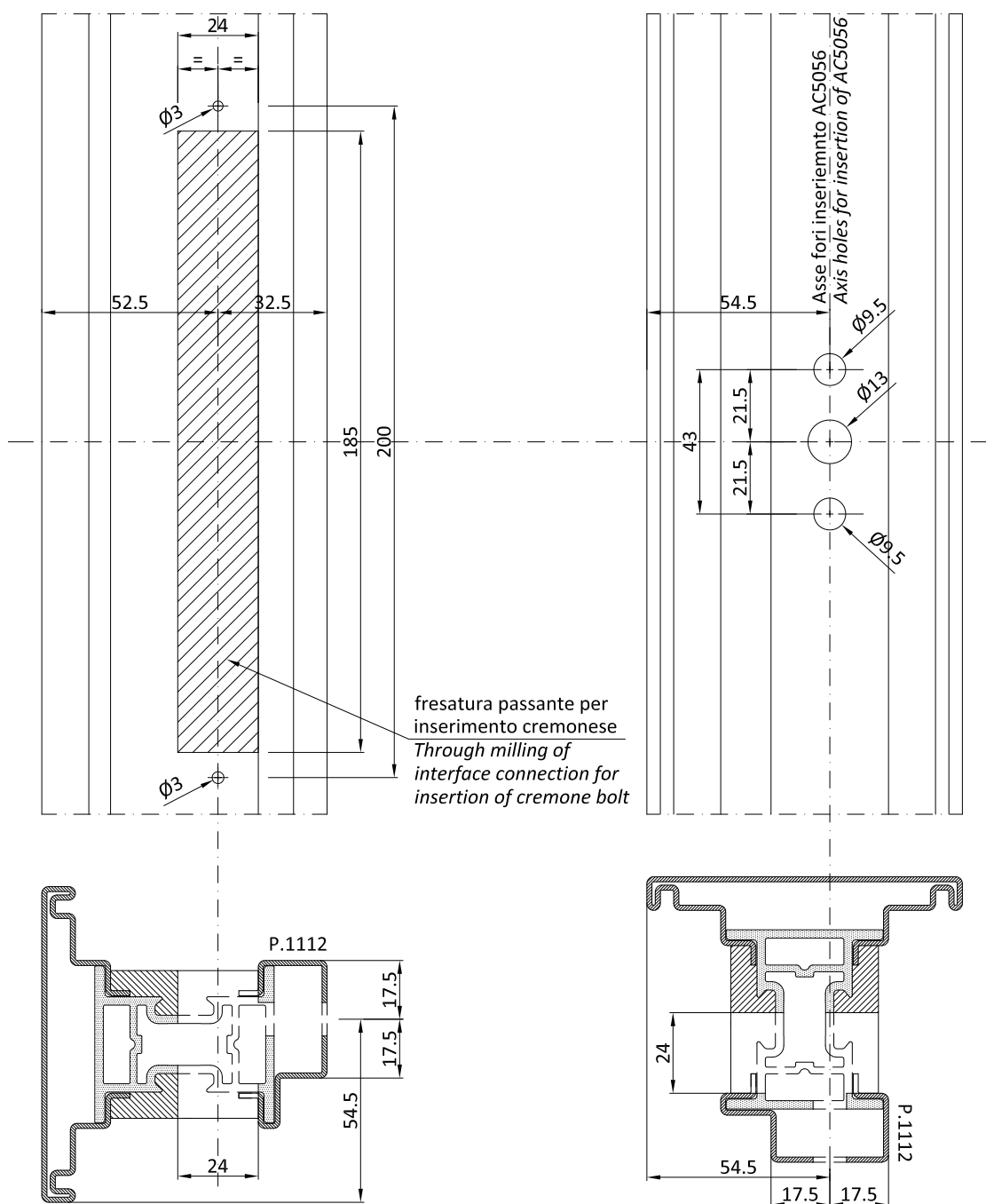
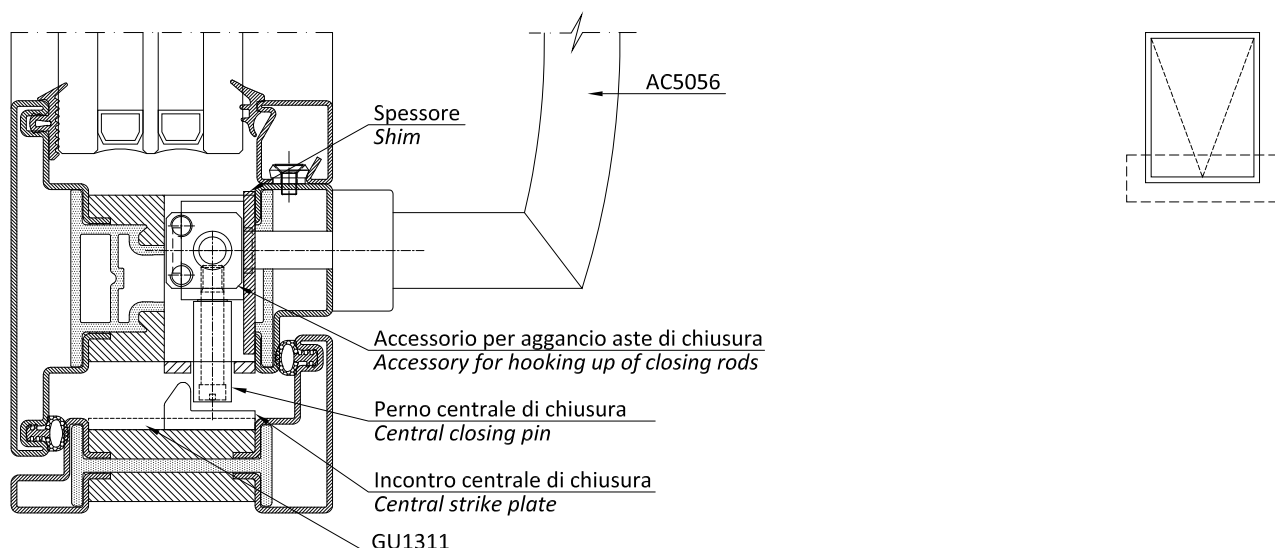


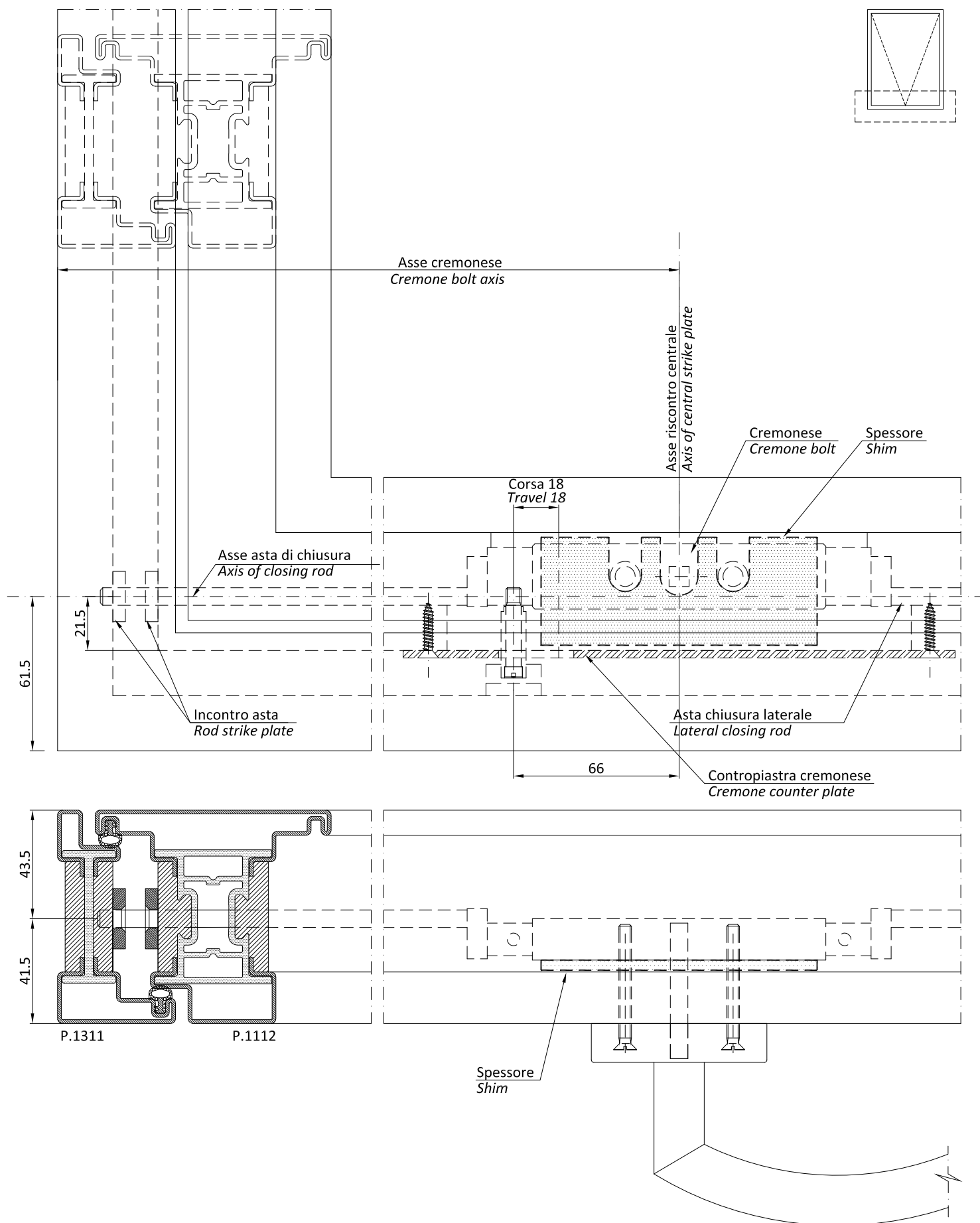
Posizionare le cerniere come da disegno saldandole sui lati.
Position the hinges as in the drawing, welding them on the sides.

- La lavorazione può essere effettuata anche in posizioni intermedie alla larghezza del vasistas.
- La lavorazione SX è speculare alla DX.
- Tooling can be carried out also in intermediate positions regarding the width of the hopper or bottom-hung window.
- Tooling on left is the same as that on the right.

