

OS2 75 L
CATALOGO
TECNICO
TECHNICAL
CATALOGUE

METALFORM™



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Sistema integrato di profili, accessori e guarnizioni a taglio termico con profili aventi sezione in vista 62 mm (nodo laterale, nodo centrale e nodo superiore), idoneo per la realizzazione di serramenti con apertura a libro con apertura verso l'interno o verso l'esterno.

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

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

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

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

Caratteristiche del sistema:

Sormonto interno ed esterno delle ante;
Sistema a 2 livelli di tenuta con guarnizione interna ed esterna di battuta per le migliori prestazioni di tenuta all'aria e all'acqua e di isolamento acustico;
Cerniere ad avvitare negli stessi materiali del profilo per porte e per finestre;
Sistema integrato per lo scarico acqua;
Kit completo per l'apertura ad anta con ferramenta a scomparsa;
Kit per l'alloggiamento di serrature completo di scatole di copertura nei diversi materiali;
Soglia inferiore con guarnizione di battuta e spazzolino.

Thermally insulated integrated system of profiles, accessories and gaskets with visible section of 62 mm (lateral section, upper section and central section) suitable for bi-fold door, inward or outward opening.

The metal profiles that make up the system are 15/10 mm thick and are obtained from the cold-forming of the coils in the various materials available.

The profile thermal break is connected by means of a glass-fibre reinforced, extruded polyamide that becomes one with the external metal parts with the use of a high density polyurethane resin, injected at high pressure. The connection is continuous, without interruptions, guaranteeing maximum resilience to torsional and bending stress.

The assembly of the frames requires that the profiles be connected by welding together the sections in contact and then that the visible welds must be ground down neatly and finished, or by combining mechanical assembly and internal welding that does not require the retouching of the finish.

The system permits to use double or triple thermal insulated glazing with **single or stratified glass** (security glass).

Features of the system:

Surmounted internal and external design of the sections ;
System with 2 barriers of tightness with internal and external rebate gasket and for the best water, wind, air tightness and acoustic performances;
High capacity to be screwed in the same material of the profile ;
Integrated system for water drain ;
Concealed hardware for side-hung windows ;
Complete kit for lock with coverings in the same material of the profile ;
Bottom threshold with rebate gasket and brush.

PRESTAZIONI

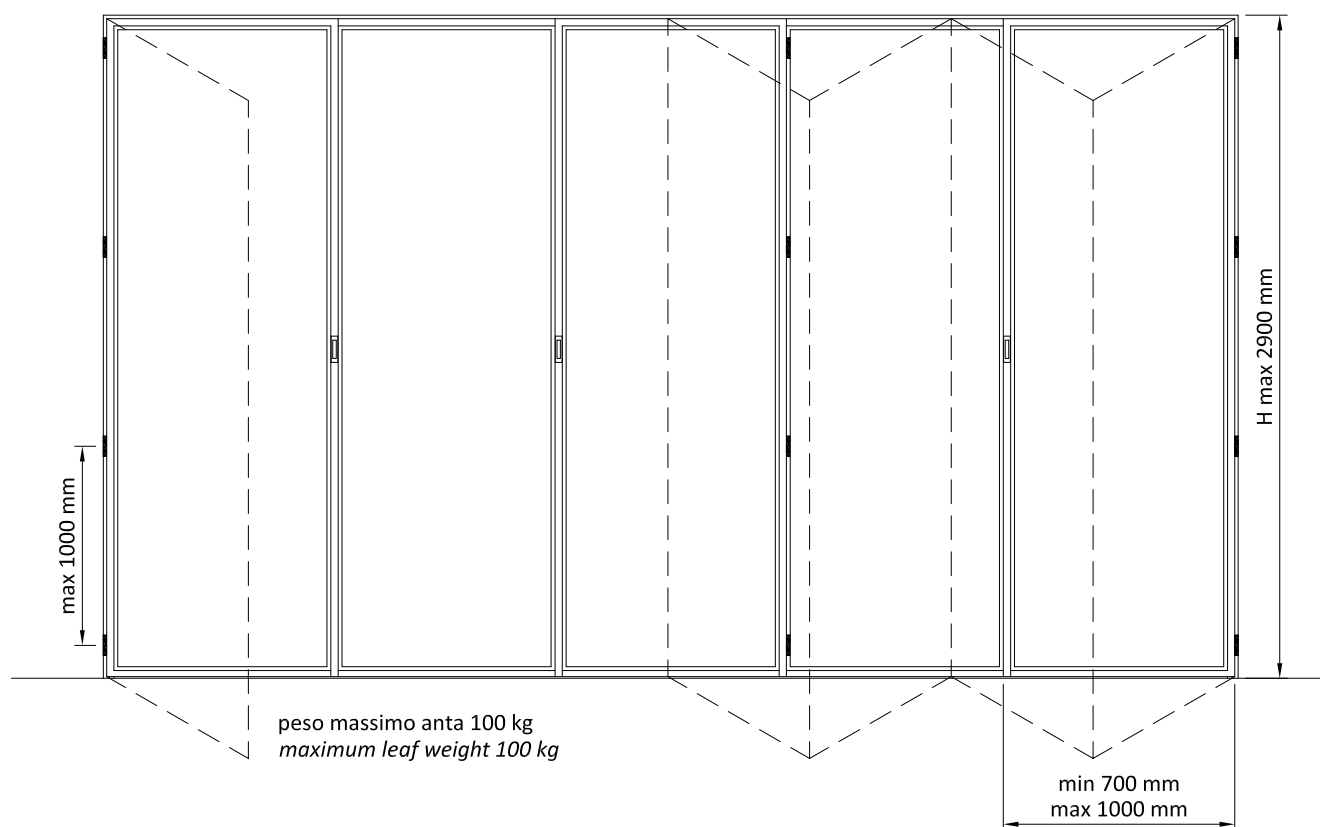
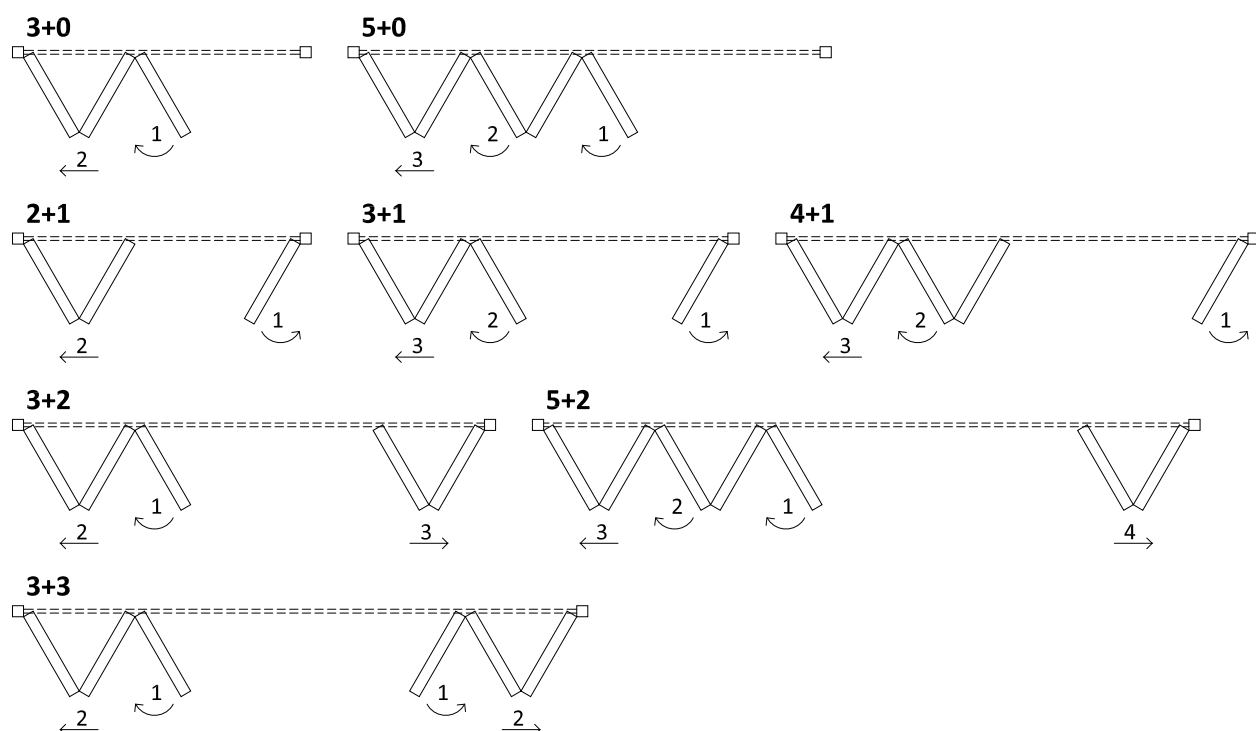
Serramenti a libro

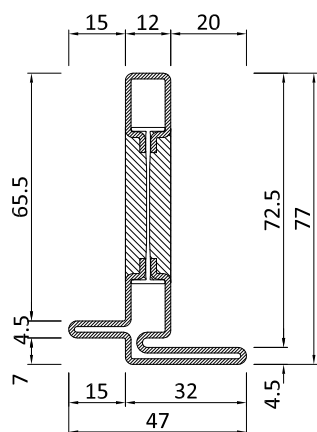
Trasmittanza termica (EN ISO 10077-2)
- Nodo tipo: $U_f = 2.50 \text{ W/m}^2\text{K}$
Resistenza all'aria (DIN EN 12207)
- Fino a Classe 4
Resistenza all'acqua (DIN EN 12208)
- Fino a Classe 5A
Resistenza al vento (DIN EN 12210)
- Fino a Classe C3

PERFORMANCES

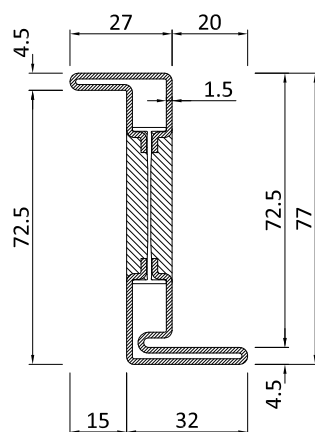
Bi-fold door

Thermal transmittance (EN ISO 10077-2)
- Typical section: $U_f = 2.50 \text{ W/m}^2\text{K}$
Air permeability (DIN EN 12207)
- Up to Class 4
Watertightness (DIN EN 12208)
- Up to Class 5A
Resistance to wind load (DIN EN 12210)
- Up to Class C3

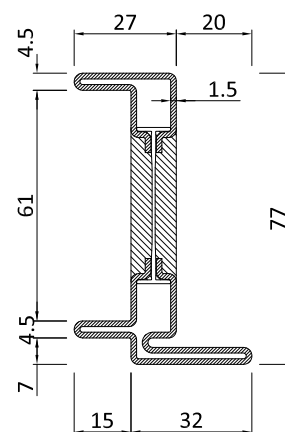
Limiti dimensionali - Maximum dimension**Esempi tipologie a libro realizzabili in apertura interna ed esterna**
Types of bi-folding doors in inward and outward opening



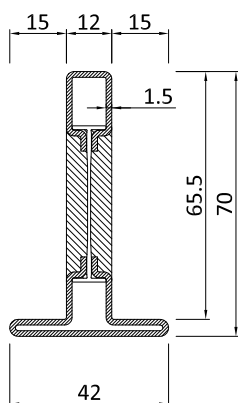
PR2962



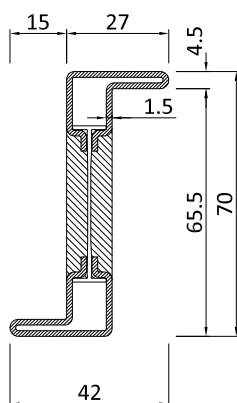
PR2963



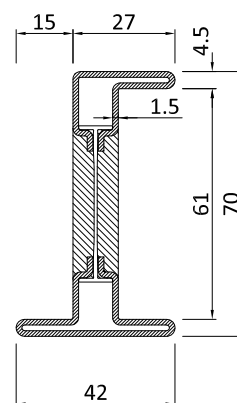
PR2965



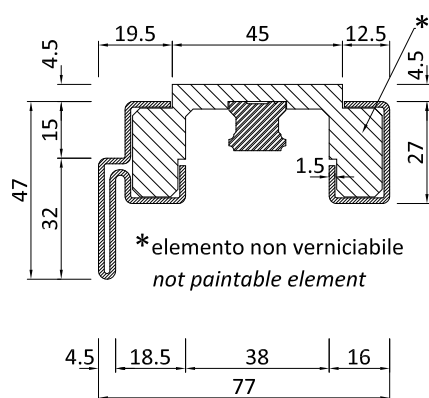
PR2972



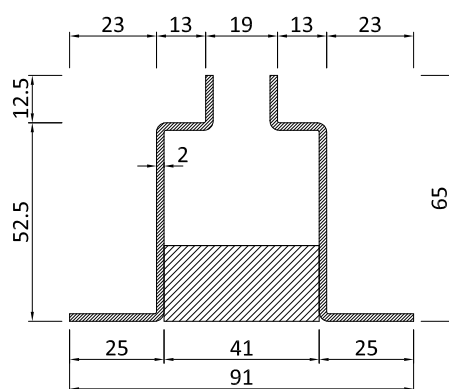
PR2973



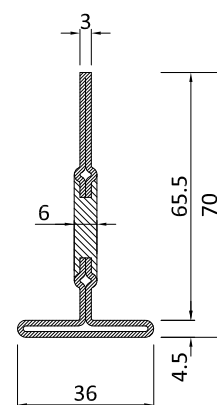
PR2974



PR2927



PR2928

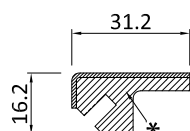
solo in acciaio inox
stainless steel only

PR2964

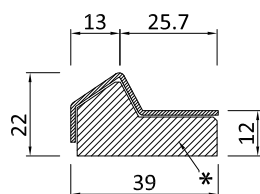
non fornito in inox
not in stainless steel

Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m
	ZN / I - CT	OT				
PR2962	2,73	2,92	0,25	17,89	2,97	6,0
PR2963	2,80	2,99	0,25	22,53	2,79	6,0
PR2965	3,07	3,29	0,28	23,73	3,82	6,0
PR2972	2,34	2,50	0,21	14,17	2,13	6,0
PR2973	2,35	2,51	0,21	16,29	3,32	6,0

Profilo / Profile n°	P Kg/m		A m ² /m	Jx cm ⁴	Jy cm ⁴	L m
	ZN / I - CT	OT				
PR2974	2,68	2,87	0,22	18,81	2,87	6,0
PR2927	3,10	3,25	0,20			4,0
PR2928	3,85					3 - 4
PR2964	2,22	2,10	0,21	14,87	1,2	6,0

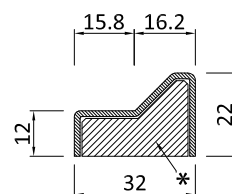


PR2929



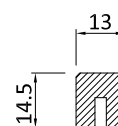
PR2938

corten non disponibile
corten steel not available

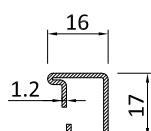


PR2939

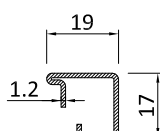
corten non disponibile
corten steel not available



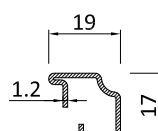
GU2926



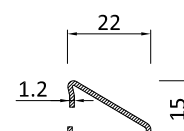
PR2606



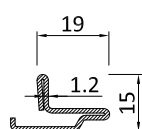
PR2607



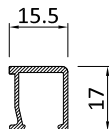
PR2627



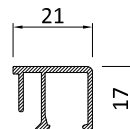
PR2629



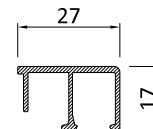
PR2638



PA2606



PA2607



PA2608

*elemento non verniciabile
not paintable element

MATERIALE | MATERIAL

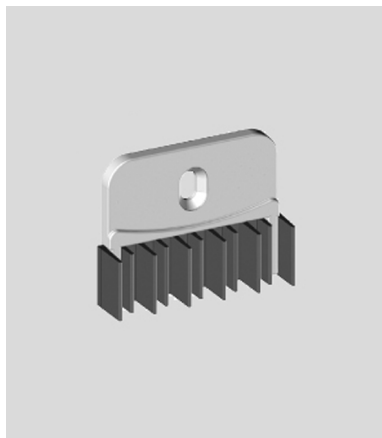
PR ____ ZN acciaio zincato | *galvanized steel*

PR ____ CZ acciaio corten grezzo | *untreated corten steel*

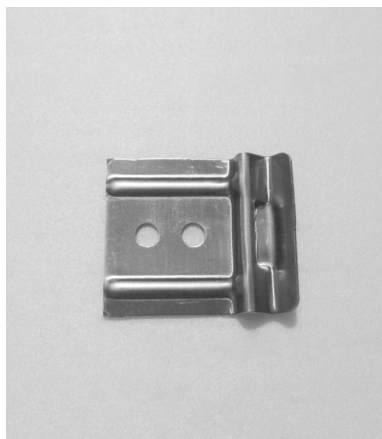
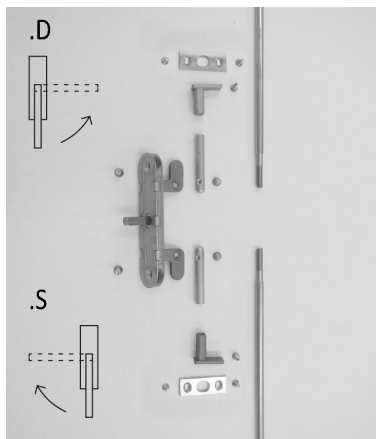
PR ____ SB acciaio inox scotch brite | *stainless steel scotch brite*

PR ____ BR ottone grezzo | *untreated brass*

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				
PR2929	0,68	0,72	0,04			3 - 4	PR2607	0,51	0,55				6,0
PR2938	1,18	1,22	0,05			3 - 4	PR2627	0,47	0,51				6,0
PR2939	1,11	1,17	0,06			3 - 4	PR2629	0,49	0,53				6,0
GU2926	0,23	PVC				3,0	PR2638	0,6	0,68				6,0
PR2606	0,48	0,52				6,0	PA2606-7-8	0,17-0,23-0,26	Alluminio				6,0

**AC 1081T**

Accessorio di battuta

Stop accessory**AC 2621L.S**Kit chiusura superiore con
catenaccio L = 650 mm*Upper closure kit with
flush bolt L = 650 mm***AC 2608**Clips per fissaggio fermavetri
PR2606 - PR2607 - PR2627
PR2629 - PR2638*Clips for securing
PR2606 - PR2607 - PR2627
PR2629 - PR2638
glazing beads***AC 2624.D**Kit cremonese dx per 1^a anta
e chiusure su ante secondarie
apertura interna
*RH cremone bolt set for master
sash and secondary
shashes inward opening***AC 2624.S**Kit cremonese sx per 1^a anta
e chiusure su ante secondarie
apertura interna
*LH cremone bolt set for master
sash and secondary
shashes inward opening***AC 2609AR**Clips per fissaggio fermavetri
su profilo PR2964*Clips for securing glazing beads
on PR2964 profile***AC 2626R**

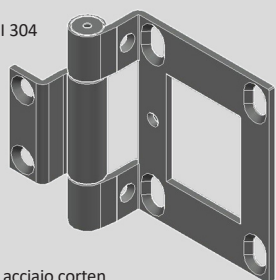
Punto di chiusura aggiuntivo

Additional locking point**AC 2621L.I**Kit chiusura inferiore con
catenaccio L = 450 mm*Bottom closure kit with
flush bolt L = 450 mm***AC 2648.xx**Cerniera a tre ali da avvitare
Peso max anta 100 kg*Three-wing screw-on hinge
Max leaf weight 100 kg*

AISI 304

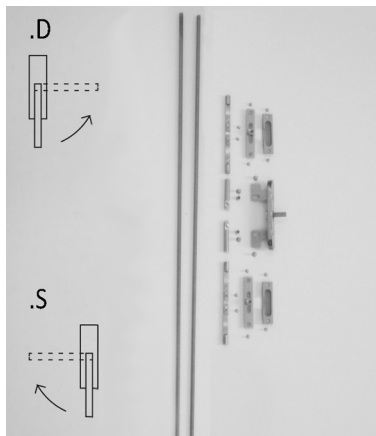
ZN acciaio zincato
galvanized steelCZ acciaio corten
corten steelSB acciaio inox scotch brite
scotch brite stainless steelIB acciaio inox brunito
burnished stainless steel

AISI 304

**CZ** acciaio corten
corten steel**SB** acciaio inox scotch brite - verniciabile
scotch brite stainless steel - paintable**IB** acciaio inox brunito
burnished stainless steel**AC 2648L.xx**

Cerniera a tre ali da avvitare
in apertura esterna su
impacchettamento dove
interferisce con la cremone
Peso max anta 100 kg

*Three-wing screw-on hinge
on folding outward opening
where interference with the
cremone
Max leaf weight 100 kg*

**AC 2683.D**

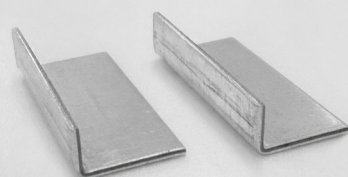
Kit cremone dx per 1^ anta
apertura esterna

*RH cremone bolt set for master
sash outward opening*

AC 2683.S

Kit cremone sx per 1^ anta
apertura esterna

*LH cremone bolt set for master
sash outward opening*

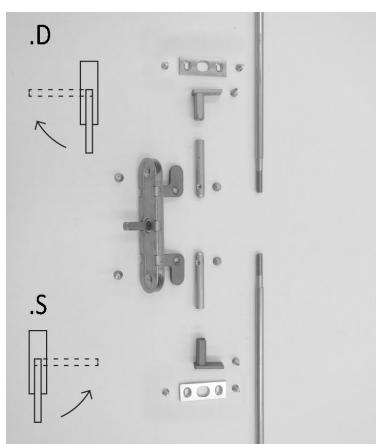


ZN acciaio zincato | galvanized steel
CZ acciaio corten | corten steel
IZ acciaio inox | stainless steel
BR ottone naturale | natural brass

AC 2653.xx

Kit fondini superiori per profili
PR2962 - PR2963

*Upper fittings kit for profiles
PR2962 - PR2963*

**AC 2684L.D**

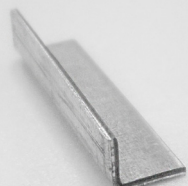
Kit cremone dx per maniglia
ridotta ACV761

*RH cremone bolt set for ACV761
reduced handle*

AC 2684L.S

Kit cremone sx per maniglia
ridotta ACV761

*LH cremone bolt set for ACV761
reduced handle*



ZN acciaio zincato | galvanized steel
CZ acciaio corten | corten steel
IZ acciaio inox | stainless steel
BR ottone naturale | natural brass

AC 2656.xx

Fondino inferiore per profili
PR2962 apertura esterna
PR2963 apertura interna

*Lower fitting for profiles
PR2962 outward opening
PR2963 inward opening*

**AC 2693**

Serratura con scrocco e
catenaccio per porta

Latch and bolt lock for door

**La soluzione porta è consentita
SOLO per ante singole che NON
devono essere impacchettate**

**The door solution is allowed
ONLY for single doors that must
NOT be packed**



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

AC 2680.xx

Maniglia di trascinamento
per aperture esterne

*Pulling handle for outward
opening*

**AC 2694.D**

Kit serratura multipunto dx
per porta

RH Multi-lock set for door

**La soluzione porta è consentita
SOLO per ante singole che NON
devono essere impacchettate**

**The door solution is allowed
ONLY for single doors that must
NOT be packed**

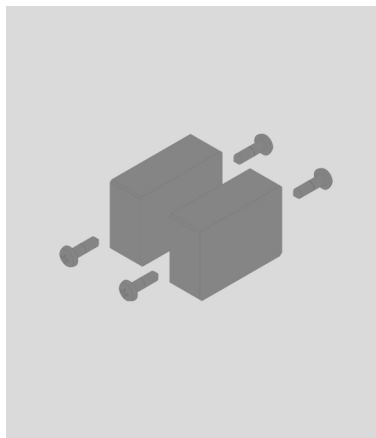
**AC 2694.S**

Kit serratura multipunto sx per porta

LH Multi-lock set for door

La soluzione porta è consentita SOLO per ante singole che NON devono essere impacchettate

The door solution is allowed ONLY for single doors that must NOT be packed

**AC 2819**

Kit tappi per guida inferiore PR2928

Bottom rail cap kit for PR2928 rail

**AC 2695.D**

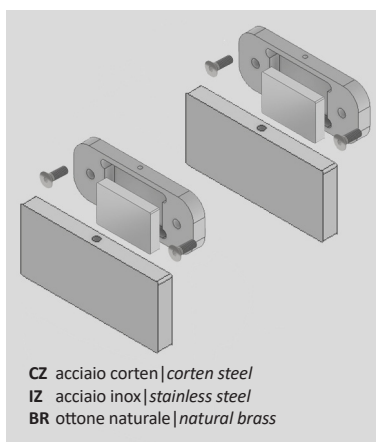
Punto di chiusura aggiuntivo dx per porta

RH additional locking point for door

AC 2695.S

Punto di chiusura aggiuntivo sx per porta

LH additional locking point for door

**AC 2825.xx**

Kit magneti blocco anta libera

Magnet kit for retain free leaf

CZ acciaio corten | corten steel
IZ acciaio inox | stainless steel
BR ottone naturale | natural brass

vedi pagine 4.2.3-4
see pages 4.2.3-4

**AC 2696.xx**

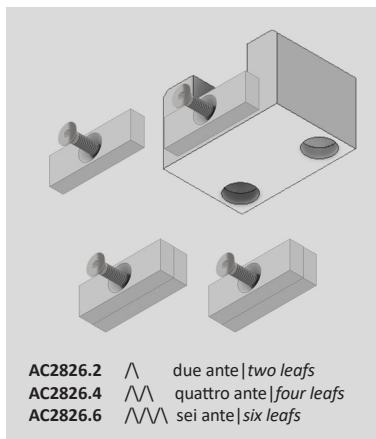
Scatola copri serratura Destra

RH lock cover box

La soluzione porta è consentita SOLO per ante singole che NON devono essere impacchettate

The door solution is allowed ONLY for single doors that must NOT be packed

ZN acciaio zincato | galvanized steel
CZ acciaio corten | corten steel
IZ acciaio inox | stainless steel AISI 304
BR ottone naturale | natural brass

**AC 2826.x**

Kit magneti per blocco ante impacchettate

Magnet kit for folding leaf stop

AC2826.2  due ante | two leaves
AC2826.4  quattro ante | four leaves
AC2826.6  sei ante | six leaves

vedi pagine 4.2.3-4
see pages 4.2.3-4

**AC 2697.xx**

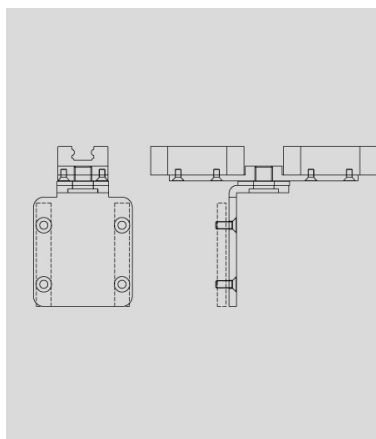
Scatola copri serratura Sinistra

LH lock cover box

La soluzione porta è consentita SOLO per ante singole che NON devono essere impacchettate

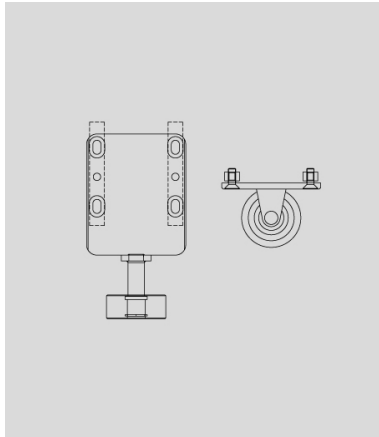
The door solution is allowed ONLY for single doors that must NOT be packed

ZN acciaio zincato | galvanized steel
CZ acciaio corten | corten steel
IZ acciaio inox | stainless steel AISI 304
BR ottone naturale | natural brass

**AC 2827**

Carrello superiore

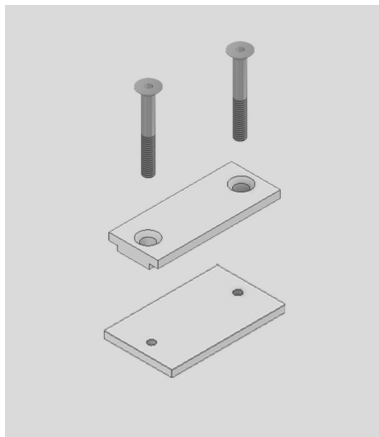
Upper roller

**AC 2828**

Carrello inferiore

Bottom roller**CV 5012.**

Boccola per fermavetri in alluminio

*Bushing for aluminium glazing bead*CV5012 acciaio zincato | *galvanized steel*
CV5012I acciaio inox | *stainless steel***AC 2828.F**

Fermo corsa per carrello inferiore

Travel stop for bottom roller**CV 1023.**

Vite per boccola fermavetri in alluminio, TPS 4.2x13

*Screw for aluminium glazing bead bushing, TPS 4.2x13*CV1023 acciaio zincato | *galvanized steel*
CV1023I acciaio inox | *stainless steel***CV 1243.**

Vite trilobata per boccola fermavetri in alluminio, TPS M4x8 su lato cremonese

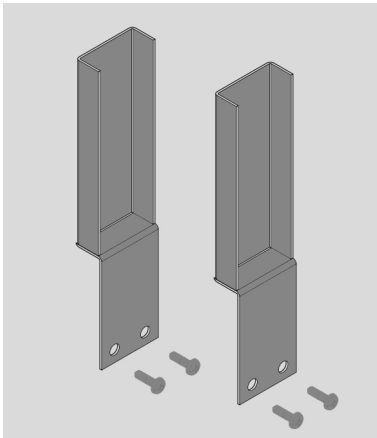
*Thread cutting machine screw for aluminium glazing bead bushing, TPS M4x8 on the cremonese side*CV1243 acciaio zincato | *galvanized steel*
CV1243I acciaio inox | *stainless steel*

**AC 2803I**

Kit squadrette allineamento

*Alignment bracket set*Profili | Profiles
PR2963 - PR2963**AC 2865I**

Kit squadrette allineamento

*Alignment bracket set*Profili | Profiles
PR2965 - PR2927**AC 2818I**

Kit staffe allineamento

*Alignment bracket set*Profili | Profiles
PR2928 - PR2965**AC 2832I**

Kit squadrette allineamento

*Alignment bracket set*Profili | Profiles
PR2962 - PR2963**AC 2862I**

Kit squadrette allineamento

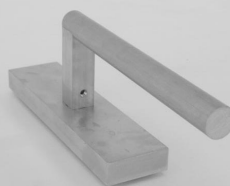
*Alignment bracket set*Profili | Profiles
PR2962 - PR2962

**ACV 751.xx**

Martellina cremonese ridotta
"VITRUVIO" medium (Ø15)
su impacchettamento
apertura interna 3+0 - 4+1 e similari
apertura esterna 2+1 e similari
T | tonda | tronca

*Reduced cremone handle
medium "VITRUVIO" (Ø15)
on opening folding
inward 3+0 - 4+1 and similar
outward 2+1 and similar
T | cut | round*

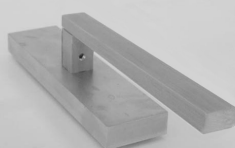
BR ottone grezzo verniciabile | paintable untreated brass
BB ottone brunito | burnished brass
CL ottone cromo lucido | polished and chromed brass
OL ottone lucido | polished brass
SB acciaio inox scotch brite | scotch-brite stainless steel

**ACV 773.xx**

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

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

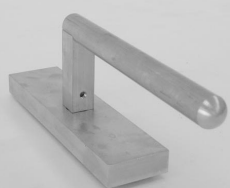
BR ottone grezzo verniciabile | paintable untreated brass
BB ottone brunito | burnished brass
CL ottone cromo lucido | polished and chromed brass
OL ottone lucido | polished brass
SB acciaio inox scotch brite | scotch-brite stainless steel

**ACV 761.xx**

Martellina cremonese ridotta
"VITRUVIO" medium
su impacchettamento
apertura esterna
L | quadra | tronca

*Reduced cremone handle
medium "VITRUVIO"
on outward opening folding
L | cut | square*

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

**ACV 774.xx**

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

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

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

**ACV 771.xx**

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

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

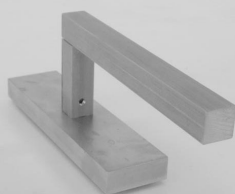
BR ottone grezzo verniciabile | paintable untreated brass
BB ottone brunito | burnished brass
CL ottone cromo lucido | polished and chromed brass
OL ottone lucido | polished brass
SB acciaio inox scotch brite | scotch-brite stainless steel

**ACV 776.xx**

Martellina cremonese
"VITRUVIO"
per finestra
KIDS

*Cremone handle
small "VITRUVIO"
for window
KIDS*

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

**ACV 772.xx**

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

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

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

**ACV 777.xx**

Martellina cremonese
"VITRUVIO"
per finestra
OVALE

*Cremone handle
small "VITRUVIO"
for window
OVAL*

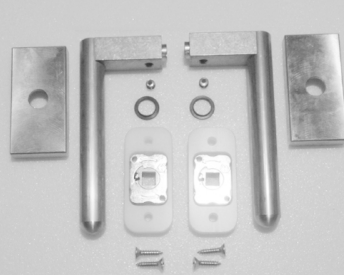
BR ottone grezzo verniciabile | paintable untreated brass
BB ottone brunito | burnished brass
CL ottone cromo lucido | polished and chromed brass
OL ottone lucido | polished brass

**ACV 779.xx**

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

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

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

**ACV 954.xx**

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

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

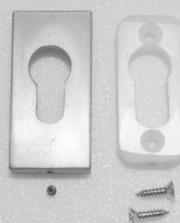
solo con ante asimmetriche
only with asymmetrical sash

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

**ACV 065**

Quadro maniglia per porta

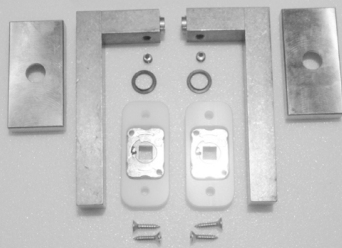
Handle spindle bar for door

**ACV 964.xx**

Bocchetta copri cilindro a profilo europeo

*Euro profile cylinder escutcheon
plate*

BR ottone grezzo verniciabile | paintable untreated brass
BB 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 952.xx**

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

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

solo con ante asimmetriche
only with asymmetrical sash

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

**ACV 953.xx**

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

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

solo con ante asimmetriche
only with asymmetrical sash

BR ottone grezzo verniciabile | paintable untreated brass
BB 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

**GE 1011**

Guarnizione interna vetro
spessore 4 mm

*Internal weather strip for
glazing bead
4 mm thick*

**GE 2907TT**

Guarnizione sotto vetro

Under glass gasket

**GE 1001TT**

Guarnizione di battuta soglia

Threshold gasket

**GP 0095**

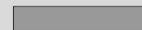
Guarnizione interna vetro
spessore 3mm

*Internal weather strip for
glazing bead
3 mm thick*

**GE 2606**

Guarnizione adesiva esterno
vetro
vedi pg. 5.1.1

*Adhesive weather strip outer
window
see pg. 5.1.2*

**GU 2036**

Piattina adesiva morbida
per fondo giunto esterno vetro
12x4 mm

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

**GE 2645TT**

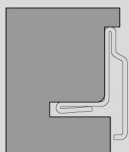
Guarnizione di battuta
interna|esterna

*Internal/external weather
strip with*

**GU 0100**

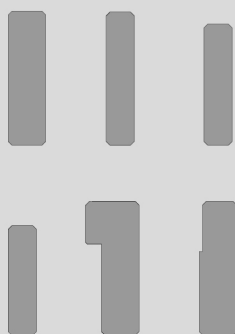
Spazzolino soglia

Threshold brush

**AT 2038**

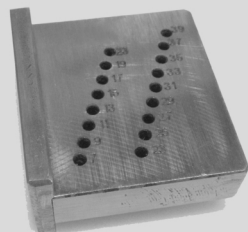
Ganasce di taglio per
PR2638

*Cutting jaws for
PR2638*

**AT 2900**

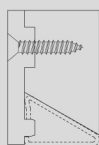
Kit ganasce di taglio

Kit of cutting jaws for profiles

**AT 2828**

Maschera per esecuzione fori
fissaggio fermavetri

*Drill jig for glazing beads
securing*

**AT 2829**

Ganasce di taglio per
fermavetro PR2629

*Kit of cutting jaws
for glazin bead PR2629*

**SA 0005.01**

Liquido neritore per brunitura
1 Kg

Burnishing liquid
1 Kg

SA 0005.10

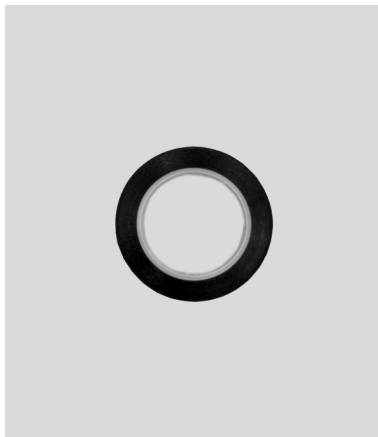
Liquido neritore per brunitura
10 Kg

Burnishing liquid
10 Kg

**SA 2031**

Liquido deumidificante vetri

Glass dehumidifying liquid

**SA 1033**

Nastro adesivo protettivo per
verniciatura
33 mm

Adhesive tape for painting
33 mm

P.29xx

**SA 2032**

Primer di adesione per profili
verniciati

*Adhesion primer for painted
profiles*

**SA 2001**

Spray detergente antimpronta
per superfici in acciaio inox

*Anti-fingerprint detergent spray
for stainless steel surfaces*

**SA 2033**

Liquido di adesione per
materiale plastico

Adhesion liquid for plastic

**SA 2002**

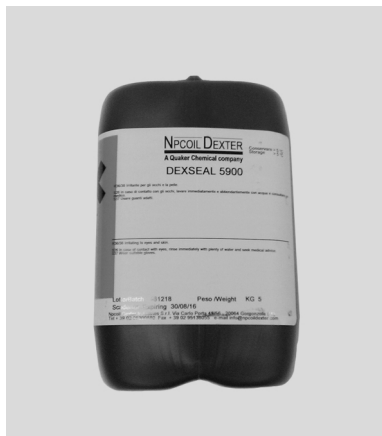
Spray solvente per rimozione
collanti su superfici in acciaio
inox

*Solvent adhesive remover spray
for stainless steel surfaces*

**SA 3001**

Acido per ossidazione corten

Oxidising acid for corten

**SA 3002.25**

Passivante per ossidazione corten
25 Kg

*Passivating agent for corten
25 Kg*

SA 3002.5

Passivante per ossidazione corten
5 Kg

*Passivating agent for corten
5 Kg*

**SA 3003**

Cera d'api per finitura corten

Beeswax for Corten finishing

**SL 0019**

Sigillante a freddo per giunzione
angoli e trasversi

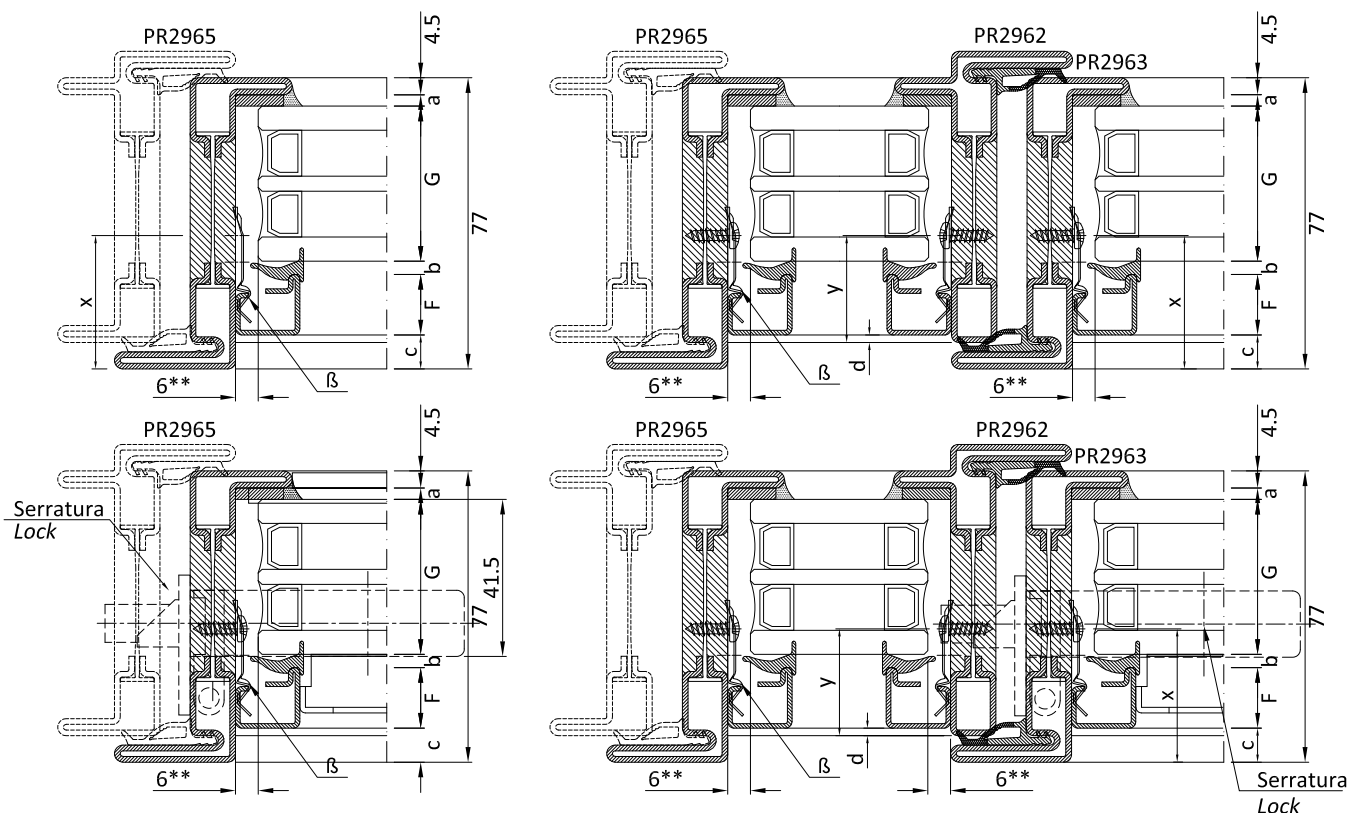
*Cold sealant for corner and
transom joints*

1 kg

**SL 0021**

Silicone nero per guarnizioni

Black silicone for gaskets



F	G	Guarnizioni - gasket		asse fissaggio viti fermavetro glazing beads securing axis		rientro fermavetro glazing beads gap		boccole e viti fissaggio fermavetro Bushings and screws for fixing of glazing bead
fermavetro glazing beads	spessore vetro glass thickness	GU2036 3 mm + sigillatura + seal	GP0095 2 / 3 mm					
codice code	mm	a	b	x	y	c	d	β
PR2606	34 - 40	3	3	42.5 - 36.5	35.5 - 29.5	16 - 10	9 - 3	AC2608
PR2607	31 - 38			42.5 - 35.5	35.5 - 28.5	16 - 9	9 - 2	AC2608
PR2627	31 - 38			42.5 - 35.5	35.5 - 28.5	16 - 9	9 - 2	AC2608
PR2629	28 - 35			53.5 - 46.5	46.5 - 39.5	16 - 9	9 - 2	AC2608
PR2638	31 - 38			50.5* - 50.5	43.5* - 43.5	16 - 9	9 - 2	AC2608

* fissare tramite il primo foro della clip

* screw in the first hole of the clip

** 7 mm per PR2638

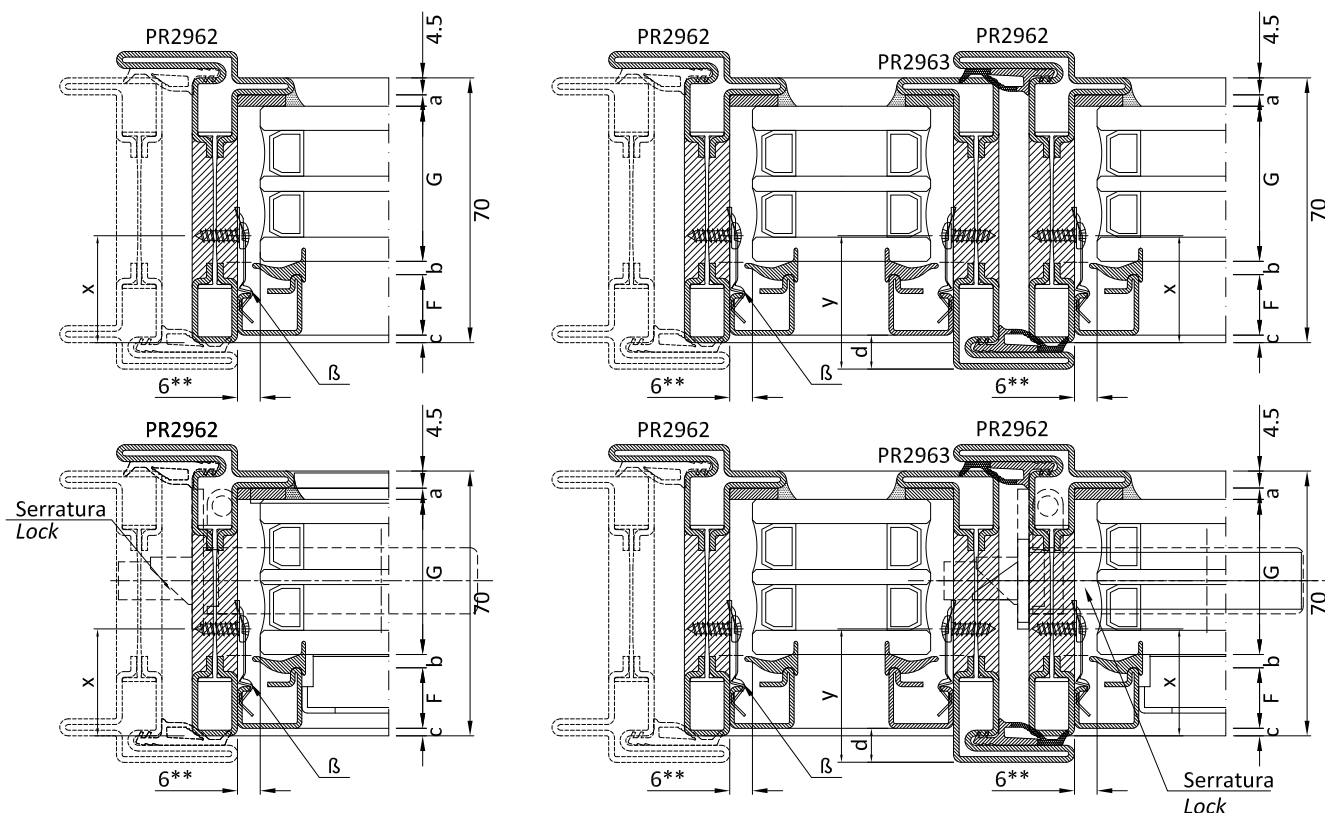
** 7 mm for PR2638

NOTA: Con serratura AC2693 utilizzare vetri con spessore ≥ 36 mm

Con serratura AC2694 utilizzare vetri con spessore = 42-43 mm

ATTN: With lock AC2693 use glass thickness ≥ 36 mm

With lock AC2694 use glass thickness = 42-43 mm



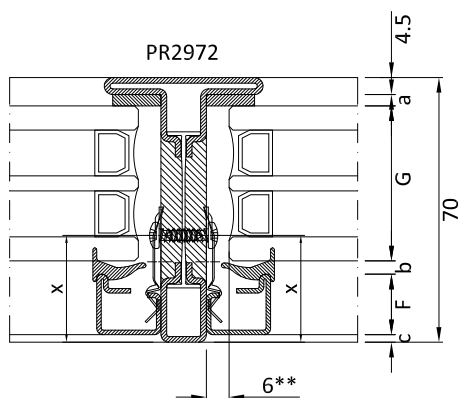
F	G	Guarnizioni - gasket						
fermavetro glazing beads	spessore vetro glass thickness	GU2036 3 mm + sigillatura + seal	GP0095 2 / 3 mm	asse fissaggio viti fermavetro glazing beads securing axis		rientro fermavetro glazing beads gap		boccole e viti fissaggio fermavetro Bushings and screws for fixing of glazing bead
codice code	mm	a	b	x	y	c	d	β
PR2606	34 - 40	3	3	35.5 - 29.5	42.5 - 36.5	9 - 3	16 - 10	AC2608
PR2607	31 - 38			35.5 - 28.5	42.5 - 35.5	9 - 2	16 - 9	AC2608
PR2627	31 - 38			35.5 - 28.5	42.5 - 35.5	9 - 2	16 - 9	AC2608
PR2629	28 - 35			39.5 - 32.5	46.5 - 39.5	9 - 2	16 - 9	AC2608
PR2638	31 - 38			43.5 - 43.5*	50.5 - 50.5*	9 - 2	16 - 9	AC2608

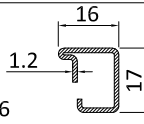
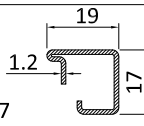
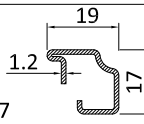
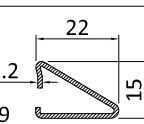
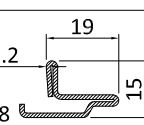
* fissare tramite il primo foro della clip
* screw in the first hole of the clip

NOTA: Con serratura AC2693 utilizzare vetri con spessore ≥ 36 mm
Con serratura AC2694 utilizzare vetri con spessore ≥ 32 mm

ATTN: With lock AC2693 use glass thickness ≥ 36 mm
With lock AC2694 use glass thickness ≥ 32 mm

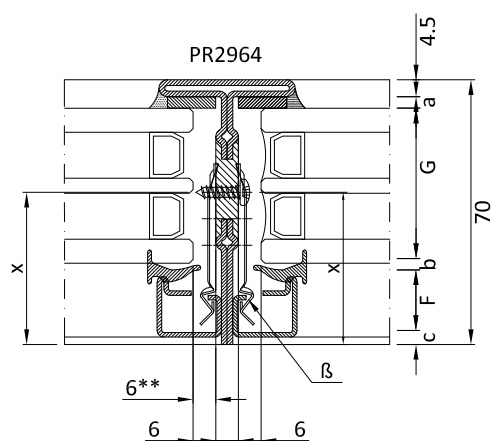
** 7 mm per PR2638
** 7 mm for PR2638



F	G	Guarnizioni - gasket					
fermavetro glazing beads	spessore vetro glass thickness	GU2036 3 mm + sigillatura + seal	GP0095 2 / 3 mm	asse fissaggio viti fermavetro glazing beads securing axis	rientro fermavetro glazing beads gap	boccole e viti fissaggio fermavetro Bushings and screws for fixing of glazing bead	
codice code	mm	a	b	x	c	d	β
PR2606 	34 - 40	3	3	35.5 - 29.5	9 - 3	16 - 10	AC2608
PR2607 	31 - 38			35.5 - 28.5	9 - 2	16 - 9	AC2608
PR2627 	31 - 38			35.5 - 28.5	9 - 2	16 - 9	AC2608
PR2629 	28 - 35			39.5 - 32.5	9 - 2	16 - 9	AC2608
PR2638 	31 - 38			43.5 - 43.5*	9 - 2	16 - 9	AC2608

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

** 7 mm per PR2638
** 7 mm for PR2638



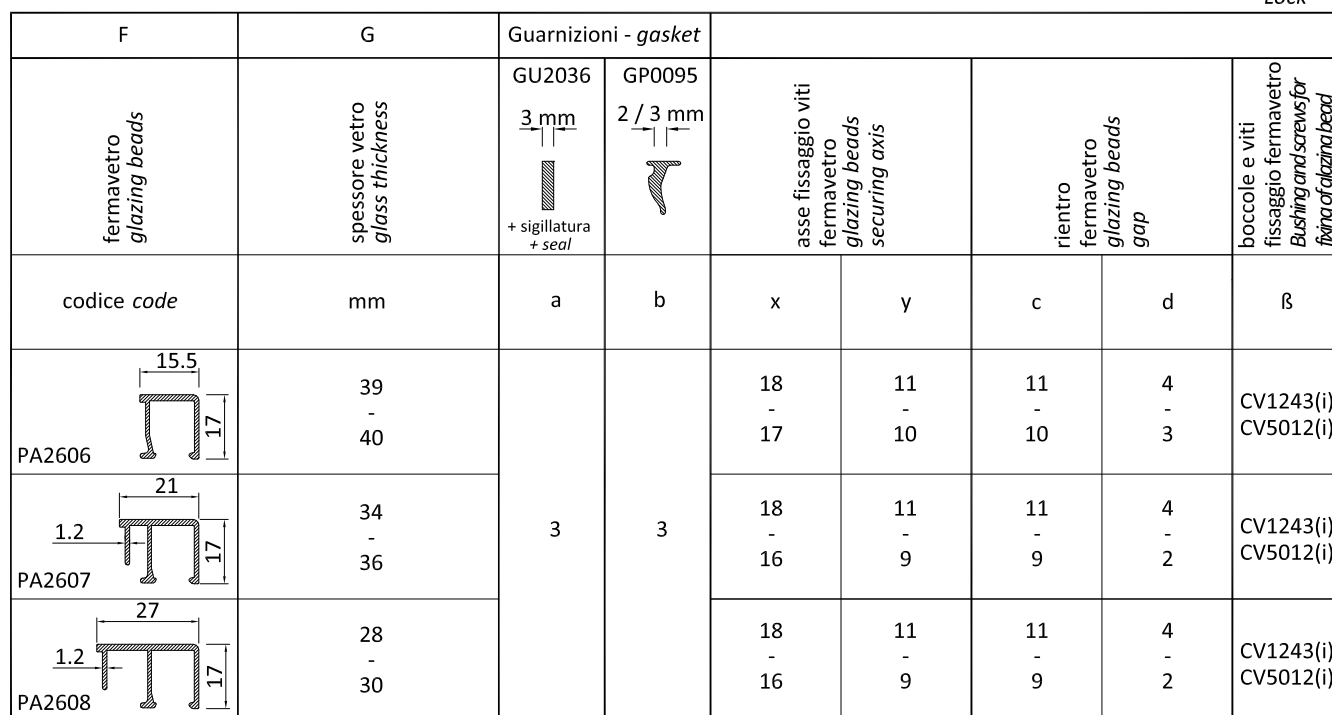
F	G	Guarnizioni - gasket				
fermavetro glazing beads	spessore vetro glass thickness	GU2036 3 mm + sigillatura + seal	GP0095 2 / 3 mm	asse fissaggio viti fermavetro glazing beads securing axis	rientro fermavetro glazing beads gap	boccole e viti fissaggio fermavetro Bushings and screws for fixing of glazing bead
codice code	mm	a	b	x	c	β
PR2606 	34 - 40	3	3	41* - 42***	9 - 3	AC2609AR
PR2607 	31 - 38			41* - 41***	9 - 2	AC2609AR
PR2627 	31 - 38			41* - 41***	9 - 2	AC2609AR

* fissare tramite il secondo foro della clip

* screw in the first hole of the clip

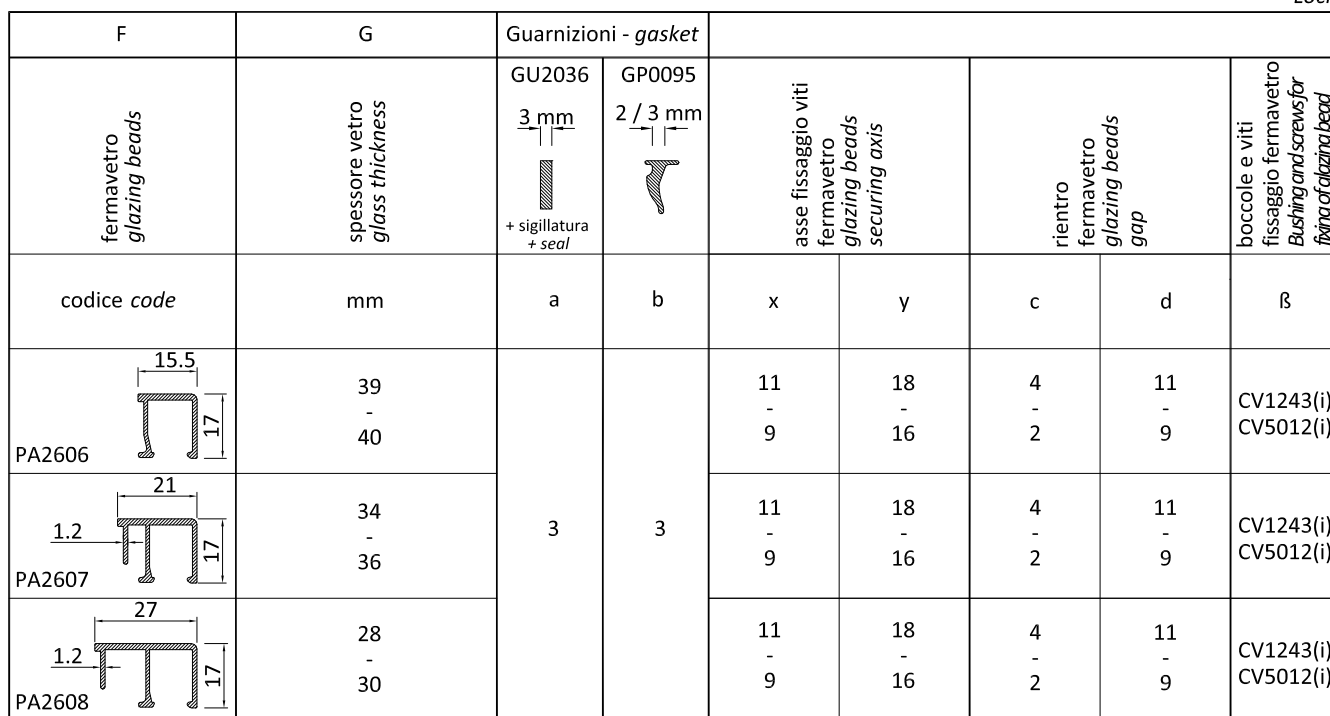
*** fissare tramite il terzo foro della clip

*** screw in the third hole of the clip



With lock AC2694 use glass thickness ≥ 44 mm

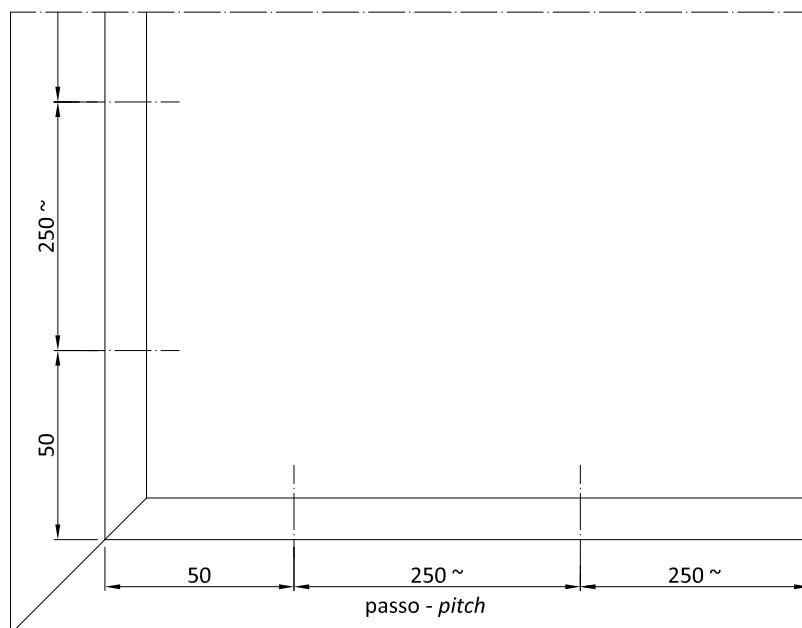
* Pay attention fixing the screw near cremone set - see pg. 2.9.13



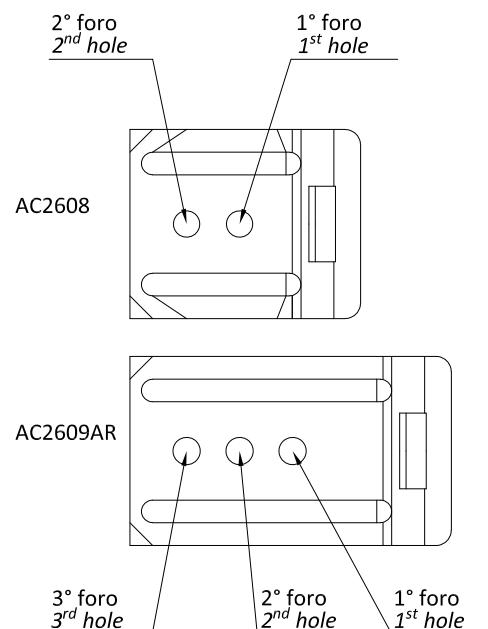
With lock AC2694 use glass thickness ≥ 32 mm

* Pay attention fixing the screw near cremone set - see pg. 2.9.13

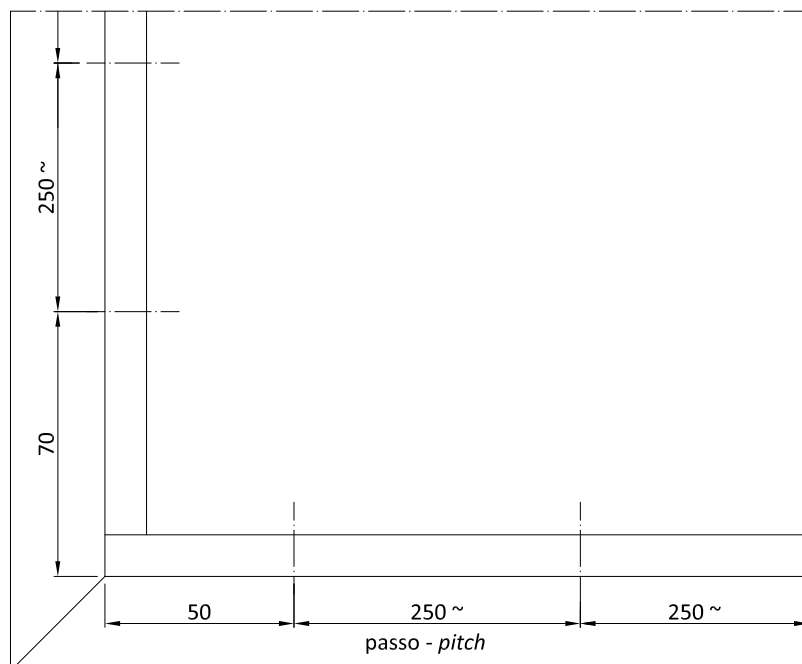
Fissaggio fermavetri PR2606 - PR2607 - PR2627 - PR2629: clip AC2608/AC2609 con vite TC 3.5 x 9.5 (non fornite)
 Glazing beads fixing PR2606 - PR2607 - PR2627 - PR2629: clip AC2608 /AC2609 with screw TC 3.5 x 9.5 (not included)



Passo clips fissaggio fermavetri
 Clip pitch for glazing beads securing

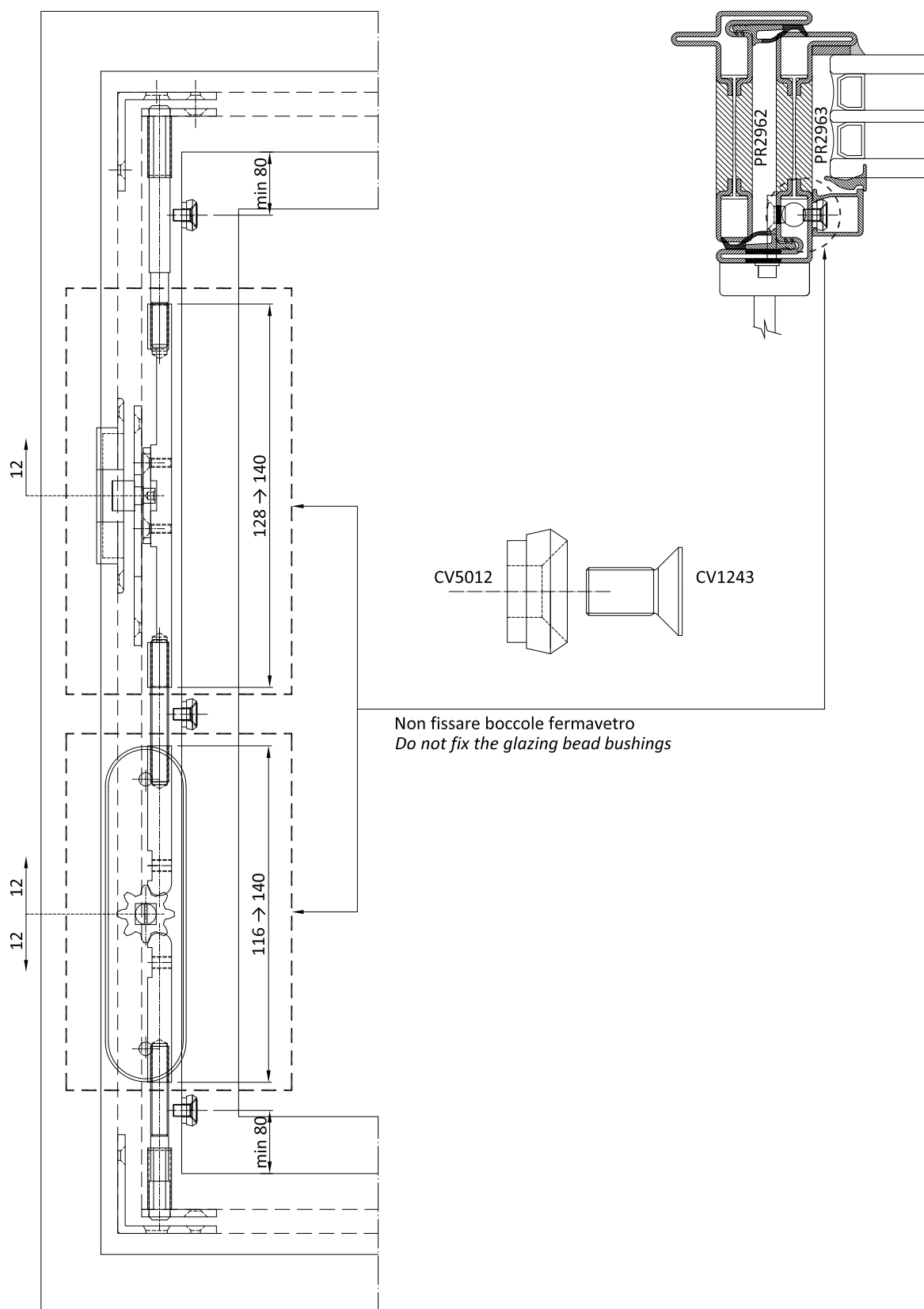


Fissaggio fermavetri PA2607 - PA2608: profili telaio vite CV1023(I) TPS 4,2 x 13 e boccola CV5012(I)
 Profili anta vite CV1243(I) TPS M4 x 8 e boccola CV5012(I).
 Glazing bead fixing PA2607 - PA2608: frame profile screw CV1023(I) TPS 4,2 x 13 and bushing CV5012(I)
 Leaf profile screw CV1243(I) TPS M4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

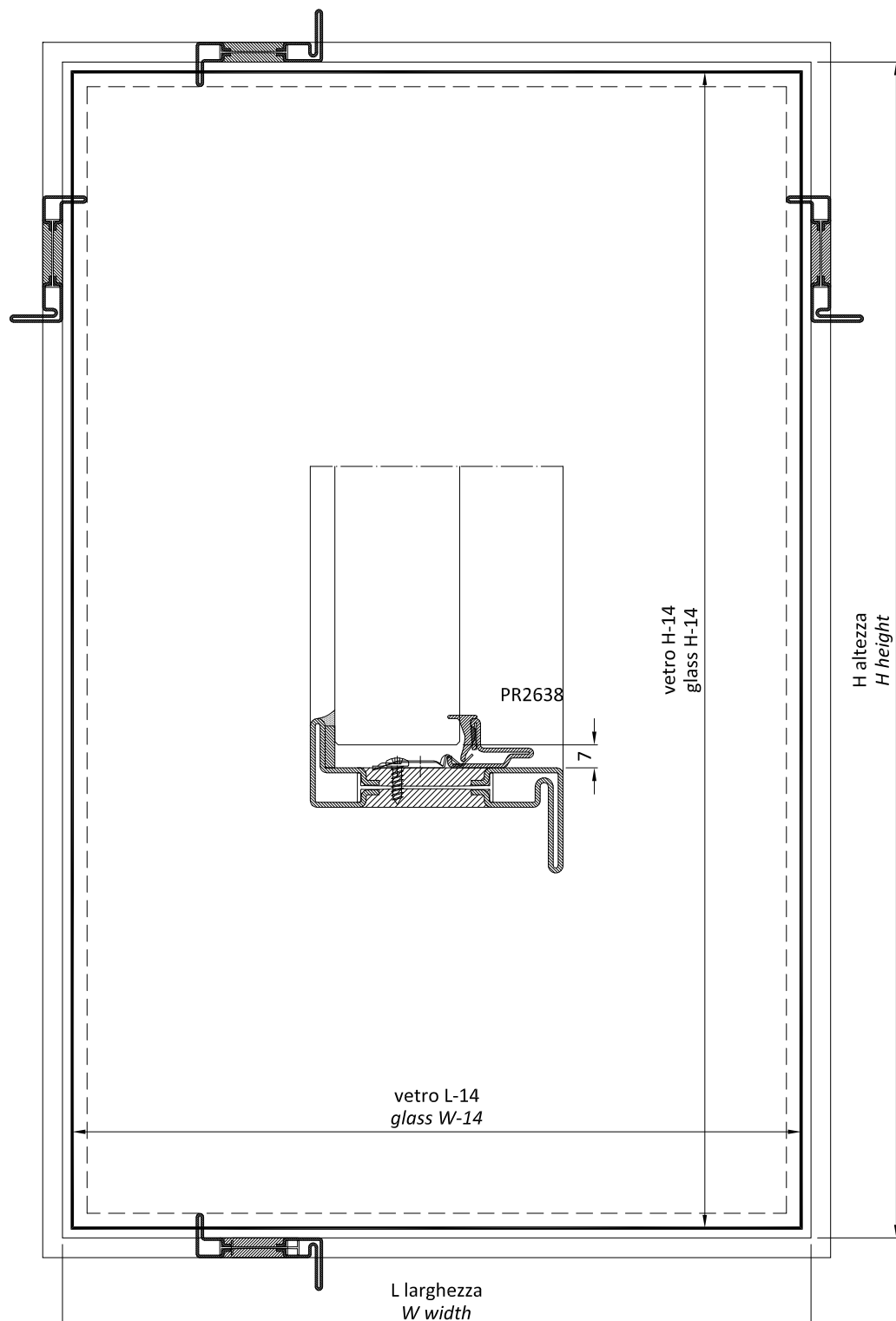
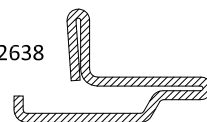


