



INFINIUM
SLIDING DOOR
SYSTEM

TECHNICAL MANUAL

MANUAL REVISION

This manual is issue controlled, please check the index below for the latest revisions.
Any updates will be sent out via mail shot and published on the web site.

REVISION	DESCRIPTION	PAGE
30.01.2017	First Issue	Complete manual
26.01.2018	Second Issue - Phase 2 profiles and hardware	Complete manual

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SECTION 1 SPECIFICATION

GENERAL REMARKS

Dimensions and thickness of aluminium profiles shown in this manual are theoretical and may vary according to tolerance provided for in EN 12020-2 standards.

Cutting lists shown in this manual do not take into account these possible variations.

We therefore recommend carefully checking aluminum profile dimensions, as well as, the cutting accuracy of all machinery.

The system described in this manual has been designed and tested as a whole. The use of AluK brand is permitted only when original AluK components are used (sections, accessories and gaskets) and only when the technical specifications given in this manual are complied with.

In the event that any component of the system is not an original AluK component, the use of the AluK brand is not authorized.

The product shall be used in accordance with the specifications, regulations and laws in force in the country where the product itself is used. AluK waives all responsibility resulting from non-compliance with the above listed instructions.

Any details provided in this manual representing frames back to the structure are merely shown as an indication to assist designers and manufacturers.

TERMS & DEFINITIONS

In-Line sliding	Door which slides horizontally along a rail
Monorail	Frame profile with a single rail
Duo/Dual Rail	Frame profile with two rails
Tri Rail	Frame profile with three rails
Sash	The frame in which the glass is set
Cleats	Angle used for joining corner profiles together
Clear opening	Dimension of clear space when the door is opened

» TECHNICAL DESCRIPTION

TECHNICAL DESCRIPTION

The INFINIUM system consists of a range of thermally broken profiles and accessories incorporating sliding hardware designed to meet current building regulations with an improved thermal performance.

SECTIONS

The extruded aluminium profiles are made from homogenised billets, with limited composition tolerances, suitable for anodising or painting.

All extruded aluminium sections are supplied at physical state 6060 alloy T6.

Dimension tolerances are in compliance with EN 12020-2.

GASKETS

Gaskets are made of EPDM (ethylene + propylene elastomer).

ACCESSORIES

Patented AluK accessories of the highest quality are expressly designed by AluK to offer the utmost reliability and safety.

GLAZING

The system allows the application of glass or panels with a thickness of 38mm.

The choice of glazing is purely the responsibility of the fabricator/installer through compliance with legislation and glass manufactures recommendations.

SYSTEM DESIGN TOLERANCES

To ensure all products are manufactured in accordance with the fabrication manual, please follow guidelines laid out below:

- a. Manufacturing tolerances shall be within +/- 1.5 (cutting tolerance of +/- 0.5mm and assembly tolerance of +/-1.0mm).
- b. Installation Tolerance to be +/-2mm i.e. the difference between the diagonals of the assembled frame shall be not greater than above.

» SURFACE TREATMENTS

ANODISING

The anodising process starts with a mechanical pre-treatment consisting in a scotch-brite brushing of raw profiles. Afterwards, all the other electro-chemical treatments and relevant controls are performed in compliance with Technical Directives of European quality mark QUALANOD.

The anodic oxide layer thickness is checked in compliance with international standard EN ISO 2360 (eddy current method), while the fixing quality of the anodic oxide layer is referred to

The minimum compulsory oxide layer thickness is 15 microns for external architectural use, can be increased to major classes (20 or 25 microns), according to customer's requirements and/or national laws in the place of destination. Possible anodising treatments are: natural silver, light bronze, medium bronze, medium bronze electro-coloured, dark bronze electro-coloured, black electro-coloured.

PAINTING

Painting is done with powders and colour can be chosen from the RAL range of colours, from our colour quire and/or based on customer's requirement.

Before painting, section surface is pre-treated with a "in-tunnel" treatment, i.e.:

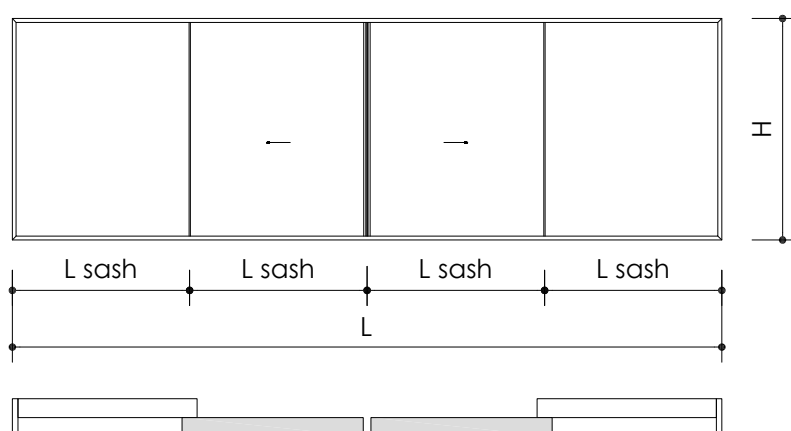
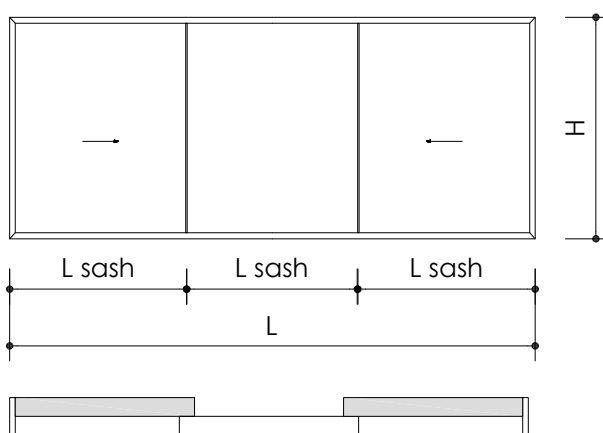
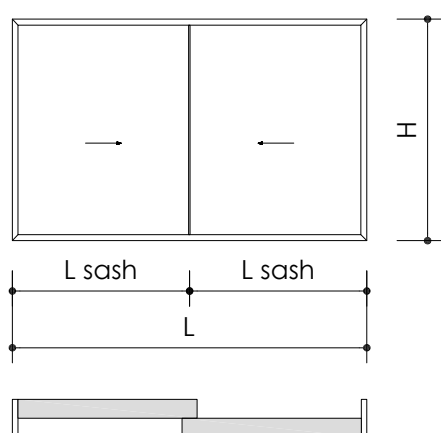
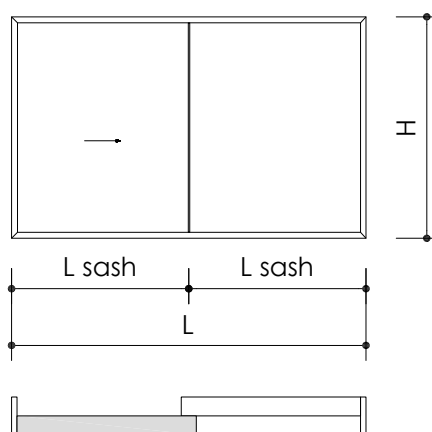
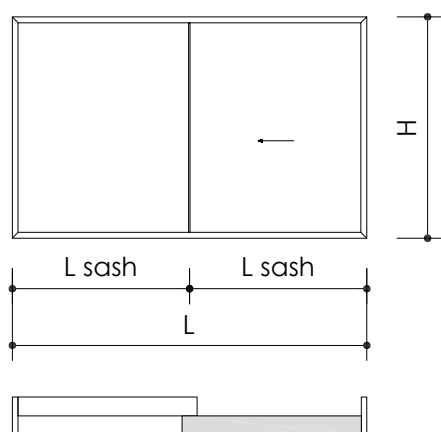
- degreasing
- washing
- etching
- washing
- chromium plating
- double washing in demineralized water
- furnace drying process

After that, special powders are applied by spray painting with electrostatic alternate spray guns, into an automatic booth, and then dried into furnace for paint polymerization.

The minimum compulsory paint layer thickness shall be at least 60 micron for external architectural use.

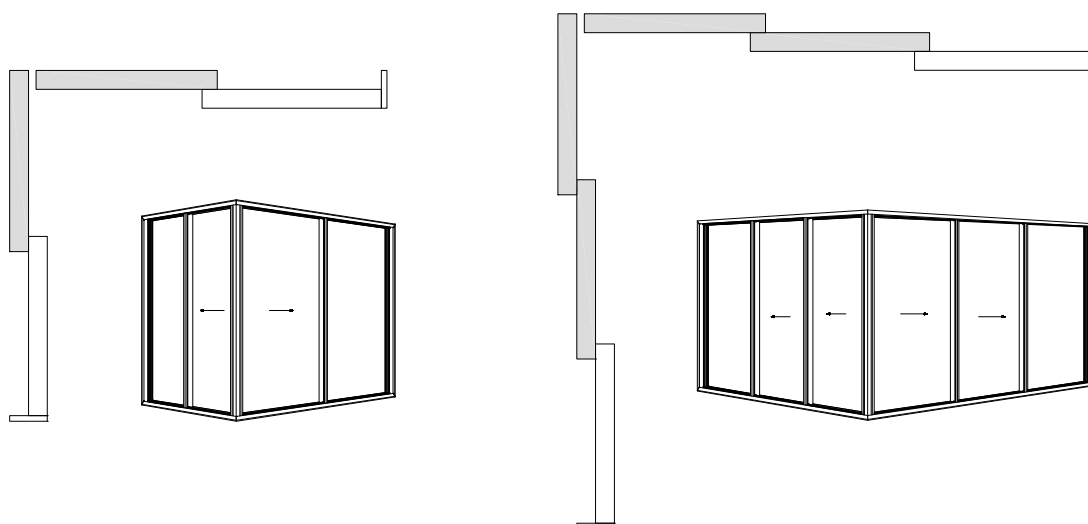
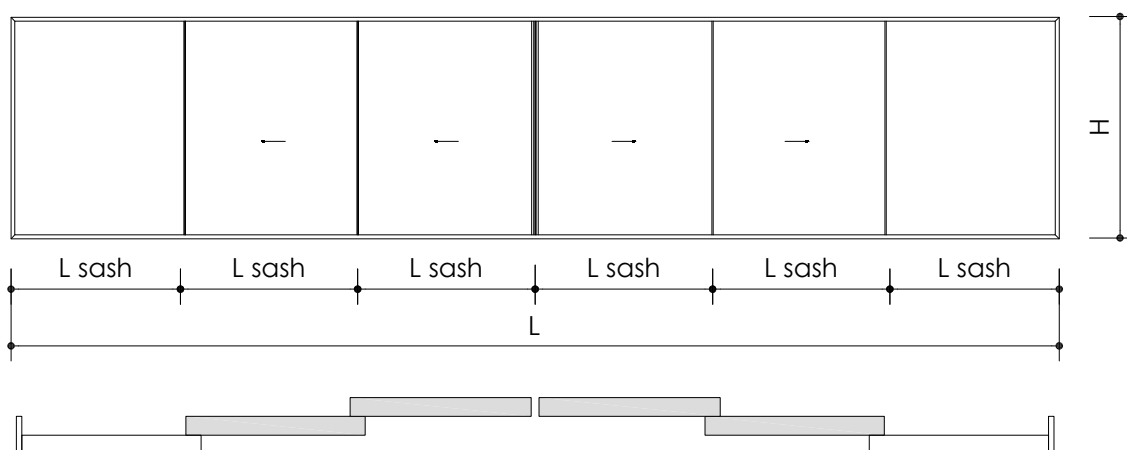
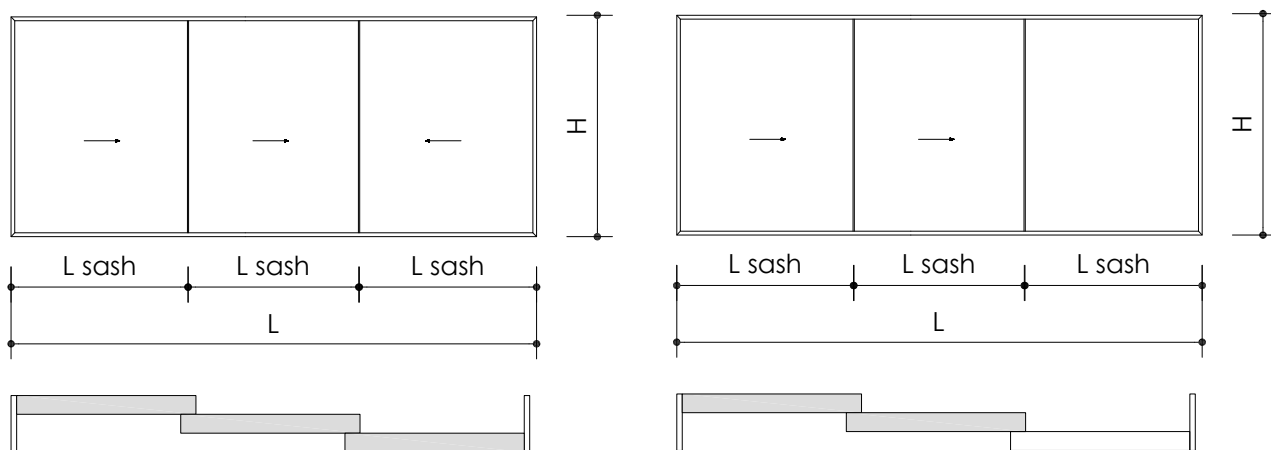
► CONFIGURATIONS

- OX / XO / XX / XOX - 2 Track outer frame (U00020 & U00021)
- OXXO - 2 Panel meeting stile (U00500 & N00901)



► CONFIGURATIONS

- Triple Track outer frame (U00000, U00001, U00022 & U00023)
- 90 Degree Corner (U00500 & U00600)



➤ CLEAR OPENING SIZES

Clear opening sizes can be calculated using the following formulae:

$$\text{CLEAR OPENING} = L/(\text{No. Panels}) - (67 + 150) \text{ Or } (67 + 155)$$

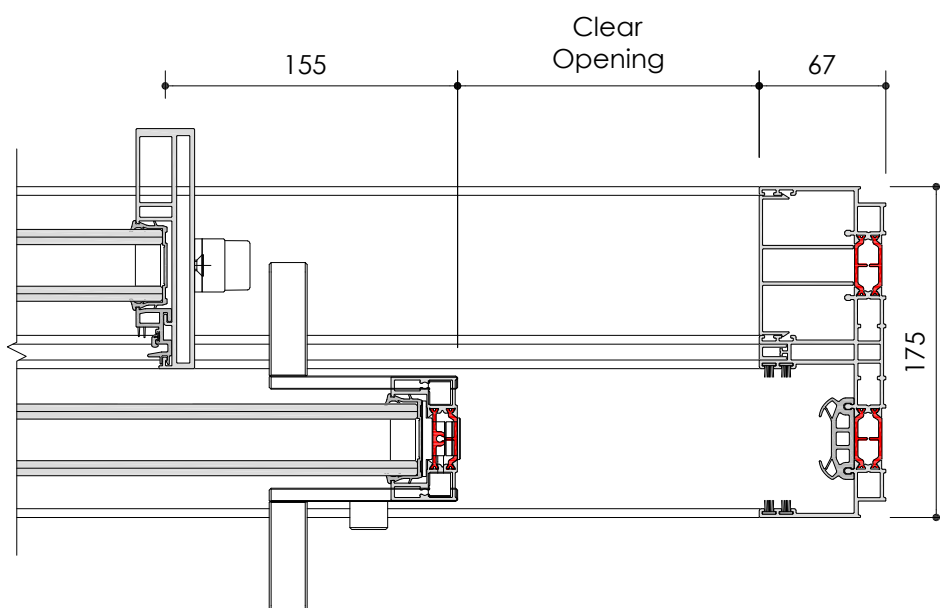
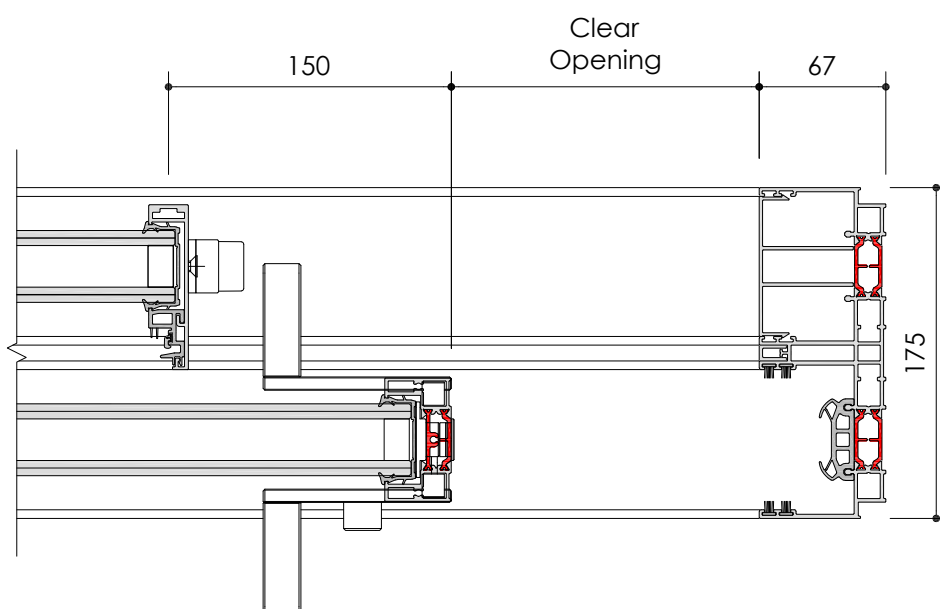
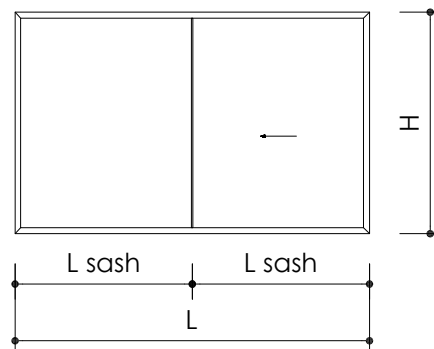
E.G.

Panel Length = 4000mm

No. Of Panels = 2

Therefore:

$$\begin{aligned} \text{CLEAR OPENING} &= 4000/2 - (67 + 150) \\ &= 2000 - 217 \\ &= 1783 \text{ mm} \end{aligned}$$



➤ CLEAR OPENING SIZES CONT.

Clear opening sizes can be calculated using the following formulae:

$$\text{CLEAR OPENING} = L/(\text{No. Panels}) - (67 + 78) \text{ Or } (67 + 83)$$

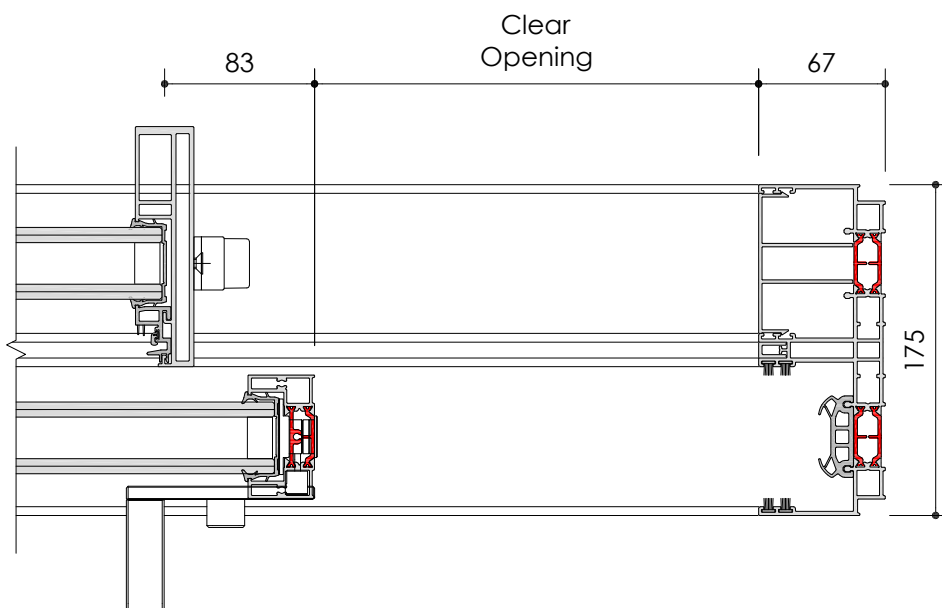
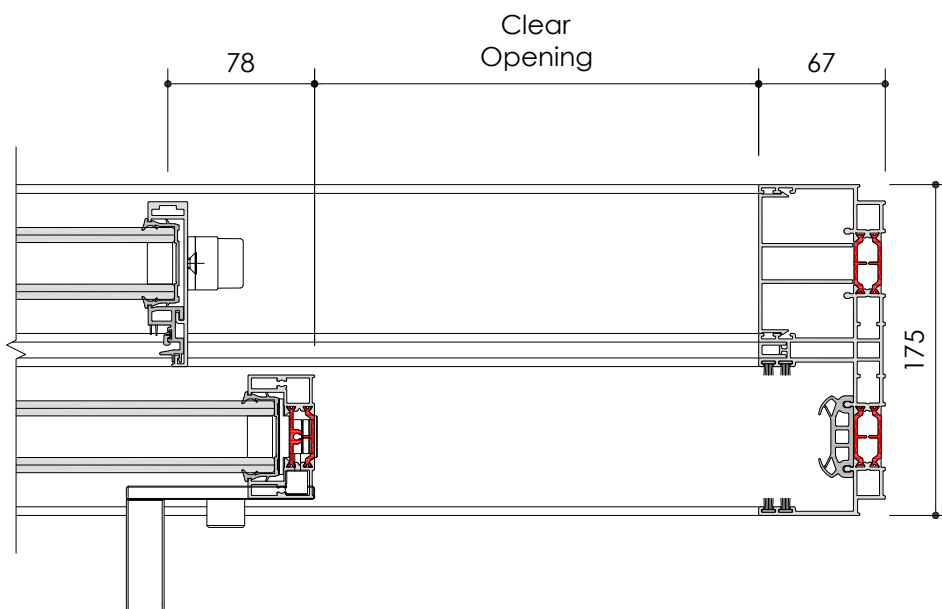
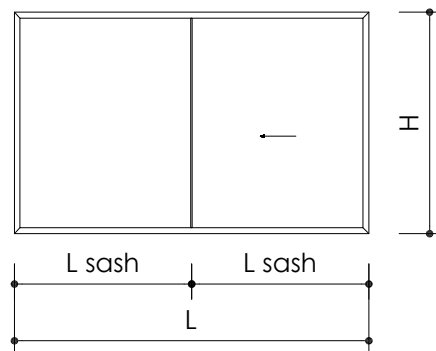
E.G.

Panel Length = 4000mm

No. Of Panels = 2

Therefore:

$$\begin{aligned} \text{CLEAR OPENING} &= 4000/2 - (67 + 78) \\ &= 2000 - 145 \\ &= 1855 \text{ mm} \end{aligned}$$

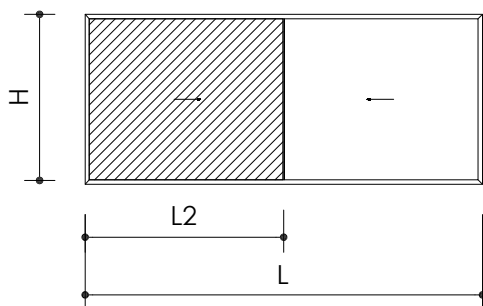


➤ SIZE LIMITS (2 ROLLERS)

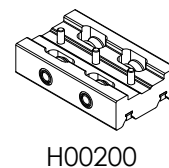
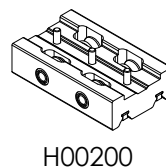
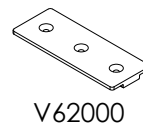
MAXIMUM SIZES

Maximum glass load of 300 Kg's per panel, based upon parameters below:

- Glass Unit: 44,2/20/44,2 (Est. 40 kg/m²) Or 55.2/18/55.2 (Est. 50 kg/m²)
- Max. panel area for 44,2/20/44,2 = (H x L2) = 7.5m²
- Max. panel area for 55.2/18/55.2 = (H x L2) = 6.0m² 
- Max. panel area for 8/16/4/16/8 = (H x L2) = 6.0m²

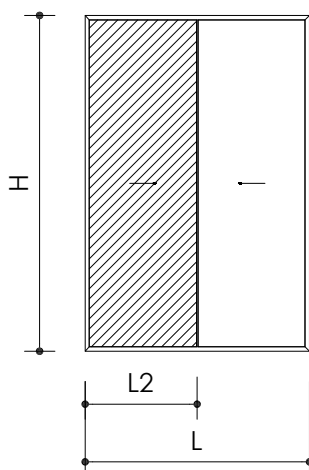
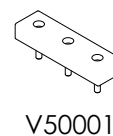
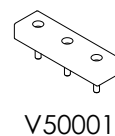
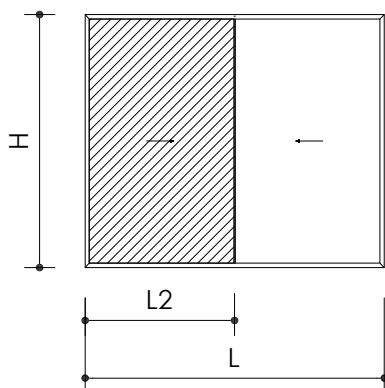


Max. Load per Panel
2 Rollers Per Sash = 300 Kg



OR

2 - 4 Fixed Blocks Per Fixed Sash = Max.
Weight < 600Kg



IMPORTANT:

Panel height can not exceed:

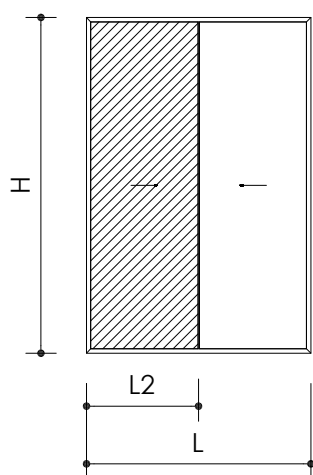
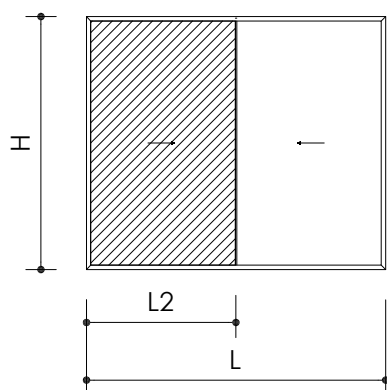
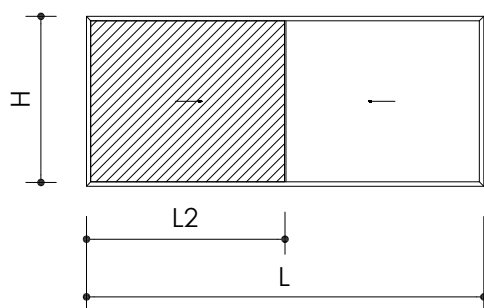
$$H/L2 < 2.5$$

➤ SIZE LIMITS (4 ROLLERS)

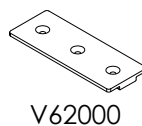
MAXIMUM SIZES

Maximum glass load of 400 Kg's per panel, based upon parameters below:

- Glass Unit: 44,2/20/44,2 (Est. 40 kg/m²) Or 55.2/18/55.2 (Est. 50 kg/m²)
- Max. panel area for 44,2/20/44,2 = (H x L2) = 10.0m²
- Max. panel area for 55.2/18/55.2 = (H x L2) = 8.0m² 
- Max. panel area for 8/16/4/16/8 = (H x L2) = 7.95m²



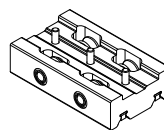
Max. Load per Panel
4 Rollers Per Sash = 400 Kg



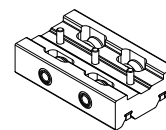
V62000



V62000



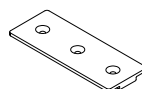
H00200



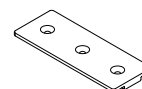
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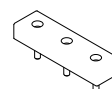
2 - 4 Fixed Blocks Per Fixed Sash = Max.
Weight < 600Kg



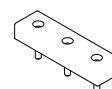
V62000



V62000



V50001



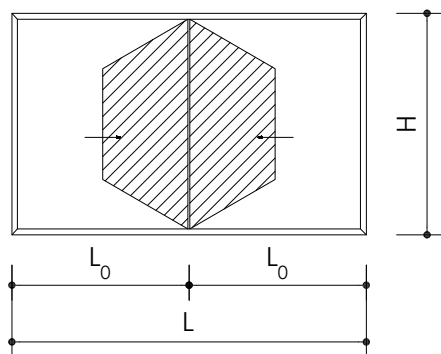
V50001

IMPORTANT:

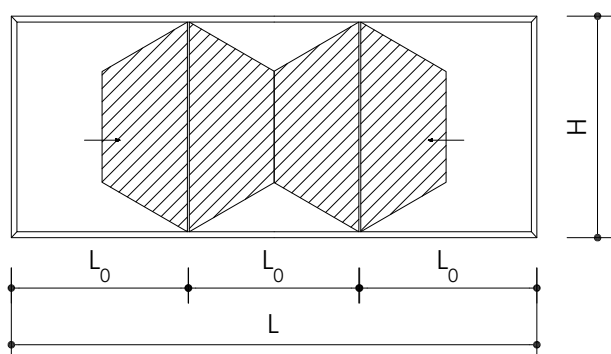
Panel height can not exceed:

$$H/L2 < 2.5$$

WIND LOADING



OX & XX Configurations



XOX Configuration

Description	Value	Unit
L	Door Length	Variable (m)
L ₀	Width sash	L/2 (m)
H	Door Height	Variable (m)
F	Maximum deflection	Calculated (mm)
P	Wind pressure	Variable (Pa)
E	Elasticity module	70.000 (N/mm ²)
I ₀	Minimum inertia	Table (cm ⁴)

Trapezoidal load

$$I_0 = \frac{P \cdot L_0 \cdot H^4 \cdot [5 - 4(L_0/2L)^2]^2}{1920 \cdot E \cdot F}$$

Triangular load

$$I_0 = \frac{P \cdot H^5}{120 \cdot E \cdot F}$$

For $L_0 \geq H$
the load becomes
triangular

The following tables determine the minimum inertia necessary for the interlock profiles based upon the wind load (from 400 Pa to 2000 Pa) and the size of the door.

The tables are representative for uses with standard size sash's and frames.

The inertia of each section are shown in the "Key" below each table and are colored to show the required combination for each of the table values shown.

All calculations should be relayed back to the appointed Structural Engineer for review / sign off in line with site specific requirements and conditions.

KEY

 lxx 27.44cm ⁴ N00120	 lxx 77.50cm ⁴ N00121	 lxx 151.17cm ⁴ N00124	 lxx 276.17cm ⁴ N00124 (Steel Reinforced 5 x 100)
 lxx 23.39cm ⁴ N00122	 lxx 96.95cm ⁴ N00123	 lxx 184.97cm ⁴ N00125	 lxx 309.97cm ⁴ N00125 (Steel Reinforced 5 x 100)

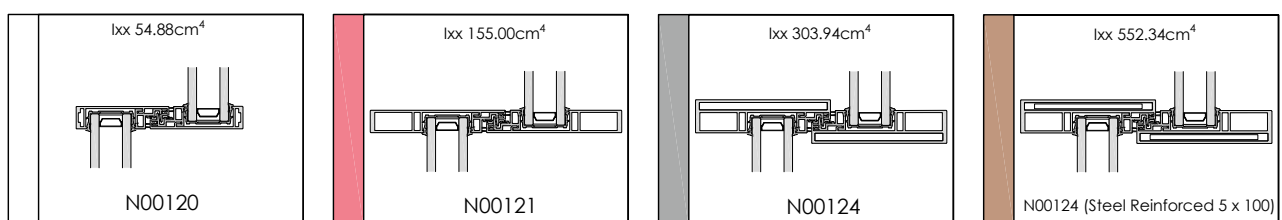
WIND LOADING CHART (400 Pa)

Deflection H/150		L sash																	
H		1.50	1.60	1.70	1.80	1.90	2.00	2.10	2.20	2.30	2.40	2.50	2.60	2.70	2.80	2.90	3.00	3.10	3.20
2.00		10.5	10.9	11.1	11.3	11.4	11.4	11.4	11.4	11.4	11.4	11.4	11.4	11.4	11.4	11.4	11.4	11.4	11.4
2.10		12.5	12.9	13.3	13.5	13.7	13.9	13.9	13.9	13.9	13.9	13.9	13.9	13.9	13.9	13.9	13.9	13.9	13.9
2.20		14.7	15.2	15.7	16.0	16.3	16.6	16.7	16.7	16.7	16.7	16.7	16.7	16.7	16.7	16.7	16.7	16.7	16.7
2.30		17.4	18.1	18.7	19.2	19.7	20.0	20.2	20.4	20.4	20.4	20.4	20.4	20.4	20.4	20.4	20.4	20.4	20.4
2.40		21.0	21.9	22.6	23.3	23.9	24.4	24.8	25.1	25.2	25.3	25.3	25.3	25.3	25.3	25.3	25.3	25.3	25.3
2.50		25.0	26.1	27.1	28.0	28.8	29.5	30.0	30.4	30.8	30.9	31.0	31.0	31.0	31.0	31.0	31.0	31.0	31.0
2.60		29.6	31.0	32.2	33.4	34.4	35.2	36.0	36.6	37.1	37.4	37.6	37.7	37.7	37.7	37.7	37.7	37.7	37.7
2.70		34.8	36.5	38.0	39.4	40.7	41.8	42.8	43.6	44.3	44.9	45.2	45.5	45.6	45.6	45.6	45.6	45.6	45.6
2.80		40.6	42.6	44.5	46.2	47.8	49.2	50.4	51.5	52.5	53.2	53.9	54.3	54.5	54.6	54.6	54.6	54.6	54.6
2.90		47.1	49.5	51.7	53.8	55.7	57.5	59.0	60.4	61.7	62.7	63.6	64.2	64.7	65.0	65.1	65.1	65.1	65.1
3.00		54.4	57.2	59.8	62.3	64.6	66.7	68.6	70.4	72.0	73.3	74.5	75.4	76.2	76.7	77.0	77.1	77.1	77.1
3.10		62.4	65.7	68.8	71.7	74.5	77.0	79.4	81.5	83.4	85.2	86.7	87.9	89.0	89.8	90.4	90.8	90.9	90.9
3.20		71.3	75.1	78.7	82.1	85.4	88.4	91.2	93.8	96.2	98.3	100.2	101.9	103.3	104.4	105.4	106.0	106.4	106.5
3.30		81.1	85.5	89.7	93.7	97.4	101.0	104.3	107.4	110.3	112.9	115.2	117.3	119.1	120.7	122.0	123.0	123.7	124.1

Deflection H/200		L sash																	
H		1.50	1.60	1.70	1.80	1.90	2.00	2.10	2.20	2.30	2.40	2.50	2.60	2.70	2.80	2.90	3.00	3.10	3.20
2.00		14.1	14.5	14.8	15.0	15.2	15.2	15.2	15.2	15.2	15.2	15.2	15.2	15.2	15.2	15.2	15.2	15.2	15.2
2.10		16.7	17.2	17.7	18.1	18.3	18.5	18.5	18.5	18.5	18.5	18.5	18.5	18.5	18.5	18.5	18.5	18.5	18.5
2.20		19.6	20.3	20.9	21.4	21.8	22.1	22.3	22.3	22.3	22.3	22.3	22.3	22.3	22.3	22.3	22.3	22.3	22.3
2.30		22.7	23.6	24.4	25.1	25.7	26.1	26.4	26.6	26.7	26.7	26.7	26.7	26.7	26.7	26.7	26.7	26.7	26.7
2.40		26.2	27.3	28.3	29.2	29.9	30.5	31.0	31.3	31.5	31.6	31.6	31.6	31.6	31.6	31.6	31.6	31.6	31.6
2.50		30.0	31.4	32.6	33.6	34.6	35.4	36.0	36.5	36.9	37.1	37.2	37.2	37.2	37.2	37.2	37.2	37.2	37.2
2.60		34.2	35.7	37.2	38.5	39.6	40.7	41.5	42.2	42.8	43.2	43.4	43.5	43.5	43.5	43.5	43.5	43.5	43.5
2.70		38.7	40.5	42.2	43.8	45.2	46.4	47.5	48.5	49.2	49.8	50.3	50.5	50.6	50.6	50.6	50.6	50.6	50.6
2.80		43.5	45.7	47.6	49.5	51.2	52.7	54.0	55.2	56.2	57.1	57.7	58.2	58.4	58.5	58.5	58.5	58.5	58.5
2.90		48.8	51.2	53.5	55.6	57.6	59.4	61.1	62.5	63.8	64.9	65.8	66.5	67.0	67.3	67.4	67.4	67.4	67.4
3.00		54.4	57.2	59.8	62.3	64.6	66.7	68.6	70.4	72.0	73.3	74.5	75.4	76.2	76.7	77.0	77.1	77.1	77.1
3.10		62.4	65.7	68.8	71.7	74.5	77.0	79.4	81.5	83.4	85.2	86.7	87.9	89.0	89.8	90.4	90.8	90.9	90.9
3.20		71.3	75.1	78.7	82.1	85.4	88.4	91.2	93.8	96.2	98.3	100.2	101.9	103.3	104.4	105.4	106.0	106.4	106.5
3.30		81.1	85.5	89.7	93.7	97.4	101.0	104.3	107.4	110.3	112.9	115.2	117.3	119.1	120.7	122.0	123.0	123.7	124.1

Deflection H/300		L sash																	
H		1.50	1.60	1.70	1.80	1.90	2.00	2.10	2.20	2.30	2.40	2.50	2.60	2.70	2.80	2.90	3.00	3.10	3.20
2.00		21.1	21.7	22.2	22.6	22.8	22.9	22.9	22.9	22.9	22.9	22.9	22.9	22.9	22.9	22.9	22.9	22.9	22.9
2.10		25.0	25.8	26.5	27.1	27.5	27.7	27.8	27.8	27.8	27.8	27.8	27.8	27.8	27.8	27.8	27.8	27.8	27.8
2.20		29.3	30.4	31.3	32.1	32.7	33.1	33.4	33.5	33.5	33.5	33.5	33.5	33.5	33.5	33.5	33.5	33.5	33.5
2.30		34.1	35.4	36.6	37.6	38.5	39.1	39.6	39.9	40.0	40.0	40.0	40.0	40.0	40.0	40.0	40.0	40.0	40.0
2.40		39.3	41.0	42.5	43.7	44.9	45.8	46.5	47.0	47.3	47.4	47.4	47.4	47.4	47.4	47.4	47.4	47.4	47.4
2.50		45.1	47.0	48.8	50.4	51.8	53.0	54.0	54.8	55.4	55.7	55.8	55.8	55.8	55.8	55.8	55.8	55.8	55.8
2.60		51.3	53.6	55.8	57.7	59.5	61.0	62.3	63.4	64.2	64.8	65.2	65.3	65.3	65.3	65.3	65.3	65.3	65.3
2.70		58.0	60.8	63.3	65.6	67.8	69.6	71.3	72.7	73.8	74.8	75.4	75.8	75.9	75.9	75.9	75.9	75.9	75.9
2.80		65.3	68.5	71.5	74.2	76.7	79.0	81.0	82.8	84.3	85.6	86.6	87.2	87.7	87.8	87.8	87.8	87.8	87.8
2.90		73.2	76.8	80.3	83.5	86.4	89.2	91.6	93.8	95.7	97.3	98.6	99.7	100.4	100.9	101.0	101.0	101.0	101.0
3.00		81.6	85.8	89.7	93.4	96.9	100.1	103.0	105.6	107.9	110.0	111.7	113.2	114.3	115.1	115.6	115.7	115.7	115.7
3.10		90.6	95.4	99.9	104.1	108.1	111.8	115.2	118.3	121.1	123.6	125.8	127.7	129.2	130.4	131.2	131.8	131.9	131.9
3.20		100.3	105.6	110.7	115.5	120.1	124.3	128.3	131.9	135.3	138.3	140.9	143.3	145.3	146.9	148.2	149.1	149.6	149.8
3.30		110.6	116.6	122.3	127.7	132.9	137.7	142.3	146.5	150.4	153.9	157.1	160.0	162.5	164.6	166.3	167.7	168.6	169.2

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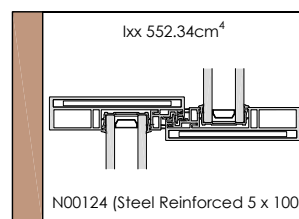
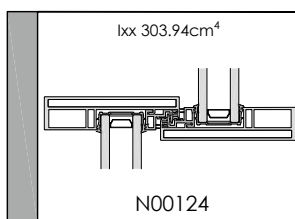
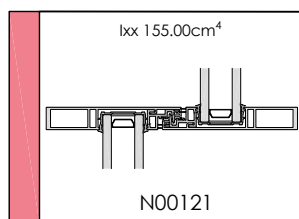
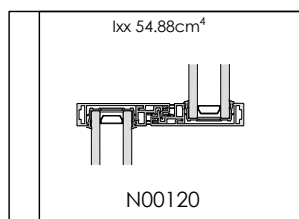
WIND LOADING CHART (800 Pa)

Deflection H/150																			
H	L sash																		
	1.50	1.60	1.70	1.80	1.90	2.00	2.10	2.20	2.30	2.40	2.50	2.60	2.70	2.80	2.90	3.00	3.10	3.20	
2.00	21.1	21.7	22.2	22.6	22.8	22.9	22.9	22.9	22.9	22.9	22.9	22.9	22.9	22.9	22.9	22.9	22.9	22.9	
2.10	25.0	25.8	26.5	27.1	27.5	27.7	27.8	27.8	27.8	27.8	27.8	27.8	27.8	27.8	27.8	27.8	27.8	27.8	
2.20	29.3	30.4	31.3	32.1	32.7	33.1	33.4	33.5	33.5	33.5	33.5	33.5	33.5	33.5	33.5	33.5	33.5	33.5	
2.30	34.9	36.2	37.4	38.5	39.3	40.0	40.5	40.8	40.9	40.9	40.9	40.9	40.9	40.9	40.9	40.9	40.9	40.9	
2.40	42.0	43.7	45.3	46.7	47.8	48.8	49.6	50.1	50.4	50.6	50.6	50.6	50.6	50.6	50.6	50.6	50.6	50.6	
2.50	50.1	52.3	54.3	56.0	57.6	58.9	60.0	60.9	61.5	61.9	62.0	62.0	62.0	62.0	62.0	62.0	62.0	62.0	
2.60	59.3	62.0	64.5	66.7	68.7	70.5	72.0	73.2	74.2	74.9	75.3	75.4	75.4	75.4	75.4	75.4	75.4	75.4	
2.70	69.6	72.9	76.0	78.8	81.3	83.6	85.5	87.2	88.6	89.7	90.5	90.9	91.1	91.1	91.1	91.1	91.1	91.1	
2.80	81.3	85.2	88.9	92.4	95.5	98.3	100.9	103.1	105.0	106.5	107.7	108.6	109.1	109.3	109.3	109.3	109.3	109.3	
2.90	94.3	99.0	103.5	107.6	111.4	114.9	118.1	120.9	123.3	125.4	127.1	128.5	129.5	130.0	130.2	130.2	130.2	130.2	
3.00	108.8	114.4	119.6	124.6	129.2	133.4	137.3	140.8	143.9	146.6	149.0	150.9	152.4	153.4	154.1	154.3	154.3	154.3	
3.10	124.9	131.4	137.6	143.4	148.9	154.0	158.7	163.0	166.9	170.3	173.3	175.9	178.0	179.6	180.8	181.5	181.8	181.8	
3.20	142.6	150.2	157.4	164.3	170.8	176.8	182.4	187.6	192.4	196.6	200.4	203.8	206.6	208.9	210.7	212.0	212.8	213.0	
3.30	162.2	171.0	179.3	187.3	194.9	202.0	208.7	214.9	220.6	225.8	230.5	234.7	238.3	241.4	243.9	245.9	247.3	248.2	

Deflection H/200																			
H	L sash																		
	1.50	1.60	1.70	1.80	1.90	2.00	2.10	2.20	2.30	2.40	2.50	2.60	2.70	2.80	2.90	3.00	3.10	3.20	
2.00	28.1	29.0	29.6	30.1	30.4	30.5	30.5	30.5	30.5	30.5	30.5	30.5	30.5	30.5	30.5	30.5	30.5	30.5	
2.10	33.3	34.5	35.4	36.1	36.6	36.9	37.0	37.0	37.0	37.0	37.0	37.0	37.0	37.0	37.0	37.0	37.0	37.0	
2.20	39.1	40.5	41.8	42.8	43.6	44.2	44.5	44.6	44.6	44.6	44.6	44.6	44.6	44.6	44.6	44.6	44.6	44.6	
2.30	45.5	47.3	48.8	50.2	51.3	52.2	52.8	53.2	53.3	53.3	53.3	53.3	53.3	53.3	53.3	53.3	53.3	53.3	
2.40	52.4	54.6	56.6	58.3	59.8	61.0	62.0	62.6	63.1	63.2	63.2	63.2	63.2	63.2	63.2	63.2	63.2	63.2	
2.50	60.1	62.7	65.1	67.2	69.1	70.7	72.0	73.1	73.8	74.3	74.4	74.4	74.4	74.4	74.4	74.4	74.4	74.4	
2.60	68.4	71.5	74.4	77.0	79.3	81.3	83.1	84.5	85.6	86.4	86.9	87.0	87.0	87.0	87.0	87.0	87.0	87.0	
2.70	77.4	81.0	84.4	87.5	90.3	92.9	95.1	96.9	98.5	99.7	100.5	101.1	101.2	101.2	101.2	101.2	101.2	101.2	
2.80	87.1	91.3	95.3	99.0	102.3	105.4	108.1	110.4	112.4	114.1	115.4	116.3	116.9	117.1	117.1	117.1	117.1	117.1	
2.90	97.5	102.4	107.0	111.3	115.3	118.9	122.1	125.0	127.6	129.8	131.5	132.9	133.9	134.5	134.7	134.7	134.7	134.7	
3.00	108.8	114.4	119.6	124.6	129.2	133.4	137.3	140.8	143.9	146.6	149.0	150.9	152.4	153.4	154.1	154.3	154.3	154.3	
3.10	124.9	131.4	137.6	143.4	148.9	154.0	158.7	163.0	166.9	170.3	173.3	175.9	178.0	179.6	180.8	181.5	181.8	181.8	
3.20	142.6	150.2	157.4	164.3	170.8	176.8	182.4	187.6	192.4	196.6	200.4	203.8	206.6	208.9	210.7	212.0	212.8	213.0	
3.30	162.2	171.0	179.3	187.3	194.9	202.0	208.7	214.9	220.6	225.8	230.5	234.7	238.3	241.4	243.9	245.9	247.3	248.2	

Deflection H/300																			
H	L sash																		
	1.50	1.60	1.70	1.80	1.90	2.00	2.10	2.20	2.30	2.40	2.50	2.60	2.70	2.80	2.90	3.00	3.10	3.20	
2.00	42.2	43.5	44.4	45.1	45.6	45.7	45.7	45.7	45.7	45.7	45.7	45.7	45.7	45.7	45.7	45.7	45.7	45.7	
2.10	50.0	51.7	53.1	54.2	54.9	55.4	55.6	55.6	55.6	55.6	55.6	55.6	55.6	55.6	55.6	55.6	55.6	55.6	
2.20	58.7	60.8	62.7	64.2	65.4	66.2	66.8	66.9	66.9	66.9	66.9	66.9	66.9	66.9	66.9	66.9	66.9	66.9	
2.30	68.2	70.9	73.3	75.3	77.0	78.3	79.2	79.8	80.0	80.0	80.0	80.0	80.0	80.0	80.0	80.0	80.0	80.0	
2.40	78.7	82.0	84.9	87.5	89.7	91.5	92.9	94.0	94.6	94.8	94.8	94.8	94.8	94.8	94.8	94.8	94.8	94.8	
2.50	90.1	94.1	97.7	100.9	103.7	106.1	108.1	109.6	110.7	111.4	111.6	111.6	111.6	111.6	111.6	111.6	111.6	111.6	
2.60	102.5	107.2	111.6	115.5	118.9	122.0	124.6	126.7	128.4	129.6	130.3	130.6	130.6	130.6	130.6	130.6	130.6	130.6	
2.70	116.0	121.5	126.6	131.3	135.5	139.3	142.6	145.4	147.7	149.5	150.8	151.6	151.8	151.8	151.8	151.8	151.8	151.8	
2.80	130.6	137.0	142.9	148.4	153.5	158.0	162.1	165.6	168.7	171.2	173.1	174.5	175.3	175.6	175.6	175.6	175.6	175.6	
2.90	146.3	153.6	160.5	166.9	172.9	178.3	183.2	187.6	191.4	194.6	197.3	199.4	200.9	201.8	202.1	202.1	202.1	202.1	
3.00	163.2	171.5	179.4	186.8	193.7	200.1	205.9	211.2	215.9	220.0	223.4	226.3	228.5	230.1	231.1	231.4	231.4	231.4	
3.10	181.2	190.7	199.7	208.2	216.1	223.5	230.4	236.6	242.2	247.3	251.6	255.3	258.4	260.8	262.5	263.5	263.9	263.9	
3.20	200.6	211.2	221.4	231.0	240.1	248.6	256.6	263.9	270.5	276.5	281.9	286.5	290.5	293.8	296.3	298.1	299.2	299.6	
3.30	221.2	233.1	244.6	255.4	265.7	275.5	284.5	293.0	300.8	307.9	314.3	320.0	324.9	329.2	332.6	335.3	337.3	338.4	

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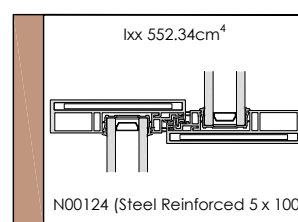
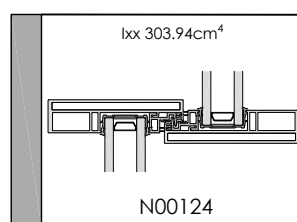
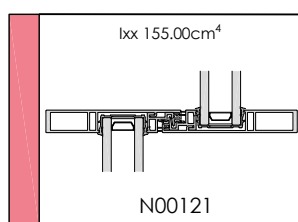
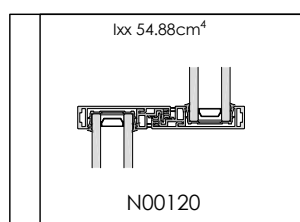
WIND LOADING CHART (1200 Pa)

Deflection H/150																		
H	L sash																	
	1.50	1.60	1.70	1.80	1.90	2.00	2.10	2.20	2.30	2.40	2.50	2.60	2.70	2.80	2.90	3.00	3.10	3.20
2.00	31.6	32.6	33.3	33.9	34.2	34.3	34.3	34.3	34.3	34.3	34.3	34.3	34.3	34.3	34.3	34.3	34.3	34.3
2.10	37.5	38.8	39.8	40.6	41.2	41.6	41.7	41.7	41.7	41.7	41.7	41.7	41.7	41.7	41.7	41.7	41.7	41.7
2.20	44.0	45.6	47.0	48.1	49.0	49.7	50.1	50.2	50.2	50.2	50.2	50.2	50.2	50.2	50.2	50.2	50.2	50.2
2.30	52.3	54.4	56.2	57.7	59.0	60.0	60.7	61.2	61.3	61.3	61.3	61.3	61.3	61.3	61.3	61.3	61.3	61.3
2.40	62.9	65.6	67.9	70.0	71.8	73.2	74.4	75.2	75.7	75.8	75.8	75.8	75.8	75.8	75.8	75.8	75.8	75.8
2.50	75.1	78.4	81.4	84.1	86.4	88.4	90.0	91.3	92.3	92.8	93.0	93.0	93.0	93.0	93.0	93.0	93.0	93.0
2.60	88.9	92.9	96.7	100.1	103.1	105.7	108.0	109.8	111.3	112.3	112.9	113.2	113.2	113.2	113.2	113.2	113.2	113.2
2.70	104.4	109.4	114.0	118.2	122.0	125.4	128.3	130.8	132.9	134.6	135.7	136.4	136.7	136.7	136.7	136.7	136.7	136.7
2.80	121.9	127.9	133.4	138.5	143.3	147.5	151.3	154.6	157.4	159.7	161.6	162.9	163.6	163.9	163.9	163.9	163.9	163.9
2.90	141.4	148.5	155.2	161.4	167.1	172.4	177.1	181.3	185.0	188.1	190.7	192.7	194.2	195.1	195.3	195.3	195.3	195.3
3.00	163.2	171.5	179.4	186.8	193.7	200.1	205.9	211.2	215.9	220.0	223.4	226.3	228.5	230.1	231.1	231.4	231.4	231.4
3.10	187.3	197.1	206.4	215.1	223.4	231.0	238.1	244.5	250.3	255.5	260.0	263.8	267.0	269.5	271.2	272.3	272.7	272.7
3.20	213.9	225.3	236.2	246.4	256.1	265.2	273.7	281.4	288.6	295.0	300.7	305.6	309.9	313.3	316.1	318.0	319.2	319.6
3.30	243.3	256.4	269.0	281.0	292.3	303.0	313.0	322.3	330.9	338.7	345.7	352.0	357.4	362.1	365.9	368.9	371.0	372.3

Deflection H/200																		
H	L sash																	
	1.50	1.60	1.70	1.80	1.90	2.00	2.10	2.20	2.30	2.40	2.50	2.60	2.70	2.80	2.90	3.00	3.10	3.20
2.00	42.2	43.5	44.4	45.1	45.6	45.7	45.7	45.7	45.7	45.7	45.7	45.7	45.7	45.7	45.7	45.7	45.7	45.7
2.10	50.0	51.7	53.1	54.2	54.9	55.4	55.6	55.6	55.6	55.6	55.6	55.6	55.6	55.6	55.6	55.6	55.6	55.6
2.20	58.7	60.8	62.7	64.2	65.4	66.2	66.8	66.9	66.9	66.9	66.9	66.9	66.9	66.9	66.9	66.9	66.9	66.9
2.30	68.2	70.9	73.3	75.3	77.0	78.3	79.2	79.8	80.0	80.0	80.0	80.0	80.0	80.0	80.0	80.0	80.0	80.0
2.40	78.7	82.0	84.9	87.5	89.7	91.5	92.9	94.0	94.6	94.8	94.8	94.8	94.8	94.8	94.8	94.8	94.8	94.8
2.50	90.1	94.1	97.7	100.9	103.7	106.1	108.1	109.6	110.7	111.4	111.6	111.6	111.6	111.6	111.6	111.6	111.6	111.6
2.60	102.5	107.2	111.6	115.5	118.9	122.0	124.6	126.7	128.4	129.6	130.3	130.6	130.6	130.6	130.6	130.6	130.6	130.6
2.70	116.0	121.5	126.6	131.3	135.5	139.3	142.6	145.4	147.7	149.5	150.8	151.6	151.8	151.8	151.8	151.8	151.8	151.8
2.80	130.6	137.0	142.9	148.4	153.5	158.0	162.1	165.6	168.7	171.2	173.1	174.5	175.3	175.6	175.6	175.6	175.6	175.6
2.90	146.3	153.6	160.5	166.9	172.9	178.3	183.2	187.6	191.4	194.6	197.3	199.4	200.9	201.8	202.1	202.1	202.1	202.1
3.00	163.2	171.5	179.4	186.8	193.7	200.1	205.9	211.2	215.9	220.0	223.4	226.3	228.5	230.1	231.1	231.4	231.4	231.4
3.10	187.3	197.1	206.4	215.1	223.4	231.0	238.1	244.5	250.3	255.5	260.0	263.8	267.0	269.5	271.2	272.3	272.7	272.7
3.20	213.9	225.3	236.2	246.4	256.1	265.2	273.7	281.4	288.6	295.0	300.7	305.6	309.9	313.3	316.1	318.0	319.2	319.6
3.30	243.3	256.4	269.0	281.0	292.3	303.0	313.0	322.3	330.9	338.7	345.7	352.0	357.4	362.1	365.9	368.9	371.0	372.3

Deflection H/300																		
H	L sash																	
	1.50	1.60	1.70	1.80	1.90	2.00	2.10	2.20	2.30	2.40	2.50	2.60	2.70	2.80	2.90	3.00	3.10	3.20
2.00	63.3	65.2	66.7	67.7	68.4	68.6	68.6	68.6	68.6	68.6	68.6	68.6	68.6	68.6	68.6	68.6	68.6	68.6
2.10	75.0	77.5	79.6	81.2	82.4	83.1	83.3	83.3	83.3	83.3	83.3	83.3	83.3	83.3	83.3	83.3	83.3	83.3
2.20	88.0	91.2	94.0	96.3	98.1	99.4	100.1	100.4	100.4	100.4	100.4	100.4	100.4	100.4	100.4	100.4	100.4	100.4
2.30	102.3	106.3	109.9	112.9	115.4	117.4	118.8	119.6	119.9	119.9	119.9	119.9	119.9	119.9	119.9	119.9	119.9	119.9
2.40	118.0	123.0	127.4	131.2	134.6	137.3	139.4	141.0	141.9	142.2	142.2	142.2	142.2	142.2	142.2	142.2	142.2	142.2
2.50	135.2	141.1	146.5	151.3	155.5	159.1	162.1	164.4	166.1	167.1	167.4	167.4	167.4	167.4	167.4	167.4	167.4	167.4
2.60	153.8	160.9	167.3	173.2	178.4	183.0	186.9	190.1	192.6	194.4	195.5	195.8	195.8	195.8	195.8	195.8	195.8	195.8
2.70	174.1	182.3	189.9	196.9	203.3	208.9	213.9	218.1	221.5	224.3	226.2	227.4	227.8	227.8	227.8	227.8	227.8	227.8
2.80	195.9	205.5	214.4	222.7	230.2	237.1	243.1	248.5	253.0	256.7	259.7	261.7	263.0	263.4	263.4	263.4	263.4	263.4
2.90	219.5	230.5	240.8	250.4	259.3	267.5	274.8	281.4	287.1	291.9	295.9	299.1	301.3	302.7	303.1	303.1	303.1	303.1
3.00	244.8	257.3	269.2	280.3	290.6	300.2	308.9	316.8	323.8	330.0	335.2	339.5	342.8	345.2	346.7	347.1	347.1	347.1
3.10	271.9	286.1	299.6	312.3	324.2	335.3	345.6	354.9	363.4	370.9	377.4	383.0	387.6	391.2	393.7	395.3	395.8	395.8
3.20	300.8	316.9	332.1	346.6	360.2	373.0	384.8	395.8	405.8	414.8	422.8	429.8	435.8	440.6	444.5	447.2	448.8	449.4
3.30	331.8	349.7	366.8	383.2	398.6	413.2	426.8	439.5	451.2	461.8	471.4	480.0	487.4	493.7	499.0	503.0	505.9	507.7

KEY



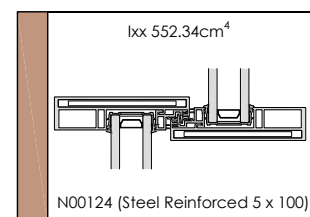
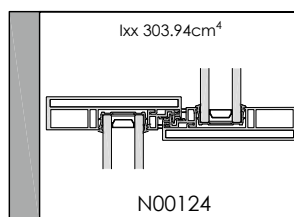
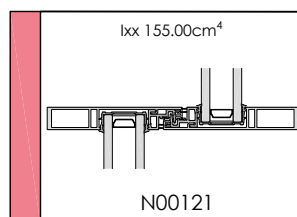
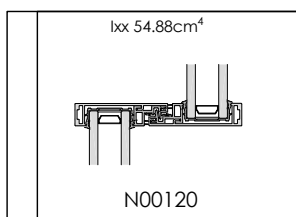
WIND LOADING CHART (1 600 Pa)

Deflection H/150		L sash																	
H		1.50	1.60	1.70	1.80	1.90	2.00	2.10	2.20	2.30	2.40	2.50	2.60	2.70	2.80	2.90	3.00	3.10	3.20
2.00		42.2	43.5	44.4	45.1	45.6	45.7	45.7	45.7	45.7	45.7	45.7	45.7	45.7	45.7	45.7	45.7	45.7	45.7
2.10		50.0	51.7	53.1	54.2	54.9	55.4	55.6	55.6	55.6	55.6	55.6	55.6	55.6	55.6	55.6	55.6	55.6	55.6
2.20		58.7	60.8	62.7	64.2	65.4	66.2	66.8	66.9	66.9	66.9	66.9	66.9	66.9	66.9	66.9	66.9	66.9	66.9
2.30		69.7	72.5	74.9	77.0	78.7	80.0	81.0	81.5	81.7	81.7	81.7	81.7	81.7	81.7	81.7	81.7	81.7	81.7
2.40		83.9	87.4	90.6	93.3	95.7	97.6	99.1	100.2	100.9	101.1	101.1	101.1	101.1	101.1	101.1	101.1	101.1	101.1
2.50		100.1	104.5	108.5	112.1	115.2	117.9	120.1	121.8	123.0	123.8	124.0	124.0	124.0	124.0	124.0	124.0	124.0	124.0
2.60		118.5	123.9	128.9	133.4	137.4	141.0	144.0	146.4	148.4	149.8	150.6	150.9	150.9	150.9	150.9	150.9	150.9	150.9
2.70		139.2	145.8	152.0	157.6	162.6	167.1	171.1	174.5	177.2	179.4	181.0	181.9	182.2	182.2	182.2	182.2	182.2	182.2
2.80		162.5	170.5	177.9	184.7	191.0	196.7	201.7	206.1	209.9	213.0	215.4	217.2	218.2	218.5	218.5	218.5	218.5	218.5
2.90		188.6	198.0	206.9	215.2	222.8	229.8	236.1	241.8	246.7	250.9	254.3	257.0	258.9	260.1	260.5	260.5	260.5	260.5
3.00		217.6	228.7	239.2	249.1	258.3	266.8	274.6	281.6	287.8	293.3	297.9	301.7	304.7	306.9	308.1	308.6	308.6	308.6
3.10		249.7	262.8	275.2	286.8	297.8	308.0	317.4	326.0	333.8	340.7	346.7	351.8	356.0	359.3	361.7	363.1	363.5	363.5
3.20		285.3	300.4	314.9	328.6	341.5	353.6	364.9	375.3	384.7	393.3	400.9	407.5	413.2	417.8	421.4	424.0	425.6	426.1
3.30		324.4	341.9	358.7	374.6	389.8	404.0	417.3	429.7	441.1	451.6	461.0	469.3	476.6	482.8	487.9	491.8	494.7	496.4

Deflection H/200		L sash																	
H		1.50	1.60	1.70	1.80	1.90	2.00	2.10	2.20	2.30	2.40	2.50	2.60	2.70	2.80	2.90	3.00	3.10	3.20
2.00		56.3	57.9	59.2	60.2	60.8	61.0	61.0	61.0	61.0	61.0	61.0	61.0	61.0	61.0	61.0	61.0	61.0	61.0
2.10		66.7	68.9	70.8	72.2	73.2	73.9	74.1	74.1	74.1	74.1	74.1	74.1	74.1	74.1	74.1	74.1	74.1	74.1
2.20		78.2	81.1	83.5	85.6	87.2	88.3	89.0	89.2	89.2	89.2	89.2	89.2	89.2	89.2	89.2	89.2	89.2	89.2
2.30		90.9	94.5	97.7	100.4	102.6	104.3	105.6	106.4	106.6	106.6	106.6	106.6	106.6	106.6	106.6	106.6	106.6	106.6
2.40		104.9	109.3	113.2	116.7	119.6	122.0	123.9	125.3	126.1	126.4	126.4	126.4	126.4	126.4	126.4	126.4	126.4	126.4
2.50		120.1	125.4	130.2	134.5	138.2	141.4	144.1	146.1	147.6	148.5	148.8	148.8	148.8	148.8	148.8	148.8	148.8	148.8
2.60		136.7	143.0	148.7	153.9	158.6	162.6	166.1	169.0	171.2	172.8	173.8	174.1	174.1	174.1	174.1	174.1	174.1	174.1
2.70		154.7	162.1	168.8	175.1	180.7	185.7	190.1	193.8	196.9	199.3	201.1	202.1	202.5	202.5	202.5	202.5	202.5	202.5
2.80		174.1	182.7	190.6	197.9	204.6	210.7	216.1	220.9	224.9	228.2	230.8	232.7	233.8	234.2	234.2	234.2	234.2	234.2
2.90		195.1	204.9	214.0	222.6	230.5	237.7	244.3	250.1	255.2	259.5	263.1	265.8	267.8	269.0	269.4	269.4	269.4	269.4
3.00		217.6	228.7	239.2	249.1	258.3	266.8	274.6	281.6	287.8	293.3	297.9	301.7	304.7	306.9	308.1	308.6	308.6	308.6
3.10		249.7	262.8	275.2	286.8	297.8	308.0	317.4	326.0	333.8	340.7	346.7	351.8	356.0	359.3	361.7	363.1	363.5	363.5
3.20		285.3	300.4	314.9	328.6	341.5	353.6	364.9	375.3	384.7	393.3	400.9	407.5	413.2	417.8	421.4	424.0	425.6	426.1
3.30		324.4	341.9	358.7	374.6	389.8	404.0	417.3	429.7	441.1	451.6	461.0	469.3	476.6	482.8	487.9	491.8	494.7	496.4

Deflection H/300		L sash																	
H		1.50	1.60	1.70	1.80	1.90	2.00	2.10	2.20	2.30	2.40	2.50	2.60	2.70	2.80	2.90	3.00	3.10	3.20
2.00		84.4	86.9	88.9	90.3	91.1	91.4	91.4	91.4	91.4	91.4	91.4	91.4	91.4	91.4	91.4	91.4	91.4	91.4
2.10		100.0	103.4	106.1	108.3	109.9	110.8	111.1	111.1	111.1	111.1	111.1	111.1	111.1	111.1	111.1	111.1	111.1	111.1
2.20		117.3	121.6	125.3	128.4	130.8	132.5	133.5	133.9	133.9	133.9	133.9	133.9	133.9	133.9	133.9	133.9	133.9	133.9
2.30		136.4	141.8	146.5	150.6	153.9	156.5	158.4	159.5	159.9	159.9	159.9	159.9	159.9	159.9	159.9	159.9	159.9	159.9
2.40		157.3	163.9	169.8	175.0	179.4	183.0	185.9	187.9	189.2	189.6	189.6	189.6	189.6	189.6	189.6	189.6	189.6	189.6
2.50		180.2	188.1	195.3	201.7	207.4	212.2	216.1	219.2	221.4	222.8	223.2	223.2	223.2	223.2	223.2	223.2	223.2	223.2
2.60		205.1	214.5	223.1	230.9	237.9	244.0	249.2	253.4	256.8	259.2	260.6	261.1	261.1	261.1	261.1	261.1	261.1	261.1
2.70		232.1	243.1	253.3	262.6	271.0	278.6	285.2	290.8	295.4	299.0	301.6	303.2	303.7	303.7	303.7	303.7	303.7	303.7
2.80		261.2	274.0	285.9	296.9	307.0	316.1	324.2	331.3	337.3	342.3	346.2	349.0	350.7	351.2	351.2	351.2	351.2	351.2
2.90		292.6	307.3	321.1	333.9	345.8	356.6	366.4	375.1	382.8	389.3	394.6	398.8	401.8	403.6	404.2	404.2	404.2	404.2
3.00		326.4	343.1	358.9	373.7	387.5	400.2	411.9	422.4	431.8	439.9	446.9	452.6	457.1	460.3	462.2	462.9	462.9	462.9
3.10		362.5	381.4	399.4	416.4	432.3	447.1	460.8	473.2	484.5	494.5	503.2	510.7	516.8	521.6	525.0	527.0	527.7	527.7
3.20		401.1	422.5	442.8	462.1	480.3	497.3	513.1	527.7	541.0	553.1	563.8	573.1	581.0	587.5	592.6	596.3	598.5	599.2
3.30		442.3	466.2	489.1	510.9	531.5	550.9	569.1	586.0	601.6	615.8	628.6	640.0	649.9	658.3	665.3	670.7	674.6	676.9

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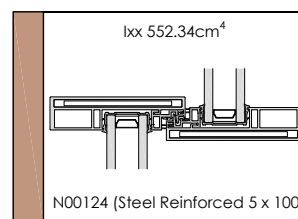
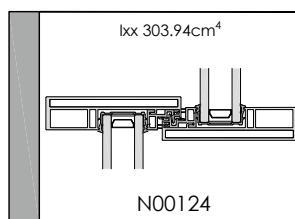
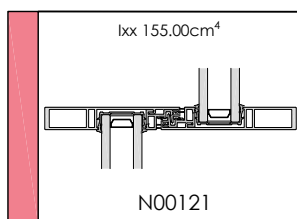
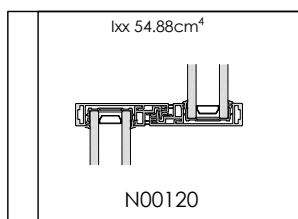
WIND LOADING CHART (2000 Pa)

Deflection H/150																		
H	L sash																	
	1.50	1.60	1.70	1.80	1.90	2.00	2.10	2.20	2.30	2.40	2.50	2.60	2.70	2.80	2.90	3.00	3.10	3.20
2.00	52.7	54.3	55.5	56.4	57.0	57.1	57.1	57.1	57.1	57.1	57.1	57.1	57.1	57.1	57.1	57.1	57.1	57.1
2.10	62.5	64.6	66.3	67.7	68.7	69.3	69.5	69.5	69.5	69.5	69.5	69.5	69.5	69.5	69.5	69.5	69.5	69.5
2.20	73.3	76.0	78.3	80.2	81.7	82.8	83.4	83.7	83.7	83.7	83.7	83.7	83.7	83.7	83.7	83.7	83.7	83.7
2.30	87.1	90.6	93.6	96.2	98.3	100.0	101.2	101.9	102.2	102.2	102.2	102.2	102.2	102.2	102.2	102.2	102.2	102.2
2.40	104.9	109.3	113.2	116.7	119.6	122.0	123.9	125.3	126.1	126.4	126.4	126.4	126.4	126.4	126.4	126.4	126.4	126.4
2.50	125.1	130.7	135.6	140.1	144.0	147.3	150.1	152.2	153.8	154.7	155.0	155.0	155.0	155.0	155.0	155.0	155.0	155.0
2.60	148.1	154.9	161.1	166.8	171.8	176.2	180.0	183.0	185.5	187.2	188.2	188.6	188.6	188.6	188.6	188.6	188.6	188.6
2.70	174.1	182.3	189.9	196.9	203.3	208.9	213.9	218.1	221.5	224.3	226.2	227.4	227.8	227.8	227.8	227.8	227.8	227.8
2.80	203.2	213.1	222.4	230.9	238.8	245.8	252.2	257.7	262.4	266.2	269.3	271.4	272.7	273.2	273.2	273.2	273.2	273.2
2.90	235.7	247.5	258.6	269.0	278.5	287.3	295.2	302.2	308.3	313.6	317.9	321.2	323.6	325.1	325.6	325.6	325.6	325.6
3.00	272.0	285.9	299.1	311.4	322.9	333.5	343.2	352.0	359.8	366.6	372.4	377.2	380.9	383.6	385.2	385.7	385.7	385.7
3.10	312.1	328.5	344.0	358.6	372.3	385.0	396.8	407.5	417.2	425.8	433.3	439.7	445.0	449.1	452.1	453.8	454.4	454.4
3.20	356.6	375.5	393.6	410.7	426.9	442.0	456.1	469.1	480.9	491.6	501.1	509.4	516.5	522.2	526.8	530.0	532.0	532.6
3.30	405.5	427.4	448.3	468.3	487.2	505.0	521.7	537.2	551.4	564.5	576.2	586.6	595.7	603.5	609.8	614.8	618.3	620.5

Deflection H/200																		
H	L sash																	
	1.50	1.60	1.70	1.80	1.90	2.00	2.10	2.20	2.30	2.40	2.50	2.60	2.70	2.80	2.90	3.00	3.10	3.20
2.00	70.3	72.4	74.1	75.2	76.0	76.2	76.2	76.2	76.2	76.2	76.2	76.2	76.2	76.2	76.2	76.2	76.2	76.2
2.10	83.3	86.1	88.4	90.3	91.6	92.3	92.6	92.6	92.6	92.6	92.6	92.6	92.6	92.6	92.6	92.6	92.6	92.6
2.20	97.8	101.4	104.4	107.0	109.0	110.4	111.3	111.6	111.6	111.6	111.6	111.6	111.6	111.6	111.6	111.6	111.6	111.6
2.30	113.7	118.2	122.1	125.5	128.3	130.4	132.0	132.9	133.3	133.3	133.3	133.3	133.3	133.3	133.3	133.3	133.3	133.3
2.40	131.1	136.6	141.5	145.8	149.5	152.5	154.9	156.6	157.6	158.0	158.0	158.0	158.0	158.0	158.0	158.0	158.0	158.0
2.50	150.2	156.8	162.8	168.1	172.8	176.8	180.1	182.7	184.5	185.6	186.0	186.0	186.0	186.0	186.0	186.0	186.0	186.0
2.60	170.9	178.7	185.9	192.4	198.2	203.3	207.6	211.2	214.0	216.0	217.2	217.6	217.6	217.6	217.6	217.6	217.6	217.6
2.70	193.4	202.6	211.1	218.8	225.9	232.1	237.6	242.3	246.2	249.2	251.3	252.6	253.1	253.1	253.1	253.1	253.1	253.1
2.80	217.7	228.3	238.2	247.4	255.8	263.4	270.2	276.1	281.1	285.3	288.5	290.8	292.2	292.7	292.7	292.7	292.7	292.7
2.90	243.8	256.1	267.5	278.2	288.1	297.2	305.3	312.6	319.0	324.4	328.8	332.3	334.8	336.3	336.8	336.8	336.8	336.8
3.00	272.0	285.9	299.1	311.4	322.9	333.5	343.2	352.0	359.8	366.6	372.4	377.2	380.9	383.6	385.2	385.7	385.7	385.7
3.10	312.1	328.5	344.0	358.6	372.3	385.0	396.8	407.5	417.2	425.8	433.3	439.7	445.0	449.1	452.1	453.8	454.4	454.4
3.20	356.6	375.5	393.6	410.7	426.9	442.0	456.1	469.1	480.9	491.6	501.1	509.4	516.5	522.2	526.8	530.0	532.0	532.6
3.30	405.5	427.4	448.3	468.3	487.2	505.0	521.7	537.2	551.4	564.5	576.2	586.6	595.7	603.5	609.8	614.8	618.3	620.5

Deflection H/300																			
H	L sash																		
	1.50	1.60	1.70	1.80	1.90	2.00	2.10	2.20	2.30	2.40	2.50	2.60	2.70	2.80	2.90	3.00	3.10	3.20	
2.00	105.5	108.6	111.1	112.9	113.9	114.3	114.3	114.3	114.3	114.3	114.3	114.3	114.3	114.3	114.3	114.3	114.3	114.3	
2.10	125.0	129.2	132.7	135.4	137.3	138.5	138.9	138.9	138.9	138.9	138.9	138.9	138.9	138.9	138.9	138.9	138.9	138.9	
2.20	146.7	152.0	156.7	160.5	163.5	165.6	166.9	167.3	167.3	167.3	167.3	167.3	167.3	167.3	167.3	167.3	167.3	167.3	
2.30	170.5	177.2	183.2	188.2	192.4	195.7	198.0	199.4	199.9	199.9	199.9	199.9	199.9	199.9	199.9	199.9	199.9	199.9	
2.40	196.7	204.9	212.3	218.7	224.3	228.8	232.4	234.9	236.5	237.0	237.0	237.0	237.0	237.0	237.0	237.0	237.0	237.0	
2.50	225.3	235.2	244.2	252.2	259.2	265.2	270.1	274.0	276.8	278.5	279.0	279.0	279.0	279.0	279.0	279.0	279.0	279.0	
2.60	256.4	268.1	278.9	288.6	297.3	305.0	311.5	316.8	321.0	324.0	325.8	326.4	326.4	326.4	326.4	326.4	326.4	326.4	
2.70	290.1	303.8	316.6	328.2	338.8	348.2	356.4	363.5	369.2	373.8	377.0	379.0	379.6	379.6	379.6	379.6	379.6	379.6	
2.80	326.5	342.5	357.4	371.1	383.7	395.1	405.2	414.1	421.7	427.9	432.8	436.2	438.3	439.0	439.0	439.0	439.0	439.0	
2.90	365.8	384.1	401.3	417.4	432.2	445.8	458.0	468.9	478.4	486.6	493.2	498.5	502.2	504.5	505.2	505.2	505.2	505.2	
3.00	407.9	428.8	448.6	467.1	484.4	500.3	514.9	528.0	539.7	549.9	558.6	565.8	571.4	575.4	577.8	578.6	578.6	578.6	
3.10	453.1	476.8	499.3	520.5	540.4	558.9	575.9	591.5	605.6	618.1	629.0	638.3	646.0	652.0	656.2	658.8	659.7	659.7	
3.20	501.4	528.1	553.5	577.6	600.3	621.6	641.4	659.6	676.3	691.3	704.7	716.3	726.3	734.4	740.8	745.3	748.1	749.0	
3.30	552.9	582.8	611.4	638.6	664.4	688.6	711.4	732.5	752.0	769.7	785.7	800.0	812.4	822.9	831.6	838.4	843.2	846.1	

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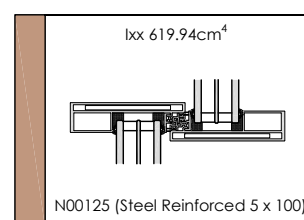
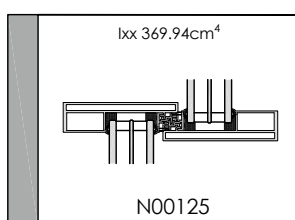
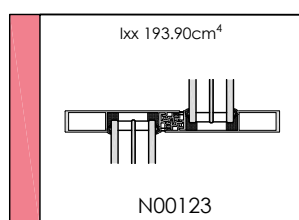
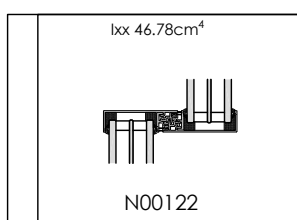
WIND LOADING CHART (400 Pa)

Deflection H/150																			
H	L sash																		
	1.50	1.60	1.70	1.80	1.90	2.00	2.10	2.20	2.30	2.40	2.50	2.60	2.70	2.80	2.90	3.00	3.10	3.20	
2.00	10.5	10.9	11.1	11.3	11.4	11.4	11.4	11.4	11.4	11.4	11.4	11.4	11.4	11.4	11.4	11.4	11.4	11.4	
2.10	12.5	12.9	13.3	13.5	13.7	13.9	13.9	13.9	13.9	13.9	13.9	13.9	13.9	13.9	13.9	13.9	13.9	13.9	
2.20	14.7	15.2	15.7	16.0	16.3	16.6	16.7	16.7	16.7	16.7	16.7	16.7	16.7	16.7	16.7	16.7	16.7	16.7	
2.30	17.4	18.1	18.7	19.2	19.7	20.0	20.2	20.4	20.4	20.4	20.4	20.4	20.4	20.4	20.4	20.4	20.4	20.4	
2.40	21.0	21.9	22.6	23.3	23.9	24.4	24.8	25.1	25.2	25.3	25.3	25.3	25.3	25.3	25.3	25.3	25.3	25.3	
2.50	25.0	26.1	27.1	28.0	28.8	29.5	30.0	30.4	30.8	30.9	31.0	31.0	31.0	31.0	31.0	31.0	31.0	31.0	
2.60	29.6	31.0	32.2	33.4	34.4	35.2	36.0	36.6	37.1	37.4	37.6	37.7	37.7	37.7	37.7	37.7	37.7	37.7	
2.70	34.8	36.5	38.0	39.4	40.7	41.8	42.8	43.6	44.3	44.9	45.2	45.5	45.6	45.6	45.6	45.6	45.6	45.6	
2.80	40.6	42.6	44.5	46.2	47.8	49.2	50.4	51.5	52.5	53.2	53.9	54.3	54.5	54.6	54.6	54.6	54.6	54.6	
2.90	47.1	49.5	51.7	53.8	55.7	57.5	59.0	60.4	61.7	62.7	63.6	64.2	64.7	65.0	65.1	65.1	65.1	65.1	
3.00	54.4	57.2	59.8	62.3	64.6	66.7	68.6	70.4	72.0	73.3	74.5	75.4	76.2	76.7	77.0	77.1	77.1	77.1	
3.10	62.4	65.7	68.8	71.7	74.5	77.0	79.4	81.5	83.4	85.2	86.7	87.9	89.0	89.8	90.4	90.8	90.9	90.9	
3.20	71.3	75.1	78.7	82.1	85.4	88.4	91.2	93.8	96.2	98.3	100.2	101.9	103.3	104.4	105.4	106.0	106.4	106.5	
3.30	81.1	85.5	89.7	93.7	97.4	101.0	104.3	107.4	110.3	112.9	115.2	117.3	119.1	120.7	122.0	123.0	123.7	124.1	

Deflection H/200																			
H	L sash																		
	1.50	1.60	1.70	1.80	1.90	2.00	2.10	2.20	2.30	2.40	2.50	2.60	2.70	2.80	2.90	3.00	3.10	3.20	
2.00	14.1	14.5	14.8	15.0	15.2	15.2	15.2	15.2	15.2	15.2	15.2	15.2	15.2	15.2	15.2	15.2	15.2	15.2	
2.10	16.7	17.2	17.7	18.1	18.3	18.5	18.5	18.5	18.5	18.5	18.5	18.5	18.5	18.5	18.5	18.5	18.5	18.5	
2.20	19.6	20.3	20.9	21.4	21.8	22.1	22.3	22.3	22.3	22.3	22.3	22.3	22.3	22.3	22.3	22.3	22.3	22.3	
2.30	22.7	23.6	24.4	25.1	25.7	26.1	26.4	26.6	26.7	26.7	26.7	26.7	26.7	26.7	26.7	26.7	26.7	26.7	
2.40	26.2	27.3	28.3	29.2	29.9	30.5	31.0	31.3	31.5	31.6	31.6	31.6	31.6	31.6	31.6	31.6	31.6	31.6	
2.50	30.0	31.4	32.6	33.6	34.6	35.4	36.0	36.5	36.9	37.1	37.2	37.2	37.2	37.2	37.2	37.2	37.2	37.2	
2.60	34.2	35.7	37.2	38.5	39.6	40.7	41.5	42.2	42.8	43.2	43.4	43.5	43.5	43.5	43.5	43.5	43.5	43.5	
2.70	38.7	40.5	42.2	43.8	45.2	46.4	47.5	48.5	49.2	49.8	50.3	50.5	50.6	50.6	50.6	50.6	50.6	50.6	
2.80	43.5	45.7	47.6	49.5	51.2	52.7	54.0	55.2	56.2	57.1	57.7	58.2	58.4	58.5	58.5	58.5	58.5	58.5	
2.90	48.8	51.2	53.5	55.6	57.6	59.4	61.1	62.5	63.8	64.9	65.8	66.5	67.0	67.3	67.4	67.4	67.4	67.4	
3.00	54.4	57.2	59.8	62.3	64.6	66.7	68.6	70.4	72.0	73.3	74.5	75.4	76.2	76.7	77.0	77.1	77.1	77.1	
3.10	62.4	65.7	68.8	71.7	74.5	77.0	79.4	81.5	83.4	85.2	86.7	87.9	89.0	89.8	90.4	90.8	90.9	90.9	
3.20	71.3	75.1	78.7	82.1	85.4	88.4	91.2	93.8	96.2	98.3	100.2	101.9	103.3	104.4	105.4	106.0	106.4	106.5	
3.30	81.1	85.5	89.7	93.7	97.4	101.0	104.3	107.4	110.3	112.9	115.2	117.3	119.1	120.7	122.0	123.0	123.7	124.1	

Deflection H/300																			
H	L sash																		
	1.50	1.60	1.70	1.80	1.90	2.00	2.10	2.20	2.30	2.40	2.50	2.60	2.70	2.80	2.90	3.00	3.10	3.20	
2.00	21.1	21.7	22.2	22.6	22.8	22.9	22.9	22.9	22.9	22.9	22.9	22.9	22.9	22.9	22.9	22.9	22.9	22.9	
2.10	25.0	25.8	26.5	27.1	27.5	27.7	27.8	27.8	27.8	27.8	27.8	27.8	27.8	27.8	27.8	27.8	27.8	27.8	
2.20	29.3	30.4	31.3	32.1	32.7	33.1	33.4	33.5	33.5	33.5	33.5	33.5	33.5	33.5	33.5	33.5	33.5	33.5	
2.30	34.1	35.4	36.6	37.6	38.5	39.1	39.6	39.9	40.0	40.0	40.0	40.0	40.0	40.0	40.0	40.0	40.0	40.0	
2.40	39.3	41.0	42.5	43.7	44.9	45.8	46.5	47.0	47.3	47.4	47.4	47.4	47.4	47.4	47.4	47.4	47.4	47.4	
2.50	45.1	47.0	48.8	50.4	51.8	53.0	54.0	54.8	55.4	55.7	55.8	55.8	55.8	55.8	55.8	55.8	55.8	55.8	
2.60	51.3	53.6	55.8	57.7	59.5	61.0	62.3	63.4	64.2	64.8	65.2	65.3	65.3	65.3	65.3	65.3	65.3	65.3	
2.70	58.0	60.8	63.3	65.6	67.8	69.6	71.3	72.7	73.8	74.8	75.4	75.8	75.9	75.9	75.9	75.9	75.9	75.9	
2.80	65.3	68.5	71.5	74.2	76.7	79.0	81.0	82.8	84.3	85.6	86.6	87.2	87.7	87.8	87.8	87.8	87.8	87.8	
2.90	73.2	76.8	80.3	83.5	86.4	89.2	91.6	93.8	95.7	97.3	98.6	99.7	100.4	100.9	101.0	101.0	101.0	101.0	
3.00	81.6	85.8	89.7	93.4	96.9	100.1	103.0	105.6	107.9	110.0	111.7	113.2	114.3	115.1	115.6	115.7	115.7	115.7	
3.10	90.6	95.4	99.9	104.1	108.1	111.8	115.2	118.3	121.1	123.6	125.8	127.7	129.2	130.4	131.2	131.8	131.9	131.9	
3.20	100.3	105.6	110.7	115.5	120.1	124.3	128.3	131.9	135.3	138.3	140.9	143.3	145.3	146.9	148.2	149.1	149.6	149.8	
3.30	110.6	116.6	122.3	127.7	132.9	137.7	142.3	146.5	150.4	153.9	157.1	160.0	162.5	164.6	166.3	167.7	168.6	169.2	

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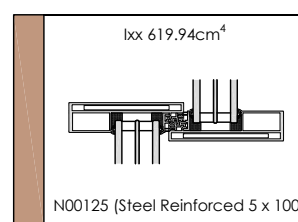
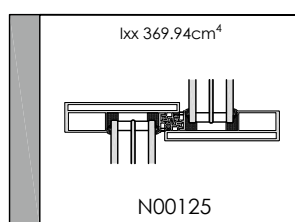
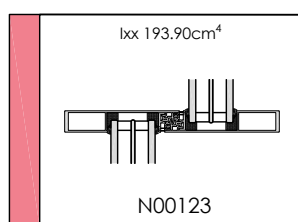
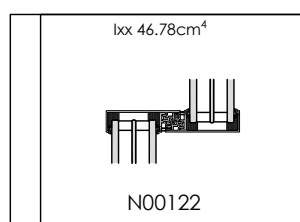
WIND LOADING CHART (800 Pa)

Deflection H/150																		
H	L sash																	
	1.50	1.60	1.70	1.80	1.90	2.00	2.10	2.20	2.30	2.40	2.50	2.60	2.70	2.80	2.90	3.00	3.10	3.20
2.00	21.1	21.7	22.2	22.6	22.8	22.9	22.9	22.9	22.9	22.9	22.9	22.9	22.9	22.9	22.9	22.9	22.9	22.9
2.10	25.0	25.8	26.5	27.1	27.5	27.7	27.8	27.8	27.8	27.8	27.8	27.8	27.8	27.8	27.8	27.8	27.8	27.8
2.20	29.3	30.4	31.3	32.1	32.7	33.1	33.4	33.5	33.5	33.5	33.5	33.5	33.5	33.5	33.5	33.5	33.5	33.5
2.30	34.9	36.2	37.4	38.5	39.3	40.0	40.5	40.8	40.9	40.9	40.9	40.9	40.9	40.9	40.9	40.9	40.9	40.9
2.40	42.0	43.7	45.3	46.7	47.8	48.8	49.6	50.1	50.4	50.6	50.6	50.6	50.6	50.6	50.6	50.6	50.6	50.6
2.50	50.1	52.3	54.3	56.0	57.6	58.9	60.0	60.9	61.5	61.9	62.0	62.0	62.0	62.0	62.0	62.0	62.0	62.0
2.60	59.3	62.0	64.5	66.7	68.7	70.5	72.0	73.2	74.2	74.9	75.3	75.4	75.4	75.4	75.4	75.4	75.4	75.4
2.70	69.6	72.9	76.0	78.8	81.3	83.6	85.5	87.2	88.6	89.7	90.5	90.9	91.1	91.1	91.1	91.1	91.1	91.1
2.80	81.3	85.2	88.9	92.4	95.5	98.3	100.9	103.1	105.0	106.5	107.7	108.6	109.1	109.3	109.3	109.3	109.3	109.3
2.90	94.3	99.0	103.5	107.6	111.4	114.9	118.1	120.9	123.3	125.4	127.1	128.5	129.5	130.0	130.2	130.2	130.2	130.2
3.00	108.8	114.4	119.6	124.6	129.2	133.4	137.3	140.8	143.9	146.6	149.0	150.9	152.4	153.4	154.1	154.3	154.3	154.3
3.10	124.9	131.4	137.6	143.4	148.9	154.0	158.7	163.0	166.9	170.3	173.3	175.9	178.0	79.6	180.8	181.5	181.8	181.8
3.20	142.6	150.2	157.4	164.3	170.8	176.8	182.4	187.6	192.4	196.6	200.4	203.8	206.6	208.9	210.7	212.0	212.8	213.0
3.30	162.2	171.0	179.3	187.3	194.9	202.0	208.7	214.9	220.6	225.8	230.5	234.7	238.3	241.4	243.9	245.9	247.3	248.2

Deflection H/200																		
H	L sash																	
	1.50	1.60	1.70	1.80	1.90	2.00	2.10	2.20	2.30	2.40	2.50	2.60	2.70	2.80	2.90	3.00	3.10	3.20
2.00	28.1	29.0	29.6	30.1	30.4	30.5	30.5	30.5	30.5	30.5	30.5	30.5	30.5	30.5	30.5	30.5	30.5	30.5
2.10	33.3	34.5	35.4	36.1	36.6	36.9	37.0	37.0	37.0	37.0	37.0	37.0	37.0	37.0	37.0	37.0	37.0	37.0
2.20	39.1	40.5	41.8	42.8	43.6	44.2	44.5	44.6	44.6	44.6	44.6	44.6	44.6	44.6	44.6	44.6	44.6	44.6
2.30	45.5	47.3	48.8	50.2	51.3	52.2	52.8	53.2	53.3	53.3	53.3	53.3	53.3	53.3	53.3	53.3	53.3	53.3
2.40	52.4	54.6	56.6	58.3	59.8	61.0	62.0	62.6	63.1	63.2	63.2	63.2	63.2	63.2	63.2	63.2	63.2	63.2
2.50	60.1	62.7	65.1	67.2	69.1	70.7	72.0	73.1	73.8	74.3	74.4	74.4	74.4	74.4	74.4	74.4	74.4	74.4
2.60	68.4	71.5	74.4	77.0	79.3	81.3	83.1	84.5	85.6	86.4	86.9	87.0	87.0	87.0	87.0	87.0	87.0	87.0
2.70	77.4	81.0	84.4	87.5	90.3	92.9	95.1	96.9	98.5	99.7	100.5	101.1	101.2	101.2	101.2	101.2	101.2	101.2
2.80	87.1	91.3	95.3	99.0	102.3	105.4	108.1	110.4	112.4	114.1	115.4	116.3	116.9	117.1	117.1	117.1	117.1	117.1
2.90	97.5	102.4	107.0	111.3	115.3	118.9	122.1	125.0	127.6	129.8	131.5	132.9	133.9	134.5	134.7	134.7	134.7	134.7
3.00	108.8	114.4	119.6	124.6	129.2	133.4	137.3	140.8	143.9	146.6	149.0	150.9	152.4	153.4	154.1	154.3	154.3	154.3
3.10	124.9	131.4	137.6	143.4	148.9	154.0	158.7	163.0	166.9	170.3	173.3	175.9	178.0	179.6	180.8	181.5	181.8	181.8
3.20	142.6	150.2	157.4	164.3	170.8	176.8	182.4	187.6	192.4	196.6	200.4	203.8	206.6	208.9	210.7	212.0	212.8	213.0
3.30	162.2	171.0	179.3	187.3	194.9	202.0	208.7	214.9	220.6	225.8	230.5	234.7	238.3	241.4	243.9	245.9	247.3	248.2

Deflection H/300																		
H	L sash																	
	1.50	1.60	1.70	1.80	1.90	2.00	2.10	2.20	2.30	2.40	2.50	2.60	2.70	2.80	2.90	3.00	3.10	3.20
2.00	42.2	43.5	44.4	45.1	45.6	45.7	45.7	45.7	45.7	45.7	45.7	45.7	45.7	45.7	45.7	45.7	45.7	45.7
2.10	50.0	51.7	53.1	54.2	54.9	55.4	55.6	55.6	55.6	55.6	55.6	55.6	55.6	55.6	55.6	55.6	55.6	55.6
2.20	58.7	60.8	62.7	64.2	65.4	66.2	66.8	66.9	66.9	66.9	66.9	66.9	66.9	66.9	66.9	66.9	66.9	66.9
2.30	68.2	70.9	73.3	75.3	77.0	78.3	79.2	79.8	80.0	80.0	80.0	80.0	80.0	80.0	80.0	80.0	80.0	80.0
2.40	78.7	82.0	84.9	87.5	89.7	91.5	92.9	94.0	94.6	94.8	94.8	94.8	94.8	94.8	94.8	94.8	94.8	94.8
2.50	90.1	94.1	97.7	100.9	103.7	106.1	108.1	109.6	110.7	111.4	111.6	111.6	111.6	111.6	111.6	111.6	111.6	111.6
2.60	102.5	107.2	111.6	115.5	118.9	122.0	124.6	126.7	128.4	129.6	130.3	130.6	130.6	130.6	130.6	130.6	130.6	130.6
2.70	116.0	121.5	126.6	131.3	135.5	139.3	142.6	145.4	147.7	149.5	150.8	151.6	151.8	151.8	151.8	151.8	151.8	151.8
2.80	130.6	137.0	142.9	148.4	153.5	158.0	162.1	165.6	168.7	171.2	173.1	174.5	175.3	175.6	175.6	175.6	175.6	175.6
2.90	146.3	153.6	160.5	166.9	172.9	178.3	183.2	187.6	191.4	194.6	197.3	199.4	200.9	201.8	202.1	202.1	202.1	202.1
3.00	163.2	171.5	179.4	186.8	193.7	200.1	205.9	211.2	215.9	220.0	223.4	226.3	228.5	230.1	231.1	231.4	231.4	231.4
3.10	181.2	190.7	199.7	208.2	216.1	223.5	230.4	236.6	242.2	247.3	251.6	255.3	258.4	260.8	262.5	263.5	263.9	263.9
3.20	200.6	211.2	221.4	231.0	240.1	248.6	256.6	263.9	270.5	276.5	281.9	286.5	290.5	293.8	296.3	298.1	299.2	299.6
3.30	221.2	233.1	244.6	255.4	265.7	275.5	284.5	293.0	300.8	307.9	314.3	320.0	324.9	329.2	332.6	335.3	337.3	338.4

KEY



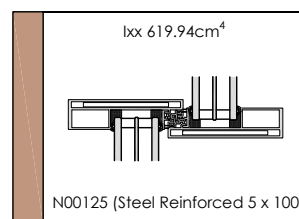
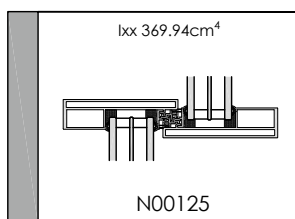
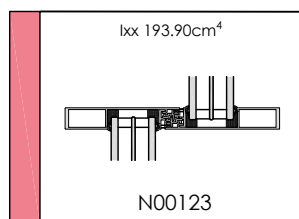
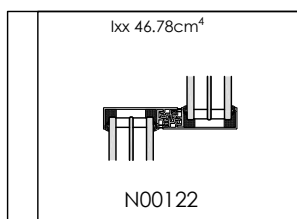
WIND LOADING CHART (1200 Pa)

Deflection H/150		L sash																	
H		1.50	1.60	1.70	1.80	1.90	2.00	2.10	2.20	2.30	2.40	2.50	2.60	2.70	2.80	2.90	3.00	3.10	3.20
2.00		31.6	32.6	33.3	33.9	34.2	34.3	34.3	34.3	34.3	34.3	34.3	34.3	34.3	34.3	34.3	34.3	34.3	34.3
2.10		37.5	38.8	39.8	40.6	41.2	41.6	41.7	41.7	41.7	41.7	41.7	41.7	41.7	41.7	41.7	41.7	41.7	41.7
2.20		44.0	45.6	47.0	48.1	49.0	49.7	50.1	50.2	50.2	50.2	50.2	50.2	50.2	50.2	50.2	50.2	50.2	50.2
2.30		52.3	54.4	56.2	57.7	59.0	60.0	60.7	61.2	61.3	61.3	61.3	61.3	61.3	61.3	61.3	61.3	61.3	61.3
2.40		62.9	65.6	67.9	70.0	71.8	73.2	74.4	75.2	75.7	75.8	75.8	75.8	75.8	75.8	75.8	75.8	75.8	75.8
2.50		75.1	78.4	81.4	84.1	86.4	88.4	90.0	91.3	92.3	92.8	93.0	93.0	93.0	93.0	93.0	93.0	93.0	93.0
2.60		88.9	92.9	96.7	100.1	103.1	105.7	108.0	109.8	111.3	112.3	112.9	113.2	113.2	113.2	113.2	113.2	113.2	113.2
2.70		104.4	109.4	114.0	118.2	122.0	125.4	128.3	130.8	132.9	134.6	135.7	136.4	136.7	136.7	136.7	136.7	136.7	136.7
2.80		121.9	127.9	133.4	138.5	143.3	147.5	151.3	154.6	157.4	159.7	161.6	162.9	163.6	163.9	163.9	163.9	163.9	163.9
2.90		141.4	148.5	155.2	161.4	167.1	172.4	177.1	181.3	185.0	188.1	190.7	192.7	194.2	195.1	195.3	195.3	195.3	195.3
3.00		163.2	171.5	179.4	186.8	193.7	200.1	205.9	211.2	215.9	220.0	223.4	226.3	228.5	230.1	231.1	231.4	231.4	231.4
3.10		187.3	197.1	206.4	215.1	223.4	231.0	238.1	244.5	250.3	255.5	260.0	263.8	267.0	269.5	271.2	272.3	272.7	272.7
3.20		213.9	225.3	236.2	246.4	256.1	265.2	273.7	281.4	288.6	295.0	300.7	305.6	309.9	313.3	316.1	318.0	319.2	319.6
3.30		243.3	256.4	269.0	281.0	292.3	303.0	313.0	322.3	330.9	338.7	345.7	352.0	357.4	362.1	365.9	368.9	371.0	372.3

Deflection H/200		L sash																	
H		1.50	1.60	1.70	1.80	1.90	2.00	2.10	2.20	2.30	2.40	2.50	2.60	2.70	2.80	2.90	3.00	3.10	3.20
2.00		42.2	43.5	44.4	45.1	45.6	45.7	45.7	45.7	45.7	45.7	45.7	45.7	45.7	45.7	45.7	45.7	45.7	45.7
2.10		50.0	51.7	53.1	54.2	54.9	55.4	55.6	55.6	55.6	55.6	55.6	55.6	55.6	55.6	55.6	55.6	55.6	55.6
2.20		58.7	60.8	62.7	64.2	65.4	66.2	66.8	66.9	66.9	66.9	66.9	66.9	66.9	66.9	66.9	66.9	66.9	66.9
2.30		68.2	70.9	73.3	75.3	77.0	78.3	79.2	79.8	80.0	80.0	80.0	80.0	80.0	80.0	80.0	80.0	80.0	80.0
2.40		78.7	82.0	84.9	87.5	89.7	91.5	92.9	94.0	94.6	94.8	94.8	94.8	94.8	94.8	94.8	94.8	94.8	94.8
2.50		90.1	94.1	97.7	100.9	103.7	106.1	108.1	109.6	110.7	111.4	111.6	111.6	111.6	111.6	111.6	111.6	111.6	111.6
2.60		102.5	107.2	111.6	115.5	118.9	122.0	124.6	126.7	128.4	129.6	130.3	130.6	130.6	130.6	130.6	130.6	130.6	130.6
2.70		116.0	121.5	126.6	131.3	135.5	139.3	142.6	145.4	147.7	149.5	150.8	151.6	151.8	151.8	151.8	151.8	151.8	151.8
2.80		130.6	137.0	142.9	148.4	153.5	158.0	162.1	165.6	168.7	171.2	173.1	174.5	175.3	175.6	175.6	175.6	175.6	175.6
2.90		146.3	153.6	160.5	166.9	172.9	178.3	183.2	187.6	191.4	194.6	197.3	199.4	200.9	201.8	202.1	202.1	202.1	202.1
3.00		163.2	171.5	179.4	186.8	193.7	200.1	205.9	211.2	215.9	220.0	223.4	226.3	228.5	230.1	231.1	231.4	231.4	231.4
3.10		187.3	197.1	206.4	215.1	223.4	231.0	238.1	244.5	250.3	255.5	260.0	263.8	267.0	269.5	271.2	272.3	272.7	272.7
3.20		213.9	225.3	236.2	246.4	256.1	265.2	273.7	281.4	288.6	295.0	300.7	305.6	309.9	313.3	316.1	318.0	319.2	319.6
3.30		243.3	256.4	269.0	281.0	292.3	303.0	313.0	322.3	330.9	338.7	345.7	352.0	357.4	362.1	365.9	368.9	371.0	372.3

Deflection H/300		L sash																	
H		1.50	1.60	1.70	1.80	1.90	2.00	2.10	2.20	2.30	2.40	2.50	2.60	2.70	2.80	2.90	3.00	3.10	3.20
2.00		63.3	65.2	66.7	67.7	68.4	68.6	68.6	68.6	68.6	68.6	68.6	68.6	68.6	68.6	68.6	68.6	68.6	68.6
2.10		75.0	77.5	79.6	81.2	82.4	83.1	83.3	83.3	83.3	83.3	83.3	83.3	83.3	83.3	83.3	83.3	83.3	83.3
2.20		88.0	91.2	94.0	96.3	98.1	99.4	100.1	100.4	100.4	100.4	100.4	100.4	100.4	100.4	100.4	100.4	100.4	100.4
2.30		102.3	106.3	109.9	112.9	115.4	117.4	118.8	119.6	119.9	119.9	119.9	119.9	119.9	119.9	119.9	119.9	119.9	119.9
2.40		118.0	123.0	127.4	131.2	134.6	137.3	139.4	141.0	141.9	142.2	142.2	142.2	142.2	142.2	142.2	142.2	142.2	142.2
2.50		135.2	141.1	146.5	151.3	155.5	159.1	162.1	164.4	166.1	167.1	167.4	167.4	167.4	167.4	167.4	167.4	167.4	167.4
2.60		153.8	160.9	167.3	173.2	178.4	183.0	186.9	190.1	192.6	194.4	195.5	195.8	195.8	195.8	195.8	195.8	195.8	195.8
2.70		174.1	182.3	189.9	196.9	203.3	208.9	213.9	218.1	221.5	224.3	226.2	227.4	227.8	227.8	227.8	227.8	227.8	227.8
2.80		195.9	205.5	214.4	222.7	230.2	237.1	243.1	248.5	253.0	256.7	259.7	261.7	263.0	263.4	263.4	263.4	263.4	263.4
2.90		219.5	230.5	240.8	250.4	259.3	267.5	274.8	281.4	287.1	291.9	295.9	299.1	301.3	302.7	303.1	303.1	303.1	303.1
3.00		244.8	257.3	269.2	280.3	290.6	300.2	308.9	316.8	323.8	330.0	335.2	339.5	342.8	345.2	346.7	347.1	347.1	347.1
3.10		271.9	286.1	299.6	312.3	324.2	335.3	345.6	354.9	363.4	370.9	377.4	383.0	387.6	391.2	393.7	395.3	395.8	395.8
3.20		300.8	316.9	332.1	346.6	360.2	373.0	384.8	395.8	405.8	414.8	422.8	429.8	435.8	440.6	444.5	447.2	448.8	449.4
3.30		331.8	349.7	366.8	383.2	398.6	413.2	426.8	439.5	451.2	461.8	471.4	480.0	487.4	493.7	499.0	503.0	505.9	507.7

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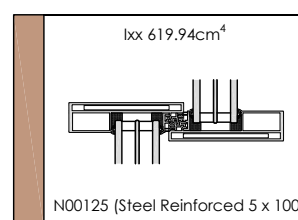
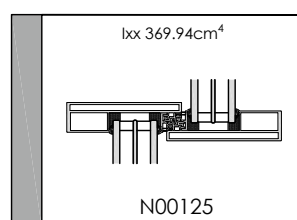
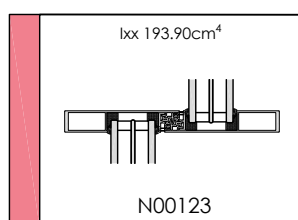
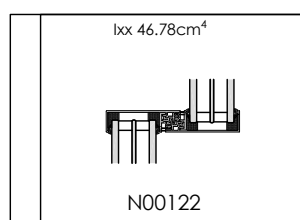
WIND LOADING CHART (1600 Pa)

Deflection H/150																		
H	L sash																	
	1.50	1.60	1.70	1.80	1.90	2.00	2.10	2.20	2.30	2.40	2.50	2.60	2.70	2.80	2.90	3.00	3.10	3.20
2.00	42.2	43.5	44.4	45.1	45.6	45.7	45.7	45.7	45.7	45.7	45.7	45.7	45.7	45.7	45.7	45.7	45.7	45.7
2.10	50.0	51.7	53.1	54.2	54.9	55.4	55.6	55.6	55.6	55.6	55.6	55.6	55.6	55.6	55.6	55.6	55.6	55.6
2.20	58.7	60.8	62.7	64.2	65.4	66.2	66.8	66.9	66.9	66.9	66.9	66.9	66.9	66.9	66.9	66.9	66.9	66.9
2.30	69.7	72.5	74.9	77.0	78.7	80.0	81.0	81.5	81.7	81.7	81.7	81.7	81.7	81.7	81.7	81.7	81.7	81.7
2.40	83.9	87.4	90.6	93.3	95.7	97.6	99.1	100.2	100.9	101.1	101.1	101.1	101.1	101.1	101.1	101.1	101.1	101.1
2.50	100.1	104.5	108.5	112.1	115.2	117.9	120.1	121.8	123.0	123.8	124.0	124.0	124.0	124.0	124.0	124.0	124.0	124.0
2.60	118.5	123.9	128.9	133.4	137.4	141.0	144.0	146.4	148.4	149.8	150.6	150.9	150.9	150.9	150.9	150.9	150.9	150.9
2.70	139.2	145.8	152.0	157.6	162.6	167.1	171.1	174.5	177.2	179.4	181.0	181.9	182.2	182.2	182.2	182.2	182.2	182.2
2.80	162.5	170.5	177.9	184.7	191.0	196.7	201.7	206.1	209.9	213.0	215.4	217.2	218.2	218.5	218.5	218.5	218.5	218.5
2.90	188.6	198.0	206.9	215.2	222.8	229.8	236.1	241.8	246.7	250.9	254.3	257.0	258.9	260.1	260.5	260.5	260.5	260.5
3.00	217.6	228.7	239.2	249.1	258.3	266.8	274.6	281.6	287.8	293.3	297.9	301.7	304.7	306.9	308.1	308.6	308.6	308.6
3.10	249.7	262.8	275.2	286.8	297.8	308.0	317.4	326.0	333.8	340.7	346.7	351.8	356.0	359.3	361.7	363.1	363.5	363.5
3.20	285.3	300.4	314.9	328.6	341.5	353.6	364.9	375.3	384.7	393.3	400.9	407.5	413.2	417.8	421.4	424.0	425.6	426.1
3.30	324.4	341.9	358.7	374.6	389.8	404.0	417.3	429.7	441.1	451.6	461.0	469.3	476.6	482.8	487.9	491.8	494.7	496.4

Deflection H/200																		
H	L sash																	
	1.50	1.60	1.70	1.80	1.90	2.00	2.10	2.20	2.30	2.40	2.50	2.60	2.70	2.80	2.90	3.00	3.10	3.20
2.00	56.3	57.9	59.2	60.2	60.8	61.0	61.0	61.0	61.0	61.0	61.0	61.0	61.0	61.0	61.0	61.0	61.0	61.0
2.10	66.7	68.9	70.8	72.2	73.2	73.9	74.1	74.1	74.1	74.1	74.1	74.1	74.1	74.1	74.1	74.1	74.1	74.1
2.20	78.2	81.1	83.5	85.6	87.2	88.3	89.0	89.2	89.2	89.2	89.2	89.2	89.2	89.2	89.2	89.2	89.2	89.2
2.30	90.9	94.5	97.7	100.4	102.6	104.3	105.6	106.4	106.6	106.6	106.6	106.6	106.6	106.6	106.6	106.6	106.6	106.6
2.40	104.9	109.3	113.2	116.7	119.6	122.0	123.9	125.3	126.1	126.4	126.4	126.4	126.4	126.4	126.4	126.4	126.4	126.4
2.50	120.1	125.4	130.2	134.5	138.2	141.4	144.1	146.1	147.6	148.5	148.8	148.8	148.8	148.8	148.8	148.8	148.8	148.8
2.60	136.7	143.0	148.7	153.9	158.6	162.6	166.1	169.0	171.2	172.8	173.8	174.1	174.1	174.1	174.1	174.1	174.1	174.1
2.70	154.7	162.1	168.8	175.1	180.7	185.7	190.1	193.8	196.9	199.3	201.1	202.1	202.5	202.5	202.5	202.5	202.5	202.5
2.80	174.1	182.7	190.6	197.9	204.6	210.7	216.1	220.9	224.9	228.2	230.8	232.7	233.8	234.2	234.2	234.2	234.2	234.2
2.90	195.1	204.9	214.0	222.6	230.5	237.7	244.3	250.1	255.2	259.5	263.1	265.8	267.8	269.0	269.4	269.4	269.4	269.4
3.00	217.6	228.7	239.2	249.1	258.3	266.8	274.6	281.6	287.8	293.3	297.9	301.7	304.7	306.9	308.1	308.6	308.6	308.6
3.10	249.7	262.8	275.2	286.8	297.8	308.0	317.4	326.0	333.8	340.7	346.7	351.8	356.0	359.3	361.7	363.1	363.5	363.5
3.20	285.3	300.4	314.9	328.6	341.5	353.6	364.9	375.3	384.7	393.3	400.9	407.5	413.2	417.8	421.4	424.0	425.6	426.1
3.30	324.4	341.9	358.7	374.6	389.8	404.0	417.3	429.7	441.1	451.6	461.0	469.3	476.6	482.8	487.9	491.8	494.7	496.4

Deflection H/300																		
H	L sash																	
	1.50	1.60	1.70	1.80	1.90	2.00	2.10	2.20	2.30	2.40	2.50	2.60	2.70	2.80	2.90	3.00	3.10	3.20
2.00	84.4	86.9	88.9	90.3	91.1	91.4	91.4	91.4	91.4	91.4	91.4	91.4	91.4	91.4	91.4	91.4	91.4	91.4
2.10	100.0	103.4	106.1	108.3	109.9	110.8	111.1	111.1	111.1	111.1	111.1	111.1	111.1	111.1	111.1	111.1	111.1	111.1
2.20	117.3	121.6	125.3	128.4	130.8	132.5	133.5	133.9	133.9	133.9	133.9	133.9	133.9	133.9	133.9	133.9	133.9	133.9
2.30	136.4	141.8	146.5	150.6	153.9	156.5	158.4	159.5	159.9	159.9	159.9	159.9	159.9	159.9	159.9	159.9	159.9	159.9
2.40	157.3	163.9	169.8	175.0	179.4	183.0	185.9	187.9	189.2	189.6	189.6	189.6	189.6	189.6	189.6	189.6	189.6	189.6
2.50	180.2	188.1	195.3	201.7	207.4	212.2	216.1	219.2	221.4	222.8	223.2	223.2	223.2	223.2	223.2	223.2	223.2	223.2
2.60	205.1	214.5	223.1	230.9	237.9	244.0	249.2	253.4	256.8	259.2	260.6	261.1	261.1	261.1	261.1	261.1	261.1	261.1
2.70	232.1	243.1	253.3	262.6	271.0	278.6	285.2	290.8	295.4	299.0	301.6	303.2	303.7	303.7	303.7	303.7	303.7	303.7
2.80	261.2	274.0	285.9	296.9	307.0	316.1	324.2	331.3	337.3	342.3	346.2	349.0	350.7	351.2	351.2	351.2	351.2	351.2
2.90	292.6	307.3	321.1	333.9	345.8	356.6	366.4	375.1	382.8	389.3	394.6	398.8	401.8	403.6	404.2	404.2	404.2	404.2
3.00	326.4	343.1	358.9	373.7	387.5	400.2	411.9	422.4	431.8	439.9	446.9	452.6	457.1	460.3	462.2	462.9	462.9	462.9
3.10	362.5	381.4	399.4	416.4	432.3	447.1	460.8	473.2	484.5	494.5	503.2	510.7	516.8	521.6	525.0	527.0	527.7	527.7
3.20	401.1	422.5	442.8	462.1	480.3	497.3	513.1	527.7	541.0	553.1	563.8	573.1	581.0	587.5	592.6	596.3	598.5	599.2
3.30	442.3	466.2	489.1	510.9	531.5	550.9	569.1	586.0	601.6	615.8	628.6	640.0	649.9	658.3	665.3	670.7	674.6	676.9

KEY



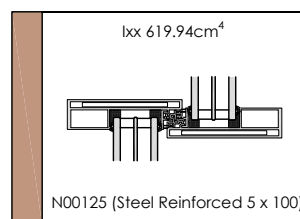
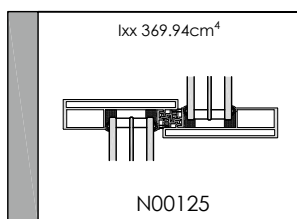
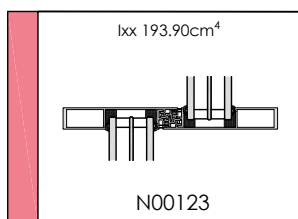
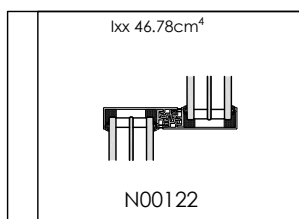
WIND LOADING CHART (2000 Pa)

Deflection H/150																			
H	L sash																		
	1.50	1.60	1.70	1.80	1.90	2.00	2.10	2.20	2.30	2.40	2.50	2.60	2.70	2.80	2.90	3.00	3.10	3.20	
2.00	52.7	54.3	55.5	56.4	57.0	57.1	57.1	57.1	57.1	57.1	57.1	57.1	57.1	57.1	57.1	57.1	57.1	57.1	
2.10	62.5	64.6	66.3	67.7	68.7	69.3	69.5	69.5	69.5	69.5	69.5	69.5	69.5	69.5	69.5	69.5	69.5	69.5	
2.20	73.3	76.0	78.3	80.2	81.7	82.8	83.4	83.7	83.7	83.7	83.7	83.7	83.7	83.7	83.7	83.7	83.7	83.7	
2.30	87.1	90.6	93.6	96.2	98.3	100.0	101.2	101.9	102.2	102.2	102.2	102.2	102.2	102.2	102.2	102.2	102.2	102.2	
2.40	104.9	109.3	113.2	116.7	119.6	122.0	123.9	125.3	126.1	126.4	126.4	126.4	126.4	126.4	126.4	126.4	126.4	126.4	
2.50	125.1	130.7	135.6	140.1	144.0	147.3	150.1	152.2	153.8	154.7	155.0	155.0	155.0	155.0	155.0	155.0	155.0	155.0	
2.60	148.1	154.9	161.1	166.8	171.8	176.2	180.0	183.0	185.5	187.2	188.2	188.6	188.6	188.6	188.6	188.6	188.6	188.6	
2.70	174.1	182.3	189.9	196.9	203.3	208.9	213.9	218.1	221.5	224.3	226.2	227.4	227.8	227.8	227.8	227.8	227.8	227.8	
2.80	203.2	213.1	222.4	230.9	238.8	245.8	252.2	257.7	262.4	266.2	269.3	271.4	272.7	273.2	273.2	273.2	273.2	273.2	
2.90	235.7	247.5	258.6	269.0	278.5	287.3	295.2	302.2	308.3	313.6	317.9	321.2	323.6	325.1	325.6	325.6	325.6	325.6	
3.00	272.0	285.9	299.1	311.4	322.9	333.5	343.2	352.0	359.8	366.6	372.4	377.2	380.9	383.6	385.2	385.7	385.7	385.7	
3.10	312.1	328.5	344.0	358.6	372.3	385.0	396.8	407.5	417.2	425.8	433.3	439.7	445.0	449.1	452.1	453.8	454.4	454.4	
3.20	356.6	375.5	393.6	410.7	426.9	442.0	456.1	469.1	480.9	491.6	501.1	509.4	516.5	522.2	526.8	530.0	532.0	532.6	
3.30	405.5	427.4	448.3	468.3	487.2	505.0	521.7	537.2	551.4	564.5	576.2	586.6	595.7	603.5	609.8	614.8	618.3	620.5	

Deflection H/200																			
H	L sash																		
	1.50	1.60	1.70	1.80	1.90	2.00	2.10	2.20	2.30	2.40	2.50	2.60	2.70	2.80	2.90	3.00	3.10	3.20	
2.00	70.3	72.4	74.1	75.2	76.0	76.2	76.2	76.2	76.2	76.2	76.2	76.2	76.2	76.2	76.2	76.2	76.2	76.2	
2.10	83.3	86.1	88.4	90.3	91.6	92.3	92.6	92.6	92.6	92.6	92.6	92.6	92.6	92.6	92.6	92.6	92.6	92.6	
2.20	97.8	101.4	104.4	107.0	109.0	110.4	111.3	111.6	111.6	111.6	111.6	111.6	111.6	111.6	111.6	111.6	111.6	111.6	
2.30	113.7	118.2	122.1	125.5	128.3	130.4	132.0	132.9	133.3	133.3	133.3	133.3	133.3	133.3	133.3	133.3	133.3	133.3	
2.40	131.1	136.6	141.5	145.8	149.5	152.5	154.9	156.6	157.6	158.0	158.0	158.0	158.0	158.0	158.0	158.0	158.0	158.0	
2.50	150.2	156.8	162.8	168.1	172.8	176.8	180.1	182.7	184.5	185.6	186.0	186.0	186.0	186.0	186.0	186.0	186.0	186.0	
2.60	170.9	178.7	185.9	192.4	198.2	203.3	207.6	211.2	214.0	216.0	217.2	217.6	217.6	217.6	217.6	217.6	217.6	217.6	
2.70	193.4	202.6	211.1	218.8	225.9	232.1	237.6	242.3	246.2	249.2	251.3	252.6	253.1	253.1	253.1	253.1	253.1	253.1	
2.80	217.7	228.3	238.2	247.4	255.8	263.4	270.2	276.1	281.1	285.3	288.5	290.8	292.2	292.7	292.7	292.7	292.7	292.7	
2.90	243.8	256.1	267.5	278.2	288.1	297.2	305.3	312.6	319.0	324.4	328.8	332.3	334.8	336.3	336.8	336.8	336.8	336.8	
3.00	272.0	285.9	299.1	311.4	322.9	333.5	343.2	352.0	359.8	366.6	372.4	377.2	380.9	383.6	385.2	385.7	385.7	385.7	
3.10	312.1	328.5	344.0	358.6	372.3	385.0	396.8	407.5	417.2	425.8	433.3	439.7	445.0	449.1	452.1	453.8	454.4	454.4	
3.20	356.6	375.5	393.6	410.7	426.9	442.0	456.1	469.1	480.9	491.6	501.1	509.4	516.5	522.2	526.8	530.0	532.0	532.6	
3.30	405.5	427.4	448.3	468.3	487.2	505.0	521.7	537.2	551.4	564.5	576.2	586.6	595.7	603.5	609.8	614.8	618.3	620.5	

Deflection H/300																			
H	L sash																		
	1.50	1.60	1.70	1.80	1.90	2.00	2.10	2.20	2.30	2.40	2.50	2.60	2.70	2.80	2.90	3.00	3.10	3.20	
2.00	105.5	108.6	111.1	112.9	113.9	114.3	114.3	114.3	114.3	114.3	114.3	114.3	114.3	114.3	114.3	114.3	114.3	114.3	
2.10	125.0	129.2	132.7	135.4	137.3	138.5	138.9	138.9	138.9	138.9	138.9	138.9	138.9	138.9	138.9	138.9	138.9	138.9	
2.20	146.7	152.0	156.7	160.5	163.5	165.6	166.9	167.3	167.3	167.3	167.3	167.3	167.3	167.3	167.3	167.3	167.3	167.3	
2.30	170.5	177.2	183.2	188.2	192.4	195.7	198.0	199.4	199.9	199.9	199.9	199.9	199.9	199.9	199.9	199.9	199.9	199.9	
2.40	196.7	204.9	212.3	218.7	224.3	228.8	232.4	234.9	236.5	237.0	237.0	237.0	237.0	237.0	237.0	237.0	237.0	237.0	
2.50	225.3	235.2	244.2	252.2	259.2	265.2	270.1	274.0	276.8	278.5	279.0	279.0	279.0	279.0	279.0	279.0	279.0	279.0	
2.60	256.4	268.1	278.9	288.6	297.3	305.0	311.5	316.8	321.0	324.0	325.8	326.4	326.4	326.4	326.4	326.4	326.4	326.4	
2.70	290.1	303.8	316.6	328.2	338.8	348.2	356.4	363.5	369.2	373.8	377.0	379.0	379.6	379.6	379.6	379.6	379.6	379.6	
2.80	326.5	342.5	357.4	371.1	383.7	395.1	405.2	414.1	421.7	427.9	432.8	436.2	438.3	439.0	439.0	439.0	439.0	439.0	
2.90	365.8	384.1	401.3	417.4	432.2	445.8	458.0	468.9	478.4	486.6	493.2	498.5	502.2	504.5	505.2	505.2	505.2	505.2	
3.00	407.9	428.8	448.6	467.1	484.4	500.3	514.9	528.0	539.7	549.9	558.6	565.8	571.4	575.4	577.8	578.6	578.6	578.6	
3.10	453.1	476.8	499.3	520.5	540.4	558.9	575.9	591.5	605.6	618.1	629.0	638.3	646.0	652.0	656.2	658.8	659.7	659.7	
3.20	501.4	528.1	553.5	577.6	600.3	621.6	641.4	659.6	676.3	691.3	704.7	716.3	726.3	734.4	740.8	745.3	748.1	749.0	
3.30	552.9	582.8	611.4	638.6	664.4	688.6	711.4	732.5	752.0	769.7	785.7	800.0	812.4	822.9	831.6	838.4	843.2	846.1	

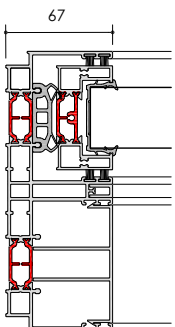
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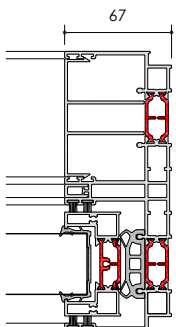


➤ THERMAL TRANSMITTANCE (U_f)

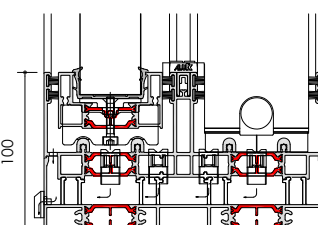
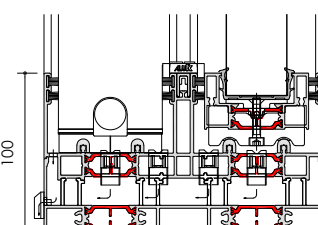
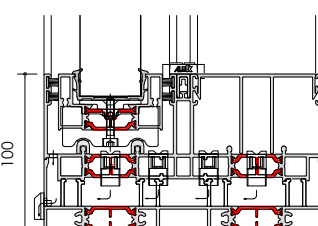
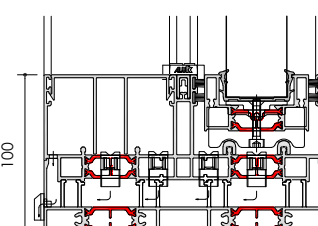
Thermal transmittance (U_f) of the nodes calculated according to EN ISO 10077-2.