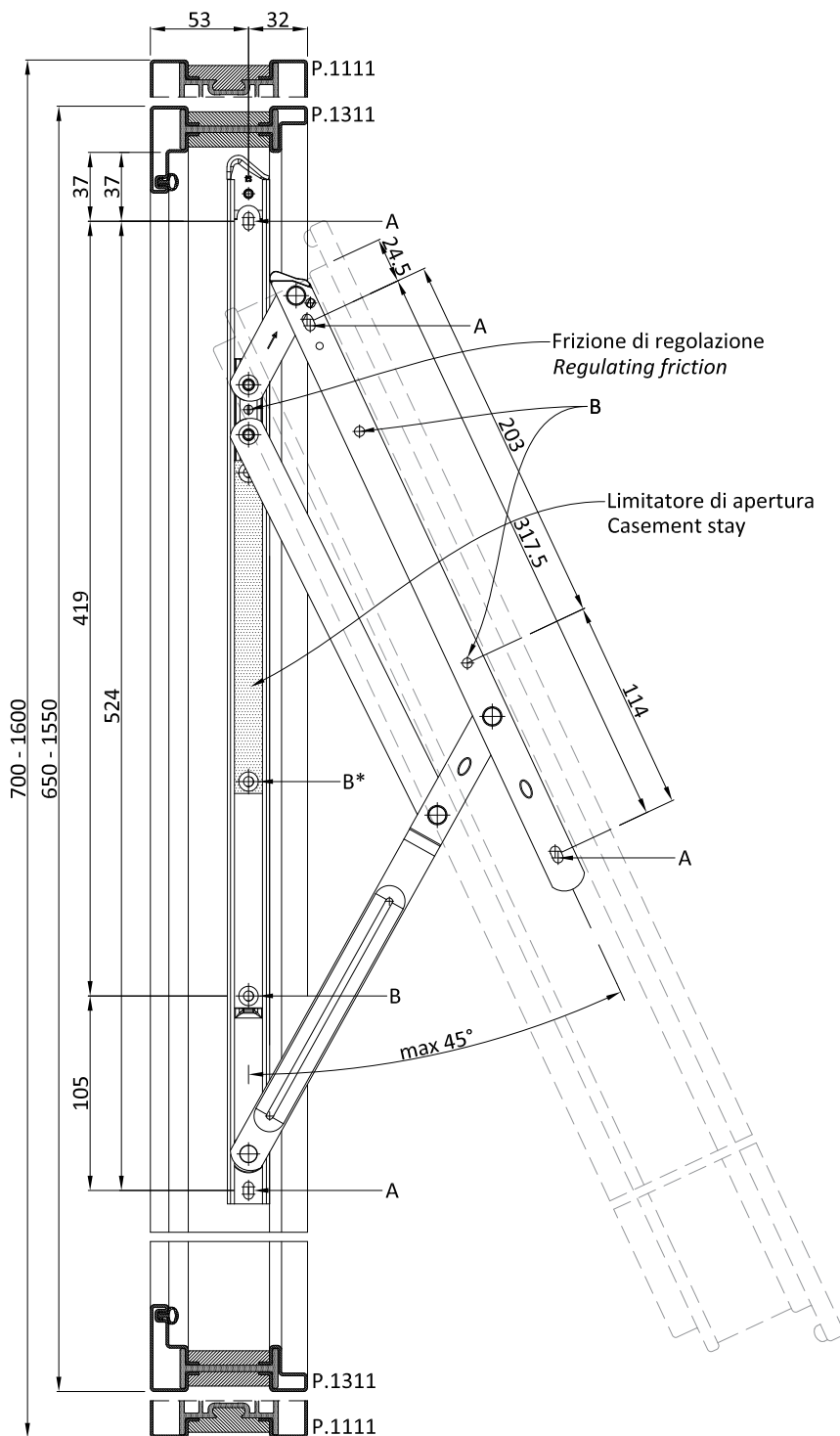
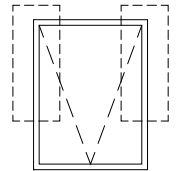








Peso massimo anta 75 kg
Maximum vent weight 75 kg

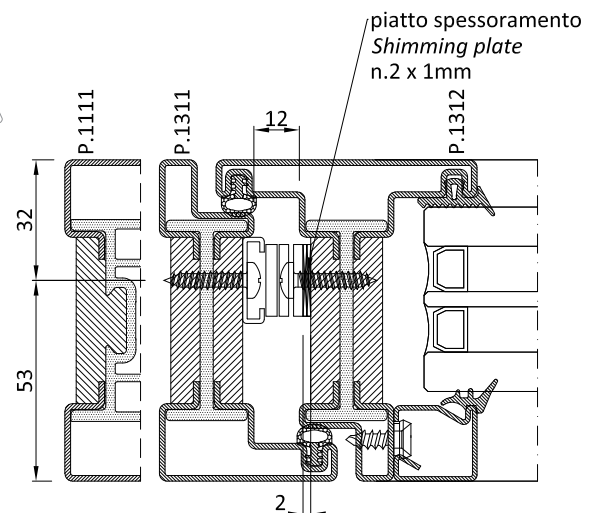


- Fissare i compassi in corrispondenza dei fori asolati A foro su profilo Ø 4 per viti TC 4.8x22 mm;
- Verificare il funzionamento dei compassi;
- Fissare l'apertura massima desiderata mediante il limitatore di apertura;
- Completare l'operazione di fissaggio nei rimanenti fori B.

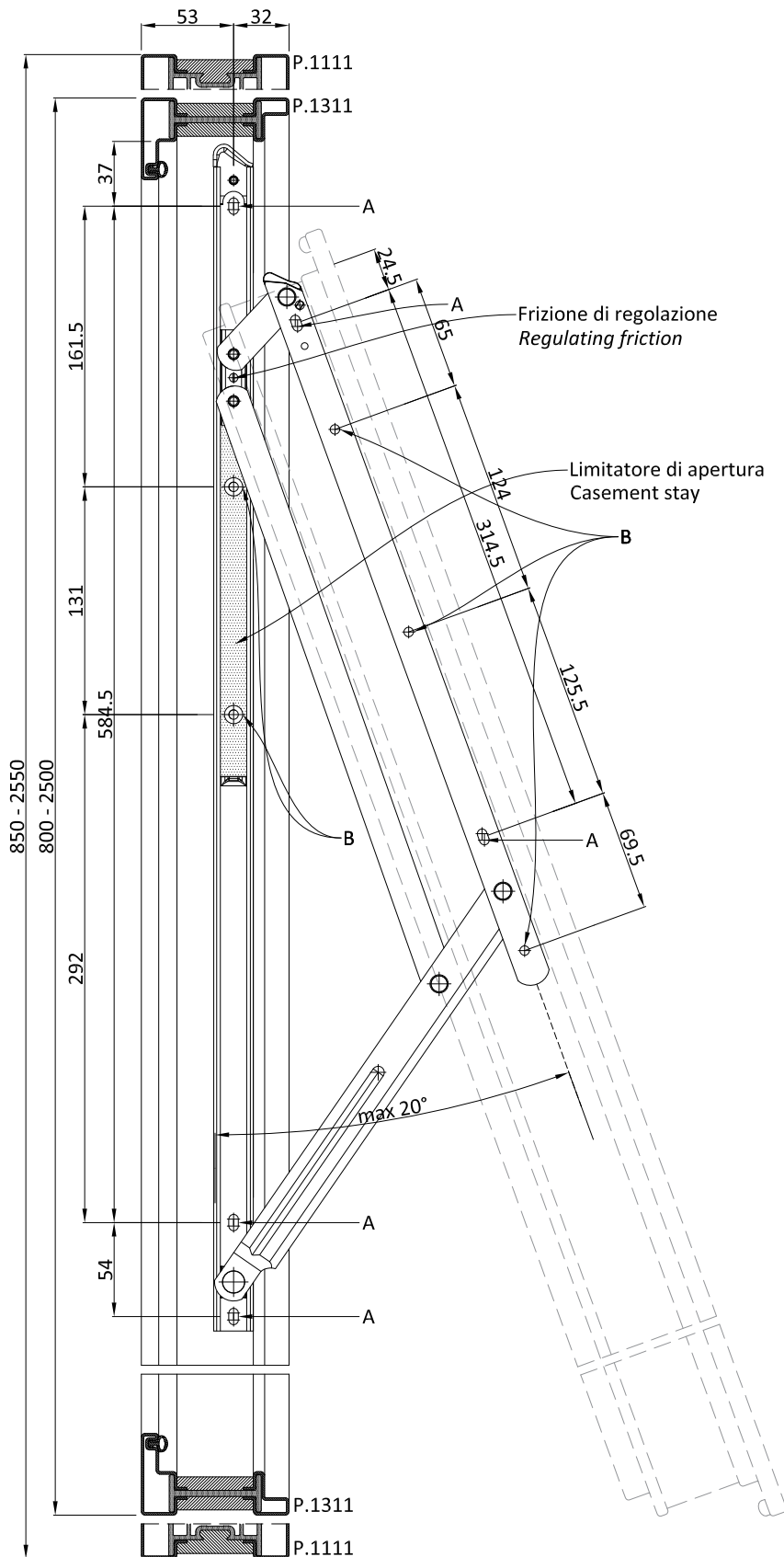
* posizione determinata dalla apertura massima desiderata - foro da eseguire in opera