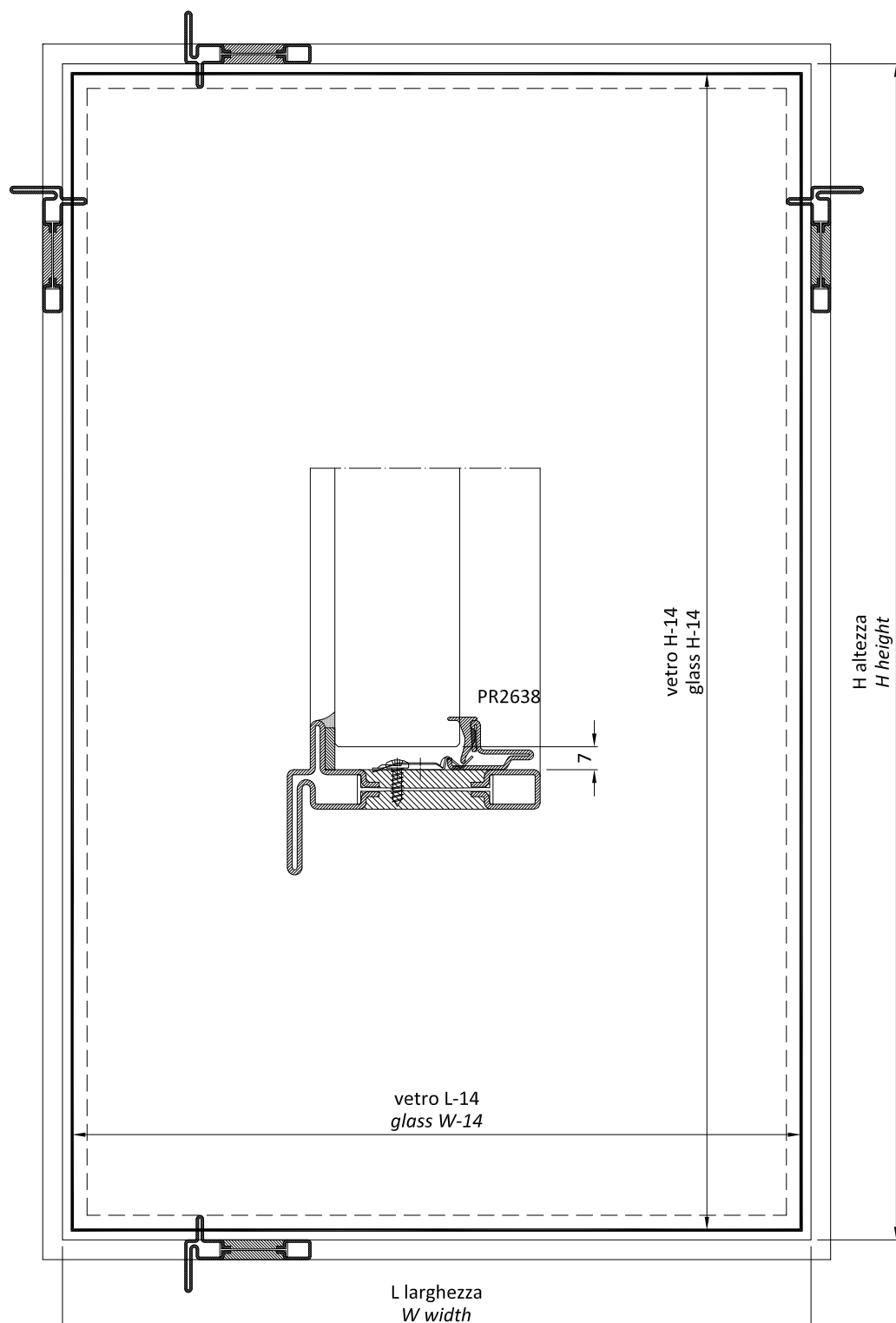
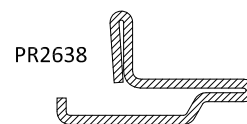
Passo vite e boccola fissaggio fermavetri
 Screw and bushing pitch for glazing beads fixing

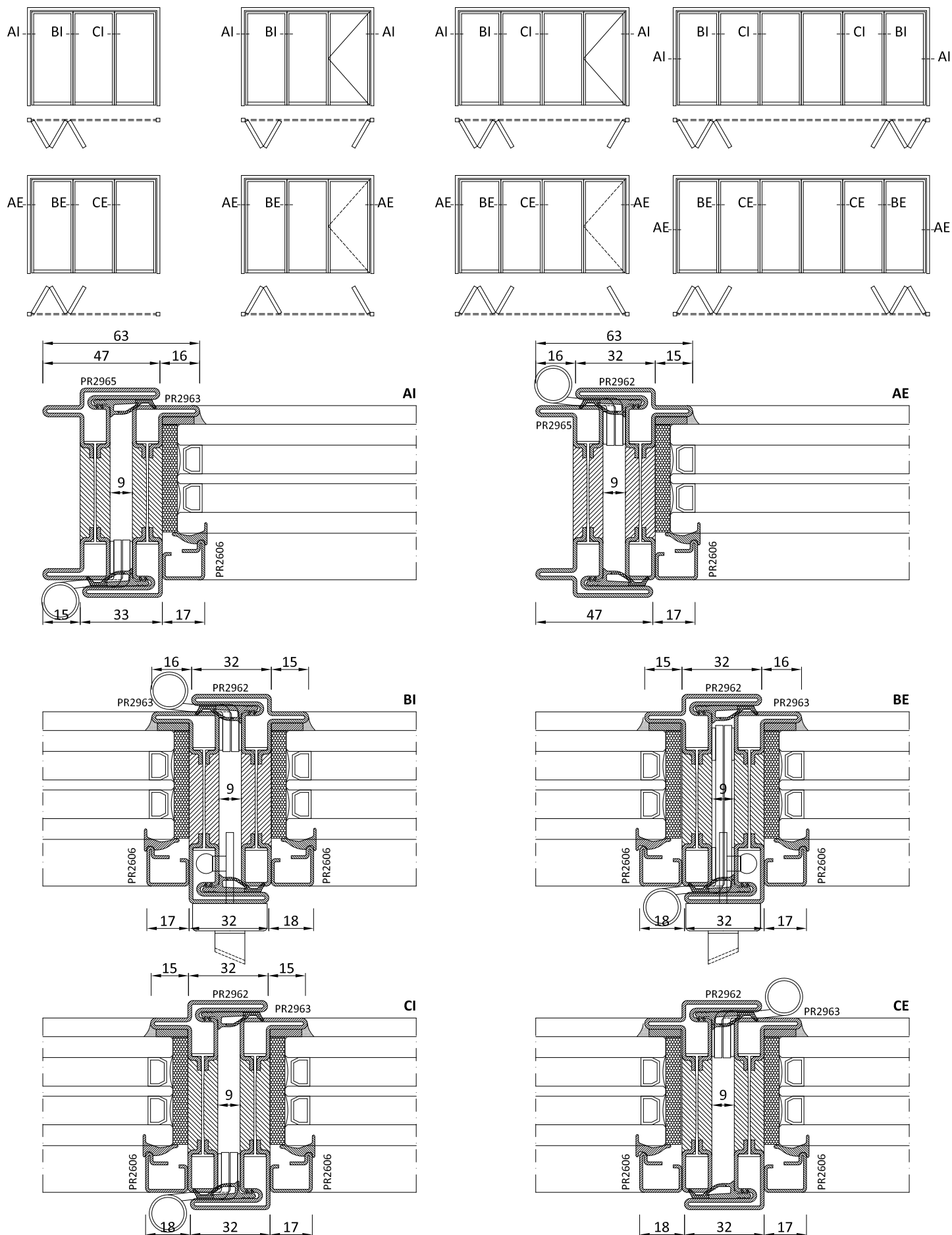
Boccole fissaggio fermavetri in alluminio
Bushing fixing for aluminium glazing beads

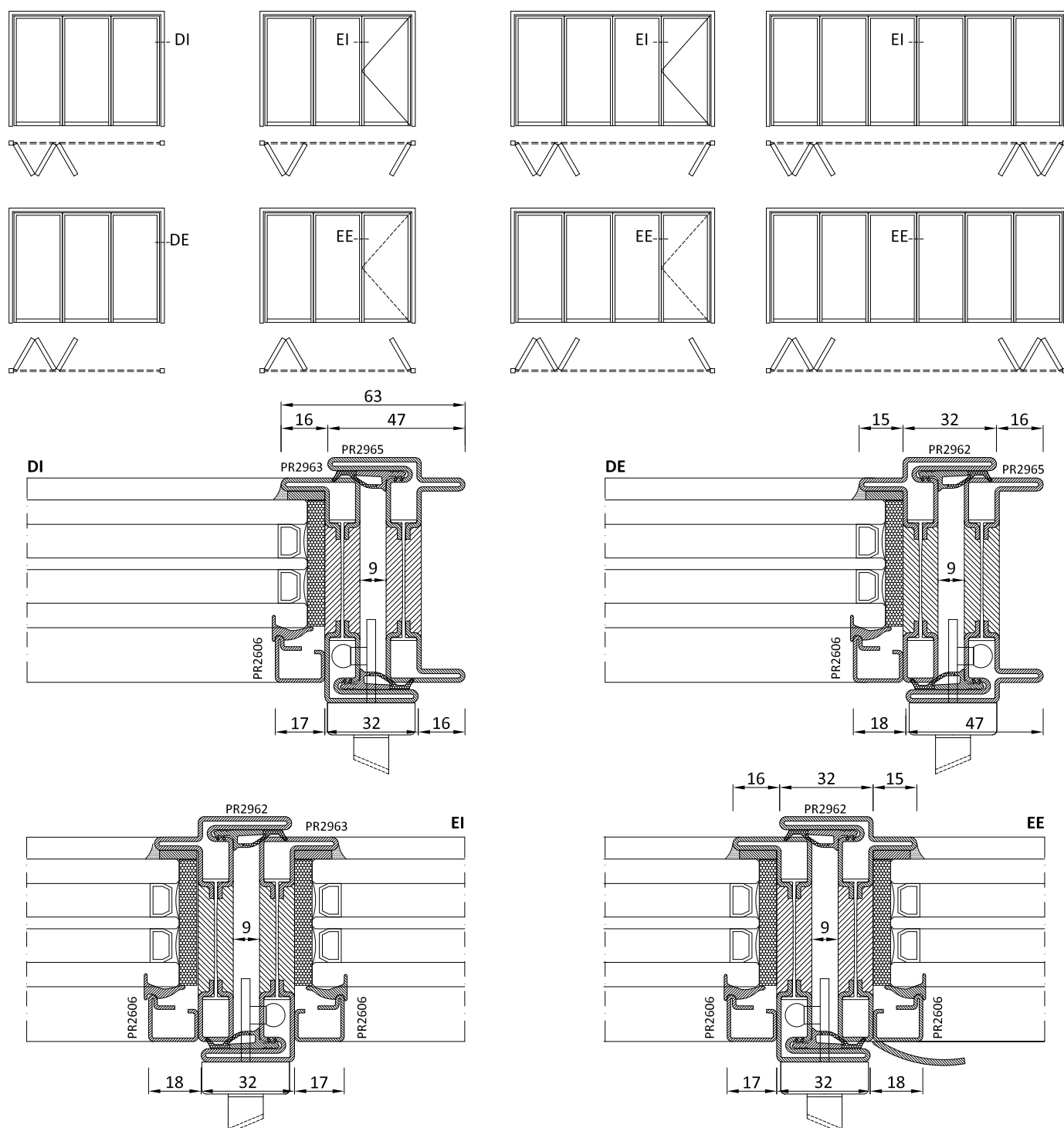


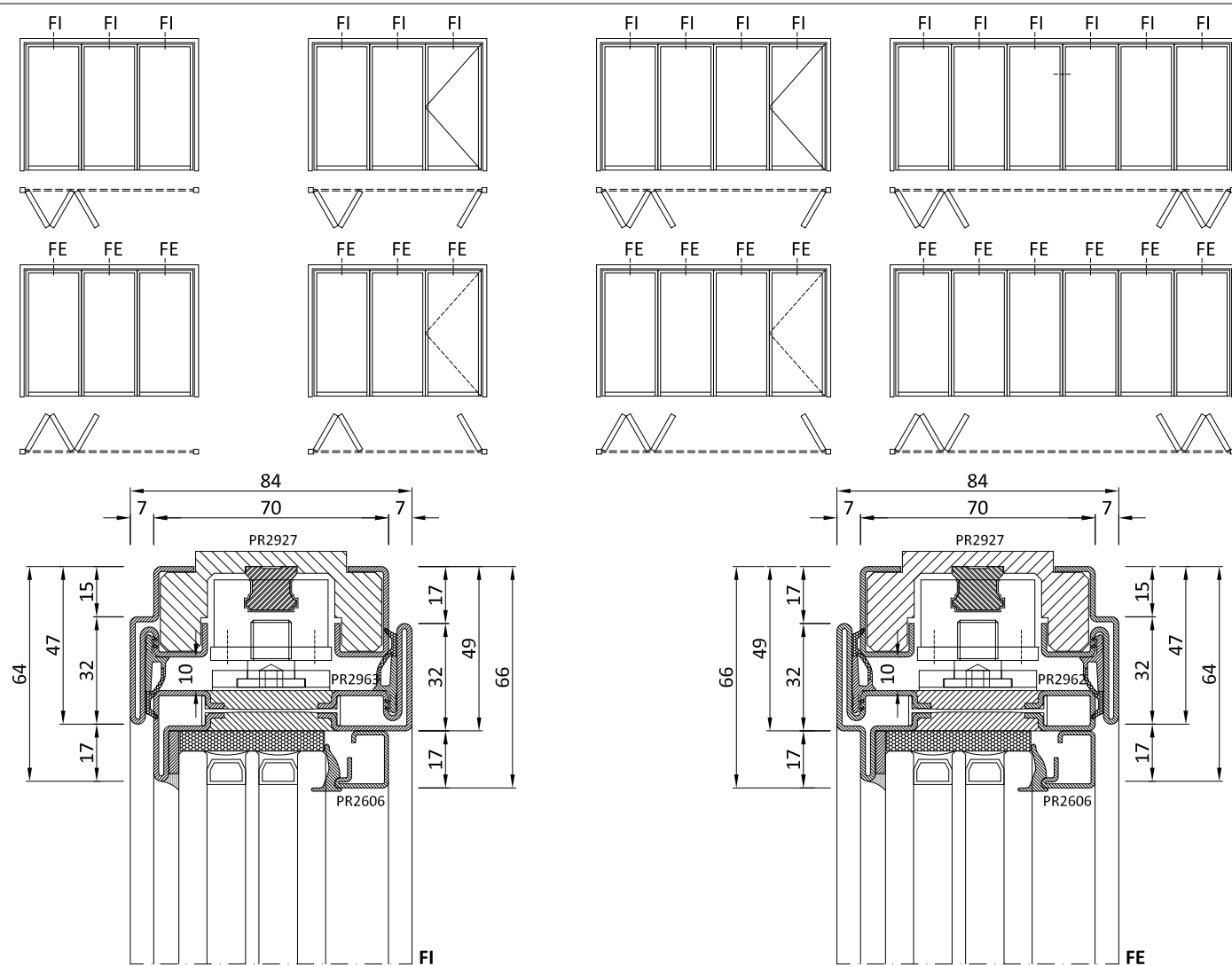
PR2638

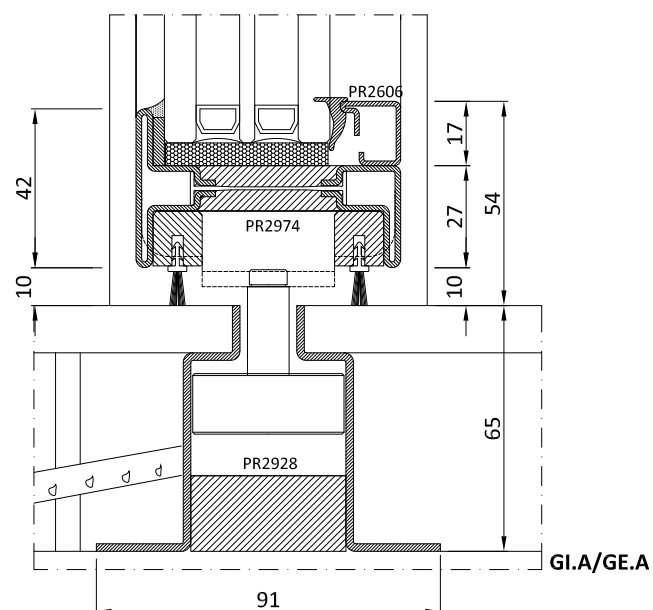
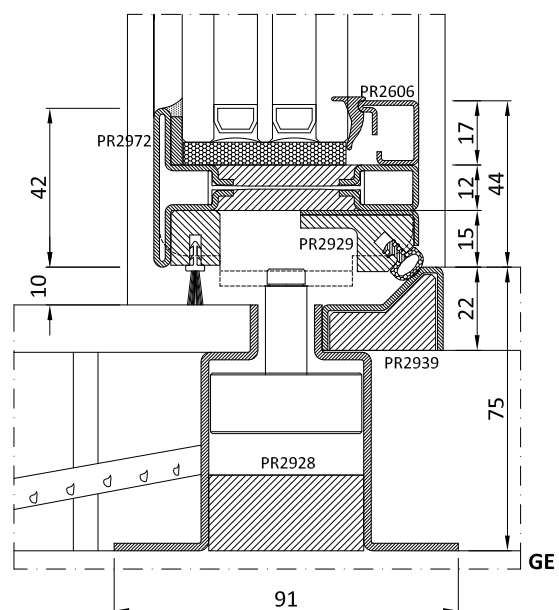
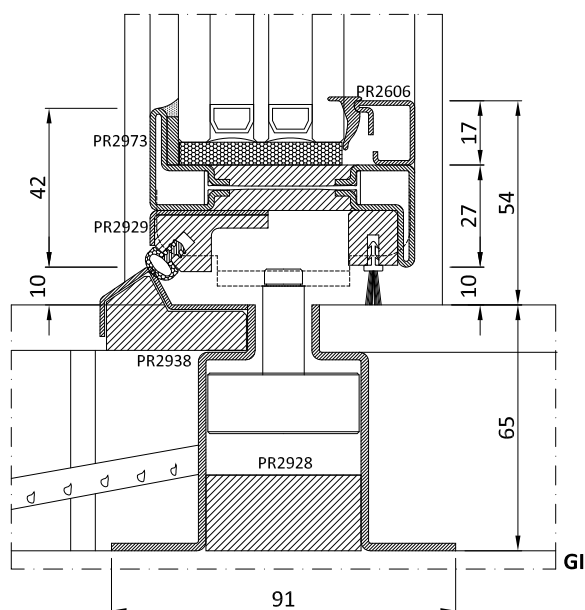
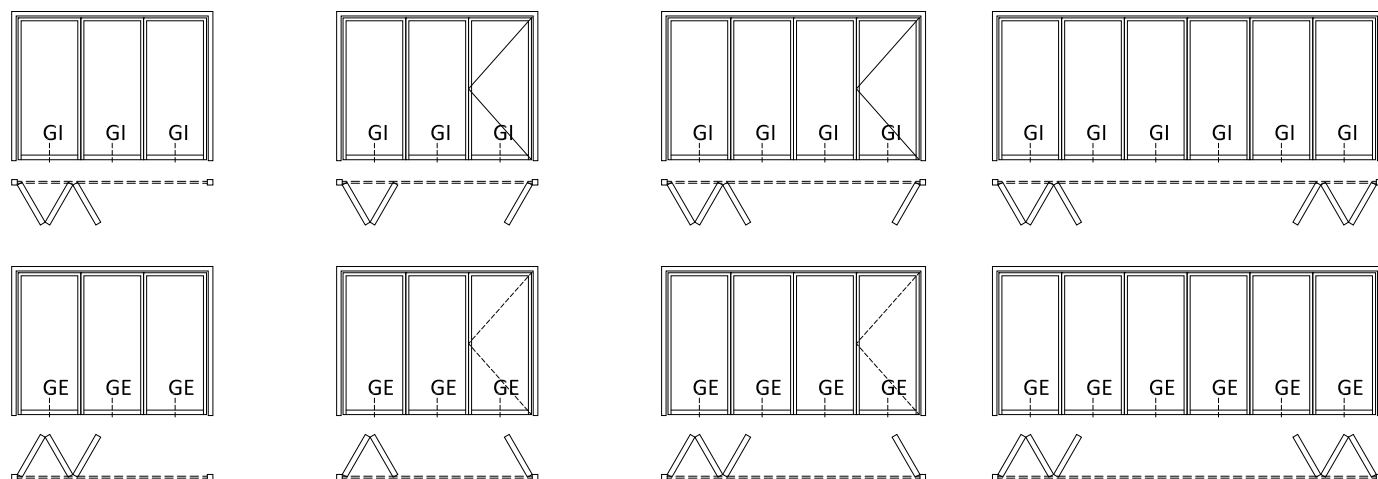


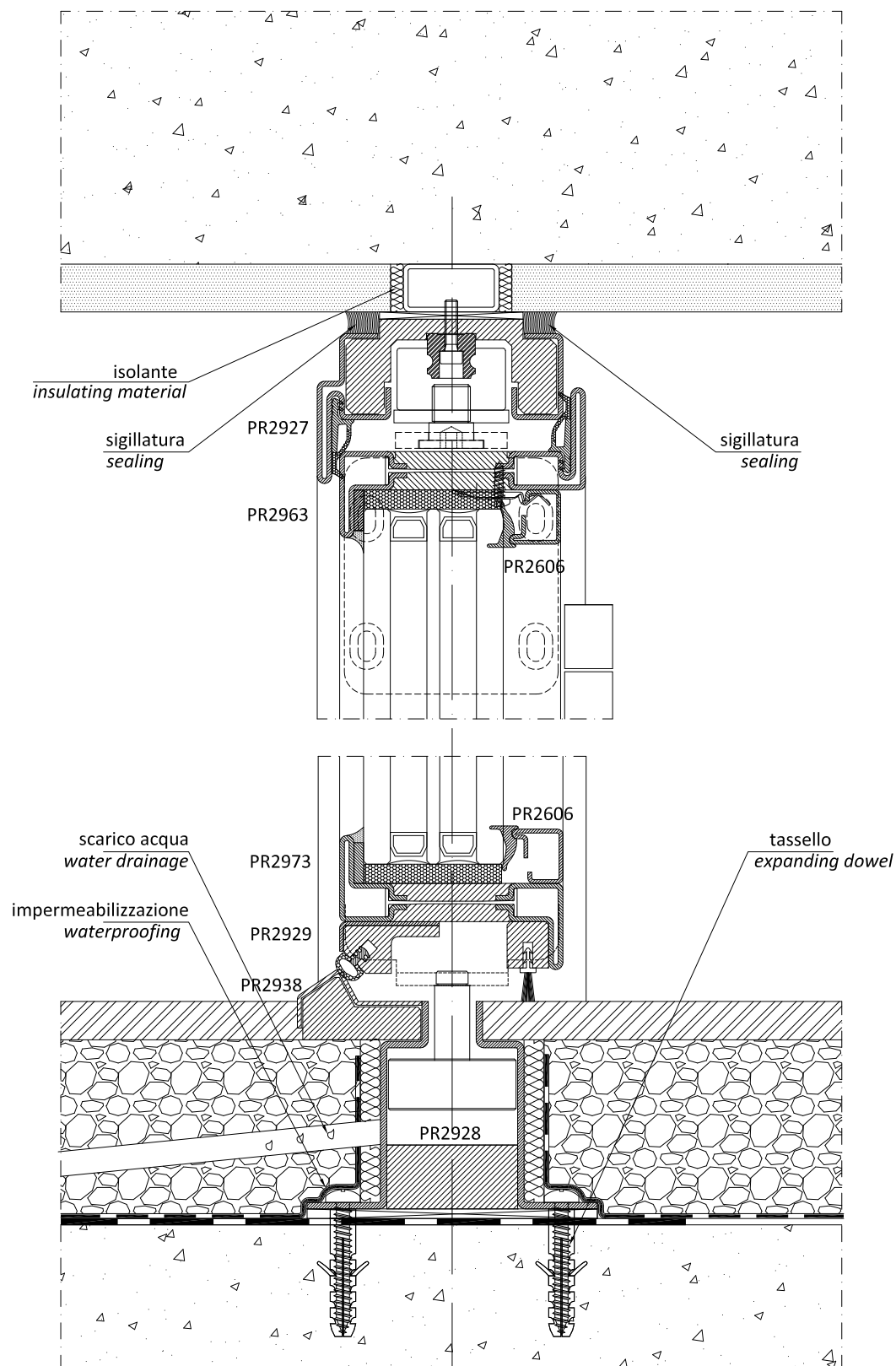


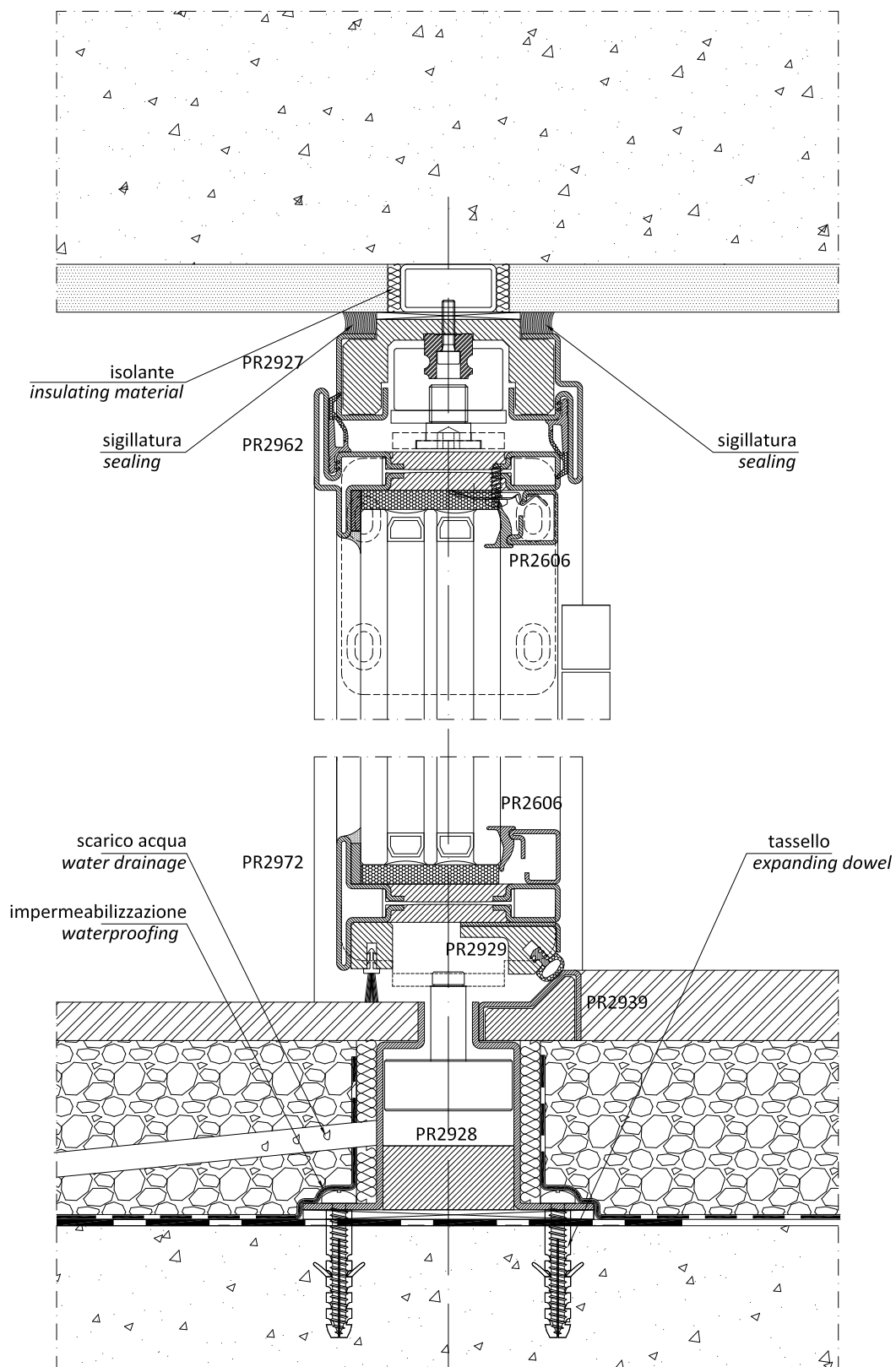


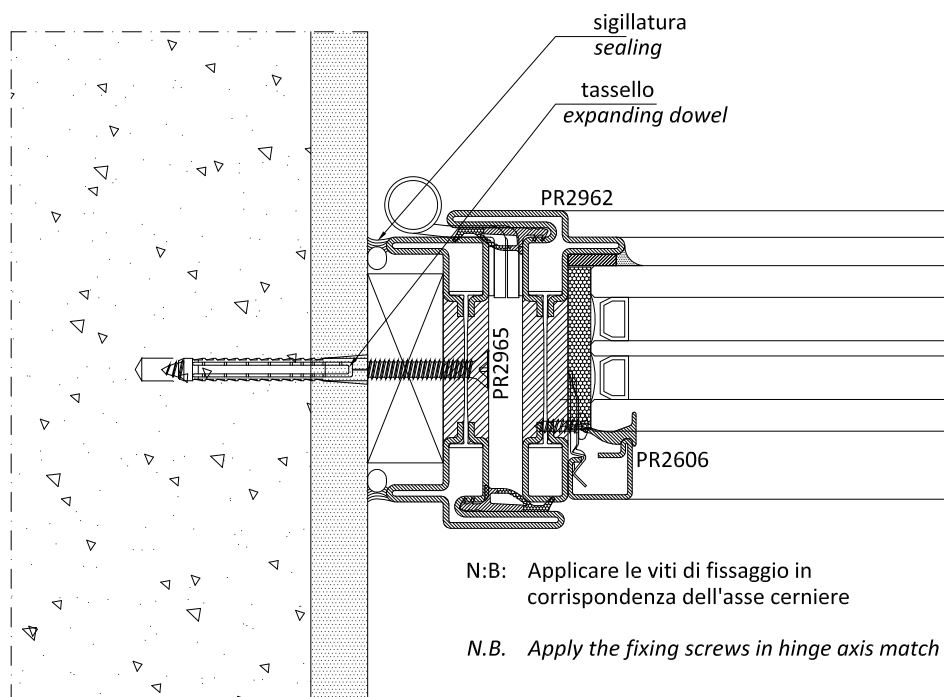
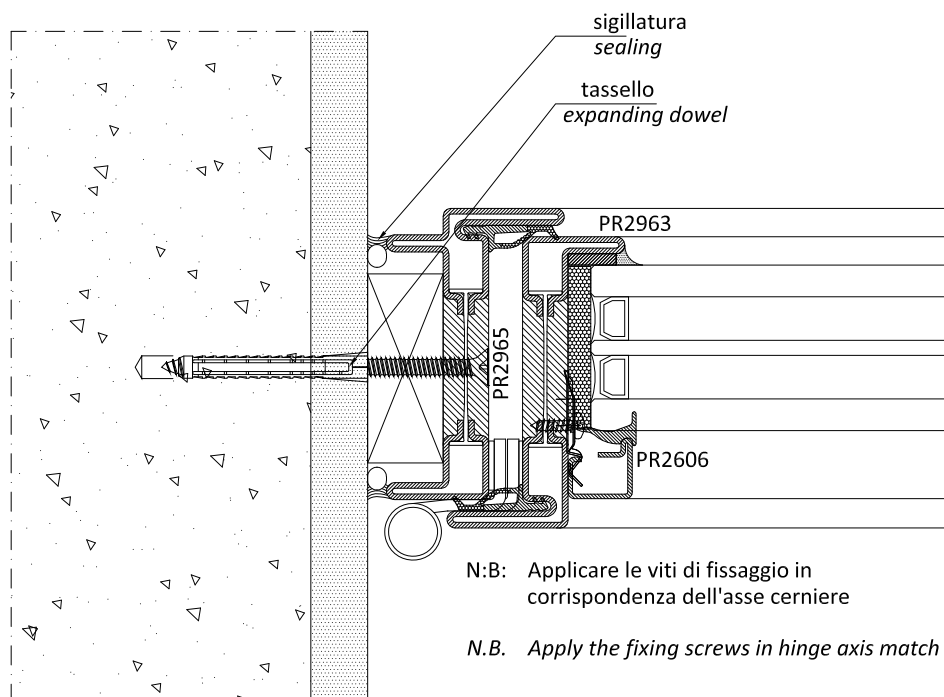


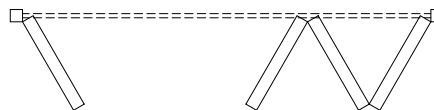
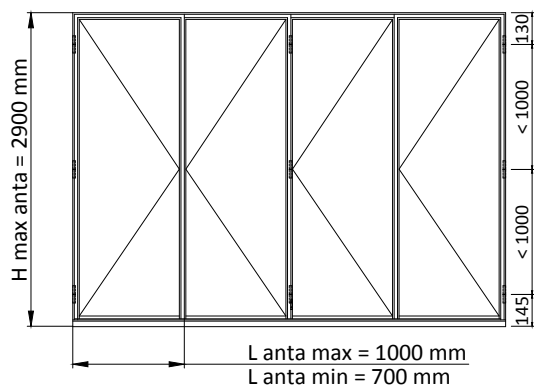




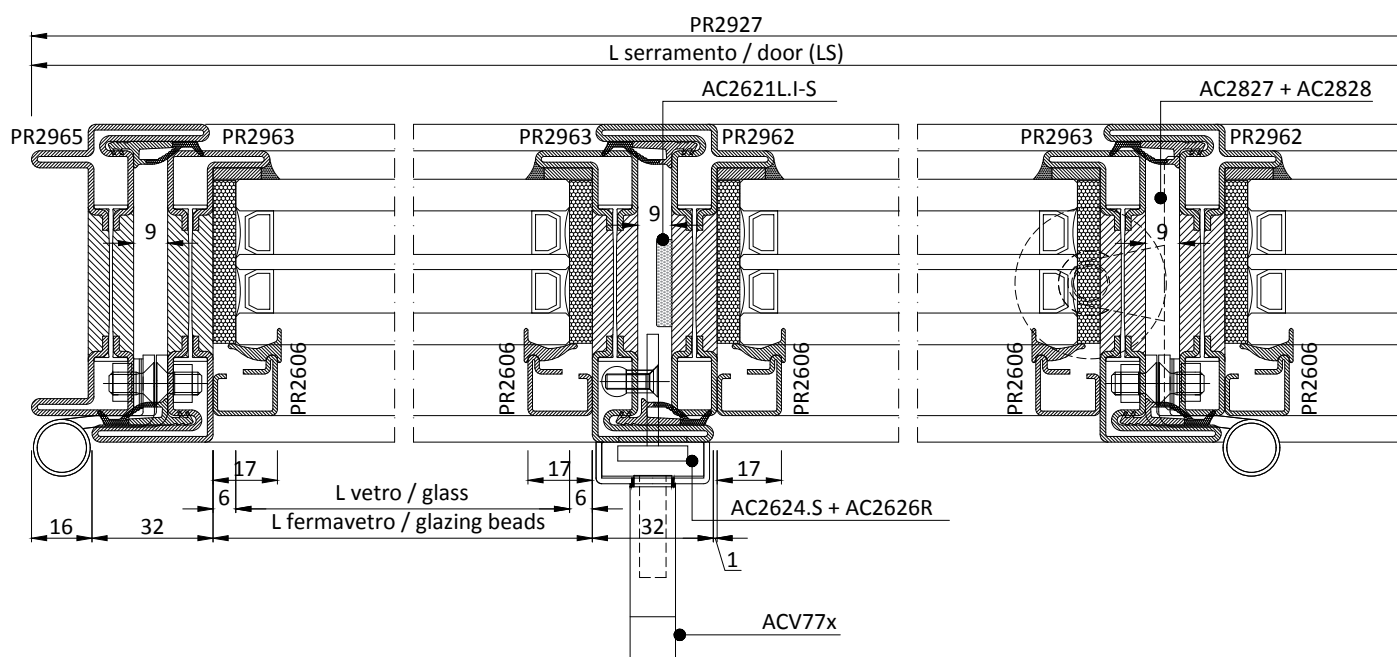








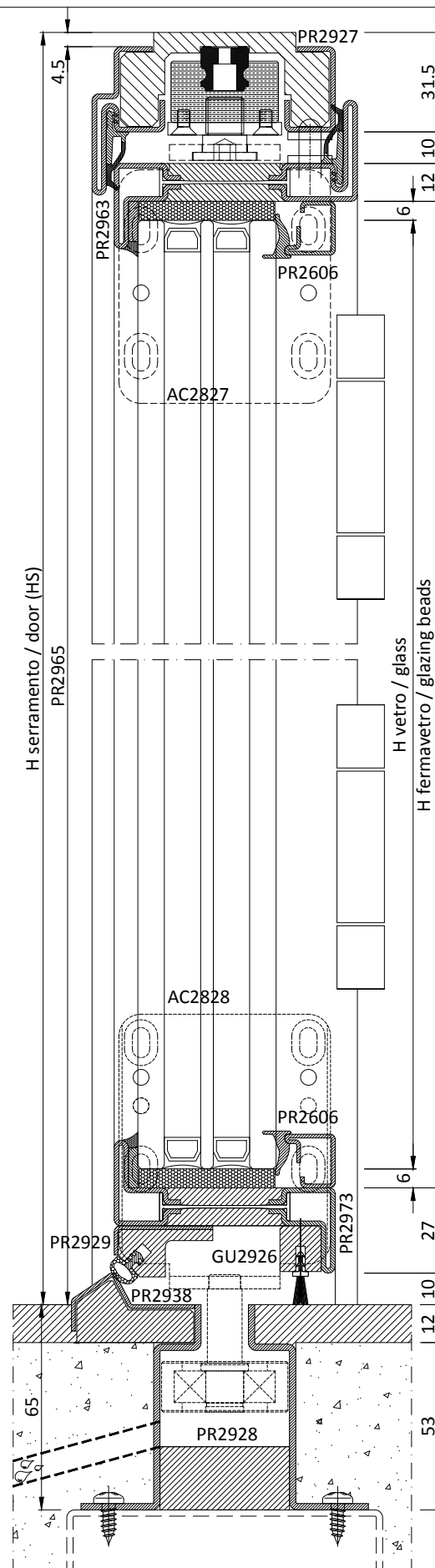
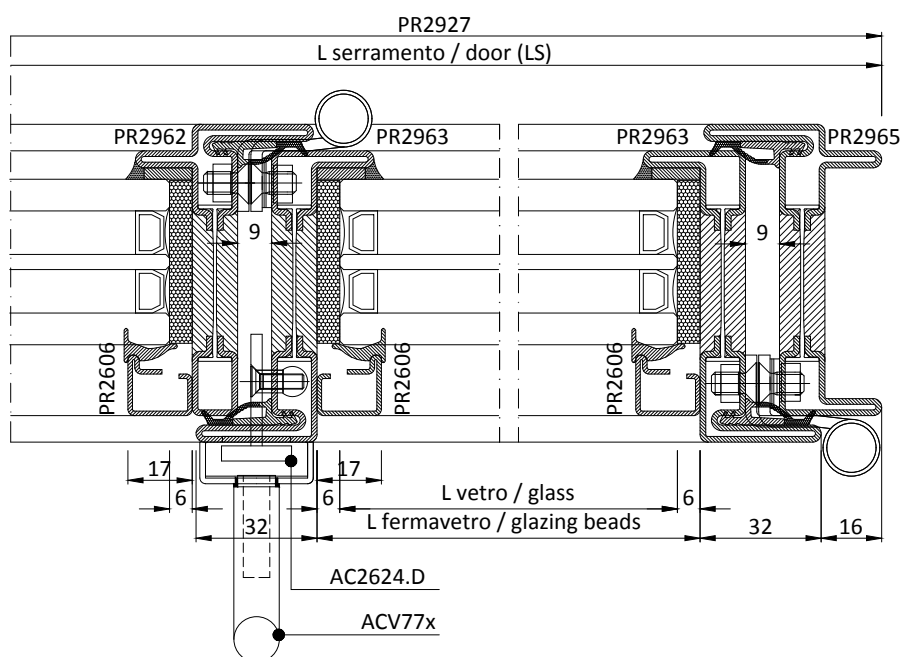
Cod.	PROFILI Descrizione	PROFILES Description	n°	Dim.	Taglio	Cutting
	Telaio	Frame				
PR2965	Profilo Zoccolo	Socle profile	1	HS - 4.5	45°	90°
PR2965	Profilo Zoccolo	Socle profile	1	HS - 4.5	90°	45°
PR2927a	Profilo Guida superiore	Upper rail profile	1	LS + 9	45°	45°
PR2927b	Guida superiore	Upper rail	1	LS-54	90°	90°
PR2928	Profilo Guida inferiore	Bottom rail profile	1	LS	90°	90°
PR2938	Profilo Battuta inferiore	Lower fitting for profiles	1	LS-54	90°	90°
	Anta	Leaf				
PR2963	Profilo a "Z" anta	"Z" profile leaf	3	H - 31.5	45°	90°
PR2963	Profilo a "Z" anta	"Z" profile leaf	2	H - 31.5	90°	45°
PR2963	Profilo a "Z" anta	"Z" profile leaf	4	(LS+61)/4	45°	45°
PR2962	Profilo a "T" anta	"T" profile leaf	1	H - 31.5	45°	90°
PR2962	Profilo a "T" anta	"T" profile leaf	2	H - 31.5	90°	45°
PR2973	Profilo Zoccolo	Socle profile	4	(LS-195)/4	90°	90°
PR2929	Profilo Finitura Inferiore	Bottom finishing profile	4	(LS-99)/4	90°	90°
GU2926	Profilo porta spazzolino inferiore	Lower brush profile	4	(LS-99)/4	90°	90°
	Fermavetri	Glazing beads				
PR2606	Profilo fermavetro	Glazing bead profile	8	(LS-195)/4	45°	45°
PR2606	Profilo fermavetro	Glazing bead profile	8	H - 90.5	45°	45°
	Vetri	Glass unit				
-	Vetrocamera	Insulated glass	4	(LS-243)/4 x HS-102		

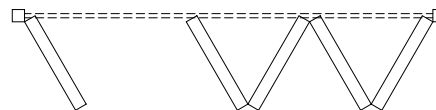
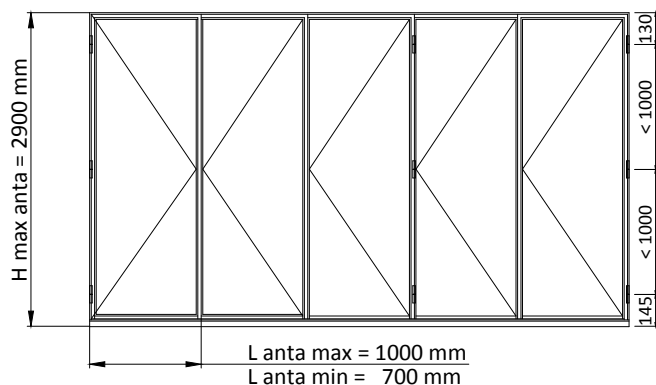


* solo con profili ottone
only with brass profiles

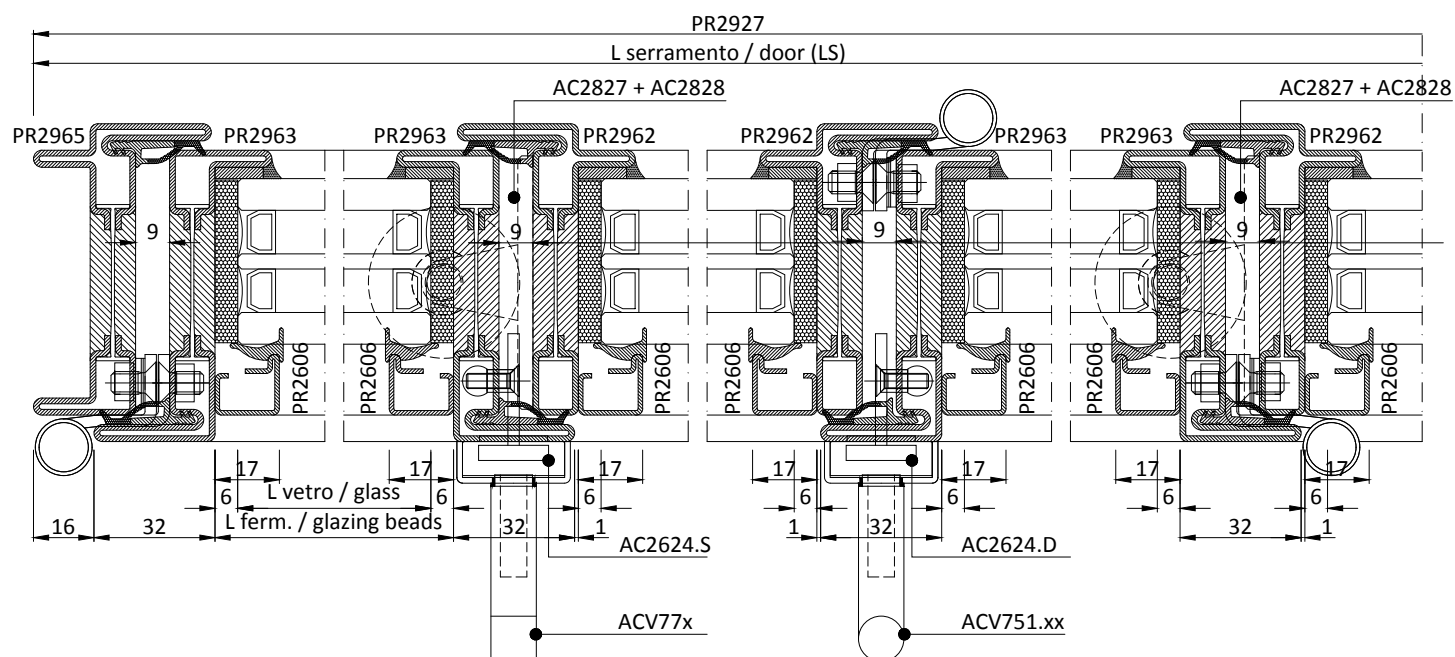
	ACCESSORI	HARDWARE	
Cod.	Descrizione	Description	n°
AC2608	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.
AC2626R	Kit chiusura aggiuntiva	Additional locking point	Var.
AC2621L.I	Catenaccio 2^ anta (H 450)	Second leaf bolt	1
AC2621L.S	Catenaccio 2^ anta (H 650)	Second leaf bolt	1
AC2653.xx	Fondino per 2^ anta	Bottom plate for second leaf	3
AC2656.xx	Fondino inferiore	Lower fitting for profiles	3
AC2818I	Staffa inf. aggancio telaio	Bottom bracket	2
AC2819	Kit tappo chiusura guida	Rail closure cap	2
AC1081T	Accessorio di battuta	Stop Accessory	5
AC2624.D	Kit cremonese	Cremona bolt set	1
AC2624.S	Kit cremonese	Cremona bolt set	1
AC2827	Carrello guida superiore	Upper roller	1
AC2828	Carrello guida inferiore	Bottom roller	1
AC2648.xx	Cerniere	Hinges	Var.
AC2825.xx	Kit magneti anta libera	Magnet kit for free leaf	1
AC2826.2	Kit magneti per blocco ante	Magnet kit for leaf stop	1
AC2828.F	Fermo corsa carrello inferiore	Travel stop for bottom roller	1
ACV77-.xx	Maniglia "Vitruvio"	"Vitruvio" handle	2
AC2803I*	Kit squadrette per PR2963	Corner brackets kit for PR2963	5
AC2832I*	Kit squadrette per PR2962-63	Corner brackets kit for PR2962-63	3

	GUARNIZIONI	GASKETS	
Cod.	Descrizione	Description	n° Dim.
GE1001TT	Guarnizione di battuta soglia	Threshold rebating gasket	1 1xLS
GE2645TT	Guarnizione esterna di battuta	Rebating gasket	2 1xLS+3xHS
GE2907TT	Guarnizione sotto vetro	Gasket to put under the glass	1 2xLS+4xHS
GU2036	Piattina adesiva fondo giunto	Adhesive shim for joint	1 2xLS+4xHS
GP0095	Guarnizione interna vetro	Internal weather strip	1 2xLS+4xHS
GU0100	Guarnizione esterna	External weather strip	1 1xLS





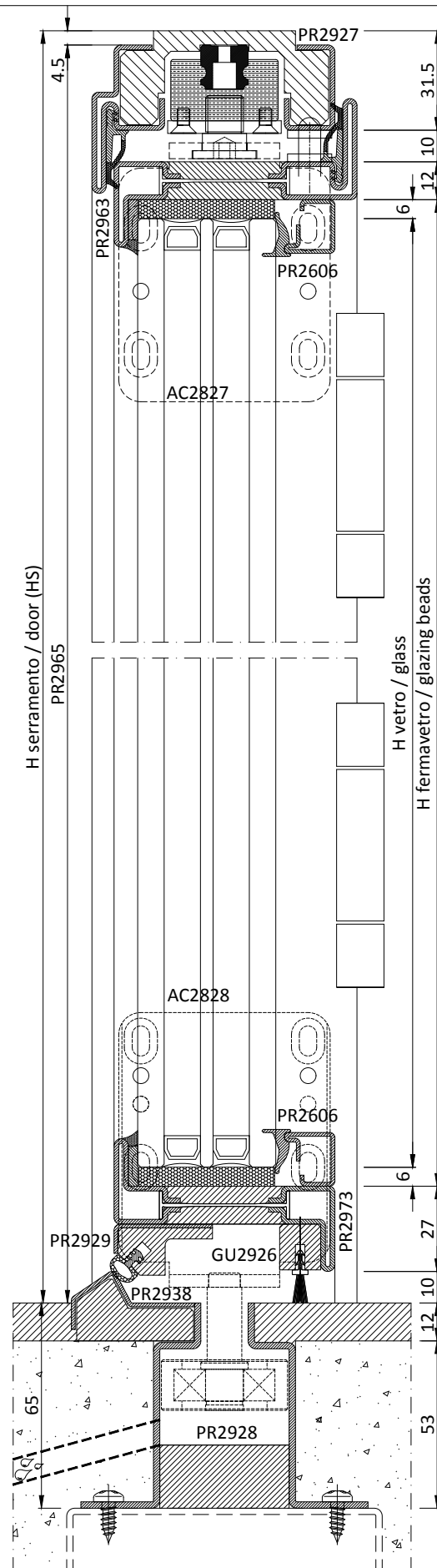
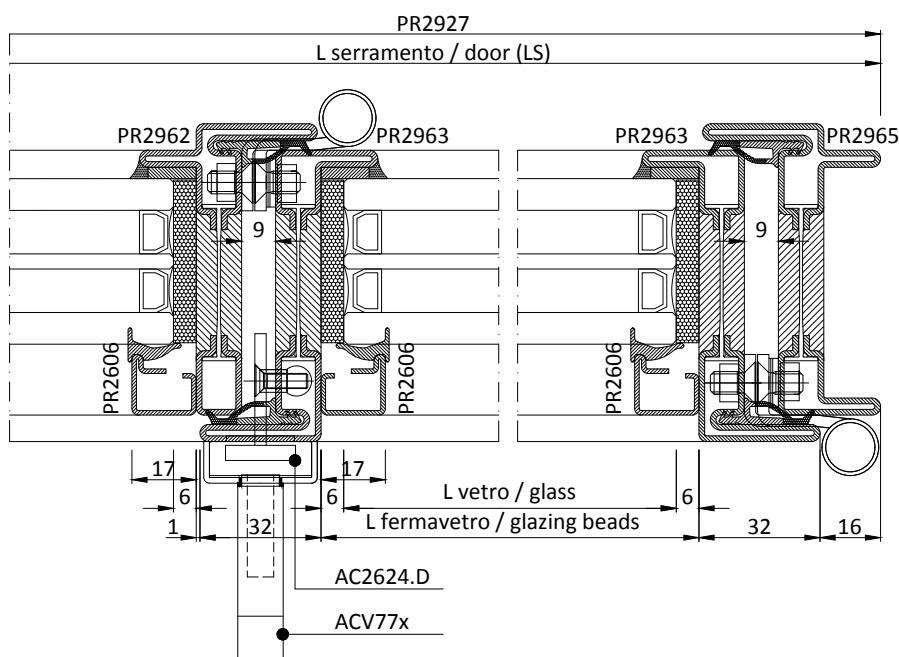
Cod.	PROFILI Descrizione	PROFILES Description	n°	Dim.	Taglio	Cutting
	Telaio	Frame				
PR2965	Profilo Zoccolo	Socle profile	1	HS - 4.5	45°	90°
PR2965	Profilo Zoccolo	Socle profile	1	HS - 4.5	90°	45°
PR2927a	Profilo Guida superiore	Upper rail profile	1	LS + 9	45°	45°
PR2927b	Guida superiore	Upper rail	1	LS-54	90°	90°
PR2928	Profilo Guida inferiore	Bottom rail profile	1	LS	90°	90°
PR2938	Profilo Battuta inferiore	Bottom profile	1	LS-54	90°	90°
	Anta	Leaf				
PR2963	Profilo a "Z" anta	"Z" profile leaf	3	H - 31.5	45°	90°
PR2963	Profilo a "Z" anta	"Z" profile leaf	3	H - 31.5	90°	45°
PR2963	Profilo a "Z" anta	"Z" profile leaf	5	(LS+92)/5	45°	45°
PR2962	Profilo a "T" anta	"T" profile leaf	2	H - 31.5	45°	90°
PR2962	Profilo a "T" anta	"T" profile leaf	2	H - 31.5	90°	45°
PR2973	Profilo Zoccolo	Socle profile	5	(LS-228)/5	90°	90°
PR2929	Profilo Finitura Inferiore	Bottom finishing profile	5	(LS-108)/5	90°	90°
GU2926	Profilo porta spazzolino inferiore	Lower brush profile	5	(LS-108)/5	90°	90°
	Fermavetri	Glazing beads				
PR2606	Profilo fermavetro	Glazing bead profile	10	(LS-228)/5	45°	45°
PR2606	Profilo fermavetro	Glazing bead profile	10	H - 90.5	45°	45°
	Vetri	Glass unit				
-	Vetrocamera	Insulated glass	5	(LS-288)/5 x HS-102		

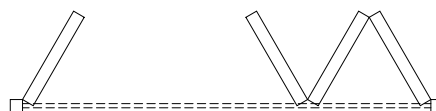
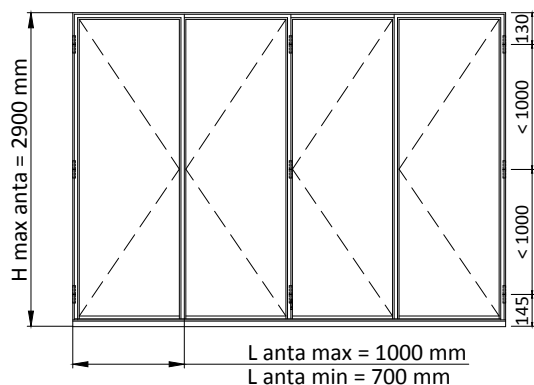


* solo con profili ottone
only with brass profiles

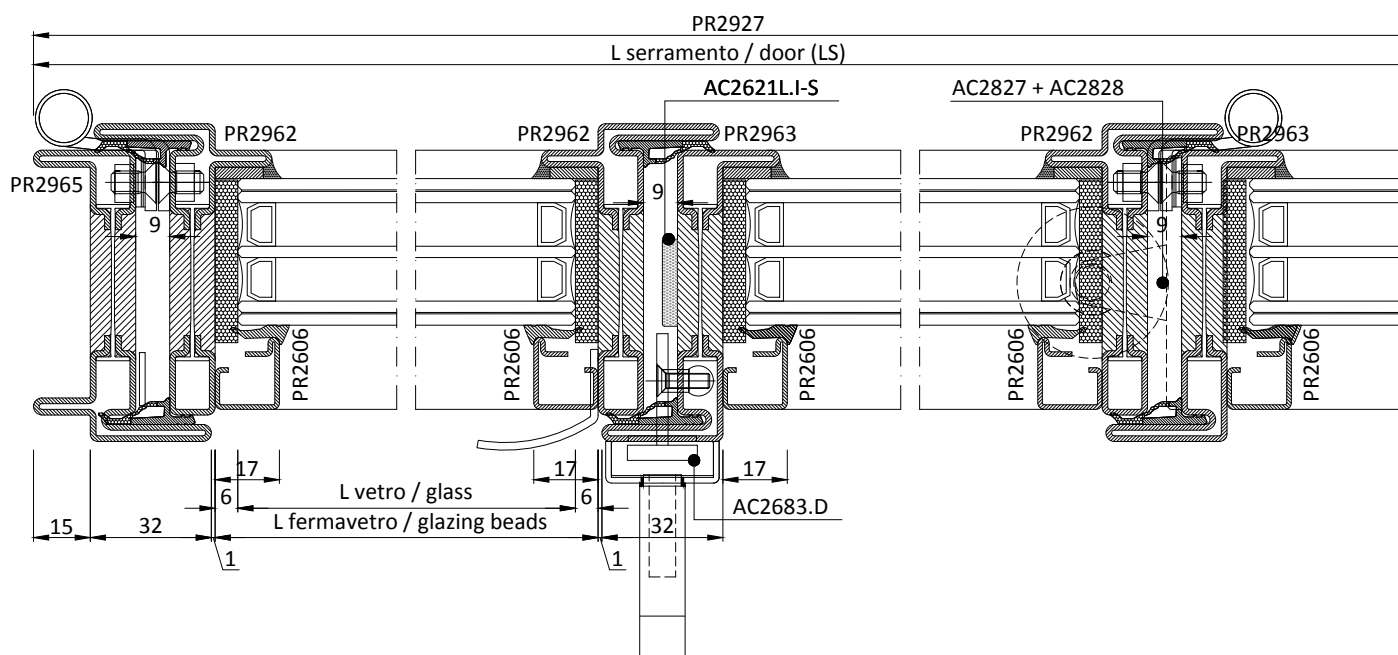
	ACCESSORI	HARDWARE	
Cod.	Descrizione	Description	n°
AC2608	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.
AC2626R	Kit chiusura aggiuntiva	Additional locking point	Var.
AC2653.xx	Fondino per 2 ^a anta	Bottom plate for second leaf	4
AC2656.xx	Fondino inferiore	Lower fitting for profiles	4
AC2818I	Staffa inf. aggancio telaio	Bottom bracket	2
AC2819	Kit tappo chiusura guida	Rail closure cap	2
AC1081T	Accessorio di battuta	Stop Accessory	6
AC2624.D	Kit cremonese	Cremone bolt set	2
AC2624.S	Kit cremonese	Cremone bolt set	1
AC2827	Carrello guida superiore	Upper roller	2
AC2828	Carrello guida inferiore	Bottom roller	2
AC2648.xx	Cerniere	Hinges	Var.
AC2826.4	Kit magneti per blocco ante	Magnet kit for leaf stop	1
AC2828.F	Fermo corsa carrello inferiore	Travel stop for bottom roller	1
ACV751.xx	Maniglia "Vitruvio" ridotta	Reduced "Vitruvio" handle	1
ACV77-.xx	Maniglia "Vitruvio"	"Vitruvio" handle	2
AC2803I*	Kit squadrette per PR2963	Corner brackets kit for PR2963	6
AC2832I*	Kit squadrette per PR2962-63	Corner brackets kit for PR2962-63	4

	GUARNIZIONI	GASKETS	
Cod.	Descrizione	Description	n° Dim.
GE1001TT	Guarnizione di battuta soglia	Threshold rebating gasket	1 1xLS
GE2645TT	Guarnizione esterna di battuta	Rebating gasket	2 1xLS+6xHS
GE2907TT	Guarnizione sotto vetro	Gasket to put under the glass	2 1xLS+5xHS
GU2036	Piattina adesiva fondo giunto	Adhesive shim for joint	2 1xLS+5xHS
GP0095	Guarnizione interna vetro	Internal weather strip	2 1xLS+5xHS
GU0100	Spazzolino soglia	Threshold brush	1 1xLS





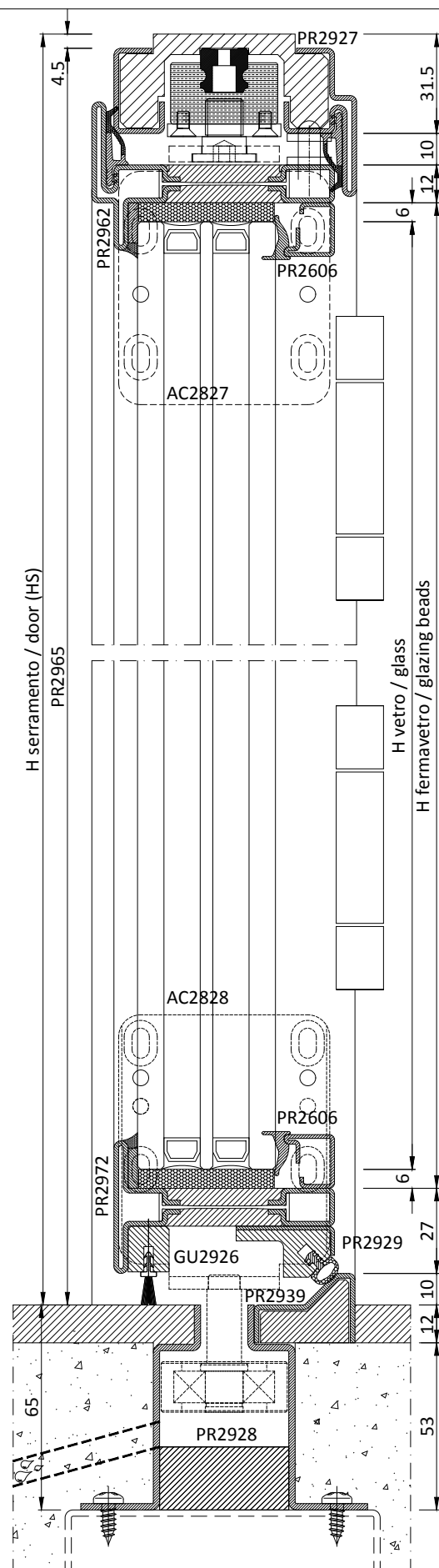
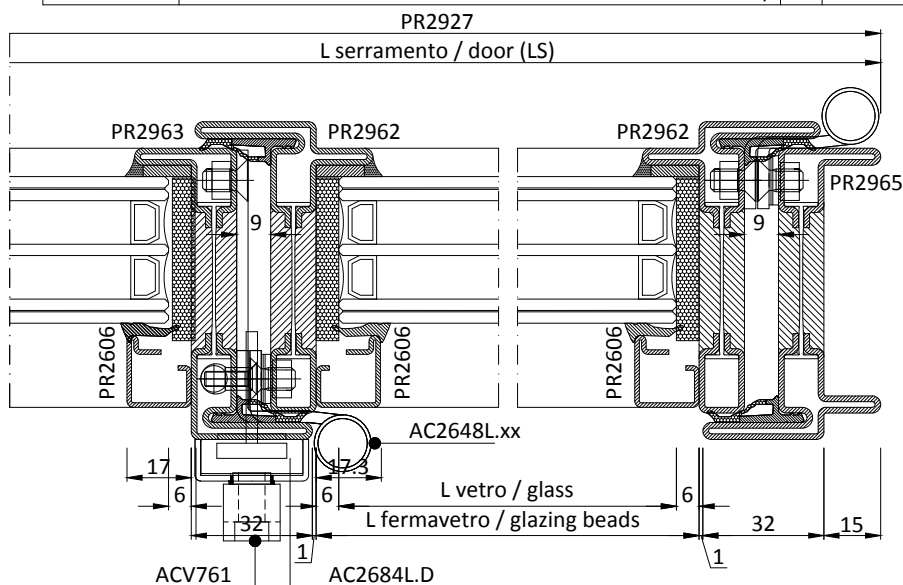
PROFILI		PROFILES				
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
Telaio		Frame				
PR2965	Profilo Zoccolo	Socle profile	1	HS - 4.5	45°	90°
PR2965	Profilo Zoccolo	Socle profile	1	HS - 4.5	90°	45°
PR2927a	Profilo Guida superiore	Upper rail profile	1	LS + 9	45°	45°
PR2927b	Guida Superiore	Upper rail	1	LS-54	90°	90°
PR2928	Profilo Guida inferiore	Bottom rail profile	1	LS	90°	90°
PR2939	Profilo Battuta inferiore	Lower fitting for profiles	1	LS-54	90°	90°
Anta		Leaf				
PR2962	Profilo a "T" anta	"T" profile leaf	3	HS-31.5	45°	90°
PR2962	Profilo a "T" anta	"T" profile leaf	2	HS-31.5	90°	45°
PR2963	Profilo a "Z" anta	"Z" profile leaf	2	HS-31.5	45°	90°
PR2963	Profilo a "Z" anta	"Z" profile leaf	2	HS-31.5	90°	45°
PR2962	Profilo a "T" anta	"T" profile leaf	4	(LS+61)/4	45°	45°
PR2972	Profilo Zoccolo	Socle profile	4	(LS-195)/4	90°	90°
PR2929	Profilo Finitura Inferiore	Bottom finishing profile	4	(LS-99)/4	90°	90°
GU2926	Profilo porta spazzolino inferiore	Lower brush profile	4	(LS-99)/4	90°	90°
Fermavetri		Glazing beads				
PR2606	Profilo fermavetro	Glazing bead profile	8	(LS-195)/4	45°	45°
PR2606	Profilo fermavetro	Glazing bead profile	8	HS-90.5	45°	45°
Vetri		Glass unit				
-	Vetrocamera	Insulated glass	4	(LS-243)/4 x HS-102		

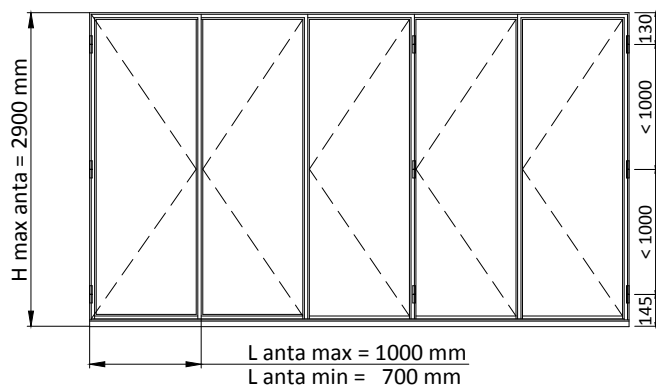


* solo con profili ottone
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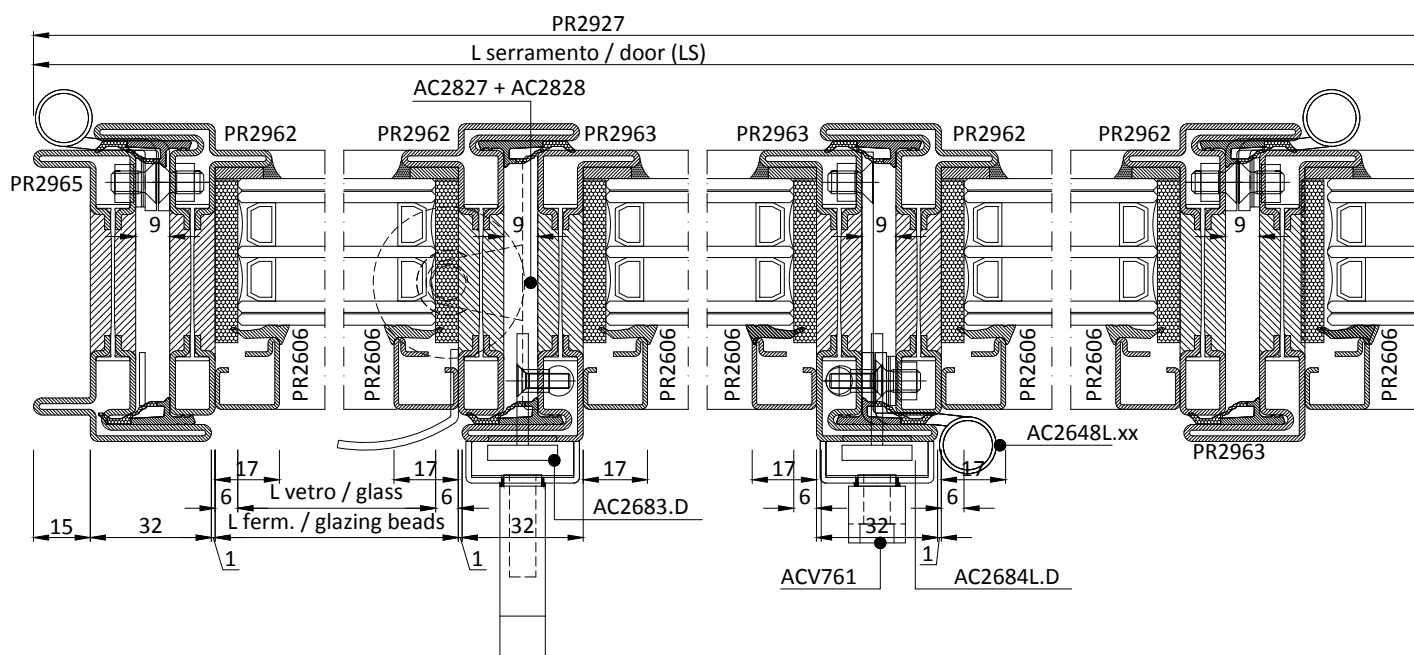
	ACCESSORI	HARDWARE	
Cod.	Descrizione	Description	n°
AC2608	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.
AC2626R	Kit chiusura aggiuntiva	Additional locking point	Var.
AC2621L.I	Catenaccio 2 ^a anta (H 450)	Second leaf bolt	1
AC2621L.S	Catenaccio 2 ^a anta (H 650)	Second leaf bolt	1
AC2653.xx	Fondino per 2 ^a anta	Bottom plate for second leaf	3
AC2656.xx	Fondino inferiore	Lower fitting for profiles	3
AC2818I	Staffa inf. aggancio telaio	Bottom bracket	2
AC2919	Kit tappo chiusura guida	Rail closure cap	2
AC1081T	Accessorio di battuta	Stop Accessory	5
AC2683.D/S	Kit cremonese	Cremone bolt set	1
AC2684L.D/S	Kit cremonese	Cremone bolt set	1
AC2827	Carrello guida superiore	Upper roller	1
AC2828	Carrello guida inferiore	Bottom roller	1
AC2648.xx	Cerniere	Hinges	Var.
AC2648L.xx	Cerniere	Hinges	Var.
AC2825.xx	Kit magneti anta libera	Magnet kit for free leaf	1
AC2826.2	Kit magneti per blocco ante	Magnet kit for leaf stop	1
AC2828.F	Fermo corsa carrello inferiore	Travel stop for bottom roller	1
AC2680.xx	Maniglia di trascinamento	Pulling handle	1
ACV751.xx	Maniglia "Vitruvio"	"Vitruvio" handle	1
ACV761.xx	Maniglia "Vitruvio" ridotta	Reduced "Vitruvio" handle	1
AC2862I*	Kit squadrette per PR2962	Corner brackets kit for PR2962	5
AC2832I*	Kit squadrette per PR2962-63	Corner brackets kit for PR2962-63	3

	GUARNIZIONI	GASKETS	
Cod.	Descrizione	Description	n° Dim.
GE1001TT	Guarnizione di battuta soglia	Threshold rebating gasket	1 1xLS
GE2645TT	Guarnizione esterna di battuta	Rebating gasket	2 1xLS+3xHS
GE2907TT	Guarnizione sotto vetro	Gasket to put under the glass	1 2xLS+4xHS
GU2036	Piattina adesiva fondo giunto	Adhesive shim for joint	1 2xLS+4xHS
GP0095	Guarnizione interna vetro	Internal weather strip	1 2xLS+4xHS
GU0100	Guarnizione esterna	External weather strip	1 1xLS





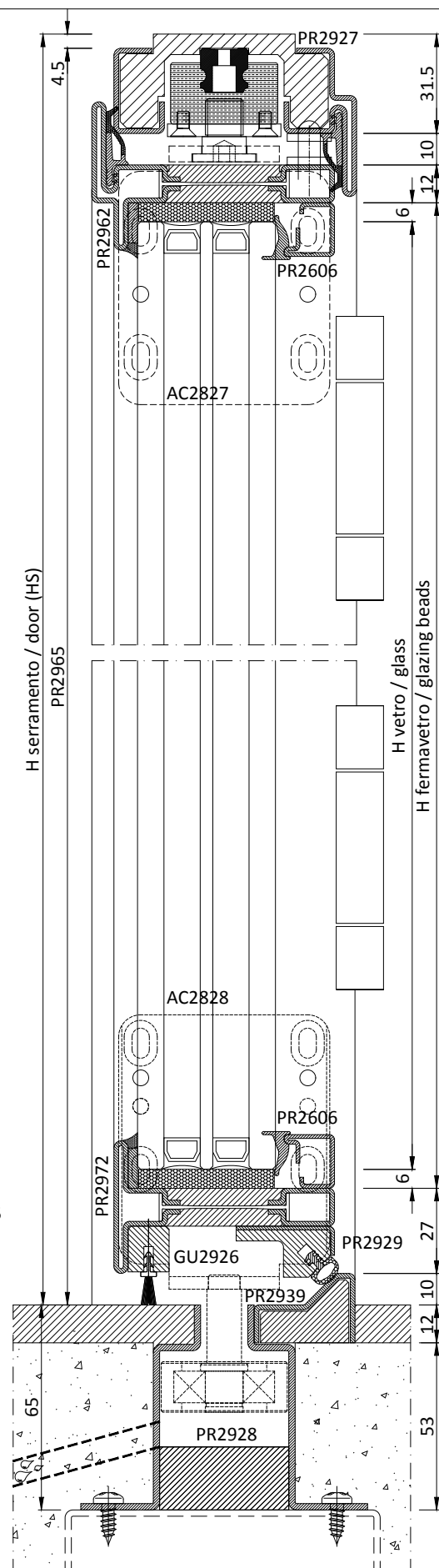
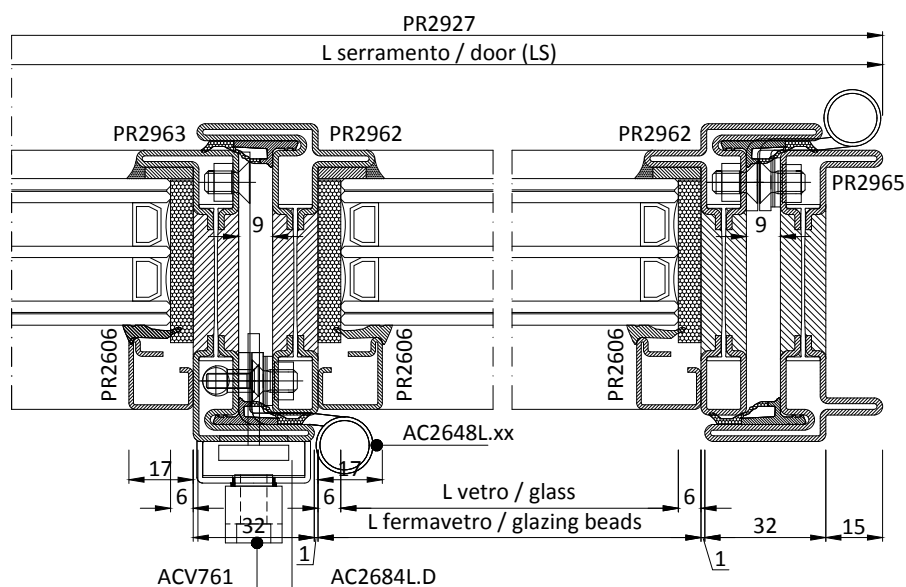
PROFILI		PROFILES				
Cod.	Descrizione	Description	n°	Dim.	Taglio	Cutting
Telaio		Frame				
PR2965	Profilo Zoccolo	Socle profile	1	HS - 4.5	45°	90°
PR2965	Profilo Zoccolo	Socle profile	1	HS - 4.5	90°	45°
PR2927a	Profilo Guida superiore	Upper rail profile	1	LS + 9	45°	45°
PR2927b	Guida Superiore	Upper rail	1	LS-54	90°	90°
PR2928	Profilo Guida inferiore	Bottom rail profile	1	LS	90°	90°
PR2939	Profilo Battuta inferiore	Lower fitting for profiles	1	LS-54	90°	90°
Anta		Leaf				
PR2962	Profilo a "T" anta	"T" profile leaf	3	HS-31.5	45°	90°
PR2962	Profilo a "T" anta	"T" profile leaf	3	HS-31.5	90°	45°
PR2963	Profilo a "Z" anta	"Z" profile leaf	2	HS-31.5	45°	90°
PR2963	Profilo a "Z" anta	"Z" profile leaf	2	HS-31.5	90°	45°
PR2962	Profilo a "T" anta	"T" profile leaf	5	(LS+92)/5	45°	45°
PR2972	Profilo Zoccolo	Socle profile	5	(LS-228)/5	90°	90°
PR2929	Profilo Finitura Inferiore	Bottom finishing profile	5	(LS-108)/5	90°	90°
GU2926	Profilo porta spazzolino inferiore	Lower brush profile	5	(LS-108)/5	90°	90°
Fermavetri		Glazing beads				
PR2606	Profilo fermavetro	Glazing bead profile	10	(LS-228)/5	45°	45°
PR2606	Profilo fermavetro	Glazing bead profile	10	HS-90.5	45°	45°
Vetri		Glass unit				
-	Vetrocamera	Insulated glass	5	(LS-288)/5 x HS-102		