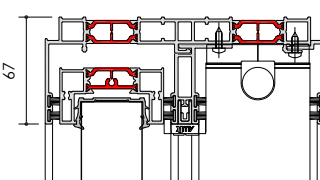
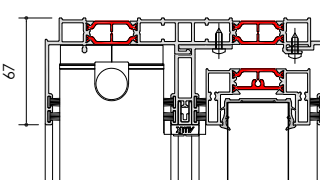
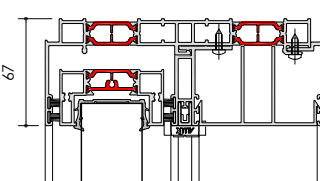
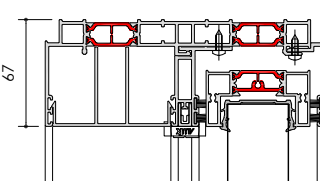
Profile Materials	Conductivity λ W/(m.K)	Emissivity ε
Aluminum alloy oxidized / painted	160	0.9
Aluminum alloy mill finish	160	0.3
Polyamide	0.3	-
EPDM	0.25	-
Mohair sweep	0.14	-
PVC Flexible	0.14	-
PVC Rigid	0.17	-
Polyurethane solid	0.21	-
Polyamid 6.6 with 25% glass fibre	0.30	-
Silicone pure	0.35	-
TPE	0.18	-
Closed cell polyethylene foam	0.038	-

	U_f [W/(m ² .K)]	
	$\varepsilon = 0.3$	$\varepsilon = 0.9$
	2.7	2.7
	U00020 U00100 N00651	

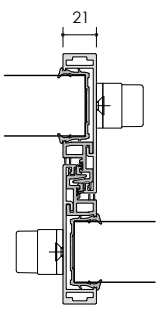
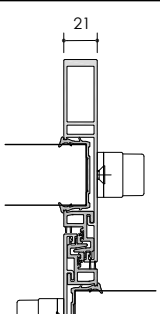
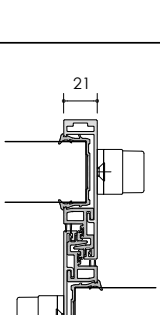
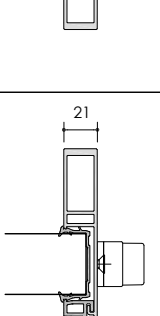
	U_f [W/(m ² .K)]	
	$\varepsilon = 0.3$	$\varepsilon = 0.9$
	2.5	2.6
	U00020 U00100 N00651	

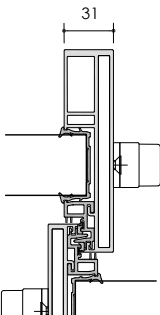
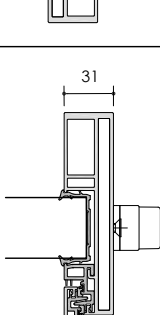
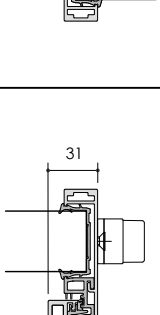
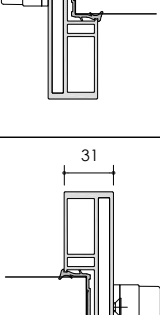
► THERMAL TRANSMITTANCE (U_f)

	U_f [W/(m ² .K)]	
	$\epsilon = 0.3$	$\epsilon = 0.9$
	2.9	3.0
	U00020 U00100 U00630	
	2.9	3.0
	U00020 U00100 U00630	
	3.1	3.2
	U00020 U00100 U00630 N00651	
	2.8	2.9
	U00020 U00100 U00630 N00651	

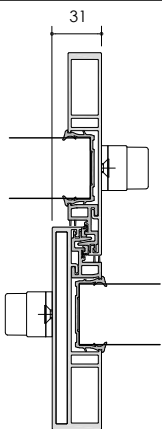
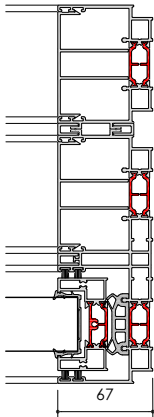
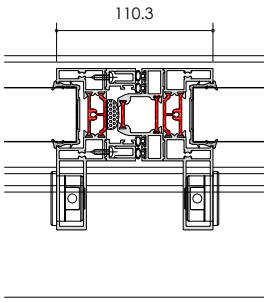
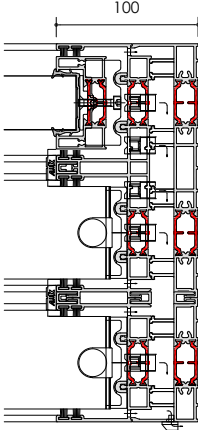
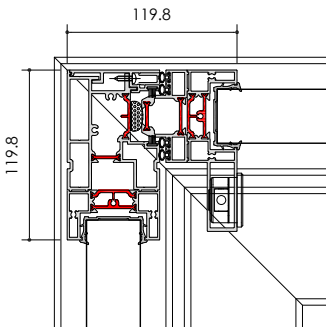
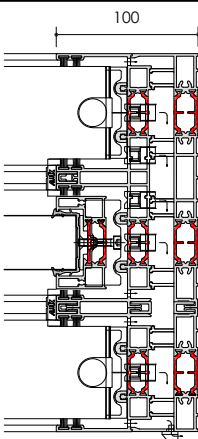
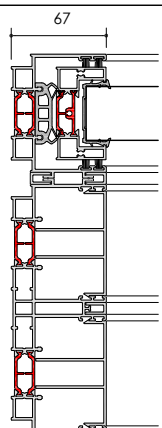
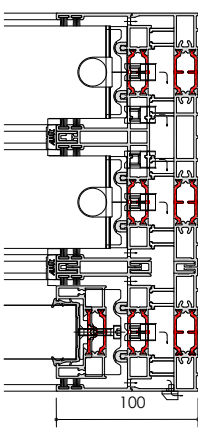
	U_f [W/(m ² .K)]	
	$\epsilon = 0.3$	$\epsilon = 0.9$
	2.9	2.9
	U00021 U00100 N00652 N00653	
	2.9	2.9
	U00021 U00100 N00652 N00653	
	3.1	3.1
	U00021 U00100 N00651 N00652 N00653	
	2.9	2.9
	U00021 U00100 N00651 N00652 N00653	

► THERMAL TRANSMITTANCE (U_f)

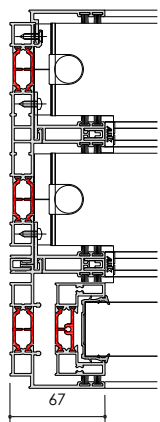
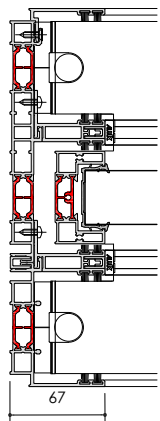
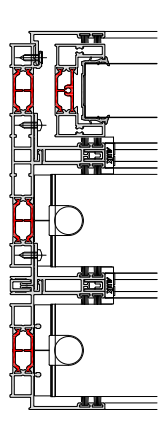
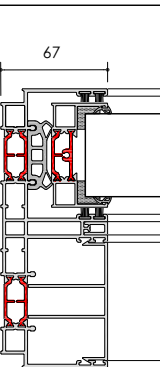
	U_f [W/(m ² .K)]	
	$\epsilon = 0.3$	$\epsilon = 0.9$
	-	11.6
	N00120 N00120	
	-	11.7
	N00121 N00120	
	-	12.6
	N00120 N00121	
	-	12.8
	N00121 N00121	

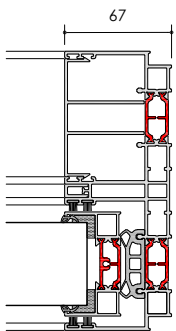
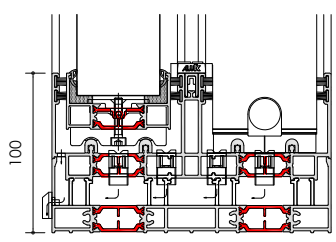
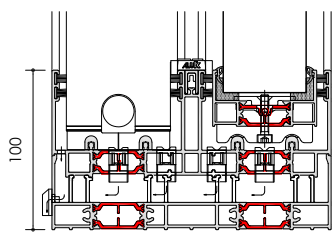
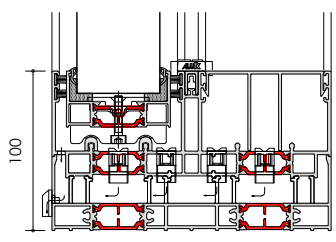
	U_f [W/(m ² .K)]	
	$\epsilon = 0.3$	$\epsilon = 0.9$
	-	9.5
	N00124 N00124	
	-	8.4
	N00124 N00120	
	-	9.2
	N00120 N00124	
	-	9.1
	N00124 N00121	

► THERMAL TRANSMITTANCE (U_f)

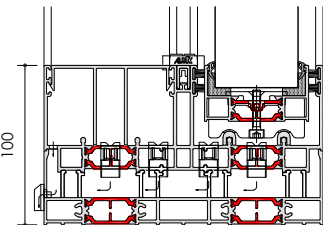
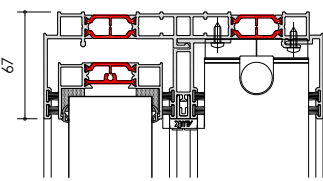
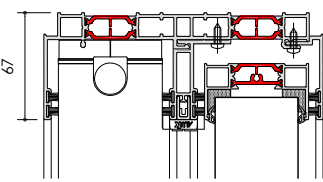
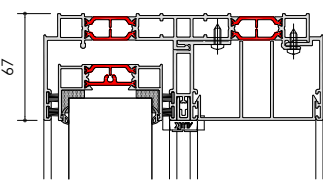
		U _f [W/(m².K)]				U _f [W/(m².K)]	
		ε = 0.3	ε = 0.9			ε = 0.3	ε = 0.9
		-	9.3			2.49	2.54
	N00121 N00124						
		2.69	2.94			2.92	2.98
	U00101 U00500 N00654 N00901						
		1.71	1.89			3.09	3.16
	U00100 U00101 U00500 U00600 N00650						
		2.72	2.78			3.19	3.26
	U00000 U00022 U00100 N00651 N00654						

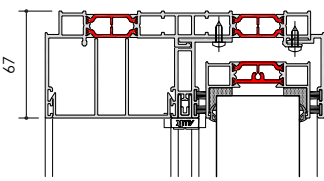
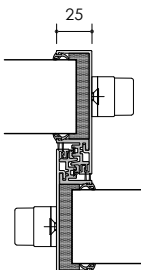
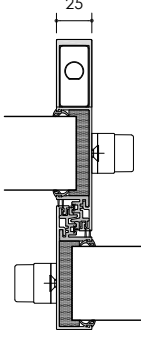
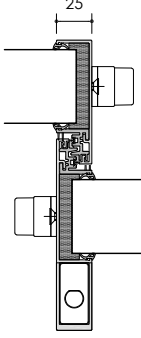
► THERMAL TRANSMITTANCE (U_f)

	U_f [W/(m ² .K)]	
	$\epsilon = 0.3$	$\epsilon = 0.9$
	3.25	3.32
	U00001 U00023 U00100 N00652 N00653 N00654	
	3.13	3.16
	U00001 U00023 U00100 N00652 N00653 N00654	
	2.88	2.93
	U00001 U00023 U00100 N00652 N00653 N00654	
	2.57	2.63
	U00020 U00102 N00651	

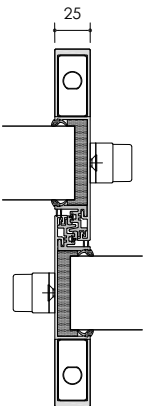
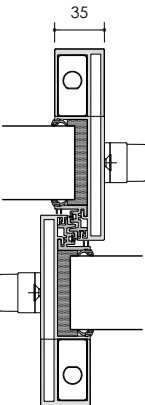
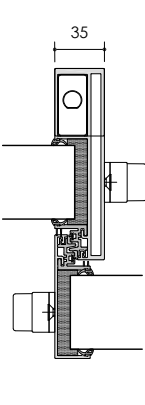
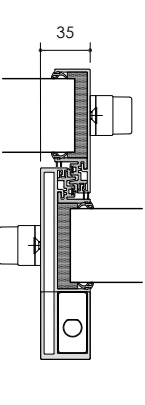
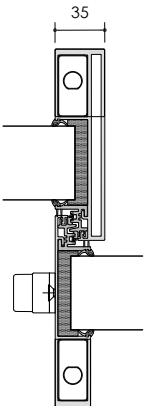
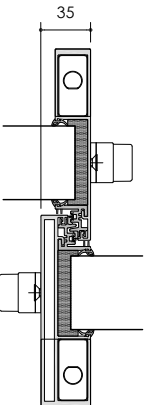
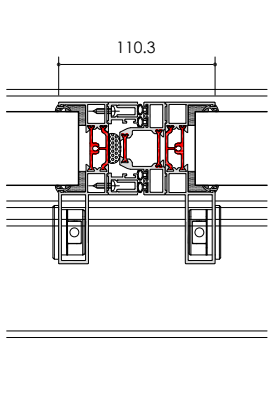
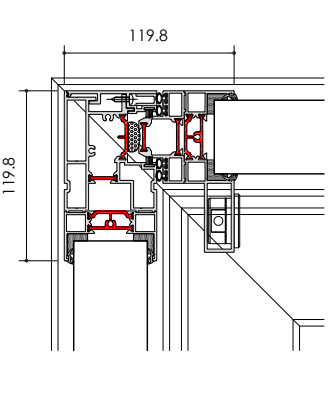
	U_f [W/(m ² .K)]	
	$\epsilon = 0.3$	$\epsilon = 0.9$
	2.41	2.46
	U00020 U00102 N00651	
	2.87	2.94
	U00020 U00102 U00630	
	2.86	2.92
	U00020 U00102 U00630 N00651	
	2.87	2.94
	U00020 U00102 U00630 N00651	

► THERMAL TRANSMITTANCE (U_f)

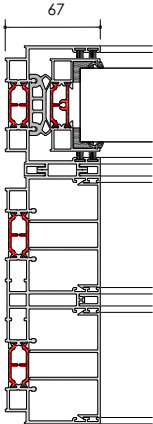
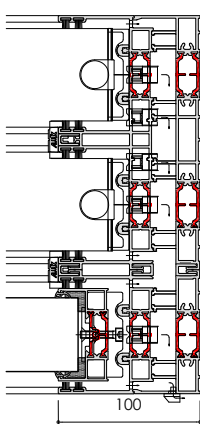
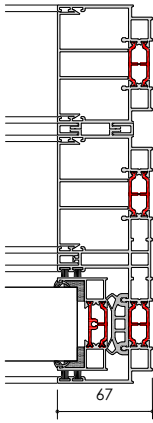
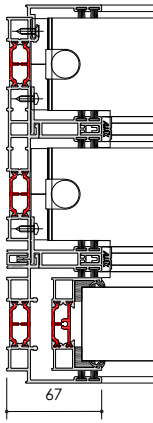
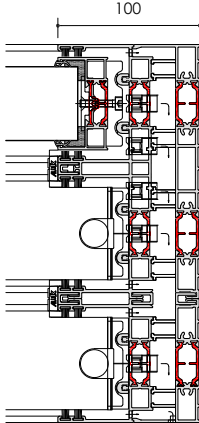
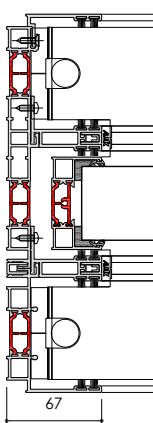
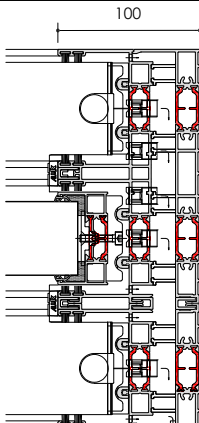
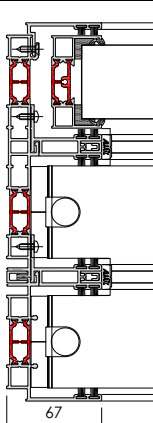
	U_f [W/(m².K)]	
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	2.86	2.92
	U00020 U00102 U00630 N00651	
	3.02	3.08
	U00021 U00102 N00652 N00653	
	2.77	2.82
	U00021 U00100 N00652 N00653	
	3.02	3.08
	U00021 U00100 N00651 N00652 N00653	

	U_f [W/(m².K)]	
	$\epsilon = 0.3$	$\epsilon = 0.9$
	2.77	2.82
	U00021 U00100 N00651 N00652 N00653	
	-	8.70
	N00122 N00122	
	-	8.81
	N00123 N00122	
	-	9.52
	N00122 N00123	

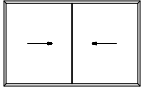
► THERMAL TRANSMITTANCE (U_f)

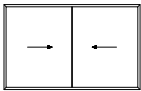
		U_f [W/(m ² .K)]	
		$\epsilon = 0.3$	$\epsilon = 0.9$
		-	9.69
	N00123 N00123		
		-	5.84
	N00125 N00125		
		-	6.54
	N00125 N00122		
		-	7.18
	N00122 N00125		
		-	7.17
	N00125 N00123		
		-	7.30
	N00123 N00125		
		2.63	2.87
	U00103 U00500 N00654 N00901		
		1.69	1.86
	U00102 U00103 U00500 U00600 N00650		

► THERMAL TRANSMITTANCE (U_f)

		U _f [W/(m².K)]				U _f [W/(m².K)]	
		ε = 0.3	ε = 0.9			ε = 0.3	ε = 0.9
		2.63	2.69			2.88	2.94
		U00000 U00022 U00102 N00651 N00654				U00000 U00022 U00102 U00631 U00632 N00654	
		2.42	2.47			3.16	3.22
		U00000 U00022 U00102 N00651 N00654				U00001 U00023 U00102 N00652 N00653 N00654	
		2.85	2.91			3.04	3.09
		U00000 U00022 U00102 U00631 U00632 N00654				U00001 U00023 U00102 N00652 N00653 N00654	
		3.02	3.09			2.78	2.83
		U00000 U00022 U00102 U00631 U00632 N00654				U00001 U00023 U00102 N00652 N00653 N00654	

➤ TEST PERFORMANCE

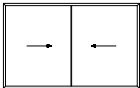
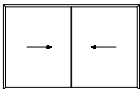
WEATHER TESTING					
MOCK UP	AIR PERMEABILITY EN 1026 EN 12207	WATERTIGHTNESS EN 1027 EN 12208	RESISTANCE TO WIND LOAD EN 12211 EN 12210	OPERATING FORCE EN 12046-2 EN 13115	LAB & TEST REPORT NO.
 L4120 H2640 mm	4	8A (450Pa)	C3 (1200Pa)	1	BSI 8635380 28.11.2016

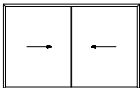
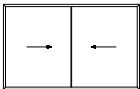
OPERATION AND STRENGTH			
MOCK UP	RESISTANCE TO REPEATED OPENING & CLOSING EN 1191 EN 12400	OPERATING FORCES EN 12046-2 EN 12217	LAB & TEST REPORT NO.
	3 (up to 25000 cycles)	1	BSI 8666307 06.04.2017

This is only a summary of test reports for information purposes only.
For complete information, please refer to the full test report which is available upon request.

TEST PERFORMANCE

THERMAL TRANSMITTANCE		
TYPOLOGY	THERMAL TRANSMITTANCE U_f	LAB & TEST REPORT NO.
Sliding door	EN ISO 10077-2	IRcCOS 1994-CPR-1460 23.01.2017
Sliding door	EN ISO 10077-2	IRcCOS 1994-CPR-1475 23.01.2017
Sliding door	EN ISO 10077-2	IRcCOS 1994-CPR-1671 24.04.2018
Sliding door	EN ISO 10077-2	IRcCOS 1994-CPR-1672 24.04.2018

THERMAL TRANSMITTANCE (U_w)		
 L4000 H2500 mm	DOUBLE GLAZING $\psi = 0.06 \text{ W/mK}$ $U_g = 1.0 \text{ W/m}^2\text{K}$	$U_w = 1.3 \text{ W/m}^2\text{K}$
 L4000 H2500 mm	TRIPLE GLAZING $\psi = 0.04 \text{ W/mK}$ $U_g = 0.6 \text{ W/m}^2\text{K}$	$U_w = 0.9 \text{ W/m}^2\text{K}$

ACOUSTICS PERFORMANCE			
MOCK UP	GLASS COMPOSITION	SOUND INSULATION OF WINDOW EN ISO 10140-2 EN ISO 717-1	LAB & TEST REPORT NO.
 L3000 H2533	66.2 / 16 / 44.2 $R_w = 42 \text{ dB}$	$R_w (C; C_{tr}) = 39 (-1 ; -4) \text{ dB}$	IRcCOS 1994-CPR-RP1545 21.09.2017
 L3000 H2533	66.2 acoustic pvb / 16 / 44.2 acoustics pvb $R_w = 49 \text{ dB}$	$R_w (C; C_{tr}) = 41 (-2 ; -5) \text{ dB}$	IRcCOS 1994-CPR-RP1545 21.09.2017

This is only a summary of test reports for information purposes only.
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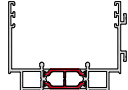
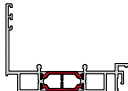
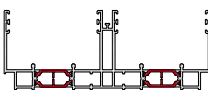
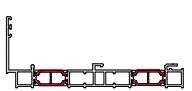
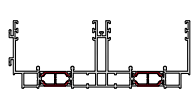
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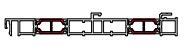
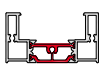
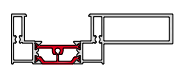
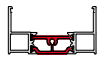
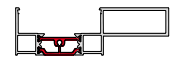
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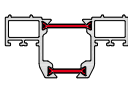
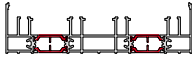
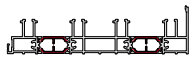
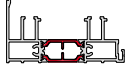


SECTION 2 PROFILE INDEX

	CODE	DESCRIPTION	L [m]	I _x [cm ⁴]	I _y [cm ⁴]	PAG.
	U00000	Single Track Outer Frame (Cill & Jamb)	6.8	23.00	67.28	5.05
	U00001	Single Track Outer Frame (Head)	6.8	13.86	53.23	5.05
	U00020	2 Track Outer Frame (Cill & Jamb)	6.8	47.37	361.61	5.01
	U00021	2 Track Outer Frame (Head)	6.8	17.10	251.17	5.02
	U00022	2 + 1 Tack Outer Frame (Cill & Jamb)	6.8	48.99	390.44	5.03

► PROFILE

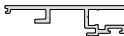
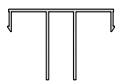
	CODE	DESCRIPTION	L [m]	I _x [cm ⁴]	I _y [cm ⁴]	PAG.
	U00023	2 + 1 Track Outer Frame (Head)	6.8	3.18	200.65	5.04
	U00100	Double Glazed Sash	6.8	25.10	4.57	5.06
	U00101	Reinforced Double Glazed Sash	6.8	86.27	7.63	5.06
	U00102	Triple Glazed Sash	6.8	20.11	2.78	5.07
	U00103	Reinforced Triple Glazed Sash	6.8	74.76	6.59	5.07

	CODE	DESCRIPTION	L [m]	I _x [cm ⁴]	I _y [cm ⁴]	PAG.
	U00500	Meeting Stile (4 Pane & 90° Corner)	4.0	15.37	3.78	5.10
	U00600	90° Corner Post	4.0	57.14	38.17	5.10
	U00630	2 Track Sub Cill	6.8	15.31	388.28	5.11
	U00631	Triple Track Sub Cill (2 + 1)	6.8	13.32	360.55	5.12
	U00632	Triple Track Sub Cill Extension Profile	6.8	7.77	51.32	5.13

► PROFILE

$\frac{X}{Y} \frac{X}{Y}$	CODE	DESCRIPTION	L [m]	I _x [cm ⁴]	I _y [cm ⁴]	PAG.
	N00120	21mm Interlock Profile	6.8	27.44	1.22	5.05
	N00121	21mm Reinforced Interlock Profile	6.8	77.50	3.13	5.05
	N00122	25mm Interlock Profile (Triple Glazed)	6.8	23.39	0.82	5.08
	N00123	25mm Reinforced Interlock Profile (Triple Glazed)	6.8	96.95	9.91	5.09
	N00124	31mm Reinforced Interlock Profile	6.8	151.17	8.01	5.05

➤ PROFILE

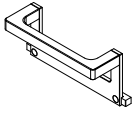
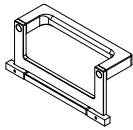
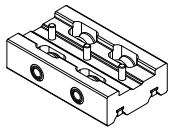
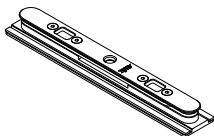
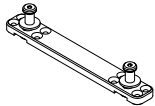
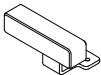
$\frac{X}{Y}$ $\frac{X}{Y}$	CODE	DESCRIPTION	L [m]	I _x [cm ⁴]	I _y [cm ⁴]	PAG.
	N00125	35mm Reinforced Interlock Profile (Triple Glazed)	6.8	184.97	10.93	5.09
	N00632 ANOD.	Aluminium Track (Ø10mm)	6.0	-	-	5.15
	N00650	90° Corner Post Cover Profile	4.0	-	-	5.14
	N00651	Outer Frame Cover Profile	6.8	-	-	5.14
	N00652	Internal Rebate (Outer Frame Head)	6.8	-	-	5.15

► PROFILE

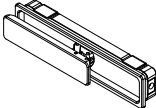
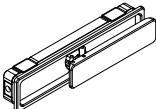
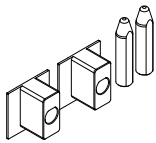
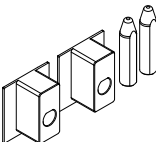
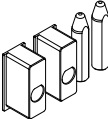
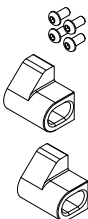
$\frac{X}{Y}$ $\frac{X}{Y}$	CODE	DESCRIPTION	L [m]	I _x [cm ⁴]	I _y [cm ⁴]	PAG.
	N00653	Central Rebate (Outer Frame Head)	6.8	-	-	5.15
	N00654* * Only for Aluk.FRA P8005	Connector Clip	6.5	-	-	5.15
	N00901	Meeting Stile Adaptor	6.8	-	-	5.15

SECTION 3
HARDWARE &
ACCESSORY

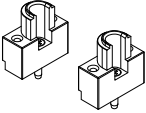
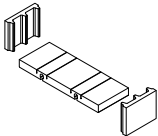
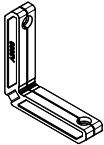
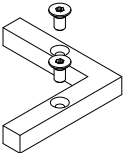
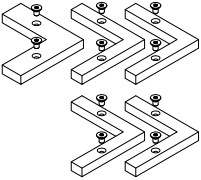
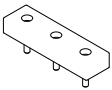
HARDWARE & ACCESSORY

IMAGE	CODE	DESCRIPTION	FINISH	UNIT
	H00100	Lateral locking handle (Internal)	Silver Anod.	1
	H00101	Lateral pull handle (External)	Silver Anod.	1
	H00200	Rollers (Polymer wheels)	-	1
	H00400	Lateral Lock	-	1
	H00401	Lateral lock adjustable keep	-	1
	H00404	Lateral lock lever (Internal)	Silver Anod.	1

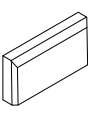
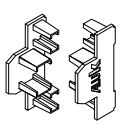
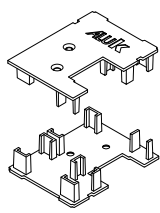
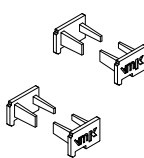
➤ HARDWARE & ACCESSORY

IMAGE	CODE	DESCRIPTION	FINISH	UNIT
	H00405	RH Interlock gearbox & Handle	Silver Anod.	1
	H00412	LH Interlock gearbox & Handle	Silver Anod.	1
	H00406	Shootbolt kit (Double glazed Interlock) Use with N00121 & N00124	-	1
	H00408	Shootbolt kit (Triple glazed Interlock) Used with N00123 & N00125	-	1
	H00409	Shootbolt kit (Reinforced Sash) U00101 & U00103	-	1
	H00410	Internal Sash Keep Used with U00101, U00103, N00121, N00123, N00124 & N00125	-	1 PR

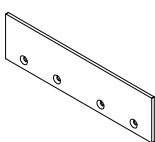
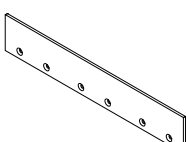
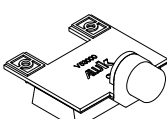
➤ HARDWARE & ACCESSORY

IMAGE	CODE	DESCRIPTION	FINISH	UNIT
	H00411	External Sash Keep Used with U00101, U00103, N00121, N00123, N00124 & N00125	-	1 PR
	V20000	Interlock Foam Plug	Grey	2
 * Only for Aluk.FRA A8008	V42000 *	Mechanical cleat (13mm)	-	8
	V42001	90 Deg. corner cleat (13mm) (Including 16off M6 x 12mm Csk Screws)	-	8
	V42016	90 Deg. sub cill corner cleat (Including 10off M6 x 12mm Csk Screws)	-	1
	V50001	Fixed sash support blocks (Including 6off M5 x 22 Cap Head Screws)	Black	2

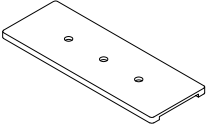
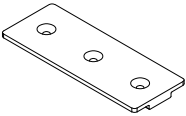
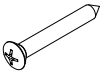
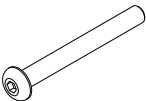
➤ HARDWARE & ACCESSORY

IMAGE	CODE	DESCRIPTION	FINISH	UNIT
	V51001 * * Only for Aluk.ITA/GBR 709616	Ø10.5mm Hole Plug	Black	100
	V51002 * * Only for Aluk.ITA/GBR 709617	Ø10.5mm Hole Plug	White	100
	V51003 * * Only for Aluk.ITA/GBR 712007	Water Drain Cap With Valve	Black	20
	V52020	End cap for meeting stile (U00500)	Black	1 PR
	V58001	End cap for corner post (U00600) LH & RH per kit	Black	1 PR
	V58002	End cap for meeting stile adaptor (N00901) LH & RH per kit	Black	2 PR

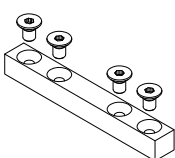
➤ HARDWARE & ACCESSORY

IMAGE	CODE	DESCRIPTION	FINISH	UNIT
	V51004 * * Only for Aluk.ITA/GBR 712008	Water Drain Cap With Valve	White	20
	V51005 * * Only for Aluk.GBR A-00-225	Storm valve	Black	20
	V53003	Interlock seal (EPDM)	Black	2
	V55000	End caps for sub-cill drainage profile	Black	2
	V55034	U00631 & U00632 Sub cill end cap	Black	2
	V58000	Interlock end cap	Black	2

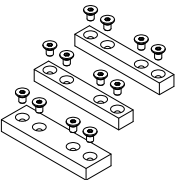
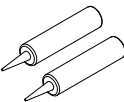
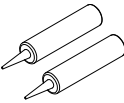
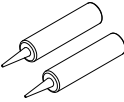
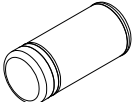
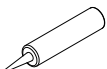
➤ HARDWARE & ACCESSORY

IMAGE	CODE	DESCRIPTION	FINISH	UNIT
	V59047	Triple glazed sash bridge packer	Black	2
	V62000	Roller glazing packer	-	1
 * Only for Aluk.FRA 86720	V70000	Mechanical cleat screw	-	50
	V70001	Ø4.2 x 30mm phillips CSK polyamide screw	-	1000
 * Only for Aluk.GBR XS006	V70002 *	Ø4.2 x 16mm pozi CSK s/tap ss screw	-	100
	V70003	M5 x 45mm Socket head machine screw Used with U00600	-	200

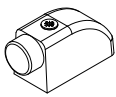
➤ HARDWARE & ACCESSORY

IMAGE	CODE	DESCRIPTION	FINISH	UNIT
	V70004	Ø3.5 x 13mm pozi pan s/tap ss screw	-	1000
	V70005	Ø4.2 x 13mm pozi pan self drill screw	-	100
	V70020	M6 x 3M Thread Bar Used with H00406, H00408 & H00409	-	1
	V72056	M5 x 25mm Socket head machine screw Used with U00500	-	200
	V70057	M5 Rivsert	-	100
	V72029	Frame jointing Kit (Including 16off M6 x 12mm Csk Screws) (L>6500mm)	-	8

➤ HARDWARE & ACCESSORY

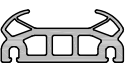
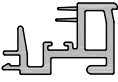
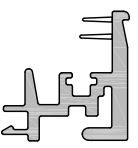
IMAGE	CODE	DESCRIPTION	FINISH	UNIT
	V72030	Sub cill jointing Kit (Including 16 off M6 x 12mm Csk Screws) (L>6500mm)	-	1
	T50000	Small Joint Sealant, 290ml (Black) (1 Box)	Black	12
	T50001	Small Joint Sealant, 290ml (White) (1 Box)	White	12
	T50002	Small Joint Sealant, 290ml (RAL 7016) (1 Box)	Grey	12
	T50003	Aluk Sealant Wipes (1 Box)	-	6
	T50004	Dow Corning 776 Silicone Bond	Black	20

➤ HARDWARE & ACCESSORY

IMAGE	CODE	DESCRIPTION	FINISH	UNIT
	709609	Door Stop	Black	2

SECTION 4
GASKET & PLASTIC
PROFILE

GASKET & PLASTIC PROFILE

SECTION	CODE	DESCRIPTION	MATERIAL	L [m]
	V00000 * Only for Aluk.IT 809119	2 - 3mm Wedge Gasket	EPDM [Black]	280
	V02000	Co Extruded Interlock Seal	Q-Lon	300
	V04000	38mm Double Glazed U-Gasket (70ShA) 38mm	EPDM [Black]	100
	V09000	Frame Bumper Seal (70ShA)	EPDM [Black]	4
	V31000	Double Glazed PVC Interlock	PVC [Black]	4
	V31008	Triple Glazed PVC Interlock	PVC [Black]	4

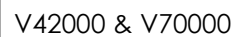
➤ GASKET & PLASTIC PROFILE

SECTION	CODE	DESCRIPTION	MATERIAL	L [m]
	V10000 * * Only for Aluk.GBR XA621	Sliding Seal / Fin pile 6.9mm x 8.5mm 6.9mm x 8.5mm	Woolpile [Black]	350
	V90015 * Only for Aluk.IT 809688	Door central gasket	PE [Grey]	20
	V03012 * Only for Aluk.FR J8002	Sliding Seal	EPDM [Grey]	100



SECTION 5 PROFILE SECTION

PROFILE SECTION



Or



* Frame extender L
> 6500mm



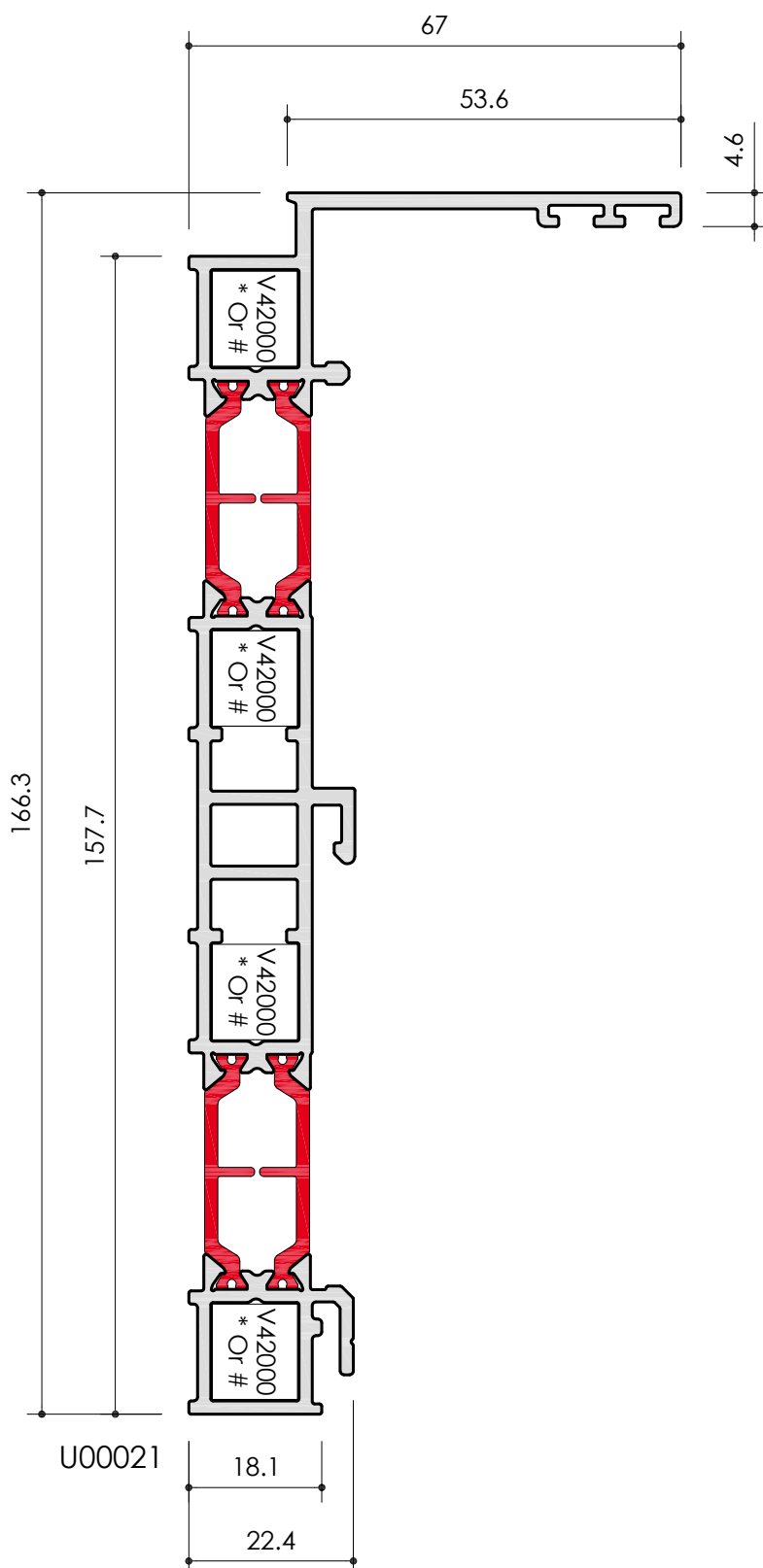
90° Corner Cleat



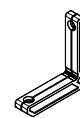
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➤ PROFILE SECTION

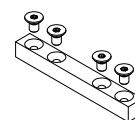


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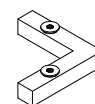
V42000 & V70000

Or



V72029 *

* Frame extender L
> 6500mm

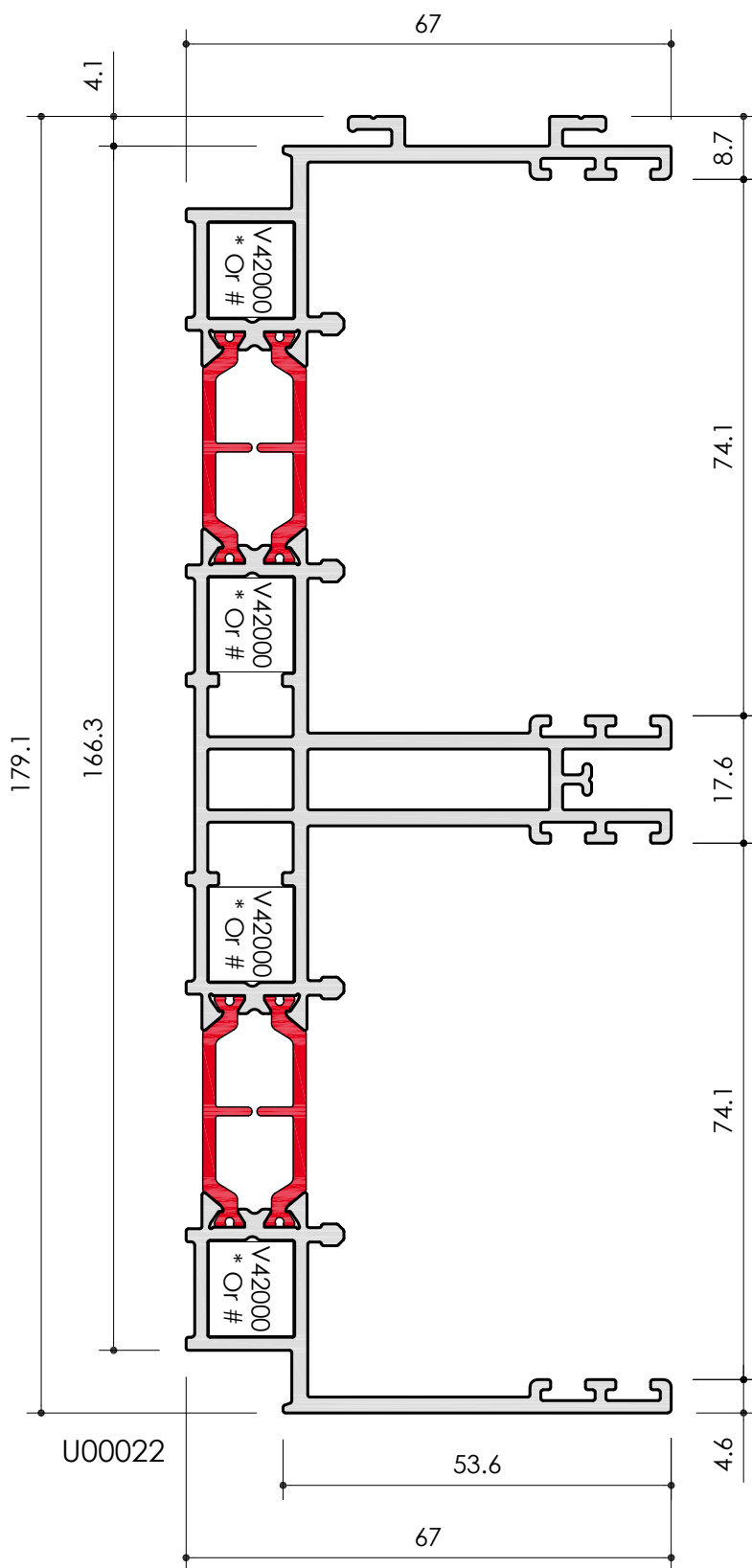


V42016 #

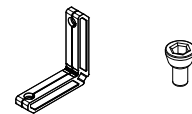
90° Corner Cleat

Scale 1 : 1

➤ PROFILE SECTION

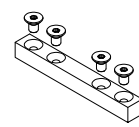


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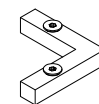
V42000 & V70000

Or



V72029 *

* Frame extender L
> 6500mm

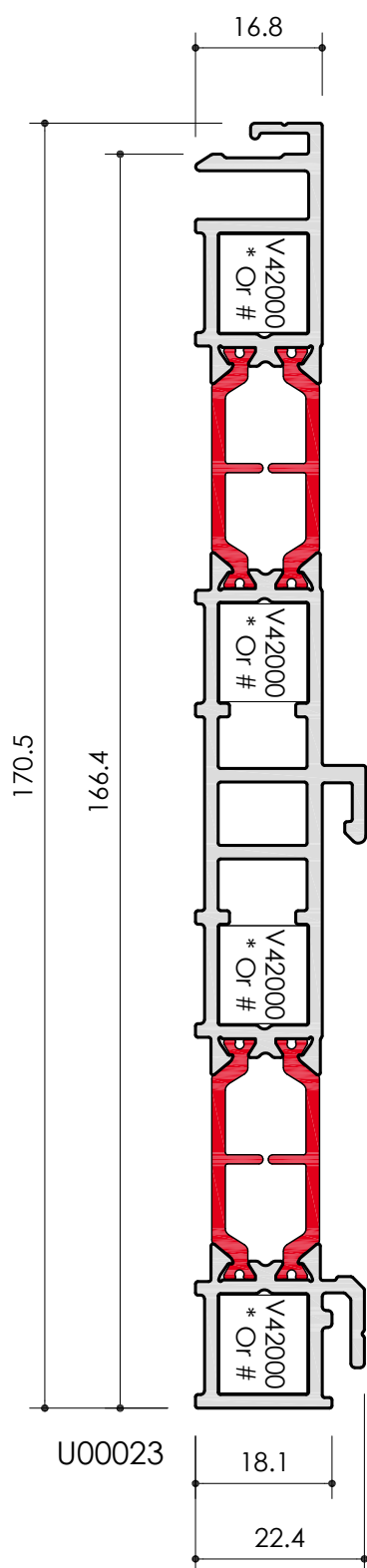


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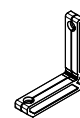
90° Corner Cleat

Scale 1 : 1

➤ PROFILE SECTION

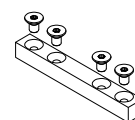


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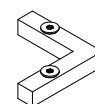
V42000 & V70000

Or



V72029 *

* Frame extender L
> 6500mm

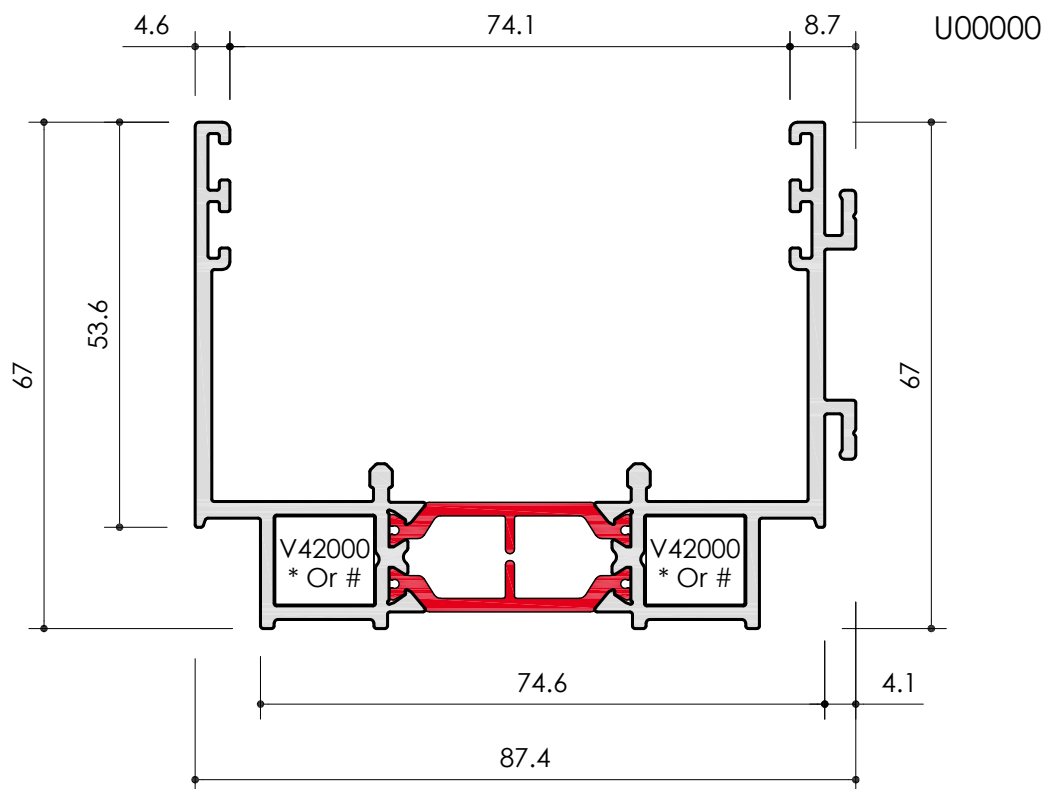


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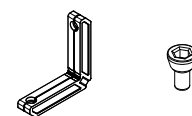
90° Corner Cleat

Scale 1 : 1

➤ PROFILE SECTION

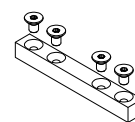


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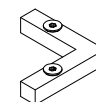
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Or



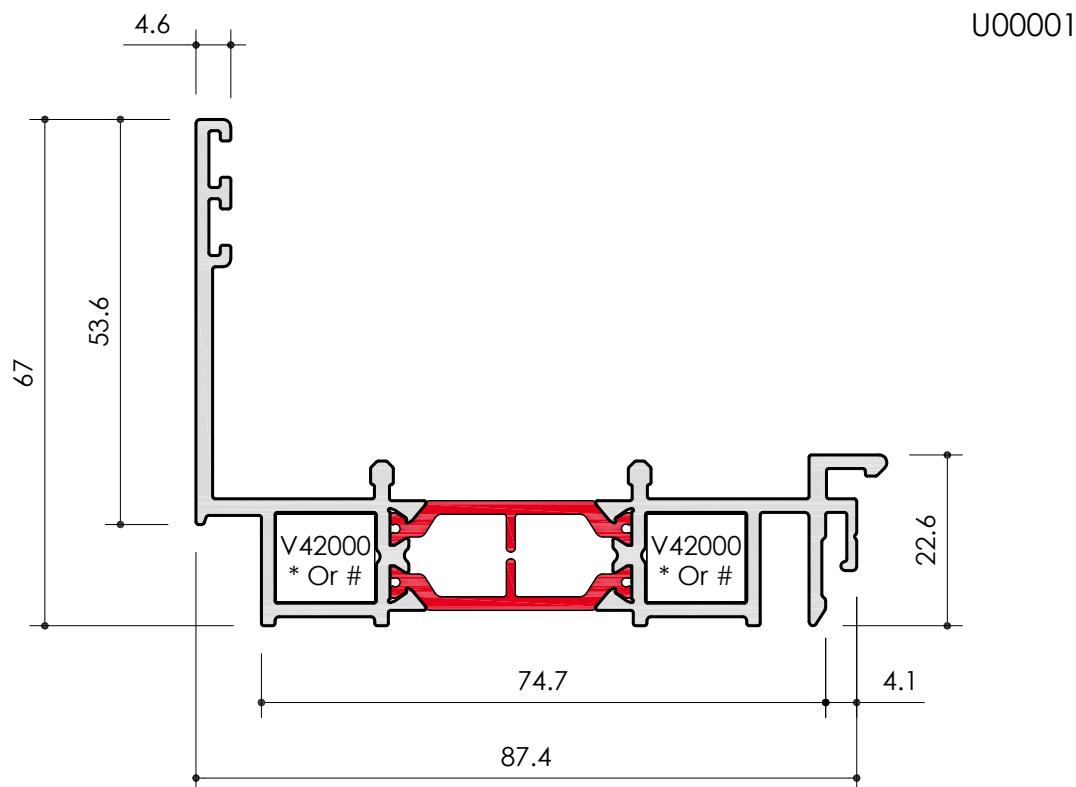
V72029 *

* Frame extender L
> 6500mm



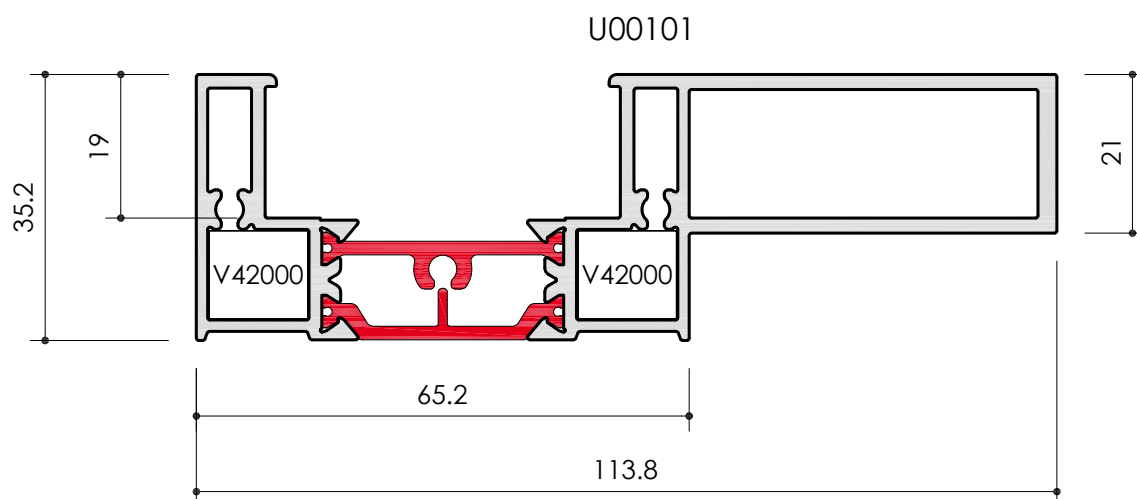
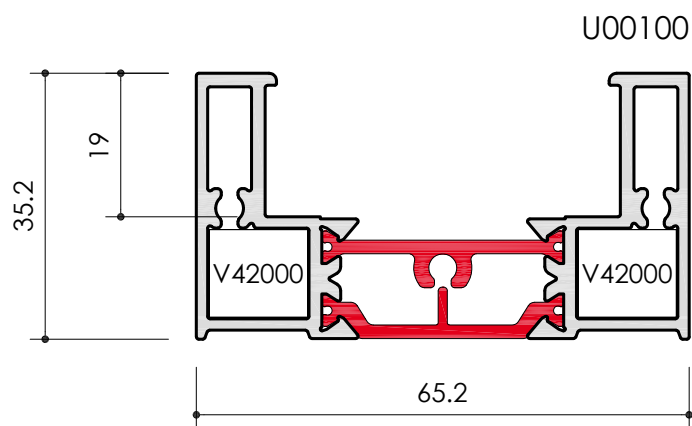
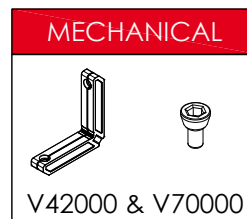
V42016 #

90° Corner Cleat



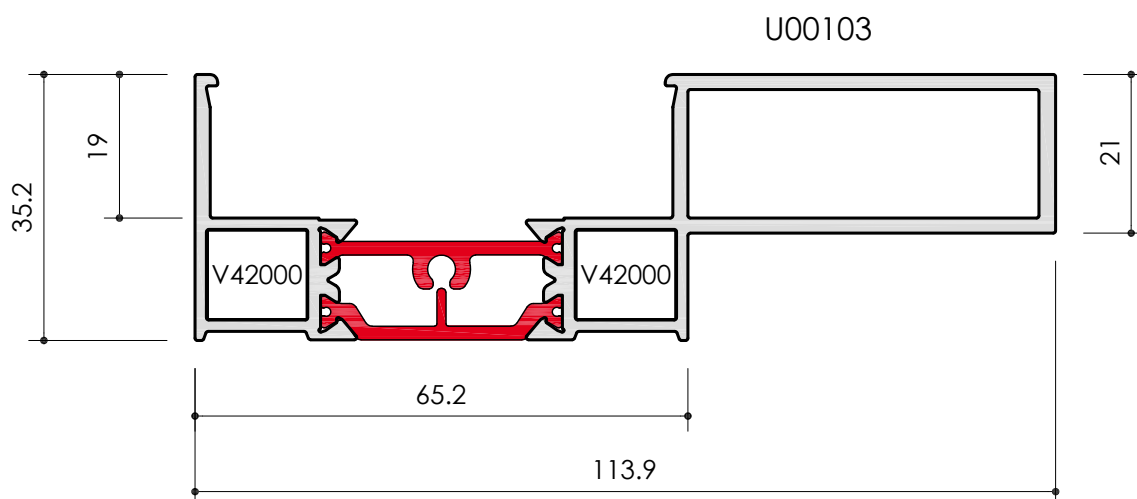
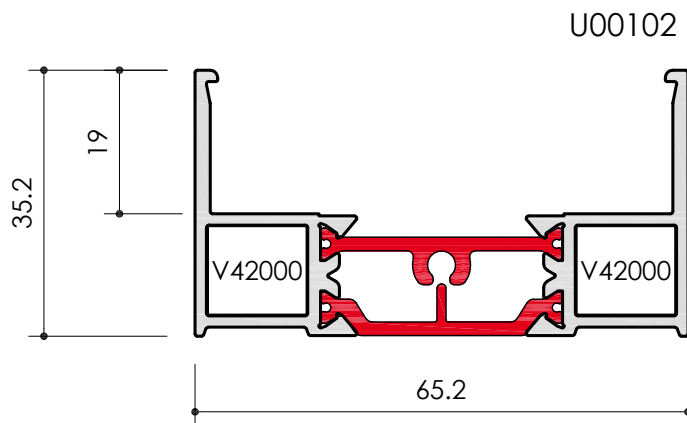
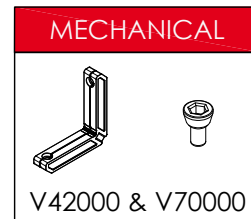
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➤ PROFILE SECTION



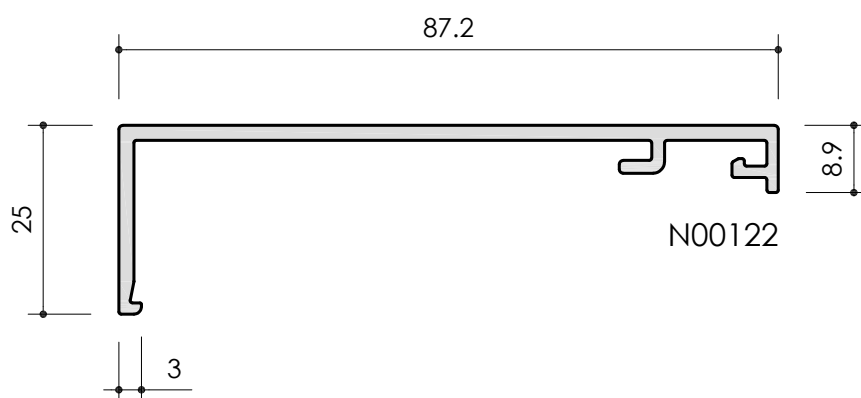
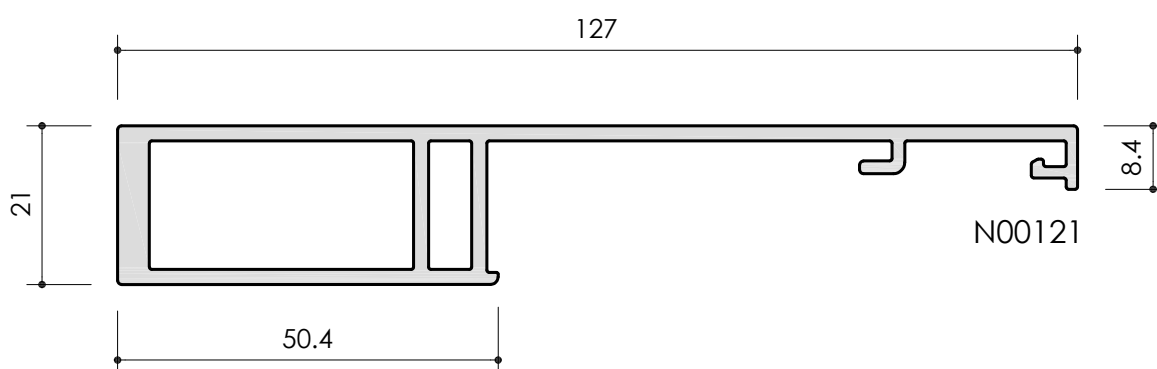
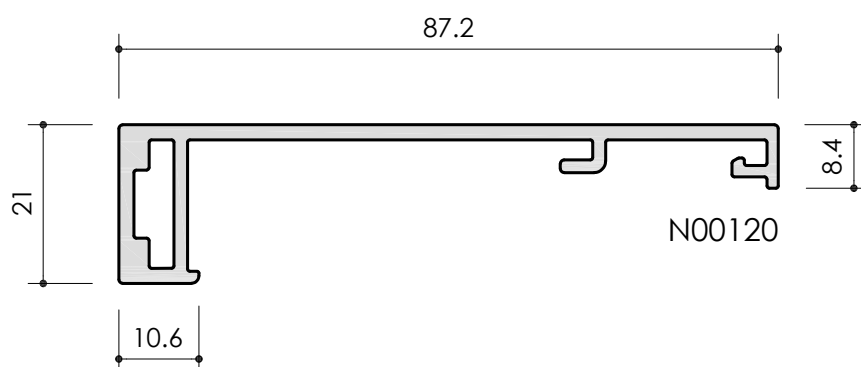
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➤ PROFILE SECTION



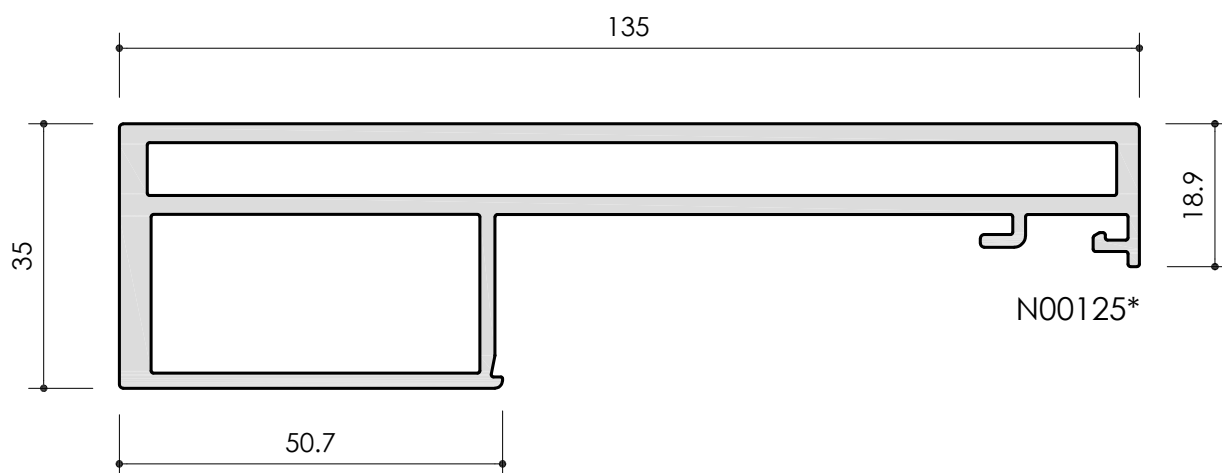
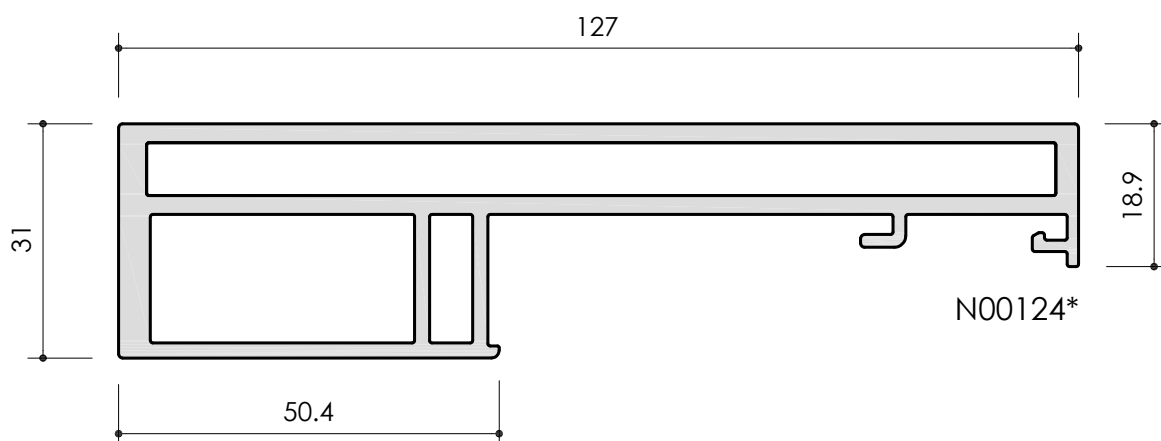
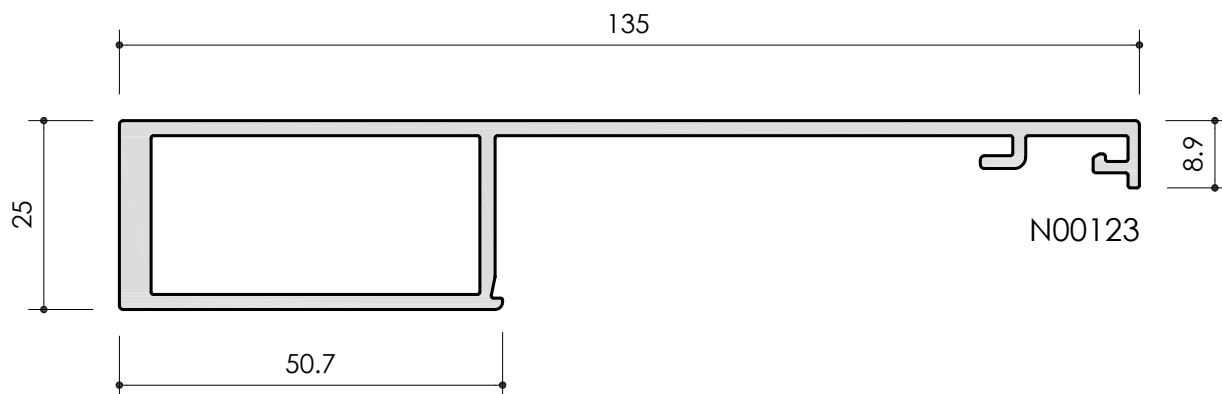
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► PROFILE SECTION



Scale 1 : 1

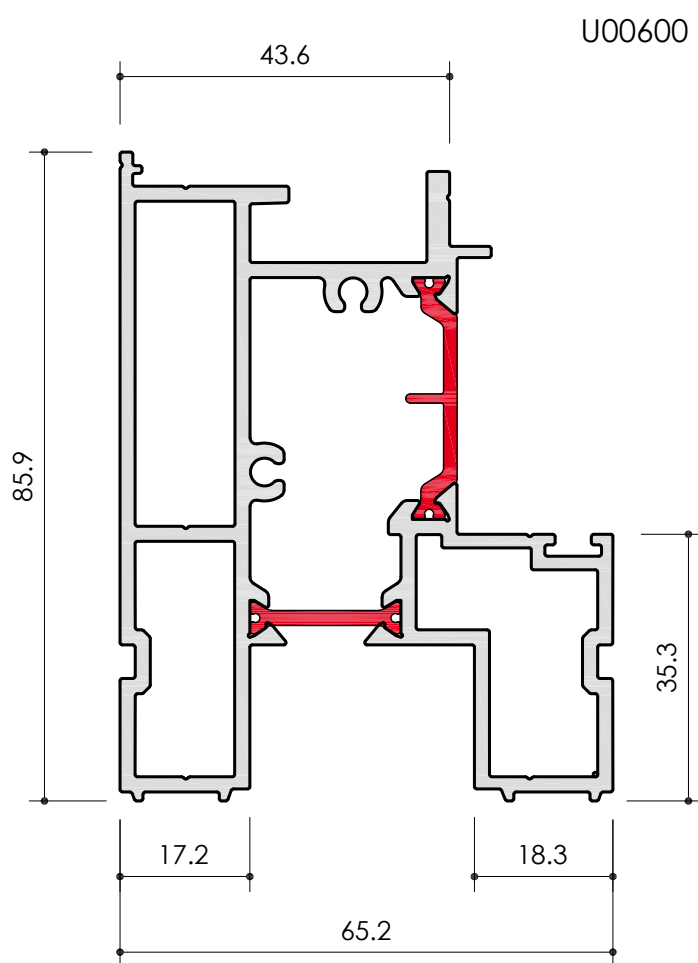
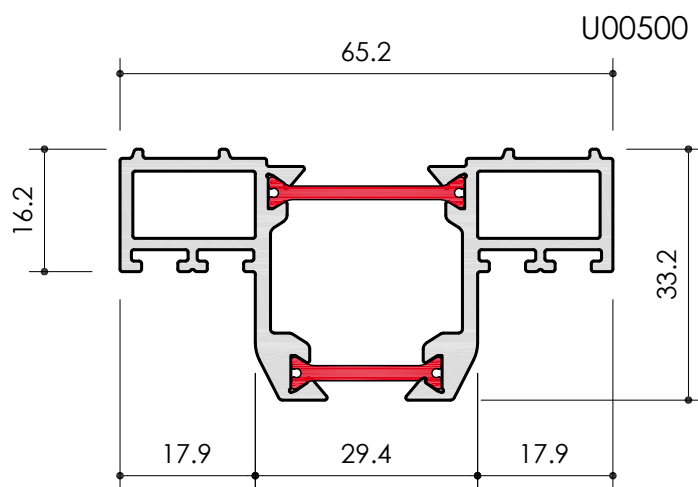
► PROFILE SECTION



* Reinforced profile to fit N00124 / N00125 = 5mm x 100mm

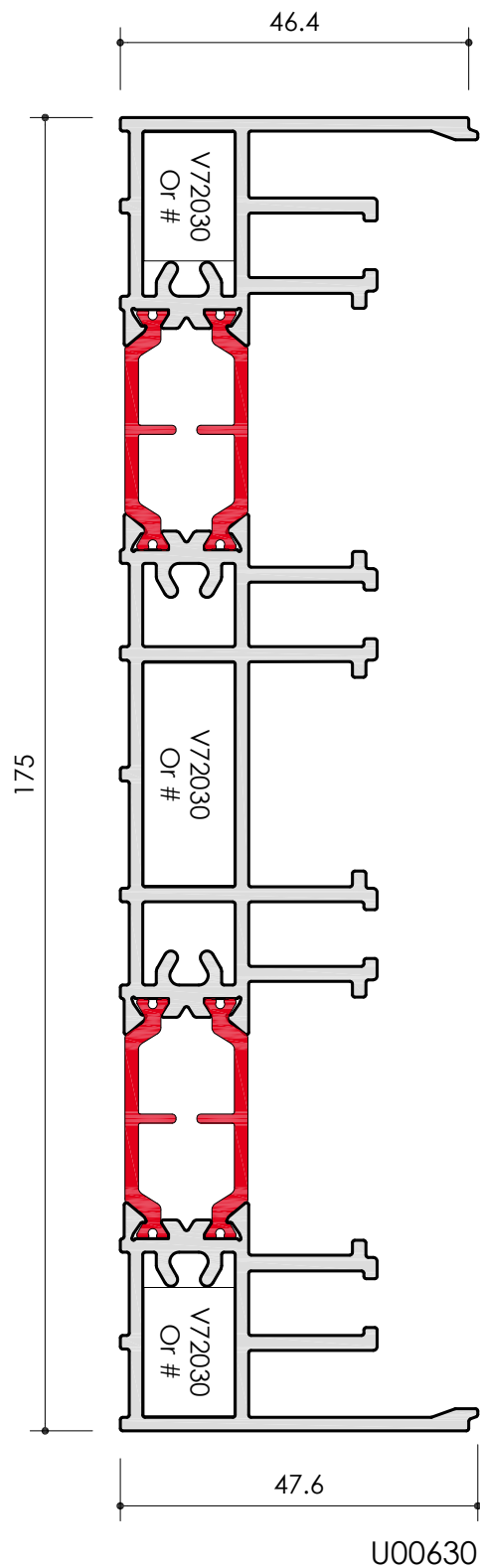
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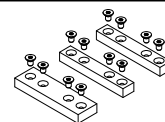


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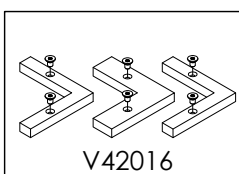
MECHANICAL



V72030

* Frame extender L
> 6500mm

Or

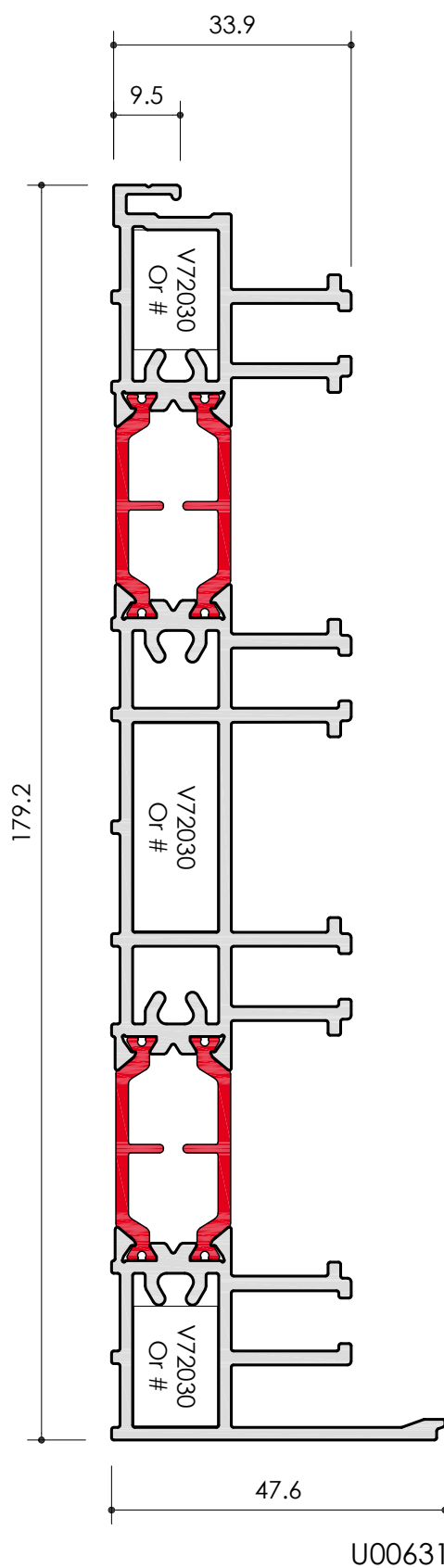


V42016

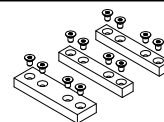
90° Corner Cleat

Scale 1 : 1

➤ PROFILE SECTION



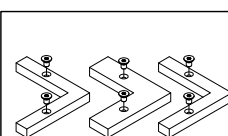
MECHANICAL



V72030

* Frame extender L
> 6500mm

Or



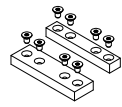
V42016

90° Corner Cleat

Scale 1 : 1

➤ PROFILE SECTION

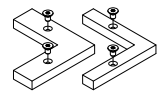
MECHANICAL



V72030

* Frame extender L
> 6500mm

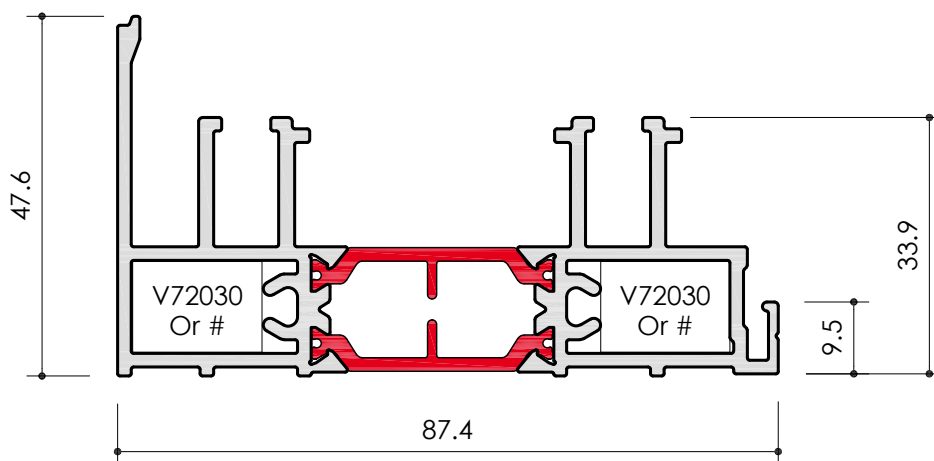
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V42016

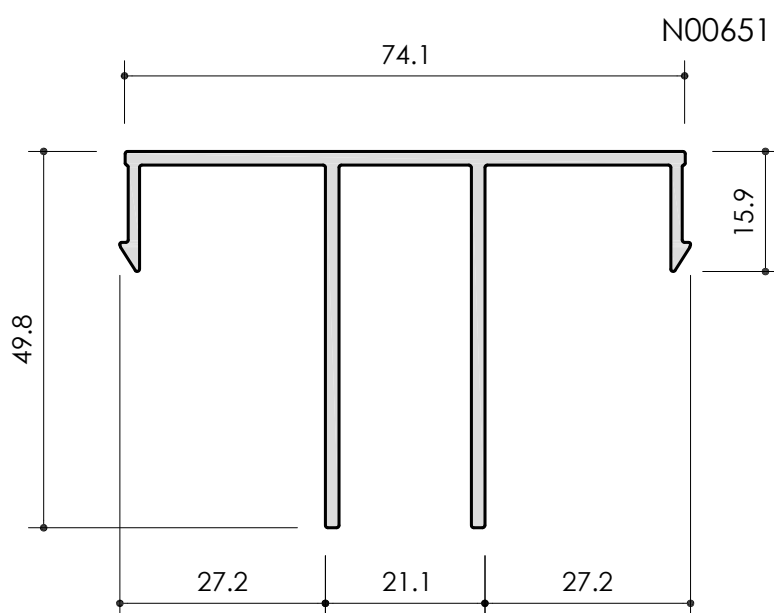
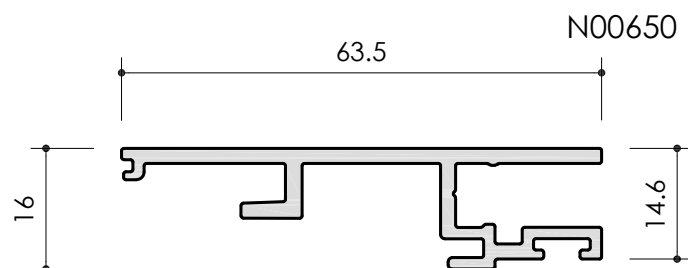
90° Corner Cleat

U00632



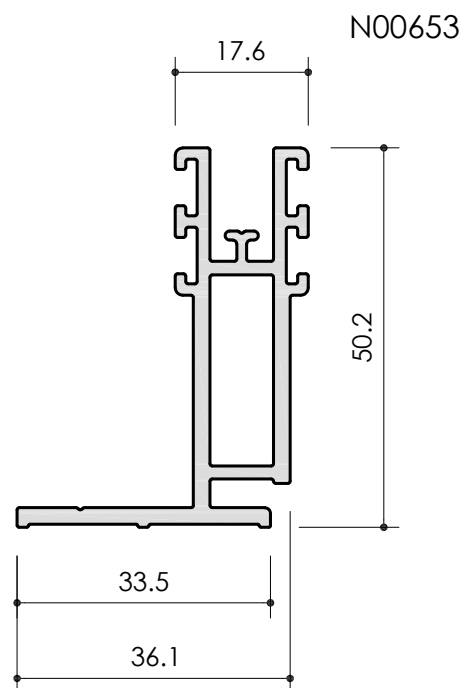
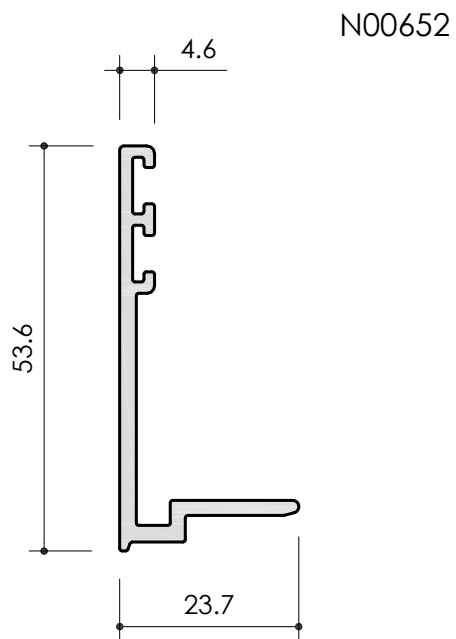
Scale 1 : 1

➤ PROFILE SECTION

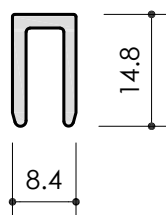


Scale 1 : 1

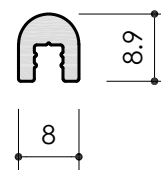
➤ PROFILE SECTION



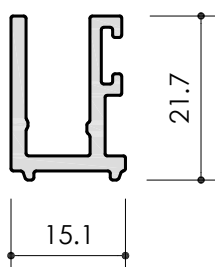
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N00632



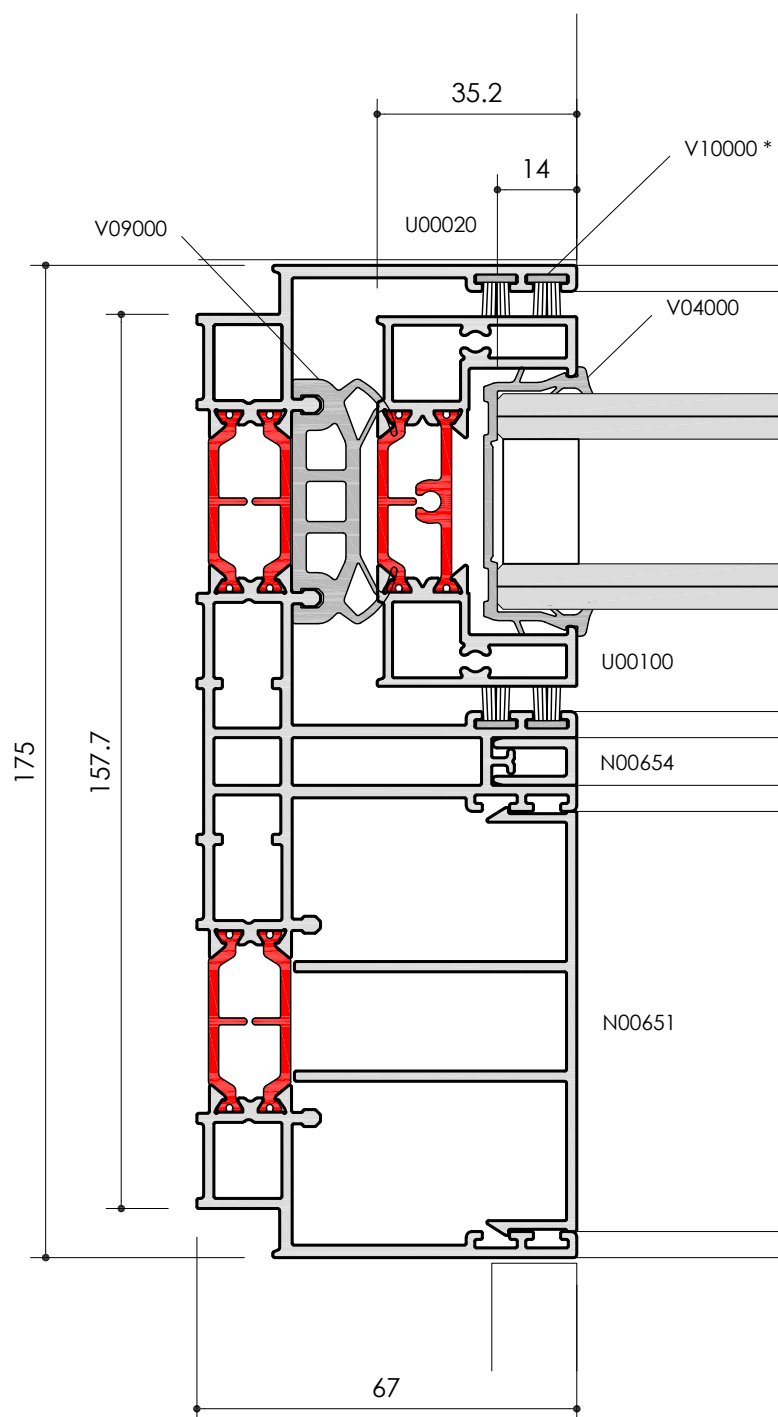
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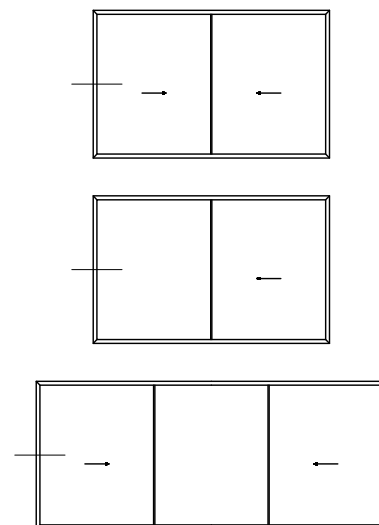
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SECTION 6
TYPICAL DETAIL

TYPICAL DETAIL



JAMB SECTIONS



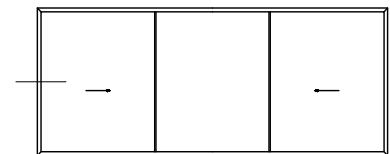
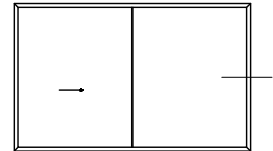
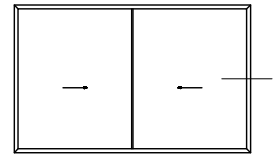
Scale 1 : 1.3

* V10000 = Only for Aluk.GBR: XA621

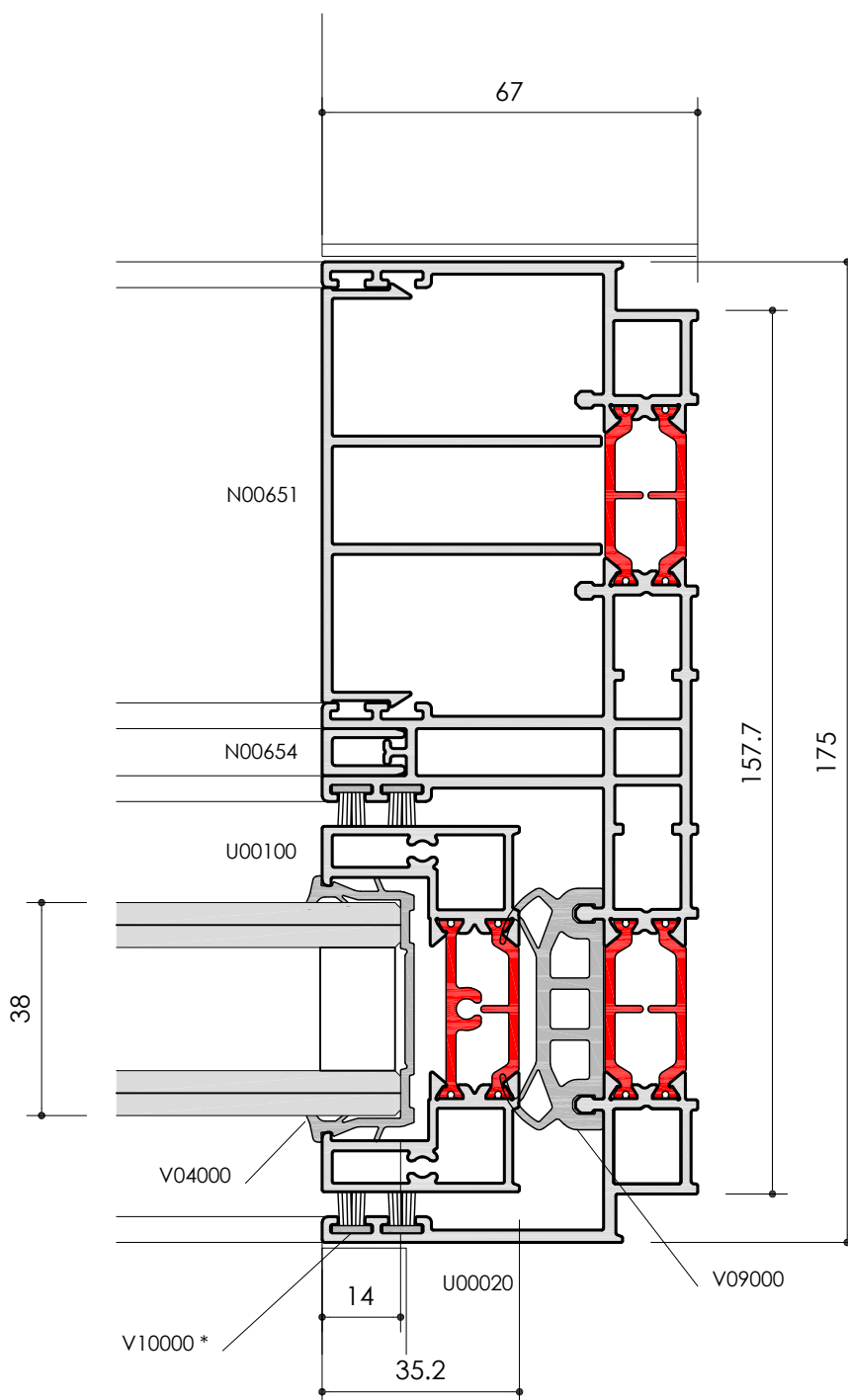
N.B. Gasket & Glazing Configurations are shown in section 7

➤ TYPICAL DETAIL

JAMB SECTIONS



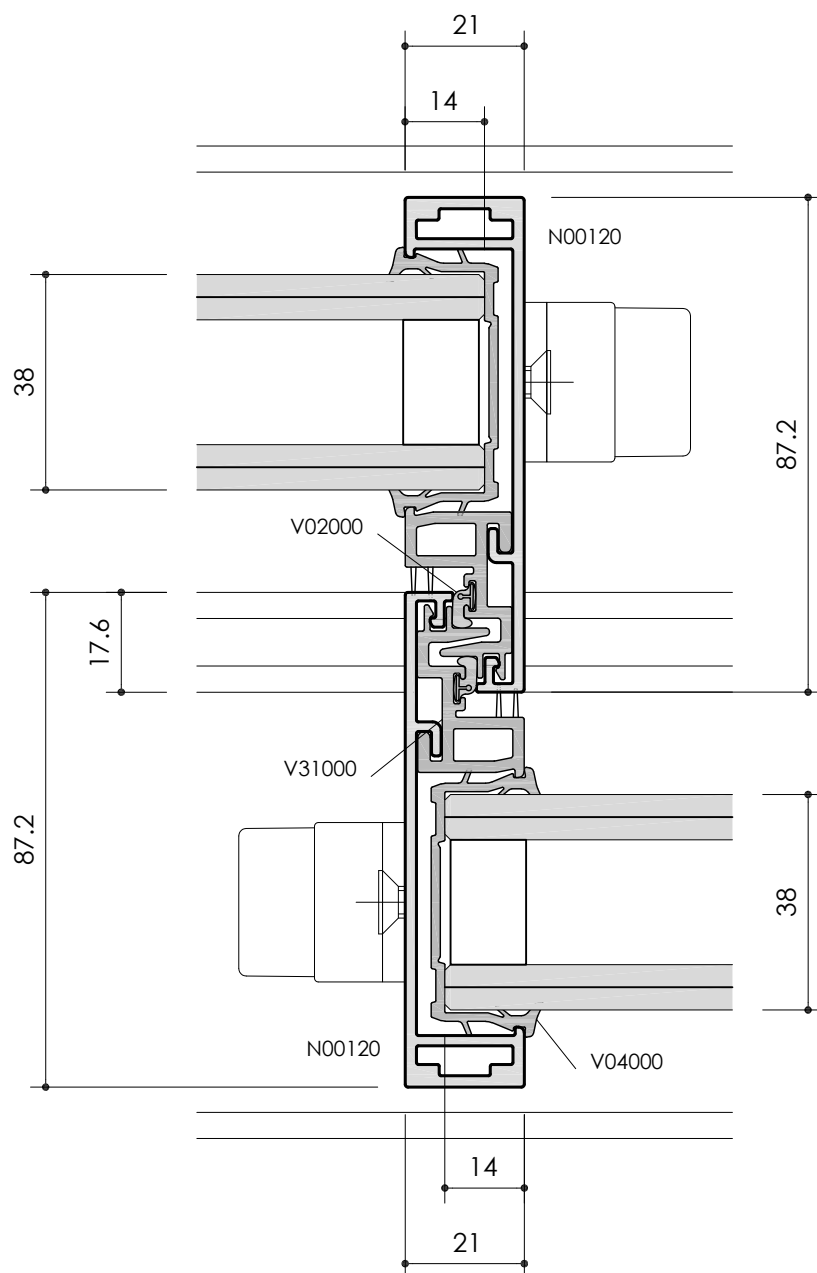
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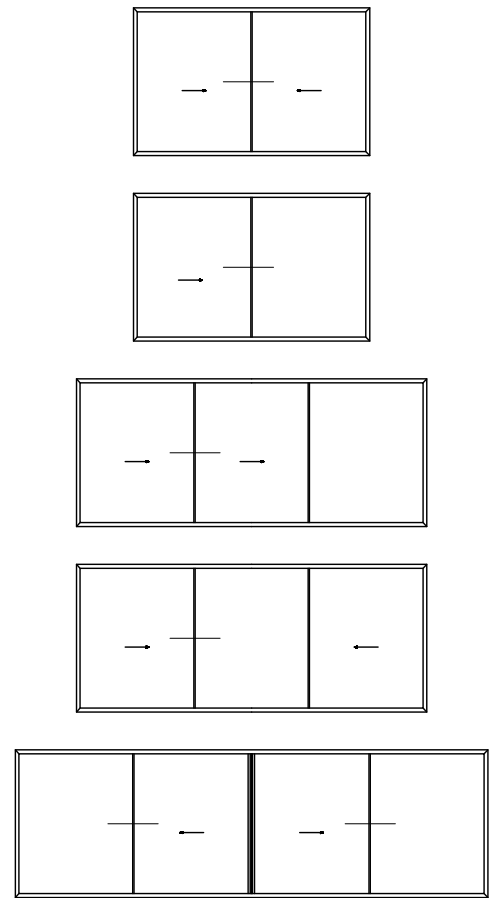
* V10000 = Only for Aluk.GBR: XA621

N.B. Gasket & Glazing Configurations are shown in section 7

> TYPICAL DETAIL



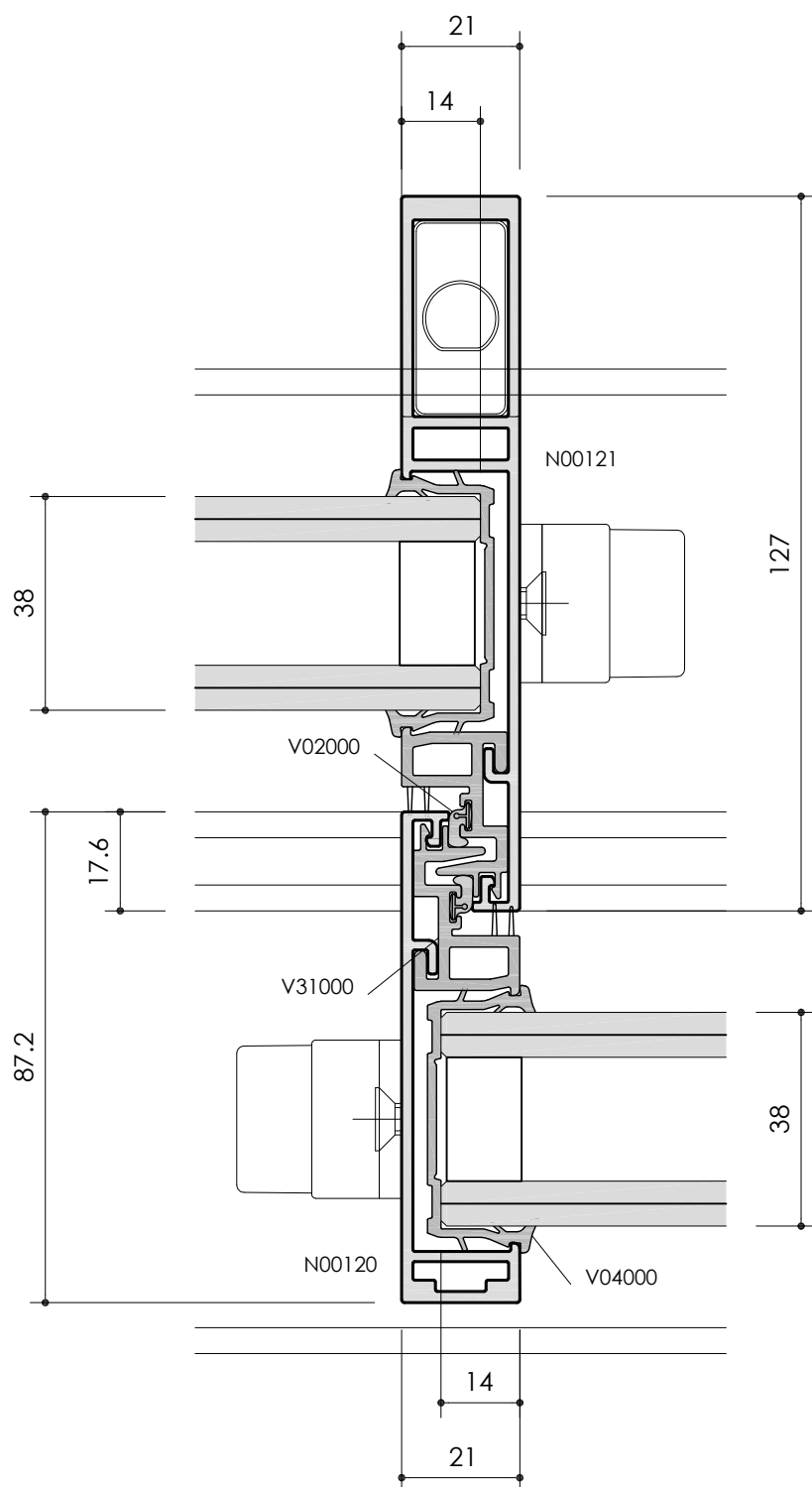
INTERLOCK SECTIONS



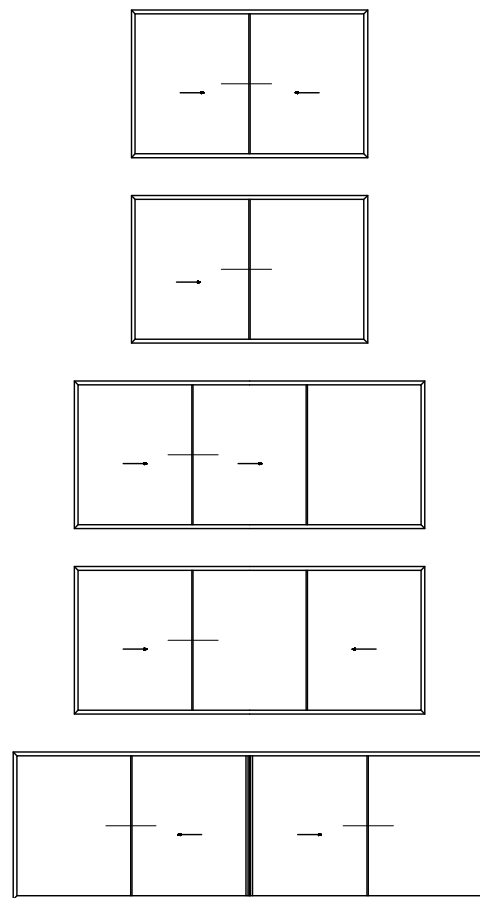
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N.B. Gasket & Glazing Configurations are shown in section 7

➤ TYPICAL DETAIL



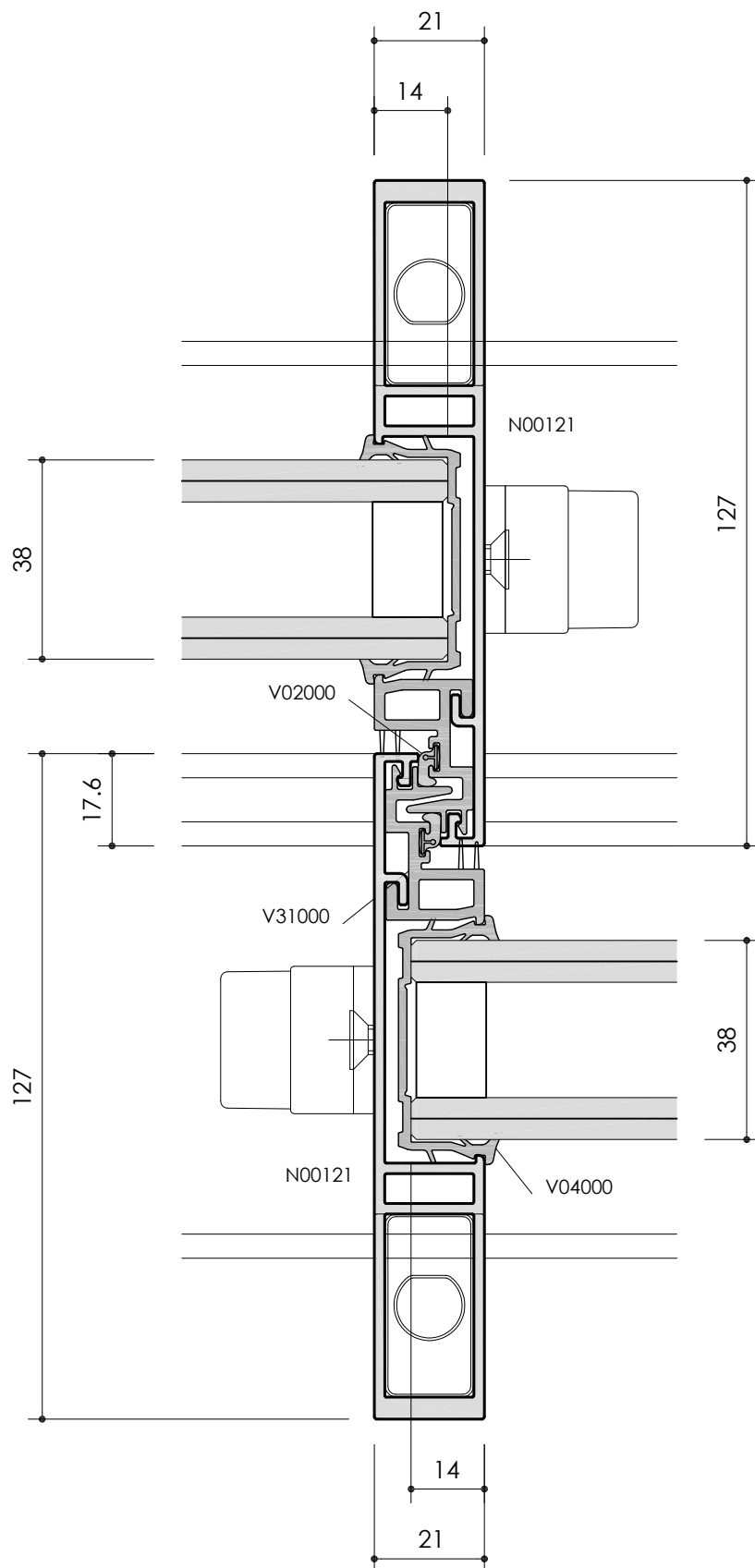
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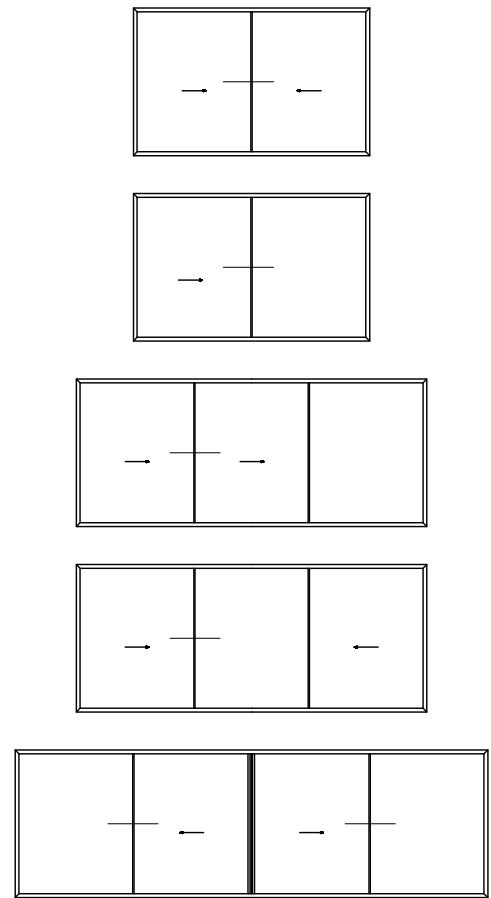
Scale 1 : 1.3

N.B. Gasket & Glazing Configurations are shown in section 7

➤ TYPICAL DETAIL



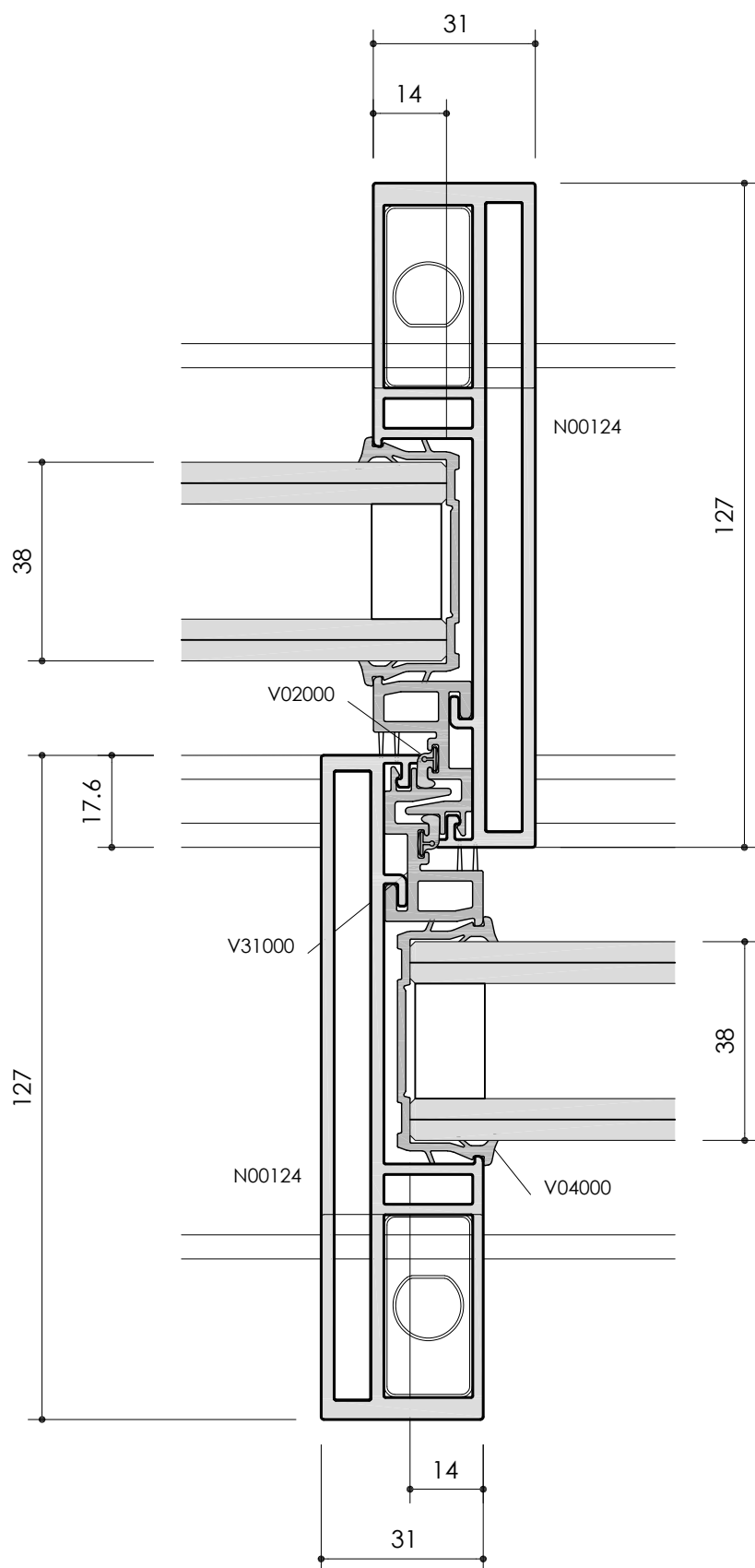
INTERLOCK SECTIONS



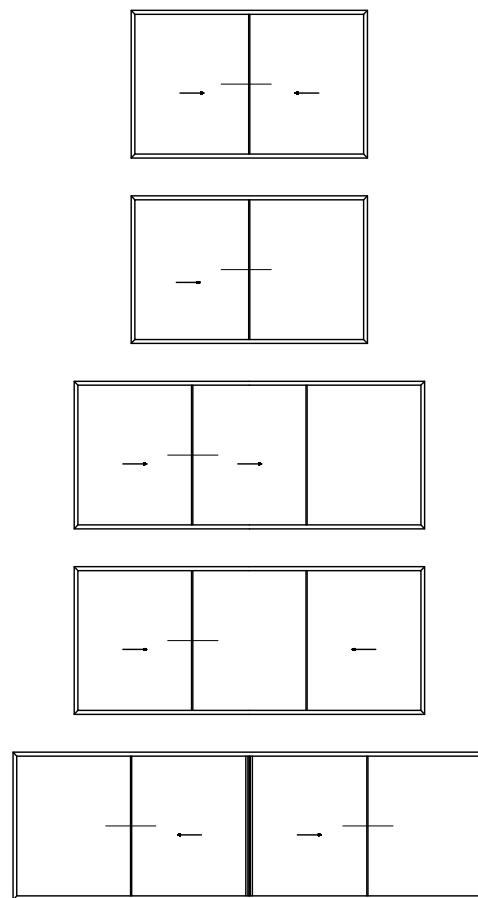
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N.B. Gasket & Glazing Configurations are shown in section 7

► TYPICAL DETAIL



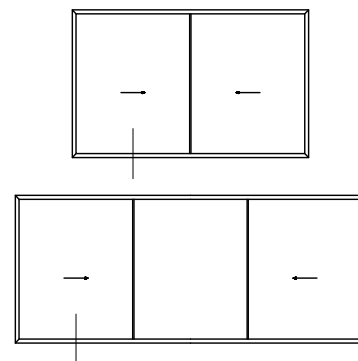
INTERLOCK SECTIONS



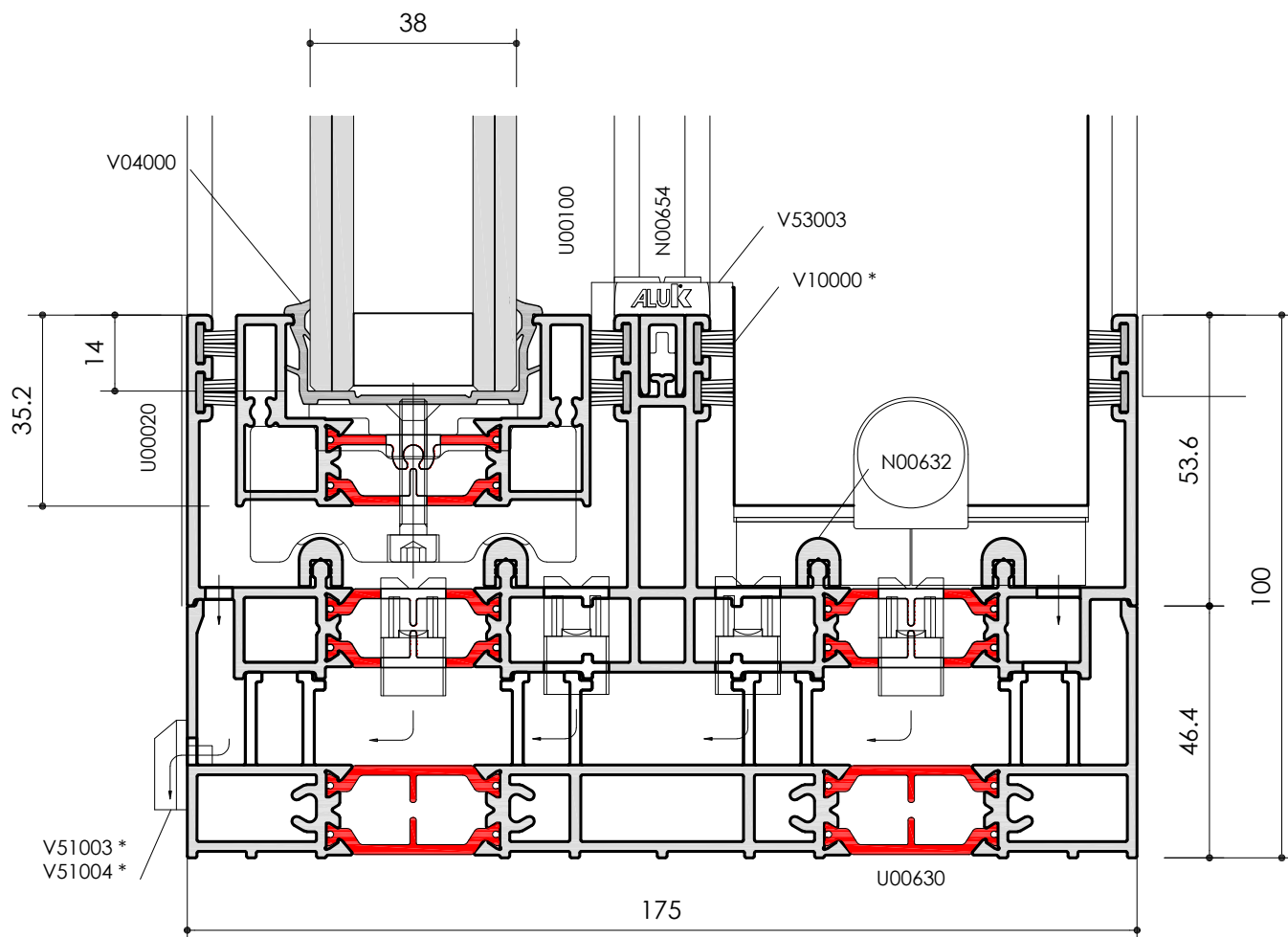
Scale 1 : 1.3

> TYPICAL DETAIL

CILL SECTIONS



Scale 1 : 1.3



* V51004 = Only for Aluk.ITA: 712008

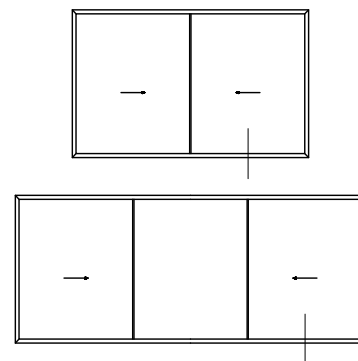
* V51003 = Only for Aluk.ITA: 712007

* V10000 = Only for Aluk.GBR: XA621

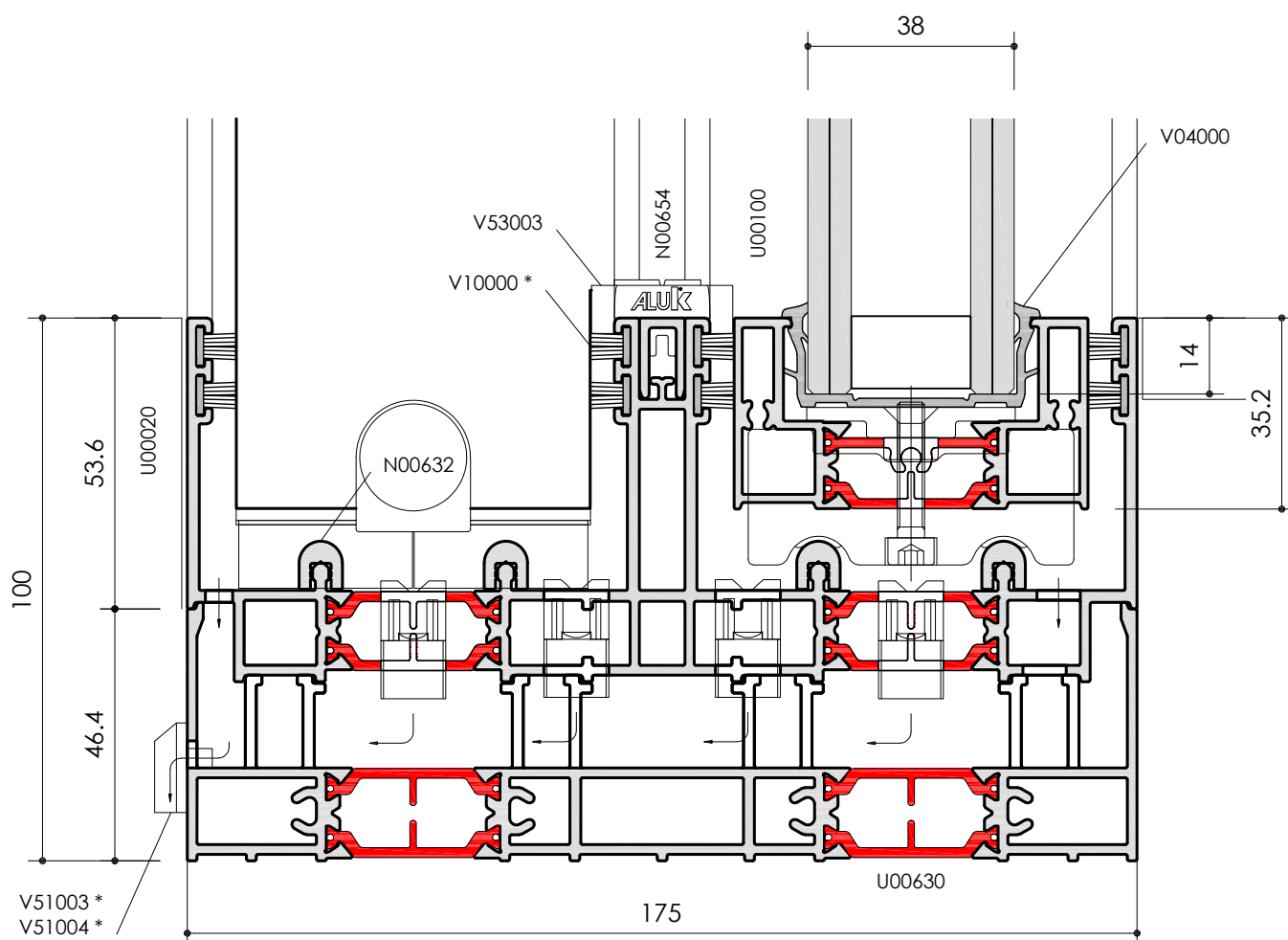
N.B. Gasket & Glazing Configurations are shown in section 7

► TYPICAL DETAIL

CILL SECTIONS



Scale 1 : 1.3



* V51004 = Only for Aluk.ITA: 712008

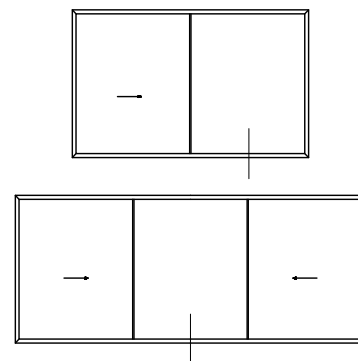
* V51003 = Only for Aluk.ITA: 712007

* V10000 = Only for Aluk.GBR: XA621

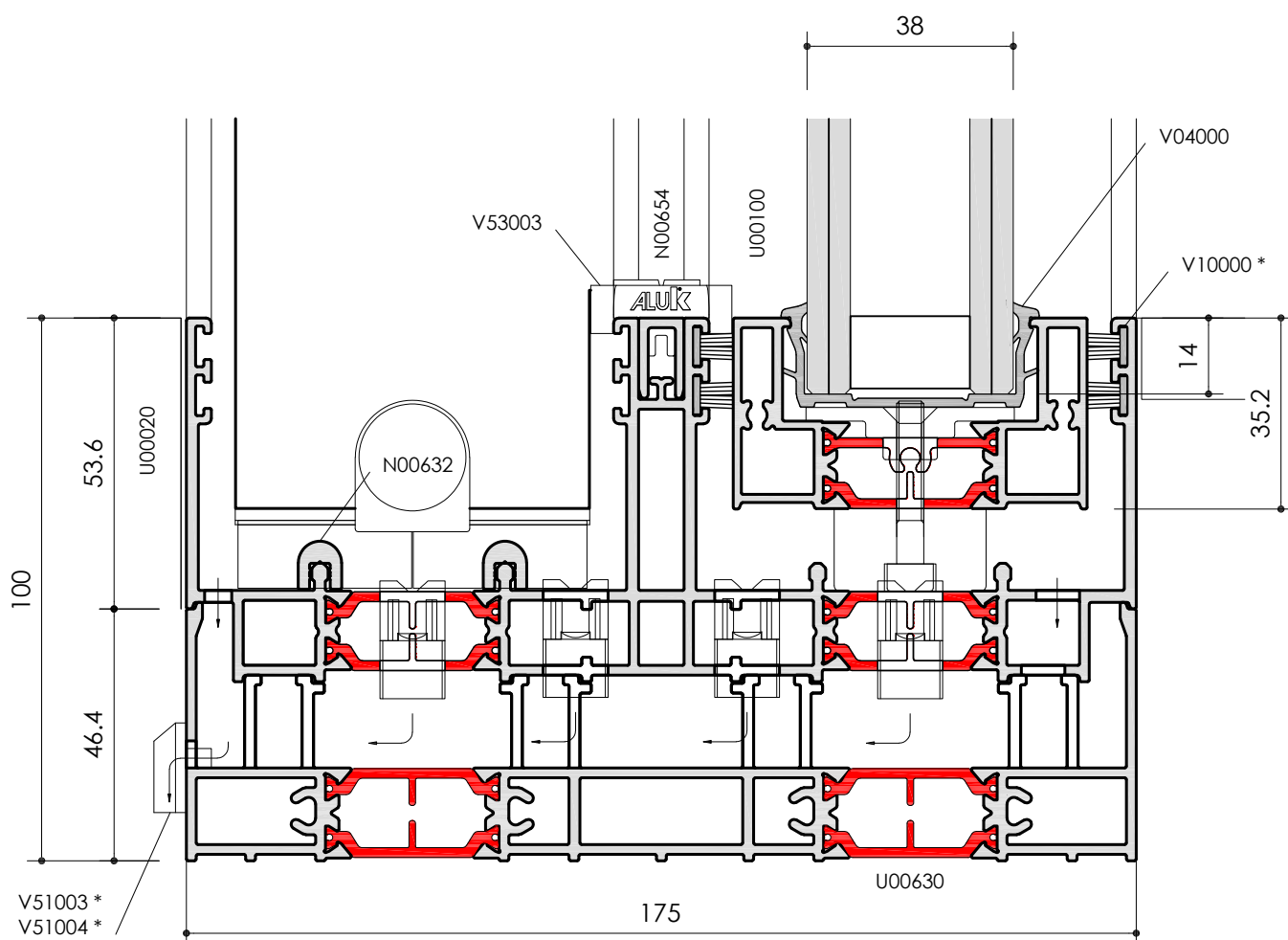
N.B. Gasket & Glazing Configurations are shown in section 7

> TYPICAL DETAIL

CILL SECTIONS



Scale 1 : 1.3



* V51004 = Only for Aluk.ITA: 712008

* V51003 = Only for Aluk.ITA: 712007

* V10000 = Only for Aluk.GBR: XA621

N.B. Gasket & Glazing Configurations are shown in section 7

ALUK

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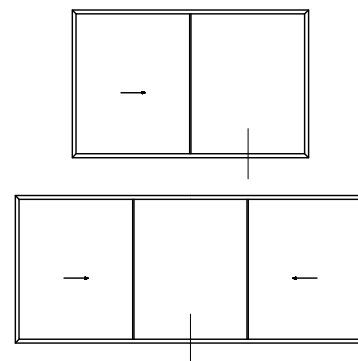
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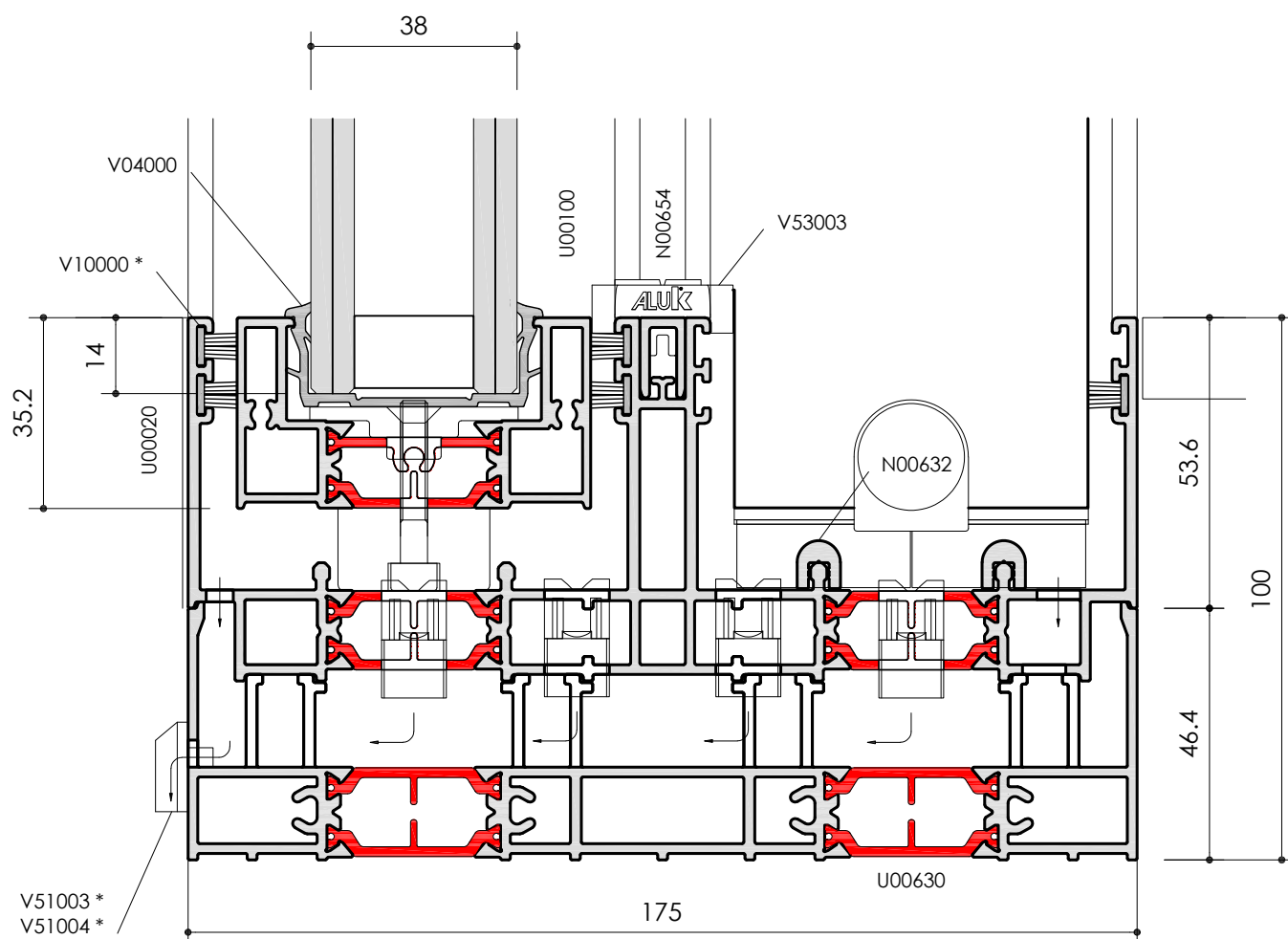
26.01.2018