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

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



Peso massimo anta 120 kg
Maximum vent weight 120 kg

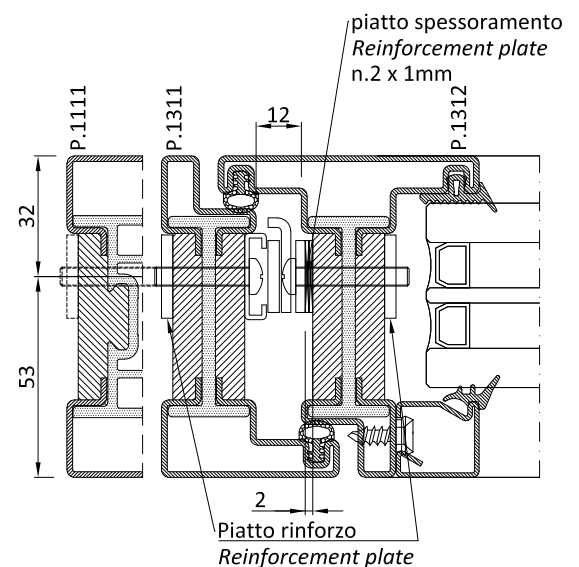


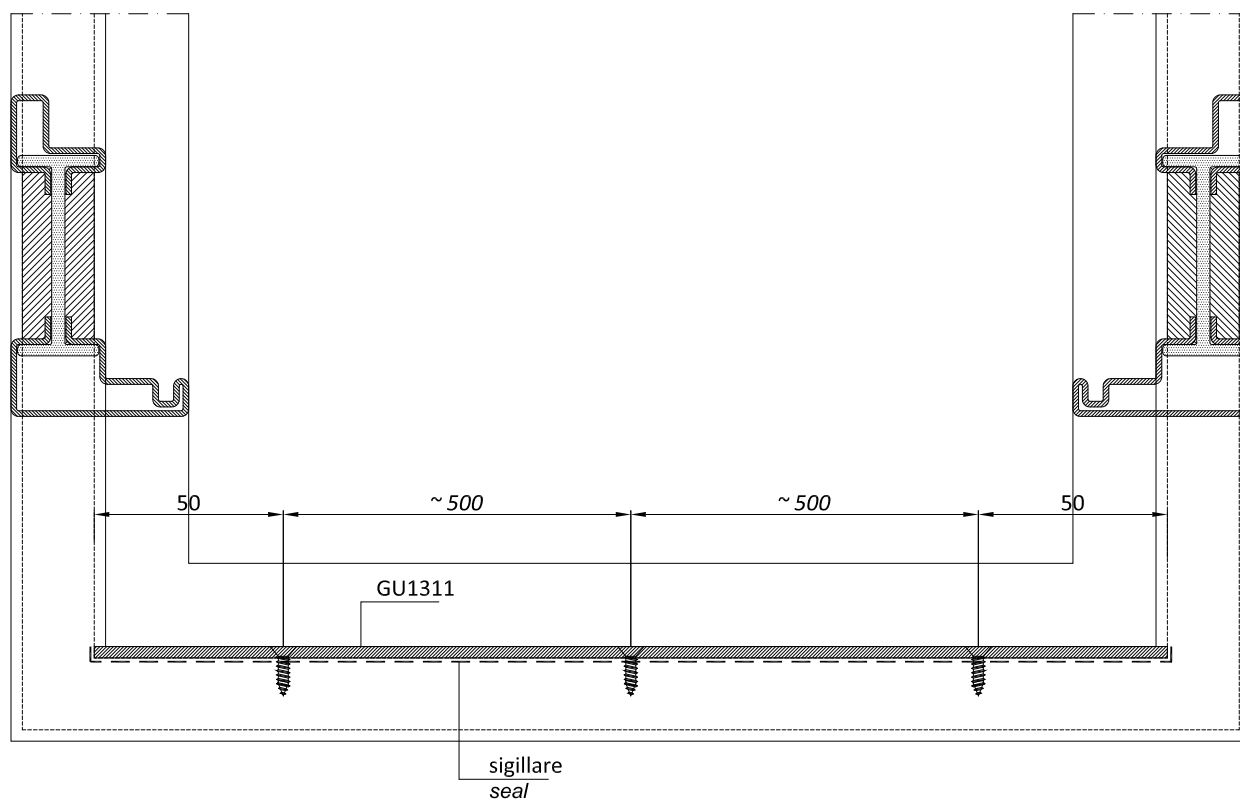
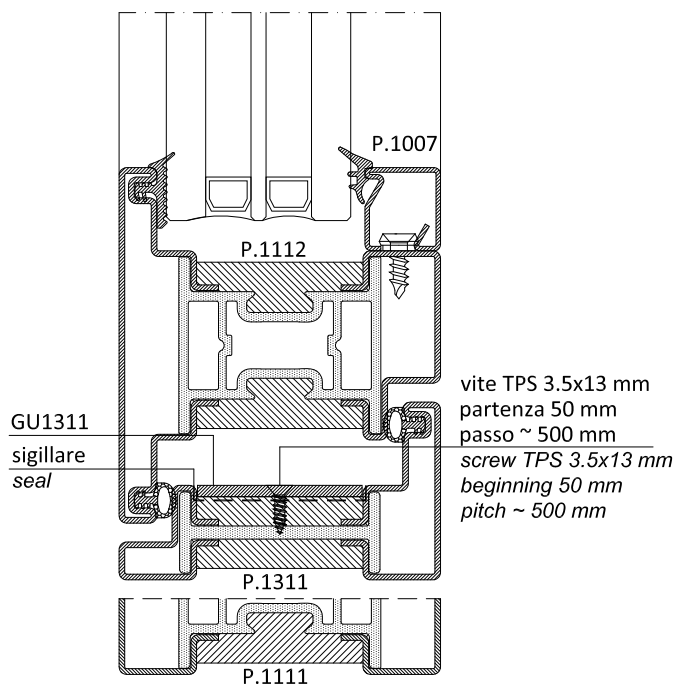
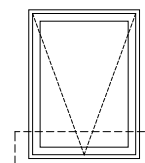
- Fissare i compassi in corrispondenza dei fori asolati A foro su profilo Ø 4 per viti TC 4.8x22 mm;
- Verificare il funzionamento dei compassi;
- Fissare l'apertura massima desiderata mediante il limitatore di apertura;
- Completare l'operazione di fissaggio nei rimanenti fori B.

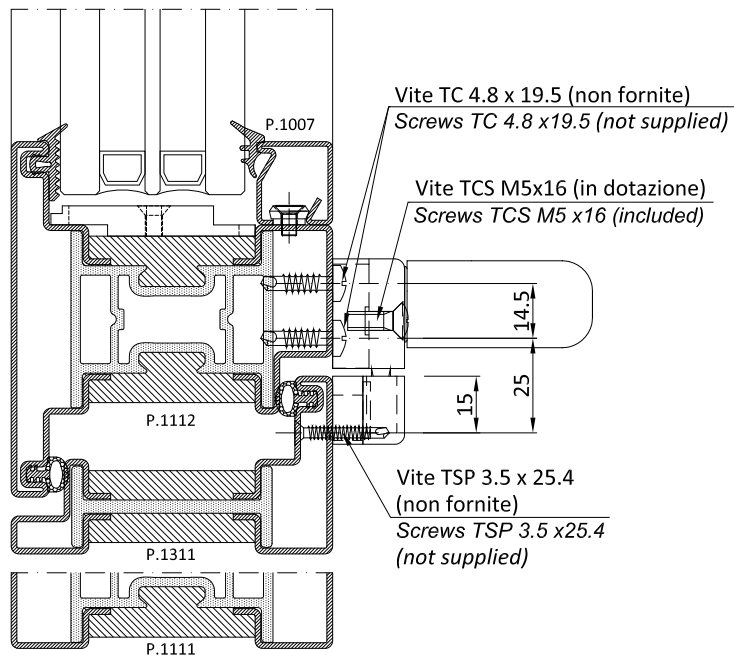
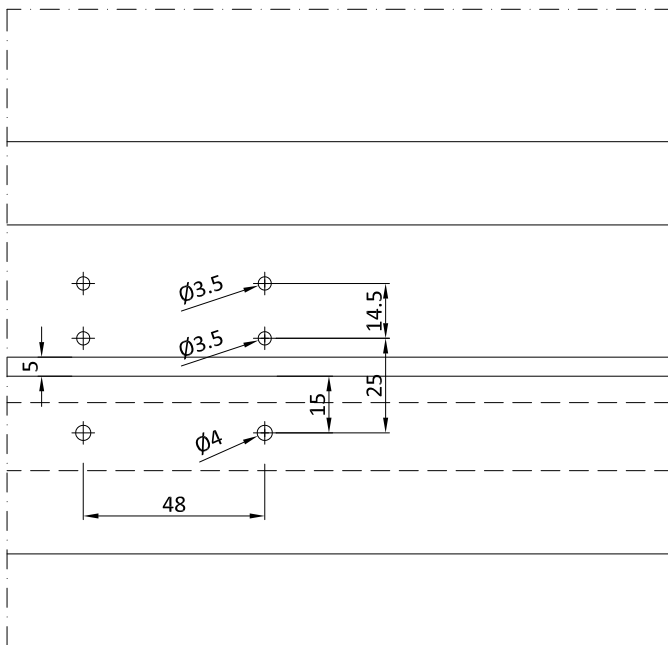
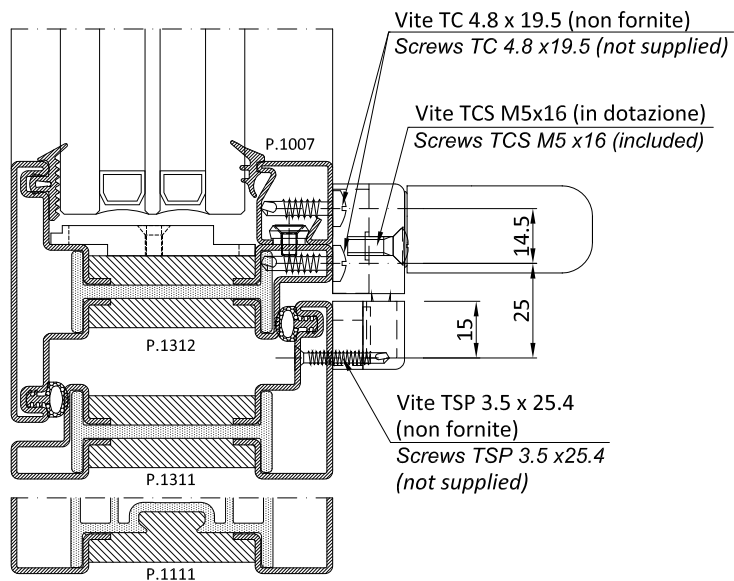
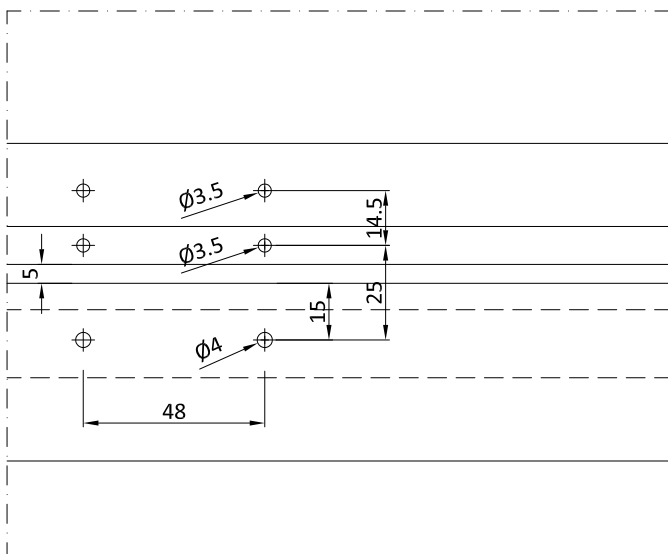
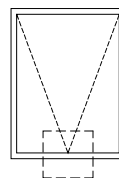
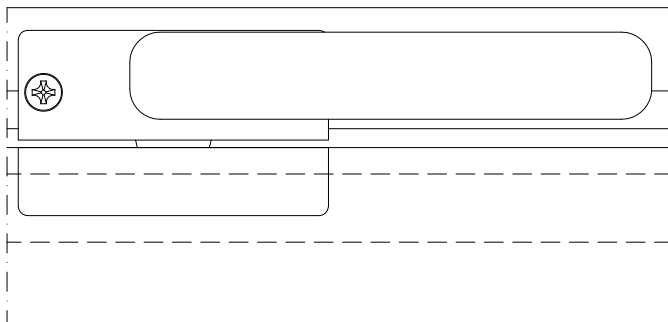
* posizione determinata dalla apertura massima desiderata - foro da eseguire in opera