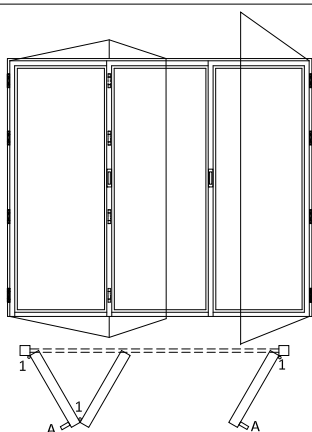


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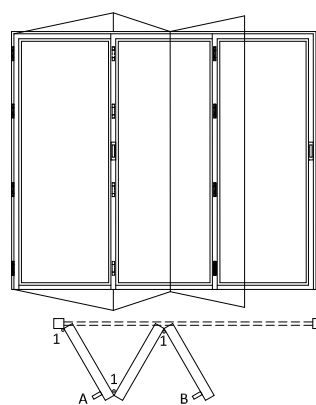
	ACCESSORI	HARDWARE	
Cod.	Descrizione	Description	n°
AC2608	Clips fissaggio fermavetri	Clips to secure glazing beads	Var.
AC2626R	Kit chiusura aggiuntiva	Additional locking point	Var.
AC2653.xx	Fondino per 2 ^a anta	Bottom plate for second leaf	4
AC2656.xx	Fondino inferiore	Lower fitting for profiles	4
AC2818I	Staffa inf. aggancio telaio	Bottom bracket	2
AC2919	Kit tappo chiusura guida	Rail closure cap	2
AC1081T	Accessorio di battuta	Stop Accessory	6
AC2684L.D/S	Kit cremonese	Cremone bolt set	2
AC2683.D/S	Kit cremonese	Cremone bolt set	1
AC2827	Carrello guida superiore	Upper roller	2
AC2828	Carrello guida inferiore	Bottom roller	2
AC2648.xx	Cerniere	Hinges	Var.
AC2648L.xx	Cerniere	Hinges	Var.
AC2826.4	Kit magneti per blocco ante	Magnet kit for leaf stop	1
AC2828.F	Fermo corsa carrello inferiore	Travel stop for bottom roller	1
AC2680.xx	Maniglia di trascinamento	Pulling handle	1
ACV751.xx	Maniglia "Vitruvio" ridotta	Reduced "Vitruvio" handle	1
ACV761.xx	Maniglia "Vitruvio"	"Vitruvio" handle	2
AC2862I*	Kit squadrette per PR2962	Corner brackets kit for PR2962	6
AC2832I*	Kit squadrette per PR2962-63	Corner brackets kit for PR2962-63	4

	GUARNIZIONI	GASKETS	
Cod.	Descrizione	Description	n° Dim.
GE1001TT	Guarnizione di battuta soglia	Threshold rebating gasket	1 1xLS
GE2645TT	Guarnizione esterna di battuta	Rebating gasket	2 1xLS+6xHS
GE2907TT	Guarnizione sotto vetro	Gasket to put under the glass	2 1xLS+5xHS
GU2036	Piattina adesiva fondo giunto	Adhesive shim for joint	2 1xLS+5xHS
GP0095	Guarnizione interna vetro	Internal weather strip	2 1xLS+5xHS
GU0100	Spazzolino soglia	Threshold brush	1 1xLS

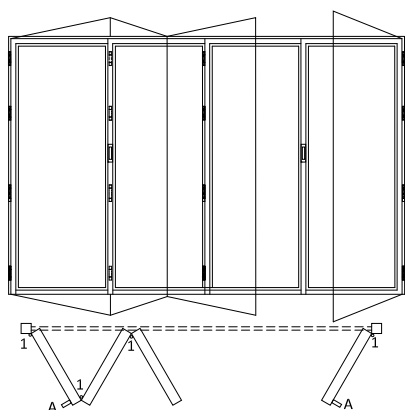


APERTURA INTERNA 2+1
INWARD OPENING 2+1

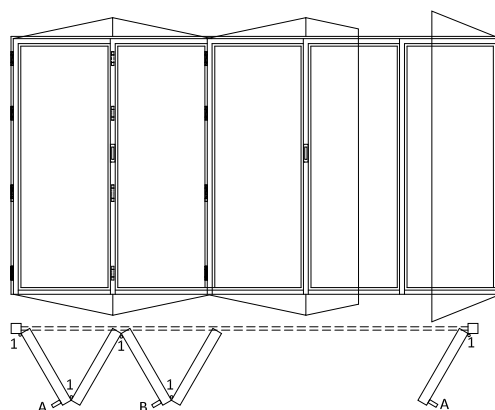
Art.	Code	Descrizione Description	Q.tà	Pag.
AC2624.D		Kit cremonese Dx chiusura <i>Cremone bolt set Rh</i>	1 pz.	4.3.12 4.5.1-2
AC2624.S		Kit cremonese Sx chiusura <i>Cremone bolt set Lh</i>	1 pz.	4.3.12 4.5.1-2
AC2626R		Punto di chiusura aggiuntivo <i>Additional locking point</i>	Opz.	4.3.15 4.5.1-2
AC2648.xx (1)		Cerniere a tre ali ad avvitare <i>Three-wing screw-in hinge</i>	Var.	4.3.16
ACV77_.xx (A)		Martellina cremonese "Vitruvio" <i>Cremone Handle "Vitruvio"</i>	2 pz.	4.5.29

APERTURA INTERNA 3+0
INWARD OPENING 3+0

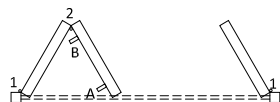
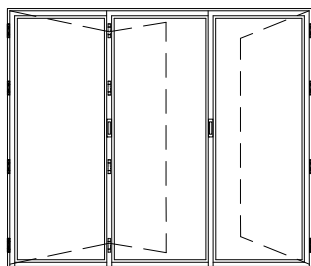
Art.	Code	Descrizione Description	Q.tà	Pag.
AC2624.S		Kit cremonese Dx chiusura <i>Cremone bolt set Rh</i>	2 pz.	4.3.12 4.5.1-2
AC2626R		Punto di chiusura aggiuntivo <i>Additional locking point</i>	Opz.	4.3.15 4.5.1-2
AC2648.xx (1)		Cerniere a tre ali ad avvitare <i>Three-wing screw-in hinge</i>	Var.	4.3.16
ACV77_.xx (A)		Martellina cremonese "Vitruvio" <i>Cremone Handle "Vitruvio"</i>	1 pz.	4.5.29
ACV751.xx (B)		Martellina cremonese "Vitruvio" <i>Cremone Handle "Vitruvio"</i>	1 pz.	4.5.27

APERTURA INTERNA 3+1
INWARD OPENING 3+1

Art.	Code	Descrizione Description	Q.tà	Pag.
AC2624.D		Kit cremonese Dx chiusura <i>Cremone bolt set Rh</i>	1 pz.	4.3.12 4.5.1-2
AC2624.S		Kit cremonese Sx chiusura <i>Cremone bolt set Lh</i>	1 pz.	4.3.12 4.5.1-2
AC2626R		Punto di chiusura aggiuntivo <i>Additional locking point</i>	Opz.	4.3.15 4.5.1-2
AC2648.xx (1)		Cerniere a tre ali ad avvitare <i>Three-wing screw-in hinge</i>	Var.	4.3.16
ACV77_.xx (A)		Martellina cremonese "Vitruvio" <i>Cremone Handle "Vitruvio"</i>	2 pz.	4.5.29
AC2621L.I		Catenaccio Inferiore <i>Bottom flush bolt</i>	1 pz.	4.3.22-23
AC2621L.S		Catenaccio Superiore <i>Upper flush bolt</i>	1 pz.	4.3.24-25

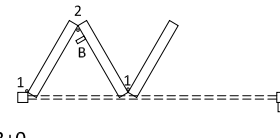
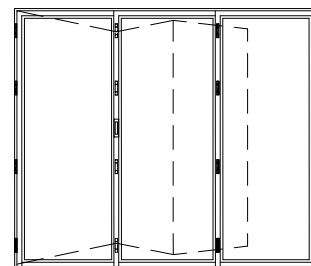
APERTURA INTERNA 4+1
INWARD OPENING 4+1

Art.	Code	Descrizione Description	Q.tà	Pag.
AC2624.D		Kit cremonese Dx chiusura <i>Cremone bolt set Rh</i>	1 pz.	4.3.12 4.5.1-2
AC2624.S		Kit cremonese Sx chiusura <i>Cremone bolt set Lh</i>	2 pz.	4.3.12 4.5.1-2
AC2626R		Punto di chiusura aggiuntivo <i>Additional locking point</i>	Opz.	4.3.15 4.5.1-2
AC2648.xx (1)		Cerniere a tre ali ad avvitare <i>Three-wing screw-in hinge</i>	Var.	4.3.16
ACV77_.xx (A)		Martellina cremonese "Vitruvio" <i>Cremone Handle "Vitruvio"</i>	2 pz.	4.5.29
ACV751.xx (B)		Martellina cremonese "Vitruvio" <i>Cremone Handle "Vitruvio"</i>	1 pz.	4.5.27



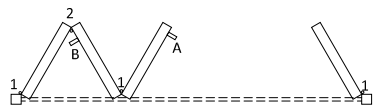
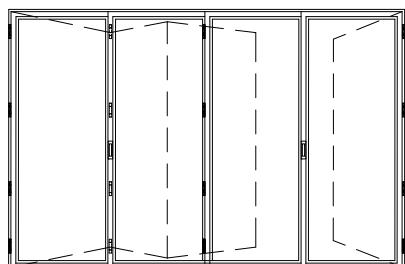
APERTURA ESTERNA 2+1
OUTWARD OPENING 2+1

Art.	Code	Descrizione Description	Q.tà	Pag.
AC2683.S		Kit cremonese Sx chiusura <i>Cremone bolt set Lh</i>	1 pz.	4.3.13 4.5.3-4
AC2684L.S		Kit cremonese Sx man. ridotta <i>Cremone bolt set Lh red. hand.</i>	1 pz.	4.3.14 4.5.5-6
AC2626R		Punto di chiusura aggiuntivo <i>Additional locking point</i>	Opz.	4.3.15 4.5.1-2
AC2648.xx (1)		Cerniere a tre ali ad avvitare <i>Three-wing screw-in hinge</i>	Var.	4.3.16
AC2648L.xx (2)		Cerniere a tre ali ad avvitare <i>Three-wing screw-in hinge</i>	Var.	4.3.17
ACV751.xx (A)		Martellina cremonese "Vitrudio" <i>Cremone Handle "Vitrudio"</i>	1 pz.	4.5.27
ACV761.xx (B)		Martellina cremonese "Vitrudio" <i>Cremone Handle "Vitrudio"</i>	1 pz.	4.5.28
AC2680.xx		Maniglia di trascinamento <i>Pulling handle</i>	1 pz.	4.5.8



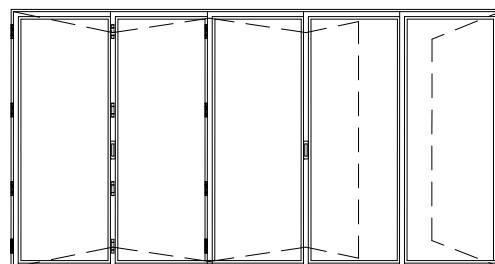
APERTURA ESTERNA 3+0
OUTWARD OPENING 3+0

Art.	Code	Descrizione Description	Q.tà	Pag.
AC2683.S		Kit cremonese Sx chiusura <i>Cremone bolt set Lh</i>	1 pz.	4.3.13 4.5.3-4
AC2684L.S		Kit cremonese Sx man. ridotta <i>Cremone bolt set Lh red. hand.</i>	1 pz.	4.3.14 4.5.5-6
AC2626R		Punto di chiusura aggiuntivo <i>Additional locking point</i>	Opz.	4.3.15 4.5.1-2
AC2648.xx (1)		Cerniere a tre ali ad avvitare <i>Three-wing screw-in hinge</i>	Var.	4.3.16
AC2648L.xx (2)		Cerniere a tre ali ad avvitare <i>Three-wing screw-in hinge</i>	Var.	4.3.17
ACV777.xx (A)		Martellina cremonese "Vitrudio" <i>Cremone Handle "Vitrudio"</i>	1 pz.	4.5.29
ACV761.xx (B)		Martellina cremonese "Vitrudio" <i>Cremone Handle "Vitrudio"</i>	1 pz.	4.5.28
AC2680.xx		Maniglia di trascinamento <i>Pulling handle</i>	1 pz.	4.5.8



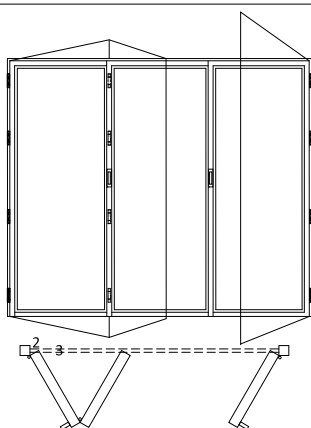
APERTURA ESTERNA 3+1
OUTWARD OPENING 3+1

Art.	Code	Descrizione Description	Q.tà	Pag.
AC2683.S		Kit cremonese Sx chiusura <i>Cremone bolt set Lh</i>	1 pz.	4.3.13 4.5.3-4
AC2684L.S		Kit cremonese Sx man. ridotta <i>Cremone bolt set Lh red. hand.</i>	1 pz.	4.3.14 4.5.5-6
AC2626R		Punto di chiusura aggiuntivo <i>Additional locking point</i>	Opz.	4.3.15 4.5.1-2
AC2648.xx (1)		Cerniere a tre ali ad avvitare <i>Three-wing screw-in hinge</i>	Var.	4.3.16
AC2648L.xx (2)		Cerniere a tre ali ad avvitare <i>Three-wing screw-in hinge</i>	Var.	4.3.17
ACV777.xx (A)		Martellina cremonese "Vitrudio" <i>Cremone Handle "Vitrudio"</i>	1 pz.	4.5.29
ACV761.xx (B)		Martellina cremonese "Vitrudio" <i>Cremone Handle "Vitrudio"</i>	1 pz.	4.5.28
AC2680.xx		Maniglia di trascinamento <i>Pulling handle</i>	1 pz.	4.5.8

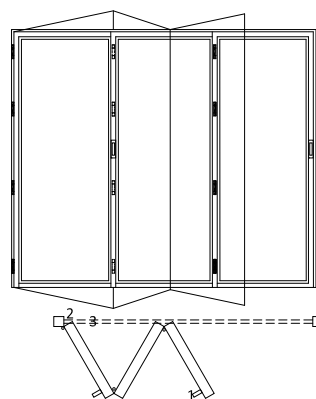


APERTURA ESTERNA 4+1
OUTWARD OPENING 4+1

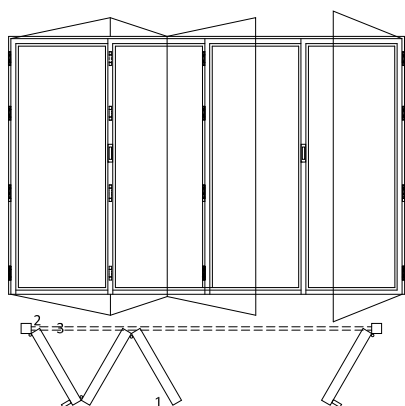
Art.	Code	Descrizione Description	Q.tà	Pag.
AC2683.S		Kit cremonese Sx chiusura <i>Cremone bolt set Lh</i>	1 pz.	4.3.13 4.5.3-4
AC2684L.S		Kit cremonese Sx man. ridotta <i>Cremone bolt set Lh red. hand.</i>	2 pz.	4.3.14 4.5.5-6
AC2626R		Punto di chiusura aggiuntivo <i>Additional locking point</i>	Opz.	4.3.15 4.5.1-2
AC2648.xx (1)		Cerniere a tre ali ad avvitare <i>Three-wing screw-in hinge</i>	Var.	4.3.16
AC2648L.xx (2)		Cerniere a tre ali ad avvitare <i>Three-wing screw-in hinge</i>	Var.	4.3.17
ACV777.xx (A)		Martellina cremonese "Vitrudio" <i>Cremone Handle "Vitrudio"</i>	1 pz.	4.5.29
ACV761.xx (B)		Martellina cremonese "Vitrudio" <i>Cremone Handle "Vitrudio"</i>	2 pz.	4.5.28
AC2680.xx		Maniglia di trascinamento <i>Pulling handle</i>	1 pz.	4.5.8

APERTURA INTERNA 2+1
INWARD OPENING 2+1

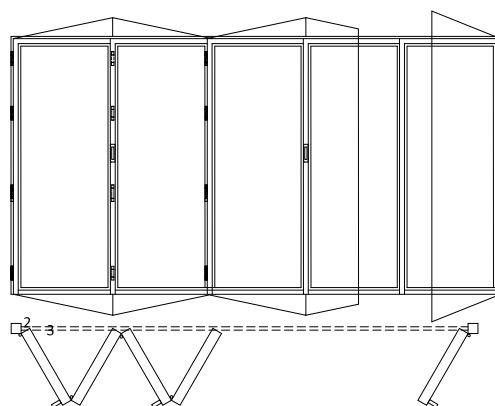
Art.	Code	Descrizione	Description	Q.tà	Pag.
	AC2826.2 (2)	Kit magneti per blocco ante impacchettate	Magnet kit upper for folding leaf stop	1 pz.	4.5.29
	AC2828.F (3)	Fermo corsa per carrello inferiore	Travel stop for bottom roller	1 pz.	4.5.31

APERTURA INTERNA 3+0
INWARD OPENING 3+0

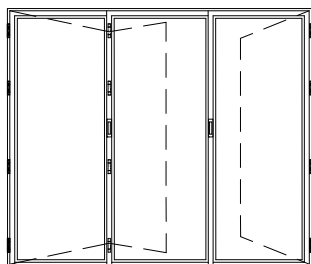
Art.	Code	Descrizione	Description	Q.tà	Pag.
	AC2825.xx (1)	Kit magneti carrelli blocco anta libera	Magnet kit for retain free leaf	1 pz.	4.5.30
	AC2826.2 (2)	Kit magneti per blocco ante impacchettate	Magnet kit upper for folding leaf stop	1 pz.	4.5.29
	AC2828.F (3)	Fermo corsa per carrello inferiore	Travel stop for bottom roller	1 pz.	4.5.31

APERTURA INTERNA 3+1
INWARD OPENING 3+1

Art.	Code	Descrizione	Description	Q.tà	Pag.
	AC2825.xx (1)	Kit magneti carrelli blocco anta libera	Magnet kit for retain free leaf	1 pz.	4.5.30
	AC2826.2 (2)	Kit magneti per blocco ante impacchettate	Magnet kit upper for folding leaf stop	1 pz.	4.5.29
	AC2828.F (3)	Fermo corsa per carrello inferiore	Travel stop for bottom roller	1 pz.	4.5.31

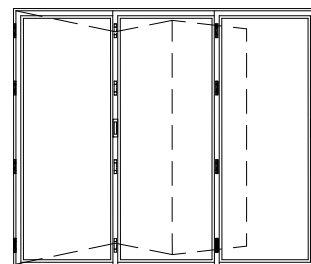
APERTURA INTERNA 4+1
INWARD OPENING 4+1

Art.	Code	Descrizione	Description	Q.tà	Pag.
	AC2826.4 (2)	Kit magneti per blocco ante impacchettate	Magnet kit upper for folding leaf stop	1 pz.	4.5.28
	AC2828.F (3)	Fermo corsa per carrello inferiore	Travel stop for bottom roller	1 pz.	4.5.31



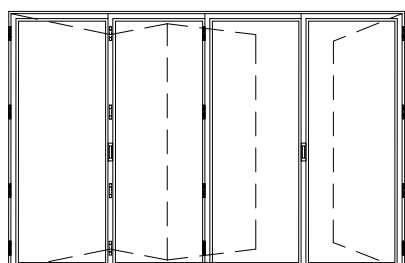
APERTURA ESTERNA 2+1
OUTWARD OPENING 2+1

Art.	Code	Descrizione	Description	Q.tà	Pag.
	AC2826.2 (2)	Kit magneti per blocco ante impacchettate	Magnet kit upper for folding leaf stop	1 pz.	4.5.29
	AC2828.F (3)	Fermo corsa per carrello inferiore	Travel stop for bottom roller	1 pz.	4.5.31



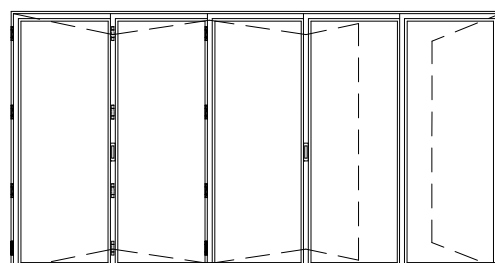
APERTURA ESTERNA 3+0
OUTWARD OPENING 3+0

Art.	Code	Descrizione	Description	Q.tà	Pag.
	AC2825.xx (1)	Kit magneti carrelli blocco anta libera	Magnet kit for retain free leaf	1 pz.	4.5.30
	AC2826.2 (2)	Kit magneti per blocco ante impacchettate	Magnet kit upper for folding leaf stop	1 pz.	4.5.29
	AC2828.F (3)	Fermo corsa per carrello inferiore	Travel stop for bottom roller	1 pz.	4.5.31



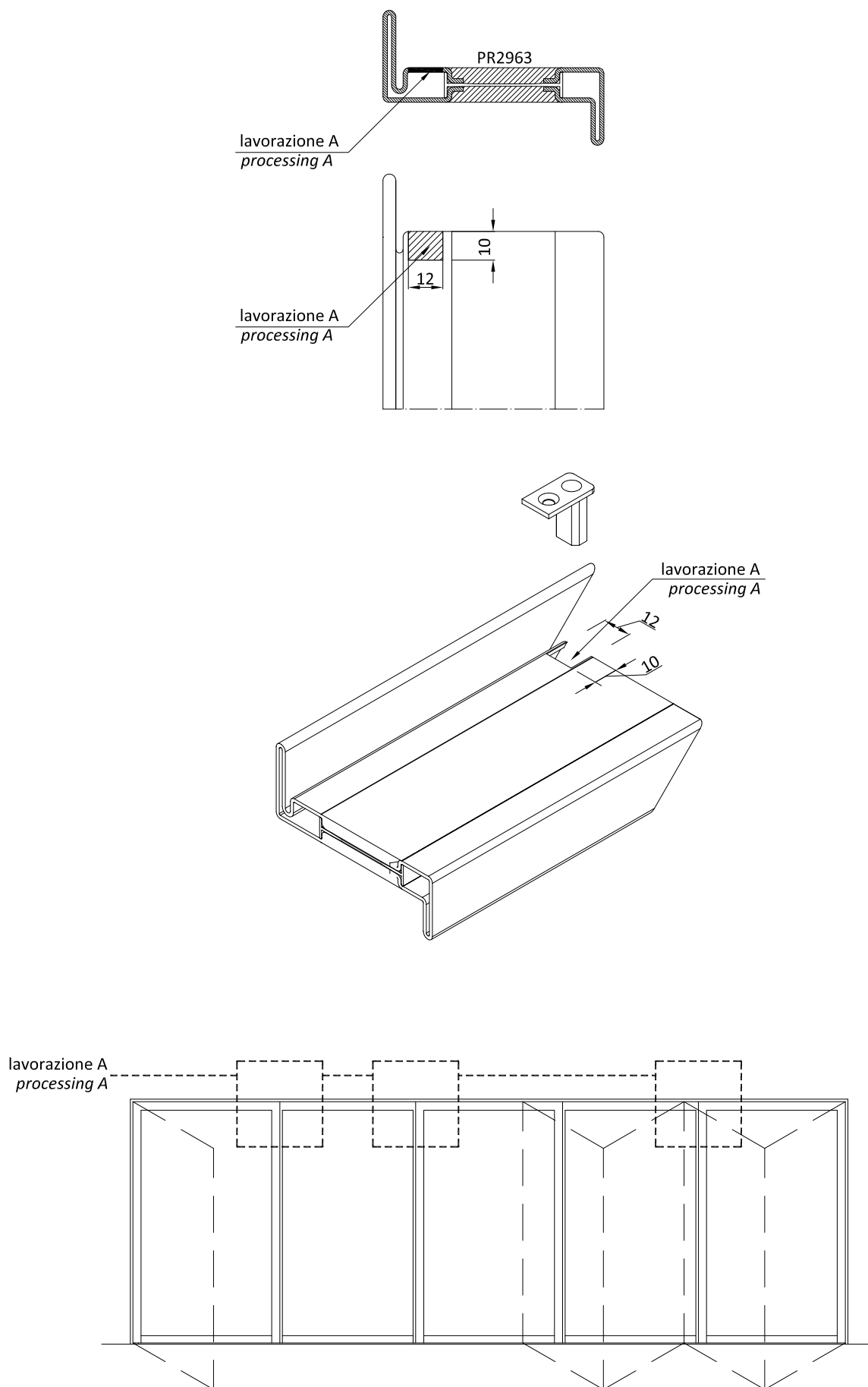
APERTURA ESTERNA 3+1
OUTWARD OPENING 3+1

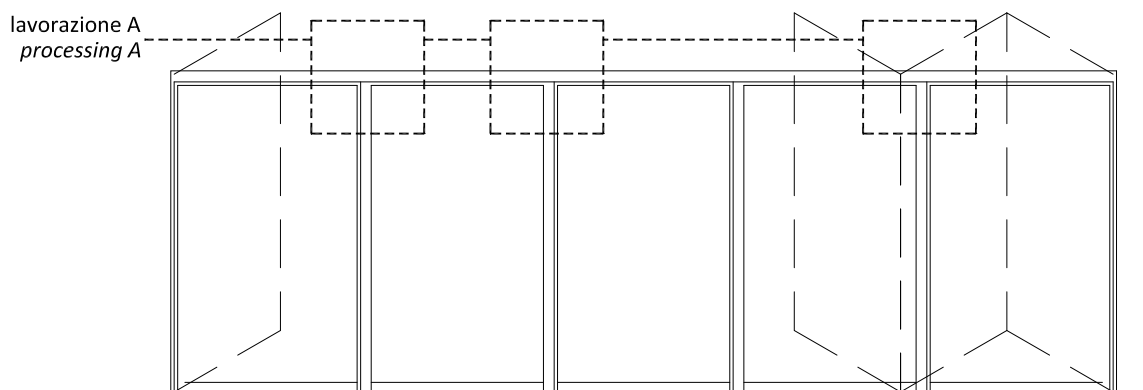
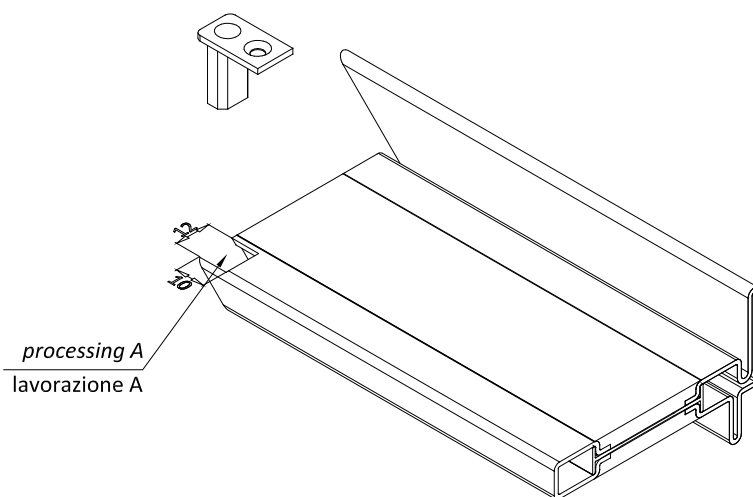
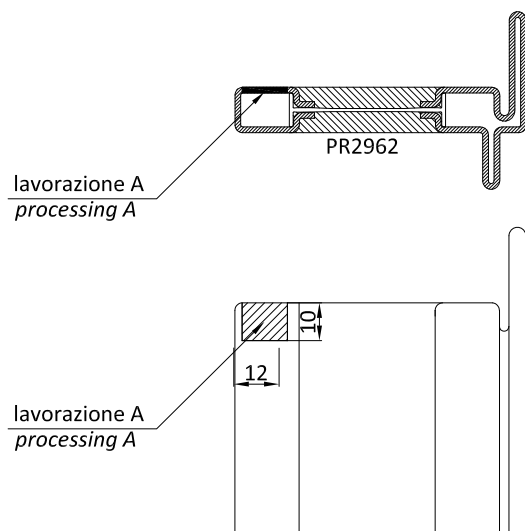
Art.	Code	Descrizione	Description	Q.tà	Pag.
	AC2825.xx (1)	Kit magneti carrelli blocco anta libera	Magnet kit for retain free leaf	1 pz.	4.5.30
	AC2826.2 (2)	Kit magneti per blocco ante impacchettate	Magnet kit upper for folding leaf stop	1 pz.	4.5.29
	AC2828.F (3)	Fermo corsa per carrello inferiore	Travel stop for bottom roller	1 pz.	4.5.31

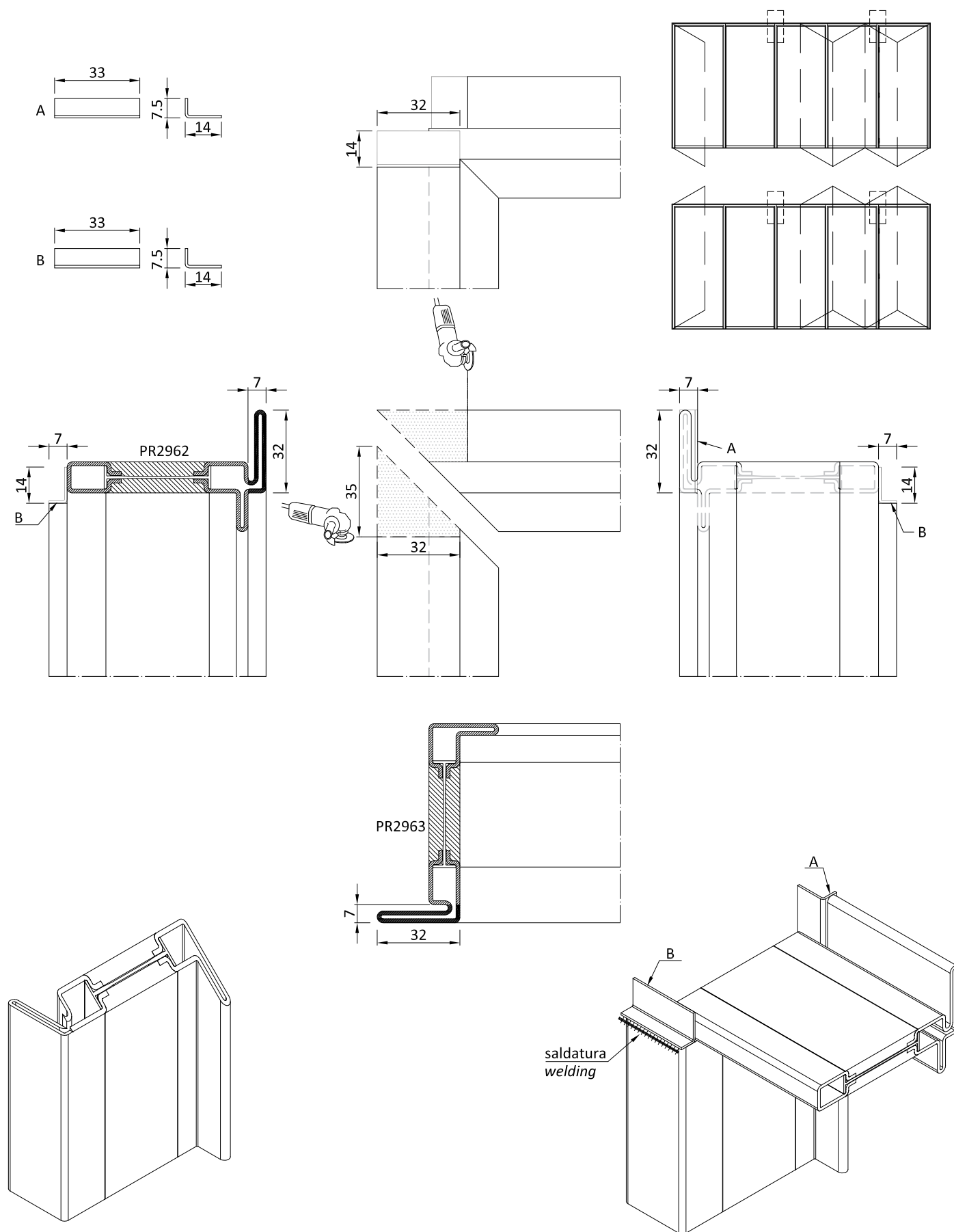


APERTURA ESTERNA 4+1
OUTWARD OPENING 4+1

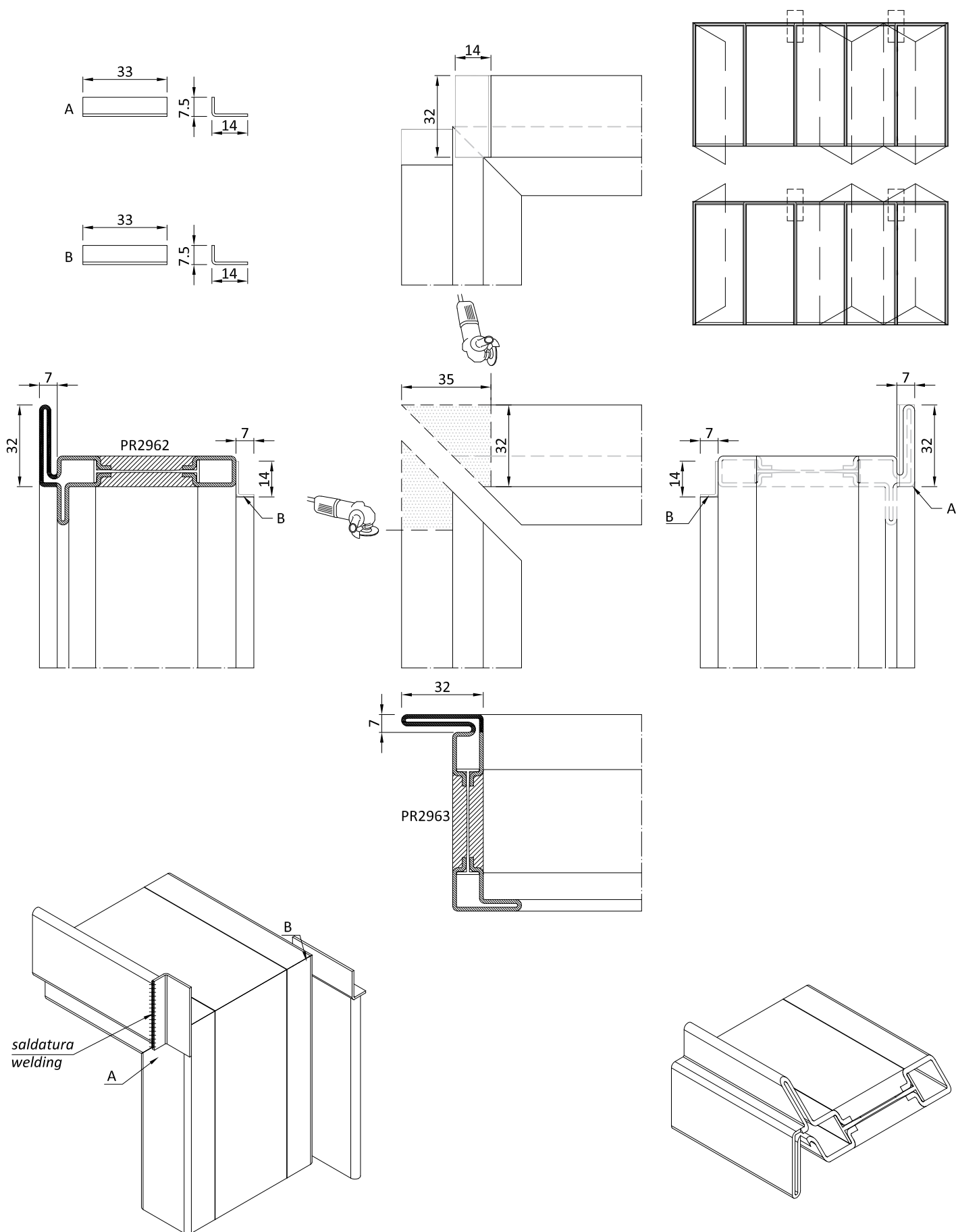
Art.	Code	Descrizione	Description	Q.tà	Pag.
	AC2826.4 (2)	Kit magneti per blocco ante impacchettate	Magnet kit upper for folding leaf stop	1 pz.	4.5.28
	AC2828.F (3)	Fermo corsa per carrello inferiore	Travel stop for bottom roller	1 pz.	4.5.31



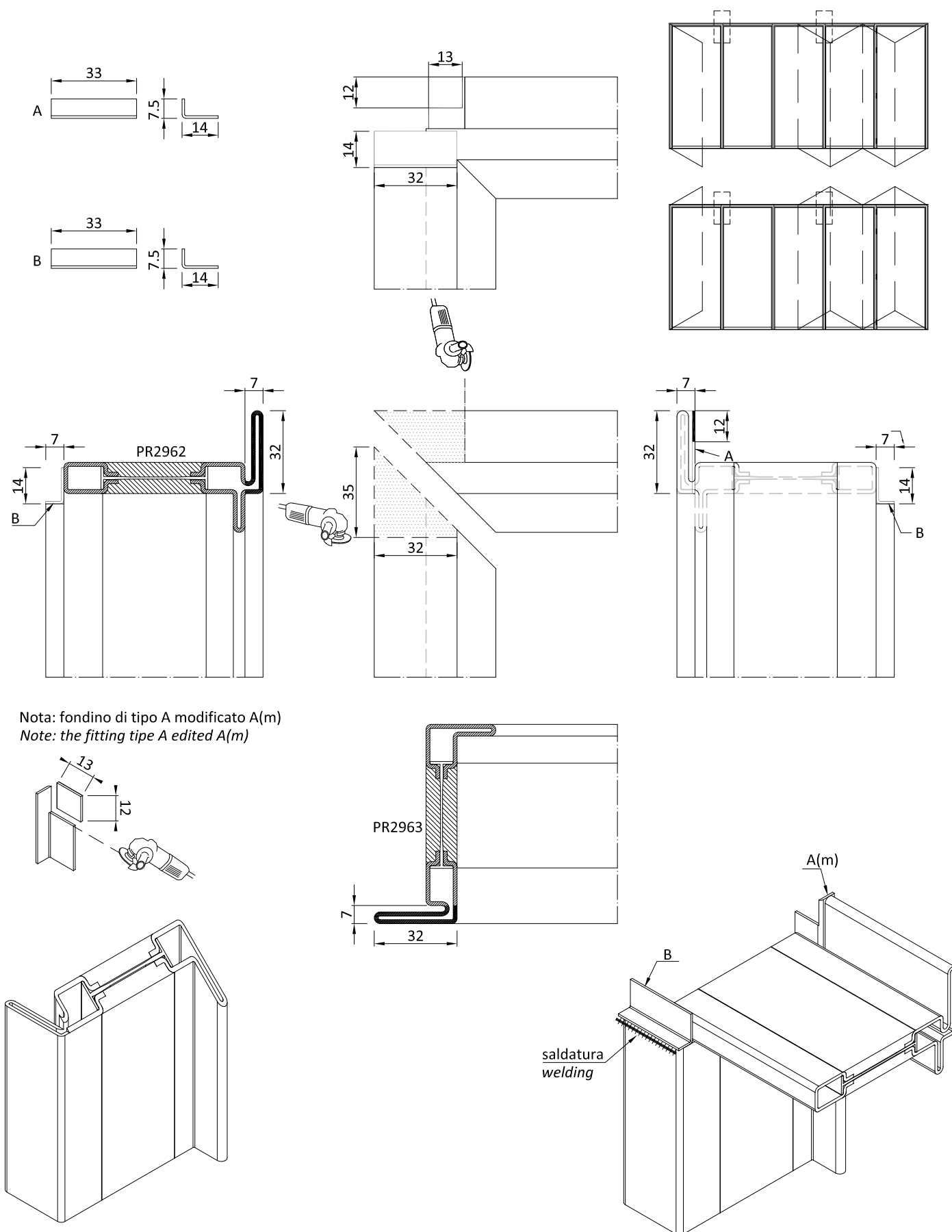




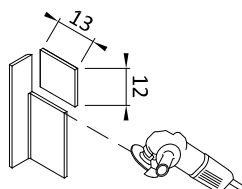
Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura
 Note: the fitting are provided larger by trimming after welding



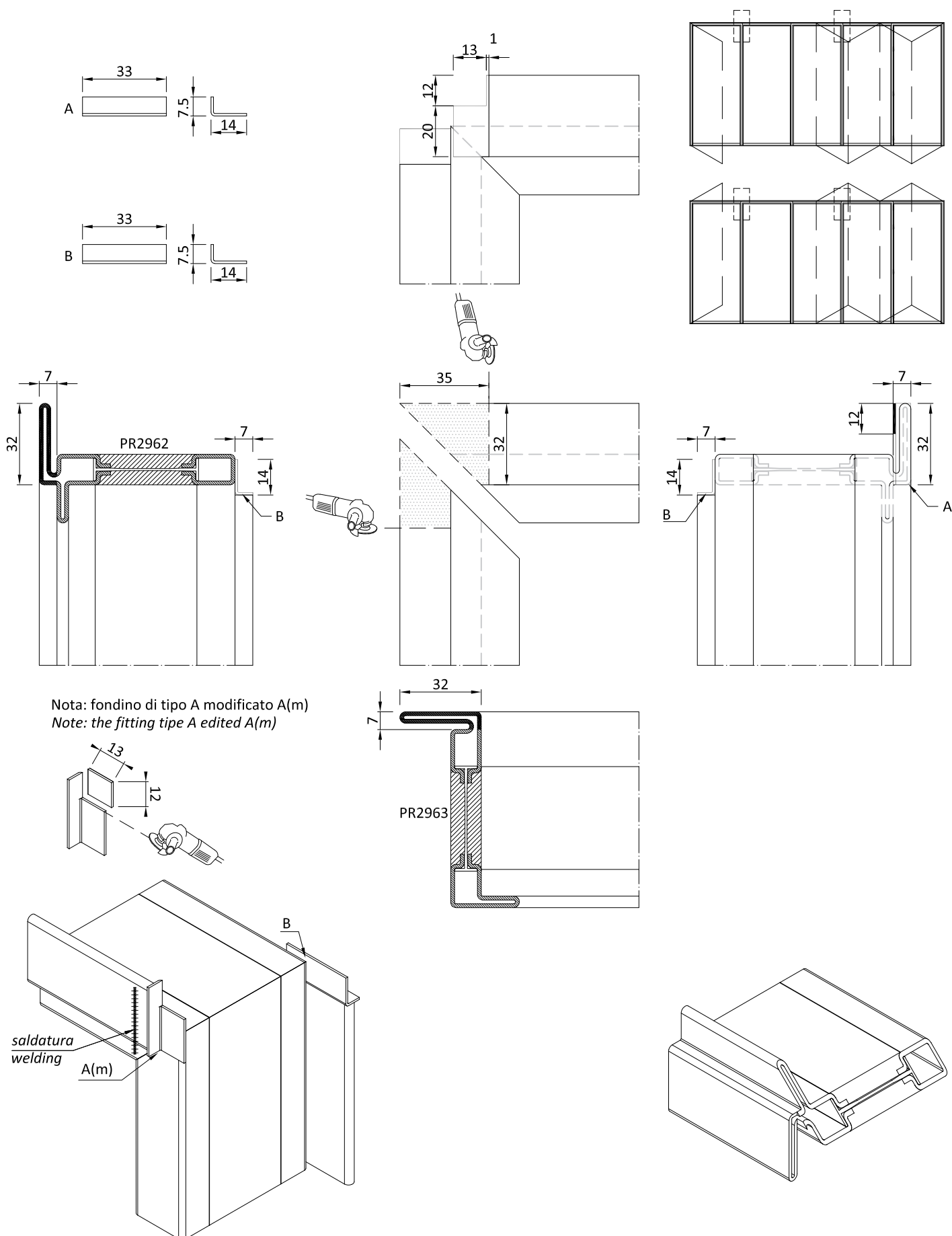
Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura
 Note: the fitting are provided larger by trimming after welding



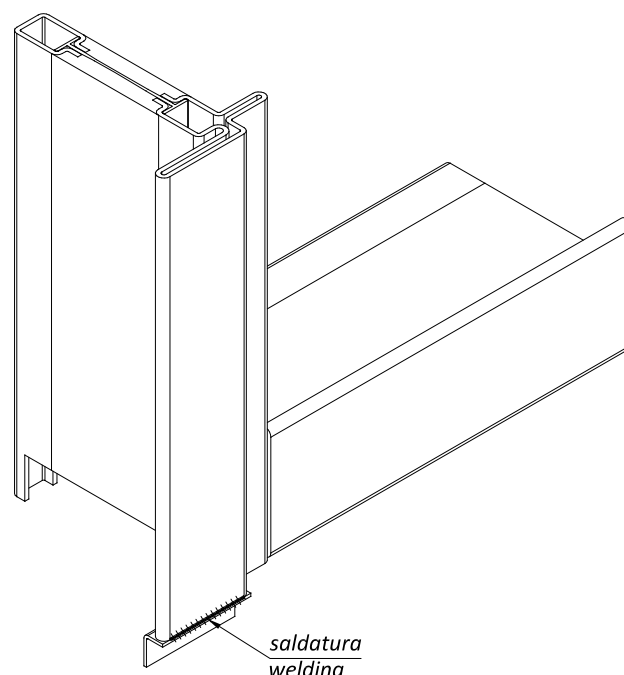
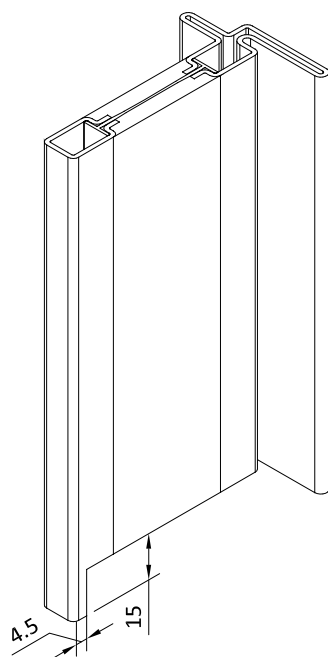
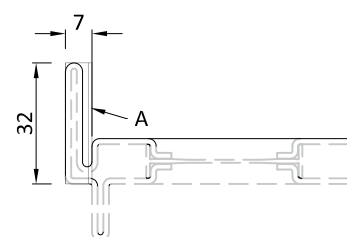
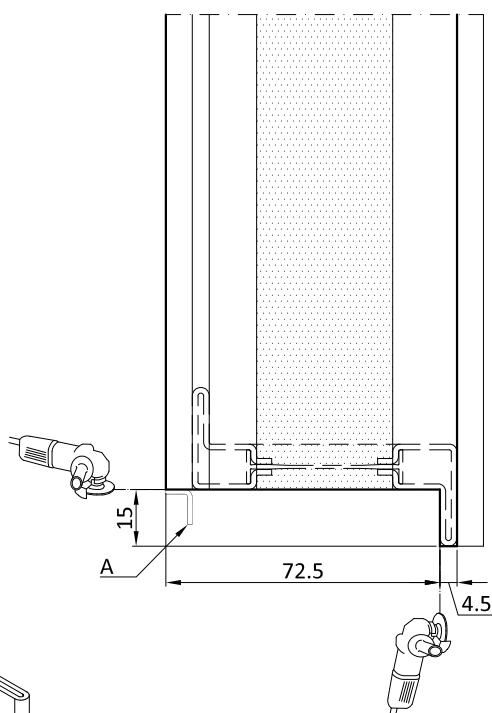
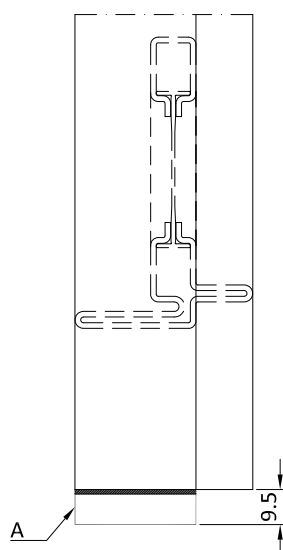
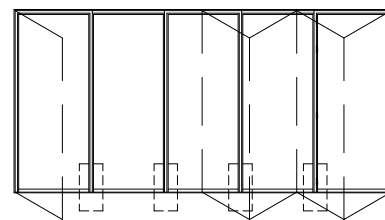
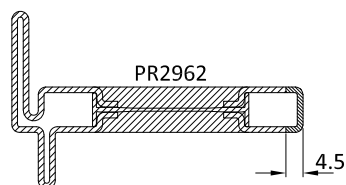
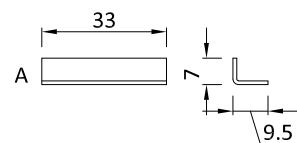
Nota: fondino di tipo A modificato A(m)
Note: the fitting tipe A edited A(m)



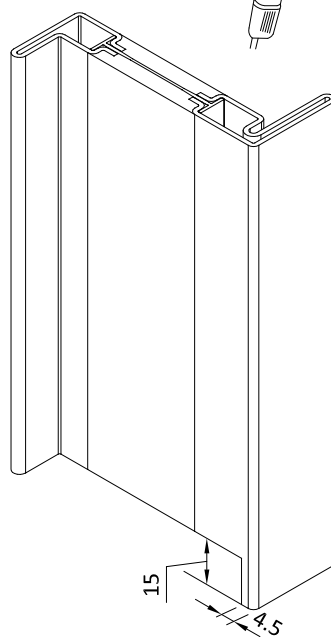
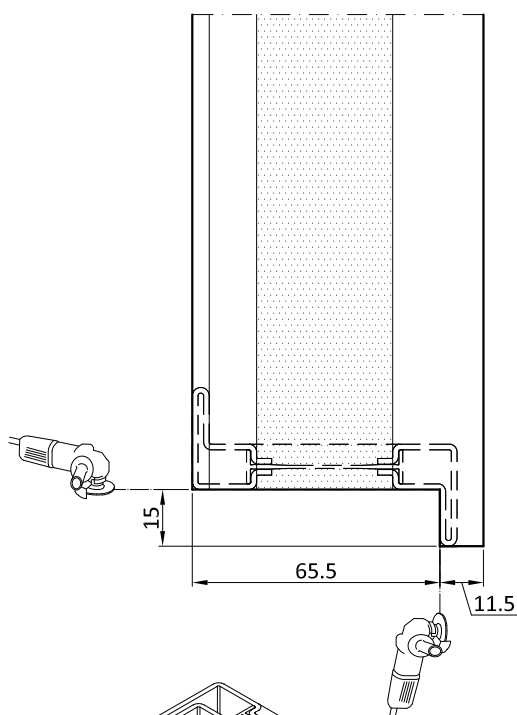
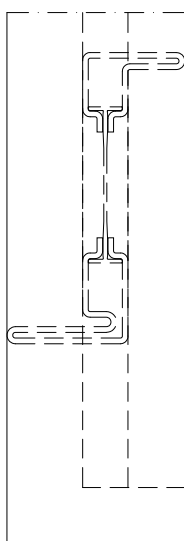
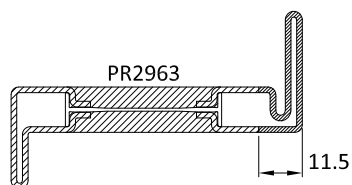
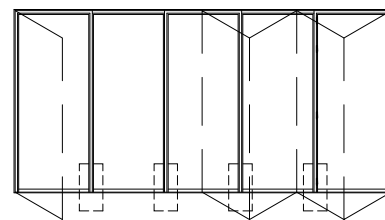
Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura
Note: the fitting are provided larger by trimming after welding



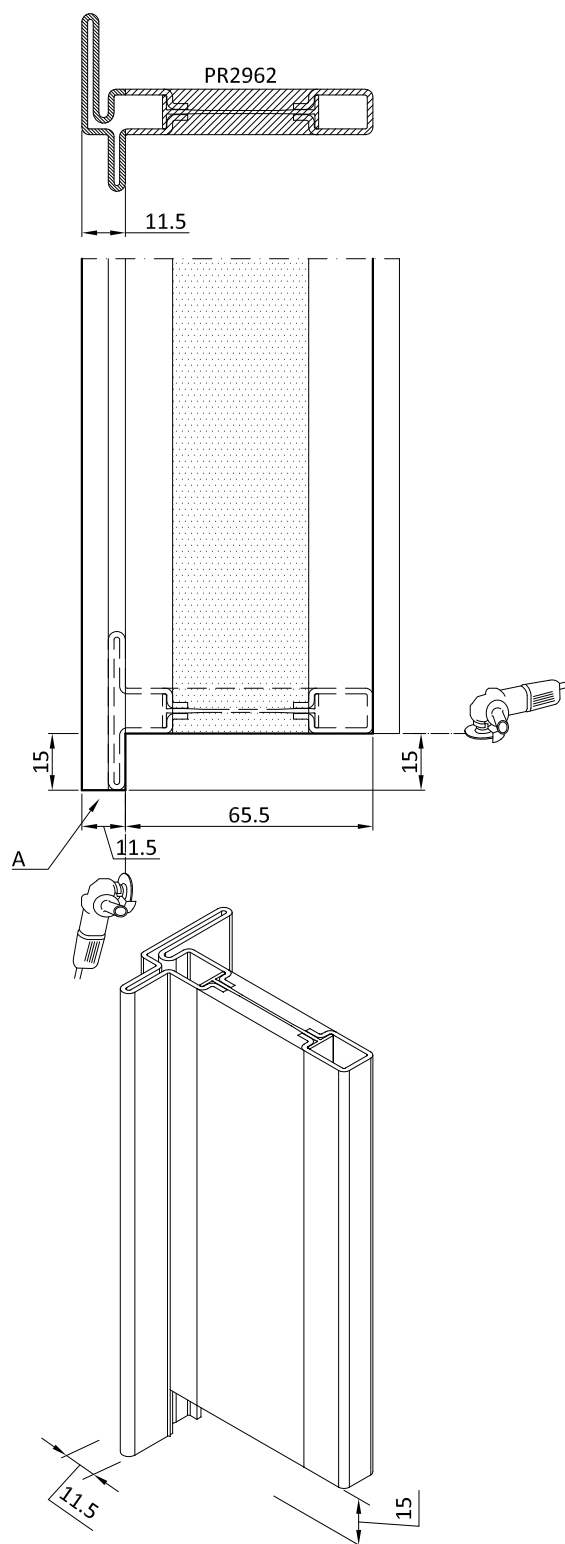
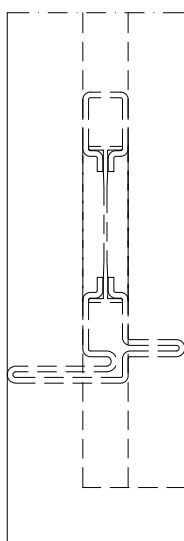
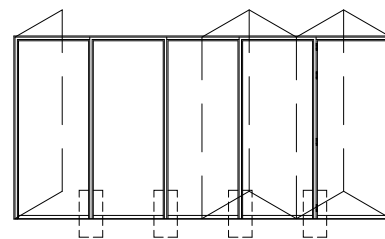
Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura
 Note: the fitting are provided larger by trimming after welding



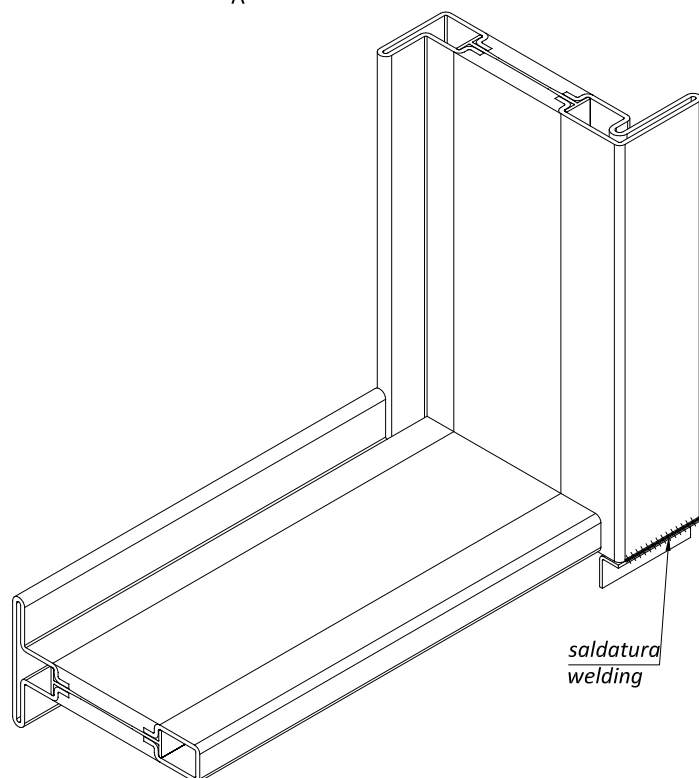
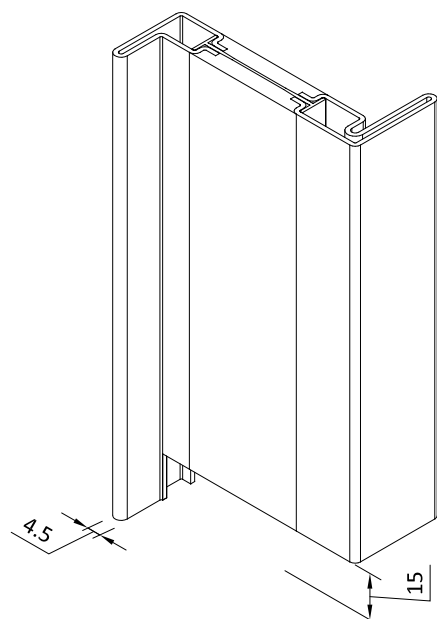
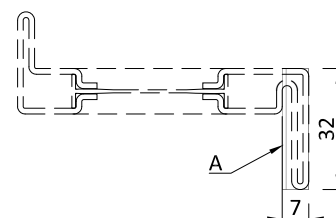
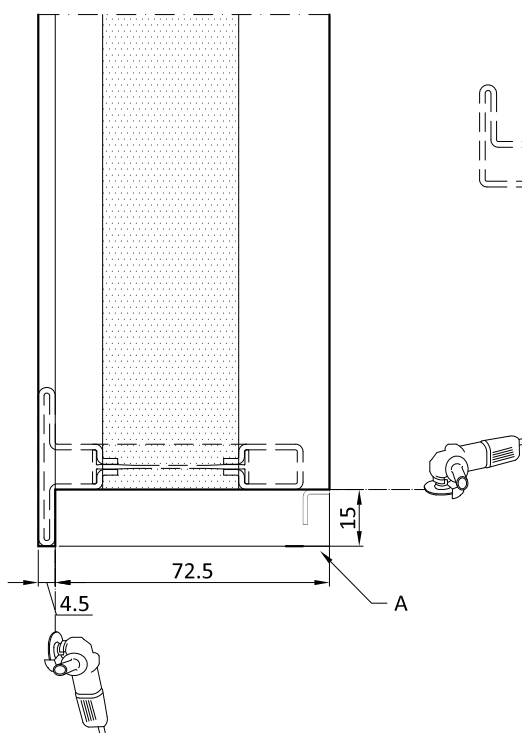
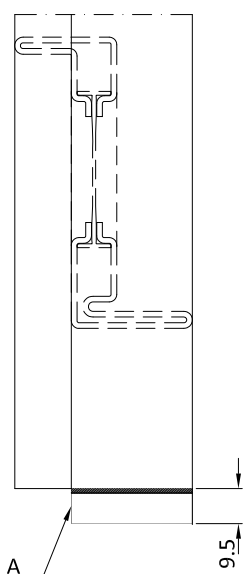
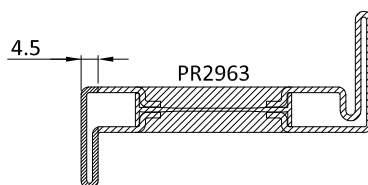
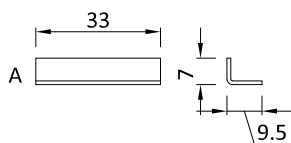
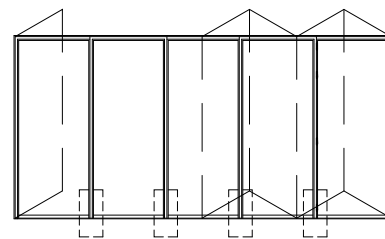
Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura
Note: the fitting are provided larger by trimming after welding



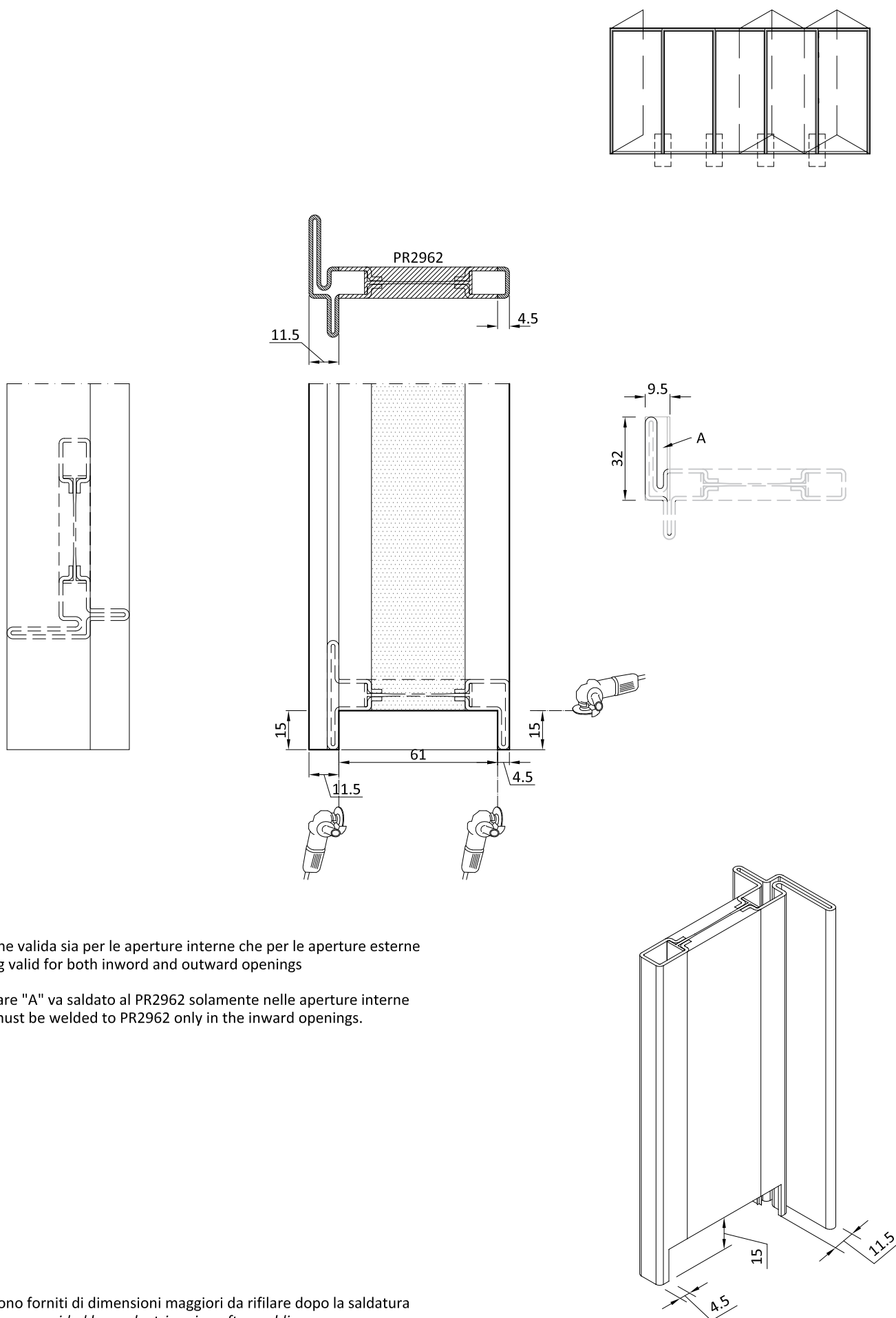
Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura
Note: the fitting are provided larger by trimming after welding



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



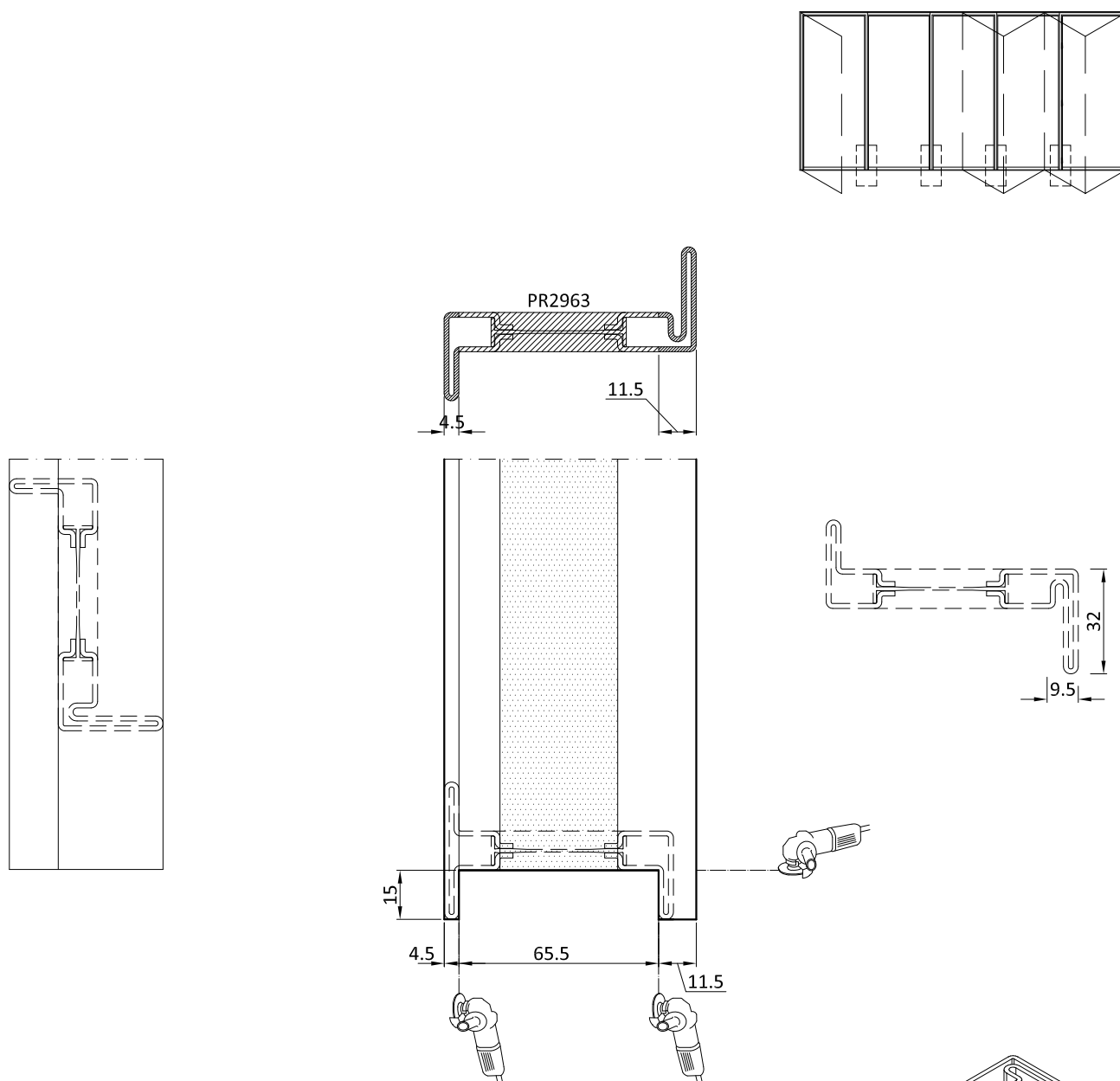
Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura
Note: the fitting are provided larger by trimming after welding



Lavorazione valida sia per le aperture interne che per le aperture esterne
Processing valid for both inward and outward openings

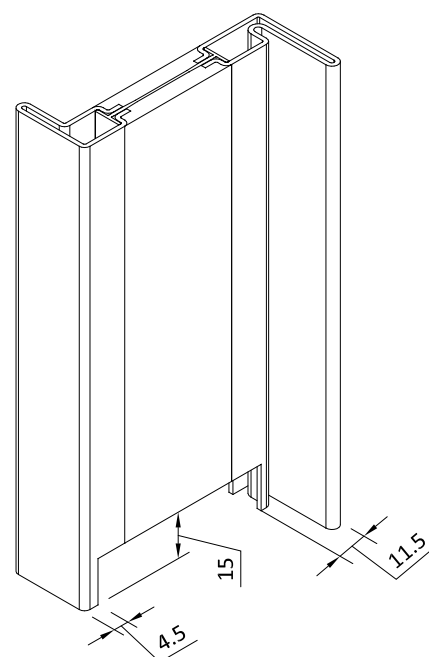
Il particolare "A" va saldato al PR2962 solamente nelle aperture interne
Part "A" must be welded to PR2962 only in the inward openings.