► TYPICAL DETAIL

CILL SECTIONS



Scale 1 : 1.3



* V51004 = Only for Aluk.ITA: 712008

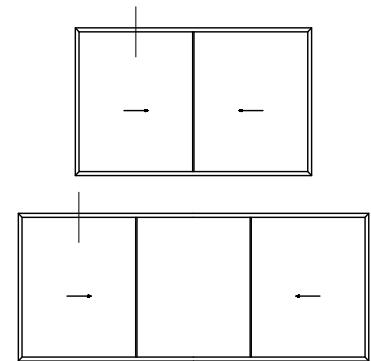
* V51003 = Only for Aluk.ITA: 712007

* V10000 = Only for Aluk.GBR: XA621

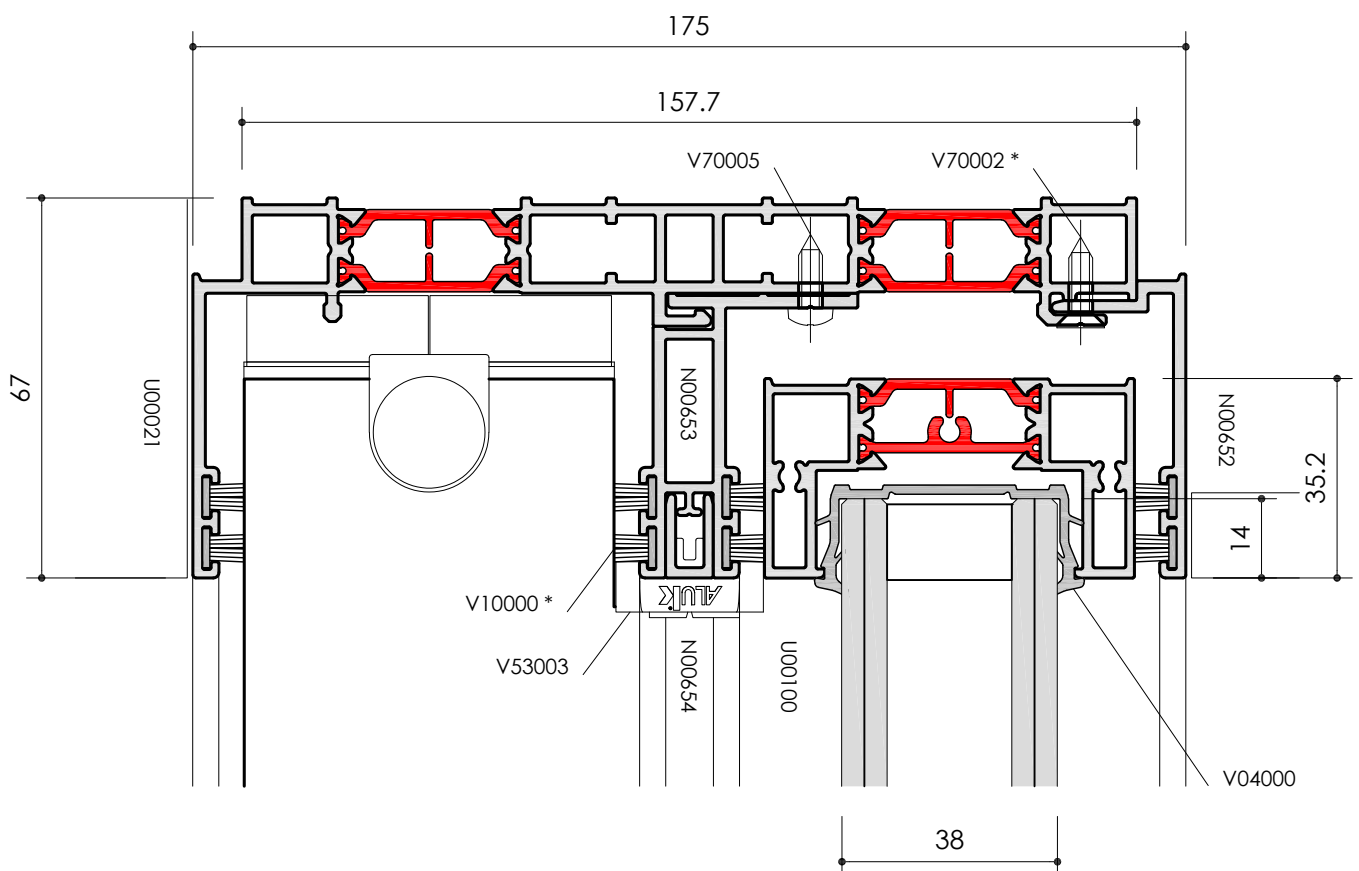
N.B. Gasket & Glazing Configurations are shown in section 7

➤ TYPICAL DETAIL

HEAD SECTIONS



Scale 1 : 1.3



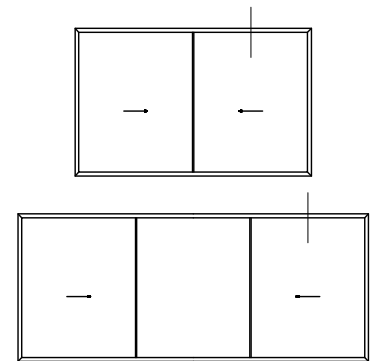
* V10000 = Only for Aluk.GBR: XA621

* V70002 = Only for Aluk.GBR: XS1006

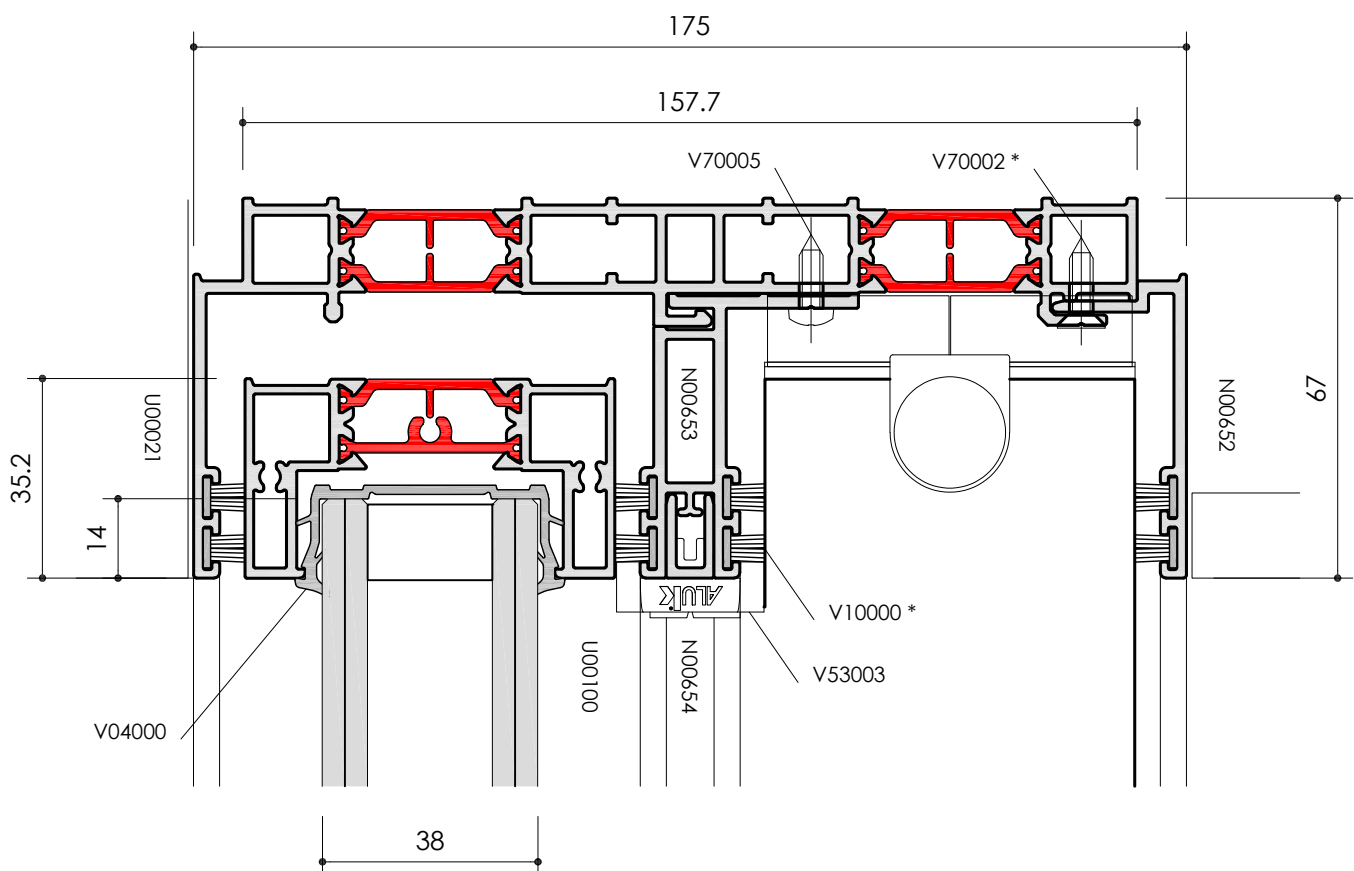
N.B. Gasket & Glazing Configurations are shown in section 7

► TYPICAL DETAIL

HEAD SECTIONS



Scale 1 : 1.3



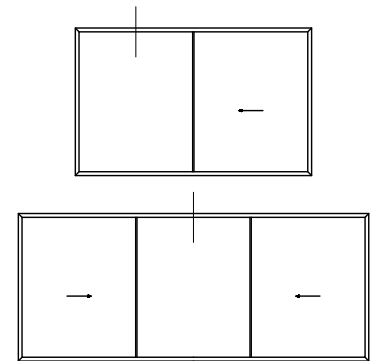
* V10000 = Only for Aluk.GBR: XA621

* V70002 = Only for Aluk.GBR: XS1006

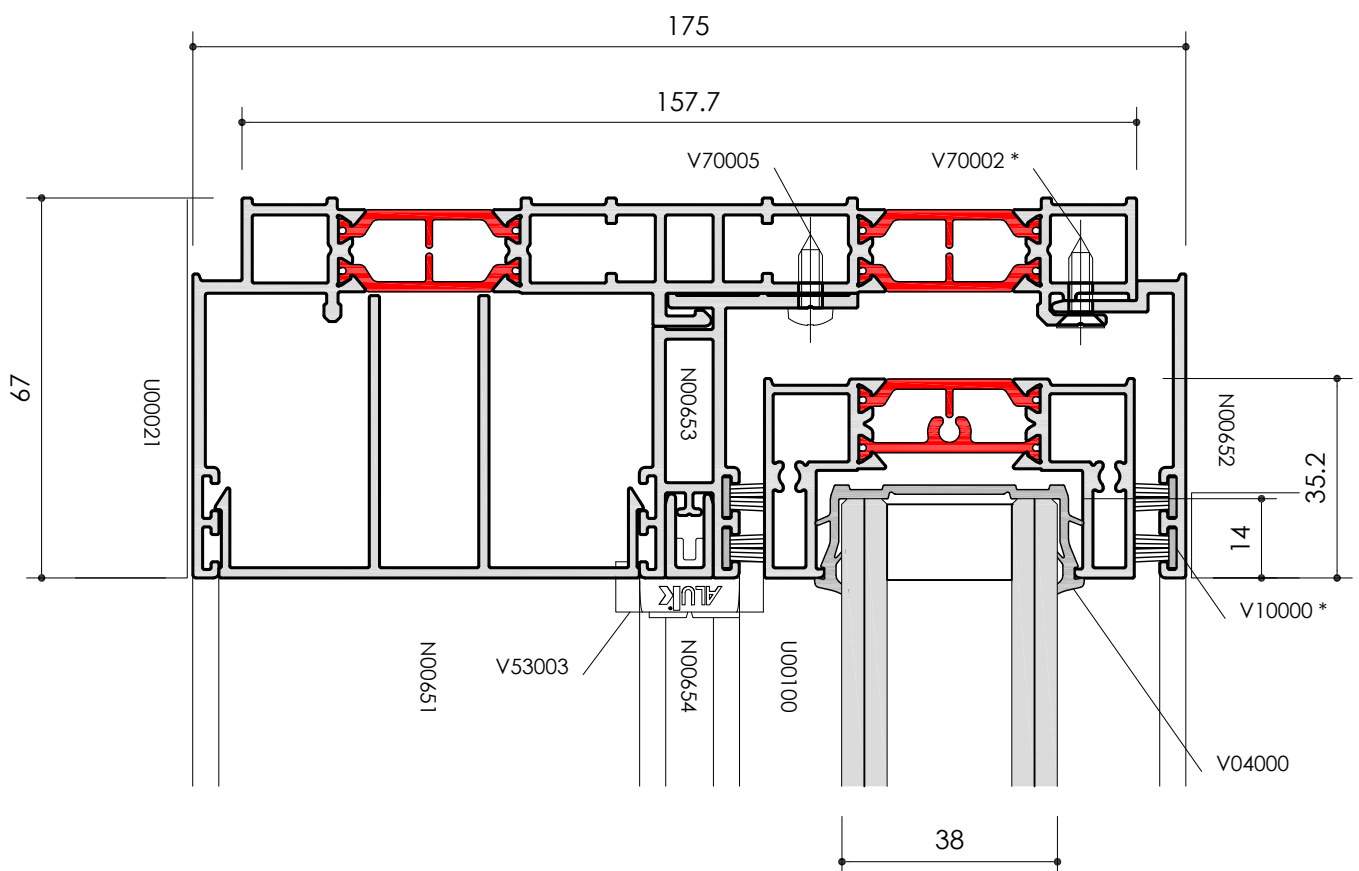
N.B. Gasket & Glazing Configurations are shown in section 7

➤ TYPICAL DETAIL

HEAD SECTIONS



Scale 1 : 1.3



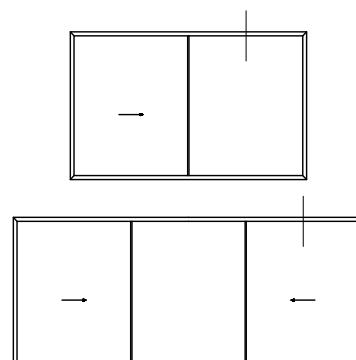
* V10000 = Only for Aluk.GBR: XA621

* V70002 = Only for Aluk.GBR: XS1006

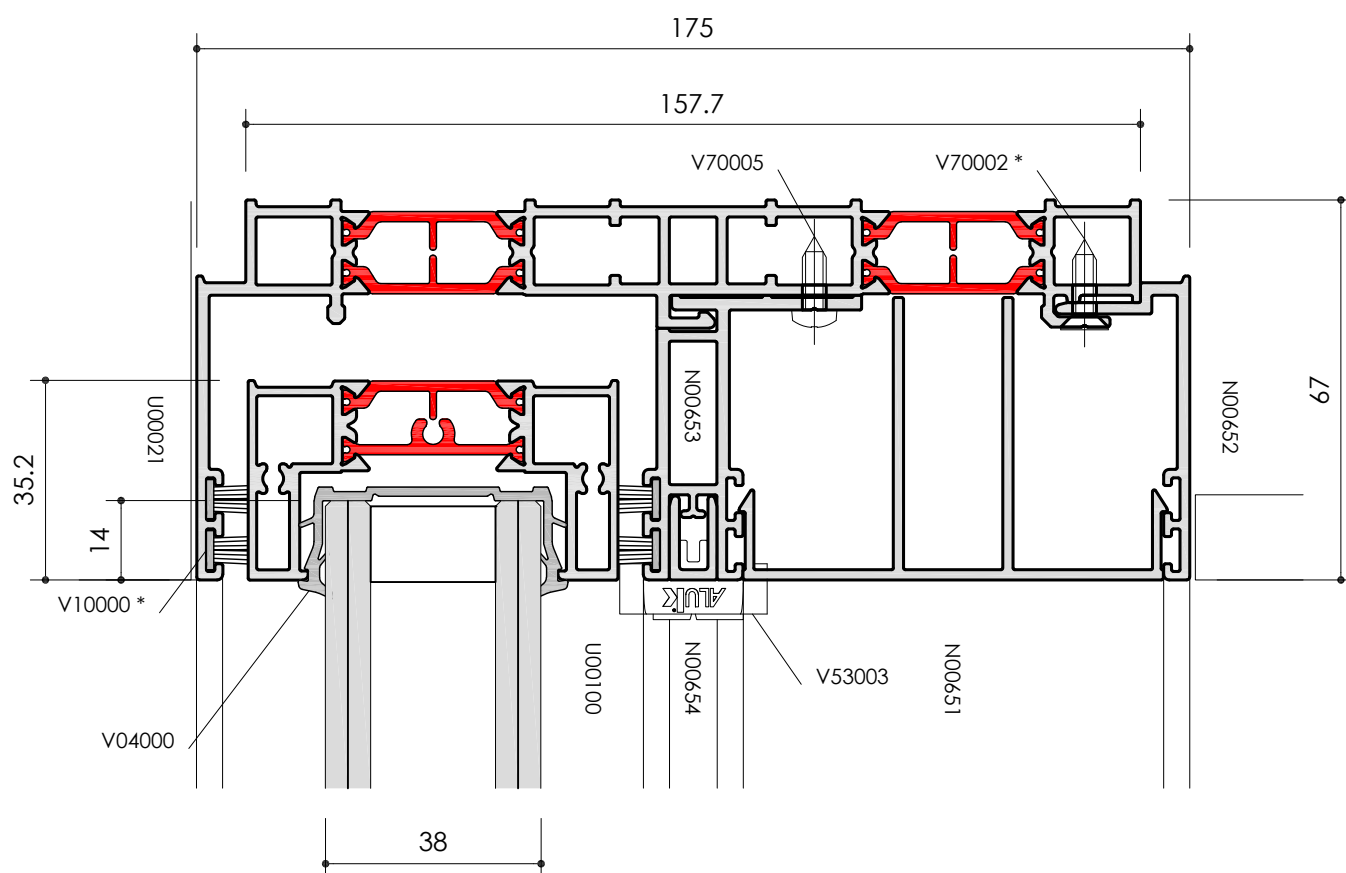
N.B. Gasket & Glazing Configurations are shown in section 7

► TYPICAL DETAIL

HEAD SECTIONS



Scale 1 : 1.3



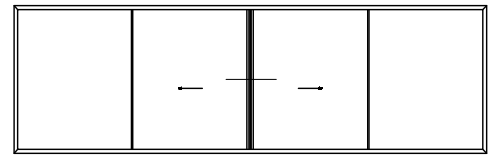
* V10000 = Only for Aluk.GBR: XA621

* V70002 = Only for Aluk.GBR: XS1006

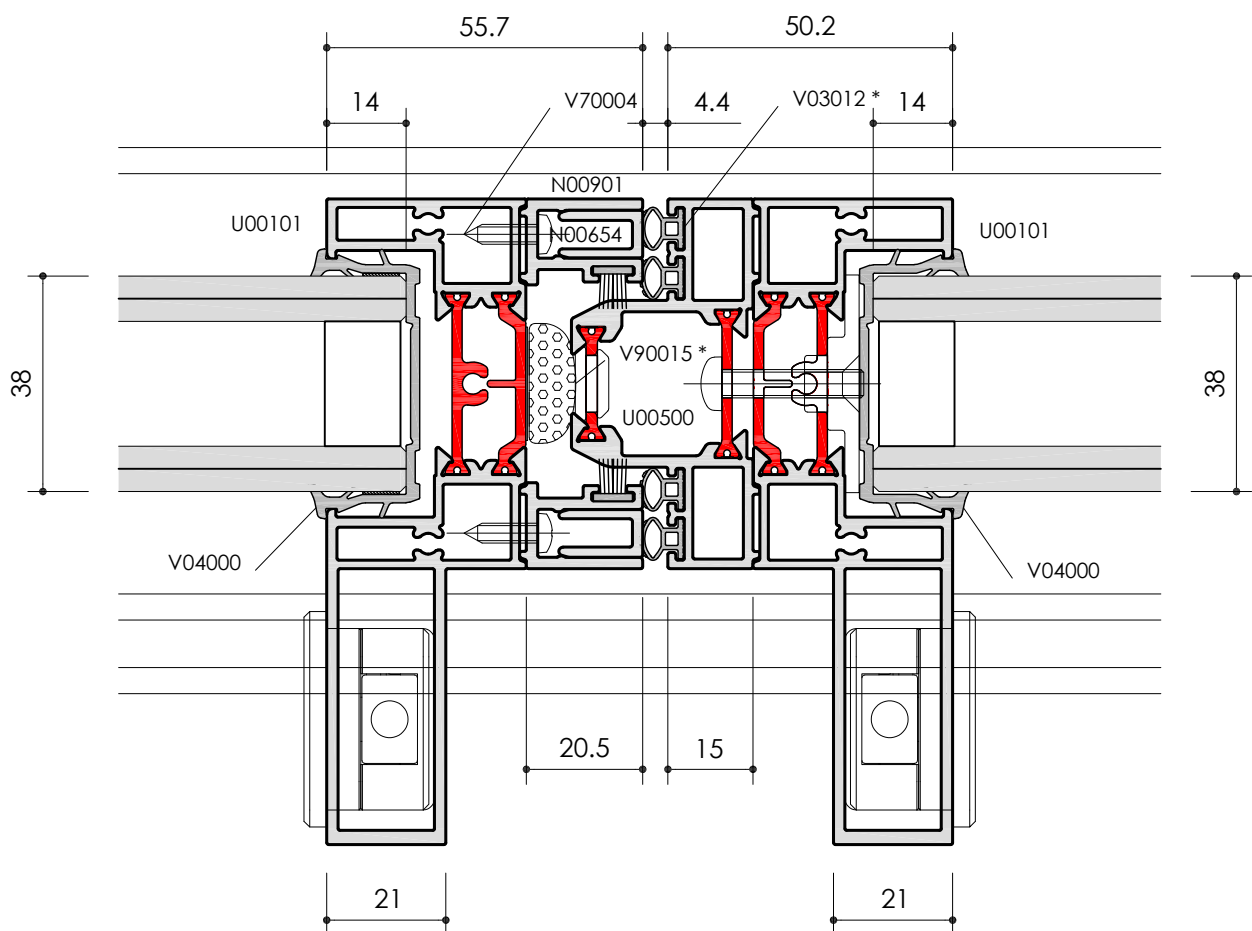
N.B. Gasket & Glazing Configurations are shown in section 7

➤ TYPICAL DETAIL

MEETING STYLE SECTION



Scale 1 : 1.3



* V10000 = Only for Aluk.GBR: XA621

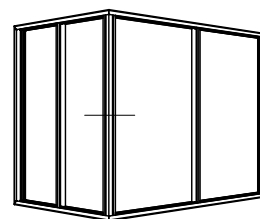
* V32012 = Only for Aluk.FR: J8002

* V90015 = Only for Aluk.IT: 809688

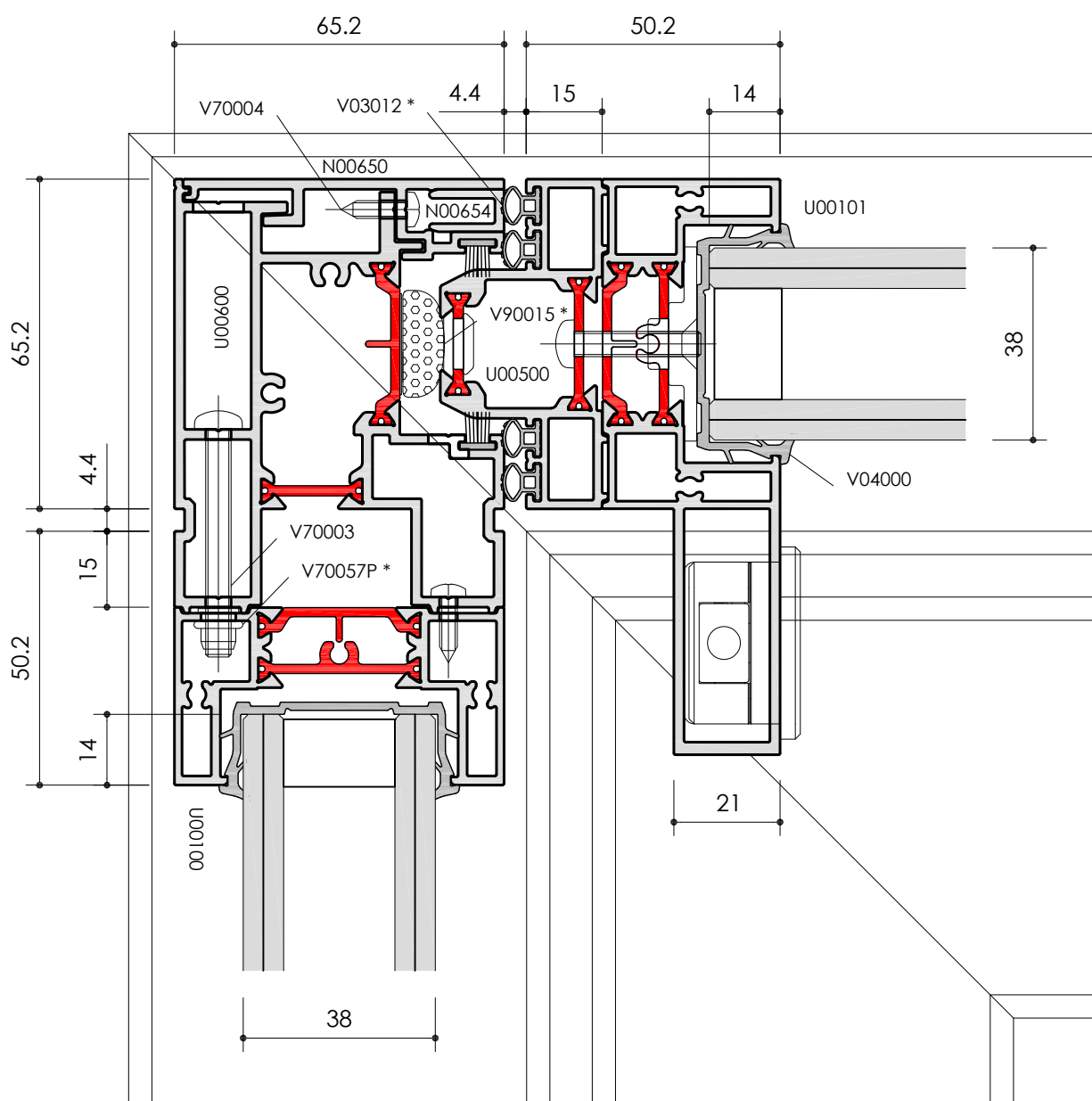
N.B. Gasket & Glazing Configurations are shown in section 7

► TYPICAL DETAIL

CORNER SECTIONS



Scale 1 : 1.3



* V10000 = Only for Aluk.GBR: XA621

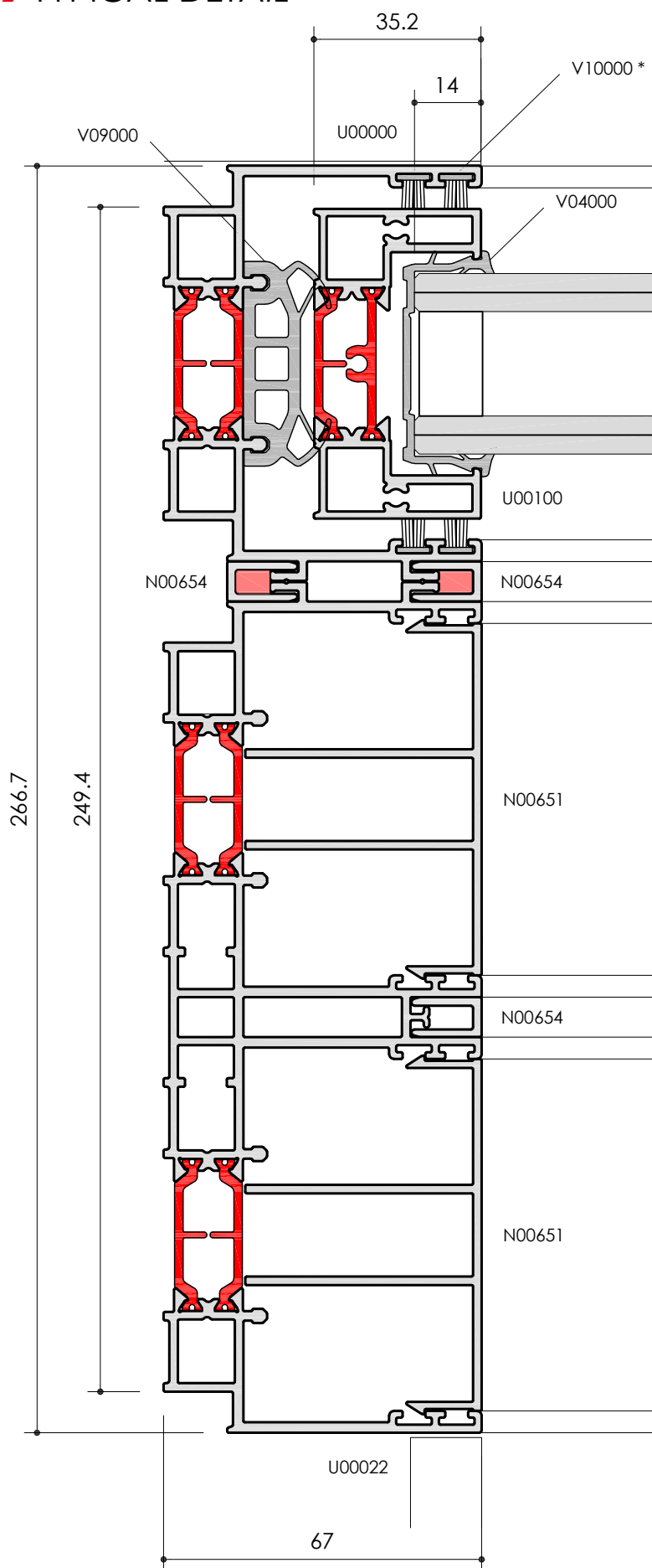
* V32012 = Only for Aluk.FR: J8002

* V70057 = Only for Aluk.GBR: RX652

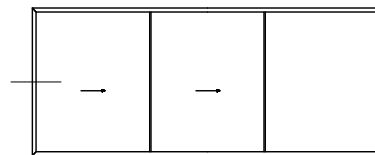
* V90015 = Only for Aluk.IT: 809688

N.B. Gasket & Glazing Configurations are shown in section 7

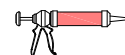
➤ TYPICAL DETAIL



JAMB SECTIONS



Scale 1 : 1.3



Key: Use T50000 - T50002

* V10000 = Only for Aluk.GBR: XA621

N.B. Gasket & Glazing Configurations are shown in section 7

ALUK

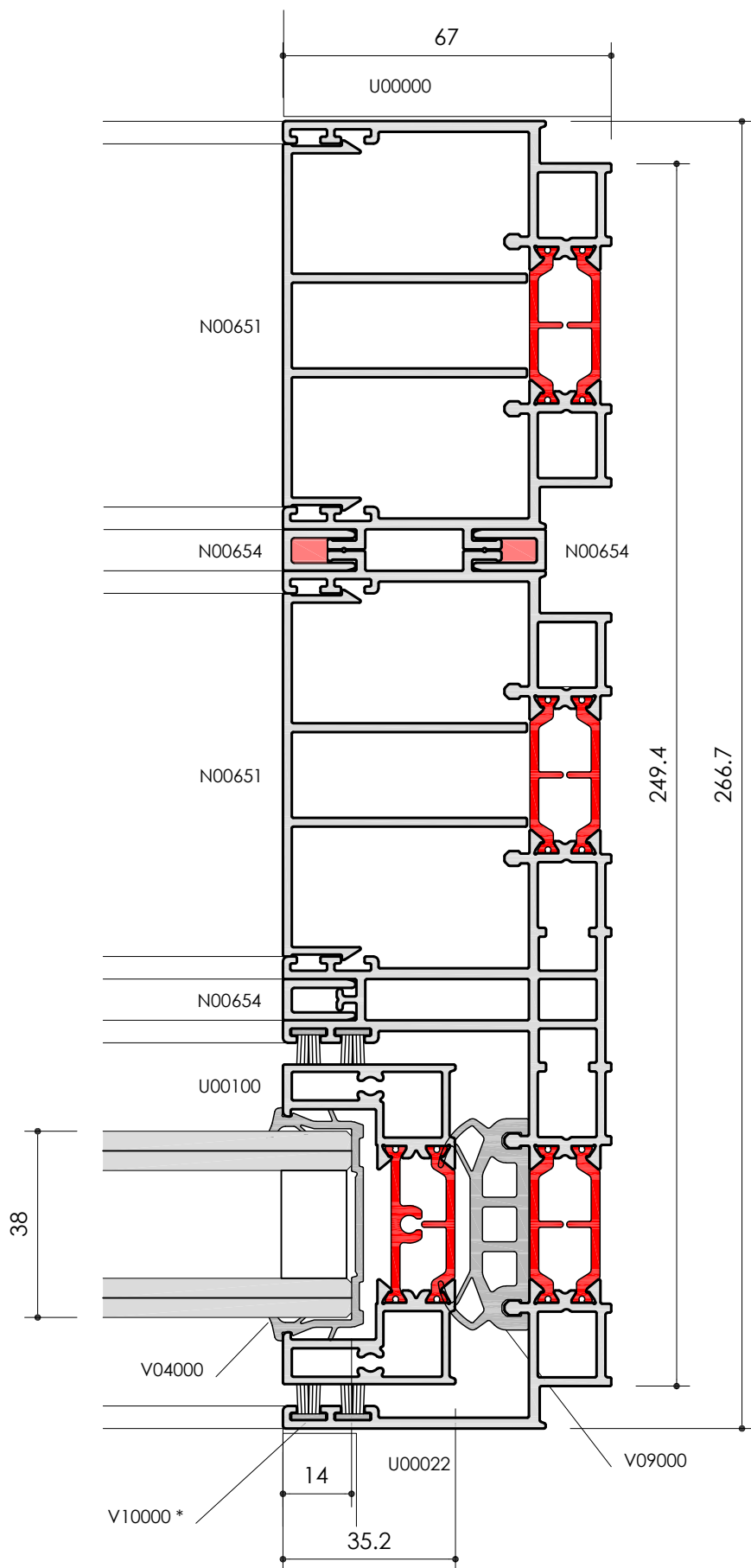
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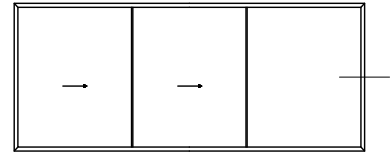
6.17

26.01.2018

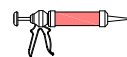
► TYPICAL DETAIL



JAMB SECTIONS



Scale 1 : 1.3

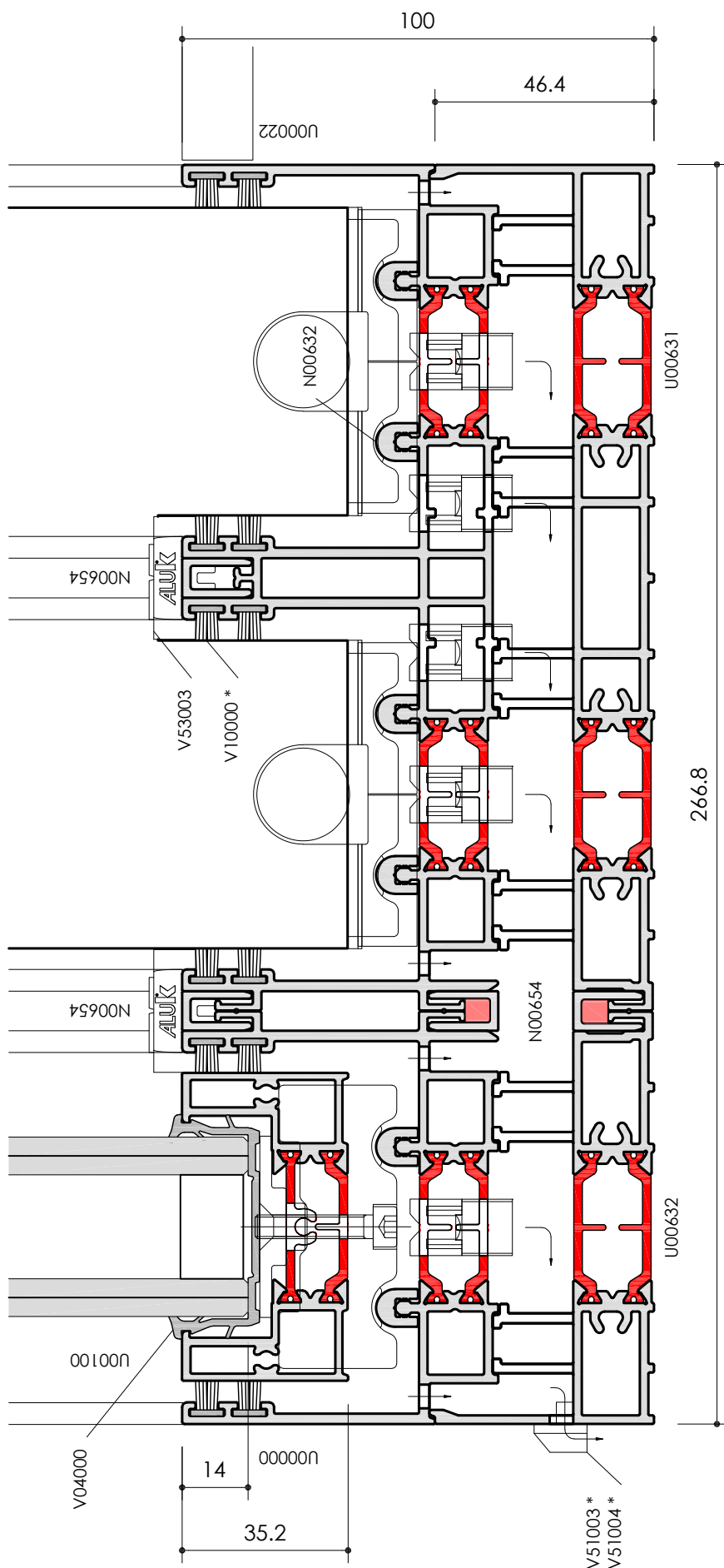


Key: Use T50000 - T50002

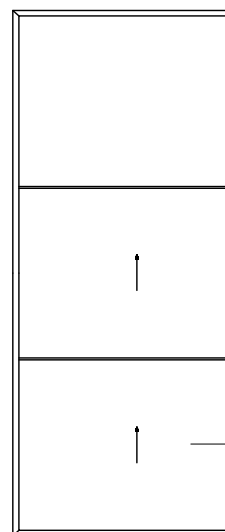
* V10000 = Only for Aluk.GBR: XA621

N.B. Gasket & Glazing Configurations are shown in section 7

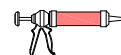
> TYPICAL DETAIL



CILL SECTIONS



Scale 1 : 1.3



Key: Use T50000 - T50002

* V51004 = Only for Aluk.ITA: 712008
 * V51003 = Only for Aluk.ITA: 712007
 * V10000 = Only for Aluk.GBR: XA621

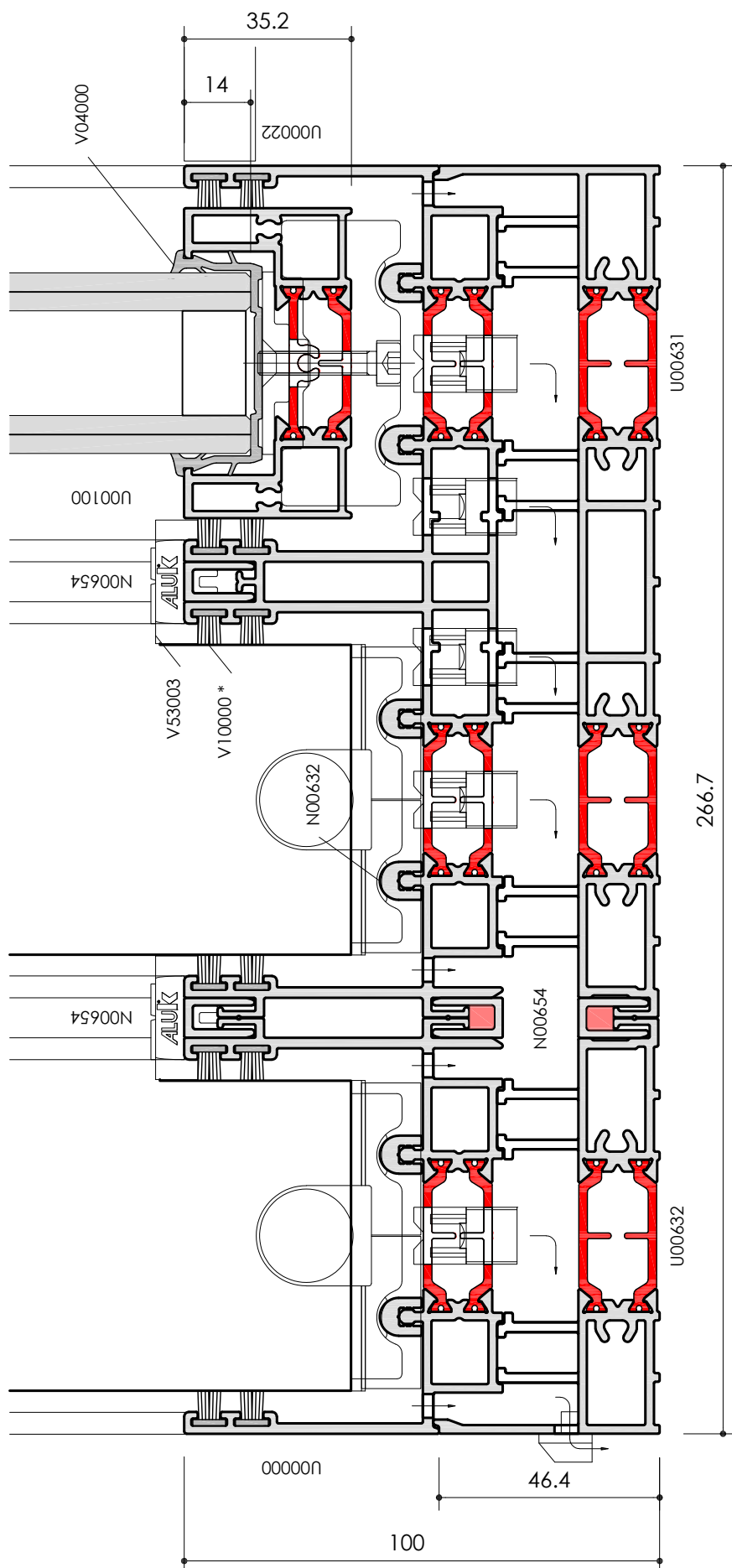
N.B. Gasket & Glazing Configurations are shown in section 7

ALUK

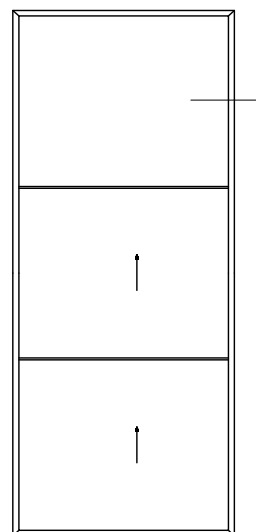
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INFINIUM 6.19 26.01.2018

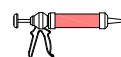
► TYPICAL DETAIL



CILL SECTIONS



Scale 1 : 1.3

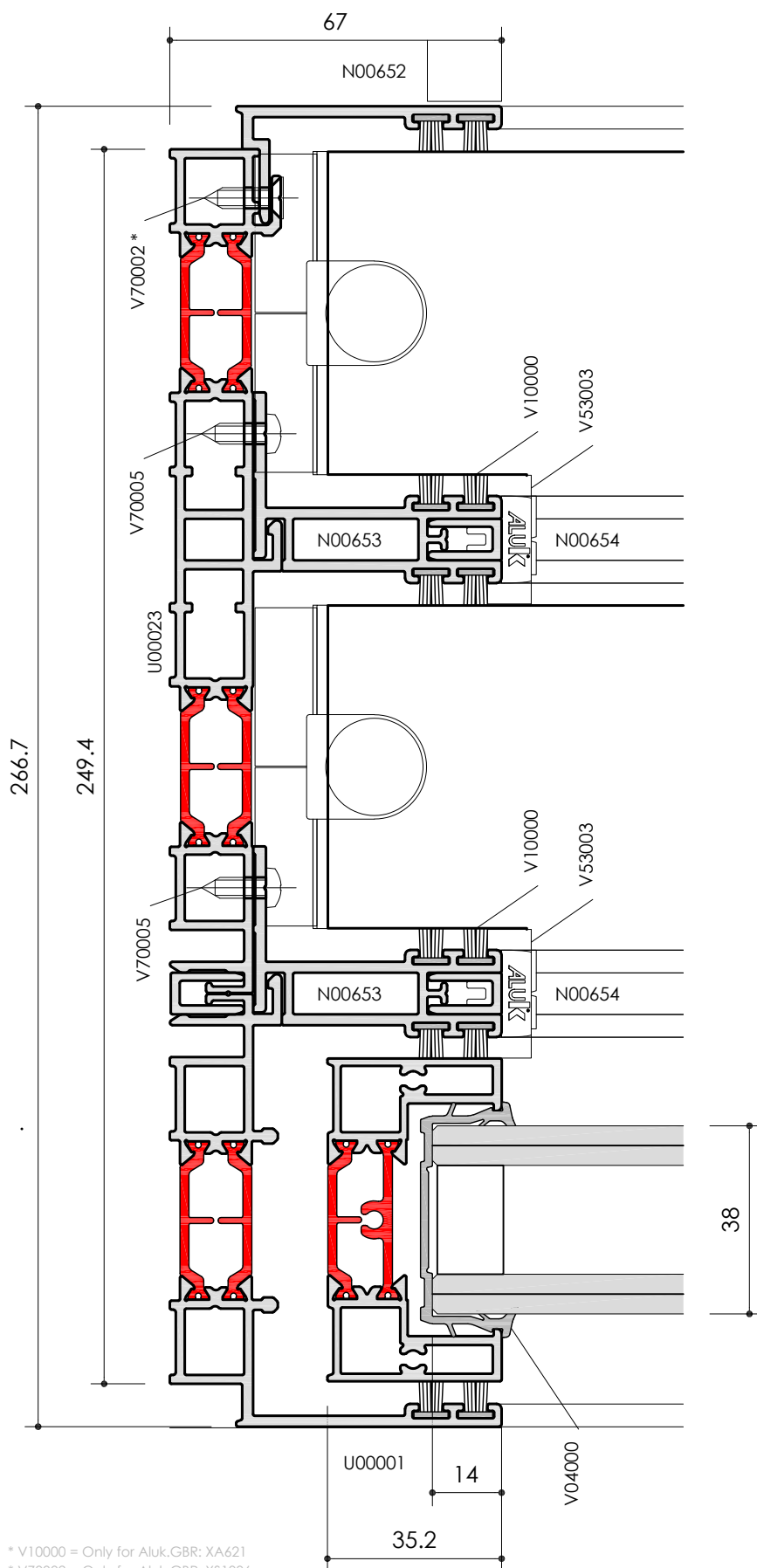


Key: Use T50000 - T50002

N.B. Gasket & Glazing Configurations are shown in section 7

* V10000 = Only for Aluk.GBR: XA621

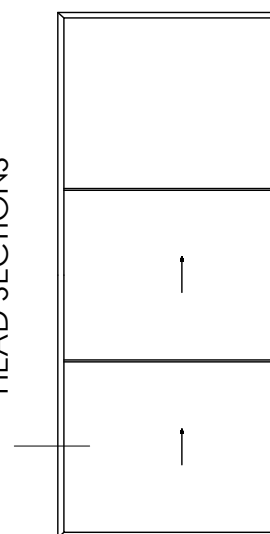
➤ TYPICAL DETAIL



* V10000 = Only for Aluk.GBR: XA621
 * V70002 = Only for Aluk.GBR: XS1006

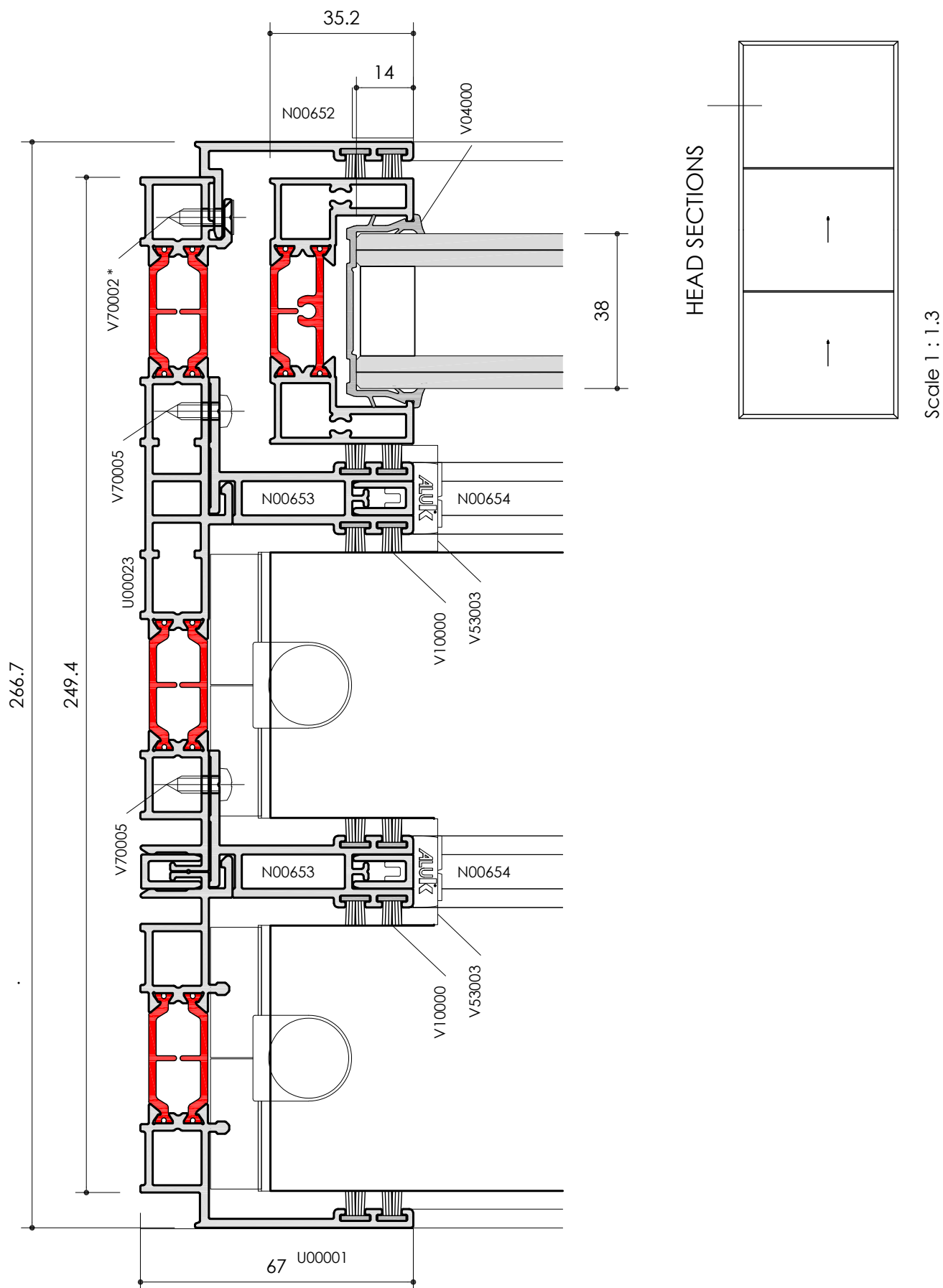
N.B. Gasket & Glazing Configurations are shown in section 7

HEAD SECTIONS



Scale 1 : 1.3

► TYPICAL DETAIL



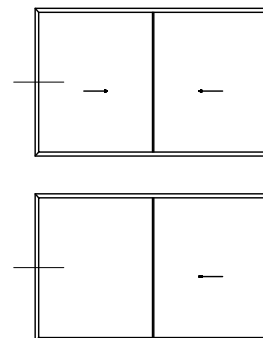
* V10000 = Only for Aluk.GBR: XA621

* V70002 = Only for Aluk.GBR: XS1006

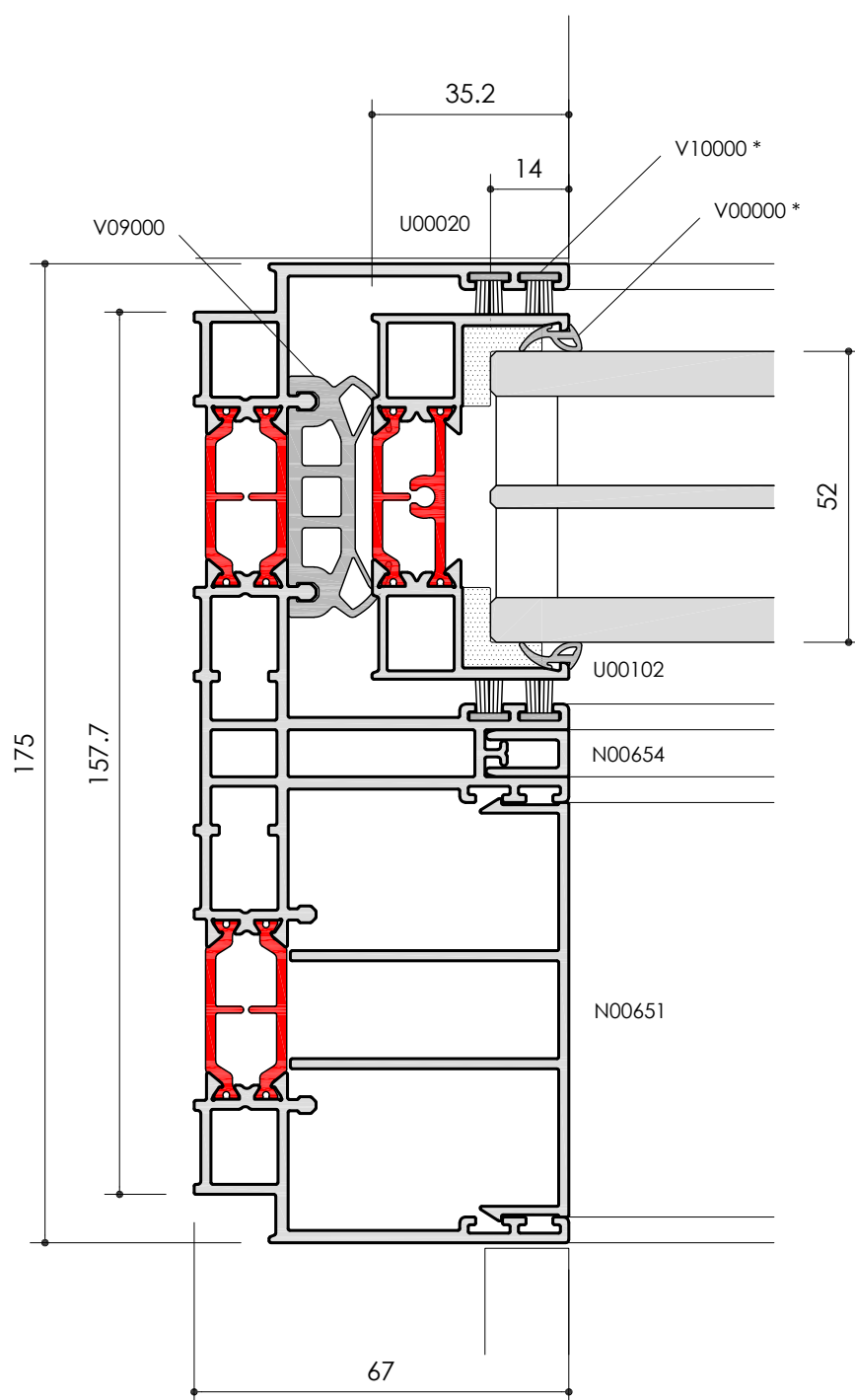
N.B. Gasket & Glazing Configurations are shown in section 7

➤ TYPICAL DETAIL

JAMB SECTIONS



Scale 1 : 1.3



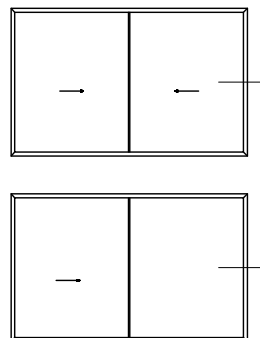
* V10000 = Only for Aluk.GBR: XA621

* V00000 = Only for Aluk.IT: 809119

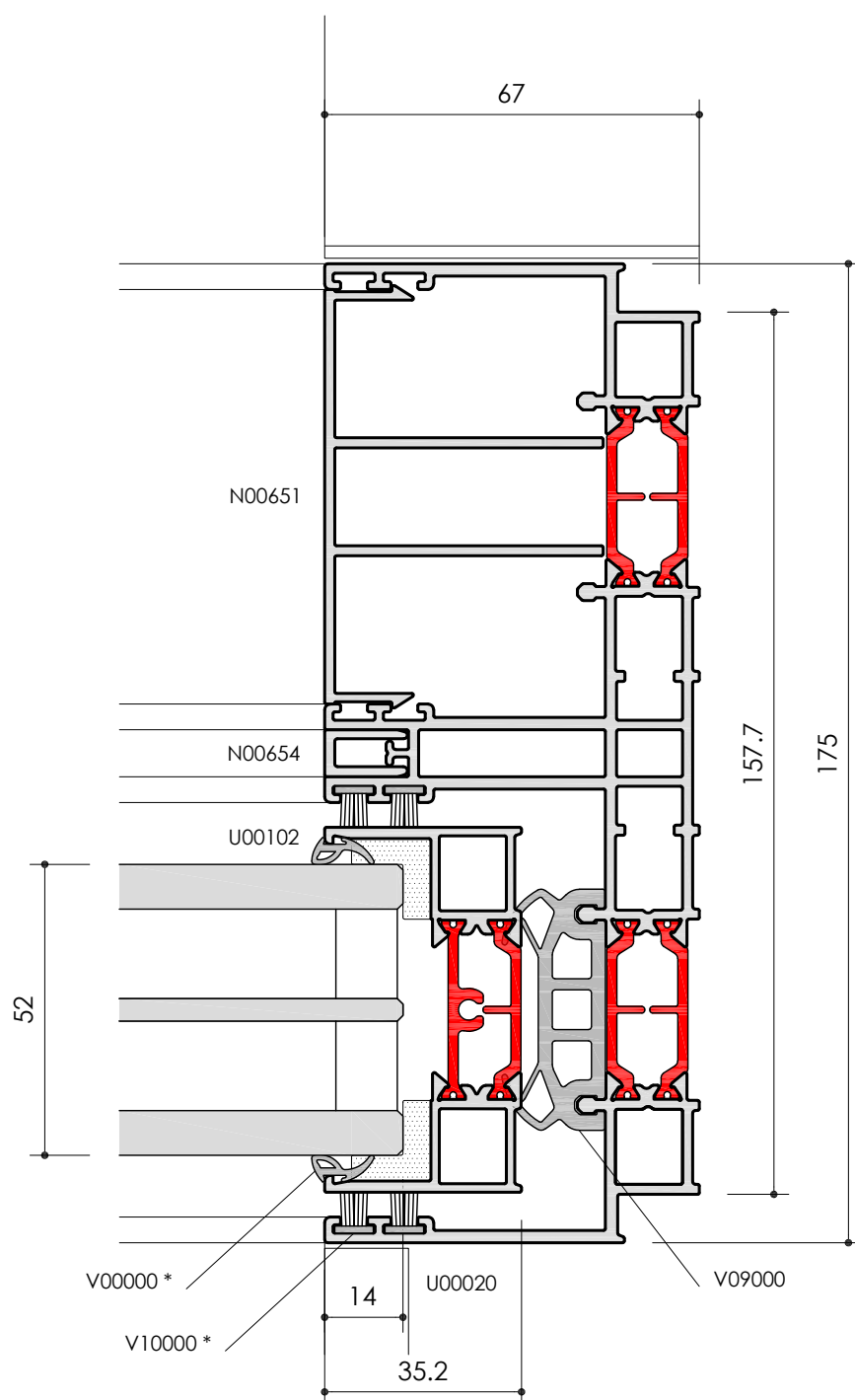
N.B. Gasket & Glazing Configurations are shown in section 7

► TYPICAL DETAIL

JAMB SECTIONS



Scale 1 : 1.3

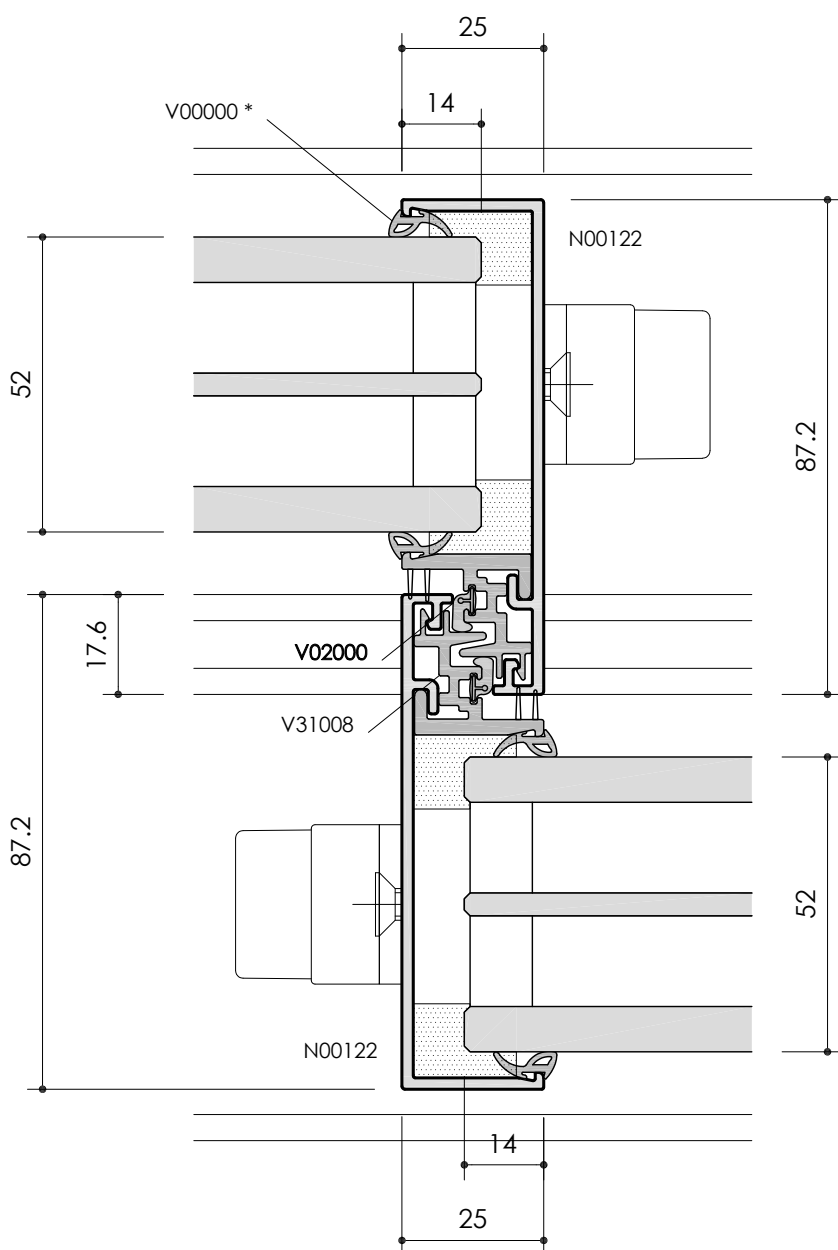


* V10000 = Only for Aluk.GBR: XA621

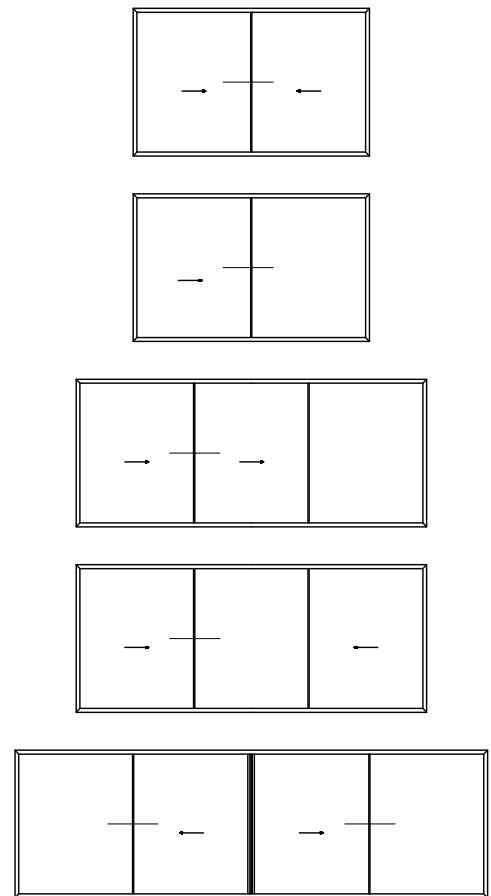
* V00000 = Only for Aluk.IT: 809119

N.B. Gasket & Glazing Configurations are shown in section 7

➤ TYPICAL DETAIL



INTERLOCK SECTIONS

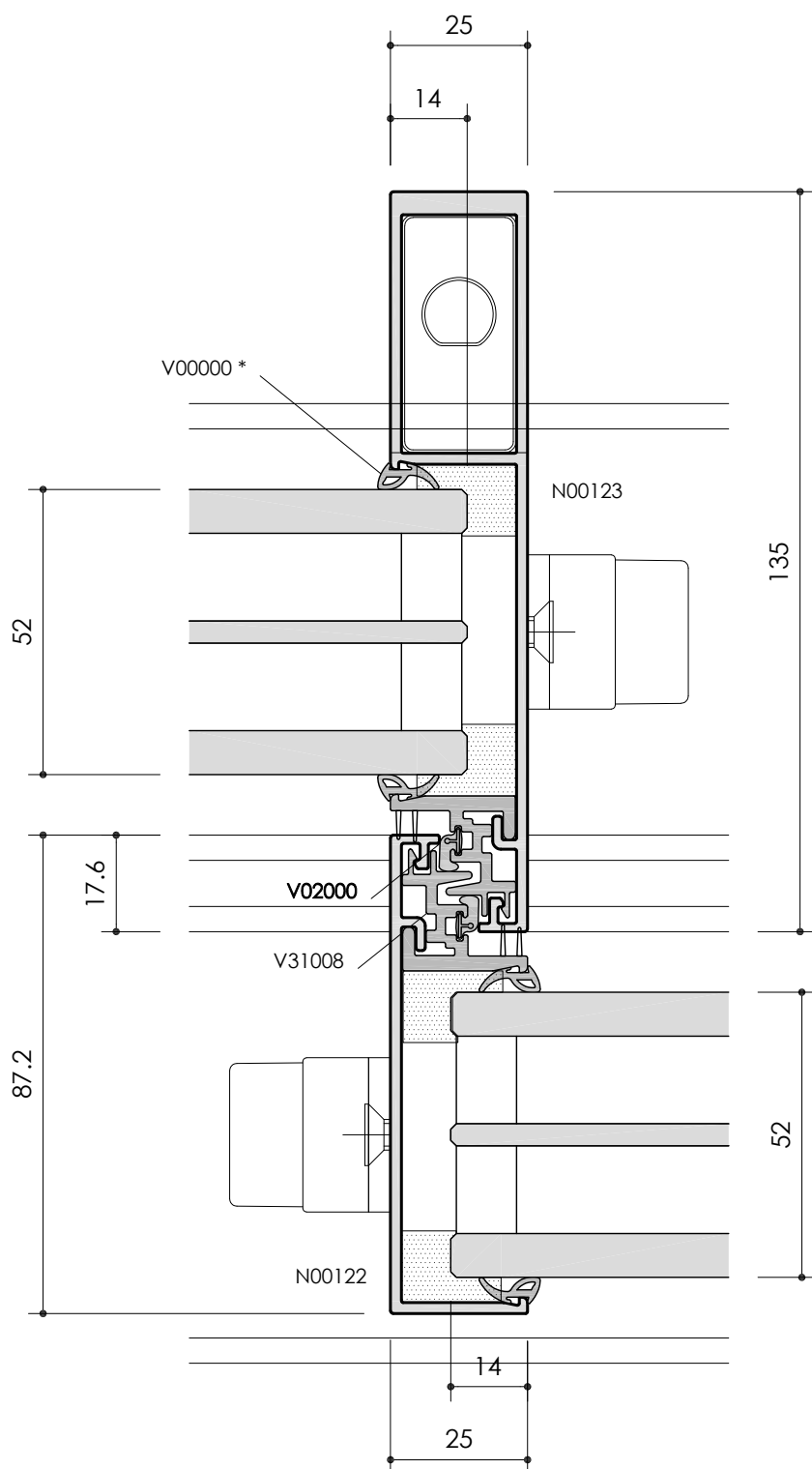


Scale 1 : 1.3

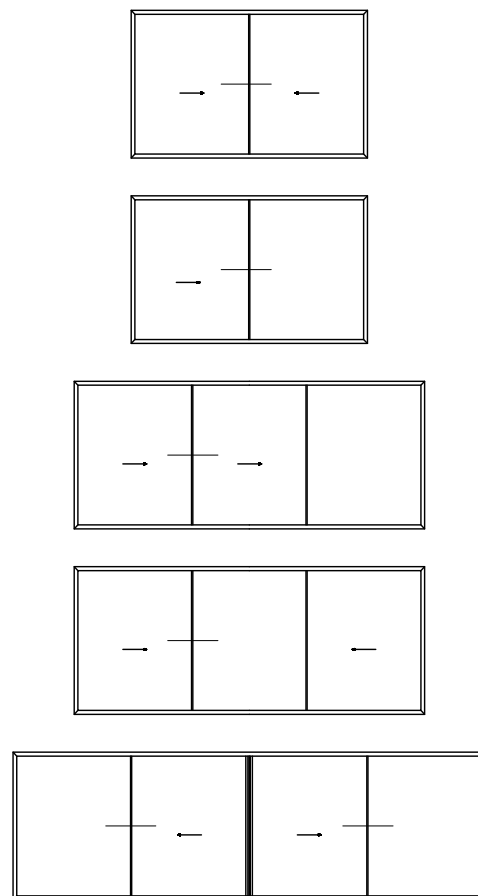
* V00000 = Only for Aluk.IT: 809119

N.B. Gasket & Glazing Configurations are shown in section 7

➤ TYPICAL DETAIL



INTERLOCK SECTIONS

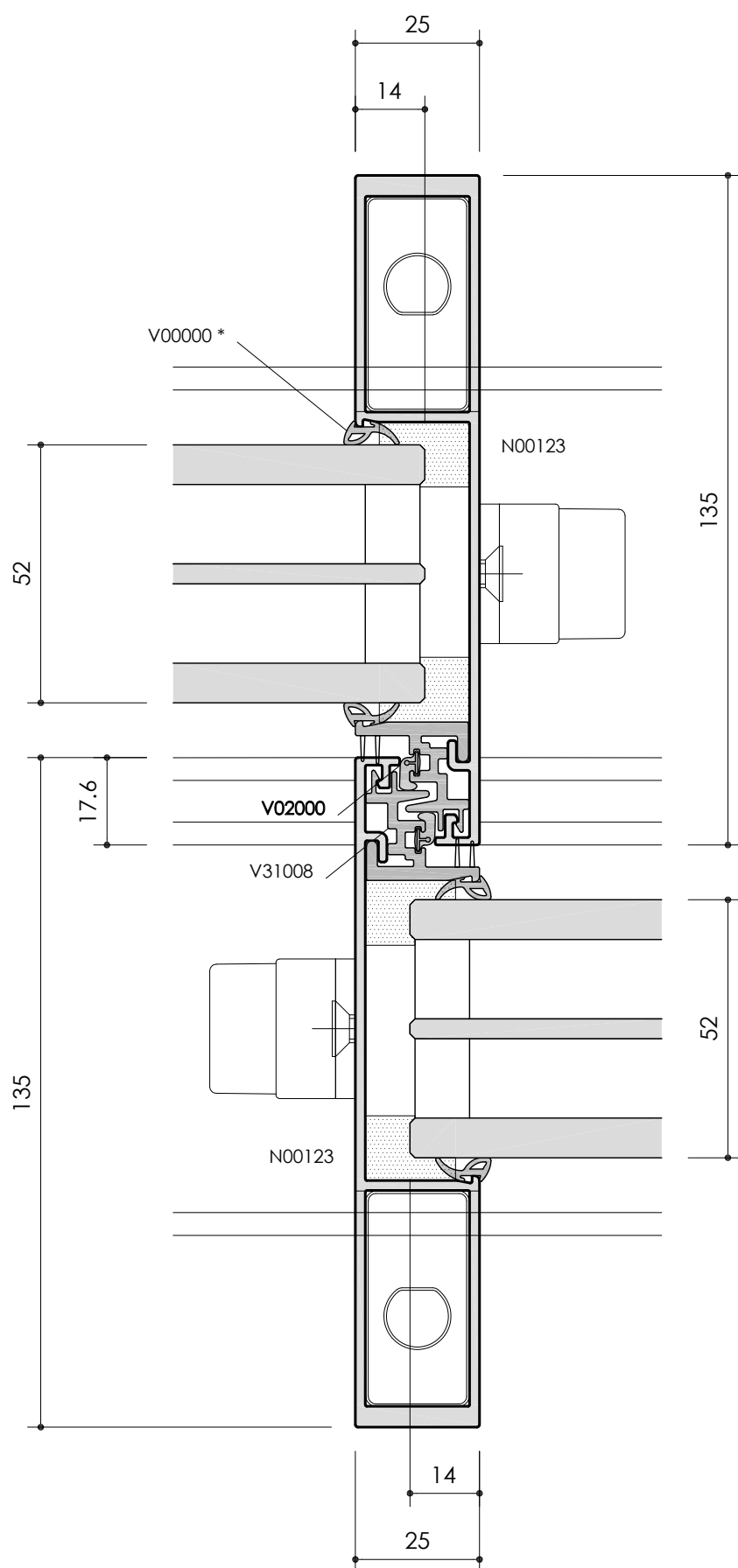


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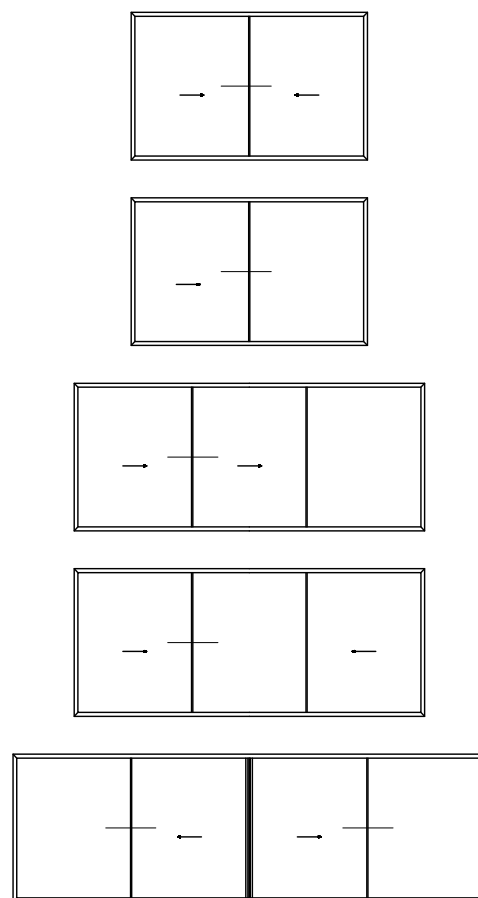
* V00000 = Only for Aluk.IT: 809119

N.B. Gasket & Glazing Configurations are shown in section 7

➤ TYPICAL DETAIL



INTERLOCK SECTIONS

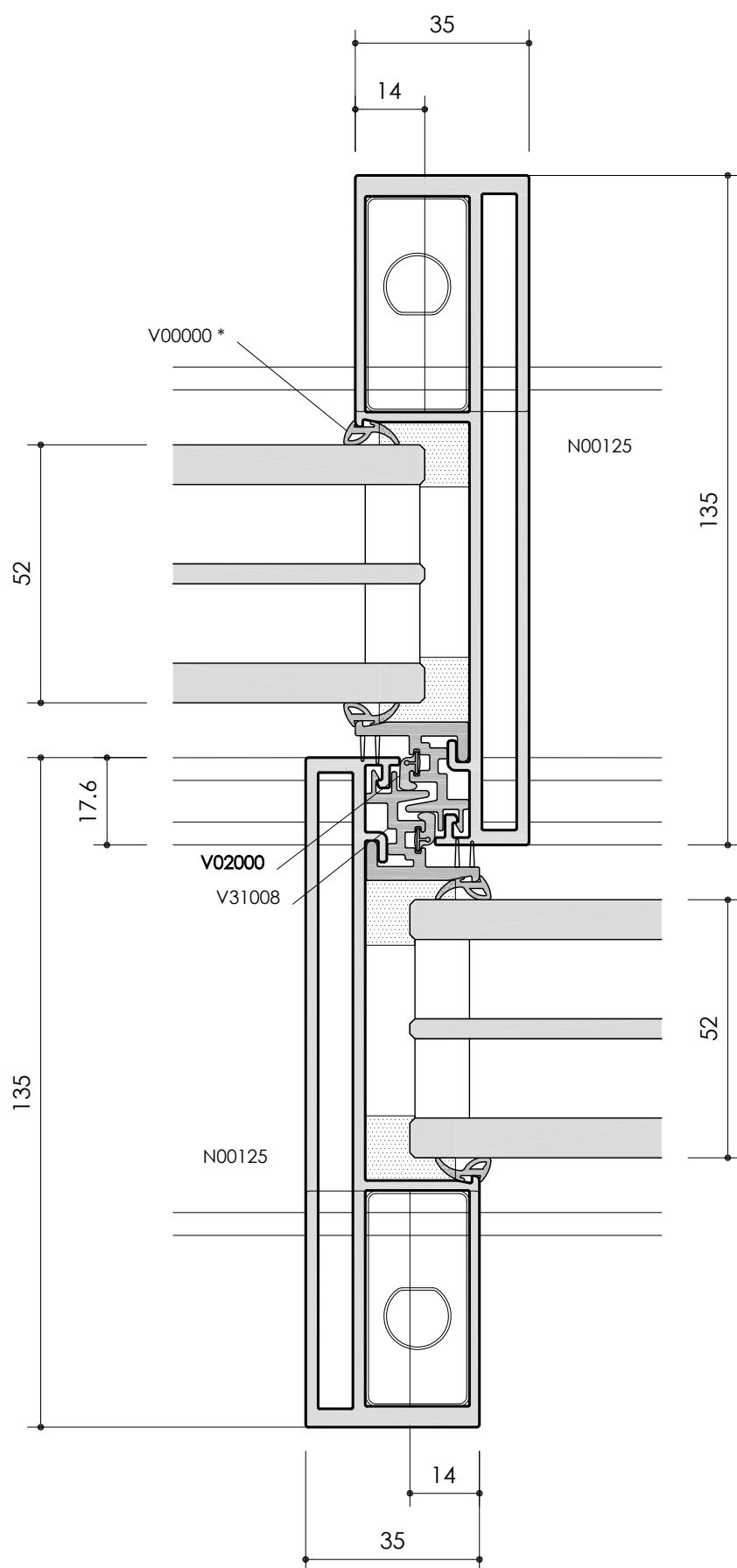


Scale 1 : 1.3

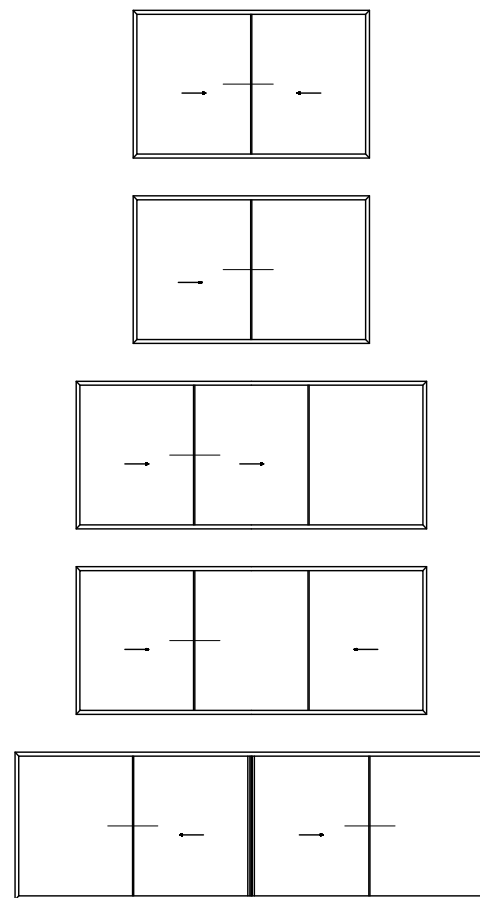
* V00000 = Only for Aluk.IT: 809119

N.B. Gasket & Glazing Configurations are shown in section 7

➤ TYPICAL DETAIL



INTERLOCK SECTIONS



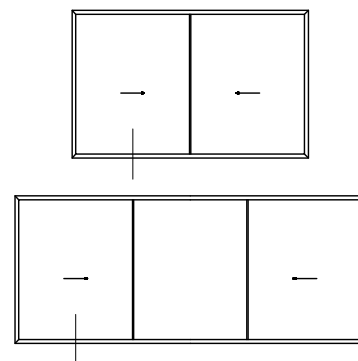
Scale 1 : 1.3

* V00000 = Only for Aluk.IT: 809119

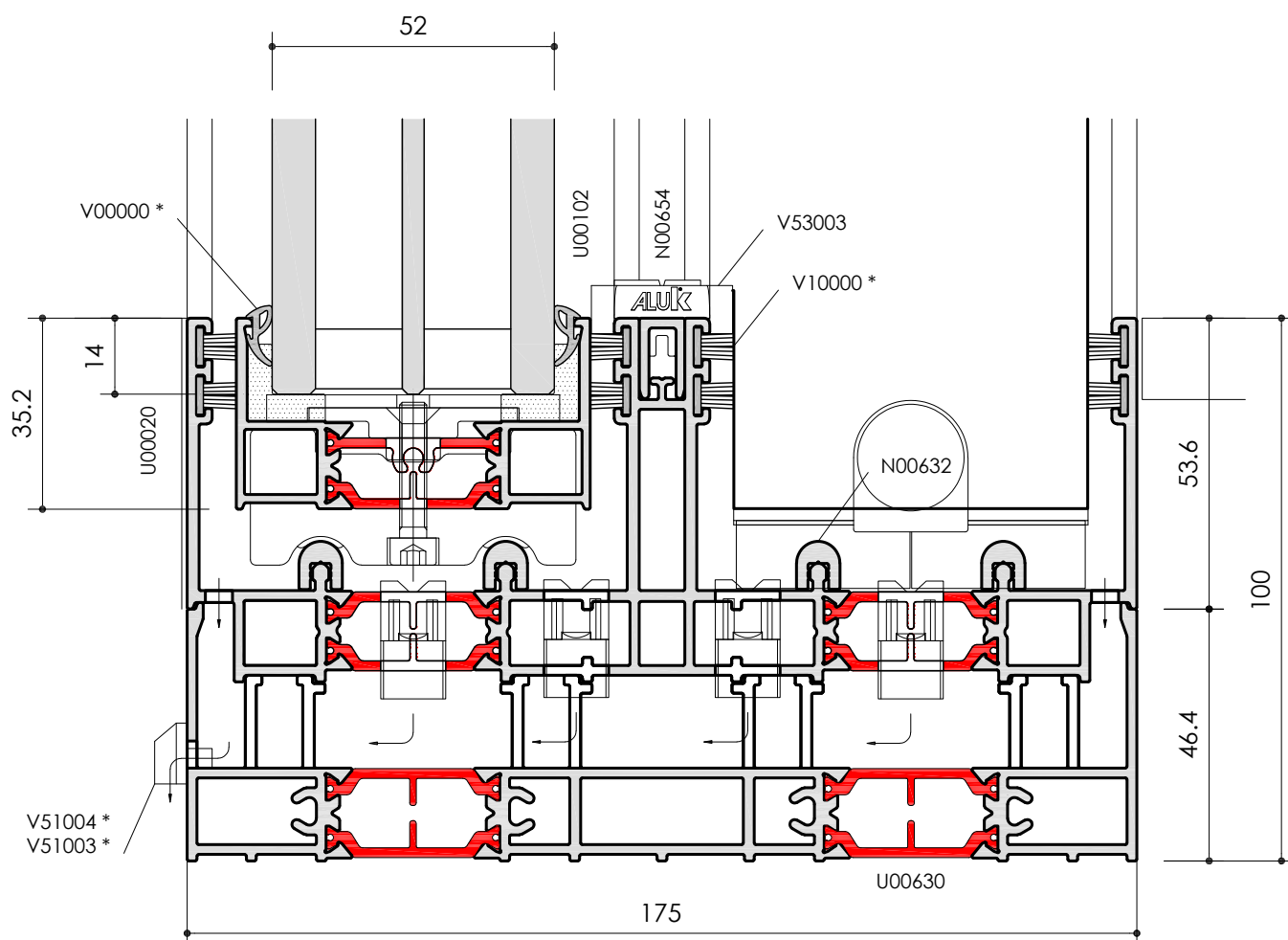
N.B. Gasket & Glazing Configurations are shown in section 7

> TYPICAL DETAIL

CILL SECTIONS



Scale 1 : 1.3



* V51004 = Only for Aluk.ITA: 712008

* V51003 = Only for Aluk.ITA: 712007

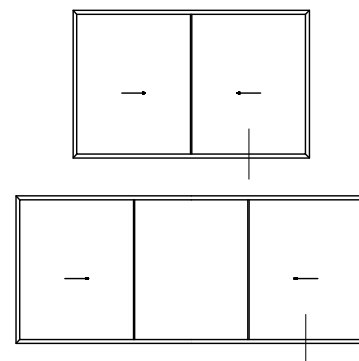
* V10000 = Only for Aluk.GBR: XA621

* V00000 = Only for Aluk.IT: 809119

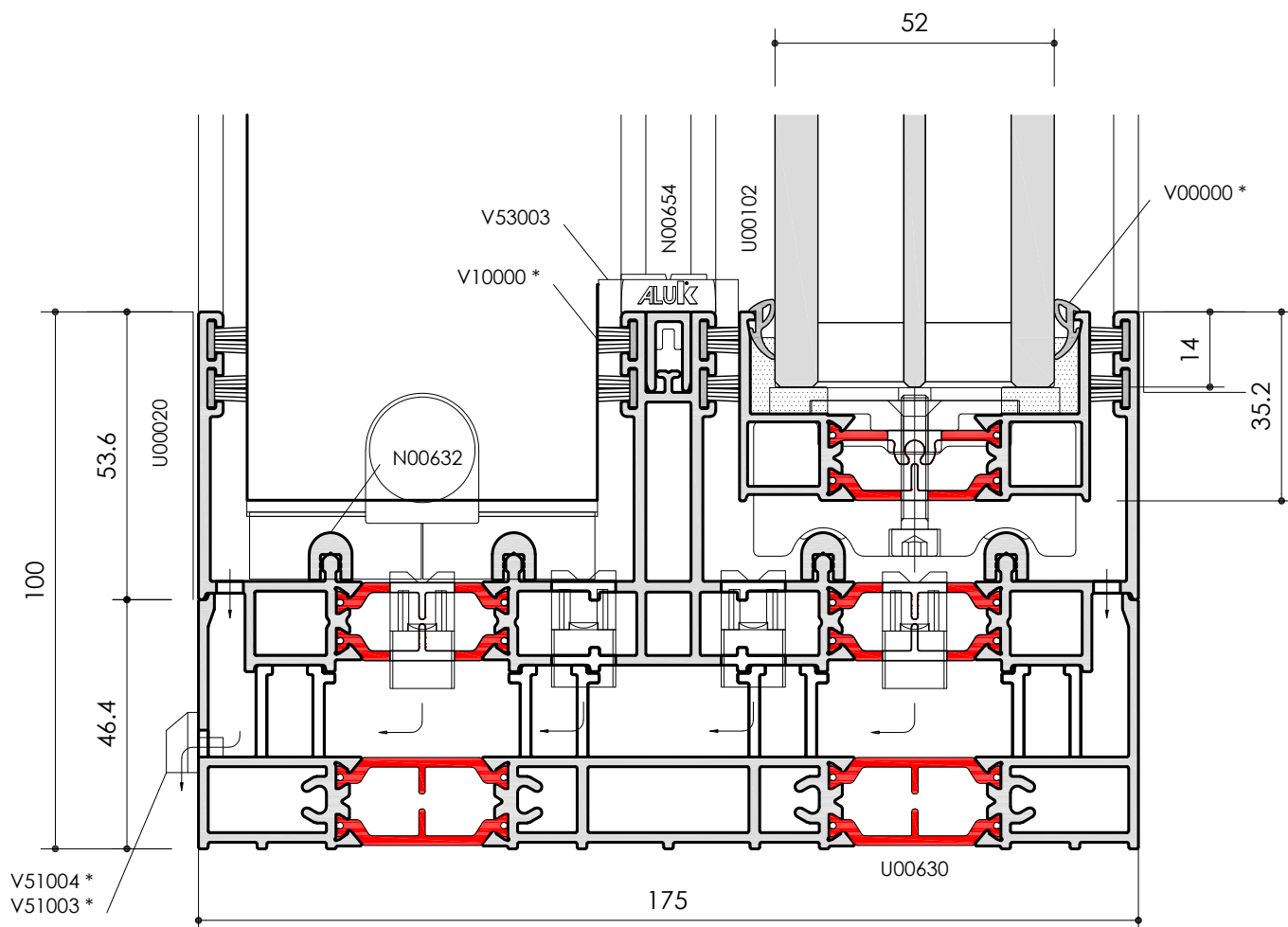
N.B. Gasket & Glazing Configurations are shown in section 7

► TYPICAL DETAIL

CILL SECTIONS



Scale 1 : 1.3



* V51004 = Only for Aluk.ITA: 712008

* V51003 = Only for Aluk.ITA: 712007

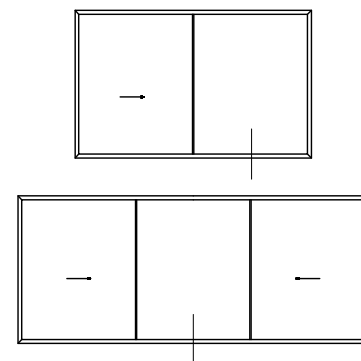
* V10000 = Only for Aluk.GBR: XA621

* V00000 = Only for Aluk.IT: 809119

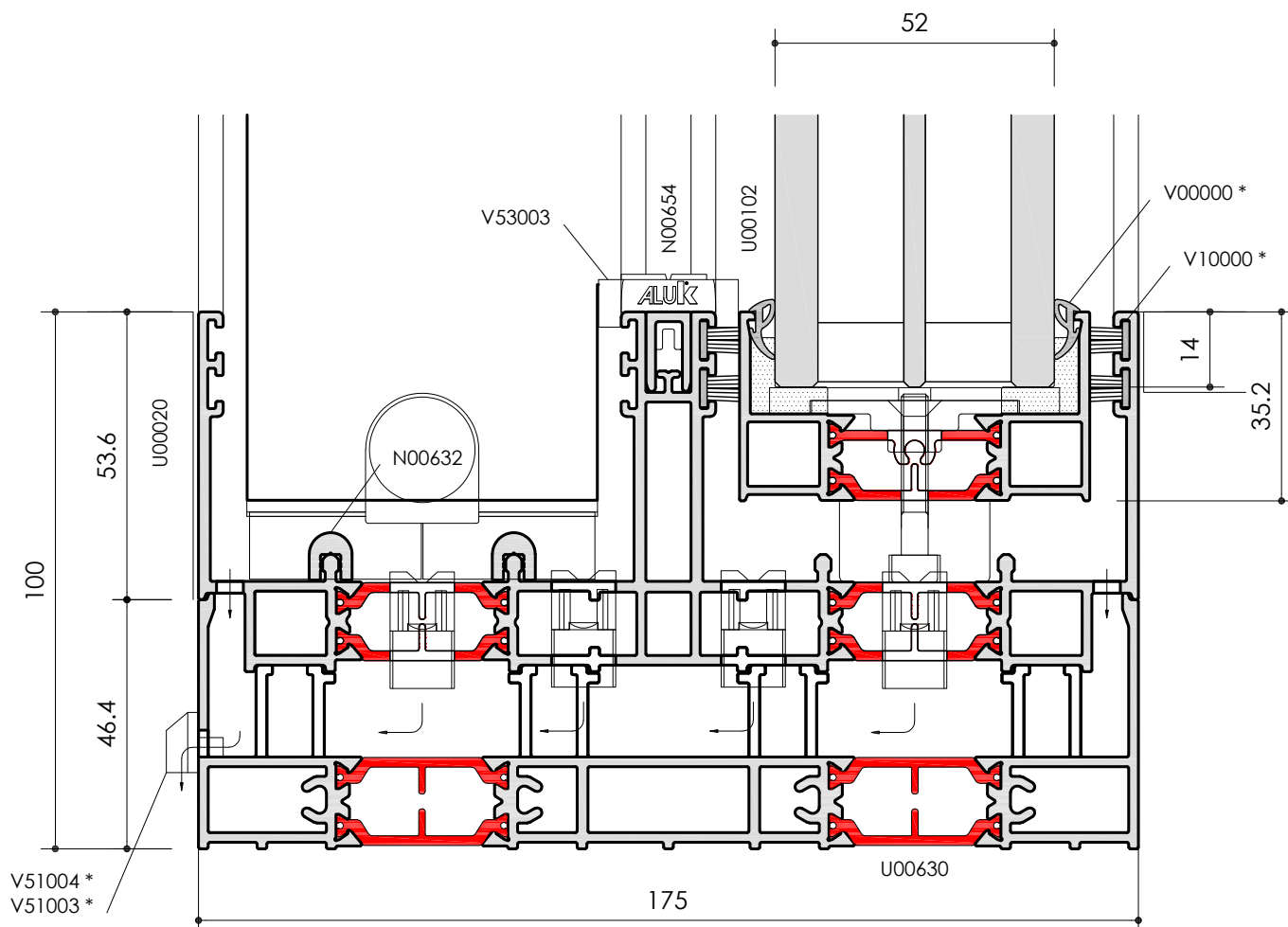
N.B. Gasket & Glazing Configurations are shown in section 7

➤ TYPICAL DETAIL

CILL SECTIONS



Scale 1 : 1.3



* V51004 = Only for Aluk.ITA: 712008

* V51003 = Only for Aluk.ITA: 712007

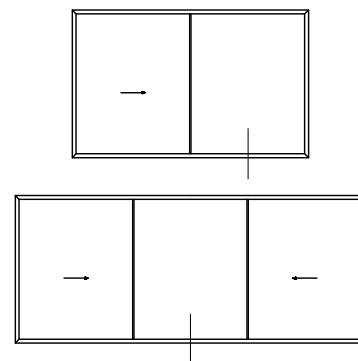
* V10000 = Only for Aluk.GBR: XA621

* V00000 = Only for Aluk.IT: 809119

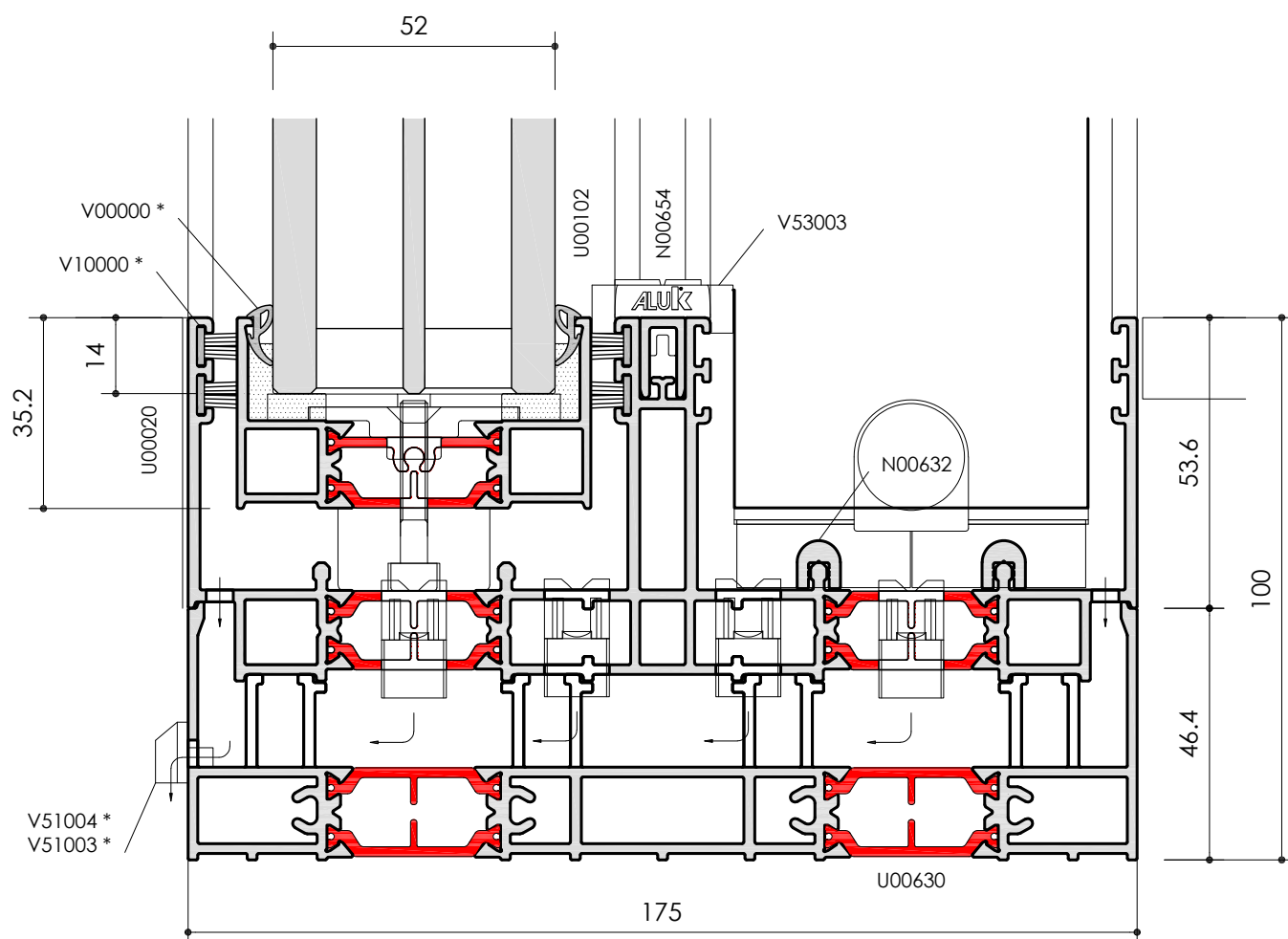
N.B. Gasket & Glazing Configurations are shown in section 7

► TYPICAL DETAIL

CILL SECTIONS



Scale 1 : 1.3



* V51004 = Only for Aluk.ITA: 712008

* V51003 = Only for Aluk.ITA: 712007

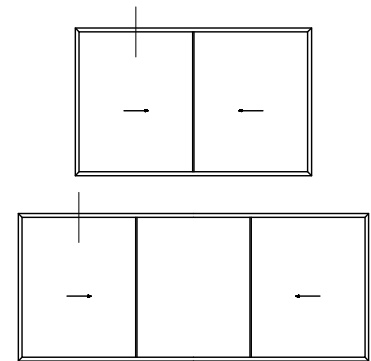
* V10000 = Only for Aluk.GBR: XA621

* V00000 = Only for Aluk.IT: 809119

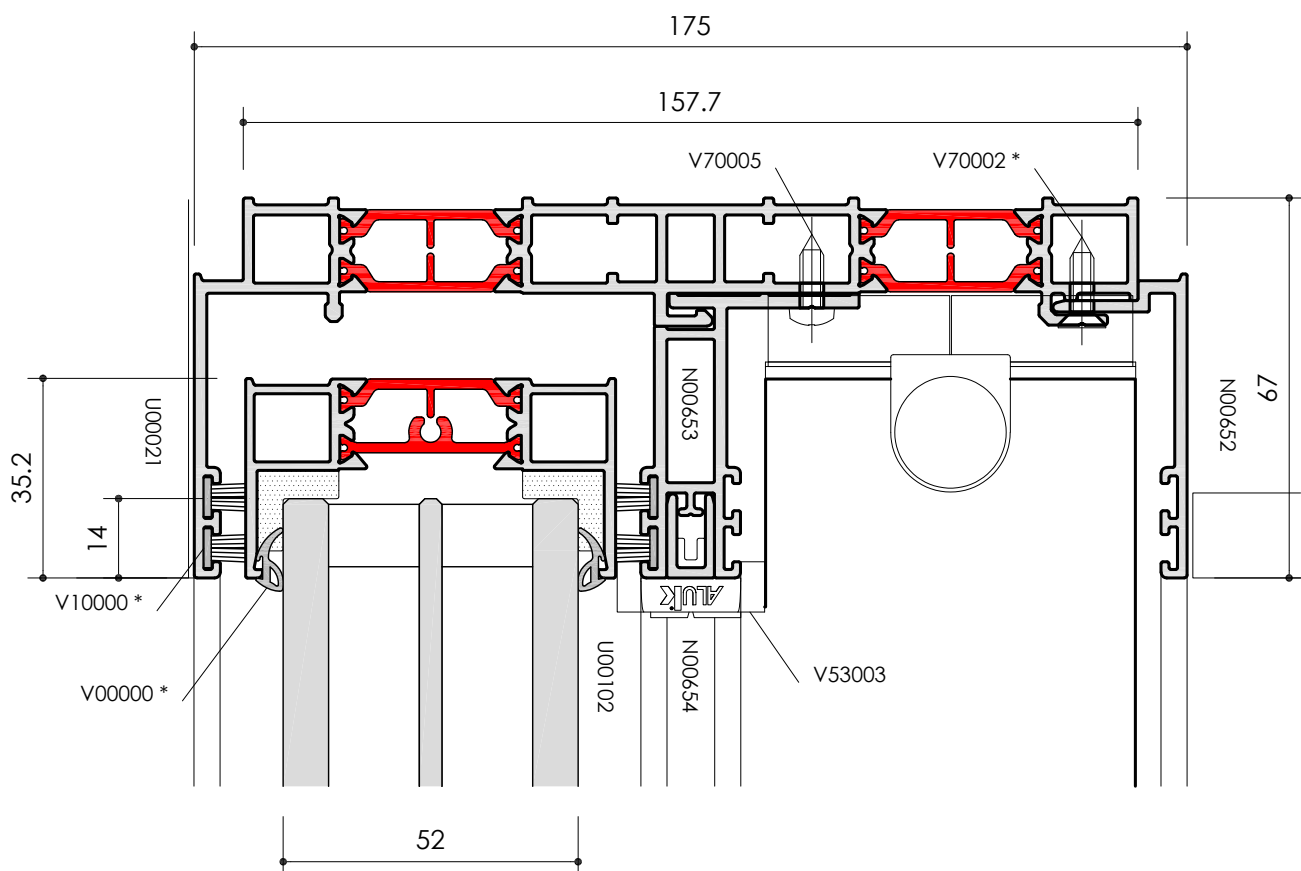
N.B. Gasket & Glazing Configurations are shown in section 7

➤ TYPICAL DETAIL

HEAD SECTIONS



Scale 1 : 1.3



* V10000 = Only for Aluk.GBR: XA621

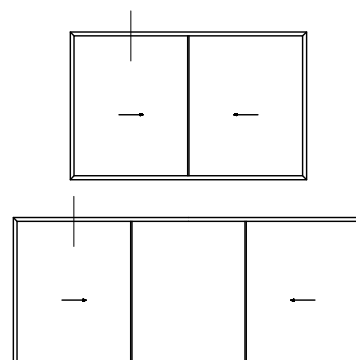
* V70002 = Only for Aluk.GBR: XS1006

* V00000 = Only for Aluk.IT: 809119

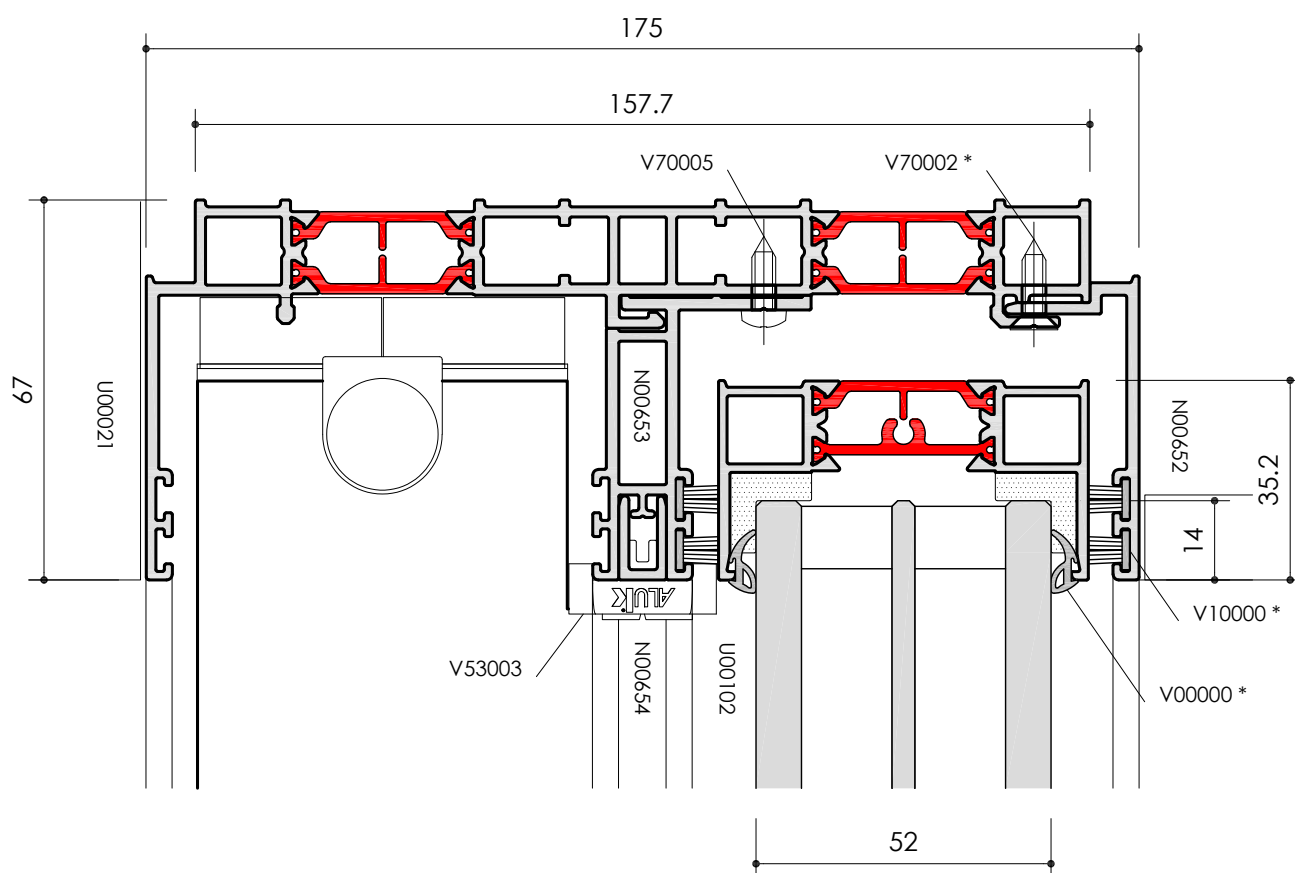
N.B. Gasket & Glazing Configurations are shown in section 7

► TYPICAL DETAIL

HEAD SECTIONS



Scale 1 : 1.3



* V10000 = Only for Aluk.GBR: XA621

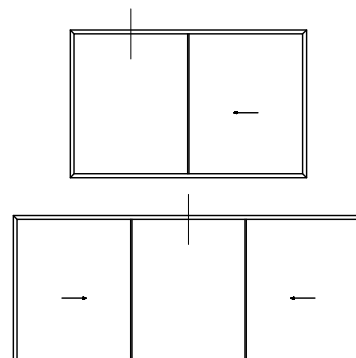
* V70002 = Only for Aluk.GBR: XS1006

* V00000 = Only for Aluk.IT: 809119

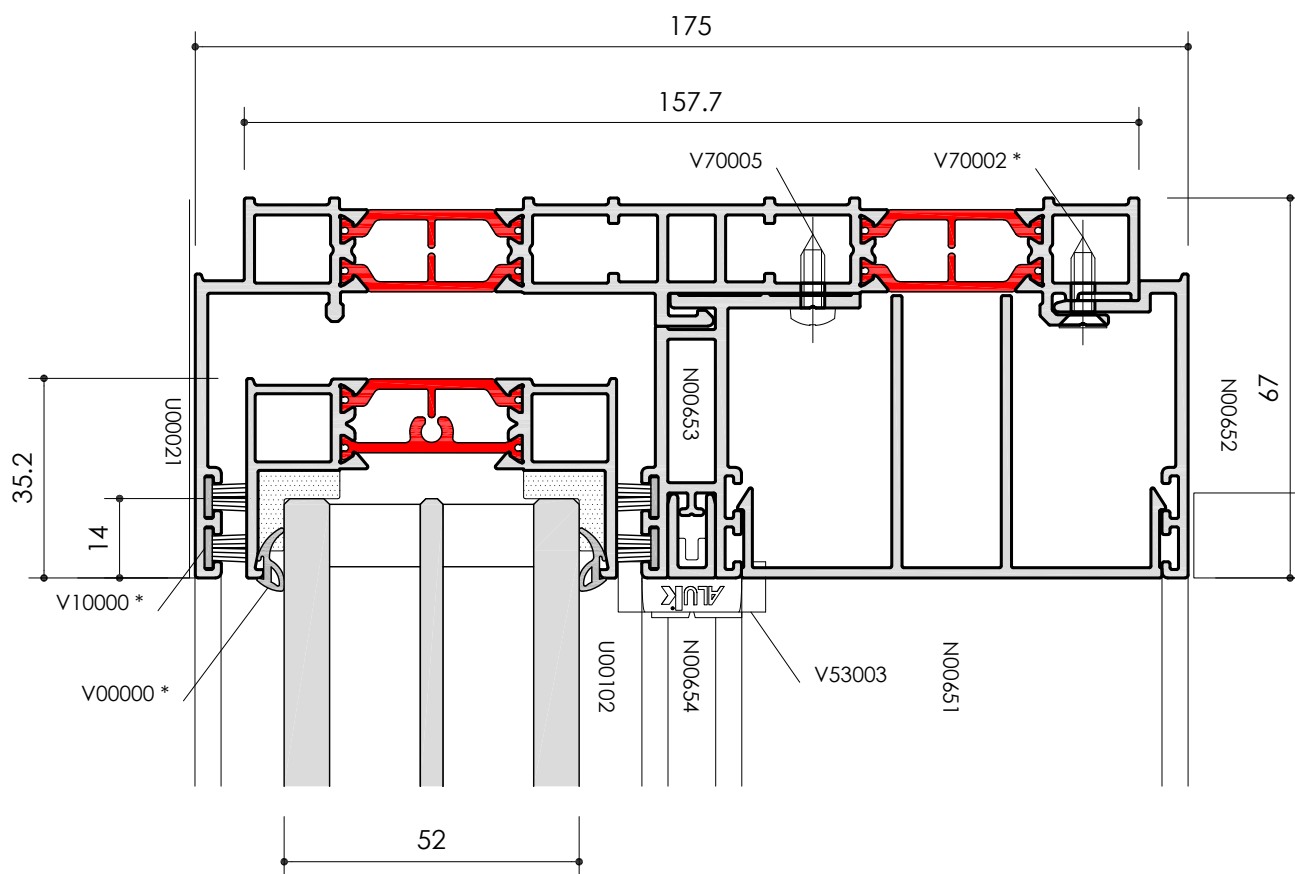
N.B. Gasket & Glazing Configurations are shown in section 7

➤ TYPICAL DETAIL

HEAD SECTIONS



Scale 1 : 1.3



* V10000 = Only for Aluk.GBR: XA621

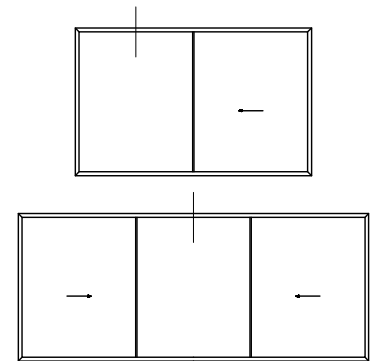
* V70002 = Only for Aluk.GBR: XS1006

* V00000 = Only for Aluk.IT: 809119

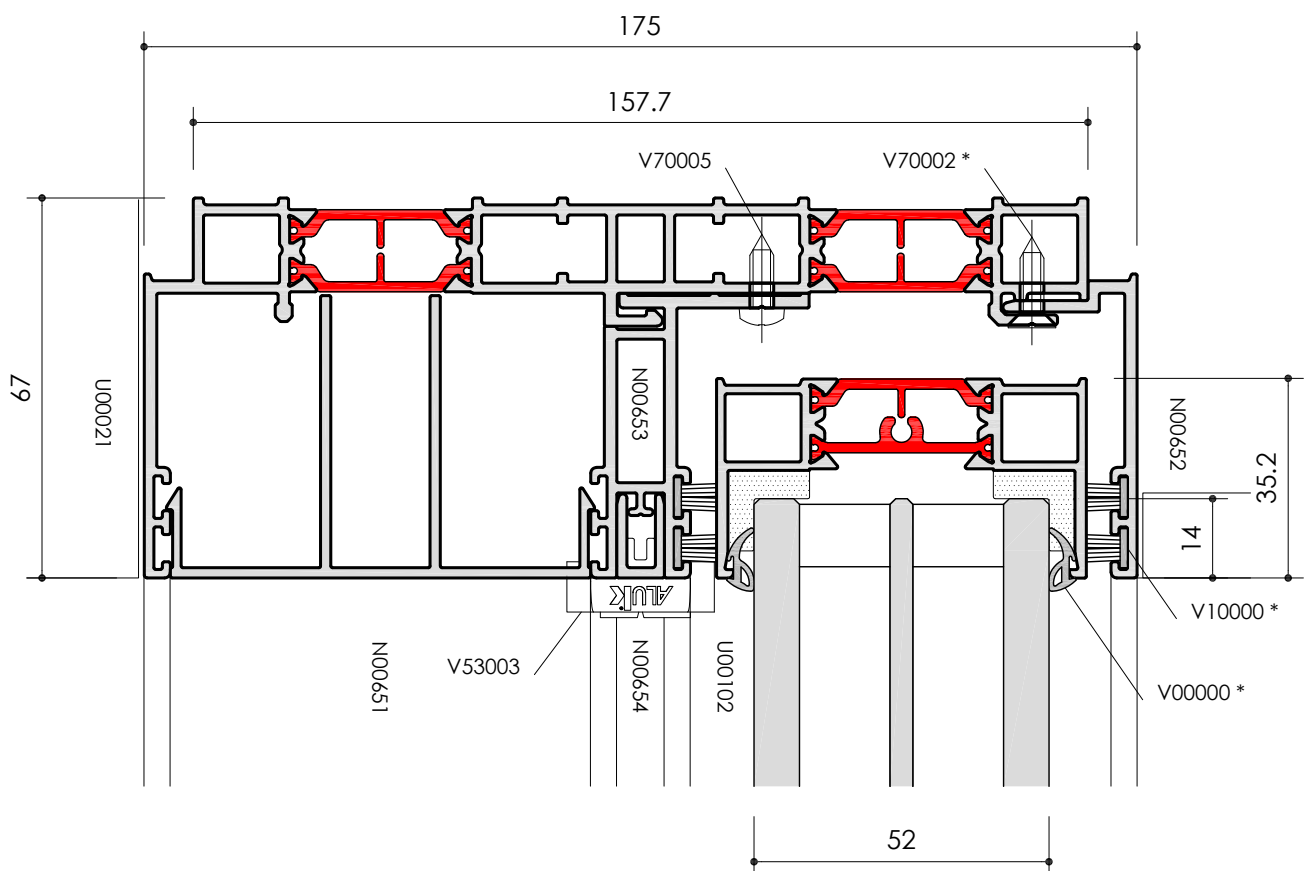
N.B. Gasket & Glazing Configurations are shown in section 7

► TYPICAL DETAIL

HEAD SECTIONS



Scale 1 : 1.3



* V10000 = Only for Aluk.GBR: XA621

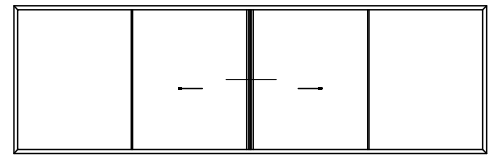
* V70002 = Only for Aluk.GBR: XS1006

* V00000 = Only for Aluk.IT: 809119

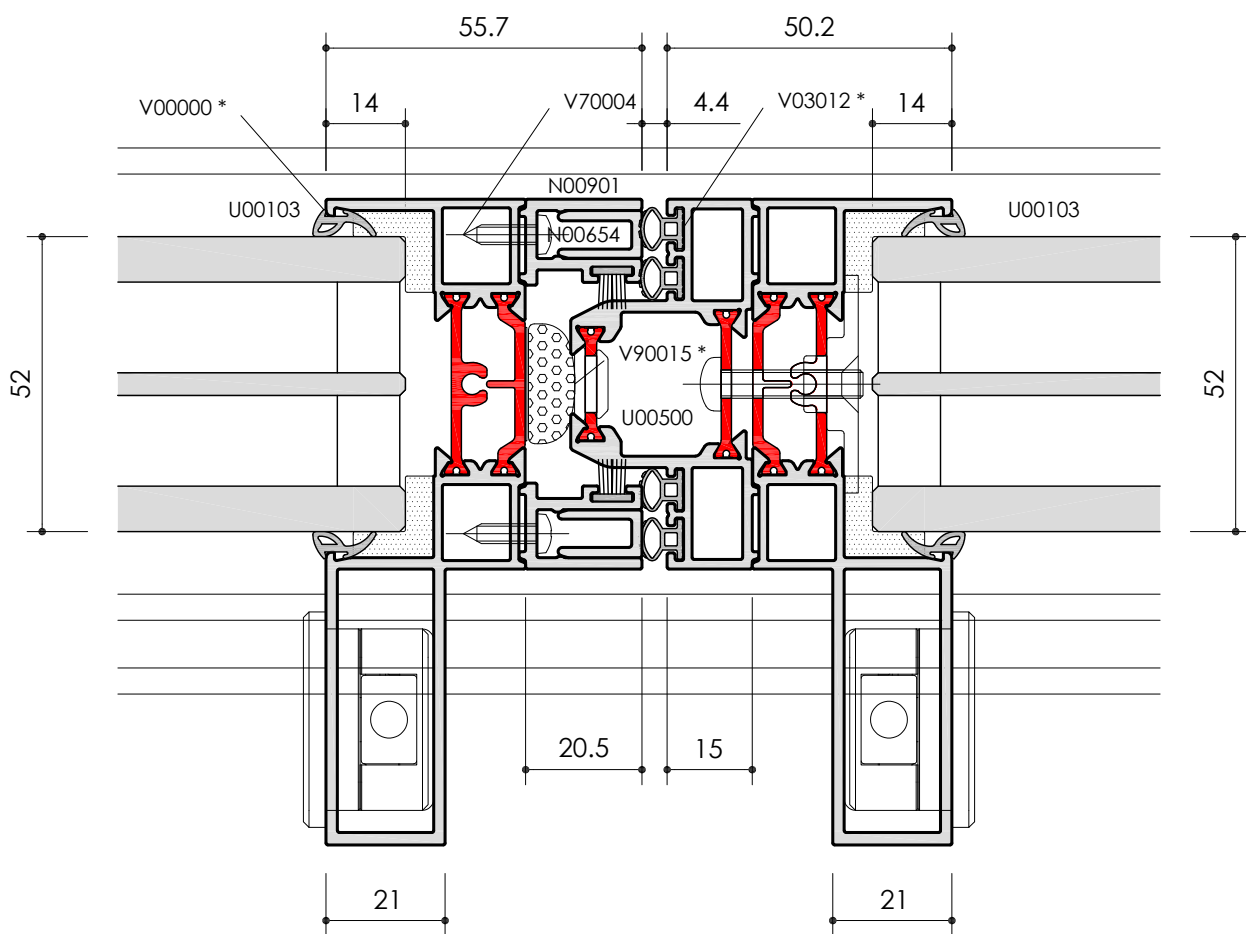
N.B. Gasket & Glazing Configurations are shown in section 7

> TYPICAL DETAIL

MEETING STYLE SECTION



Scale 1 : 1.3



* V10000 = Only for Aluk.GBR: XA621

* V00000 = Only for Aluk.IT: 809119

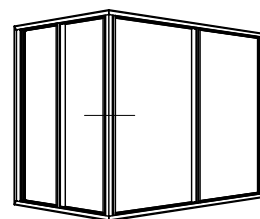
* V32012 = Only for Aluk.FR: J8002

* V90015 = Only for Aluk.IT: 809688

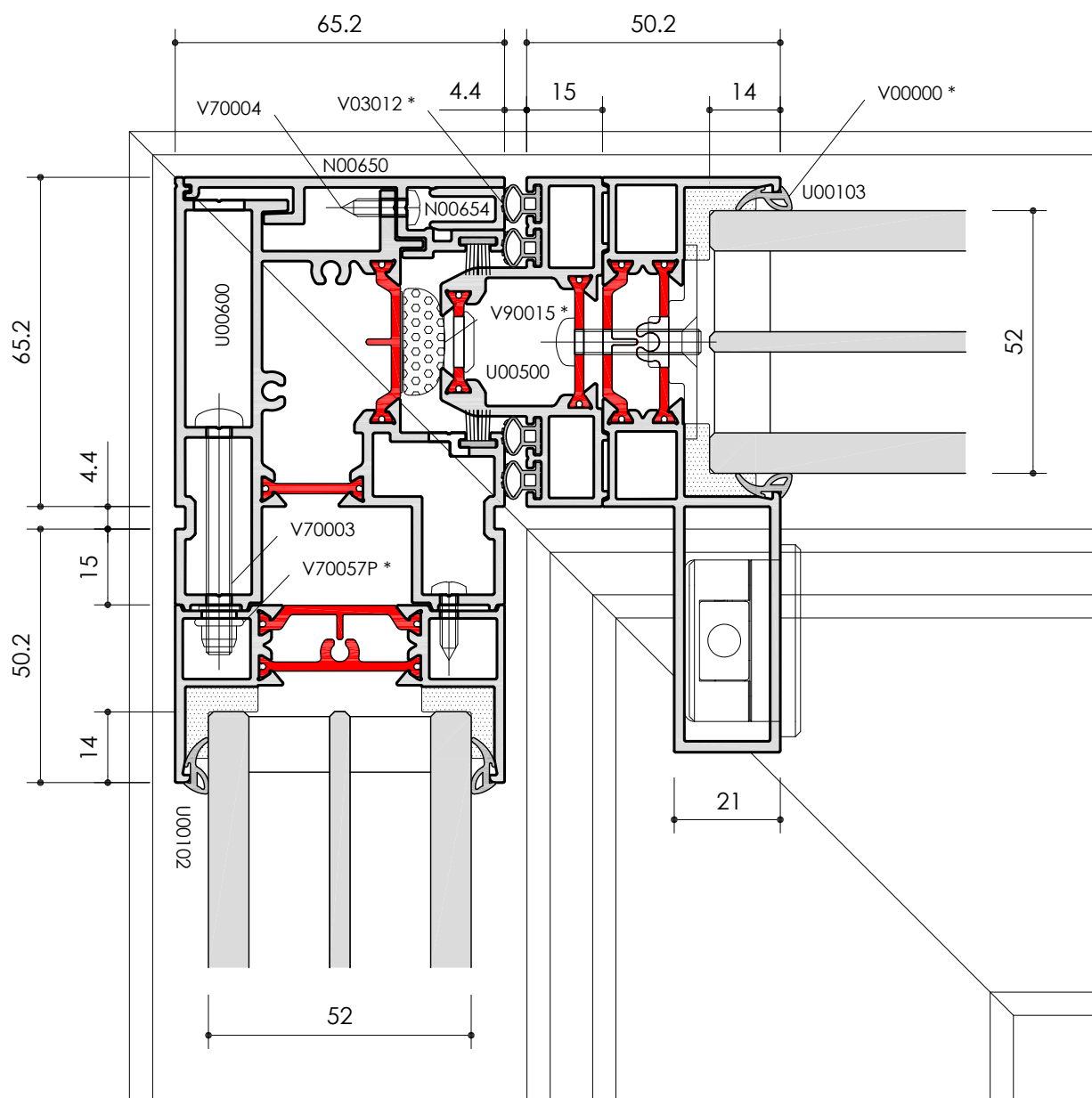
N.B. Gasket & Glazing Configurations are shown in section 7