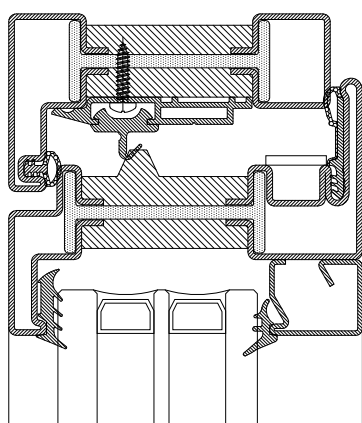
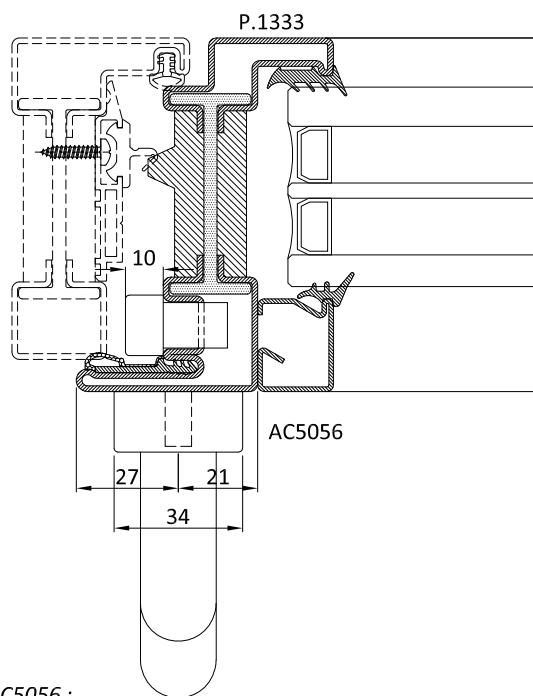
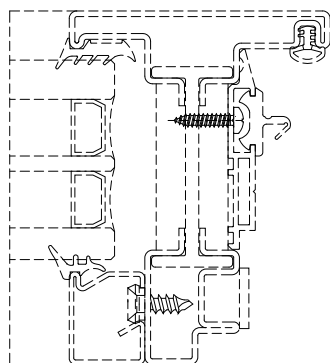
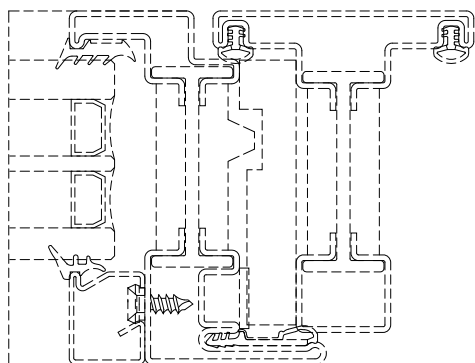
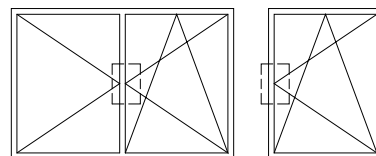
- Fit the side arms into the slotted holes A - hole on profile Ø 4 for TC 4.8x22 mm screws;
- Check the side arms move properly;
- Set the desired maximum opening using the casement stay;
- Complete the anchoring operation in the remaining B holes.

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







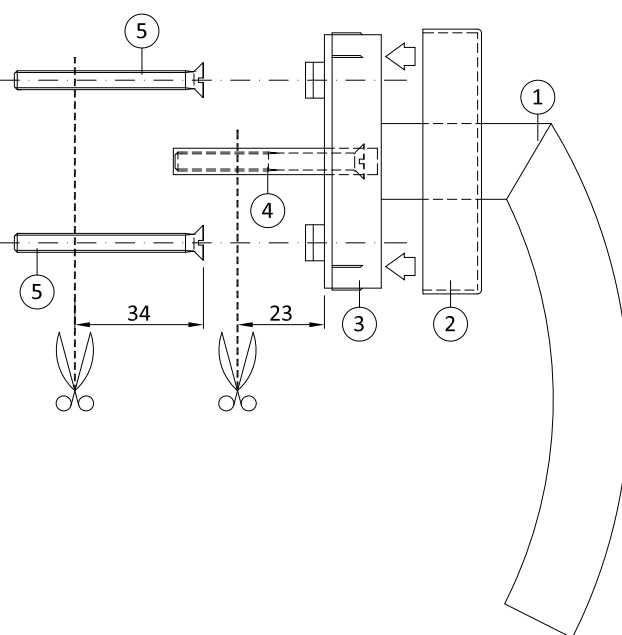
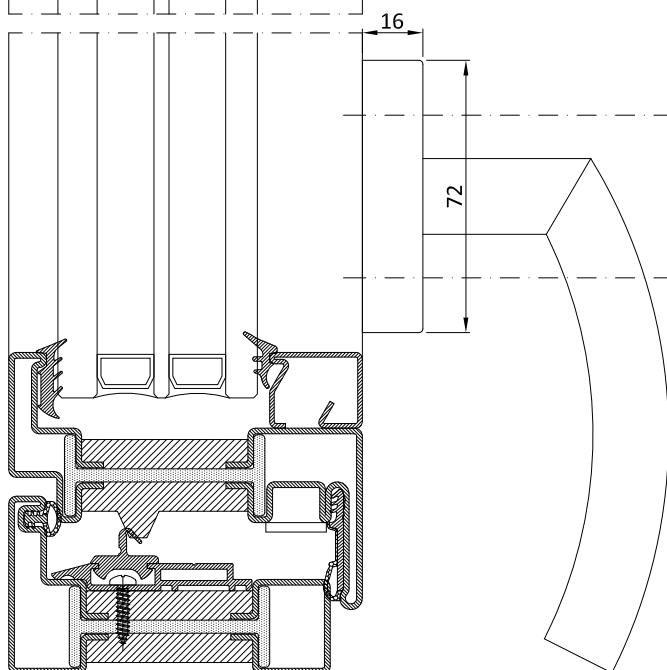


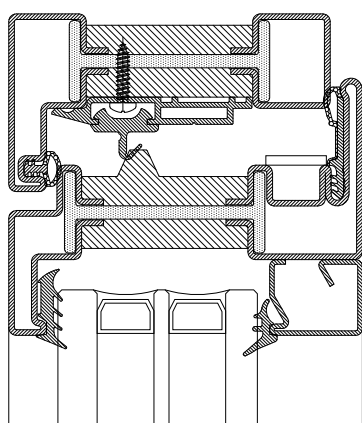
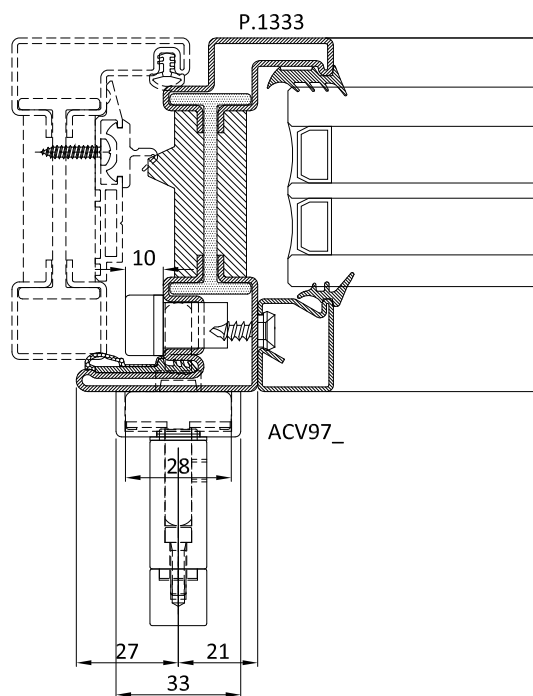
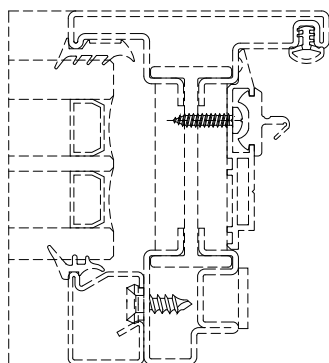
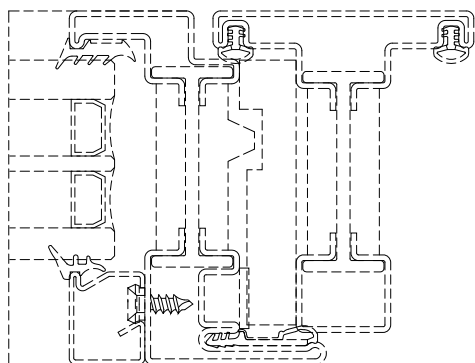
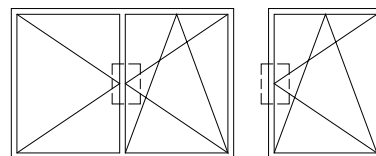
AC5056 :

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

AC5056 :