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

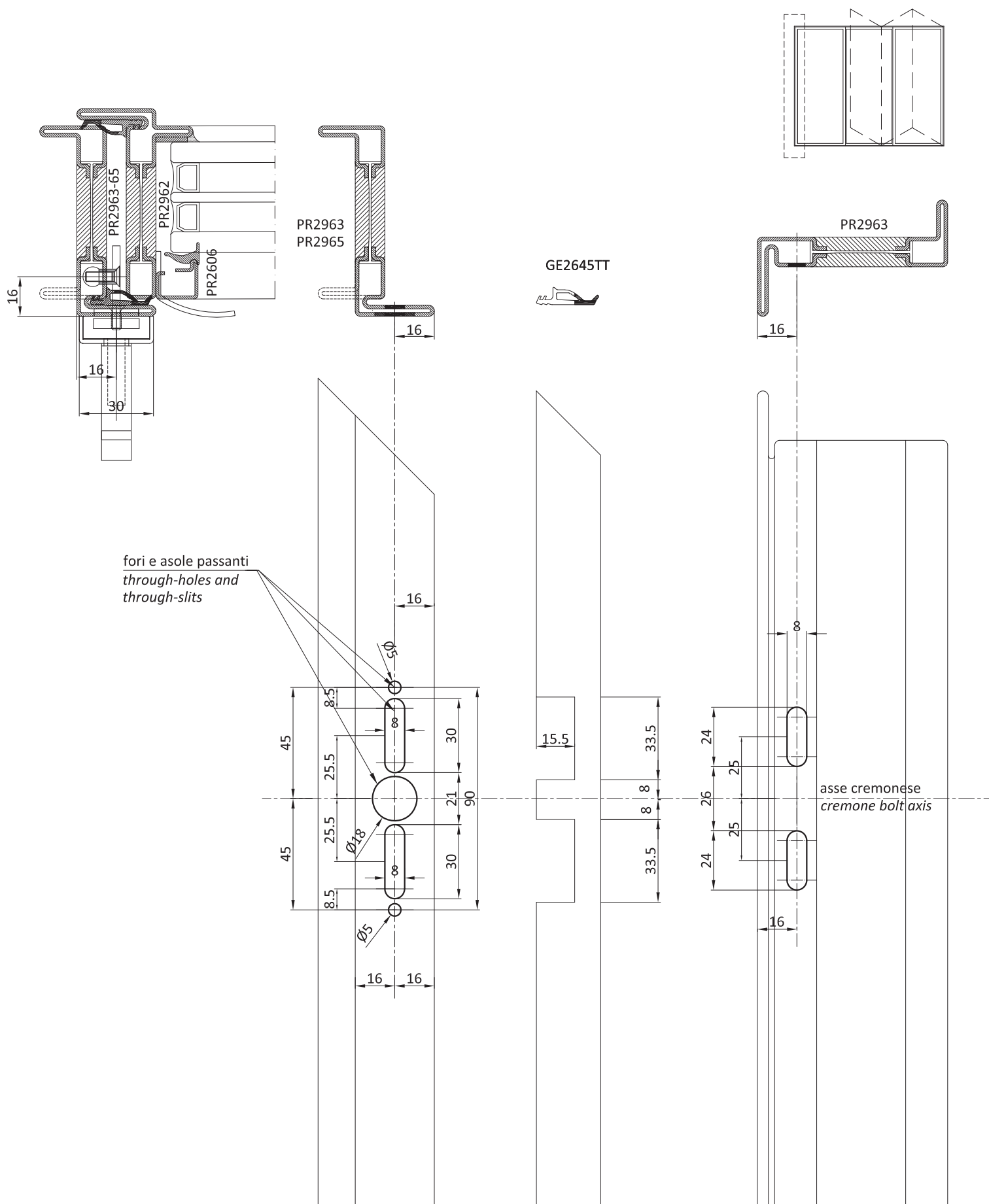


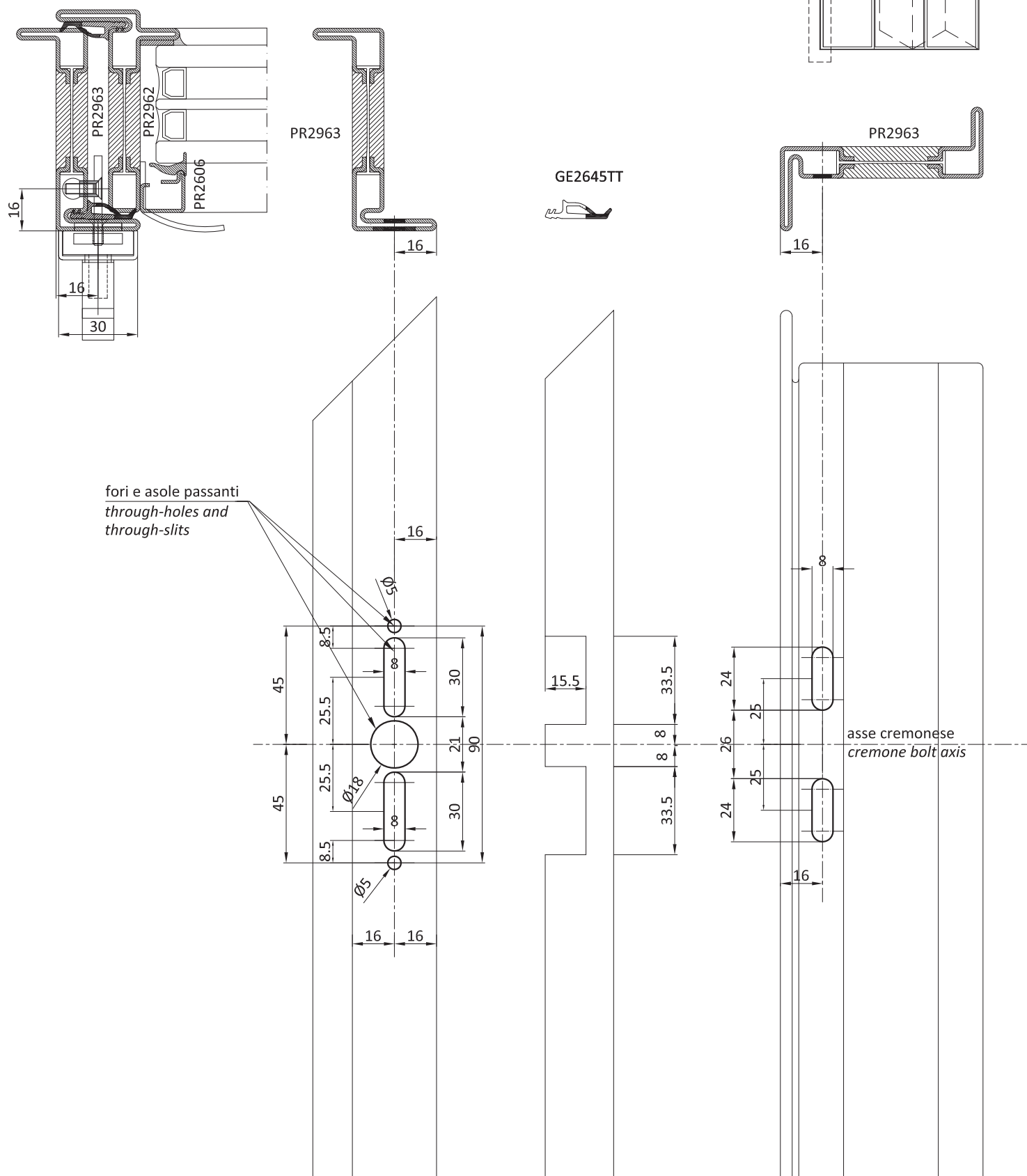
Lavorazione valida sia per le aperture interne che per le aperture esterne
Processing valid for both inward and outward openings

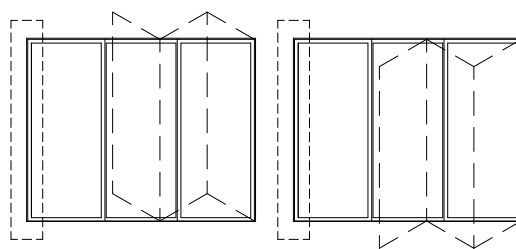
Il particolare "A" va saldato al PR2963 solamente nelle aperture interne
Part "A" must be welded to PR2963 only in the inward openings.



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

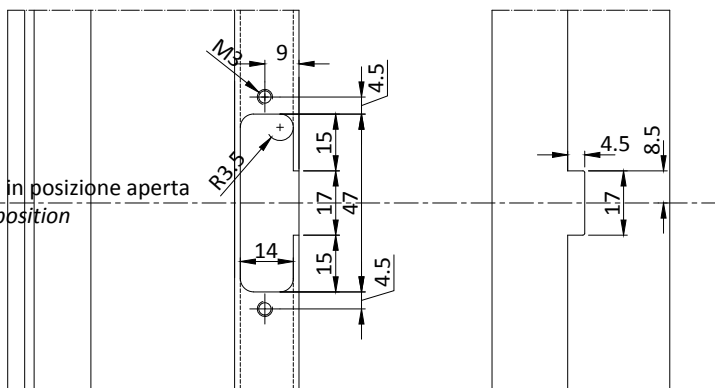




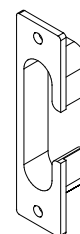
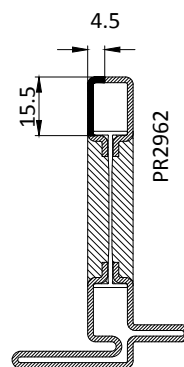
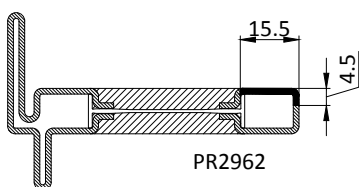


lavorazione applicazione incontro
Processing for the installation of the strike plate

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



AC2626R Incontro 3^ chiusura
3rd lock strike plate

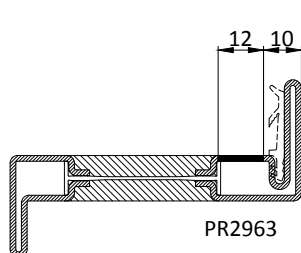
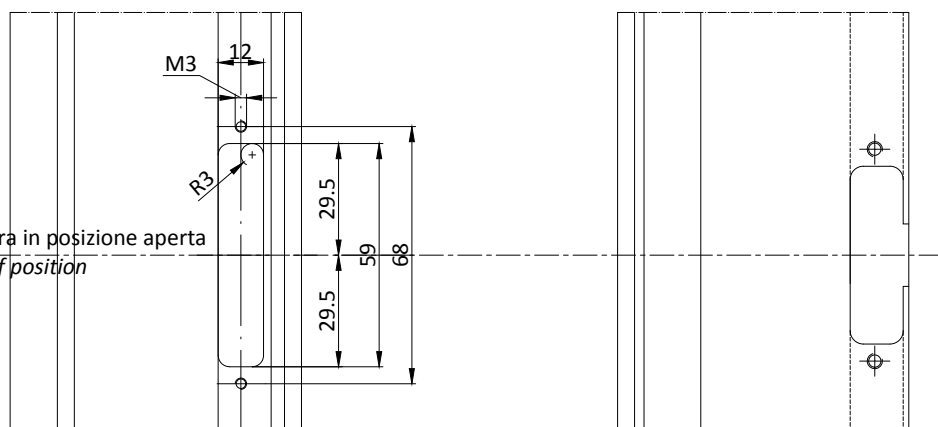


N.B.: Distanza massima tra i punti
di chiusura 1000 mm

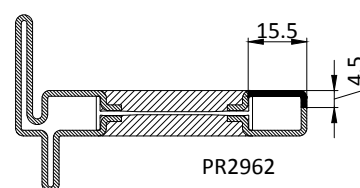
N.B.: Distance between the closing
points max. 1000 mm

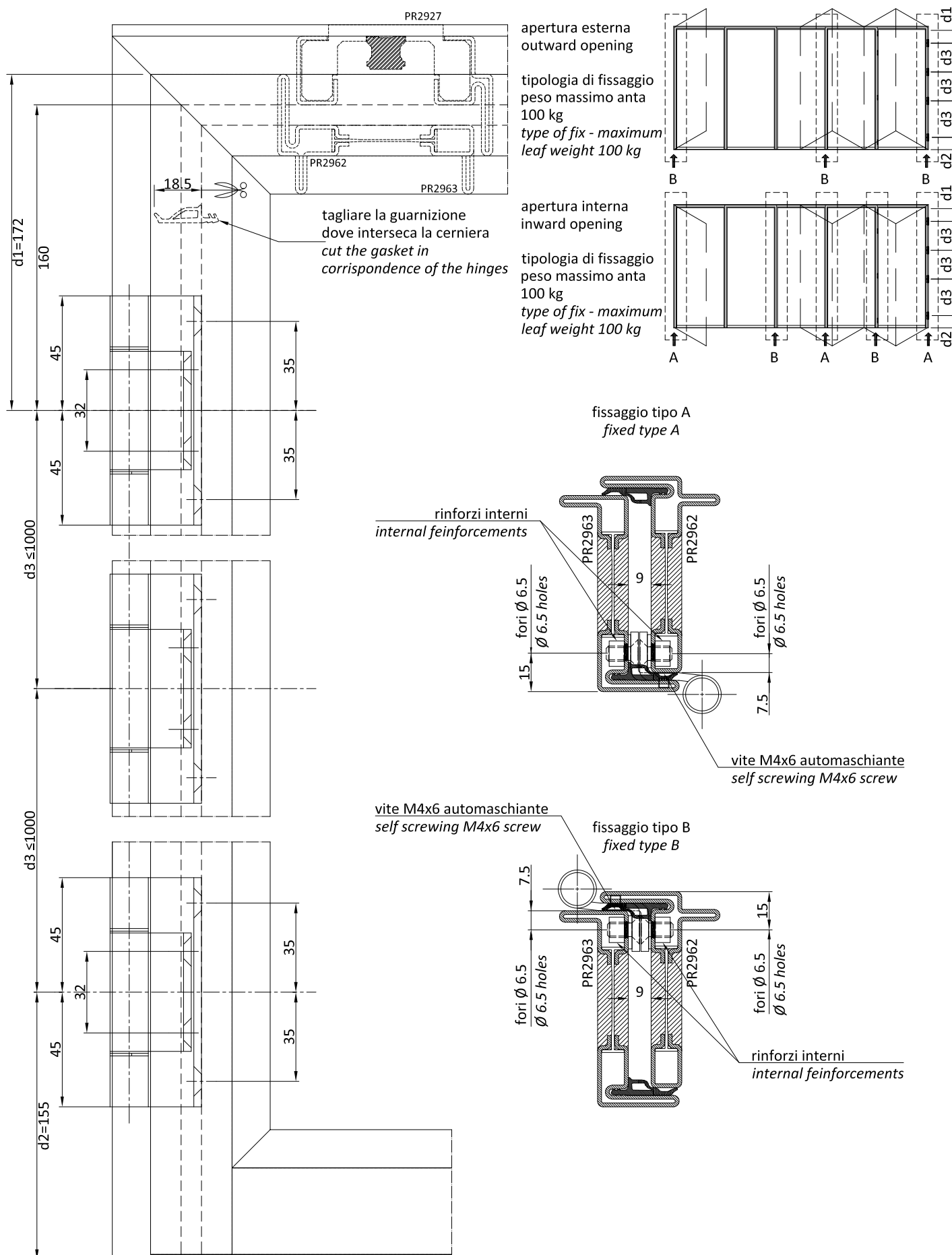
lavorazione applicazione nottolino
processing for plug installation

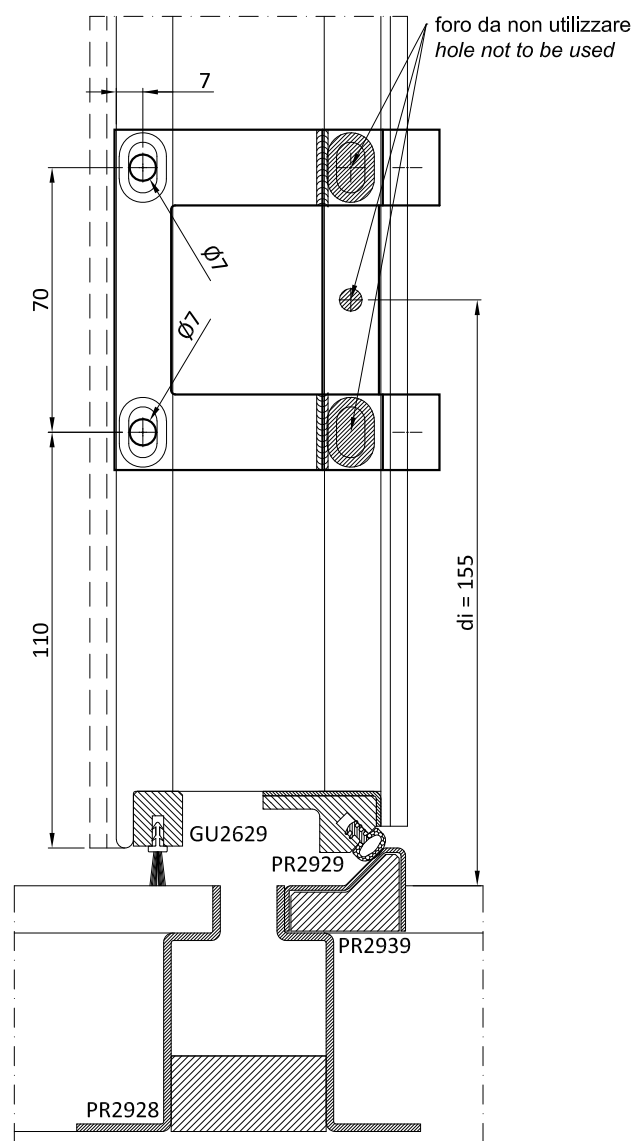
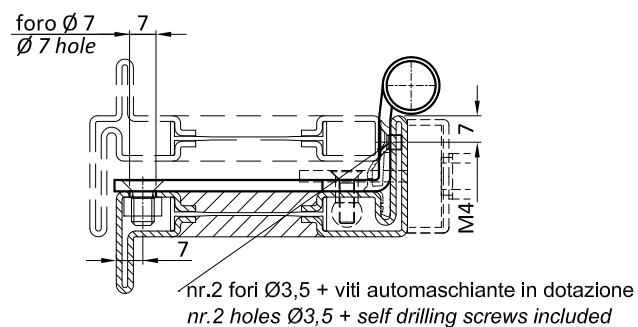
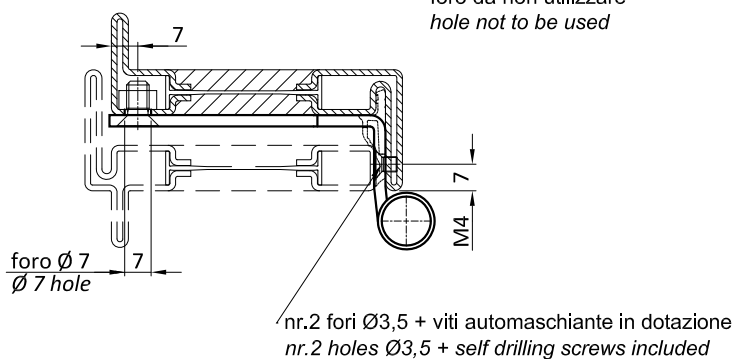
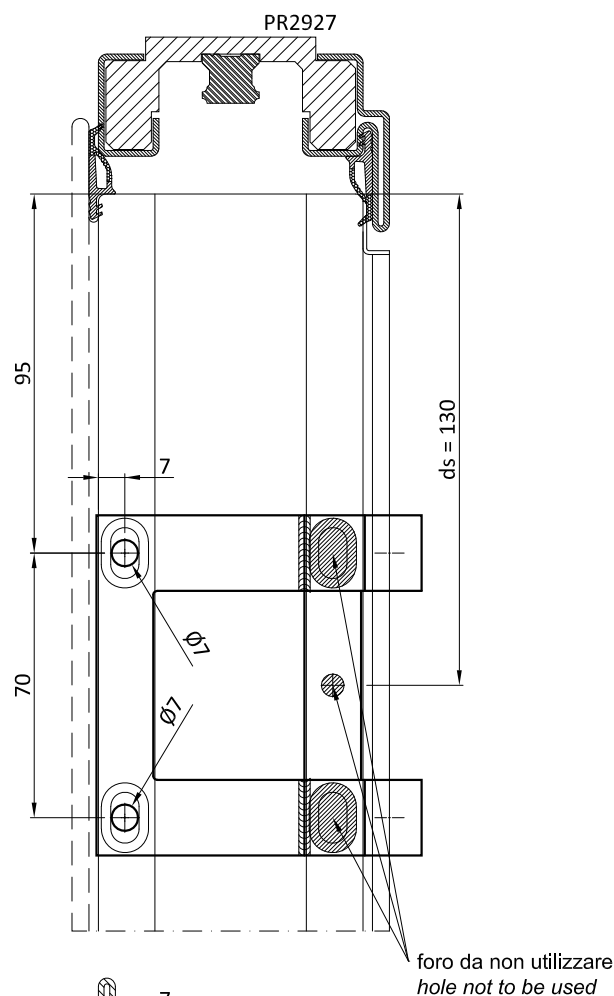
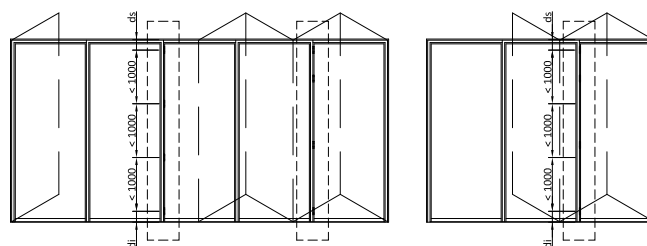
asse nottolino 3^ chiusura in posizione aperta
3rd plug axis in open leaf position



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

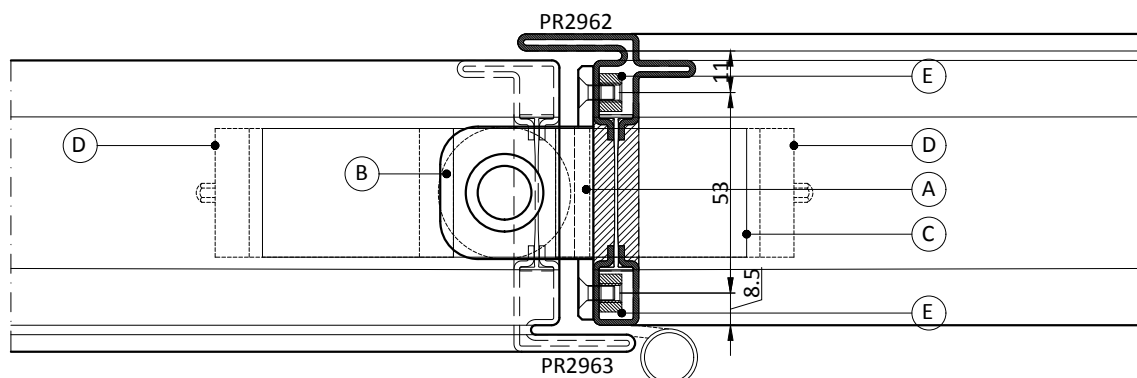
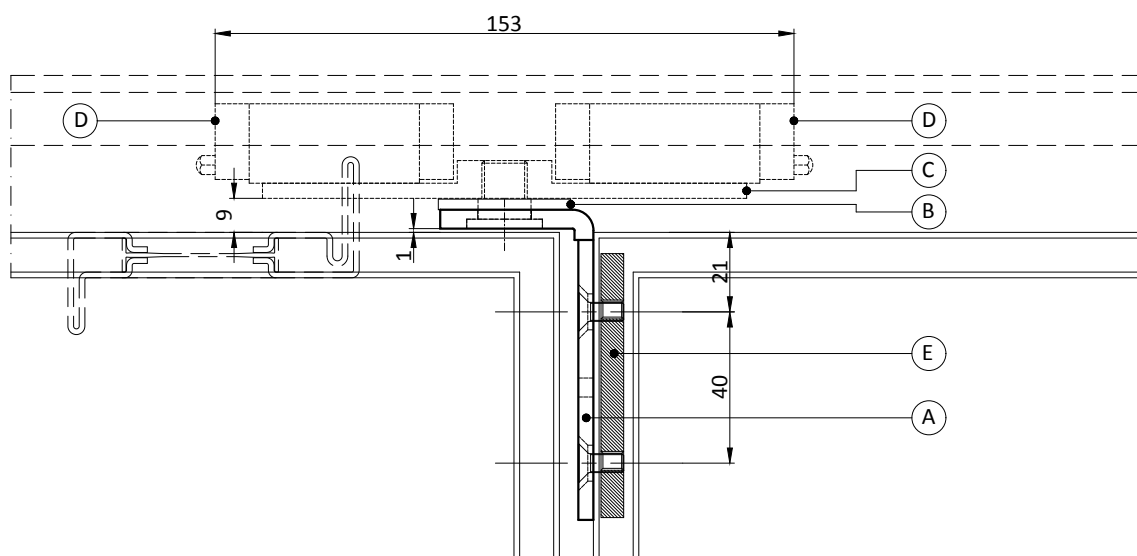
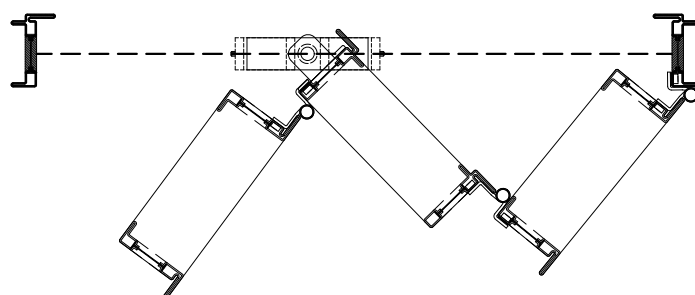
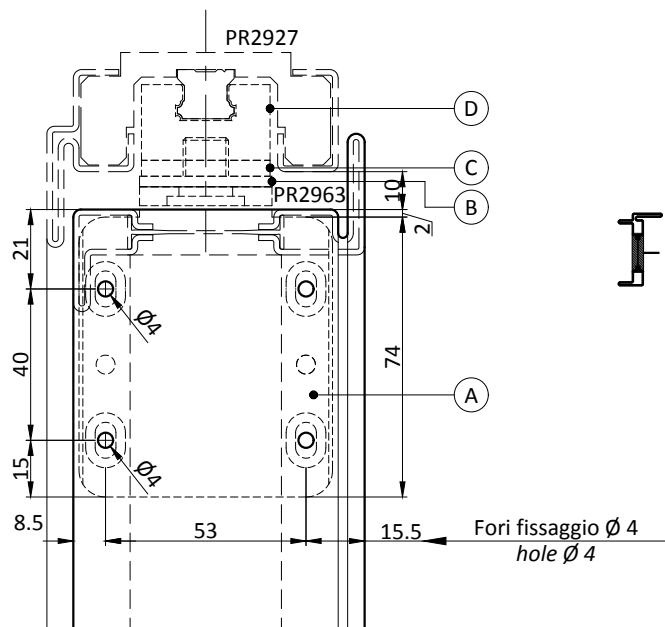
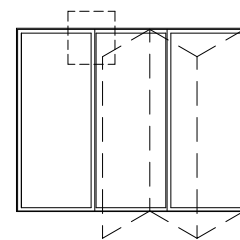




apertura ESTERNA
OUTWARD opening

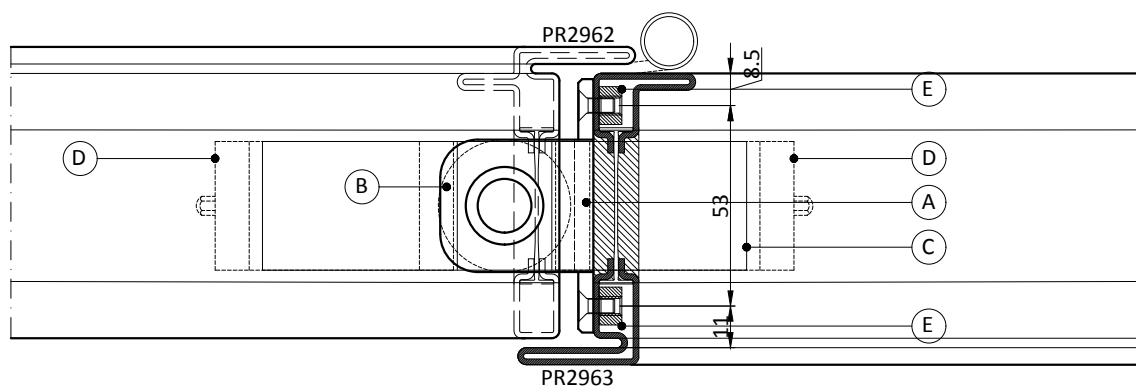
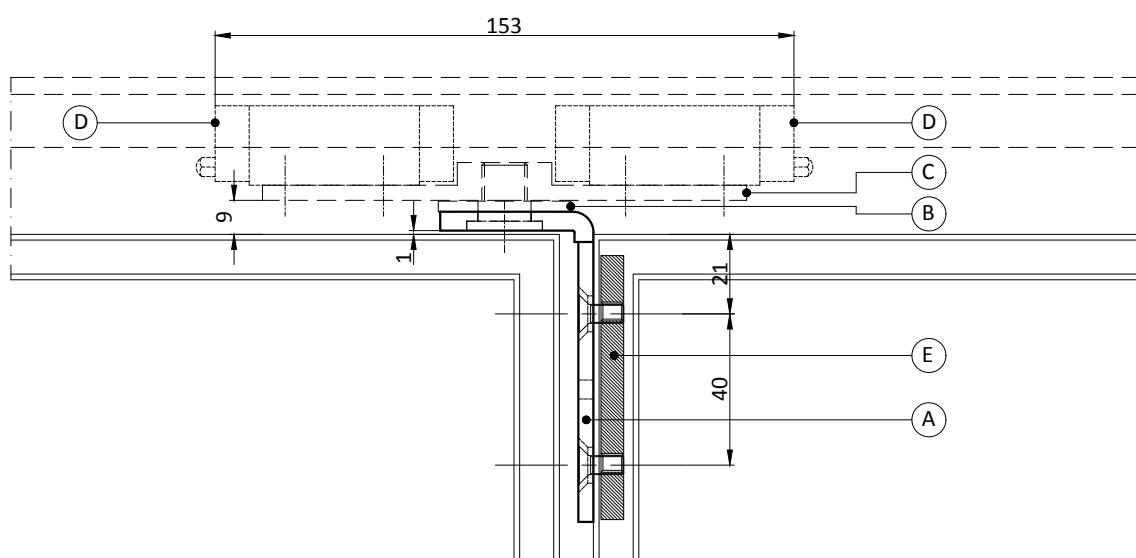
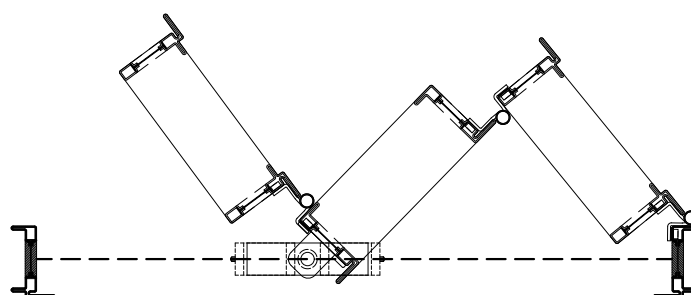
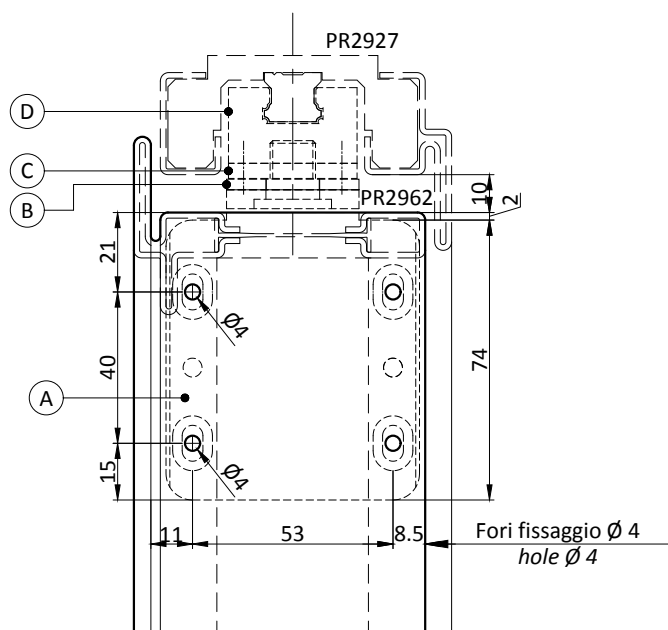
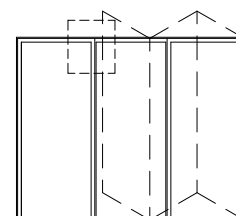
apertura INTERNA
INWARD opening

- A - Staffa angolare | Corner bracket
B - Rondella ottone | Brass washer
C - Piastra collegamento carelli | Connection plate for roller
D - Carrelli | Rollers
E - Rinforzo | Reinforcement



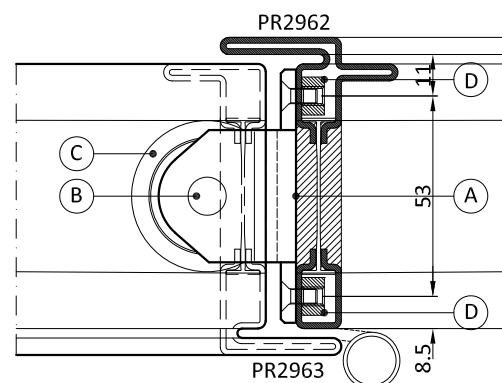
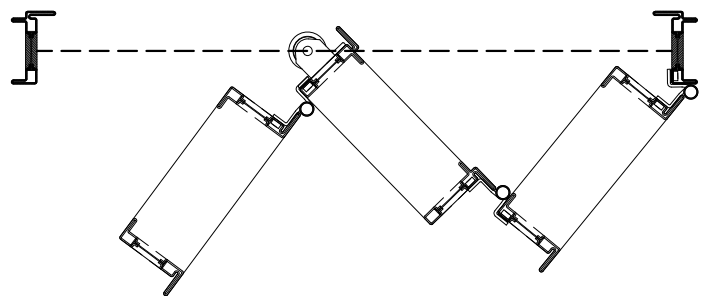
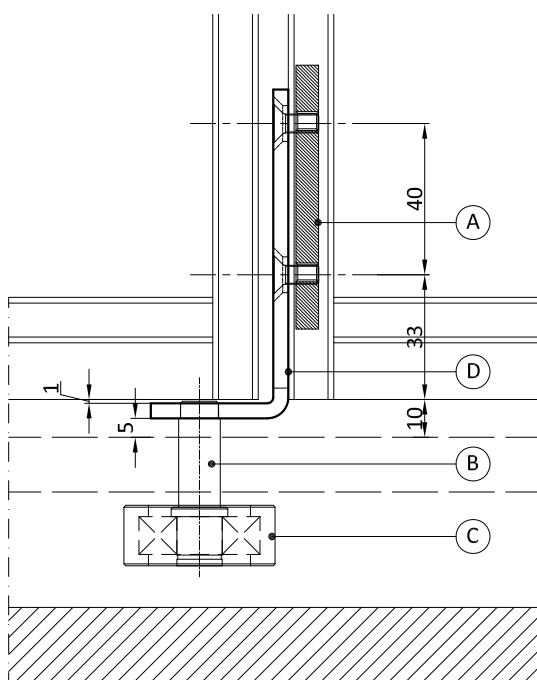
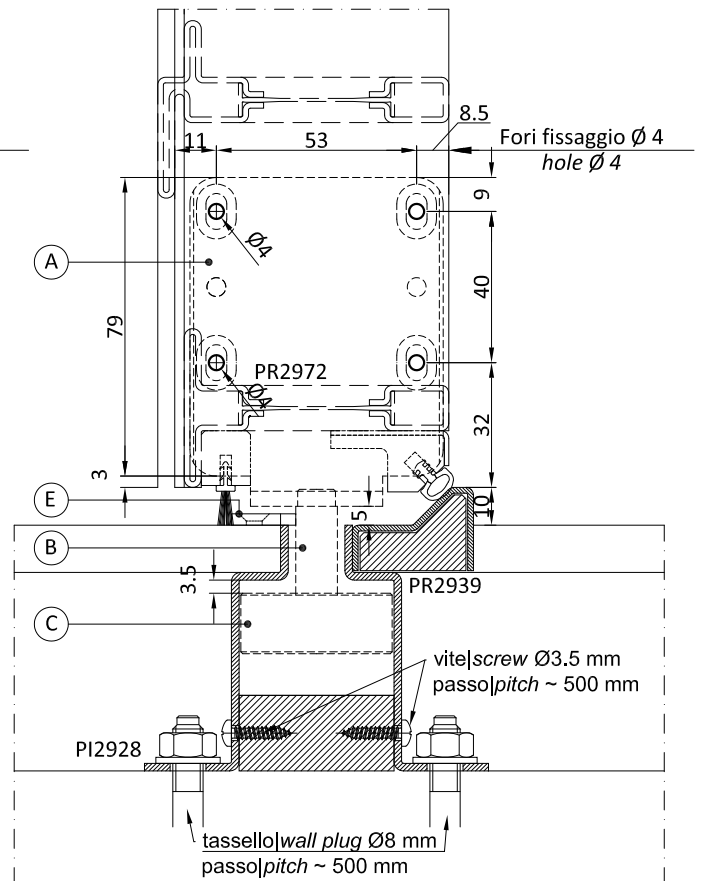
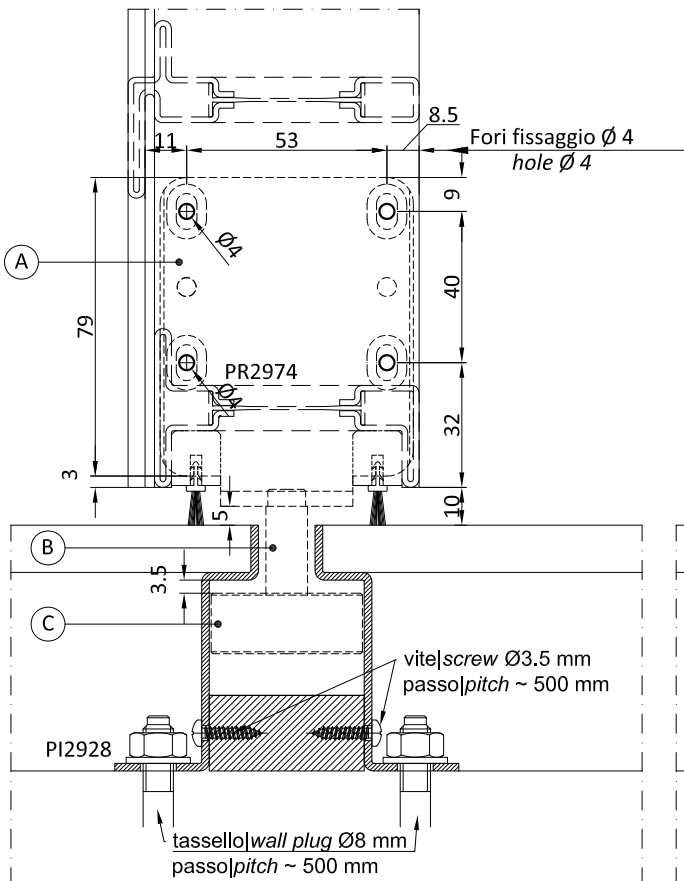
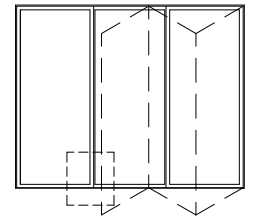
apertura ESTERNA
OUTWARD opening

- A - Staffa angolare | *Corner bracket*
 B - Rondella ottone | *Brass washer*
 C - Piastra collegamento carelli | *Connection plate for roller*
 D - Carrelli | *Rollers*
 E - Rinforzo | *Reinforcement*



apertura INTERNA
INWARD opening

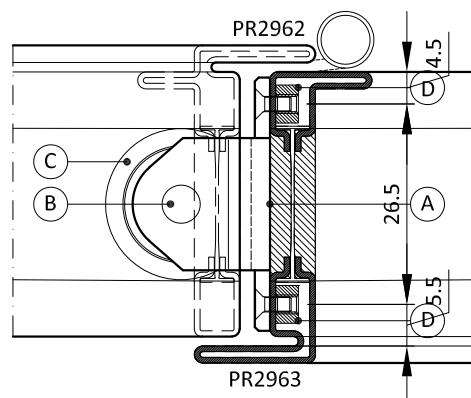
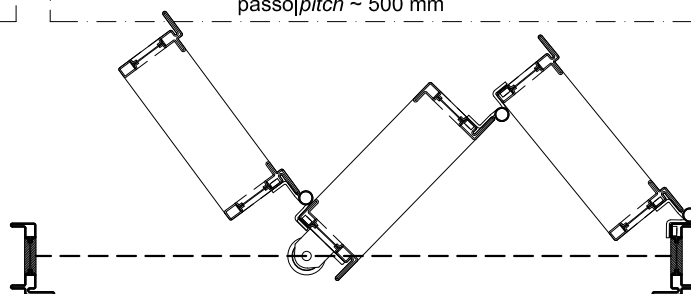
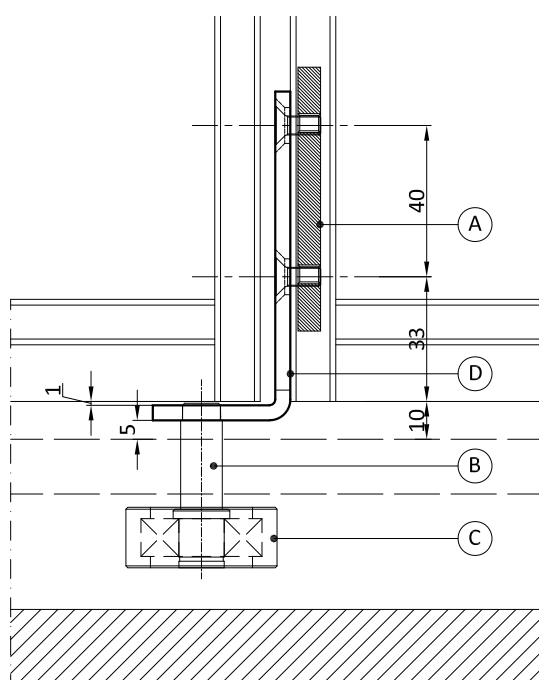
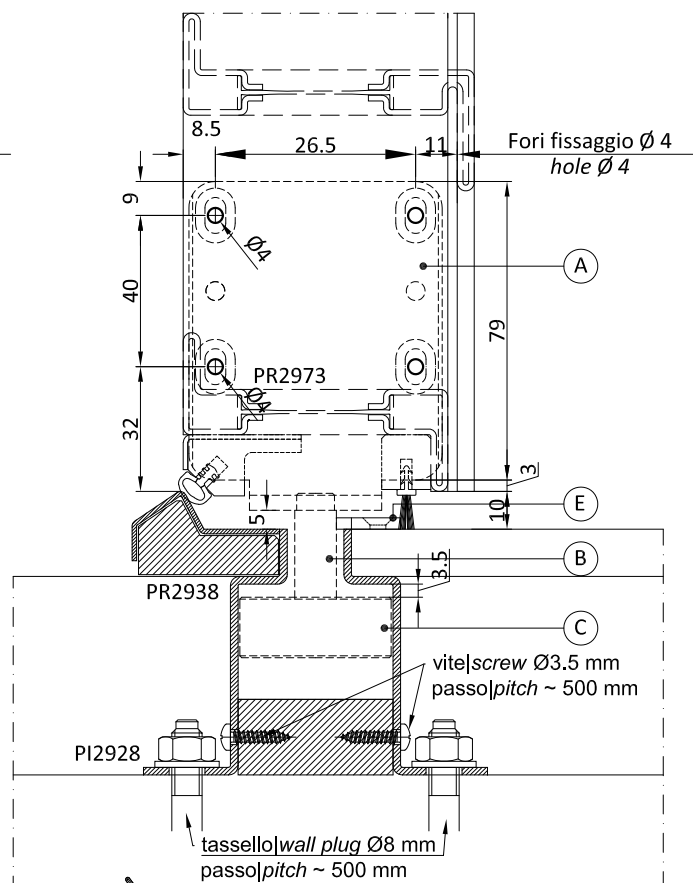
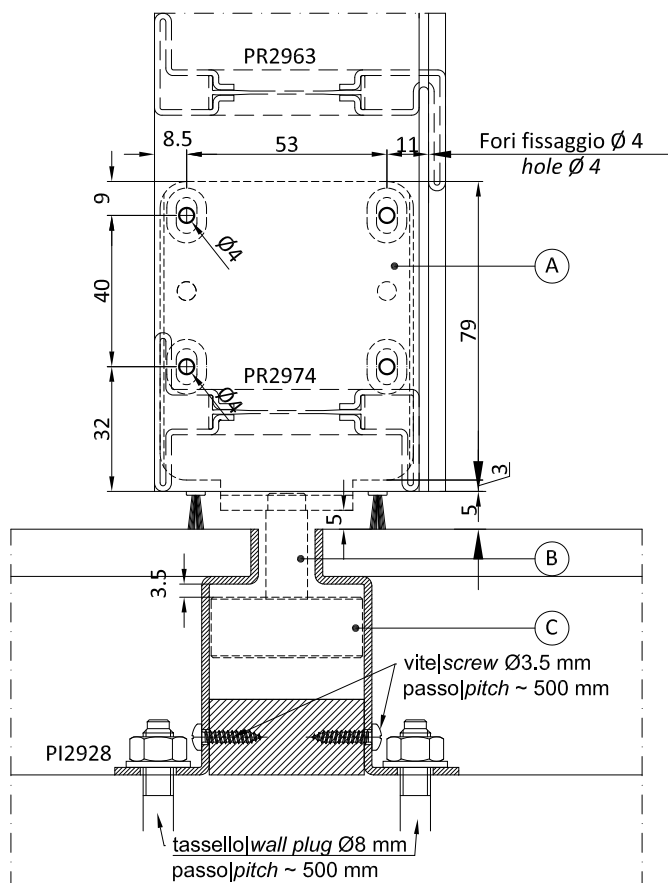
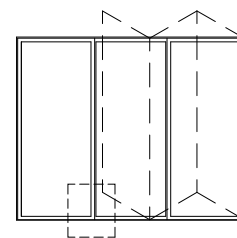
- A - Staffa angolare | Corner bracket
 B - Perno | Pivot
 C - Cuscinetto a sfera | Ball bearing
 D - Rinforzo | Reinforcement
 E - Incontro | Strike plate



viti e tasselli non inclusi | screws and wall plugs not supplied

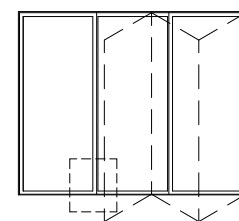
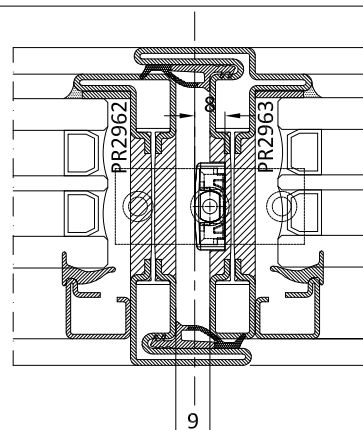
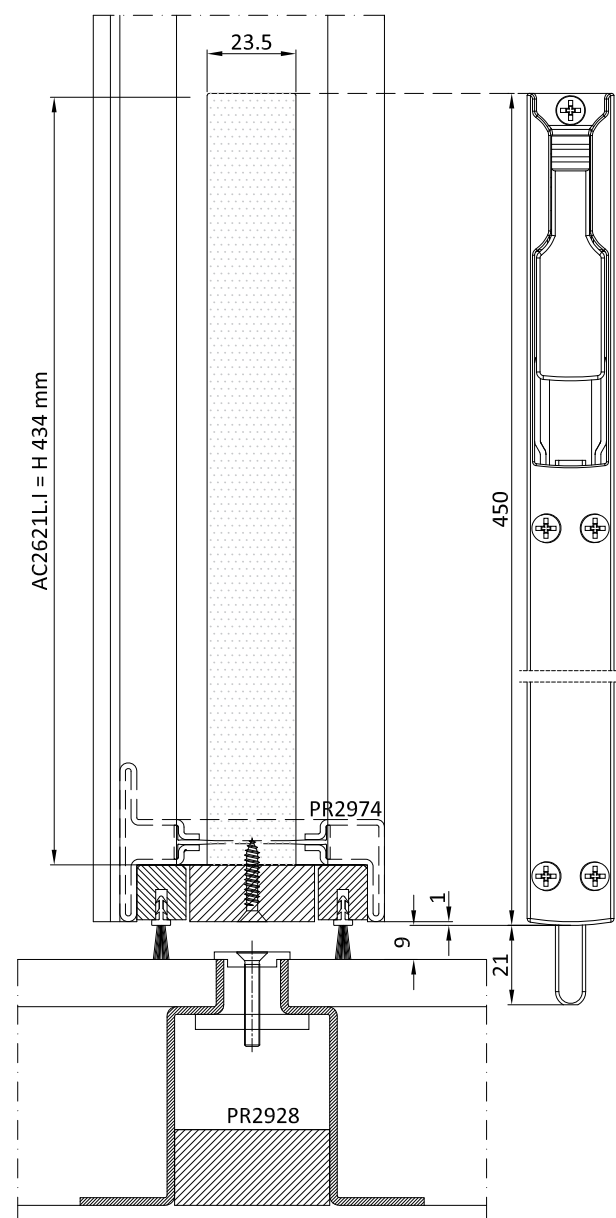
apertura ESTERNA
OUTWARD opening

- A - Staffa angolare | Corner bracket
 B - Perno | Pivot
 C - Cuscinetto a sfera | Ball bearing
 D - Rinforzo | Reinforcement
 E - Incontro | Strike plate

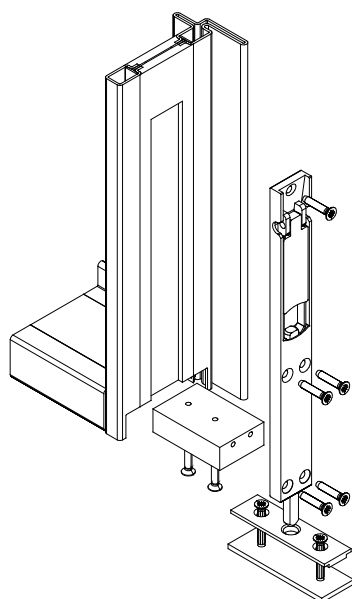
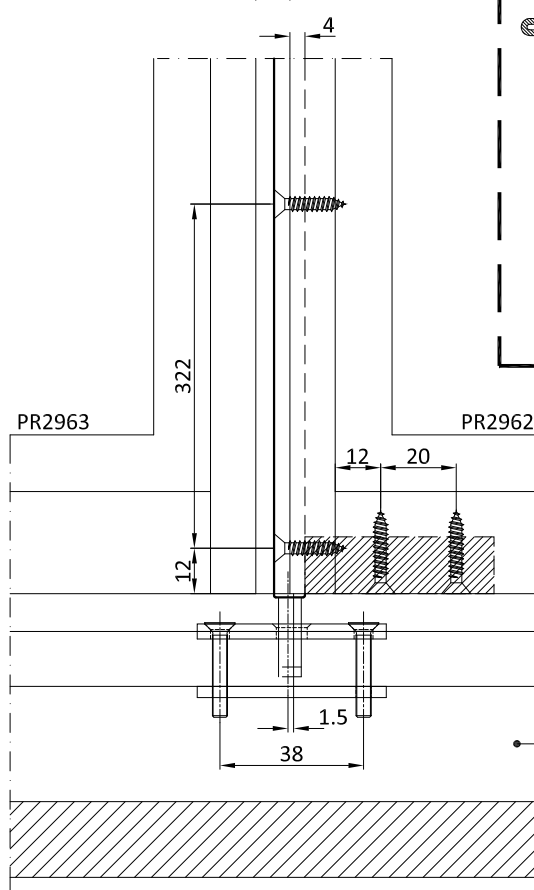
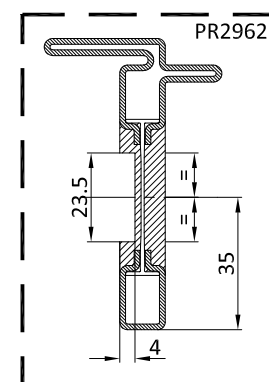


viti e tasselli non inclusi | screws and wall plugs not supplied

apertura INTERNA
INWARD opening

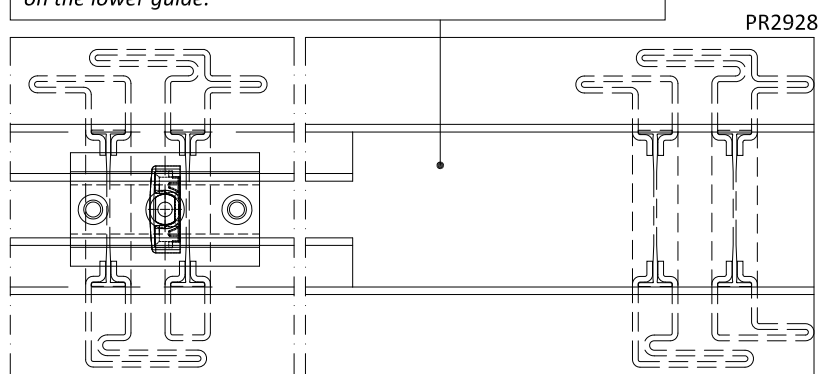


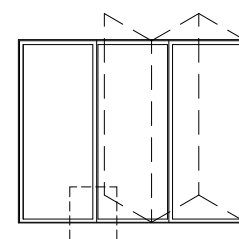
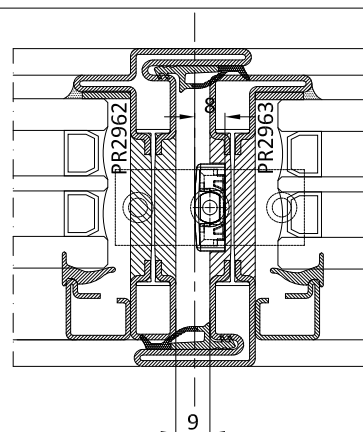
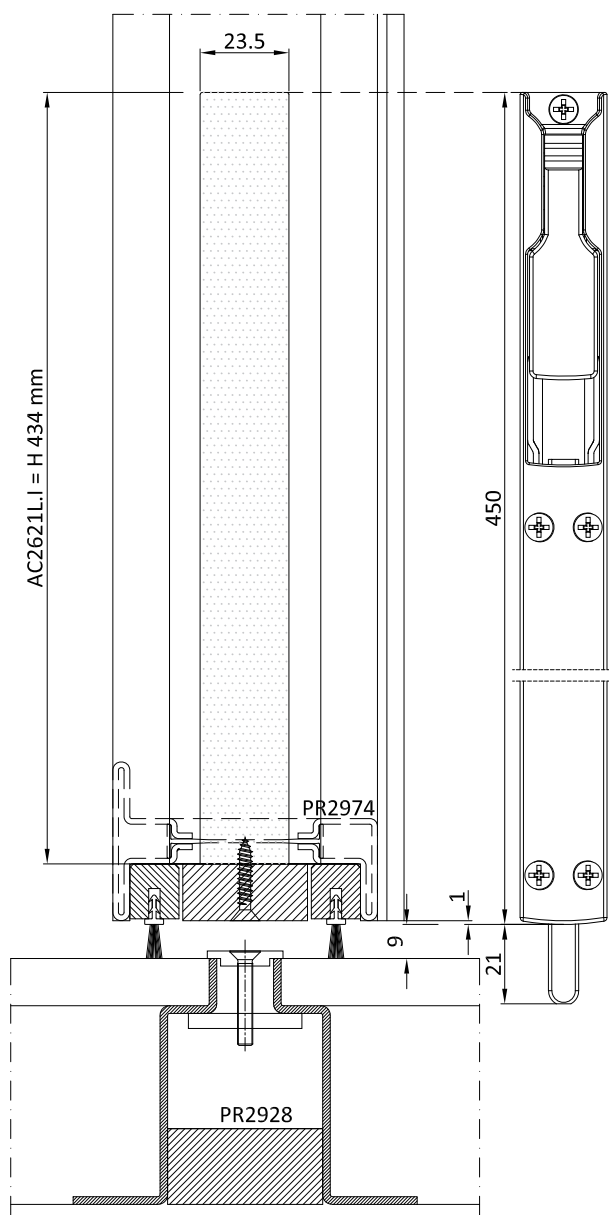
Applicazione valida anche
con profilo zoccolo PR2973
*Application valid with
PR2973 bottom profile*



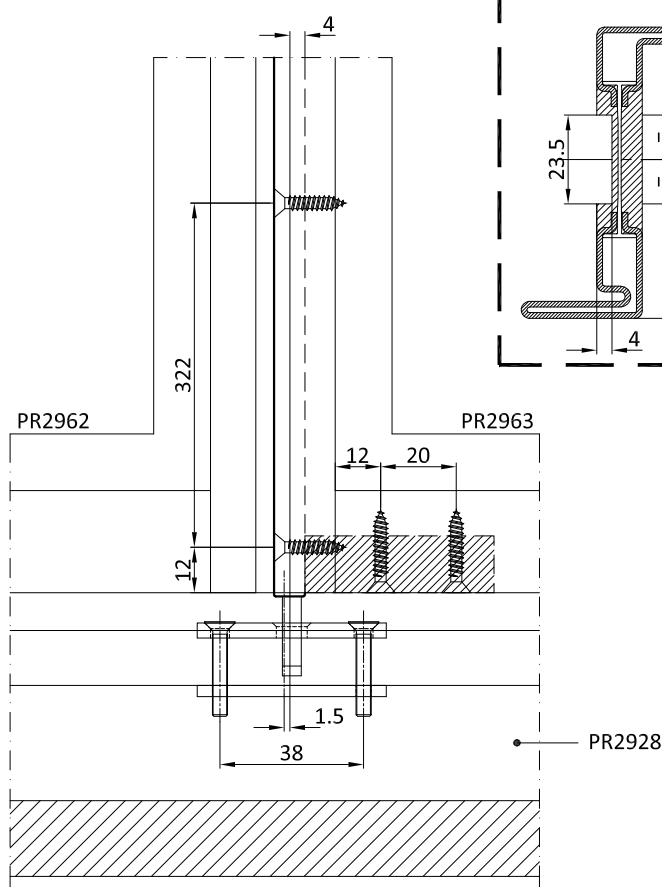
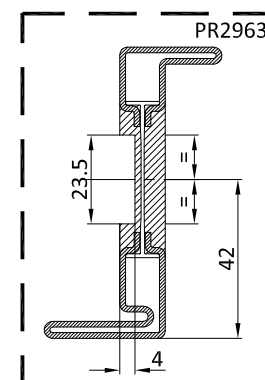
Pre-assemblare l'incontro, inserirlo dallo scasso guida necessario ai carrelli inferiori, farlo scorrere nella corretta posizione prima di inserire ante e carrelli.

Pre-assemble the strike plate before fitting the sashes and rollers, insert and slide it into position from the slot for the bottom rollers on the lower guide.

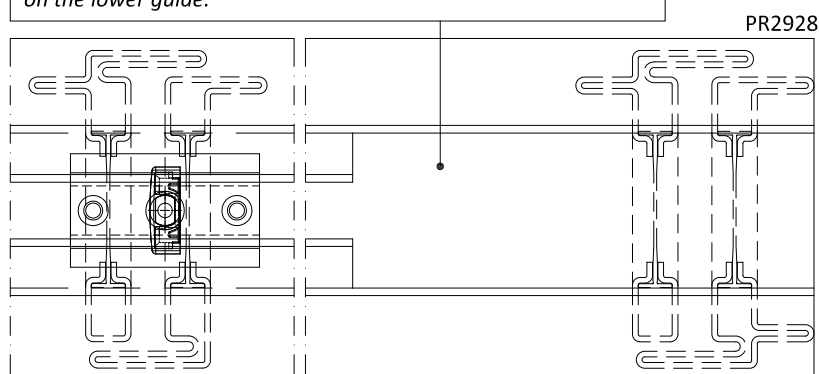
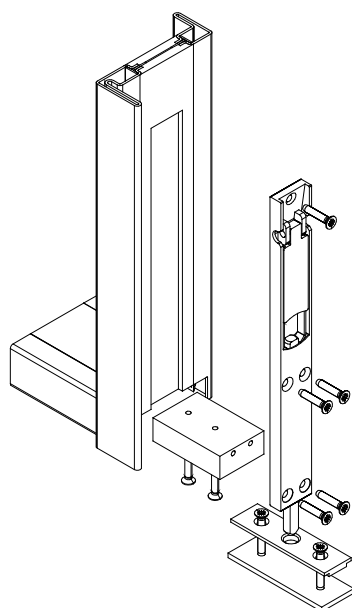


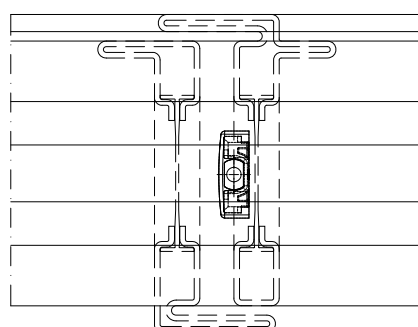
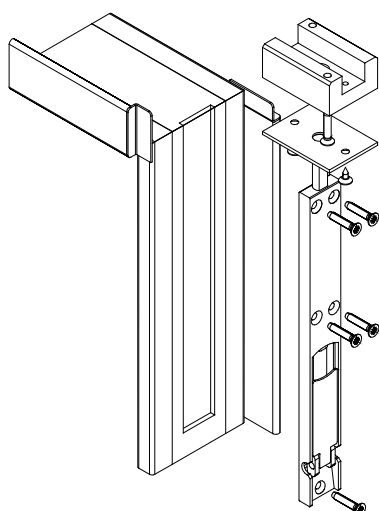
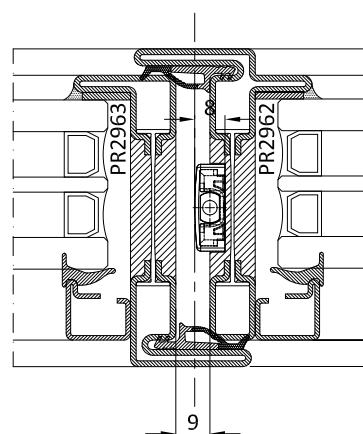
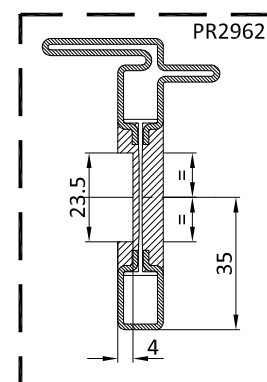
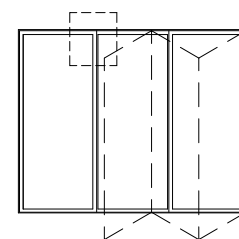
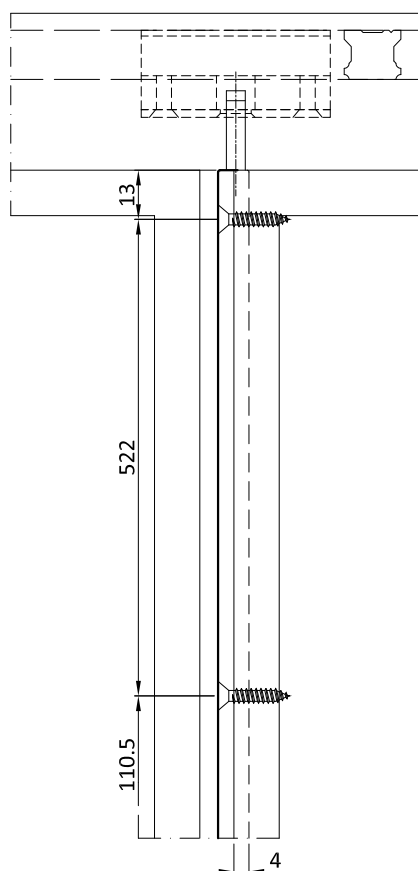
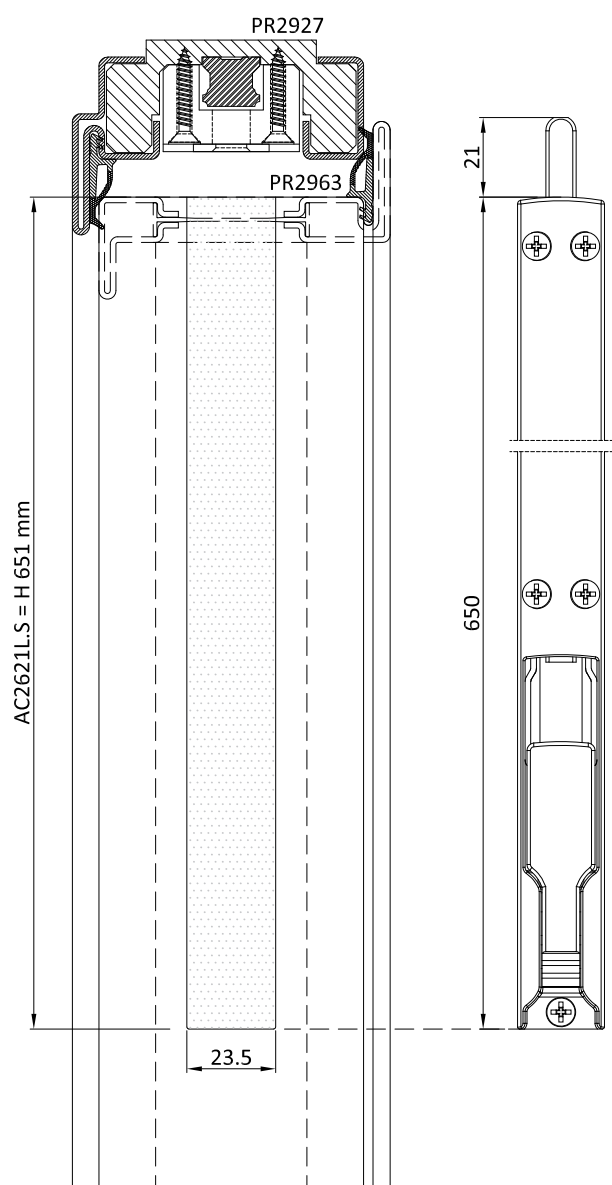
apertura ESTERNA
OUTWARD opening

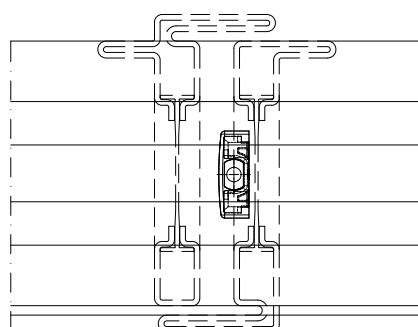
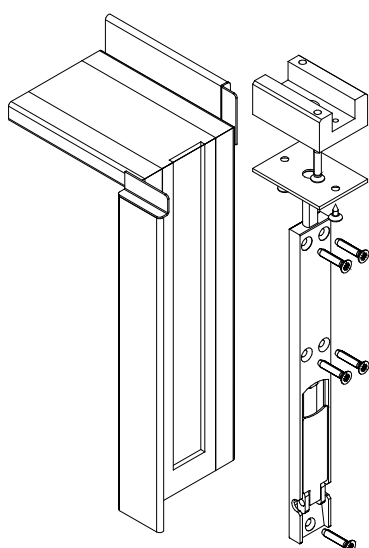
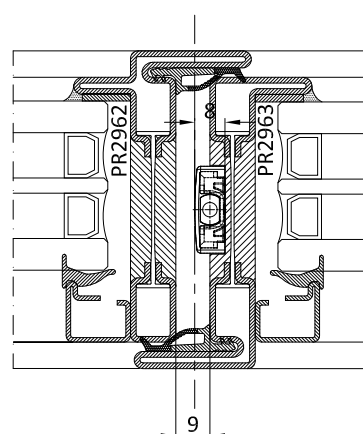
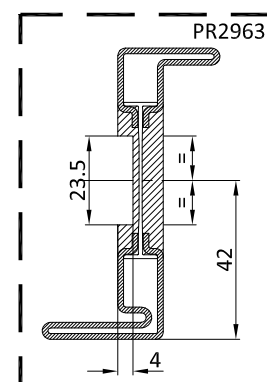
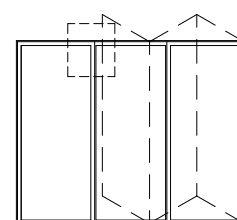
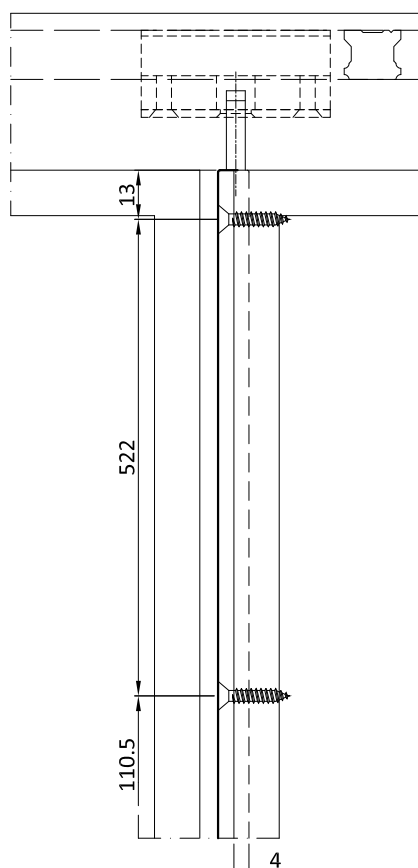
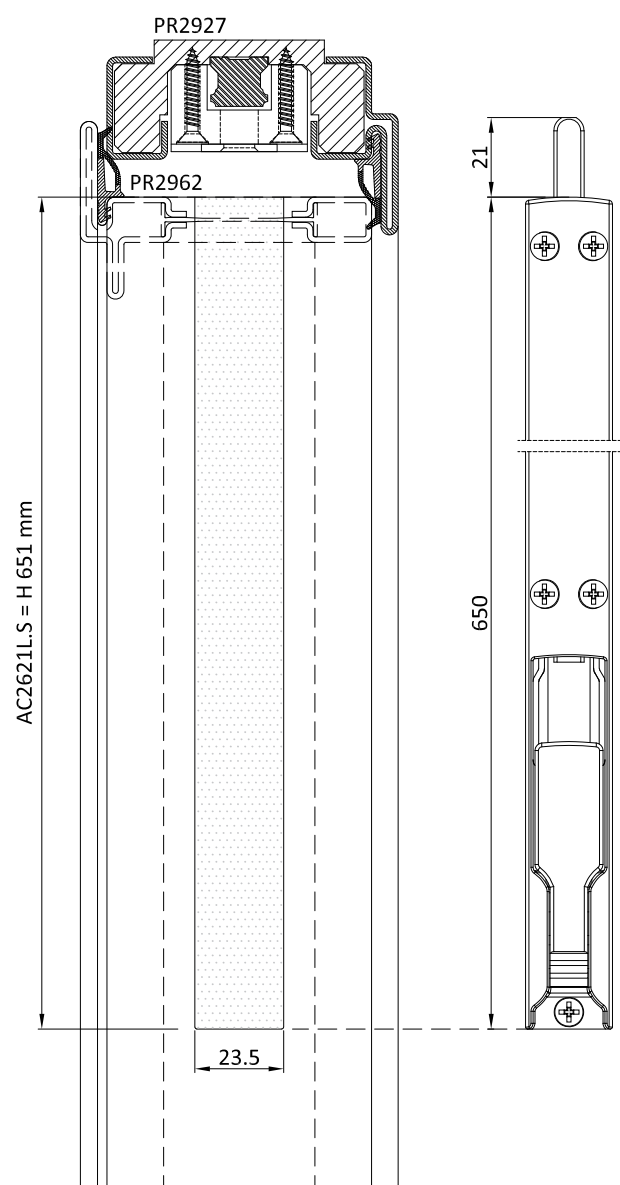
Applicazione valida anche
con profilo zoccolo PR2972
Application valid with
PR2972 bottom profile

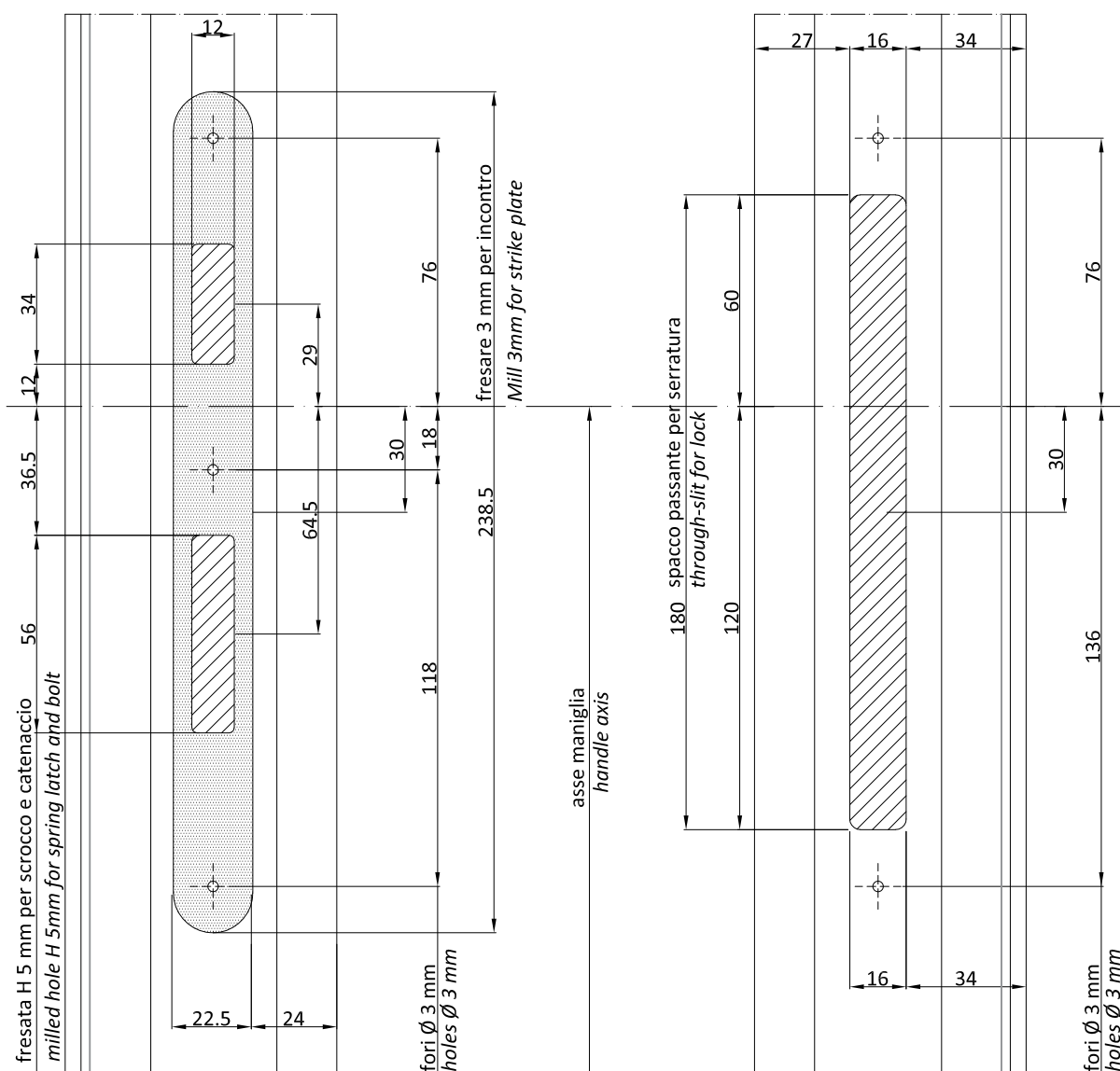
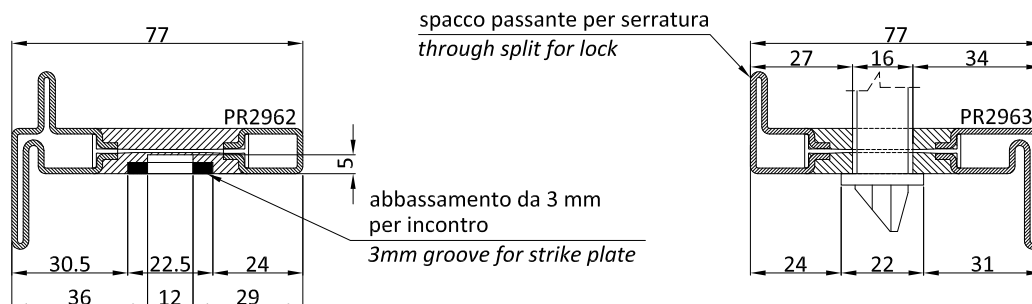
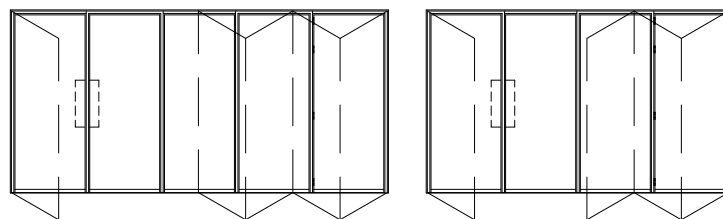


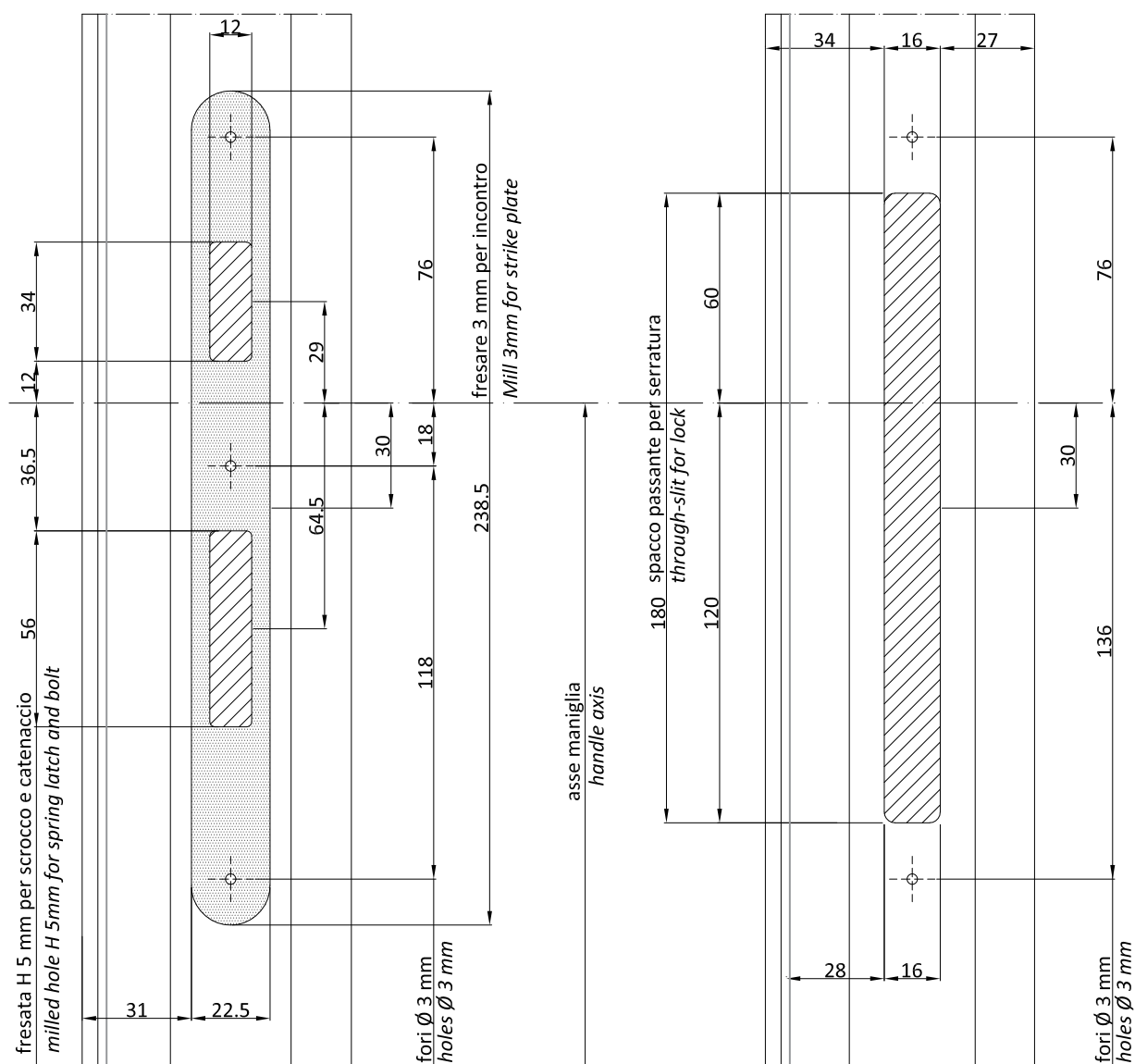
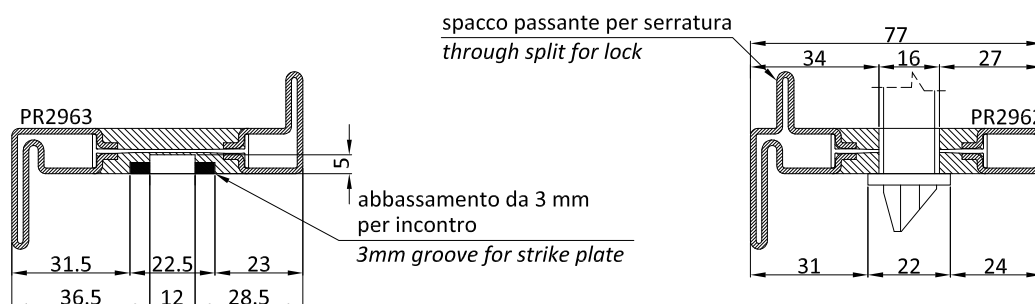
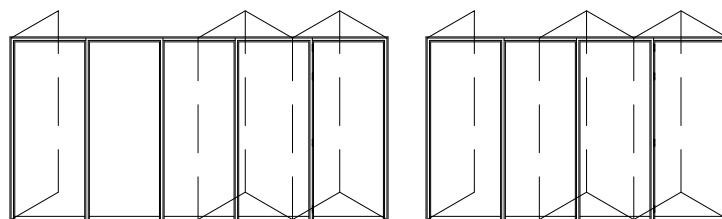
Pre-assemblare l'incontro, inserirlo dallo scasso guida necessario
ai carrelli inferiori, farlo scorrere nella corretta posizione prima di
inserire ante e carrelli.
Pre-assemble the strike plate before fitting the sashes and rollers,
insert and slide it into position from the slot for the bottom rollers
on the lower guide.