► TYPICAL DETAIL

CORNER SECTIONS



Scale 1 : 1.3



* V10000 = Only for Aluk.GBR: XA621

* V00000 = Only for Aluk.IT: 809119

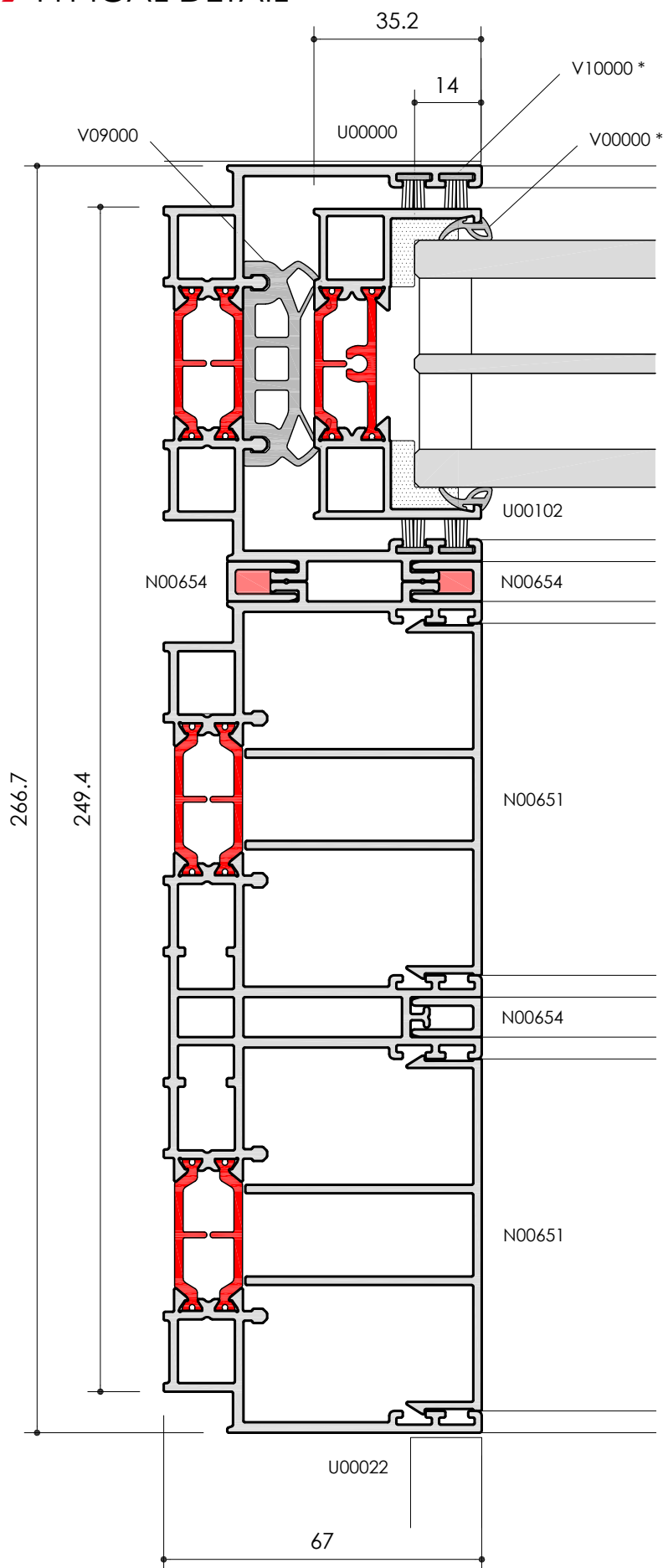
* V32012 = Only for Aluk.FR: J8002

* V70057 = Only for Aluk.GBR: RX652

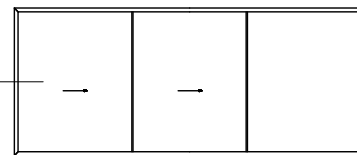
* V90015 = Only for Aluk.IT: 809688

N.B. Gasket & Glazing Configurations are shown in section 7

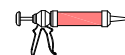
➤ TYPICAL DETAIL



JAMB SECTIONS



Scale 1 : 1.3



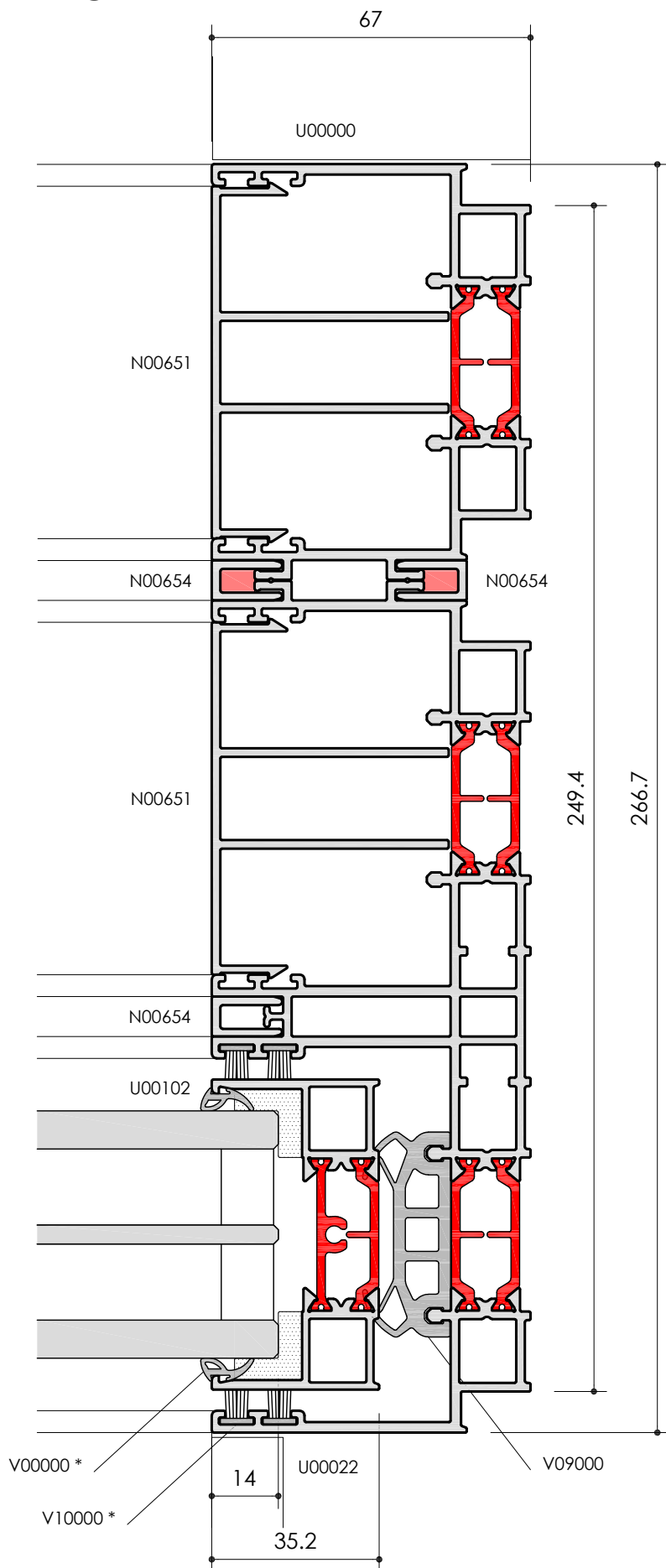
Key: Use T50000 - T50002

* V10000 = Only for Aluk.GBR: XA621

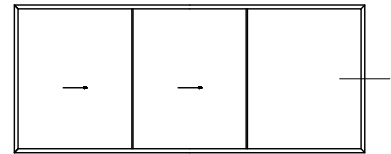
* V00000 = Only for Aluk.IT: 809119

N.B. Gasket & Glazing Configurations are shown in section 7

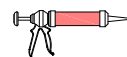
► TYPICAL DETAIL



JAMB SECTIONS



Scale 1 : 1.3



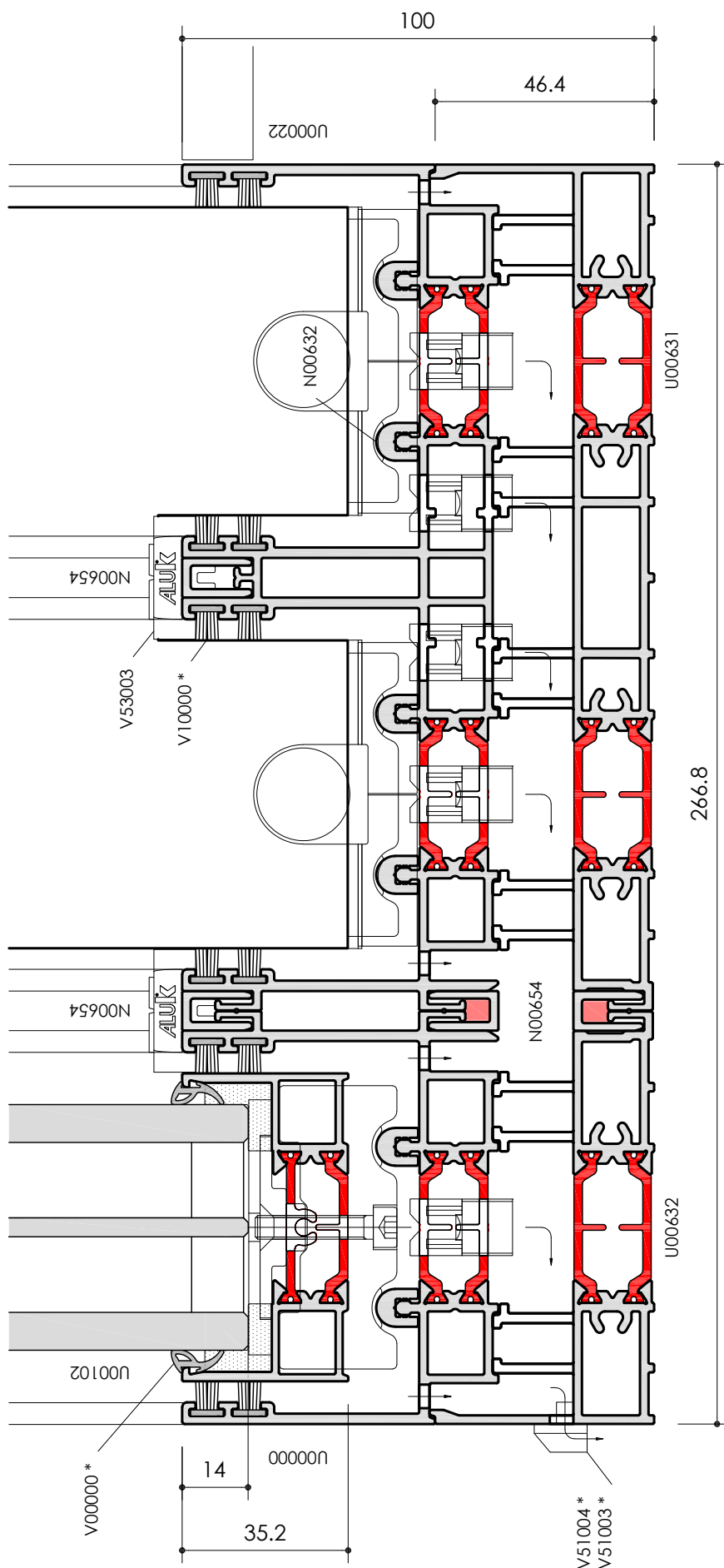
Key: Use T50000 - T50002

* V10000 = Only for Aluk.GBR: XA621

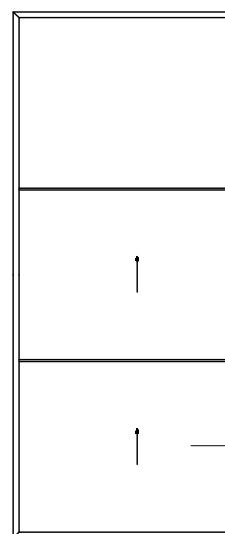
* V00000 = Only for Aluk.IT: 809119

N.B. Gasket & Glazing Configurations are shown in section 7

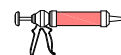
> TYPICAL DETAIL



CILL SECTIONS



Scale 1 : 1.3



Key: Use T50000 - T50002

- * V51004 = Only for Aluk.ITA: 712008
- * V51003 = Only for Aluk.ITA: 712007
- * V10000 = Only for Aluk.GBR: XA621
- * V00000 = Only for Aluk.IT: 809119

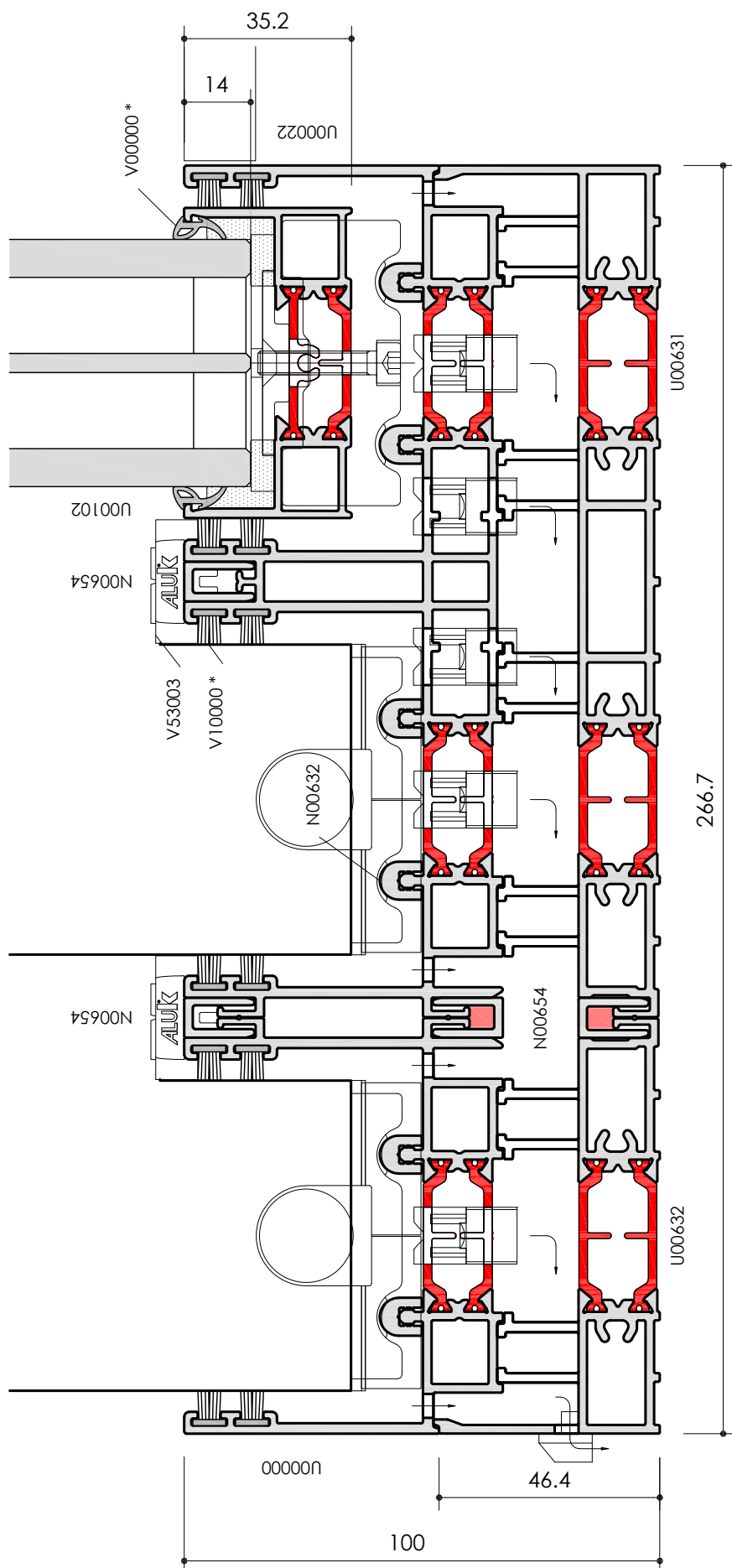
N.B. Gasket & Glazing Configurations are shown in section 7

ALUK

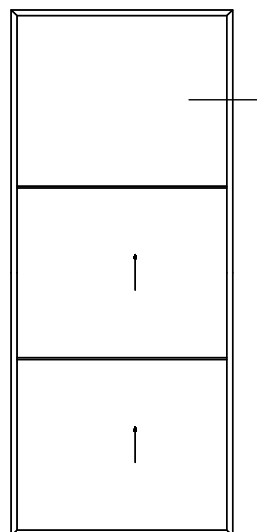
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INFINIUM 6.41 26.01.2018

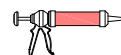
► TYPICAL DETAIL



CILL SECTIONS



Scale 1 : 1.3

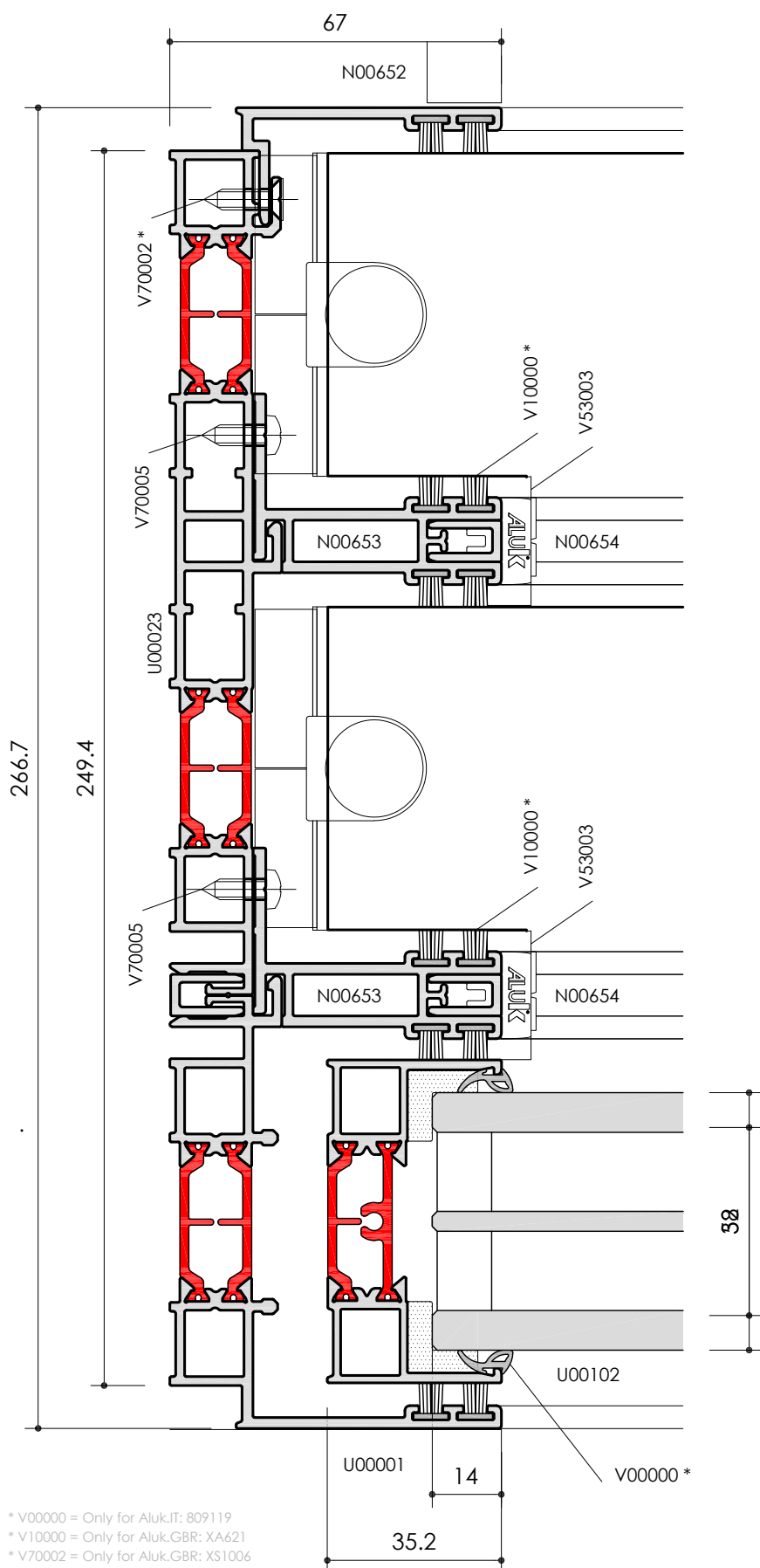


Key: Use T50000 - T50002

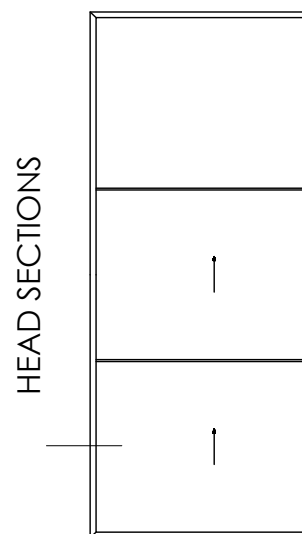
* V10000 = Only for Aluk.GBR: XA621
* V00000 = Only for Aluk.IT: 809119

N.B. Gasket & Glazing Configurations are shown in section 7

▶ TYPICAL DETAIL

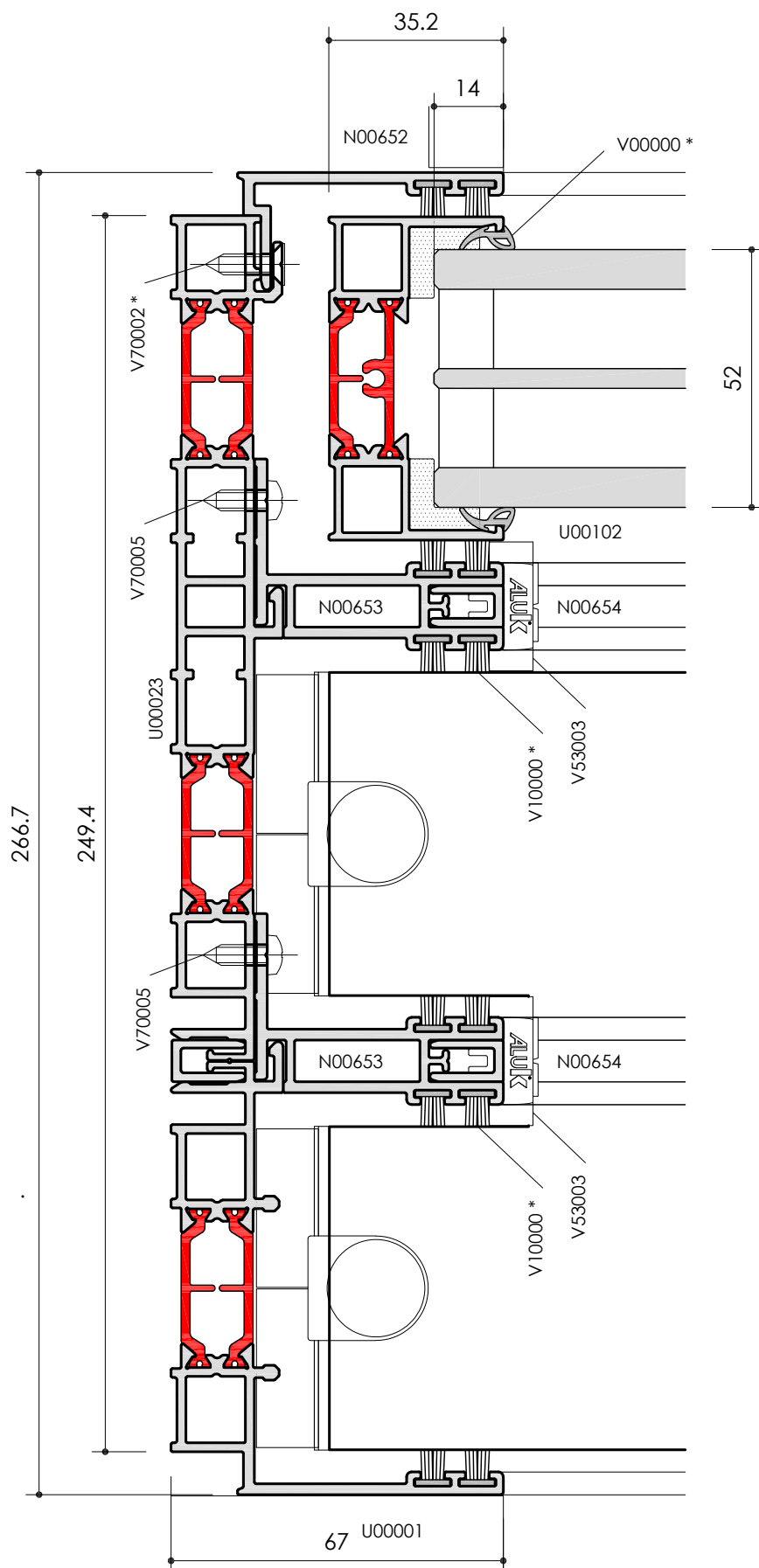


N.B. Gasket & Glazing Configurations are shown in section 7

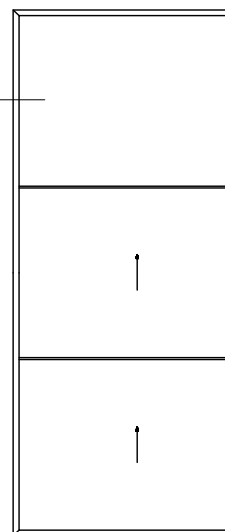


Scale 1 : 1.3

► TYPICAL DETAIL



HEAD SECTIONS



Scale 1 : 1.3

* V00000 = Only for Aluk.IT: 8091119

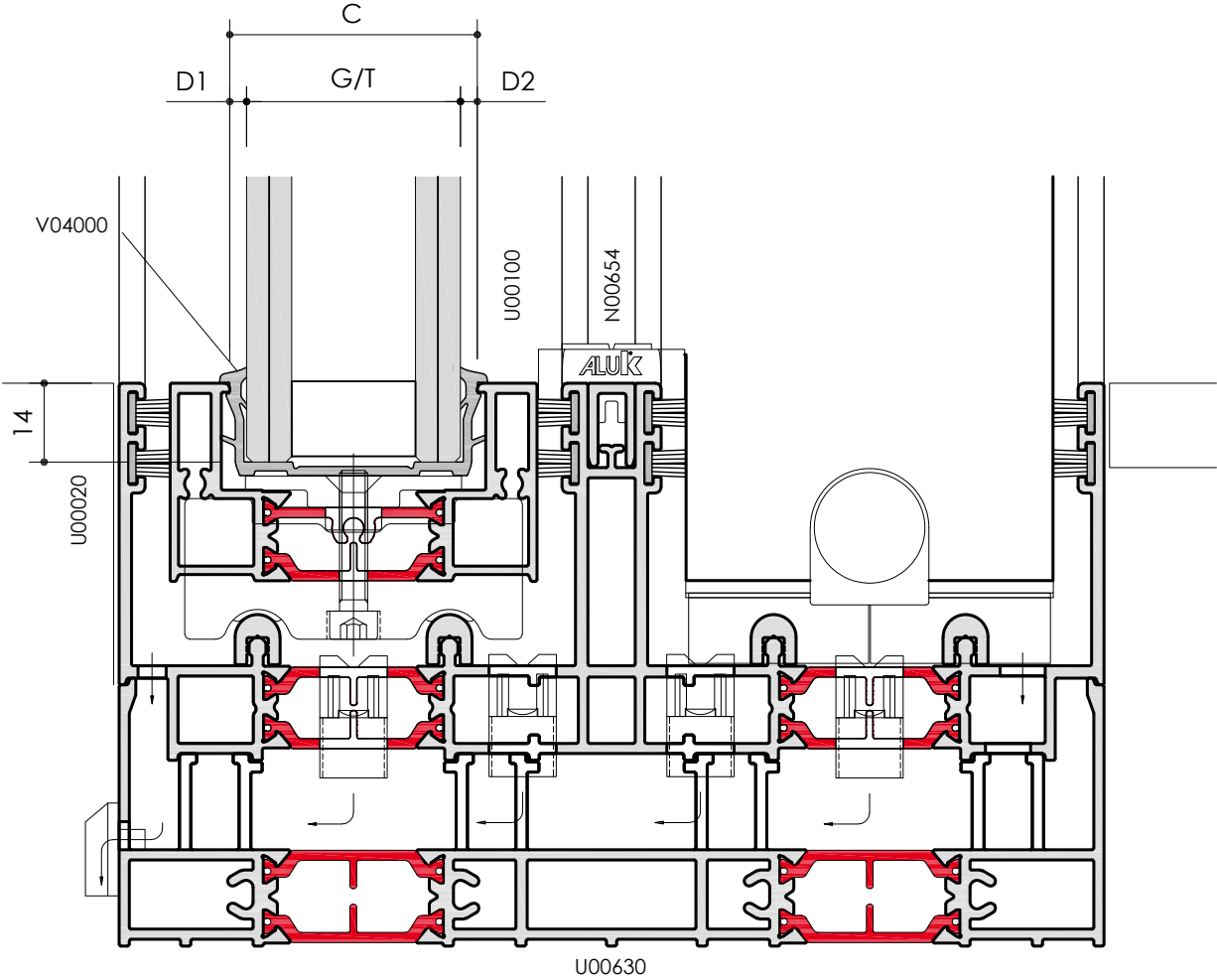
* V10000 = Only for Aluk.GBR: XA621

* V70002 = Only for Aluk.GBR: XS1006

N.B. Gasket & Glazing Configurations are shown in section 7

SECTION 7
GLAZING DETAIL

U00100 Glazing Chart			
G/T	D1	D2	GASKET
mm	Wedge	Wedge	C [U-Gasket]
38	-	-	V04000



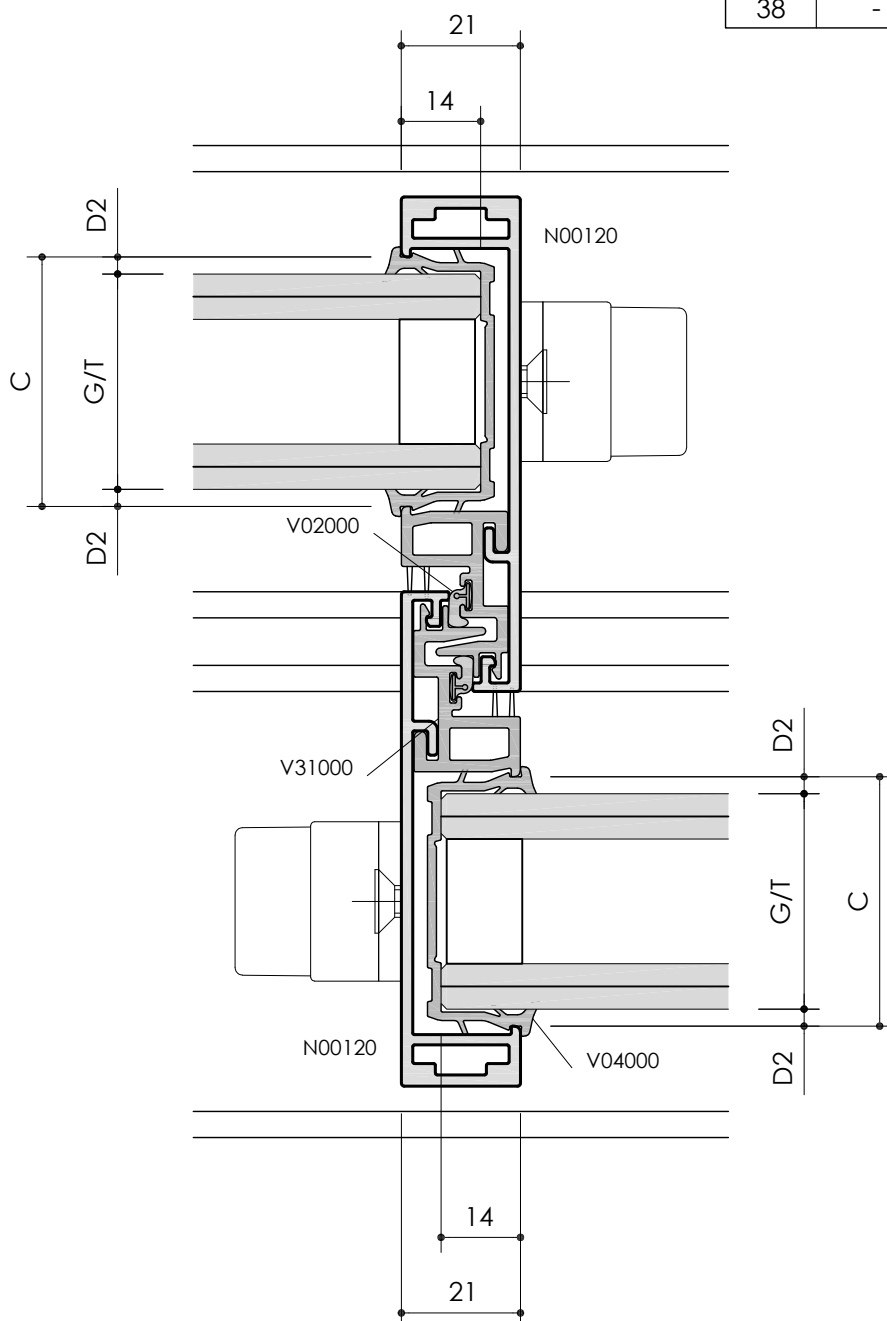
U-GASKET	WEDGE
V04000	-
	
38mm	-

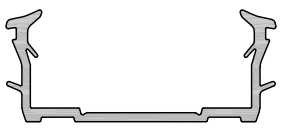
Applicable Profile(s):
U00100 & U00101

N.B. Values shown in the table are exact and could vary depending on tolerances within glazing arrangement.

➤ GLAZING DETAIL

N00120 - N00124 - Glazing Chart			
G/T	D1	D2	GASKET
mm	Wedge	Wedge	C [U-Gasket]
38	-	-	V04000



U-GASKET	WEDGE
V04000	-
	-
38mm	-

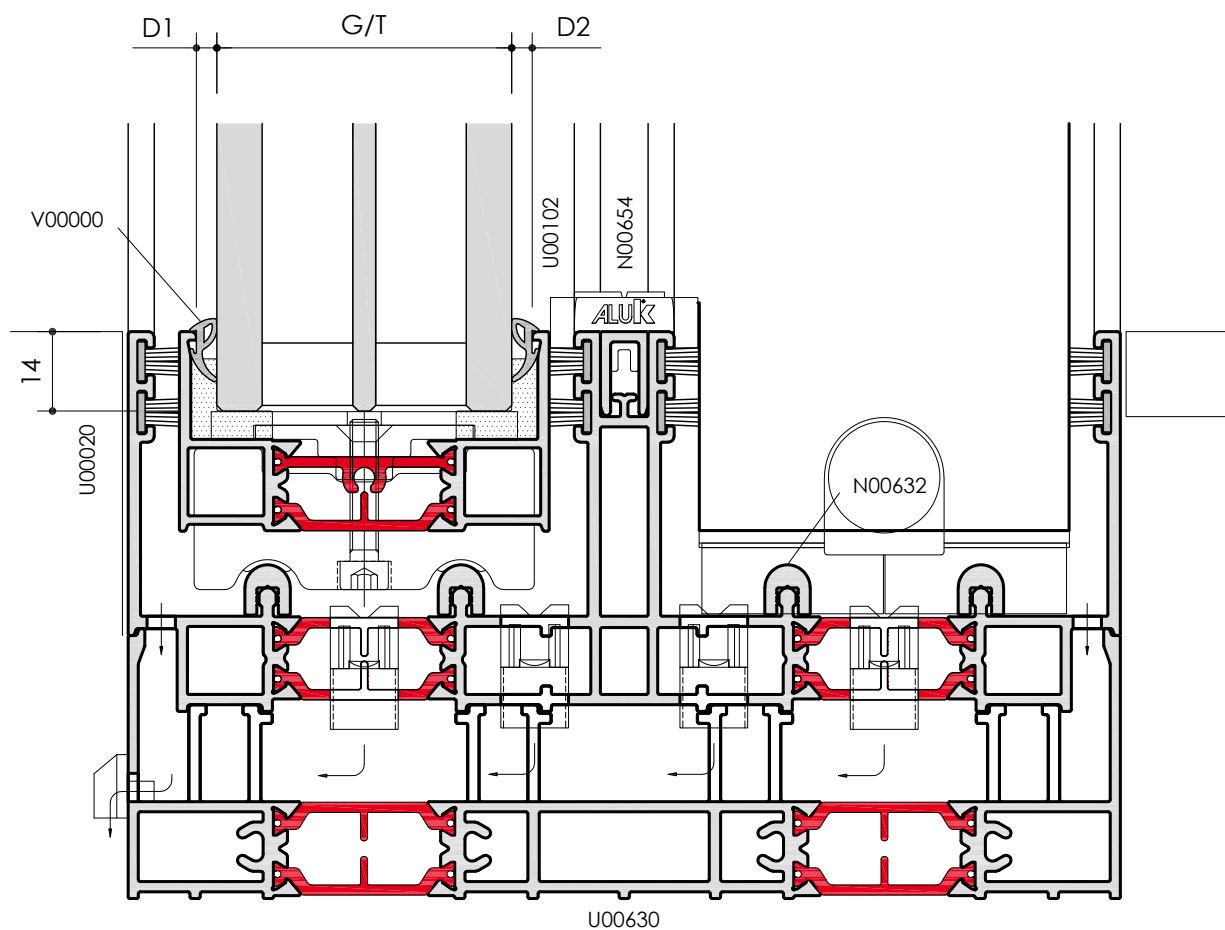
Applicable Profile(s):
N00120, N00121 & N00124

N.B. Values shown in the table are exact and could vary depending on tolerances within glazing arrangement.

> GLAZING CONFIGURATION

U00100 - Glazing Chart

G/T	D1	D2	GASKET
mm	Wedge	Wedge	C [U-Gasket]
52	V00000	V00000	-



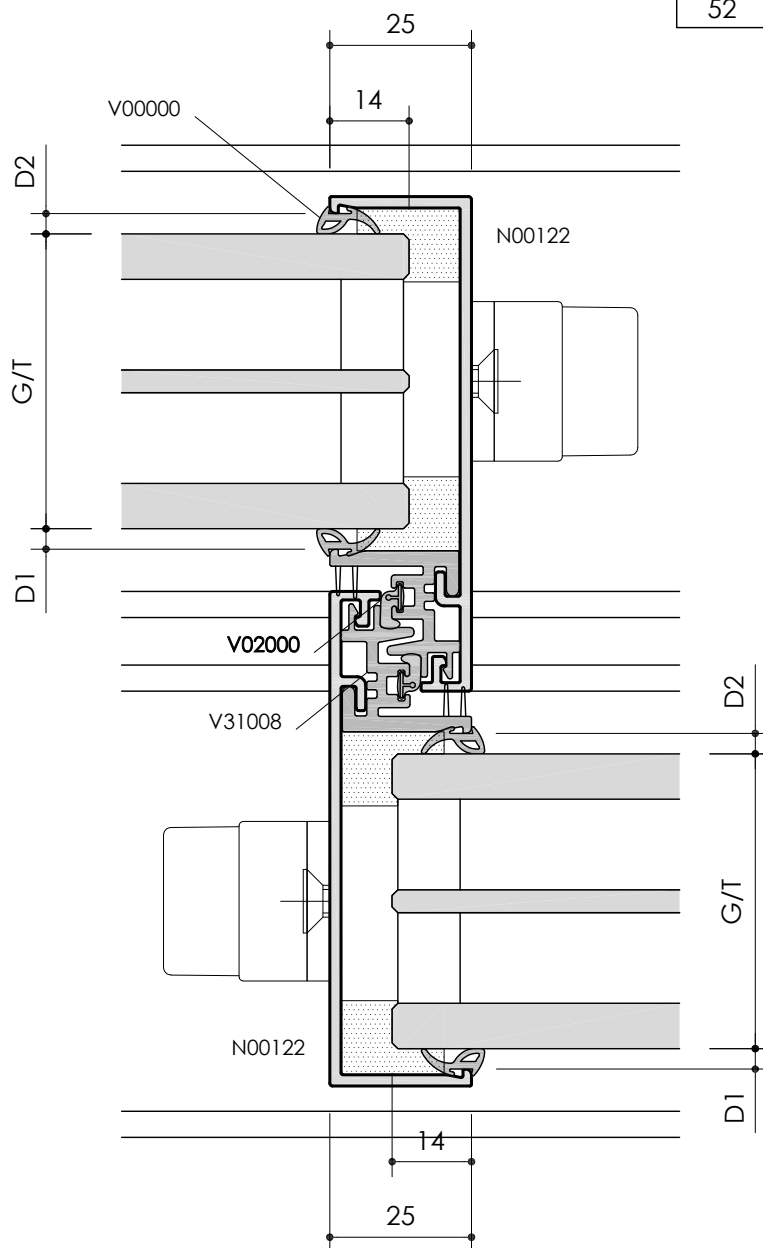
U-GASKET	WEDGE
-	V00000
-	
-	-

Applicable Profile(s):
U00102 & U00103

N.B. Values shown in the table are exact and could vary depending on tolerances within glazing arrangement.

➤ GLAZING CONFIGURATION

N00120 - N00124 - Glazing Chart			
G/T	D1	D2	GASKET
mm	Wedge	Wedge	C [U-Gasket]
52	V00000	V00000	-



U-GASKET	WEDGE
-	V00000
-	

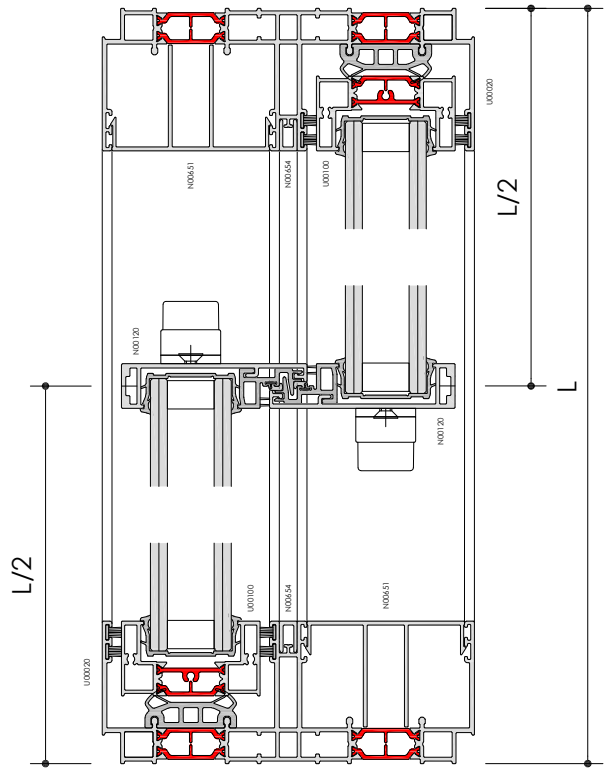
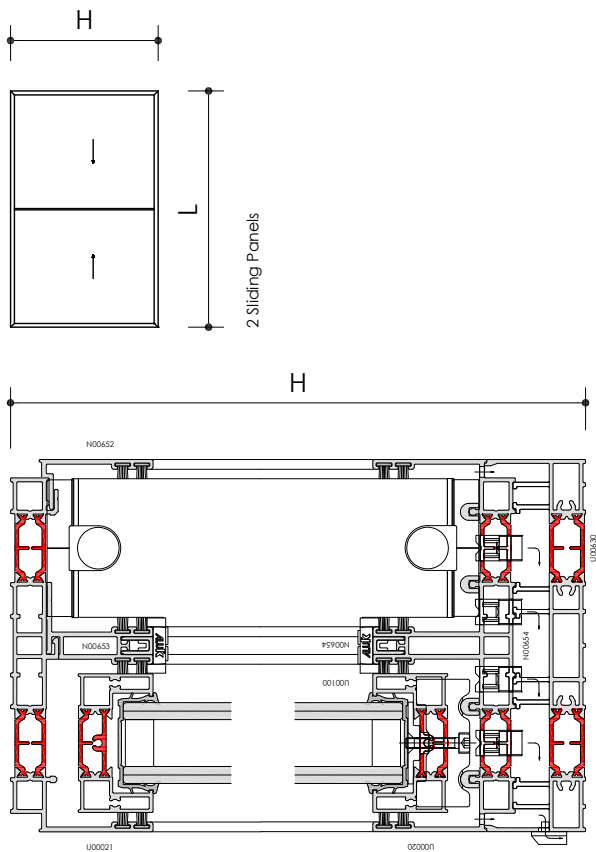
Applicable Profile(s):
N00122, N00123 & N00125

N.B. Values shown in the table are exact and could vary depending on tolerances within glazing arrangement.



SECTION 8 CUTTING LIST

CUTTING LIST

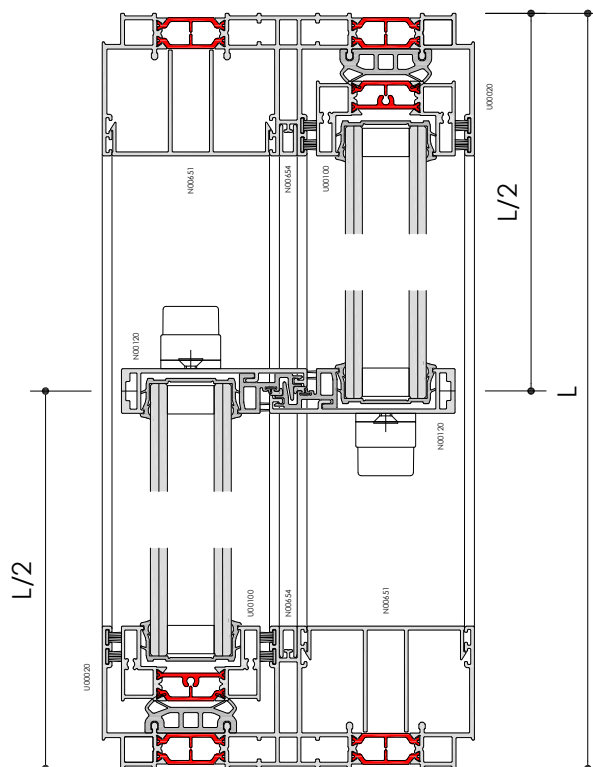
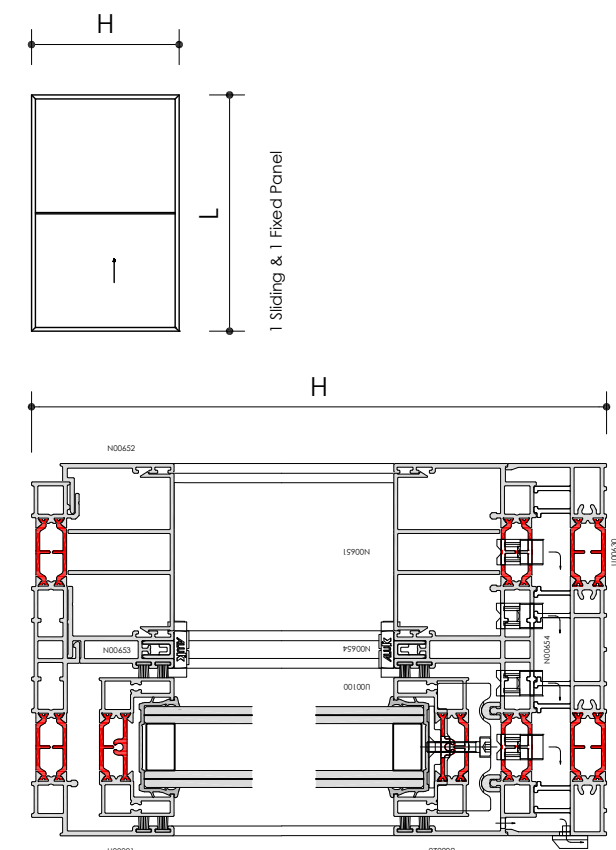


PROFILE	DESCRIPTION	NO.	SIZE	ANGLE
U00020	2 Track Outer Frame	1	L	45°-45°
U00020	2 Track Outer Frame	2	H - 33	45°-45°
U00021	2 Track Outer Frame (Head)	1	L	45°-45°
U00630	Drainage Sub Cill	1	L	90°-90°
N00632	Aluminium Track	4	L - 44	90°-90°
N00651	Outer Frame Cover Profile	2	H - 74.2	90°-90°
N00652	Internal Rebate	1	L - 26.8	45°-45°
N00653	Central Rebate	1	L - 33.6	45°-45°
N00654	Connector Clip	4	(L - 155)/2	90°-90°
N00654	Connector Clip	2	H - 167	90°-90°
U00100	Double Glazed Sash	2	H - 96.6	45°-45°
U00100	Double Glazed Sash	2	L/2 - 23.3	45°-90°
U00100	Double Glazed Sash	2	L/2 - 23.3	45°-90°
N00120	21mm Interlock Profile	2	H - 96.6	90°-90°
ACCESSORIES				
V20000	Interlock Foam Plug			2
V42000 *	Mechanical Cleat (13mm)			24
V53003	Interlock Seal (EPDM)			4
V55000	Sub Cill End Caps			1 Pair
V58000	Interlock End Cap			4
V62000	Roller Glazing Packer			4
V70000 *	Mechanical Cleat Screw			48
V70001	Ø4.2 x 30mm Pozzi Pan Polyamide Screw			4
V51001 *	Ø10.5mm Hole Plug (Black)			-
V51003 *	Water Drain Cap With Valve (Black)			-
V51004 *	Water Drain Cap With Valve (White)			-
V51005 *	Drainage Ball Valves			-
T50000/1/2	Small Joint Sealant/Adhesive			-
T50003	Aluk Sealant Wipes			-
GASKET / PLASTIC PROFILE				
V02000	Co-Extruded Bubble Seal (Q-Lon)		2H	
V04000	38mm Double Glazed U Gasket		2L + 4H	
V09000	Outer Frame Bumper Seal		2H	
V10000 *	Outer Frame Sliding Seal/Fin Pile 6.9mmx 6mm		16L + 8H	
V31000	21mm PVC Interlock Profile	2	H - 96.6	90°-90°
GLASS				
Glass unit 38mm		NO.	WIDTH	HEIGHT
		2	L/2 - 49.5	H - 139

HARDWARE		PACK QTY	QUANTITY
H00100	Lateral Locking Handle	1	2
H00101	Lateral Pull Handle	1	2
H00200	Roller Wheels	1	4
H00400	Lateral Lock	1	2
H00401	Lateral Lock Adjustable Keep	1	2
H00404	Lateral Lock Lever	1	2

* V00000 = Only for Aluk.ITA; 809119
 * V10000 = Only for Aluk.GBR; XA621
 * V42000 = Only for Aluk.FRA; 27500
 * V51001 = Only for Aluk.ITA; 709616
 * V51002 = Only for Aluk.ITA; 709617
 * V51003 = Only for Aluk.ITA; 712007
 * V51004 = Only for Aluk.ITA; 712008
 * V51005 = Only for Aluk.GBR; A-00-225
 * V70000 = Only for Aluk.FRA; 86720

CUTTING LIST

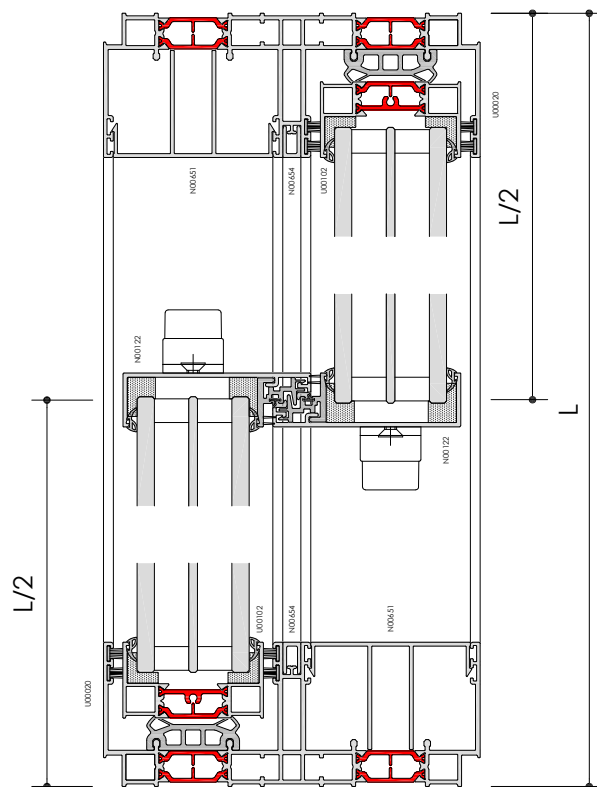
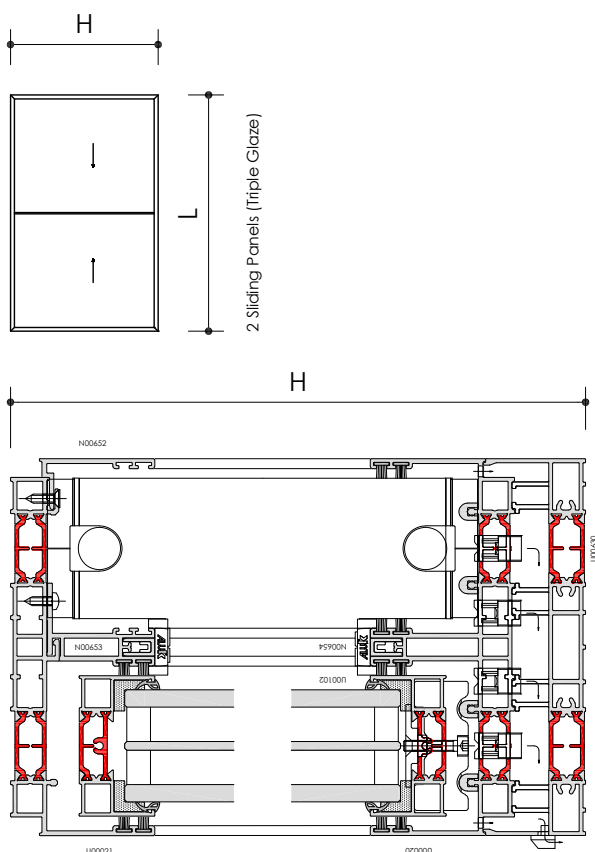


PROFILE	NO.	SIZE	ANGLE
U00020	1	L	45°-45°
U00020	2	H - 33	45°-45°
U00021	1	L	45°-45°
U00630	1	L	90°-90°
N00632	2	L - 44	90°-90°
N00651	2	H - 74.2	90°-90°
N00651	2	L/2 - 77.5	90°-90°
N00652	1	L - 26.8	45°-45°
N00653	1	L - 33.6	45°-45°
N00654	4	(L - 155)/2	90°-90°
N00654	2	H - 167	90°-90°
U00100	2	H - 96.6	45°-45°
U00100	2	L/2 - 23.3	45°-90°
U00100	2	L/2 - 23.3	45°-90°
N00120	2	H - 96.6	90°-90°
ACCESSORIES			
V20000	2		
V42000 *	24		
V50001	2		
V53003	2		
V55000	1 Pair		
V58000	4		
V62000	4		
V70000 *	48		
V70001	4		
V51001 *	-		
V51003 *	-		
V51004 *	-		
V51005 *	-		
T50000/1/2	-		
T50003	-		
GASKET / PLASTIC PROFILE			
V02000	2H		
V04000	2L + 4H		
V09000	2H		
V10000 *	16L + 8H		
V31000	2	H - 96.6	90°-90°
GLASS	2	WIDTH	HEIGHT
Glass unit 38mm	2	L/2 - 49.5	H - 139

HARDWARE	PACK QTY	QUANTITY
H00100	1	1
H00101	1	1
H00200	1	2
H00400	1	1
H00401	1	1
H00404	1	1

* V00000 = Only for Aluk.IT: 809119
 * V10000 = Only for Aluk.GBR: XA621
 * V42000 = Only for Aluk.FRA: 27500
 * V51001 = Only for Aluk.ITA: 709616
 * V51002 = Only for Aluk.ITA: 709617
 * V51003 = Only for Aluk.ITA: 712007
 * V51004 = Only for Aluk.ITA: 712008
 * V51005 = Only for Aluk.GBR: A-00-225
 * V70000 = Only for Aluk.FRA: 86720

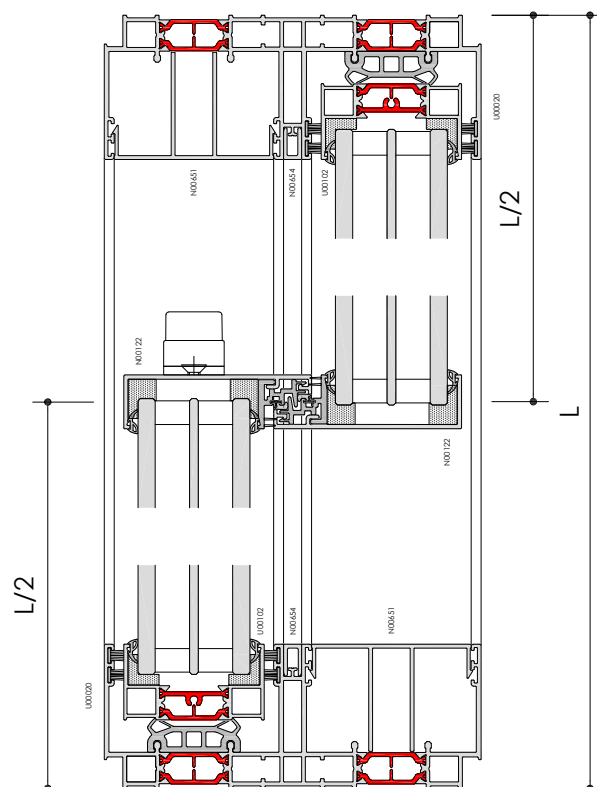
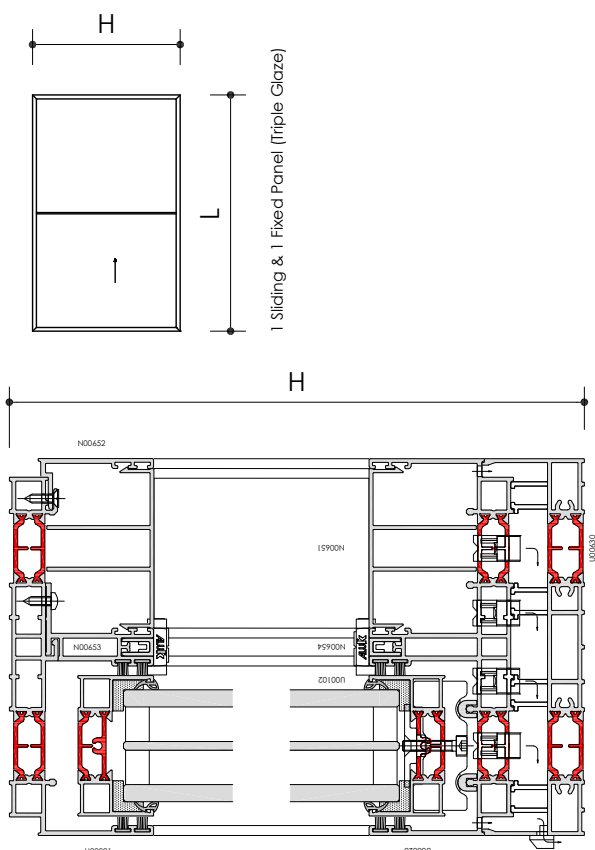
CUTTING LIST



TG PROFILE	DESCRIPTION	NO.	SIZE	ANGLE
U00020	2 Track Outer Frame	1	L	45°-45°
U00020	2 Track Outer Frame	2	H - 33	45°-45°
U00021	2 Track Outer Frame (Head)	1	L	45°-45°
U00030	Drainage Sub Cill	1	L	90°-90°
N00632	Aluminium Track	4	L - 44	90°-90°
N00651	Outer Frame Cover Profile	2	H - 74.2	90°-90°
N00652	Internal Rebate	1	L - 26.8	45°-45°
N00653	Central Rebate	1	L - 33.6	45°-45°
N00654	Connector Clip	4	(L - 155)/2	90°-90°
N00654	Connector Clip	2	H - 167	90°-90°
U00102	Triple Glazed Sash	2	H - 96.6	45°-45°
U00102	Triple Glazed Sash	2	L/2 - 23.3	45°-90°
U00102	Triple Glazed Sash	2	L/2 - 23.3	45°-90°
N00122	25mm TG Interlock Profile	2	H - 96.6	90°-90°
TG ACCESSORIES				
V20000	Interlock Foam Plug	2		QTY
V42000 *	Mechanical Cleat (13mm)	24		
V53003	Interlock Seal (EPDM)	4		
V55000	Sub Cill End Caps	1 Pair		
V58000	Interlock End Cap	4		
V59047	Triple Glazed Sash Bridge Packer	8		
V62000	Roller Glazing Packer	8		
V70000 *	Mechanical Cleat Screw	48		
V70001	Ø4.2 x 30mm Pozzi Pan Polyamide Screw	4		
V51001 *	Ø10.5mm Hole Plug (Black)	-		
V51003 *	Water Drain Cap With Valve (Black)	-		
V51004 *	Water Drain Cap With Valve (White)	-		
V51005 *	Drainage Ball Valves	-		
T50000-2	Small Joint Sealant/Adhesive	-		
T50003	Aluk Sealant Wipes	-		
T50004	Dow Corning 776 Silicone Bond	-		
GASKET / PLASTIC PROFILE				
V02000	Co-Extruded Bubble Seal (Q-Lon)	2H		
V00000 *	2 - 3mm Wedge Gasket	2L + 4H		
V09000	Outer Frame Bumper Seal	2H		
V10000 *	Sliding Seal/Fin Pile 6.9 x 8.5mm	16L + 8H		
V31008	25mm PVC Interlock Profile	2	H - 96.6	90°-90°
GLASS				
	Glass unit 52mm	NO.	WIDTH	HEIGHT
		2	L/2 - 49.5	H - 139
HARDWARE				
H00100	Lateral Locking Handle	PACK QTY	QTY	
H00101	Lateral Pull Handle	1	1	
H00200	Roller Wheels	1	8	
H00400	Lateral Lock	1	1	
H00401	Lateral Lock Adjustable Keep	1	1	
H00404	Lateral Lock Lever	1	1	

* V00000 = Only for Aluk IT: 809119
 * V10000 = Only for Aluk.GBR: XA621
 * V42000 = Only for Aluk.FRA: 27500
 * V51001 = Only for Aluk.ITA: 709616
 * V51002 = Only for Aluk.ITA: 709617
 * V51003 = Only for Aluk.ITA: 712007
 * V51004 = Only for Aluk.ITA: 712008
 * V51005 = Only for Aluk.GBR: A-00-225
 * V70000 = Only for Aluk.FRA: 86720

CUTTING LIST



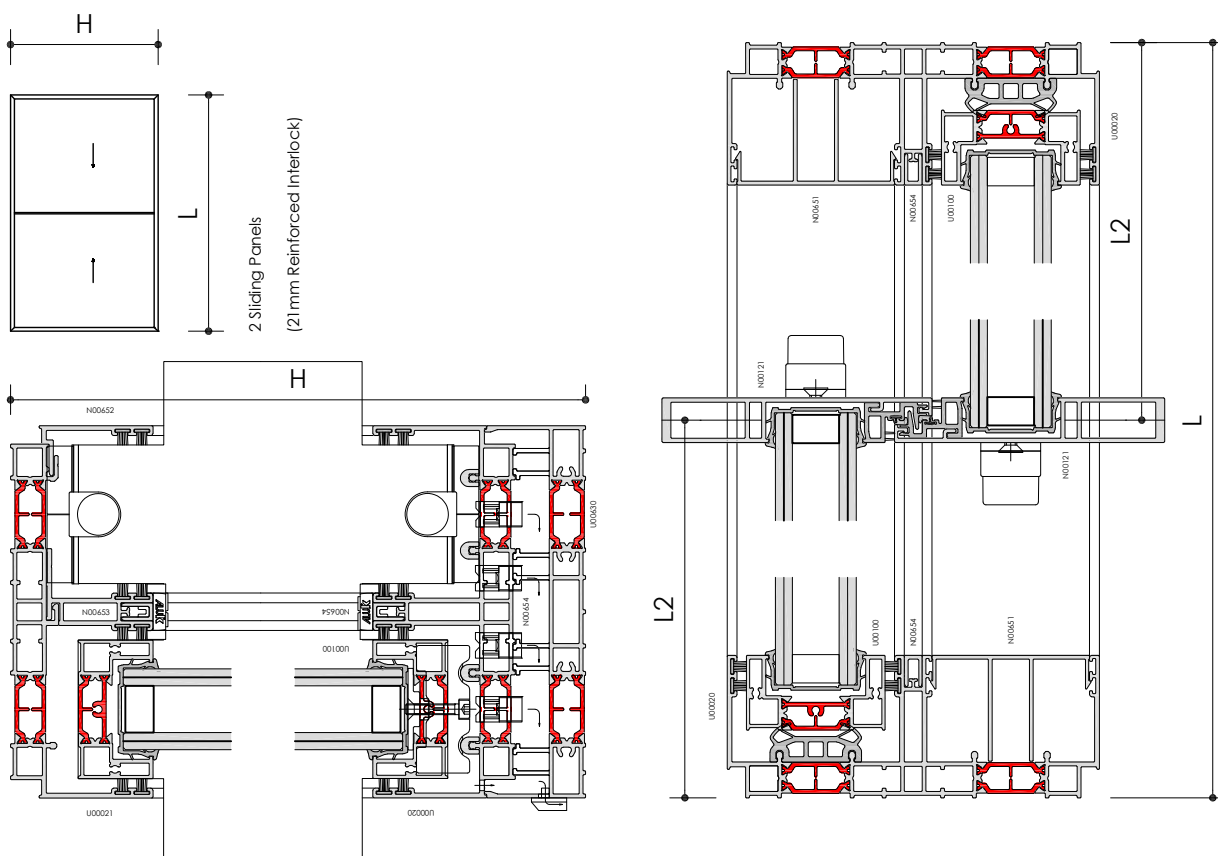
TG PRO.	DESCRIPTION	NO.	SIZE	ANGLE
U00020	2 Track Outer Frame	1	L	45°-45°
U00020	2 Track Outer Frame	2	H - 33	45°-45°
U00021	2 Track Outer Frame (Head)	1	L	45°-45°
U00630	Drainage Sub Cill	1	L	90°-90°
N00630	Aluminium Track	2	L - 44	90°-90°
N00651	Outer Frame Cover Profile	2	H - 74.2	90°-90°
N00651	Outer Frame Cover Profile	2	L/2 - 77.5	90°-90°
N00652	Internal Rebate	1	L - 26.8	45°-45°
N00653	Central Rebate	1	L - 33.6	45°-45°
N00654	Connector Clip	4	(L - 155)/2	90°-90°
N00654	Connector Clip	2	H - 167	90°-90°
U00102	Triple Glazed Sash	2	H - 96.6	45°-45°
U00102	Triple Glazed Sash	2	L/2 - 23.3	45°-90°
U00102	Triple Glazed Sash	2	L/2 - 23.3	45°-90°
N00122	25mm TG Interlock Profile	2	H - 96.6	90°-90°
TG ACC.				
V20000	Interlock Foam Plug	2		QTY
V42000 *	Mechanical Cleat (13mm)	24		
V50001	Fixed Sash Support Blocks	4		
V53003	Interlock Seal (EPDM)	4		
V55000	Sub Cill End Caps	1 Pair		
V58000	Interlock End Cap	4		
V59047	Triple Glazed Sash Bridge Packer	8		
V62000	Roller Glazing Packer	4		
V70000 *	Mechanical Cleat Screw	48		
V70001	Ø4.2 x 30mm Pozz Pan Polyamide Screw	4		
V51001 *	Ø10.5mm Hole Plug (Black)	-		
V51003 *	Water Drain Cap With Valve (Black)	-		
V51004 *	Water Drain Cap With Valve (White)	-		
V51005 *	Drainage Ball Valves	-		
T50000-2	Small Joint Sealant/Adhesive	-		
T50003	Aluk Sealant Wipes	-		
T50004	Dow Corning 776 Silicone Bond	-		
GASKET / PLASTIC PROFILE				
		NO.	SIZE	
V02000	Co-Extruded Bubble Seal (Q-Lon)		2H	
V00000 *	2 - 3mm Wedge Gasket		2L + 4H	
V09000	Outer Frame Bumper Seal		2H	
V10000 *	Sliding Seal/Fin Pile 6.9mmx 8.5mm		16L + 8H	
V31008	25mm PVC Interlock Profile	2	H - 96.6	90°-90°
GLASS				
		NO.	WIDTH	HEIGHT
Glass unit 52mm		2	L/2 - 49.5	H - 139
HARDWARE				
		PACK QTY		QTY
H00100	Lateral Locking Handle	1		1
H00101	Lateral Pull Handle	1		1
H00200	Roller Wheels	1		4
H00400	Lateral Lock	1		1
H00401	Lateral Lock Adjustable Keep	1		1
H00404	Lateral Lock Lever	1		1

* V00000 = Only for Aluk.ITA: 8091119
 * V10000 = Only for Aluk.GBR: XA621
 * V42000 = Only for Aluk.FRA: 27500
 * V51001 = Only for Aluk.ITA: 709616
 * V51002 = Only for Aluk.ITA: 709617
 * V51003 = Only for Aluk.ITA: 712007
 * V51004 = Only for Aluk.ITA: 712008
 * V51005 = Only for Aluk.GBR: A-00-225
 * V70000 = Only for Aluk.FRA: 86720

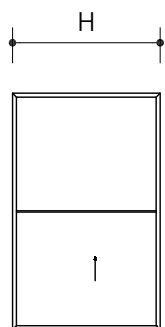
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HARDWARE		PACK QTY	QTY
H00100	Lateral Locking Handle	1	2
H00101	Lateral Pull Handle	1	2
H00200	Roller Wheels	1	4
H00400	Lateral Lock	1	2
H00401	Lateral Lock Adjustable Keep	1	2
H00404	Lateral Lock Lever	1	2

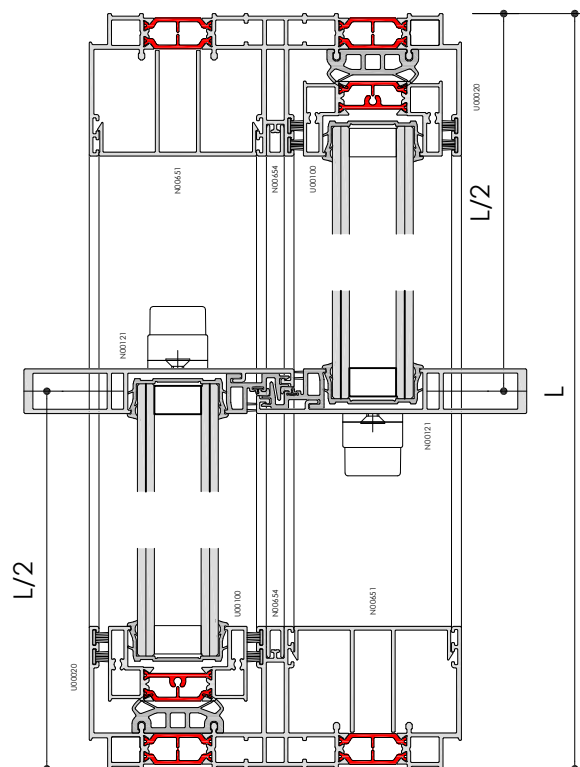
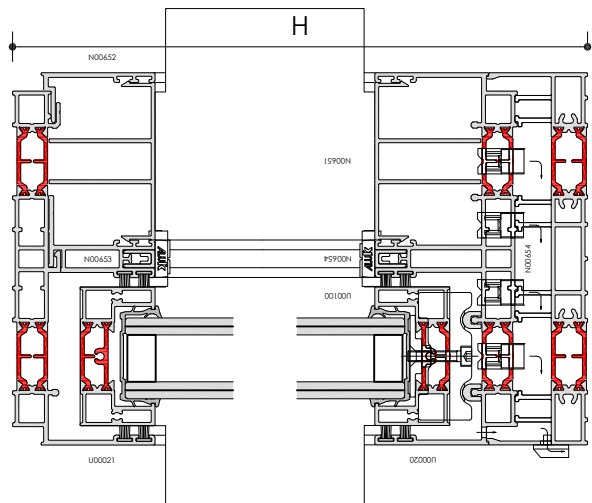
CUTTING LIST



CUTTING LIST



1 Sliding & 1 Fixed Panel
(21mm Reinforced Interlock)



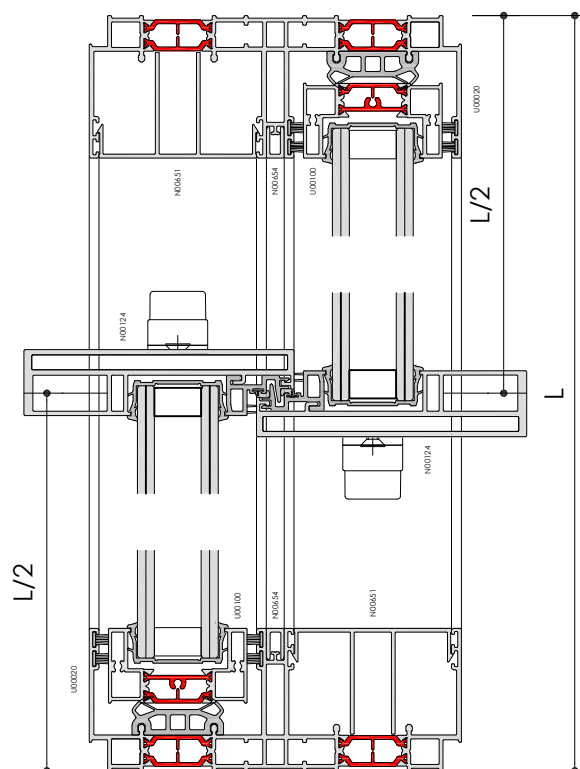
DG PRO.	DESCRIPTION	TG PRO.	DESCRIPTION	NO.	SIZE	ANGLE
U00020	2 Track Outer Frame			1	L	45°-45°
U00020	2 Track Outer Frame			2	H - 33	45°-45°
U00021	2 Track Outer Frame (Head)			1	L	45°-45°
U00030	Drainage Sub Cill			1	L	90°-90°
N00032	Aluminium Track			2	L - 44	90°-90°
N00051	Outer Frame Cover Profile			2	H - 74.2	90°-90°
N00051	Outer Frame Cover Profile			2	L/2 - 77.5	90°-90°
N00052	Internal Rebate			1	L - 26.8	45°-45°
N00053	Central Rebate			1	L - 33.6	45°-45°
N00054	Connector Clip			4	(L - 155)/2	90°-90°
N00054	Connector Clip			2	H - 167	90°-90°
U00100	Double Glazed Sash	U00102	Triple Glazed Sash	2	H - 96.6	45°-45°
U00100	Double Glazed Sash	U00102	Triple Glazed Sash	2	L/2 - 23.3	45°-90°
U00100	Double Glazed Sash	U00102	Triple Glazed Sash	2	L/2 - 23.3	45°-90°
N00121	21mm Interlock Profile	N00123	25mm Rein. TG Interlock Profile	2	H - 96.6	90°-90°
DG ACC.		TG ACC.	DESCRIPTION			QTY
V20000	Interlock Foam Plug			2		2
V42000 *	Mechanical Cleat (13mm)					24
V50001	Fixed Sash Support Blocks					2
V53003	Interlock Seal (EPDM)					2
V55000	Sub Cill End Caps					1 Pair
V58000	Interlock End Cap					4
V62000	Roller Glazing Packer					4
V70000 *	Mechanical Cleat Screw					48
V70001	Ø4.2 x 30mm Pozzi Pan Polyamide Screw					4
V51001 *	Ø10.5mm Hole Plug (Black)					-
V51003 *	Water Drain Cap With Valve (Black)					-
V51004 *	Water Drain Cap With Valve (White)					-
V51005 *	Drainage Ball Valves					-
T50000-2	Small Joint Sealant/Adhesive					-
T50003	Aluk Sealant Wipes					-
T50004	Dow Corring 776 Silicone Bond (New Item)					-
GASKET / PLASTIC PROFILE		TG ACC.	DESCRIPTION	NO.	SIZE	
V02000	Co-Extruded Bubble Seal (Q-Lon)					2H
V04000	38mm Double Glazed U Gasket	V00000 *	2 - 3mm Wedge Gasket			2L + 4H
V09000	Outer Frame Bumper Seal					2H
V10000 *	Sliding Seal/Fin Pile 6.9mmx 8.5mm					1.6L + 8H
V31000	21mm PVC Interlock Profile	V31008	25mm PVC Interlock Profile	2	H - 96.6	90°-90°
GLASS				NO.	WIDTH	HEIGHT
Glass unit 38mm	Glass unit 52mm			2	L/2 - 49.5	H - 139

HARDWARE	DESCRIPTION	PACK QTY	QTY
H00100	Lateral Locking Handle	1	1
H00101	Lateral Pull Handle	1	1
H00200	Roller Wheels	1	2
H00400	Lateral Lock	1	1
H00401	Lateral Lock Adjustable Keep	1	1
H00404	Lateral Lock Lever	1	1

* V00000 = Only for AlukITA: 809119
 * V510003 = Only for AlukITA: 712007
 * V510004 = Only for Aluk.GBR: XA621
 * V510005 = Only for Aluk.FRA: 712008
 * V42000 = Only for Aluk.FRA: 27500
 * V51001 = Only for Aluk.FRA: 709616
 * V70000 = Only for Aluk.FRA: 86720
 * V51002 = Only for Aluk.FRA: 709617

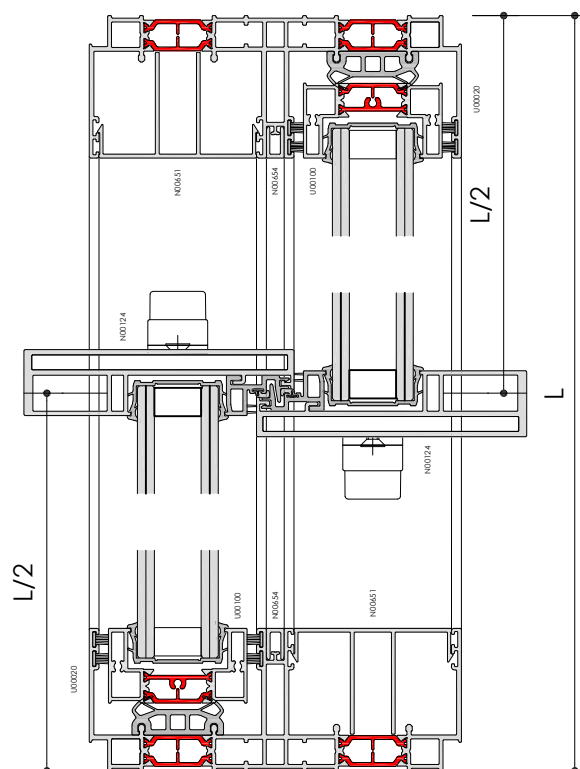
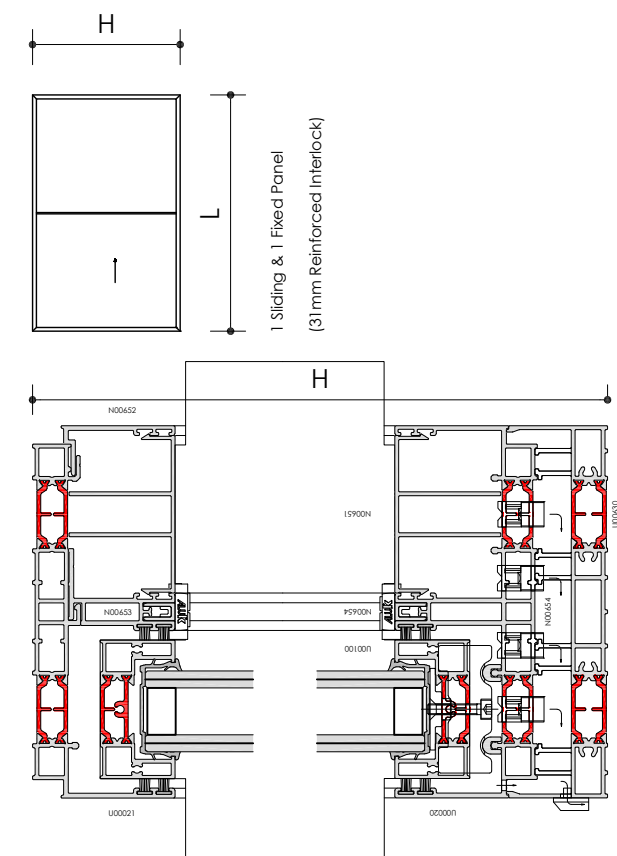
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* V50000 = Only for Auk:IT; 809119
* V10000 = Only for Auk:GBR; XA21
* V42000 = Only for Auk:FRA; 27500
* V51001 = Only for Auk:ITA; 709616
* V51002 = Only for Auk:ITA; 709617
* V51003 = Only for Auk:ITA; 712007
* V51004 = Only for Auk:ITA; 712008
* V51005 = Only for Auk:GBR; A-00-225
* V70000 = Only for Auk:FRA; 86720



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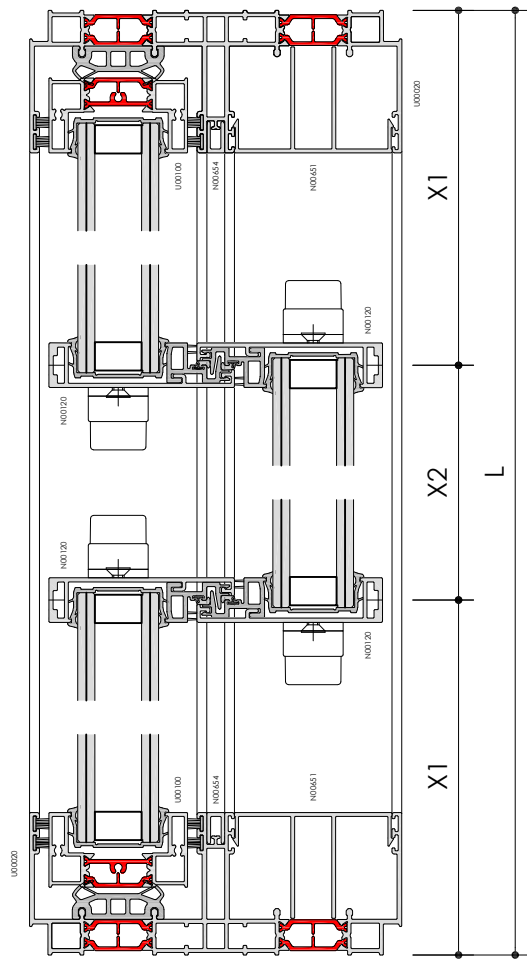
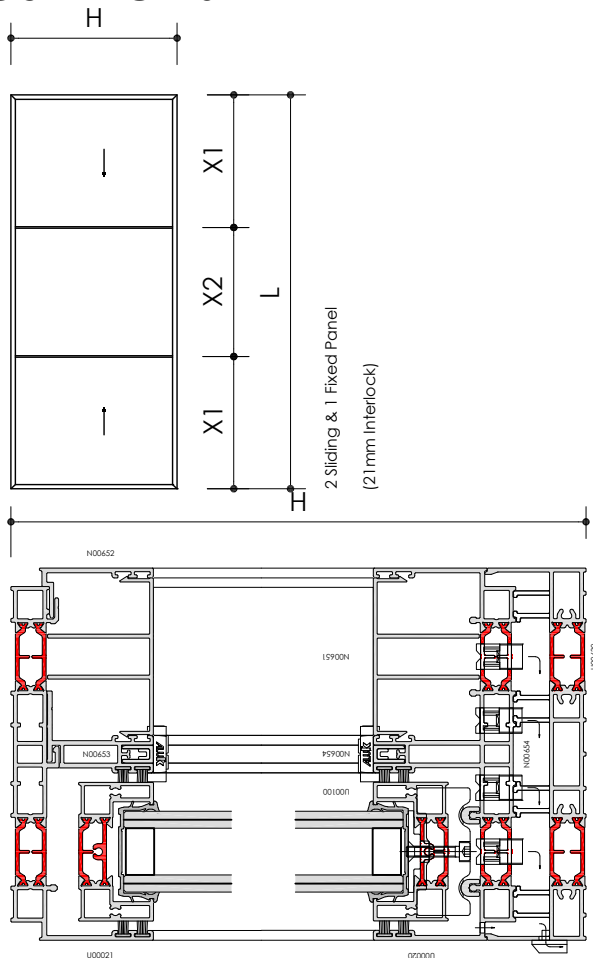


DG PRO.	DESCRIPTION	TG PRO.	DESCRIPTION	NO.	SIZE	ANGLE
U00020	2 Track Outer Frame			1	L	45°-45°
U00020	2 Track Outer Frame			2	H - 33	45°-45°
U00021	2 Track Outer Frame (Head)			1	L	45°-45°
U00430	Drainage Sub Cill			1	L	90°-90°
N00432	Aluminium Track			2	L - 44	90°-90°
N00451	Outer Frame Cover Profile			2	H - 74.2	90°-90°
N00451	Outer Frame Cover Profile			2	L/2 - 77.5	90°-90°
N00452	Internal Rebate			1	L - 26.8	45°-45°
N00453	Central Rebate			1	L - 33.6	45°-45°
N00454	Connector Clip			4	(L - 155)/2	90°-90°
N00454	Connector Clip			2	H - 167	90°-90°
U00100	Double Glazed Sash			2	H - 96.6	45°-45°
U00100	Double Glazed Sash			2	L/2 - 23.3	45°-90°
U00100	Double Glazed Sash			2	L/2 - 23.3	45°-90°
N00124	31mm Reinforced Interlock Profile			2	H - 96.6	90°-90°
DG ACC.	DESCRIPTION	TG ACC.	DESCRIPTION	NO.	SIZE	QTY
V20000	Interlock Foam Plug			2		2
V42000 *	Mechanical Cleat (13mm)			24		24
V50001	Fixed Sash Support Blocks			2		2
V53003	Interlock Seal (EPDM)			2		2
V55000	Sub Cill End Caps			1 Pair		1 Pair
V58000	Interlock End Cap			4		4
V62000	Roller Glazing Packer			4		4
V70000 *	Mechanical Cleat Screw			48		48
V70001	Ø4.2 x 30mm Pozz Pan Polyamide Screw			4		4
V51001 *	Ø10.5mm Hole Plug (Black)			-		-
V51003 *	Water Drain Cap With Valve (Black)			-		-
V51004 *	Water Drain Cap With Valve (White)			-		-
V51005 *	Drainage Ball Valves			-		-
T50000-2	Small Joint Sealant/Adhesive			-		-
T50003	Aluk Sealant Wipes			-		-
GASKET / PLASTIC PROFILE	DESCRIPTION	TG ACC.	DESCRIPTION	NO.	SIZE	QTY
V02000	Co-Extruded Bubble Seal (Q-Lon)			2H		2H
V04000	38mm Double Glazed U Gasket			2L + 4H		2L + 4H
V09000	Outer Frame Bumper Seal			2H		2H
V10000 *	Sliding Seal/Fin Pile 6.9mmx 8.5mm			1.6L + 8H		1.6L + 8H
V31000	21mm PVC Interlock Profile			2	H - 96.6	90°-90°
GLASS	DESCRIPTION	TG ACC.	DESCRIPTION	NO.	WIDTH	HEIGHT
	Glass unit 38mm			2	L/2 - 49.5	H - 139

HARDWARE	DESCRIPTION	PACK QTY	QTY
H00100	Lateral Locking Handle	1	1
H00101	Lateral Pull Handle	1	1
H00200	Roller Wheels	1	2
H00400	Lateral Lock	1	1
H00401	Lateral Lock Adjustable Keep	1	1
H00404	Lateral Lock Lever	1	1

* V00000 = Only for Aluk.IT: 809119
 * V510003 = Only for Aluk.ITA: 712007
 * V10000 = Only for Aluk.GBR: XA621
 * V510004 = Only for Aluk.ITA: 712008
 * V42000 = Only for Aluk.FRA: 27500
 * V51005 = Only for Aluk.GBR: A-00-225
 * V51001 = Only for Aluk.ITA: 709616
 * V70000 = Only for Aluk.FRA: 86720
 * V51002 = Only for Aluk.ITA: 709617

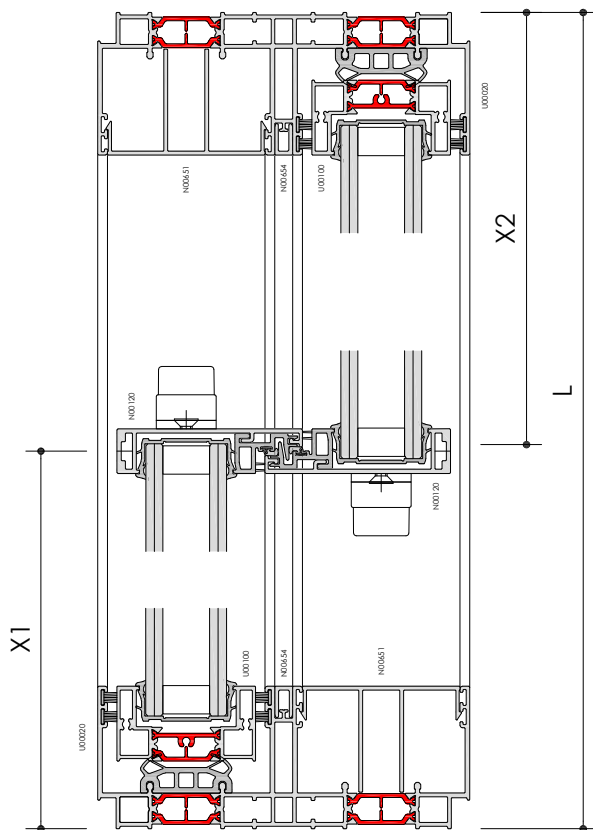
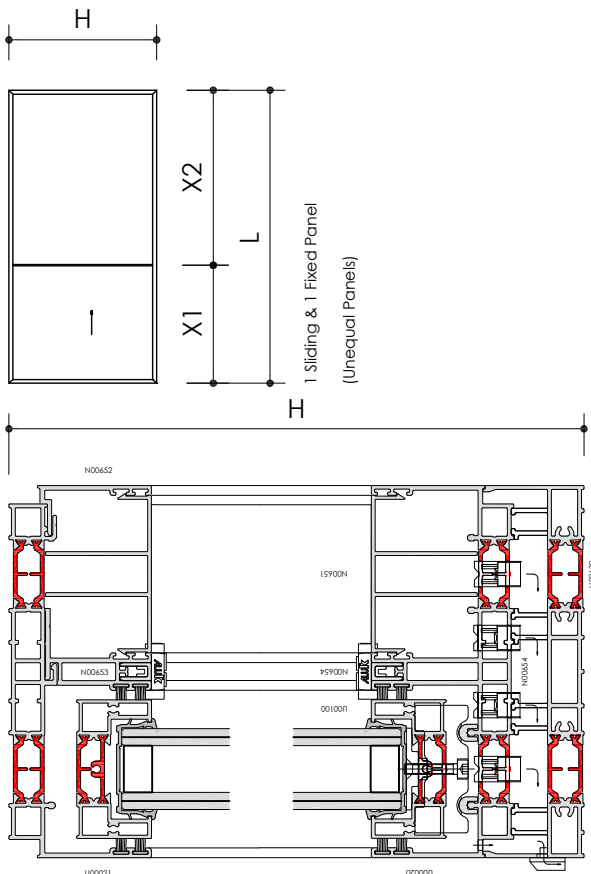
➤ CUTTING LIST



DG. PRO.	DESCRIPTION	TG. PRO.	DESCRIPTION	NO.	SIZE	ANGLE
U00020	2 Track Outer Frame			1	L	45°-45°
U00020	2 Track Outer Frame			2	H - 33	45°-45°
U00021	2 Track Outer Frame (Head)			1	L	45°-45°
U00630	Drainage Sub Cill			1	L	90°-90°
N00632	Aluminium Track			2	L - 44	90°-90°
N00651	Outer Frame Cover Profile			2	H - 74.2	90°-90°
N00651	Outer Frame Cover Profile			4	X1 - 77.5	90°-90°
N00652	Internal Rebate			1	L - 26.8	45°-45°
N00653	Central Rebate			1	L - 33.6	45°-45°
N00654	Connector Clip			6	(L - 176/3	90°-90°
N00654	Connector Clip			2	H - 167	90°-90°
U00100	Double Glazed Sash	U00102	Triple Glazed Sash	2	H - 96.6	45°-45°
U00100	Double Glazed Sash (X1)	U00102	Triple Glazed Sash (X1)	2	(L-134)/3 + 43.7	45°-90°
U00100	Double Glazed Sash (X1)	U00102	Triple Glazed Sash (X1)	2	(L-134)/3 - 43.7	45°-90°
U00100	Double Glazed Sash (X2)	U00102	Triple Glazed Sash (X2)	2	(L-134)/3 + 17	90°-90°
N00120	21mm Interlock Profile	N00122	25mm TG Interlock Profile	4	H - 96.6	90°-90°
DG. ACC.		TG. ACC.	DESCRIPTION			QTY
V20000	Interlock Foam Plug					8
V42000 *	Mechanical Cleat (13mm)					24
V50001	Fixed Sash Support Blocks					2
V53003	Interlock Seal (EPDM)					4
V55000	Sub Cill End Caps					1 Pair
V58000	Interlock End Cap					8
V62000	Roller Glazing Packer	V59047	Triple Glazed Sash Bridge Packer			6/3 Pairs
V70000 *	Mechanical Cleat Screw					8
V70001	Ø4.2 x 30mm Pozzi Pan Polyamide Screw					-
V51001 *	Ø10.5mm Hole Plug (Black)					-
V51003 *	Water Drain Cap With Valve (Black)					-
V51004 *	Water Drain Cap With Valve (White)					-
V51005 *	Drainage Ball Valves					-
T50000-2	Small Joint Sealant/Adhesive					-
T50003	Aluk Sealant Wipes	T50004	Dow Corning 776 Silicone Bond (New Item)			-
GASKET / PLASTIC PROFILE		TG. ACC.	DESCRIPTION	NO.	SIZE	
V02000	Co-Extruded Bubble Seal (G-Lon)				4H	
V04000	38mm Double Glazed U Gasket	V00000 *	2 - 3mm Wedge Gasket		2L + 6H	
V09000	Outer Frame Bumper Seal				2H	
V10000 *	Sliding Seal/Fin Pile 6.9mmx 8.5mm				16L + 8H	
V31000	21mm PVC Interlock Profile	V31008	25mm PVC Interlock Profile	4	H - 96.6	90°-90°
GLASS				NO.	WIDTH	HEIGHT
Glass unit 38mm	Glass unit 52mm			2	X1 - 49.5	H - 139
Glass unit 38mm	Glass unit 52mm			1	X2 + 7	H - 139
HARDWARE				PACK QTY		QTY
H00100	Lateral Locking Handle			1		2
H00101	Lateral Pull Handle			1		2
H00200	Roller Wheels			1		4
H00400	Lateral Lock			1		2
H00401	Lateral Lock Adjustable Keep			1		2
H00404	Lateral Lock Lever			1		2

* V0000 = Only for Aluk.II: 809119
 * V1000 = Only for Aluk.GBR: YA621
 * V42000 = Only for Aluk.FRA: 27500
 * V51001 = Only for Aluk.ITA: 709616
 * V51002 = Only for Aluk.ITA: 709617
 * V51003 = Only for Aluk.ITA: 712007
 * V51004 = Only for Aluk.ITA: 712008
 * V51005 = Only for Aluk.GBR: A-00-225
 * V70000 = Only for Aluk.FRA: 86720

CUTTING LIST

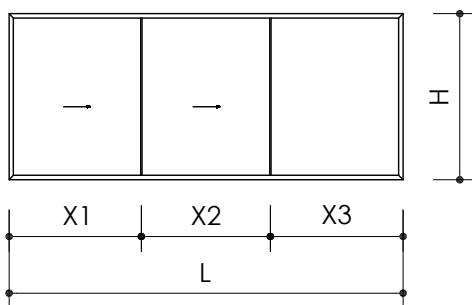


DG PRO.	DESCRIPTION	TG PRO.	DESCRIPTION	NO.	SIZE	ANGLE	
U00020	2 Track Outer Frame			1	L	45°-45°	
U00020	2 Track Outer Frame			2	H - 33	45°-45°	
U00021	2 Track Outer Frame (Head)			1	L	45°-45°	
U00630	Drainage Sub Cill			1	L	90°-90°	
N00632	Aluminium Track			2	L - 44	90°-90°	
N00651	Outer Frame Cover Profile			2	H - 74.2	90°-90°	
N00651	Outer Frame Cover Profile			2	X1 - 77.5	90°-90°	
N00652	Internal Rebate			1	L - 26.8	45°-45°	
N00653	Central Rebate			1	L - 33.6	45°-45°	
N00654	Connector Clip			4	X1 - 77.5	90°-90°	
N00654	Connector Clip			2	X2 - 77.5	90°-90°	
N00654	Connector Clip			2	H - 167	90°-90°	
U00100	Double Glazed Sash		U00102	Triple Glazed Sash	2	H - 96.6	45°-45°
U00100	Double Glazed Sash		U00102	Triple Glazed Sash	2	X1 - 23.3	45°-90°
U00100	Double Glazed Sash		U00102	Triple Glazed Sash	2	X2 - 23.3	45°-90°
N00120	21mm Interlock Profile		N00122	25mm TG Interlock Profile	2	H - 96.6	90°-90°
DG ACC.		TG ACC.	DESCRIPTION			QTY	
V20000	Interlock Foam Plug					2	
V42000 *	Mechanical Cleat (13mm)					24	
V50001	Fixed Sash Support Blocks					2	
V53003	Interlock Seal (EPDM)					2	
V55000	Sub Cill End Caps					1 Pair	
V58000	Interlock End Cap					4	
V62000	Roller Glazing Packer					4	
V70000 *	Mechanical Cleat Screw					48	
V70001	Ø4.2 x 30mm Pozl Pan Polyamide Screw					4	
V51001 *	Ø10.5mm Hole Plug (Black)					-	
V51003 *	Water Drain Cap With Valve (Black)					-	
V51004 *	Water Drain Cap With Valve (White)					-	
V51005 *	Drainage Ball Valves					-	
T50000-2	Small Joint Sealant/Adhesive					-	
T50003	Aluk Sealant Wipes					-	
		T50004	Dow Corning 776 Silicone Band (New Item)			-	
GASKET / PLASTIC PROFILE		TG ACC.	DESCRIPTION	NO.	SIZE		
V02000	Co-Extruded Bubble Seal (Q-Lon)				2H		
V04000	38mm Double Glazed U Gasket		V00000 *	2 - 3mm Wedge Gasket		2L + 4H	
V09000	Outer Frame Bumper Seal					2H	
V10000 *	Sliding Seal/Fin Pile 6.9mmx 8.5mm					16L + 8H	
V31000	21mm PVC Interlock Profile		V31008	25mm PVC Interlock Profile	2	H - 96.6	90°-90°
GLASS				NO.	WIDTH	HEIGHT	
Glass unit 38mm	Glass unit 52mm			1	X1 - 49.5	H - 139	
Glass unit 38mm	Glass unit 52mm			1	X2 - 49.5	H - 139	

HARDWARE		PACK QTY	QTY
H00100	Lateral Locking Handle	1	1
H00101	Lateral Pull Handle	1	1
H00200	Roller Wheels	1	2
H00400	Lateral Lock	1	1
H00401	Lateral Lock Adjustable Keep	1	1
H00404	Lateral Lock Lever	1	1

* V00000 = Only for Auk.IT: 809119
* V10000 = Only for Auk.GBR: XA21
* V42000 = Only for Auk.FRA: 27500
* V51001 = Only for Auk.ITA: 709616
* V51002 = Only for Auk.ITA: 709617
* V51003 = Only for Auk.ITA: 712007
* V51004 = Only for Auk.ITA: 712008
* V51005 = Only for Auk.GBR: A-00-225
* V70000 = Only for Auk.FRA: 86720

CUTTING LIST



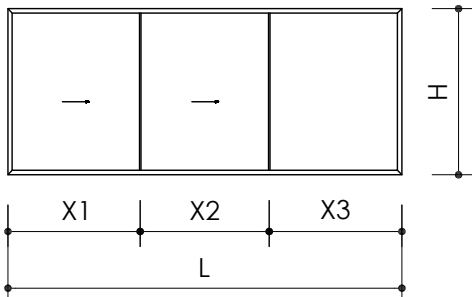
Triple Track - 2 Sliding & 1 Fixed Panel
(25mm / 21mm Interlock)

NOTES:

- * Add additional 2mm deduction to allow for N00122 (25mm interlock)
- ** Also applicable to X3 (Fixed Panel)

DG PRO.	DESCRIPTION	TG PRO.	DESCRIPTION	NO.	SIZE	ANGLE
U00022	2 + 1 Track Outer Frame			1	L	45°-45°
U00000	Single Track Outer Frame			1	L	45°-45°
U00022	2 + 1 Track Outer Frame			2	H - 33	45°-45°
U00000	Single Track Outer Frame			2	H - 33	45°-45°
U00023	2 + 1Track Outer Frame (Head)			1	L	45°-45°
U00001	Single Track Outer Frame (Head)			1	L	45°-45°
U00631	Triple Track Sub Cill (2 + 1)			1	L	90°-90°
U00632	Triple Track Sub Cill Extension Profile			1	L	90°-90°
N00632	Aluminium Track			4	L - 44	90°-90°
N00651	Outer Frame Cover Profile			4	H - 74.2	90°-90°
N00651	Outer Frame Cover Profile			2	(L - X3) - 77.5*	90°-90°
N00652	Internal Rebate			1	L - 26.8	45°-45°
N00653	Central Rebate			2	L - 33.6	45°-45°
N00654	Connector Clip			2	(L - X3) - 77.5*	90°-90°
N00654	Connector Clip			2	X3 - 77.5*	90°-90°
N00654	Connector Clip			2	(L - X1) - 77.5*	90°-90°
N00654	Connector Clip			2	X1 - 77.5*	90°-90°
N00654	Connector Clip			2	H - 167	90°-90°
N00654	Connector Clip			2	L - 26.8	45°-45°
N00654	Connector Clip			2	H - 32.7	45°-45°
U00100	Double Glazed Sash	U00102	Triple Glazed Sash	2	H - 96.6	45°-45°
U00100	Double Glazed Sash (X1)	U00102	Triple Glazed Sash (X1)	2	(L-134)/3 + 40.3*	45°-90°
U00100	Double Glazed Sash (X3)	U00102	Triple Glazed Sash (X3)	2	(L-134)/3 + 40.3*	45°-90°
U00100	Double Glazed Sash (X2)	U00102	Triple Glazed Sash (X2)	2	(L-134)/3 + 17*	90°-90°
N00120	21mm Interlock Profile	N00122	25mm TG Interlock Profile	4	H - 96.6	90°-90°
DG ACC.	DESCRIPTION	TG ACC.	DESCRIPTION	QTY		
V20000	Interlock Foam Plug			4		
V42000 *	Mechanical Cleat (13mm)			32		
V50001	Fixed Sash Support Blocks			2		
V53003	Interlock Seal (EPDM)			4		
V55034	U00631 & U00632 Sub Cill End Caps			1 Pair		
V58000	Interlock End Cap			8		
V62000	Roller Glazing Packer	V59047	Triple Glazed Sash Bridge Packer	6		
V70000 *	Mechanical Cleat Screw			64		
V70001	Ø4.2 x 30mm Pozi Pan Polyamide Screw			8		
V51001 *	Ø10.5mm Hole Plug (Black)			-		
V51003 *	Water Drain Cap With Valve (Black)			-		
V51004 *	Water Drain Cap With Valve (White)			-		
V51005 *	Drainage Ball Valves			-		
T50000-2	Small Joint Sealant/Adhesive			-		
T50003	Aluk Sealant Wipes	T50004	Dow Corning 776 Silicone Bond (New Item)	-		
GASKET / PLASTIC PROFILE		TG ACC.	DESCRIPTION	NO.	SIZE	
V02000	Co-Extruded Bubble Seal (Q-Lon)				4H	
V04000	38mm Double Glazed U Gasket	V00000 *	2 - 3mm Wedge Gasket		2L + 6H	
V09000	Outer Frame Bumper Seal				2H	
V10000 *	Sliding Seal/Fin Pile 6.9mmx 8.5mm				16L + 8H	
V31000	21mm PVC Interlock Profile	V31008	25mm PVC Interlock Profile	4	H - 96.6	90°-90°
GLASS				NO.	WIDTH	HEIGHT
Glass unit 38mm	X1 & X3 Glass Sizes (38mm Unit)			2	X** - 49.5*	H - 139
Glass unit 38mm	X2 Glass Sizes (38mm Unit)			1	X2 + 7*	H - 139
Glass unit 52mm	X1 & X3 Glass Sizes (52mm Unit)			2	X** - 49.5*	H - 139
Glass unit 52mm	X2 Glass Sizes (52mm Unit)			1	X2 + 7*	H - 139
HARDWARE				PACK QTY	QTY	
H00100	Lateral Locking Handle			1	1	
H00101	Lateral Pull Handle			1	1	
H00200	Roller Wheels			1	4	
H00400	Lateral Lock			1	1	
H00401	Lateral Lock Adjustable Keep			1	1	
H00404	Lateral Lock Lever			1	1	

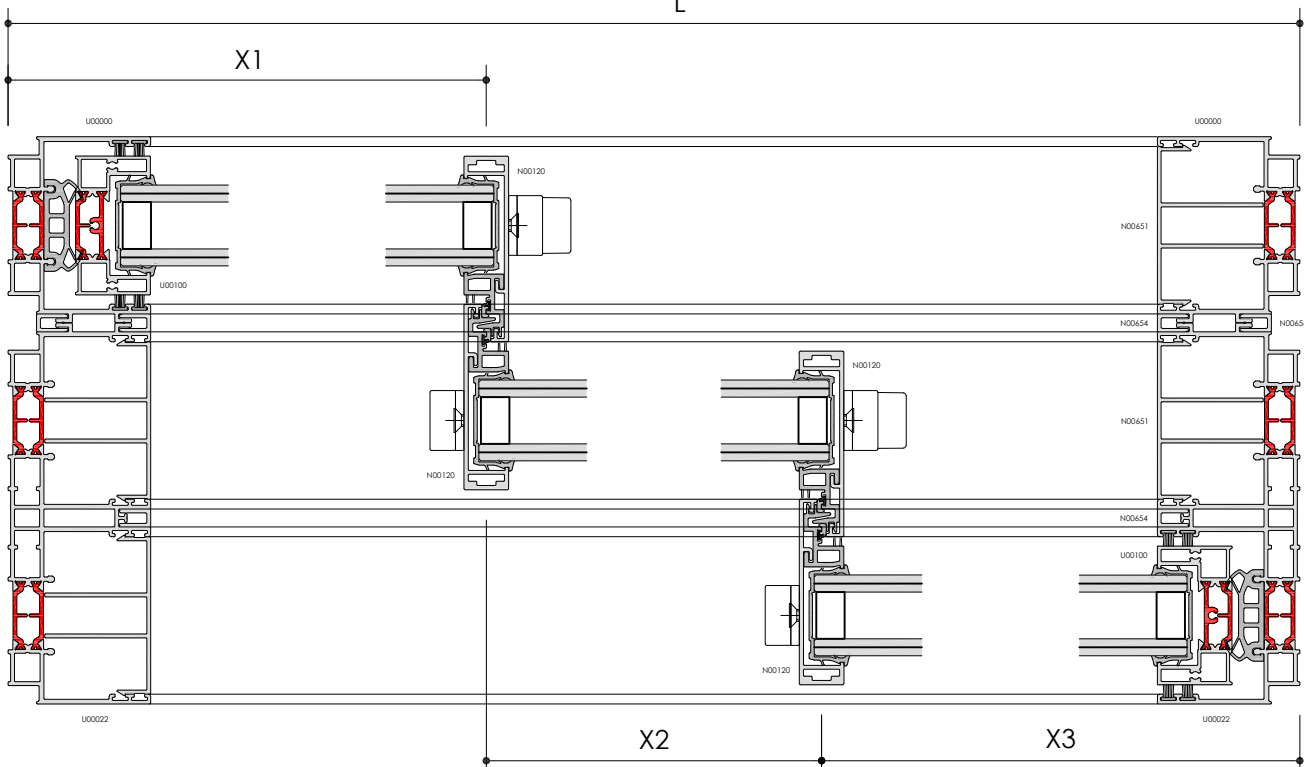
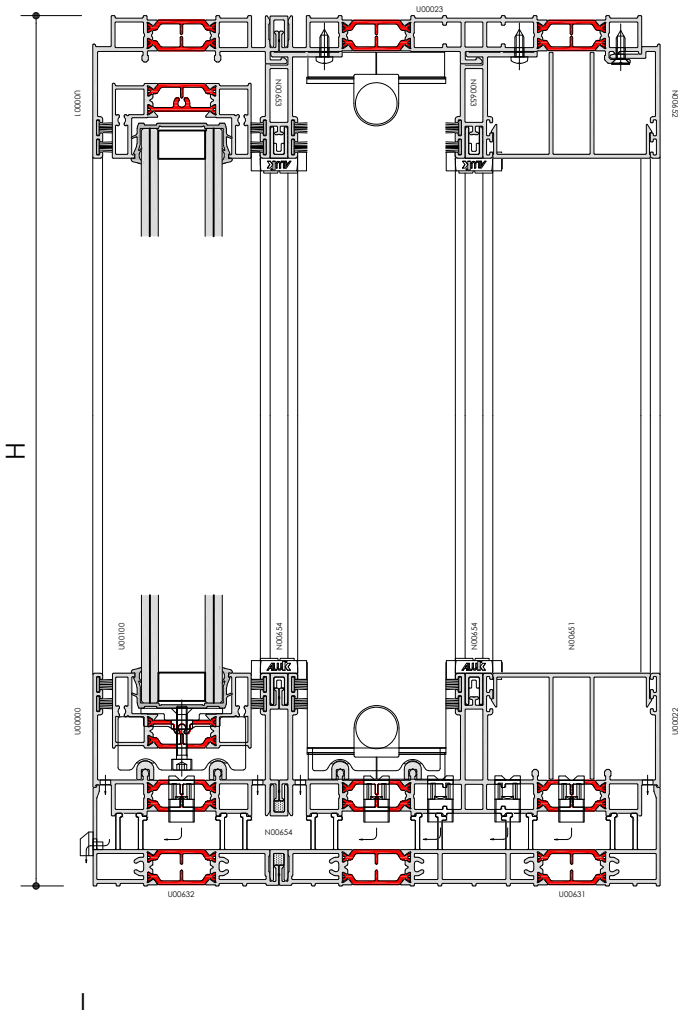
CUTTING LIST



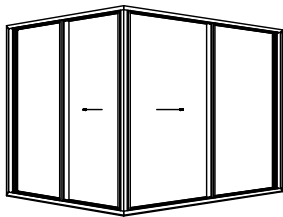
Triple Track - 2 Sliding & 1 Fixed Panel

(25mm / 21mm Interlock)

- * V00000 = Only for Aluk.IT: 809119
- * V10000 = Only for Aluk.GBR: XA621
- * V42000 = Only for Aluk.FRA: 27500
- * V51001 = Only for Aluk.ITA: 709616
- * V51002 = Only for Aluk.ITA: 709617
- * V51003 = Only for Aluk.ITA: 712007
- * V51004 = Only for Aluk.ITA: 712008
- * V51005 = Only for Aluk.GBR: A-00-225
- * V70000 = Only for Aluk.FRA: 86720



CUTTING LIST



90 Deg. Corner - 2 Sliding & 2 Fixed Panel

(25mm / 21mm Interlock)

NOTES:

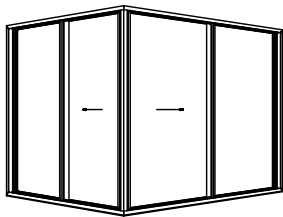
* Add additional 2mm deduction to allow for N00122 (25mm interlock)

** For panel/sash weights > 300Kgs add 2 additional rollers and packer per panel (Max. 400Kgs)

DG PRO.	DESCRIPTION	TG PRO.	DESCRIPTION	NO.	SIZE	ANGLE
U00020	2 Track Outer Frame			1	L1	45°-45°
U00020	2 Track Outer Frame			1	L2	45°-45°
U00020	2 Track Outer Frame			2	H - 33	45°-45°
U00021	2 Track Outer Frame (Head)			1	L1	45°-45°
U00021	2 Track Outer Frame (Head)			1	L2	45°-45°
U00630	Drainage Sub Cill			1	L1	45°-90°
U00630	Drainage Sub Cill			1	L2	45°-90°
N00632	Aluminium Track			1	L1 Or L2 - 42.4	90°-45°
N00632	Aluminium Track			1	L1 Or L2 - 76.5	90°-45°
N00632	Aluminium Track			1	L1 Or L2 - 134	90°-45°
N00632	Aluminium Track			1	L1 Or L2 - 168.2	90°-45°
N00651	Outer Frame Cover Profile			2	H - 74.2	90°-90°
N00651	Outer Frame Cover Profile			2	L1 - (X1 + 107*)	90°-45°
N00651	Outer Frame Cover Profile			2	L2 - (X2 + 107*)	90°-45°
N00652	Internal Rebate			2	L1 Or L2 - 170.4	45°-45°
N00653	Central Rebate			2	L1 Or L2 - 95.5	45°-45°
N00654	Connector Clip		Also applicable for L2 - (X2 + 93.8*)	2	L1 - (X1 + 93.8*)	90°-45°
N00654	Connector Clip		Also applicable for X2 - 77.5*	2	X1 - 77.5*	90°-45°
N00654	Connector Clip			4	H - 167	90°-90°
U00100	Double Glazed Sash	U00102	Triple Glazed Sash	3	H - 96.6	45°-45°
U00101	Reinforced Double Glazed Sash	U00103	Reinforced Triple Glazed Sash	1	H - 96.6	45°-45°
U00100	Double Glazed Sash (X1 Or X2)	U00102	Triple Glazed Sash (X1 Or X2)	2	(L1÷2) + (23.3*)	45°-90°
U00100	Double Glazed Sash (X3)	U00102	Triple Glazed Sash (X3)	2	(L1÷2) - (85*)	45°-90°
U00100	Double Glazed Sash (X4)	U00102	Triple Glazed Sash (X4)	2	(L2÷2) - (85*)	45°-90°
N00120	21mm Interlock Profile	N00122	25mm TG Interlock Profile	4	H - 96.6	90°-90°
U00500	Meeting Style (4 Pane & 90° Corner)			1	H - 101	90°-90°
U00600	90° Corner Post			1	H - 101	90°-90°
N00650	90° Corner Post Cover Profile			1	H - 101	90°-90°
DG ACC.	DESCRIPTION	TG ACC.	DESCRIPTION	QTY		
V20000	Interlock Foam Plug			8		
V42000 *	Mechanical Cleat (13mm)			32		
V42001	90 Deg. Corner Cleat (13mm)			8		
V42016	90 Deg. Sub Cill Corner Cleat			1		
V50001	Fixed Sash Support Blocks			4		
V53003	Interlock Seal (EPDM)			4		
V55000	Sub Cill End Caps			1 Pair		
V58000	Interlock End Cap			8		
V62000	Roller Glazing Packer	V59047	Triple Glazed Sash Bridge Packer	9		
V70000 *	Mechanical Cleat Screw			64		
V70001	Ø4.2 x 30mm Pozz Pan Polyamide Screw			8		
V51001 *	Ø10.5mm Hole Plug (Black)			-		
V51003 *	Water Drain Cap With Valve (Black)			-		
V51004 *	Water Drain Cap With Valve (White)			-		
V51005 *	Drainage Ball Valves			-		
V52020	End Cap for Meeting Stile (U00500)			1 Pair		
V58001	End Cap for Corner Cost (U00600)			1 Pair		
T50000-2	Small Joint Sealant/Adhesive			-		
T50003	Aluk Sealant Wipes	T50004	Dow Corning 776 Silicone Bond (New Item)	-		
GASKET / PLASTIC PROFILE		TG ACC.	DESCRIPTION	NO.	SIZE	
V02000	Co-Extruded Bubble Seal (Q-Lon)				4H	
V04000	38mm Double Glazed U Gasket	V00000 *	2 - 3mm Wedge Gasket		2L1 + 2L2 + 18H	
V09000	Outer Frame Bumper Seal				2H	
V10000 *	Sliding Seal/Fin Pile 6.9mmx 8.5mm				8L1 + 8L2 + 8H	
V31000	21mm PVC Interlock Profile	V31008	25mm PVC Interlock Profile	4	H - 96.6	90°-90°
V03012 *	Sliding Seal			4	H - 92.2	90°-90°
V90015 *	Door Central Gasket			1	H - 96.6	90°-90°
GLASS				NO.	WIDTH	HEIGHT
Glass unit 38mm	Glass unit 52mm		Also applicable for X2 - 36.1*	1	X1 - 36.1*	H - 139
Glass unit 38mm	Glass unit 52mm		Also applicable for X4 - 111.3*	1	X3 - 111.3*	H - 139

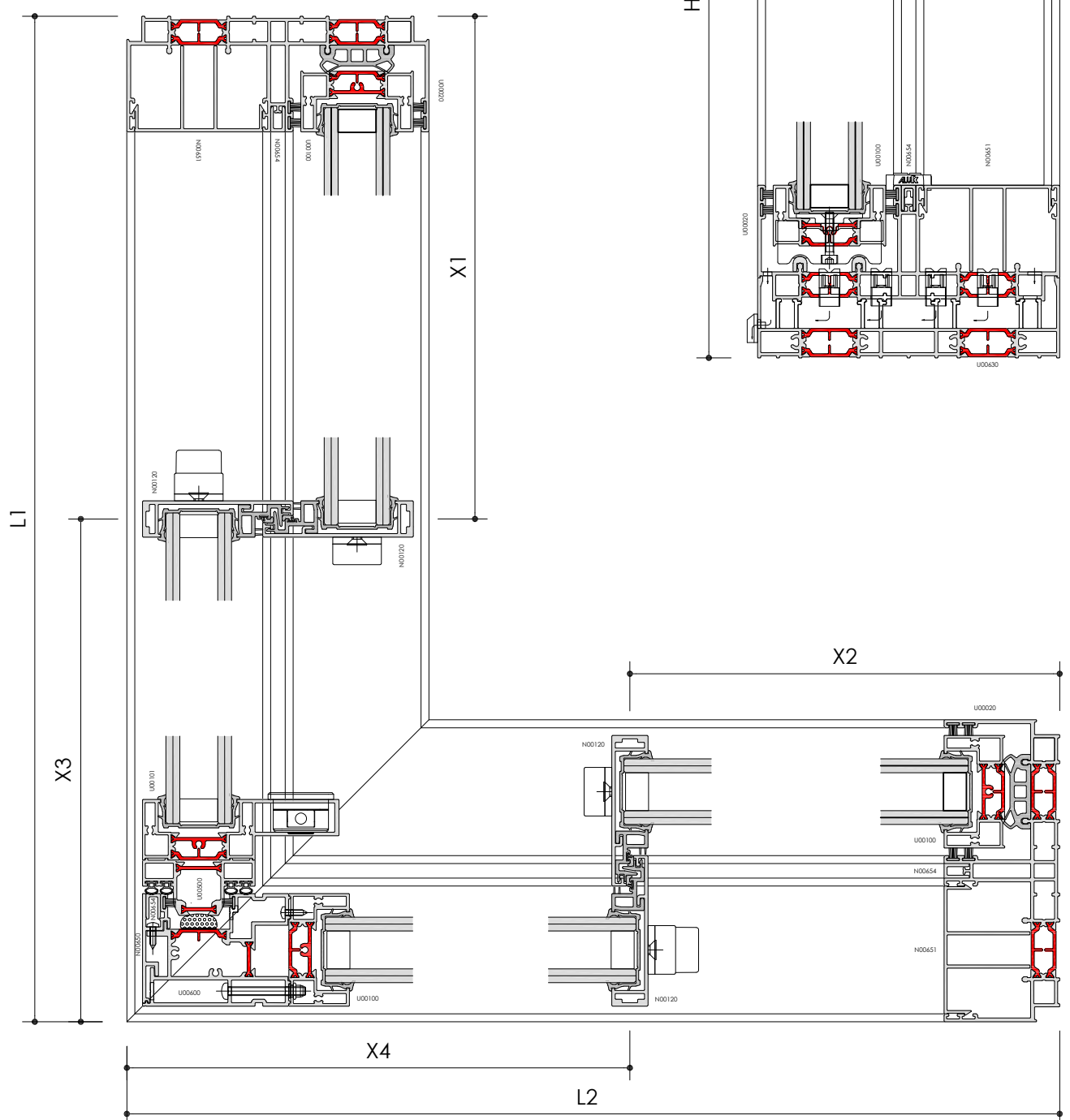
HARDWARE				PACK QTY	QTY
H00200	Roller Wheels			1	4**
H00405	RH Interlock Gearbox & Handle	H00412	LH Interlock Gearbox & Handle	1	1
H00409	Shootbolt kit (Reinforced Sash)			1	1
H00411	External Keep			1 Pair	1
V70020	M6 x 3M Threaded Bar			1	2

➤ CUTTING LIST

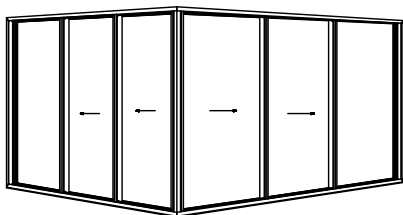


90 Deg. Corner - 2 Sliding & 2 Fixed Panel
(25mm / 21mm Interlock)

- * V00000 = Only for Aluk.IT: 809119
- * V10000 = Only for Aluk.GBR: XA621
- * V03012 = Only for Aluk.FRA: J8002
- * V42000 = Only for Aluk.FRA: 27500
- * V51001 = Only for Aluk.ITA: 709616
- * V51002 = Only for Aluk.ITA: 709617
- * V51003 = Only for Aluk.ITA: 712007
- * V51004 = Only for Aluk.ITA: 712008
- * V51005 = Only for Aluk.GBR: A-00-225
- * V70000 = Only for Aluk.FRA: 86720
- * V90015 = Only for Aluk.ITA: 809688



CUTTING LIST



Part 1: 90 Deg. Corner - 4 Sliding & 2 Fixed Panels

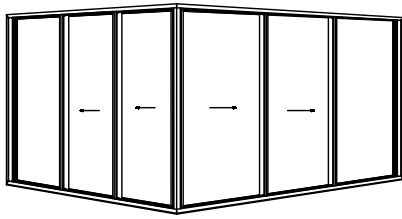
(25mm / 21mm Interlock)

NOTES:

- * Add additional 2mm deduction to allow for N00122 (25mm interlock)
- ** For panel/sash weights > 300Kgs add 2 additional rollers and packers per panel (Max. 400Kgs)