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



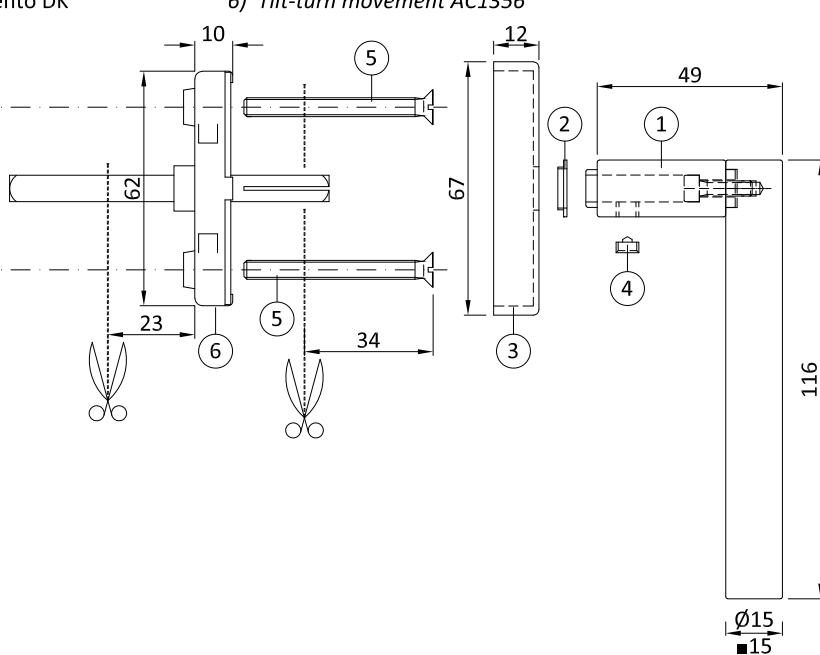
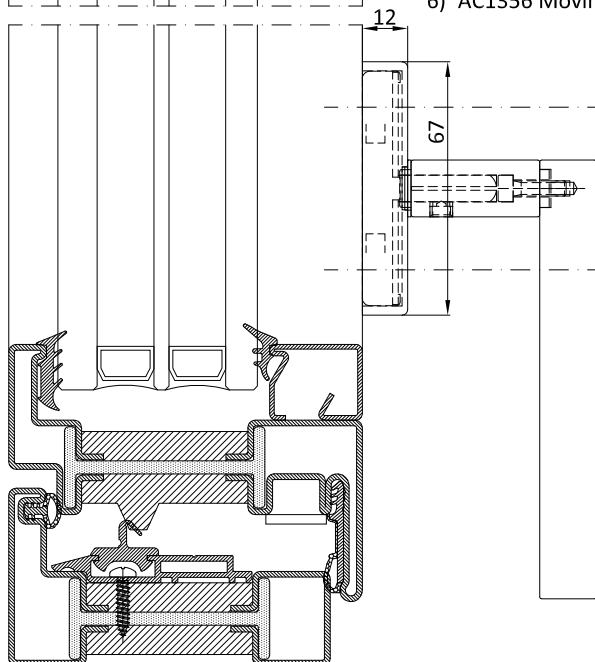


ACV97- :

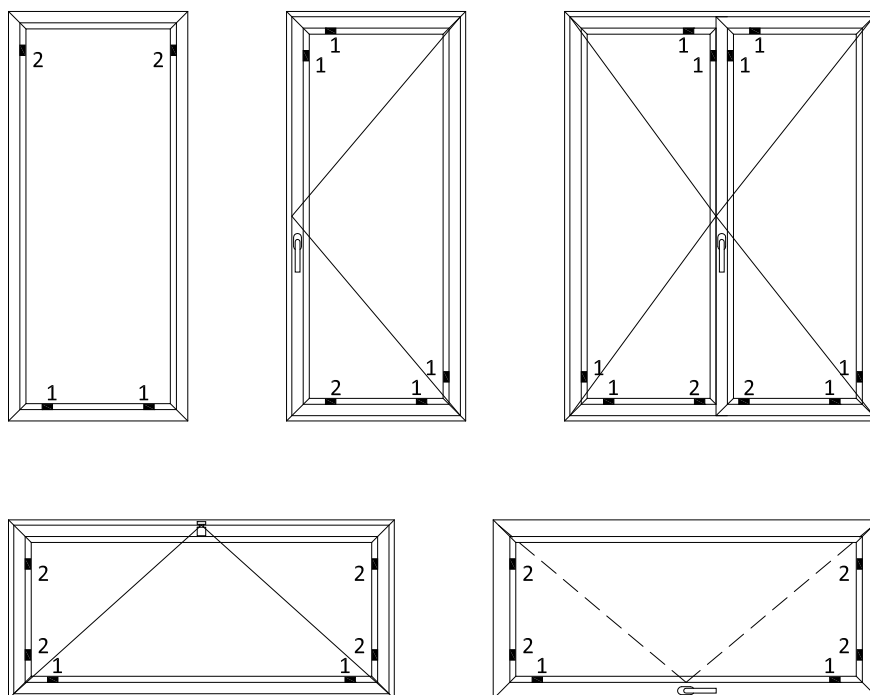
- 1) Impugnatura
- 2) Rondella
- 3) Rosetta
- 4) Grano M6x6
- 5) Vite TP M5x50 (non fornite)
- 6) AC1356 Movimento DK

ACV97- :

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

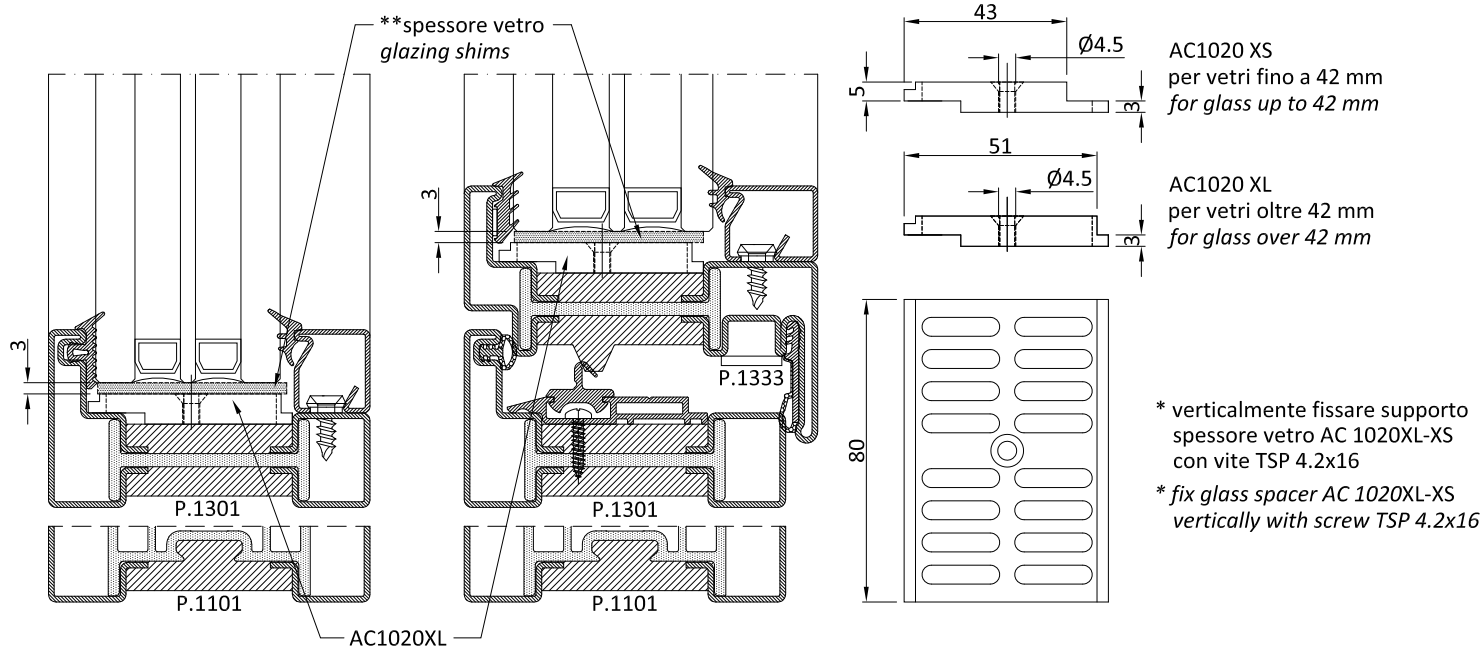


Finestra | Window



1) spessore portante | carry shim

2) spessore distanziatore | compensation shim



Note / Note

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

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

** spessori vetro non inclusi - glass thickness not included

Generalità

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

Tolleranze

EBE 85 prevede l'accoppiamento tra i telai esterni e le ante apribili con distanza di 12 mm su porte e 15 mm su finestre. Per garantire il corretto funzionamento degli accessori e delle guarnizioni le lavorazioni devono essere eseguite con particolare attenzione e precisione: si consiglia di mantenere la tolleranza per la dimensione degli elementi apribili compresa tra +0/-2 mm e la tolleranza per il sormonto degli stessi compresa tra +0/+1 mm.

Taglio/Lavorazioni

I profili EBE 85 in acciaio zincato, acciaio inox e corten possono essere tagliati con le normali troncatrici a disco utilizzate per i tubolari in acciaio, mentre per il taglio dei profili in ottone possono anche essere utilizzate troncatrici per le serie di alluminio. Vista la loro particolare dimensione e forma si consiglia di utilizzare le ganasce di taglio previste dal sistema per assicurare una perfetta stabilità dei profili durante il taglio. La verifica del taglio, sia per la sezione inclinata a 45° che per la sezione verticale a 90°, dovrebbe garantire una tolleranza compresa tra -1°/+1°. Tutte le lavorazioni devono essere eseguite con il rispetto della seguente nota tecnica ed eventuali modifiche concordate con l'ufficio tecnico Secco Sistemi.

Saldatura

I profili EBE 85 possono essere saldati con i tradizionali sistemi di saldatura (MIG/MAG, TIG), con un idoneo sistema di lubrificazione/refrigerazione e utilizzando le istruzioni presenti nella presente nota tecnica ed evitando di saldare in prossimità della giunzione a taglio termico. L'eventuale riscaldamento del poliuretano libera sostanze gassose a base di aldeidi e CO: per tale ragione si consiglia di saldare con gli appositi DPI previsti e in zone con sufficiente areazione e in presenza di sistema per l'evacuazione dei fumi. I profili in corten devono essere saldati con apposito filo in corten mentre per i profili in ottone si può utilizzare un filo CuSi3. Si raccomanda di saldare in profondità e senza lasciare fori e porosità le aree in contatto, di lisciare e pulire adeguatamente la superficie saldata per garantire una corretta resistenza strutturale all'angolo e permettere una successiva verniciatura senza imperfezioni estetiche visibili (pori e ondulazioni).

Verniciatura/Brunitura

I profili EBE 85 sono stati progettati per essere verniciati a polveri in forni con temperature di 180°C per 25 minuti. La zona a taglio termico in poliuretano non è in grado di accogliere con sufficiente adesione le polveri poliesteri e perciò si consiglia di ricoprire tali zone, nelle sole parti destinate ad essere in vista, con apposite pellicole adesive idonee al passaggio in forno.

I telai prima della verniciatura o della brunitura devono essere forati come da istruzioni presenti in questa nota tecnica per permettere la fuoriuscita dei liquidi utilizzati durante il pretrattamento delle superfici. All'uscita del forno di polimerizzazione della polvere i telai vanno rimossi accuratamente e adagiati in posizione piana sino al loro completo raffreddamento. Si consiglia di seguire il ciclo di pretrattamenti e verniciatura presente nella documentazione Secco Sistemi.

Vetrazione

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

Installazione

La corretta installazione deve garantire il mantenimento delle performance dichiarate nella marcatura CE e testate in laboratorio. Si consiglia di progettare un corretto numero di fissaggi in relazione al tipo di 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 dei telai e del vetro.