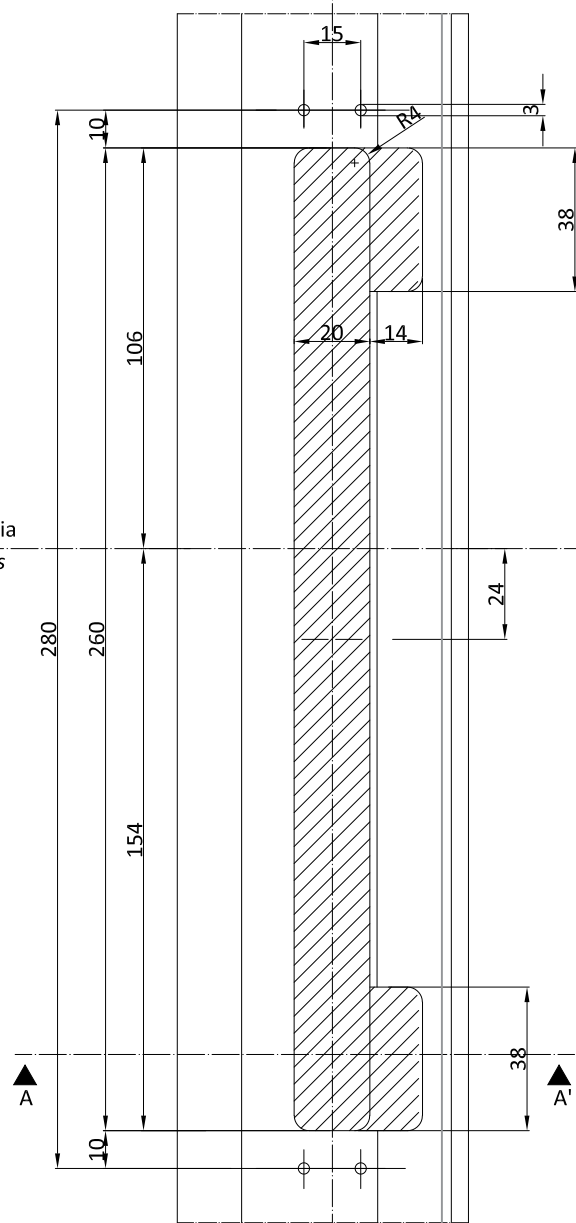
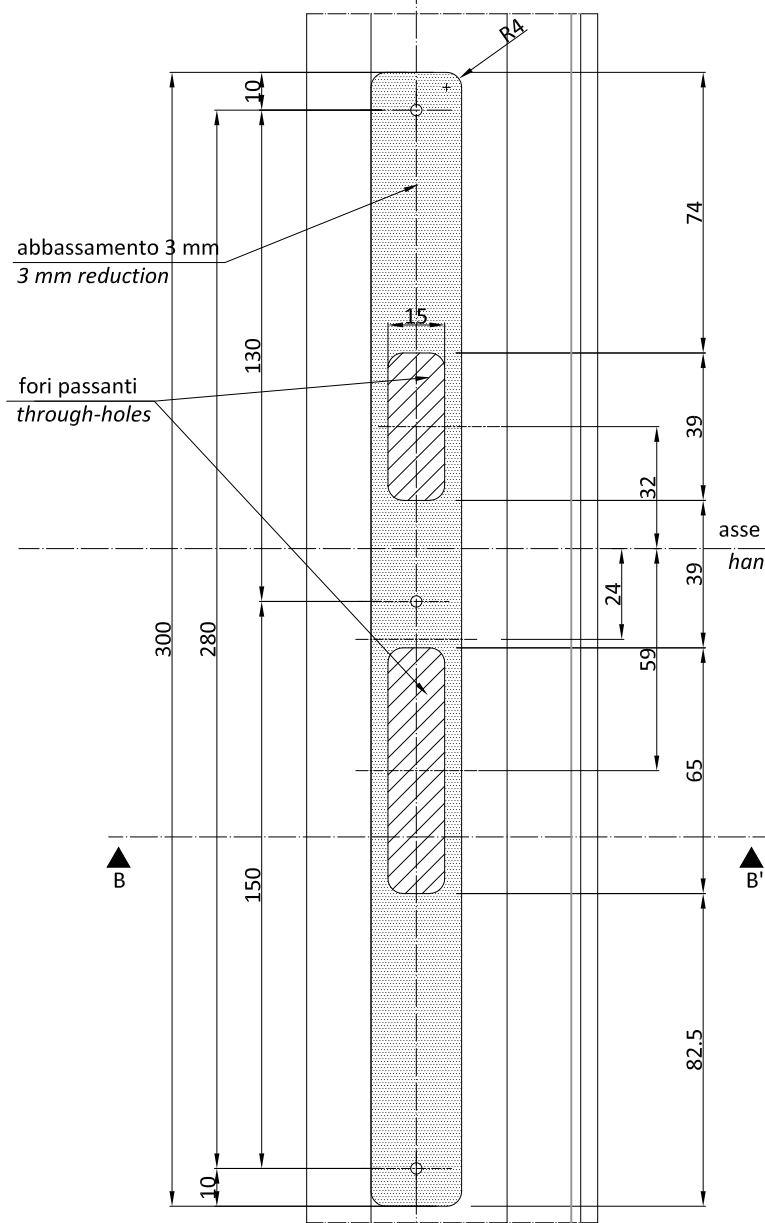
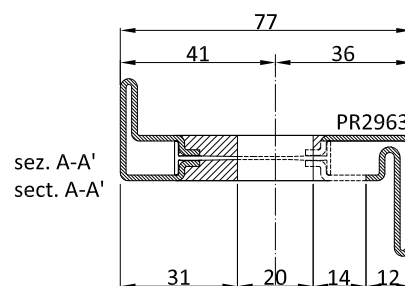
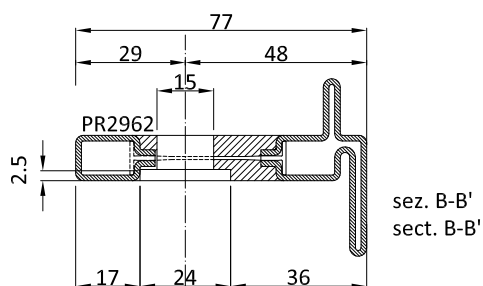
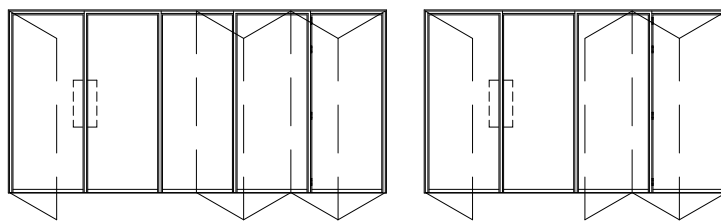


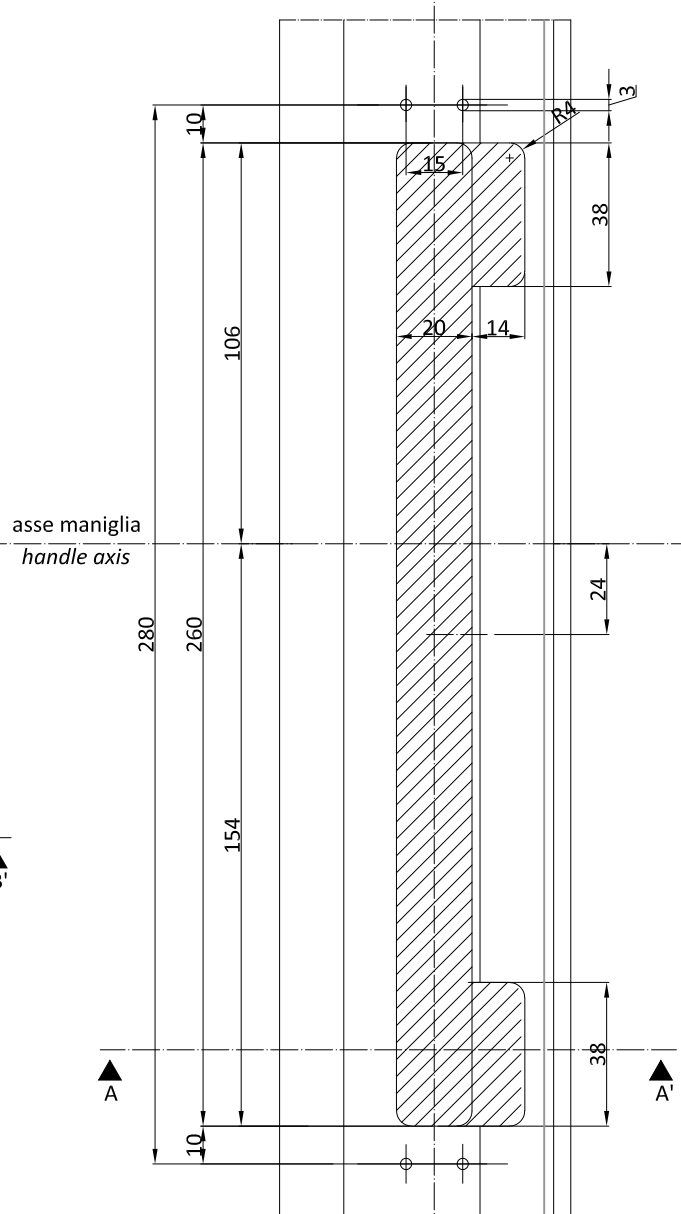
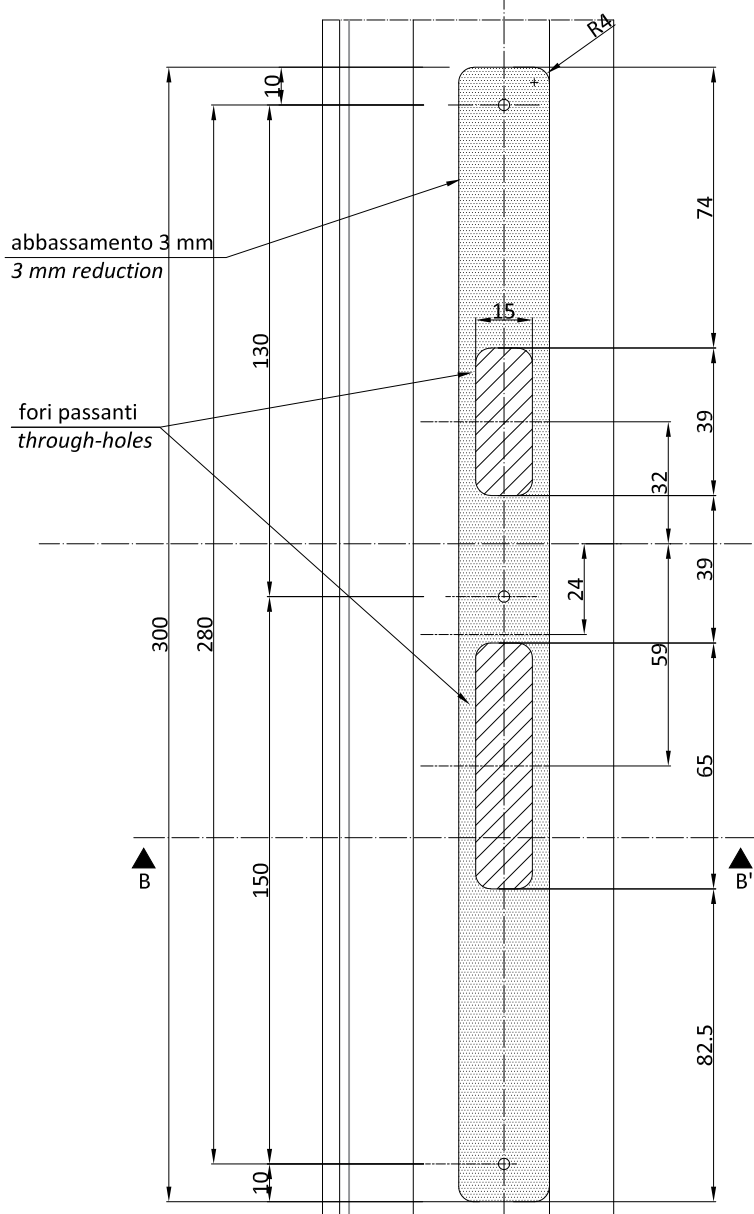
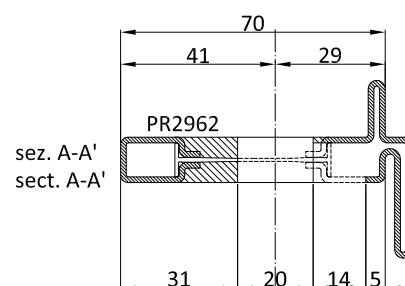
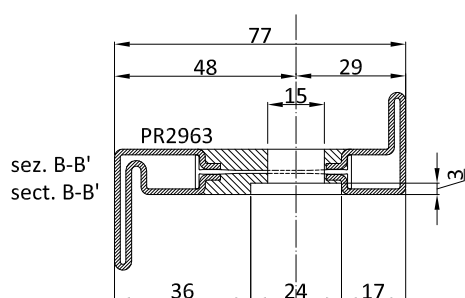
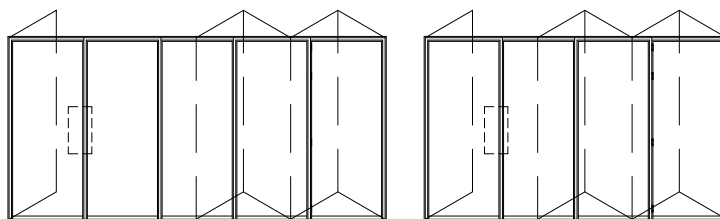
apertura INTERNA
INWARD opening

apertura ESTERNA
OUTWARD opening

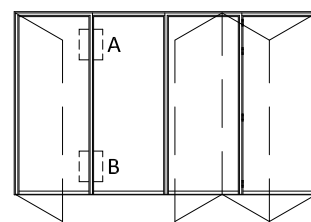
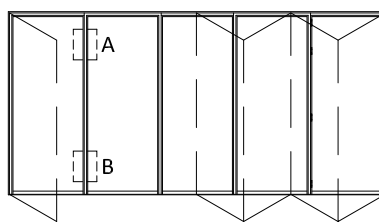
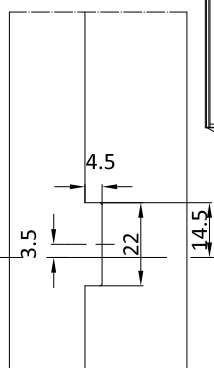
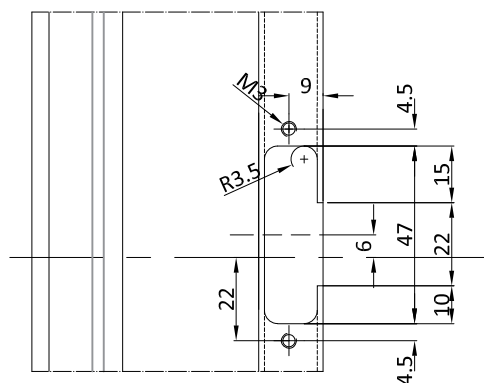




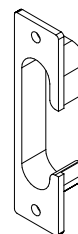




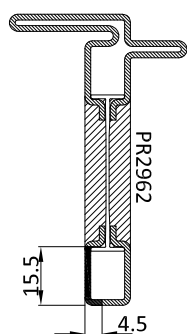
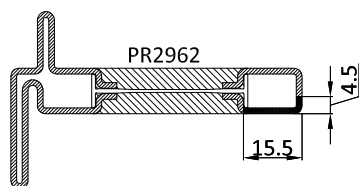
lavorazione applicazione incontro
processing strike plate installation



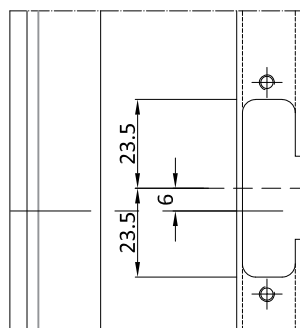
asse nottolino 3^a chiusura in posizione aperta
latch axis for the 3rd lock in open position



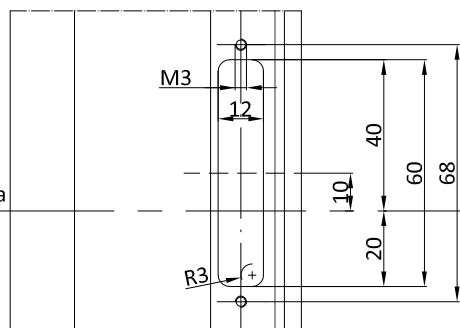
Incontro 3^a chiusura
3rd lock strike plate



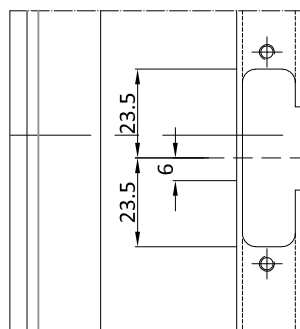
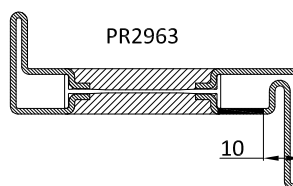
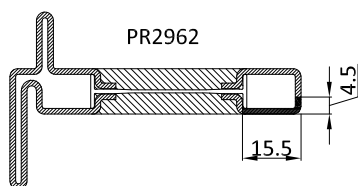
lavorazione applicazione nottolino
processing for the assembling of the 3rd lock



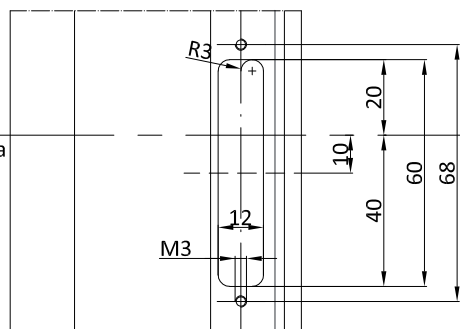
asse nottolino 3^a chiusura in posizione aperta
latch axis for the 3rd lock in open position



lavorazione superiore A
upper processing A



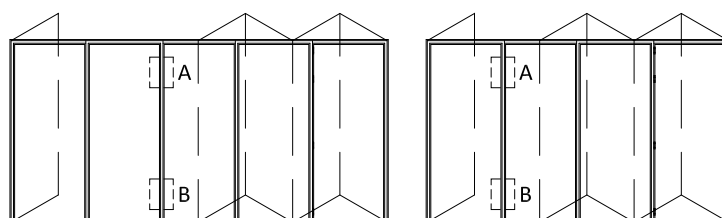
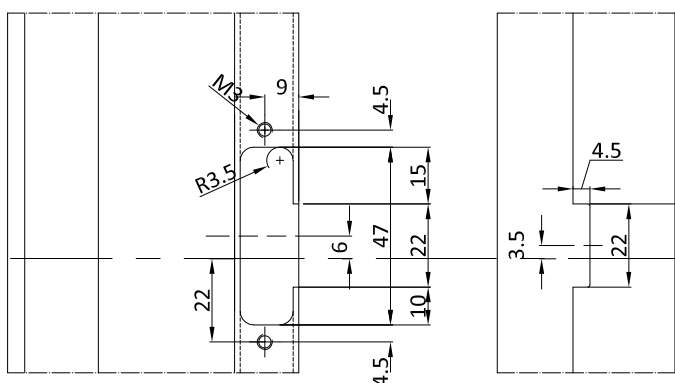
latch axis for the 3rd lock in open position
asse nottolino 3^a chiusura in posizione aperta



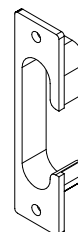
lavorazione inferiore B
lower processing B

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

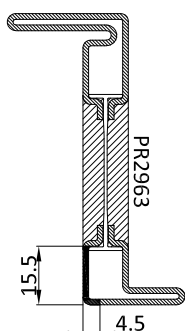
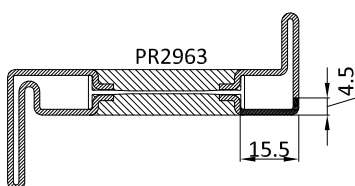
lavorazione applicazione incontro
processing strike plate installation



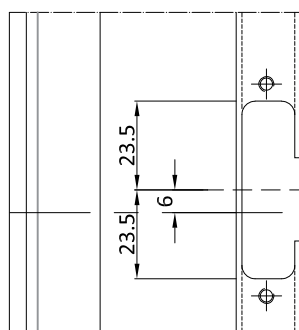
asse nottolino 3^a chiusura in posizione aperta
latch axis for the 3rd lock in open position



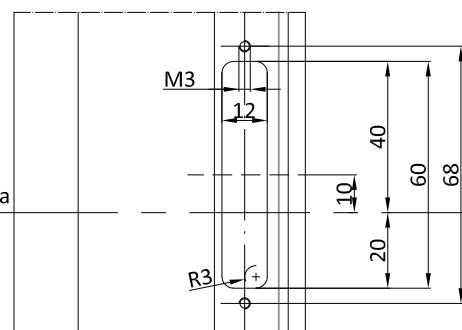
Incontro 3^a chiusura
3rd lock strike plate



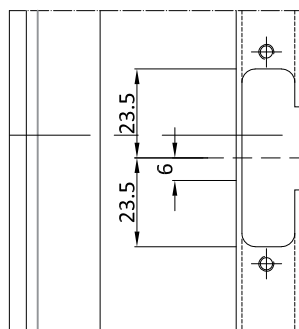
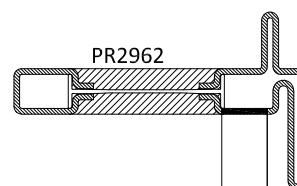
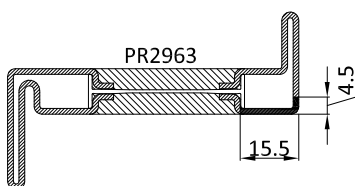
lavorazione applicazione nottolino
processing for the assembling of the 3rd lock



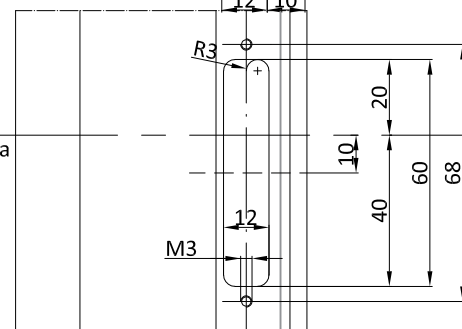
asse nottolino 3^a chiusura in posizione aperta
latch axis for the 3rd lock in open position



lavorazione superiore A
upper processing A

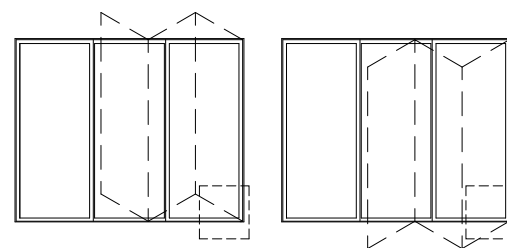


latch axis for the 3rd lock in open position
asse nottolino 3^a chiusura in posizione aperta

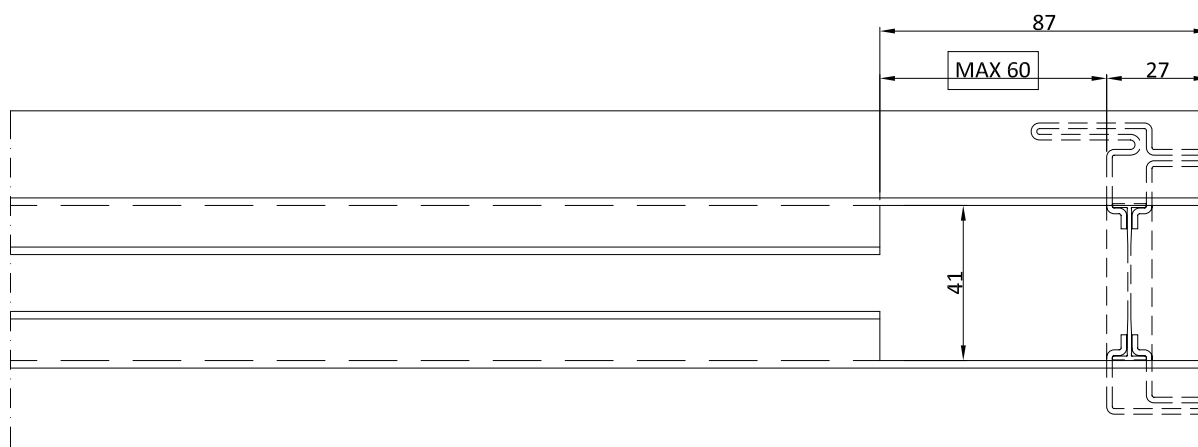
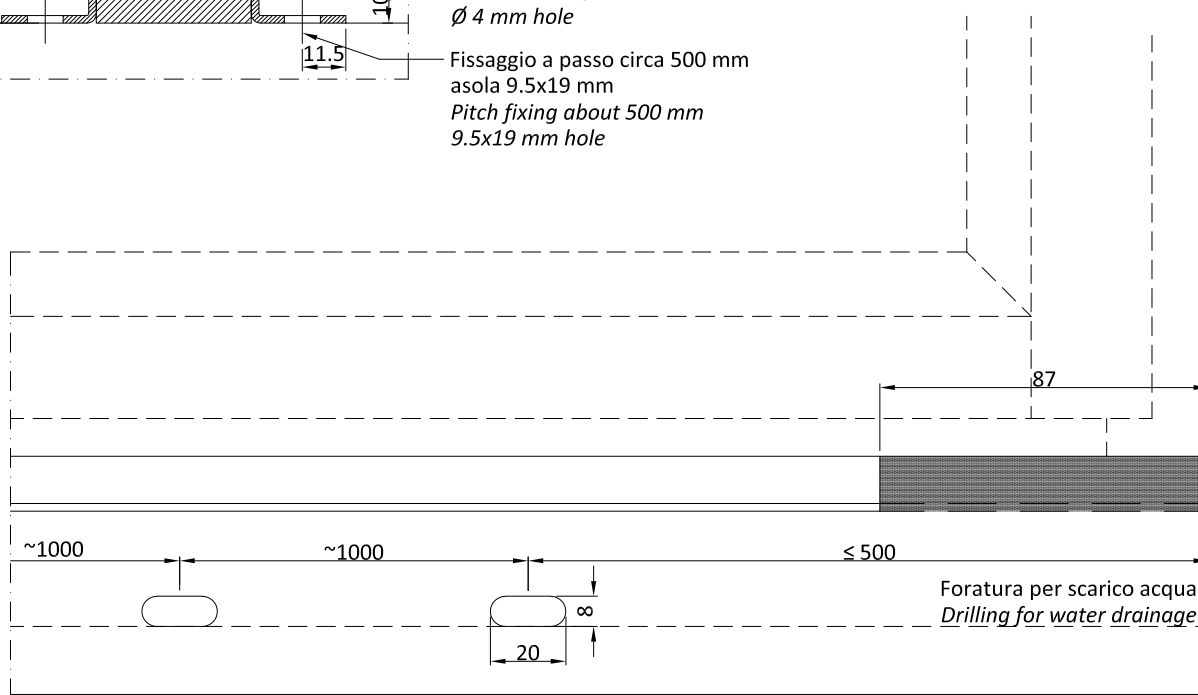
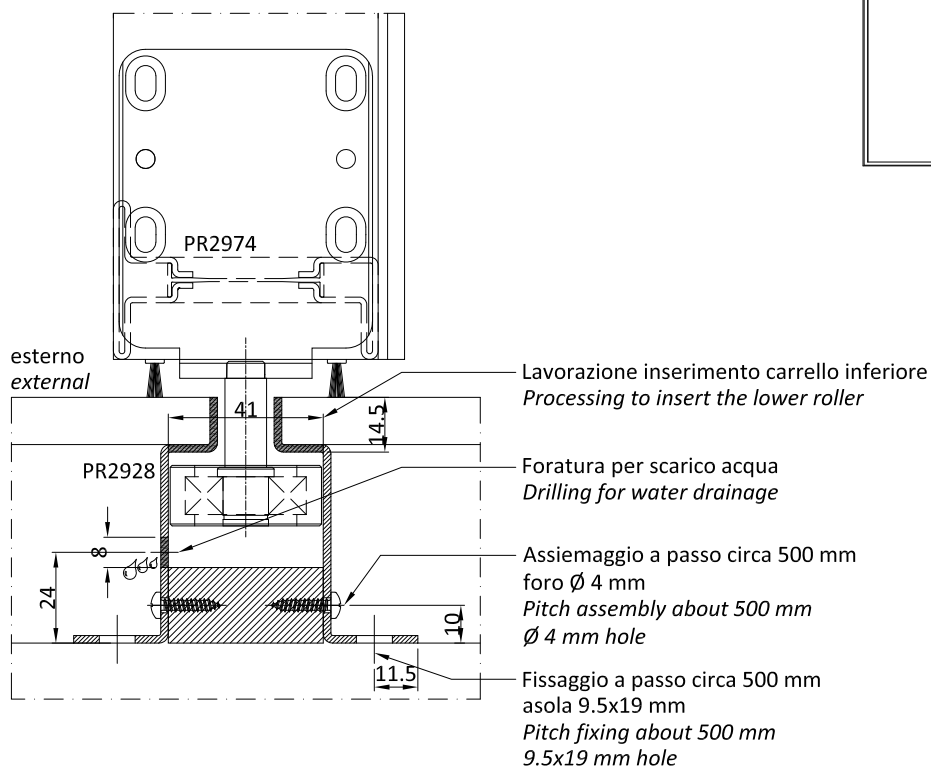


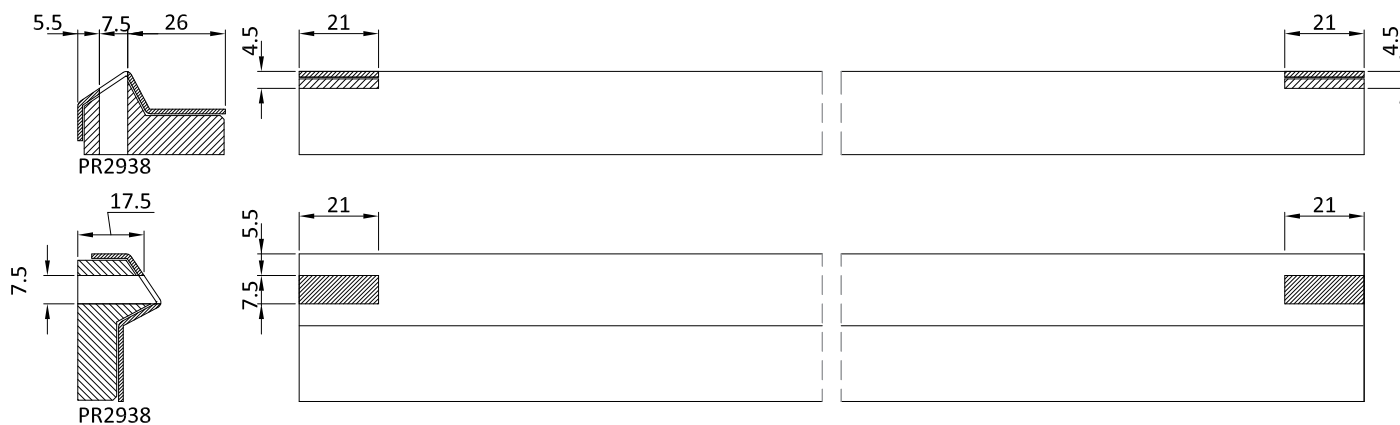
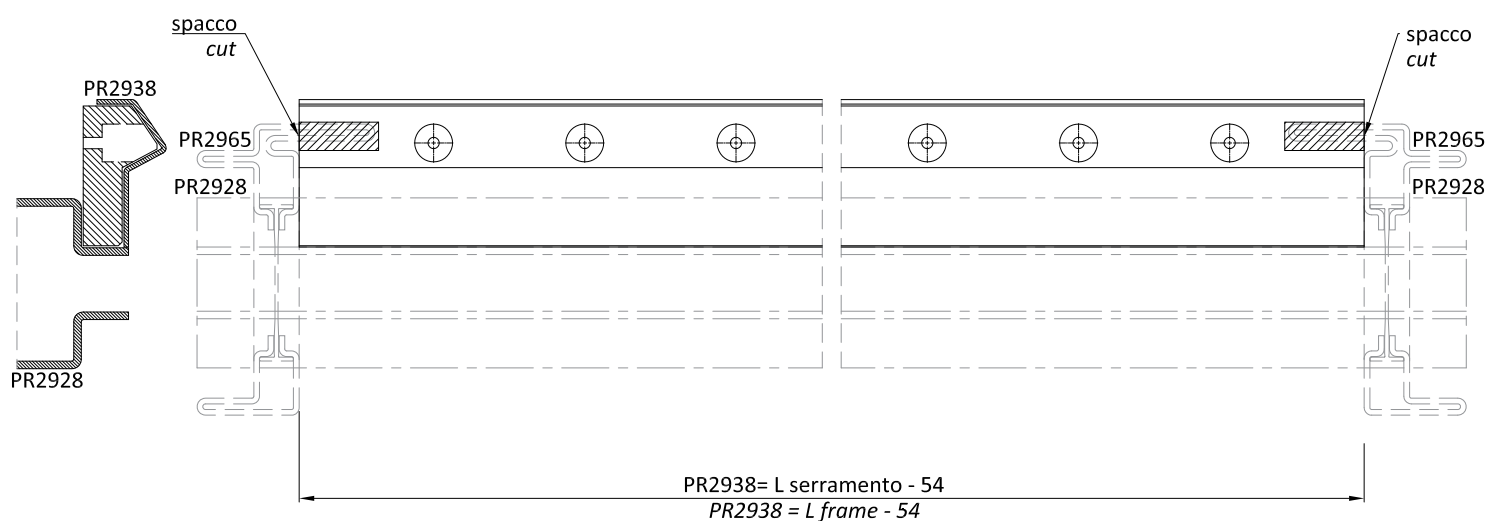
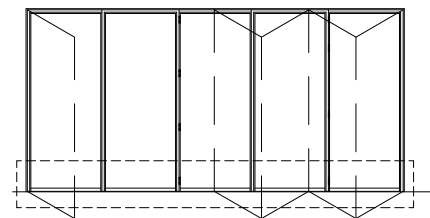
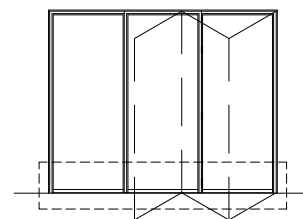
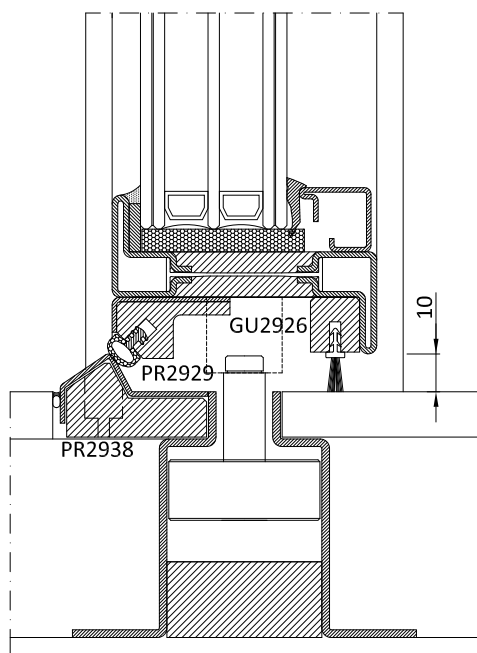
lavorazione inferiore B
lower processing B

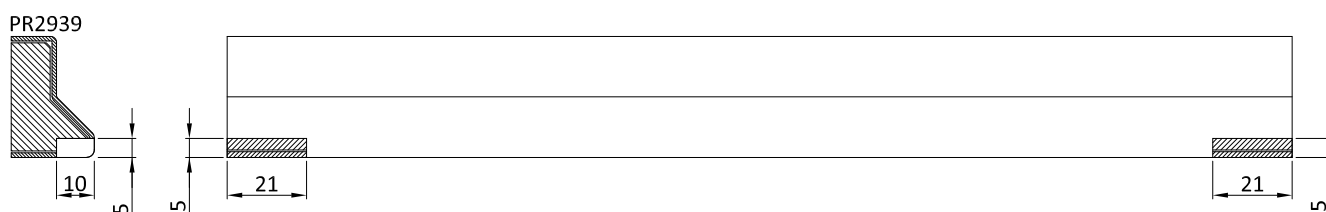
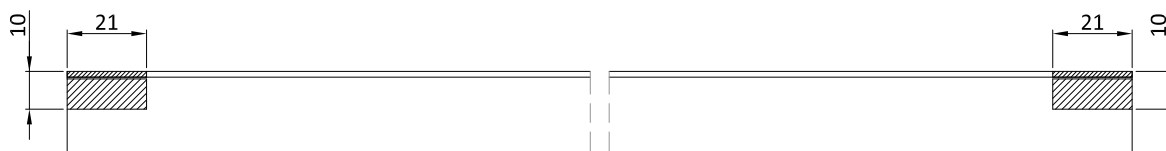
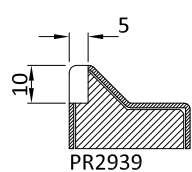
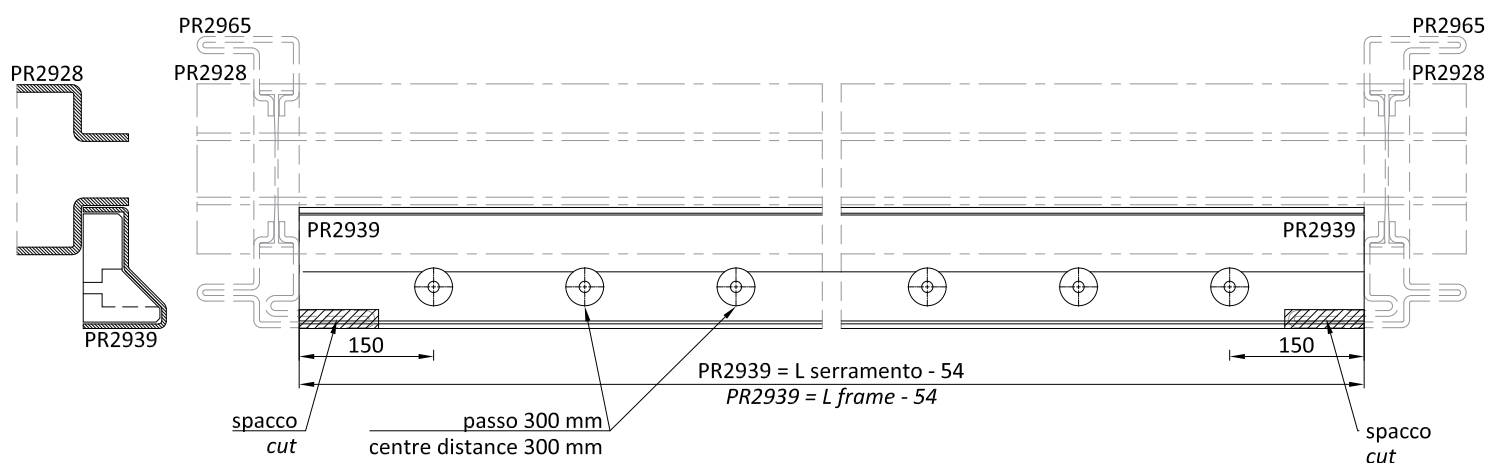
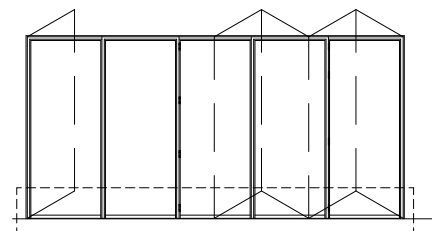
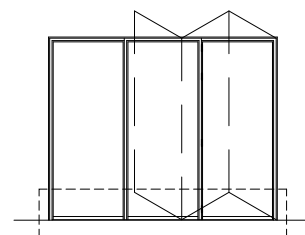
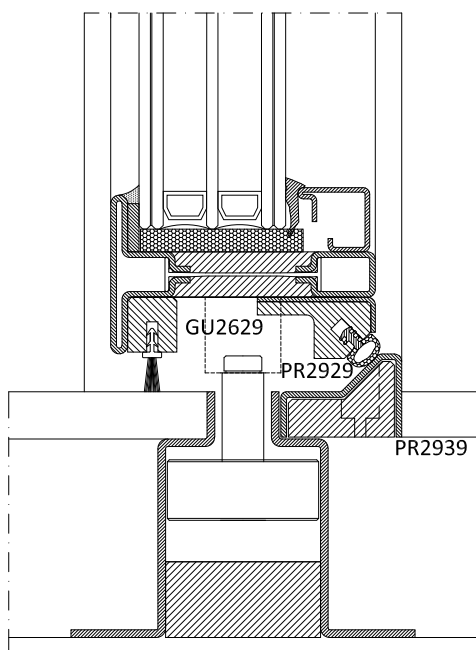
lavorazione superiore; inferiore specchiata orizzontalmente
upper working; bottom working horizontally mirrored

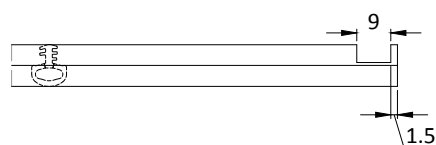
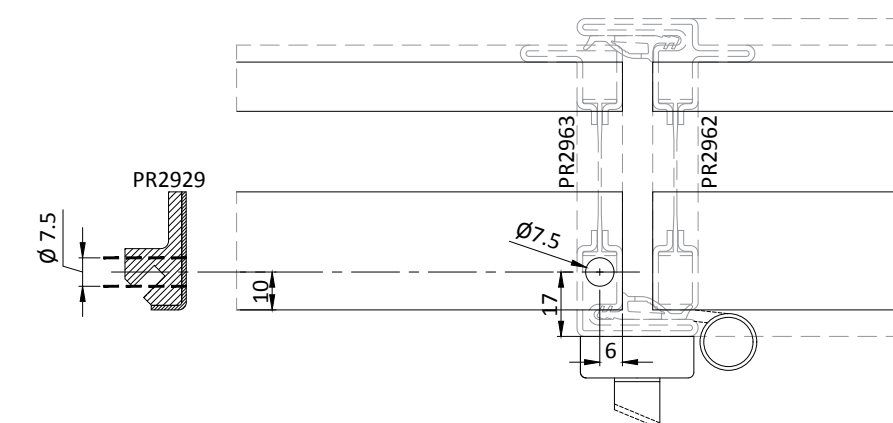
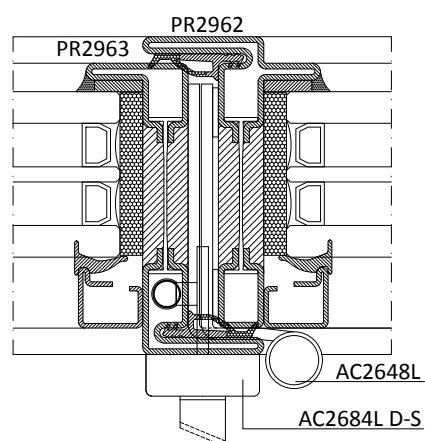
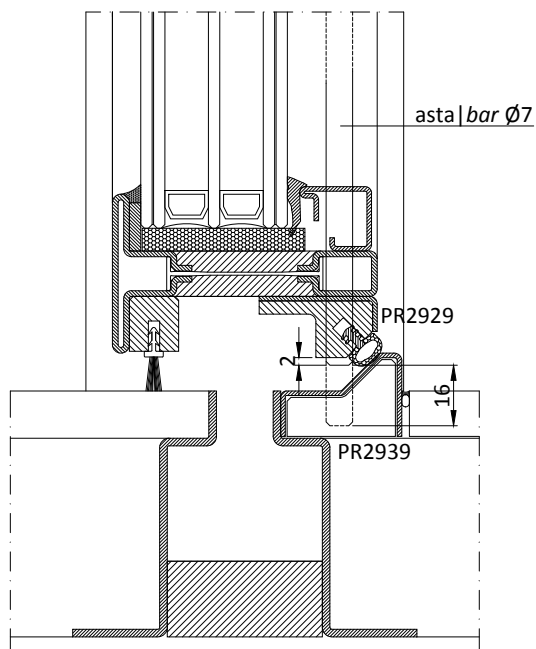
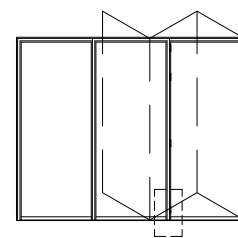


Applicazione tipo, valida per aperture interne e aperture esterne
Example application, for internal and external openings

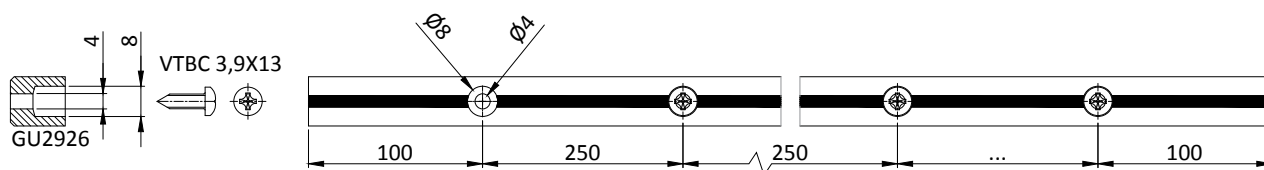
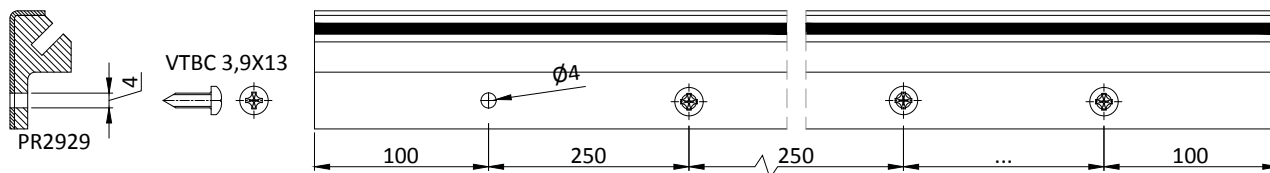
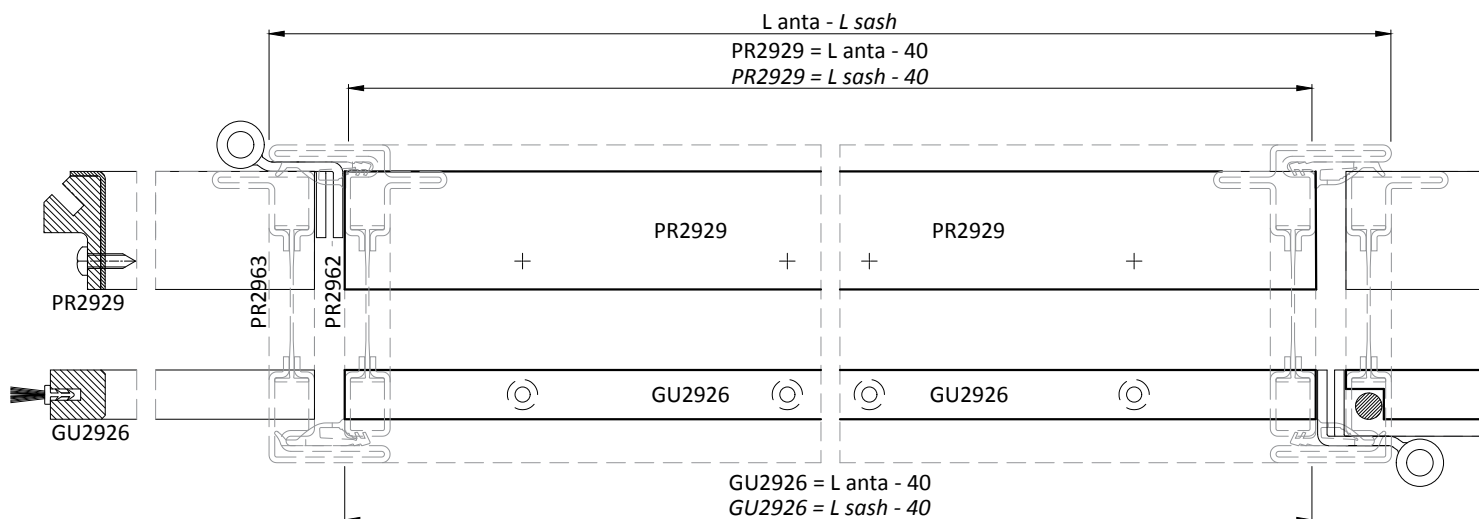
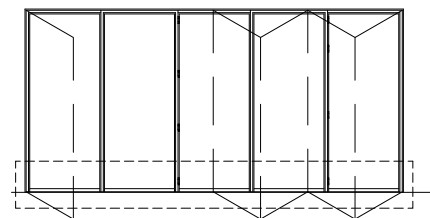
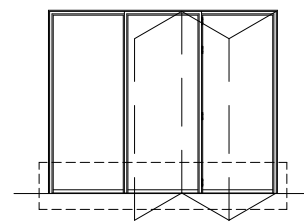
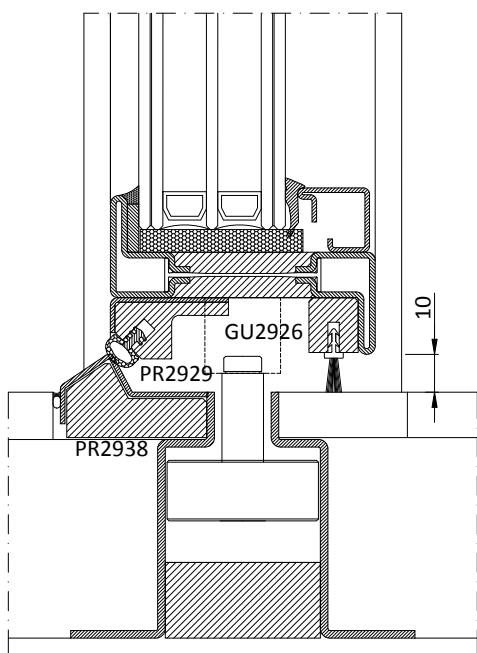




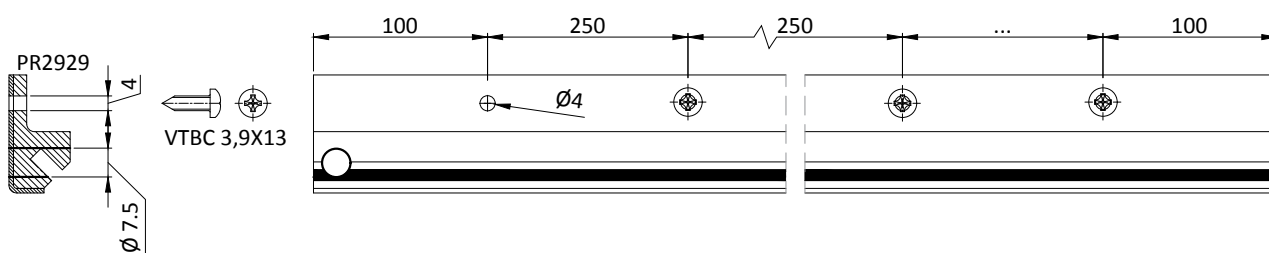
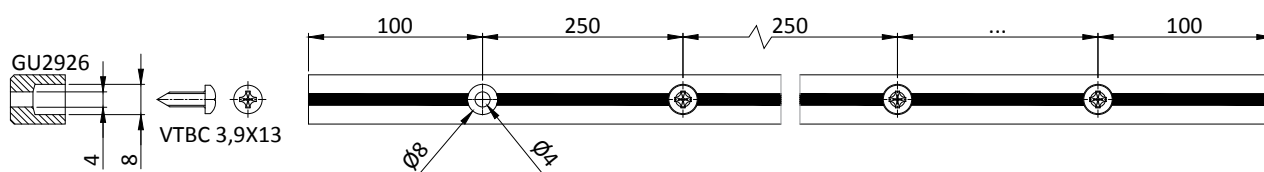
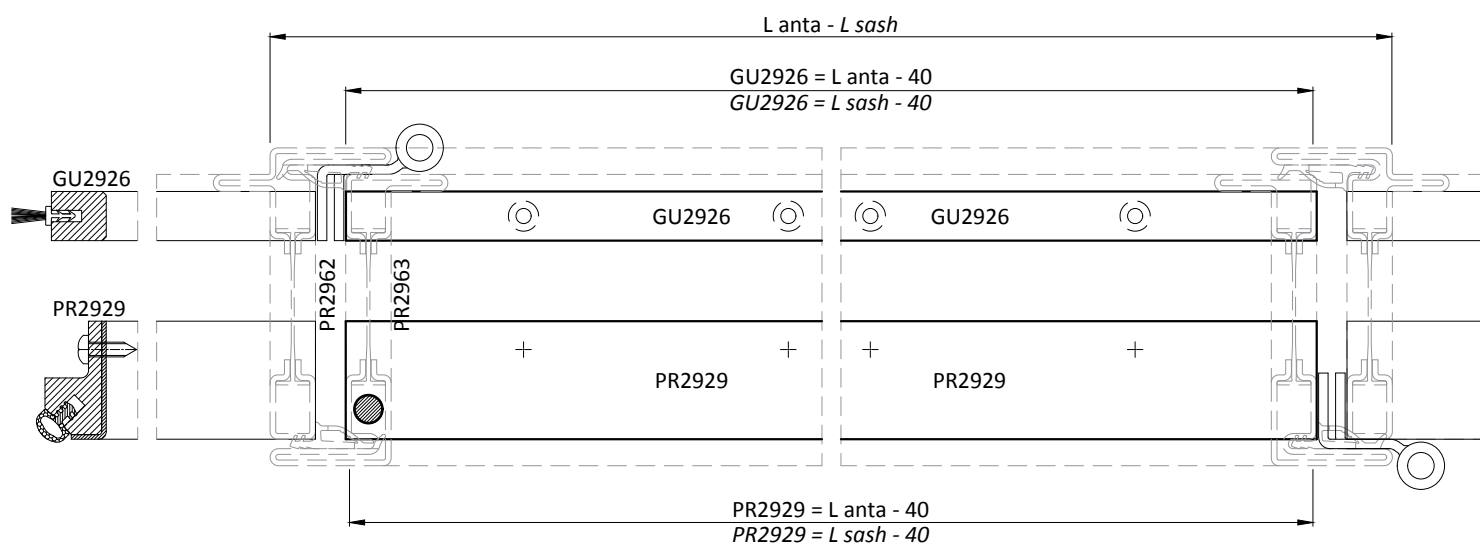
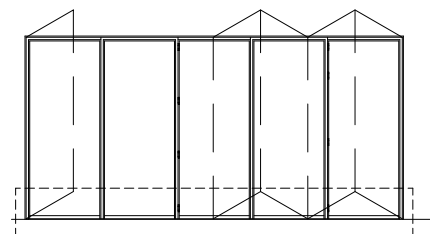
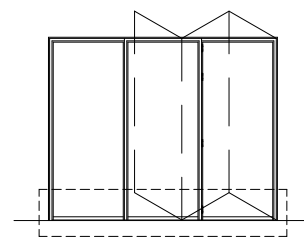
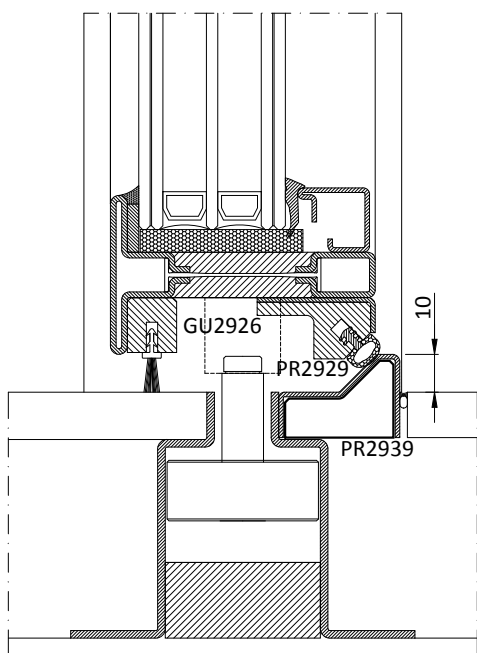




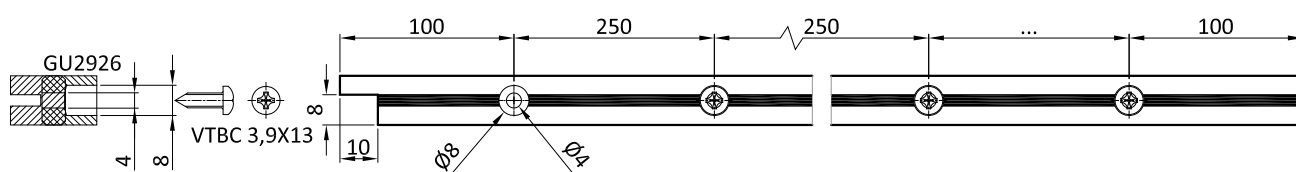
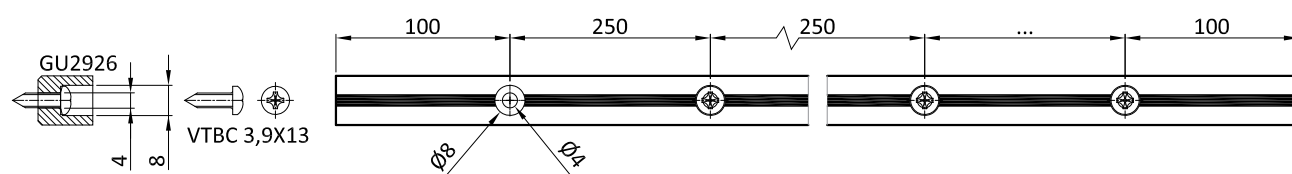
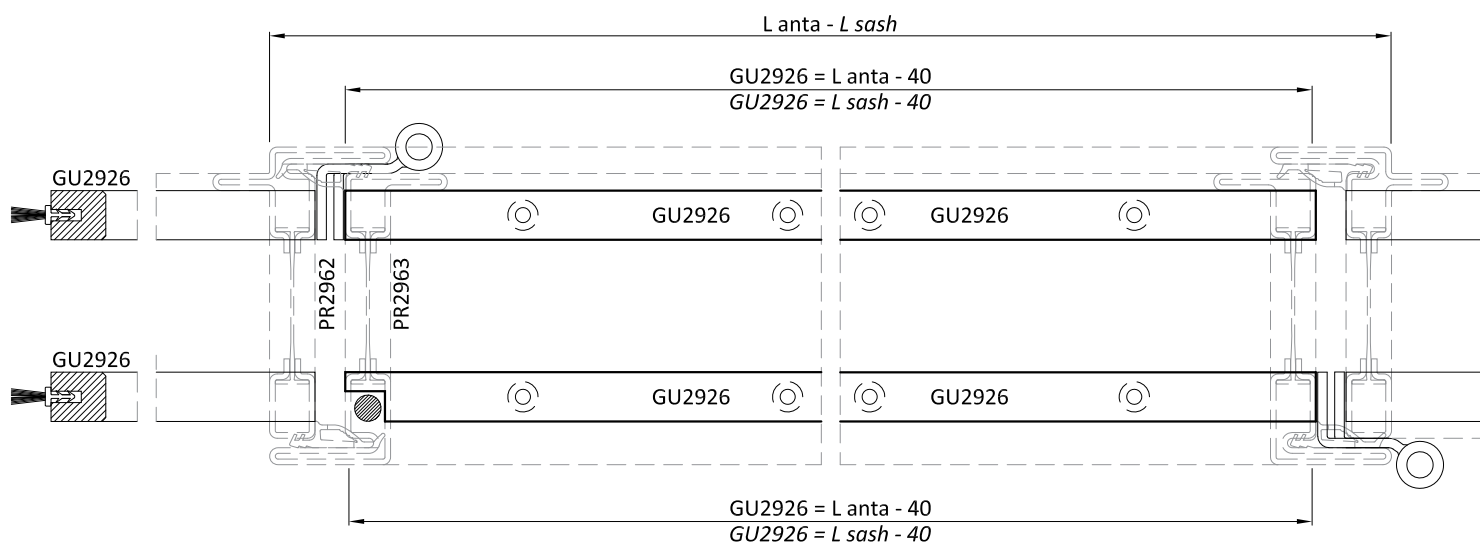
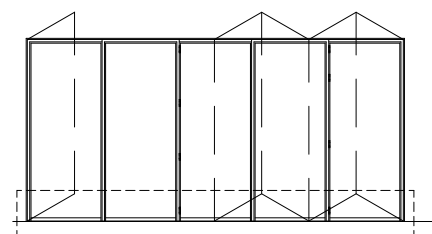
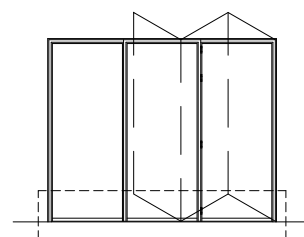
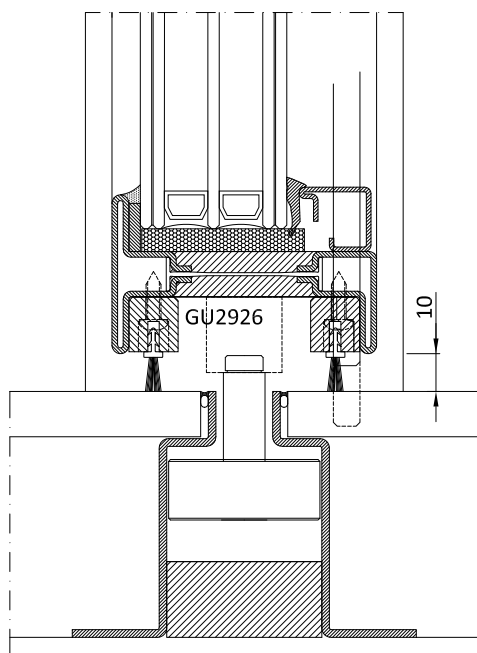
in prossimità del taglio incollare la guarnizione
near the cut, glue the gasket



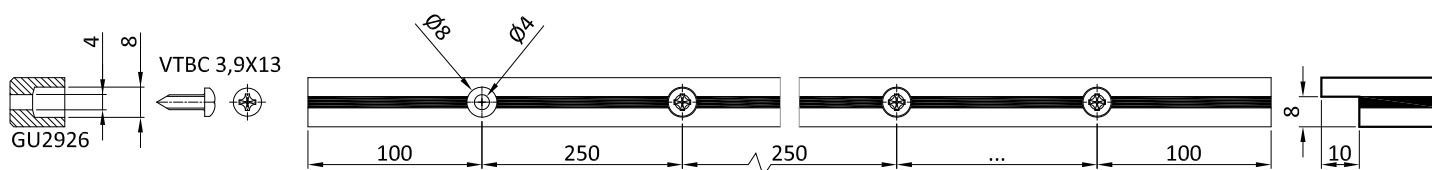
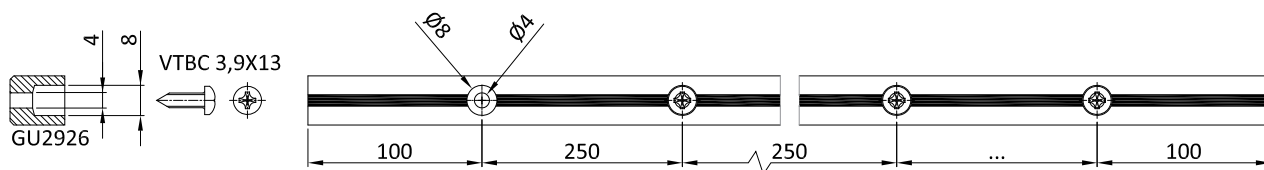
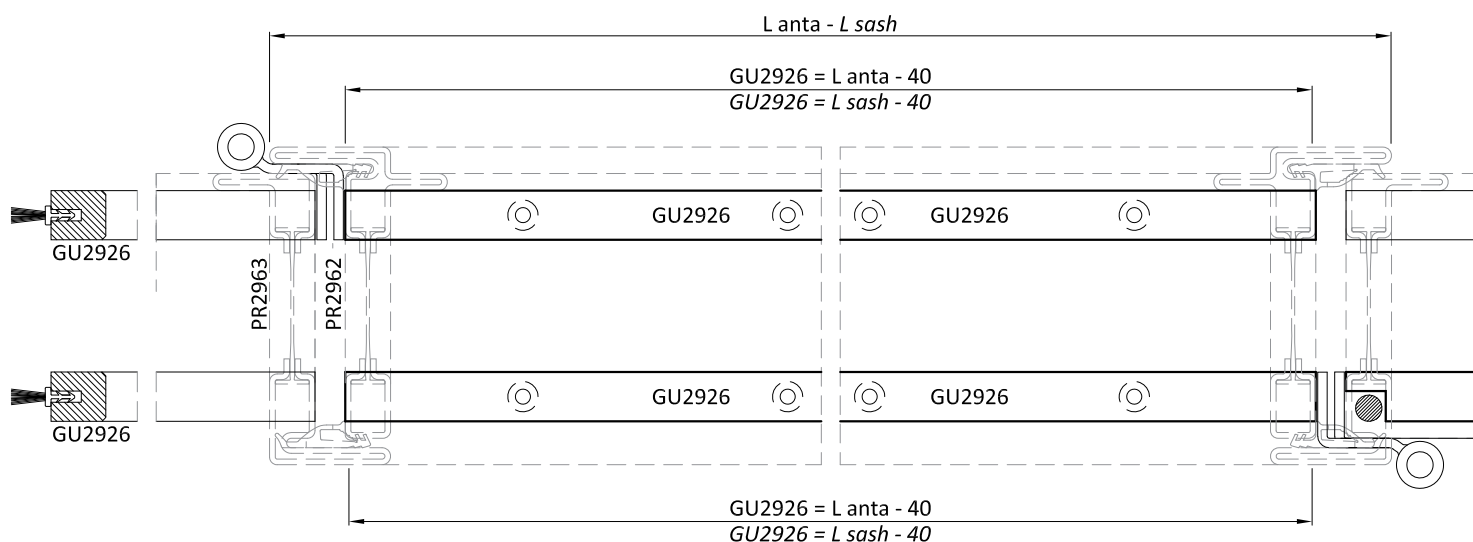
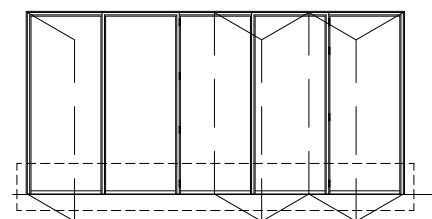
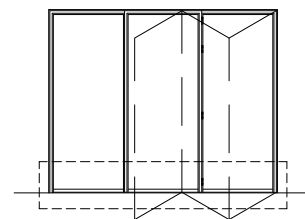
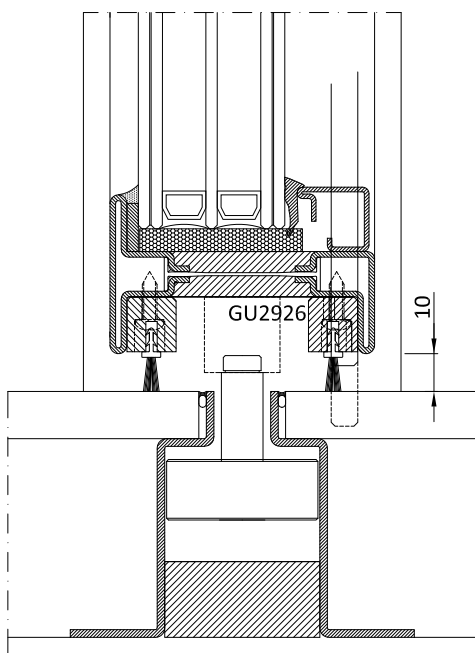
viti non comprese - screws not supplied



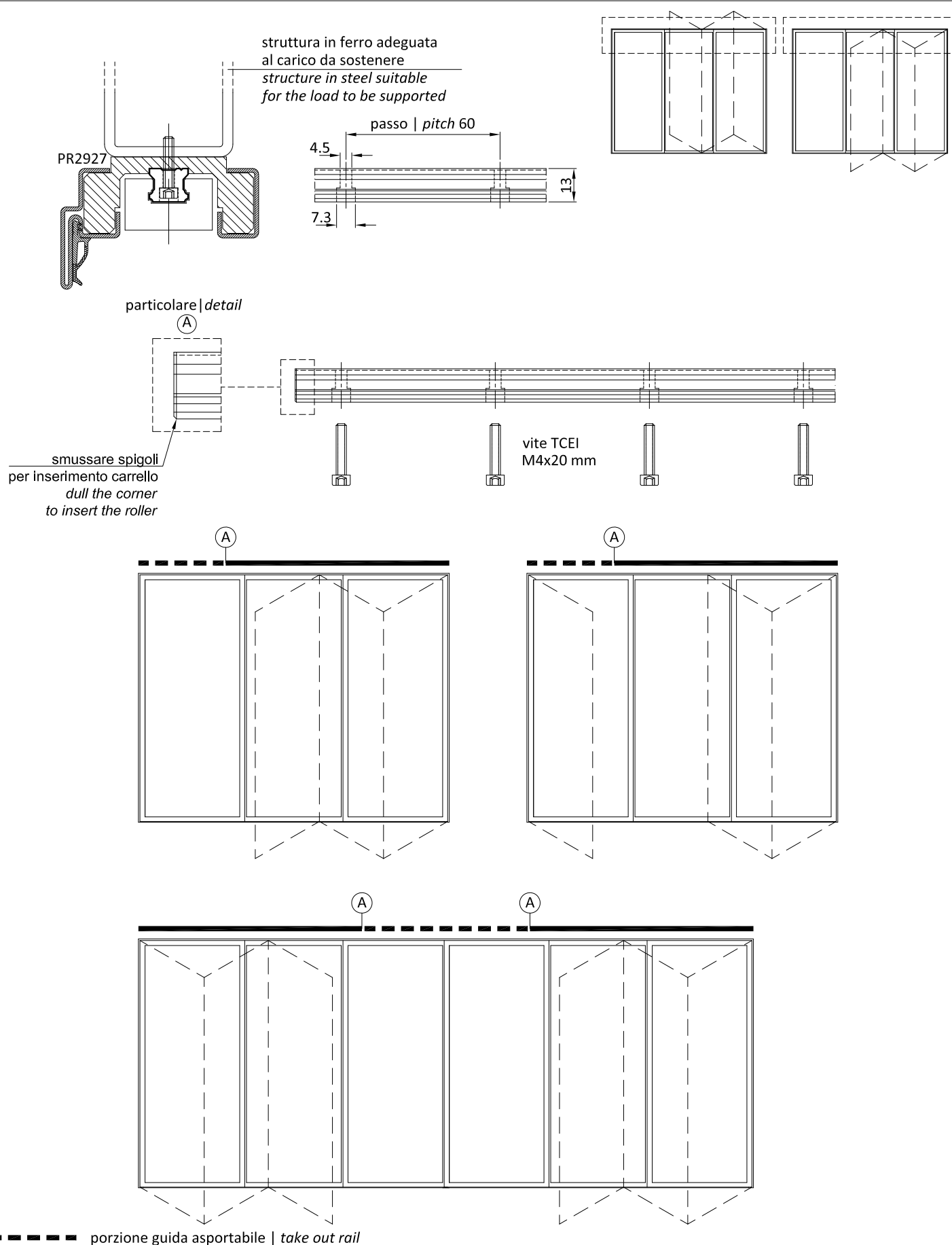
viti non comprese - screws not supplied



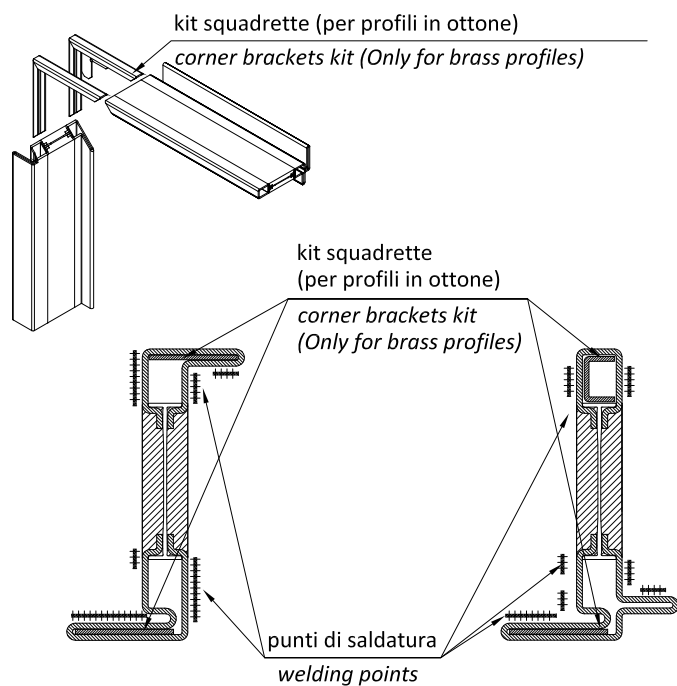
viti non comprese - screws not supplied



viti non comprese - screws not supplied



TCEI M4x20 mm
viti non comprese - screws not supplied

**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

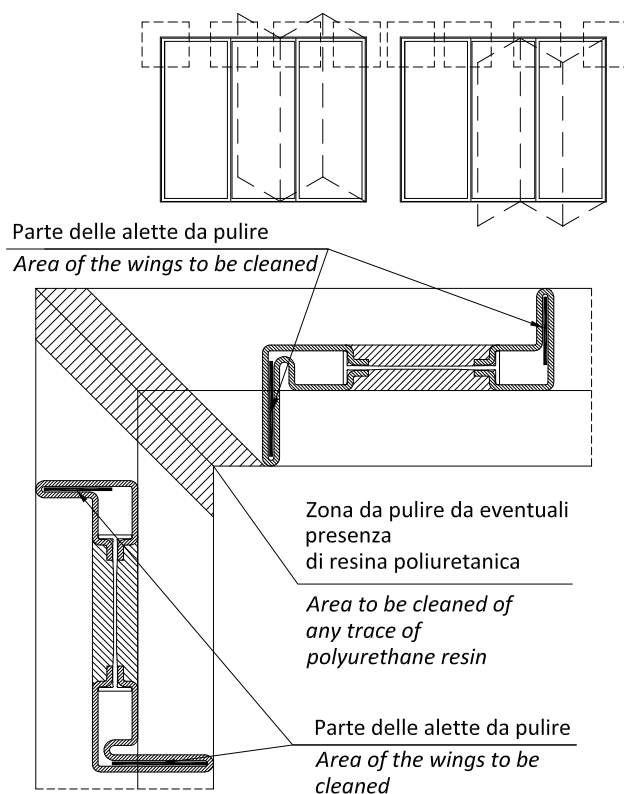
Use corner brackets, seal all surfaces in touch with profiles that are not to be seam-welded. Spot weld (TIG) the marked areas.