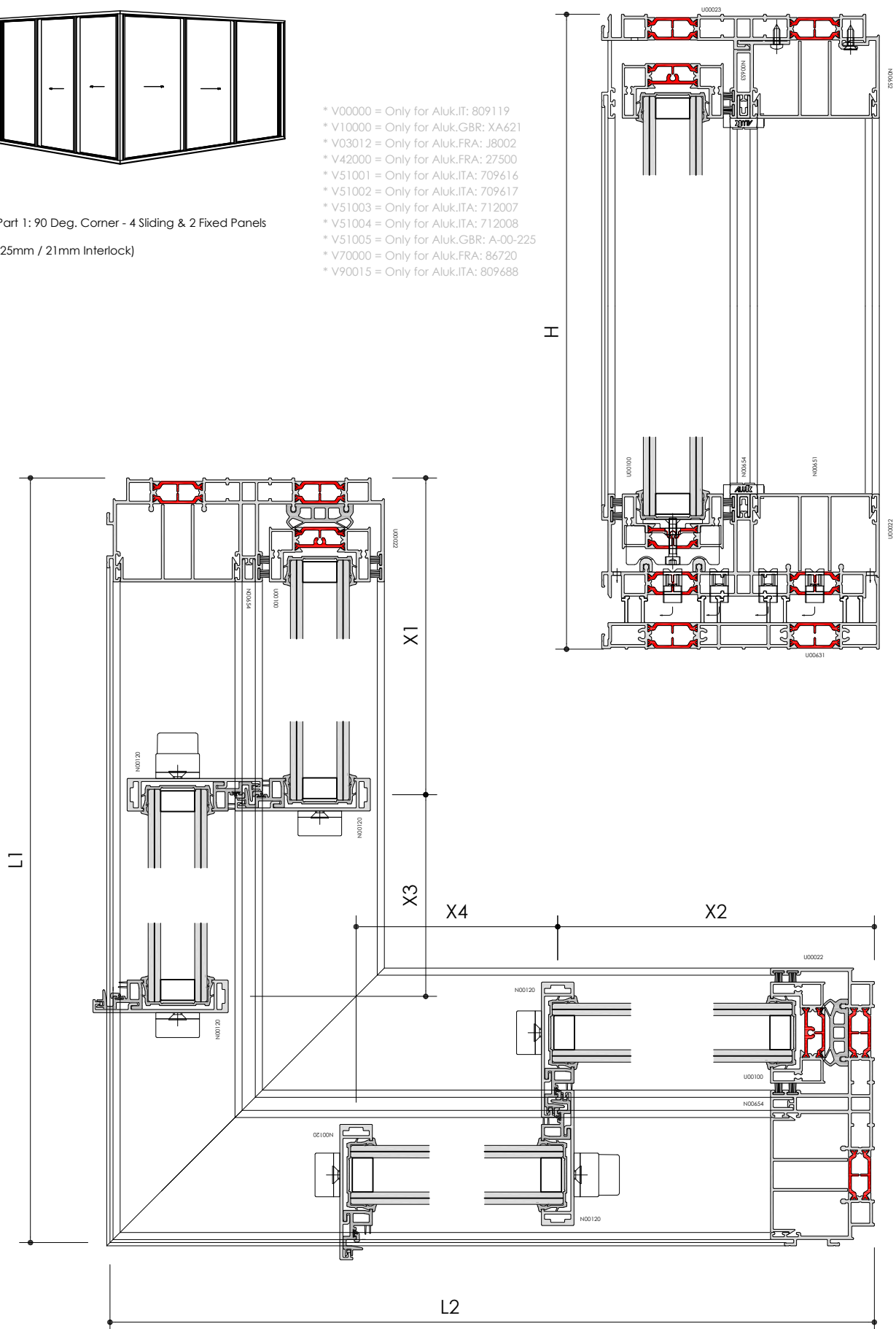
DG PRO.	DESCRIPTION	TG PRO.	DESCRIPTION	NO.	SIZE	ANGLE
U00022	2 Track Outer Frame			1	L1	45°-45°
U00022	2 Track Outer Frame			1	L2	45°-45°
U00022	2 Track Outer Frame			2	H - 33	45°-45°
U00023	2 Track Outer Frame (Head)			1	L1	45°-45°
U00023	2 Track Outer Frame (Head)			1	L2	45°-45°
U00631	Drainage Sub Cill			1	L1	45°-90°
U00631	Drainage Sub Cill			1	L2	45°-90°
N00632	Aluminium Track			1	L1 Or L2 - 42.4	90°-45°
N00632	Aluminium Track			1	L1 Or L2 - 76.5	90°-45°
N00651	Outer Frame Cover Profile			2	H - 74.2	90°-90°
N00651	Outer Frame Cover Profile			2	L1 - (X1 + 107*)	90°-45°
N00651	Outer Frame Cover Profile			2	L2 - (X2 + 107*)	90°-45°
N00652	Internal Rebate			1	L1 Or L2 - 170.4	45°-45°
N00653	Central Rebate			2	L1 Or L2 - 95.5	45°-45°
N00654	Connector Clip		Also applicable for L2 - (X2 + 93.8*)	2	L1 - (X1 + 93.8*)	90°-45°
N00654	Connector Clip		Also applicable for X2 - 77.5*	2	X1 - 77.5*	90°-45°
N00654	Connector Clip			4	H - 167	90°-90°
U00100	Double Glazed Sash	U00102	Triple Glazed Sash	2	H - 96.6	45°-45°
U00100	Double Glazed Sash (X1 Or X2)	U00102	Triple Glazed Sash (X1 Or X2)	2	(L1÷2) + (23.3*)	45°-90°
U00100	Double Glazed Sash (X3)	U00102	Triple Glazed Sash (X3)	2	(L1÷2) - (85*)	45°-90°
U00100	Double Glazed Sash (X4)	U00102	Triple Glazed Sash (X4)	2	(L2÷2) - (85*)	45°-90°
N00120	21mm Interlock Profile	N00122	25mm TG Interlock Profile	6	H - 96.6	90°-90°
DG ACC.	DESCRIPTION	TG ACC.	DESCRIPTION	QTY		
V20000	Interlock Foam Plug			8		
V42000 *	Mechanical Cleat (13mm)			24		
V42001	90 Deg. Corner Cleat (13mm)			2		
V42016	90 Deg. Sub Cill Corner Cleat			1		
V50001	Fixed Sash Support Blocks			4		
V53003	Interlock Seal (EPDM)			2		
V58000	Interlock End Cap			6		
V62000	Roller Glazing Packer	V59047	Triple Glazed Sash Bridge Packer	8		
V70000 *	Mechanical Cleat Screw			48		
V70001	Ø4.2 x 30mm Pozz Pan Polyamide Screw			12		
V51001 *	Ø10.5mm Hole Plug (Black)			-		
V51003 *	Water Drain Cap With Valve (Black)			-		
V51004 *	Water Drain Cap With Valve (White)			-		
V51005 *	Drainage Ball Valves			-		
T50000-2	Small Joint Sealant/Adhesive			-		
T50003	Aluk Sealant Wipes	T50004	Dow Corning 776 Silicone Bond (New Item)	-		
GASKET / PLASTIC PROFILE		TG ACC.	DESCRIPTION	NO.	SIZE	
V02000	Co-Extruded Bubble Seal (Q-Lon)				6H	
V04000	38mm Double Glazed U Gasket	V00000 *	2 - 3mm Wedge Gasket		2L1 + 2L2 + 16H	
V09000	Outer Frame Bumper Seal				2H	
V10000 *	Sliding Seal/Fin Pile 6.9mmx 8.5mm				16L1 + 16L2 + 8H	
V31000	21mm PVC Interlock Profile	V31008	25mm PVC Interlock Profile	6	H - 96.6	90°-90°
GLASS				NO.	WIDTH	HEIGHT
Glass unit 38mm	Glass unit 52mm		Also applicable for X2 - 36.1*	1	X1 - 36.1*	H - 139
Glass unit 38mm	Glass unit 52mm		Also applicable for X4 - 111.3*	1	X3 - 111.3*	H - 139
HARDWARE				PACK QTY		QTY
H00200	Roller Wheels			1		4**
H00411	External Keep			1 Pair		1

➤ CUTTING LIST

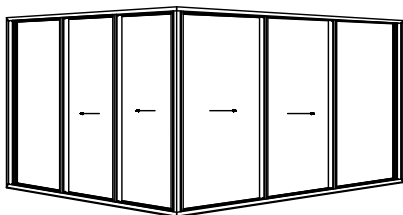


Part 1: 90 Deg. Corner - 4 Sliding & 2 Fixed Panels
(25mm / 21mm Interlock)

- * V00000 = Only for Aluk.IT: 809119
- * V10000 = Only for Aluk.GBR: XA621
- * V03012 = Only for Aluk.FRA: J8002
- * V42000 = Only for Aluk.FRA: 27500
- * V51001 = Only for Aluk.ITA: 709616
- * V51002 = Only for Aluk.ITA: 709617
- * V51003 = Only for Aluk.ITA: 712007
- * V51004 = Only for Aluk.ITA: 712008
- * V51005 = Only for Aluk.GBR: A-00-225
- * V70000 = Only for Aluk.FRA: 86720
- * V90015 = Only for Aluk.ITA: 809688



CUTTING LIST



Part 2: 90 Deg. Corner - 4 Sliding & 2 Fixed Panels

(25mm / 21mm Interlock)

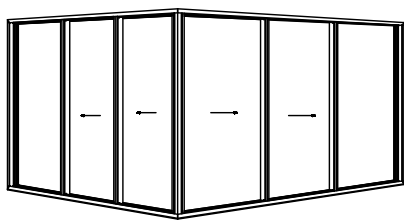
NOTES:

- * Add additional 2mm deduction to allow for N00122 (25mm interlock)
- ** For panel/sash weights > 300Kgs add 2 additional rollers and packers per panel (Max. 400Kgs)

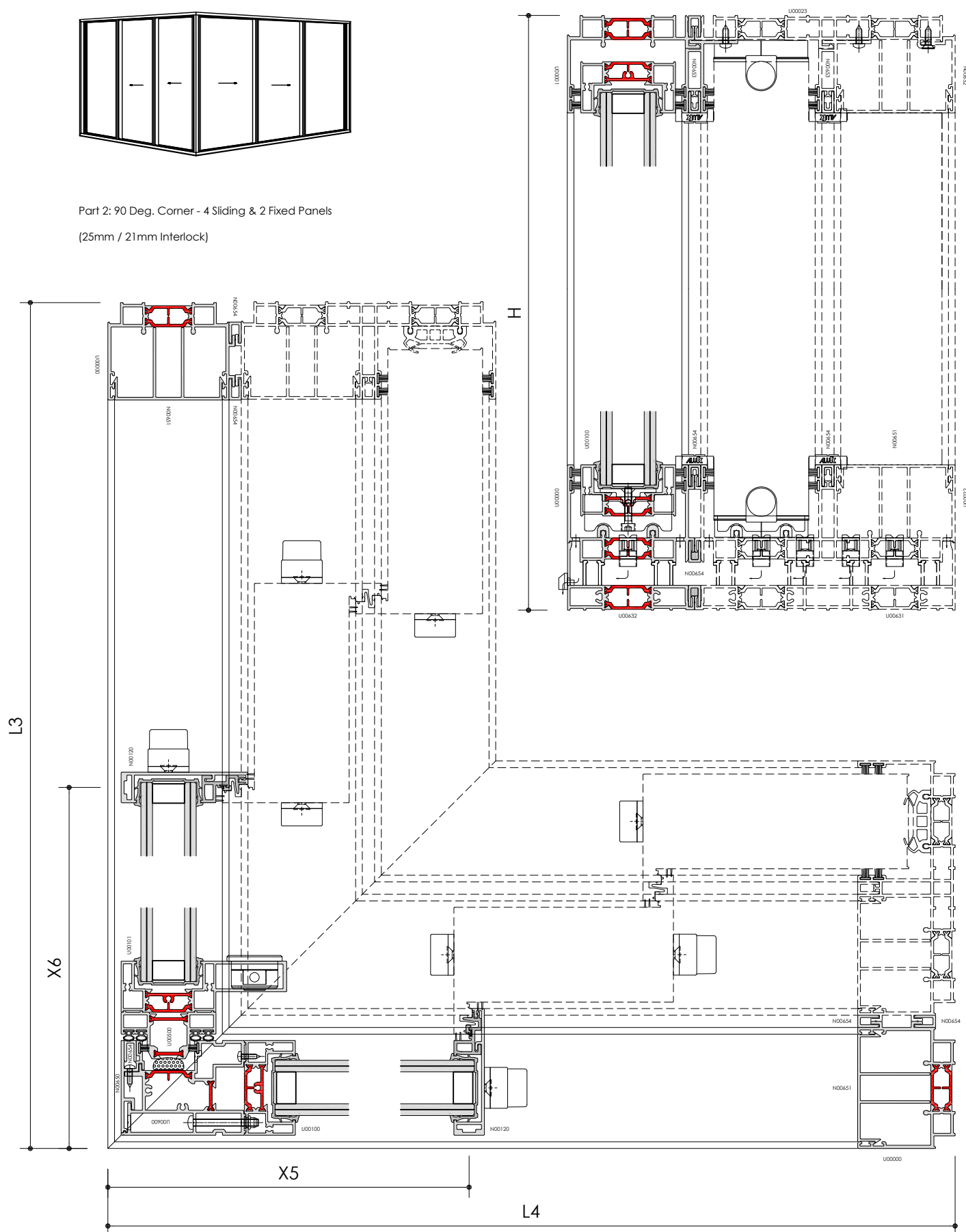
DG PRO.	DESCRIPTION	TG PRO.	DESCRIPTION	NO.	SIZE	ANGLE
U00000	Single Track Outer Frame			1	L3 = L1 + 87.6	45°-45°
U00000	Single Track Outer Frame			1	L4 = L2 + 87.6	45°-45°
U00000	Single Track Outer Frame			2	H - 33	45°-45°
U00001	Single Track Outer Frame (Head)			1	L3 = L1 + 87.6	45°-45°
U00001	Single Track Outer Frame (Head)			1	L4 = L2 + 87.6	45°-45°
U00632	Triple Track Sub Cill Extension Profile			1	L3 = L1 + 87.6	45°-90°
U00632	Triple Track Sub Cill Extension Profile			1	L4 = L2 + 87.6	45°-90°
N00632	Aluminium Track			1	L3 Or L4 - 42.4	90°-45°
N00632	Aluminium Track			1	L3 Or L4 - 76.5	90°-45°
N00651	Outer Frame Cover Profile			2	H - 74.2	90°-90°
N00653	Central Rebate			2	L3 Or L4 - 95.5	45°-45°
N00654	Connector Clip			2	L3 - (X6 + 10.5*)	90°-45°
N00654	Connector Clip			2	X6 - 77.5*	90°-45°
N00654	Connector Clip			4	H - 167	90°-90°
N00654	Connector Clip			1	H - 101	90°-90°
U00100	Double Glazed Sash	U00102	Triple Glazed Sash	1	H - 96.6	45°-45°
U00101	Reinforced Double Glazed Sash	U00103	Reinforced Triple Glazed Sash	1	H - 96.6	45°-45°
U00100	Double Glazed Sash (X6)	U00102	Triple Glazed Sash (X6)	2	L3 - (X1 + X3 + 85)	45°-90°
U00100	Double Glazed Sash (X5)	U00102	Triple Glazed Sash (X5)	2	L4 - (X2 + X4 + 85)	45°-90°
N00120	21mm Interlock Profile	N00122	25mm TG Interlock Profile	2	H - 96.6	90°-90°
U00500	Meeting Style (4 Pane & 90° Corner)			1	H - 101	90°-90°
U00600	90° Corner Post			1	H - 101	90°-90°
N00650	90° Corner Post Cover Profile			1	H - 101	90°-90°
DG ACC.	DESCRIPTION	TG ACC.	DESCRIPTION	QTY		
V20000	Interlock Foam Plug					2
V42000 *	Mechanical Cleat (13mm)					16
V42001	90 Deg. Corner Cleat (13mm)					1
V42016	90 Deg. Sub Cill Corner Cleat					1
V53003	Interlock Seal (EPDM)					2
V55034	U00631 & U00632 Sub Cill End Caps					1 Pair
V58000	Interlock End Cap					2
V62000	Roller Glazing Packer	V59047	Triple Glazed Sash Bridge Packer			7
V70000 *	Mechanical Cleat Screw					32
V70001	Ø4.2 x 30mm Pozz Pan Polyamide Screw					4
V51001 *	Ø10.5mm Hole Plug (Black)					-
V51003 *	Water Drain Cap With Valve (Black)					-
V51004 *	Water Drain Cap With Valve (White)					-
V51005 *	Drainage Ball Valves					-
V52020	End Cap for Meeting Style (U00500)					1 Pair
V58001	End Cap for Corner Cost (U00600)					1 Pair
T50000-2	Small Joint Sealant/Adhesive					-
T50003	Aluk Sealant Wipes	T50004	Dow Corning 776 Silicone Bond (New Item)			-
GASKET / PLASTIC PROFILE		TG ACC.	DESCRIPTION	NO.	SIZE	
V02000	Co-Extruded Bubble Seal (Q-Lon)				2H	
V04000	38mm Double Glazed U Gasket	V00000 *	2 - 3mm Wedge Gasket		2L1 + 2L2 + 18H	
V10000 *	Sliding Seal/Fin Pile 6.9mmx 8.5mm				8L1 + 8L2 + 8H	
V31000	21mm PVC Interlock Profile	V31008	25mm PVC Interlock Profile	4	H - 96.6	90°-90°
V03012 *	Sliding Seal			4	H - 92.2	90°-90°
V90015 *	Door Central Gasket			1	H - 96.6	90°-90°
GLASS				NO.	WIDTH	HEIGHT
Glass unit 38mm	Glass unit 52mm			1	X5 - 118.5*	H - 139
Glass unit 38mm	Glass unit 52mm			1	X6 - 118.5*	H - 139

HARDWARE				PACK QTY	QTY
H00200	Roller Wheels			1	4**
H00405	RH Interlock Gearbox & Handle	H00412	LH Interlock Gearbox & Handle	1	1
H00409	Shootbolt kit (Reinforced Sash)			1	1
H00411	External Keep			1 Pair	1
V70020	M6 x 3M Threaded Bar			1	2

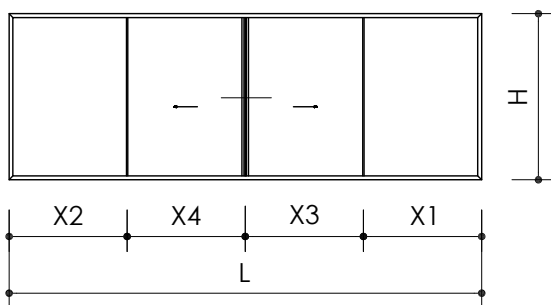
➤ CUTTING LIST



Part 2: 90 Deg. Corner - 4 Sliding & 2 Fixed Panels
(25mm / 21mm Interlock)



CUTTING LIST



2 Sliding & 2 Fixed Panel

(25mm / 21mm Interlock)

NOTES:

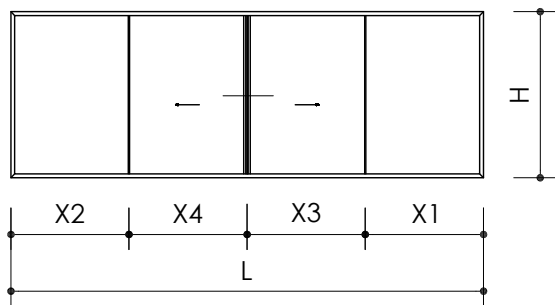
* Add additional 2mm deduction to allow for N00122 (25mm interlock)

** For panel/sash weights > 300Kgs add 2 additional rollers and packers per panel (Max. 400Kgs)

DG PRO.	DESCRIPTION	TG PRO.	DESCRIPTION	NO.	SIZE	ANGLE
U00020	2 Track Outer Frame			1	L	45°-45°
U00020	2 Track Outer Frame			2	H - 33	45°-45°
U00021	2 Track Outer Frame (Head)			1	L	45°-45°
U00630	Drainage Sub Cill			1	L	90°-90°
N00632	Aluminium Track			2	L - 44	90°-90°
N00651	Outer Frame Cover Profile			2	H - 74.2	90°-90°
N00651	Outer Frame Cover Profile			2	L - (X1+X2+10.5*)	90°-90°
N00652	Internal Rebate			1	L - 26.8	45°-45°
N00653	Central Rebate			1	L - 33.6	45°-45°
N00654	Connector Clip			2	L/2 - (X3 + 77.5*)	90°-90°
N00654	Connector Clip			2	L/2 - (X4 + 77.5*)	90°-90°
N00654	Connector Clip			2	L - (X1+X2+10.5*)	90°-90°
N00654	Connector Clip			2	H - 167	90°-90°
U00100	Double Glazed Sash			2	H - 96.6	45°-45°
U00100	Double Glazed Sash (X1)	U00102	Triple Glazed Sash (X1)	2	L1/4 - 23.3*	45°-90°
U00100	Double Glazed Sash (X2)	U00102	Triple Glazed Sash (X2)	2	L1/4 - 23.3*	45°-90°
U00100	Double Glazed Sash (X3)	U00102	Triple Glazed Sash (X3)	2	L1/4 - 8.7*	45°-90°
U00100	Double Glazed Sash (X4)	U00102	Triple Glazed Sash (X4)	2	L1/4 - 14.2*	45°-90°
U00101	Reinforced Double Glazed Sash	U00103	Reinforced Triple Glazed Sash	2	H - 96.6	45°-45°
N00120	21mm Interlock Profile	N00122	25mm TG Interlock Profile	4	H - 96.6	90°-90°
U00500	Meeting Stile			2	H - 101	90°-90°
N00901	Meeting Stile Adaptor			2	H - 101	90°-90°
DG ACC.	DESCRIPTION	TG ACC.	DESCRIPTION	QTY		
V20000	Interlock Foam Plug			4		
V42000 *	Mechanical Cleat (13mm)			32		
V50001	Fixed Sash Support Blocks			4		
V52020	End Cap For Meeting Style (U00500)			1 Pair		
V53003	Interlock Seal (EPDM)			4		
V55000	Sub Cill End Caps			1 Pair		
V58000	Interlock End Cap			8		
V58002	End Cap For Meeting Style Adaptor			1		
V62000	Roller Glazing Packer	V59047	Triple Glazed Sash Bridge Packer	11		
V70000 *	Mechanical Cleat Screw			64		
V70001	Ø4.2 x 30mm Pozl Pan Polyamide Screw			8		
V51001 *	Ø10.5mm Hole Plug (Black)			-		
V51003 *	Water Drain Cap With Valve (Black)			-		
V51004 *	Water Drain Cap With Valve (White)			-		
V51005 *	Drainage Ball Valves			-		
T50000-2	Small Joint Sealant/Adhesive			-		
T50003	Aluk Sealant Wipes	T50004	Dow Corning 776 Silicone Bond (New Item)	-		
GASKET / PLASTIC PROFILE		TG ACC.	DESCRIPTION	NO.	SIZE	
V02000	Co-Extruded Bubble Seal (Q-Lon)				4H	
V04000	38mm Double Glazed U Gasket	V00000 *	2 - 3mm Wedge Gasket		2L + 8H	
V09000	Outer Frame Bumper Seal				2H	
V10000 *	Sliding Seal/Fin Pile 6.9mmx 8.5mm				16L + 8H	
V31000	21mm PVC Interlock Profile	V31008	25mm PVC Interlock Profile	4	H - 96.6	90°-90°
V03012 *	Sliding Seal			4	H - 92.2	90°-90°
V90015 *	Door Central Gasket			1	H - 96.6	90°-90°
GLASS				NO.	WIDTH	HEIGHT
Glass unit 38mm	X1 Glass Sizes (38mm Unit)			1	L1/4 - 49.5*	H - 139
Glass unit 38mm	X2 Glass Sizes (38mm Unit)			1	L1/4 - 49.5*	H - 139
Glass unit 52mm	X3 Glass Sizes (52mm Unit)			1	L1/4 - 34.9*	H - 139
Glass unit 52mm	X4 Glass Sizes (52mm Unit)			1	L1/4 - 40.4*	H - 139

HARDWARE			PACK QTY	QTY
H00200	Roller Wheels		1	4**
H00405	RH Interlock Gearbox & Handle		1	1
H00409	Shootbolt kit (Reinforced Sash)		1	2
H00411	External Keep		2	4
H00412	LH Interlock Gearbox & Handle		1	1
V70020	M6 x 3M Threaded Bar		1	4

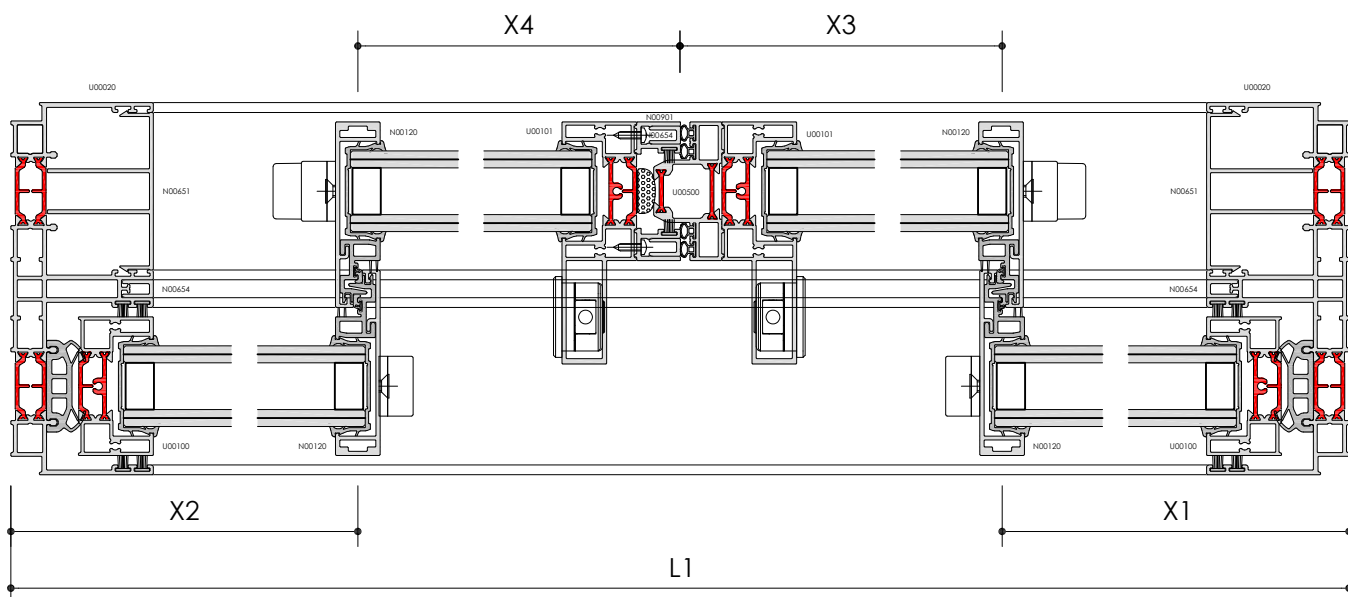
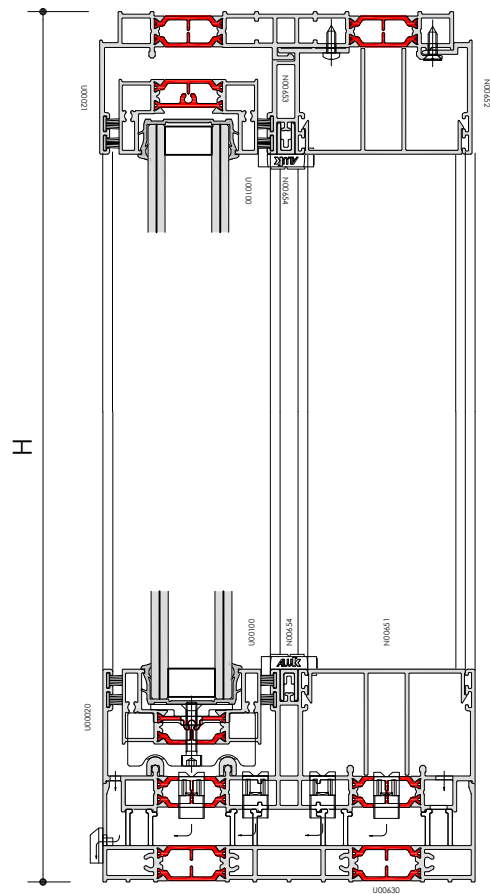
CUTTING LIST



2 Sliding & 2 Fixed Panel

(25mm / 21mm Interlock)

- * V00000 = Only for Aluk.IT: 809119
- * V10000 = Only for Aluk.GBR: XA621
- * V03012 = Only for Aluk.FRA: J8002
- * V42000 = Only for Aluk.FRA: 27500
- * V51001 = Only for Aluk.ITA: 709616
- * V51002 = Only for Aluk.ITA: 709617
- * V51003 = Only for Aluk.ITA: 712007
- * V51004 = Only for Aluk.ITA: 712008
- * V51005 = Only for Aluk.GBR: A-00-225
- * V70000 = Only for Aluk.FRA: 86720
- * V90015 = Only for Aluk.ITA: 809688



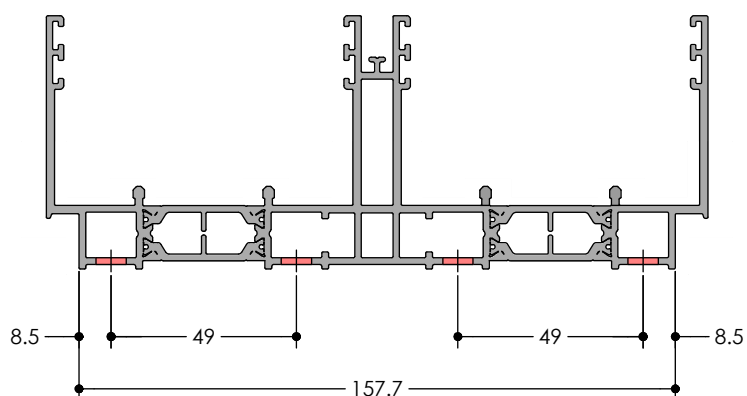


SECTION 9 MACHINING

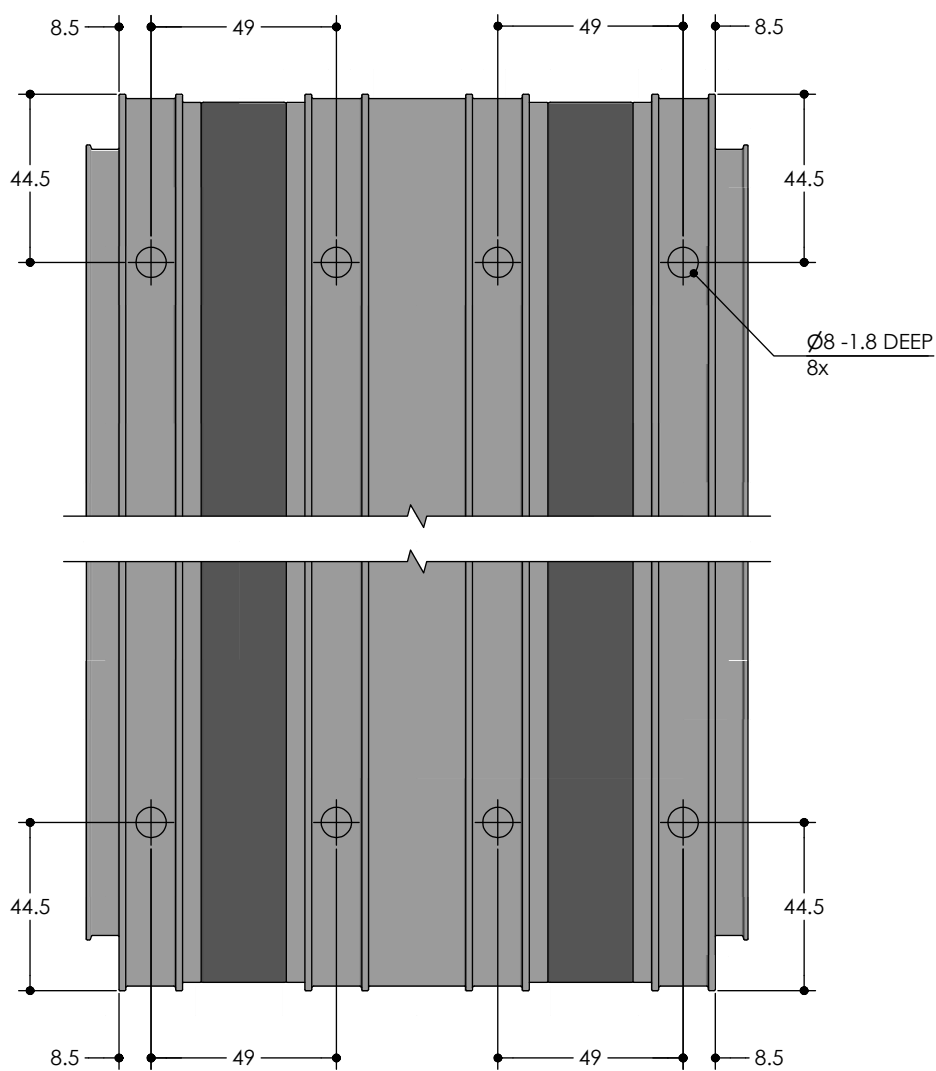
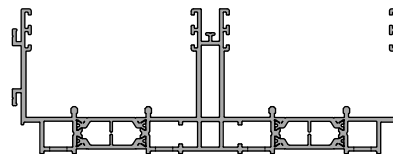
» INLINE SLIDING DOOR

➤ U00020 & U00022 - MECHANICAL CLEAT

U00020



Also applicable to U00022

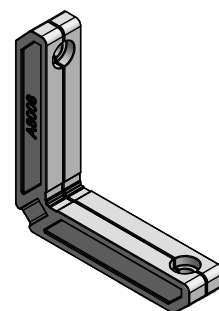


* ALUK FR/GBR CODE: 27500
** ALUK FR/GBR CODE: 86720

Use cleat and screw ref:



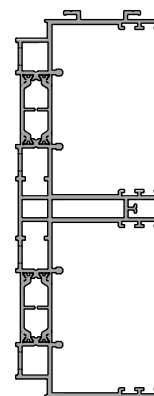
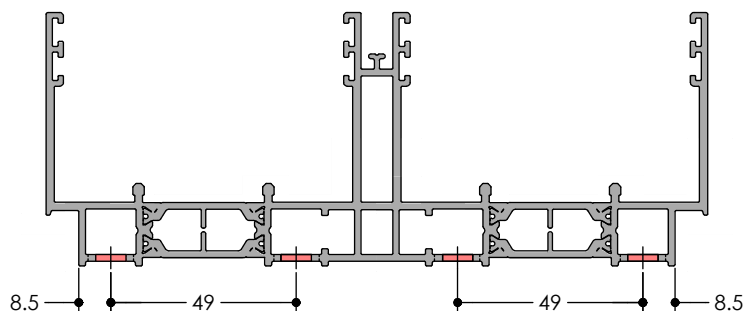
V70000**
x8 Per Corner
(PU x50)



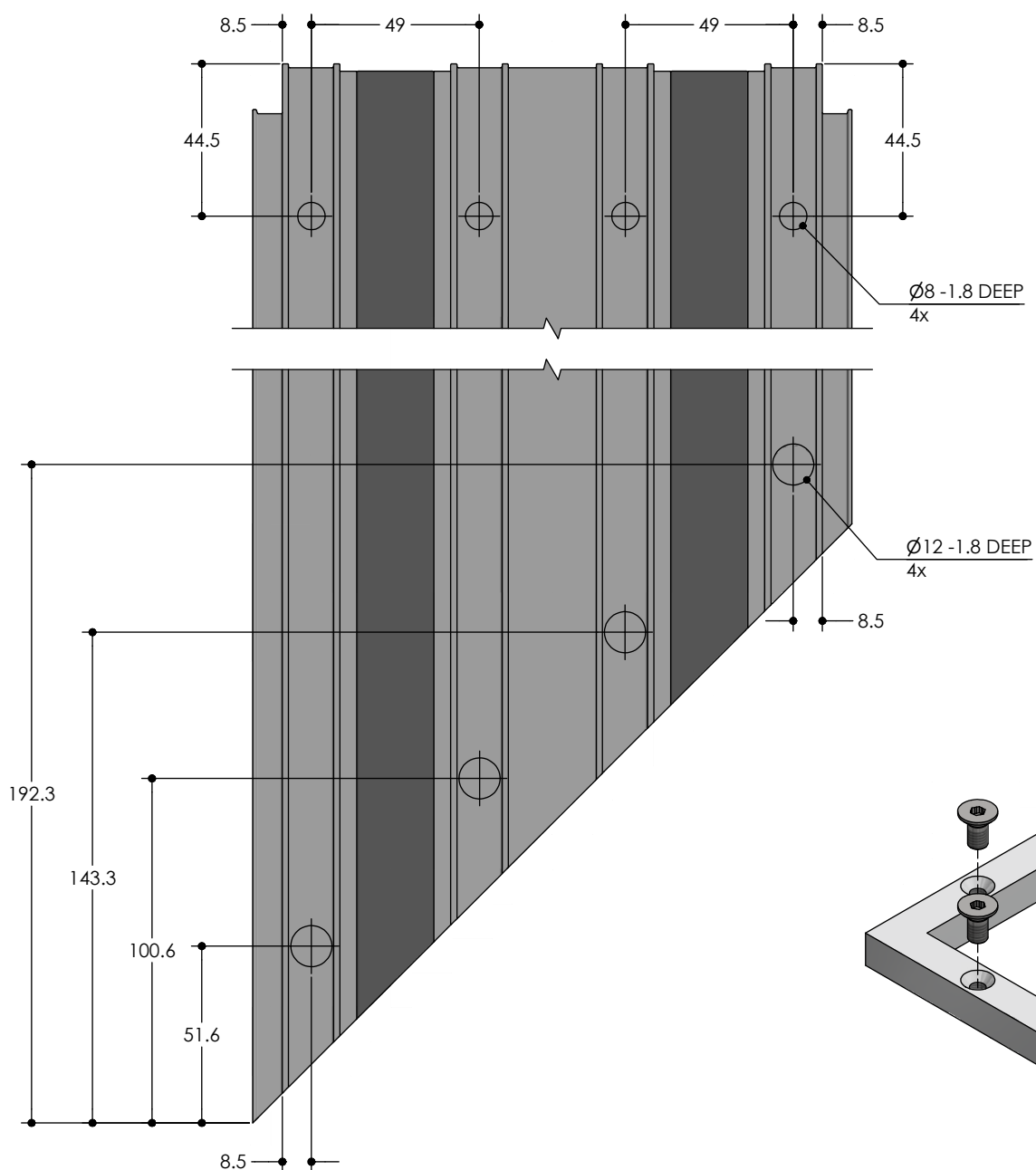
V42000*
x4 Per Corner
(PU x8)

➤ U00020 & U00022 - 90 DEG. CORNER

U00020



Also applicable to U00022

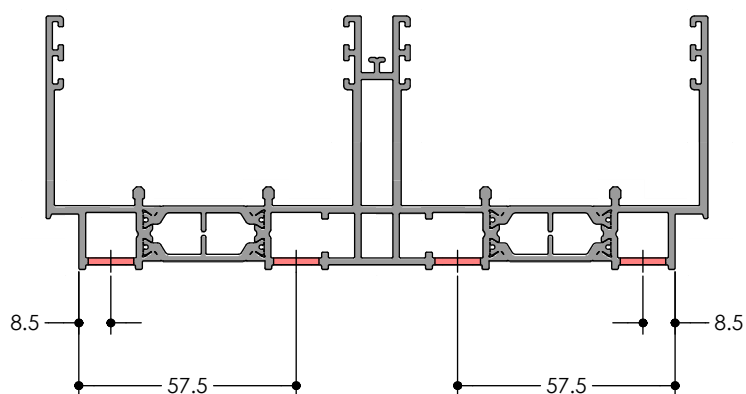


V42001

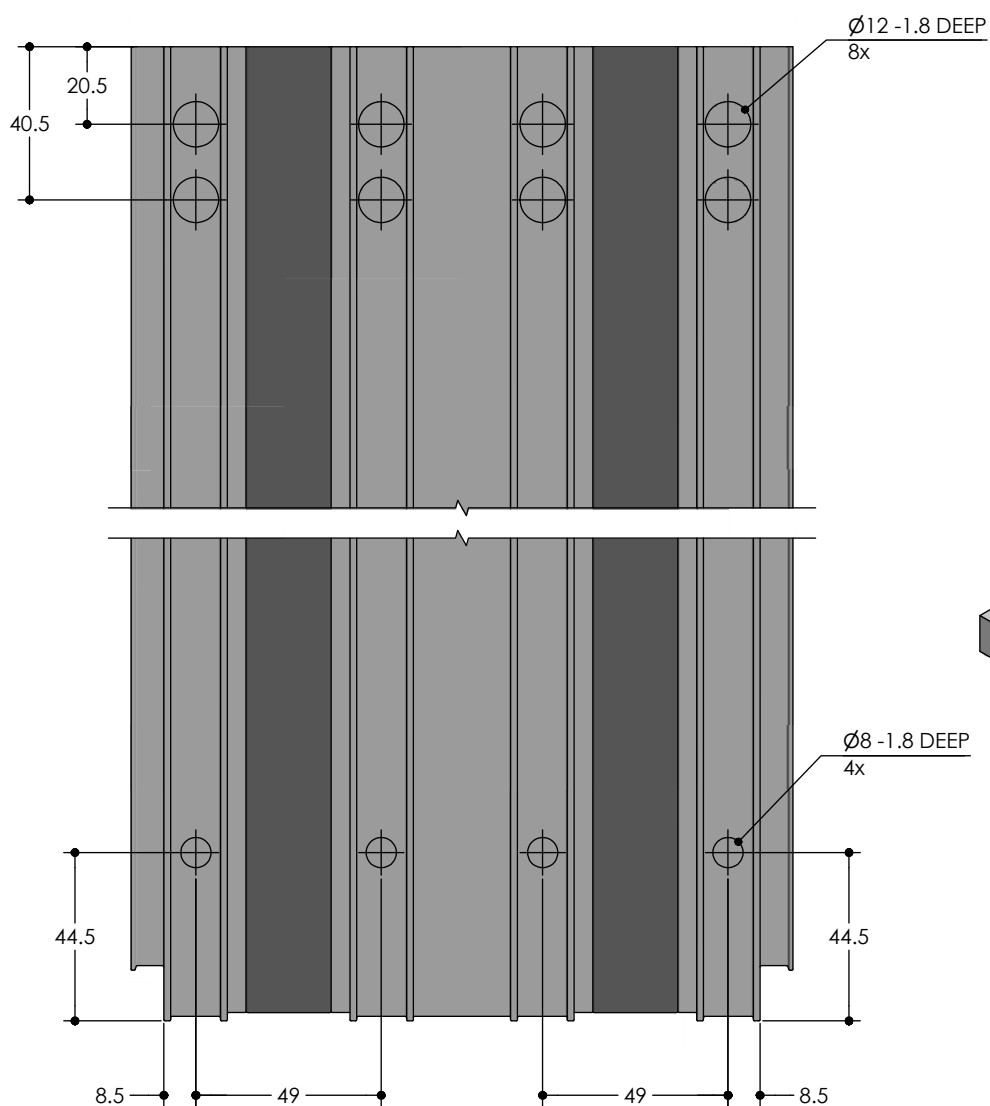
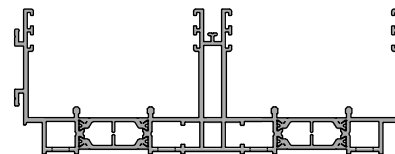
x4 Per Corner
(PU x8)

➤ U00020 & U00022 - EXTENSION JOINT

U00020

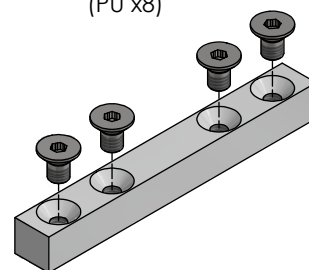


Also applicable to U00022

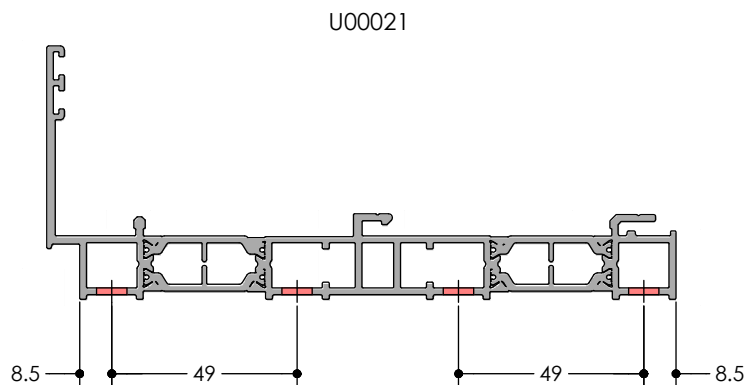


V72029

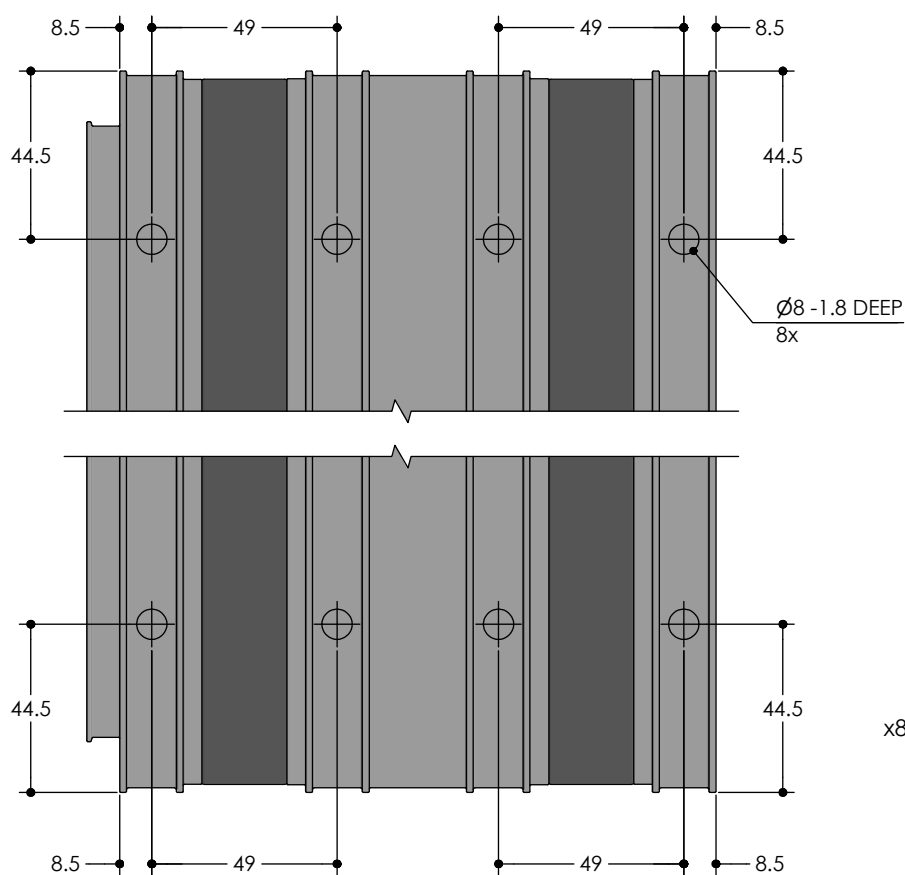
x4 Per Joint
(PU x8)



➤ U00021 & U00023 - MECHANICAL CLEAT

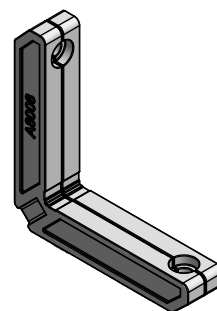


Also applicable to U00023



* ALUK FR/GBR CODE: 27500
** ALUK FR/GBR CODE: 86720

Use cleat and screw ref:



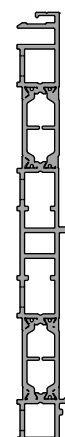
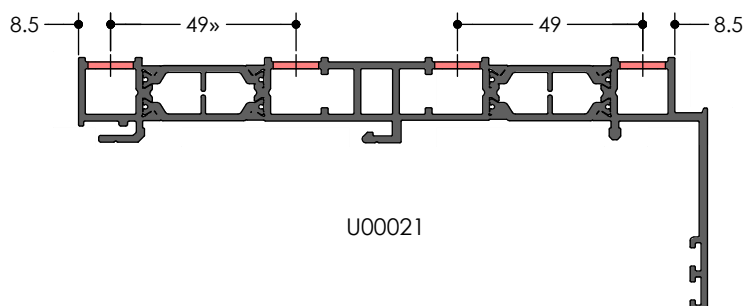
V70000**

x8 Per Corner
(PU x50)

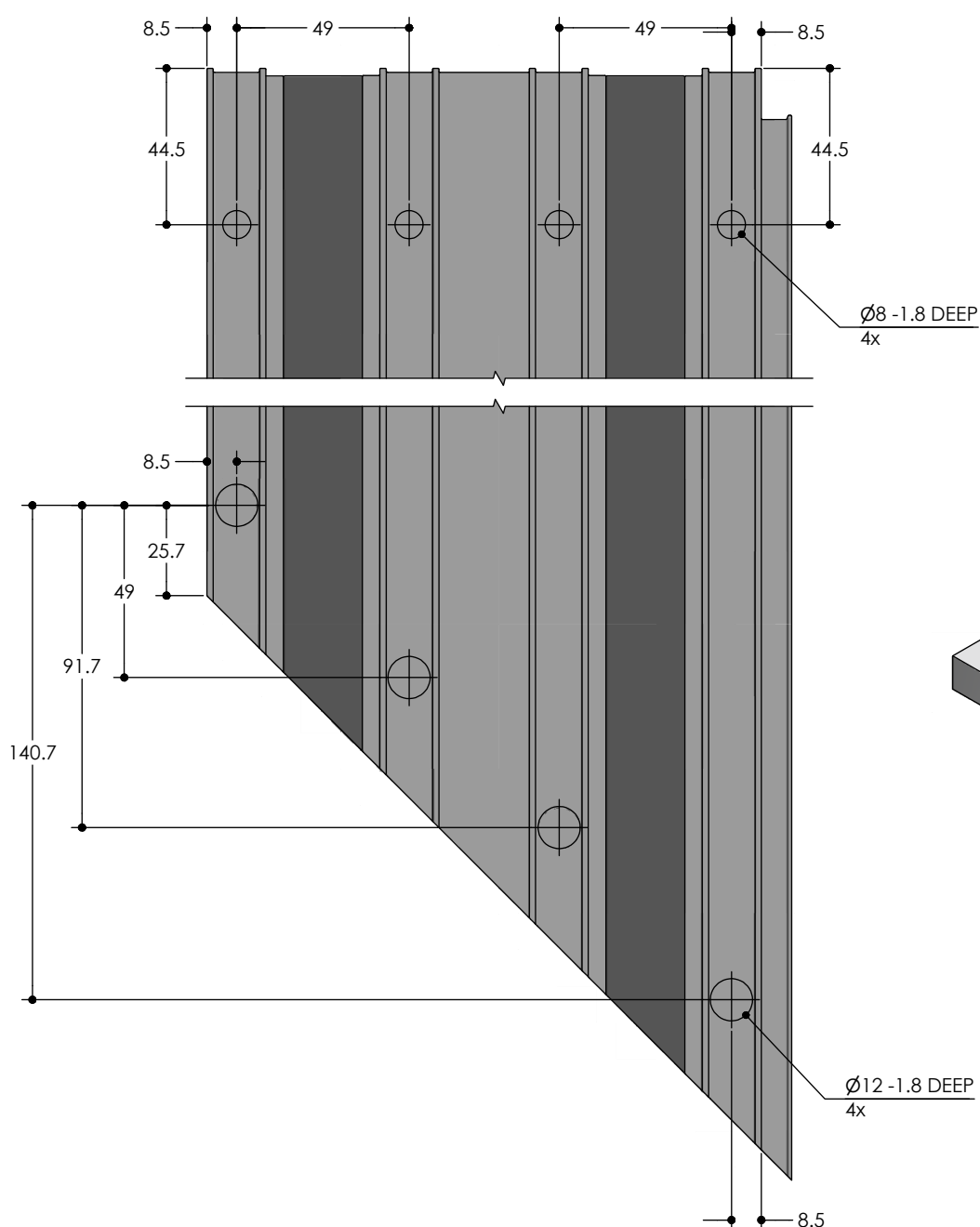
V42000*

x4 Per Corner
(PU x8)

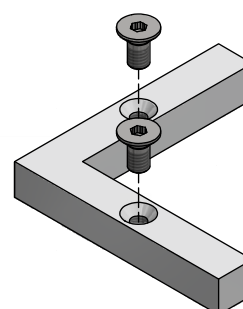
▶ U00021 & U00023 - 90 DEG. CORNER



Also applicable to U00023

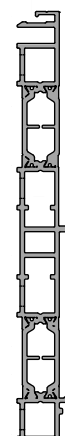
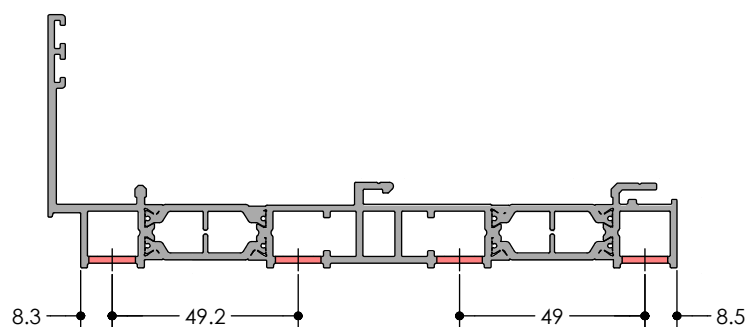


x4 Per Corner
(PU x8)

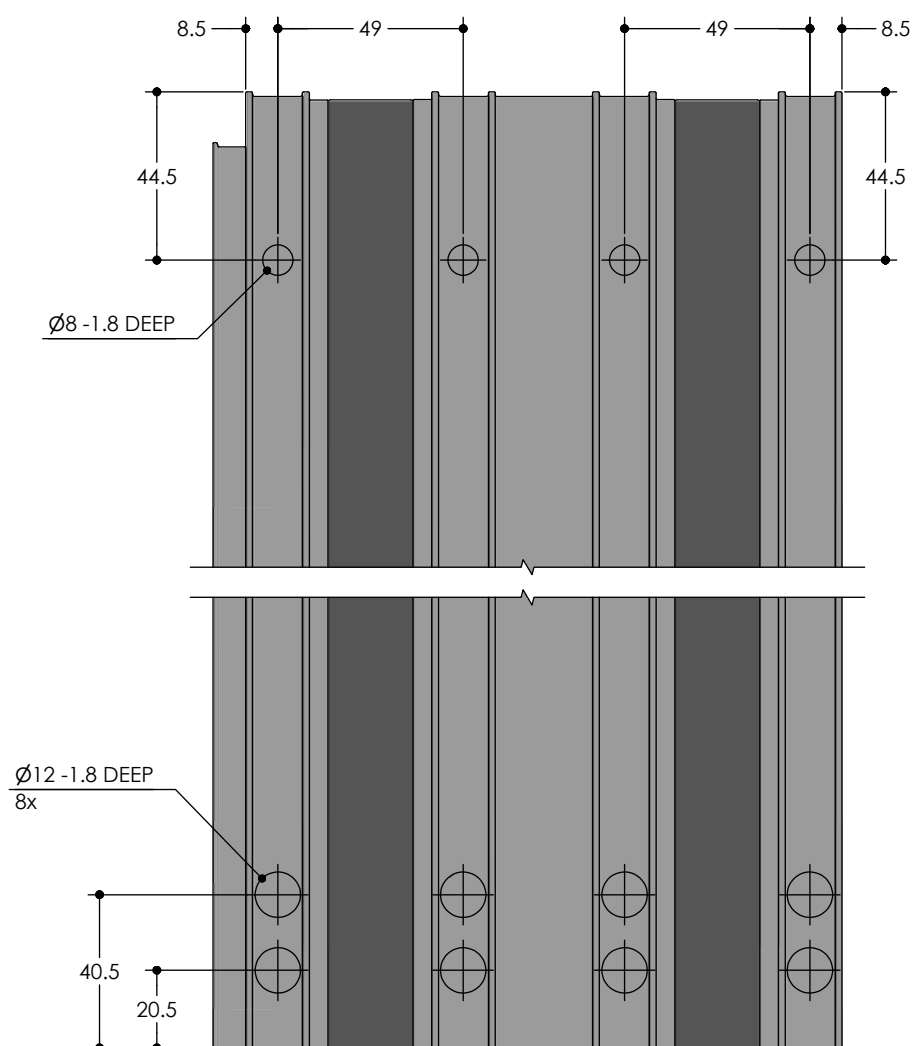


➤ U00021 & U00023 - EXTENSION JOINT

U00021

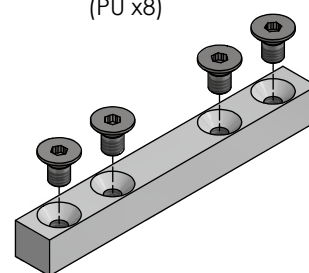


Also applicable to U00023



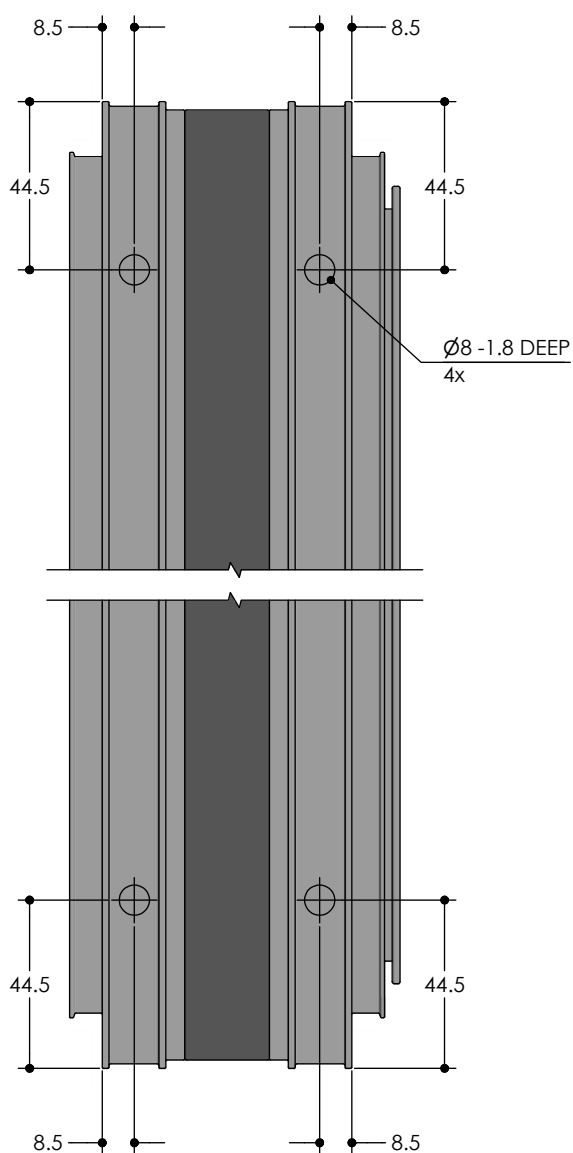
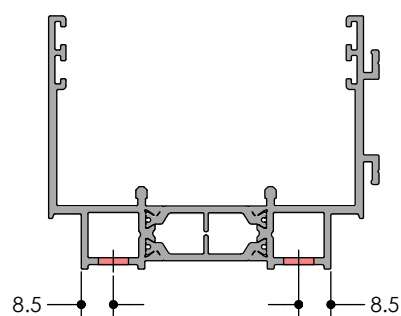
V72029

x4 Per Joint
(PU x8)



➤ U00000 - MECHANICAL CLEAT

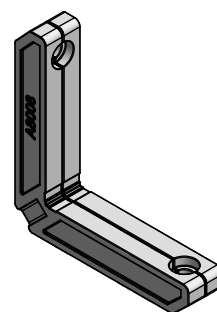
U00000



* ALUK FR/GBR CODE: 27500

** ALUK FR/GBR CODE: 86720

Use cleat and screw ref:



V70000**

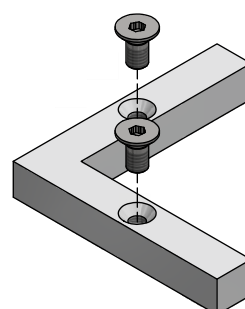
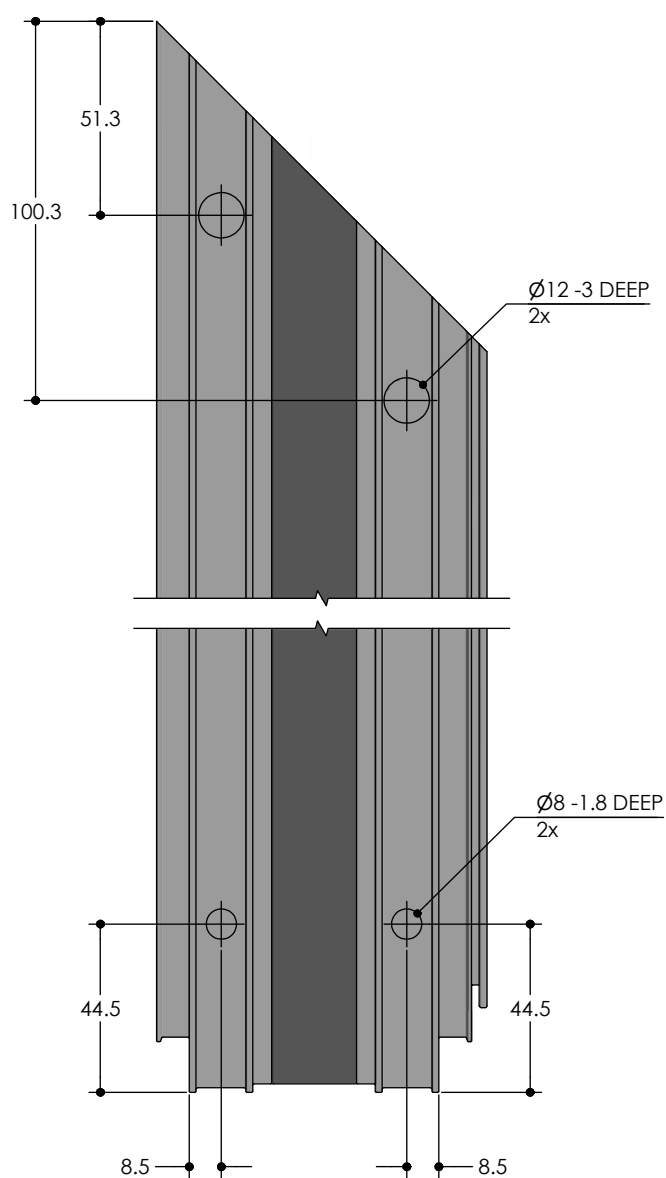
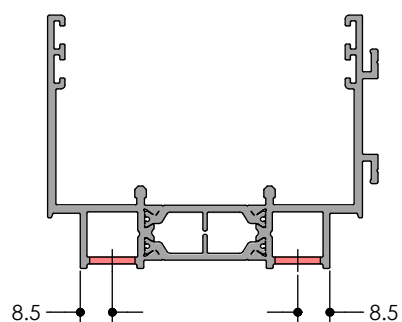
x8 Per Corner
(PU x50)

V42000*

x4 Per Corner
(PU x8)

➤ U00000 - 90 DEG. CORNER

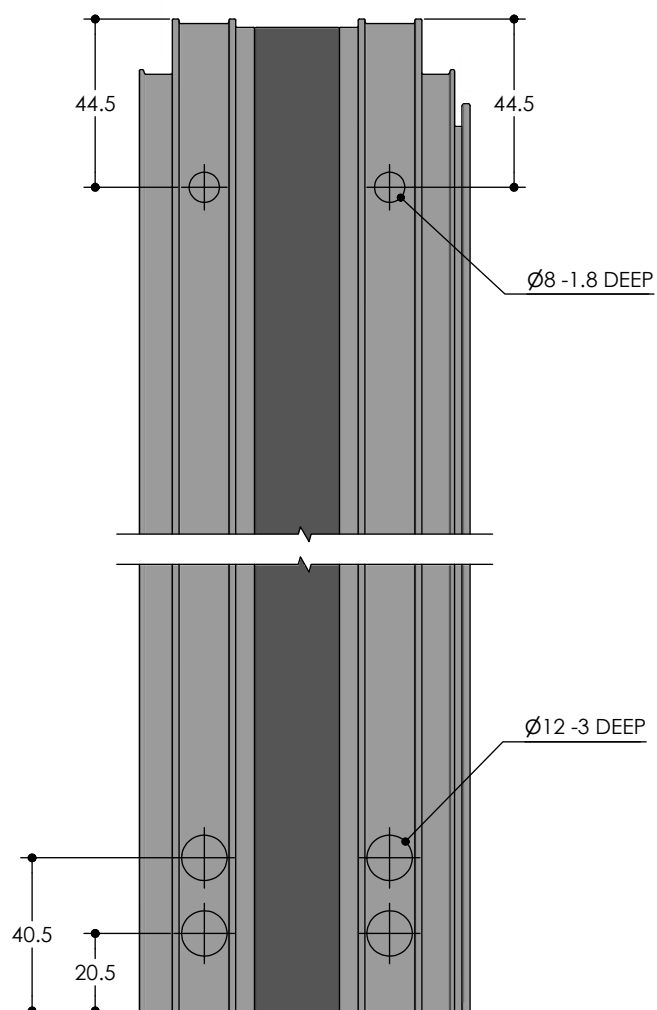
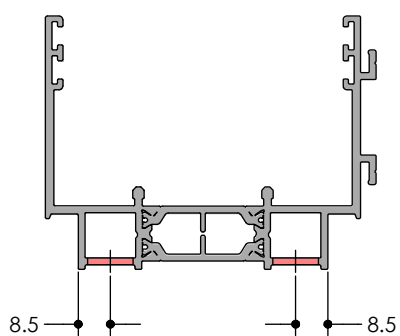
U00000



V42001
x2 Per Corner
(PU x8)

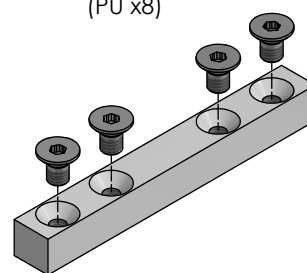
➤ U00000 - EXTENSION JOINT

U00000



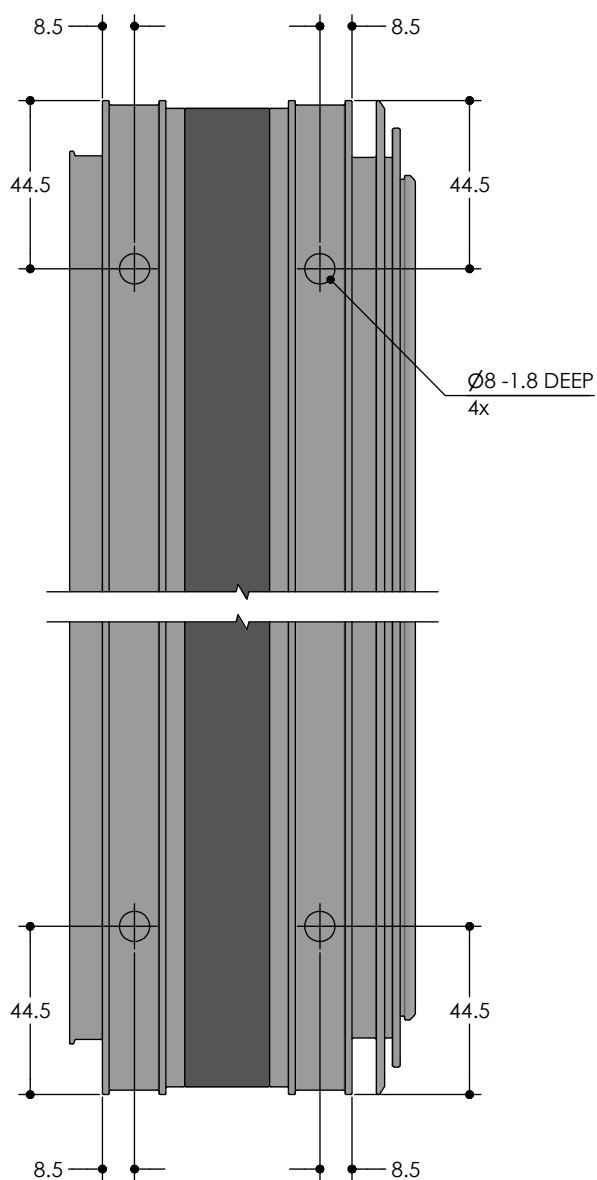
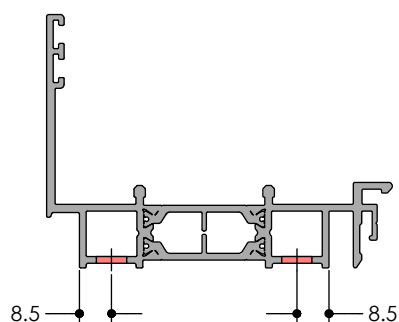
V72029

x4 Per Joint
(PU x8)



U00001 - MECHANICAL CLEAT

U00001

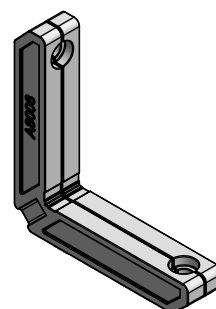


* ALUK FR/GBR CODE: 27500
 ** ALUK FR/GBR CODE: 86720

Use cleat and screw ref:



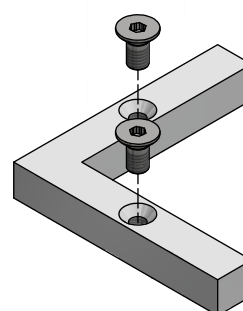
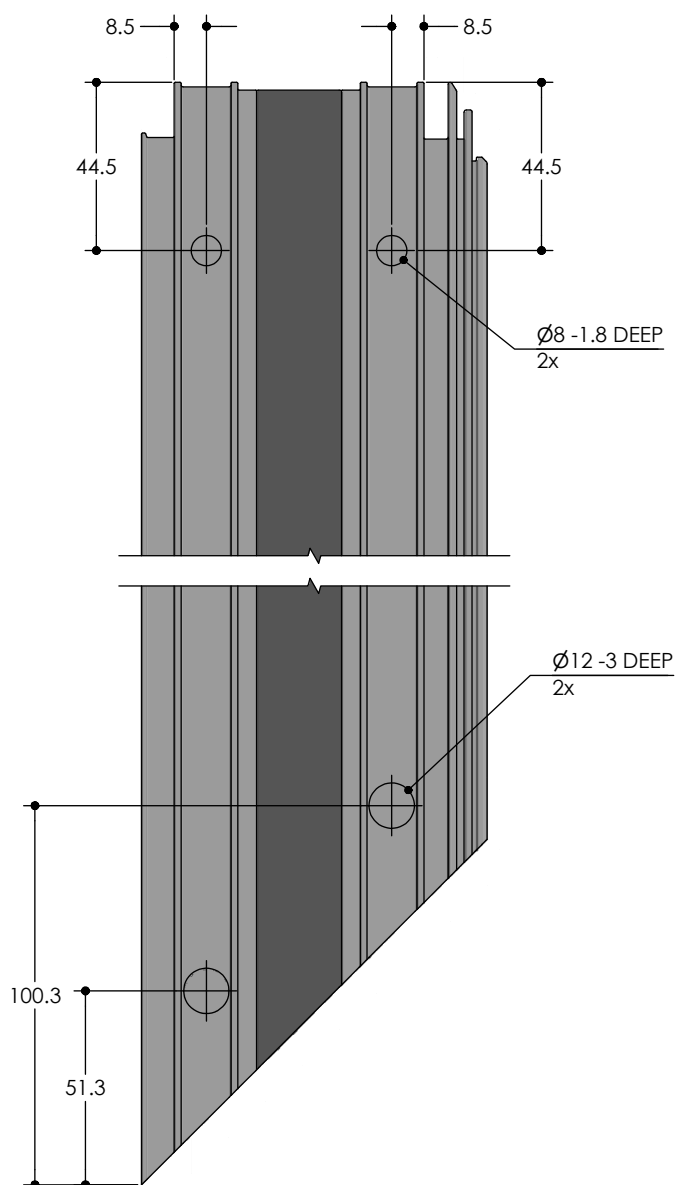
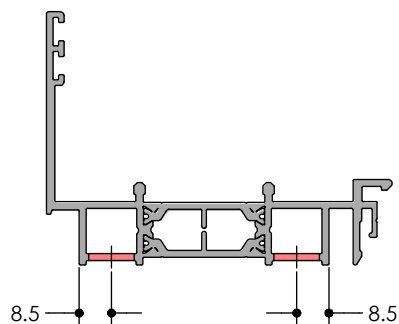
V70000**
 x8 Per Corner
 (PU x50)



V42000*
 x4 Per Corner
 (PU x8)

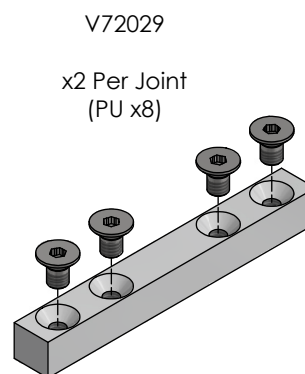
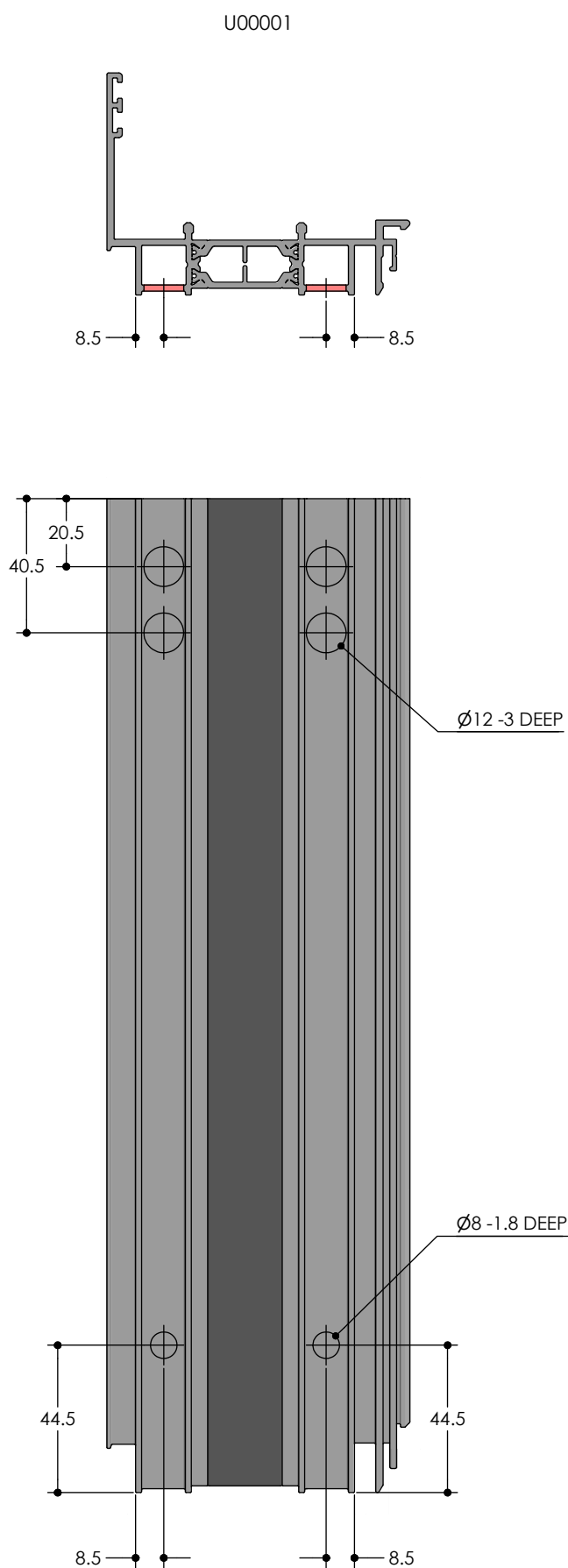
➤ U00001 - 90 DEG. CORNER

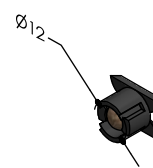
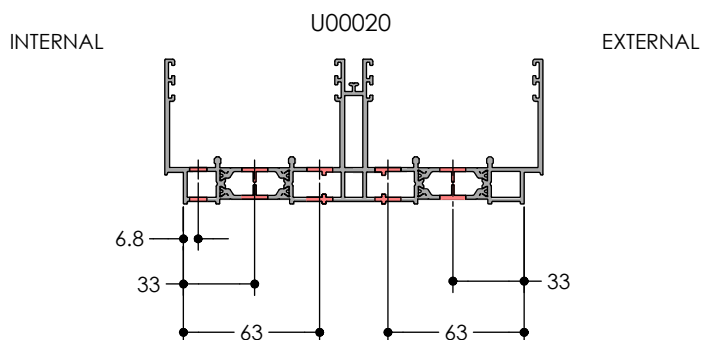
U00001



V42001
x2 Per Corner
(PU x8)

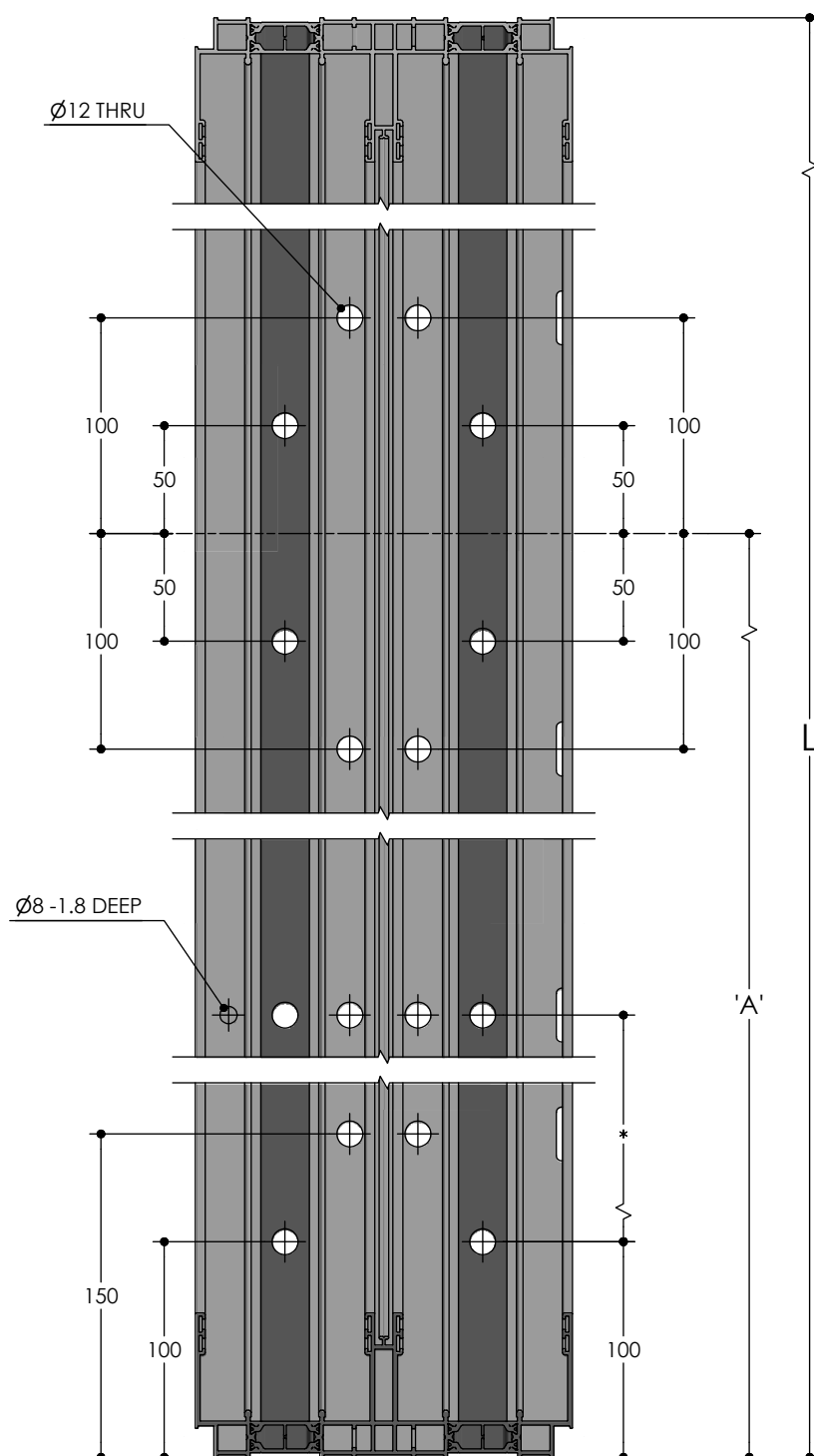
➤ U00001 - EXTENSION JOINT





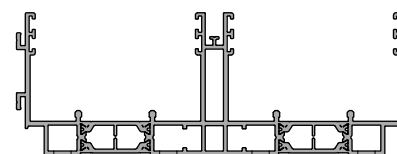
V51005*

Drainage Valve



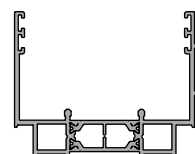
* ALUK GBR CODE: A-00-225

Also applicable to U00022 & U00000



EXTERNAL

INTERNAL

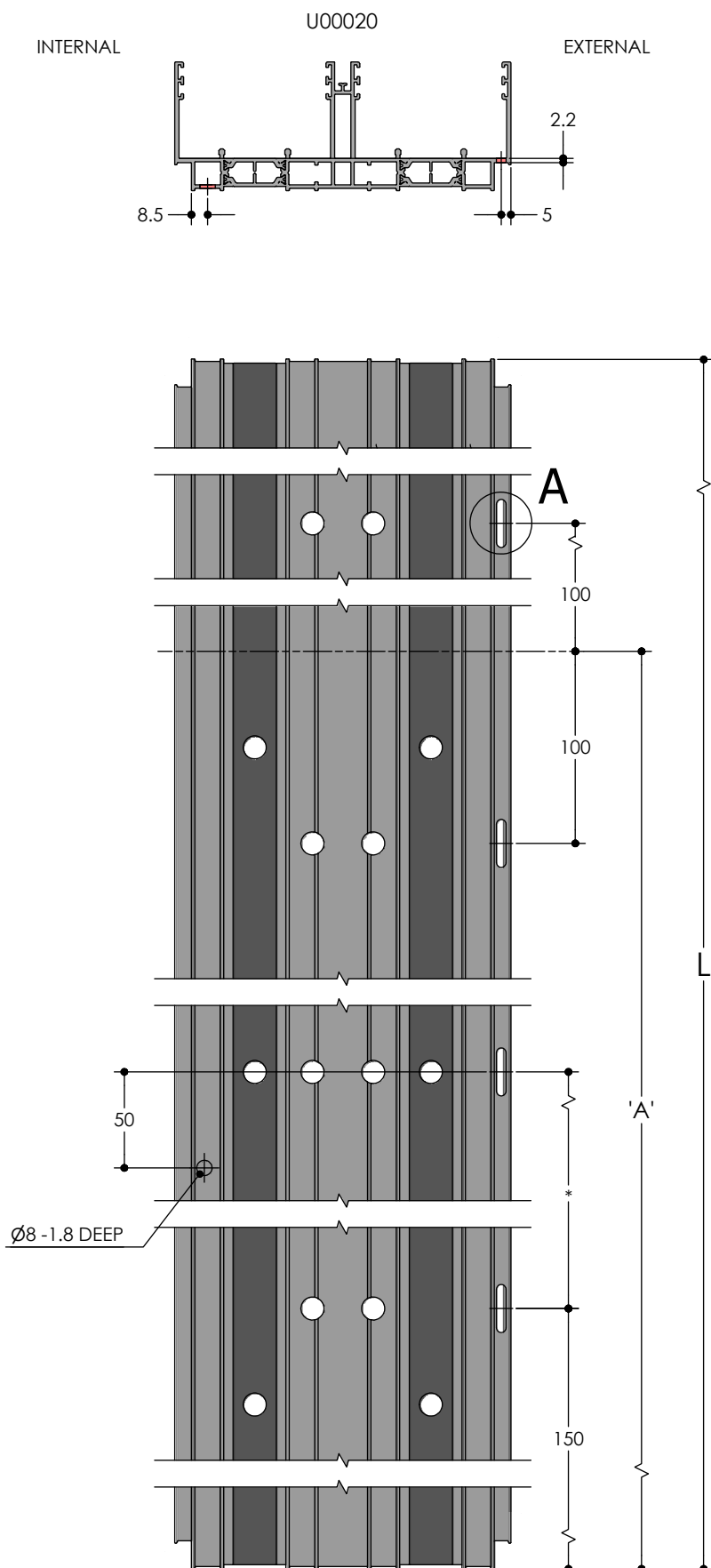


IMPORTANT:

Dim. 'A' - Mirror drainage holes around
the
mid-point of each interlock.

*Continue at a maximum of 600mm centres.

➤ U00020 - DRAINAGE CONT.



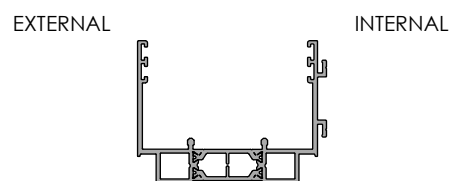
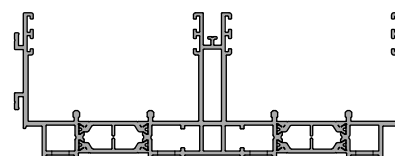
IMPORTANT:

Ø8 holes offset by 50mm from top holes.

Dim. 'A' - Mirror drainage holes around the mid-point of each interlock.

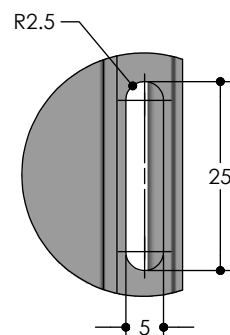
*Continue at a maximum of 600mm centres.

Also applicable to U00022 & U00000



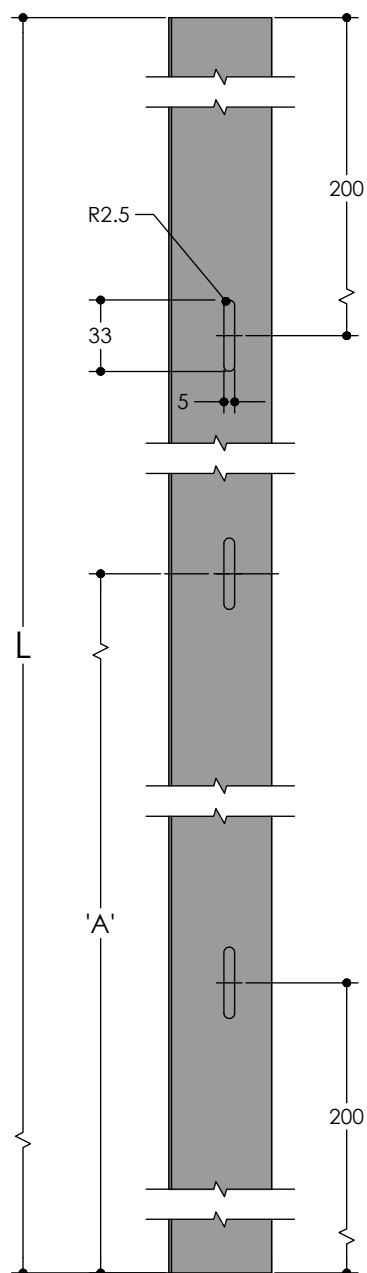
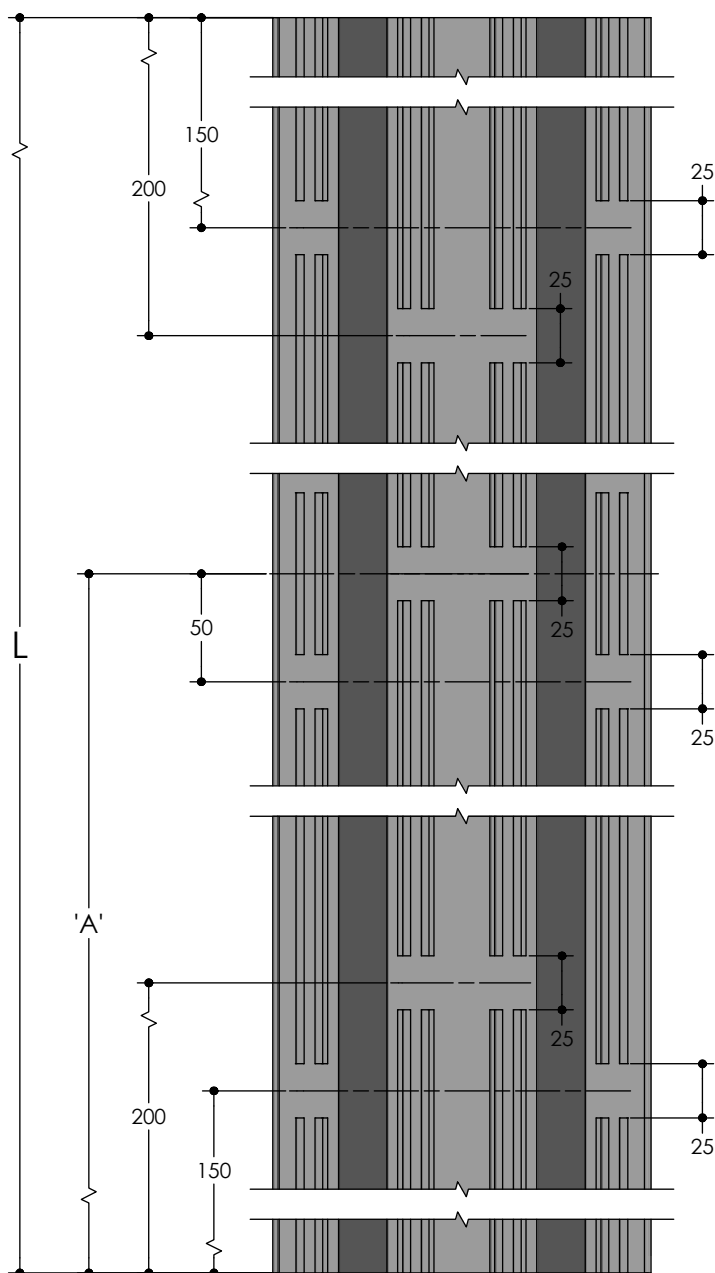
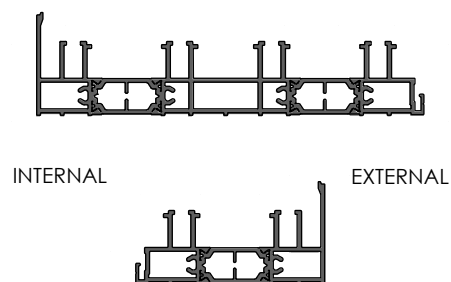
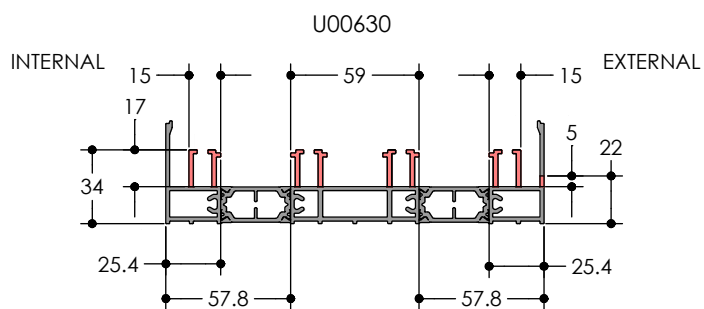
A

Thru slot 'A' to be machined from bottom surface of the profile.



➤ U00630 - DRAINAGE

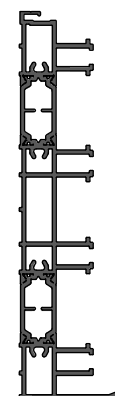
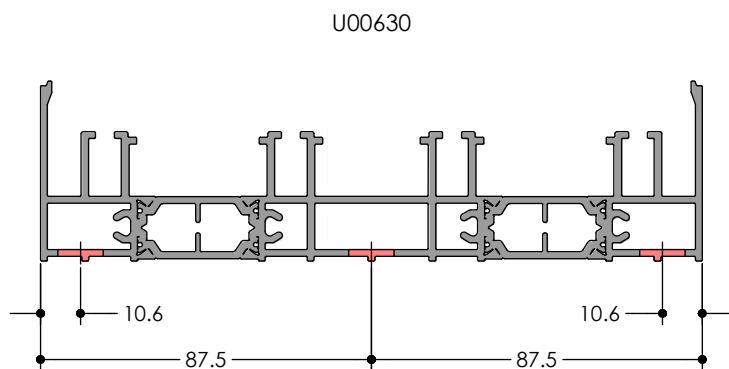
Also applicable to U00631 & U00632



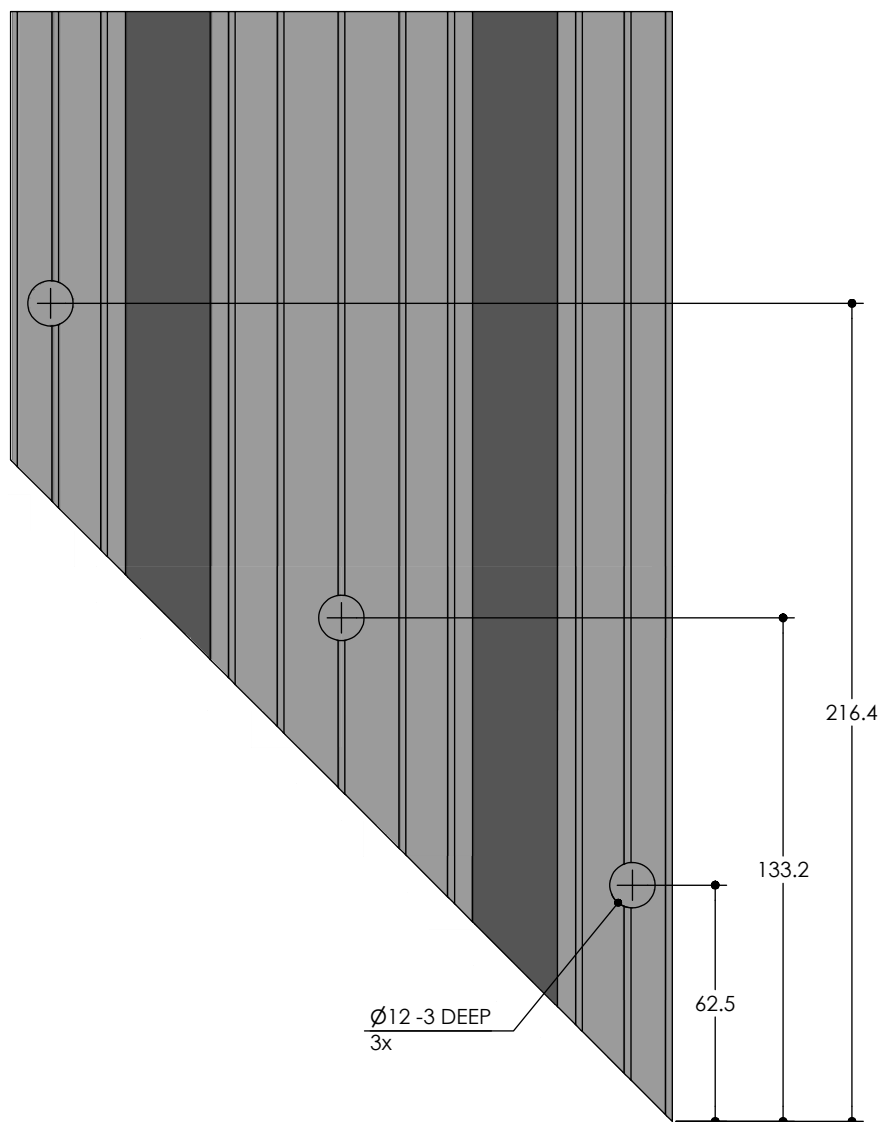
IMPORTANT:

Dim. 'A' - Add drainage slots around the mid-point of each interlock and inbetween at 600mm centres

➤ U00631 - 90 DEG. CORNER

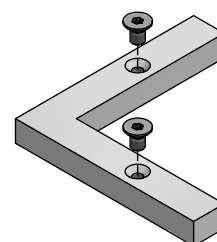
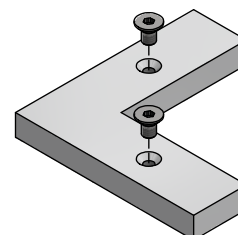


Also applicable to U00631



Part of V42016

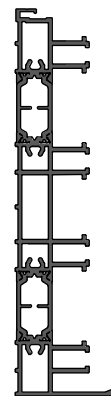
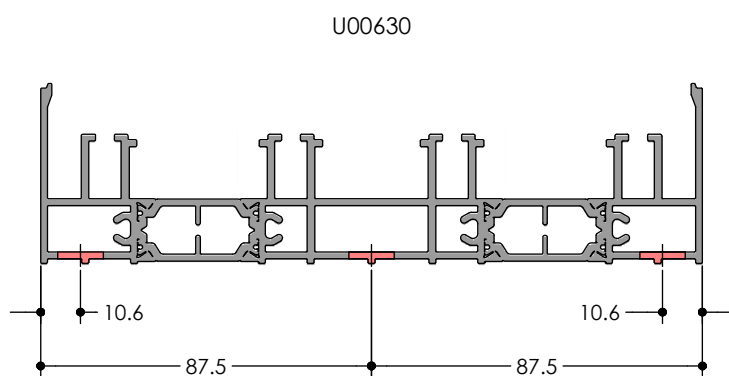
x1 Per Joint
(PU x1)



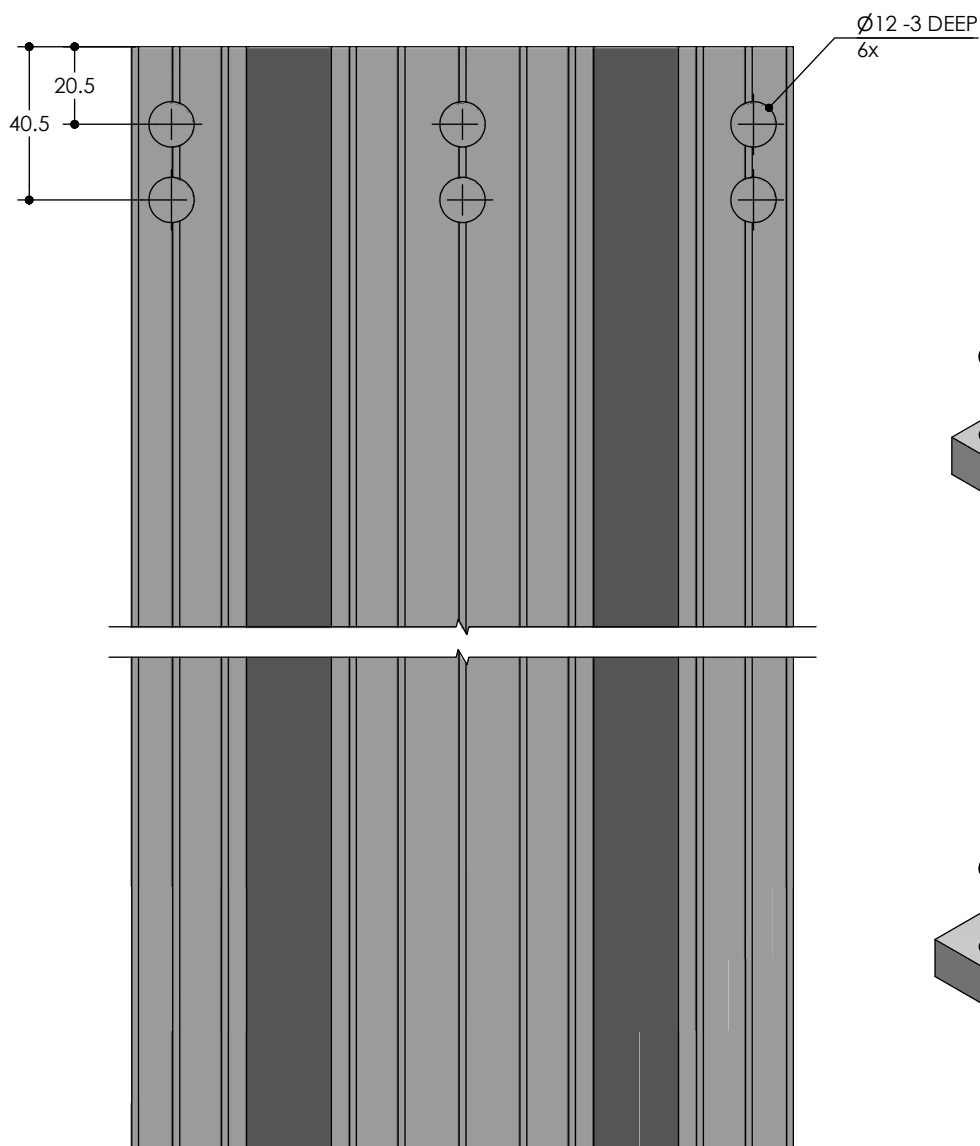
Part of V42016

x2 Per Joint
(PU x4)

➤ U00630 - EXTENSION JOINT

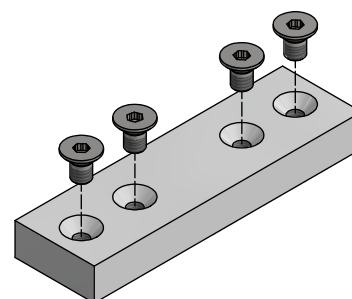
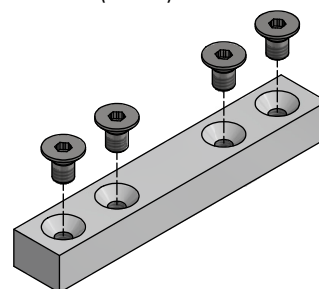


Also applicable to U00631



Part of V72030

x2 Per Joint
(PU x2)

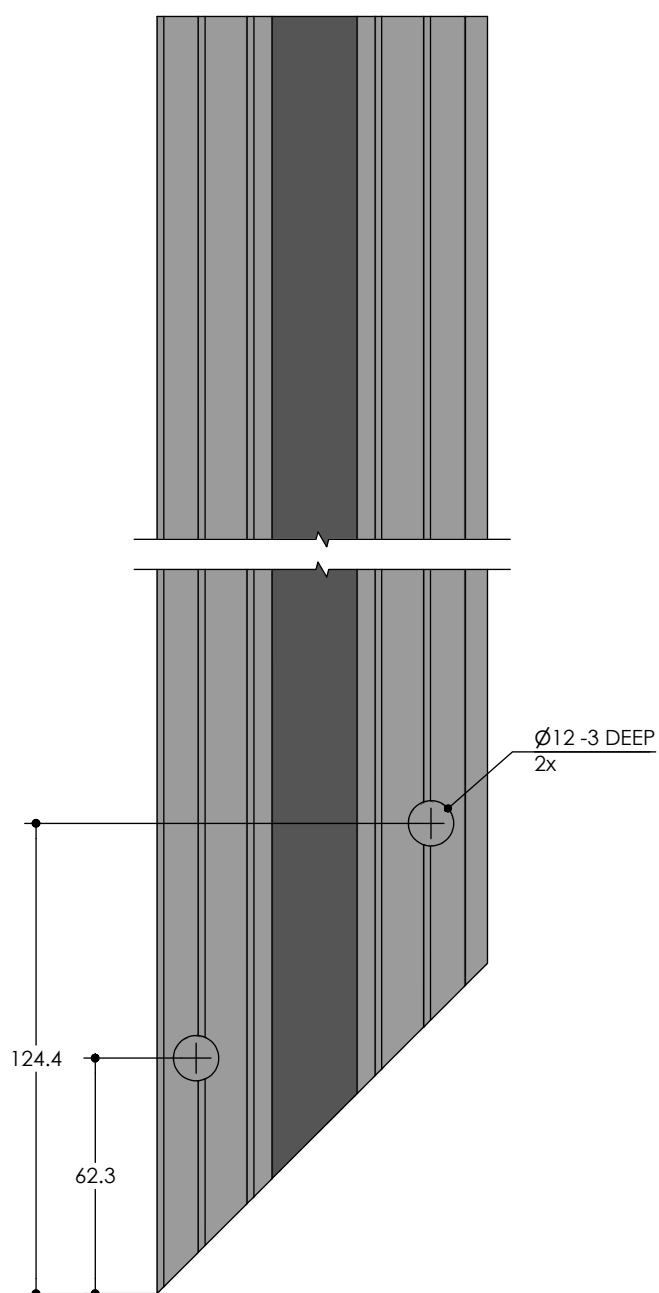
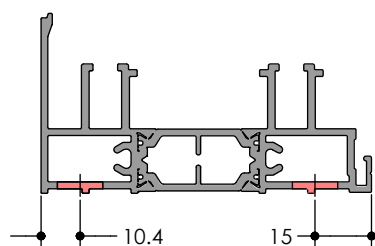


Part of V72030

x1 Per Joint
(PU x1)

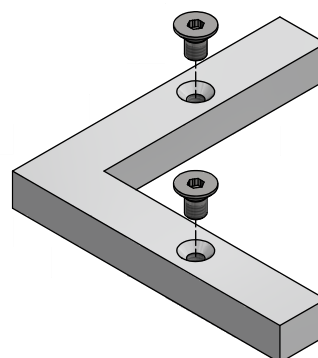
➤ U00632 - 90 DEG. CORNER

U00632



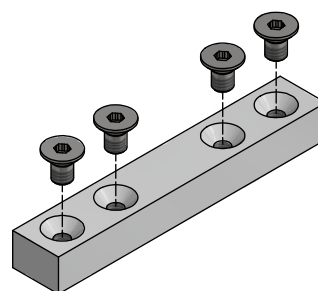
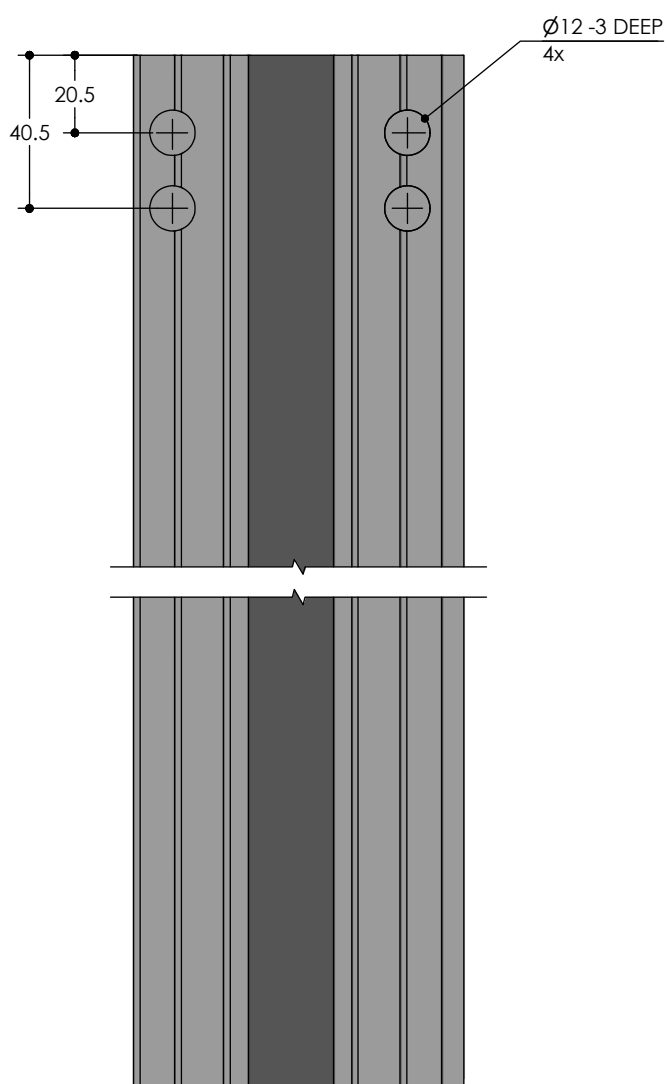
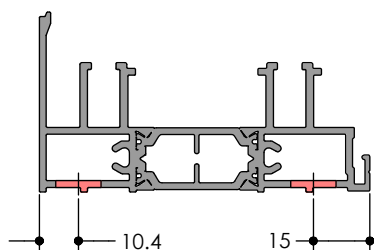
Part of V42016

x2 Per Joint
(PU x4)



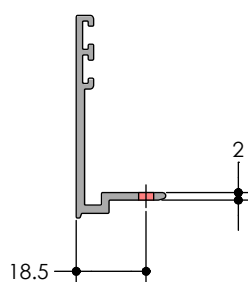
➤ U00632 - EXTENSION JOINT

U00632



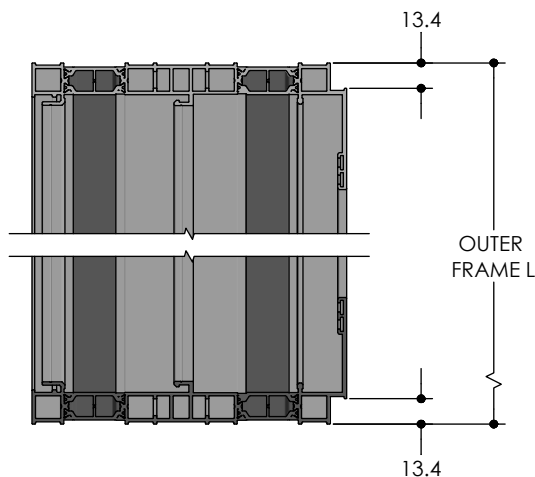
Per of V72030

x2 Per Joint
(PU x2)

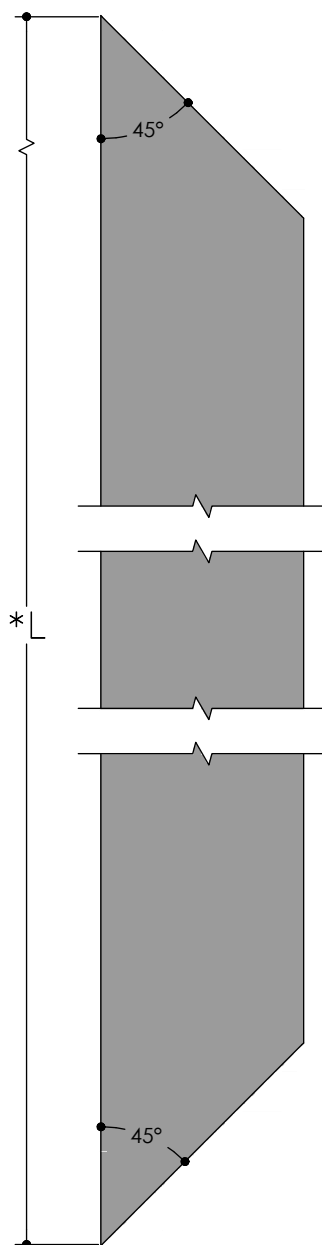
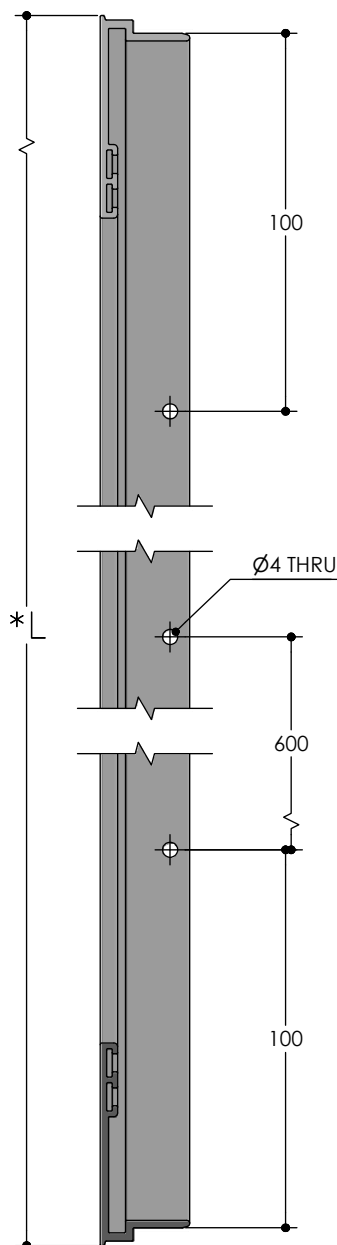


IMPORTANT:

Continue Ø4mm holes at 600mm centres
along full length of N00652

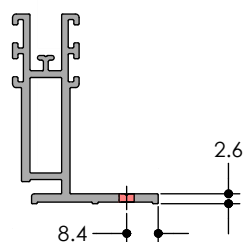


*L = OUTER FRAME L - 26.8



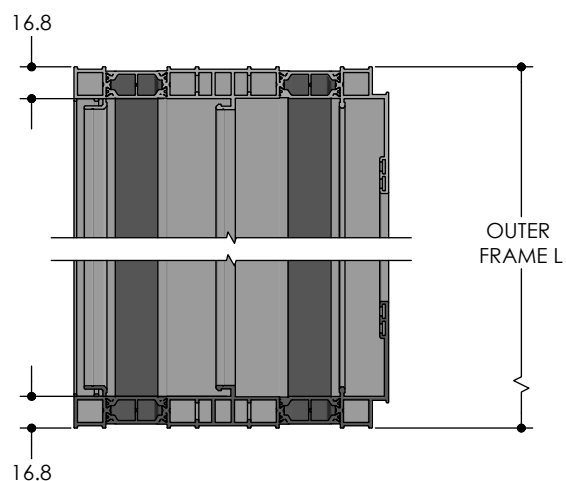
➤ N00653 - CENTRAL REBATE

N00653

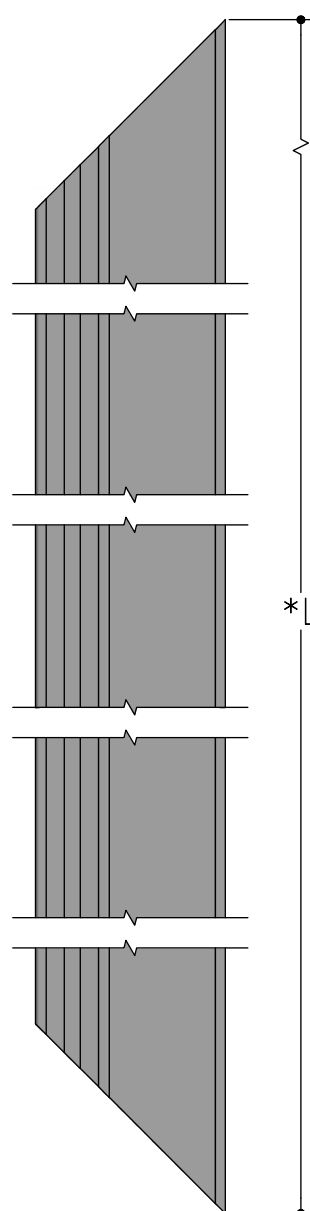
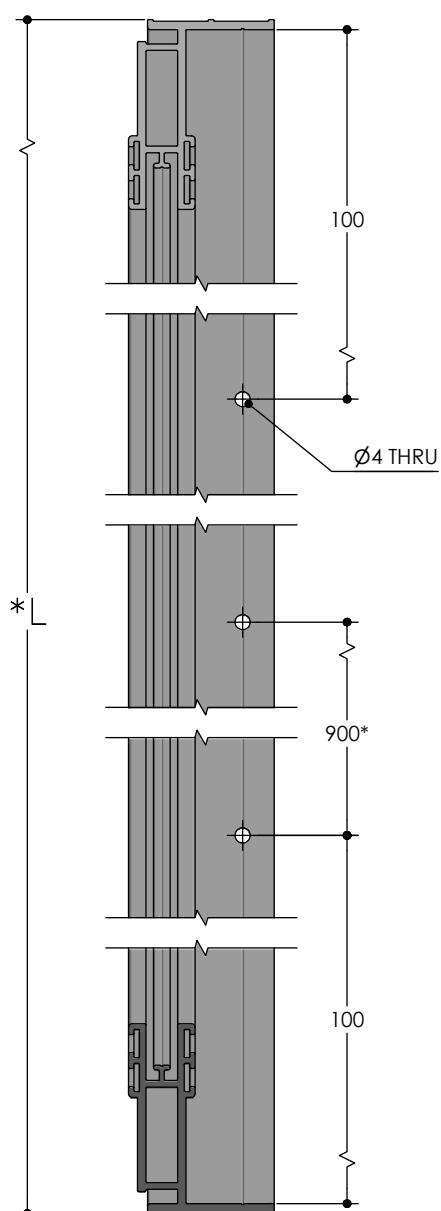


IMPORTANT:

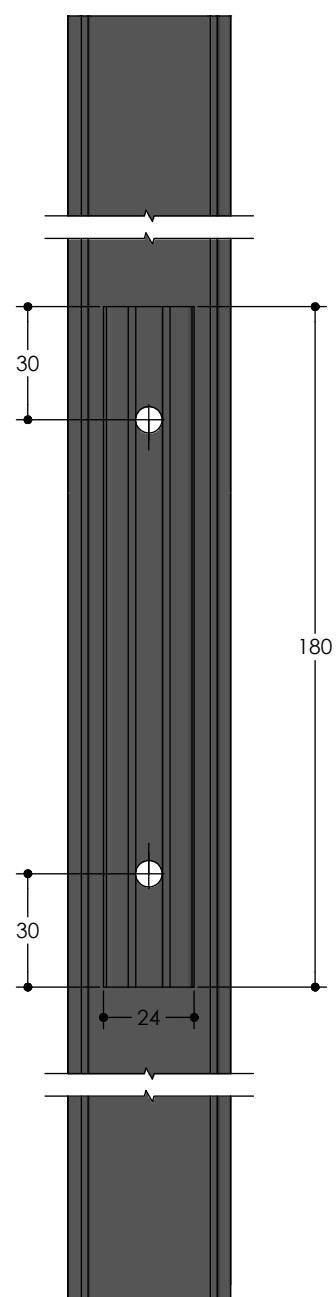
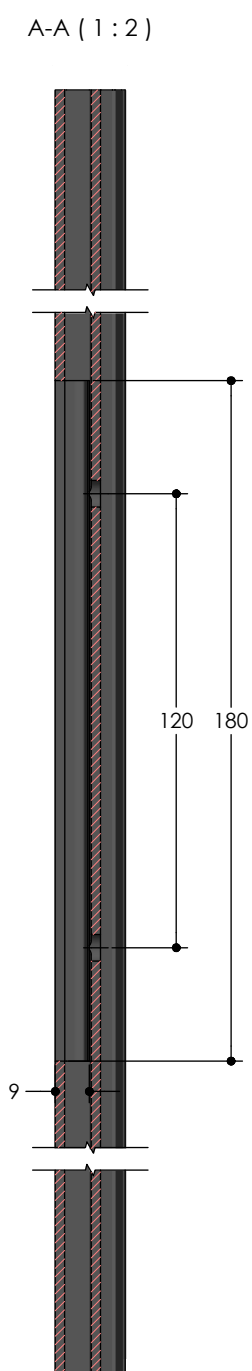
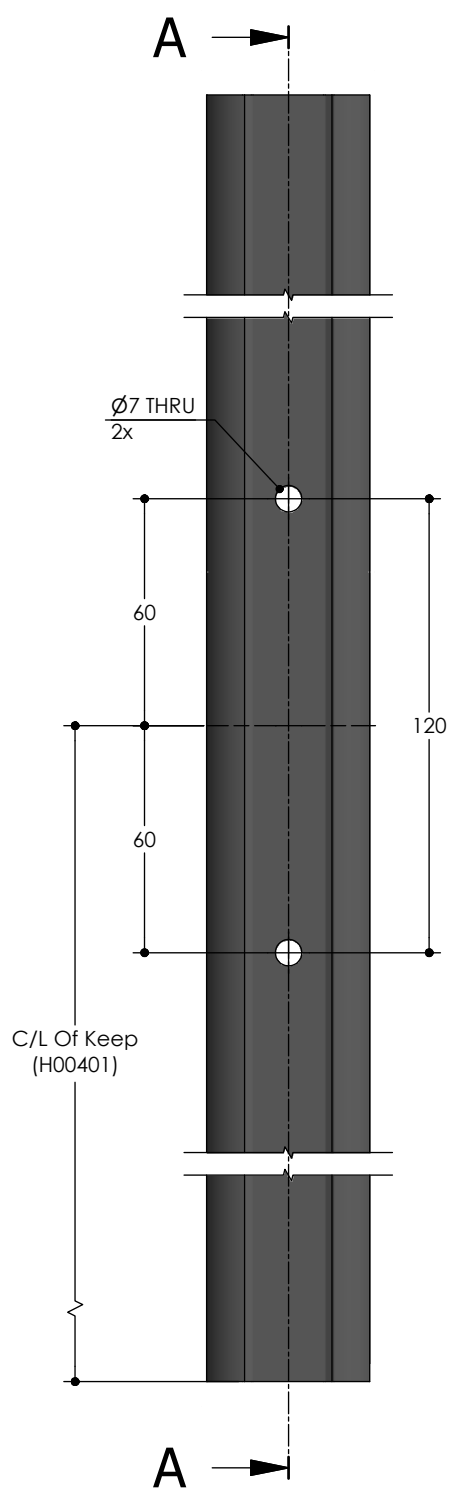
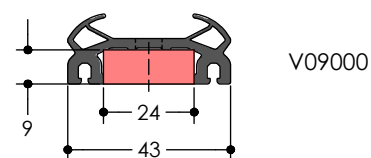
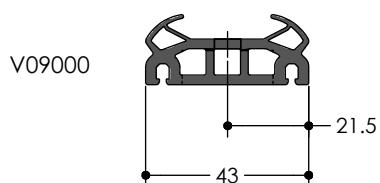
Continue Ø3mm holes at 900mm centres along full length of N00653



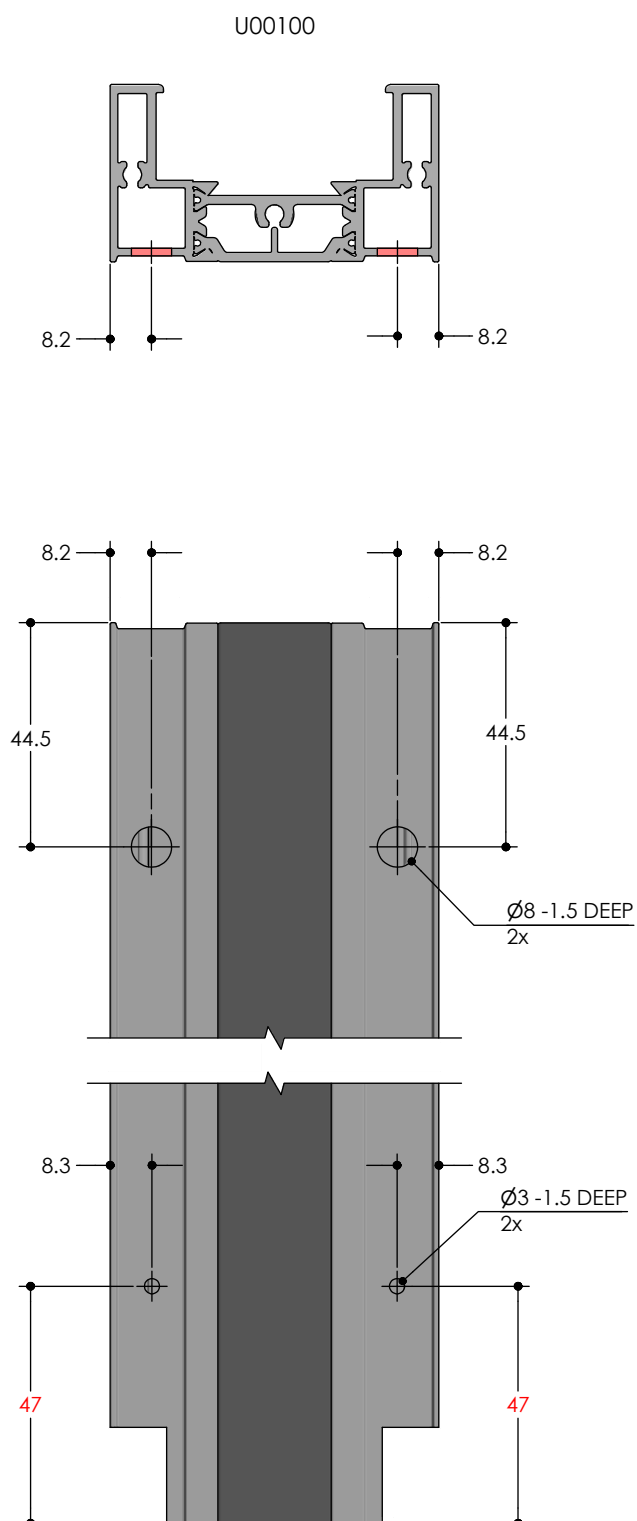
$$*L = \text{OUTER FRAME L} - 33.6$$



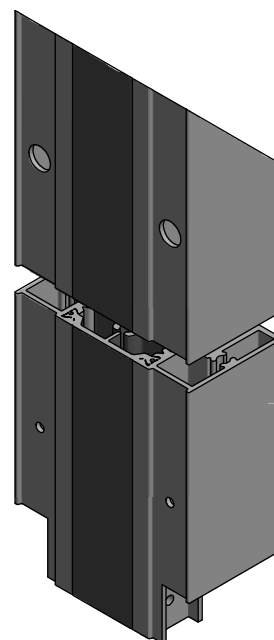
➤ V09000 - KEEP CUT OUT



➤ U00100 - HEAD/CILL CLEAT MACHINING



When using N00124 interlock
dimension equals 57mm.