General information

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

Tolerance

EBE 85 is made by coupling external frames with the opening leaves with a distance of 12 mm on doors and 15 mm on windows. To ensure the correct functioning of hardware and gaskets, tooling must be performed with great care and precision. It is advised to keep the tolerance between $+0/-1$ mm for opening elements and between $+0/+0.5$ mm for their overlapping area.

Cut / Processing

EBE 85 profiles in galvanized steel, stainless steel and corten steel can be cut with normal saws, like those used for steel pipes. EBE 85 profiles in brass can be cut with saws used for aluminium. Given their dimension and size, it is recommended to use the cutting jaws advised to ensure perfect stability during the cutting procedure. In order to verify the correctness of the cut, the tolerance of both the 45° and the 90° sections must be between $-1^\circ/+1^\circ$. All Tooling must be performed in line with this technical note and any variations agreed with Secco Sistemi's Technical Department.

Welding

EBE 85 profiles can be welded with the traditional systems (MIG/MAG, TIG), with an appropriate lubricating/cooling system and according to the instructions as per this technical note. Avoid welding near the thermal break joint. Heating any polyurethane items releases gaseous substances containing aldehydes and CO. For this reason it is recommended to weld with the special Personal Protective Equipment suggested and in areas with sufficient ventilation and fume-disposing systems. The corten profiles must be welded with special corten wire, while for profiles in brass a CuSi3 wire can be used. It is recommended to weld in depth, to avoid leaving any holes or porosity on the surfaces and to smooth and clean the welded surface thoroughly. This is to guarantee a proper structural resistance at the corner and to allow for later painting without any visible imperfections (pores and ripples).

Painting/Burnishing

EBE 85 profiles have been designed to be painted with the powder coating technique in industrial ovens at temperatures of 180°C for 25 minutes. The thermal break area is not designed to absorb polyester powders and therefore it's advised to cover the visible areas with appropriate industrial-oven-resistant adhesive films (SA1024 and SA1033). Holes must be drilled in the frames (as per instructions in these technical specifications) before painting or burnishing in order to allow drainage of any liquid used as a pre-treatment of the surfaces. Once out of the oven, the frames must be accurately removed and laid in a horizontal position until complete cooled.

It is advised to follow pre-treatment and painting cycles as outlined in the Secco Sistemi documentation.

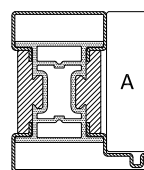
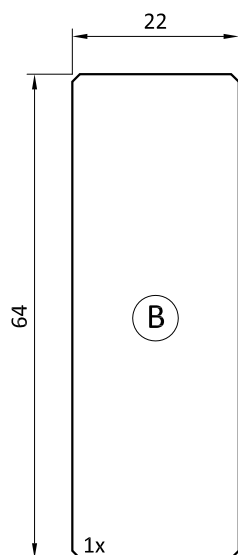
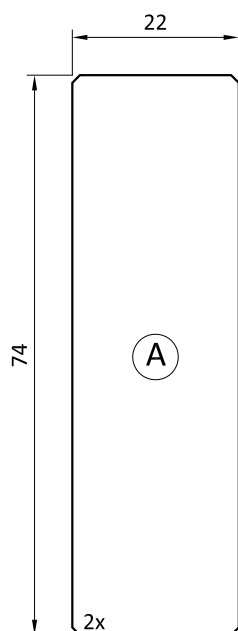
Glass application

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

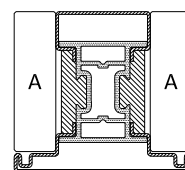
Installation

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

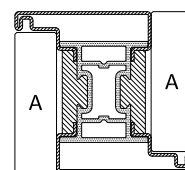
AT1100



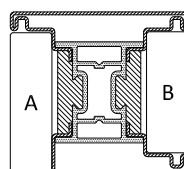
P.1101



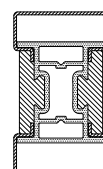
P.1102



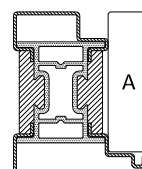
P.1103



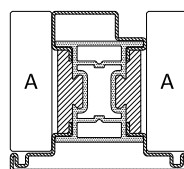
P.1105



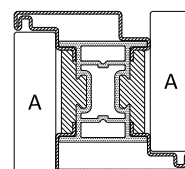
P.1110



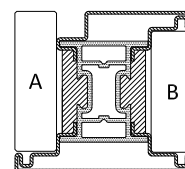
P.1111



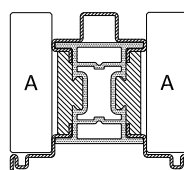
P.1112



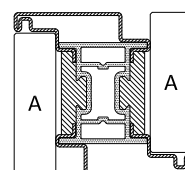
P.1113



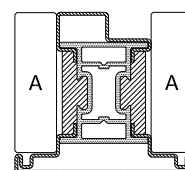
P.1115



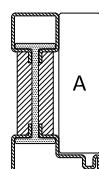
P.1122



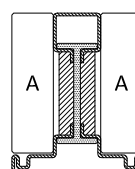
P.1123



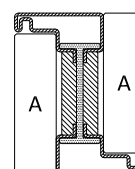
P.1127



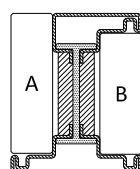
P.1301



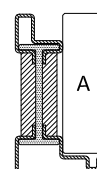
P.1302



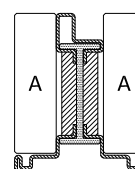
P.1303



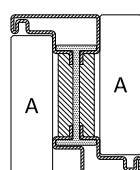
P.1305



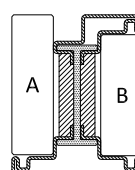
P.1311



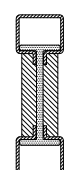
P.1312



P.1313

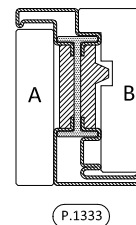
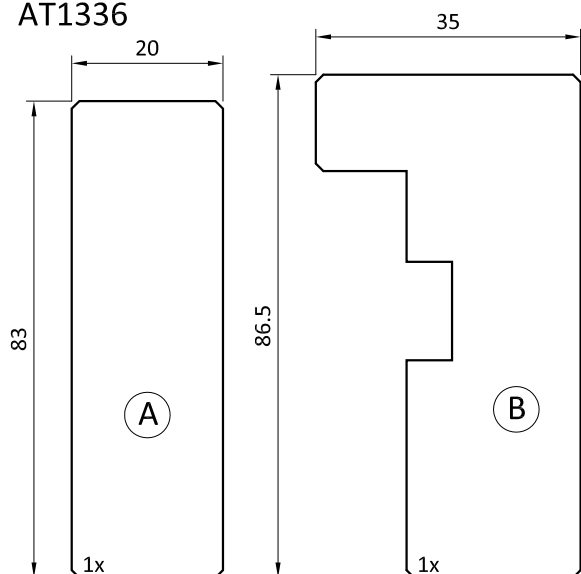


P.1315

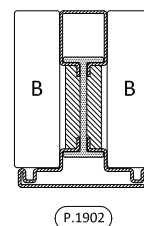
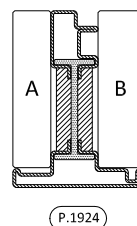
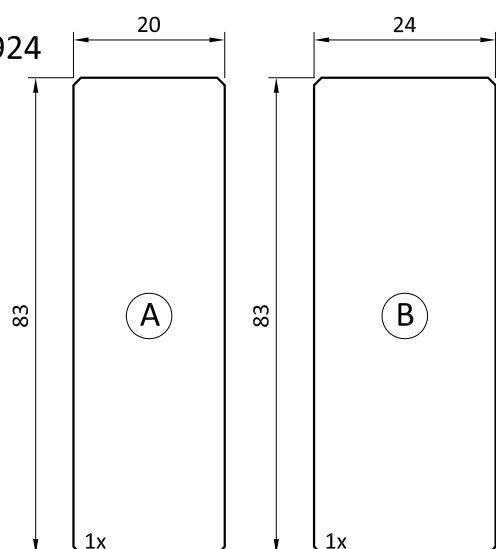


P.1320

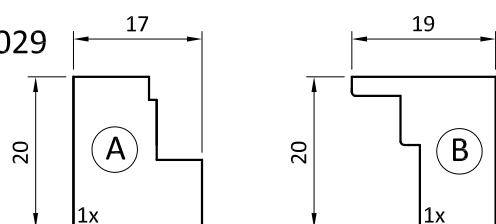
AT1336



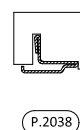
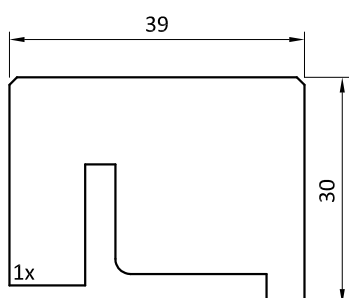
AT1924