Acciaio zincato - Acciaio Corten - Acciaio inox

Saldare in continuo le superfici di contatto.

Galvanised steel - Cor-ten steel - Stainless steel

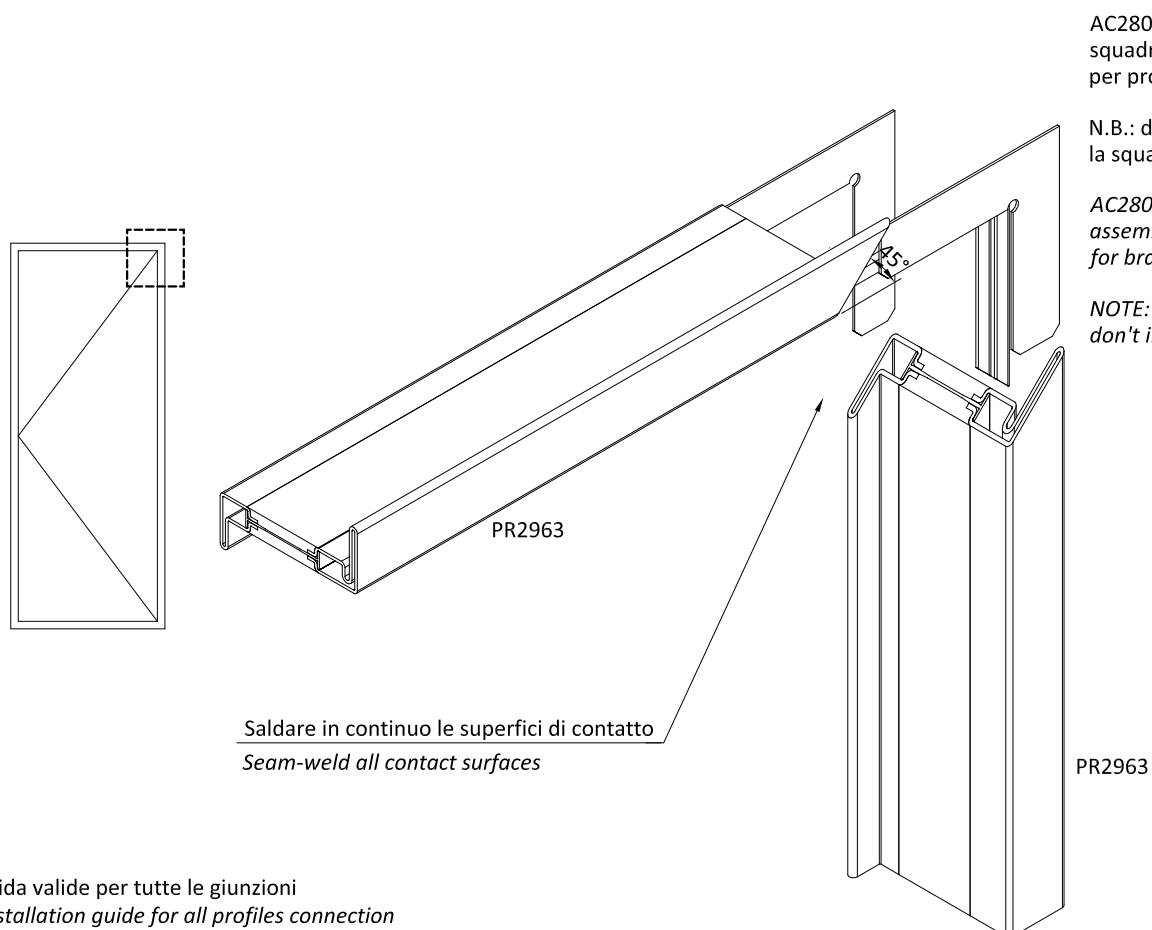
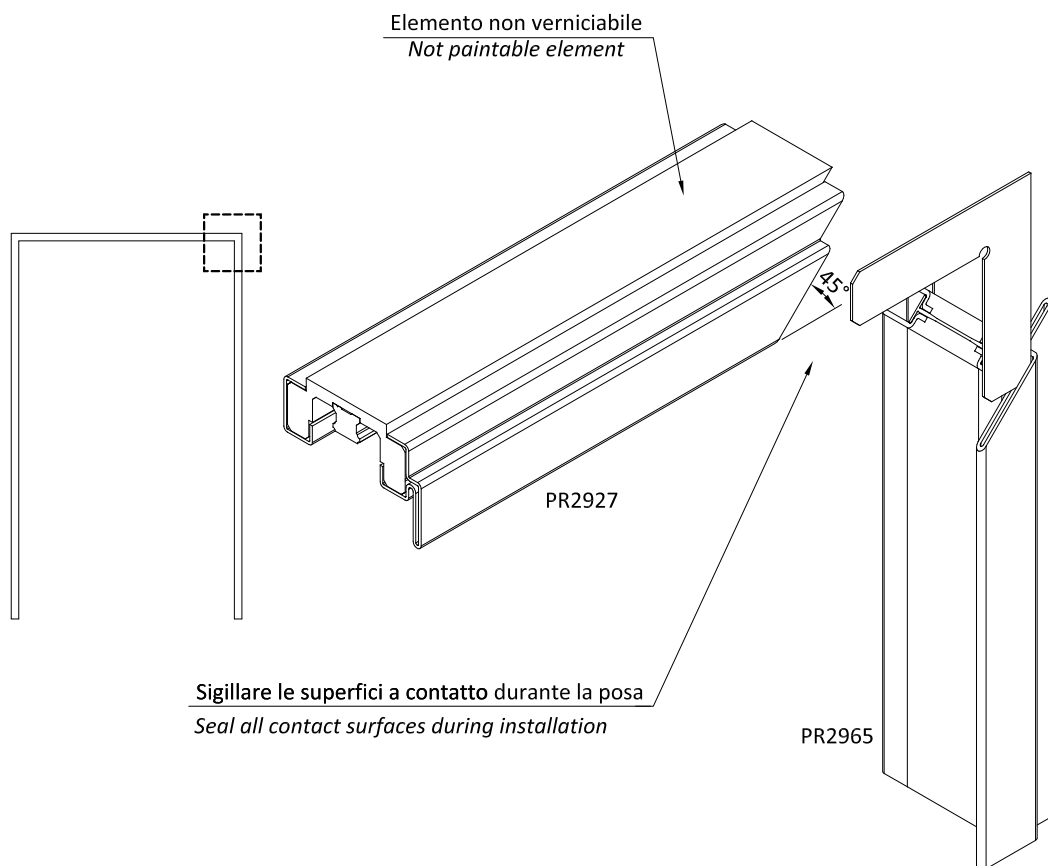
Seam-weld all contact surfaces.



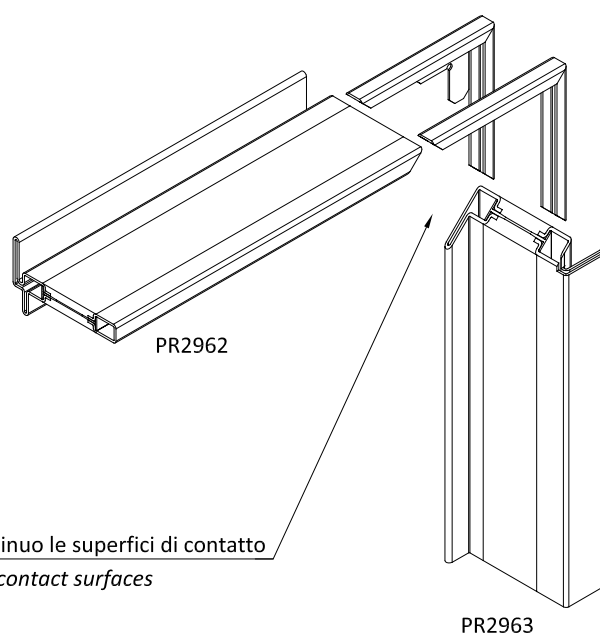
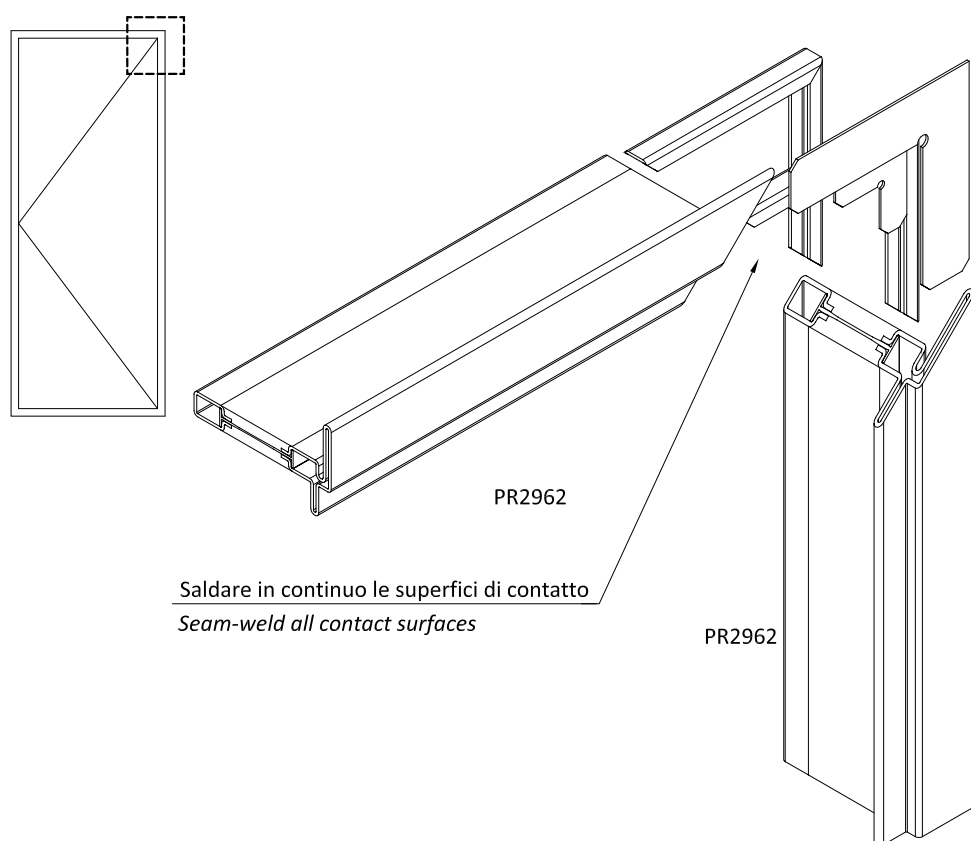
N.B. Prima di saldare l'angolo del profilo eliminare l'eventuale resina poliuretanica presente all'interno dell'aletta scaldando leggermente il profilo stesso per circa 20 mm. in modo da sciogliere la resina ed eliminare le impurità presenti.

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

Profilo Profile	Kit squadrette Corner brackets set
Codice Code	Codice Code
PR2963-PR2963	AC 2803I
PR2962-PR2963	AC 2832I
PR2962-PR2962	AC 2862I
PR2965-PR2927	AC 2865I



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

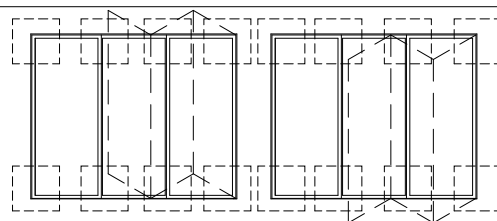


AC2832I
squadretta di assiemaggio
per profili in ottone

N.B.: dove c'è l'asta non inserire
la squadretta

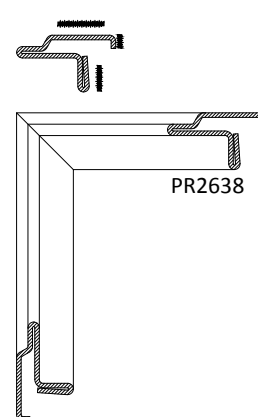
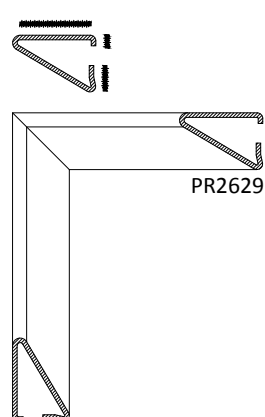
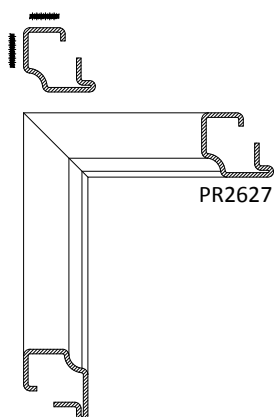
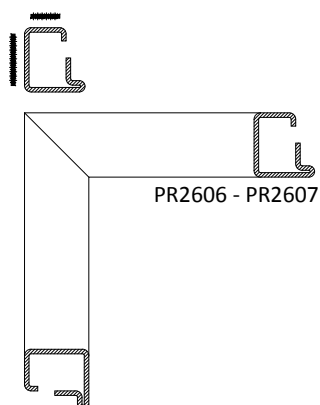
AC2832I
assembling corner brackets
for brass profiles

NOTE: Where there is the rod,
don't insert corner brackets



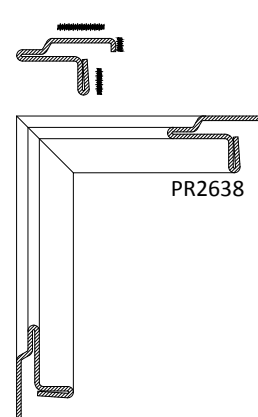
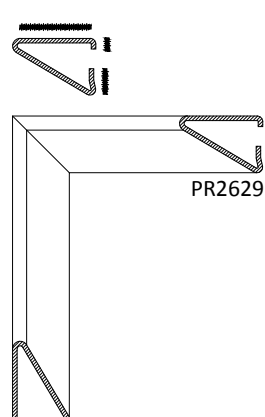
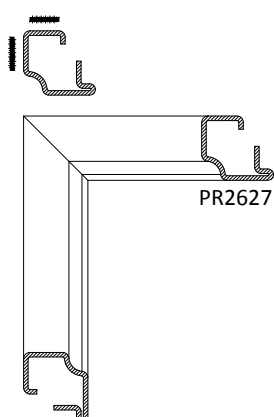
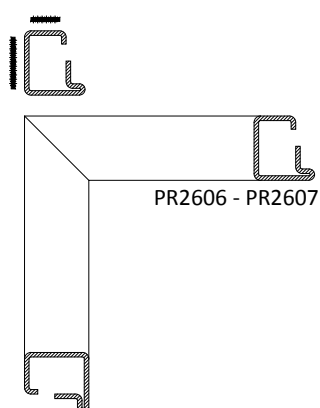
Acciaio zincato - Acciaio Corten - Acciaio inox
Saldare in continuo le superfici di contatto indicate

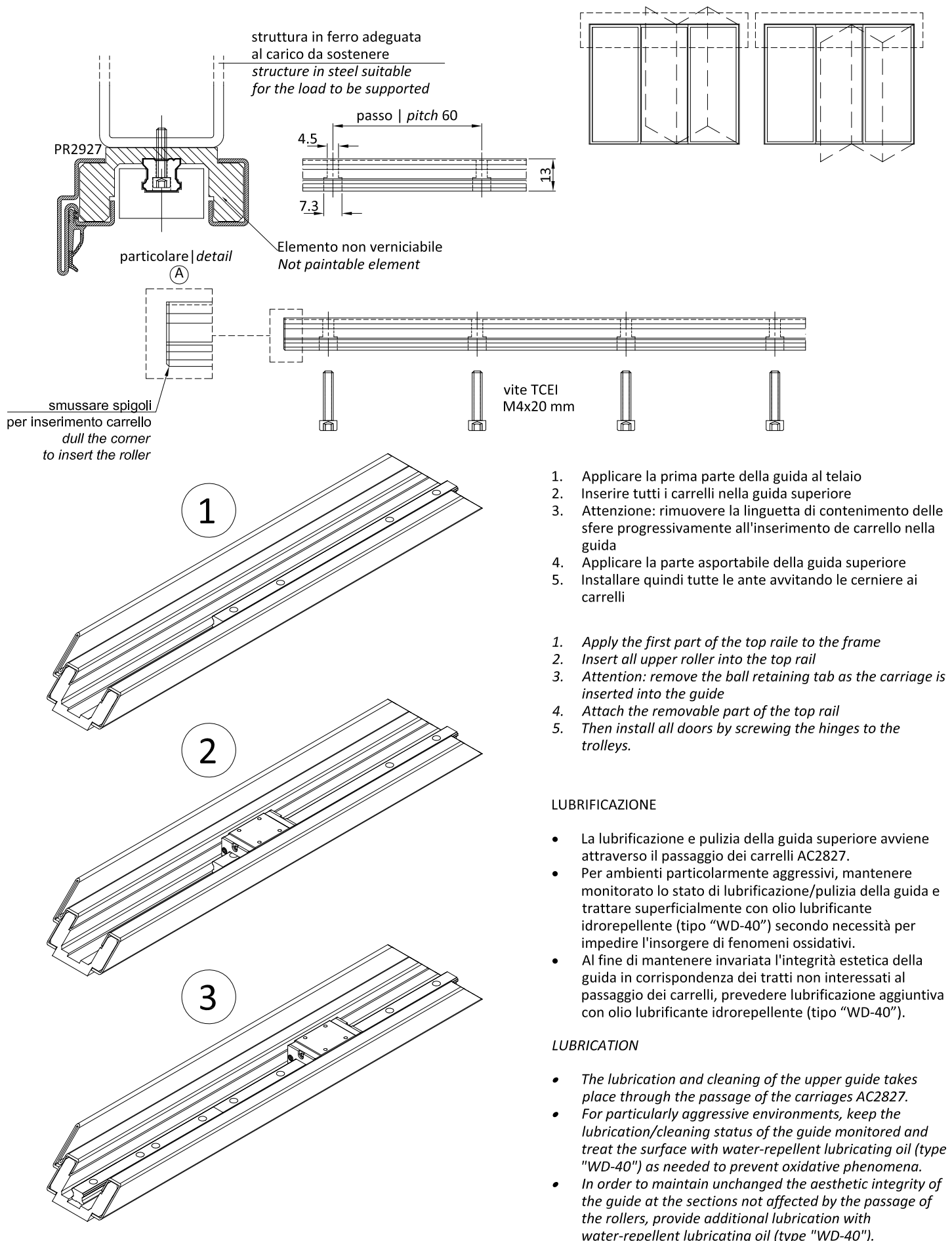
Galvanised steel - Cor-ten steel - Stainless steel
Seam-weld the shown areas



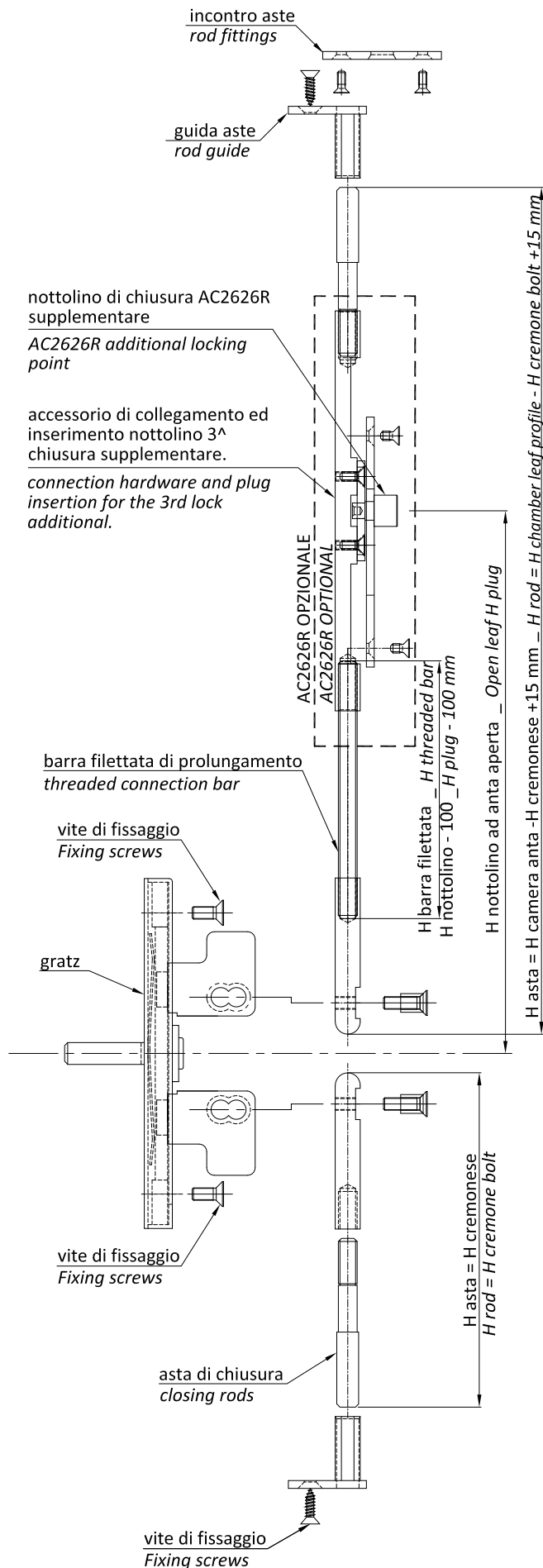
Ottone
Saldare a TIG a punti le zone indicate.

Brass
Spot weld (TIG) the marked areas.



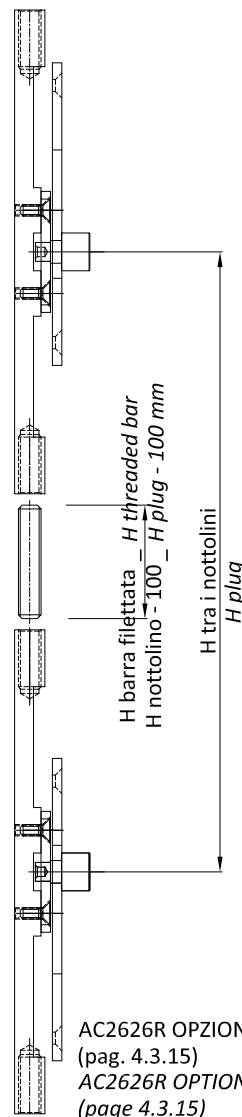


viti non comprese - screws not supplied

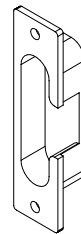


- 1) Avvitare le aste di chiusura agli accessori di collegamento.
- 2) Inserire le aste negli spacchi predisposti agli angoli dell'anta.
- 3) Inserire e fissare il GRATZ all'anta.
- 4) Fissare le aste di chiusura al GRATZ con viti M4 in dotazione.
- 5) Inserire gli accessori guida aste negli spacchi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

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

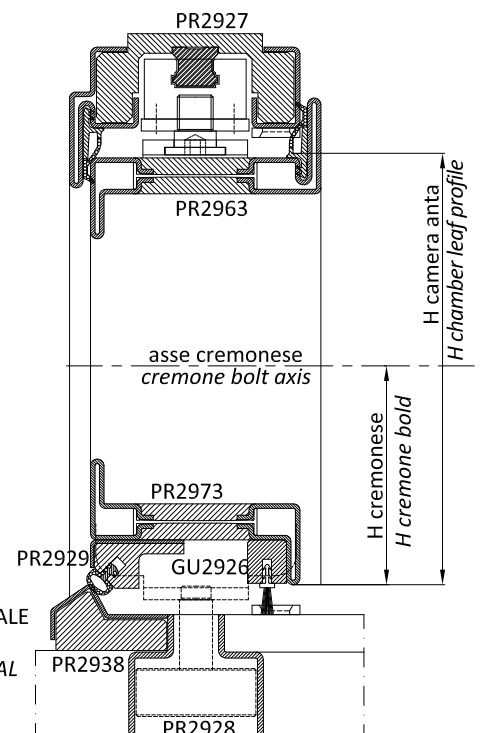


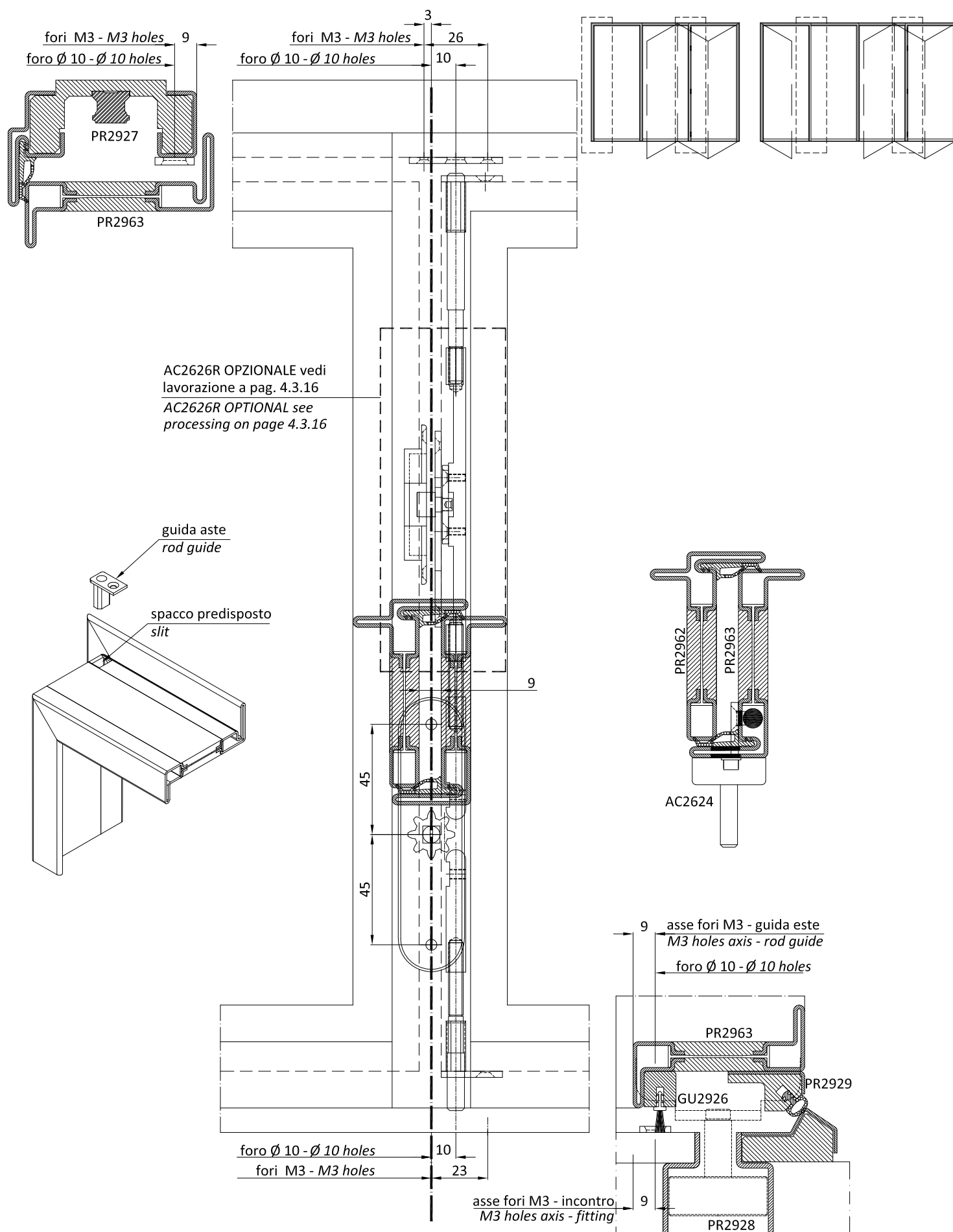
AC2626R OPZIONALE
(pag. 4.3.15)
AC2626R OPTIONAL
(page 4.3.15)

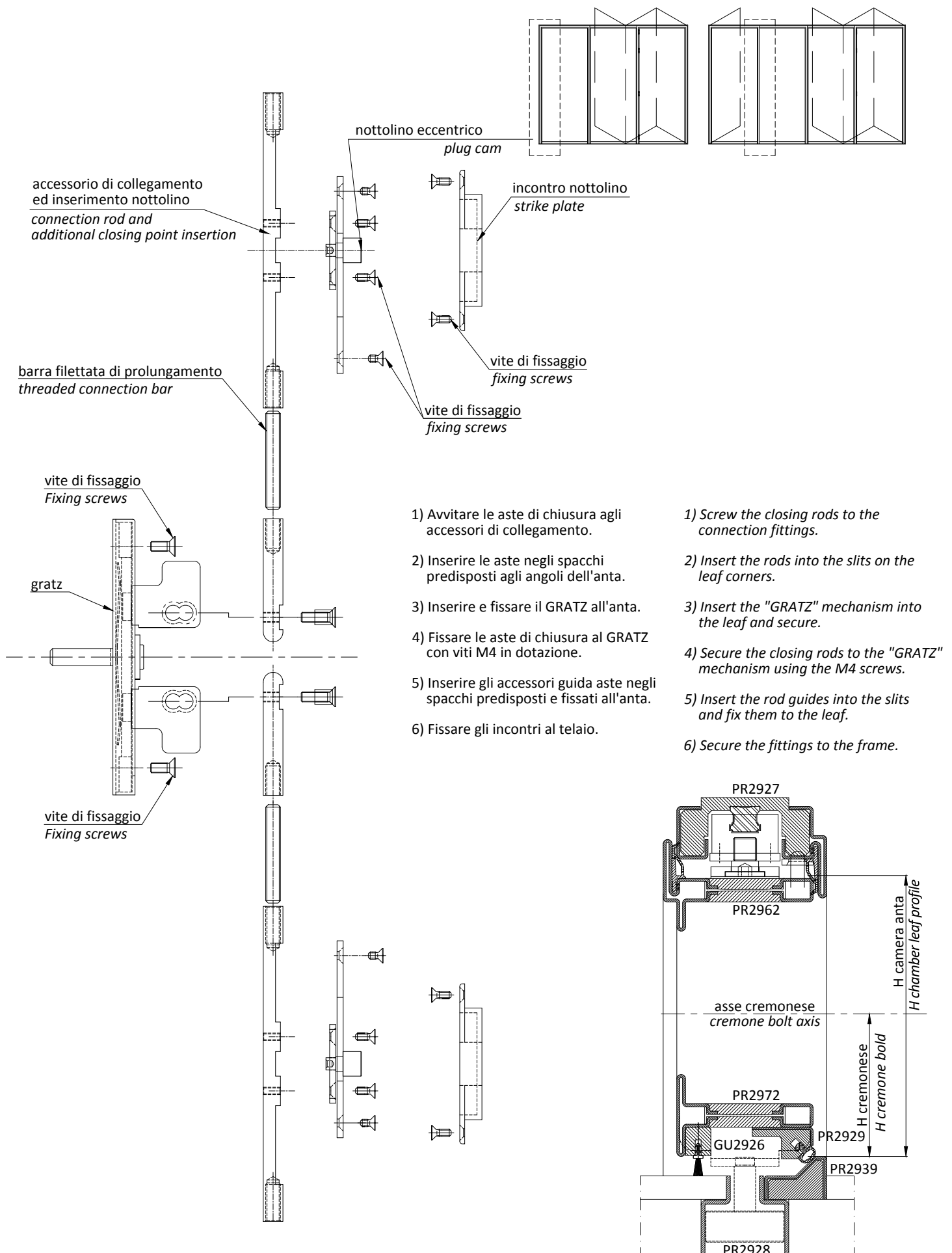


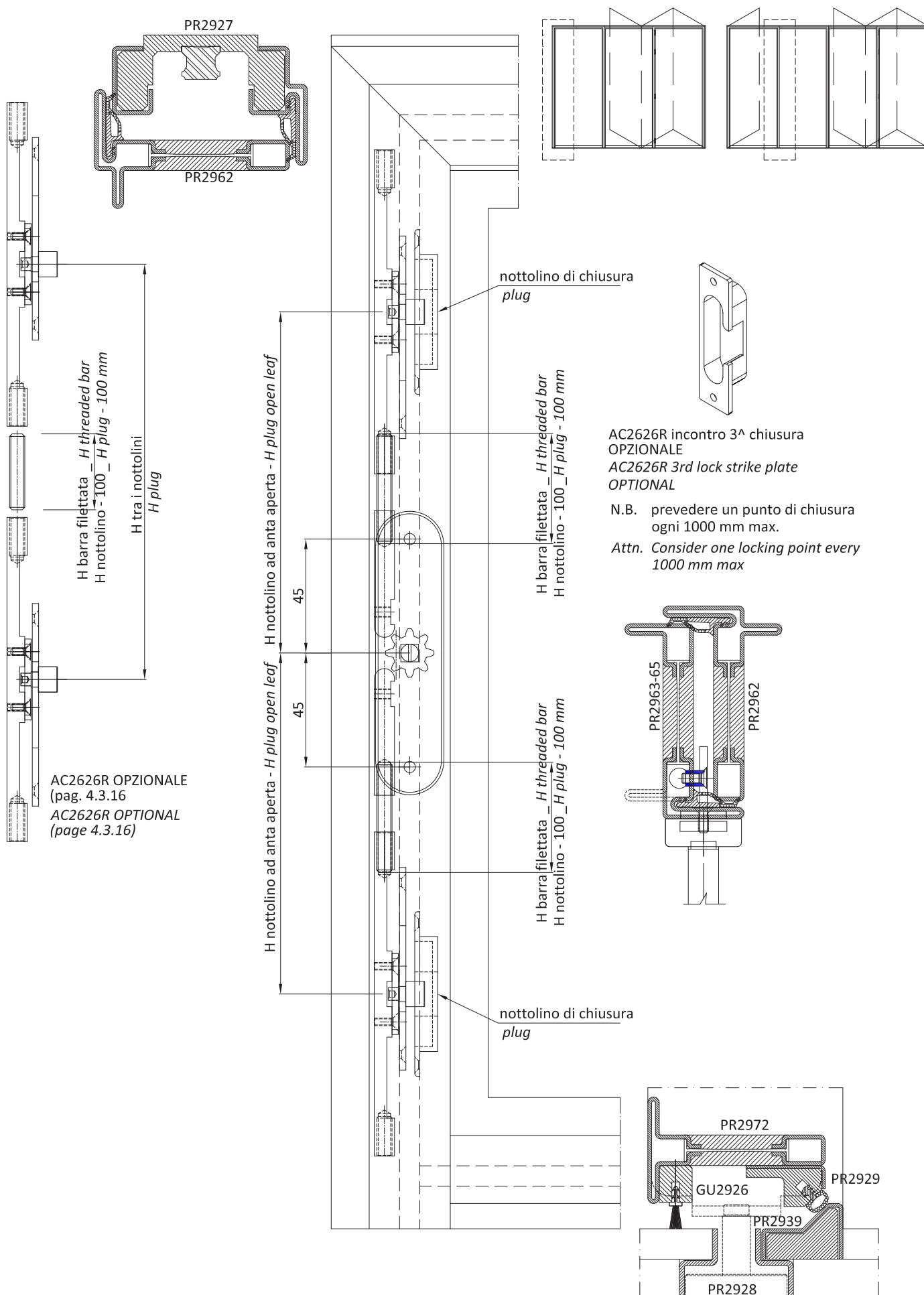
AC2626R incontro 3ª chiusura
OPZIONALE
AC2626R 3rd lock strike plate
OPTIONAL

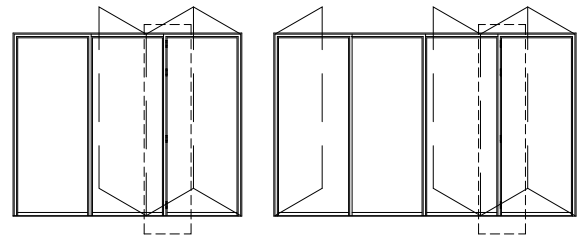
N.B. prevedere un punto di chiusura ogni 1000 mm max.
Attn. Consider one locking point every 1000 mm max.





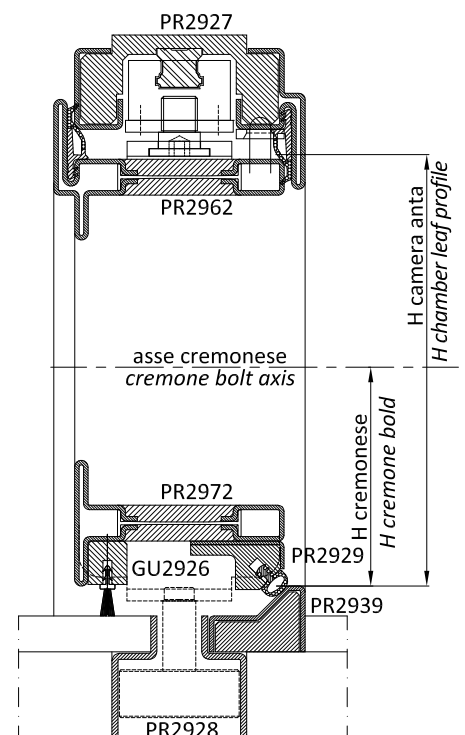
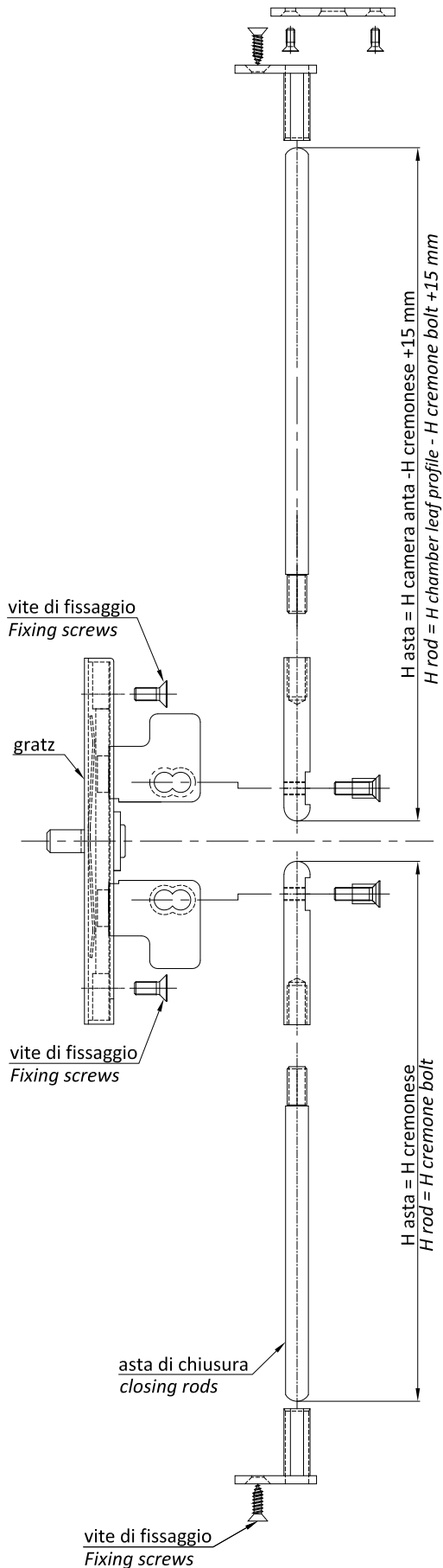


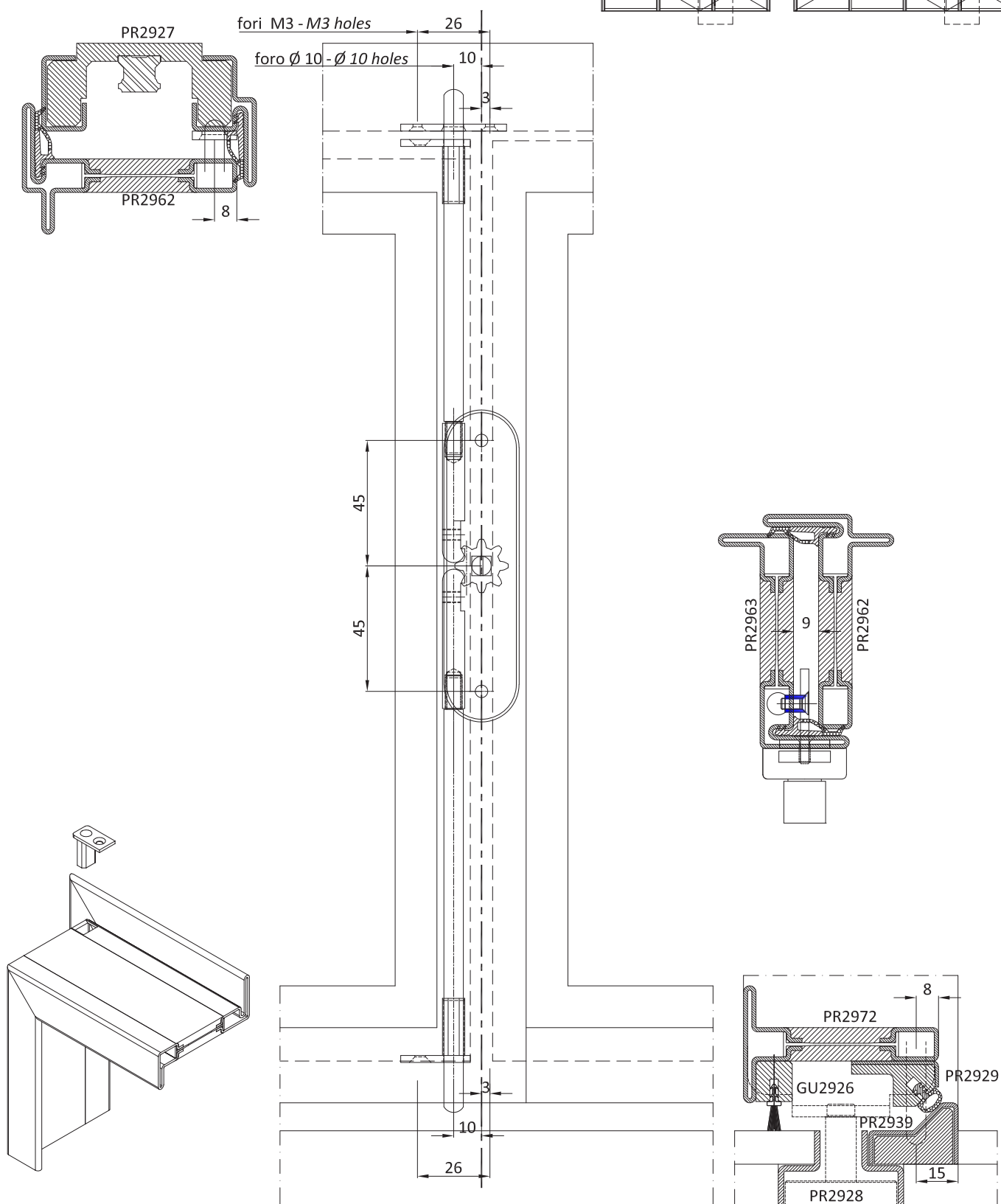
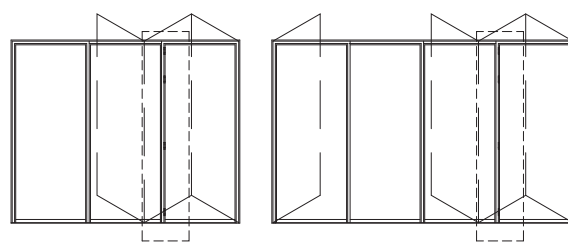


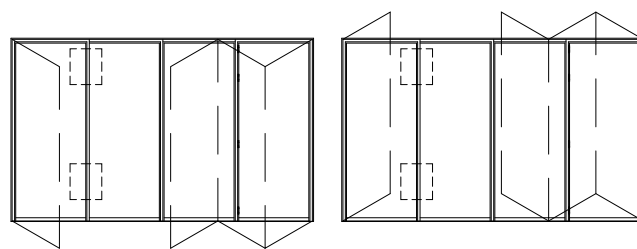
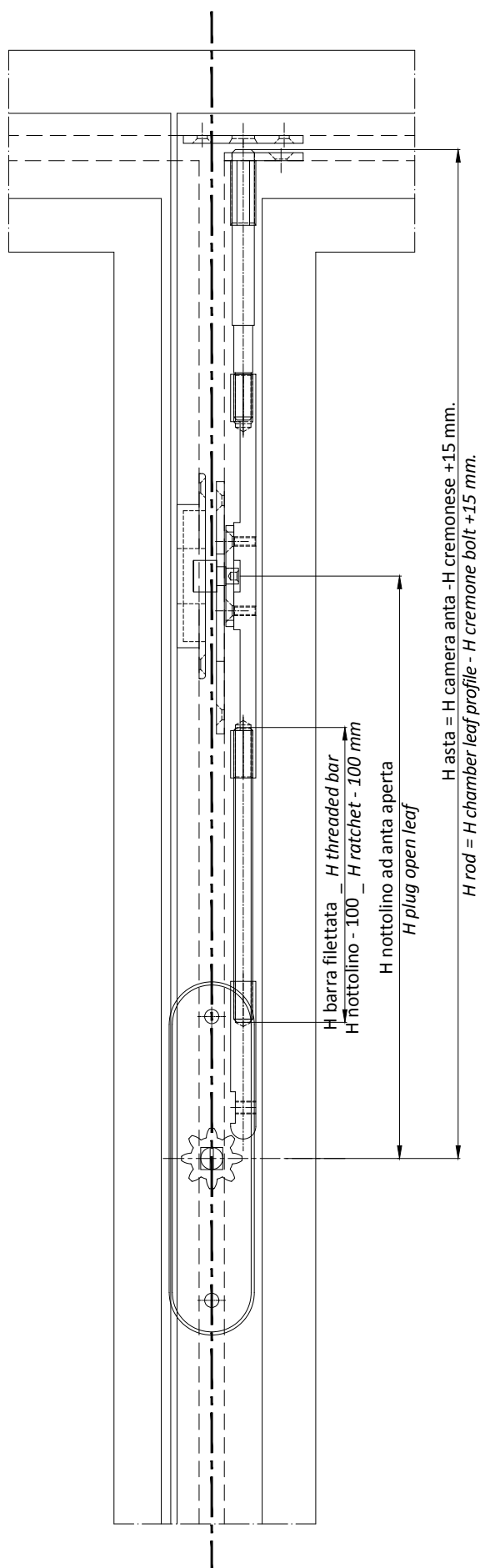


- 1) Avvitare le aste di chiusura agli accessori di collegamento
- 2) Inserire le aste negli spacchi predisposti agli angoli dell'anta
- 3) Inserire e fissare il GRATZ all'anta
- 4) Fissare le aste di chiusura al GRATZ con viti M4 in dotazione
- 5) Inserire gli accessori guida aste negli spacchi predisposti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

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

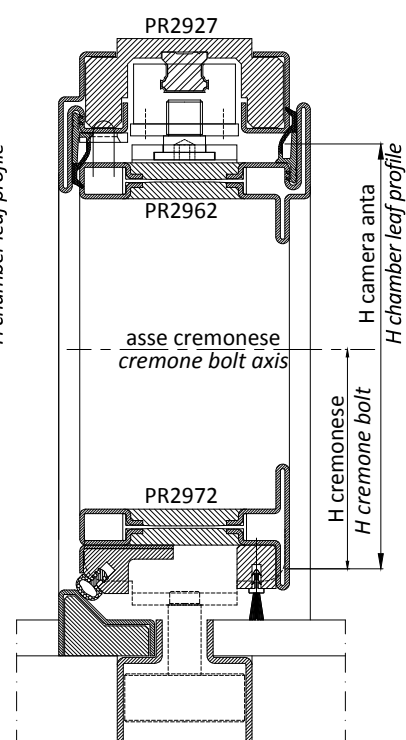
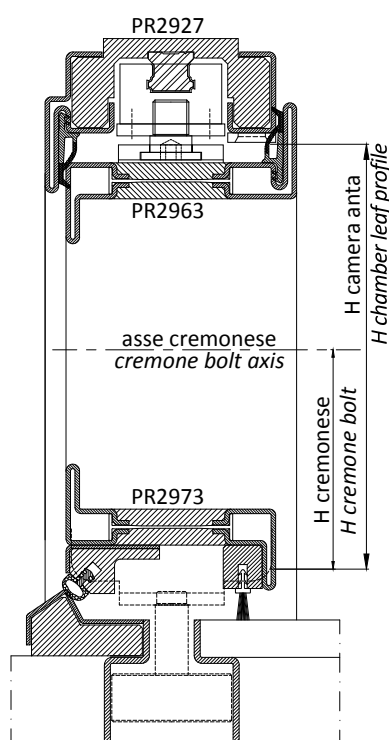
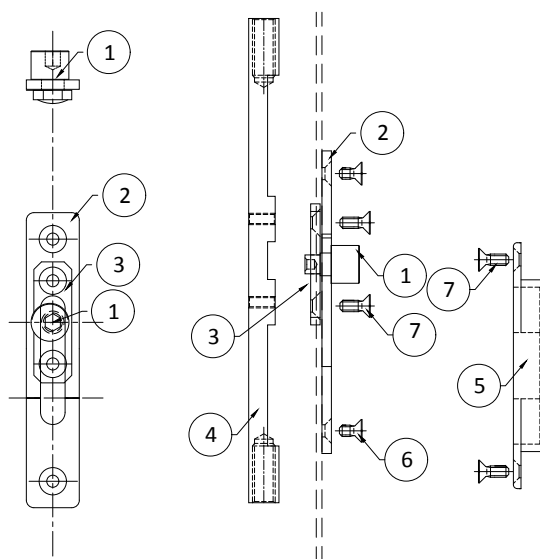


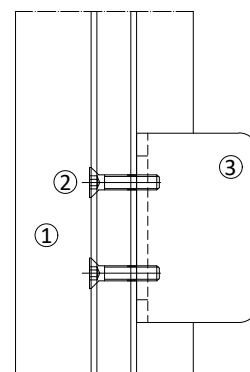
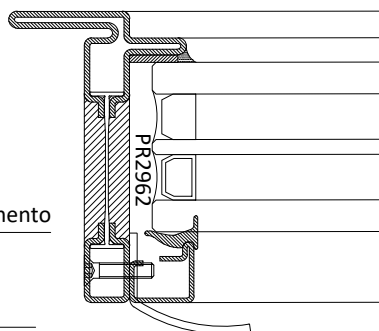
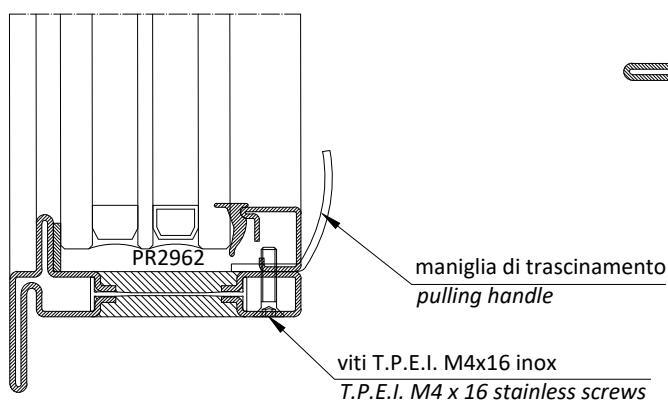
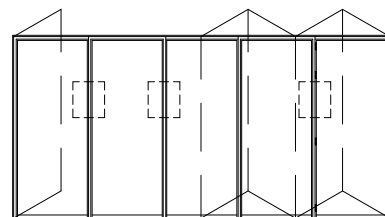
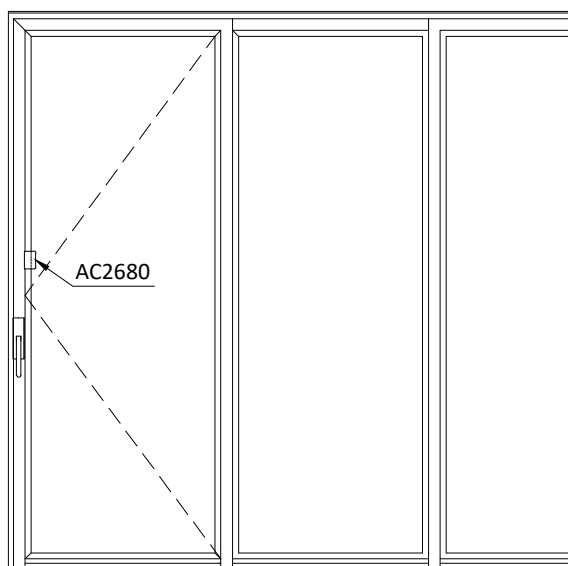




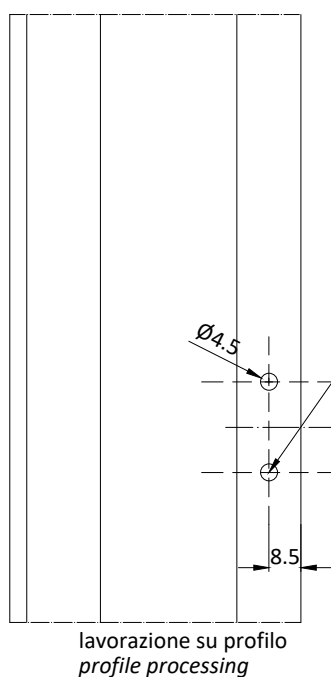
- 1) Rullino eccentrico
- 2) Piastra di fissaggio
- 3) Piastra di collegamento
- 4) Accessorio aggancio aste
- 5) Incontro 3^a chiusura
- 6) viti M3x6 mm
- 7) viti M3x8 mm

- 1) Barrel cam
- 2) Installation plate
- 3) Connecting plate
- 4) Rod docking accessory
- 5) 3rd lock strike plate
- 6) screws M3x6 mm
- 7) screws M3x8 mm

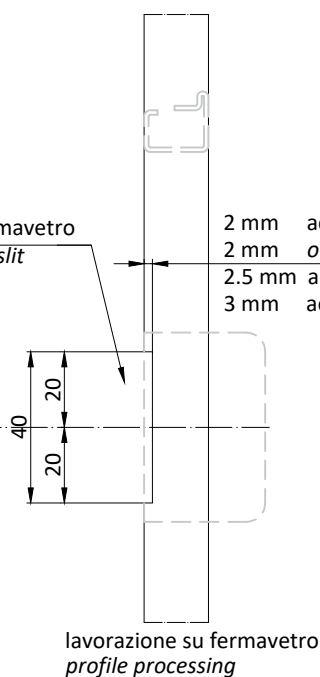




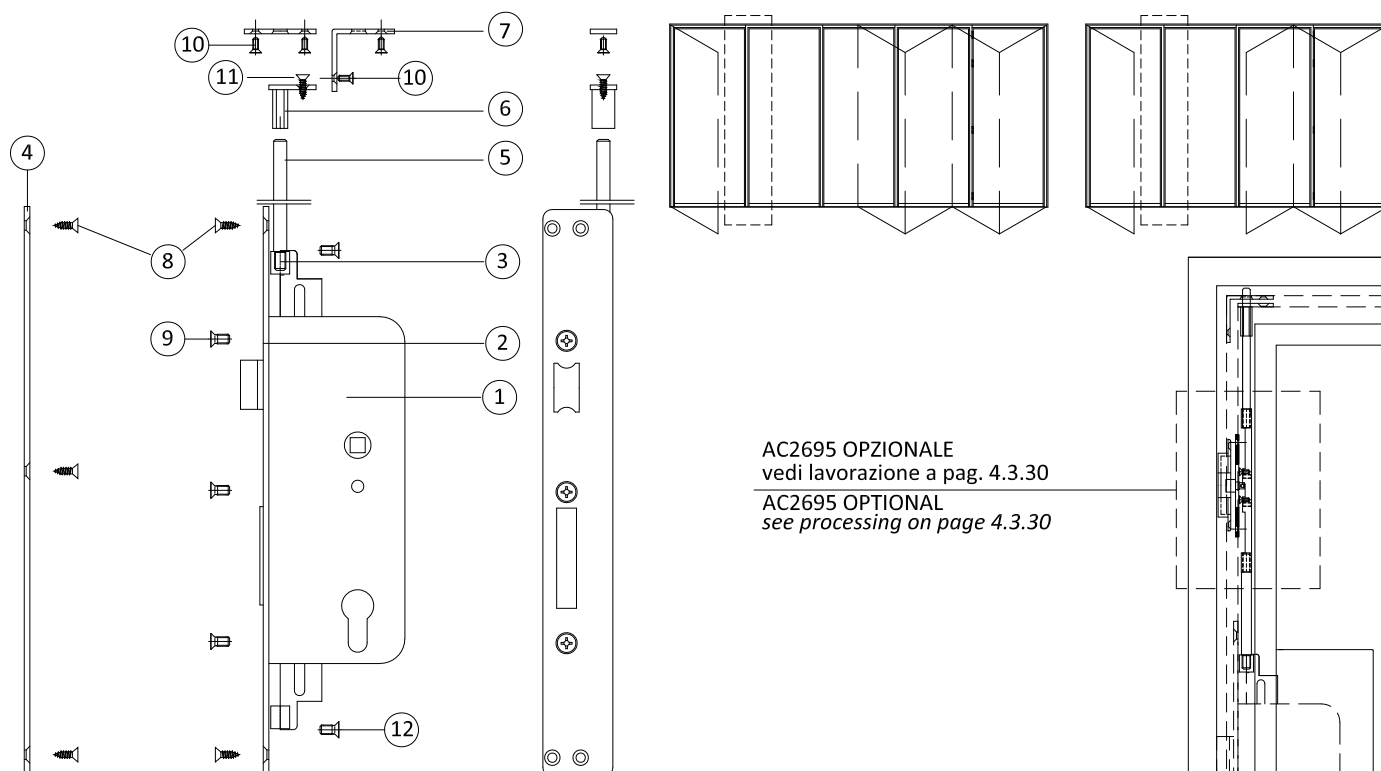
- 1 Maniglia di trascinamento | pulling handle
- 2 Viti TSPEI M4x16 | TSPEI M4 x 16 stainless screws
- 3 T Profilo anta | T leaf profile



spacco su fermavetro
glazing bead slit



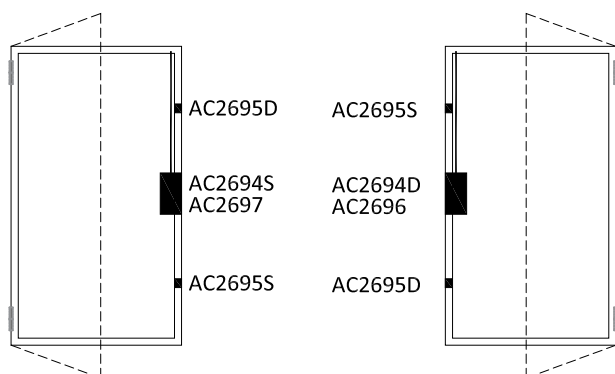
2 mm acciaio zincato | galvanized steel
2 mm ottone | brass
2.5 mm acciaio inox | stainless steel
3 mm acciaio corten | corten steel



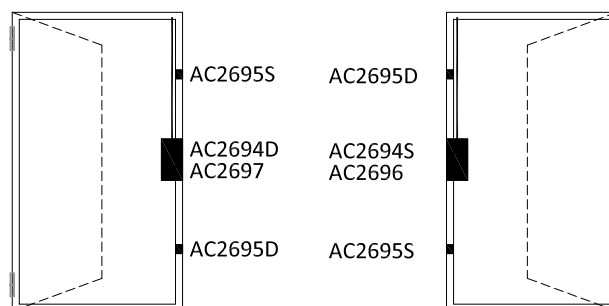
- 1) Serratura
- 2) Frontalino (Dx o Sx)
- 3) Riduttore di collegamento
- 4) Incontro per serratura
- 5) Aste inox
- 6) Guida aste superiore
- 7) Incontro aste per porte a due ante
- 7 bis) Incontro aste per porte ad un'anta
- 8) Viti autof. Inox A2 T.P.T.C. 3,9x13
- 9) Viti Inox T.P.T.C. m5x10
- 10) Viti Inox T.P.E.I. 3x8
- 11) Viti autof. Inox T.P.T.C. 3,5x13
- 12) Viti Inox T.S.P.E.I. M4x8