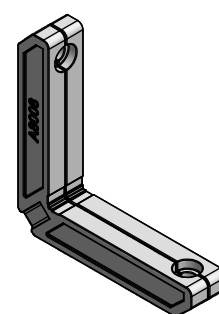


* ALUK FR/GBR CODE: 27500
** ALUK FR/GBR CODE: 86720

Use cleat and screw ref:



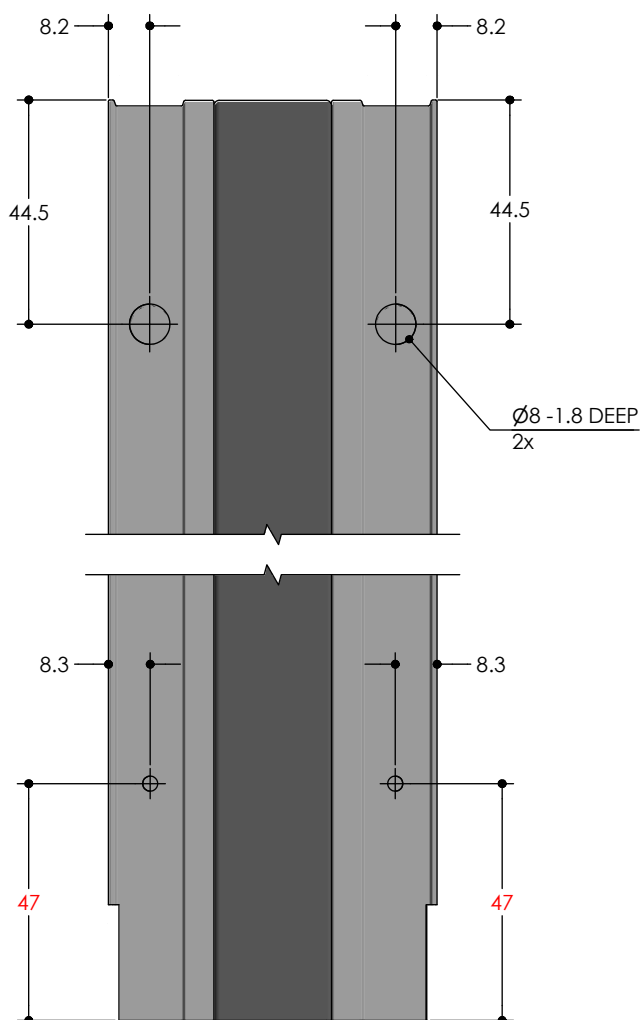
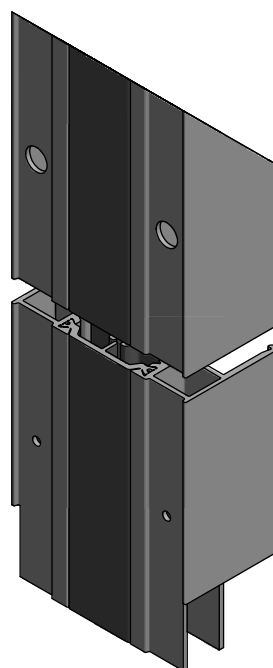
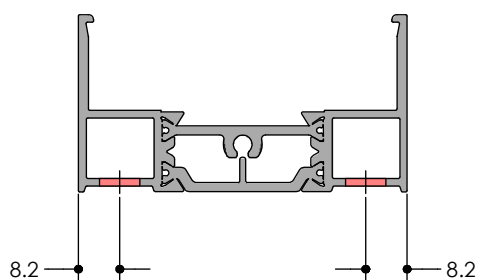
V70000*
x4 Per Corner



V42000*
x2 Per Corner

➤ U00102 - HEAD/CILL CLEAT MACHINING

U00102

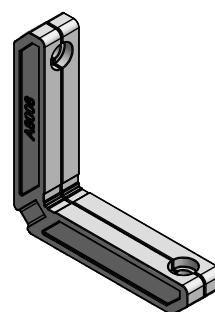


* ALUK FR/GBR CODE: 27500
** ALUK FR/GBR CODE: 86720

Use cleat and screw ref:



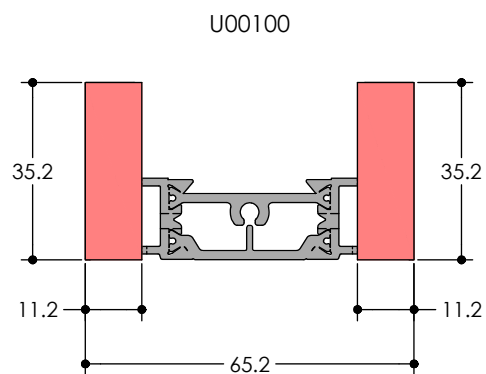
V70000*
x4 Per Corner



V42000*
x2 Per Corner

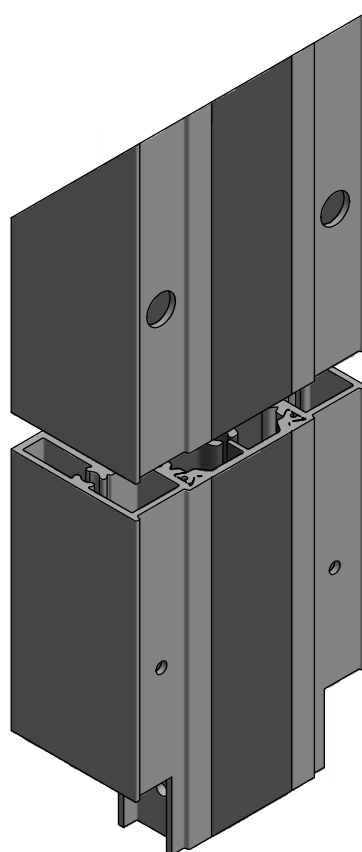
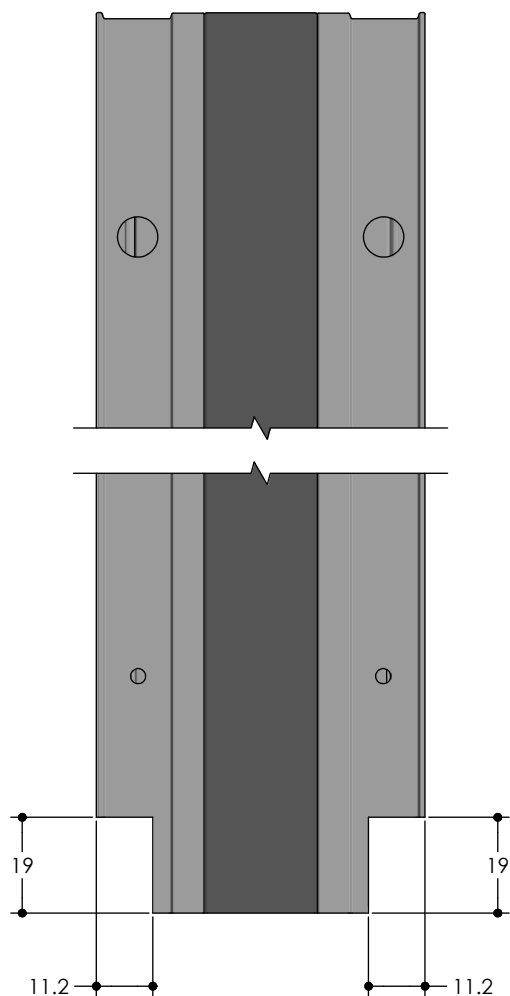
When using N00125 interlock
dimension equals 57mm

➤ U00100 - HEAD/CILL END MILLING



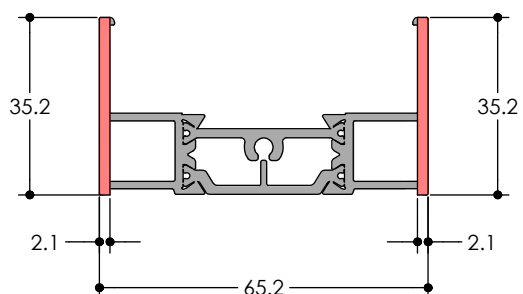
NOTE:

Mill on end of the head and cill section to fit into the interlock.



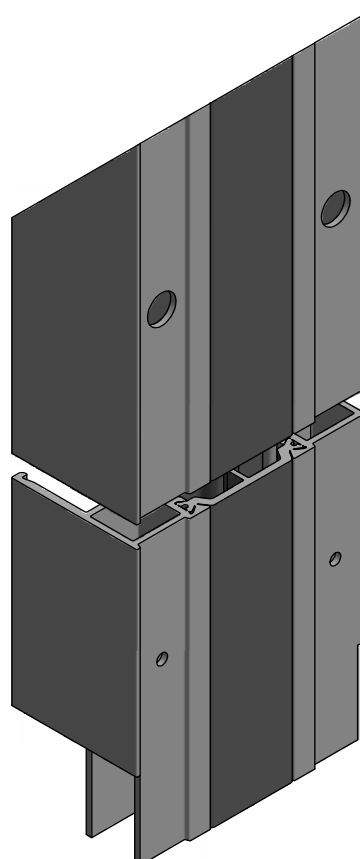
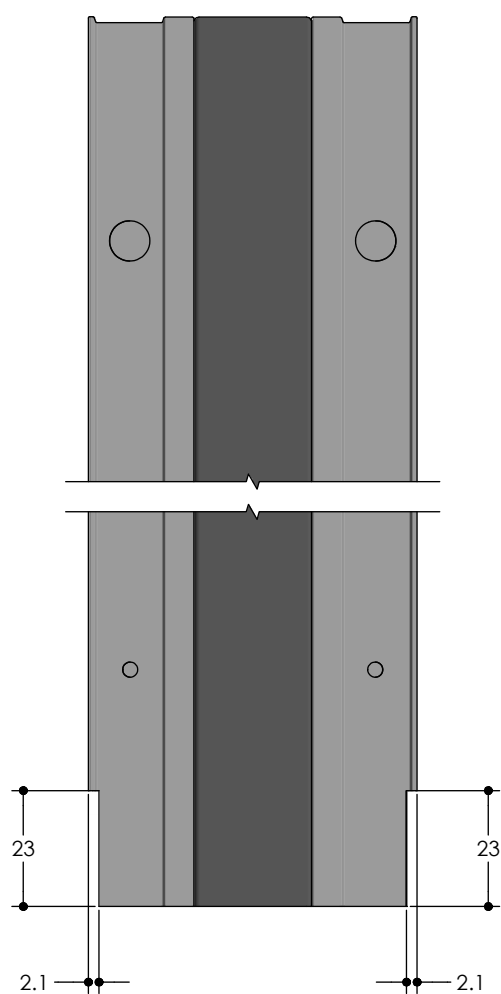
➤ U00102 - HEAD/CILL END MILLING

U00102

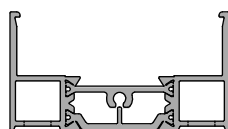
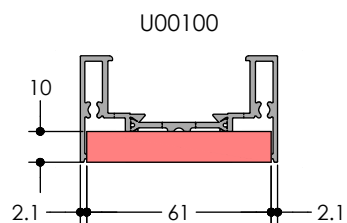


NOTE:

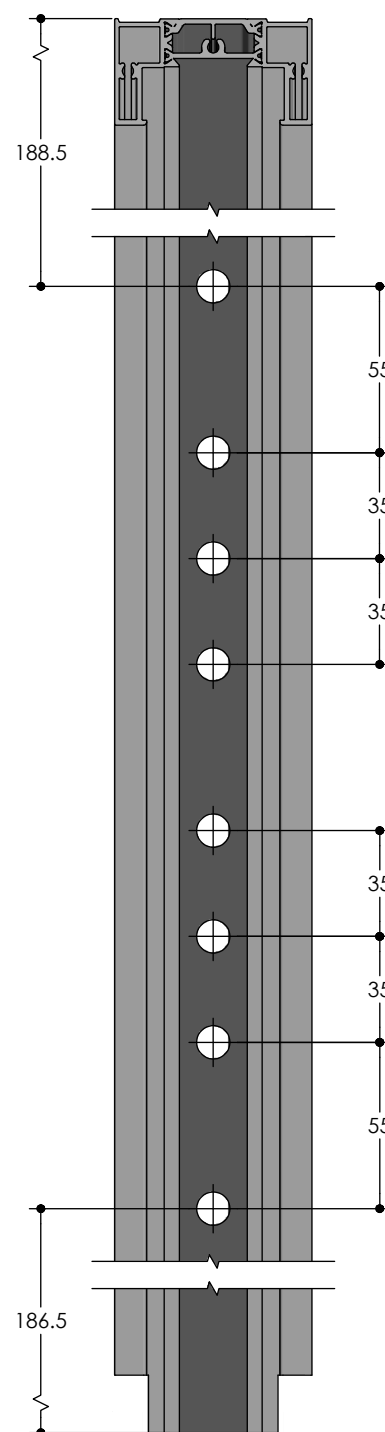
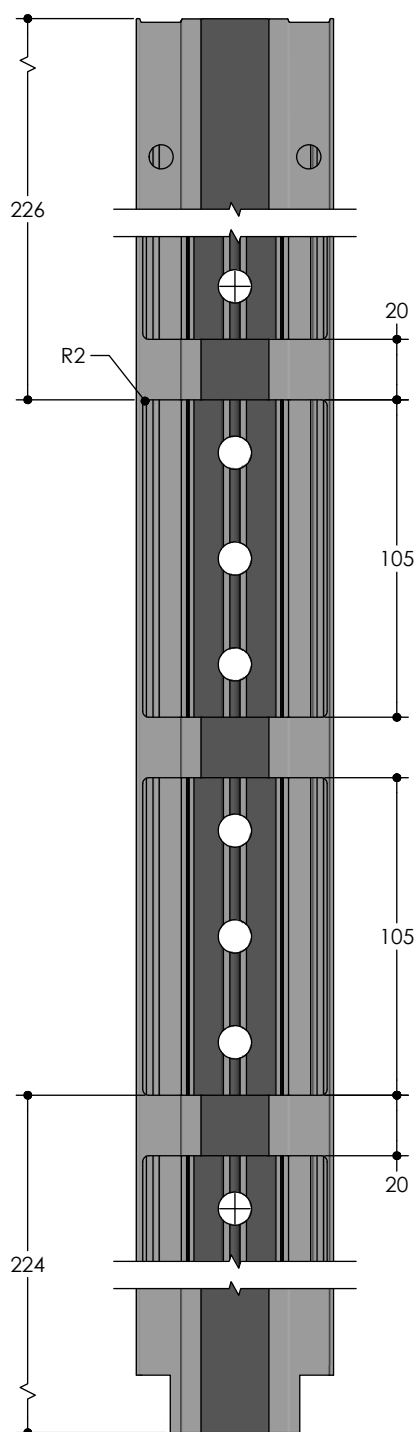
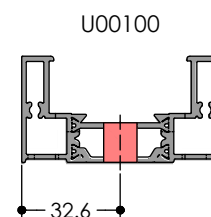
Mill on end of the head and cill section to fit into the interlock.



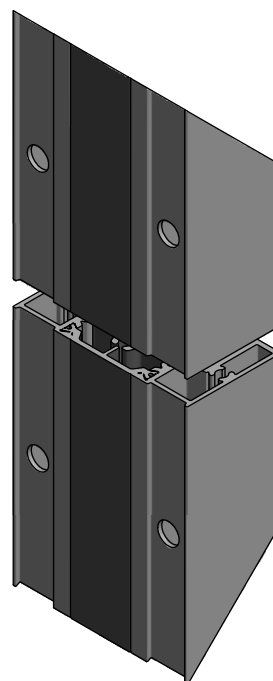
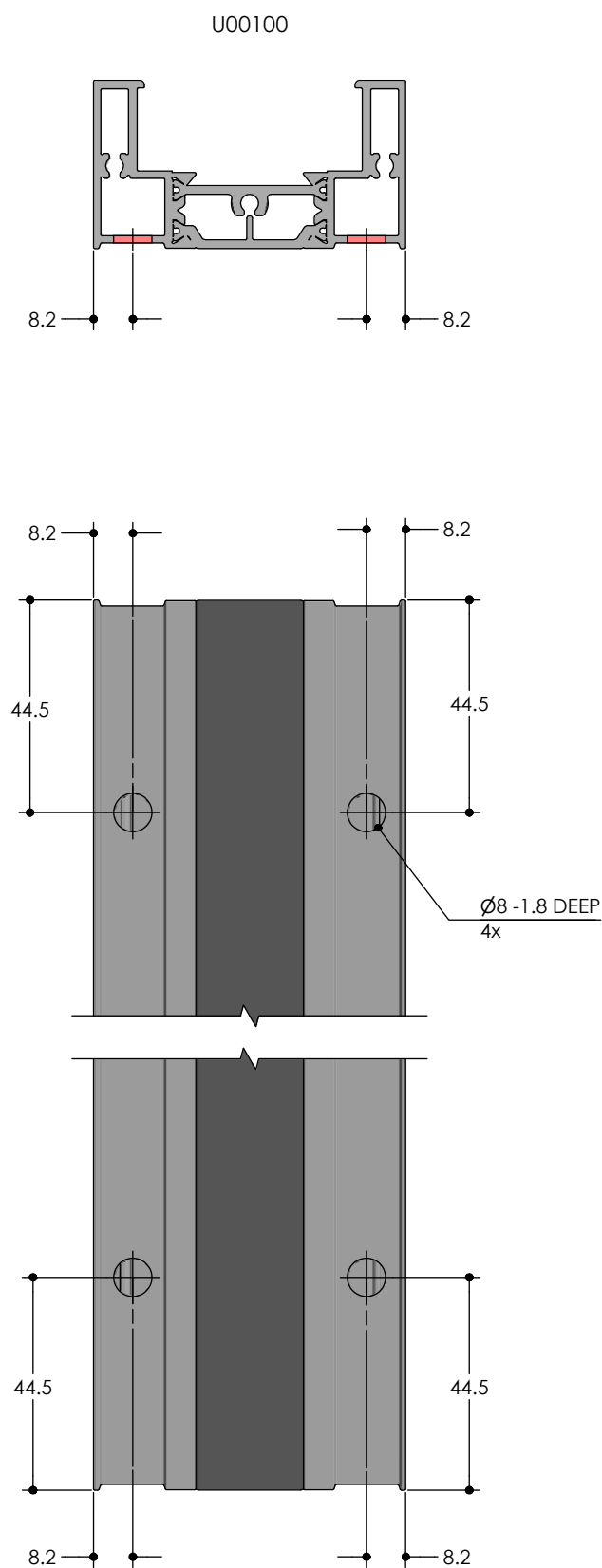
➤ U00100 - 4 ROLLERS (H00200 & V62000)



Also applicable to U00102



➤ U00100 - JAMB CLEAT MACHINING

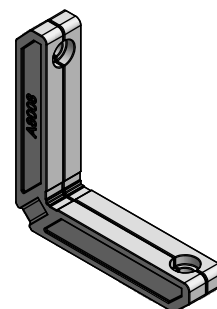


* ALUK FR/GBR CODE: 27500
 ** ALUK FR/GBR CODE: 86720

Use cleat and screw ref:



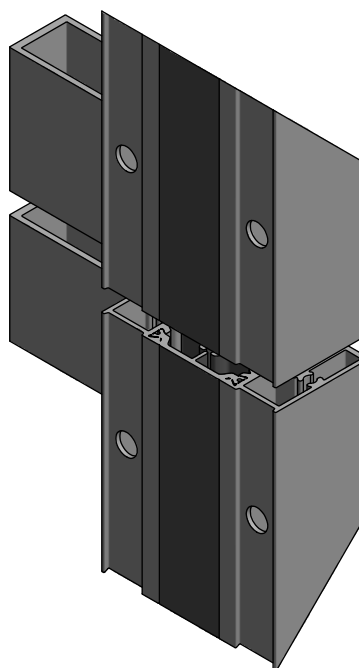
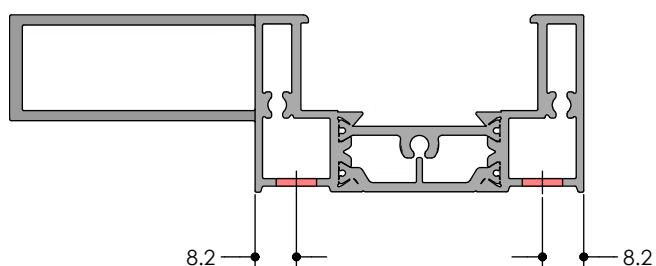
V70000**
 x4 Per Corner



V42000*
 x2 Per Corner

➤ U00101, U00103 - MECHANICAL CLEAT

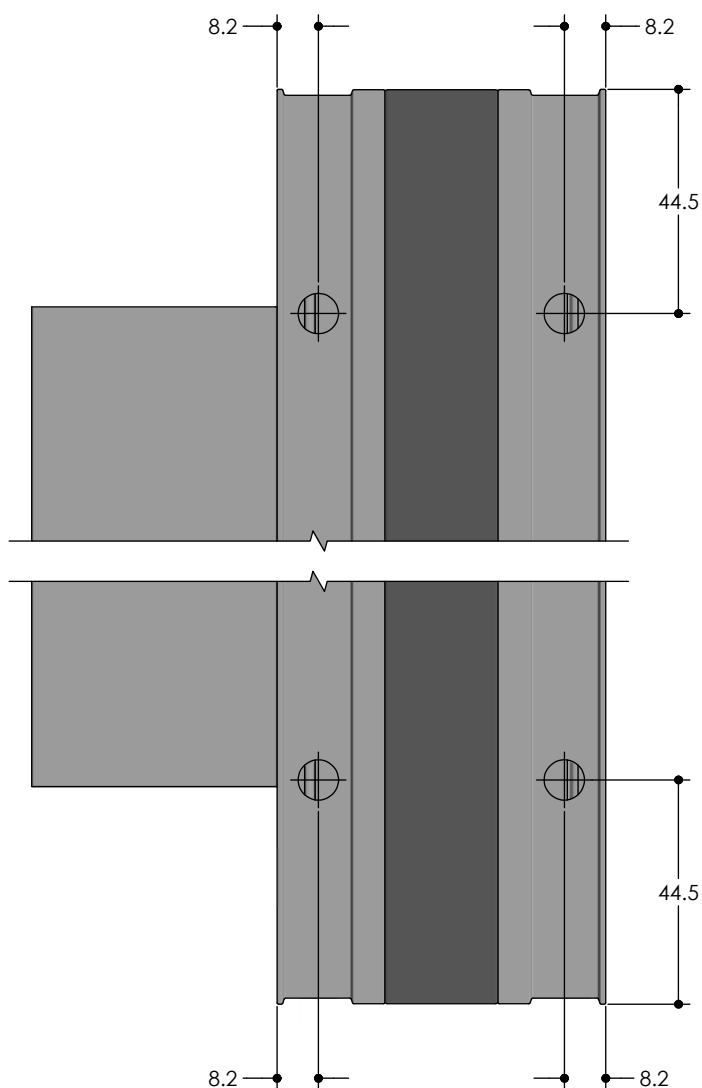
U00101



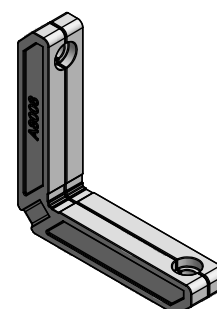
Also applicable to U00103

* ALUK FR/GBR CODE: 27500
** ALUK FR/GBR CODE: 86720

Use cleat and screw ref:

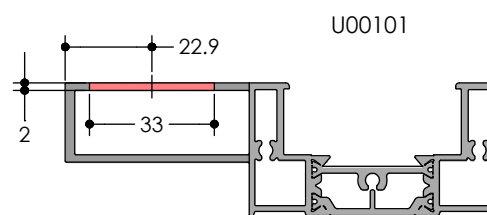
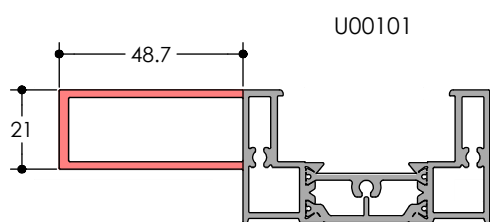


V70000**
x4 Per Corner

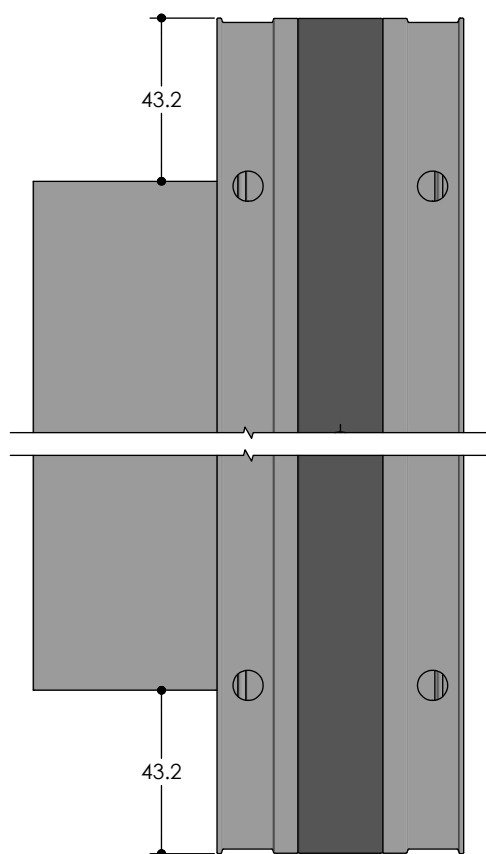


V42000*
x2 Per Corner

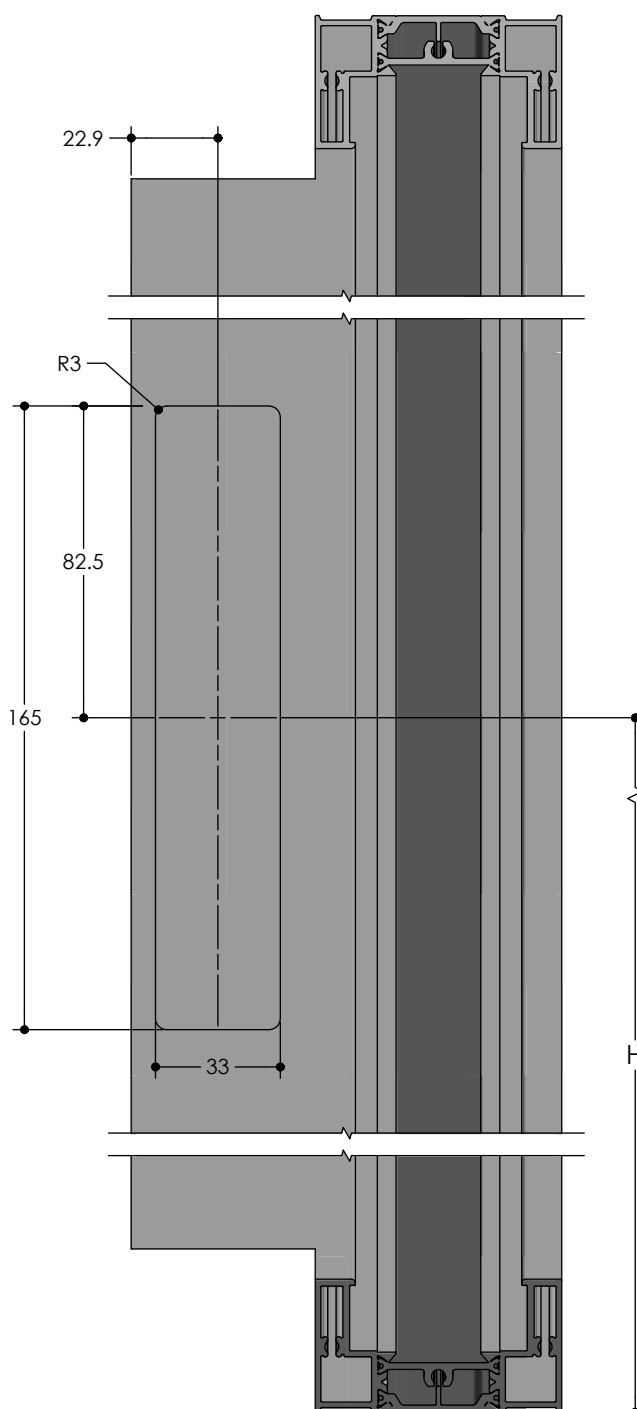
➤ U00101, U00103 - HANDLE PREP. (H00405 & H00412)



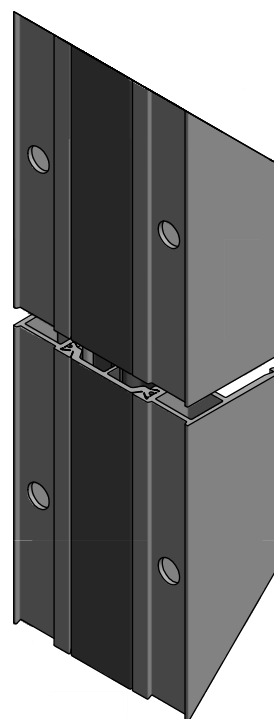
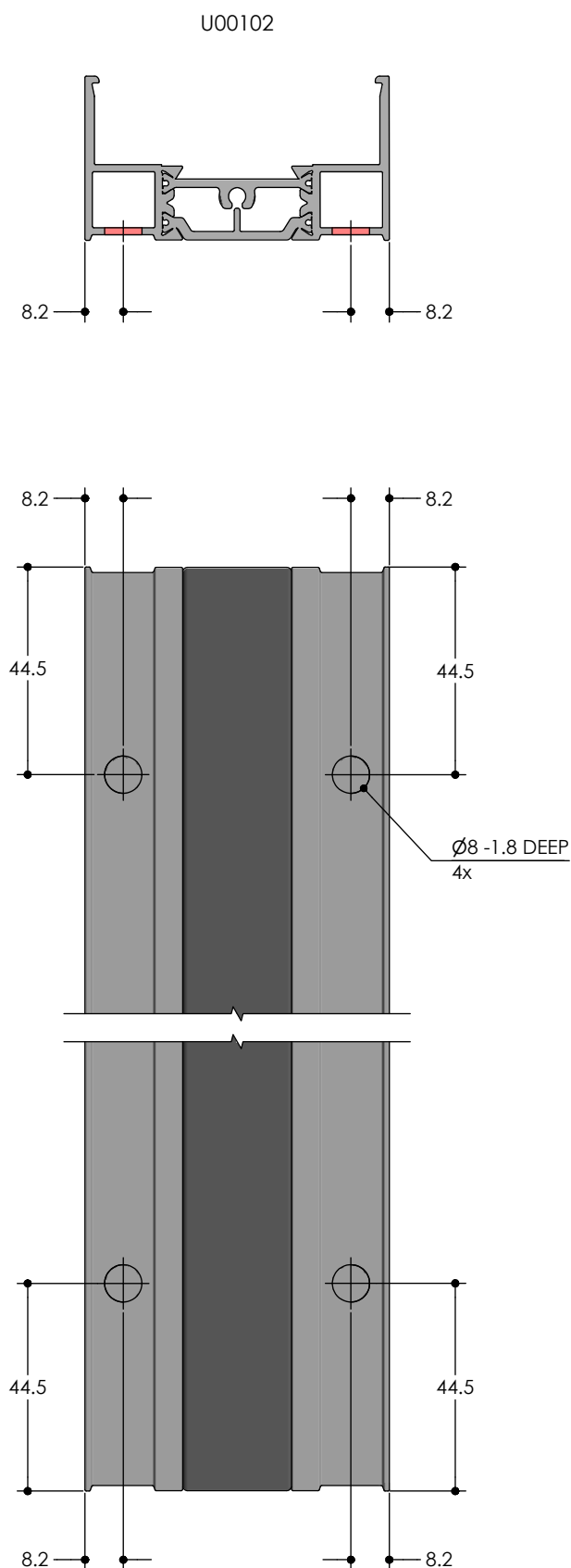
H = Handle height C/L



Also applicable to U00103



➤ U00101 - JAMB CLEAT MACHINING

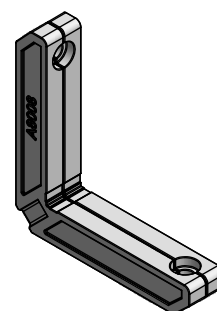


* ALUK FR/GBR CODE: 27500
** ALUK FR/GBR CODE: 86720

Use cleat and screw ref:



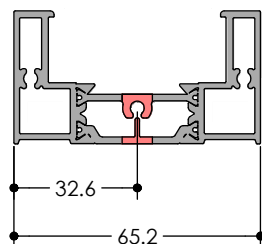
V70000**
x4 Per Corner



V42000*
x2 Per Corner

➤ U00100 - DRAINAGE HOLES

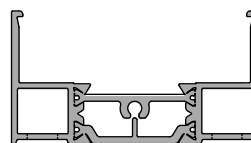
U00100



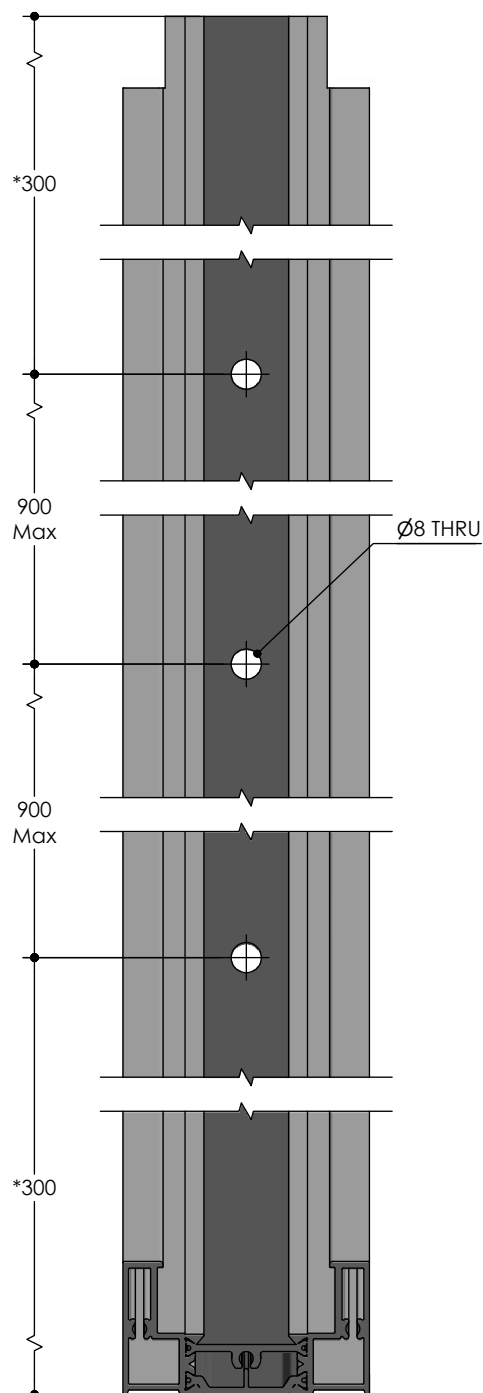
NOTE:

Continue @ 900mm centres on bottom profile only.

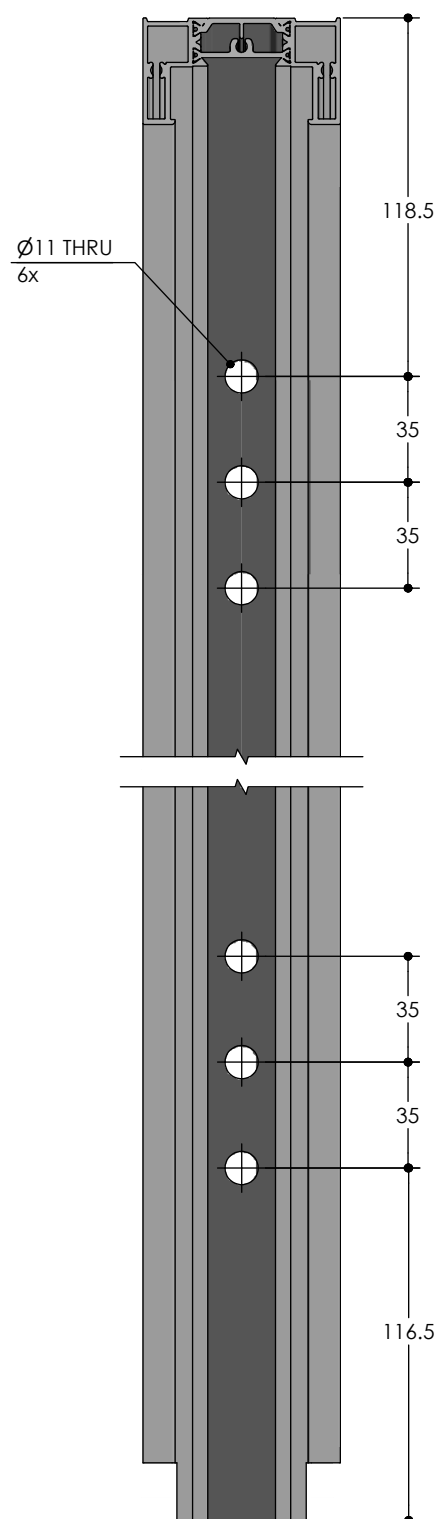
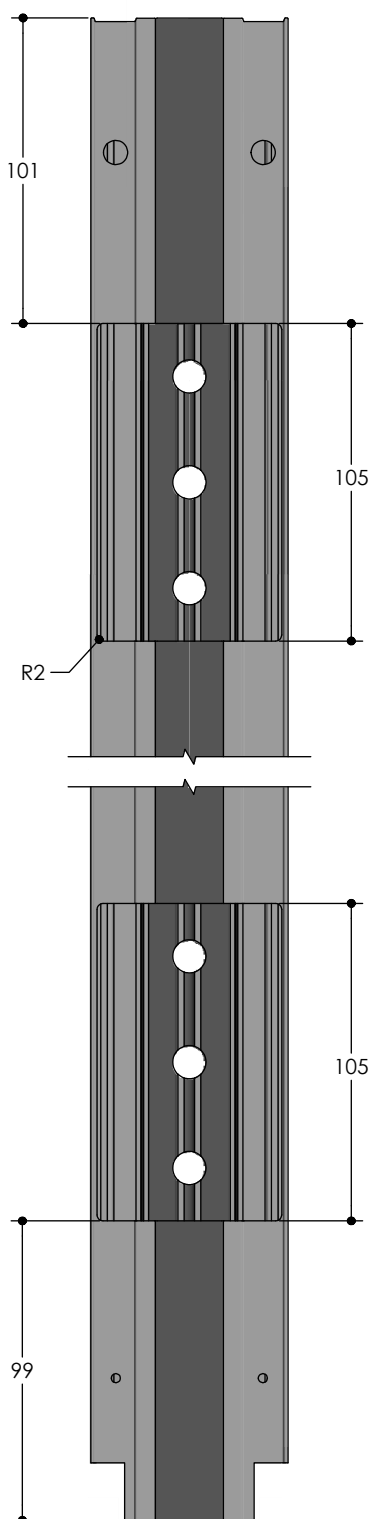
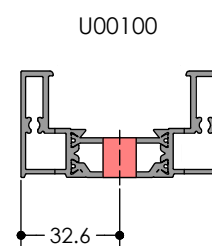
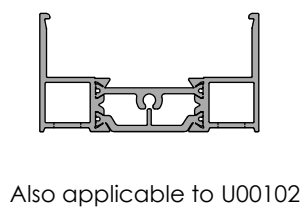
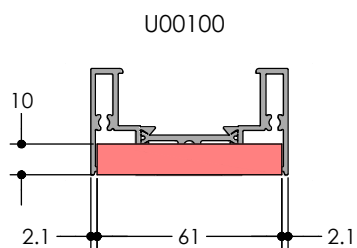
* When using 4 rollers position at 400mm from each end.



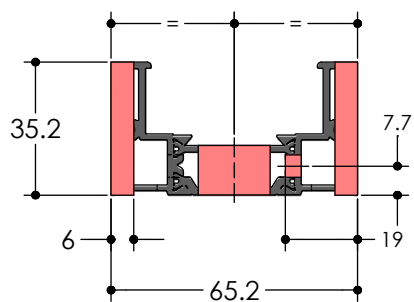
Also applicable to U00102



➤ U00100 - 2 ROLLERS (H00200 & V62000)



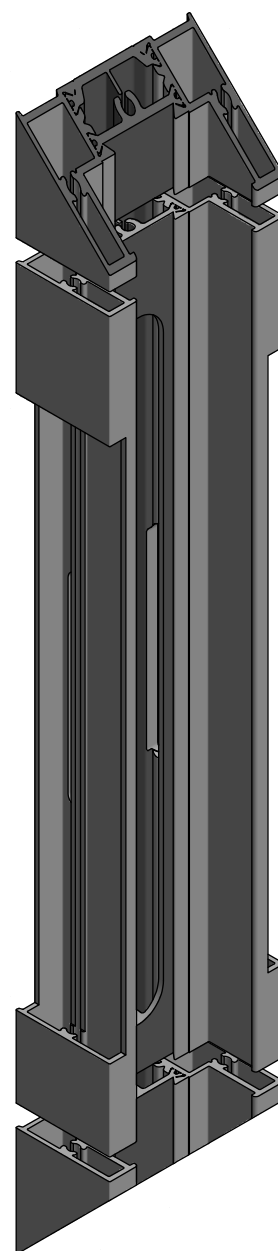
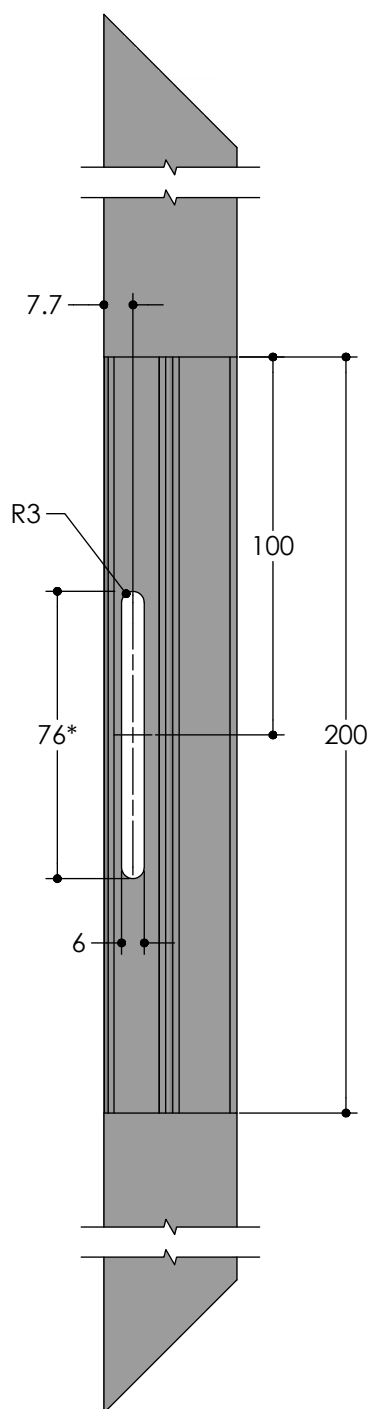
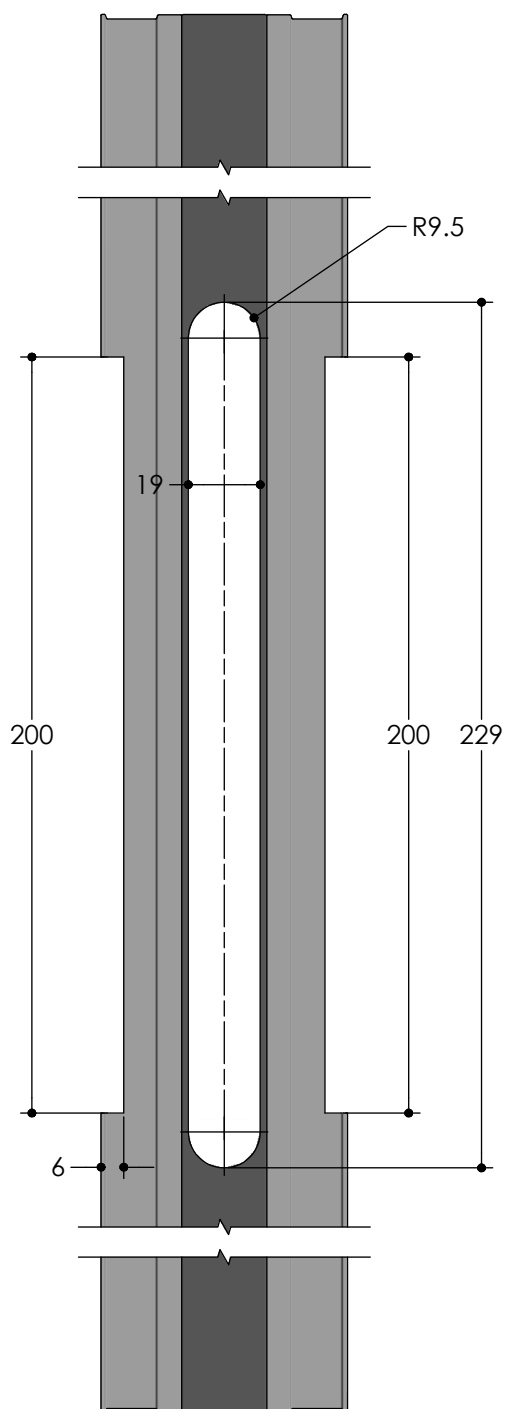
➤ U00100 - LOCK & HANDLE MACHINING



NOTE:

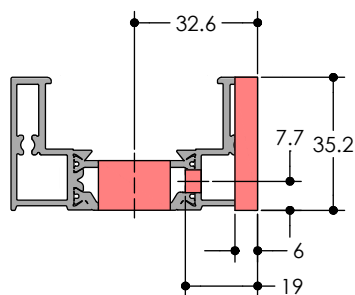
Machining for lock (H00400), Lever (H00404), Internal handle (H00100) and external handle (H00101).

INTERNAL SIDE



* Slot depth 4.3mm

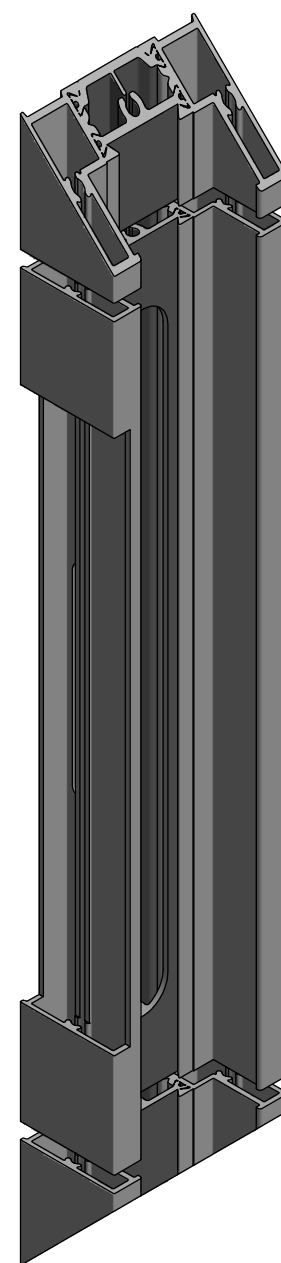
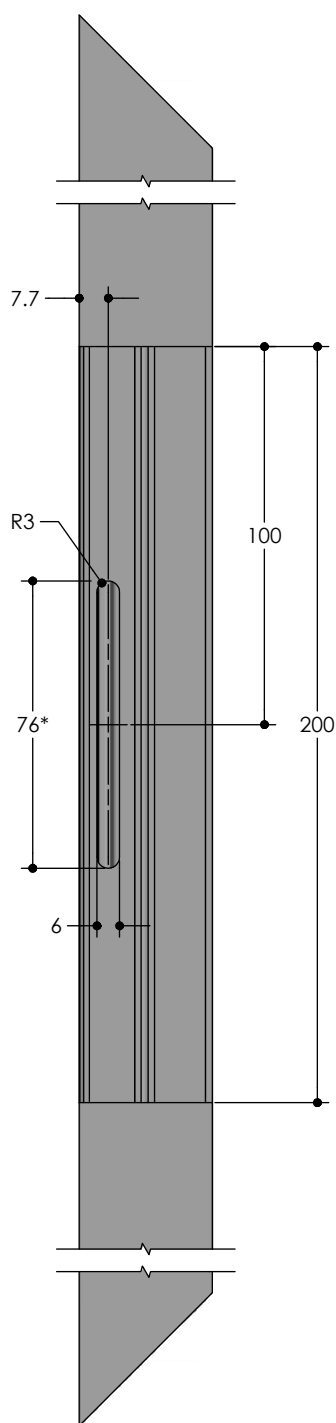
➤ U00100 - LOCK & SINGLE HANDLE MACHINING



NOTE:

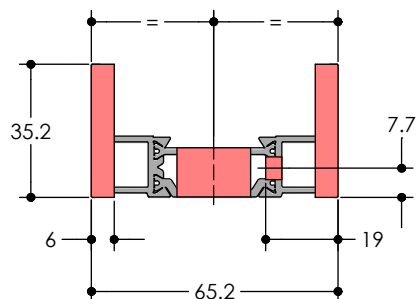
Machining for lock (H00400), Lever (H00404), Internal handle (H00100) ONLY.

INTERNAL SIDE



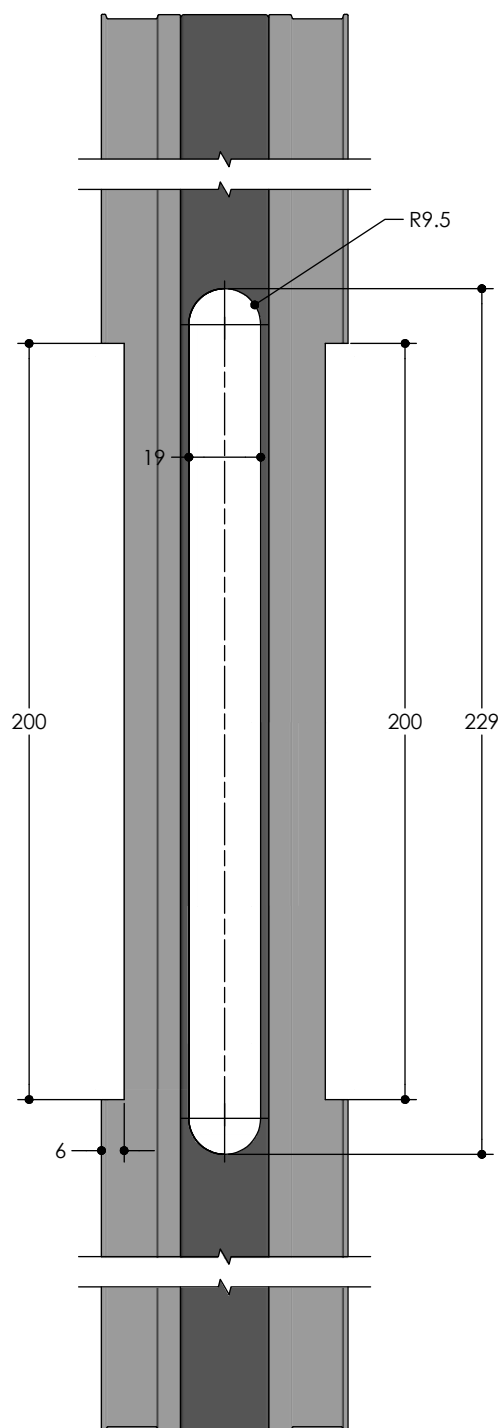
* Slot depth 4.3mm

➤ U00102 - LOCK & HANDLE MACHINING

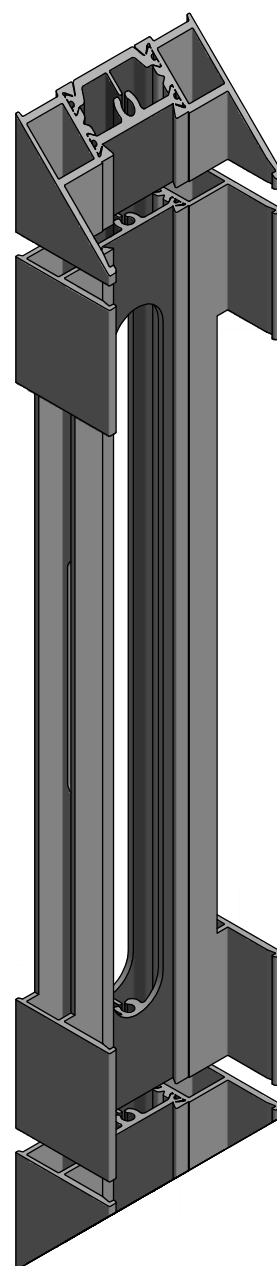
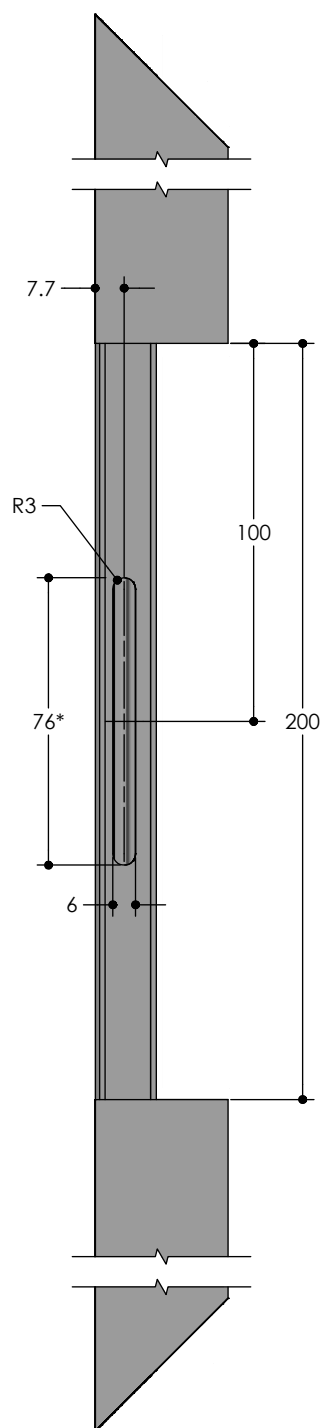


NOTE:

Machining for lock (H00400), Lever (H00404), Internal handle (H00100) and external handle (H00101).

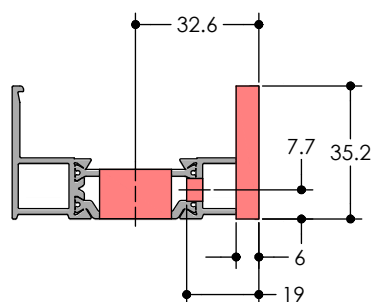


INTERNAL SIDE



* Slot depth 4.3mm

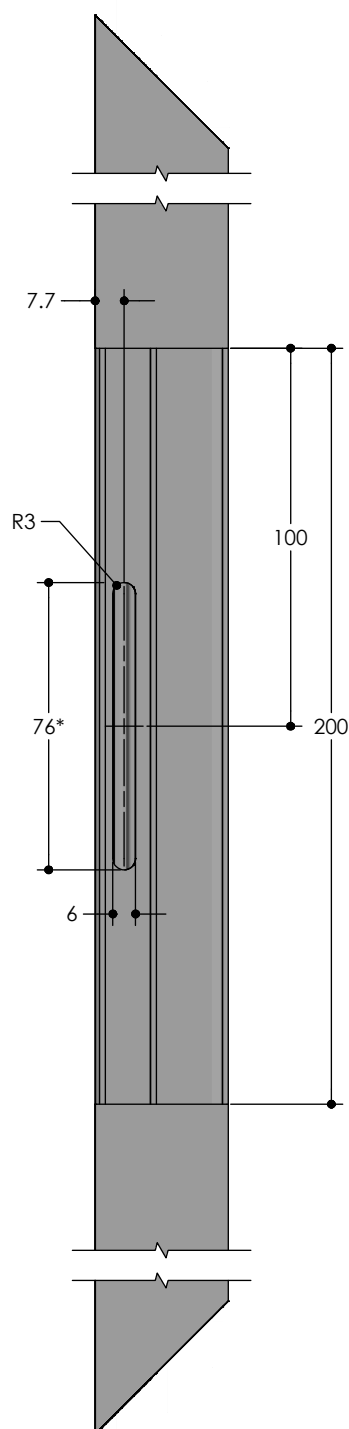
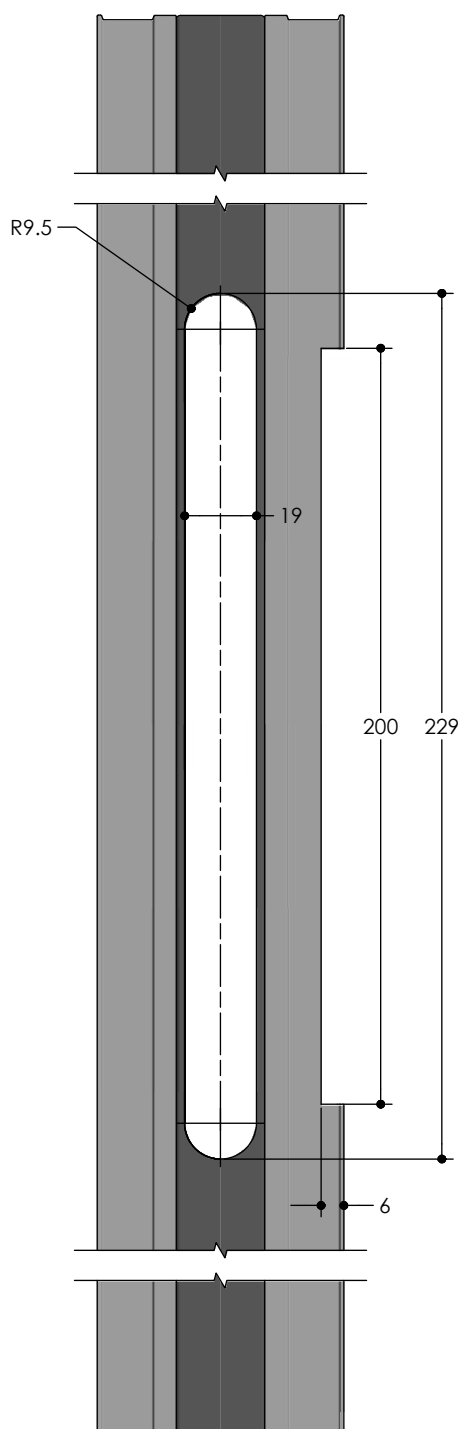
➤ U00102 - LOCK & SINGLE HANDLE MACHINING



NOTE:

Machining for lock (H00400), Lever (H00404), Internal handle (H00100) ONLY.

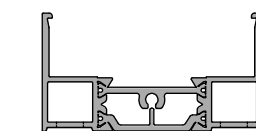
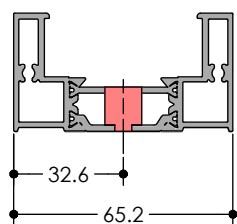
INTERNAL SIDE



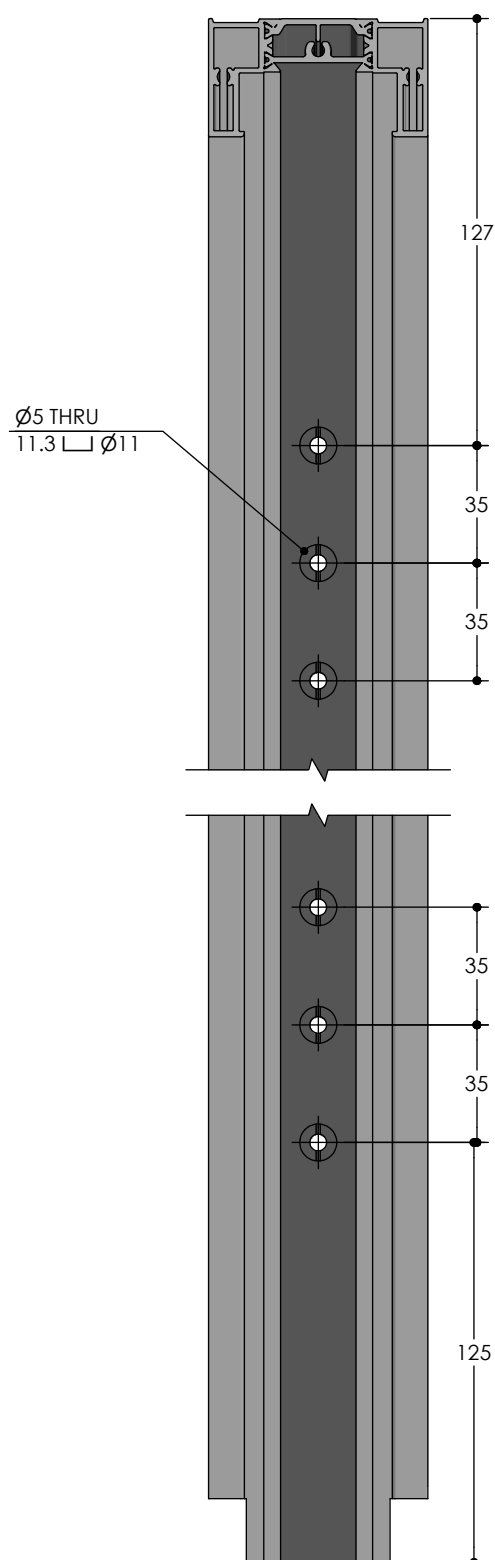
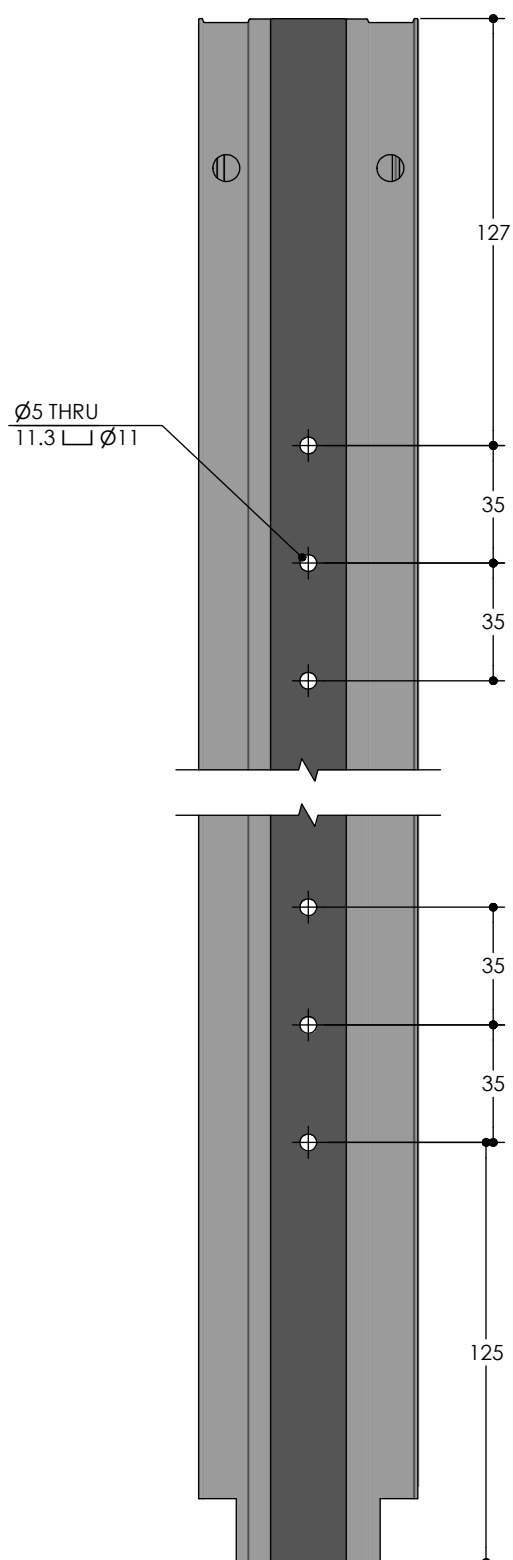
* Slot depth 4.3mm

➤ U00100 - FIXED PANEL SUPPORT BLOCKS

U00020

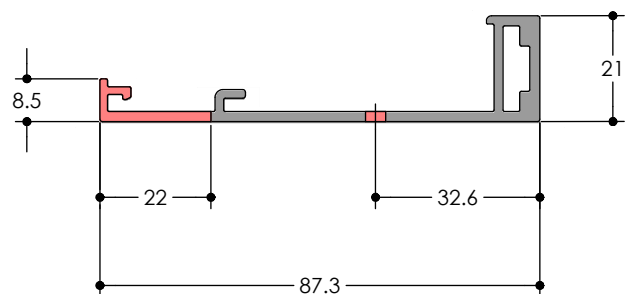


Also applicable to U00102



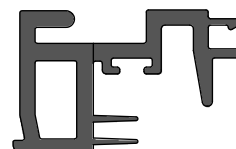
➤ N00120 - STANDARD INTERLOCK

N00120

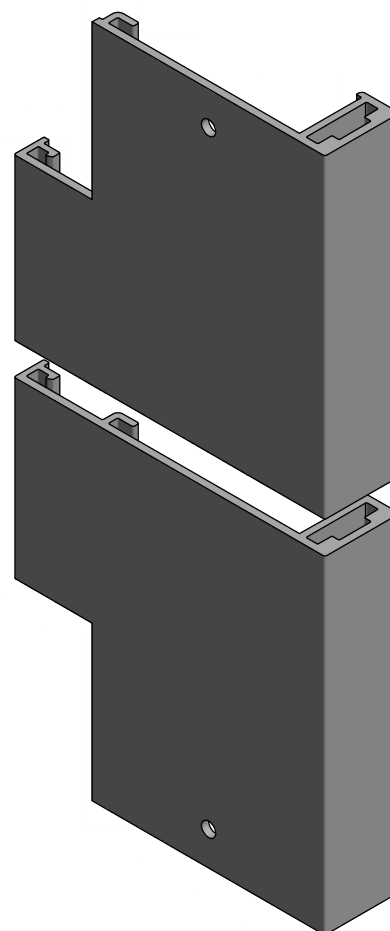
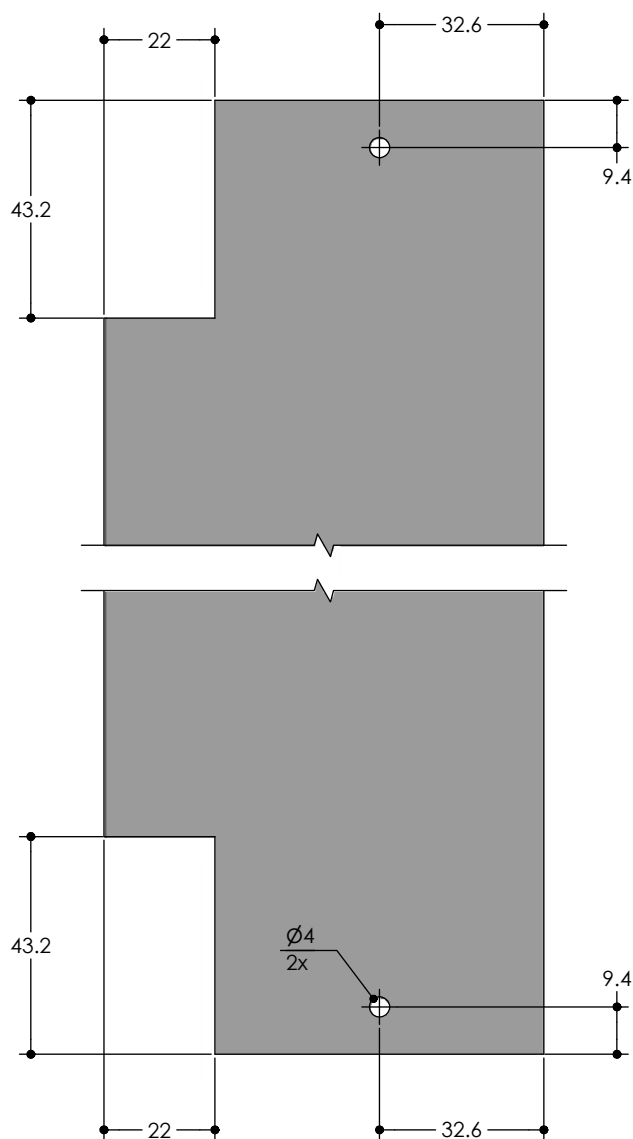


NOTE:

Insert V31000 (PVC Interlock) into N00120 before machining together.

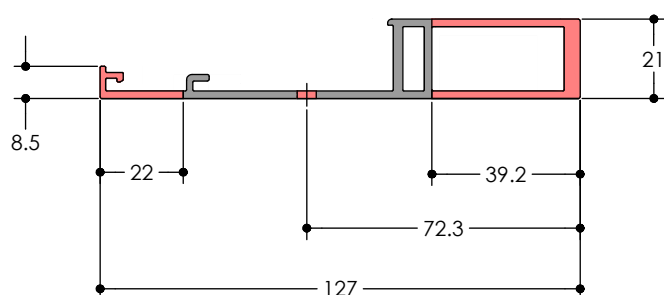


V31000



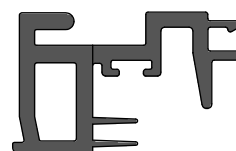
➤ N00121 - REINFORCED INTERLOCK

N00121

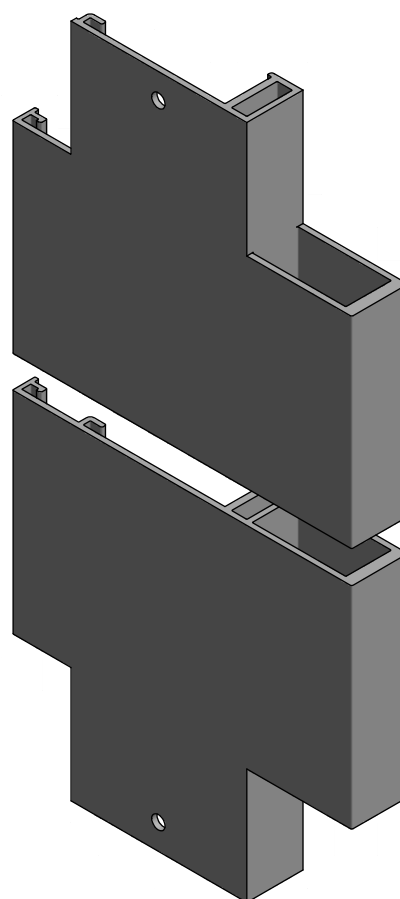
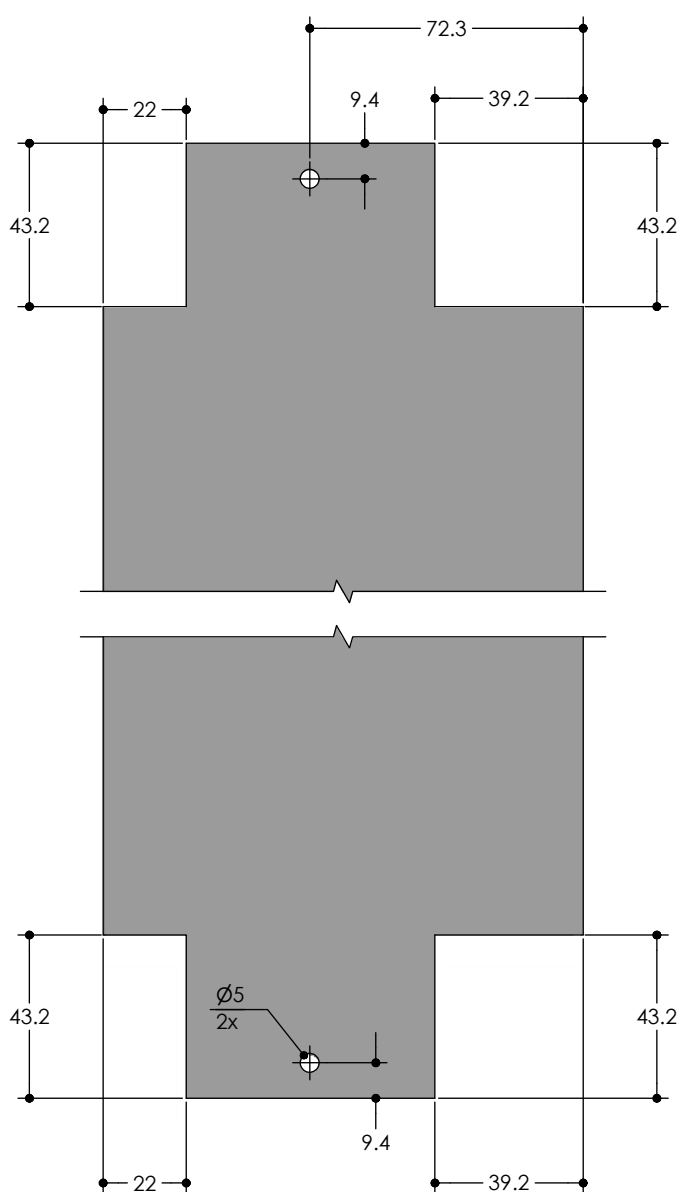


NOTE:

Insert V31000 (PVC Interlock) into N00121 before machining together.

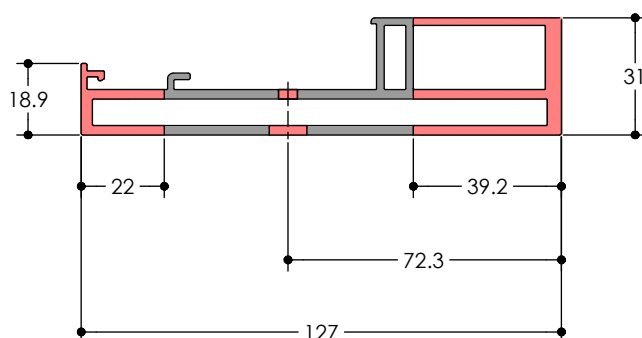


V31000



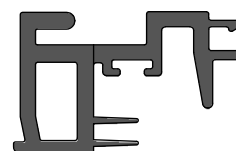
➤ N00124 - REINFORCED INTERLOCK

N00124

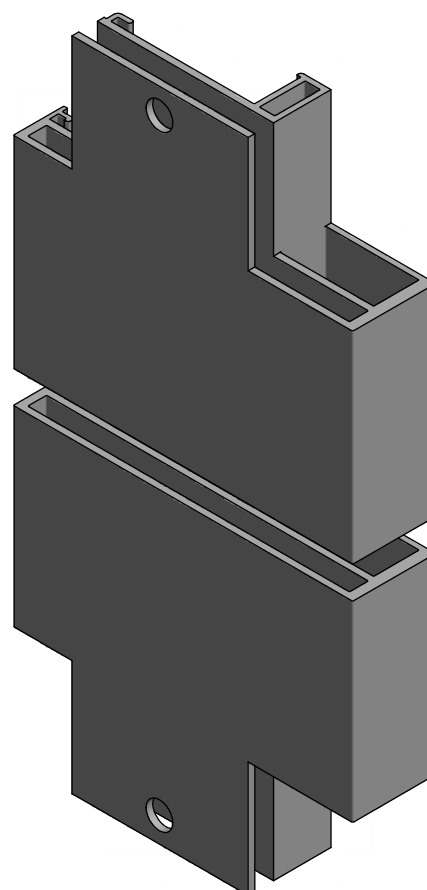
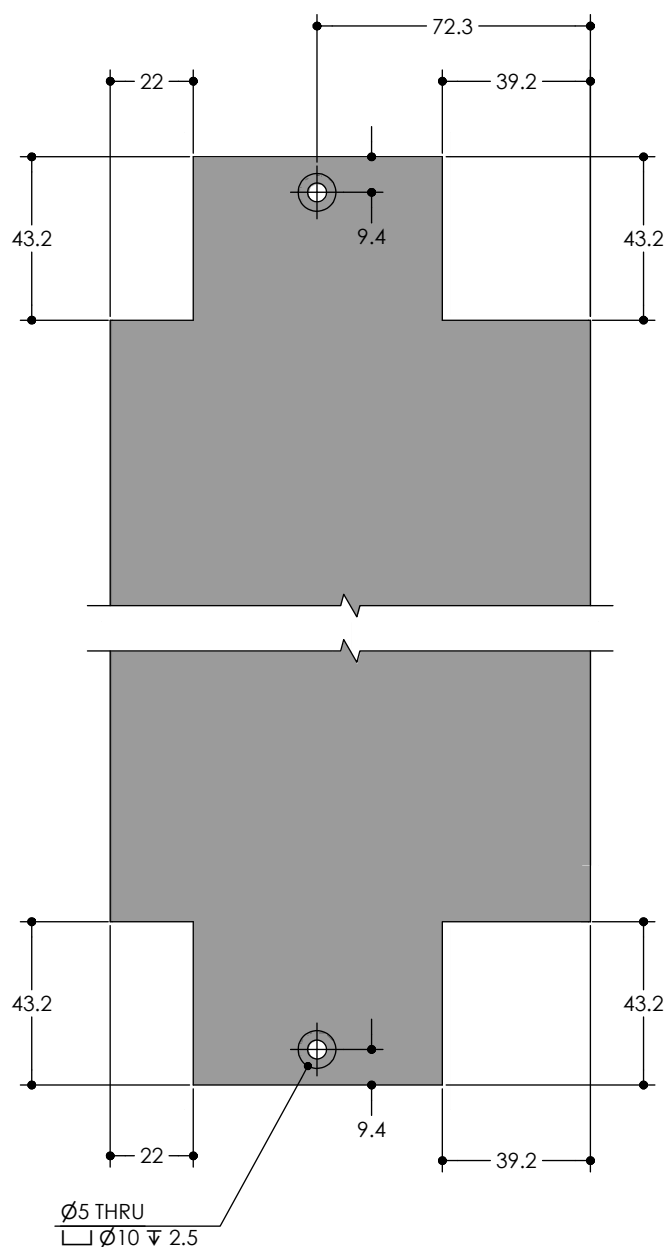


NOTE:

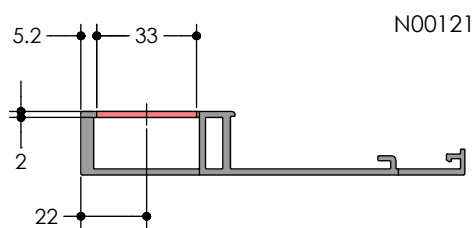
Insert V31000 (PVC Interlock) into N00124 before machining together.



V31000

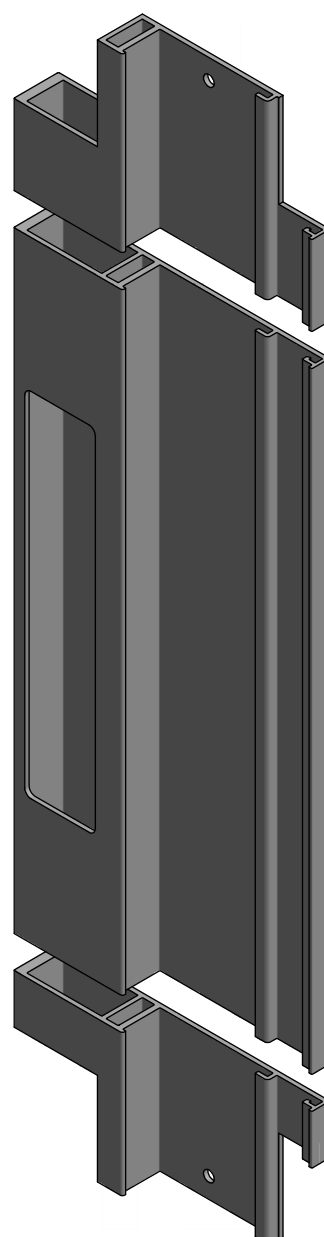
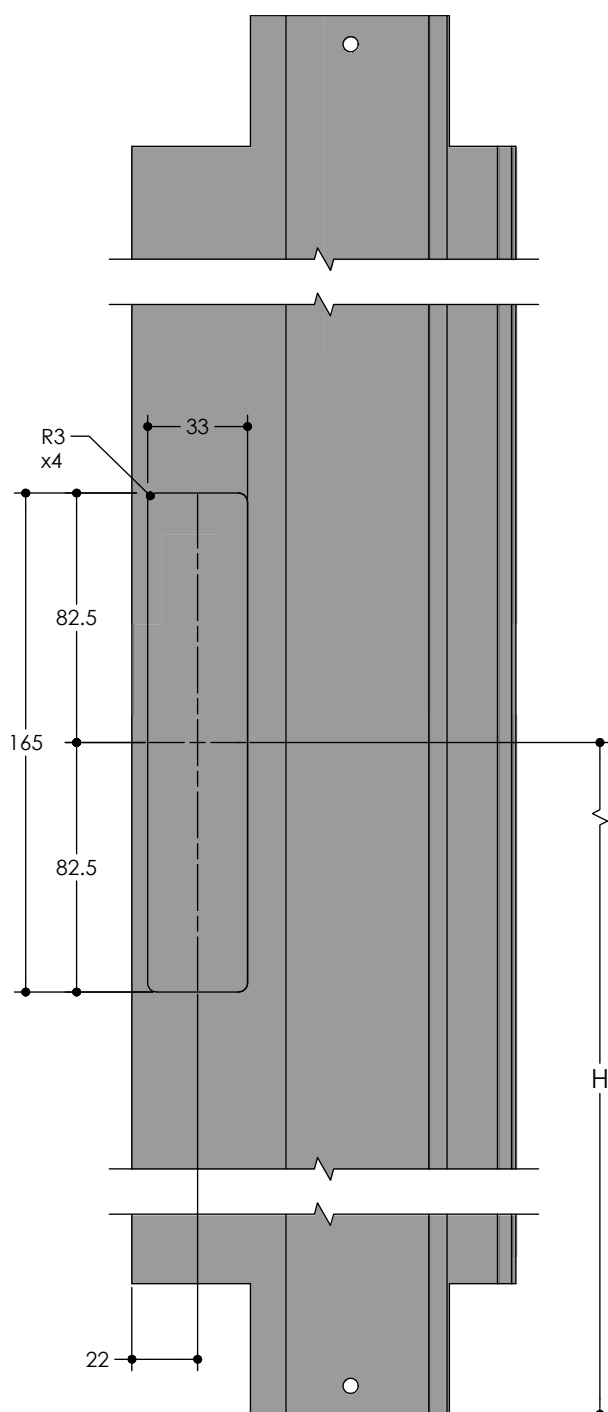
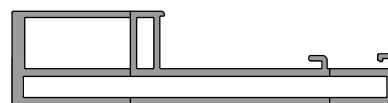


➤ N00121 - H00405 & H00412 MACHINING



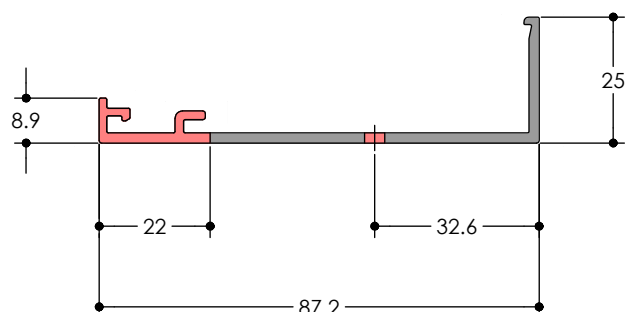
N00121

Also applicable to N00124



➤ N00122 - TG STANDARD INTERLOCK

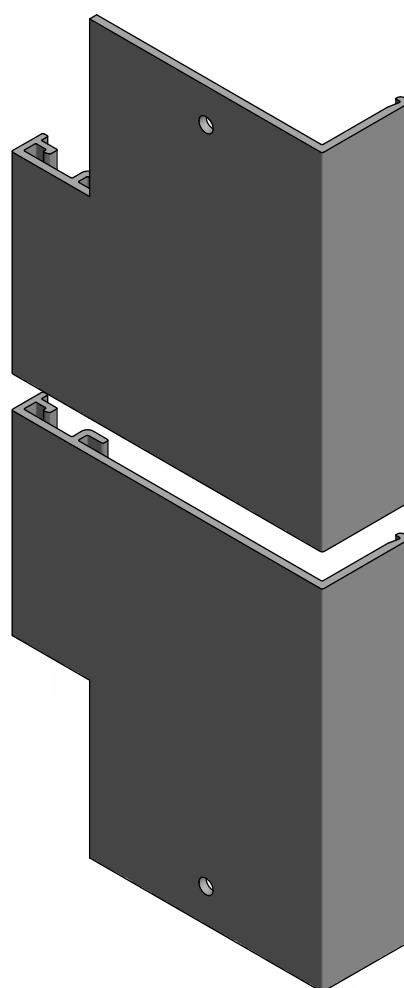
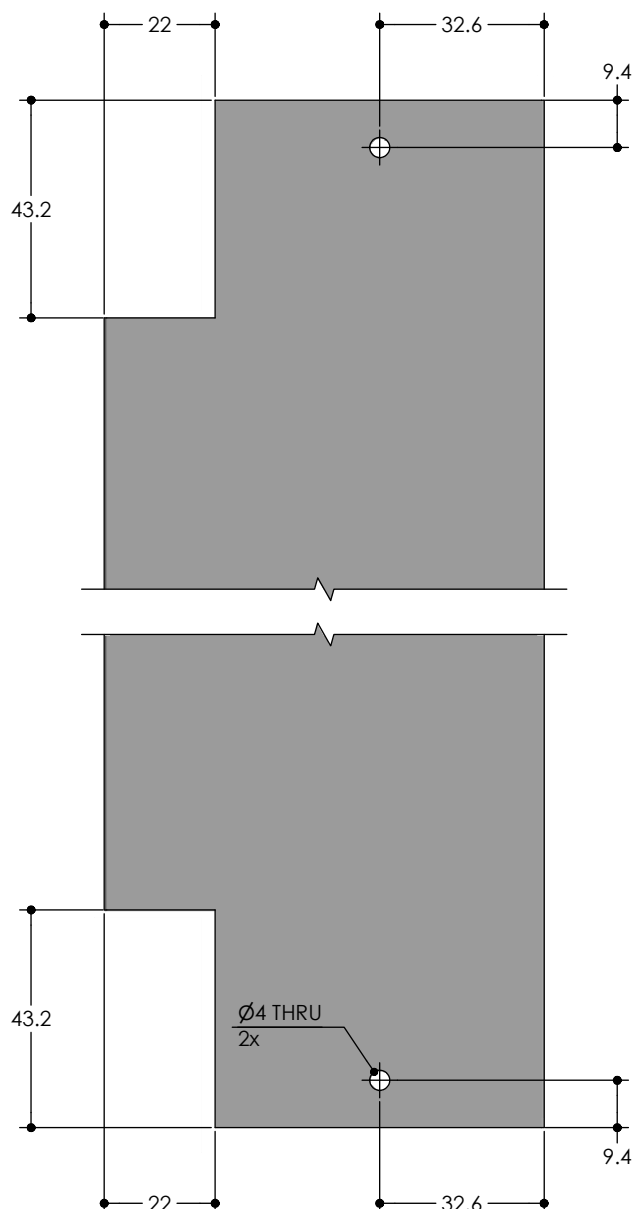
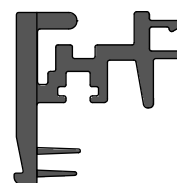
N00122



NOTE:

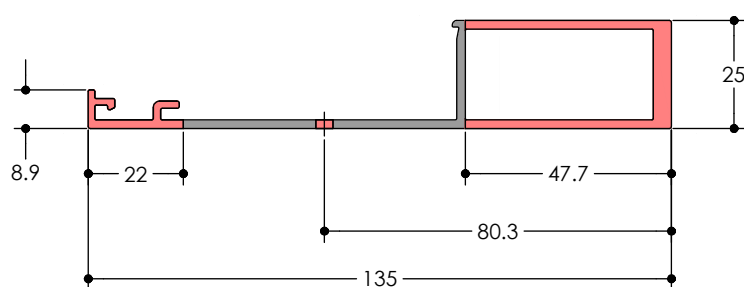
Insert V31008 (PVC Interlock) into N00122 before machining together.

V31008



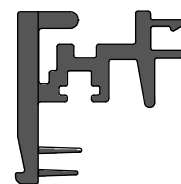
➤ N00123 - TG REINFORCED INTERLOCK

N00123

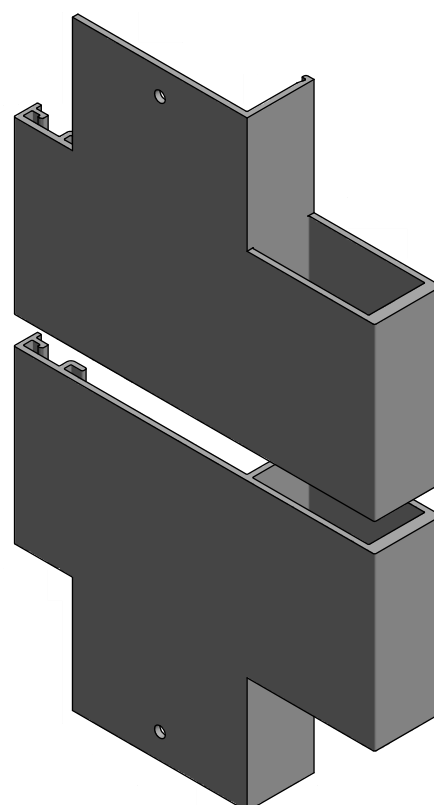
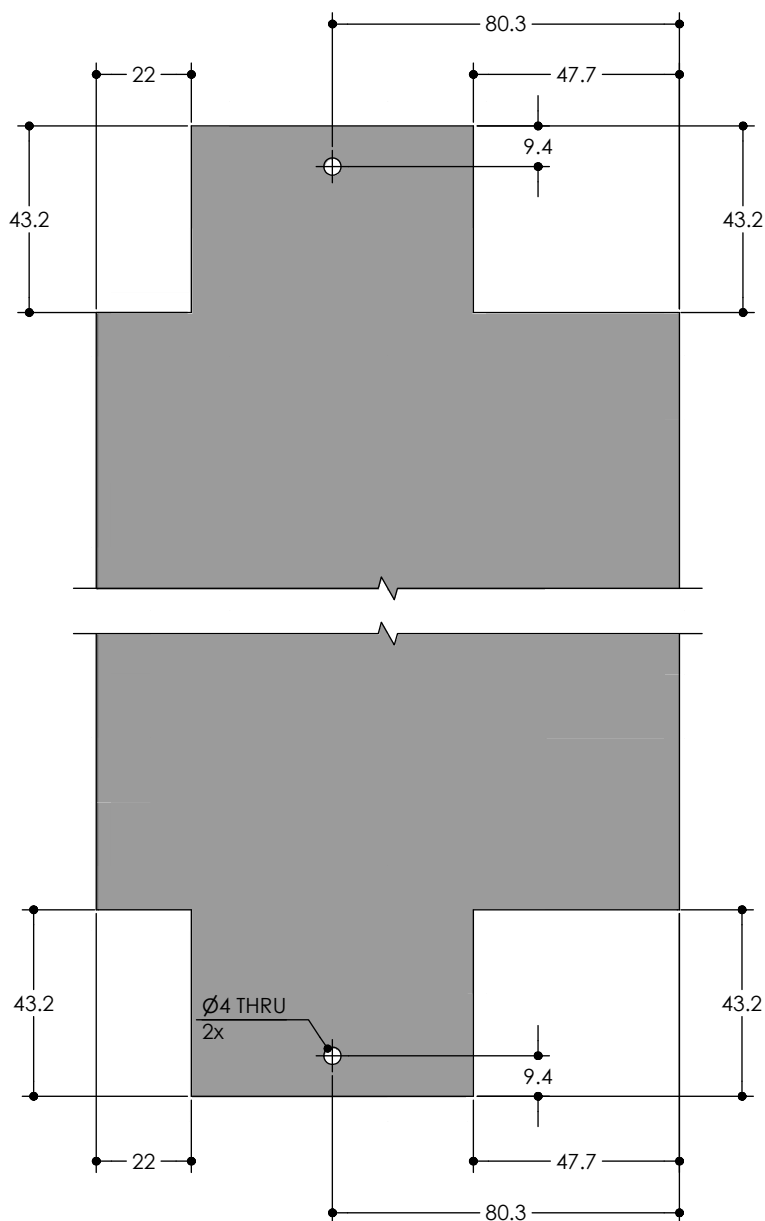


NOTE:

Insert V31008 (PVC Interlock) into N00123 before machining together.

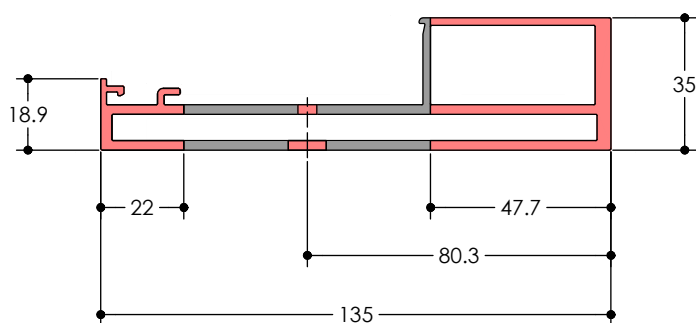


V31008



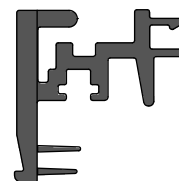
➤ N00125 - REINFORCED INTERLOCK

N00125

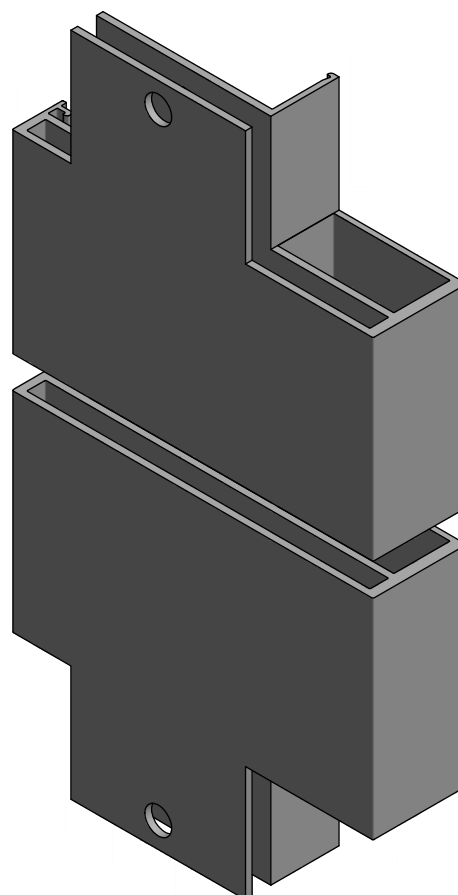
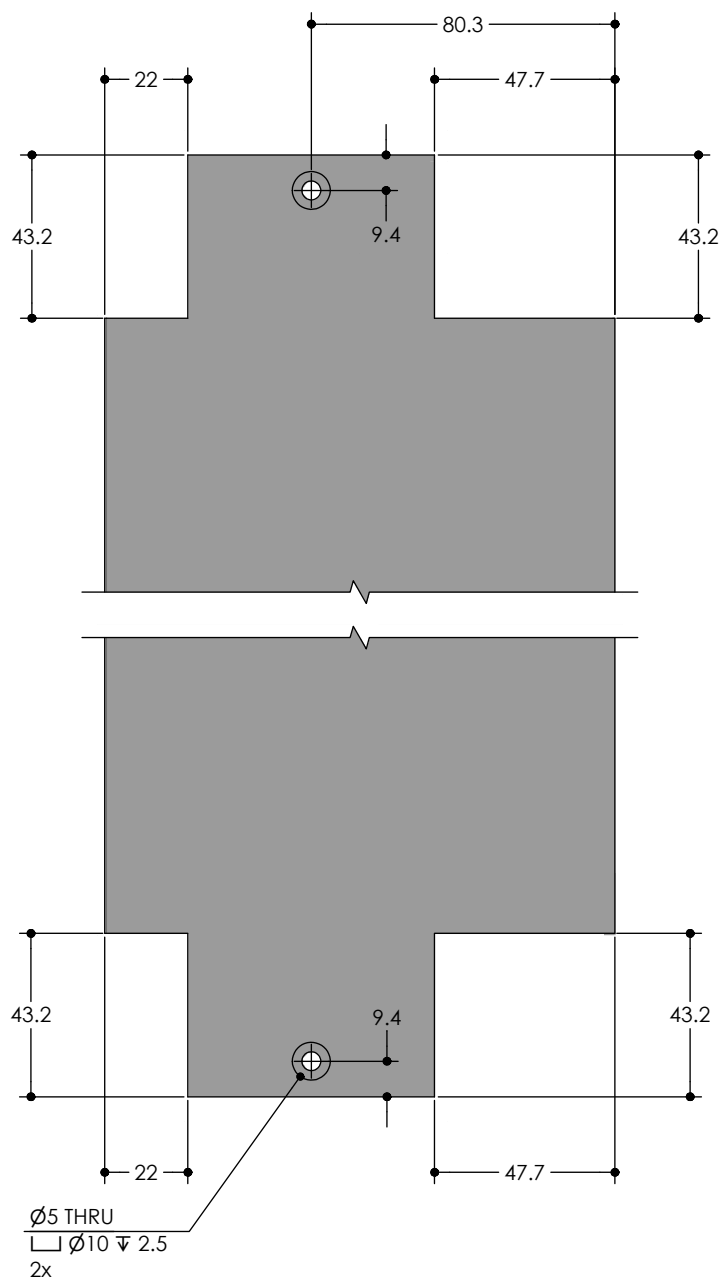


NOTE:

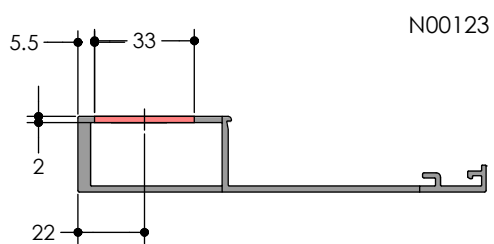
Insert V31008 (PVC Interlock) into N00125 before machining together.



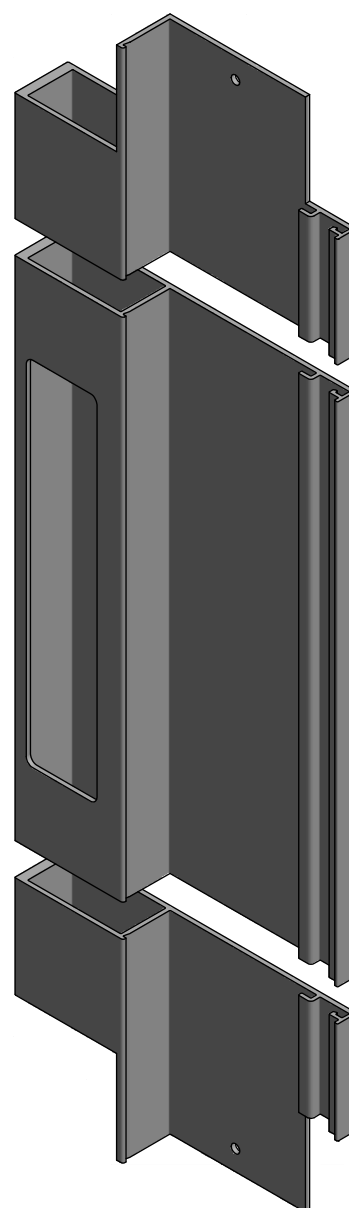
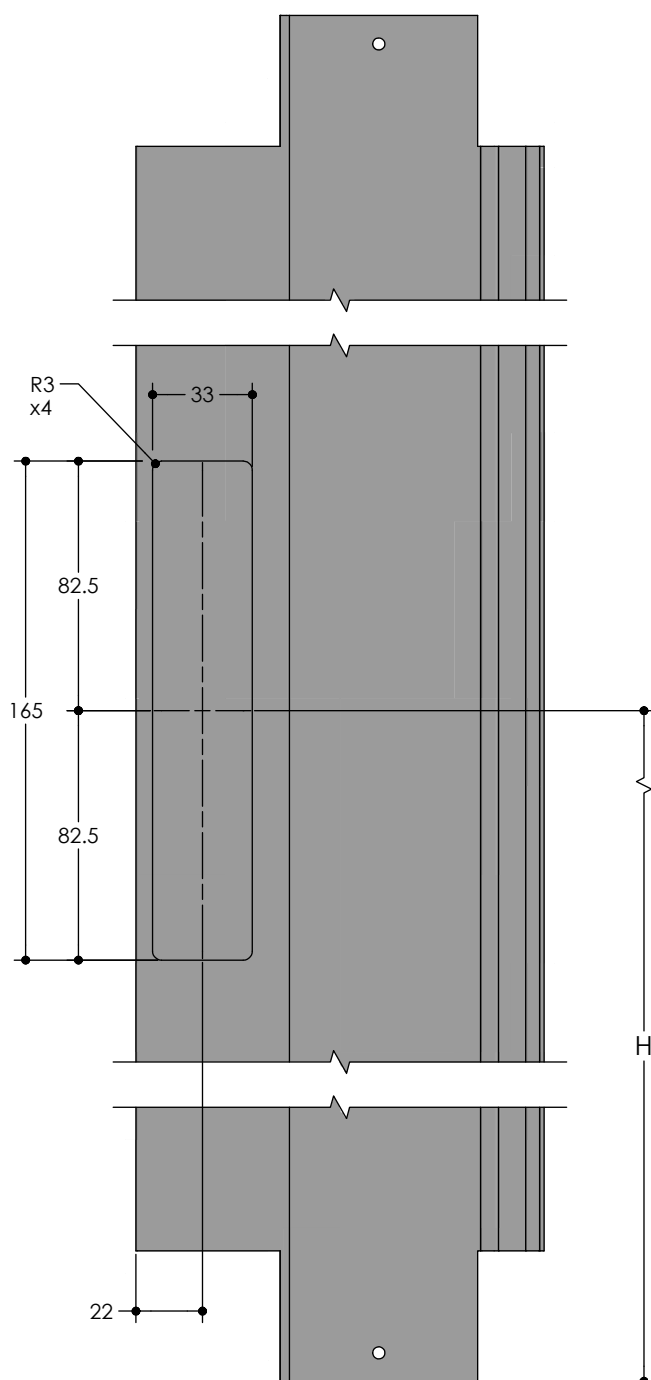
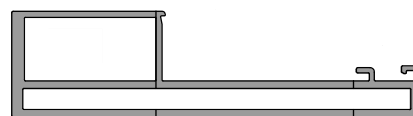
V31008



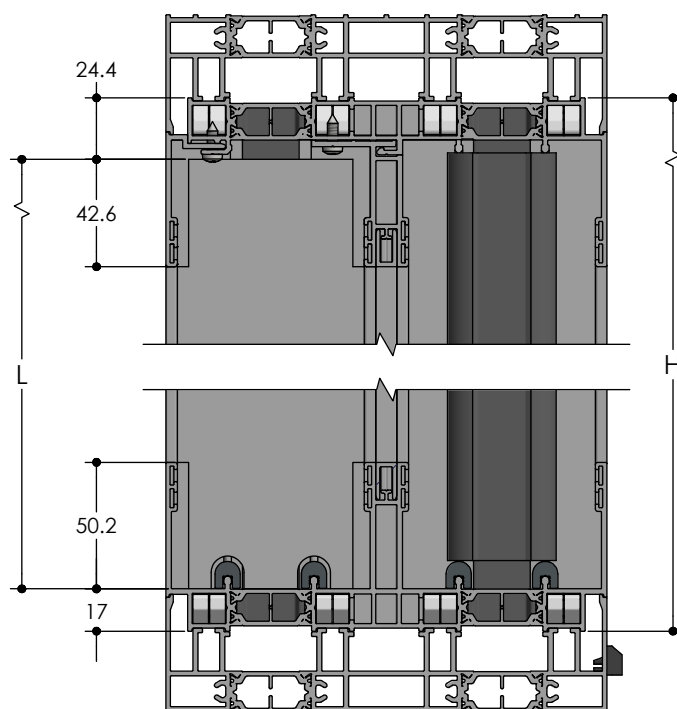
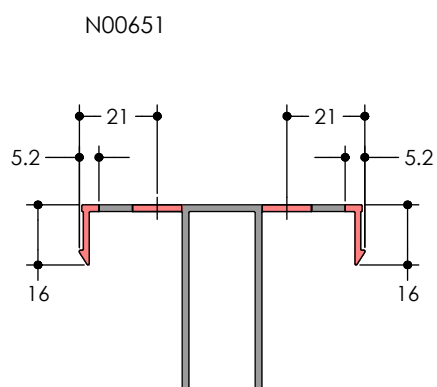
➤ N00123 - H00405 & H00412 MACHINING



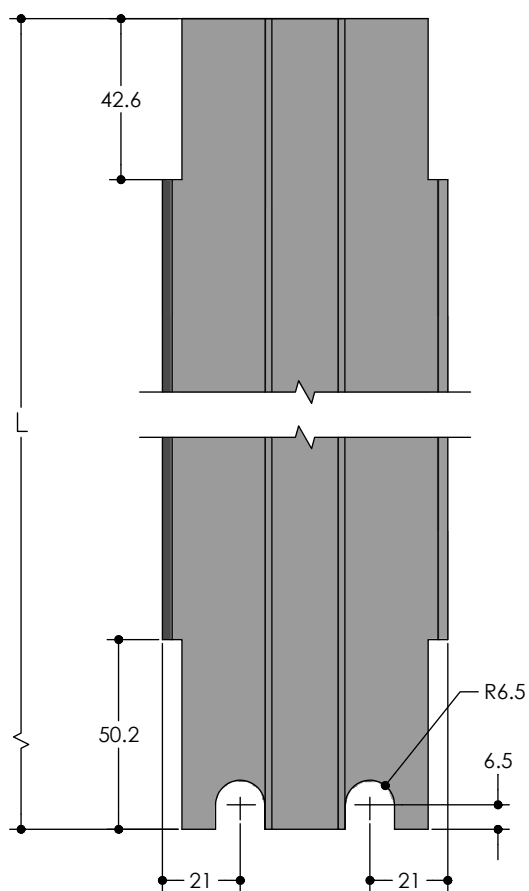
Also applicable to N00125



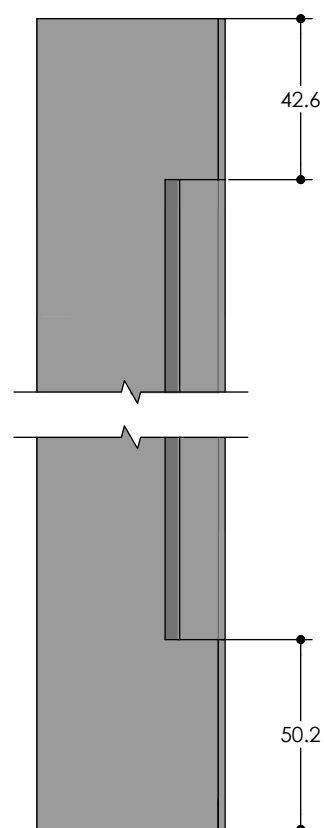
➤ N00651 - JAMB COVER PLATE



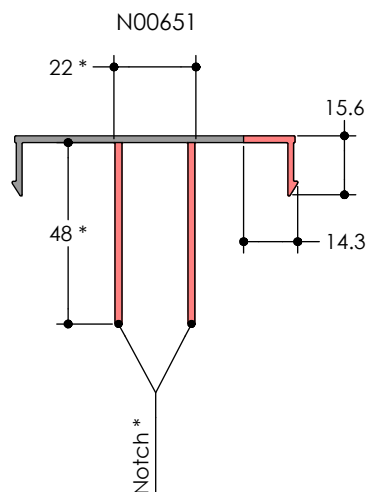
TOP



BOTTOM



➤ N00651 - OXXO DOOR KEEP



N00651 Cut Length for OXXO:

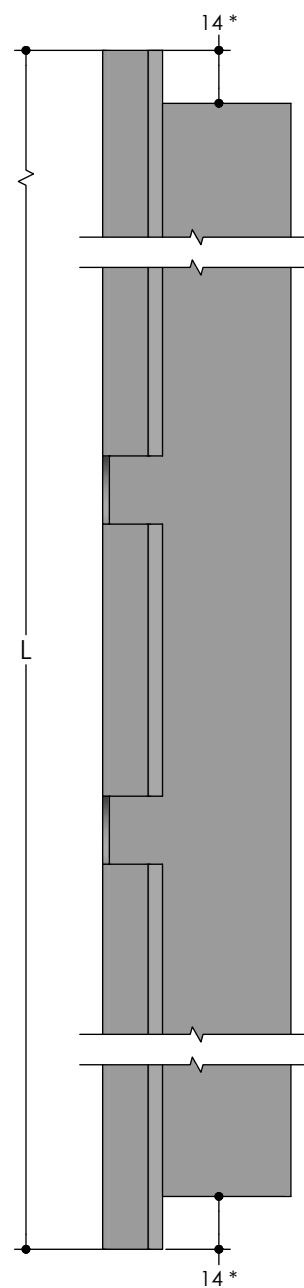
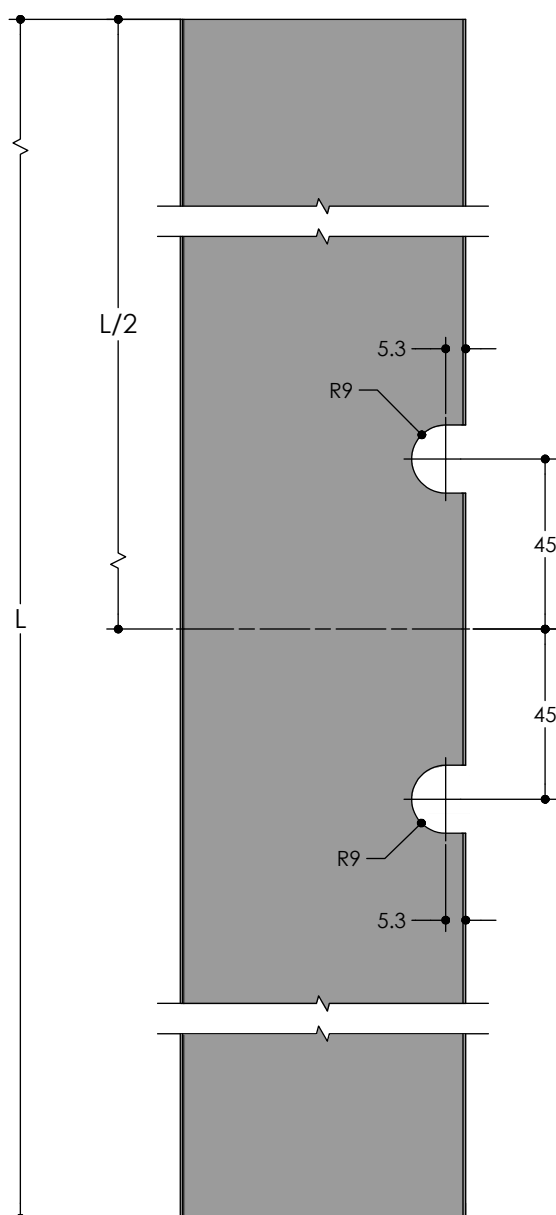
$$= WO - (SW1 + SW2 + 63.6)$$

Where:

WO = Outer Frame Width

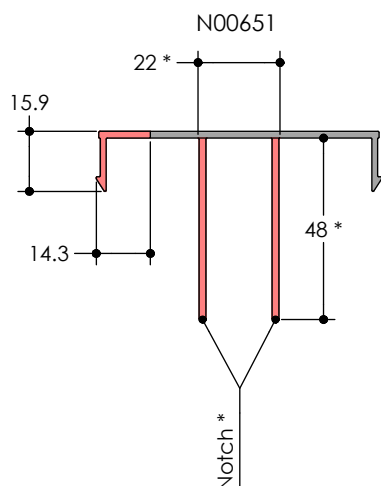
SW1 = Fixed Sash Width 1

SW2 = Fixed Sash Width 2



* Notch legs to fit around fixed sash end caps (V58000)

➤ N00651 - 90 DEG. CORNER POST KEEP

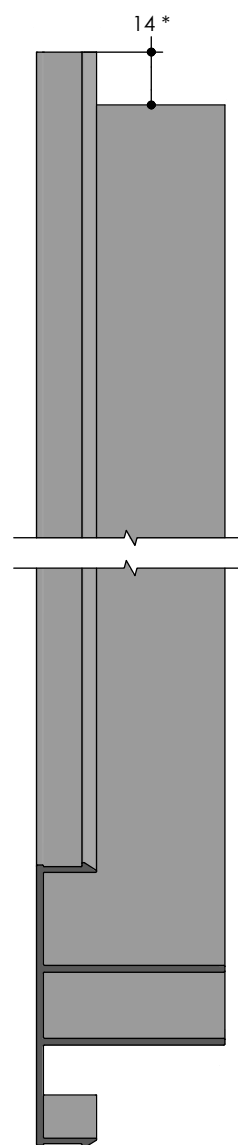
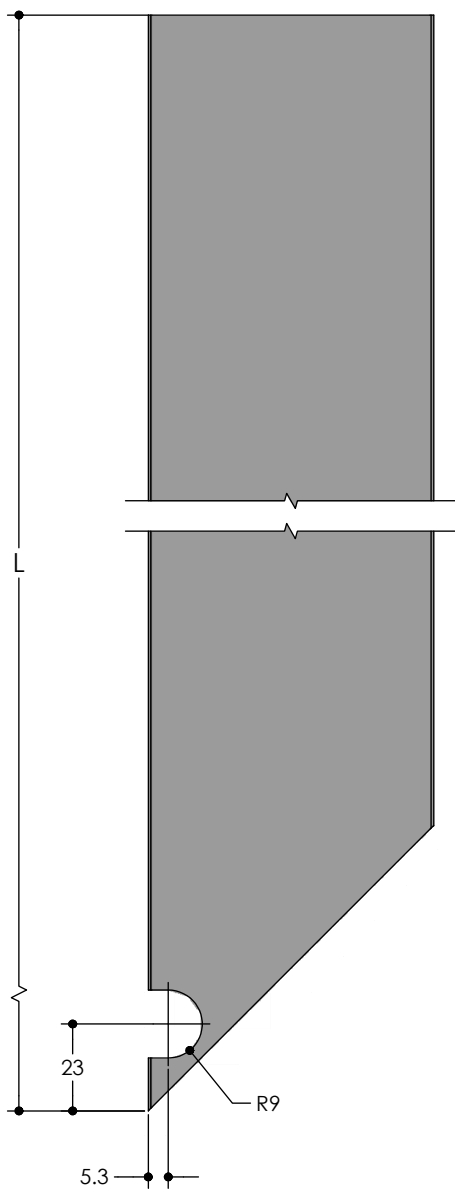


N00651 Cut Length for OX-XO (90° Corner):

$$= WO - (SW + 128.1)$$

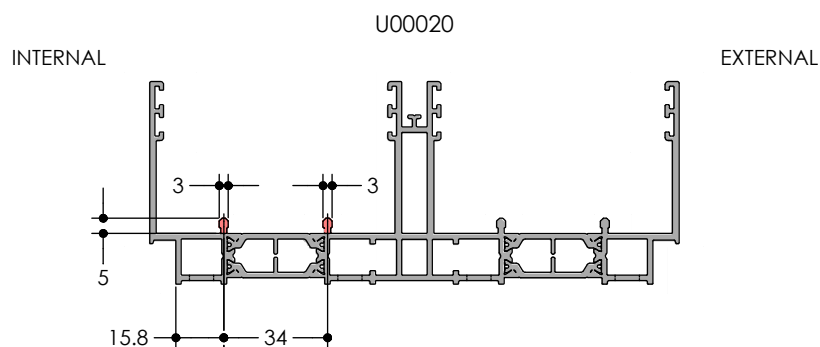
Where:

WO = Outer Frame Width
SW = Fixed Sash Width

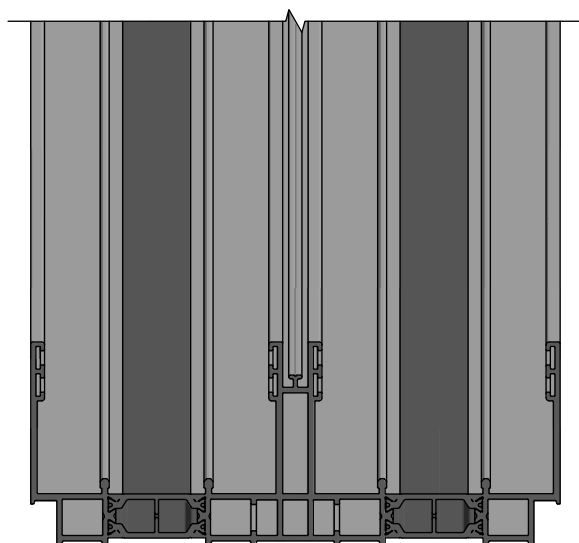
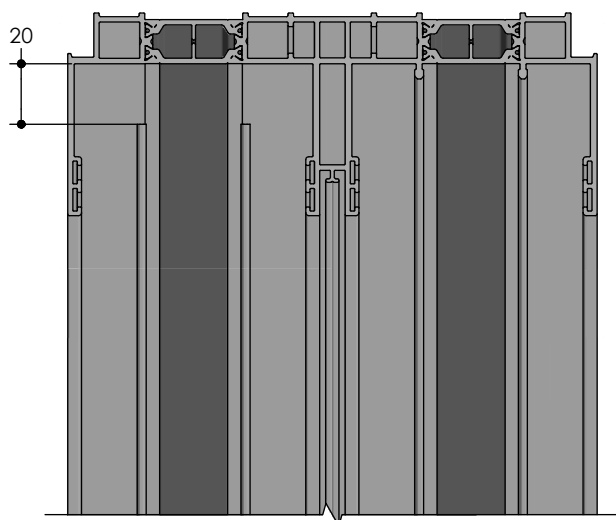


* Notch legs to fit around fixed sash end caps (V58000)

➤ U00020 - N00652 & N00653 CLEARANCE



TOP

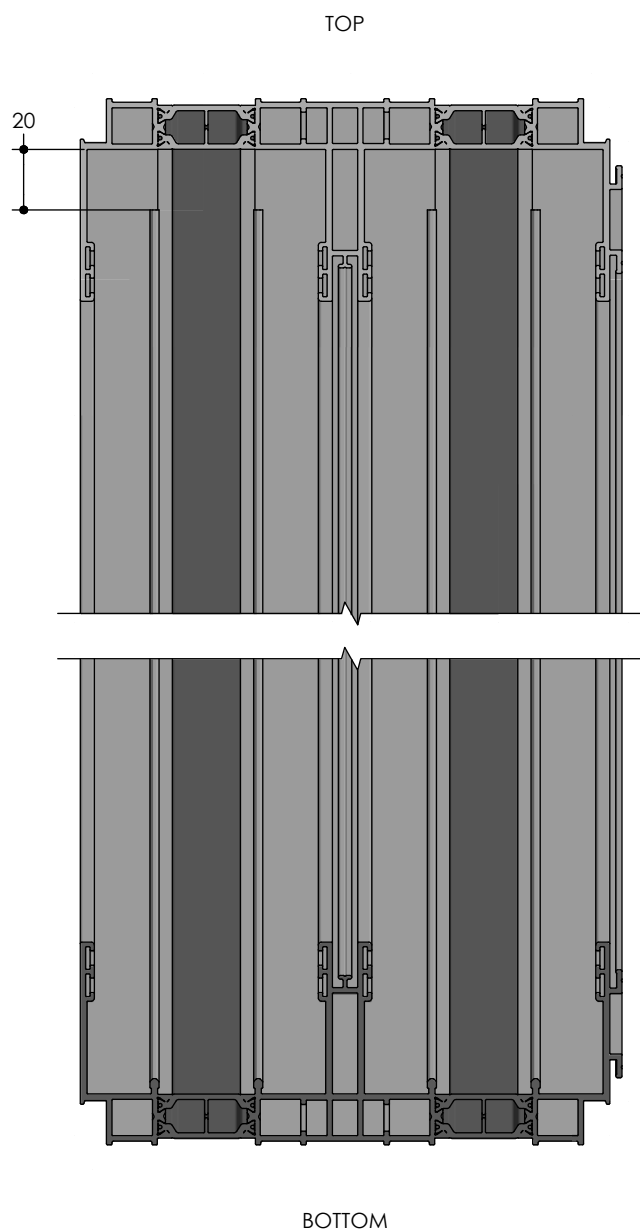
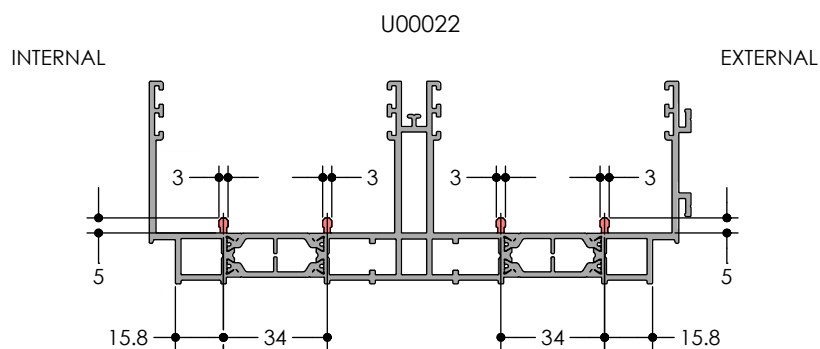


BOTTOM

IMPORTANT:

Machine track pins on the internal side of each jamb (U00020) to allow for N00652 and N00653 installation.

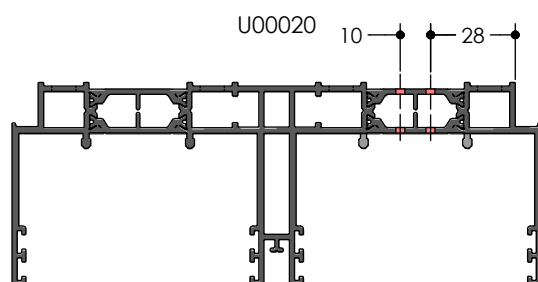
➤ U00022 - N00652 & N00653 CLEARANCE



IMPORTANT:

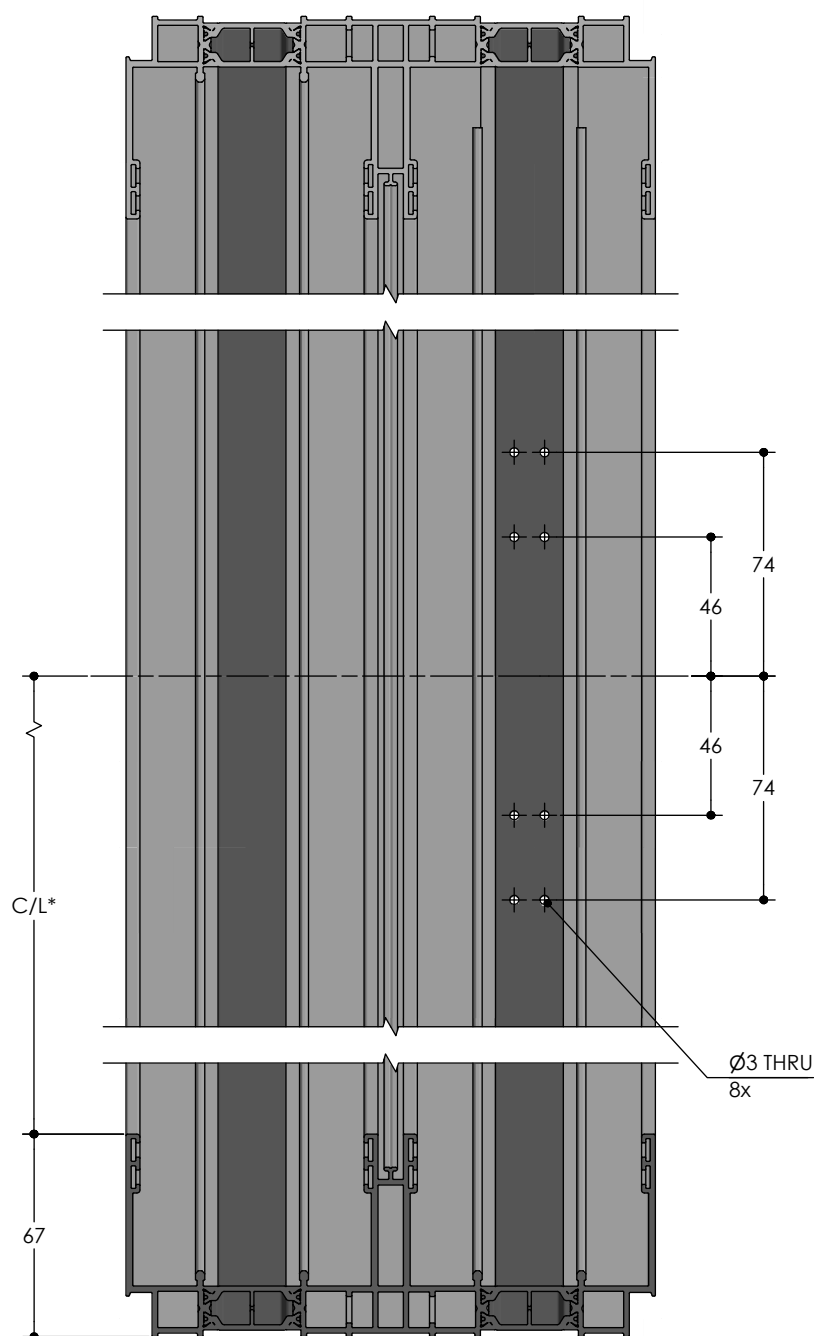
Machine track pips on the internal side of each jamb (U00022) to allow for N00652 and N00653 installation.

➤ U00020 - KEEP FIXING POSITIONS (H00401)

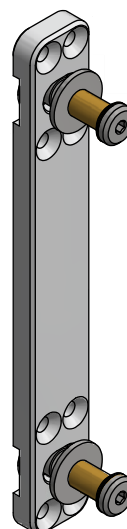


NOTE:

C/L* = Centre line of H00100 & H00101 Handles.

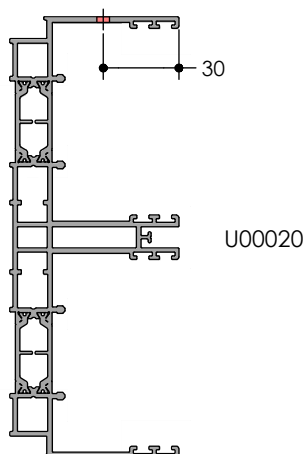


H00401

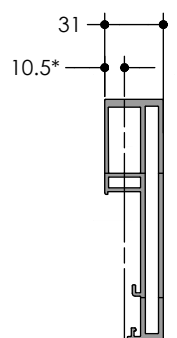


➤ U00020 & U00022 - H00410 KEEP MACHINING

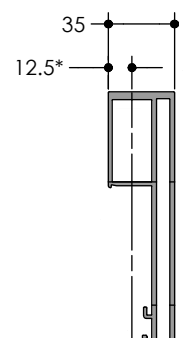
INTERNAL



U00020

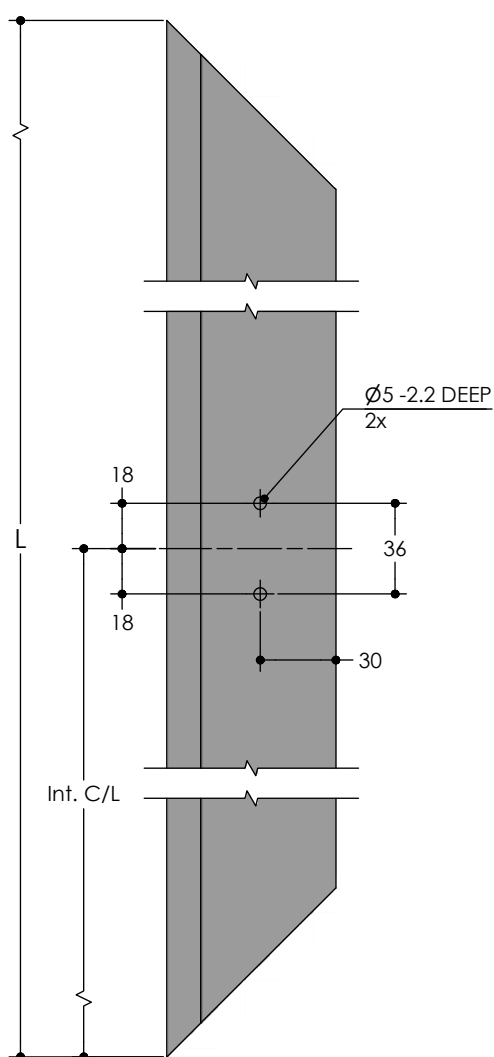


N00124



N00125

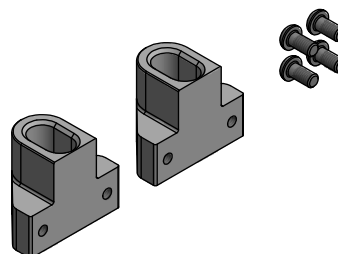
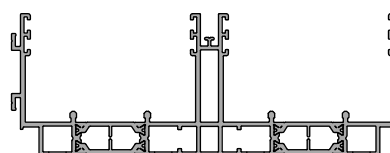
EXTERNAL



IMPORTANT:

Position holes equally around the centre line of each interlock apart from N00124 & N00125. As these must be offset equally either side of the dimensions* below.