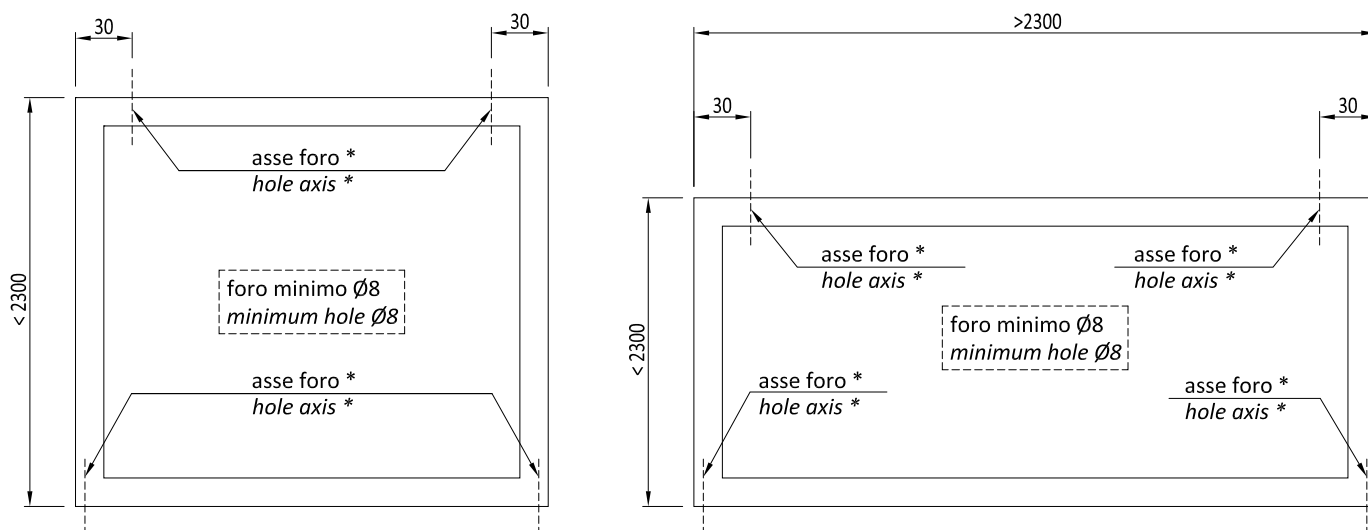


AT2029



AT2038





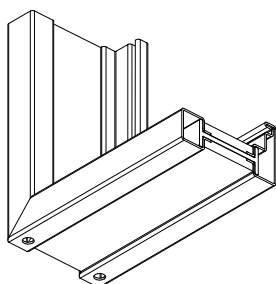
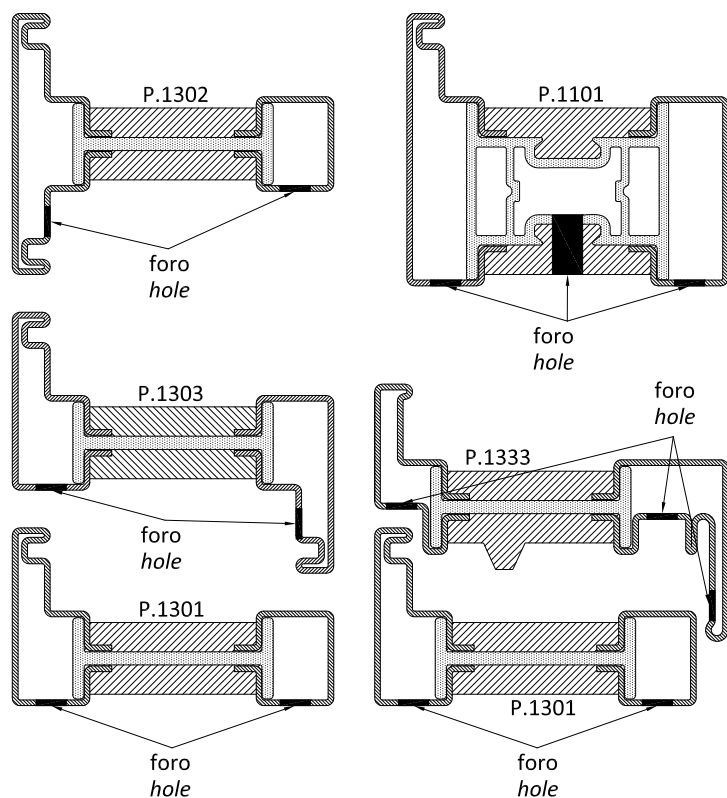
* forare alla massima estremità

* to be drilled on the extremity

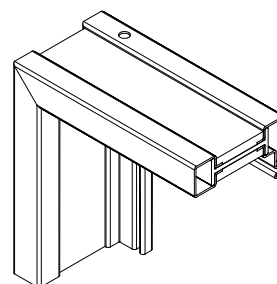
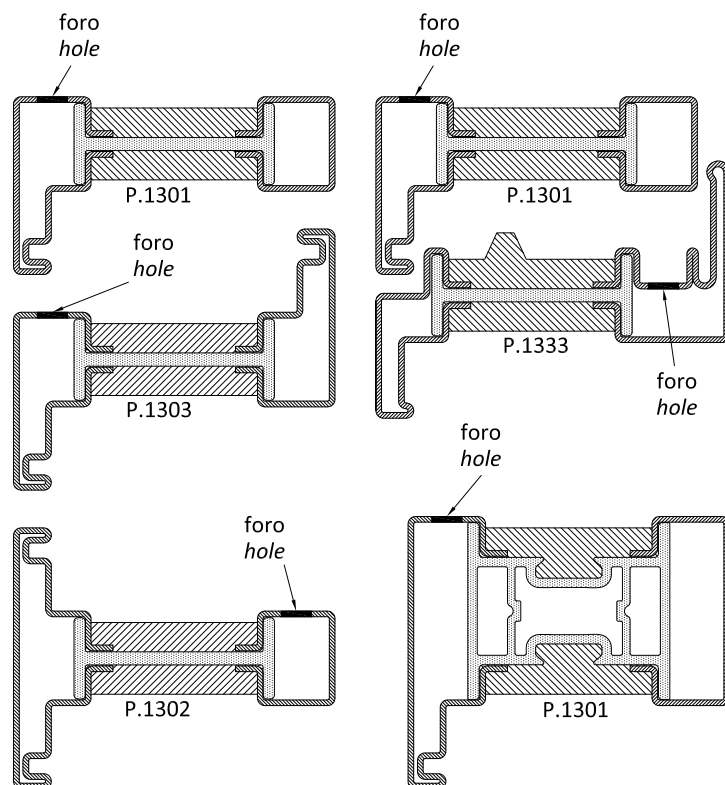
N.B. dimensioni orientamento telai indicative - da verificare con l'impianto di verniciatura/brunitura scelto

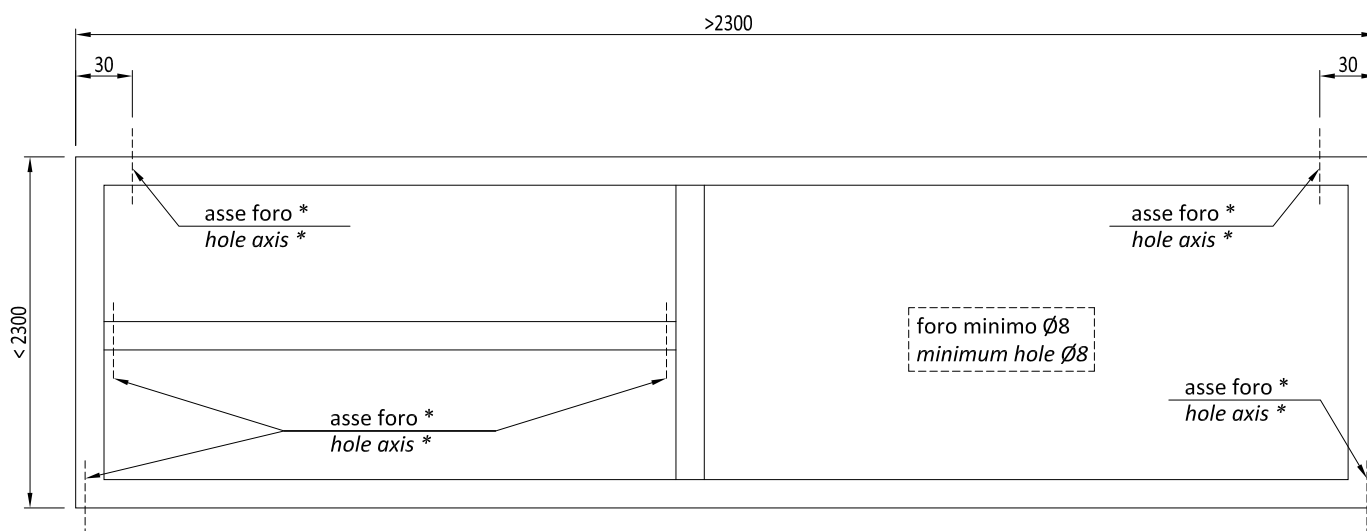
N.B. frame dimensions are indicative - they have to be checked with the powder painting / burnishing plant

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



FORATURA LATO SUPERIORE PER APPENDERE
DRILLING UPPER FRAME FOR FRAME HANGING





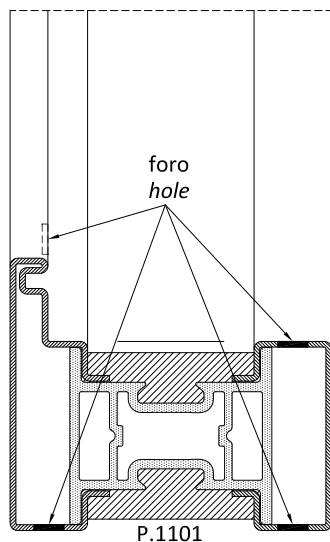
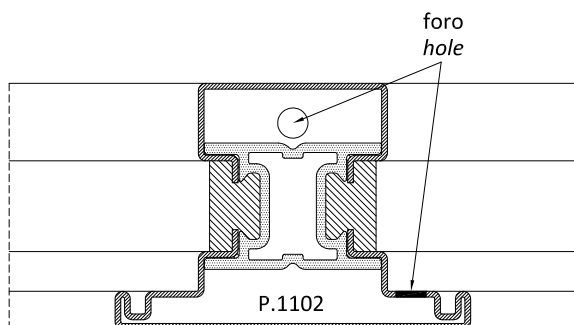
* forare alla massima estremità

* to be drilled on the extremity

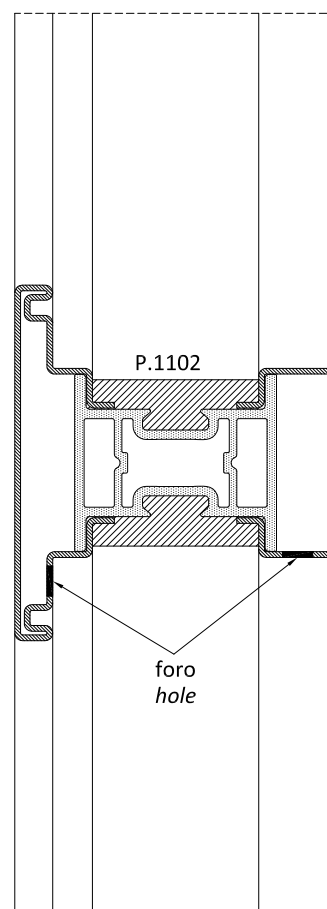
N.B. dimensioni orientamento telai indicative - da verificare con l'impianto di verniciatura/brunitura scelto

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

FORATURA MONTANTI DRILLING MULLION



FORATURA TRAVERSI DRILLING TRANSOM



Troncatricecaratteristiche minime della macchina

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

caratteristiche della lama

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

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

Pantografocaratteristiche minime della macchina

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

caratteristiche minime delle frese

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

Foraturemontaggio componenti di chiusura e movimentazione sui profilati in acciaio inox

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

fresatura di cave e asole sui profili inox

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

CutterMinimum requirements for the use of the machine

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

Blade specifications

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

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

PhantographMinimum requirements for the use of the machine

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

Minimum requirements for the use of a milling machine

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

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

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

Milling slots and loops in the profiles

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

1. Controllo materiale in arrivo / *Incoming equipment Control*Verifica visiva dell'intergrità delle barre con attenzione a: / *Profiles wholeness visual control paying attention to:*

- Strisci profondi / *Deep scratches* verifica visiva / *visual control*
- Botte e avvallamenti sulla superficie / *Bumps and dips on surface* verifica visiva / *visual control*
- 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°

MATERIALI**ACCIAIO INOX****Materiale**

Profilati ricavati da nastro di lamiera di acciaio inox laminato a freddo pre-trattato industrialmente per garantire la massima qualità e uniformità.