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

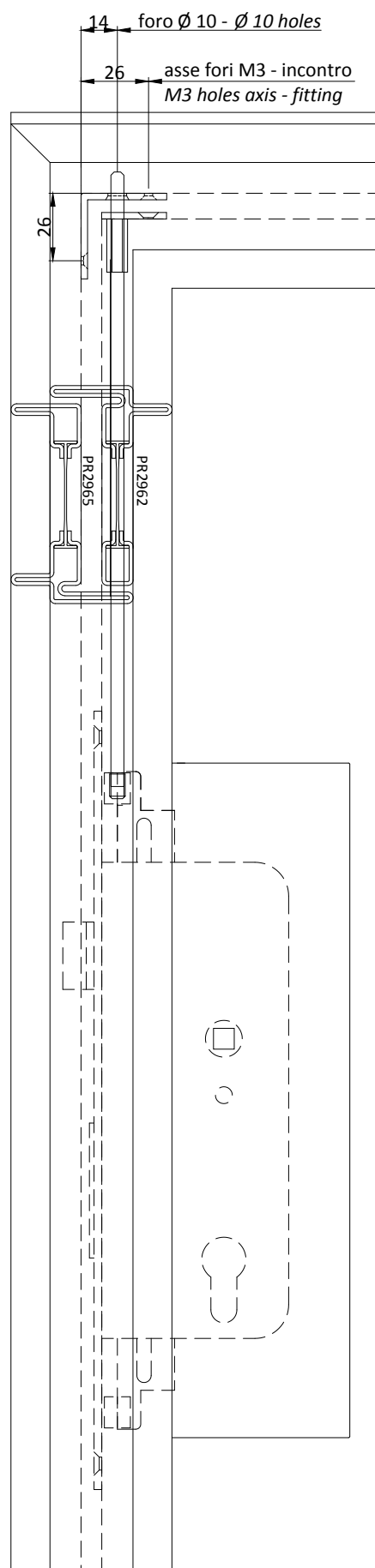
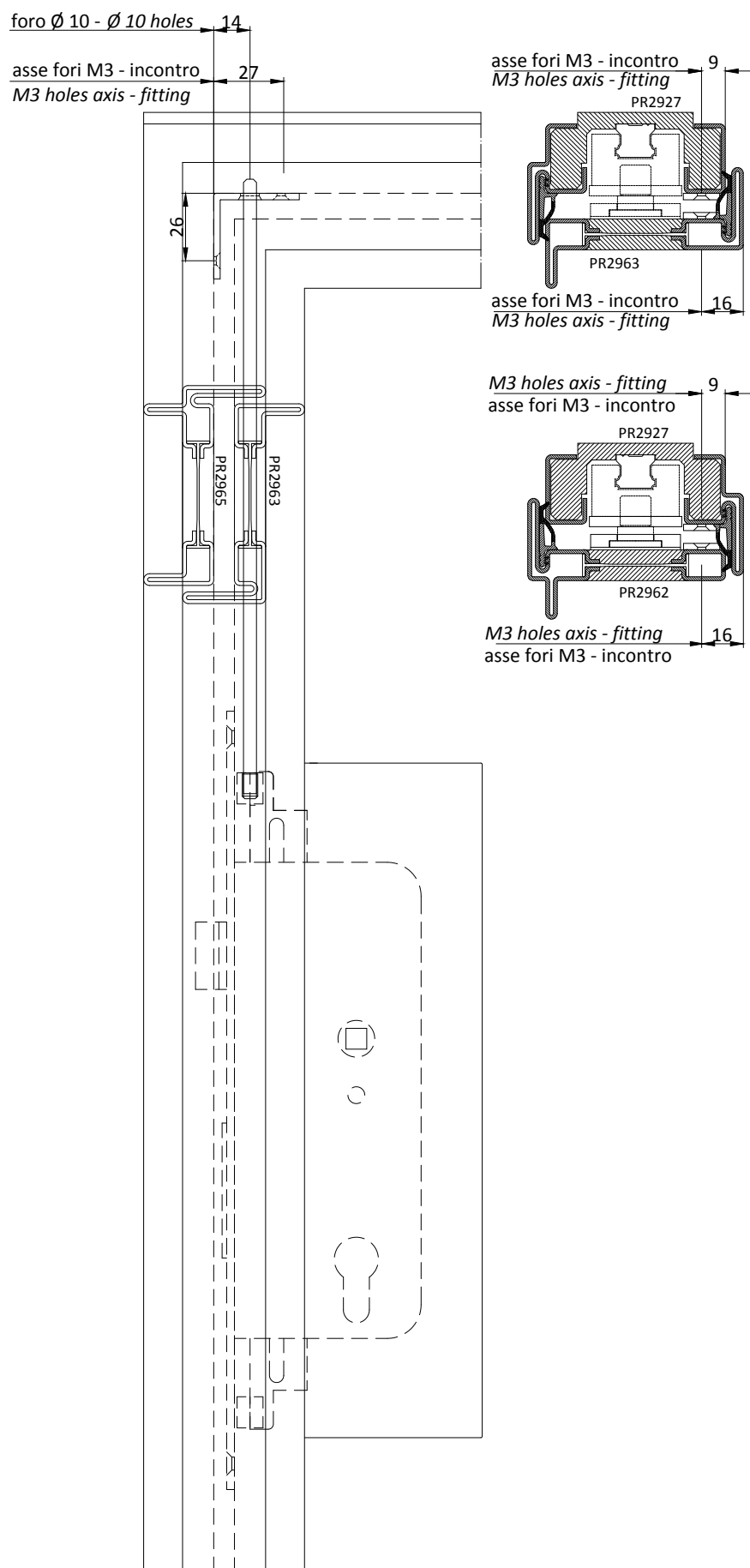
SCHEMA UTILIZZO SERRATURE E TERZE CHIUSURE
CHART FOR THE USE OF LOCKS AND THIRD LOCKS

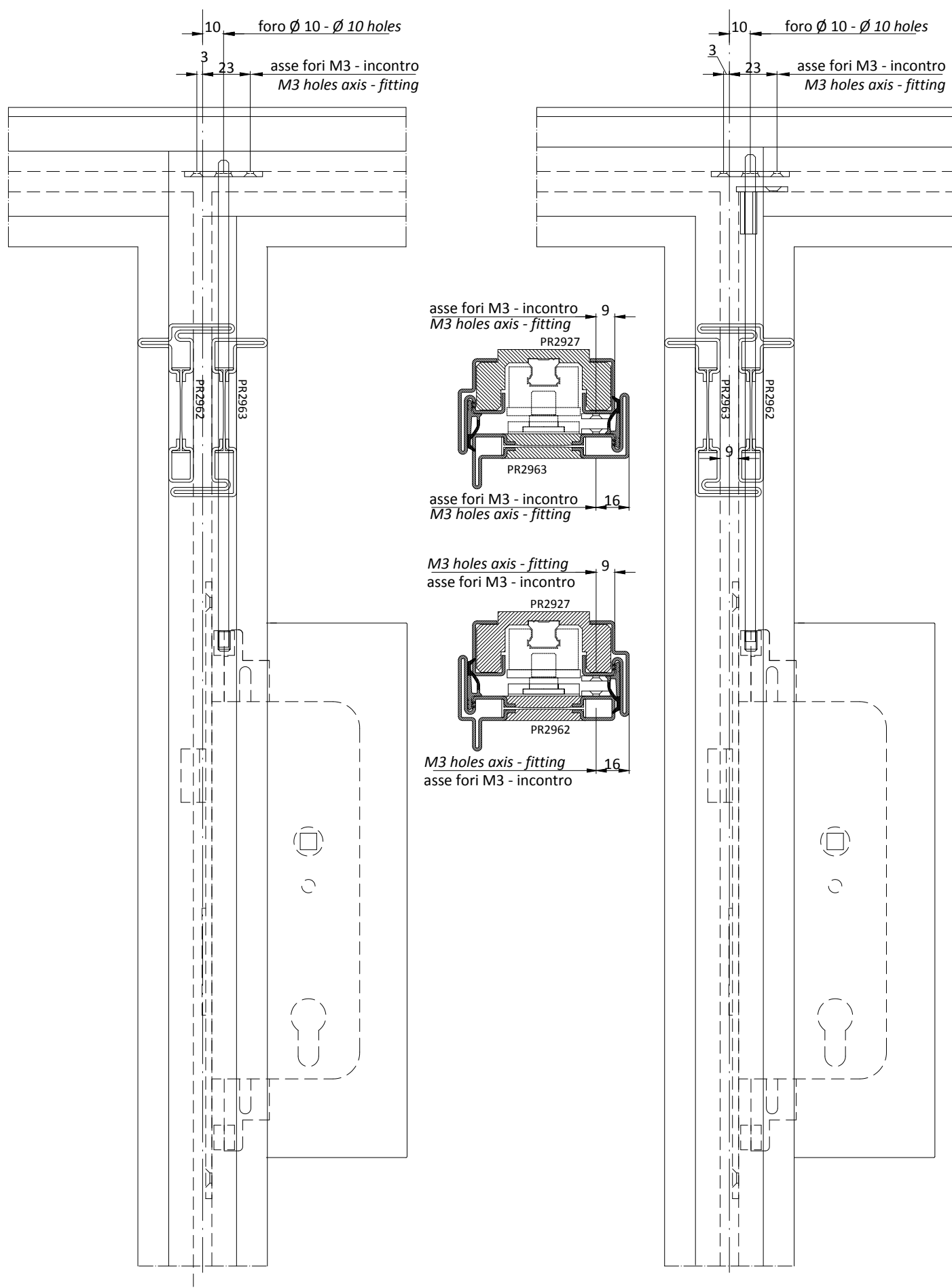


APERTURA INTERNA _ VISTA INTERNA
INWARDS OPENING _ INTERIOR ELEVATION



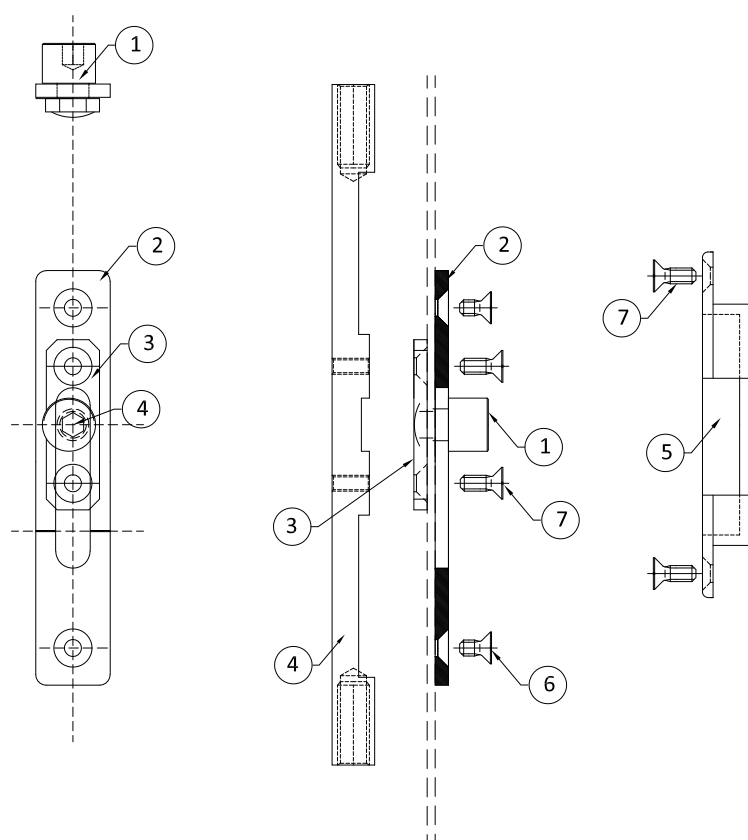
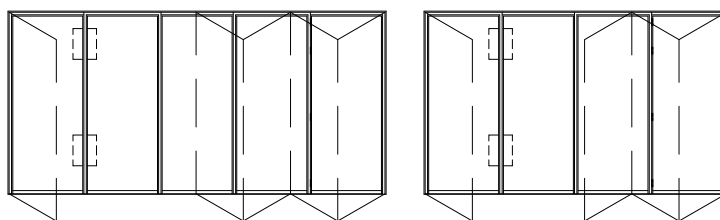
APERTURA ESTERNA _ VISTA INTERNA
OUTWARDS OPENING _ INTERIOR ELEVATION



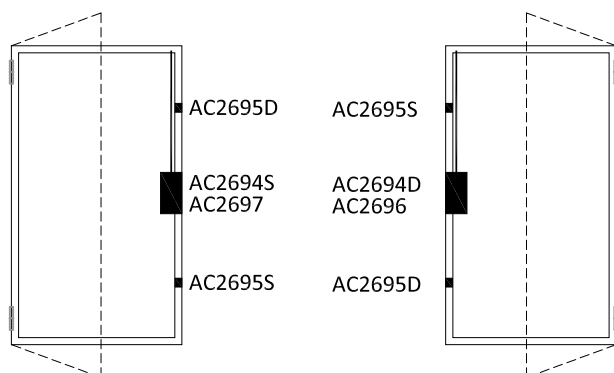


- 1) Rullino eccentrico
- 2) Piastra di fissaggio
- 3) Piastra di collegamento
- 4) Accessorio aggancio aste
- 5) Incontro 3^a chiusura
- 6) viti M3 x 6
- 7) viti M3 x 8

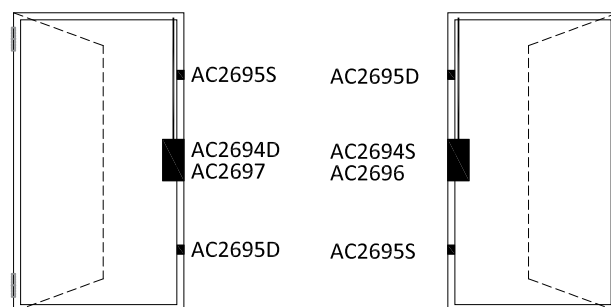
- 1) Barrel cam
- 2) Installation plate
- 3) Connecting plate
- 4) Rod docking accessory
- 5) 3rd lock strike plate
- 6) screws M3 x 6
- 7) screws M3 x 8



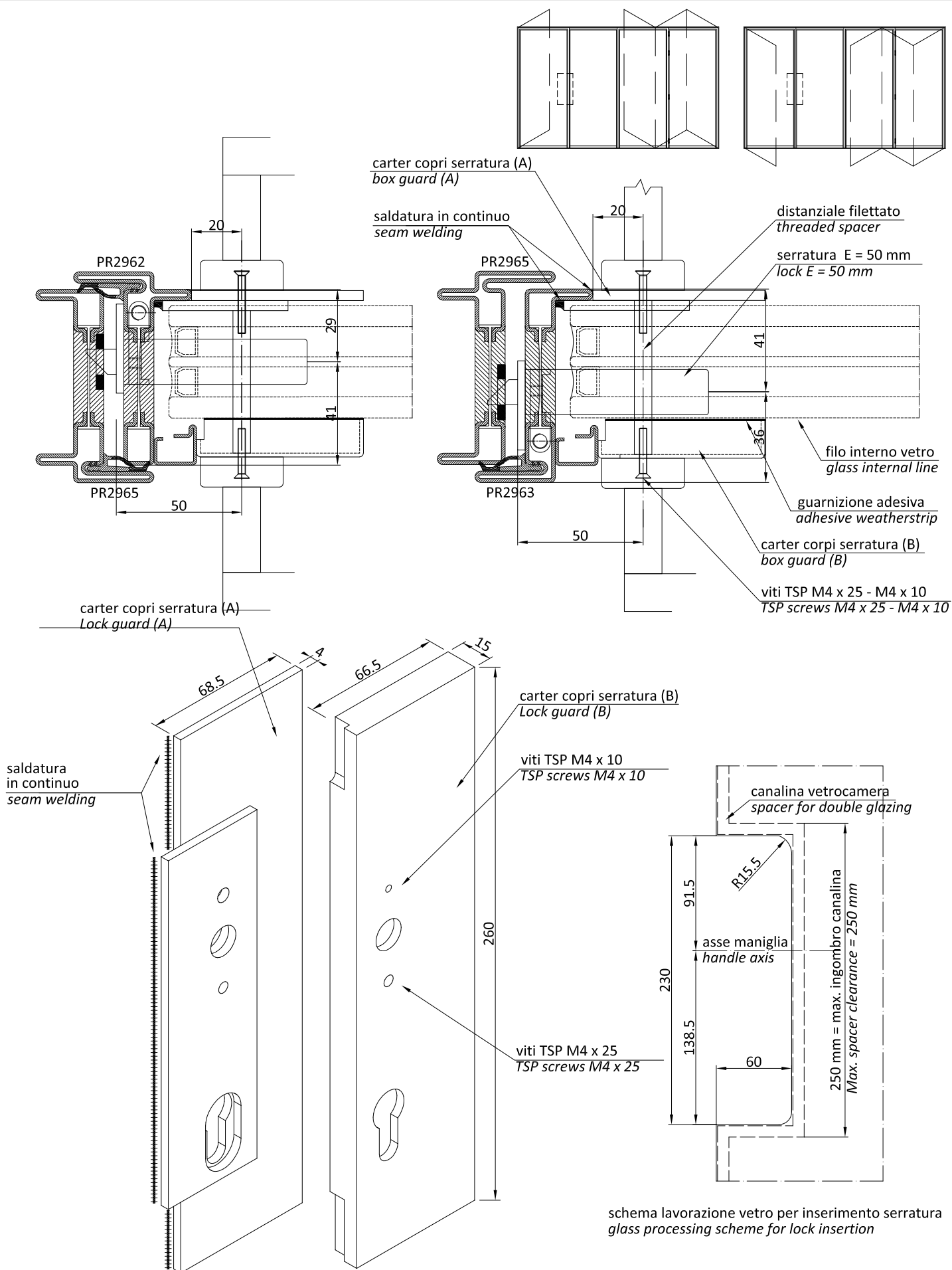
SCHEMA UTILIZZO SERRATURE E TERZE CHIUSURE
CHART FOR THE USE OF LOCKS AND THIRD LOCKS

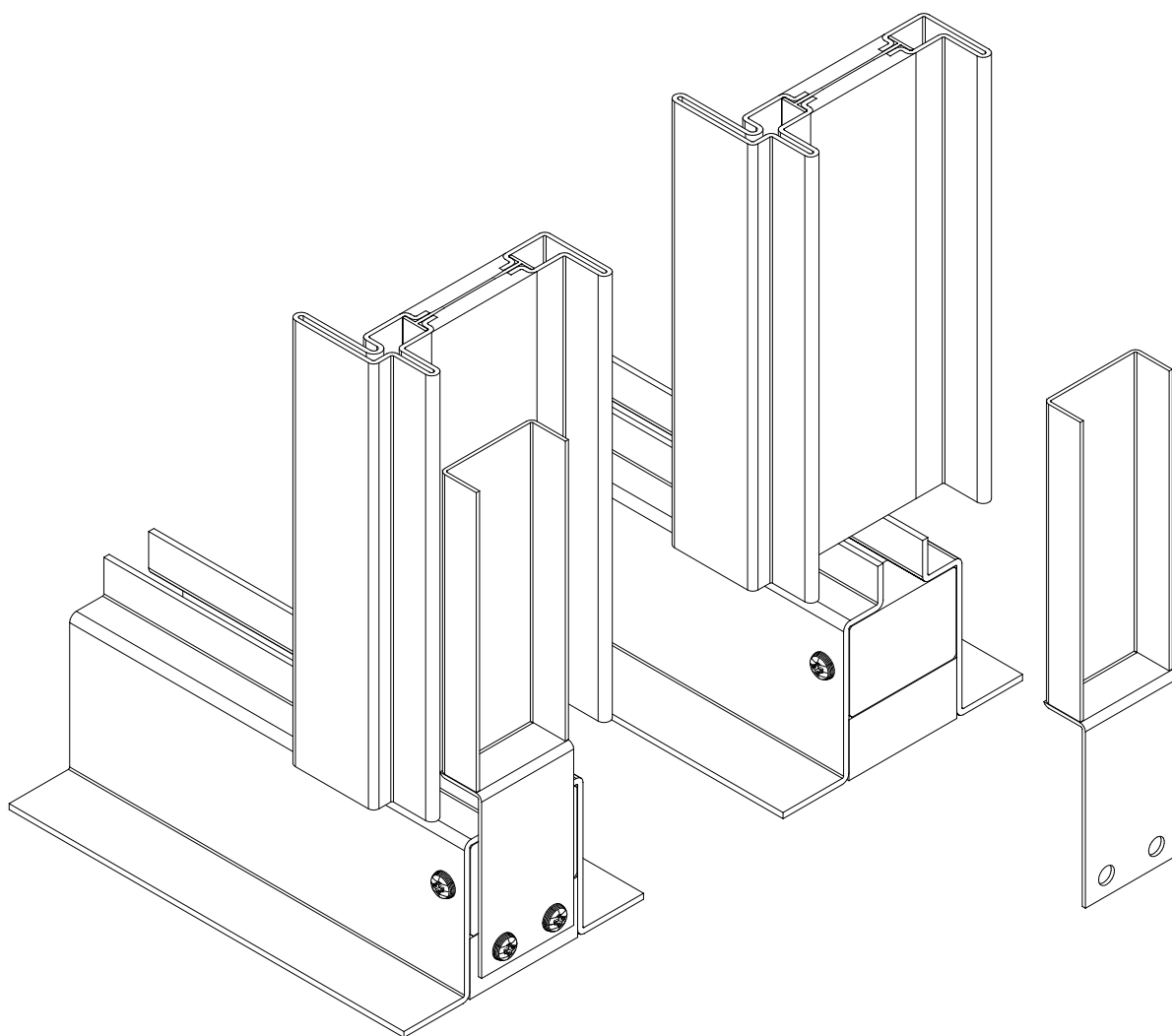
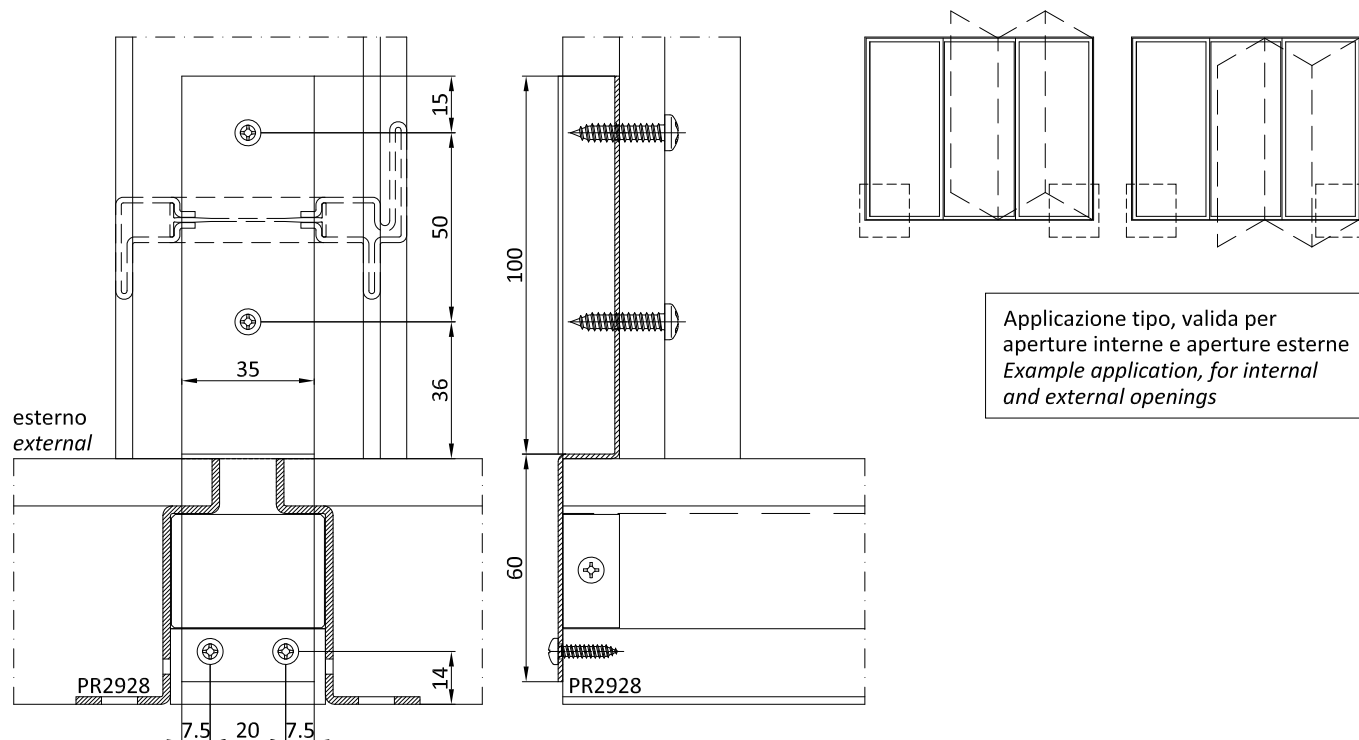


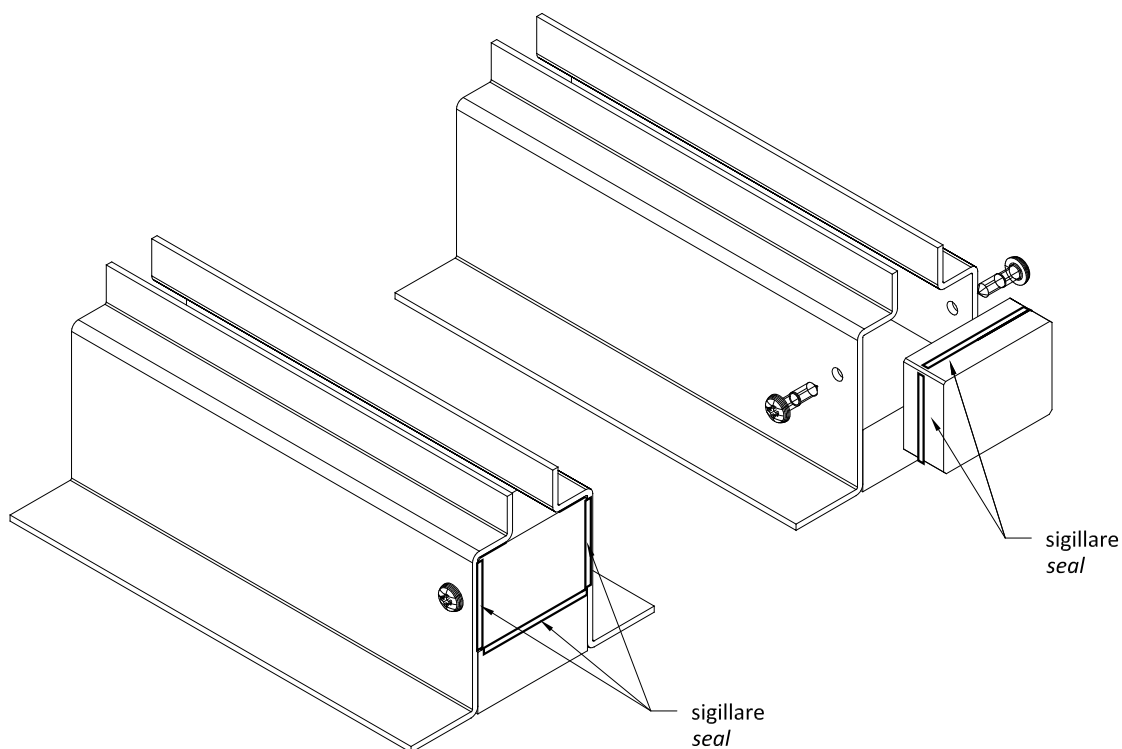
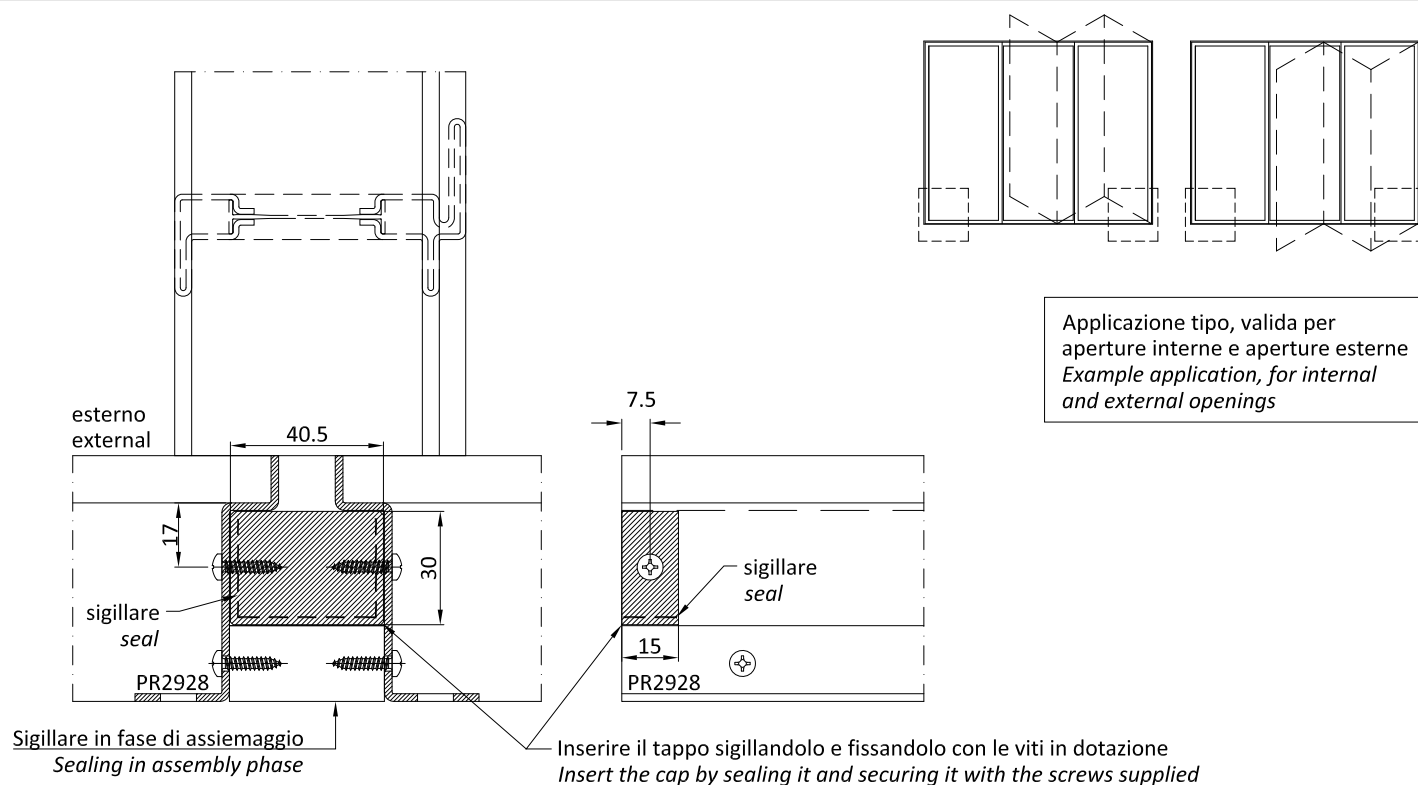
APERTURA INTERNA _ VISTA INTERNA
INWARDS OPENING _ INTERIOR ELEVATION



APERTURA ESTERNA _ VISTA INTERNA
OUTWARDS OPENING _ INTERIOR ELEVATION

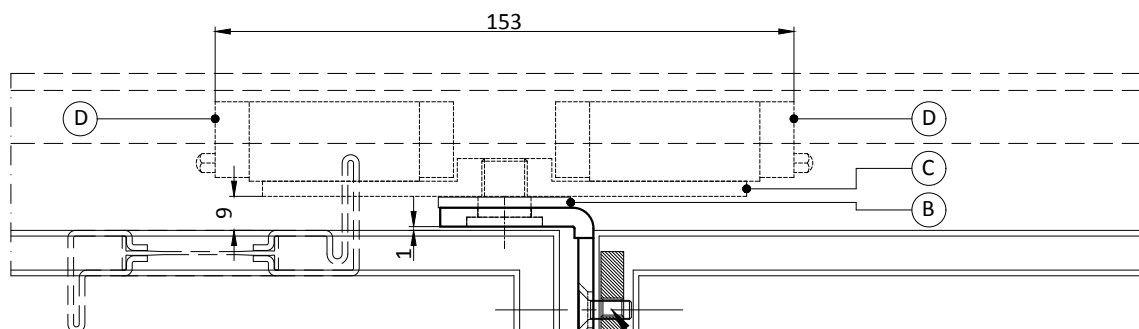
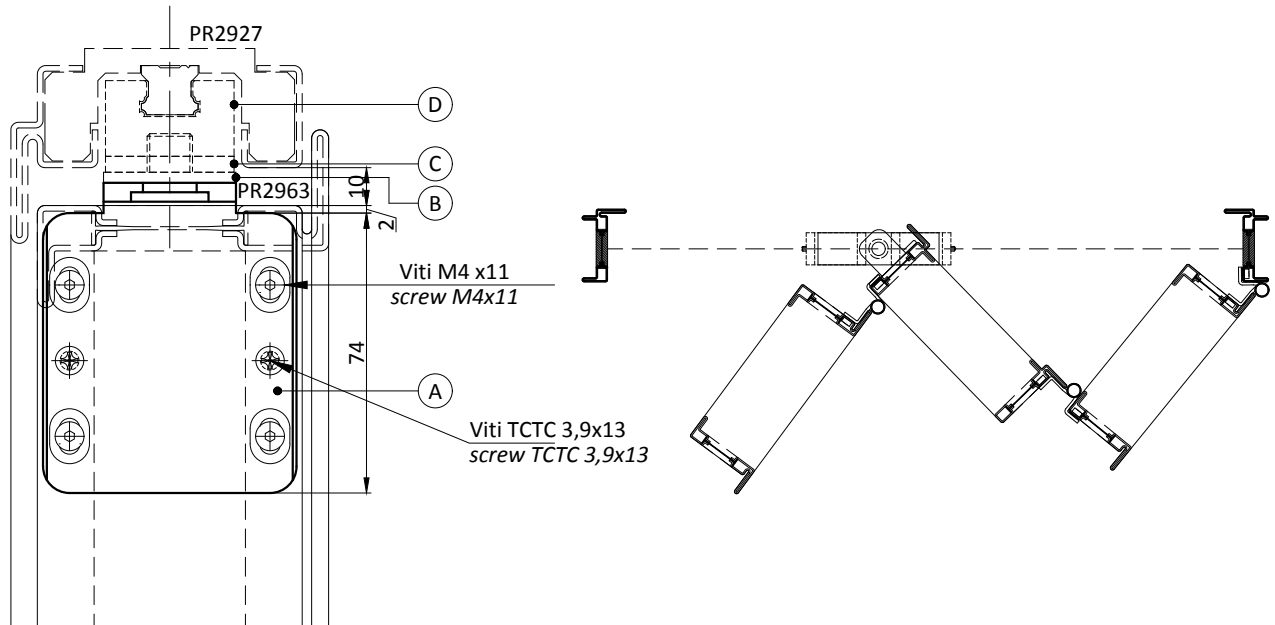
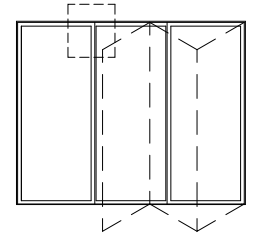






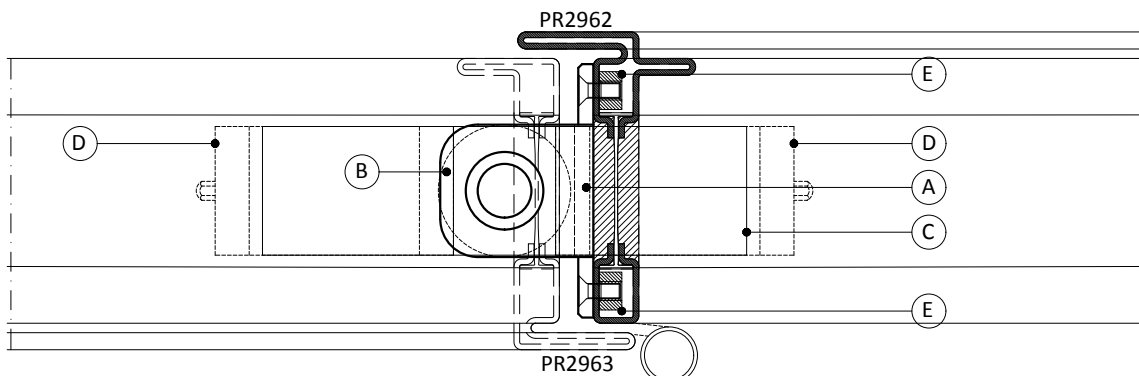
apertura INTERNA
INWARD opening

- A - Staffa angolare | *Corner bracket*
 B - Rondella ottone | *Brass washer*
 C - Piastra collegamento carelli | *Connection plate for roller*
 D - Carrelli | *Rollers*
 E - Rinforzo | *Reinforcement*



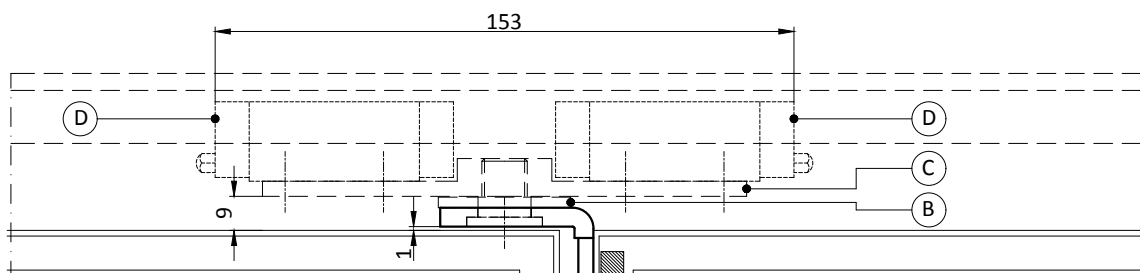
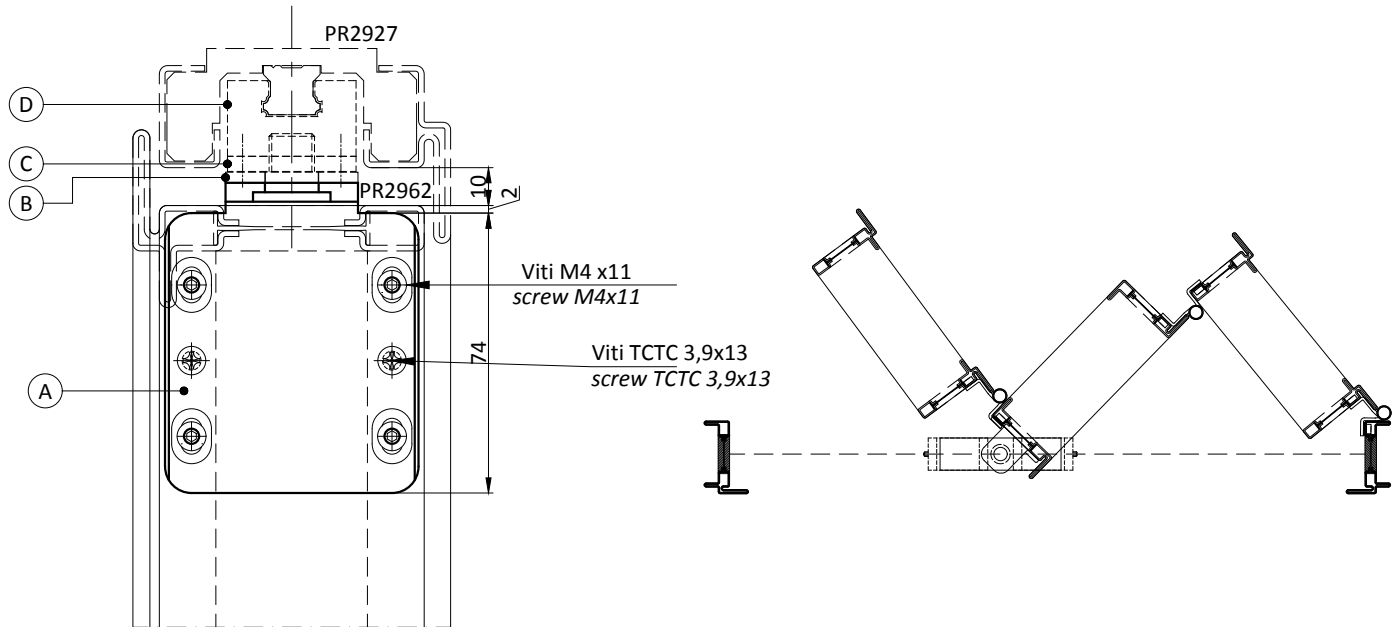
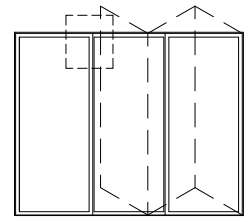
Dopo la registrazione di tutte le ante e verificato il corretto funzionamento dei carrelli bloccare i carrelli in posizione applicando le due viti autofilettanti TCTC 3,9x13 utilizzando i fori predisposti nei carrelli.

After all the doors have been adjusted and the correct functioning of the carriages has been verified, lock the carriages in position by applying the two self-tapping TCTC 3.9x13 screws using the holes provided in the carriages.



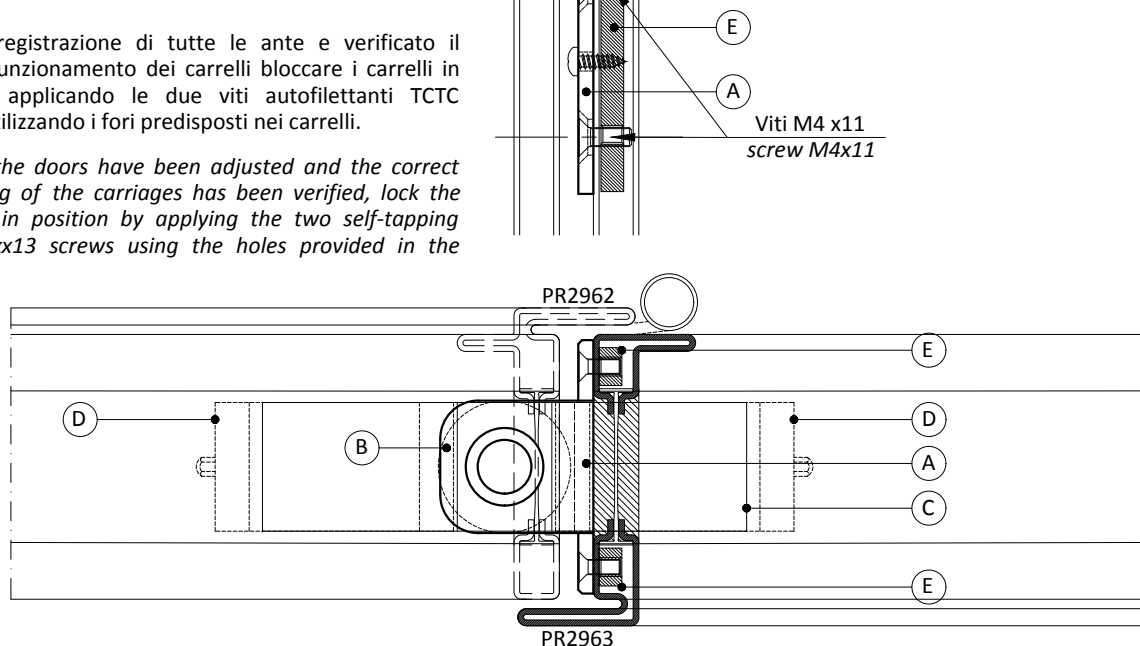
apertura ESTERNA
OUTWARD opening

- A - Staffa angolare | *Corner bracket*
 B - Rondella ottone | *Brass washer*
 C - Piastra collegamento carelli | *Connection plate for roller*
 D - Carrelli | *Rollers*
 E - Rinforzo | *Reinforcement*



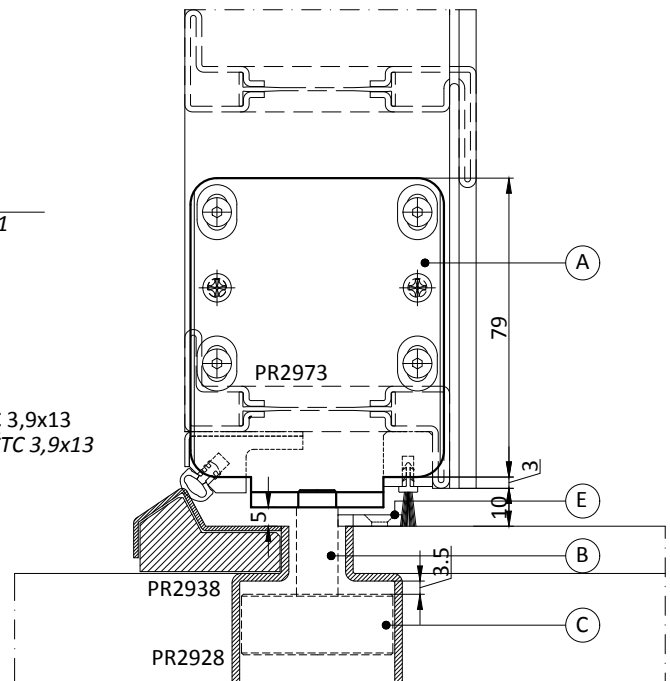
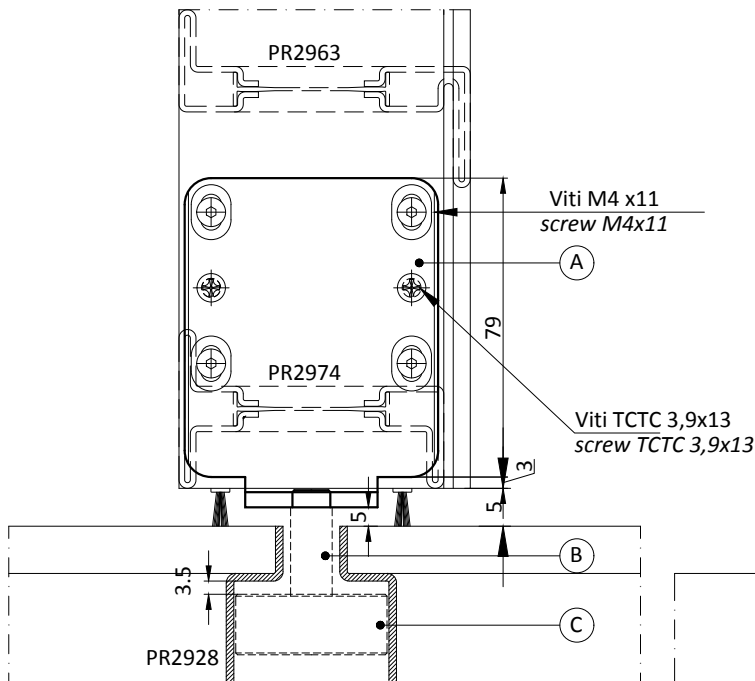
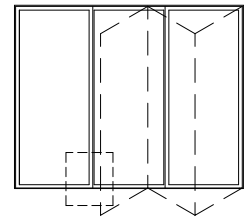
Dopo la registrazione di tutte le ante e verificato il corretto funzionamento dei carrelli bloccare i carrelli in posizione applicando le due viti autofilettanti TCTC 3,9x13 utilizzando i fori predisposti nei carrelli.

After all the doors have been adjusted and the correct functioning of the carriages has been verified, lock the carriages in position by applying the two self-tapping TCTC 3.9x13 screws using the holes provided in the carriages.



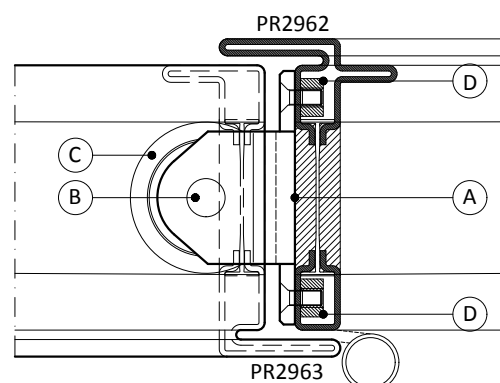
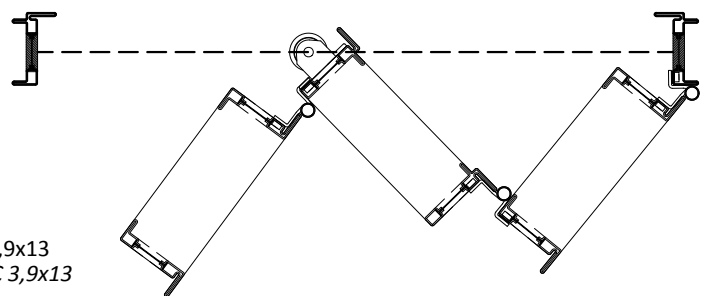
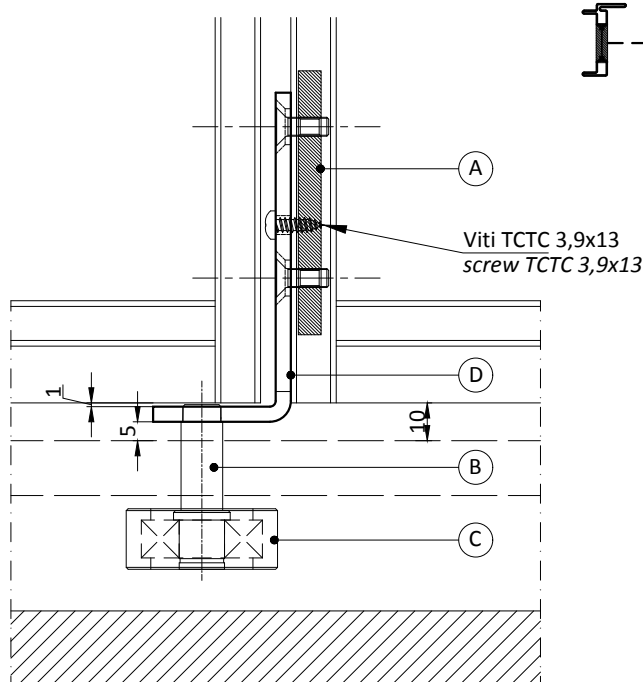
apertura INTERNA
INWARD opening

- A - Staffa angolare | *Corner bracket*
 B - Perno | *Pivot*
 C - Cuscinetto a sfera | *Ball bearing*
 D - Rinforzo | *Reinforcement*
 E - Incontro | *Strike plate*



Dopo la registrazione di tutte le ante e verificato il corretto funzionamento dei carrelli bloccare i carrelli in posizione applicando le due viti autofilettanti TCTC 3,9x13 utilizzando i fori predisposti nei carrelli.

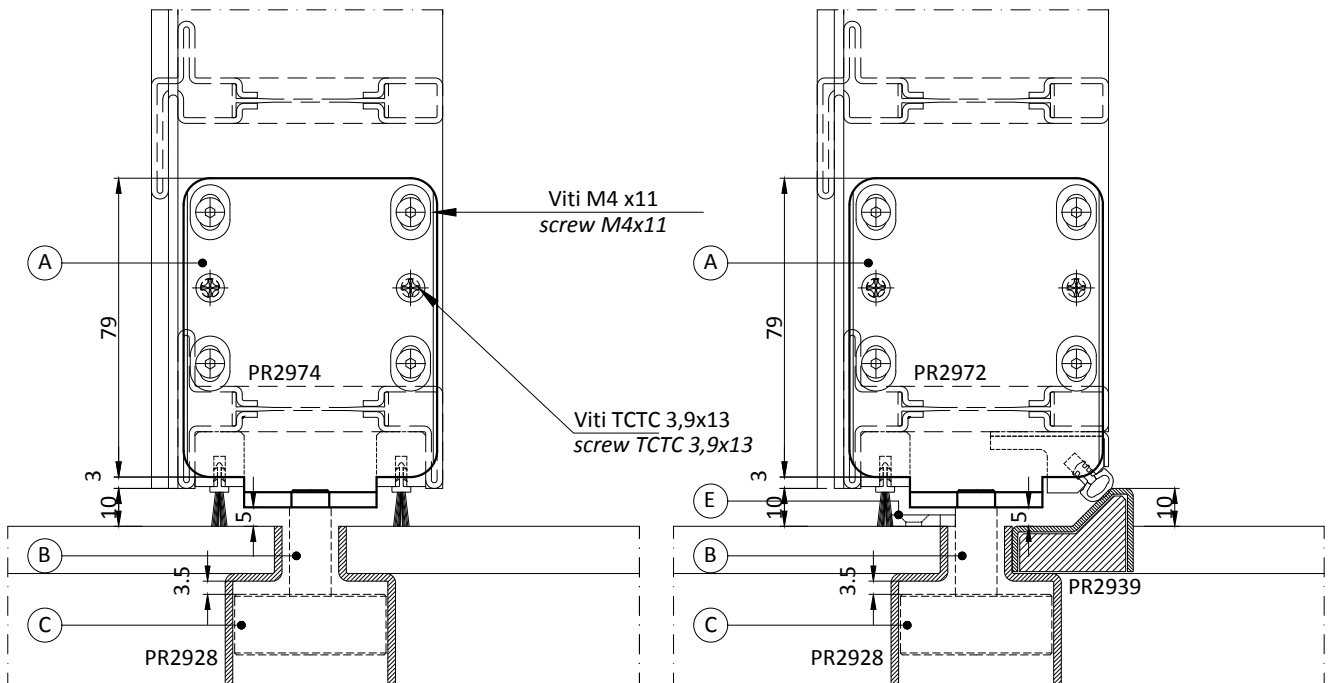
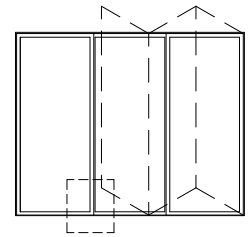
After all the doors have been adjusted and the correct functioning of the carriages has been verified, lock the carriages in position by applying the two self-tapping TCTC 3.9x13 screws using the holes provided in the carriages.



viti e tasselli non inclusi | screws and wall plugs not supplied

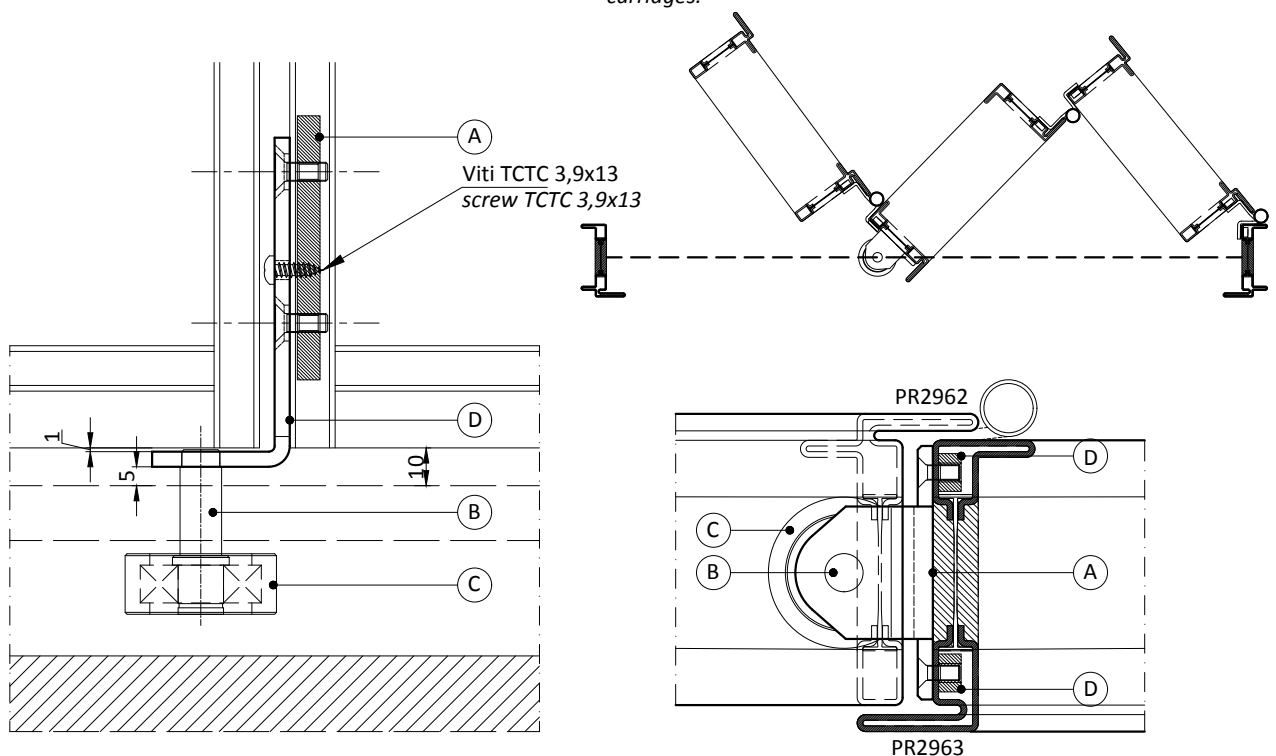
apertura ESTERNA
OUTWARD opening

A - Staffa angolare | Corner bracket
B - Perno | Pivot
C - Cuscinetto a sfera | Ball bearing
D - Rinforzo | Reinforcement
E - Incontro | Strike plate



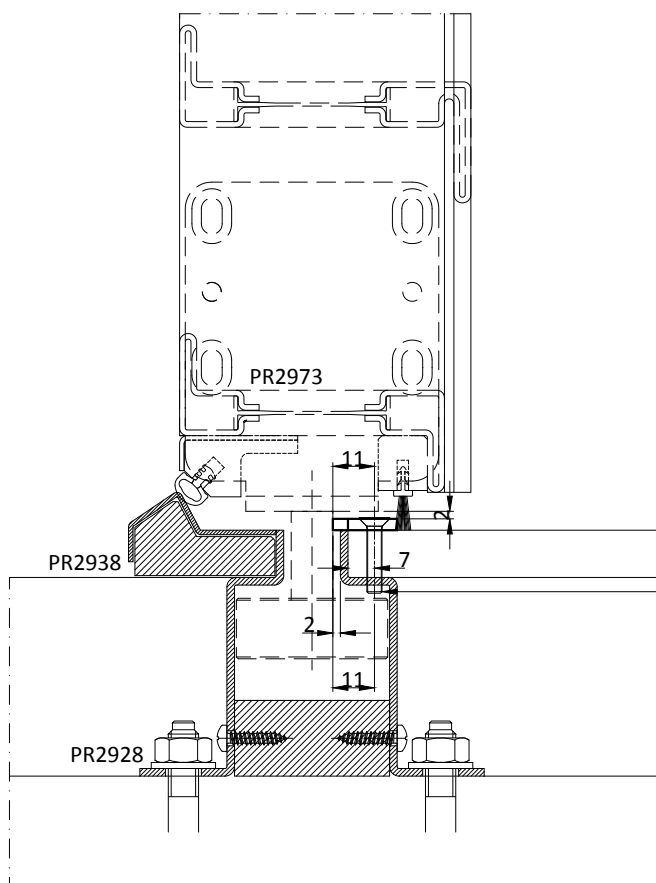
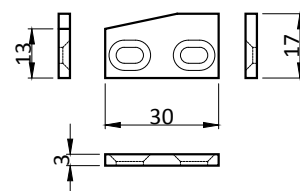
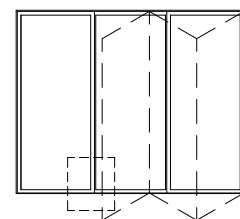
Dopo la registrazione di tutte le ante e verificato il corretto funzionamento dei carrelli bloccare i carrelli in posizione applicando le due viti autofilettanti TCTC 3,9x13 utilizzando i fori predisposti nei carrelli.

After all the doors have been adjusted and the correct functioning of the carriages has been verified, lock the carriages in position by applying the two self-tapping TCTC 3.9x13 screws using the holes provided in the carriages.

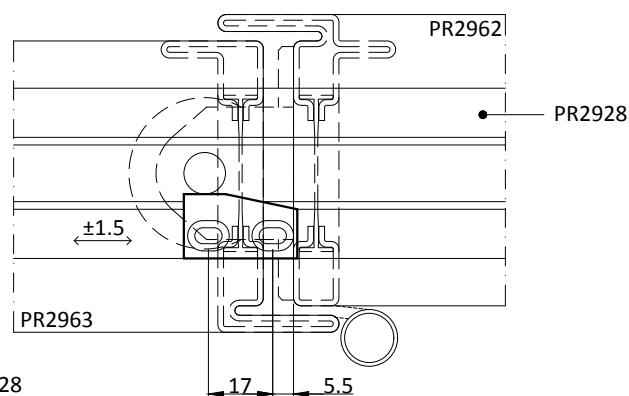
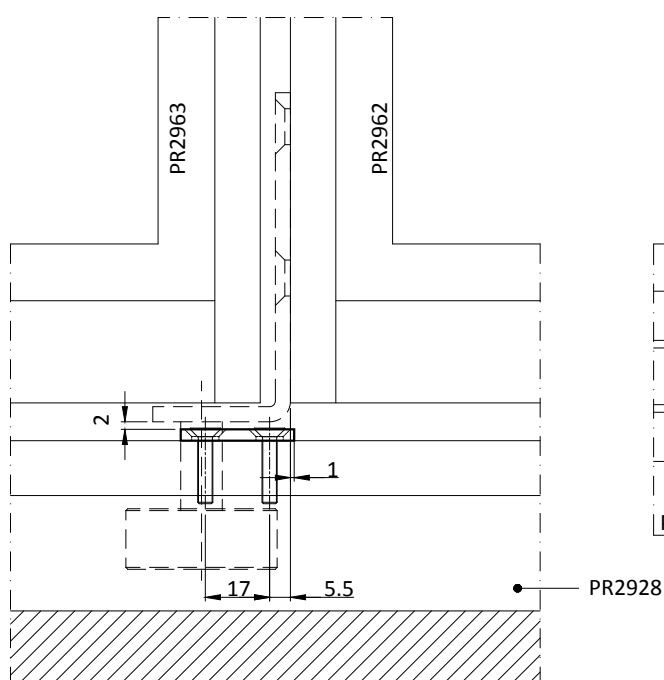


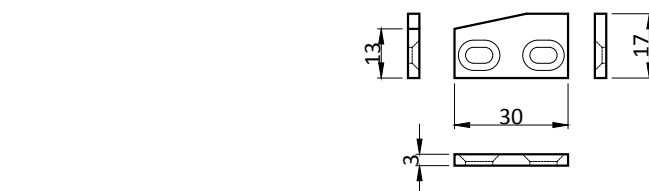
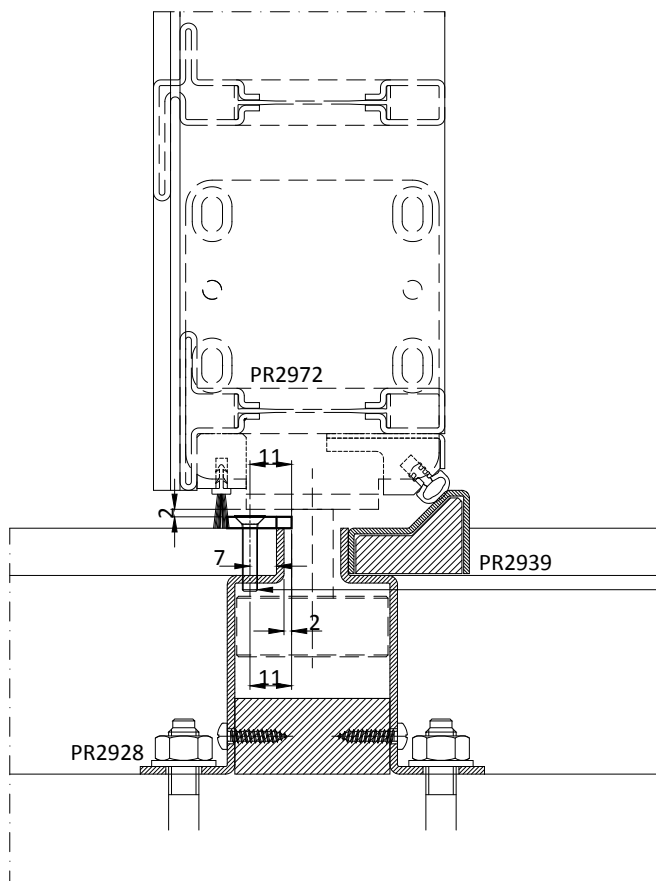
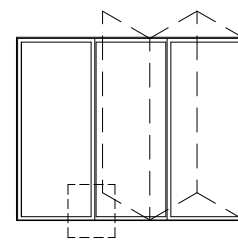
viti e tasselli non inclusi | screws and wall plugs not supplied

apertura INTERNA
INWARD opening

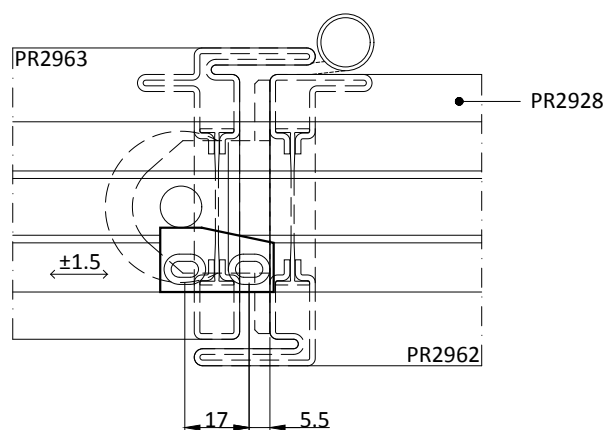
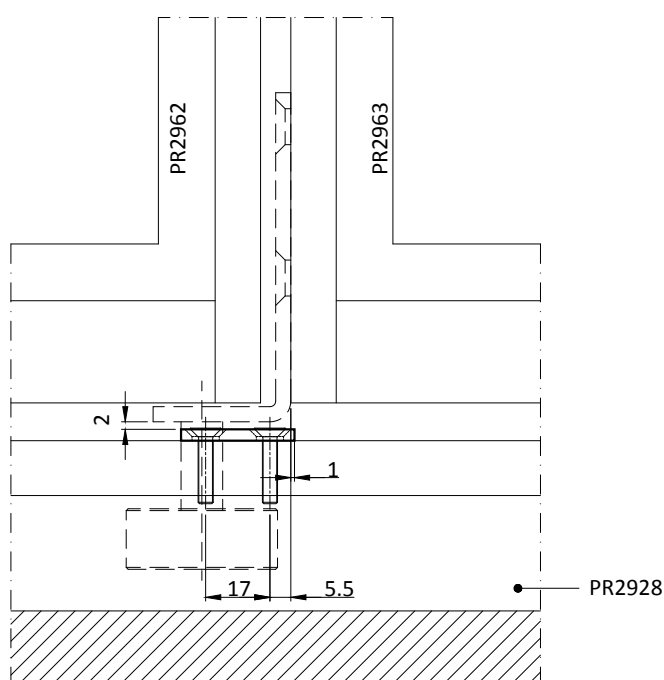


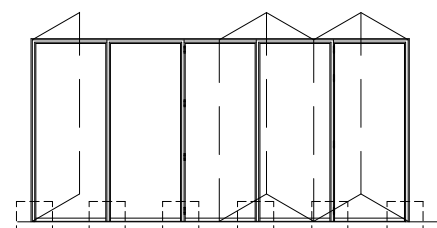
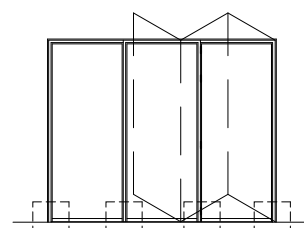
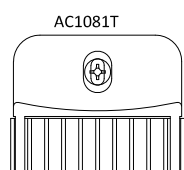
vite | screw TPSEI M4x20 mm
ATTENZIONE | WARNING
accorciare la vite di 2 mm
reduce the screw by 2 mm



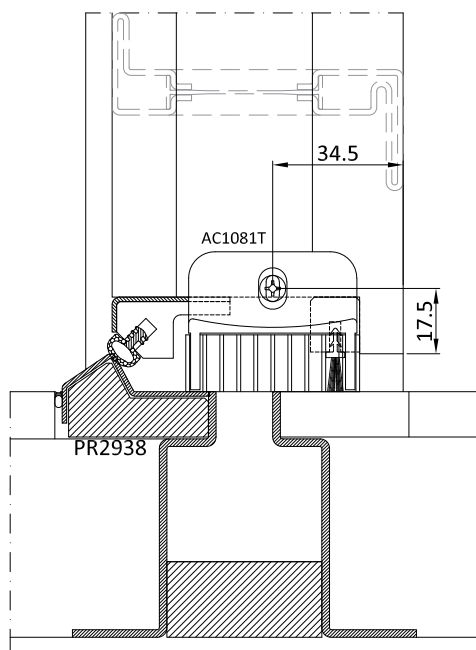
apertura ESTERNA
OUTWARD opening

vite | screw TPSEI M4x20 mm
ATTENZIONE | WARNING
accorciare la vite di 2 mm
reduce the screw by 2 mm

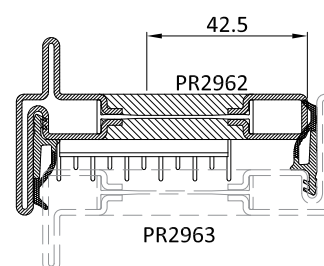
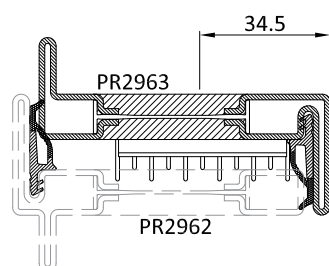
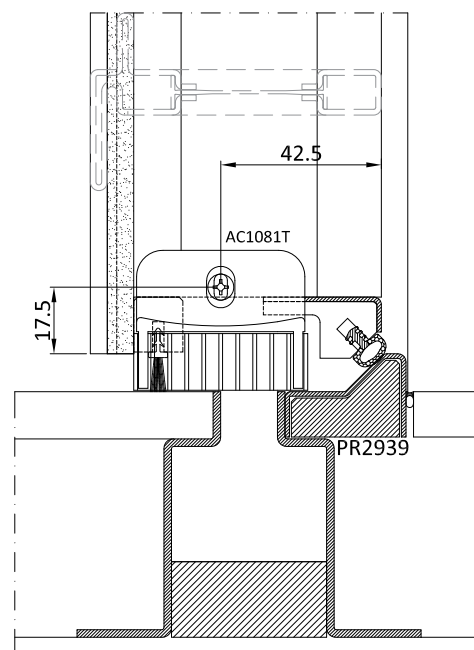




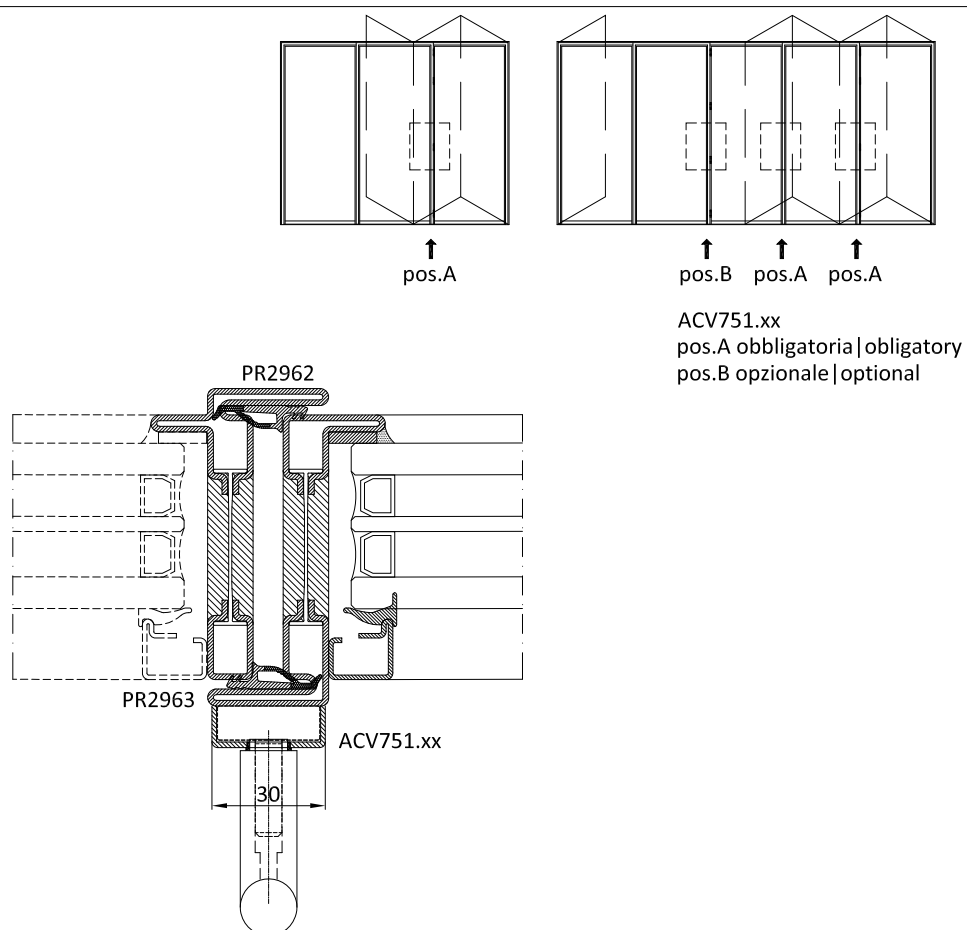
apertura INTERNA
INWARD opening



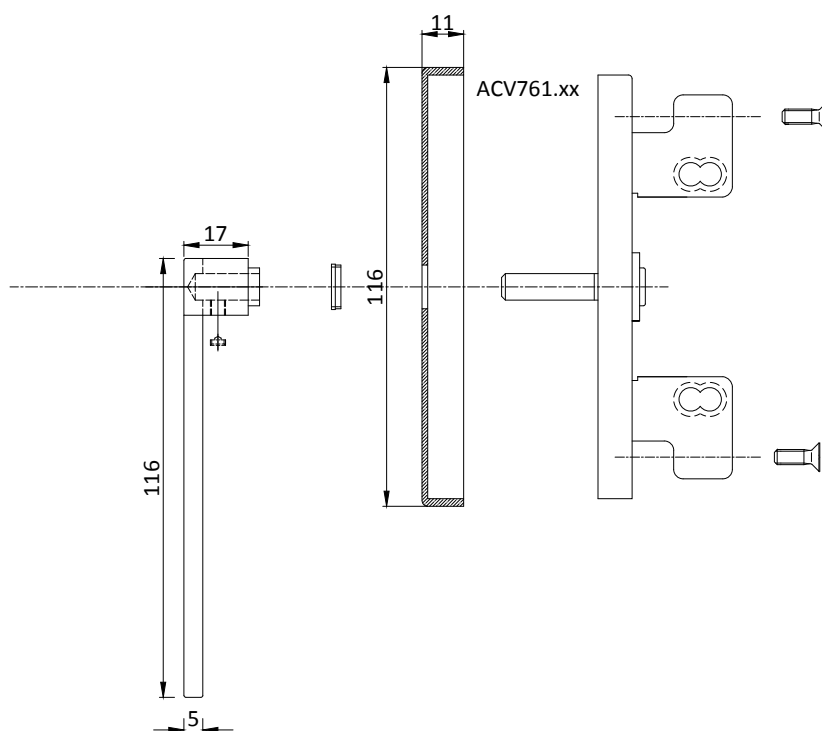
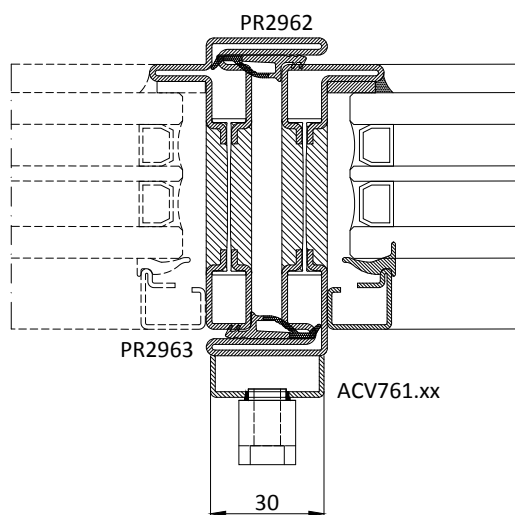
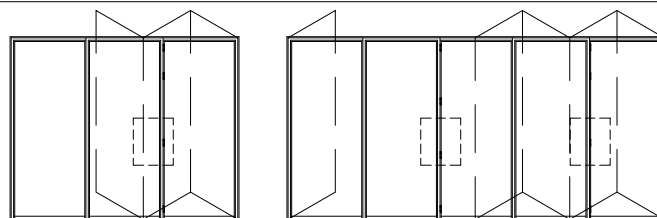
apertura ESTERNA
OUTWARD opening