Also applicable to U00022

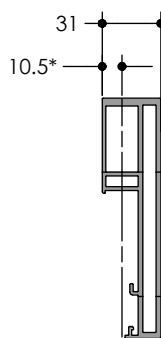
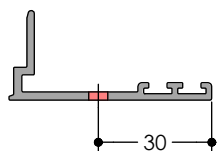


H00410 / Pair

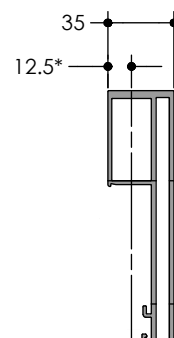
Machine for use with H00410 keep ONLY!

➤ N00652 - H00410 KEEP MACHINING

N00652



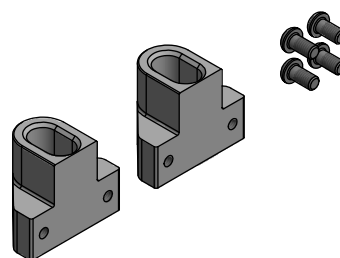
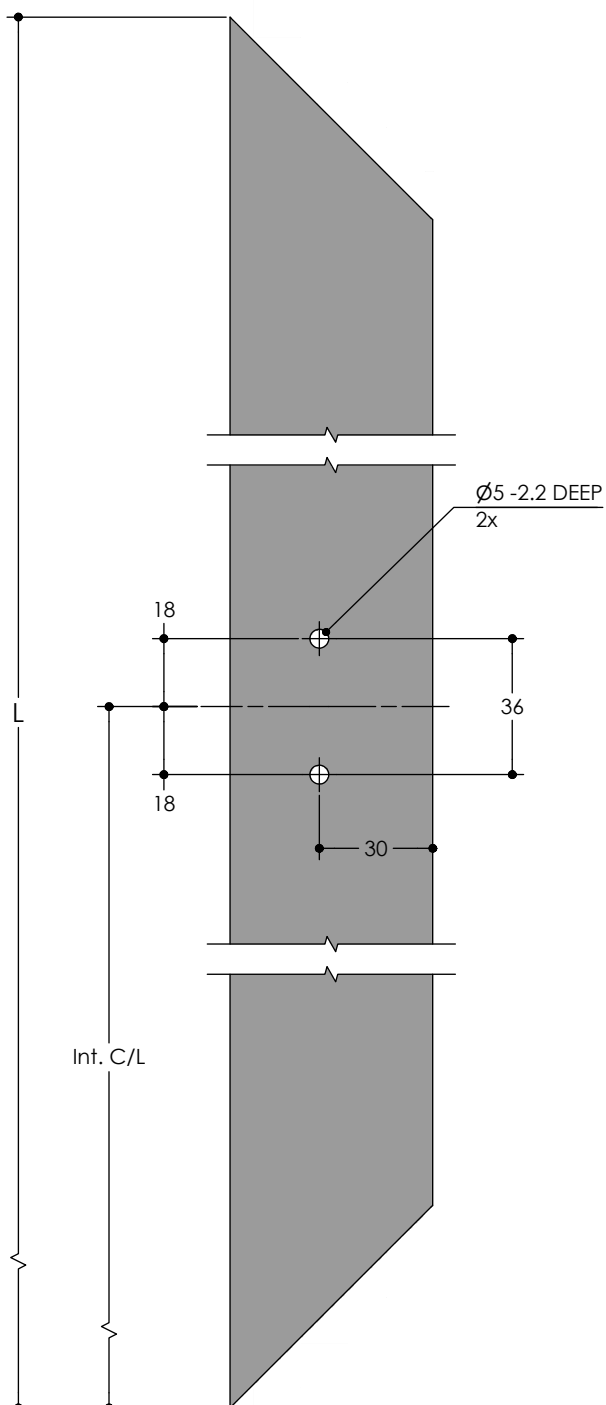
N00124



N00125

IMPORTANT:

Position holes equally around the centre line of each interlock apart from N00124 & N00125. As these must be offset equally either side of the dimensions* below.



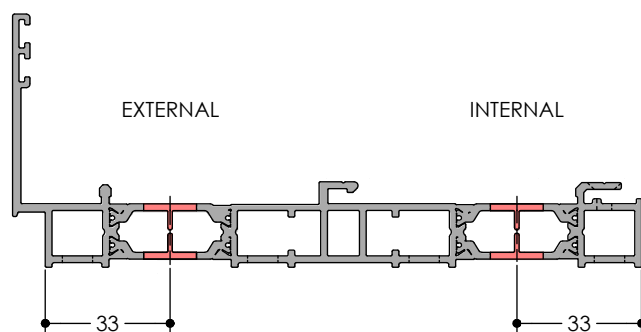
H00410 / Pair

Machine for use with H00410 keep ONLY!

➤ U00021 - DOOR STOP (709609)

U00021

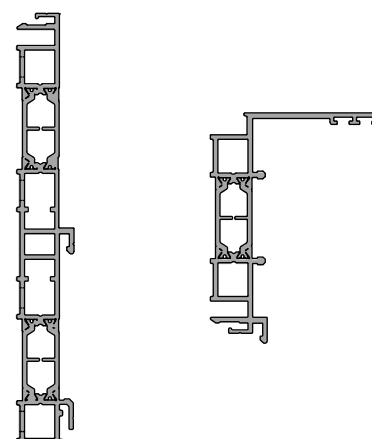
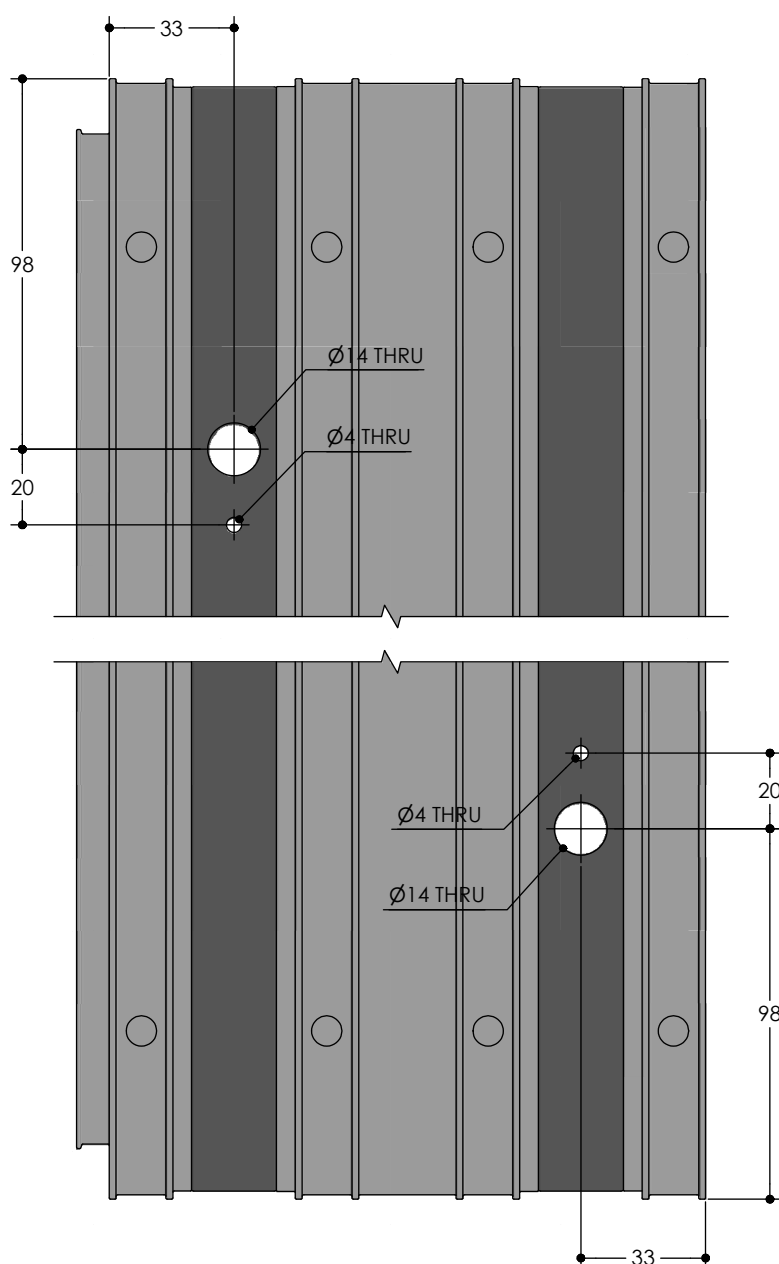
709609



IMPORTANT:

709609 hole positions based upon XX door configuration.

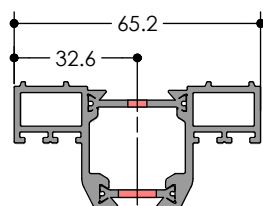
If using any other configuration i.e. OX only machine opposing side to the moving panel.



Also applicable to U00023 & U00001

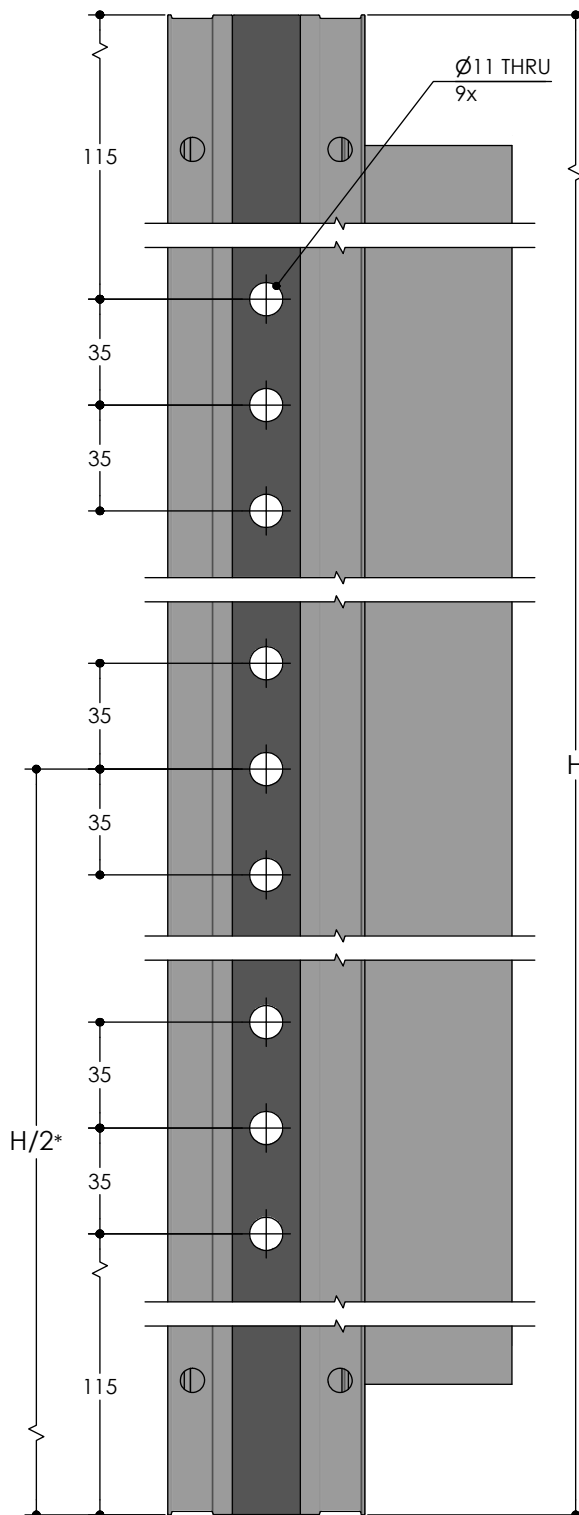
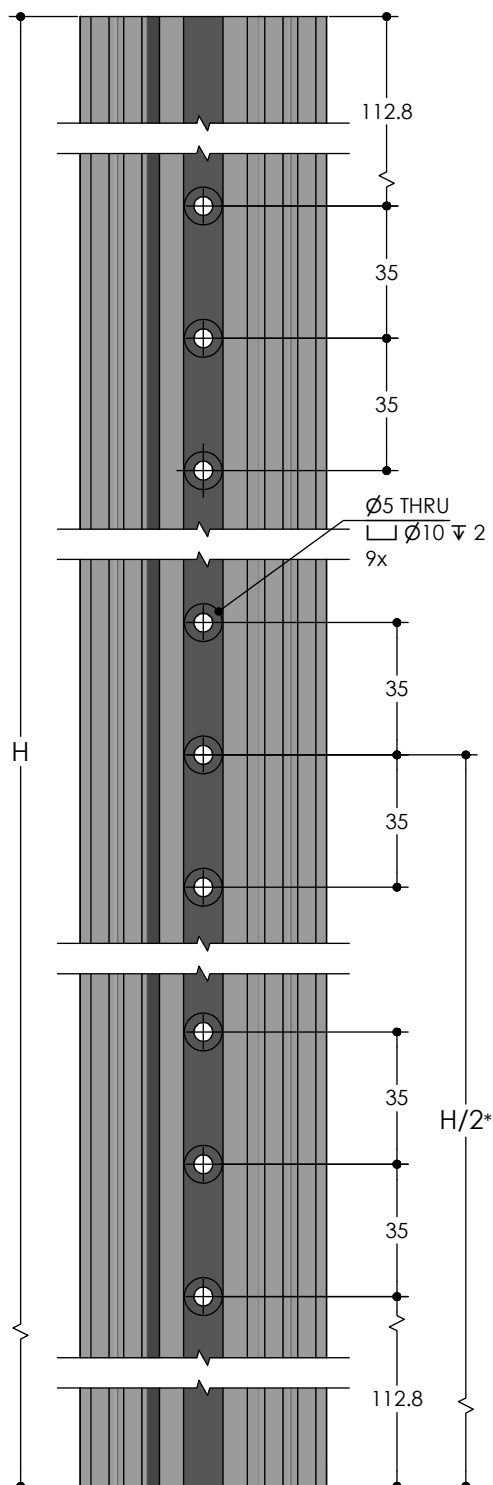
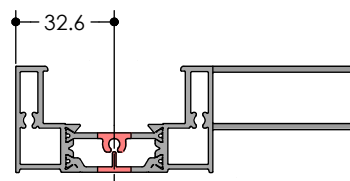
➤ U00101 & U00500 - OXXO & 90 DEG. CORNER

U00500

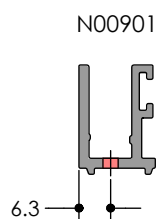


*For H > 2500mm add additional 3 holes i.e. space two inner fixings equally between top and bottom holes.

U00101

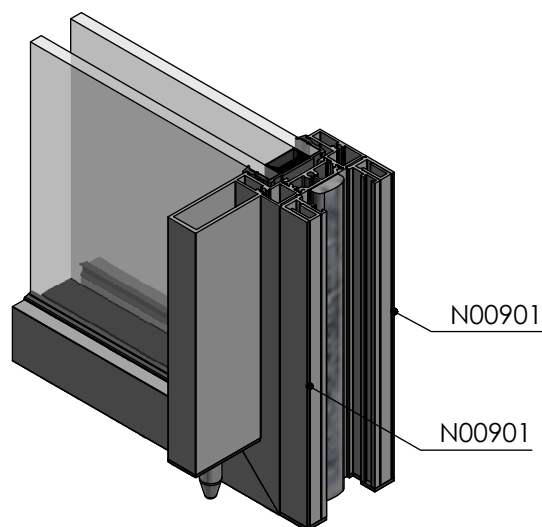
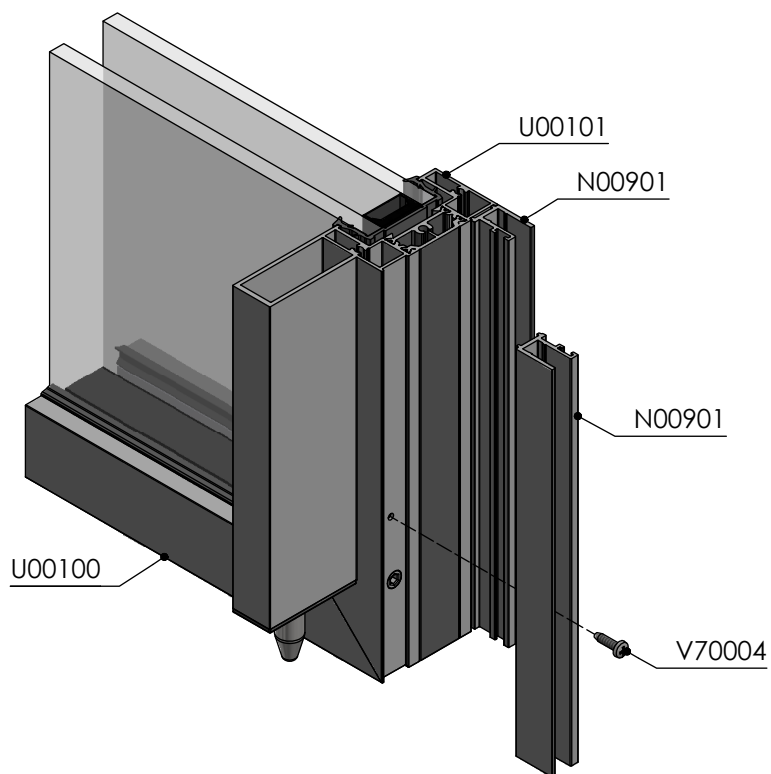
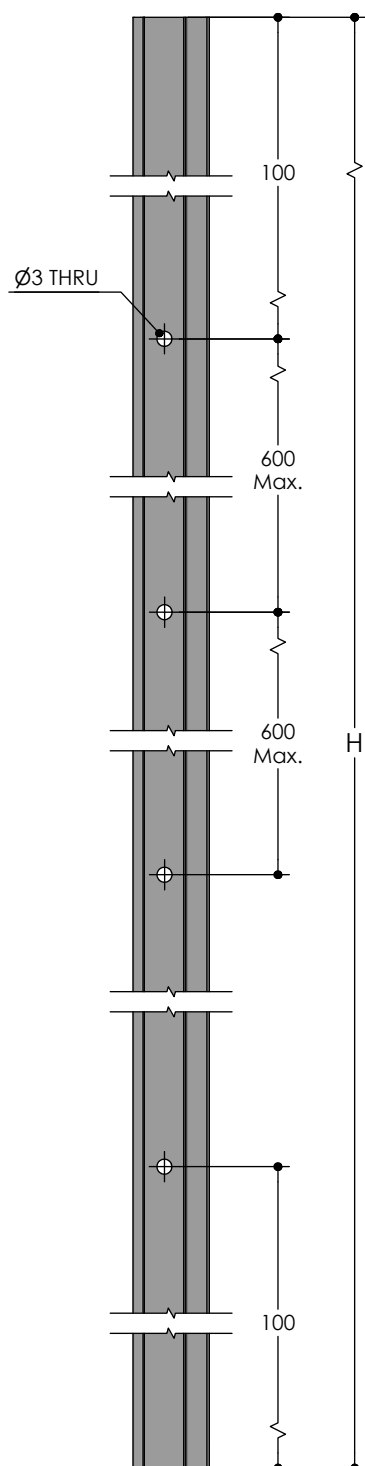


➤ N00901 - OXXO ADAPTOR PROFILE

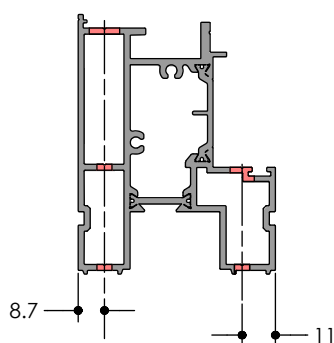


IMPORTANT:

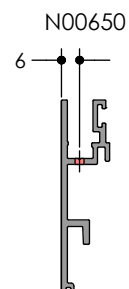
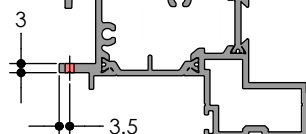
Cut H to require sash height minus 4.4mm,
to allow for the end caps (V58002)



➤ U00600, U00500, N00650 - 90 DEG.CORNER POST

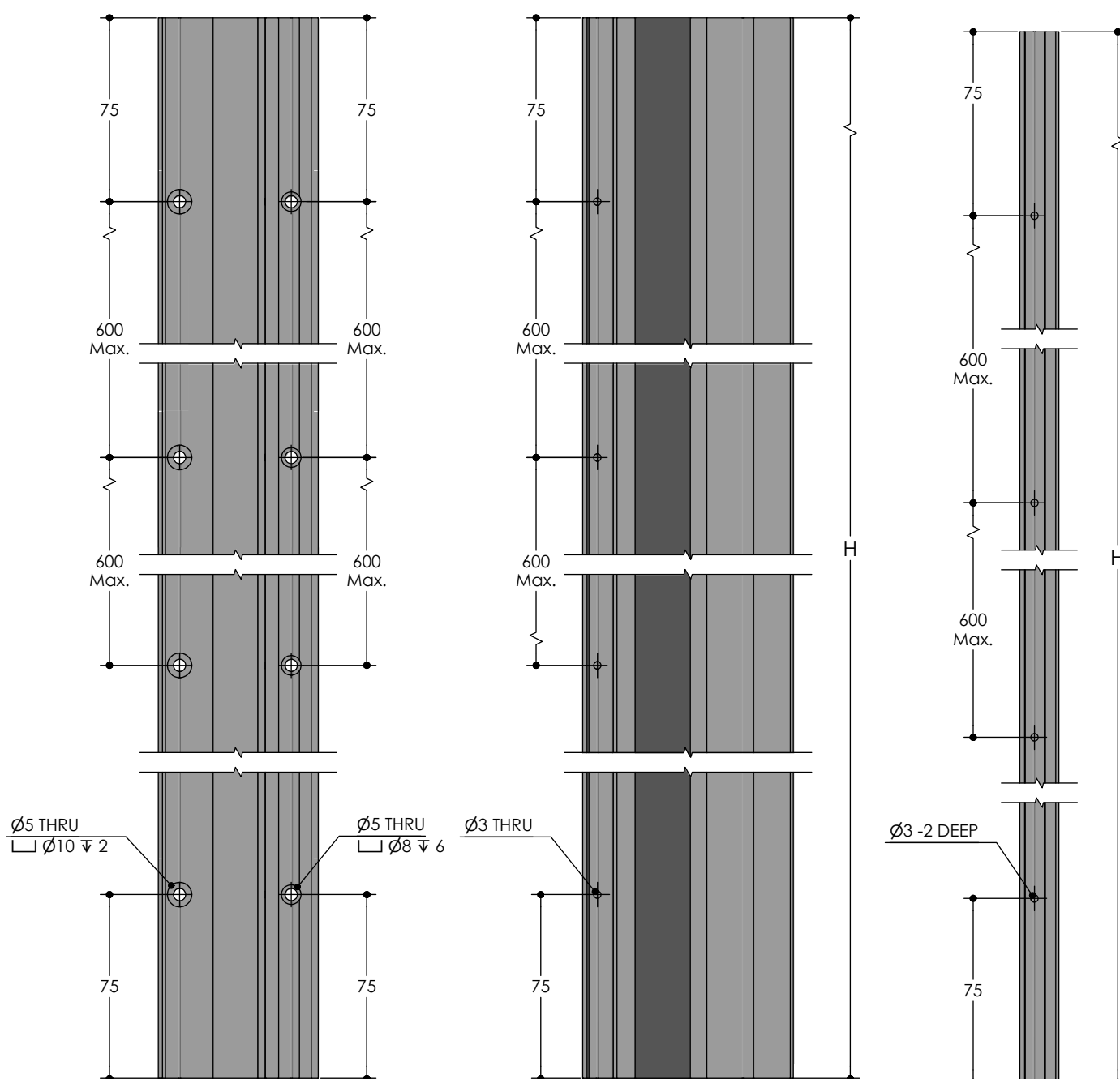


U00600



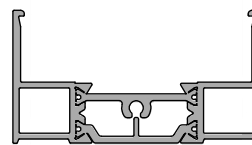
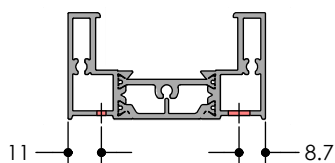
IMPORTANT:

Cut H to require sash height minus 4.4mm,
to allow for the end caps (V58001)



➤ U00100 - 90 DEG. CORNER POST

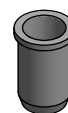
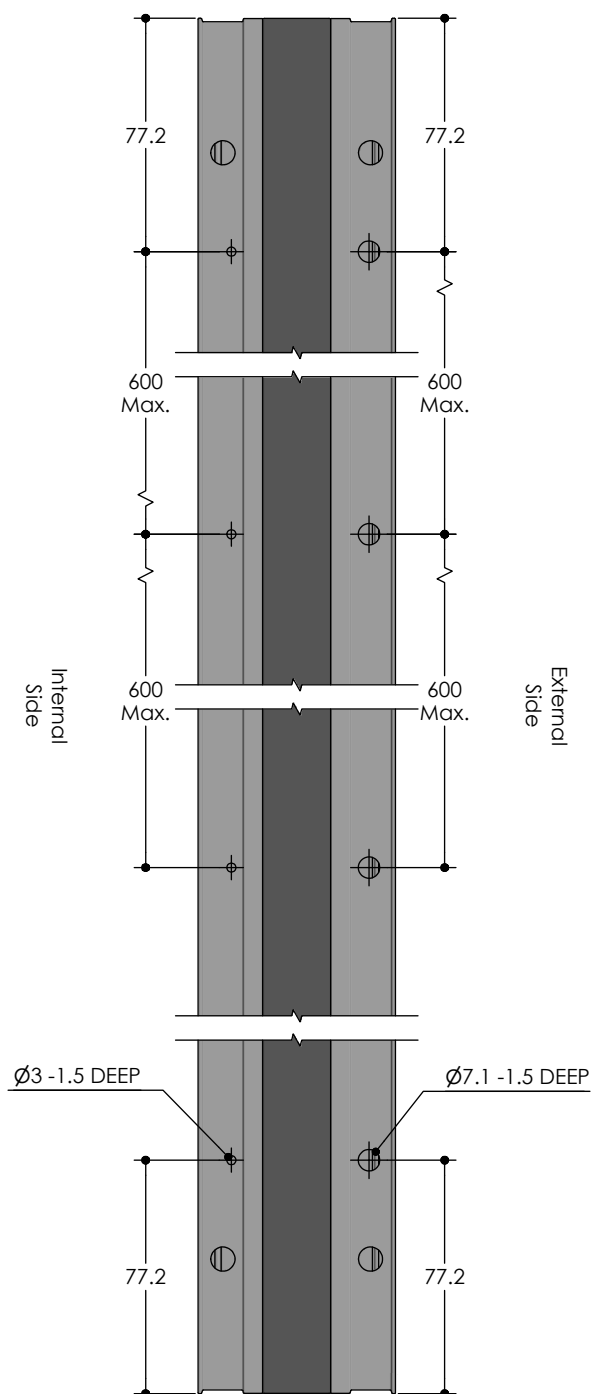
U00100



Also applicable to U00102

IMPORTANT:

Ø7.1 mm to be drilled nearest to the external part of the outer frame.



V70057

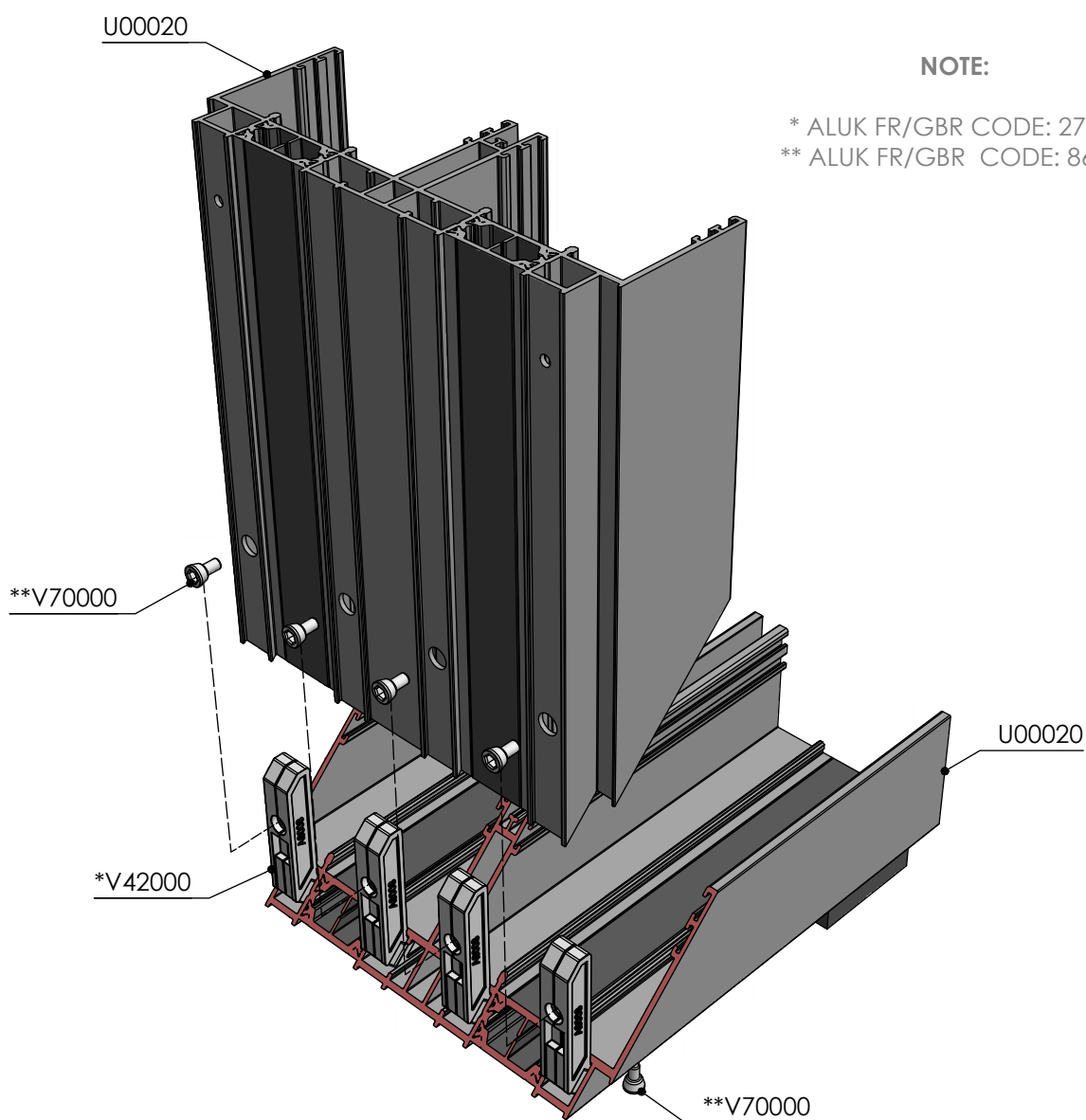
Used in Ø7.1 holes to connect corner post (U00600)

SECTION 10
ASSEMBLY

» INFINIUM ASSEMBLY

➤ U00020 - CORNER JOINT

INFINIUM MECHANICAL JOINT			
Series	Section	Cleat	Screw
INFINIUM	U00020	*V42000	**V70000
INFINIUM	U00022	*V42000	**V70000

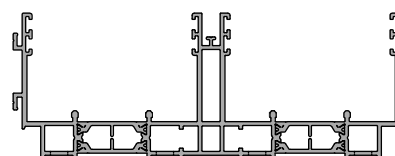
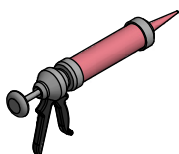


NOTE:

- * ALUK FR/GBR CODE: 27500
- ** ALUK FR/GBR CODE: 86720

Apply Sealant!

T50000 - T50002

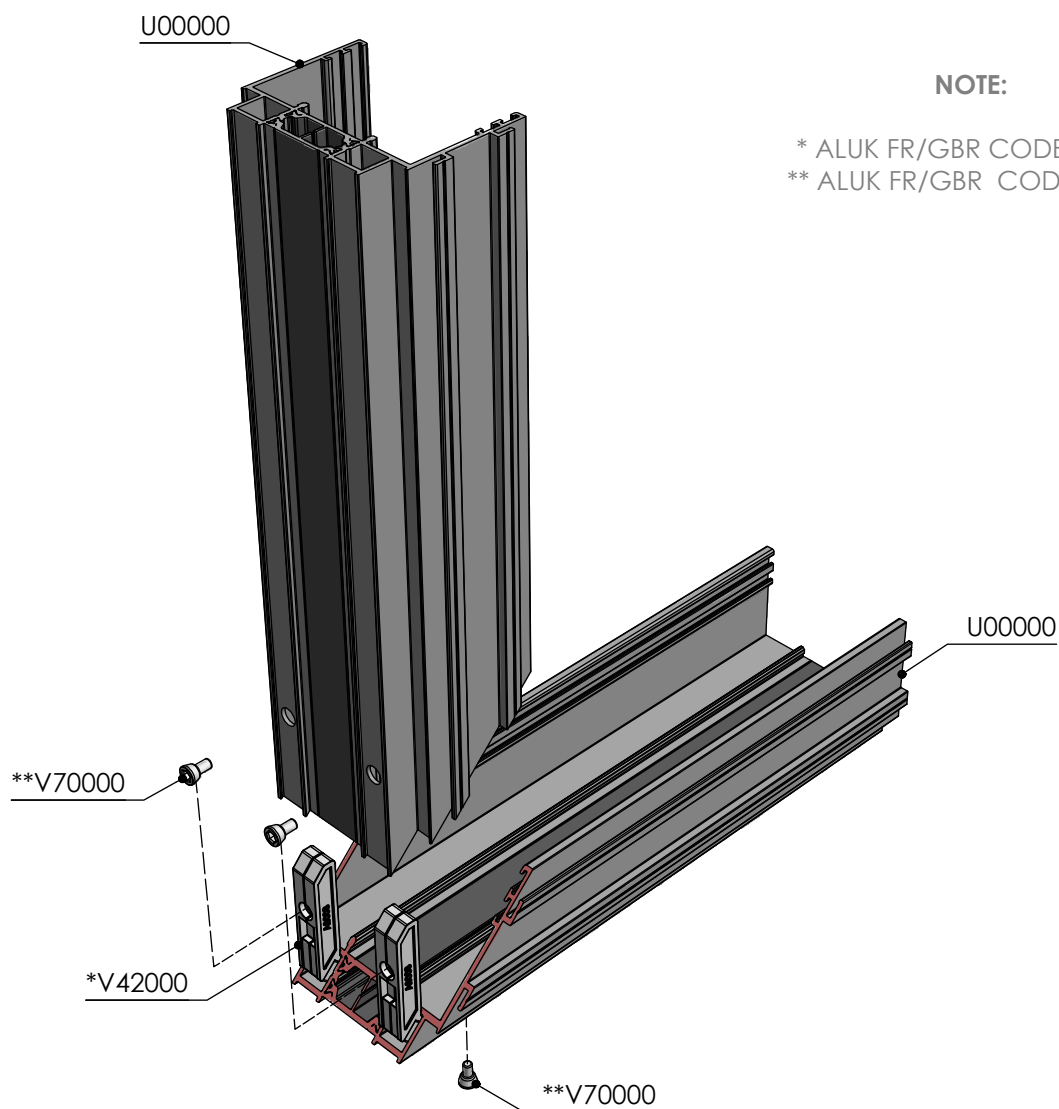


Also applicable to U00022

Apply small joint sealant on all corner surfaces before assembling the frame.
Once fixed wipe away any excess sealant using T50003.

➤ U00000 - CORNER JOINT

INFINIUM MECHANICAL JOINT			
Series	Section	Cleat	Screw
INFINIUM	U00000	*V42000	**V70000



NOTE:

* ALUK FR/GBR CODE: 27500

** ALUK FR/GBR CODE: 86720

Apply Sealant!

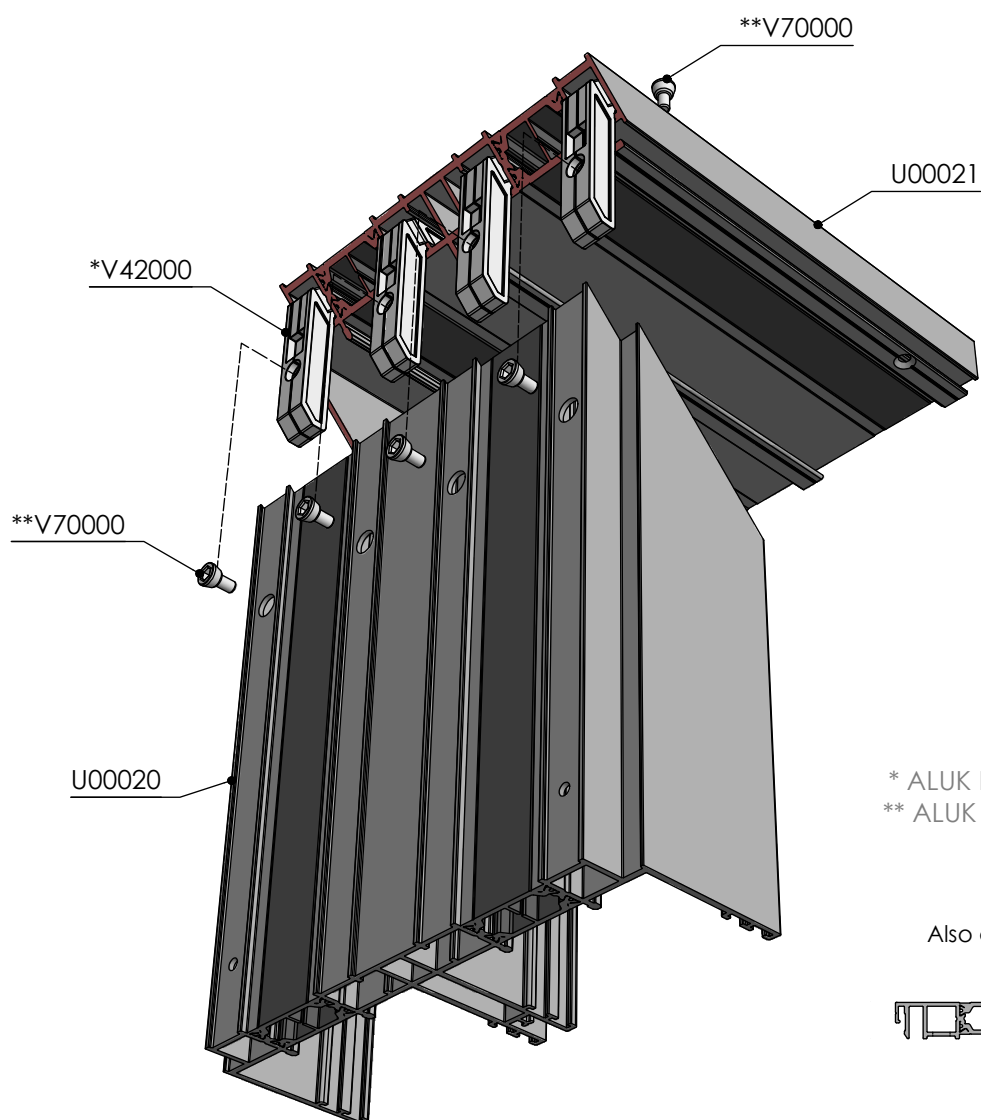
T50000 - T50002



Apply small joint sealant on all corner surfaces before assembling the frame.
Once fixed wipe away any excess sealant using T50003.

➤ U00020 & U00021 - CORNER JOINT

INFINIUM MECHANICAL JOINT			
Series	Section	Cleat	Screw
INFINIUM	U00020 / 21	*V42000	**V70000
"	U00022 / 23	*V42000	**V70000



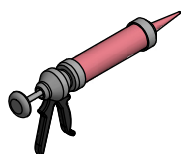
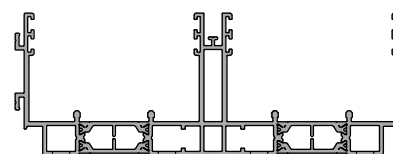
NOTE:

* ALUK FR/GBR CODE: 27500
 ** ALUK FR/GBR CODE: 86720

Also applicable to U00023



Also applicable to U00022



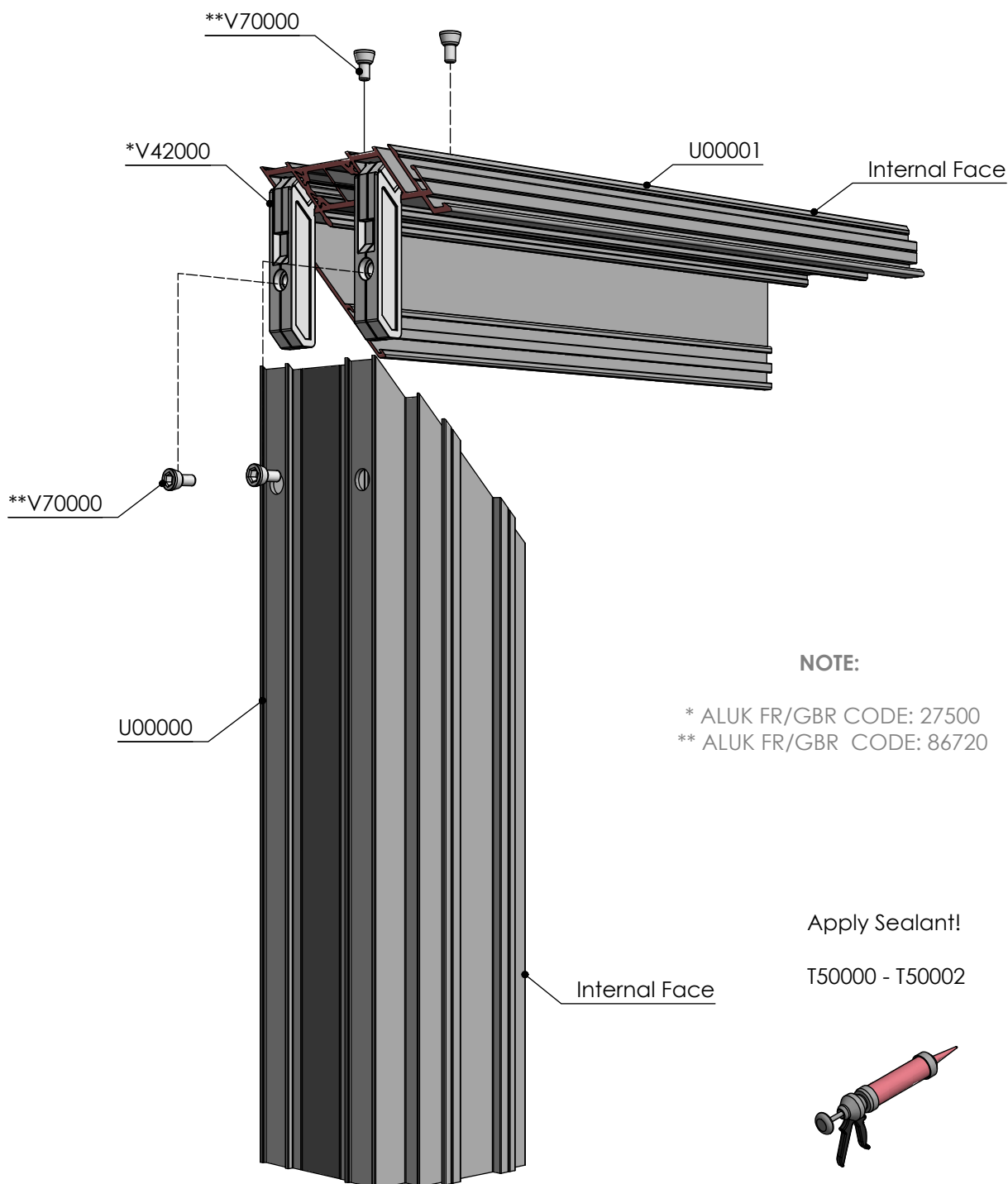
Apply Sealant!

T50000 - T50002

Apply small joint sealant on all corner surfaces before assembling the frame.
 Once fixed wipe away any excess sealant using T50003.

➤ U00000 & U00001 - CORNER JOINT

INFINIUM MECHANICAL JOINT			
Series	Section	Cleat	Screw
INFINIUM	U00000	*V42000	**V70000
"	U00001	*V42000	**V70000

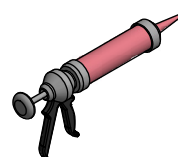


NOTE:

- * ALUK FR/GBR CODE: 27500
- ** ALUK FR/GBR CODE: 86720

Apply Sealant!

T50000 - T50002



Apply small joint sealant on all corner surfaces before assembling the frame.
Once fixed wipe away any excess sealant using T50003.

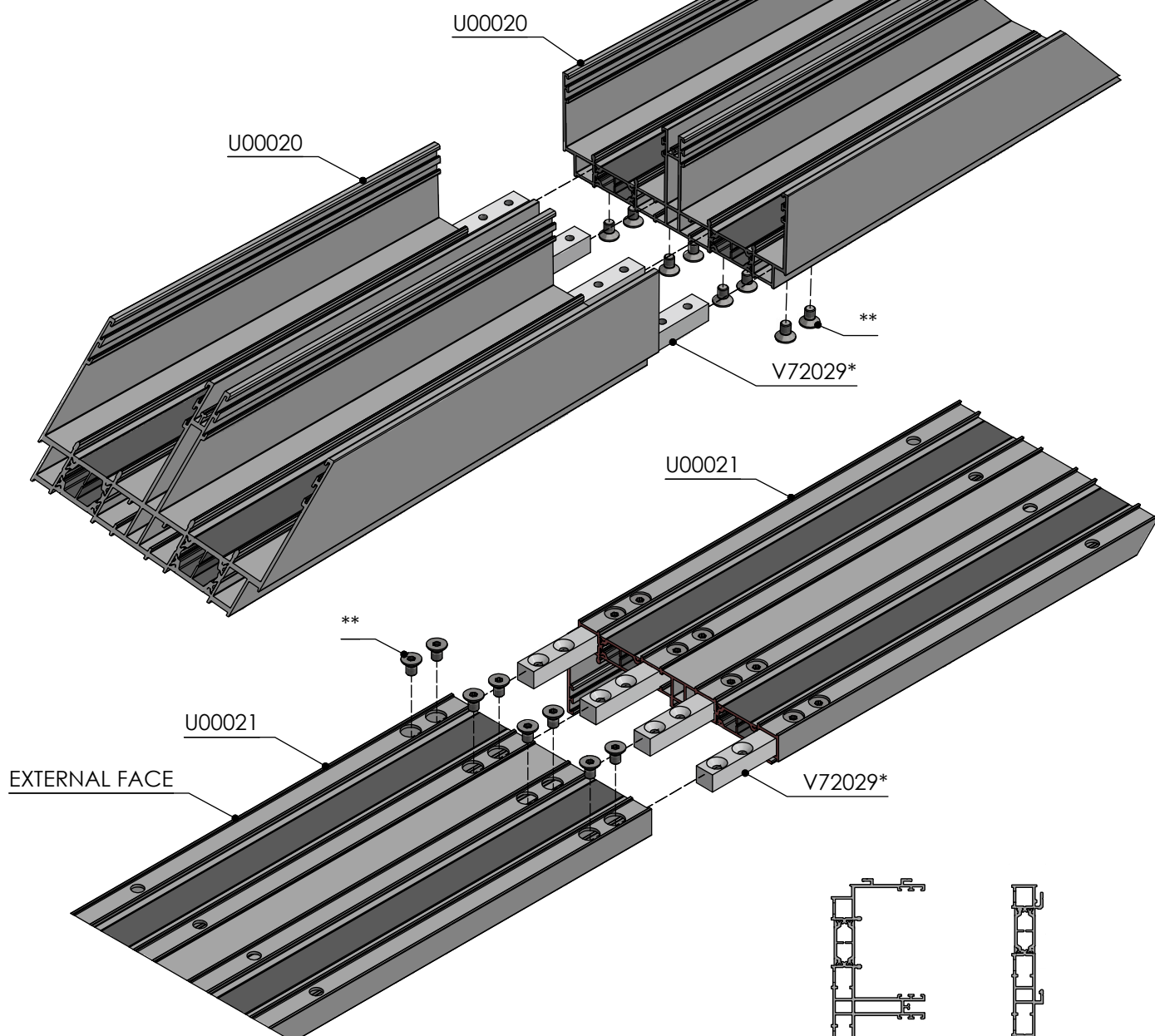
➤ U00020 - U00023 - EXTENSION JOINT

INFINIUM MECHANICAL JOINT			
Series	Section	Cleat	Screw
INFINIUM	U00020 / 21	*V72029	**Part of V72029
"	U00022 / 23	*V72029	**Part of V72029

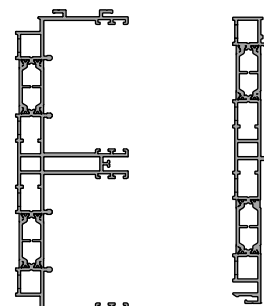


Apply Sealant!

T50000 - T50002



If $L > 6500\text{mm}$ use extension piece (V72029) and seal each joint using T50000 - T50002. Remove any excess with wipes (T50003).



Also applicable to U00022/23

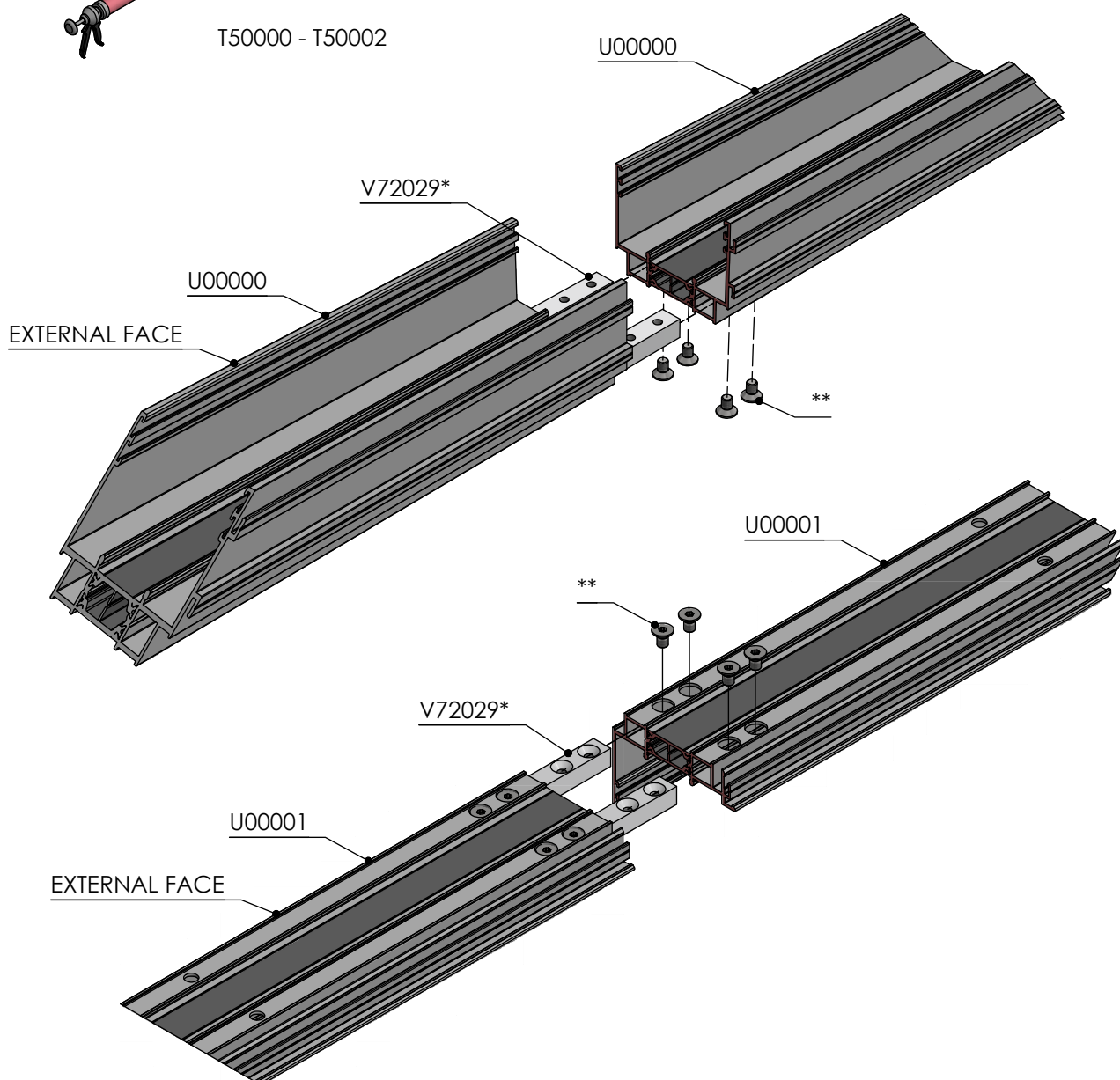
➤ U00000 & U00001 - EXTENSION JOINT

INFINIUM MECHANICAL JOINT			
Series	Section	Cleat	Screw
INFINIUM	U00000	*V72029	**Part of V72029
"	U00001	*V72029	**Part of V72029



Apply Sealant!

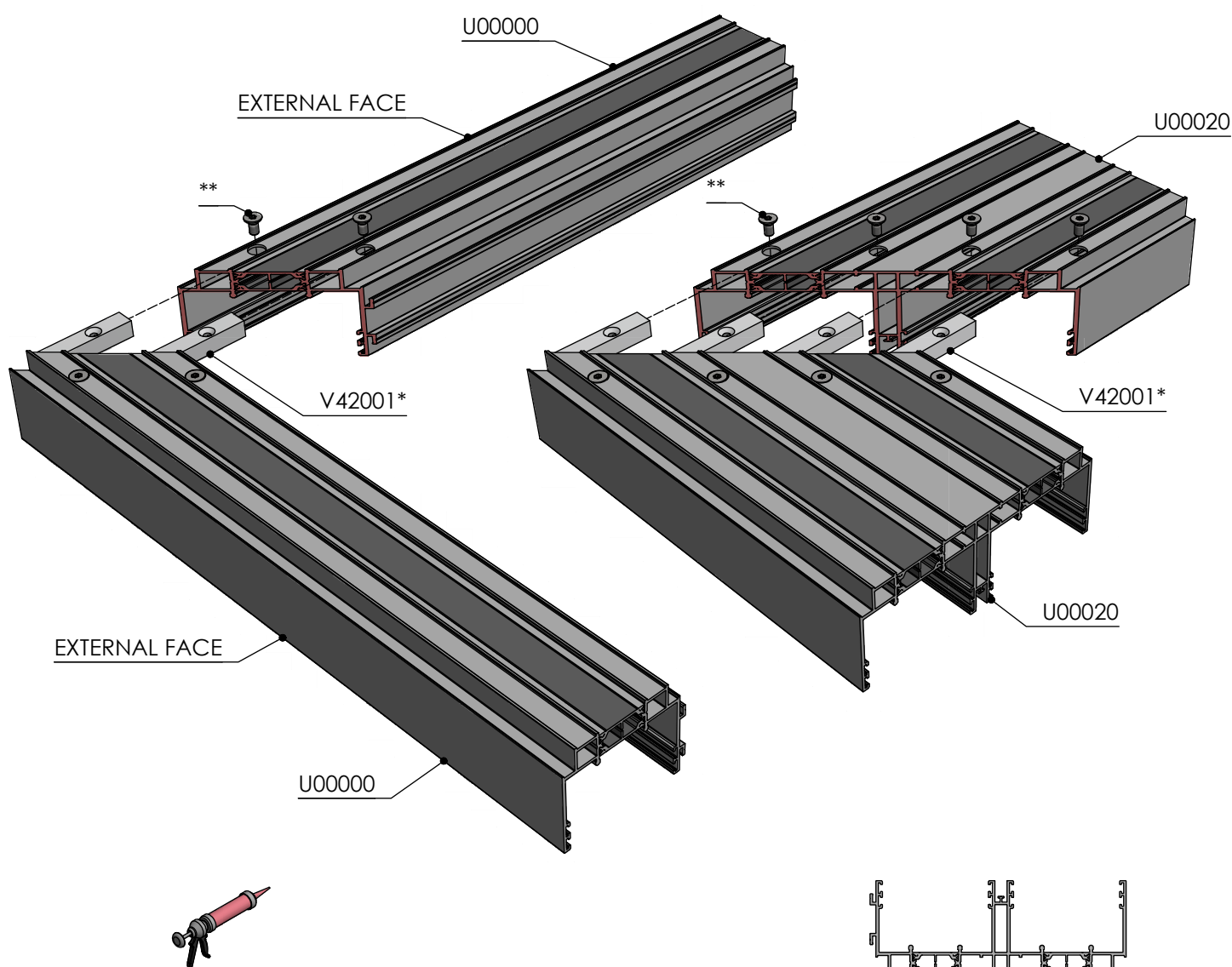
T50000 - T50002



If L > 6500mm use extension piece (V72029) and seal each joint using T50000 - T50002. Remove any excess with wipes (T50003).

➤ U00000, U00020 & U00023 - 90 DEG. CORNER

INFINIUM MECHANICAL JOINT			
Series	Section	Cleat	Screw
INFINIUM	U00020	*V42001	**Part of V42001
"	U00022	*V42001	**Part of V42001
"	U00000	*V42001	**Part of V42001



Apply Sealant!

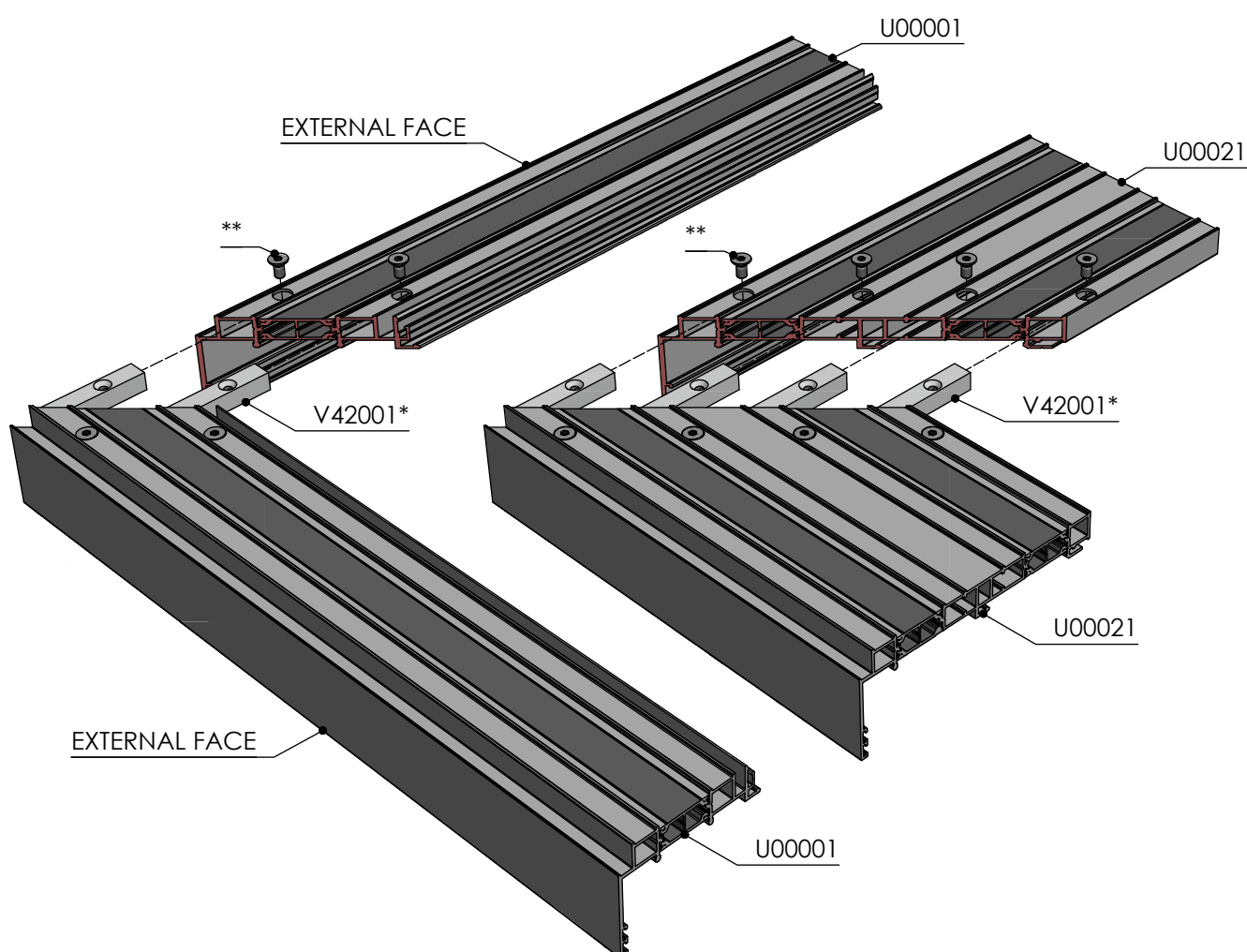
T50000 - T50002

Also applicable to U00022

For 90 degree corner joints use (V42001) and seal each joint using T50000 - T50002. Remove any excess with wipes (T50003).

➤ U00001, U00021 & U00023 - 90 DEG. CORNER

INFINIUM MECHANICAL JOINT			
Series	Section	Cleat	Screw
INFINIUM	U00021	*V42001	**Part of V42001
"	U00023	*V42001	**Part of V42001
"	U00001	*V42001	**Part of V42001



Apply Sealant!

T50000 - T50002



Also applicable to U00023

For 90 degree corner joints use (V42001) and seal each joint using T50000 - T50002. Remove any excess with wipes (T50003).

➤ U00630 - U00631 - EXTENSION JOINT

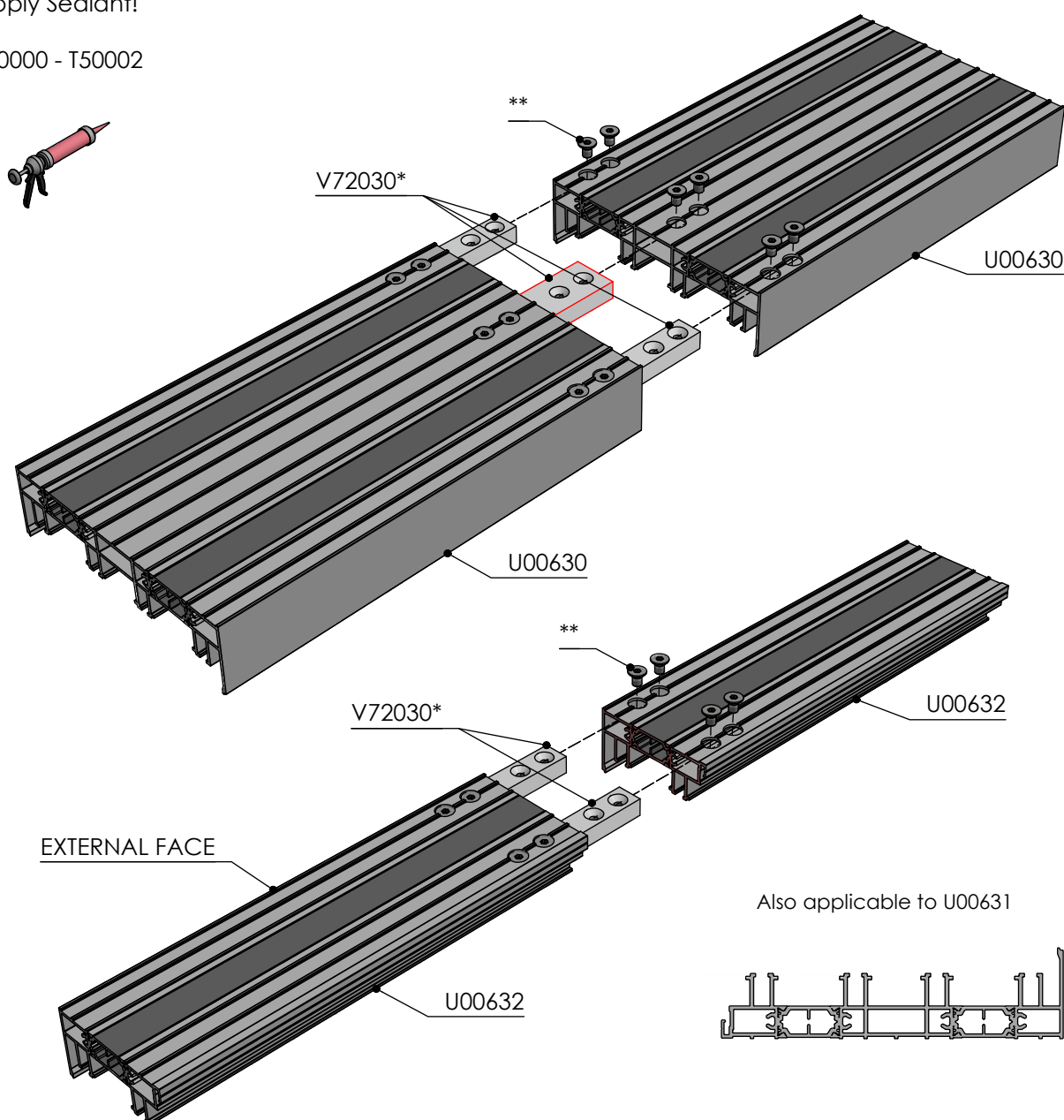
INFINIUM MECHANICAL JOINT			
Series	Section	Cleat	Screw
INFINIUM	U00630	*V72030	**Part of V72030
"	U00631	"	"
"	U00632	"	"

IMPORTANT:

When using U00632 the larger joining cleat (Highlighted In RED) is not required. This is only used with U00630 and U00631.

Apply Sealant!

T50000 - T50002



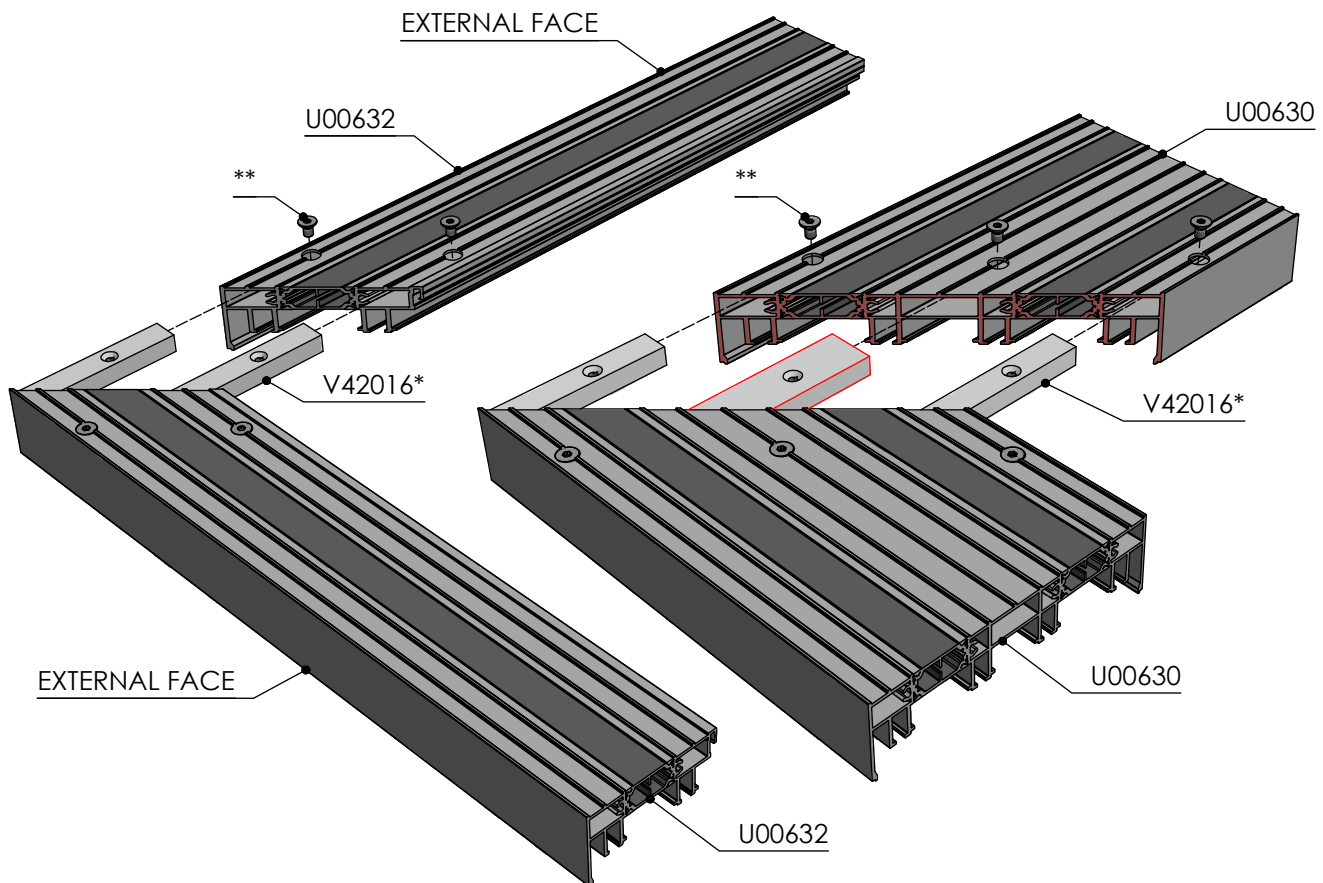
If L > 6500mm use extension piece (V72029) and seal each joint using T50000 - T50002. Remove any excess with wipes (T50003).

➤ U00630 - U00632 - 90 DEG. CORNER

INFINIUM MECHANICAL JOINT			
Series	Section	Cleat	Screw
INFINIUM	U00630	*V42016	**Part of V42016
"	U00631	"	"
"	U00632	"	"

IMPORTANT:

When using U00632 the larger 90 degree corner cleat (Hihglighted In RED) is not required. This is only used with U00630 and U00631.

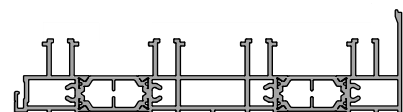


Also applicable to U00631



Apply Sealant!

T50000 - T50002



For 90 degree corner use corner cleat (V42016) and seal each joint using T50000 - T50002. Remove any excess with wipes (T50003).

➤ U00630 - SUB CILL ASSEMBLY

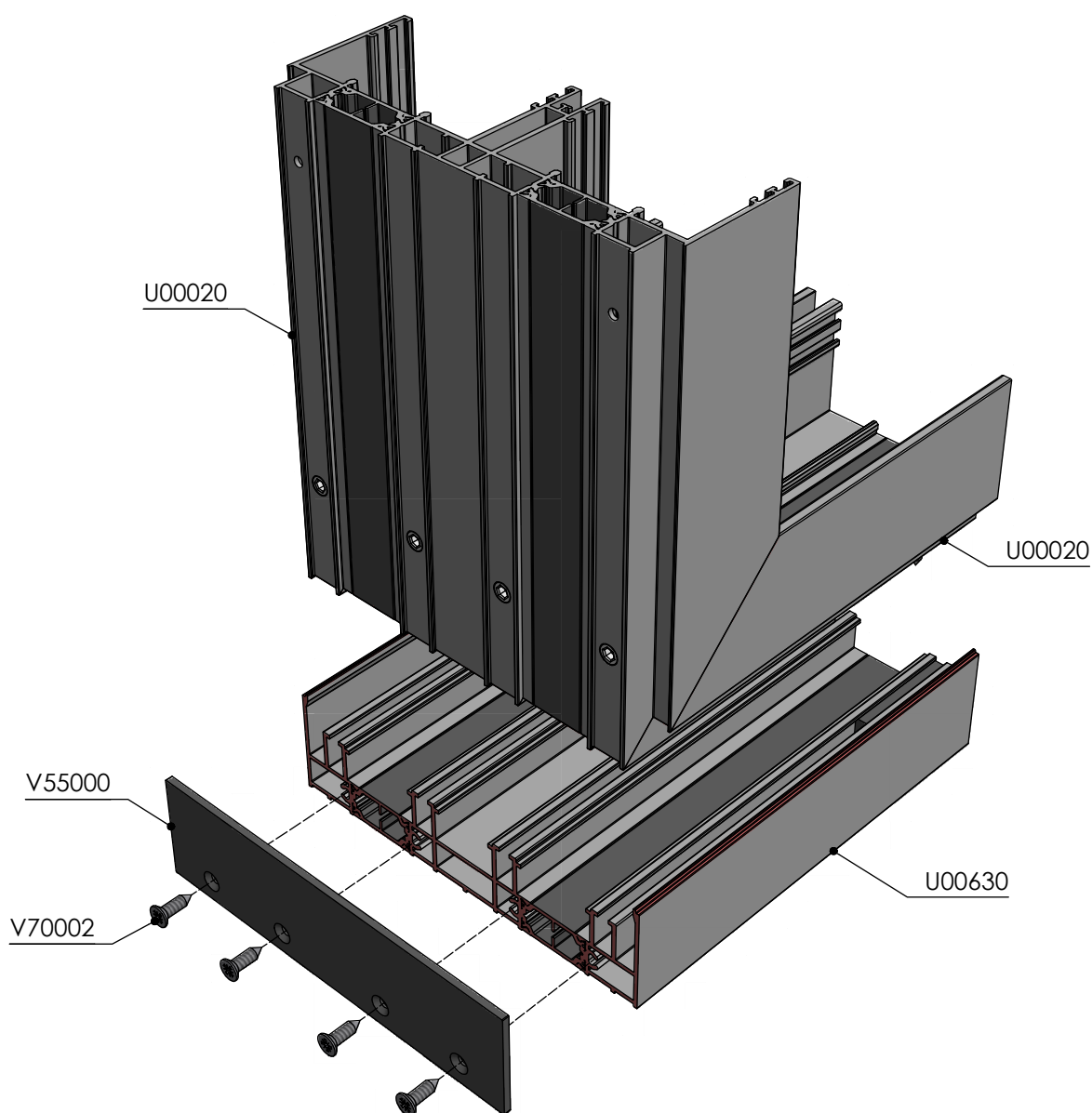
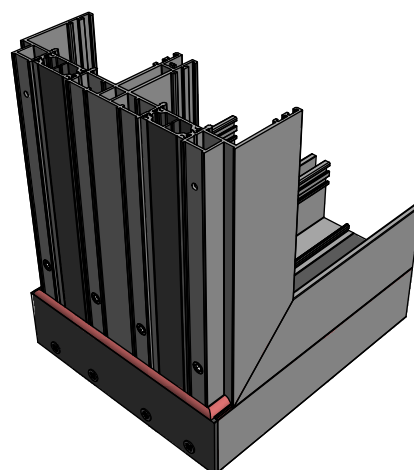
NOTE:

Apply small joint sealant along the edge of the end cap and in each corner.



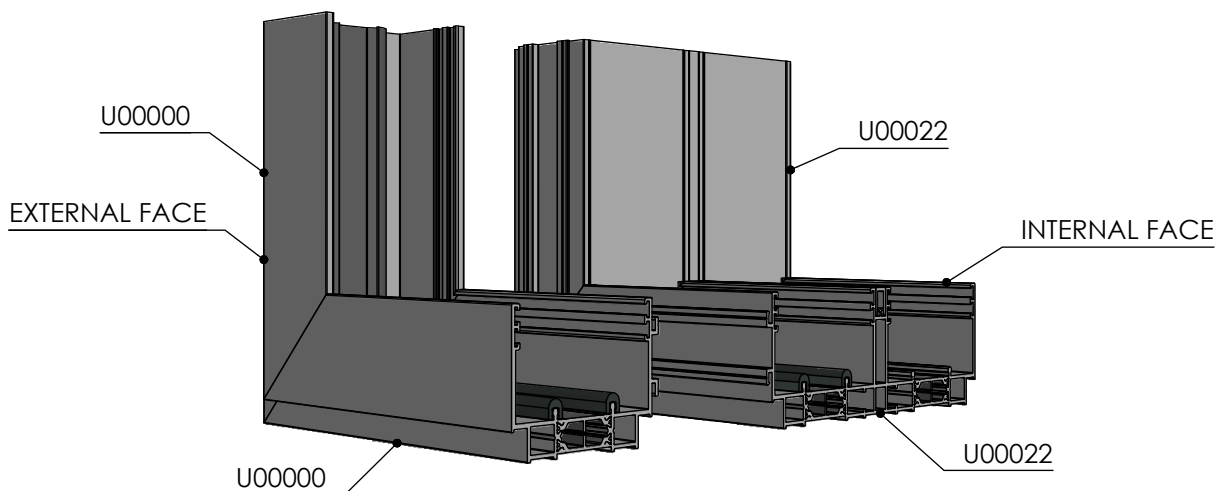
Apply Sealant!

T50000 - T50002



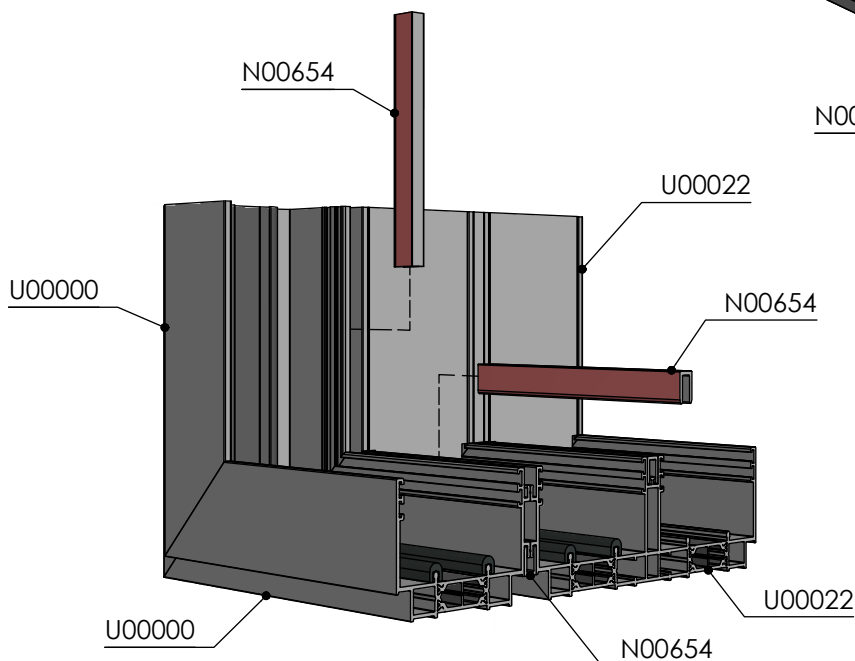
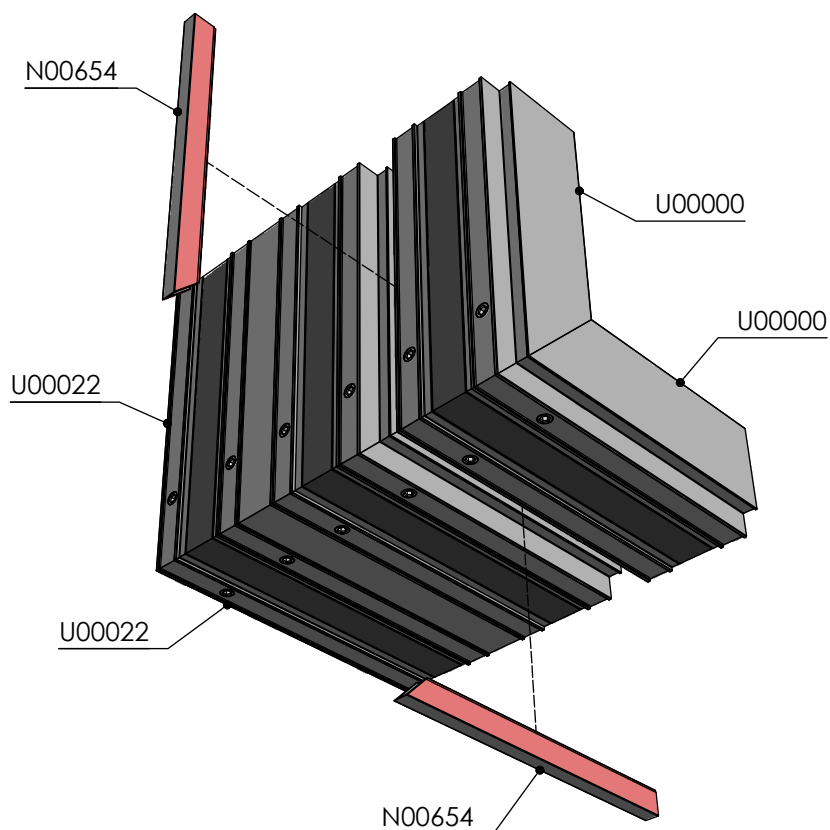
Apply small joint sealant on all corner surfaces before assembling the frame.
Once fixed wipe away any excess sealant using T50003.

➤ U00022 & U00000 - TRIPLE TRACK CILL & JAMB



Apply small joint sealant on all mating surfaces before assembling the frame.

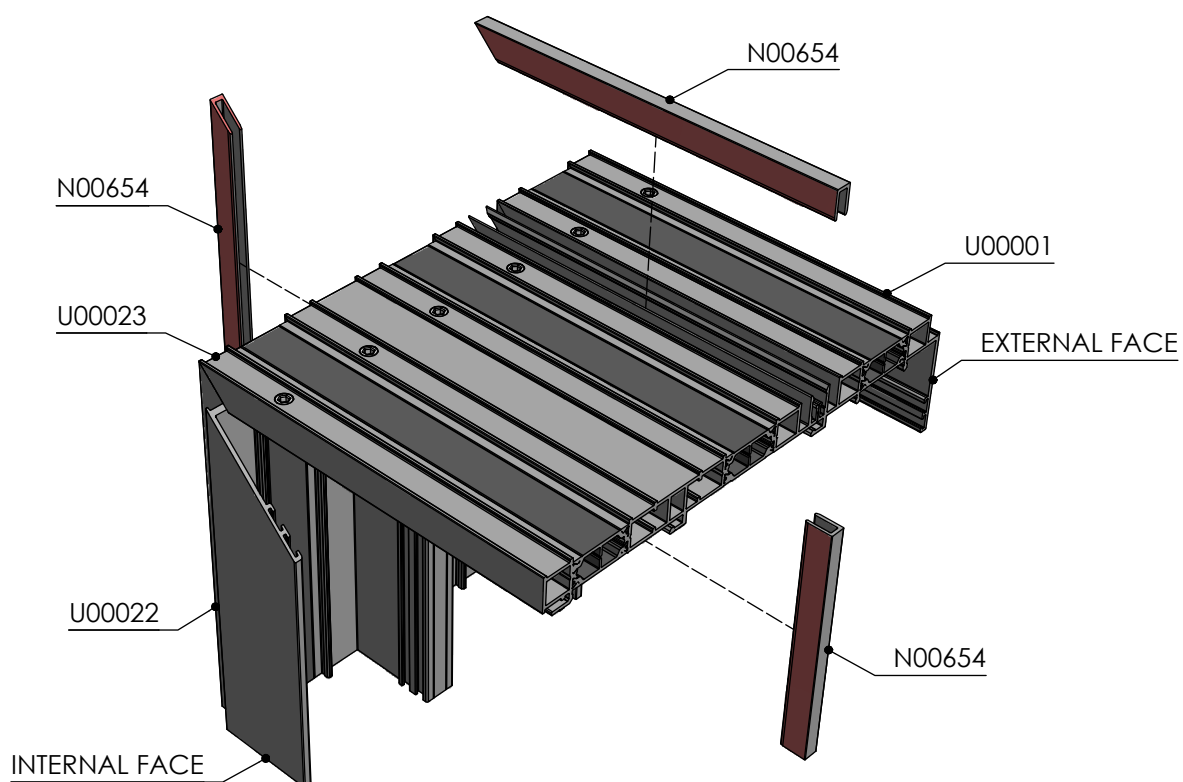
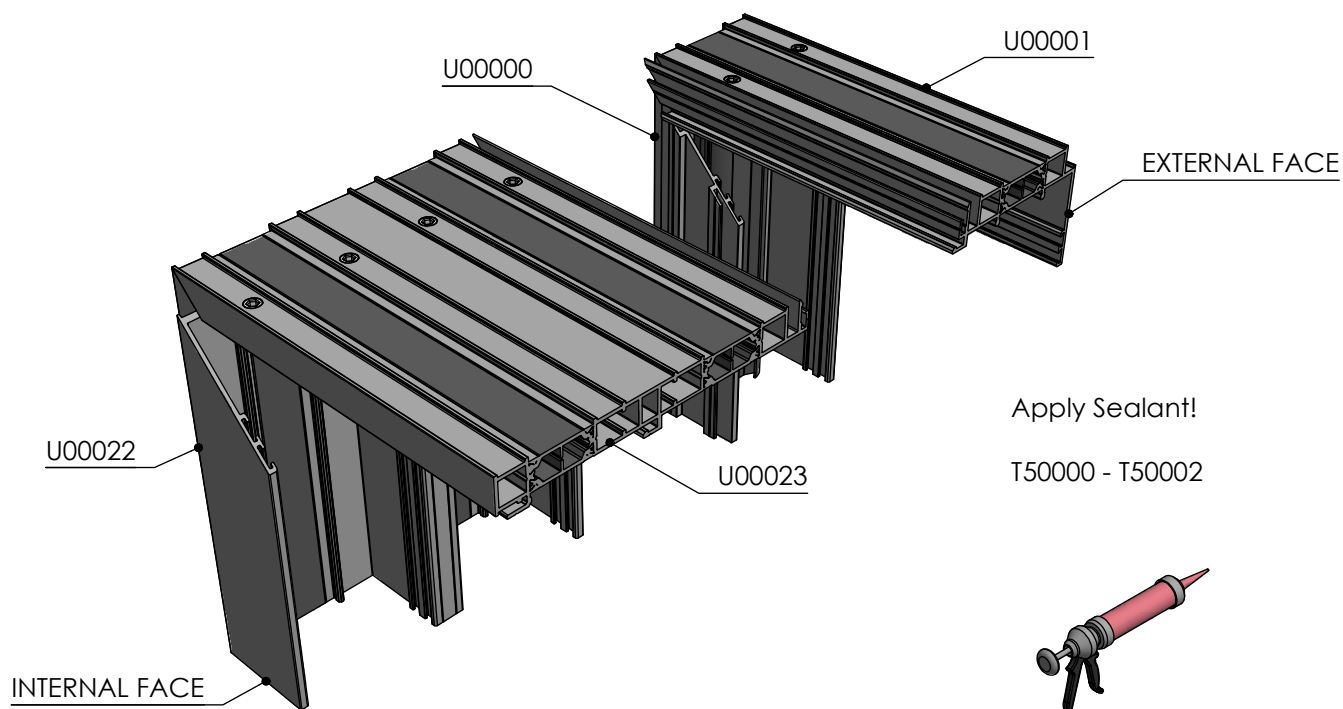
Once fixed wipe away any excess sealant using T50003.



Apply Sealant!

T50000 - T50002

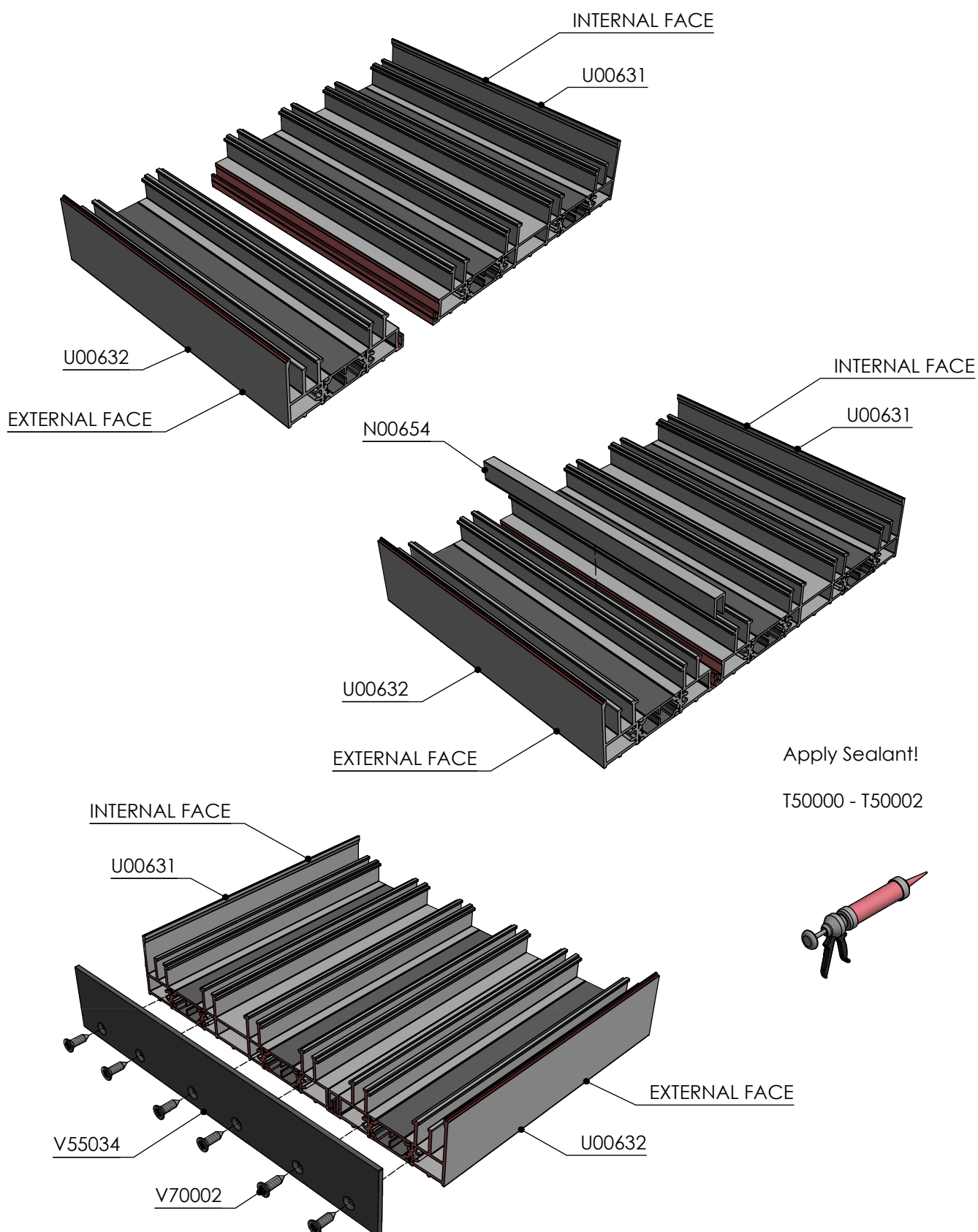
➤ U00022/23, U00000/1 - TRIPLE TRACK HEAD & JAMB



Apply small joint sealant on all mating surfaces before assembling the frame.

Once fixed wipe away any excess sealant using T50003.

➤ U00631 & U00632 - TRIPLE TRACK SUB CILL



Apply small joint sealant on all mating surfaces before assembling the frame.

Once fixed wipe away any excess sealant using T50003.

➤ U00631 & U00632 - SUB CILL ASSEMBLY

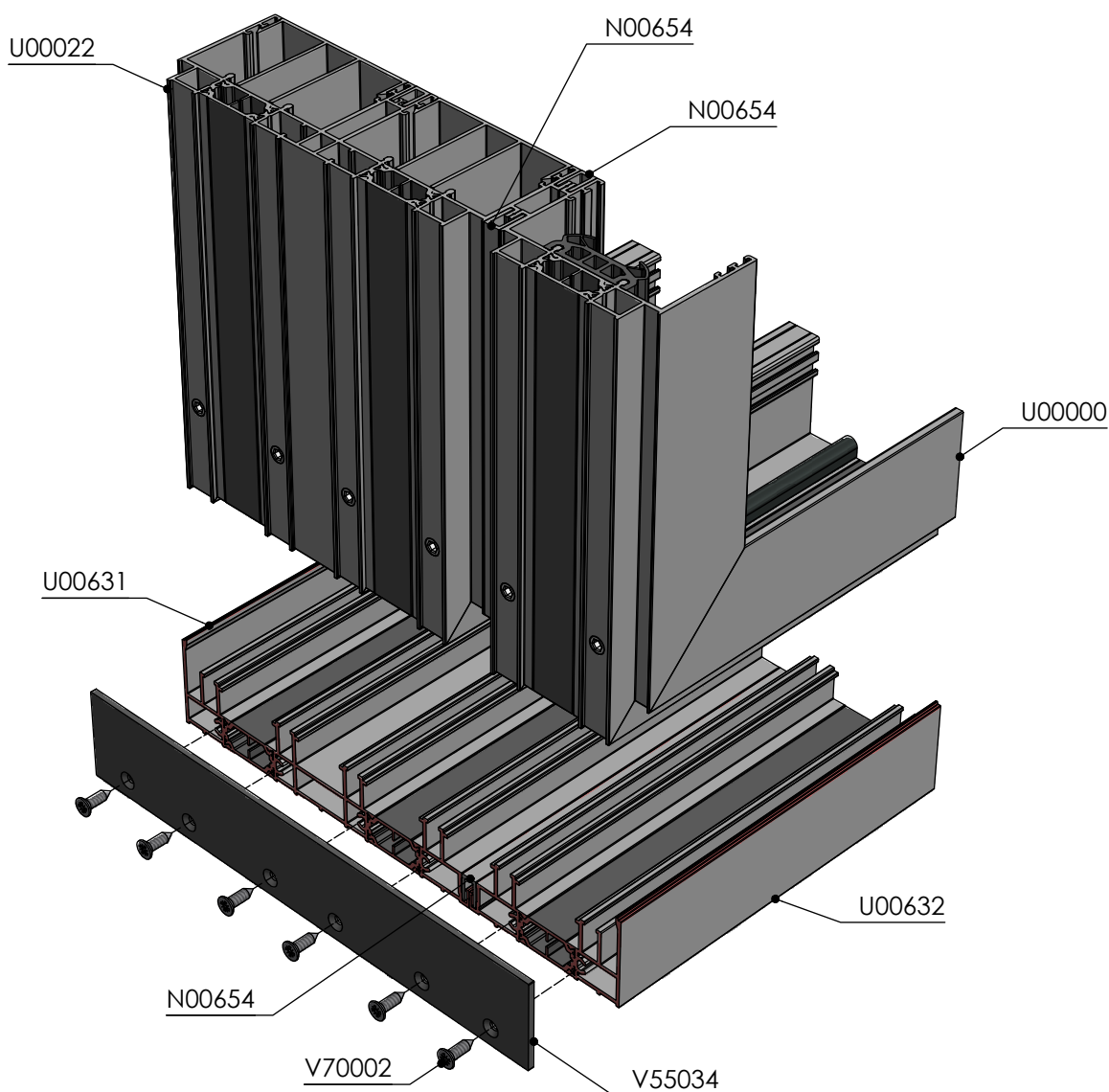
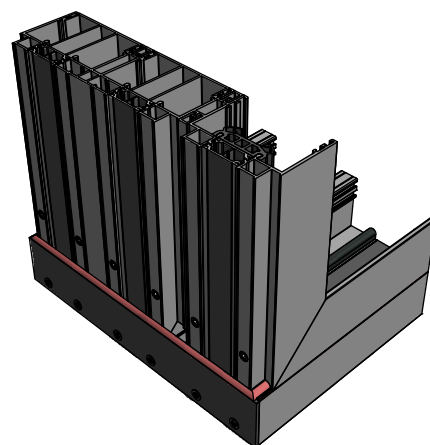
NOTE:

Apply small joint sealant along the edge of the end cap and in each corner.



Apply Sealant!

T50000 - T50002

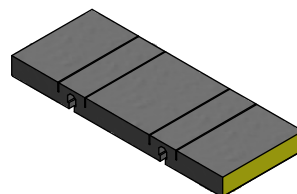
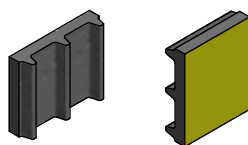


Apply small joint sealant on all corner surfaces before assembling the frame.
Once fixed wipe away any excess sealant using T50003.

➤ V20000 - INTERLOCK FOAM SEAL

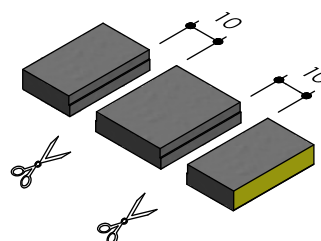
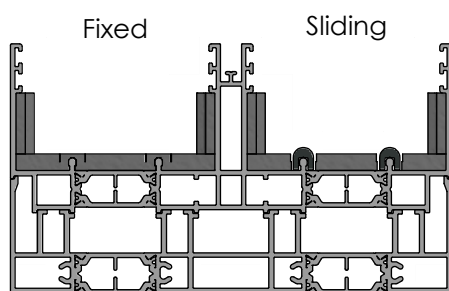
V20000 (Part 2)

Sliding/Fixed



V20000 (Part 1)

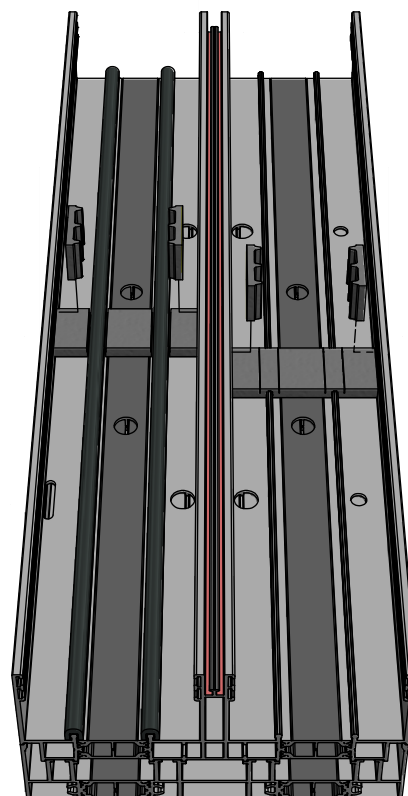
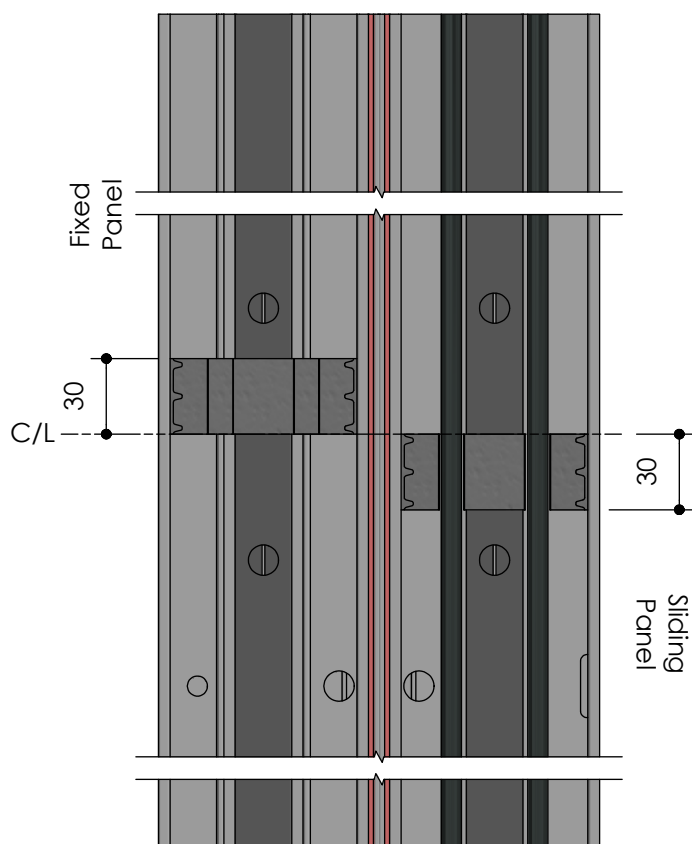
Fixed



V20000 (Part 1)

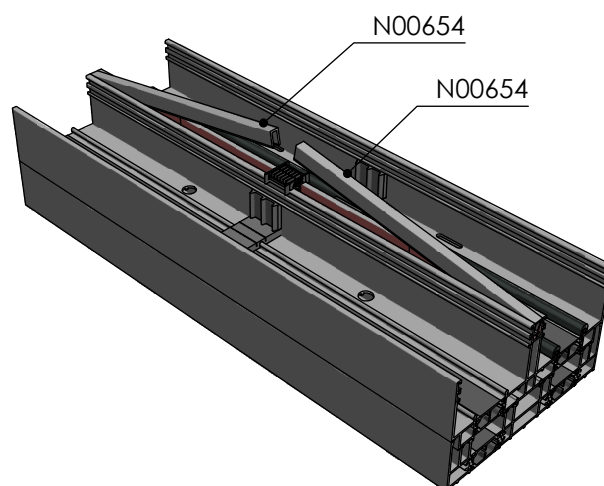
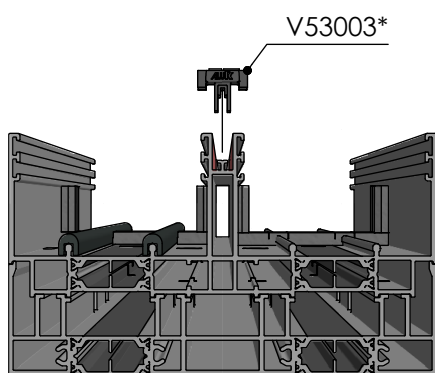
Sliding

Cut along score lines when used with U00632 Track for sliding panels.



NB: Check position of V20000 before removing backing tape and sticking in place.

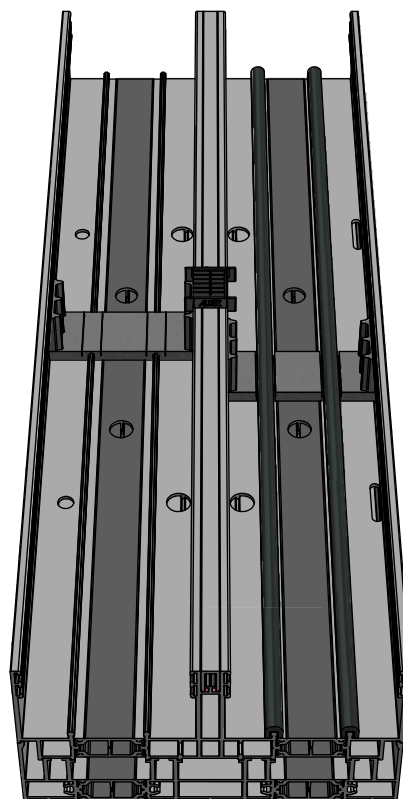
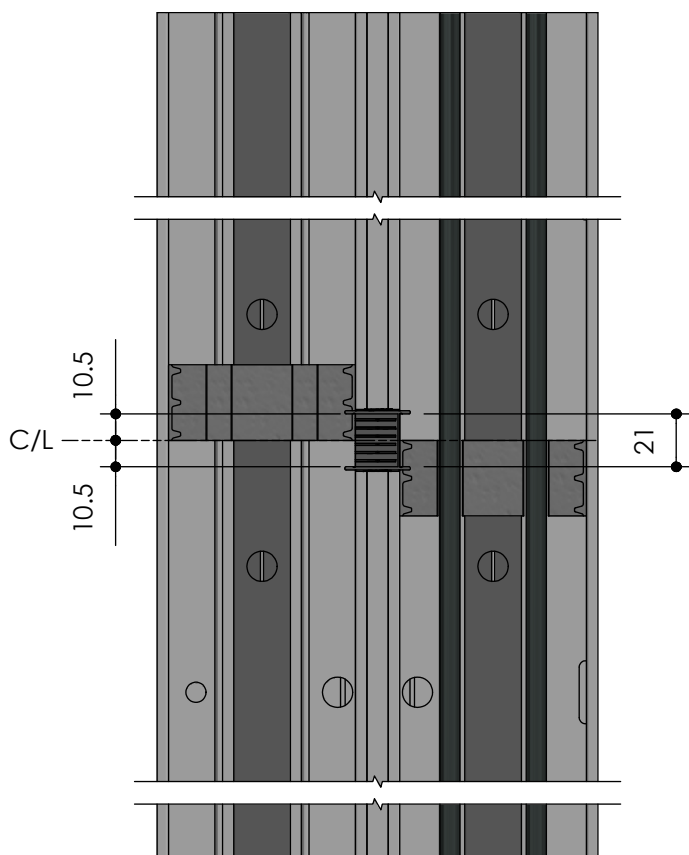
➤ U00020 - V53003 EPDM INTERLOCK SEAL



Apply Sealant!

T50000 - T50002

*Fix interlock mouldings (V53003) in place using cyanoacrylic glue, before applying N00654.



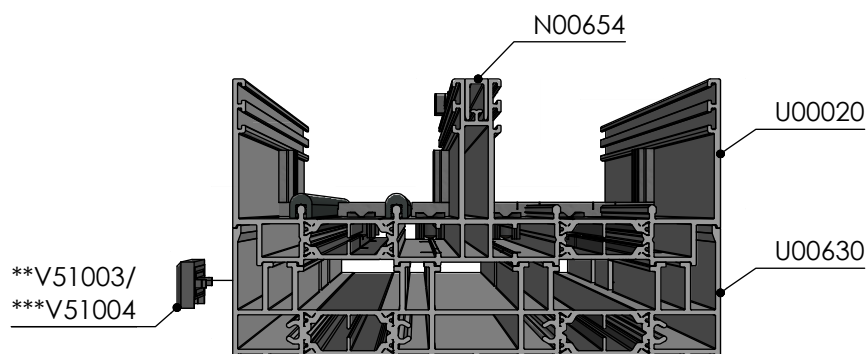
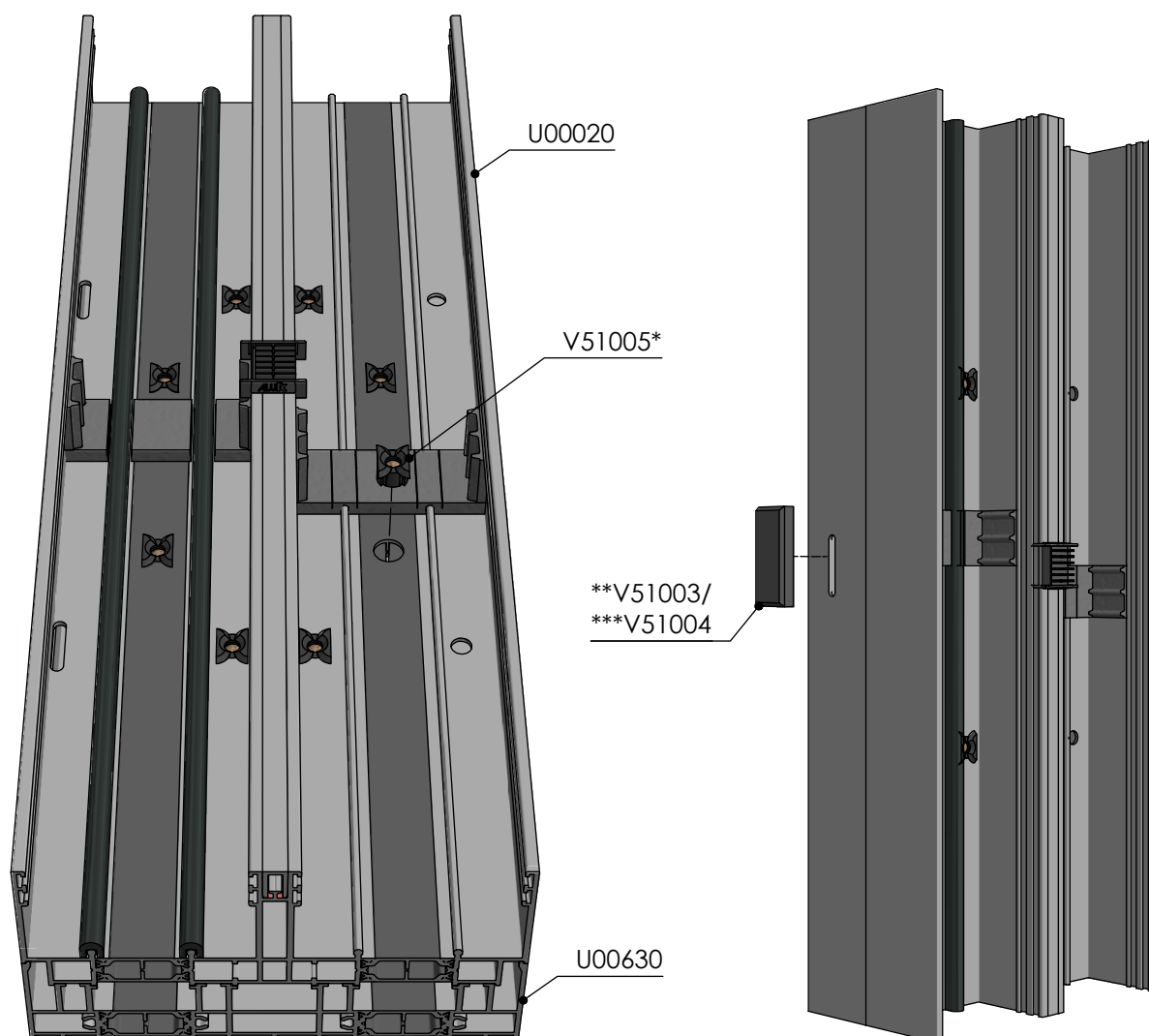
Apply small joint sealant along U-channel before assembling N00654.
Once fixed wipe away any excess sealant using T50003.

➤ U00020 & U00630 - DRAINAGE VALVES

* ALUK GBR CODE: A-00-225

** ALUK ITA CODE: 712007

*** ALUK ITA CODE: 712008



NOTE:

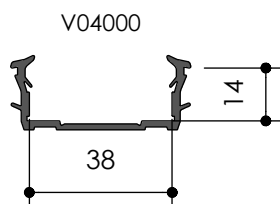
Makesure all drainage valves (V51003, V51004 & V51005) are fitted in appropriate holes/slots.

➤ V04000 - GLAZING GASKET

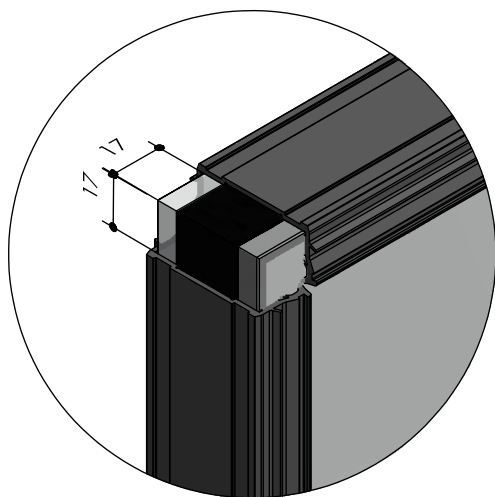
IMPORTANT:

Max/Min. Unit thickness = 38mm

Glazing depth/coverage Min = 14mm



Crop/notch gasket (V04000) at each corner of the unit ensuring the gasket remains in one piece.



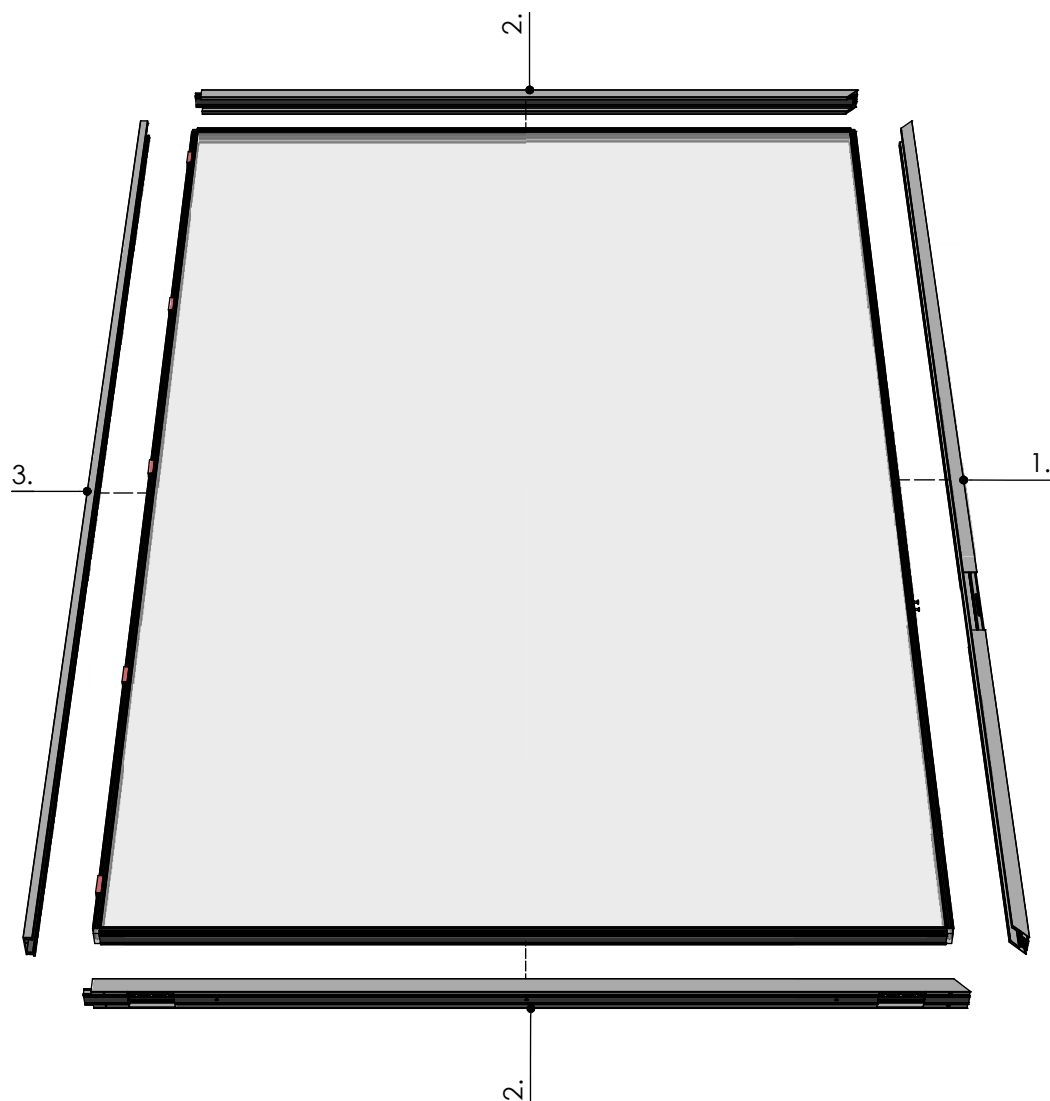
* Cut and join V04000 at the top of the unit using cyanoacrylate glue before assembling the profile.

Failure to join the gasket correctly may cause water ingress or the gasket to move when assembled.

➤ SASH ASSEMBLY METHOD

Installation Procedure:

- Install U00100 (Profiles 1 & 2) around the glass unit and U-gasket (V04000) including cleats etc.
- Install interlock N00120, N00121 Or N00124 (Profile 3).

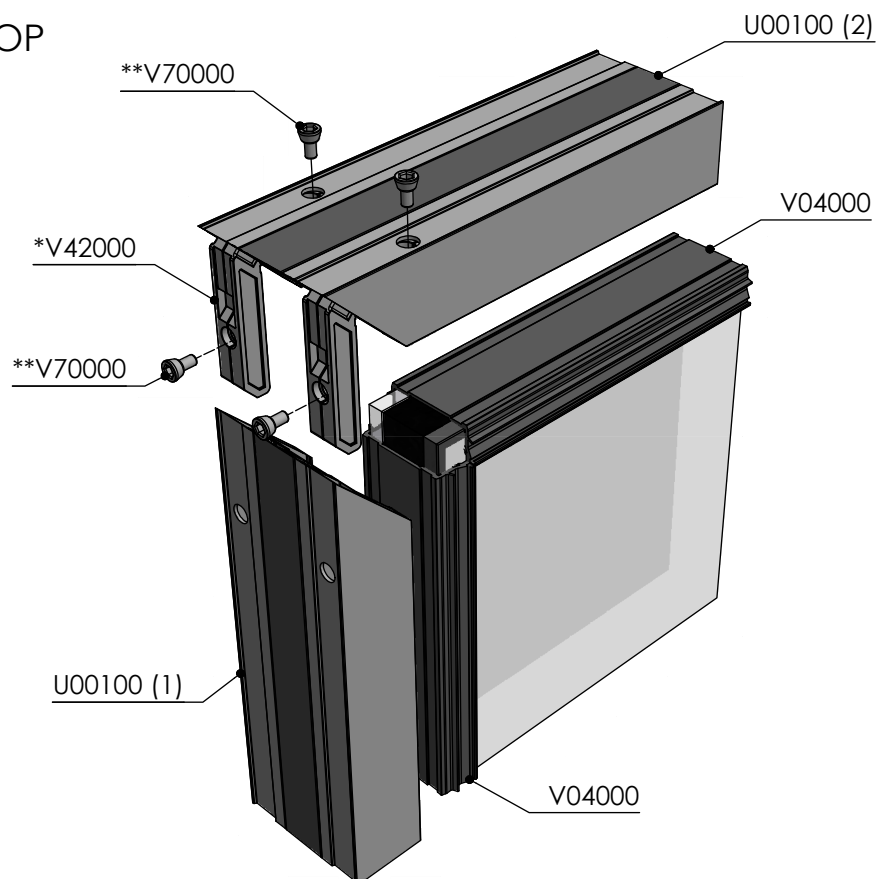


IMPORTANT:

For detail corner sections including accessories and hardware assembly please refer to the pages that following this sheet.

➤ U00100 - CORNER ASSEMBLY

TOP

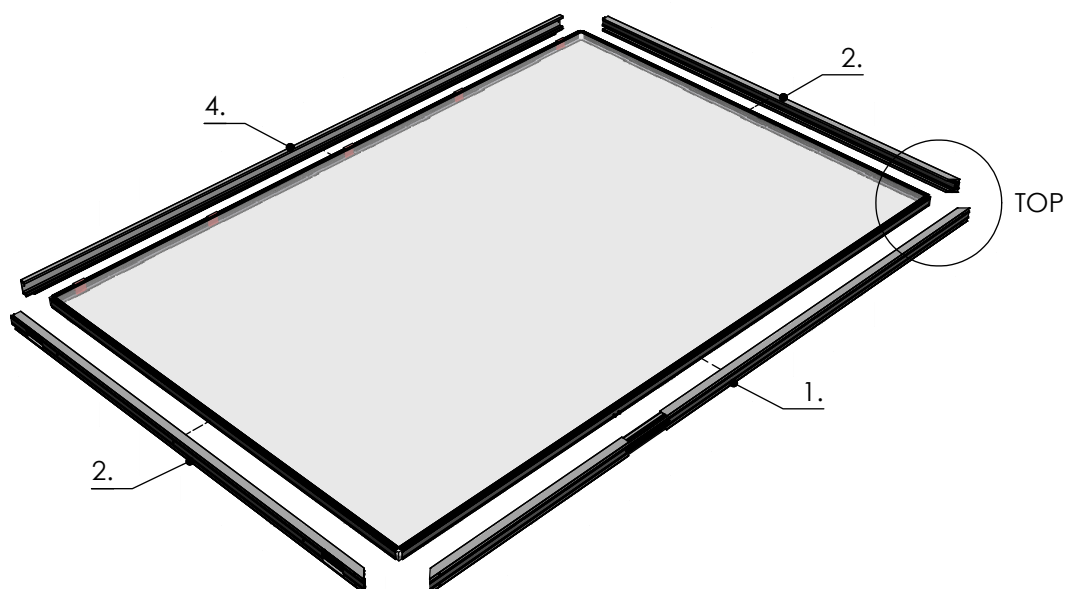


* ALUK FR/GBR CODE: 27500
 ** ALUK FR/GBR CODE: 86720



Apply Sealant!

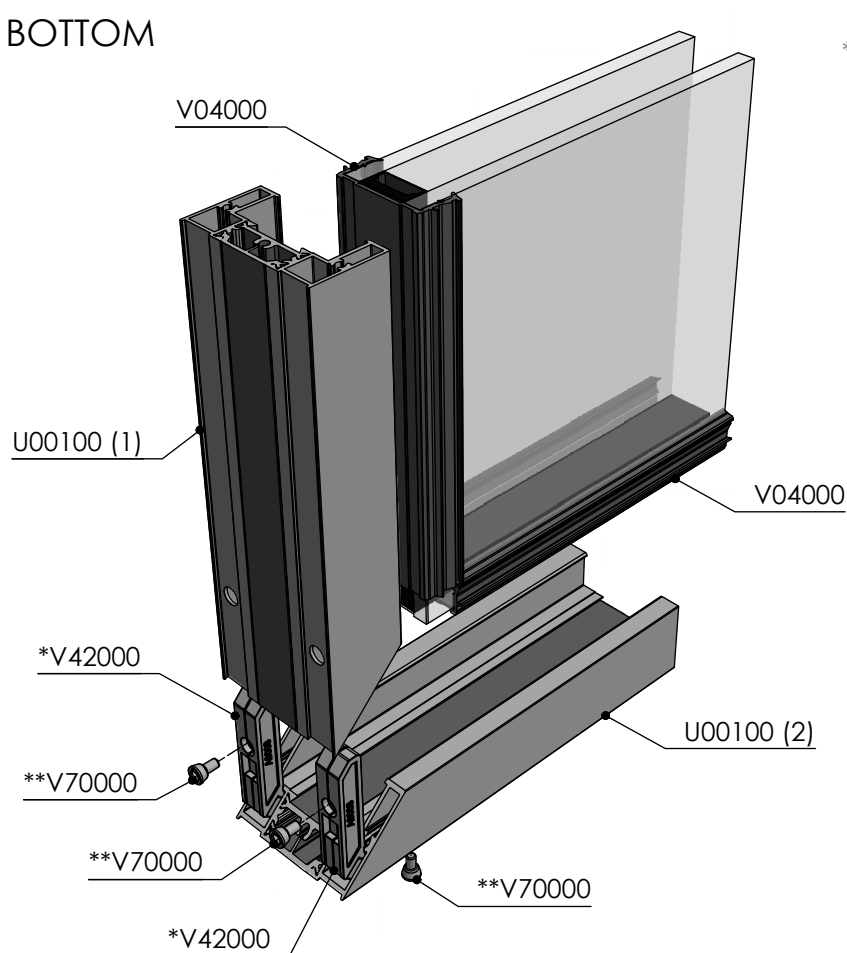
T50000 - T50002



Apply small joint sealant on all corner surfaces before assembling the frame.
 Once fixed wipe away any excess sealant using T50003.

➤ U00100 - CORNER ASSEMBLY

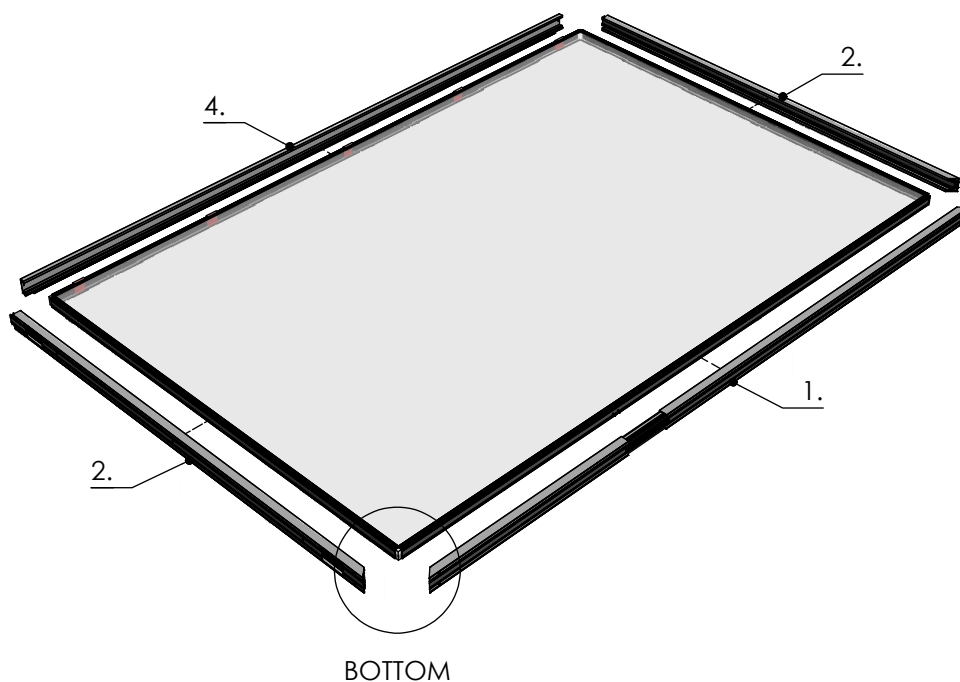
BOTTOM



* ALUK FR/GBR CODE: 27500
** ALUK FR/GBR CODE: 86720



Apply Sealant!
T50000 - T50002



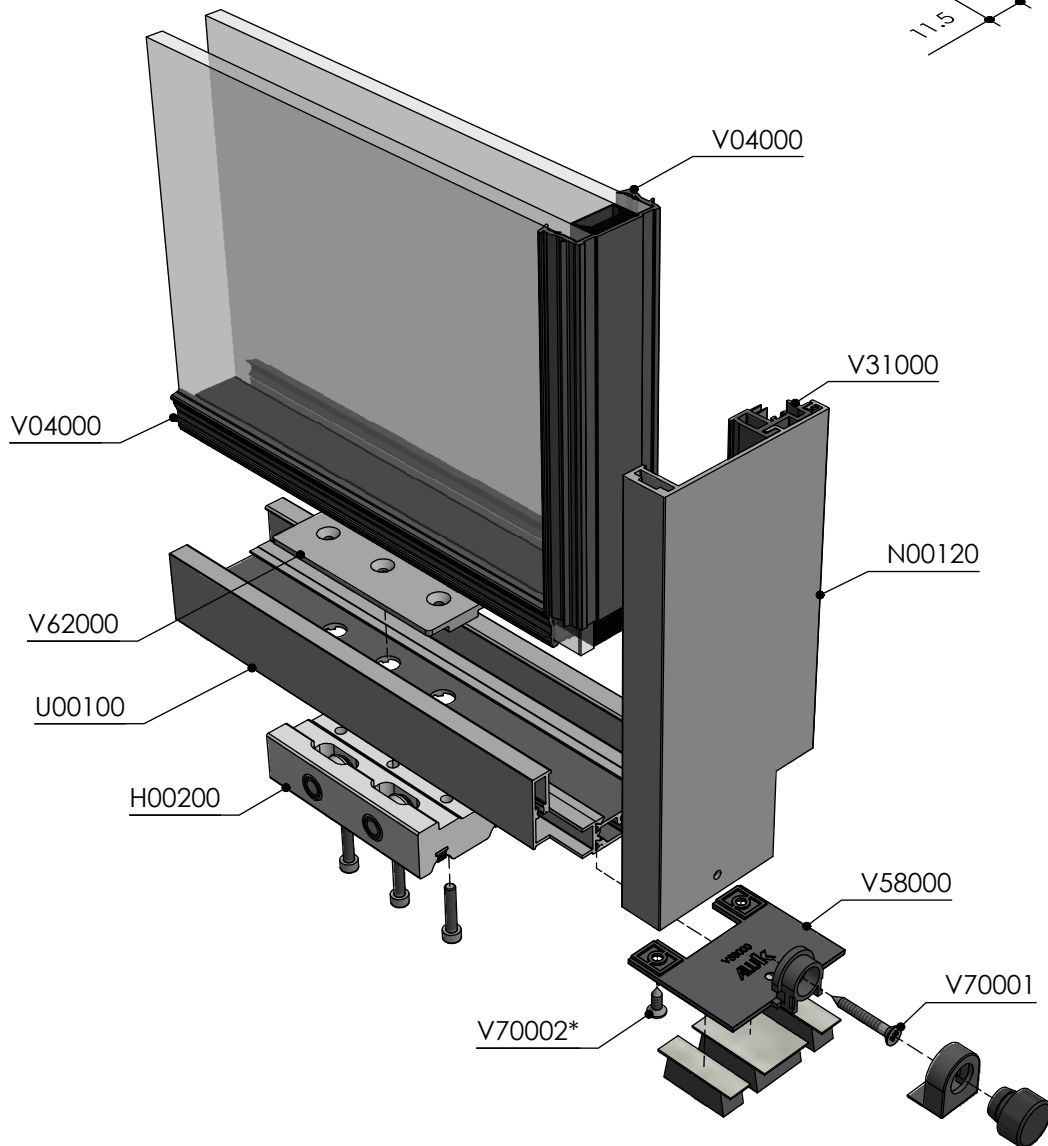
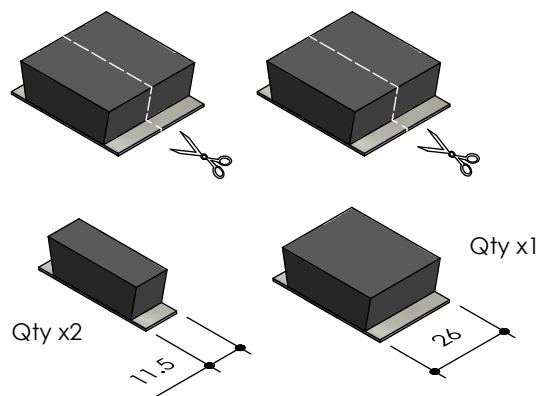
Apply small joint sealant on all corner surfaces before assembling the frame.
Once fixed wipe away any excess sealant using T50003.