Caratteristiche fisiche

AISI 316L Marino (X2 CrNiMo 17-12-2)

Norme di riferimento

EN 10088-2; EU 114

Trattamenti superficiali

Finitura satinata: ottenuta su nastro AISI 304 con finitura superficiale 2B con successiva satinatura con abrasivi a grana 240-280.

Finitura lucida: ottenuta su nastro AISI 316L (marino) con finitura superficiale 2R, riflettività 53% e successiva lucidatura a specchio.

Finitura Scotch Brite: ottenuta su nastro AISI 316L (marino) con finitura superficiale 2B con successiva spazzolatura Scotch Brite.

ACCIAIO COR-TEN**Materiale**

Profilati ottenuti da nastro in acciaio altoresistenziale, autopassivante (che un tempo veniva commercializzato con il nome Cor-Ten) tale da formare, se esposto all'aria, uno strato di ossido uniforme e stabile che, ricoprendo la lamiera, ne arresta la corrosione atmosferica.

Caratteristiche fisiche

Fe 510 X (C max % 0,12; Si % 0,25-0,75; Mn % 0,20-0,50; P % 0,07-0,15; Cu % 0,25-0,55; Cr % 0,30-1,25; Ni max % 0,65)

Norme di riferimento

EN 10149

Trattamenti superficiali

Dopo la profilatura il materiale viene immerso in speciali bagni ossidanti tali da accelerare la formazione dello strato protettivo. Raggiunta la tonalità desiderata della superficie si procede ad una ceratura di stabilizzazione del materiale.

ACCIAIO ZINCATO VERNICIATO**Materiale**

Profilati ottenuti da nastro in lamiera di acciaio zincato a caldo sistema Sendzimir finitura skinpassata

Caratteristiche fisiche

FeP02 GZ 200 (copertura di zinco pari a 200gr/m² per faccia)

Norme di riferimento

UNI EN 10142/3/7; EURONORM 143

Trattamenti superficiali per la verniciatura

La preparazione del supporto zincato si effettua tramite i processi di sgrassaggio, decapaggio e lavaggio in acqua. Segue l'applicazione di uno strato di zinco per fosfatazione seguito da lavaggi in acqua demineralizzata. Infine applicazione della mano a finire con polveri poliestere cotte in forno a 180 °C per 25 minuti.

LEGA DI RAME OT67**Materiale**

Profilati ottenuti da nastro di Lega di Rame OT67 laminato a freddo rincrudito allo stato grezzo.

Caratteristiche fisiche

Cu Zn 33 CW 506L (OT 67, 67% rame)

Norme di riferimento

EN 1652:1999

Trattamenti superficiali

Finitura brunita: dopo la profilatura viene eseguita una ricottura di distensione, quindi la pulitura meccanica con abrasivo e la successiva brunitura per immersione con liquido brunitore; il profilo viene poi lavato e asciugato ed infine protetto mediante trattamento con olio di vaselina.

Finitura lucida: dopo la profilatura viene eseguita una ricottura di distensione e successivamente la lucidatura a specchio.

MATERIALS**STAINLESS STEEL****Materials**

Sections processed out of the cold-rolled coils, industrially pre-treated for utmost quality and uniformity.

Physical features

AISI 316L Marino (X2 CrNiMo 17-12-2)

Norms of reference

EN 10088-2; EU 114

Surface treatment

Satined: obtained on AISI 304 coil 2B pre-finish with post-treatment by means of abrasive 240-280 in grain size.

Polished: obtained on AISI 316L (marine) coil pre-finish with 2R surface finish, 53% reflectivity, and mirror post-polish.

Scotch Brite: obtained on AISI 316L (marine) coil 2B pre-finish with Scotch-Brite post-scrubbing.

CORTEN STEEL**Materials**

Sections processed out of highly resistant self-oxidising steel coils – once traded under the name Cor-Ten. If exposed to the open air, it produces a uniform protective layer that reduces weather corrosion.

Physical features

Fe 510 X (C max % 0,12; Si % 0,25-0,75; Mn % 0,20-0,50; P % 0,07-0,15; Cu % 0,25-0,55; Cr % 0,30-1,25; Ni max % 0,65)

Norms of reference

EN 10149

Surface treatment

After forming, sections are plunged into a special oxydising bath to catalyze formation of the protective coating. Once the desired tone obtained, sections are stabilized by a wax coating.

GALVANIZED AND PAINTED STEEL**Materials**

Sections processed out of hot galvanized steel coils, band "Sendzimir, skinpassed finishing.

Physical features

FeP02 GZ 200 (with zinc coating of 200 gr/sq x m on both faces)

Norms of reference

UNI EN 10142/3/7; EURONORM 143

Pre-painted surface treatment

The preparation of a galvanised surface is made through several processes: degreasing, pickling and washing. A coating of zinc is then applied through a phosphatising process followed by rinses in demineralised water. A final coat is then applied with polyester powders baked at 180 °C for 25 minutes.

COPPER ALLOY OT67**Materials**

Sections processed out of copper alloy coils, industrially cold-rolled.

Physical features

Cu Zn 33 CW 506L (OT 67, 67% copper e 33% zinc)

Norms of reference

EN 1652:1999

Surface treatment

Burnished finish: after forming, the product is submitted to stress relieving, then to mechanical cleaning with abrasive products and ultimately to burnishing by plunging into a burnishing solution. It is then washed and dried and protected with a vaseline coating.

Glossy finish: after forming, the product is submitted to stress relieving and then mirror-like polished.

INDICE ANALITICO | SUBJECT INDEX

AC1001I	4.2.5	AC1237	4.4.48-50
AC1002I	4.2.5	AC1355	4.4.1
AC1003I	4.2.6	AC1356	4.4.15 4.4.56 4.4.71
AC1004I	4.2.7	AC1708I	4.2.19
AC1005I	4.2.8	AC1714	4.4.3-5 4.4.9
AC1006I	4.2.8	AC1716	4.4.7-9
AC1007I	4.2.9	AC1730I	4.2.17
AC1008I	4.2.9	AC1731I	4.2.14
AC1009I	4.2.6	AC1732I	4.2.15
AC1013I	4.2.7 4.2.10	AC1733I	4.2.16
AC1014	4.3.1-2	AC1733IE	4.2.16
AC1020XL	4.3.44 4.4.72	AC1735I	4.2.14
AC1020XS	4.3.44 4.4.72	AC2608	2.9.11
AC1021	4.2.20	AC2632/C	4.4.51 4.4.62
AC1022	4.2.21	AC5002	4.3.41
AC1023	4.2.22	AC5037	4.4.69
AC1024ID	4.2.10	AC5056	4.4.15 4.4.56 4.4.70
AC1024IS	4.2.10	AC6023	4.3.13
AC1033.	4.3.4-6	ACV942	4.3.42
AC1033/R	4.3.6	ACV943	4.3.42
AC1037.	4.3.7-9	ACV944	4.3.42
AC1037/R	4.3.9	ACV947	4.3.42
AC1039	4.4.64-65	ACV948	4.3.42
AC1040	4.3.30	ACV949	4.3.42
AC1046	4.4.66	ACV952	4.3.43
AC1046M	4.4.67	ACV953	4.3.43
AC1065W D-S	4.3.15-17	ACV954	4.3.43
AC1066W D-S	4.3.15 4.3.18-19	ACV957	4.3.43
AC1067W D-S	4.3.20-22	ACV958	4.3.43
AC1068	4.3.10-12	ACV959	4.3.43
AC1070	4.3.23 4.3.25-26	ACV970	4.4.71
AC1071	4.3.24-26	ACV971	4.4.71
AC1072	4.3.27-29	ACV972	4.4.71
AC1075	4.3.23-29	ACV973	4.4.71
AC1080I	4.3.14	ACV974	4.4.71
AC1081	4.3.31-33	ACV976	4.4.71
AC1081AT	4.3.36 4.3.40	ACV977	4.4.71
AC1201I	4.2.12	ACV979	4.4.71
AC1202I	4.2.12 4.2.17	AG1224	4.4.61
AC1203I	4.2.13	AG1264	4.4.55-57
AC1207I	4.2.18	AG1271-2-5-6	4.4.14 4.4.19-21 4.4.38-42 4.4.45-46
AC1209I	4.2.13	AG1273	4.4.13
AC1211I	4.2.23	AG1274	4.4.55-56 4.4.58
AC1211IA	4.2.24	AG1278	4.4.13
AC1219.	4.4.6-7	AG1281-2-5-6	4.4.14 4.4.25-28 4.4.38-42 4.4.45-46
AC1219NE	4.4.6-7	AG1291-2-5-6	4.4.14 4.4.32-34 4.4.38-42 4.4.45-46
AC1221	4.4.60	AG1385	4.4.52-53
AC1223I	4.4.63	AG1386	4.4.54
AC1231S	4.4.63	AG6530	4.4.47
AC1235	4.4.59	AGA271-5	4.4.13 4.4.35-36 4.4.40-44

AGA775	4.4.13 4.4.37 4.4.40-44
AGE271-2-5-6	4.4.13 4.4.16-17 4.4.21 4.4.38-44
AGE775-6	4.4.13 4.4.18 4.4.21 4.4.40-44
AGE281-2-5-6	4.4.13 4.4.22-23 4.4.28 4.4.38-44
AGE785-6	4.4.13 4.4.24 4.4.27 4.4.40-44
AGE291-2-5-6	4.4.13 4.4.29-30 4.4.34 4.4.38-44
AGE795-6	4.4.13 4.4.31 4.4.34 4.4.40-44
AT1100	5.1.4
AT1336	5.1.4
AT1924	5.1.4
AT2029	5.1.4
AT2038	5.1.4
CV5001	2.9.11
CV5012	2.9.11
GU1134	4.3.36 4.3.40
GU1311	4.4.64 4.4.68
P.1127	4.3.3
P.1129	4.3.37
P.1130	4.3.34-35 4.3.38-39
P.2027	4.4.11-12

METALFORM™

www.metalformgroup.com
sales@metalformgroup.com

 @metalformgroup

 /metalformeurope



Secco Sistemi S.p.A.

www.seccosistemi.com