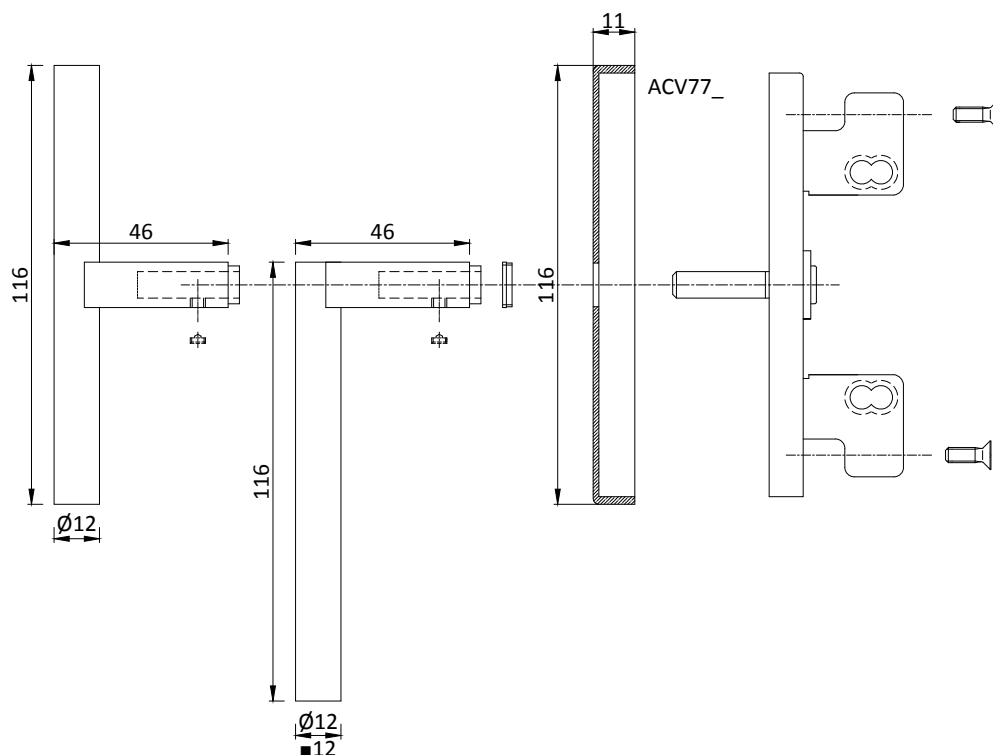
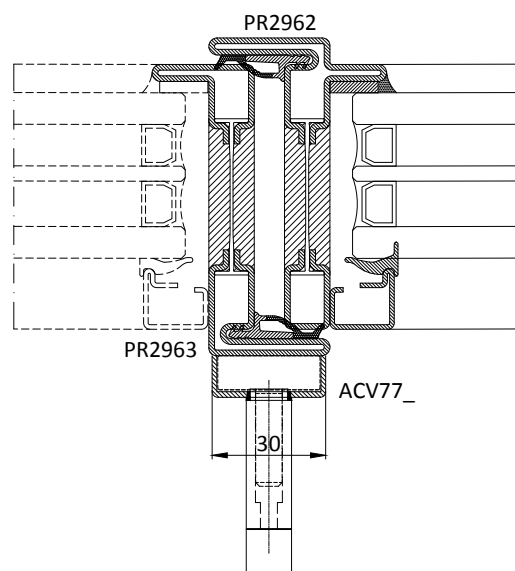
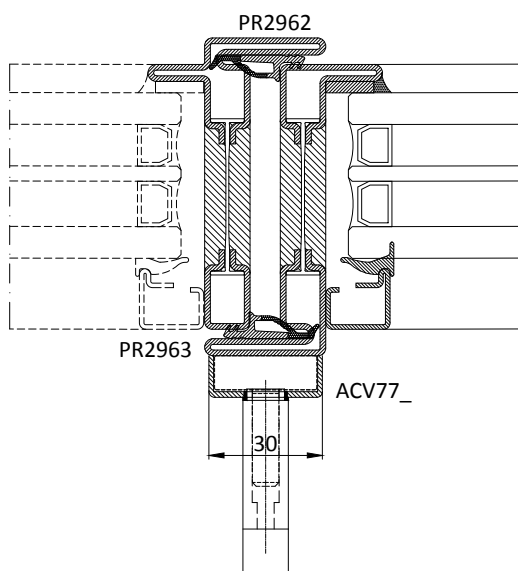
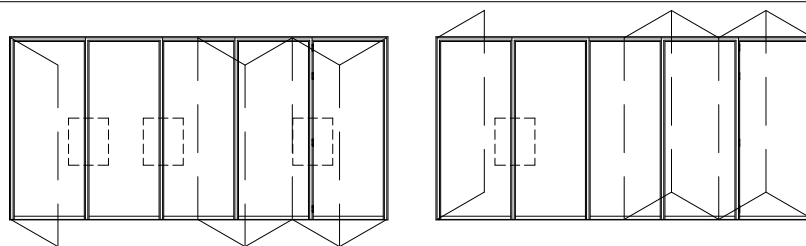
viti non comprese - screws not supplied

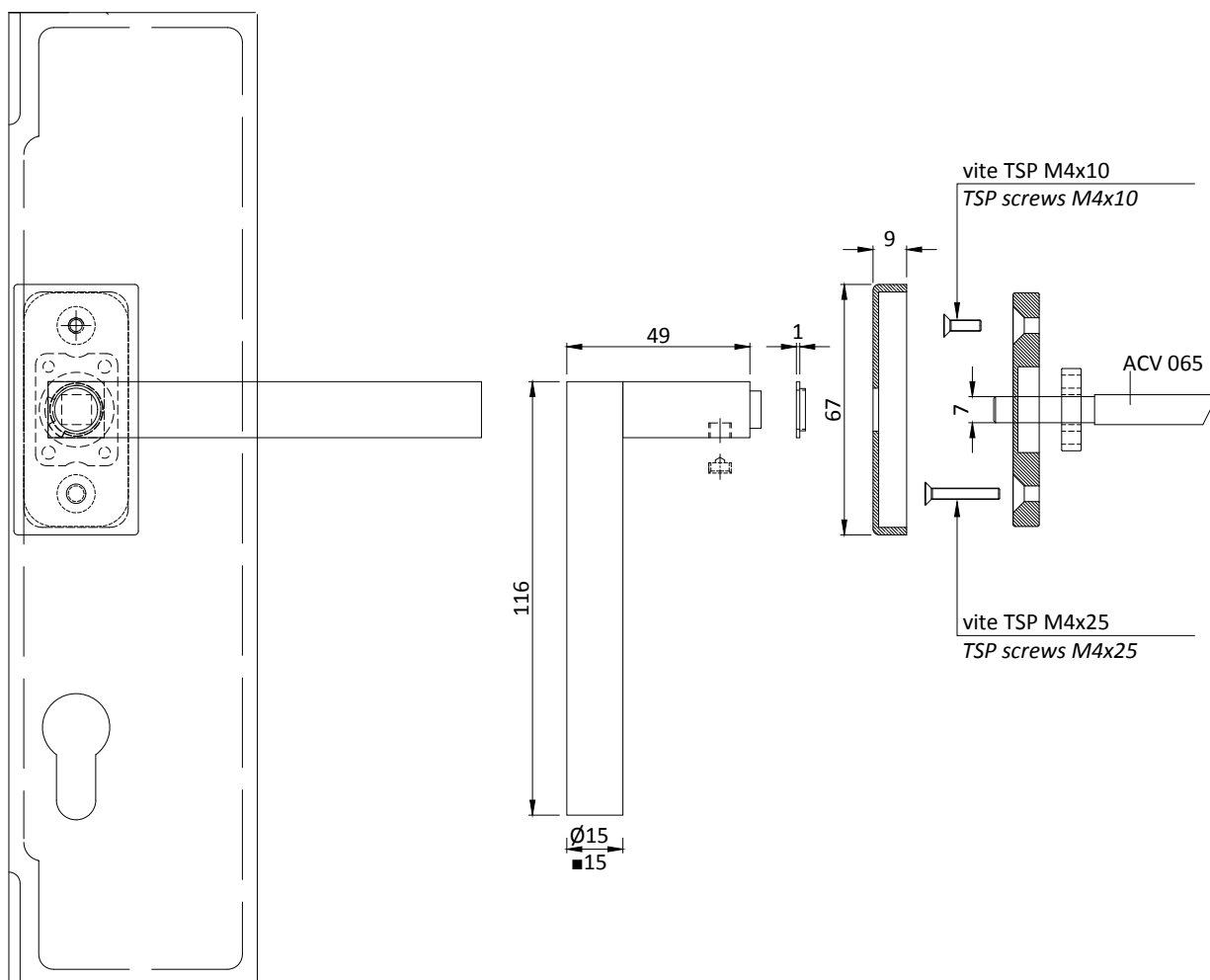
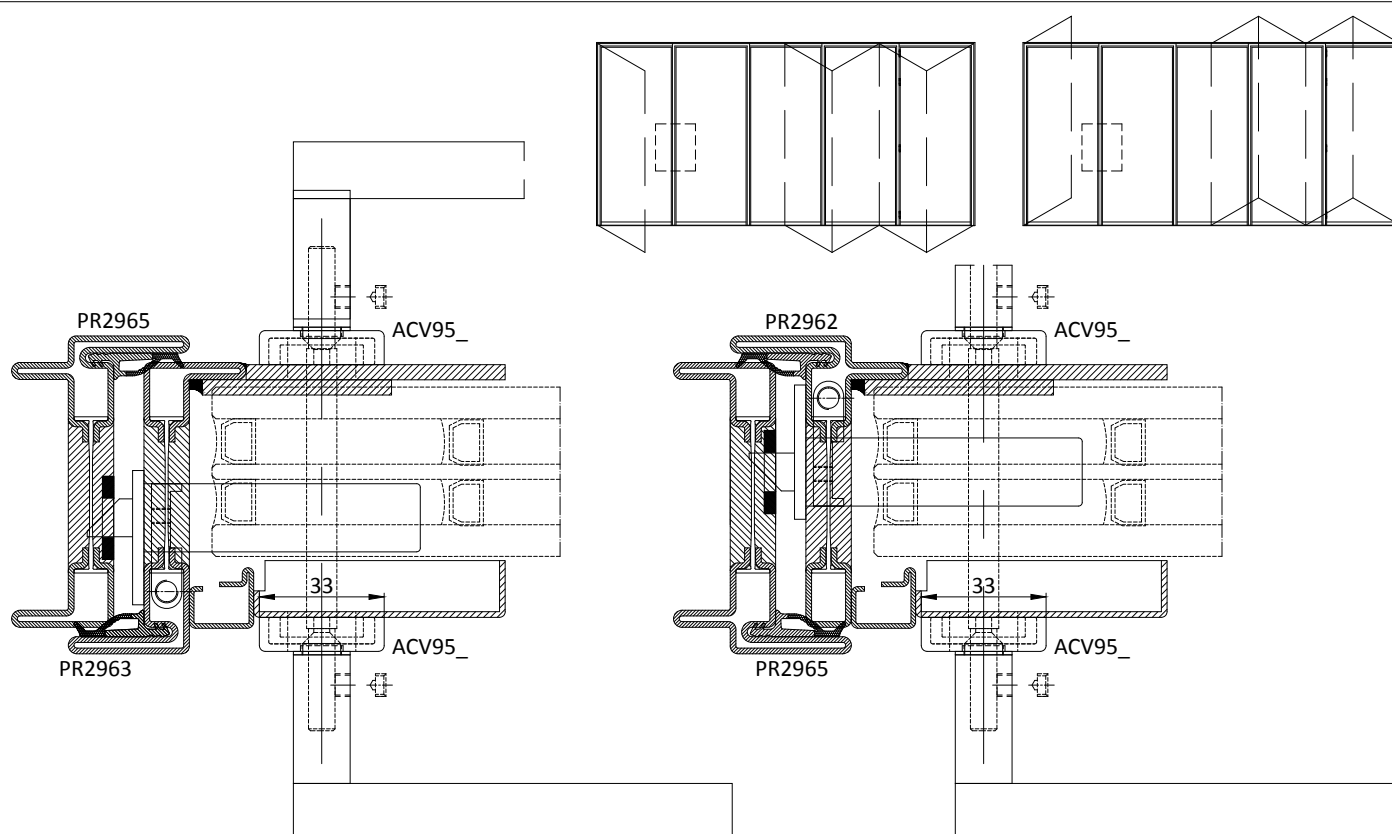


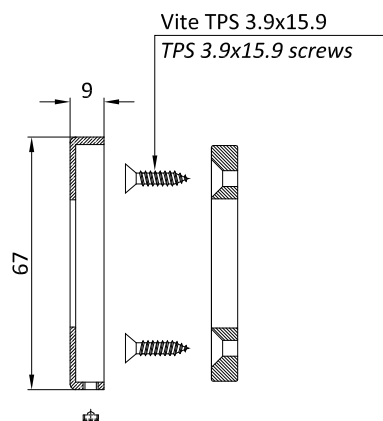
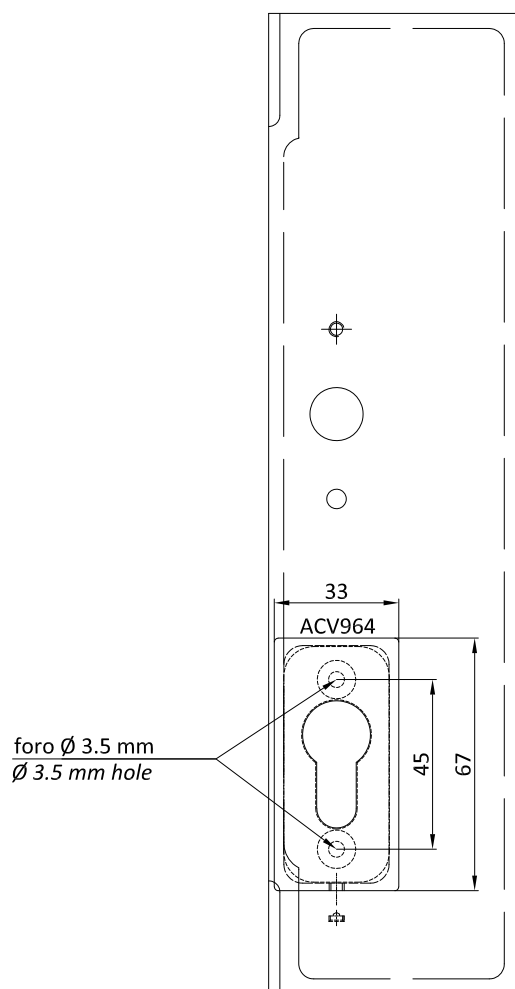
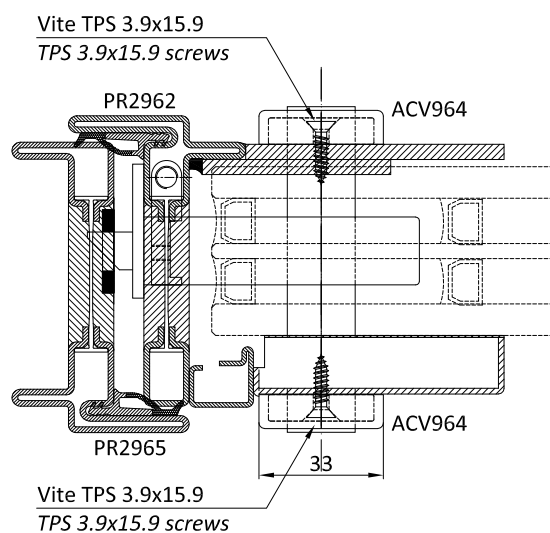
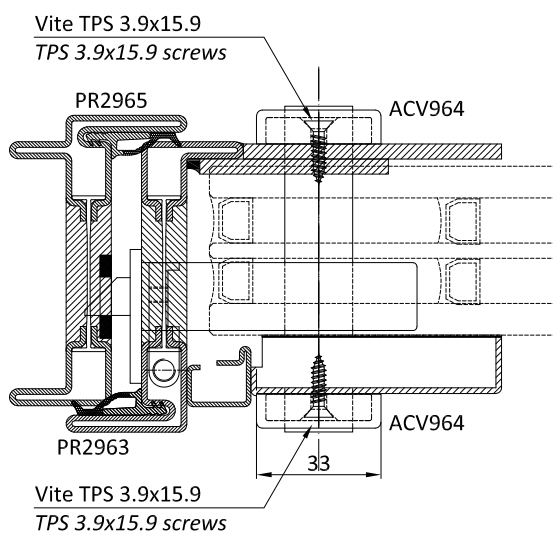
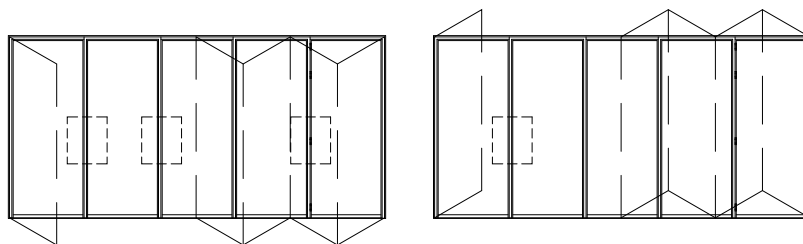
Martellina cremonese ridotta su impacchettamento Apertura Interna 3+0;4+1 e similari, apertura esterna 2+1 e similari
Reduce cemone handle on opening folding inward 3+0; 4+1 and similar, outward 2+1 and similar

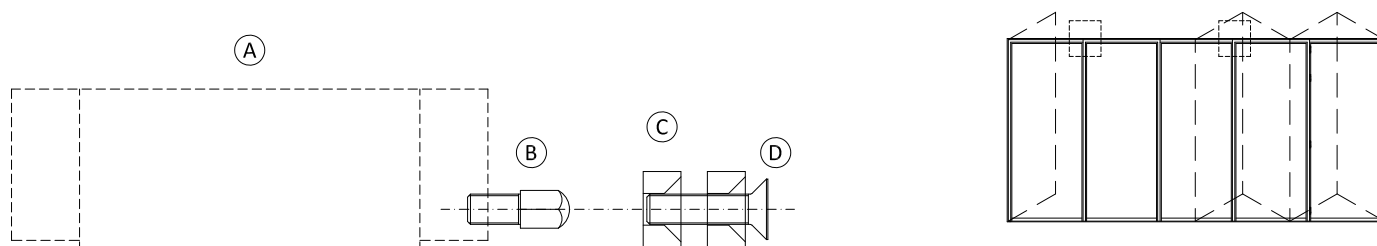


Martellina cremonese ridotta su impacchettamento apertura esterna
Reduce cemone handle on opening folding outward









A - Carrello superiore | *Upper roller*

B - Valvola di lubrificazione carrello | *Roller lubrication valve*

C - Magneti | *Magnets*

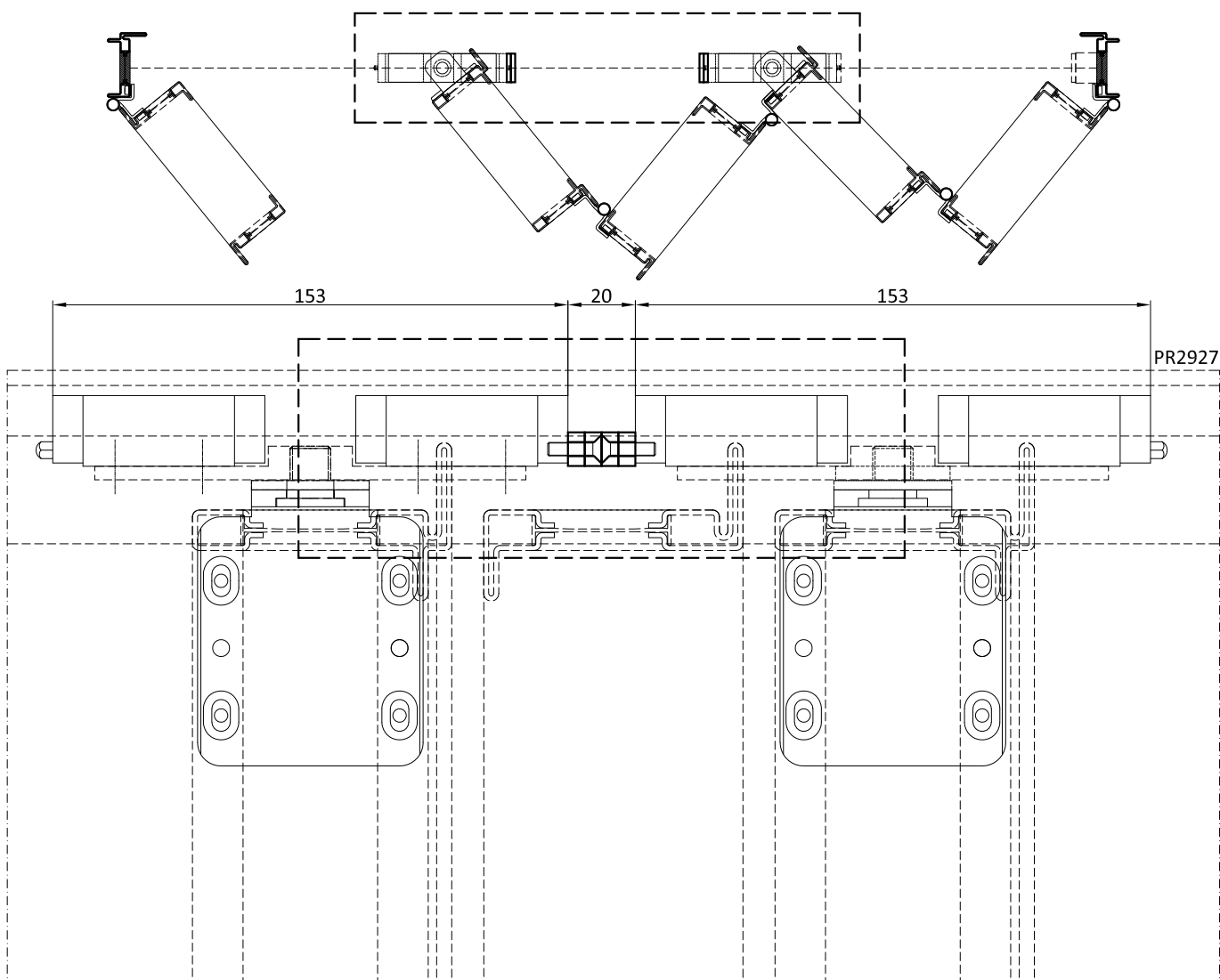
D - Vite TPSEI M4x16 | *Screw TPSEI M4x16*

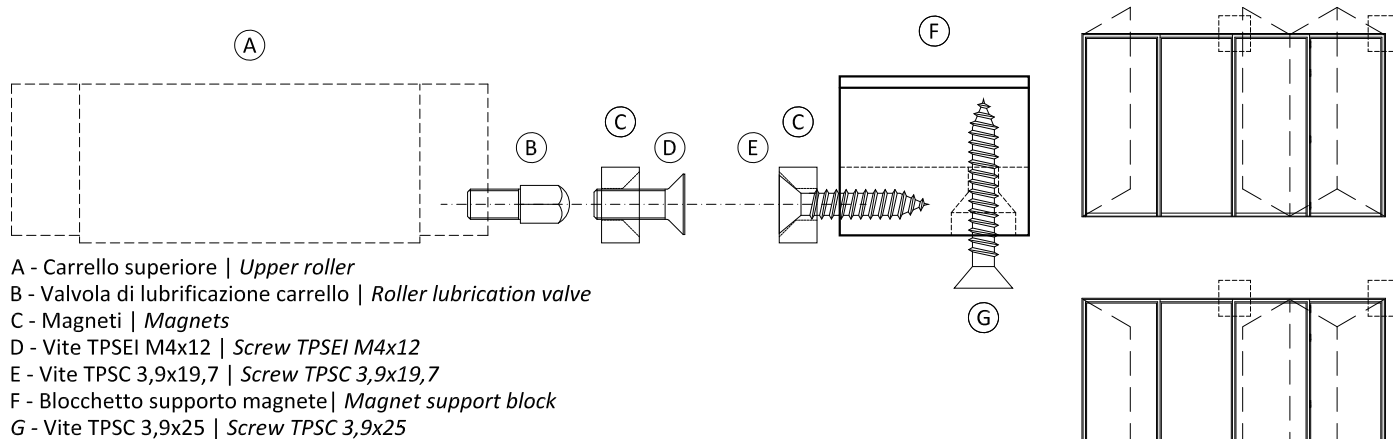
Rimuovere la valvola di lubrificazione (B) dal carrello superiore (A)

To remove the lubrication valve (B) from the upper roller (A)

Avvitare i 2 magneti (C) tramite la vite M4x16 (D)

To screw the two magnets (C) with the screw M4x16 (D)



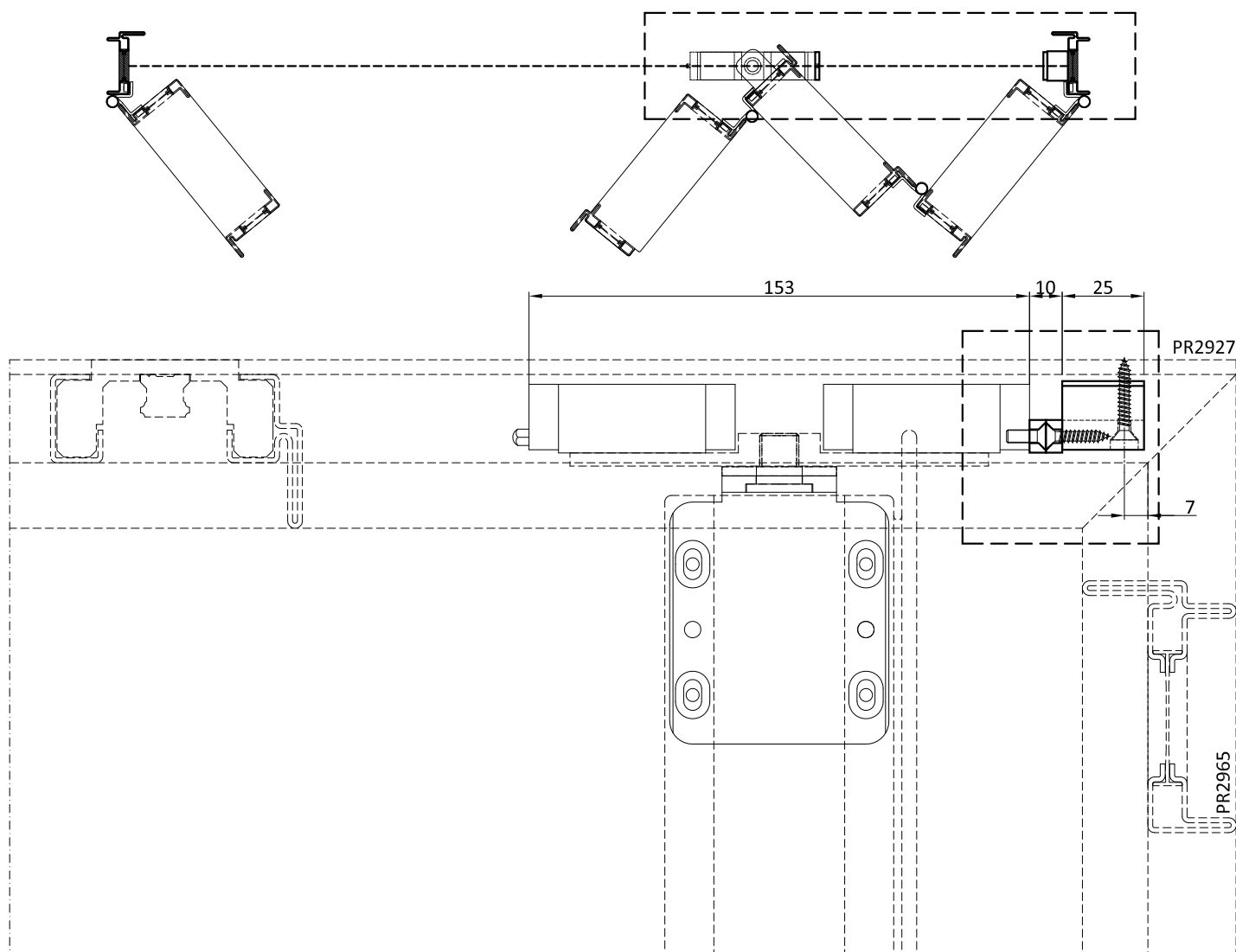


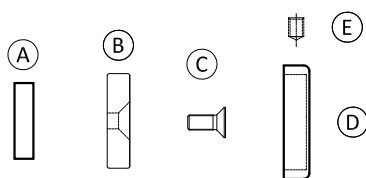
Rimuovere la valvola di lubrificazione (B) dal carrello superiore (A)
To remove the lubrication valve (B) from the upper roller (A)

Avvitare il magnete (C) tramite la vite M4x12 (D) al carrello superiore (A)
To screw the magnet (C) with the screw M4x12 (D) to the upper roller (A)

Avvitare il magnete (C) tramite la vite TPSC 3,9x19,7 (E) al blocchetto supporto magnete (F)
To screw the magnet (C) with the screw TPSC 3,9x19,7 (E) to the magnet support block (F)

Fissare il blocchetto (F) alla guida superiore tramite la vite TPSC 3,9x25 (G)
To fix the support block (F) to the upper guide with the screw TPSC 3,9x25 (G)



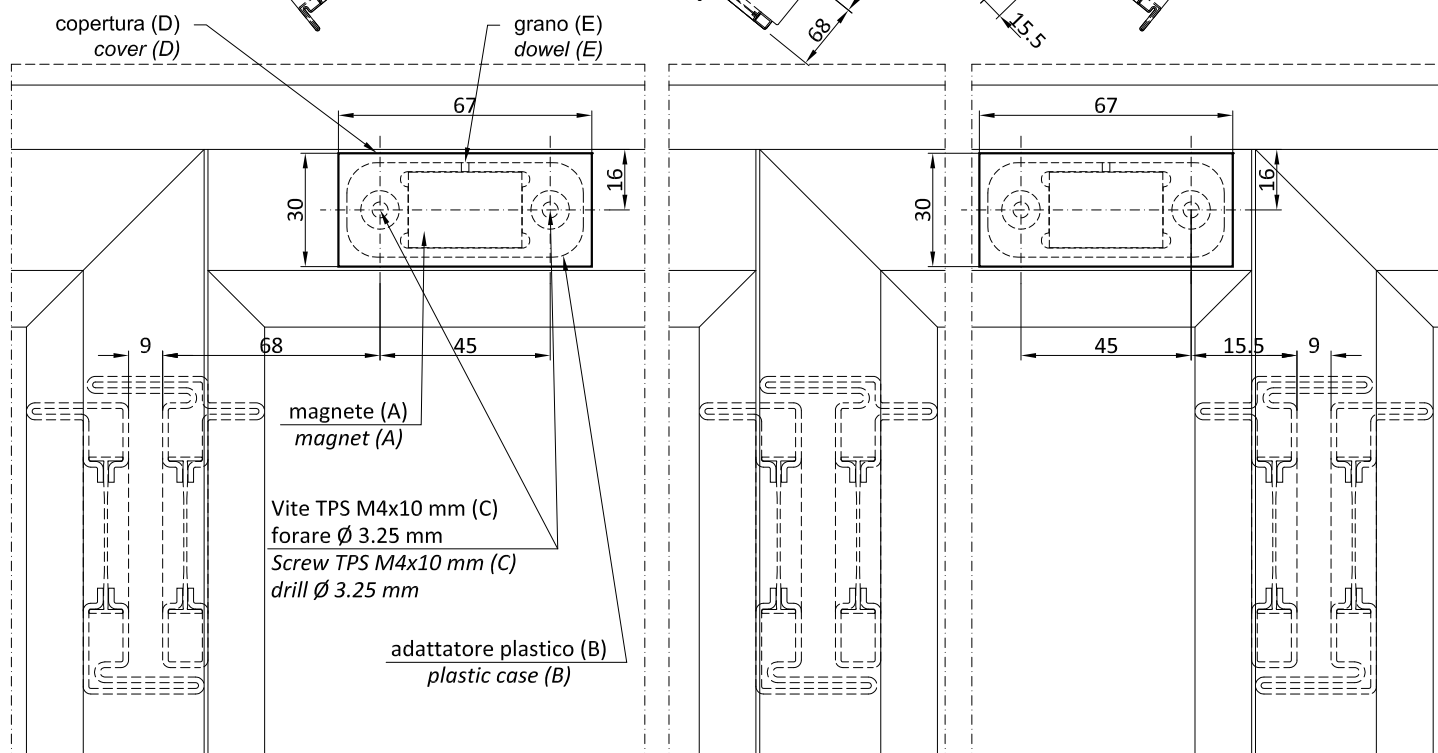
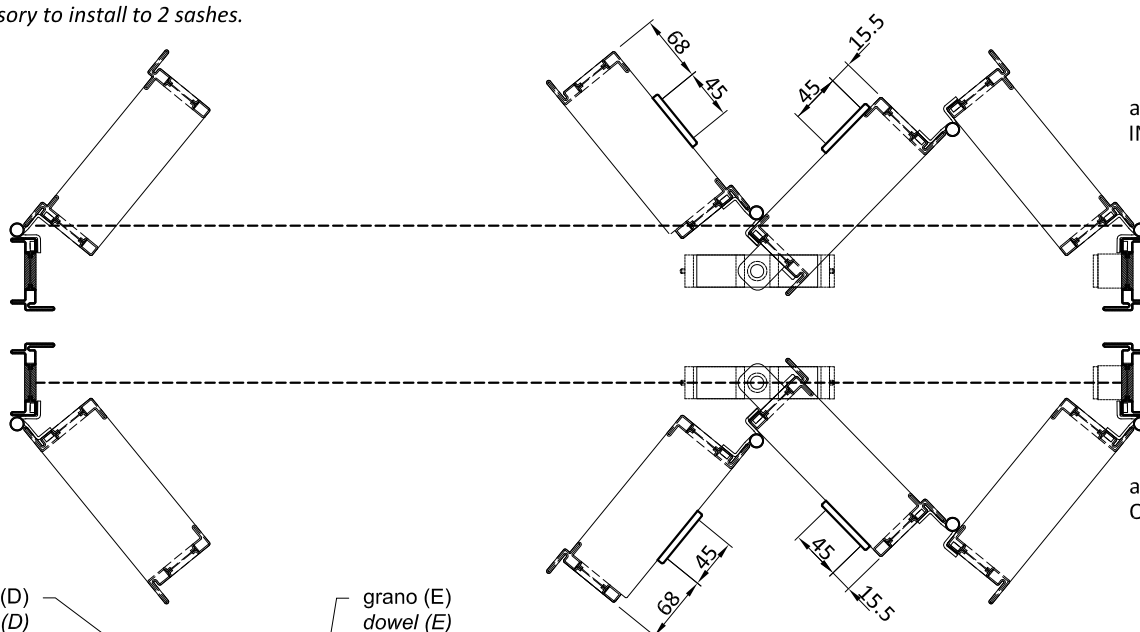
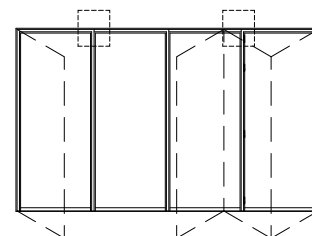
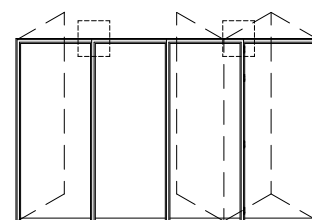


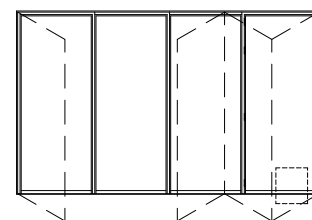
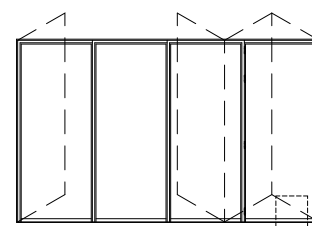
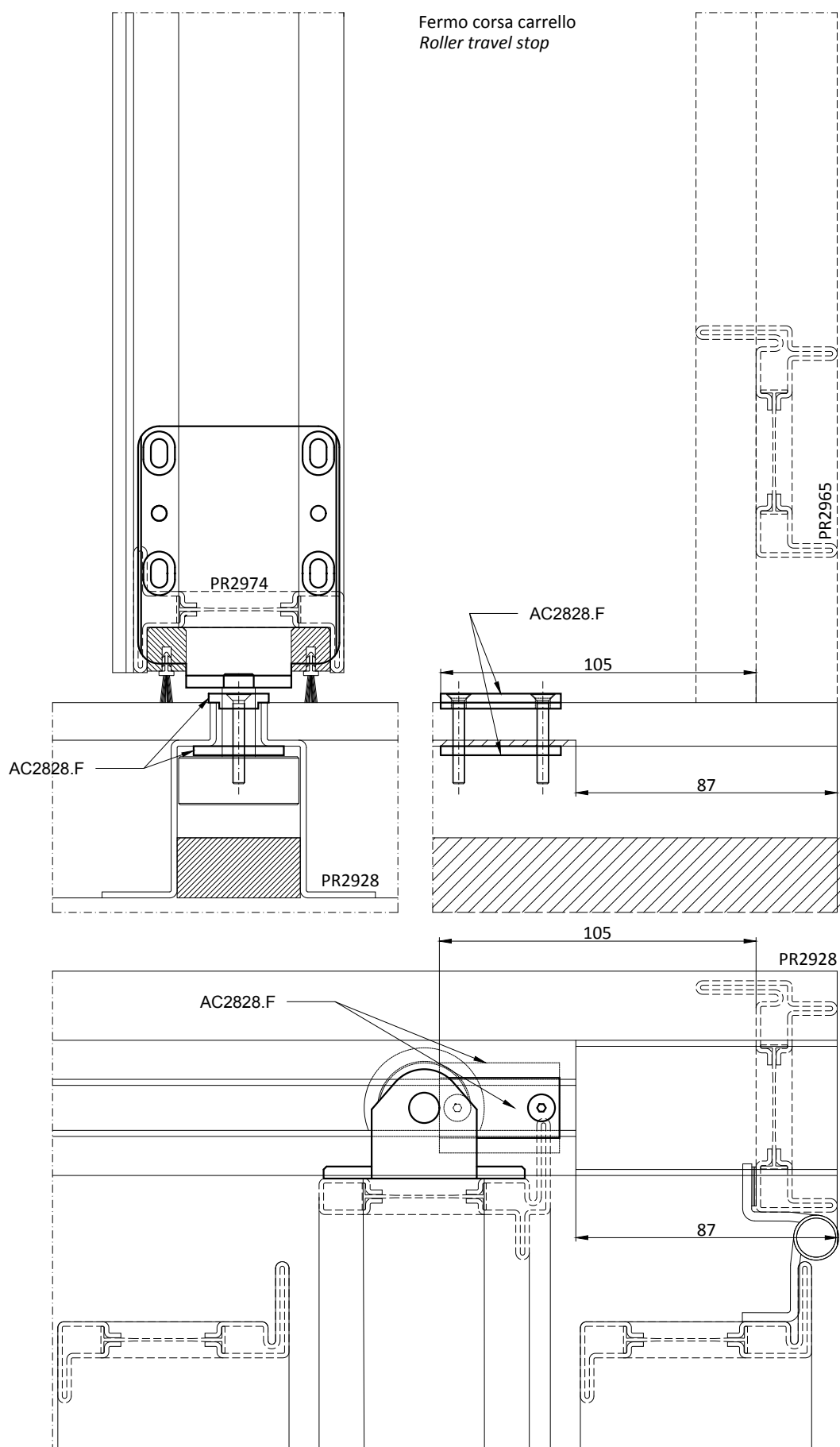
- A - Magnete | Magnet
 B - Adattatore plastico | Plastic case
 C - Vite TPS M4x10 mm | Screw TPS M4x10 mm
 D - Copertura porta magnete | Magnet cover
 E - Grano A2 M4x6 mm | Dowel A2 M4x6

Inserire il magnete (A) all'adattatore plastico (B) e fissare all'ante tramite le viti 3,9x12,7 (C)
 To put the magnet (A) to the plastic case (B) and to fix to the sash with screw 3,9x12,7 (C)

Posizionare la copertura porta magnete (D) e fissarla all'adattatore plastico (B) tramite il grano M4x6 (E)
 To fit in the magnet cover (D) and to fix it (B) with the dowel M4x6 (E) to the plastic case (B)

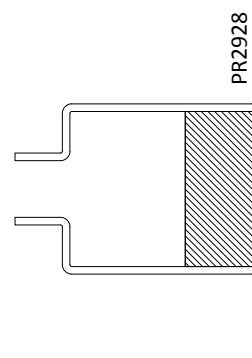
N.b.: accessorio da installare su 2 ante.
 Note: accessory to install to 2 sashes.

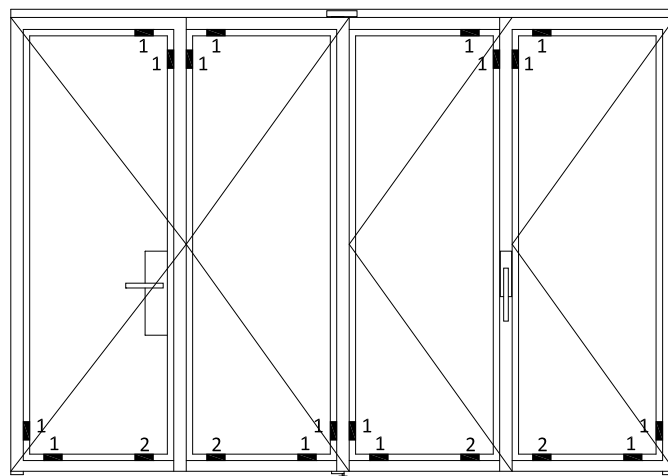
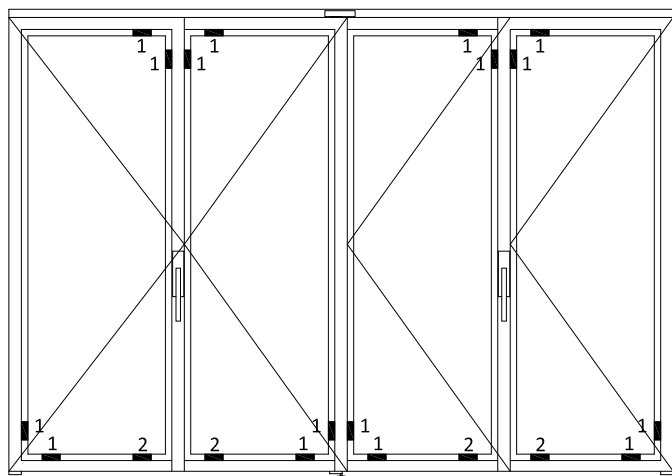




Applicazione valida anche con
profilo zoccolo PR2972 e PR2973

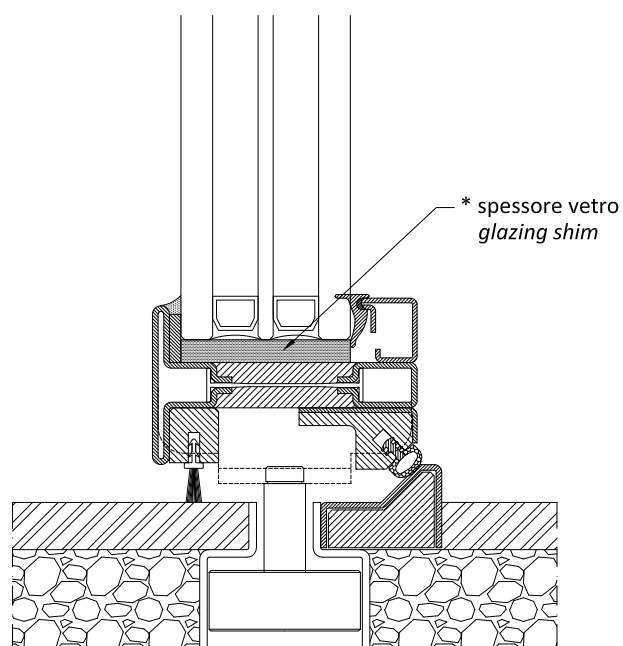
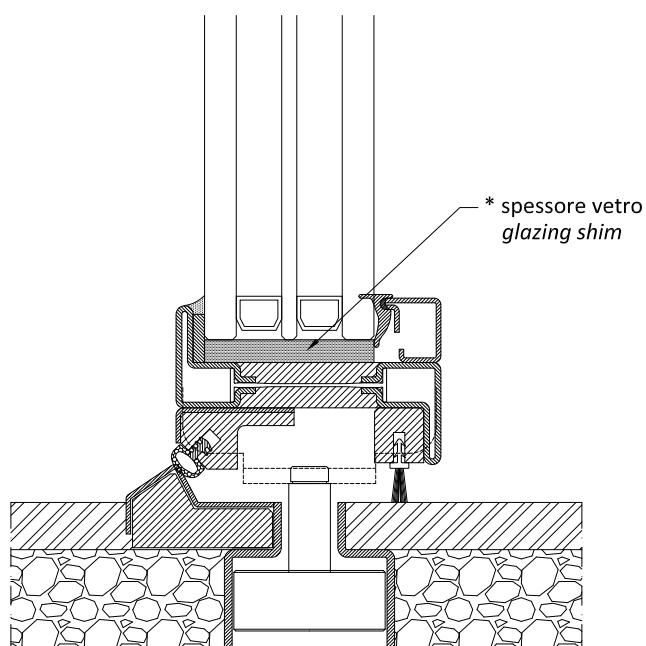
Application valid with PR2972
and PR2973 bottom profile





1) spessore portante | *carry shim*

2) spessore distanziatore | *compensation shim*



Note / Note

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

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

Generalità

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

Tolleranze

OS2 75 L è composto da una serie di profili dalle ridottissime dimensioni e prevede un accoppiamento dei telai esterni con le ante apribili con distanza di 8 mm in verticale e 10 mm in orizzontale. Per garantire il corretto funzionamento degli accessori e delle guarnizioni le lavorazioni devono essere eseguite con particolare attenzione e precisione: si consiglia di mantenere la tolleranza per la dimensione degli elementi apribili compresa tra +0/-1 mm e la tolleranza per il sormonto degli stessi compresa tra +0/+0.5 mm.

Taglio/Lavorazioni

I profili OS2 75 L in acciaio, acciaio inox e corten possono essere tagliati con le normali troncatrici a disco utilizzate per i tubolari in acciaio, mentre per il taglio dei profili in ottone possono anche essere utilizzate troncatrici utilizzate per le serie di alluminio. Vista la loro particolare dimensione e forma si consiglia di utilizzare le ganasce di taglio previste dal sistema (AT2900) per assicurare una perfetta stabilità dei profili durante il taglio. La verifica del taglio sia per la sezione inclinata a 45° che per la sezione verticale a 90° dovrebbe garantire una tolleranza compresa tra -1°/+1°. Tutte le lavorazioni devono essere eseguite con il rispetto della seguente nota tecnica ed eventuali modifiche concordate con l'ufficio tecnico Secco Sistemi.

Saldatura

I profili OS2 75 L possono essere saldati con i tradizionali sistemi di saldatura (MIG/MAG, TIG), con un idoneo sistema di lubrificazione/refrigerazione e utilizzando le istruzioni presenti nella presente nota tecnica ed evitando di saldare in prossimità della giunzione a taglio termico. L'eventuale riscaldamento del poliuretano libera sostanze gassose a base di aldeidi e CO: per tale ragione si consiglia di saldare con gli appositi DPI previsti e in zone con sufficiente areazione e in presenza di sistema per l'evacuazione dei fumi. I profili in corten devono essere saldati con apposito filo in corten mentre per i profili in ottone si può utilizzare un filo CuSi3. Si raccomanda di saldare in profondità e senza lasciare fori e porosità le aree in contatto, di lisciare e pulire adeguatamente la superficie saldata per garantire una corretta resistenza strutturale all'angolo e permettere una successiva verniciatura senza imperfezioni estetiche visibili (pori e ondulazioni).

Verniciatura/Brunitura

I profili OS2 75 L 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 (SA1033). I telai prima della verniciatura o della brunitura devono essere forati come da istruzioni presenti in questa nota tecnica per permettere la fuoriuscita dei liquidi utilizzati durante il pretrattamento delle superfici. All'uscita del forno di polimerizzazione della polvere i telai vanno rimossi accuratamente e adagiati in posizione piana sino al loro completo raffreddamento. Si consiglia di seguire il ciclo di pretrattamenti e verniciatura presente nella documentazione Secco Sistemi.

Vetrazione

Il sistema di fissaggio del vetro prevede l'utilizzo di fermavetri agganciati all'interno tramite clips o boccole interne e mandati in pressione con l'incastro dell'apposita guarnizione e all'esterno, l'utilizzo di siliconatura o inserimento della guarnizione adesiva GE2606 (il sistema con sigillatura è da utilizzarsi quando le ante superano 1 m² di superficie per garantire una maggior rigidità del pannello vetrato). Per il corretto funzionamento del sistema si suggerisce di verificare la perfetta compressione delle guarnizioni interne del fermavetro e la mancanza di imperfezioni lungo il perimetro della siliconatura esterna.

Installazione

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

OS2 75 L is made of a series of very thin profiles. It provides coupling of external frames with opening leaves with a distance of 8 mm in vertical side and 10 mm in horizontal side. To ensure the correct use of hardware and gaskets the processing must be performed with great care and precision. It is advised to keep the tolerance between +0/-1 mm for opening elements and between +0/+0.5 mm for their overlapping area.

Cut / Processing

OS2 75 L profiles in steel, stainless steel and corten can be cut with normal saws, like the ones used for steel pipes. OS2 75 L profiles in brass can be cut with saws used for aluminium. Given their dimension and size, it is recommended to use the cutting jaws provided with the system (AT2900) to ensure perfect stability during the cutting procedure. In order to verify the correctness of the cut, the tolerance of both the 45° and the 90° sections must be between -1°/+1°. Processing must be performed in line with this technical note and any variation agreed with Secco Sistemi's Technical Department.

Welding

OS2 75 L profiles can be welded with the traditional systems (MIG/MAG, TIG), with an appropriate lubricating/cooling system and according to the instructions as per this technical note. Avoid welding near the thermal break joint. Heating any polyurethane items releases gaseous substances containing aldehydes and CO. For this reason it is recommended to weld with the special DPLs provided and in areas with sufficient ventilation and with fumes disposing systems. The corten profiles must be welded with special corten wire, while for profiles in brass a CuSi3 wire can be used. It is recommended to weld in depth, to avoid leaving any holes or porosity on the surfaces and to smooth and clean the welded surface thoroughly. This is to guarantee a proper structural resistance at the corner and to allow for a later painting without any visible imperfections (pores and ripples).

The proper set up must guarantee that the performance in the CE marking and verified in the lab will remain constant. It is advised

Painting/Burnishing

OS2 75 L 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 (SA1033). Holes must be drilled (as per instructions) in the frames before painting or burnishing in order to allow drainage of any liquid used as a pre-treatment of the surfaces. Once out of the oven, the frames must be accurately removed and laid in a horizontal position until complete cooling.

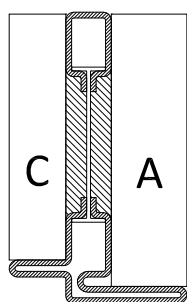
It is advised to follow pre-treatment and painting cycles as outlined in Secco Sistemi documentation.

Glass application

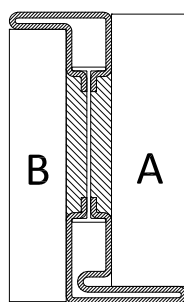
Glass needs to be secured internally and externally. Internally, glass beads must be used together with clips or bushings and then secured by pressure with the appropriate gasket. Externally, glass must be secured by applying silicone or adhesive gasket GE2606 (the latter is recommended when leaves dimensions are bigger than 1 square metre in order to guarantee a higher rigidity of the glass). In order to ensure the correct behaviour of the system, it is recommended to verify the proper pressurization of the internal glass bead gaskets and that the external silicone perimeter is completely free of imperfections.

Set up

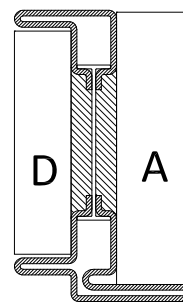
The proper set up must guarantee that the performance in the CE marking and verified in the lab will remain constant. It is advised to design a correct series of set ups with reference to the existing type of subframe/brickwork and to the dimensions of the elements to set up. Once the set up is finished, you should verify the proper behaviour of the window/door (easiness of opening/closing, stability of the open leaf, etc.), the correctness of joints and overlapping areas between opening leaves and fixed frames, the proper positioning of gaskets and seals, the drainage of frames with weep system and the absence of any aesthetic defects on the frame and glass surfaces.



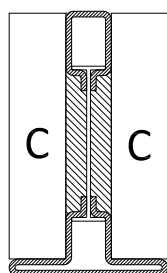
PR2962



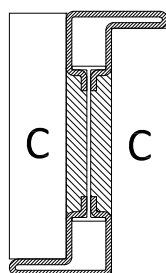
PR2963



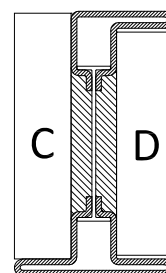
PR2965



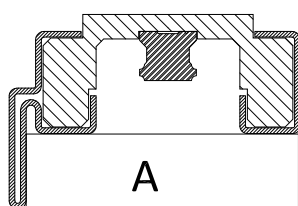
PR2972



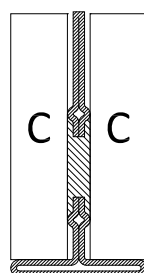
PR2973



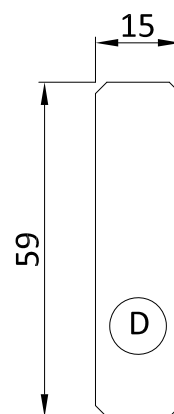
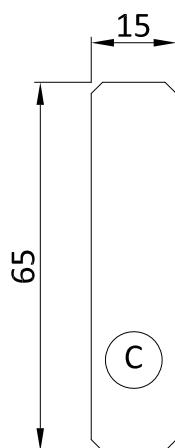
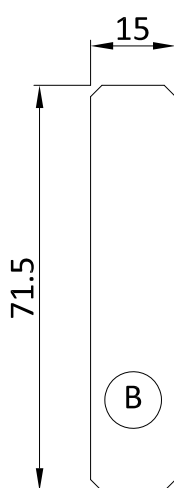
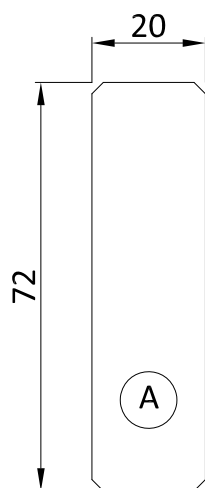
PR2974

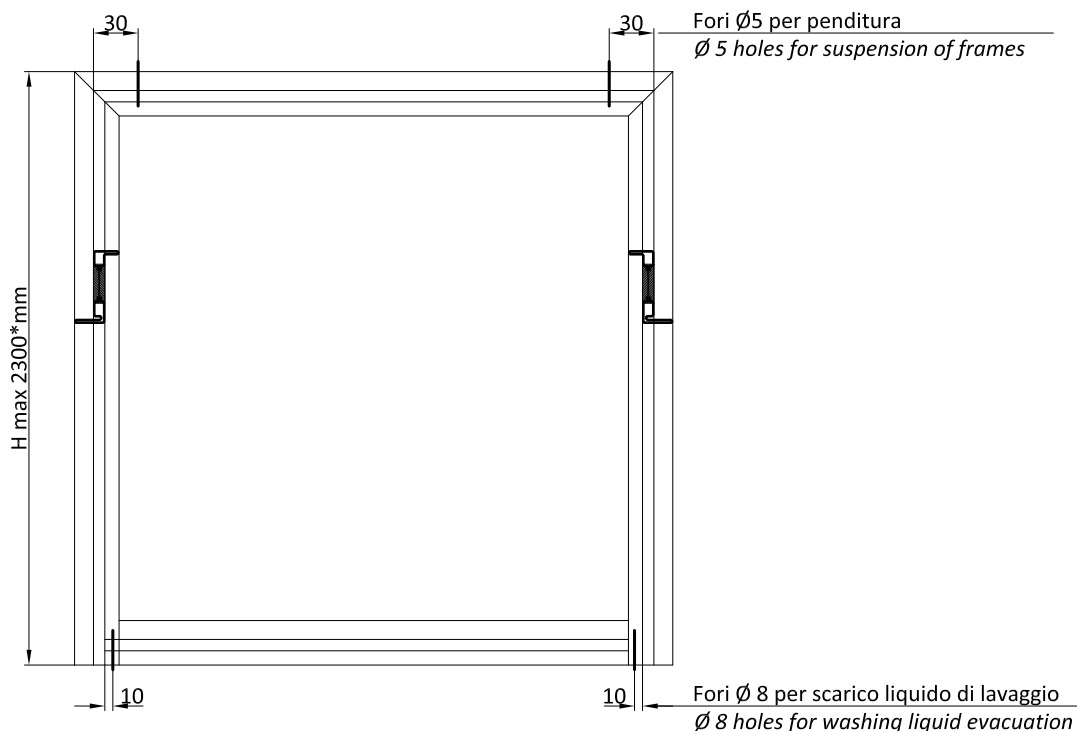


PR2927



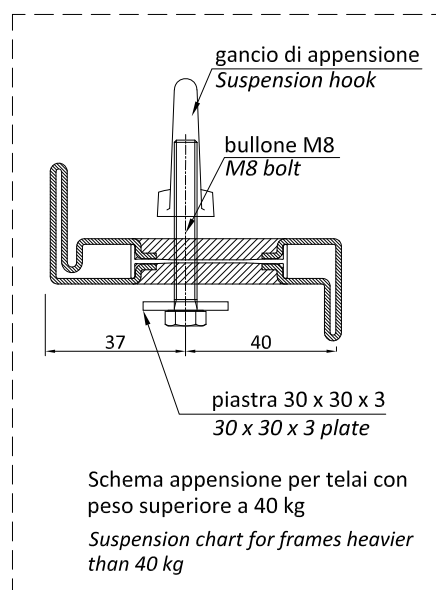
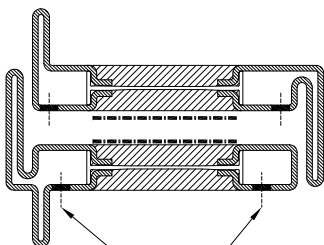
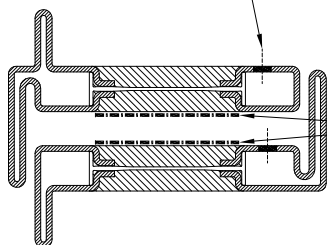
PR2964





Fori $\varnothing 5$ per pendinatura
telai con peso inferiore
a 40 kg

$\varnothing 5$ holes for suspension
of frames not heavier
than 40 kg



SOLO PER BRUNITURA

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

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

ONLY FOR BURNISHING

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

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

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

Troncatricecaratteristiche minime della macchina

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

caratteristiche della lama

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

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

Pantografocaratteristiche minime della macchina

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

caratteristiche minime delle frese

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

Foraturemontaggio componenti di chiusura e movimentazione sui profilati in acciaio inox

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

fresatura di cave e asole sui profili inox

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

CutterMinimum requirements for the use of the machine

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

Blade specifications

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

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

PhantographMinimum requirements for the use of the machine

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

Minimum requirements for the use of a milling machine

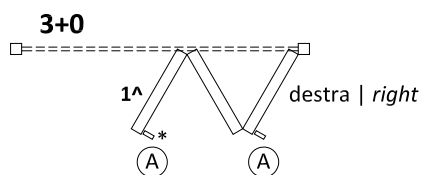
- Material: HSS (please verify availability of longer lasting material on the market);
- Use a 4-tooth milling machine;
- Use a milling machine with a 5-mm diameter for groove processing.

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

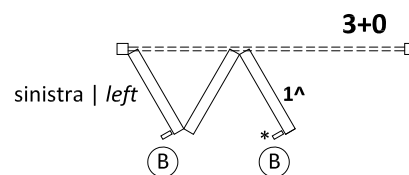
- Use a HSS drill. The diameter of the drill is indicated in the technical note;
- Thread the hole with self-threading zinc-plated screws with the same diameter as the stainless steel screw provided with the kit;
- Position and secure the item with the stainless steel screws provided.

Milling slots and loops in the profiles

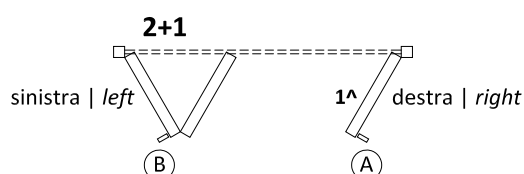
- Use machines designed for steel processing (pantographs or milling machines);
- Max rpm setting (3000 rpm);
- Use milling machines with a diameter no bigger than 8 mm and with 4 HSS steel blades;
- Exceed with lubrication, mainly on the machine;
- Processed slowly until the milling is as clean as possible;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

apertura INTERNA
INWARD opening

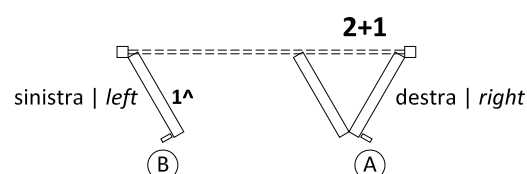
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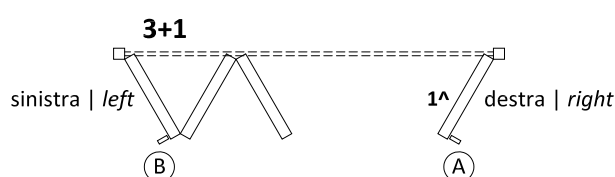
	Codice Code	nr.	Descrizione Description
A	AC 2624.S	2	Kit cremonese Cremona bolt



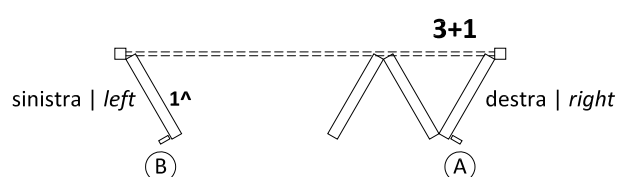
	Codice Code	nr.	Descrizione Description
A	AC 2624.D	1	Kit cremonese Cremona bolt
B	AC 2624.S	1	Kit cremonese Cremona bolt



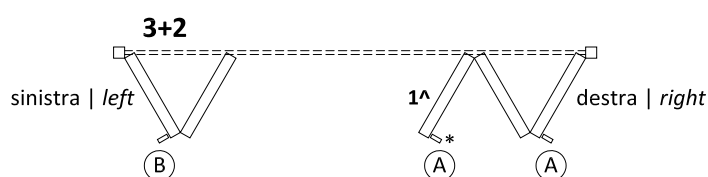
	Codice Code	nr.	Descrizione Description
A	AC 2624.D	1	Kit cremonese Cremona bolt
B	AC 2624.S	1	Kit cremonese Cremona bolt



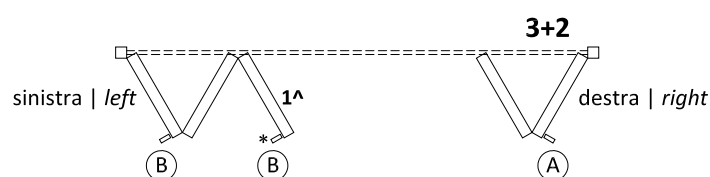
	Codice Code	nr.	Descrizione Description
A	AC 2624.D	1	Kit cremonese Cremona bolt
B	AC 2624.S	1	Kit cremonese Cremona bolt



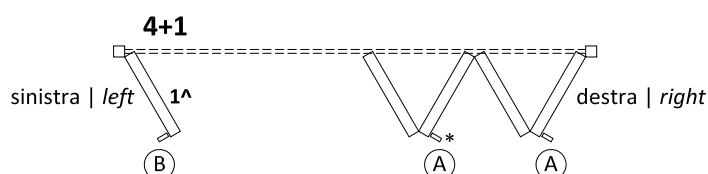
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A	AC 2624.D	1	Kit cremonese Cremona bolt
B	AC 2624.S	1	Kit cremonese Cremona bolt



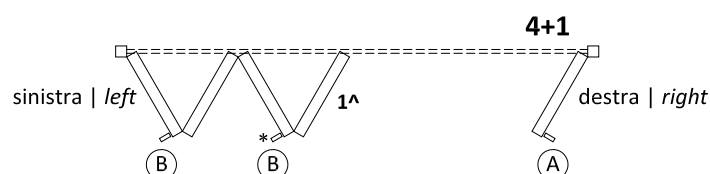
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A	AC 2624.D	2	Kit cremonese Cremona bolt
B	AC 2624.S	1	Kit cremonese Cremona bolt



	Codice Code	nr.	Descrizione Description
A	AC 2624.D	1	Kit cremonese Cremona bolt
B	AC 2624.S	2	Kit cremonese Cremona bolt

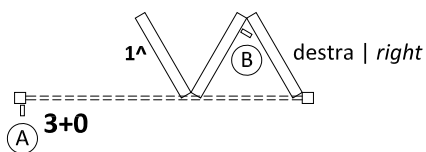


	Codice Code	nr.	Descrizione Description
A	AC 2624.D	2	Kit cremonese Cremona bolt
B	AC 2624.S	1	Kit cremonese Cremona bolt

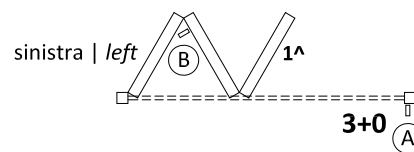


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A	AC 2624.D	1	Kit cremonese Cremona bolt
B	AC 2624.S	2	Kit cremonese Cremona bolt

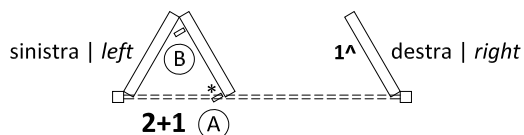
* si rende necessario l'utilizzo della maniglia ACV751 | is necessary to use the handle ACV751

apertura ESTERNA
OUTWARD opening

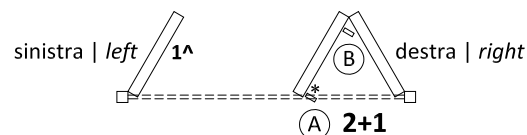
	Codice Code	nr.	Descrizione Description
A	AC 2683.D	1	Kit cremonese Cremonese bolt
B	AC 2684L.D	1	Kit cremonese Cremonese bolt



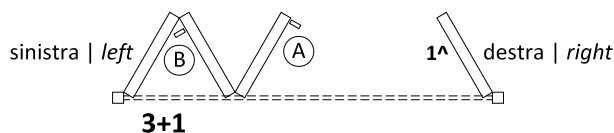
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A	AC 2683.S	1	Kit cremonese Cremonese bolt
B	AC 2684L.S	1	Kit cremonese Cremonese bolt



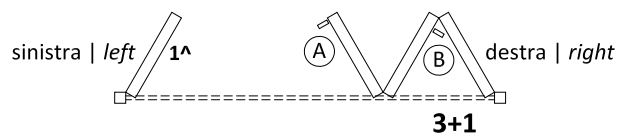
	Codice Code	nr.	Descrizione Description
A	AC 2683.S	1	Kit cremonese Cremonese bolt
B	AC 2684L.S	1	Kit cremonese Cremonese bolt



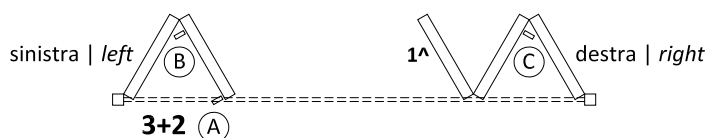
	Codice Code	nr.	Descrizione Description
A	AC 2683.D	1	Kit cremonese Cremonese bolt
B	AC 2684L.D	1	Kit cremonese Cremonese bolt



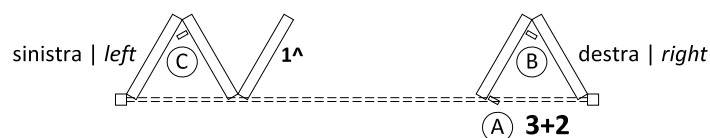
	Codice Code	nr.	Descrizione Description
A	AC 2683.S	1	Kit cremonese Cremonese bolt
B	AC 2684L.S	1	Kit cremonese Cremonese bolt



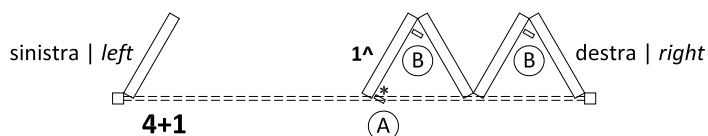
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A	AC 2683.D	1	Kit cremonese Cremonese bolt
B	AC 2684L.D	1	Kit cremonese Cremonese bolt



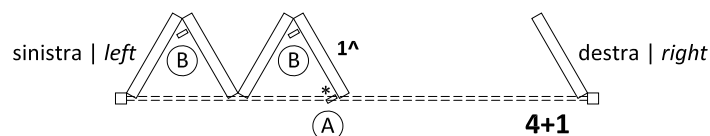
	Codice Code	nr.	Descrizione Description
A	AC 2683.S	1	Kit cremonese Cremonese bolt
B	AC 2684L.S	1	Kit cremonese Cremonese bolt
C	AC 2684L.D	1	Kit cremonese Cremonese bolt



	Codice Code	nr.	Descrizione Description
A	AC 2683.D	1	Kit cremonese Cremonese bolt
B	AC 2684L.D	1	Kit cremonese Cremonese bolt
C	AC 2684L.S	1	Kit cremonese Cremonese bolt



	Codice Code	nr.	Descrizione Description
A	AC 2683.D	1	Kit cremonese Cremonese bolt
B	AC 2684L.D	2	Kit cremonese Cremonese bolt



	Codice Code	nr.	Descrizione Description
A	AC 2683.S	1	Kit cremonese Cremonese bolt
B	AC 2684L.S	2	Kit cremonese Cremonese bolt

* si rende necessario l'utilizzo della maniglia ACV751 | is necessary to use the handle ACV751

NOTE il kit AC2684L.D-S richiede la maniglia ACV761 | kit AC2684L.D-S requires handle ACV761

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

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

2. Taglio barre e controllo barre / *Cut and Control of profiles*

- Misura lunghezza / *Length measurement* ± 0.5 mm
- Verifica 45° / *45° Control* $\pm 1^\circ$
- Verifica 90° / *90° Control* $\pm 1^\circ$

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

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

Caratteristiche fisiche

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

Norme di riferimento

EN 10088-2; EU 114

Trattamenti superficiali

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

ACCIAIO COR-TEN**Materiale**

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

Caratteristiche fisiche

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

Norme di riferimento

EN 10149

Trattamenti superficiali

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

ACCIAIO ZINCATO VERNICIATO**Materiale**

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

Caratteristiche fisiche

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

Norme di riferimento

UNI EN 10142/3/7; EURONORM 143

Trattamenti superficiali per la verniciatura

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

LEGA DI RAME OT67**Materiale**

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

Caratteristiche fisiche

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

Norme di riferimento

EN 1652:1999

Trattamenti superficiali

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

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

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

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

Physical features

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

Norms of reference

EN 10088-2; EU 114

Surface treatment

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

CORTEN STEEL**Materials**

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

Physical features

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

Norms of reference

EN 10149

Surface treatment

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

GALVANIZED AND PAINTED STEEL**Materials**

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

Physical features

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

Norms of reference

UNI EN 10142/3/7; EURONORM 143

Pre-painted surface treatment

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

COPPER ALLOY OT67**Materials**

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

Physical features

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

Norms of reference

EN 1652:1999

Surface treatment

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

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

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