➤ U00100, N00120 - SASH & INTERLOCK ASSEMBLY

* ALUK GBR CODE: XS006

NOTE: Cut wool pile before peeling off backing and sticking to V58000 (Sliding panels only).

Part of V58000



Apply Sealant!

T50000 - T50002

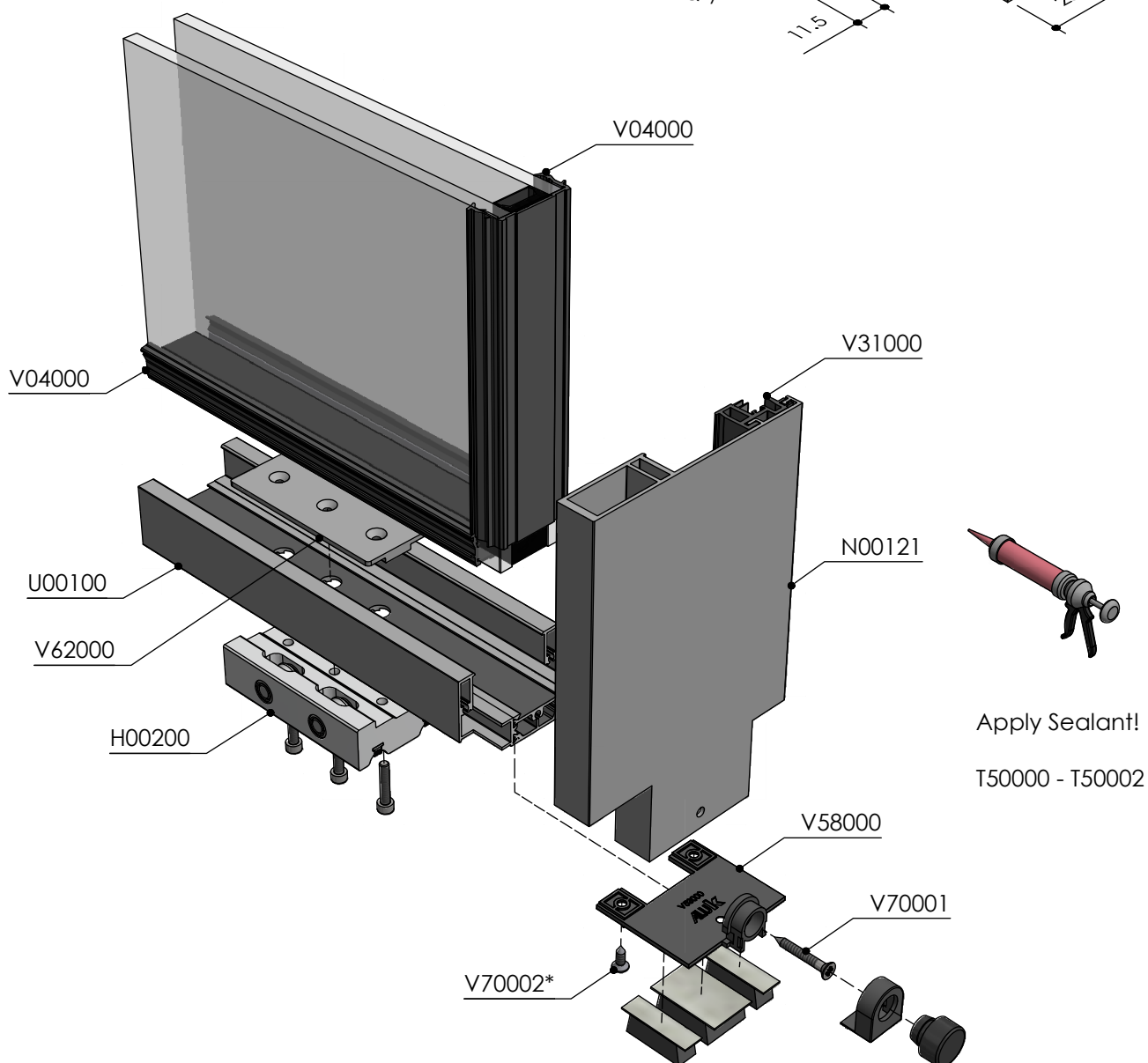
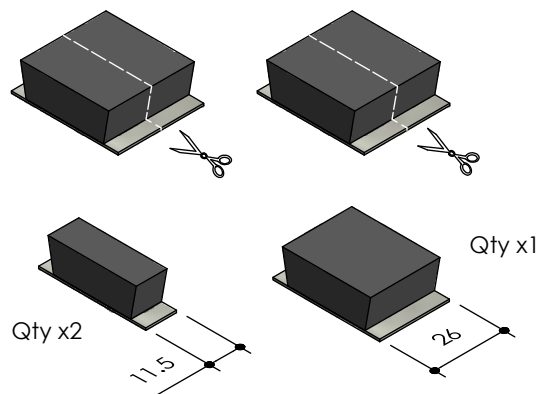
Apply small joint sealant on all corner surfaces before assembling the frame.
Once fixed wipe away any excess sealant using T50003.

➤ U00100, N00121 - SASH & INTERLOCK ASSEMBLY

* ALUK GBR CODE: XS006

NOTE: Cut wool pile before peeling off backing and sticking to V58000 (Sliding panels only).

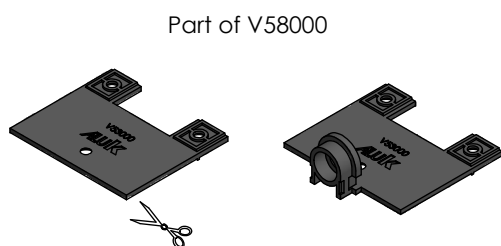
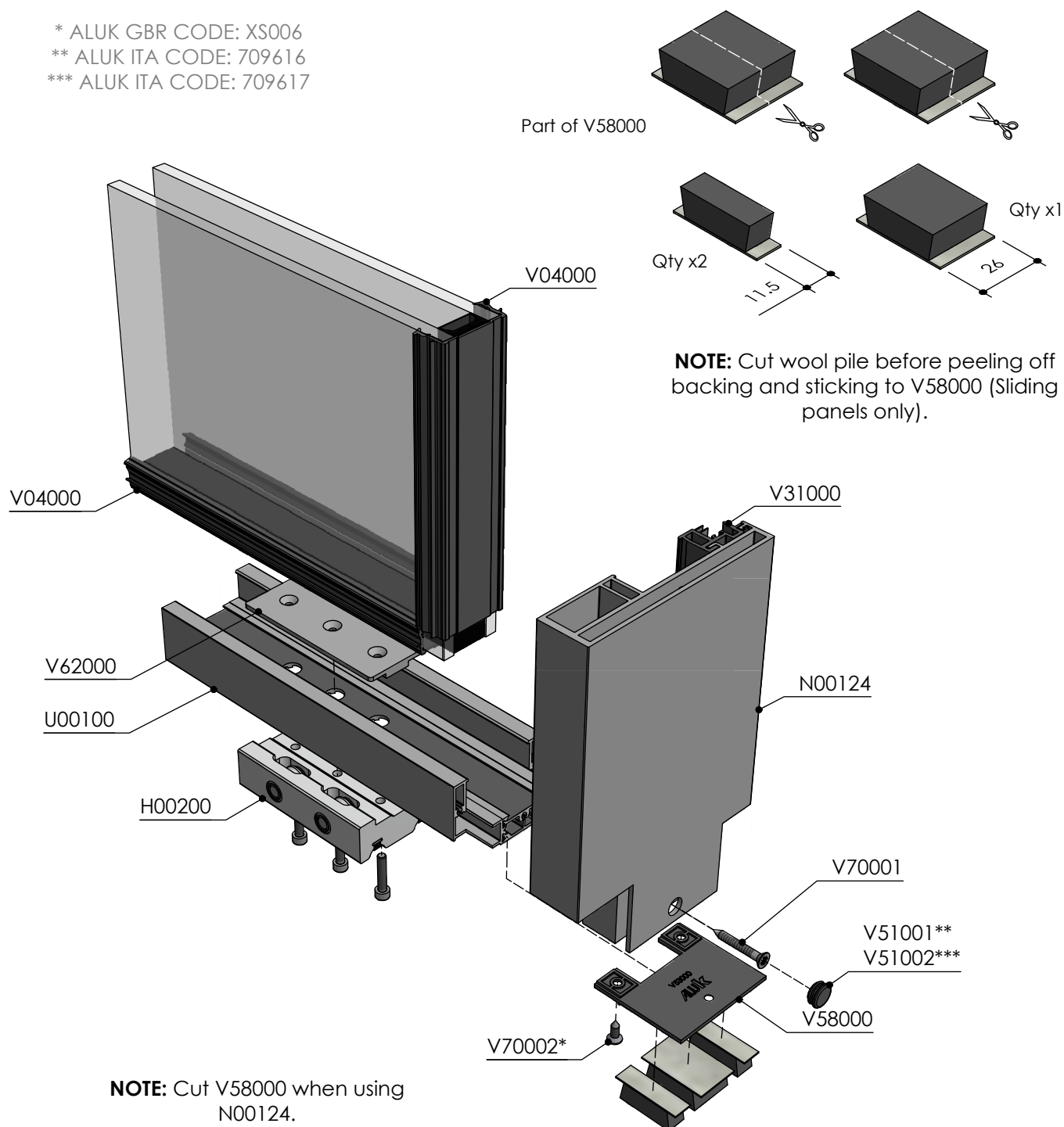
Part of V58000



Apply small joint sealant on all corner surfaces before assembling the frame.
Once fixed wipe away any excess sealant using T50003.

➤ U00100, N00124 - SASH & INTERLOCK ASSEMBLY

* ALUK GBR CODE: XS006
 ** ALUK ITA CODE: 709616
 *** ALUK ITA CODE: 709617



Apply Sealant!
 T50000 - T50002

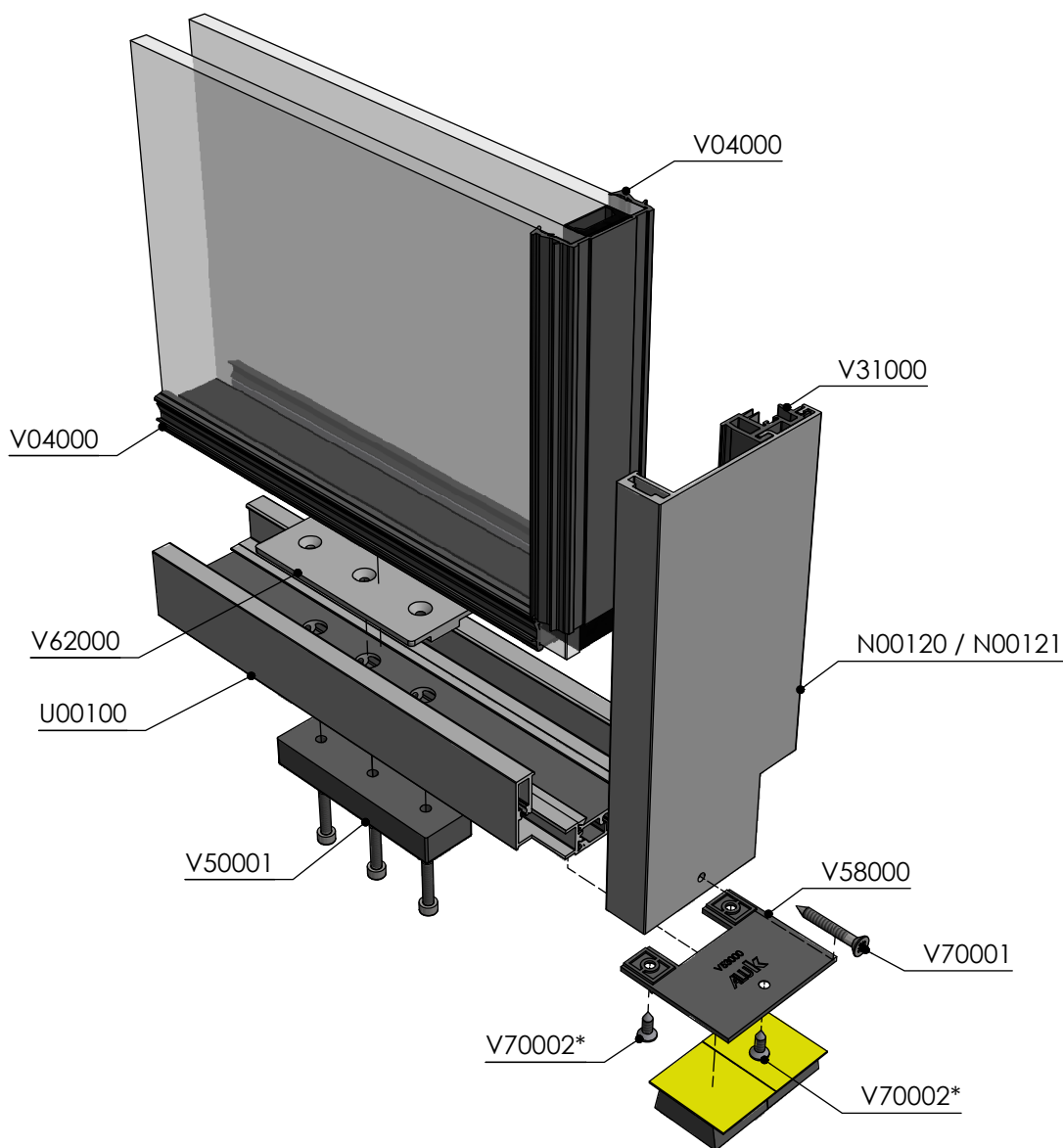
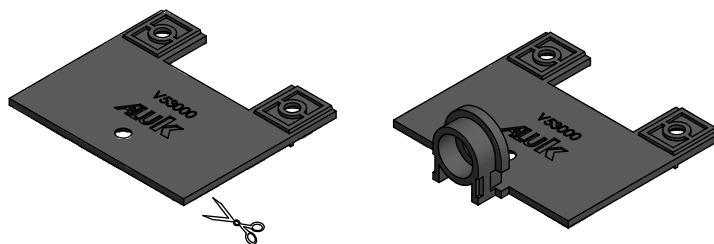
Apply small joint sealant on all corner surfaces before assembling the frame.
 Once fixed wipe away any excess sealant using T50003.

➤ U00100, N00120 - FIXED SASH & INTERLOCK ASSEMBLY

* ALUK GBR CODE: XS006

NOTE: Cut V58000 to avoid N00651 when installed (Fixed panels only).

Part of V58000



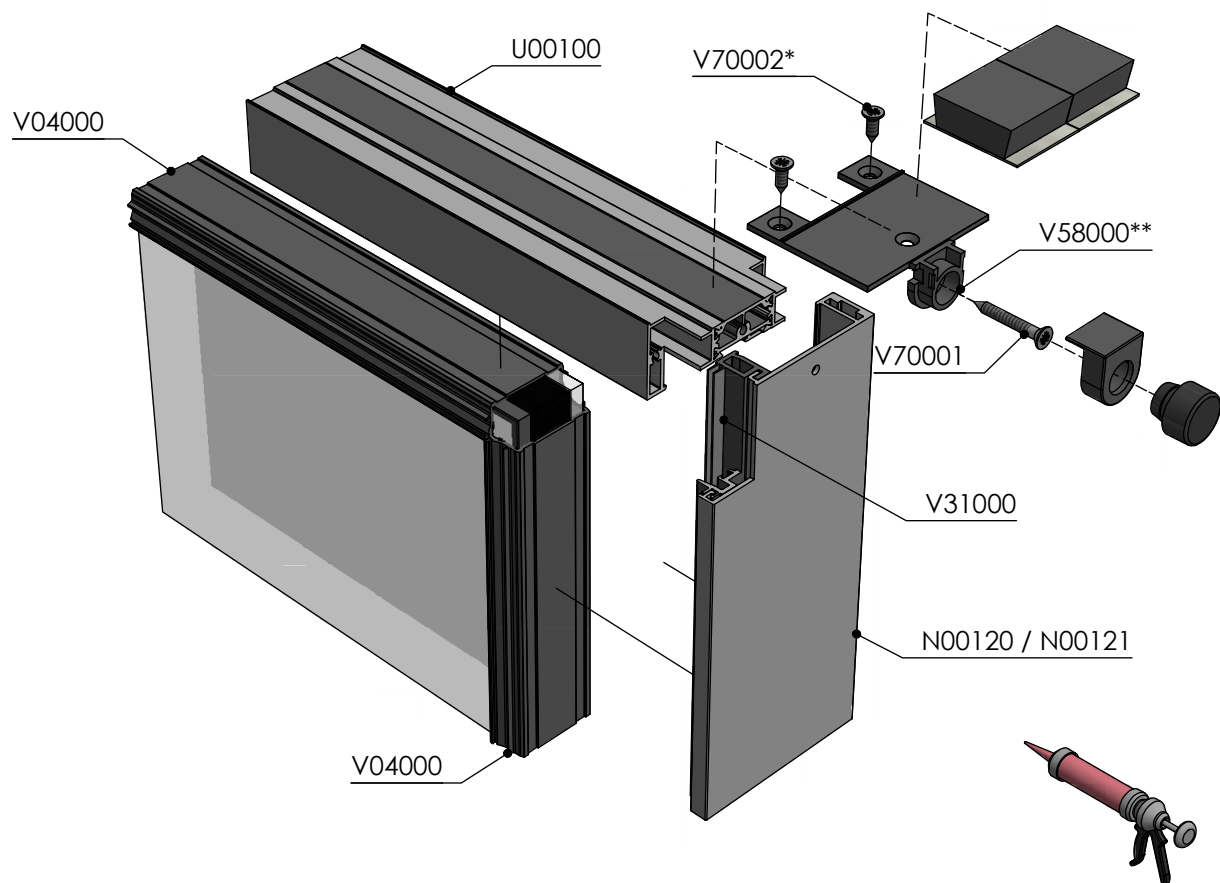
Apply Sealant!

T50000 - T50002

Apply small joint sealant on all corner surfaces before assembling the frame.
Once fixed wipe away any excess sealant using T50003.

➤ U00100, N00120 - SASH & INTERLOCK ASSEMBLY

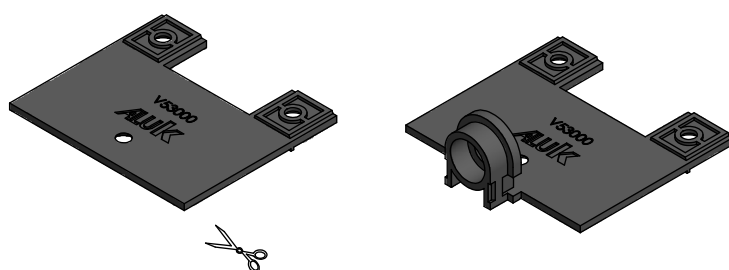
* ALUK GBR CODE: XS006



Part of V58000

Apply Sealant!

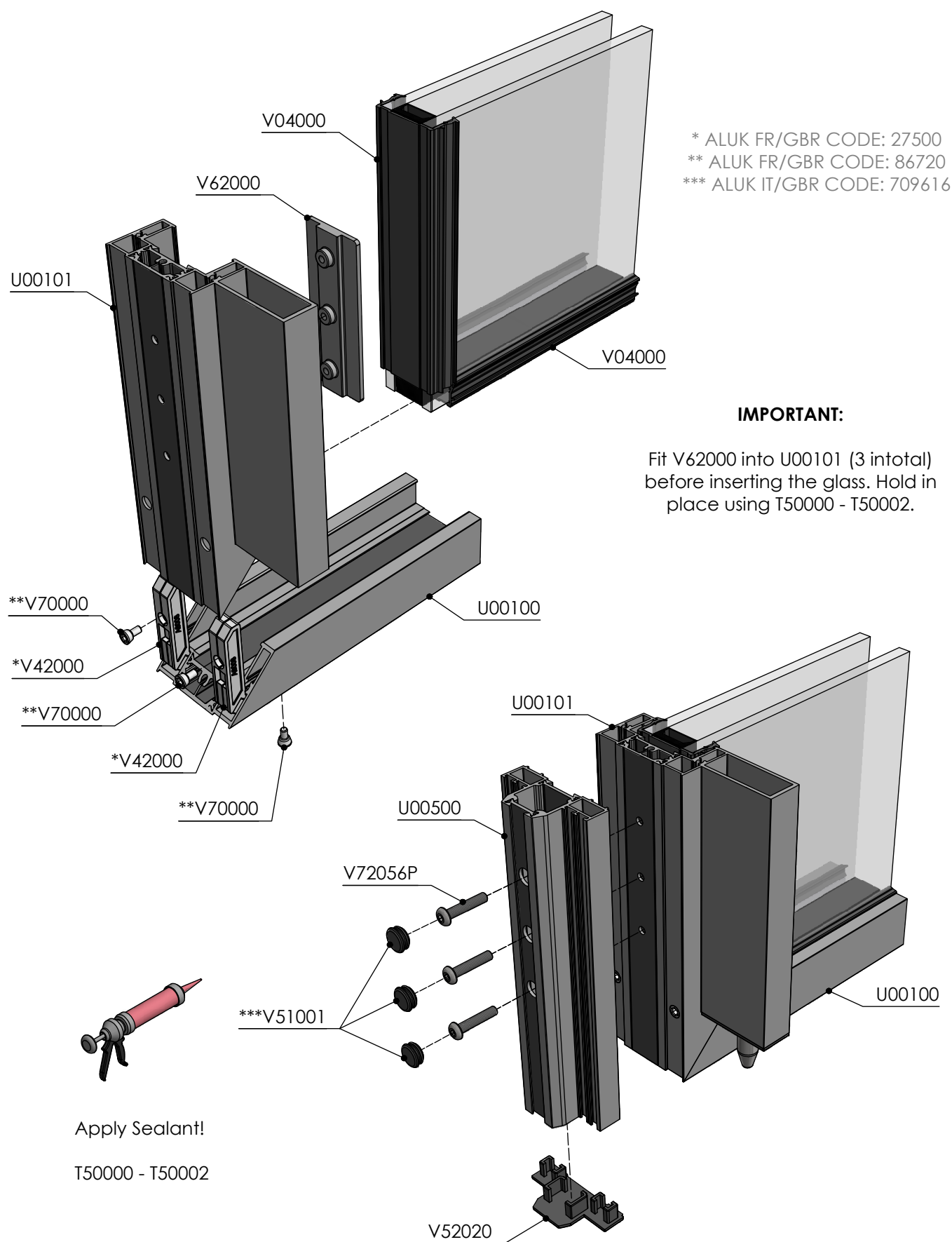
T50000 - T50002



**Cut V58000 to avoid N00651
when installed (Fixed panels
only).

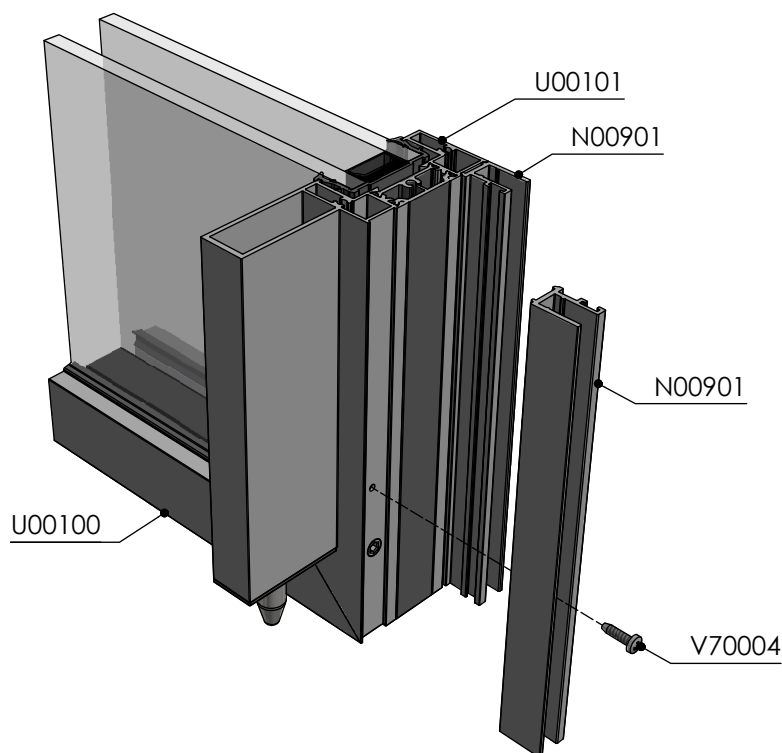
Apply small joint sealant on all corner surfaces before assembling the frame.
Once fixed wipe away any excess sealant using T50003.

➤ U00101 & U00500 - 90 DEG. CORNER & OXXO MEETING STYLE

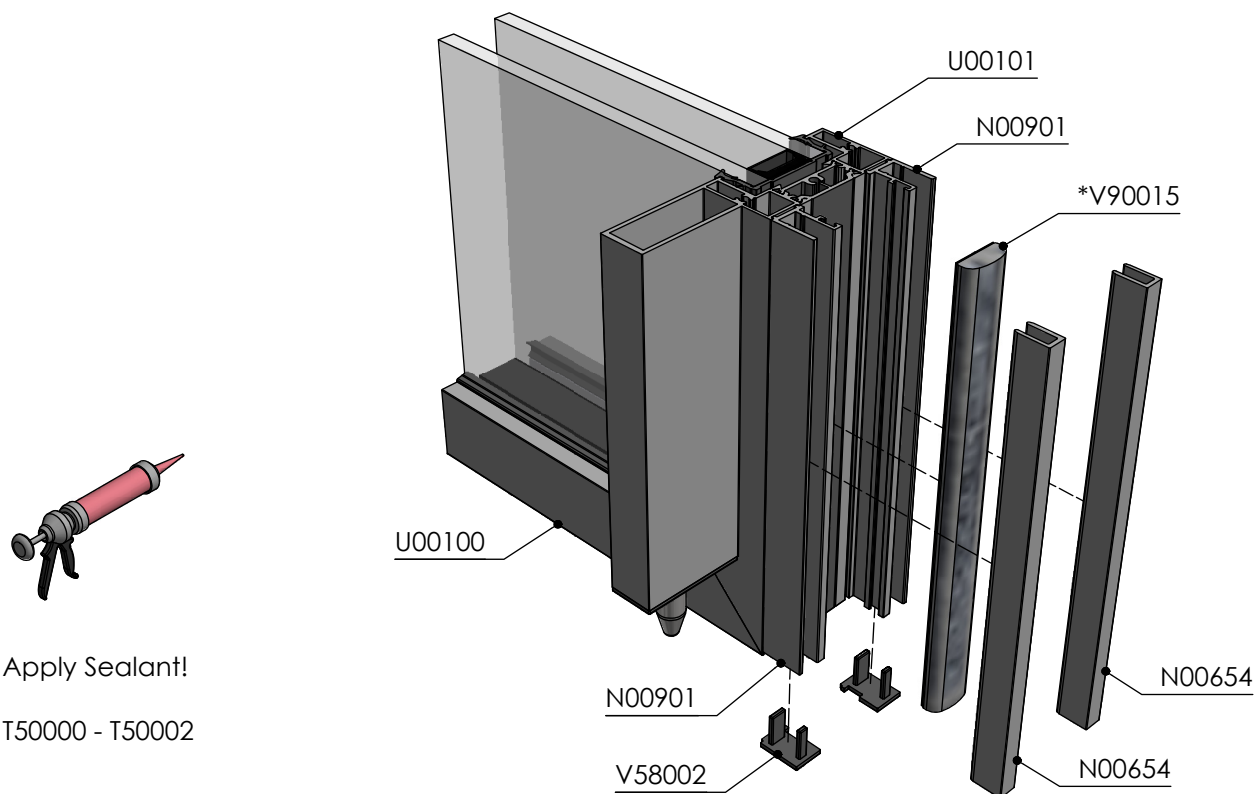


Apply small joint sealant on all mating surfaces before assembling the frame.
 Once fixed wipe away any excess sealant using T50003.

➤ U00101 & N00901 - SLAVE OXXO DOOR

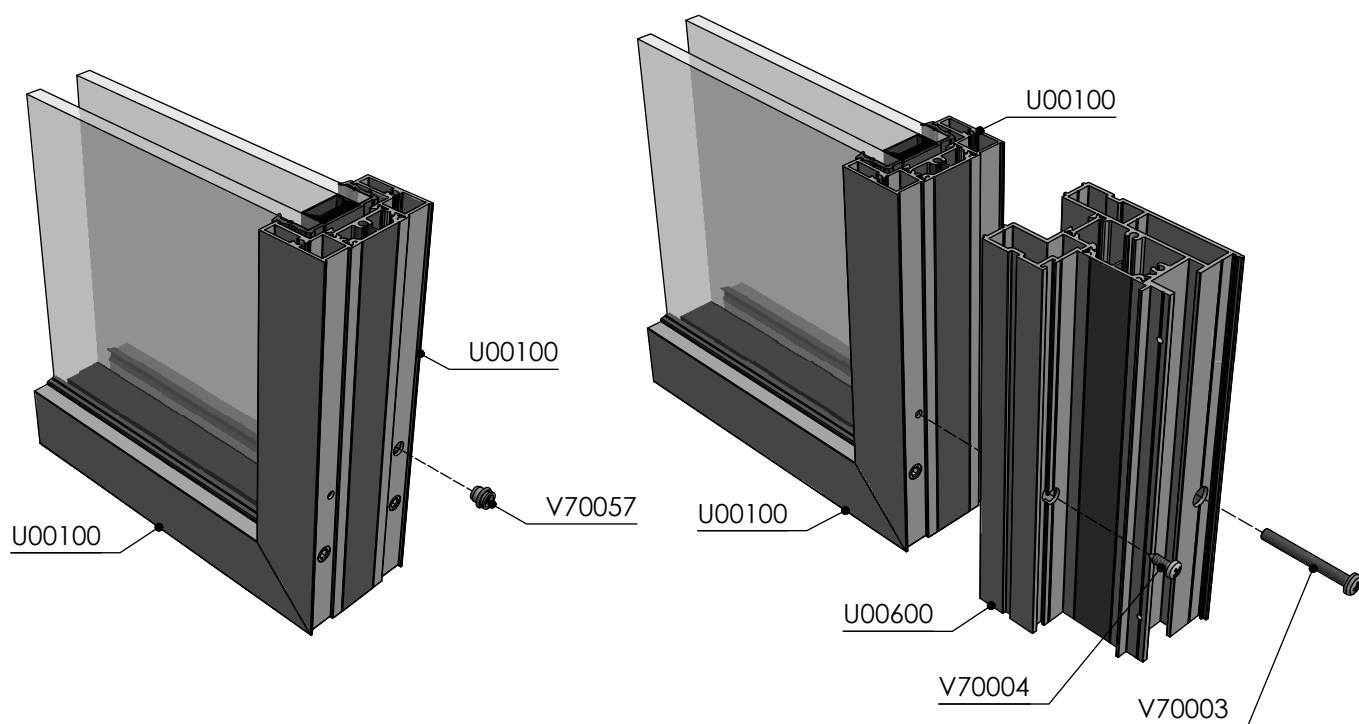


*ALUK IT/GBR CODE: 809688



Apply small joint sealant on all mating surfaces before assembling the frame.
Once fixed wipe away any excess sealant using T50003.

➤ U00100 & U00600 - 90 DEG. CORNER POST

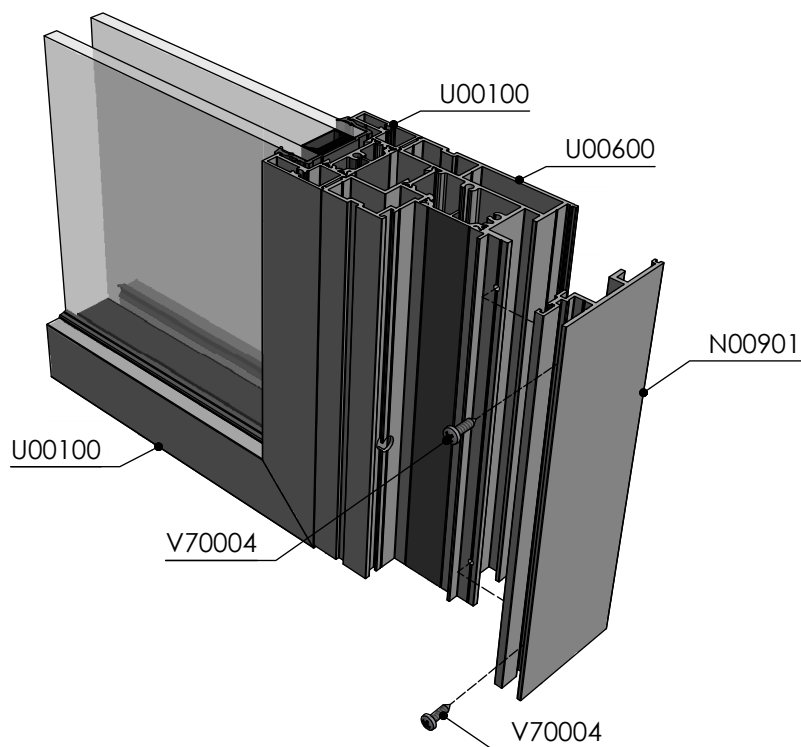
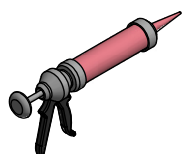


IMPORTANT:

Fit V70057 to external side of the sash only.

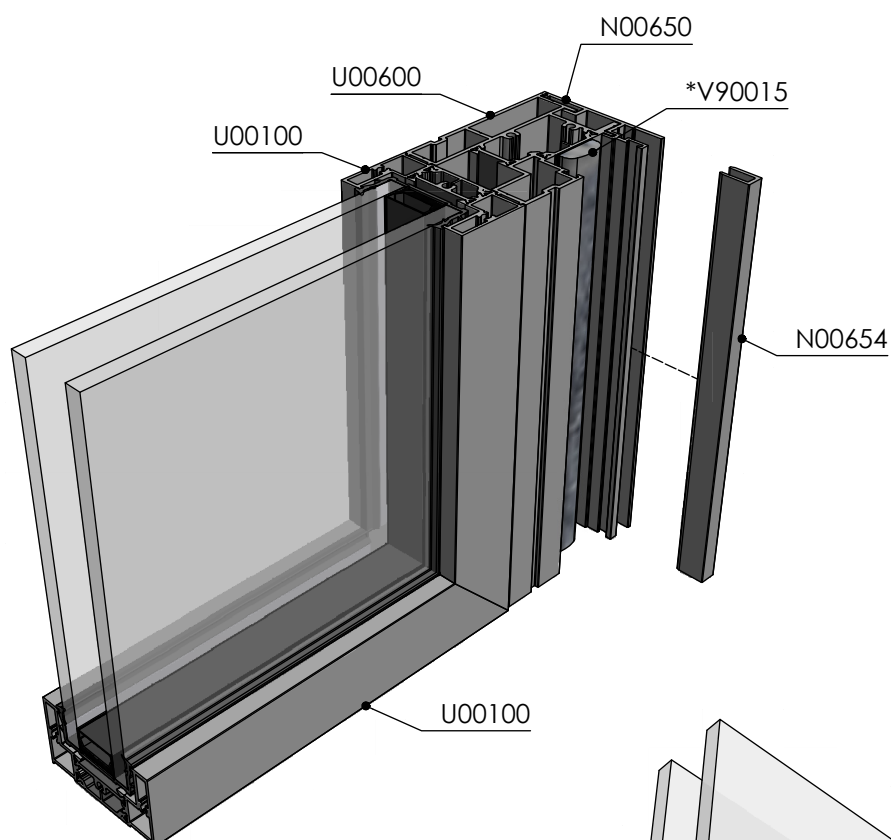
Apply Sealant!

T50000 - T50002



Apply small joint sealant on all mating surfaces before assembling the frame.
Once fixed wipe away any excess sealant using T50003.

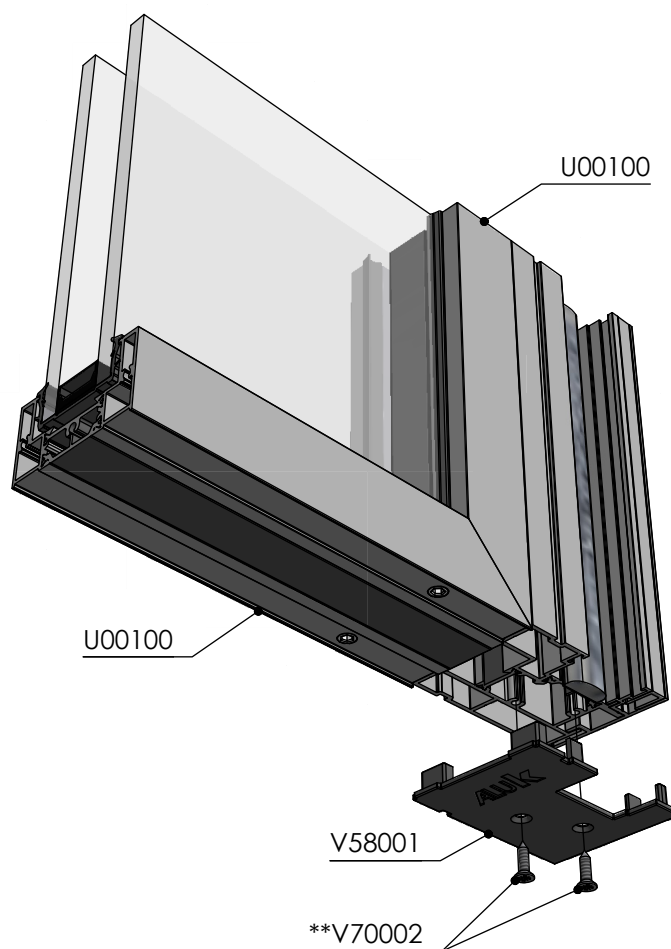
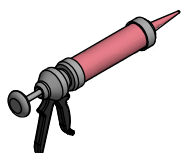
➤ U00100 & U00600 - 90 DEG. CORNER POST CONT.



*ALUK IT/GBR CODE: 809688
**ALUK GBR CODE: XS006

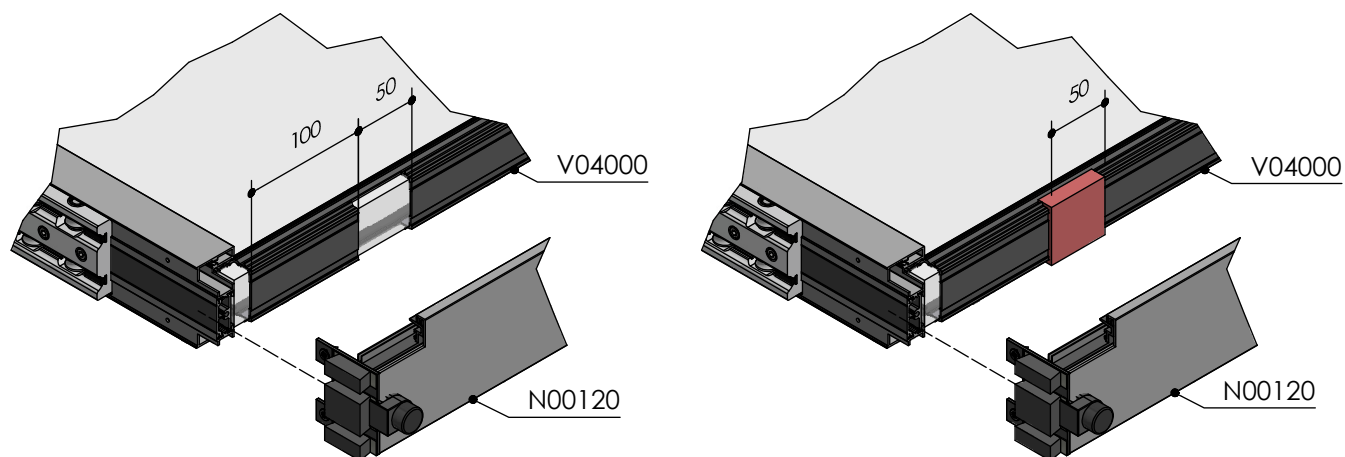
Apply Sealant!

T50000 - T50002



Apply small joint sealant on all mating surfaces before assembling the frame.
Once fixed wipe away any excess sealant using T50003.

➤ T50004 - BONDED HANDLE / INTERLOCK (OPTIONAL)

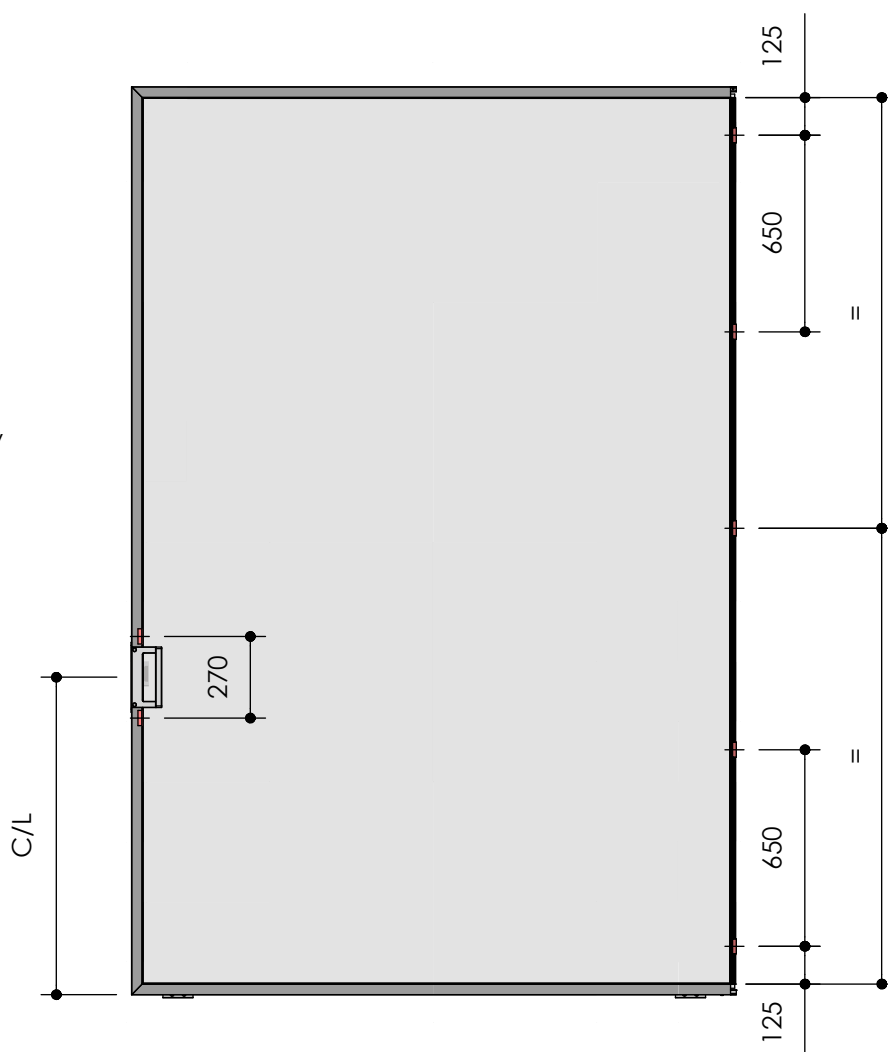


NOTE:

For additional strength/tightness apply T50004 along the interlock and around the handle, by cropping 50mm from V04000 at the following intervals:



T50004



T50004 is NOT required as a standard and is only offered for additional strength/adhesion when applying the interlock profile N00120/N00121/N00124 and handle (H00100 & H00101).

***IMPORTANT:**

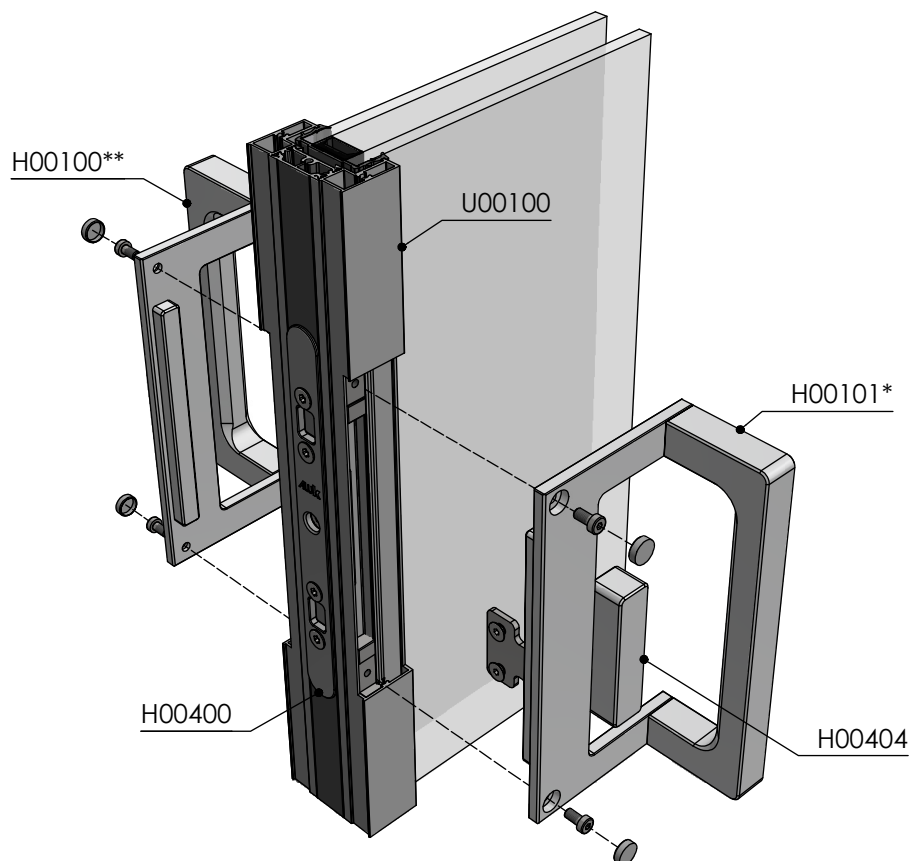
H00400 backing plate must be fitted before glazing.



Fit H00404 (Lever) into H00100 by removing the stainless steel plate before assembling the handles.

Also applicable to U00102

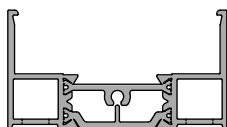
➤ U00100, H00100, H00101 - HANDLE ASSEMBLY



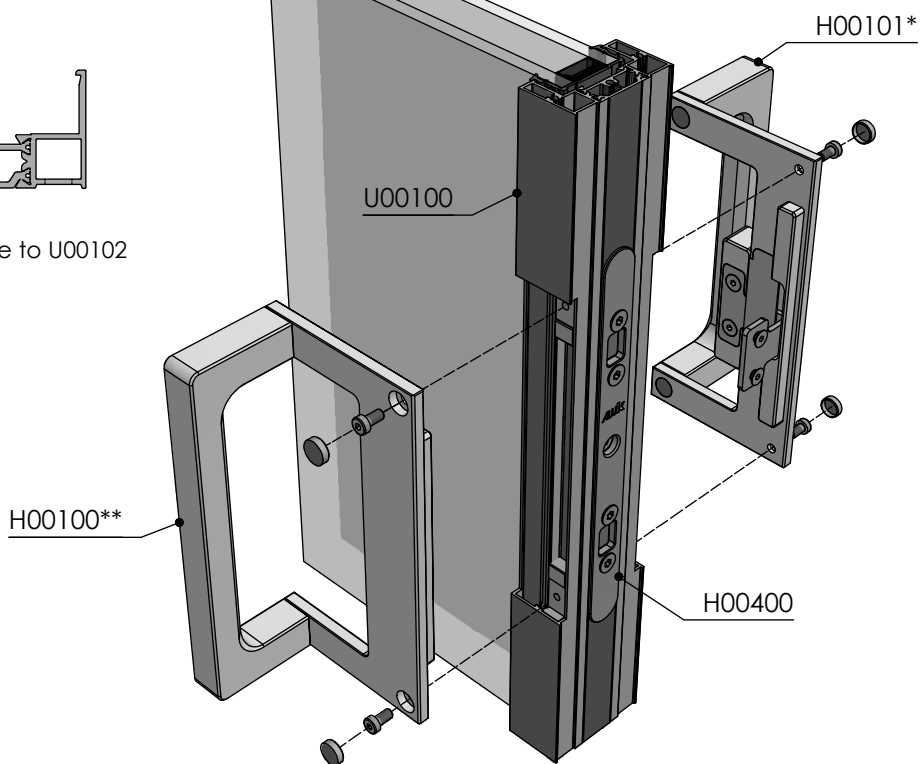
NOTE:

** External Handle ONLY!

* Internal Handle ONLY!

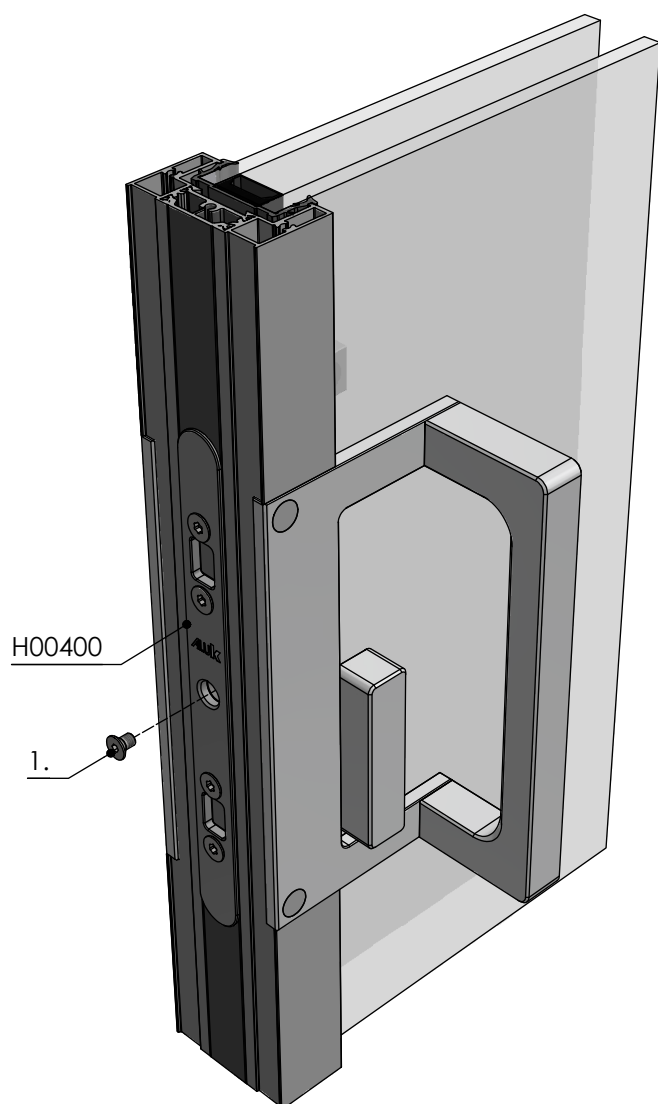


Also applicable to U00102

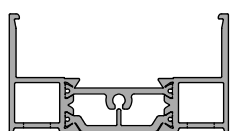


H00100 & H00101 can be fitted after glazing to avoid damage during transport.
For internal handle ONLY fit H00101 & H00400 (See page 9.35 for machining detail)

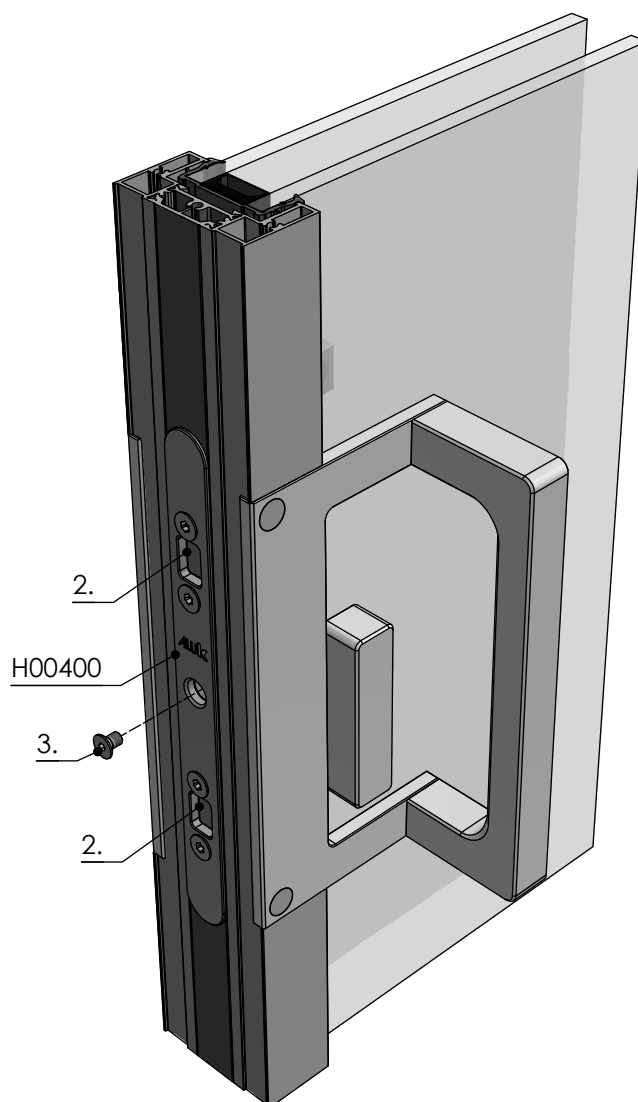
➤ H00400 & H00404 - FINAL FIXING



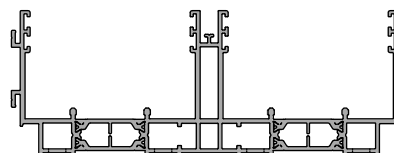
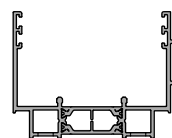
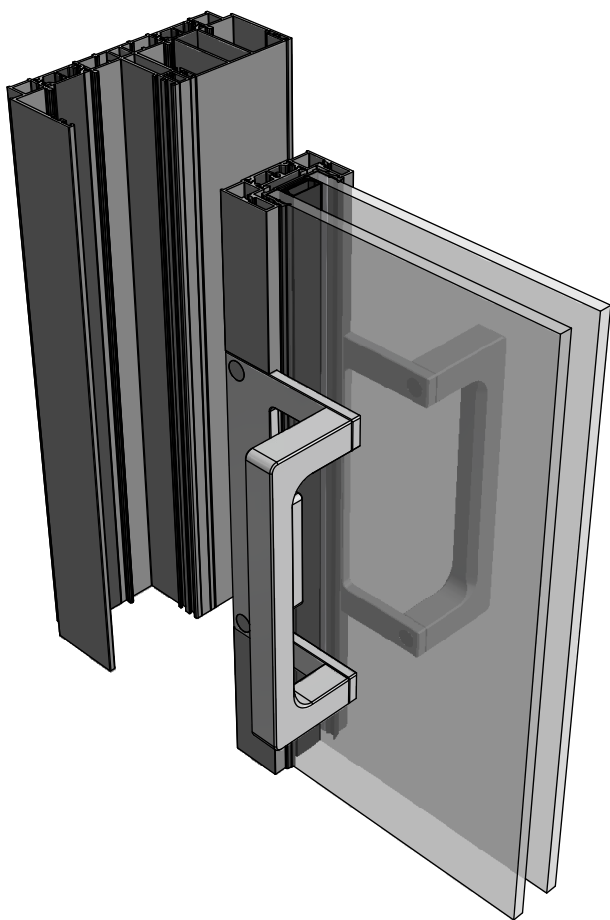
1. Fix lever (H00404) in place through clearance hole in H00400 face plate.
2. For second fixing press anti miss handling pads inwards and slide the lever up/down depending upon the starting position.
3. Fix final screw in place through the same hole as the first through the face plate.



Also applicable to U00102



➤ U0020, U00100, H00401 - KEEP ALIGNMENT



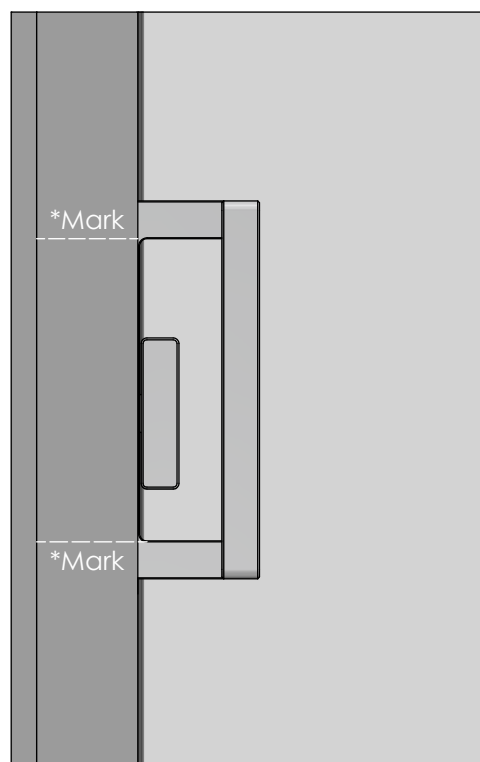
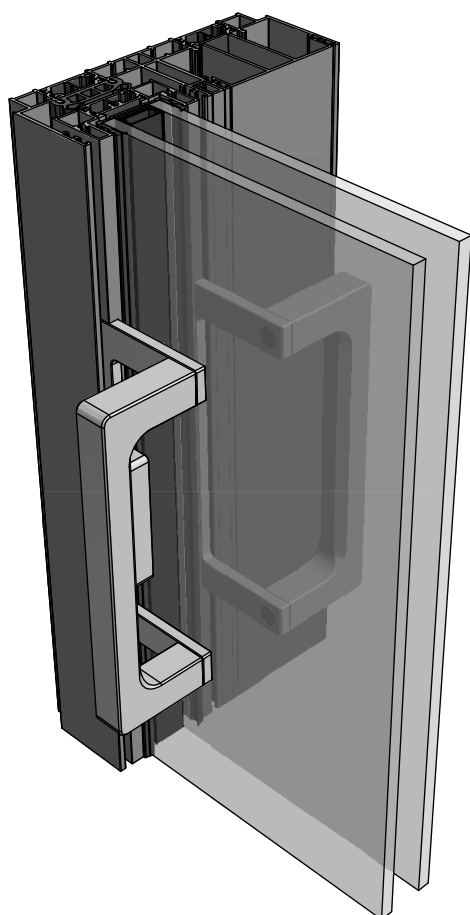
Also applicable to U00000 & U00022

Note:

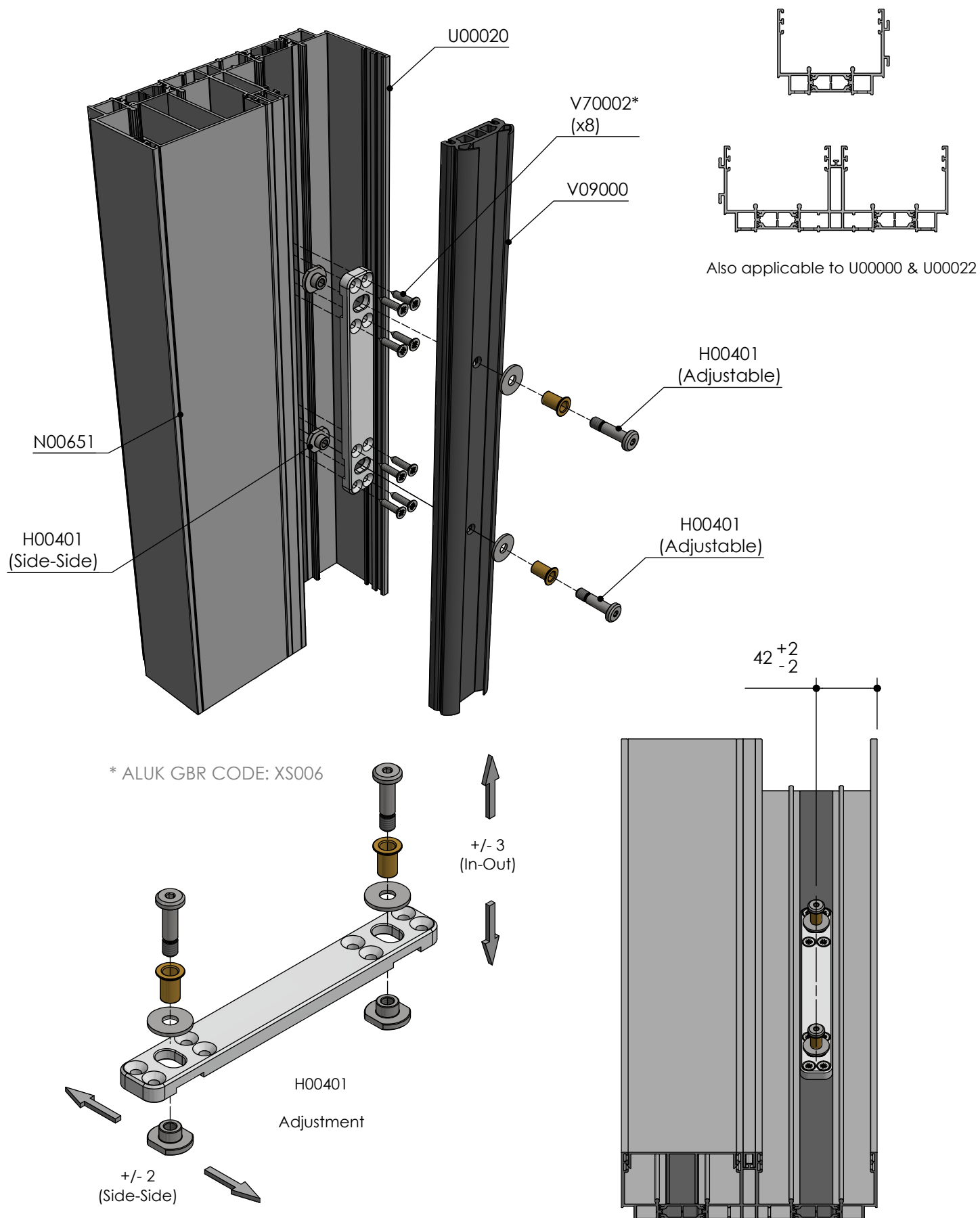
Slide door shut.

* Mark a pencil line from the internal side of the handle grip.

Use marks to align top and bottom of H00401 Keep.

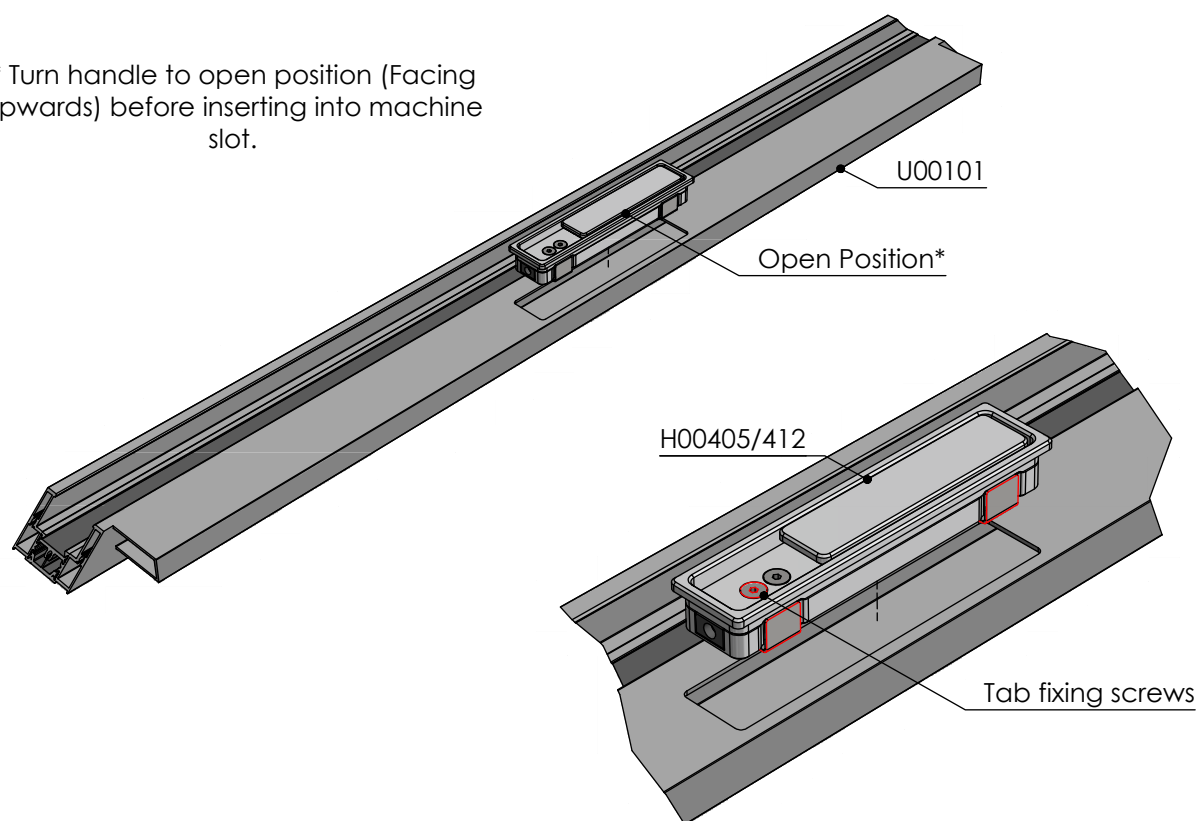


➤ U00020, H00401 - KEEP ASSEMBLY



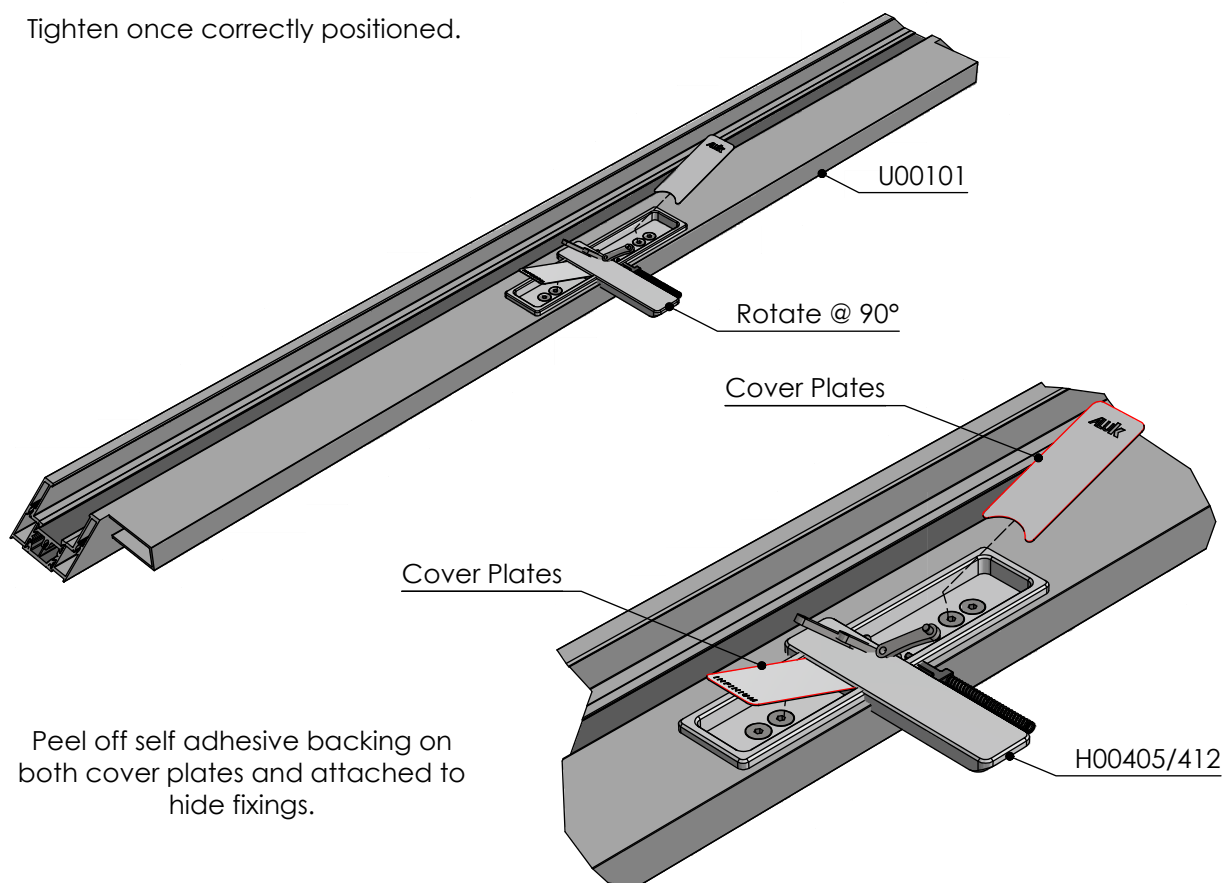
➤ H00405/412 - POP UP HANDLE ASSEMBLY

* Turn handle to open position (Facing upwards) before inserting into machine slot.



loosen the screw (Highlighted in RED) so the tab is at its lowest position.

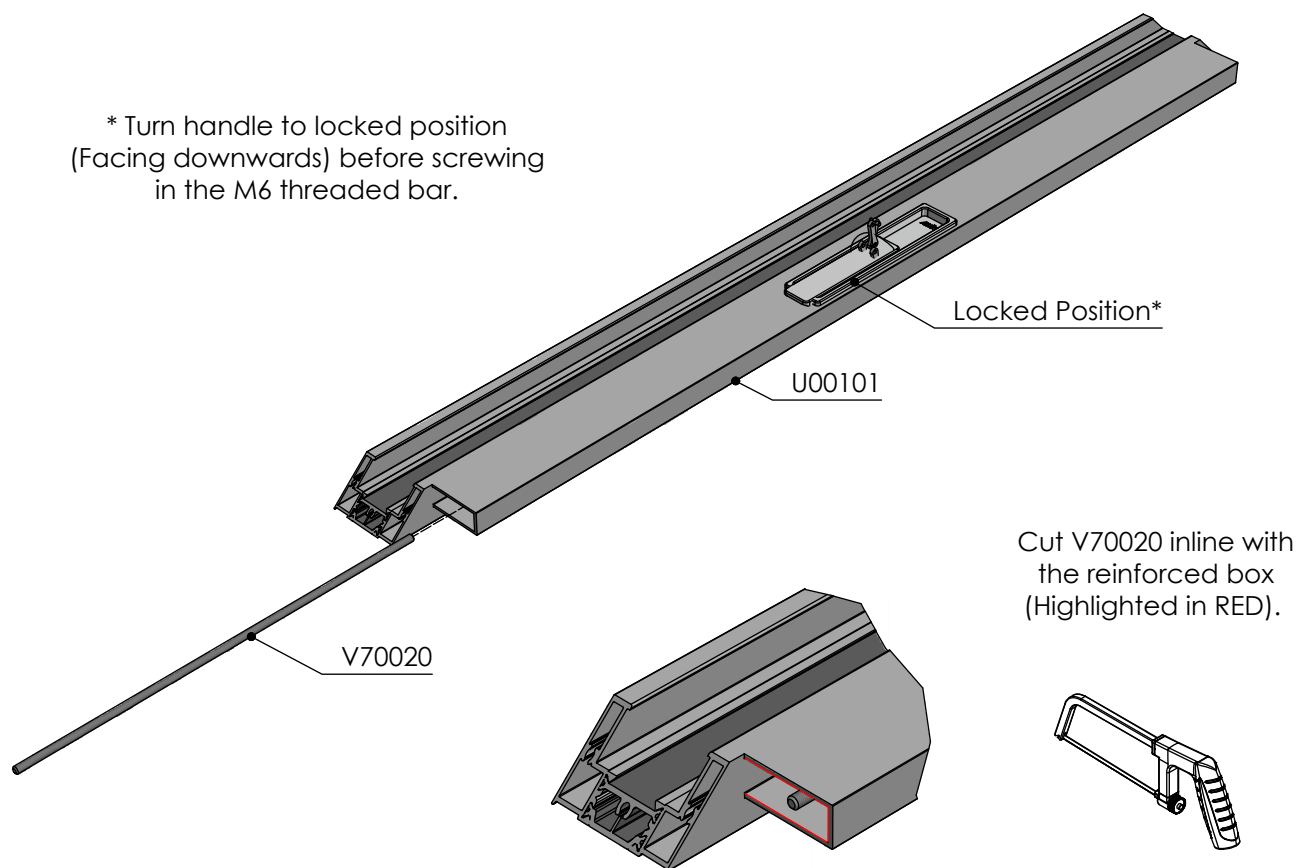
Tighten once correctly positioned.



Peel off self adhesive backing on both cover plates and attached to hide fixings.

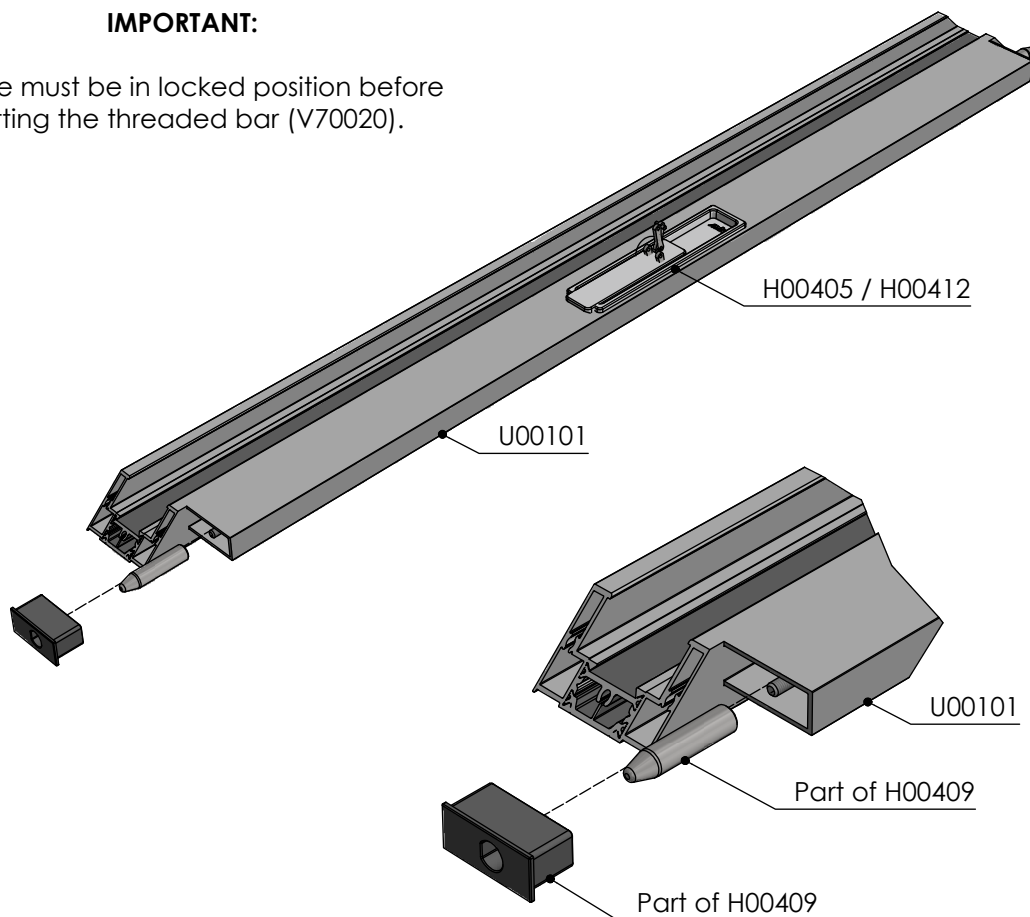
➤ H00405/412 - POP UP HANDLE ASSEMBLY

* Turn handle to locked position (Facing downwards) before screwing in the M6 threaded bar.



IMPORTANT:

Handle must be in locked position before cutting the threaded bar (V70020).

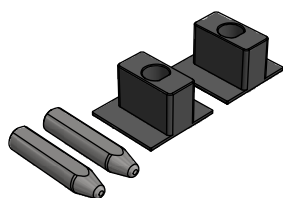


➤ H00406/408/409 - SHOOTBOLT KITS

See table below for applicable shootbolt kits used on both sash and reinforced interlocking profiles:

H00406/408/409 - Shootbolt Kits				
Part No.	Description	Sash Used	Interlock Used	Keep
H00406	Shootbolt Kit DG	-	N00121 / N00124	H00410 / H00411
H00408	Shootbolt Kit TG	-	N00122 / N00125	H00410 / H00411
H00409	Shootbolt Kit (Reinforced Sash)	U00101 / U00103	-	H00410 / H00411
V70020	M6 x 3M Threaded Bar	U00101 / U00103	N00121 / N00122 N00124 / N00125	H00410 / H00411

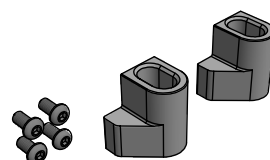
H00406



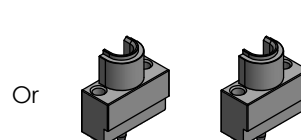
V70020



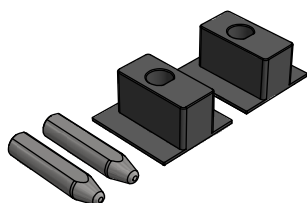
H00410



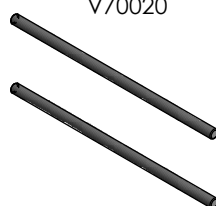
H00411



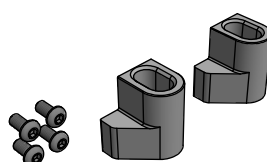
H00408



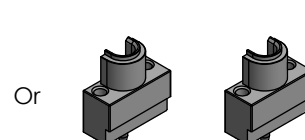
V70020



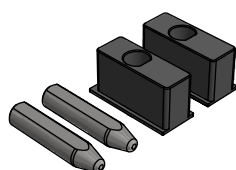
H00410



H00411



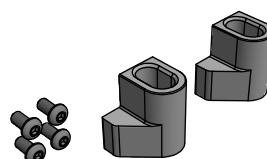
H00409



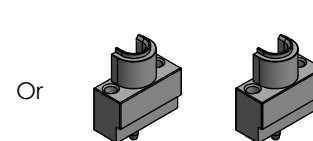
V70020



H00410

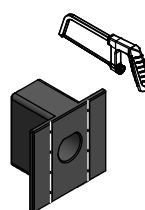


H00411

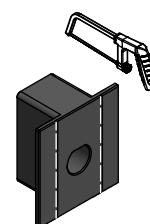


IMPORTANT:

Remove tabs from end caps when used with N00121, N00123, N00124 or N0125.

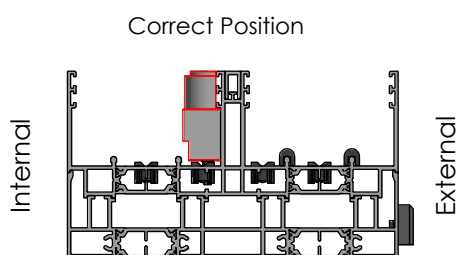
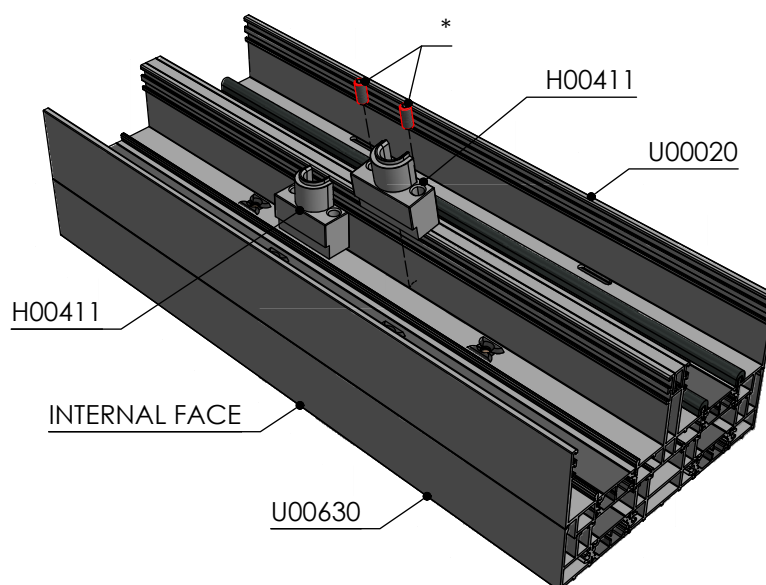


Part of H00406



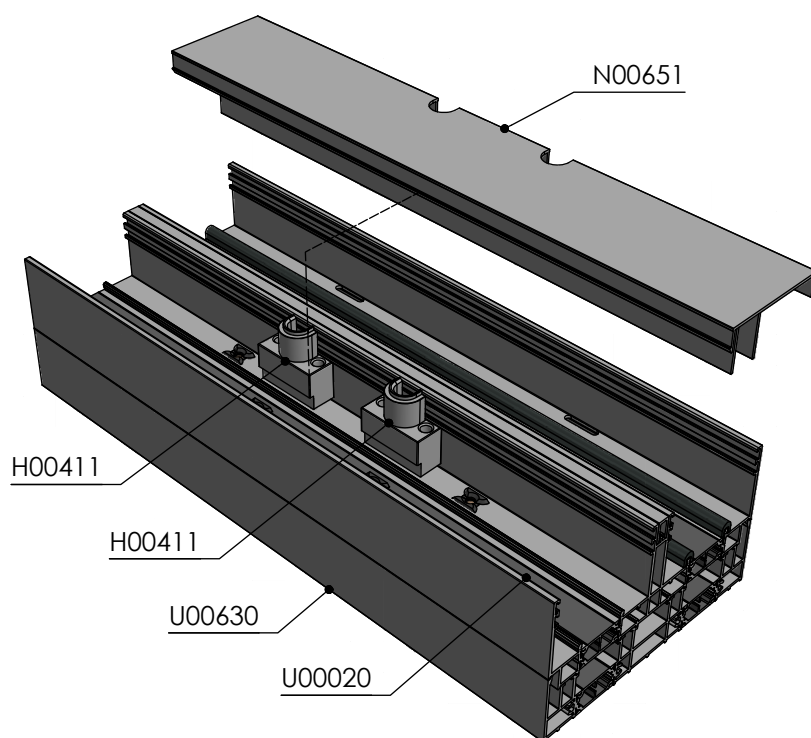
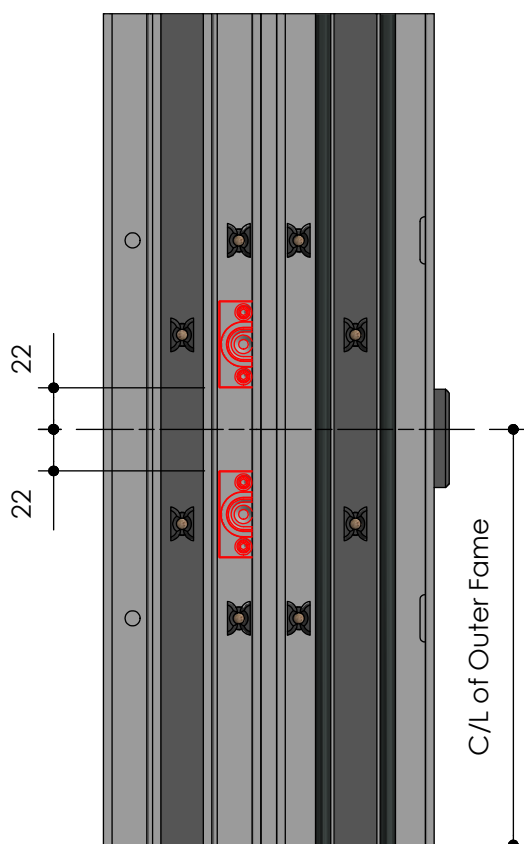
Part of H00407

➤ H00411 & U00020 - OXXO KEEP ASSEMBLY



Position H00411 into outer frame and space equally around the centre line of the door.

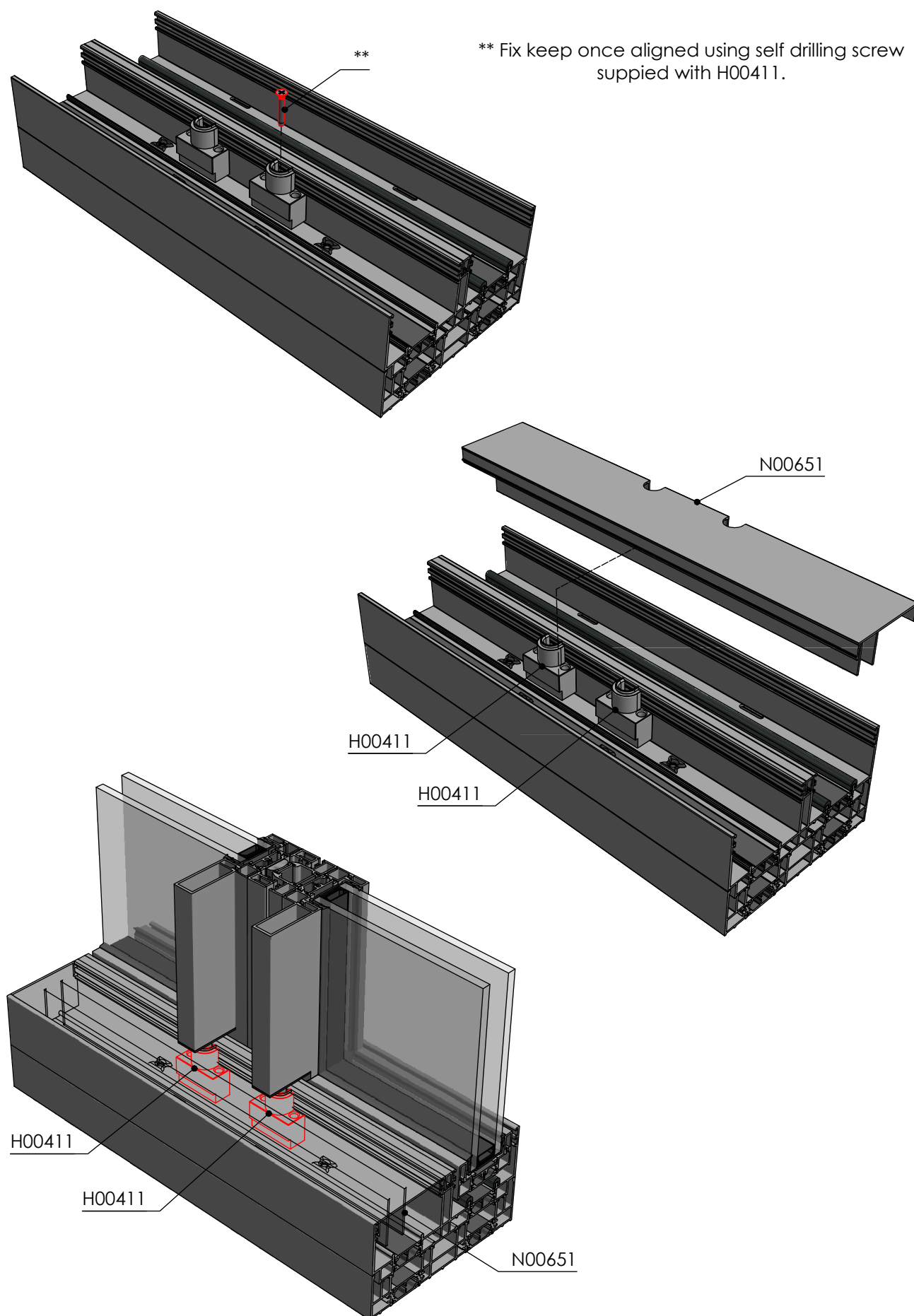
* Set by tightening the 2 grub screws supplied with H00411 before final fix.



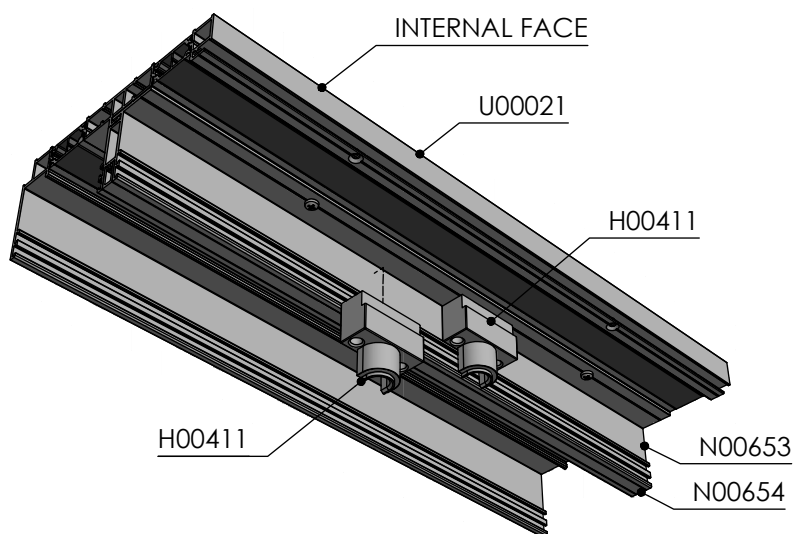
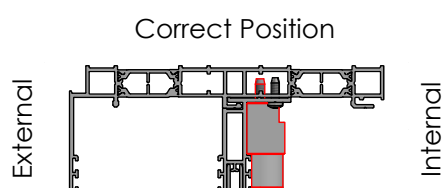
IMPORTANT:

Check keep position (H00411) with cover plate (N00651) for alignment before applying final fixing screw.

➤ H00411 & U00020 - OXXO KEEP ASSEMBLY

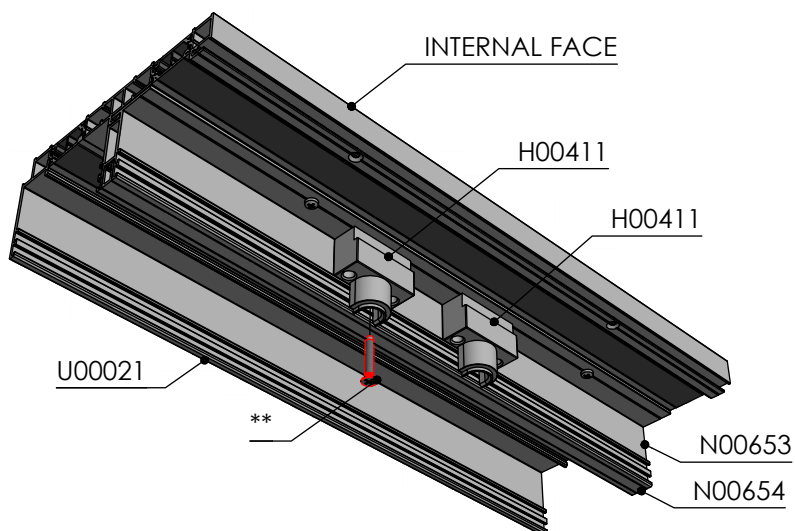
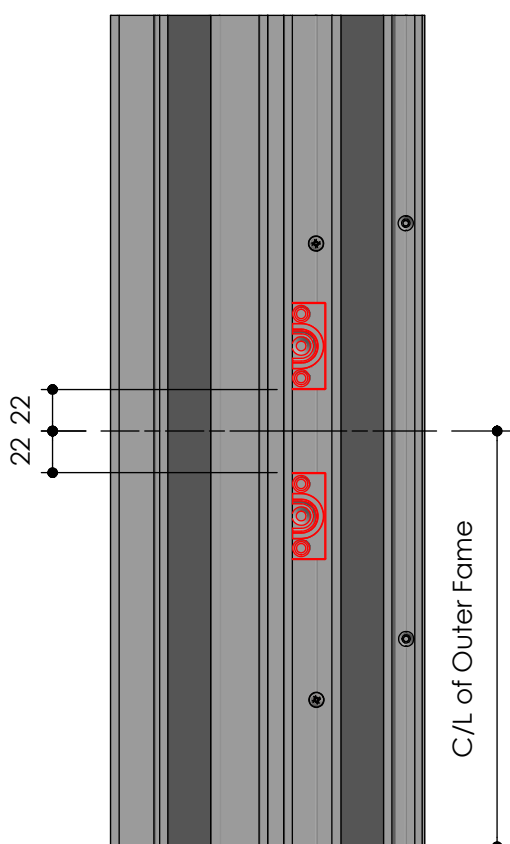


➤ H00411 & U00021 - OXXO KEEP ASSEMBLY



Position H00411 into outer frame and space equally around the centre line of the door.

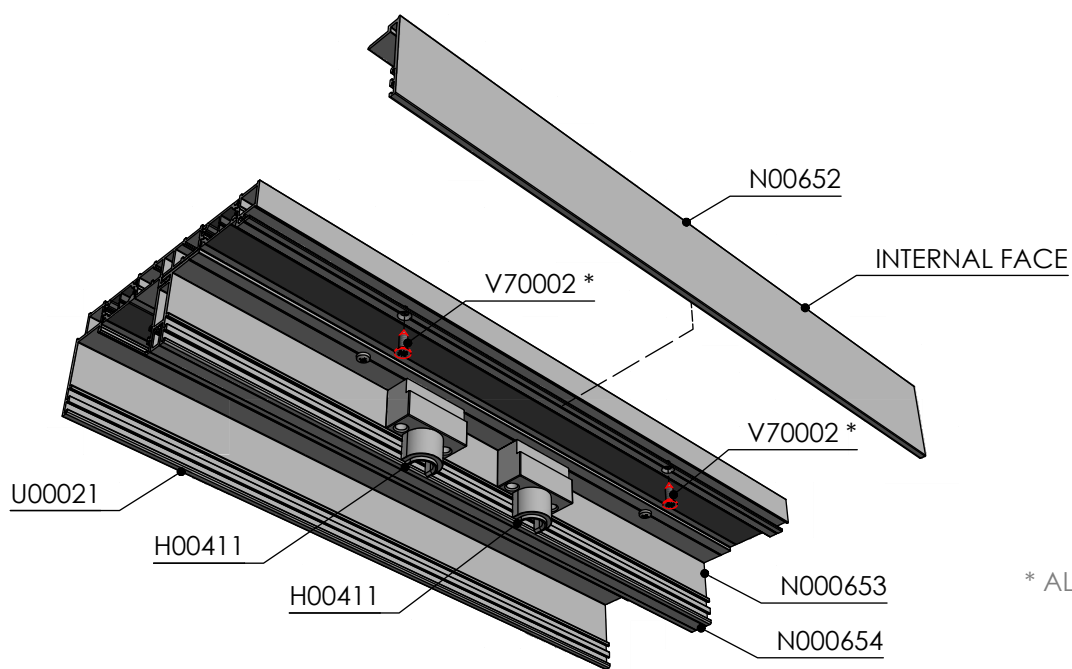
Remove the 2 grub screws supplied with H00411 as these are only applied when used with U00020, U00022 & U00000.



IMPORTANT:

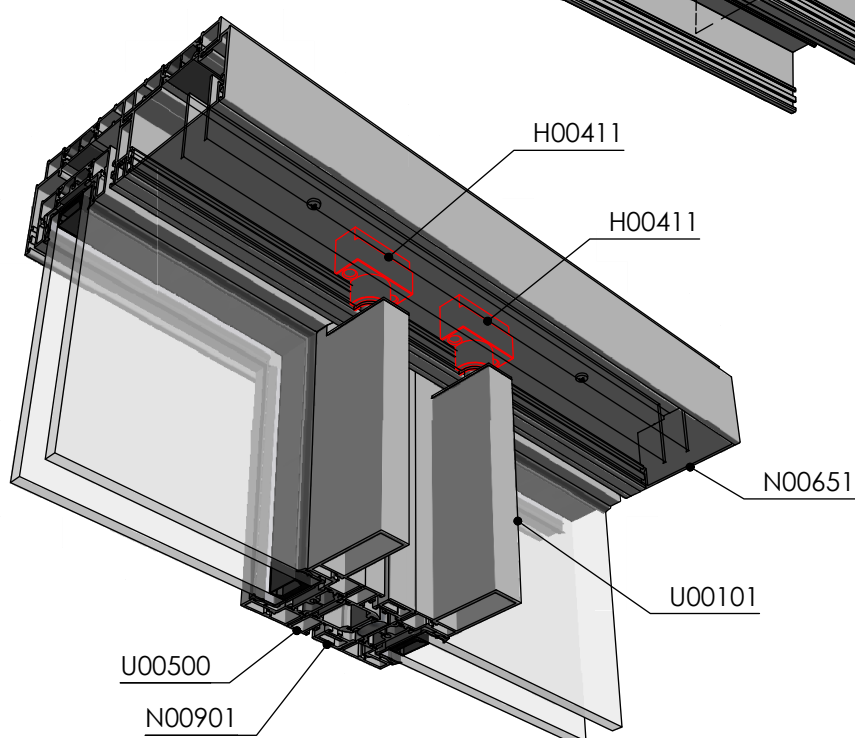
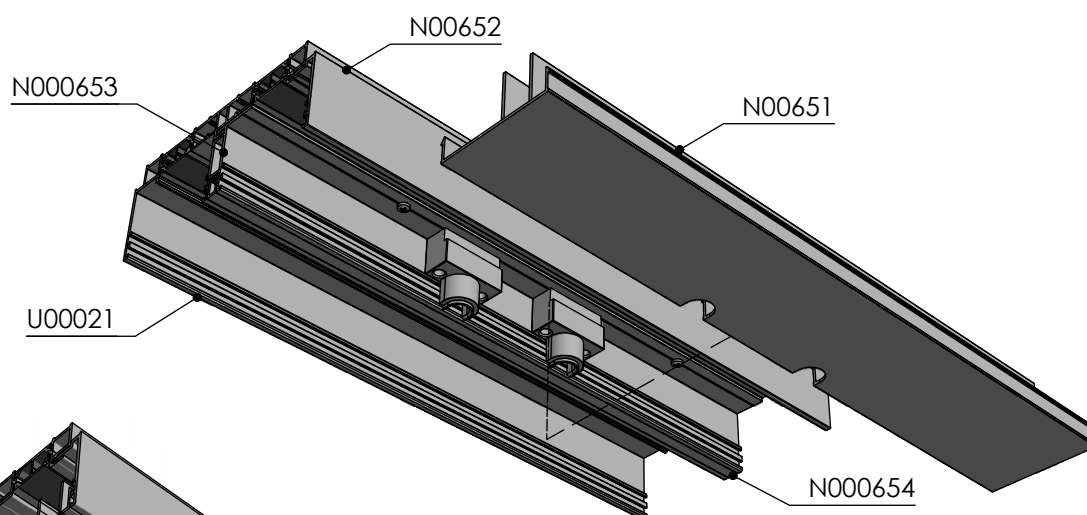
** Check keep position (H00411) with cover plate (N00651) for alignment before applying final fixing screw.

➤ H00411 & U00021 - OXXO KEEP ASSEMBLY

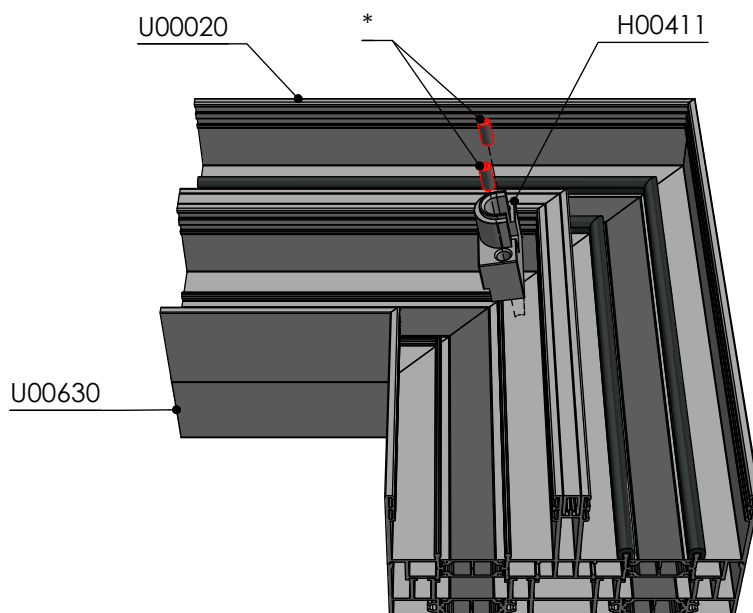


NOTE:

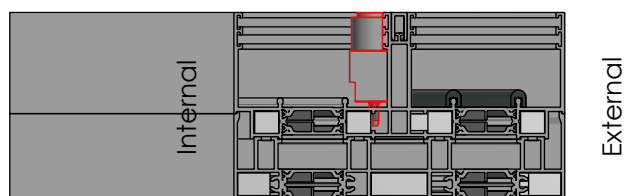
* ALUK GBR CODE: XS???



➤ H00411 - 90 DEG. CORNER KEEP

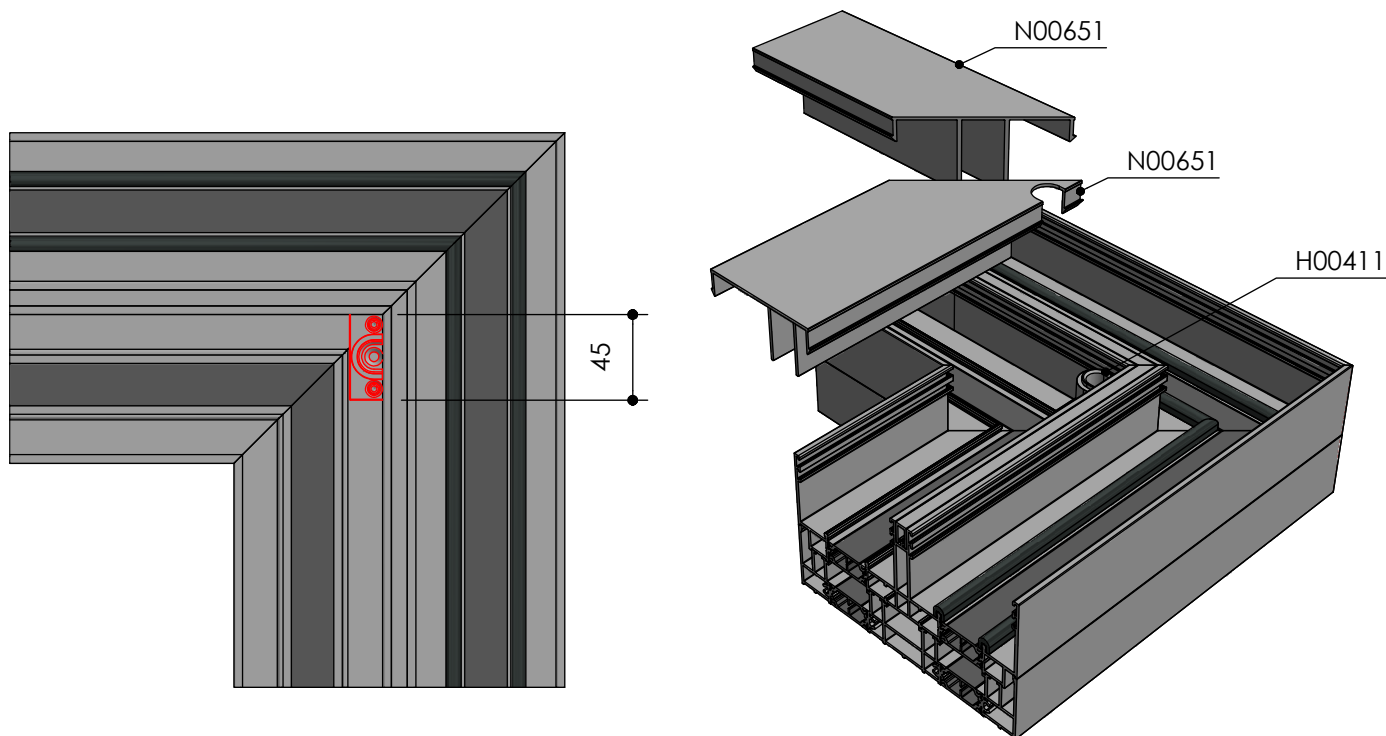


Correct Position



Position H00411 into corner of the outer frame as shown.

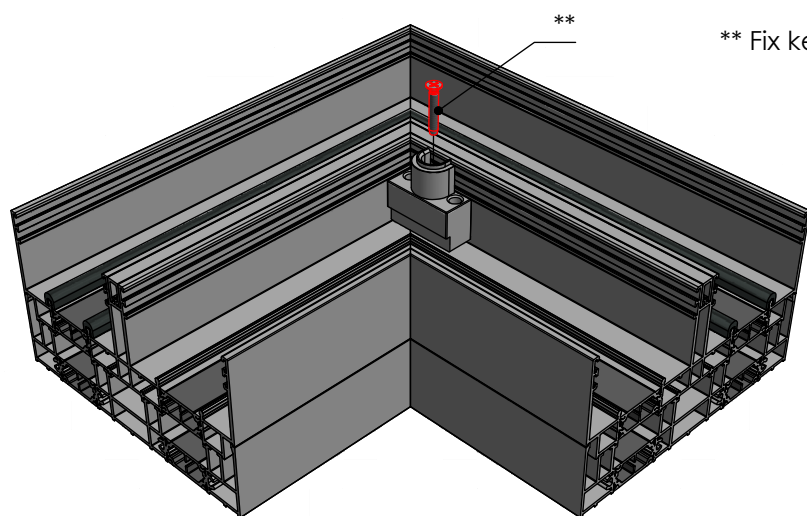
* Set by tightening the 2 grub screws supplied with H00411 before final fix.



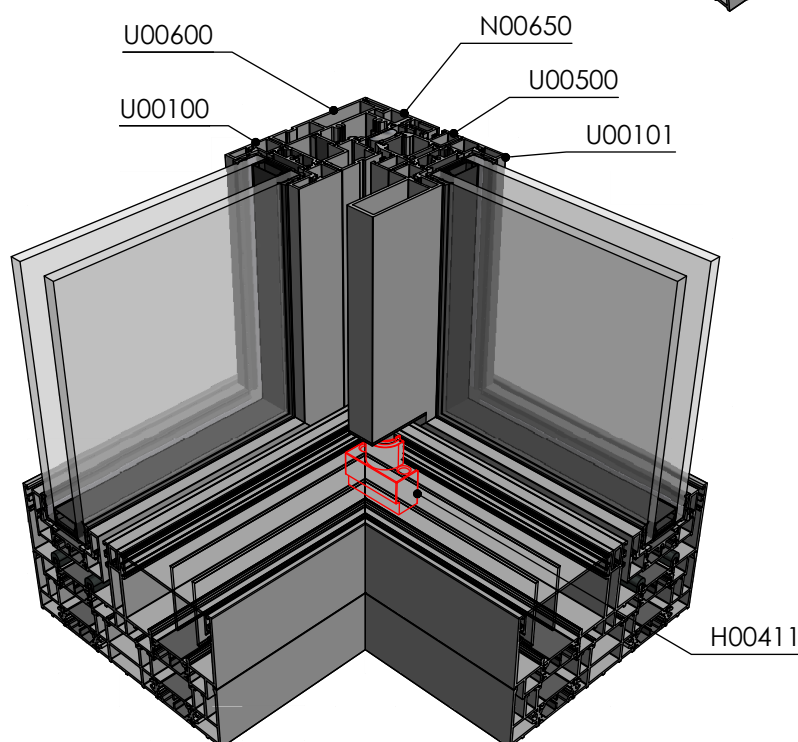
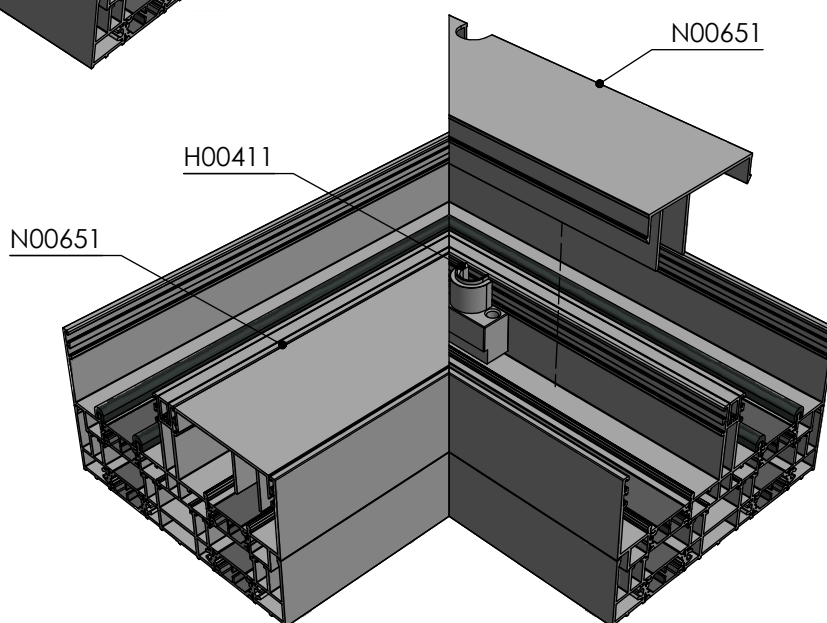
IMPORTANT:

Check keep position (H00411) with cover plate (N00651) for alignment before applying final fixing screw.

➤ H00411 - 90 DEG. CORNER KEEP



** Fix keep once aligned using self drilling screw supplied with H00411.



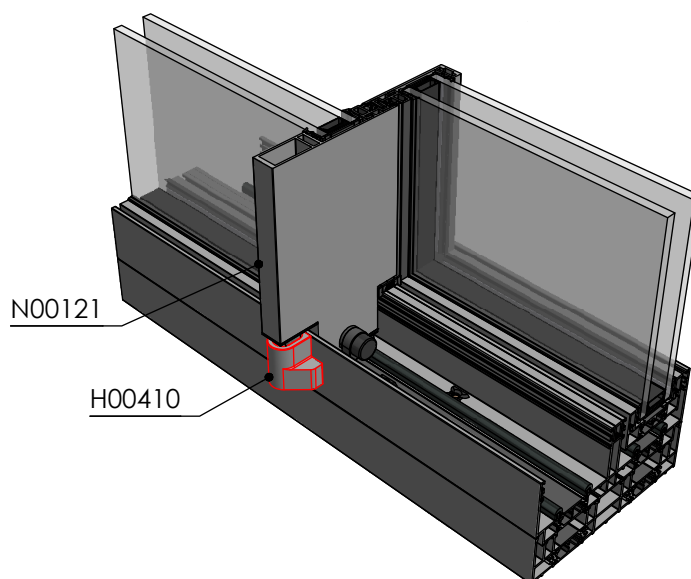
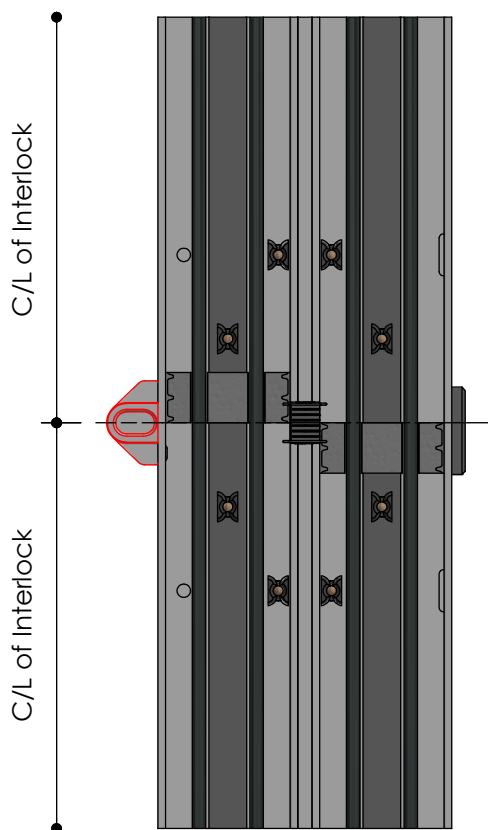
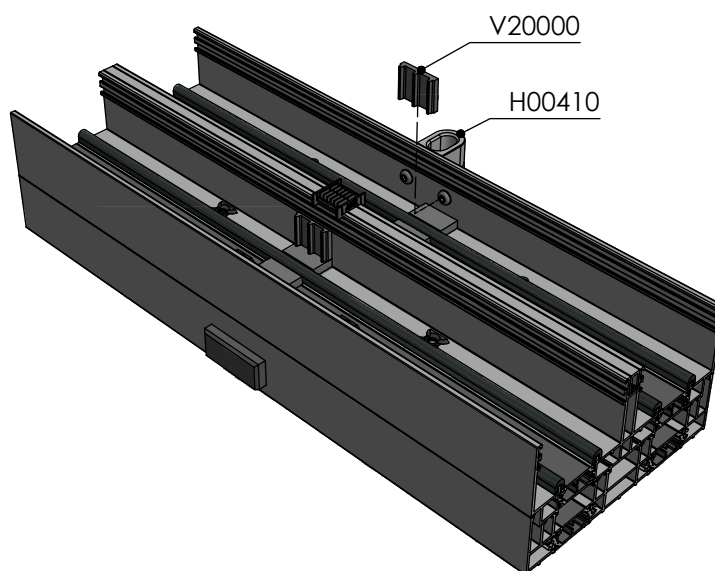
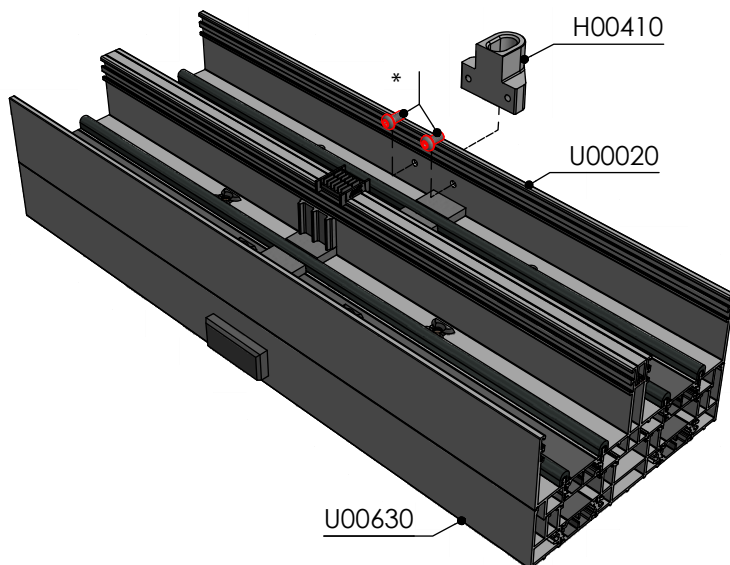
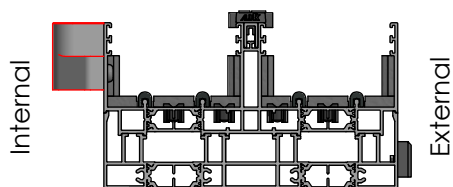
IMPORTANT:

Follow the same procedure for the head section (U00021/23) but do not use grub screws supplied with H00411 before final fix.

➤ H00410 - INTERLOCK KEEP

* Fix H00410 keep before inserting the sliding panel using screws provided.

Correct Position



IMPORTANT:

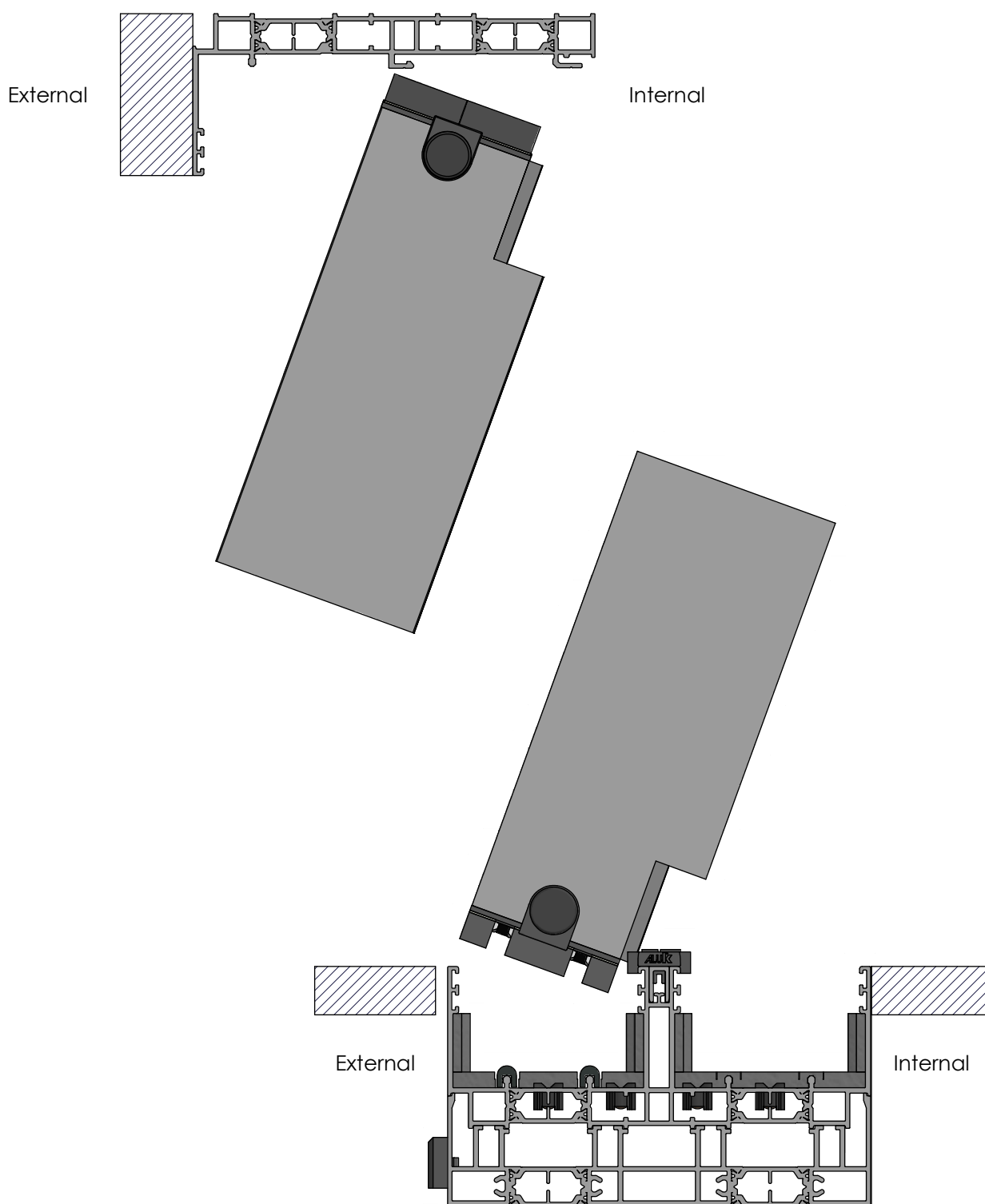
Crop V20000 to fit around the fixing closest to the foam centre seal.

➤ PANEL INSTALLATION

Panel Installation:

1. Lift and angle external panel into exterior outer frame pocket.
2. Once verticle slide door panel into jamb.

1. & 2.

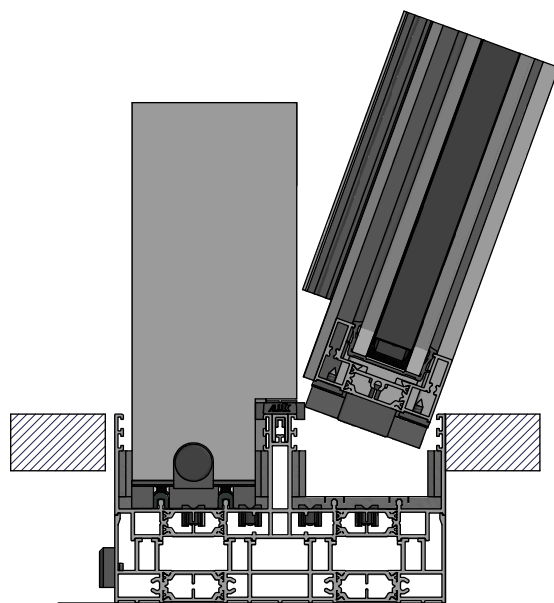
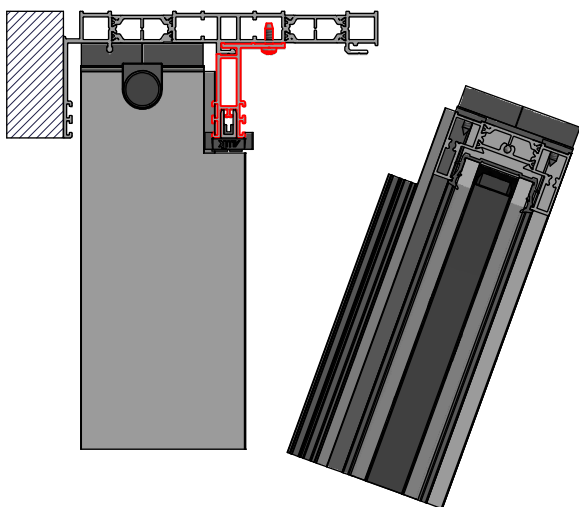


➤ PANEL INSTALLATION CONT.

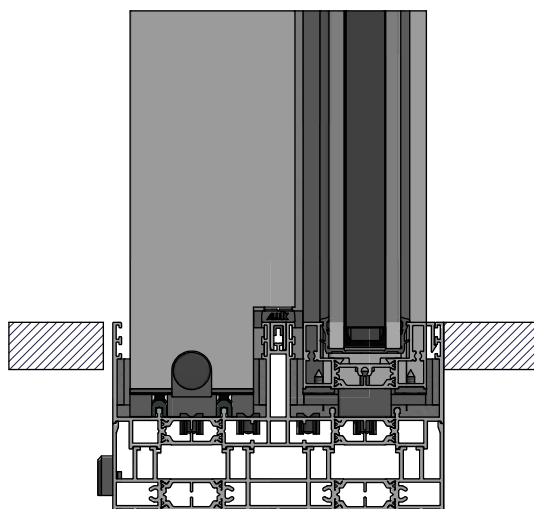
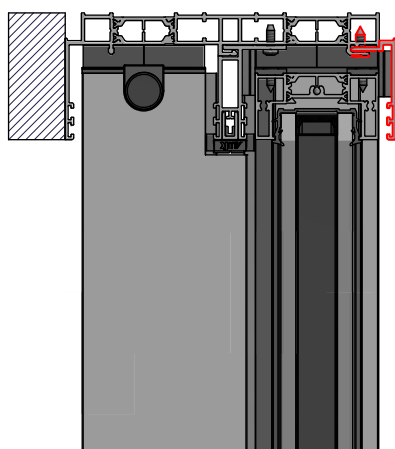
Panel Installation continued:

3. Install/fix central rebate (N00653) into the head profile (U00021) using V70005.
4. Repeat step 1 but into interior outer frame pocket.
5. Slide door panel into opposing jamb.
6. Install/fix internal rebate (N00652) into the head profile (U00021) using V70002.

3. & 4.



5. & .6





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